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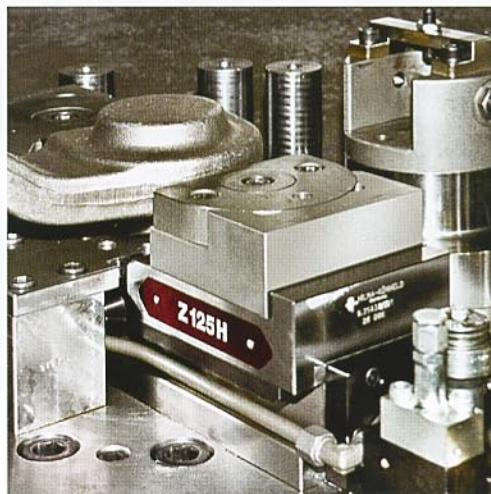
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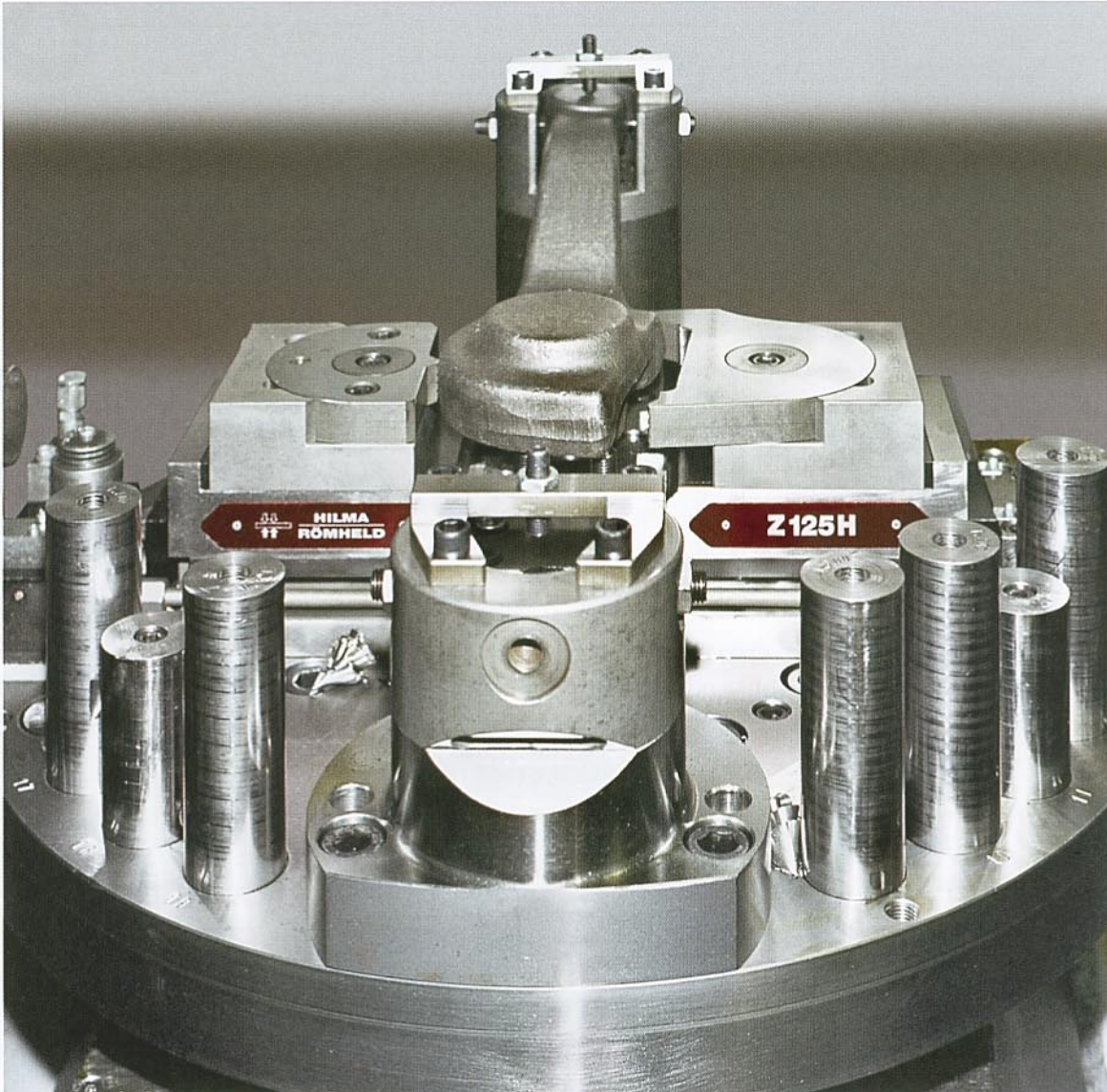
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Self-centering vice
hydraulically operated





