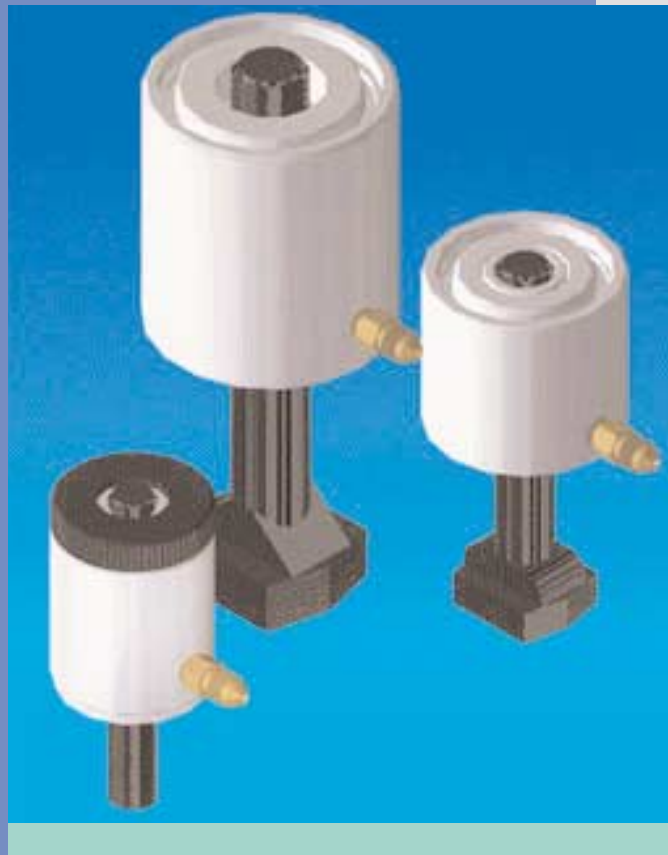


**American Aerostar
Corporation**

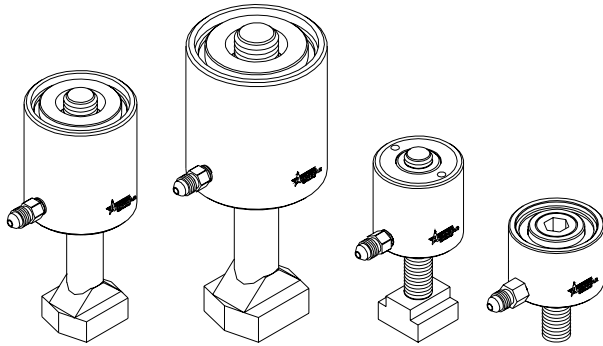
**Hydraulic Nuts
Hollow Piston Style Clamps**



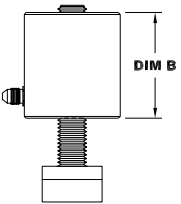
**A leading manufacturer
of equipment for
Quick Die Change**

Hydraulic Nuts

Model-200; 201; 205; 206



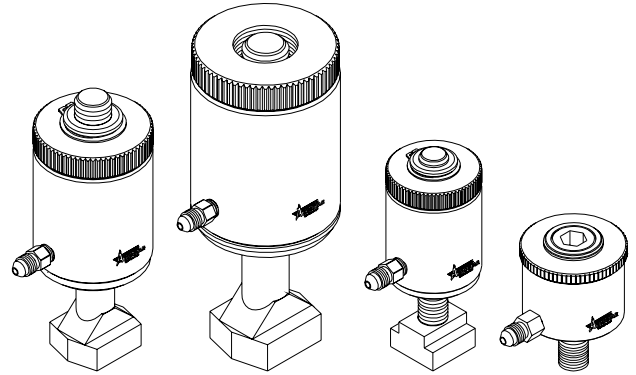
Examples-other Models available



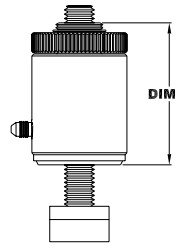
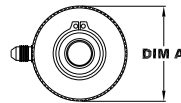
Model	200	201	205	206
Clamping force @5,000 psi	10,000	15,000	8,000	6,800
Clamping Stroke	.29	.60	.25	.13
Stud Thread Size	3/4-10	1"-8	5/8-11	5/8-11
Dim A	2.50	3.12	2.00	2.12
Dim B	2.20	3.45	1.96	1.52
Weight-lbs	2.5	8	1.5	1.3

Hydra-Mechanical Nuts

Model-200L; 201L; 205L; 206L



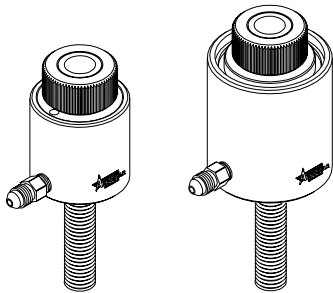
Examples-other Models available



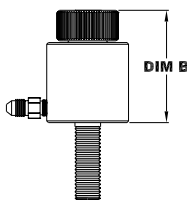
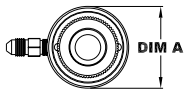
Model	200L	201L	205L	206L
Clamping force @5,000 psi	10,000	15,000	8,000	6,800
Clamping Stroke	.29	.60	.25	.13
Stud Thread Size	3/4-10	1"-8	5/8-11	5/8-11
Dim A	2.50	3.12	2.00	2.12
Dim B	3.51	4.50	3.00	1.91
Weight-lbs	3	8.5	2.0	1.8

