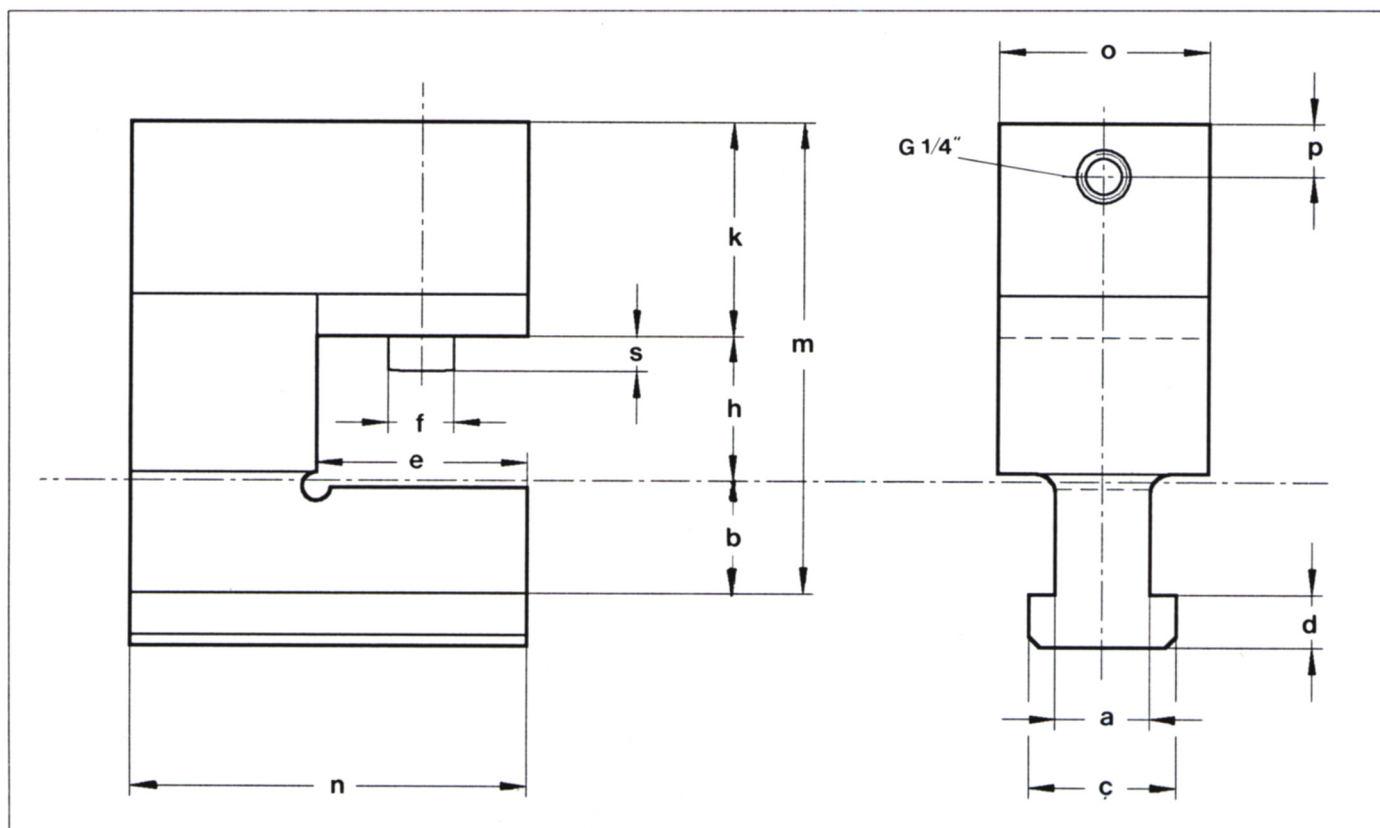
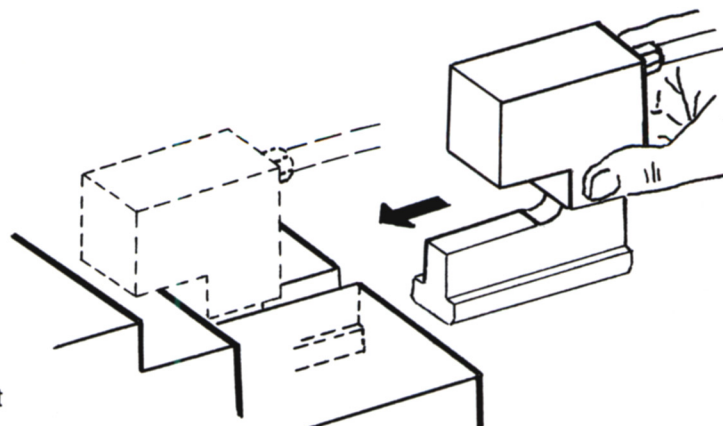


