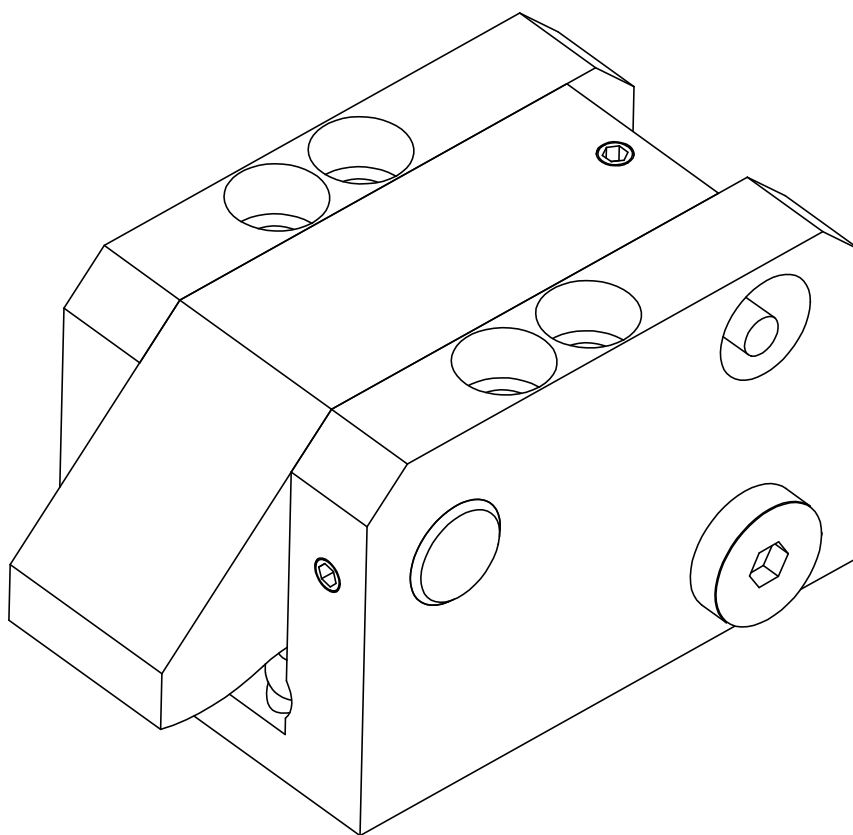


NOTICE TECHNIQUE *USER MANUAL*

BRIDES HLC ***HLC CLAMP***

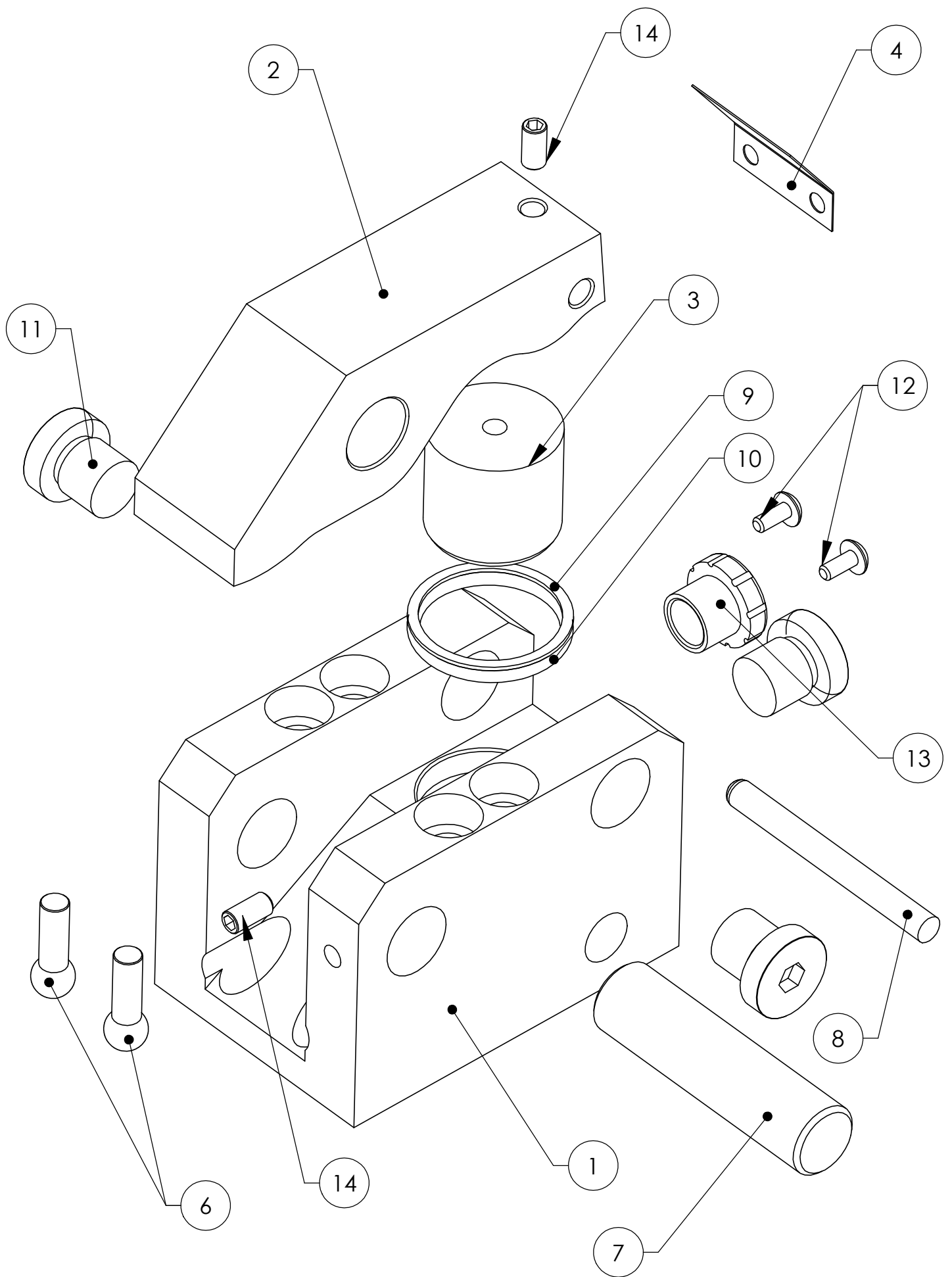


ROTOBLOC-PSP
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25480 PIREY

