

Request Checklist for **Electric swing clamps as per data sheet B 1.8310**

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Installation situation					
Swing angle Direction of rotation	0°	90° clockwise rotation	180°	other	(min. 45°)
Mounting position	vertical	hanging upright			
Position of the clamping Please mark in the sketch			I mounting positio	n	
	11 12 10 9 · · · · · · · · · · · · · · · · · ·	2 3- 4 10 9 8 7 Clan	3- 6 5 10 2	11 12 1 9 · 3- 8 7 6 5 Clamp 3	11 12 1 10 2 -9 3- 8 7 6 5 Clamp 4
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Clamping arm	Accessory	as per data sheet B 1.83	310 Part no.:		
Special clamping arm	Special cla		odel available e send step file)	Material	
	 Radial to 				
		uation of the clamping m length, radial torque, m		LD desired? yes	no
	If a 3D mod	repare an offer for the el is not available, ROEMH on a manufacturing drawin m.	ELD prepares a 3D m		no

Is the workpiece to be positioned or to be pulled against the support?
Displacement force F _V = [N]
Displacement stroke s _V =[mm]
Condition:
The subsequent clamping force is to be adjusted at least to 4.5 kN. The usable displacement force F _V is depending on the clamping arm length between 0.7 and 1.1 kN.
Note:
Evaluate the maximum displacement force as per diagram on data sheet B 1.8310. Positioning up to 2 mm displacement stroke possible.
Is there the risk of side load introduction during clamping / unclamping?
Description of the side load:
Note: Additionally introduced side loads (F _Q), apart from the side loads introduced by the admissible clamping arms, are generally to be avoided during clamping / unclamping.
Examples of side load introduction:
During the clamping process, rotatory loads must not be introduced into the piston, since this could lead to wear of the guide elements or to damage of the components. This type of load can e.g. be generated by clamping on an inclined surface. Due to the slipping of the clamping screw on the inclined surface, a side load to the clamping arm will be caused and transferred to the internal mechanics of the electric swing clamp.
Environmental conditions
minimum quantity lubrication
dust
wet
Type:
Note: If there is any danger that fluids penetrate into the electric swing clamp, the screw plug at the venting port G 1/8 has to be removed and a vent hose has to be connected. The other end of the hose has to be placed to an absolutely dry area where no liquids, liquid mist or similar can be sucked in. It is recommended to connect a dry positive air pressure protection with 0.2 bar.
Ambient temperature [C°]Admissible: -10 +40 °C
Must vibrations/oscillations be expected?
Note: Vibrations/oscillations can lead to the loss of self-locking when disconnecting the power supply.

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ls a metallic wiper required?	yes no
What type of swarf/contamination is	s to be expected?
What is the number of load changes	5?
Load changes/day	Load changes/week Load changes/month
	ne electric swing clamp after 500,000 clamping cycles to ROEMHELD for overhaul. elements are replaced, and the spindle is cleaned and greased.
What control is provided for the elec	ctric swing clamps?
How are they controlled?	PLC conventional push-button contacts IO link
	Note: Provide error display/error evaluation Provide error reset possibility Provide error handling routine, if necessary Observe power supply unit dimensioning per clamp: at least 15 A Couplings for standard plugs available as accessories
s the electric swing clamp automat	ically coupled electrically?
	Note: Coupling and uncoupling must only be effected in de-energised state
Cable length/cable cross section	< 7 m = 1 mm ²
	\sim 20 m = 2.5 mm ²
should be laid and fi	les must be shielded. The shielding must be grounded on the control side. The connecting cables ixed so that damages are excluded. Cable lengths longer than 30 m are not allowed. ion on control, see operating manual B18310.
Fixed or variable clamping force?	☐ fixed ☐ variable
	Note: • Analogue input must be connected and the trimmer F on the board must be set to "0".
Other comments	

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