



**HILMA  
RÖMHELD**

*Clamping with system*

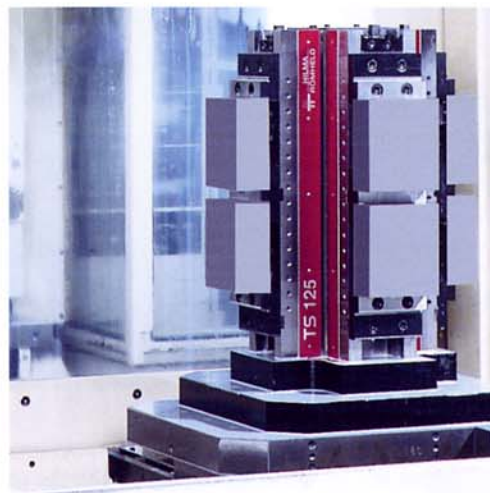
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## Tower

Product line TS / TS Magnum



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**TS**

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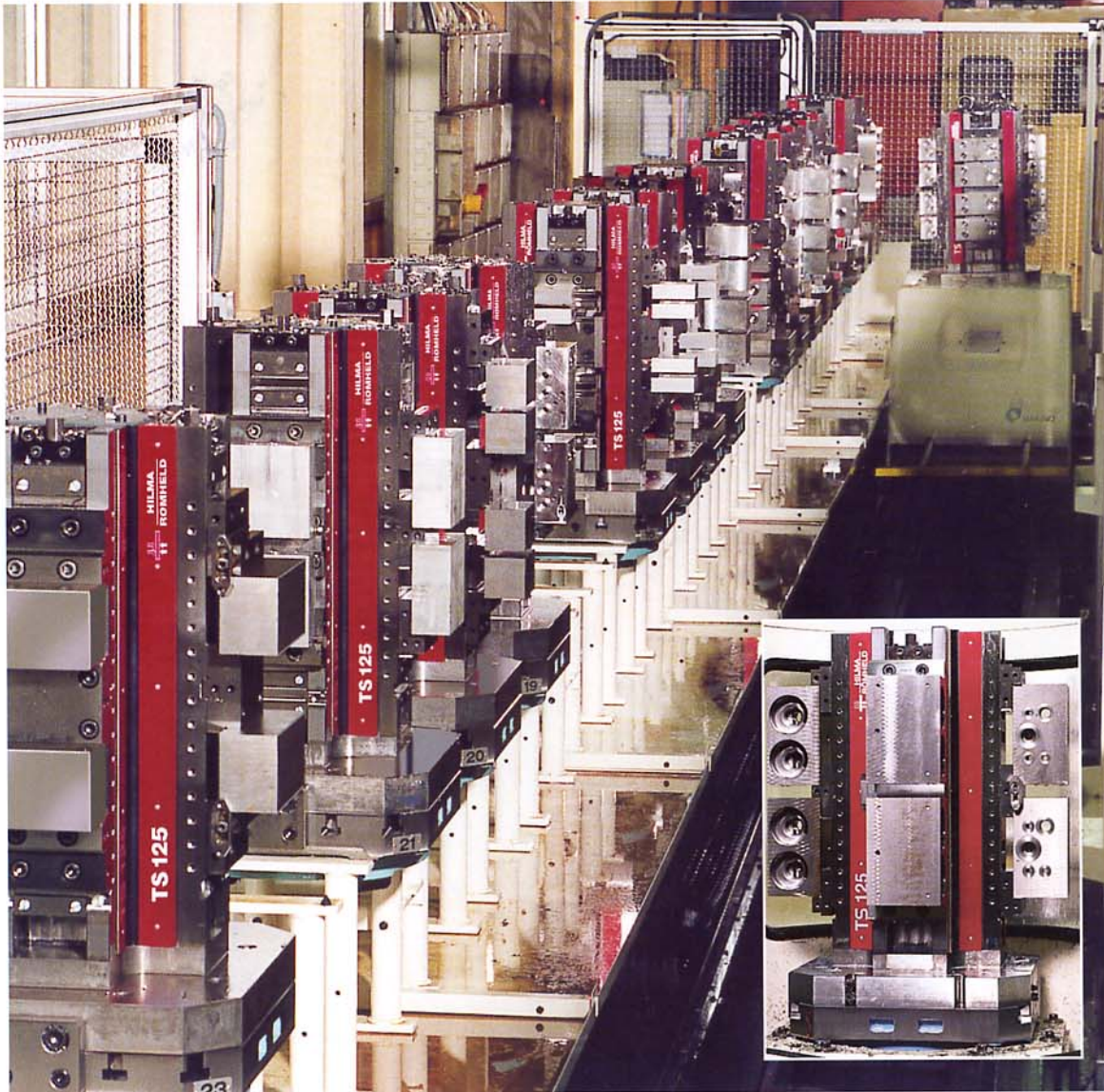
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## Turmspannsystem TS 125/TS 125 Magnum