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Fax 03 81 53 80 80

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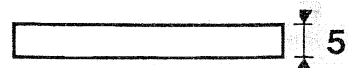
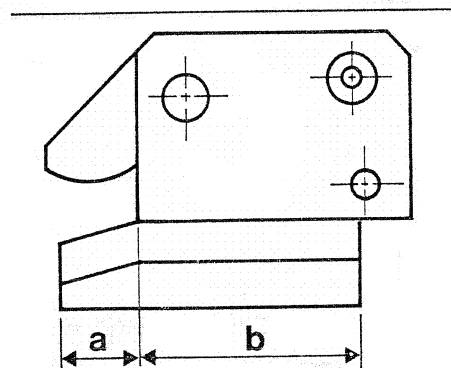
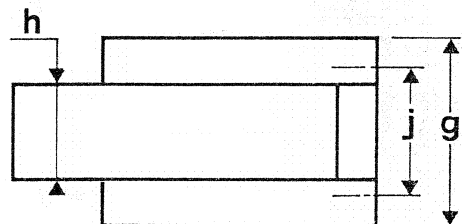
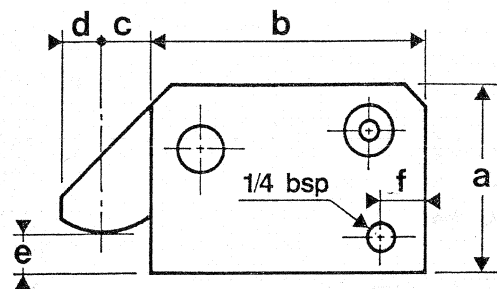


