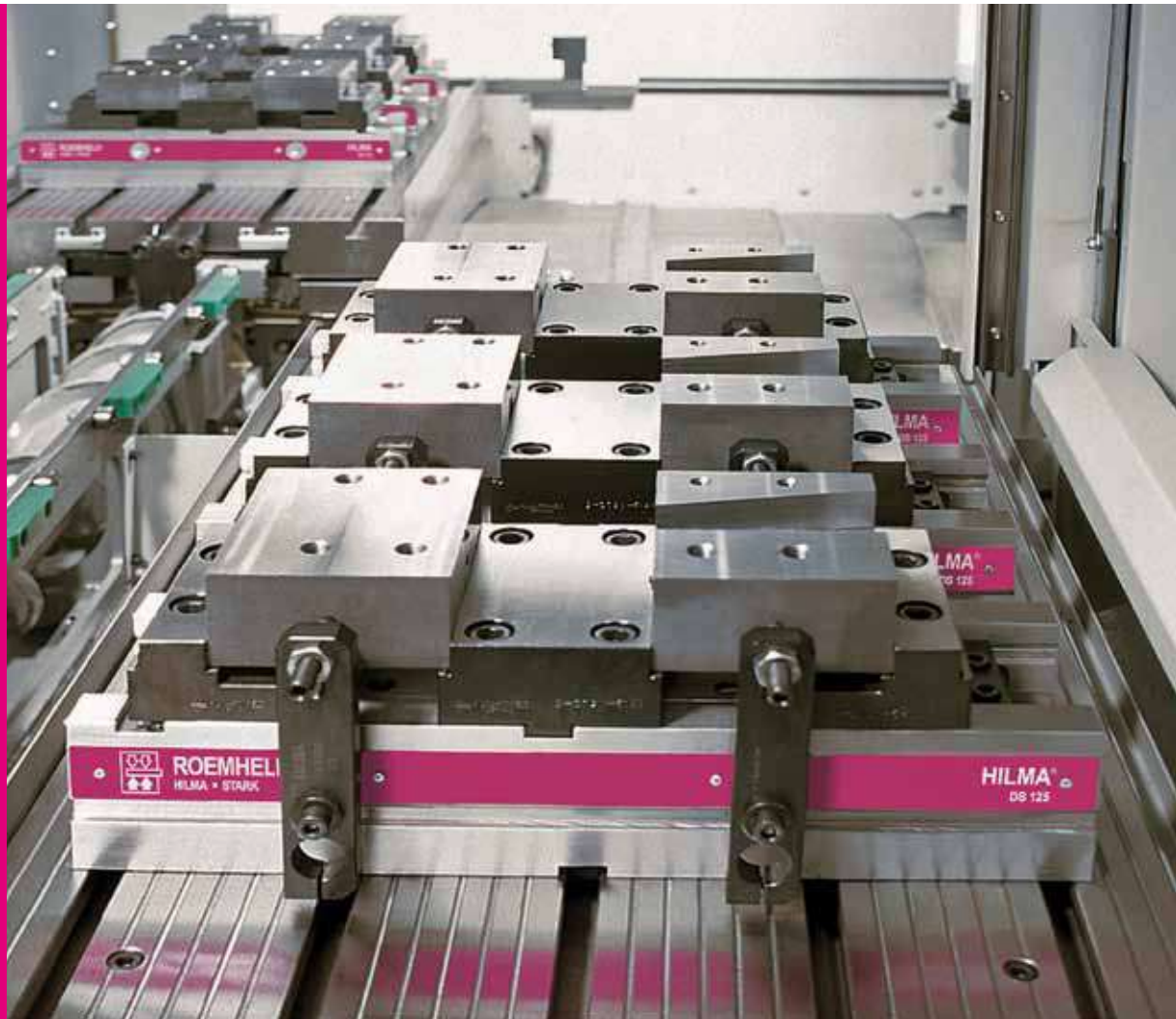




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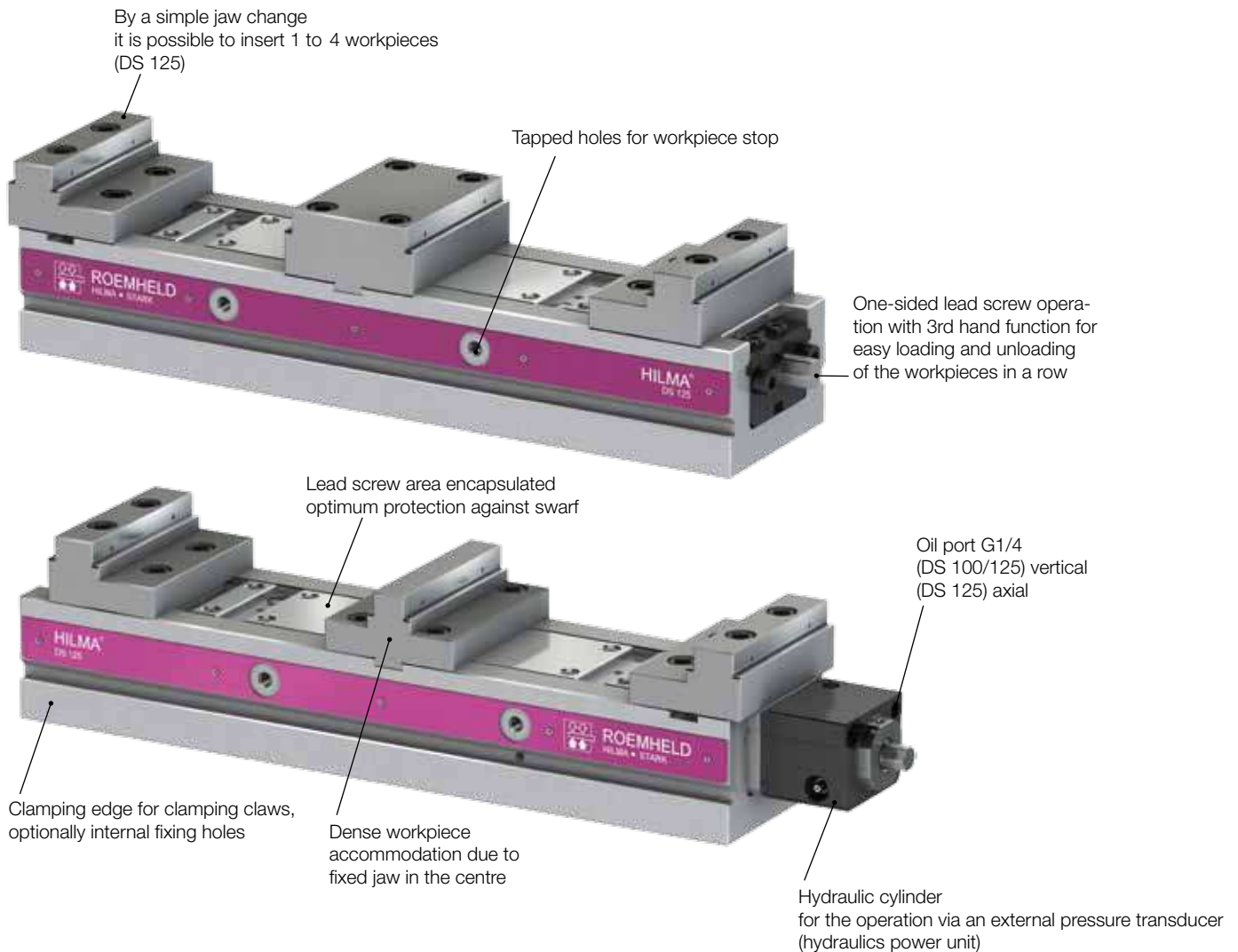


Workholding Systems

HILMA DS

3.3660

3.3680



Your benefits at a glance:

- ★ Flexible use
- ★ User friendly
- ★ Fixing on the machine table
- ★ High efficiency
- ★ Operation



DS 100 hydraulic



DS 125 mechanical
with floating central jaws



DS hydraulic arranged in a row for clamping of workpieces which require several clamping points. Can be automated.

With a corresponding jaw selection 1 to 4 workpieces (DS 125), also of different dimensions, can be clamped. This allows a high flexibility in series production.

The operation of all clamping points is made via one lead screw side. The 3rd hand function ensures a user-friendly and safe clamping of workpieces arranged in a row.