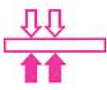


Rapid and safe multiple clamping on two levels in horizontal machining centres. User-friendly loading and unloading of workpieces thanks to the "third hand function".

The solid one-piece design of the steel tower and a base plate made from high-tensile aluminium guarantee maximum precision and stability.

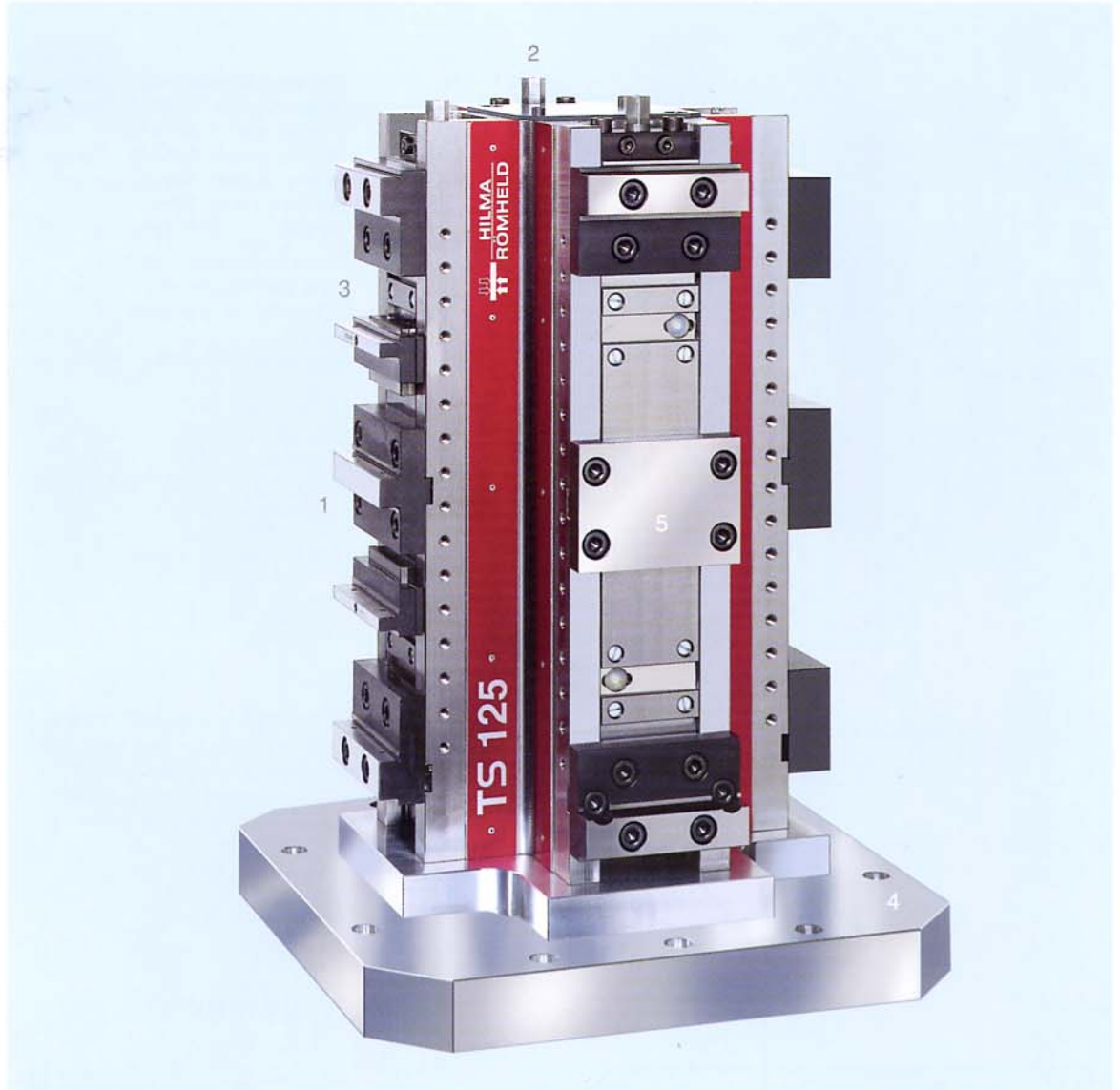
TS and TS Magnum are universal clamping systems, designed to suit a large number of positioning and clamping applications in flexible production.