REP	Designation					
	HLC 20K	HLC 40K	HLC 60K	HLC 100K	NB/Qty	Français English
1	R 1031	R 1074	R 1071	R 1060	1	CORPS DE BRIDE CLAMP BODY
2	R 3653	R 3654	R 3655	R 3656	1	MORS DE BRIDE JAW
3	R 1034	R 1080	R 1066	R 1055	1	PISTON PISTON
4	R 3657	R 3658	R 3859	R 3860	1	PROTECTEUR SHIELD
5	64 SR CXF 10*38	64 SR CXF 10*25	64 SR CXF 13*51	64 SR CXF 13*76	2	RESSORT DE RAPPEL RETURN SPRING
6	R 1038	R 1038	R 1163	R 1163	2	VIS DE RAPPEL ADJUSTING SCREW
7	R 1037	R 1081	R 1064	R 1058	1	AXE DE CLAME JAW SHAFT
8	02 SR 0660	02 SR 0880	02 SR 10100	02 SR 12120	1	GOUPILLE PIN
9	81 SR 262*2824 N9	81 SR 353*3769 N9	81 SR 353*4404 N9	81 SR 353*5674 N9	1	BAGUE ANTI-EXTRUSION ANTI EXTRUSION RING
10	80 SR 262*2824 N7	80 SR 353*3769 N7	80 SR 353*4536 N7	80 SR 353*5674 N7	1	JOINT TORIQUE PISTON GASKET
11	R 1129	R 1129	R 1129	R 1129	3	BOUCHON HYDRAULIQUE HYDRAULIC CAP
12	16 SR 0408	16 SR 0408	16 SR 0408	16 SR 0408	2	VIS SCREW
13	R 1128	R 1128	R 1128	R 1128	1	CAPUCHON CAP
14	11 SR 0608	11 SR 0610	11 SR 0620	11 SR 0620	2	VIS SCREW

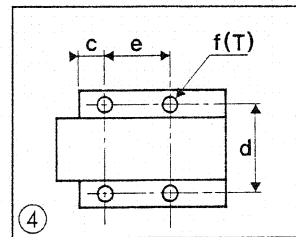
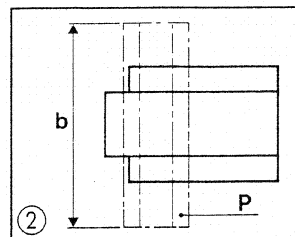
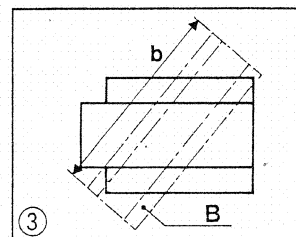
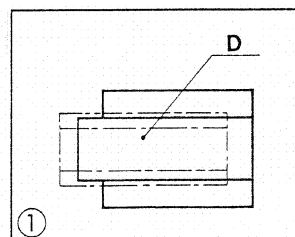
- CARACTERISTIQUES -

Strength
Pressure
Opening
stroke
Tightening
stroke
Oil quantity

CARACTÉRISTIQUES		TYPE DE BRIDE			
		HLC 20 K	HLC 40 K	HLC 60 K	HLC 100 K
Force	kN	20	40	60	100
Pression	bar	250	250	250	250
COURSE d'ouverture	mm	2	3	3	3
COURSE de serrage	mm	4	4	5	5
Volume d'huile	cm ³	4	7	11	18
a	cm	60	75	90	105
b		90	105	120	150
c		15	17	20	22
d		7,5	7,5	10	10
e		20	25	30	35
f		20	20	20	25
g		60	80	100	120
h		30	40	50	60
i		24	26	30	40



