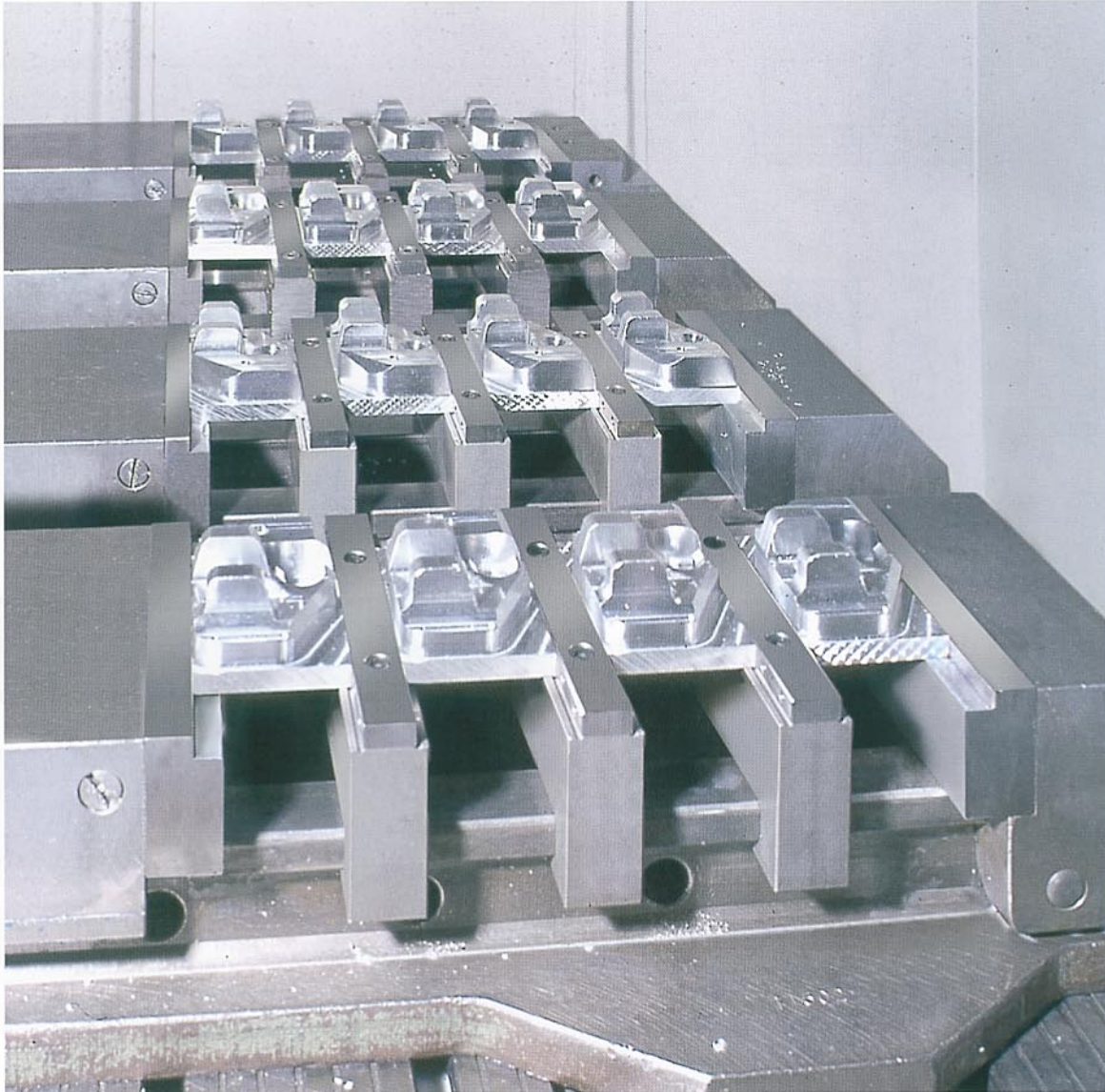


Floating central jaws for multiple clamping using machine vices

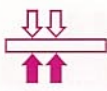


Using floating central jaws for multiple clamping allows optimum use of the working area of NC machines.

The resulting reduction in the number of die changes and travelling distances contributes to a significant reduction of the cost of each item machined.