- ◆ When using a floating central jaw, up to 16 workpieces can be loaded
- ◆ Absolutely safe manual clamping without need for a hydro unit (up to 40 kN per clamping point); precisely adjustable clamping forces
- ◆ The slide guideways being free from play, the spindle area is fully protected
- ◆ Rapid changeover to accommodate other workpieces
- ◆ Multiple clamping ensures extended pallet cycles



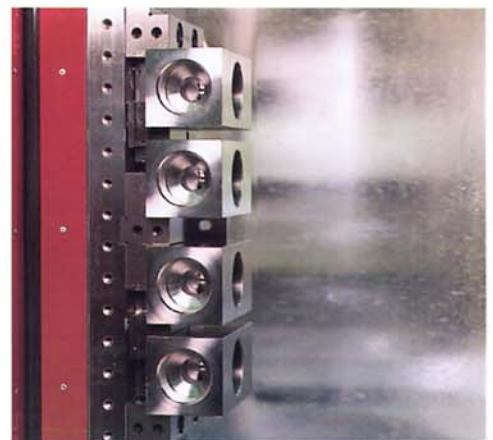
**HILMA  
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*Clamping with system*



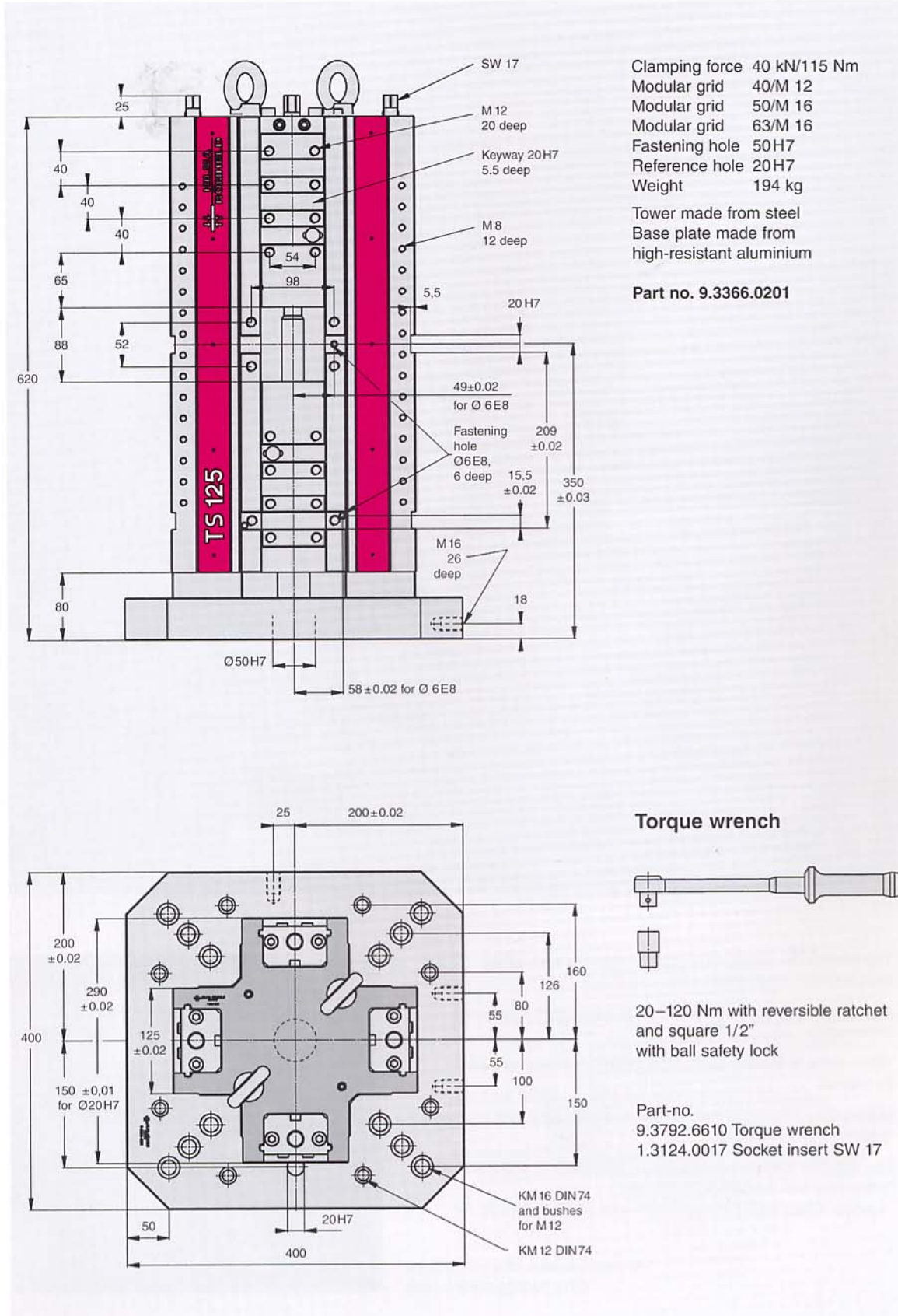
1. The workpieces are accommodated close to each other, thus minimum tool travel
2. Rapid and user-friendly clamping just requiring a short lever movement