VERSIONS	Brides	a	b	c	d	e	f	RAINURES				CALES
								18	22	28	36	
Tasseaux D	20 K	25	65									
T-bolt D	40 K	25	80									
	60 K	25	100									
	100 K	25	120									
Tasseaux P	20 K		100									
T-bolt P	40 K		120									
	60 K		140									
	100 K		160									
Tasseaux B	20 K		110									
T-bolt B	40 K		140									
	60 K		160									
	100 K		185									
Fixation table	20 K			31	45	15	M10					
	40 K			36	60	18	M10					
	60 K			39	75	20	M12					
	100 K			49	90	24	M14					



INFORMATIONS



IMPORTANT

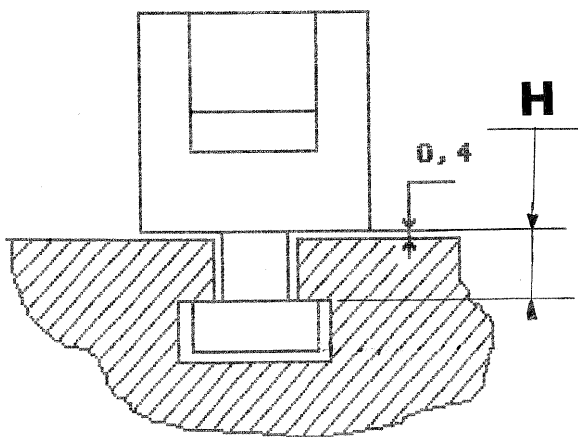
- DON'T USE THE CLAMP BEFORE READING THE MANUAL.
- DO NOT MODIFY THIS CLAMP.
- TO USE, MAINTAIN AND ADJUST THE CLAMP, READ THIS MANUAL FIRST.
- FOLLOW THE SAFETY ADVICES.

SPECIFICATIONS

- SCREW CLASS 14-9 (NF - A35-557 - DIN 912)
- SCREW TIGHTENING TORQUE:
 - * M10 = 70 Nm (For HLC 20 K and 40K)
 - * M12 = 120 Nm (For HLC 60K)
 - * M14 = 190 Nm (For HLC 100K)

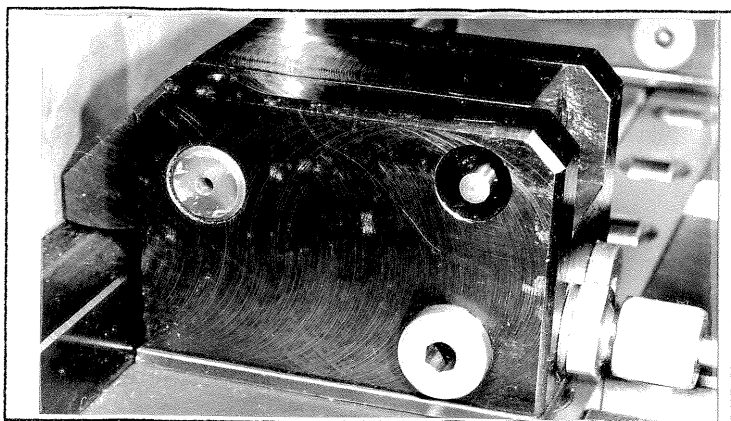
MOUNTING SCREWS: LOCTITE 242
Anaerobic glue

(R = 140 daN/mm² - 14-9 class)