Self-centering vice, hydraulically operated



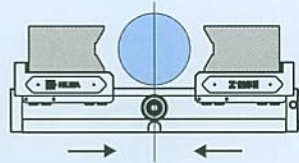
Self-centering vices position and clamp workpieces exactly on a defined symmetrical axis, taking account of their contours.

They may be used flexibly in machining centres, on machine tools and final processing machines as well as in special jigs and fixtures.

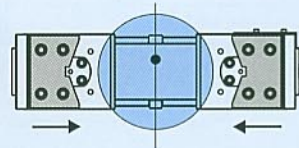
Hydraulic clamping and unclamping is powered by an external pressure transmitter with a double-acting circuit.

The synchronising device which is adjustable without play ensures high centering precision.

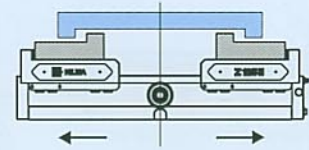
- ◆ high clamping repeatability ± 0.01 mm
- ◆ constant length and large clamping ranges
- ◆ any mounting position
- ◆ possibilities for positioning and fastening customer-specific jaws
- ◆ protection against coolant and swarf by integral wipers in the clamping slides
- ◆ large stroke of the slide
- ◆ limitation of the opening stroke by a proximity switch (optional extra)
- ◆ an additional pilot-controlled check valve can be fitted to the 'clamping' port



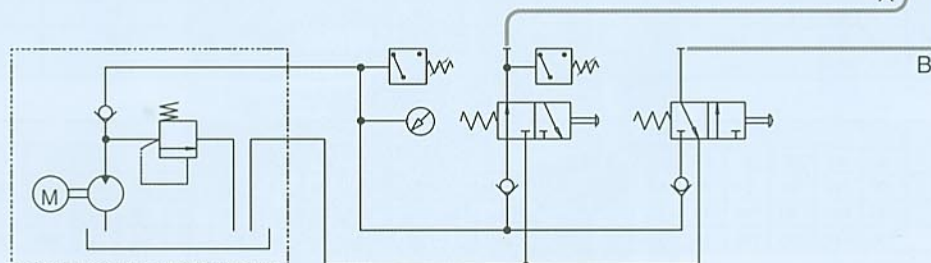
Z 100 H \varnothing 15 mm – \varnothing 120 mm
 Z 125 H \varnothing 22 mm – \varnothing 170 mm
 Z 160 H \varnothing 28 mm – \varnothing 224 mm



Z 100 H \varnothing 150 mm – \varnothing 260 mm
 Z 125 H \varnothing 180 mm – \varnothing 360 mm
 Z 160 H \varnothing 200 mm – \varnothing 450 mm



On request



1. Fitting key, positioning and mounting holes for standard and special jaws
2. Keyway across the length for positioning
3. Clamping edge for claws
4. Lubrication nipples and connections, respectively, for central lubrication
5. Oil ports G 1/4, A - clamping, B - unclamping
6. Mounting hole pattern: dimensions on request!



Installation (example)

For hydraulic oil supply, pump units working intermittently are preferred. In the clamped condition, the directional valves are idle, and the operating pressure is maintained by an integral check valve.