3. When using a floating central jaw, up to 16 workpieces can be loaded
4. Standardised base plate which can be easily fastened to any type of DIN / JIS pallets
5. The effective clamping range can be extended to 430 (550) mm (when only one workpiece is clamped)

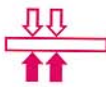
Accommodation of 4 workpieces  
using floating central jaws



**5.3360**

**Technical data**





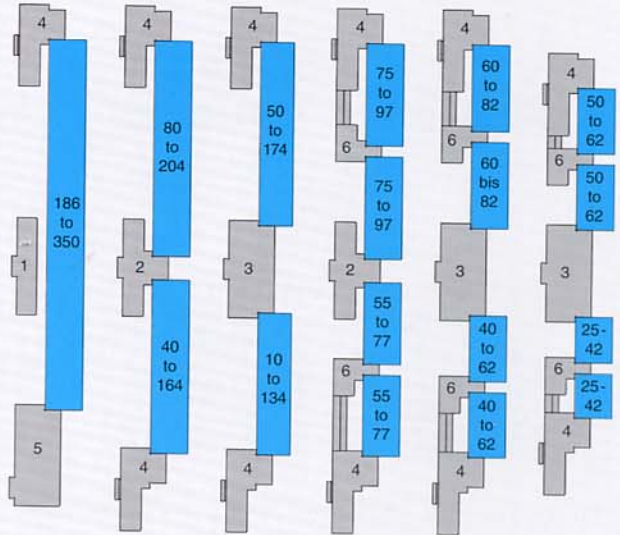
**Clamping ranges using standard clamping jaws**

Using standard jaws, between 4 and 16 equally or differently sized workpieces can be clamped

Larger clamping ranges (186 to 430 mm) can be achieved using fixed reversible step jaws.