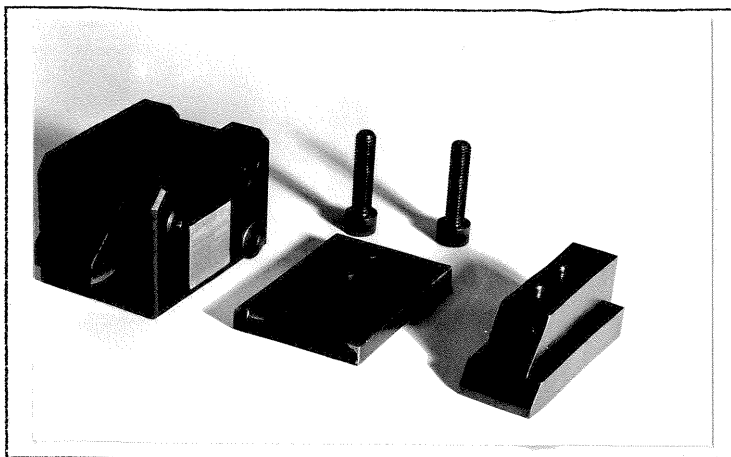
MOUNTING CLAMP:

- In clamping position, the gap between the clamp and the table must be 0.4 mm
- Modify the H dimension of the T-Bolt if necessary



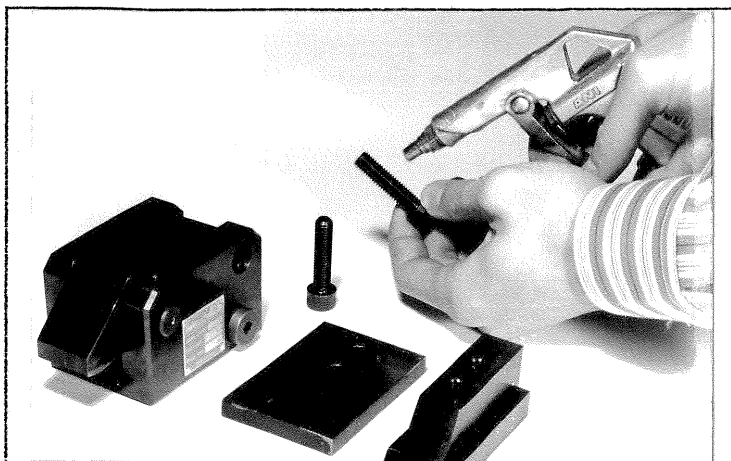
ADJUSTING THE HIGH:

- Do not put more than 2 leveling wedges between the T-Slot and the clamp
- Machine a special leveling wedge if necessary



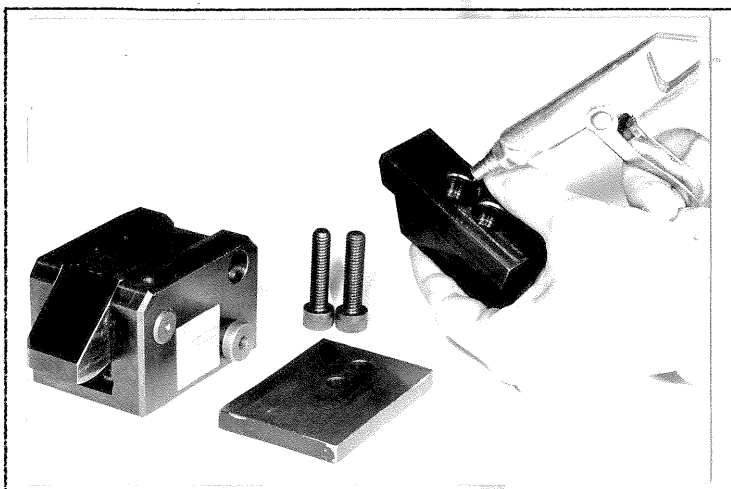
ASSEMBLY CLAMP-T-BOLT:

- This assembly is made with the specified screws.
- When disassembling, respect the following instructions.