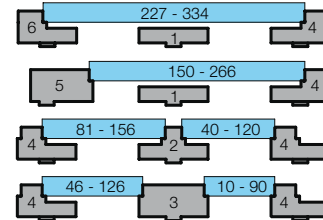
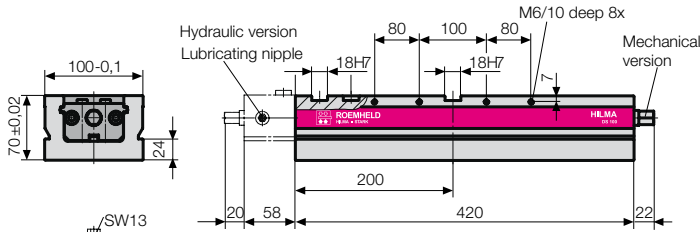
By means of the insertion of fixing holes, the double clamping system DS can be directly clamped through the base onto the machine table. Thus, disruptive clamping jaws are no longer required and a closer side-by-side arrangement of the clamping systems is possible.

The arrangement of a central fixed jaw does not only provide high precision (cancellation of clamping forces) but also results in considerable cost reduction due to less jaws.

For medium and large series with preferably short cycle times, the double clamping system DS enables the operation by a separate pressure transducer (hydraulic power unit). Therefore a user-friendly operation by means of a manual switch or foot switch is possible.



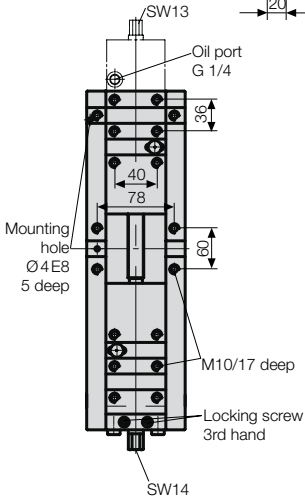
Double clamping system DS 100, hydraulically or mechanically operated



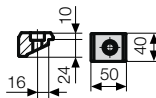
DS 100	mechanical	hydraulic
Clamping force / torque	25 kN / 55 Nm	25 kN / 400 bar
Clamping stroke per slide	44 mm	44 mm
Power stroke / oil volume	-	10 mm/8 cm ³ 5 mm/side
Weight without clamping jaws	19.5 kg	21 kg
Part no. standard	9.3665.0101	9.3685.0101
Part no.	Planned variant for customer-specific mounting and fixation on request.	

Pos.	Part no.	Description
1	9.3791.5140	Guide plate
2	9.3791.5111	Central step jaw 26 mm
3	9.3791.5121	Central step jaw 86 mm
4	9.3791.5211	Reversible step jaw
5	9.3791.5341	Fixed step jaw
6	9.3791.5311	Fixed step jaw

The standard clamping jaws allow the accommodation of 1 to 2 workpieces with identical or different dimensions.



All dimensions in mm



Set of clamping claws 4 off
with 4 screws DIN 912
Part no. **9.3777.2011**
for T-slot 14 mm



Torque wrench

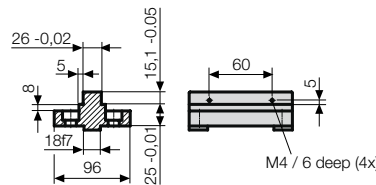
Part no.. **9.3792.6610**

20–120 Nm with reversible ratchet and square 1/2" with ball lock

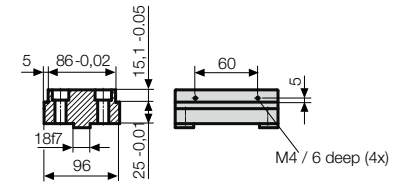
SW 14 socket wrench 1.3124.0020 mech.

DS 100 standard jaws, case-hardened and ground with 8 mm steps (free space for tools and swarf)
Supplied including fixing screws.

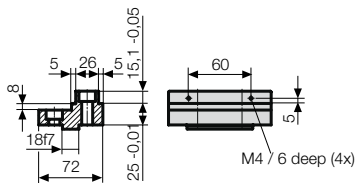
Mounting holes for all jaws KM 10
All dimensions in mm



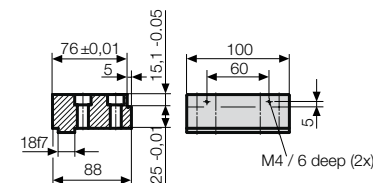
Central step jaw
Part no. **9.3791.5111**