Part no. 9.3791.6311

Item	Part no.	Designation
1	9.3791.6140	Guide plate
2	9.3791.6111	Central step jaw 22 mm
3	9.3791.6121	Central step jaw 82 mm
4	9.3791.6211	Step jaw, reversible
5	9.3791.6341	Step jaw, fixed
6	9.3791.6511	Central jaw, floating
For jaw dimensions, see page 6		

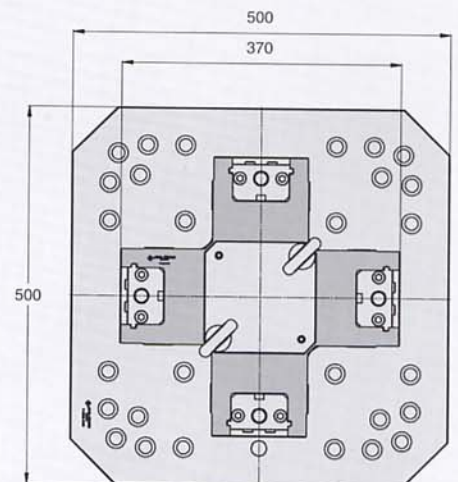
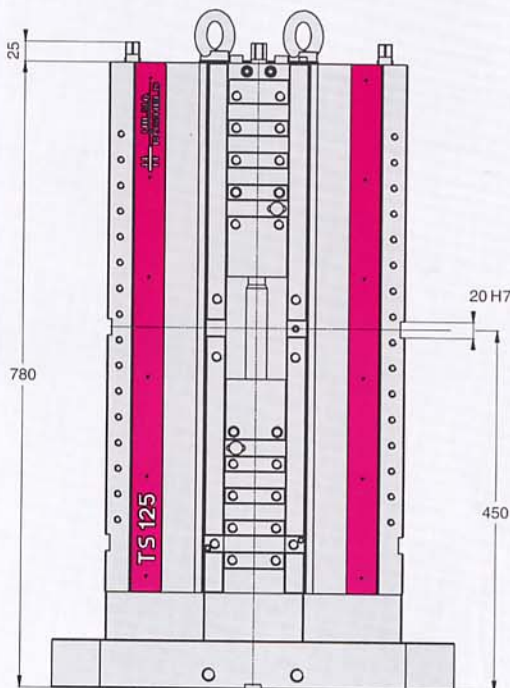


**Tower clamping system TS 125/Magnum**

The alternative, preferably for use on machining centres BT 50. The workpiece is readily accessible for three-side machining, hence maximum utilisation of spindle travel and machine performance.

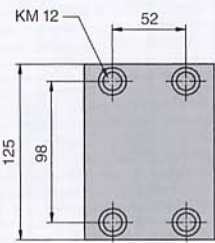
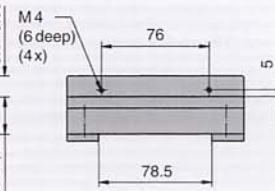
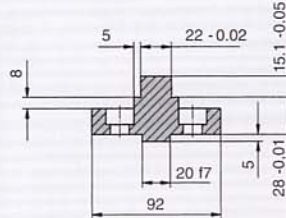
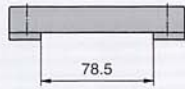
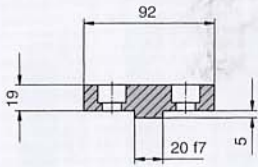
Workpieces	Clamping range
4	346 – 550
8	10 – 264
16	25 – 127
Suitable clamping jaws see above	

on request

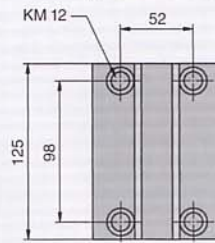


## Dimensions of standard clamping jaws

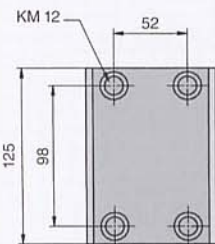
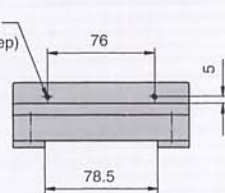
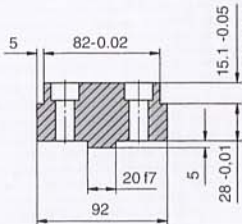
**Standard clamping jaws**, case-hardened and ground with steps 8 mm (space for tooling and swarf).  
Supplied with fastening screws.



