

FITTING

Initial fitting can be made into standard 'T' slots (TD) with standard or special sections according to the DIN 650 (see table 2). The angled 'T' slot holders (TB & TP) can be fitted to the Bridabloc body for special applications. For all applications the clamping body has to locate totally onto the table surface during clamping. Height adjustments are made via packing block (C) supplied for adaption to suit. Bridabloc can be fixed directly onto the table with integrated hydraulic feed.

Note

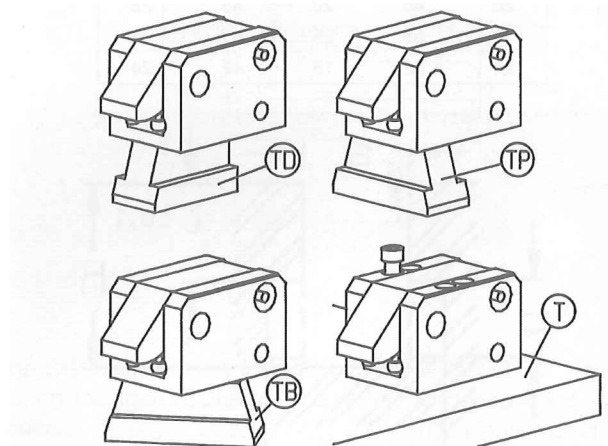
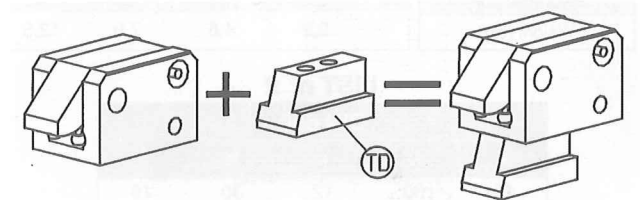
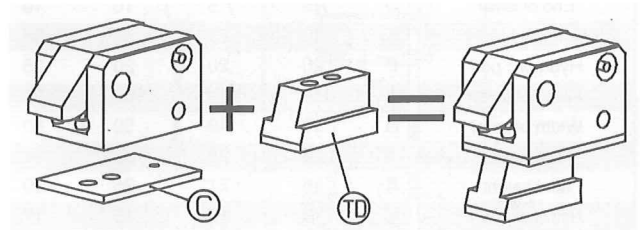
The assembly screws used for securing the clamp to the table, must be of the correct length and of a high resistance material. See technical note. The hydraulic Bridabloc HLC, using a constant pressure, directly linked to an exterior power pack, see page : hydraulic pressure generator for the available options, also for Bridabloc connections.

APPLICATION

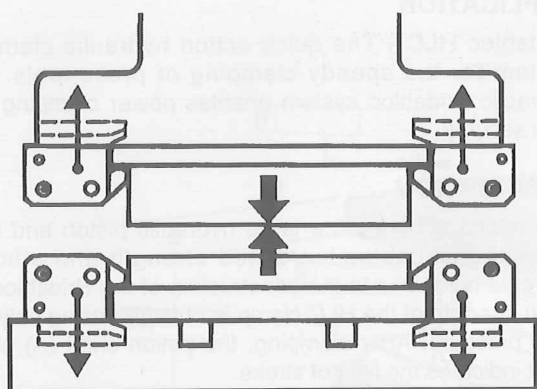
Bridabloc HLC - The quick action hydraulic clamping system for the speedy clamping of press tools. The hydraulic Bridabloc system enables power clamping with high security.

DESCRIPTION

The relations between a large hydraulic piston and lever gives the Bridabloc increased strength and efficient powerful hold. Due to the construction of the Bridabloc the great strength of the HLC clamp is obtained using only 250 bars pressure. After clamping, the pinion shaft (A) of the lever indicates the limit of stroke.



Dimensions and information may be modified

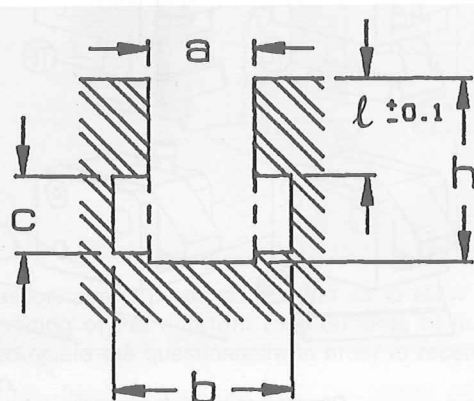


LIST n° 1

Specifications	HLC 20 K	HLC 40 K	HLC 60 K	HLC 100 K
Force Kg (DaN)	2000	4000	6000	10000
Pressure (Bar)	250	250	250	250
Oil volume (cm³)	4	7	11	18
Height of body	A 60	75	90	105
Length of body	B 90	105	120	150
Nominal point	C 15	17	20	22
End of lever	D 7,5	7,5	10	10
Nominal height	E 20	25	30	35
Hydraulic port	F 20	20	20	25
Width of body	G 60	80	100	120
Width of lever	H 30	40	50	60
Maxi height	J 22	28	33	38
Mini height	K 16	21	25	30
Hydraulic port	L 13	15	15	17
Hydraulic port	M 1/4 BSPP	1/4 BSPP	1/4 BSPP	1/4 BSPP
Hydraulic port	N 24	26	30	40
Weight (Kg)	2,2	4,6	7,9	12,5

LIST n° 2

DIN 650				
a	b	c	h	ℓ
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24



LOAD OF CLAMPING

The clamp load required is defined by different main parameters, tool weight, strokes per minute of the press, rigidity of press frame, material to be used, pull back etc. One can approximate the clamp force at 15 to 20% of the press capacity. (about 15% for the double sided press, and 20% for open front forging press). This strength should be divided by the total number of clamps. By this method you arrive at a figure for the required clamping strength per clamp.