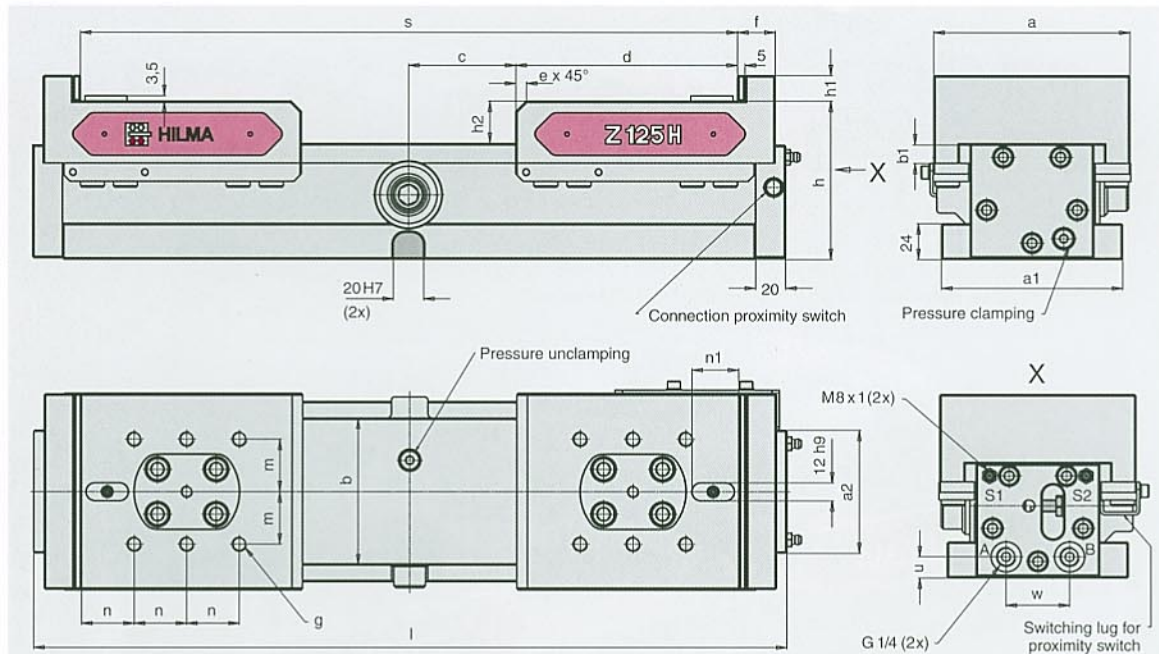
Two pressure switches (pump control and machine safety) monitor the adjusted operating pressure.

Clamping and unclamping can be controlled by hand-operated valves, by selector or foot-operated switch or, in fully automatically, by signals.



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Technical data

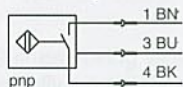


Connections: A - clamping, B - unclamping, S1 - oil lubrication slide 1, S2 - oil lubrication slide 2

Part no.	Type	Jaw width		Clamping force Operating pressure		Power stroke per slide	Oil consumption total stroke		Weight
		a		kN	bar		clamping	unclamping	
		mm							
9.3542.0201	Z 100 H	100	100	16	150	22	61	61	22
9.3543.0201	Z 125 H	130	120	25	150	35	138	138	39
9.3544.0201	Z 160 H	160	142	40	150	45	280	280	68

Type	Dimensions in mm																			
	a	a1	a2	b	b1	c	d	e	f	g	h	h1	h2	l	m	n	n1	s	u	w
Z 100 H	100	100	62	74	10	43	115	7	25	M 8x12	95	16	26	390	30	25	25	316	13	36
Z 125 H	130	120	82	98	13	71	147	7	25	M 10x15	105	17	28	500	35	35	32	436	14	42
Z 160 H	160	142	100	122	15	75	185	10	30	M 12x18	125	20	34	600	40	50	32	520	16	46

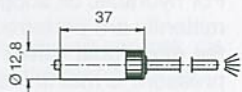
Proximity switch for limitation of the opening stroke



Operating voltage: 10 ... 30 VDC
Residual ripple: $W_{ss} \leq 10\%$
Max. operating current: 150 mA

Type of protection: IP 67
Temperature range: $-25^\circ\text{C} \dots +70^\circ\text{C}$
Switching output: NO-contact

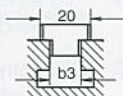
Connecting cable
with screw coupling,
5-pole



Part no. 5700.013
Part no. 5700.014

Cable length 5 m
Cable length 10 m

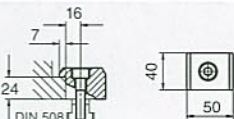
Set of tenon blocks
DIN 6323



1 set = 2 blocks
Part no. 9.3917.4121
Part no. 9.3917.4141

Slot in the machine bed 14h6 (b3)
Slot in the machine bed 18h6 (b3)

Set of clamping claws
with screws
M 12x45



For safe clamping on the machine bed
1 set = 4 claws
Part no. 9.3777.2011

Subject to change without notice. Printed in Germany

8.3540

HILMA-RÖMHELD GMBH

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