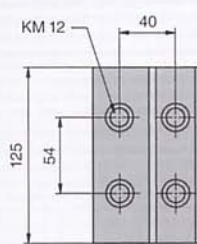
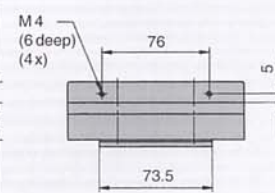
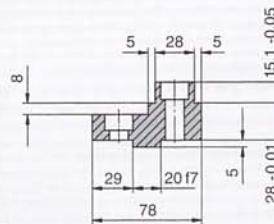
Guide plate  
Part no. 9.3791.6140



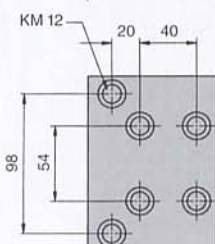
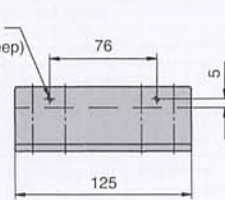
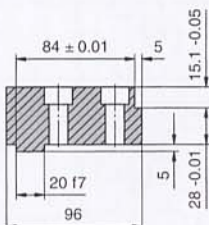
Central step jaw 22 mm  
Part no. 9.3791.6111



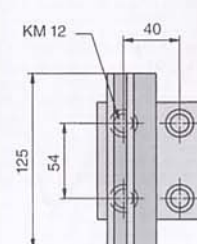
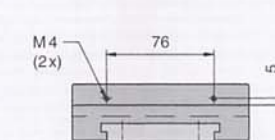
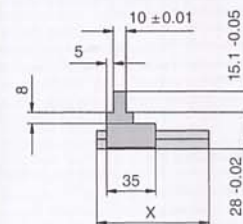
Central step jaw 82 mm  
Part no. 9.3791.6121



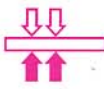
Step jaw, reversible  
Part no. 9.3791.6211



Step jaw, fixed  
Part no. 9.3791.6341

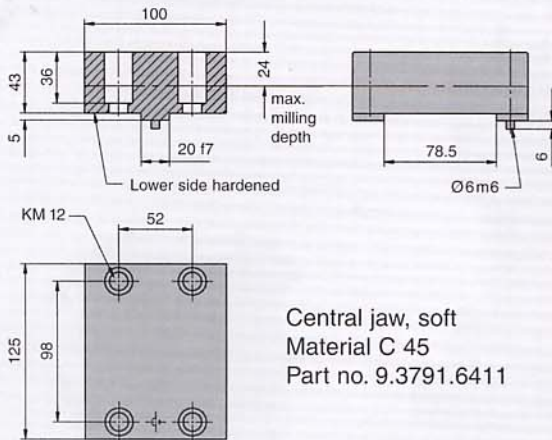


Central jaw, floating  
x = 50 and 56 mm  
Part no. 9.3791.6541  
x = 50 and 80 mm  
Part no. 9.3791.6511

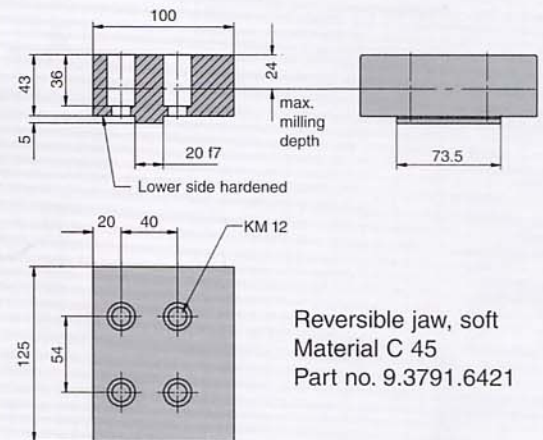


## Dimensions of standard clamping jaws / turbo quick-insert jaws

**Soft standard clamping jaws** for milling workpiece contours, steps, stops etc..  
Delivery including fastening screws.