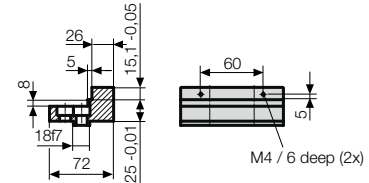
Central step jaw
Part no. **9.3791.5121**



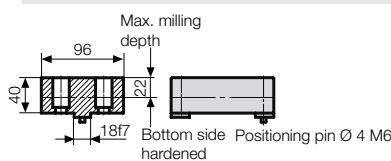
Reversible step jaw
Part no. **9.3791.5211**



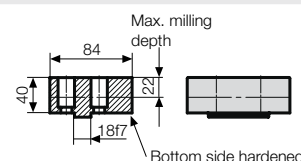
Fixed step jaw
Part no. **9.3791.5341**



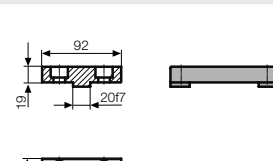
Fixed step jaw
for maximum clamping range
Part no. **9.3791.5311**



Central jaw, soft
Material C45
Part no. **9.3791.5411**



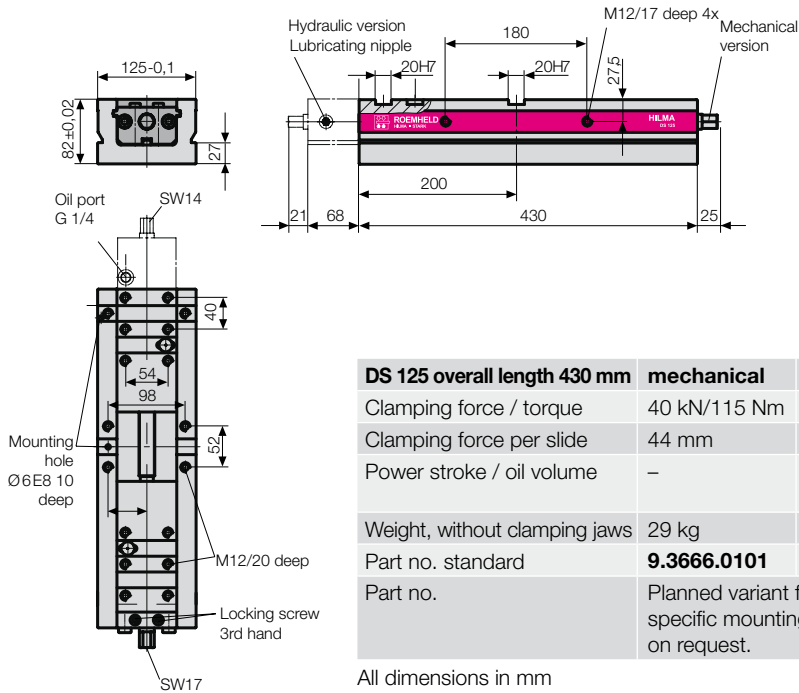
Reversible jaw, soft
Material C45
Part no. **9.3791.5421**



Guide plate
Part no. **9.3791.5140**

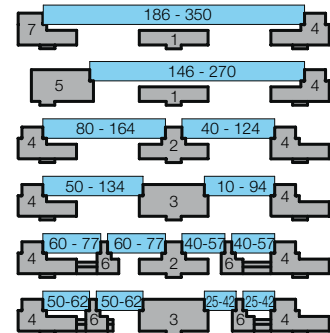


Double clamping system DS 125, overall length 430 mm, hydraulically or mechanically operated



DS 125 overall length 430 mm	mechanical	hydraulic
Clamping force / torque	40 kN/115 Nm	40 kN/400 bar
Clamping force per slide	44 mm	44 mm
Power stroke / oil volume	–	10 mm/10 cm ³ 5 mm/side
Weight, without clamping jaws	29 kg	32 kg
Part no. standard	9.3666.0101	9.3686.0101
Part no.	Planned variant for customer-specific mounting and fixation on request.	