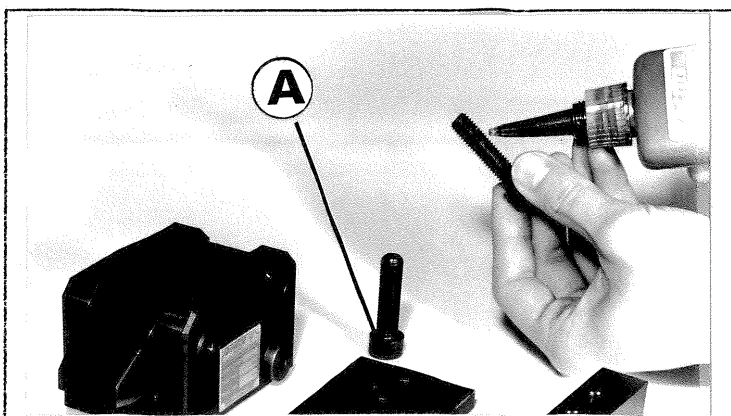
DISASSEMBLING T-BOLT:

- Unscrew and remove the fixing screws from the T-bolt
- Clean and dry the screws and the thread

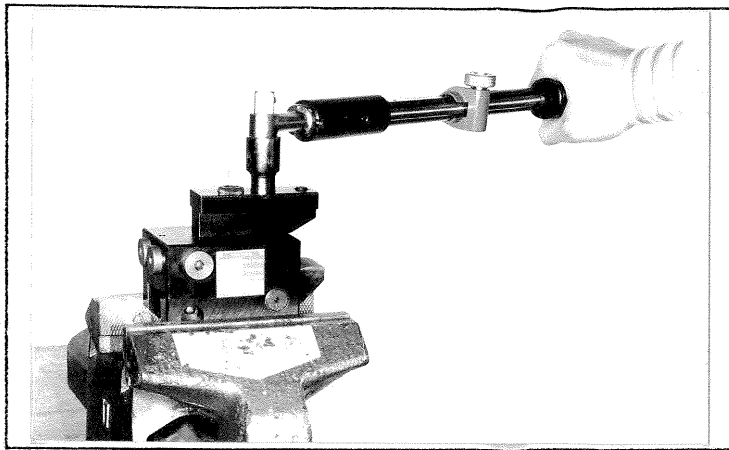


RESASSEMBLING T-BOLT:

- Clean and dry carefully the screws and the contact faces (Body, T-Bolt, screws)
- Check that the length of the screw in the body once mounted, is $1.5 \times$ the diameter of the screw



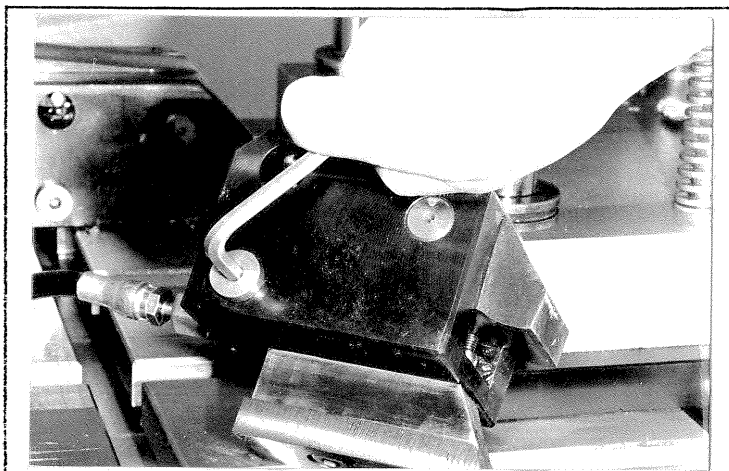
- Grease slightly under the screw head A
- Put some LOCTITE glue on the screw thread



- Put the clamp in a vice
- Screw with the requested torque, beginning with the screw in front of the jaw

WARNING:

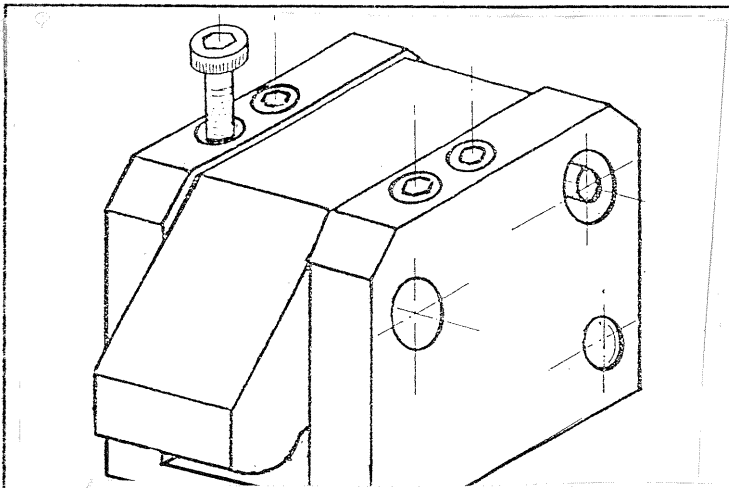
Use a torque wrench to use the correct tightening torque



BLEEDING THE CLAMP:

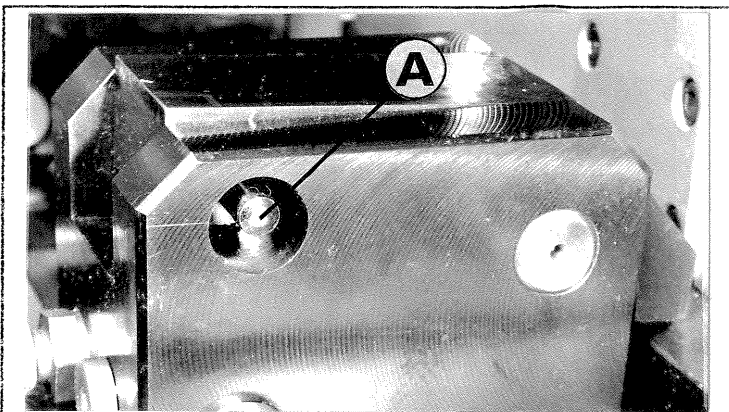
WHEN UNDER PRESSURE FOR THE FIRST TIME, YOU HAVE TO BLEED THE CLAMP :

- Remove the pressure (with the hydraulic drive)
- Loosen the cap and tilt the clamp
- Put under pressure, bleed the air
- Tighten the cap on the clamp



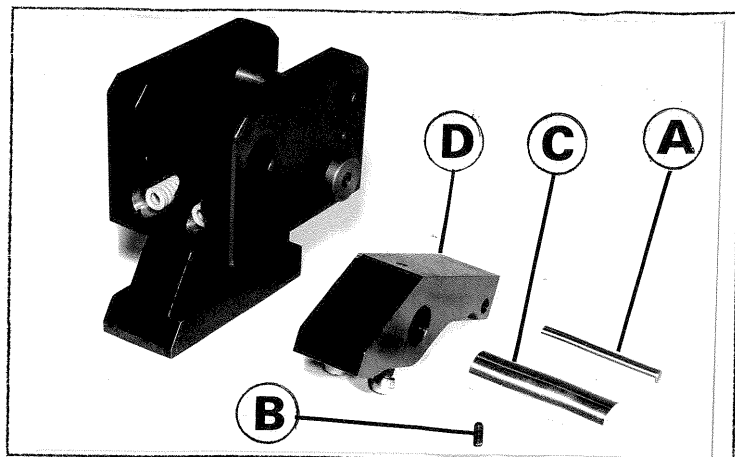
FASTENING THE CLAMP ON THE TABLE:

The clamps fastened on the table must be mounted with the same conditions of cleanness and tightening than indicated in the paragraph "Reassembling T-Bolt"



