Hydraulic Die Clamping Cylinders
Single Acting / Spring Return Pull Type

Description
- Die clamping cylinders are pull type, spring return cylinders. An integral ‘T’, suitable to 28mm ‘T’ Slot, is provided
to the piston rod of the cylinder.

Application
- These cylinders are widely used for the quick change of Dies & Tools on Presses.
- Max. working pressure : 200 kg/cm²

Operation
- For changing the tool, first the cylinder pressure is released and cylinders are
moved away from the tool, either manually or by a pneumatic cylinder.
After changing the tool, the cylinders are placed back at the clamping points
and are pressurized.

Important Notes
- Slot dimensions are as per DIN650.
- Cylinder stroke is only 8mm. Clamping height of different tools must be the
same with the tolerance of ±1 mm.
Specify dimension ‘H’ (clamping height of the tool), while ordering the
cylinder.
- For seal kits, add prefix SK to part no.

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>4650 – 411</th>
<th>4650 – 511</th>
<th>4650 – 611</th>
</tr>
</thead>
<tbody>
<tr>
<td>Force</td>
<td>50 kN</td>
<td>75 kN</td>
<td>105 kN</td>
</tr>
<tr>
<td>G</td>
<td>87</td>
<td>87</td>
<td>92</td>
</tr>
<tr>
<td>F</td>
<td>95</td>
<td>105</td>
<td>125</td>
</tr>
<tr>
<td>J</td>
<td>60</td>
<td>74</td>
<td>78</td>
</tr>
<tr>
<td>d</td>
<td>40</td>
<td>40</td>
<td>45</td>
</tr>
<tr>
<td>Oil Volume</td>
<td>20.73 cc</td>
<td>30.16 cc</td>
<td>42.99 cc</td>
</tr>
</tbody>
</table>

- All dimensions are in mm
- Overall dimensional tolerance ±0.5 mm