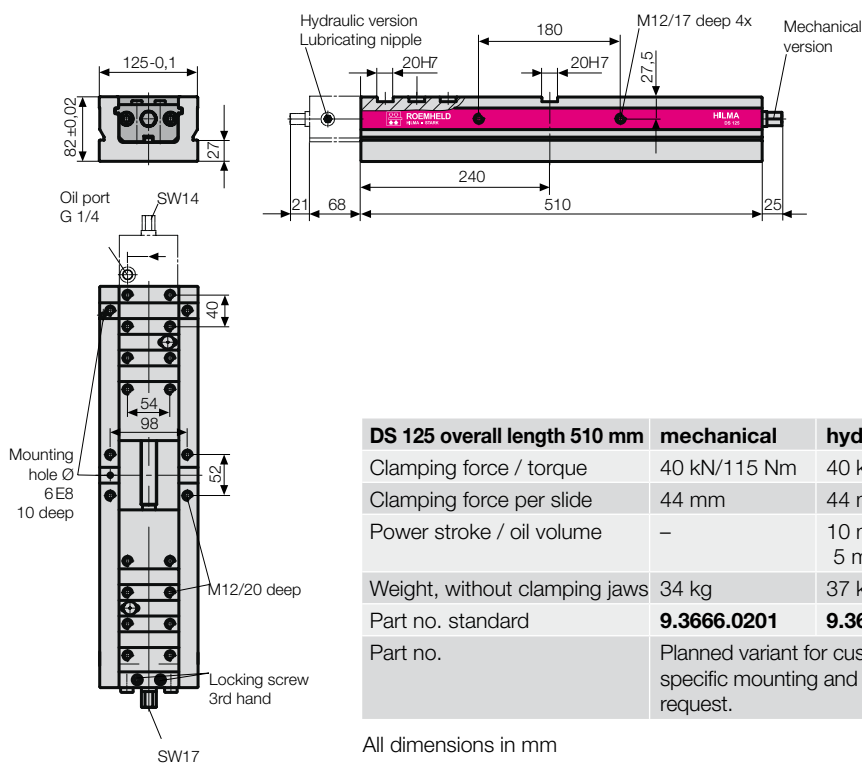
All dimensions in mm



Pos.	Part no.	Description
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	Reversible step jaw
5	9.3791.6341	Fixed step jaw
6	9.3791.6541	Floating central jaw
7	9.3791.6311	Fixed step jaw

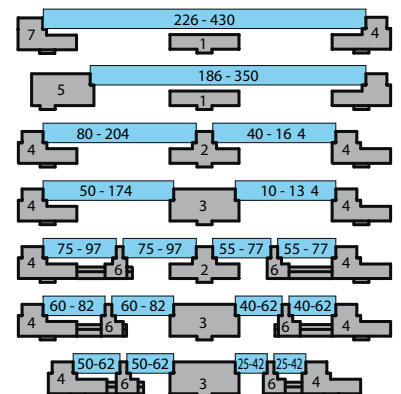
The standard clamping jaws allow the accommodation of 1 to 4 workpieces with identical or different dimensions.

Double clamping system DS 125, overall length 510 mm, hydraulically or mechanically operated



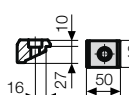
DS 125 overall length 510 mm	mechanical	hydraulic
Clamping force / torque	40 kN/115 Nm	40 kN/400 bar
Clamping force per slide	44 mm	44 mm
Power stroke / oil volume	–	10 mm / 10 cm ³ 5 mm/side
Weight, without clamping jaws	34 kg	37 kg
Part no. standard	9.3666.0201	9.3686.0201
Part no.	Planned variant for customer-specific mounting and fixation on request.	

All dimensions in mm



Pos.	Part no.	Description
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	Reversible step jaw
5	9.3791.6341	Fixed step jaw
6	9.3791.6511	Floating central jaw
7	9.3791.6311	Fixed step jaw

The standard clamping jaws allow the accommodation of 1 to 4 workpieces with identical or different dimensions.



Set of clamping claws 4 off with 4 screws DIN 912
 Part no. **9.3777.3011** M12 x 45 for T-slot 14 mm
 Part no. **9.3777.3021** M16 x 50 for T-slot 18 mm

