Bore Clamp
double-acting, pull-type, with and without centring function, clamping for bore diameter 16 to 46 mm, max. operating pressure from 50 up to 350 bar

Advantages
- Clamping and supporting with one element
- Compact design
- High clamping force
- Repetitive accuracy of clamping force 0.005 mm
- 5 optimised clamping ranges
- Hardened support face
- Pneumatic seat check
- Easy exchange of segment clamping bushings
- Centring at the bottom of the body
- Compensating and non-centring variants are available
- Oil supply optionally by pipe threads or drilled channels
- Standard FKM seals
- Vulcanised segment clamping bushing

Function

Pneumatic seat check

Connecting possibilities
Pipe thread

Drilled channels

Centring function
- Bore clamp with centring
  Part no.: 4317-X00
  Fixed centring cone

- Bore clamp with compensation
  Part no.: 4317-X10
  Centring cone in one axial direction ± 0.5 mm movable

- Bore clamp without centring
  Part no.: 4317-X20
  Centring cone in all directions ± 0.5 mm movable

Applications
- Centre and clamp in 1 bore hole
- Centre and clamp in 2 bore holes
- Centre and clamp in more than 2 bore holes

Application
The bore clamp is particularly suitable for centring and clamping of workpieces with smooth machined bores ranging from 16 to 46 mm in diameter and a support surface square to the hole axis.

Description
The bore clamp is a combination of a double-acting pull-type cylinder equipped with a segment clamping bushing, which is pulled by a tie rod over a fixed cone. Thereby the segment clamping bushing expands radially to the bore diameter of the workpiece to be clamped. By the simultaneous axial movement the workpiece is clamped onto the hardened support at the housing. The obtainable low-clamping force depends on the factor of friction within the bore and the operating pressure.

The sectioning of the complete clamping range from 16 to 46 mm in 5 sub-ranges (chart page 2) allows an optimum adaptation of tie rods, cone, workpiece support and operating pressure. For detailed information on possible low-clamping forces and maximum operating pressures see charts and diagrams on page 2.

Important notes
Since the segment clamping bushings are operated by a tie rod, it is imperative to consider the max. operating pressure depending on the clamping range. A too high operating pressure will destroy the tie rod. The maximum operating pressure for the segment clamping bushing is 80°C. Avoid clamping without workpiece, if possible. Operating conditions and other data see data sheet A 0.100.
# Technical data

## Dimensions

<table>
<thead>
<tr>
<th>Ø 59</th>
<th>Ø 6.6</th>
<th>Ø 6,6</th>
<th>Ø 6.6</th>
</tr>
</thead>
</table>

- **Technical data**
  - **Dimensions**
  - **Material**: Cylinder body - Steel
  - **Piston, workpiece support and segment clamping bushing**: Case-hardening steel, hardened
  - **Low-clamping force**
    - Material: Steel, unhardened
    - Surface finish: Rmax. 3 µm

## Notes

- The bore clamps are delivered without segment clamping bushings.
- These can be ordered separately as accessory.

## Tables

### Size

<table>
<thead>
<tr>
<th>Size (BG)</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
<th>5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ø [mm]</td>
<td>16-21.9</td>
<td>22-27.9</td>
<td>28-33.9</td>
<td>34-39.9</td>
<td>40-46</td>
</tr>
<tr>
<td>Max. low-clamping force [kN]</td>
<td>0.6</td>
<td>1.3</td>
<td>3.1</td>
<td>5.5</td>
<td>7.9</td>
</tr>
<tr>
<td>Max. operating pressure [bar]</td>
<td>50</td>
<td>75</td>
<td>150</td>
<td>250</td>
<td>350</td>
</tr>
<tr>
<td>Adm. torque [Nm]</td>
<td>15</td>
<td>35</td>
<td>90</td>
<td>190</td>
<td>300</td>
</tr>
</tbody>
</table>

### Low-clamping force

- Material: Steel, unhardened
- Surface finish: Rmax. 3 µm

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- **Material**: Steel, unhardened
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**Actual issue see www.roemheld.com**

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Subject to modifications
## Accessories

### Workpiece dimensions

For each bore hole diameter within the clamping range the appropriate segment clamping bushing has to be selected:

**Part no. 3338-XXX (clamping Ø in 0.1 mm)**

**Example of ordering:**
- Clamping Ø: 16.0 Part no. 3338-160
- Clamping Ø: 34.8 Part no. 3338-348

### Workpiece dimensions and workpiece tolerance

The workpiece to be clamped should always contact the hardened support surface and cover at least in the zone of the bore hole a minimum surface of the segment clamping bushing. This is only guaranteed, if the relevant dimensions meet the requirements shown in the drawing.

<table>
<thead>
<tr>
<th>Size</th>
<th>(BG) 1 2 3 4 5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamping range Ø</td>
<td>16-21.9 22-27.9 28-33.9 34-39.9 40-46</td>
</tr>
<tr>
<td>g max. [mm]</td>
<td>12 12 12 15 15</td>
</tr>
<tr>
<td>h min. [mm]</td>
<td>18 18 18 24 24</td>
</tr>
<tr>
<td>k min. [mm]</td>
<td>35 35 55 55 55</td>
</tr>
</tbody>
</table>

**Workpiece tolerance of selected clamping Ø [mm]:**
- –0.1...+0.3
- –0.1...+0.5
- –0.1...+0.5
- –0.1...+0.5
- –0.1...+0.5

Standard stepping 1 mm (intermediate stepping on request)

**Example:**
- Selected clamping diameter = 16 mm
- Workpiece tolerance = –0.1 up to +0.3 mm
- Workpiece diameter = 15.9 up to 16.3 mm

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### Adjustment of the segment clamping bushing

Unclamp bore clamp (extended). Unscrew lock nut of the bore clamp and screw on segment clamping bushing onto the threaded rod. Check the diameter of the segment clamping bushing by means of a vernier caliper. The diameter of the segment clamping bushing should be adjusted to approx. 0.1 mm up to 0.2 mm less than the clamping diameter to be in the position to insert easily the workpiece to be clamped. Clamping without workpiece should be avoided due to the overexpansion of the vulcanisation.

Tightening torque for the lock nut see chart on page 2. When tightening the lock nut to hold the segment clamping bushing without this to adjust.

### Accessory - segment clamping bushing

Accessory for connection through drilled channels

- O-ring 8x1.5 Part no. 3000-343
- Screw plug with collar and hexagon socket G1/4 Part no. 3610-191
  - G1/8 Part no. 3610-158
- Alternatively, sealing plug without collar with thread sealing ring G1/4 Part no. 0361-987
  - G1/8 Part no. 0361-986

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