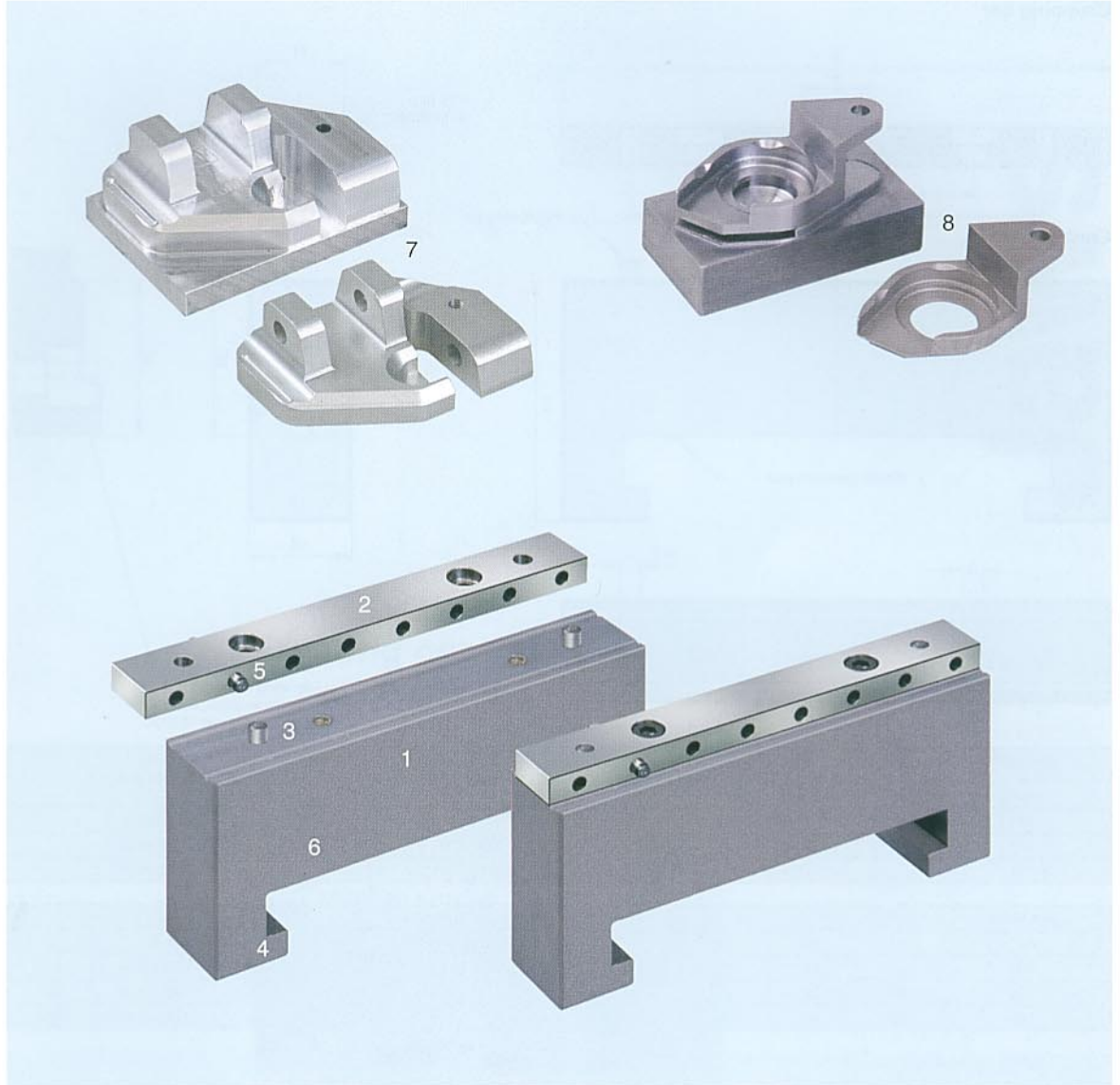
In combination with precision step jaws, these jaws may be used for HILMA clamping systems type SM, NC, UNC, Flex and DF with a jaw width of between 100 and 160 mm.