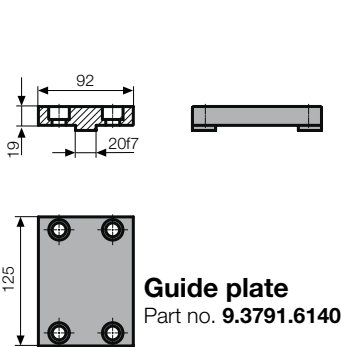


Torque wrench Part no. **9.3792.6610**

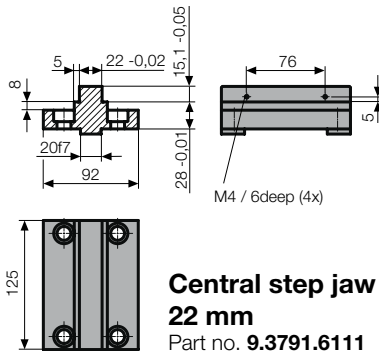
20–120 Nm with reversible ratchet and square 1/2" with ball lock
 SW 14 socket wrench **1.3124.0020** hydr.
 SW 17 socket wrench **1.3124.0017** mech.



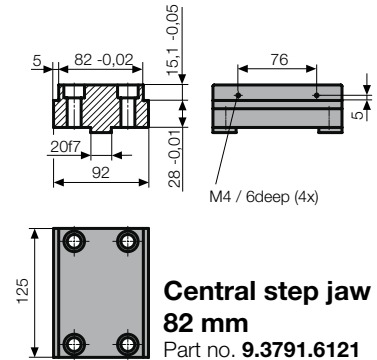
DS 125 standard jaws, case-hardened and ground with 8 mm steps (free space for tools and swarf). Supplied including fixing screws.



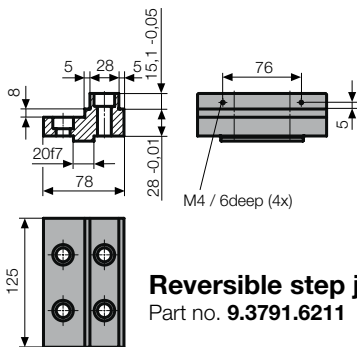
Guide plate
Part no. **9.3791.6140**



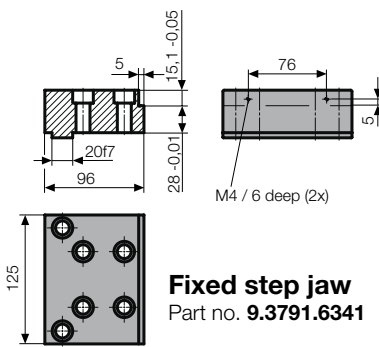
**Central step jaw
22 mm**
Part no. **9.3791.6111**



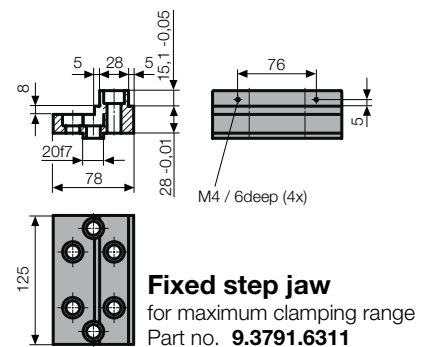
**Central step jaw
82 mm**
Part no. **9.3791.6121**



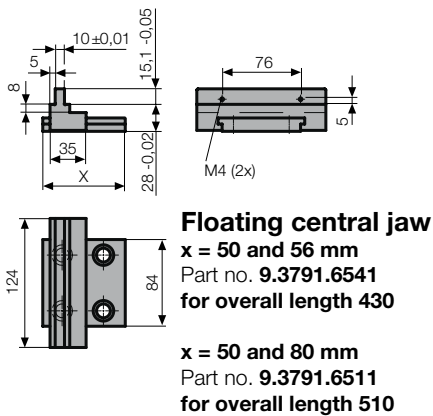
Reversible step jaw
Part no. **9.3791.6211**



Fixed step jaw
Part no. **9.3791.6341**



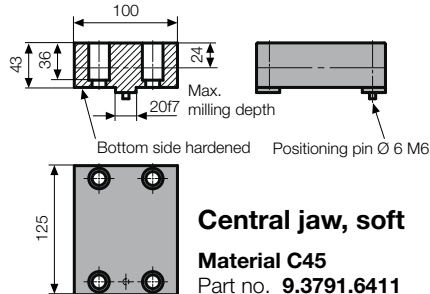
**Fixed step jaw
for maximum clamping range**
Part no. **9.3791.6311**



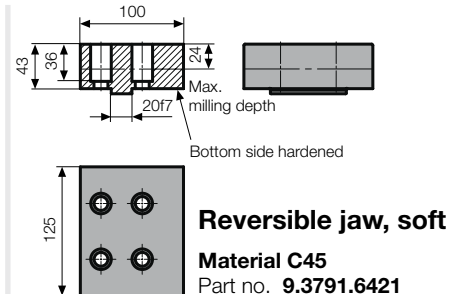
Floating central jaw
x = 50 and 56 mm
Part no. **9.3791.6541**
for overall length 430

x = 50 and 80 mm
Part no. **9.3791.6511**
for overall length 510

Standard clamping jaws, soft, for milling of workpiece contours, steps, stops, etc. Supplied including fixing screws.