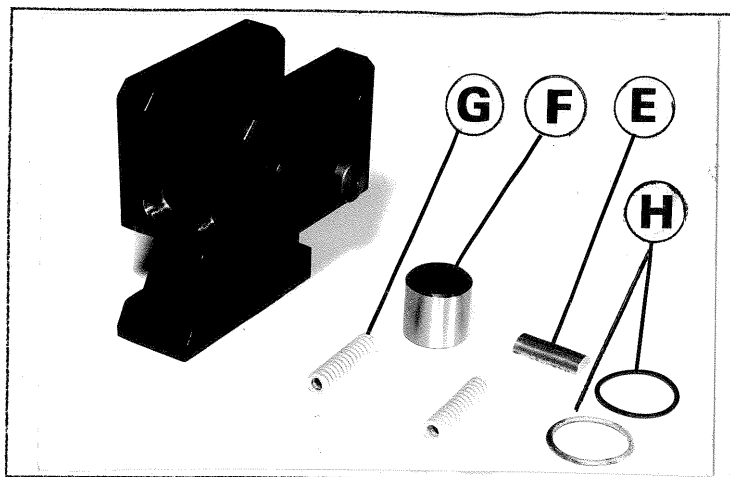
USING THE CLAMP

- The conditions of use must respect the clamp characteristics
- After every clamping, check the remaining tightening stroke with the position of the pin A

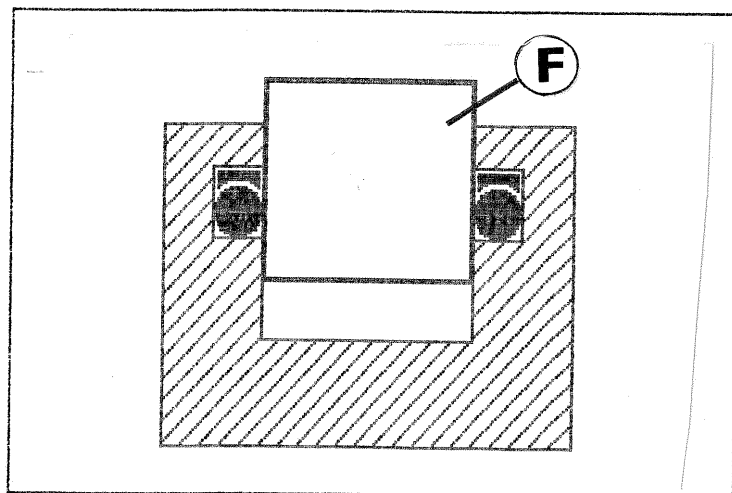


UNMOUNTING THE CLAMP:

- Remove the A pin
- Remove the B tightening screw
- Remove with a presse the C shaft
- Remove the D jaw

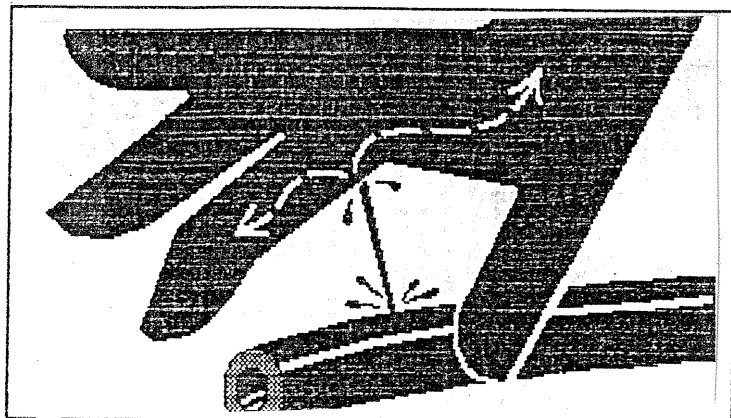


- Remove the E pin (in some versions)
- Remove the F piston
- Remove the G springs
- Remove the H gaskets which are in the body bore



REASSEMBLING THE CLAMP:

- **IMPORTANT** - You have to put new gaskets after unmounting .
- Lubricate and reassemble the gaskets as indicated
- Grease the C shaft and the F piston
- Reassemble in the reverse way
- Bleed the clamp.



WARNING:

Oil projection under high pressure can cause severe damage and serious poisoning.

YOU ARE UNDER THE OBLIGATION TO SEE A DOCTOR IN THIS CASE