

Item description/product images



Calculating the effective clamping force with hydraulic rotary lever clamps:

Effective clamping force F_{Sp} is dependent on piston force F_{Kol} and tension lever length L .

Calculation:
 Clamping force $F_{Sp} = \frac{F_{Kol} \times L5}{L}$
 Clamping force $F_{Sp} = \frac{2.5 \text{ kN} \times 10 \text{ mm}}{18 \text{ mm}} = 1.39 \text{ kN}$

Example:
 Rotary lever clamp cylinder size 16
 Operating pressure 100 bar
 Piston force F_{Kol} at 100 bar = 2.5 kN
 Dimension L5 acc. to table = 10 mm
 Tension lever length $L = 18 \text{ mm}$
 Resulting effective clamping force $F_{Sp} = 1.39 \text{ kN}$

Calculating the effective clamping force with pneumatic rotary lever clamps:

Effective clamping force F_{Sp} is dependent on piston force F_{Kol} and tension lever length L .

Calculation:
 Clamping force $F_{Sp} = \frac{F_{Kol} \times L3}{L}$
 Clamping force $F_{Sp} = \frac{1.99 \text{ kN} \times 25 \text{ mm}}{45 \text{ mm}} = 1.11 \text{ kN}$

Example:
 Rotary lever clamp cylinder size 40
 Operating pressure 6 bar
 Piston force F_{Kol} at 6 bar = 1.99 kN
 Dimension L3 acc. to table = 25 mm
 Tension lever length $L = 45 \text{ mm}$
 Resulting effective clamping force $F_{Sp} = 1.11 \text{ kN}$

Description

Product description:

The tension lever can be used for the hydraulic rotary lever clamp 04624-20 or the pneumatic rotary lever clamp 04624-19. The "standard" tension lever or the "blank" tension lever can be selected. The "standard" tension lever is finish machined and can be mounted directly. The "blank" tension lever can be individually machined to suit. The blank lever is made from unhardened steel for easier machining. After the individual contour has been machined, the tension levers must be annealed and hardened before mounting to prevent deformation of the levers during use.

Material:

Standard and blank steel.

Version:

Standard hardened.

Blank not hardened.

Note:

By positioning the rotary lever clamp correctly, workpiece tolerances can be optimally compensated for despite the short clamping lever.

The clamping elements must be checked regularly for dirt and cleaned if necessary.

The effective clamping force must be calculated for every tension lever.

The optimum tension lever position is 90°.

The following hardness grade must be achieved before a "blank" tension lever is used: Hardened depth 0.3 + 0.2 HRC 50 +/- 2.

Follow safety instruction.

Assembly:

The tension lever is attached to the piston of the rotary lever clamp and secured with a dowel pin. The tension lever is thus axially secured and secured against rotation.

On request:

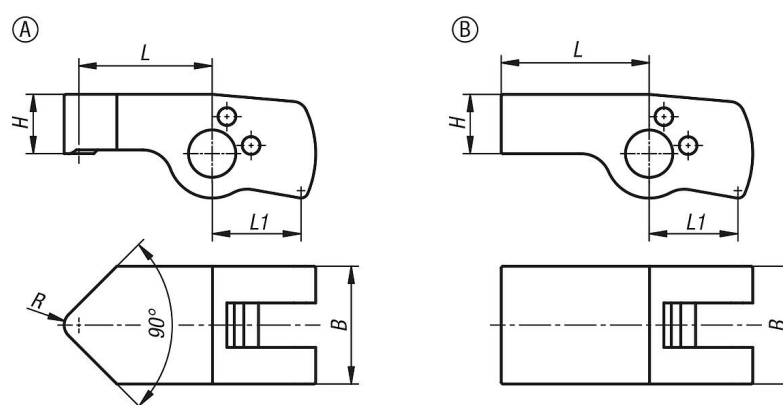
Other sizes and types.

Drawing reference:

Form A: Standard

Form B: Blank

Drawings



Overview of items

Order No.	Form	Form definition	For piston Ø	travel	B	H	L	L1	R
04624-30-12091	A	0.048	12	0,98	12	6	9	9	1,5
04624-30-12131	A	0.048	12	1,12	12	6	13,5	9	1,5
04624-30-12181	A	0.048	12	1,97	12	6	18	9	1,5
04624-30-12221	A	0.048	12	2,45	12	6	22,5	9	1,5
04624-30-16121	A	0.048	16	0,78	16	8	12	12	2
04624-30-16181	A	0.048	16	1,16	16	8	18	12	2
04624-30-16241	A	0.048	16	1,6	16	8	24	12	2
04624-30-16301	A	0.048	16	1,94	16	8	30	12	2
04624-30-20151	A	0.048	20	1,48	20	10	15	15	2,5
04624-30-20221	A	0.048	20	2,21	20	10	22,5	15	2,5
04624-30-20301	A	0.048	20	2,95	20	10	30	15	2,5
04624-30-20371	A	0.048	20	3,68	20	10	37,5	15	2,5
04624-30-25191	A	0.048	25	1,26	25	12,5	19	18,8	3
04624-30-25281	A	0.048	25	1,86	25	12,5	28	18,8	3
04624-30-25381	A	0.048	25	2,52	25	12,5	38	18,8	3
04624-30-25471	A	0.048	25	3,12	25	12,5	47	18,8	3
04624-30-32241	A	0.048	32	2,56	32	16	24	24	4
04624-30-32361	A	0.048	32	3,85	32	16	36	24	4
04624-30-32481	A	0.048	32	5,13	32	16	48	24	4
04624-30-32601	A	0.048	32	6,4	32	16	60	24	4
04624-30-40301	A	0.048	40	3,05	40	20	30	30	5
04624-30-40451	A	0.048	40	4,6	40	20	45	30	5
04624-30-40601	A	0.048	40	6,1	40	20	60	30	5
04624-30-40751	A	0.048	40	7,6	40	20	75	30	5
04624-30-12152	B	programmed	12	1,64	12	6	15	9	-
04624-30-12242	B	programmed	12	2,62	12	6	24	9	-
04624-30-16202	B	programmed	16	1,29	16	8	20	12	-
04624-30-16322	B	programmed	16	2,07	16	8	32	12	-
04624-30-20252	B	programmed	20	2,45	20	10	25	15	-
04624-30-20402	B	programmed	20	3,92	20	10	40	15	-
04624-30-25312	B	programmed	25	2,1	25	12,5	31	18,8	-
04624-30-25502	B	programmed	25	3,32	25	12,5	50	18,8	-
04624-30-32402	B	programmed	32	4,28	32	16	40	24	-
04624-30-32642	B	programmed	32	6,84	32	16	64	24	-
04624-30-40502	B	programmed	40	5,08	40	20	50	30	-
04624-30-40802	B	programmed	40	8,1	40	20	80	30	-