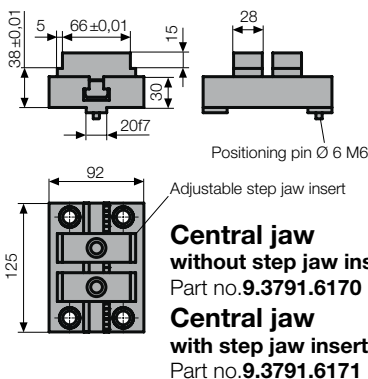


Central jaw, soft
Material C45
Part no. **9.3791.6411**



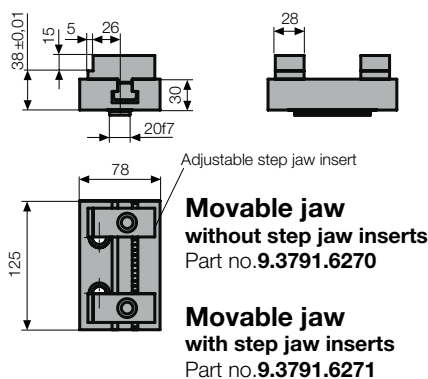
Reversible jaw, soft
Material C45
Part no. **9.3791.6421**

SlimFlex jaw system, case-hardened and ground with 8 mm steps (free space for tools and swarf). Supplied including fixing screws. The continuously adjustable jaw inserts ensure optimum tool access without the risk of collision. Smallest clamping dimension 26 mm.



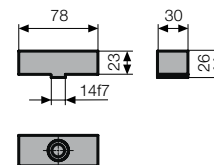
**Central jaw
without step jaw inserts**
Part no. **9.3791.6170**

**Central jaw
with step jaw inserts**
Part no. **9.3791.6171**



**Movable jaw
without step jaw inserts**
Part no. **9.3791.6270**

**Movable jaw
with step jaw inserts**
Part no. **9.3791.6271**



**Jaw insert made of
C45 steel soft,**
for SlimFlex jaw system
**for self-production of any
step dimensions**
Part no. **9.3285.8009**

Mounting holes for all jaws KM 12 all dimensions in mm



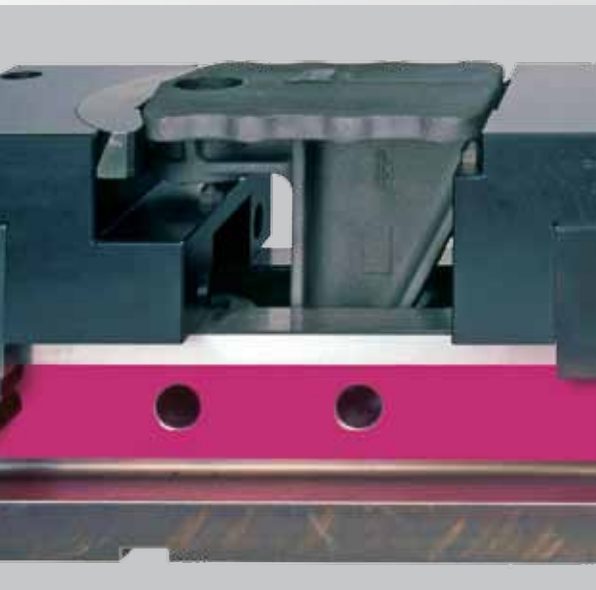


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KNC back to back



NC with clamping force display



NC with special clamping jaws



MC for 5-sided machining

Hilma-Römheld GmbH

Schützenstraße 74 · 57271 Hilchenbach, Germany
Phone: +49 27 33 / 281-0 · Fax: +49 27 33 / 281-169
E-mail: info@hilma.de · www.roemheld-group.com