Hydraulic Thumbscrews

Model-210; 225



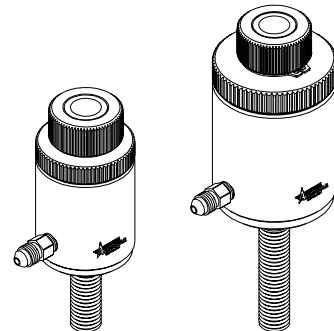
Examples-other Models available



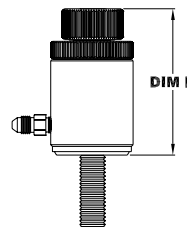
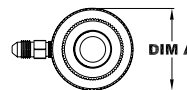
Model	210	225
Clamping force @5,000 psi	8,000	10,000
Clamping Stroke	.25	.29
Stud Thread Size	1/2-13	5/8-11
Dim A	2.00	2.50
Dim B	2.58	3.00
Weight-lbs	3	5

Hydra-Mechanical Thumbscrews

Model-210L; 225L



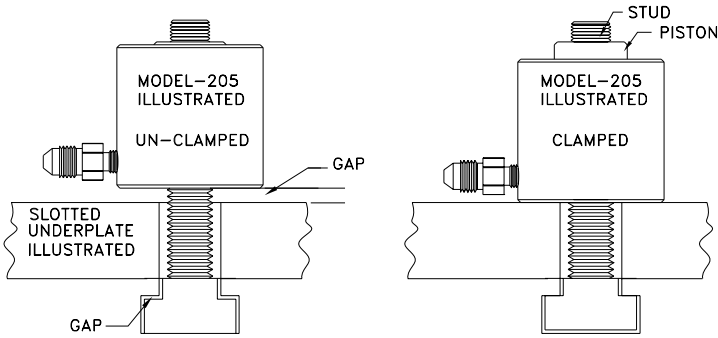
Examples-other Models available



Model	210L	225L
Clamping force @5,000 psi	8,000	10,000
Clamping Stroke	.25	.29
Stud Thread Size	1/2-13	5/8-11
Dim A	2.00	3.12
Dim B	3.63	4.20
Weight-lbs	3.5	5.5

Hydraulic Nuts

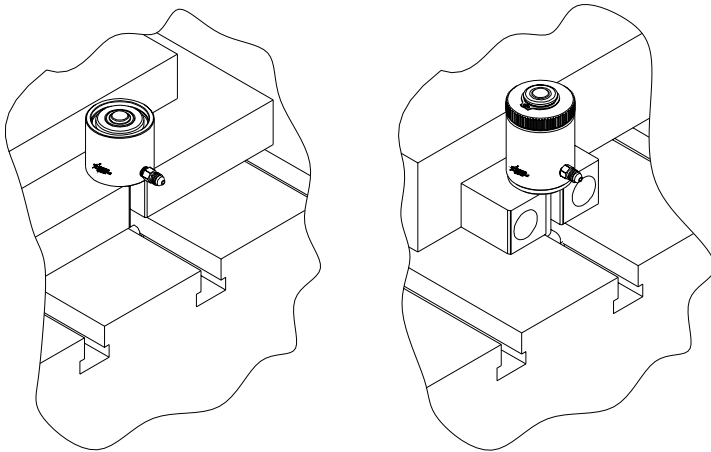
How they work:



When hydraulic pressure is applied the clamp body moves towards the die underplate. Note that the two gaps illustrated in the unclamped position are closed in the clamped position. The clamp stalls when full pre-load clamping force is applied. Springs inside the clamp retract the piston to open clamp when hydraulic pressure is released.

The stud can be rotated to match different clamping heights providing sufficient thread engagement is maintained.

How they are used:



Model-200 Clamp

Model-200L Clamp

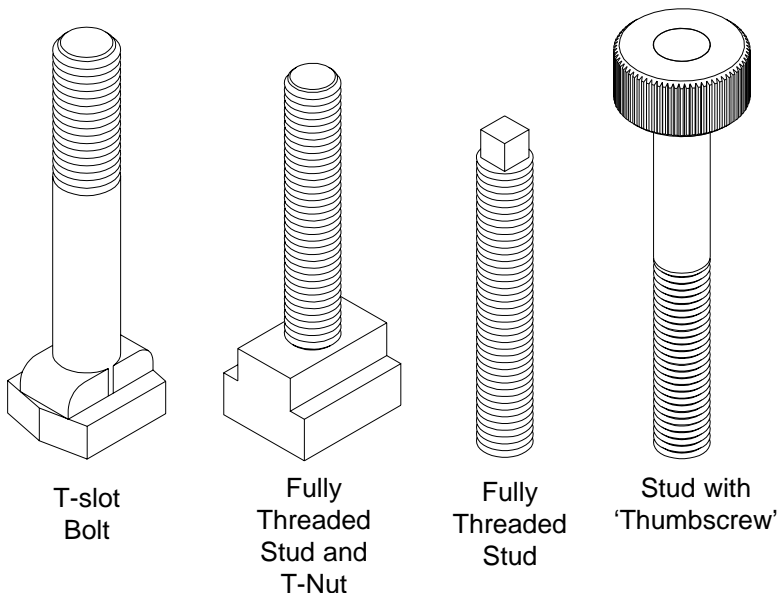
Use hydraulic nuts with dies having slotted underplates, pockets or ears. A U-slot bracket, (Model-487 illustrated), may be utilized in some applications.

The Model-200 clamp shown at far left requires constant hydraulic pressure to maintain clamping force.

The Model-200L clamp is hydraulically actuated and mechanically locked during stamping operations. To open clamp hydraulic pressure must be re-applied.

Select the clamp model and quantity which provides a clamping force (clamp-preload) in excess of the loads applied to the clamps during use.

How clamps are secured:

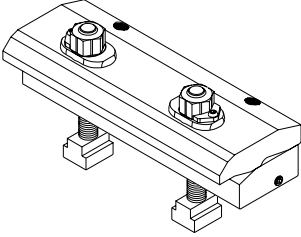
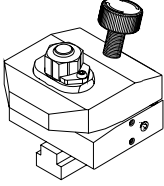
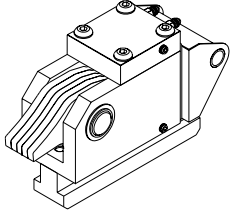
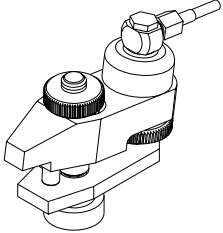
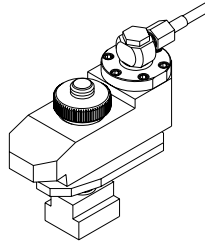
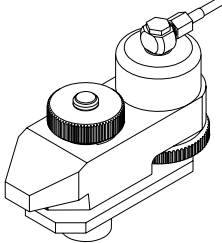
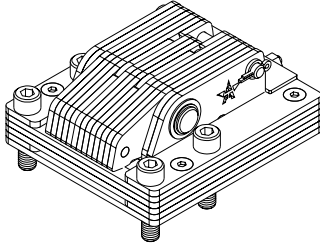
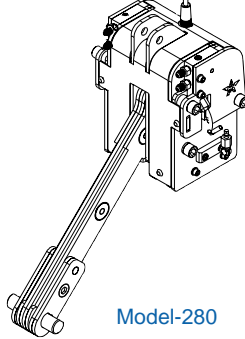
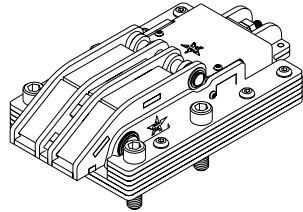
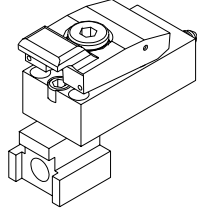
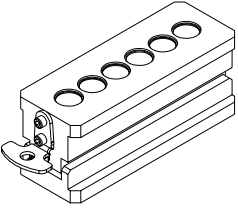
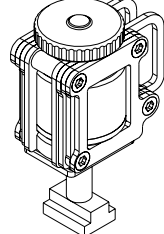


A T-slot bolt may be used to secure the clamps. A fully threaded stud and T-nut assembly is used when greater clamping height adjustment is required. Either way the clamps are usually moved up in T-slots to and away from the die.

In some applications - usually with standardized die underplates - the rear mounted clamps are fixed mounted. A threaded stud can be used for this purpose. Dies are then pushed to the clamps which engage U-slots.

The 'thumbscrew' is used to secure a hydraulic nut having a clearance hole through the piston. Typically the thumbscrew is inserted through a ram clearance hole to engage a threaded hole in the upper die shoe.

Other Clamp Styles

<p>Rocker Clamps</p>	 <p>Model-128</p>	 <p>Model-428L</p>	 <p>Model-979</p>
 <p>Model-661L</p>	<p>Power Strap Clamps</p>	 <p>Model-662</p>	 <p>Model-825L</p>
 <p>Model-751</p>	 <p>Model-280</p>	<p>Multi-Articulating Clamps</p>	 <p>Model-750</p>
 <p>Model-221B</p>	 <p>Model-928</p>	 <p>Model-203LH</p>	<p>Specialty Clamps</p>

Other Hydraulic Clamp Brochures:

Rocker Clamps • Power Strap Clamps • Specialty Clamps • Multi-Articulating Clamps

Related Brochures:

Die Lifters • Bolster Extensions • Mechanical Die Lifters • Power and Control Modules

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