- ◆ complex parts for milling can be machined on all sides
- ◆ minimum set-up time by easy jaw changing
- ◆ all workpieces are clamping by applying the same clamping force
- ◆ close arrangement of workpieces ensures optimum use of the working area of NC machines
- ◆ determination of lateral workpiece position by stop pins which may be repositioned
- ◆ downside recess and spring elements prevent vibration and lifting up of workpieces
- ◆ changeable clamping bars ensure high degree of flexibility
- ◆ longer machine running times allow the operation of several machines



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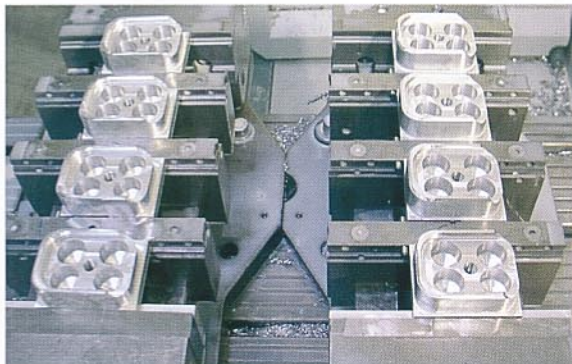
Clamping with system



1. Central jaw, aluminium hard anodised
2. Clamping bar, replaceable
3. Positioning pin for clamping bar

4. Downside recess
5. Stop pin, re-locatable
6. Integral spring elements

7. Workpiece with / without clamping edge
8. Workpiece with / without 'lost head'

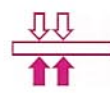


After finish machining, the 'clamping edge' is milled off the workpiece in a second clamping cycle.



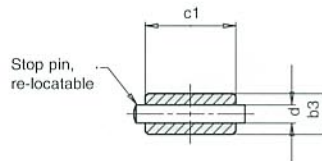
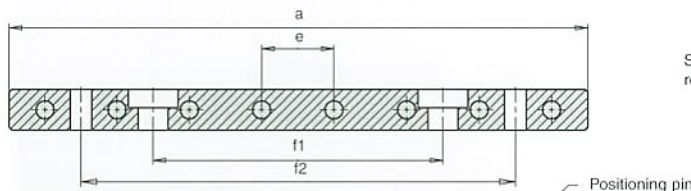
After finish machining, the 'lost head' is removed from the workpiece using a disk milling cutter.

10.3740

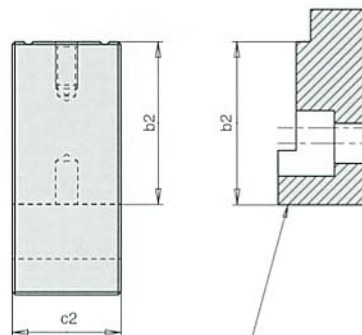
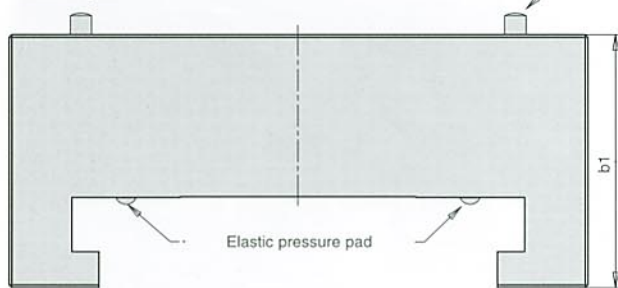


Floating central jaws, standard design for HILMA clamping systems type SM, NC, UNC and DF

Clamping bar



Central jaw



Precision step jaw
for slide and fixed jaw
For dimensions, see
catalogue sheet 10.3720

Jaw width a (mm)	Part no. Central jaw with clamping bar	Part no. Clamping bar	Part no. Precision step
100	9.3715.0211	9.3715.1201	5.2082.0001
125	9.3715.0311	9.3715.1301	5.2082.0002
160	9.3715.0411	9.3715.1401	5.2082.0003

Jaw width a	Dimensions in mm									
	b1	b2	b3	c1	c2	d	e	f1	f2	g
100	48	29	6	12 - 0,01	20	3	13	52	78 ± 0,01	M5
125	61	39	7	16 - 0,01	26	4	16	64	96 ± 0,01	M5
160	70	45	9	20 - 0,01	30	5	20	80	120 ± 0,01	M6



Efficient and economic: Existing or new HILMA machine vices can be changed from single to multiple workpiece clamping at a low investment cost and with a minimum expenditure of time.

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