Example: Press capacity: 160 tonnes Number of clamps on the slide: 4

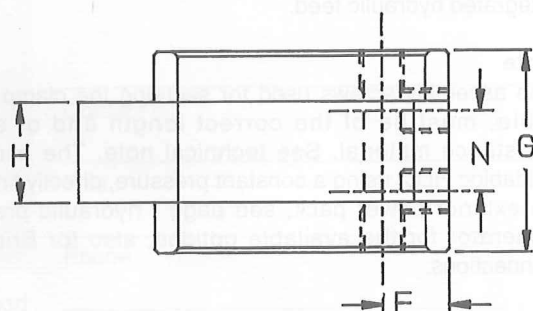
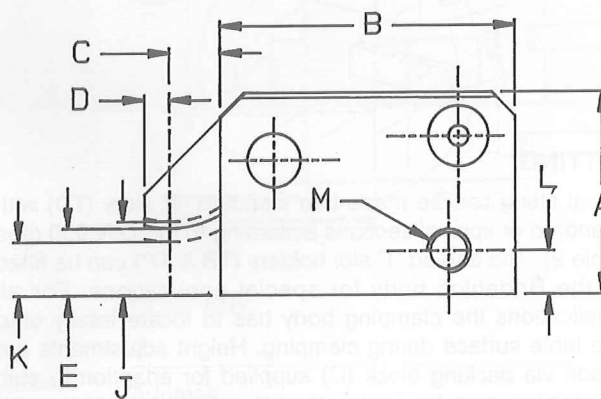
Number of clamps on the table: 4

Total force: 160 x 0.015 : 24 tonnes . Clamp strength: 24/8 : 3 tonnes

If the stripping forces are very important, you will add them to the force F.

Clamping force F for each enters into the coding of the clamp.

Note - A constant check of the mechanical and hydraulic components is advised in order to prevent unnecessary breakdown.

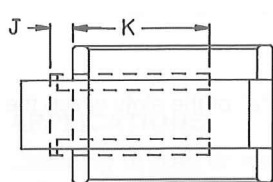


Dimensions and information may be modified

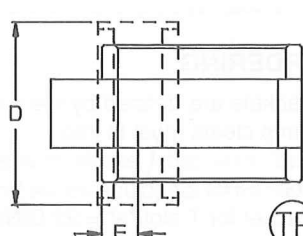
LIST n° 3

Models	Clamps	D	E	F	G	H	J	K	M	N	P	R	Grooves				Shims C
													18	22	28	36	
adaptator TD	20 K						10	60									
	40 K						10	70									
	60 K						10	80									
	100 K						10	95									
adaptator TP	20 K	80	14														
	40 K	100	14														
	60 K	120	18														
	100 K	140	18														
adaptator TB	20 K								32	55	90						
	40 K								39	50	118						
	60 K								45	54	138						
	100 K								53	52	164						
Table Securing	20 K			31	15	45						M 8					
	40 K			36	18	60						M10					
	60 K			38	20	75						M12					
	100 K			49	24	90						M14					

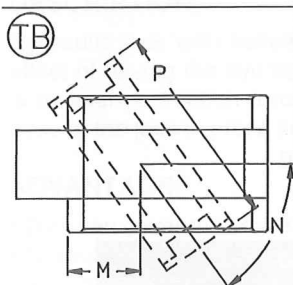
See the table 3 for the sizes of fitting and standard T.SLOTS for different BRIDABLOC types.



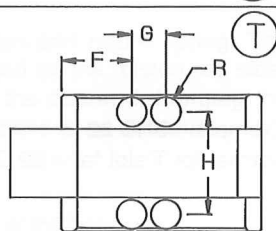
(TD)



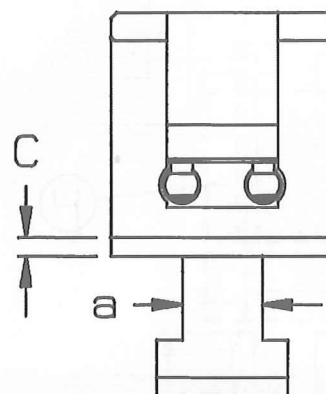
(TP)



(TB)



(T)



CODIFICATION OF AN ORDER

Fill Up the following table :

1	2	3	4
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Note the following ref. for the BRIDABLOC order :

1 Choose the force according to the need (table I)

Example : BRIDABLOC 20L (clamp strength 2000 kg)
REF. 20K

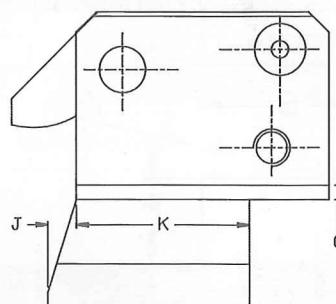
2 Choose the type of clamp according to the groove or the need (table 2 or 3) Example : straight T.SLOT for groove a : 22 according to the DIN 650 REF. TD.22

3 Choose the standard shim, thickness 10 mm
REF. C10 (if it is necessary).

4 For a special T.SLOT, note the groove sizes a, l, c, d.
Example : special T.SLOT for groove a : 20 l : 18 - c : 15 - b : 29

REF. TS a 20 - l 18 - c 15 - b 29

General example : BRIDABLOC HLC 20K TD22 C10



The SHS are advised for hanging the BRIDABLOC break during the tool changeover. See the SHS pages for the choice.

NOTE

The size "l" must be given with a precision : ± 0.1 mm

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