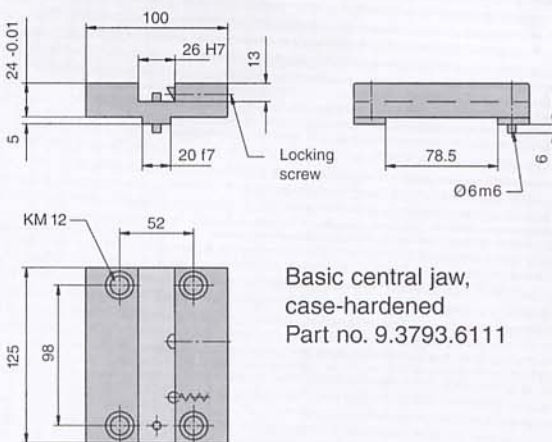


Central jaw, soft  
Material C 45  
Part no. 9.3791.6411

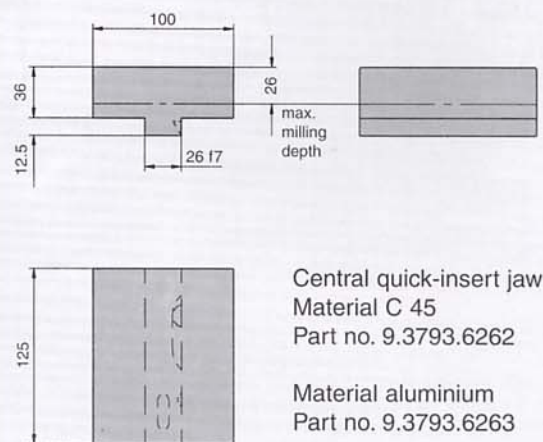


Reversible jaw, soft  
Material C 45  
Part no. 9.3791.6421

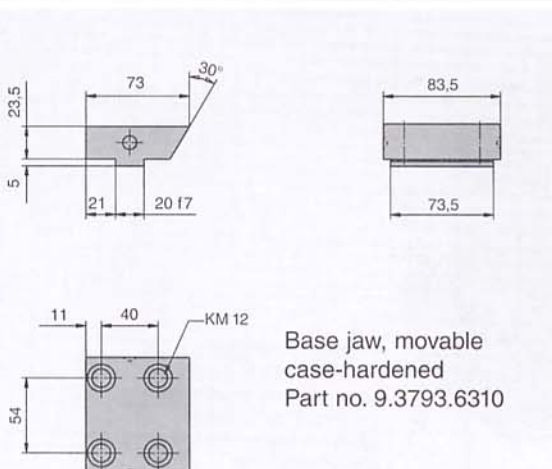
**Turbo quick-insert jaws:** Jaw change in a few seconds, without screws. Quick-insert jaws soft, made from steel C 45 or high-tensile aluminium for milling workpiece contours, steps, stops etc..



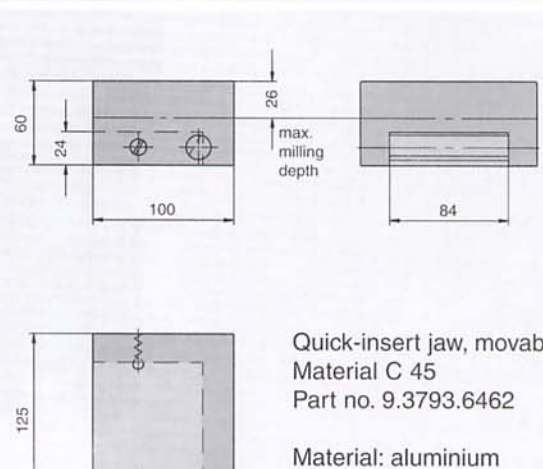
Basic central jaw,  
case-hardened  
Part no. 9.3793.6111



Central quick-insert jaw  
Material C 45  
Part no. 9.3793.6262  
Material aluminium  
Part no. 9.3793.6263



