

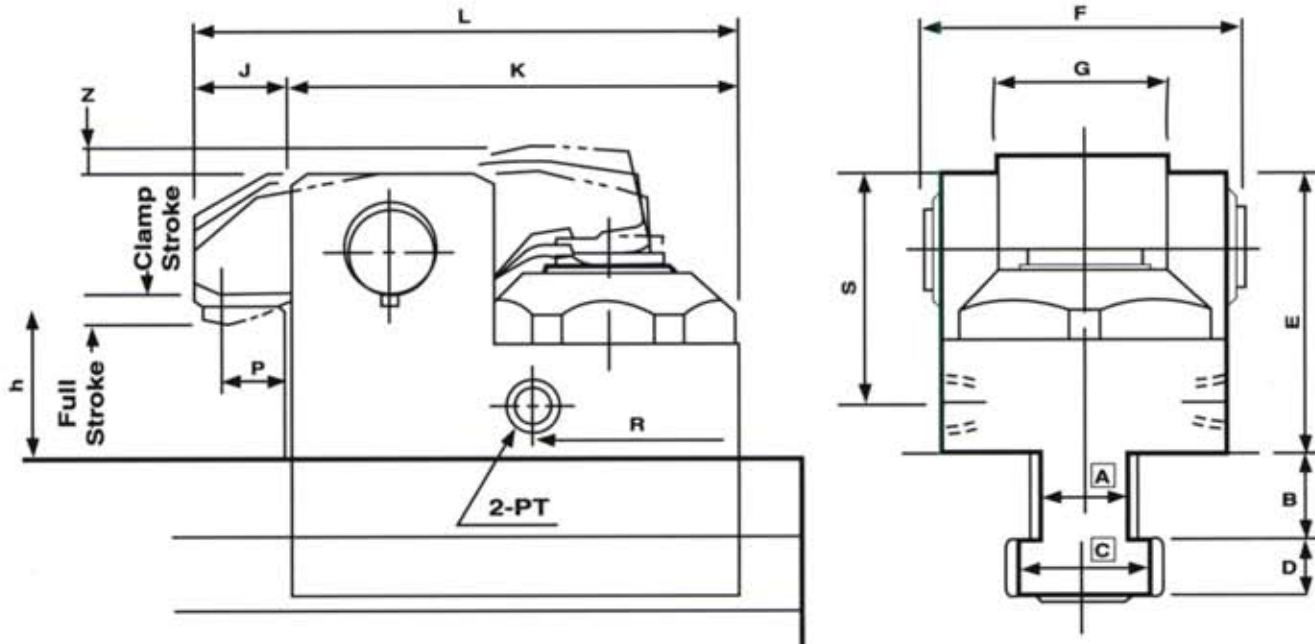
Features:

- 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 operation
- Hydraulic activation assures quick and effortless clamping
- Generous piston stroke allows for variations in die shoe thickness
- Compact jaw design requires minimal clamping surface

MODEL	HLC 10	HCL16	HCL25	HCL40	HCL63	HCL100	HCL160	HCL250
Clamping Force (at 3500 psi) tons	1.0	1.7	2.7	4.2	6.7	10.6	17.0	26.5
Full Stroke in.	.24	.28	.28	.28	.31	.31	.31	.31
Clamping Stroke in.	.12	.14	.14	.14	.16	.16	.16	.16
Cylinder Cap. @ Full Stroke cu.in.	.15	.29	.44	.73	1.32	2.12	3.37	5.34
Minimum T-slot "a" Dimension	.50	.50	.625	.750	8.75	1.00	1.25	1.50

Notes:

1. Clamping strokes and full strokes are for standard models; custom strokes available on request.
2. Dimensions A, B, C and D determined by T-slot dimensions.
3. Specify T-slot dimensions (a, b, c, d) and clamping height (h) when ordering.
4. Specify dimension "h" down to 0.20" increments.
5. Clamps with a dimension greater than Max. h are also optionally available.



Type	MIN E	F	G	J	K	L	h	P	R	S	PT
HLC 10	1.75	1.69	.79	.59	2.28	2.87	.75-1.125	.39	1.28	1.36	1/8
HLC 16	2.01	2.09	1.02	.71	2.76	3.46	.75-1.125	.49	1.46	1.61	1/8
HLC 25	2.32	2.48	1.26	.79	3.31	4.09	1.00-1.375	.55	1.71	1.85	1/4
HLC 40	2.68	2.87	1.57	.91	4.15	5.06	1.00-1.375	.63	2.02	2.20	1/4
HLC 63	3.19	3.66	1.97	1.18	5.12	6.30	1.125-1.875	.79	1.93	2.72	1/4
HLC 100	4.25	4.09	2.17	1.18	6.26	7.44	1.50-2.375	.79	2.64	3.74	1/4
HLC 160	5.12	4.92	2.36	1.18	7.83	9.02	1.75-2.625	.79	2.80	4.57	1/4
HLC 250	5.98	5.98	2.87	1.18	9.45	10.63	2.00-2.75	.79	2.73	5.31	1/4

Operation Procedure:

1. Visually inspect clamp for obvious defects and make certain that the hydraulic power supply is deactivated and that the clamp jaw is fully tipped back (hydraulic piston is its 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 jaw and the die surface to ensure that it does not exceed the full stroke of the clamp. **WARNING:** Clamp will not generate clamp force if gap exceeds the full stroke.
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 tons: _____

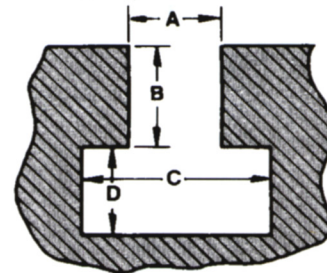
Weight of dies: _____ top _____ bottom

Clearance between ram and bolster (shut height): _____

T-Slot Dimensions

If standard: _____

- If not-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			Width D		
		Maximum	Minimum	Maximum (Basic)	Tolerance (Minus)	Minimum	Maximum (Basic)	Tolerance (Minus)	Minimum
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	1-3/16	31/64	0.031	29/64
3/4	13/16	1-1/16	9/16	1-15/32	0.094	1-3/8	5/8	0.031	19/32
1	1-1/16	1-1/4	3/4	1-27/32	0.094	1-3/4	53/64	0.047	25/32
1-1/4	1-5/16	1-9/16	1	2-7/32	0.094	2-1/8	1-3/32	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