Hydraulic C-Frame Clamp

Features:

- A safe, quick and simple way to clamp Dies, Workpieces and Fixtures
- Easily inserted into existing T-Slots, adapts to any Die width
- Allows semi-automated Die change operations
- Hydraulic activation assures quick and effortless clamping
- Generous piston stroke allows for variations in Die shoe thickness
- Compact design assures minimal space requirement



Type	Clamp Force (tons at 5800 psi)	Stroke s	a	b	c	d	e	f	h	k	m	n	o	p	Oil Volume (in ³)
HEE 25	2.75	.35	*	*	*	*	1.57	.55	*	1.89	$h + 2.24$	2.95	1.57	.43	.40
HEE 40	4.4	.39	*	*	*	*	1.71	.70	*	2.17	$h + 2.56$	3.54	1.97	.43	.61
HEE 63	7	.47	*	*	*	*	2.17	.70	*	2.36	$h + 2.84$	4.33	2.17	.43	1.16

(*) customer specified

Technical Data

Operation Procedure (HEE): To Clamp

1. Visually inspect clamp for obvious defects and make certain that the hydraulic power supply is disactivated and the clamp piston is in its fully retracted position.
2. Place clamp into T-slot.
3. Push clamp forward (toward die) as far as possible to ensure proper seating. Make

certain that the die shoe surface is free of debris and lubricants.

4. Inspect the gap between the clamping cylinder and die surface to ensure that it does not exceed the stroke "s" of the clamp. Warning: Clamp will not generate clamp force if gap exceeds the stroke "s".
5. Activate hydraulic supply

To Unclamp - Reverse procedure

Ordering Information

When ordering or requesting a quote, please take a few minutes to complete the following data sheet.

Necessary Data

Range of die shoe thickness: (min. and max. values must be within .25" of each other) _____ min. _____ max.

Press tonnage: _____

Weight of dies: _____ top _____ bottom

Clearance between ram and bolster (shut height): _____

T-Slot Dimensions

If standard: _____

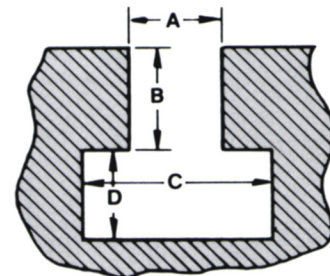
If non-standard:

Width of throat (A) _____

Depth of throat (B) _____

Width of head (C) _____

Depth of head (D) _____



Note: Please give depth of throat dimension "B" even if using a standard T-slot.

Standard T-Slot Dimensions

Diameter of T-Bolt	Width of Throat A	Depth of Throat B		Head Space Dimensions and Tolerances					
				Width C			Depth D		
		Maximum	Minimum	Maximum (Basic)	Tolerance (Minus)	Minimum	Maximum (Basic)	Tolerance (Minus)	Minimum
1/4	9/32	3/8	1/8	9/16	0.063	1/2	15/64	0.031	13/64
5/16	11/32	7/16	5/32	21/32	0.063	19/32	17/64	0.031	15/64
3/8	7/16	9/16	7/32	25/32	0.063	23/32	21/64	0.031	19/64
1/2	9/16	11/16	5/16	31/32	0.063	29/32	25/64	0.031	23/64
5/8	11/16	7/8	7/16	1 1/4	0.063	13/16	31/64	0.031	29/64
3/4	13/16	1 1/16	9/16	1 15/32	0.094	13/8	5/8	0.031	19/32
1	1 1/16	1 1/4	3/4	1 27/32	0.094	13/4	53/64	0.047	25/32
1 1/4	1 5/16	1 9/16	1	2 7/32	0.094	2 1/8	13/32	0.063	1 1/32
1 1/2	1 9/16	1 15/16	1 1/4	2 21/32	0.094	2 9/16	1 11/32	0.063	1 9/32