Base jaw, movable  
case-hardened  
Part no. 9.3793.6310

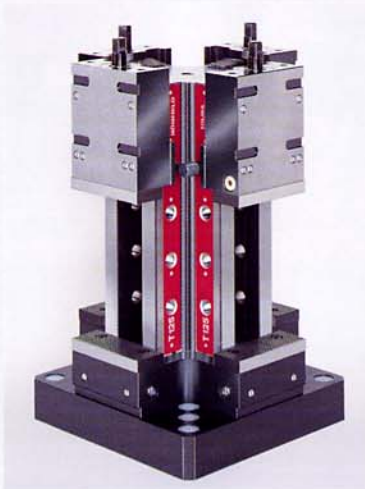


Quick-insert jaw, movable  
Material C 45  
Part no. 9.3793.6462  
Material: aluminium  
Part no. 9.3793.6463

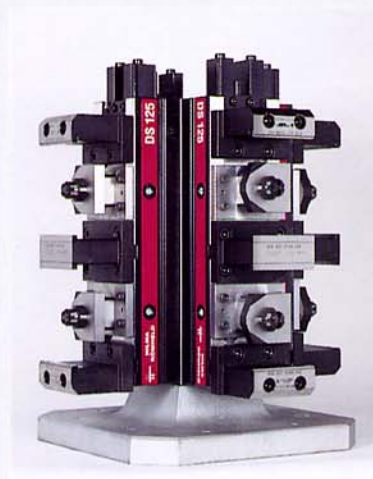
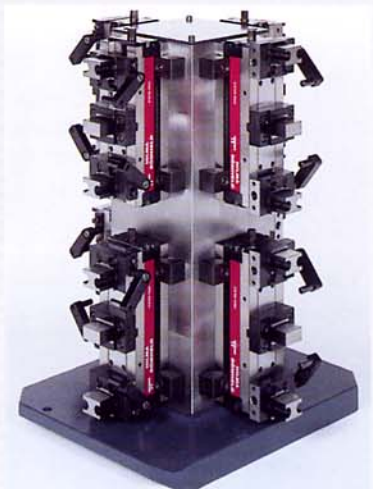


**Other tower clamping systems**

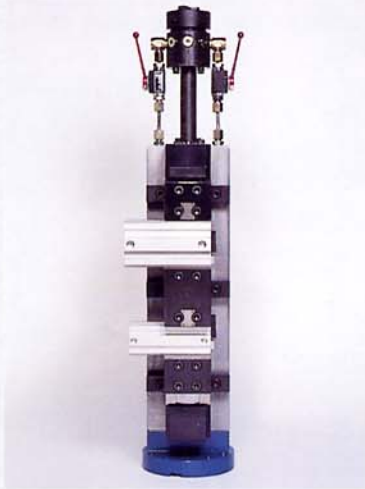
Flexible clamping cube 4 x 90°  
in one-piece design.  
Clamping of 4 equally or differently  
sized workpieces



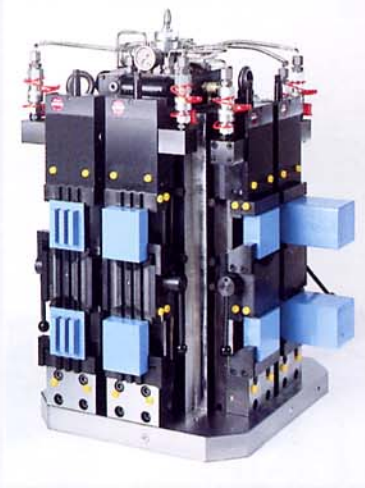
Clamping cube 4 x 90°  
with 8 compact clamps DUO 80/200  
for 16 workpieces.  
Constant reference points;  
therefore highest precision



Clamping cube 4 x 90°  
with 4 double clamping systems DS 125.  
Equipped with customised special jaws,  
designed to accommodate 4 x 2 aluminium  
brake housings



Hydraulic clamping system  
for aluminium valve bodies  
for positioning and clamping  
4 workpieces in sequence



Hydraulic clamping system  
for notched bar impact tests,  
cost effective solution using  
standard components.  
4 machining cycles can be carried  
out in sequence

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