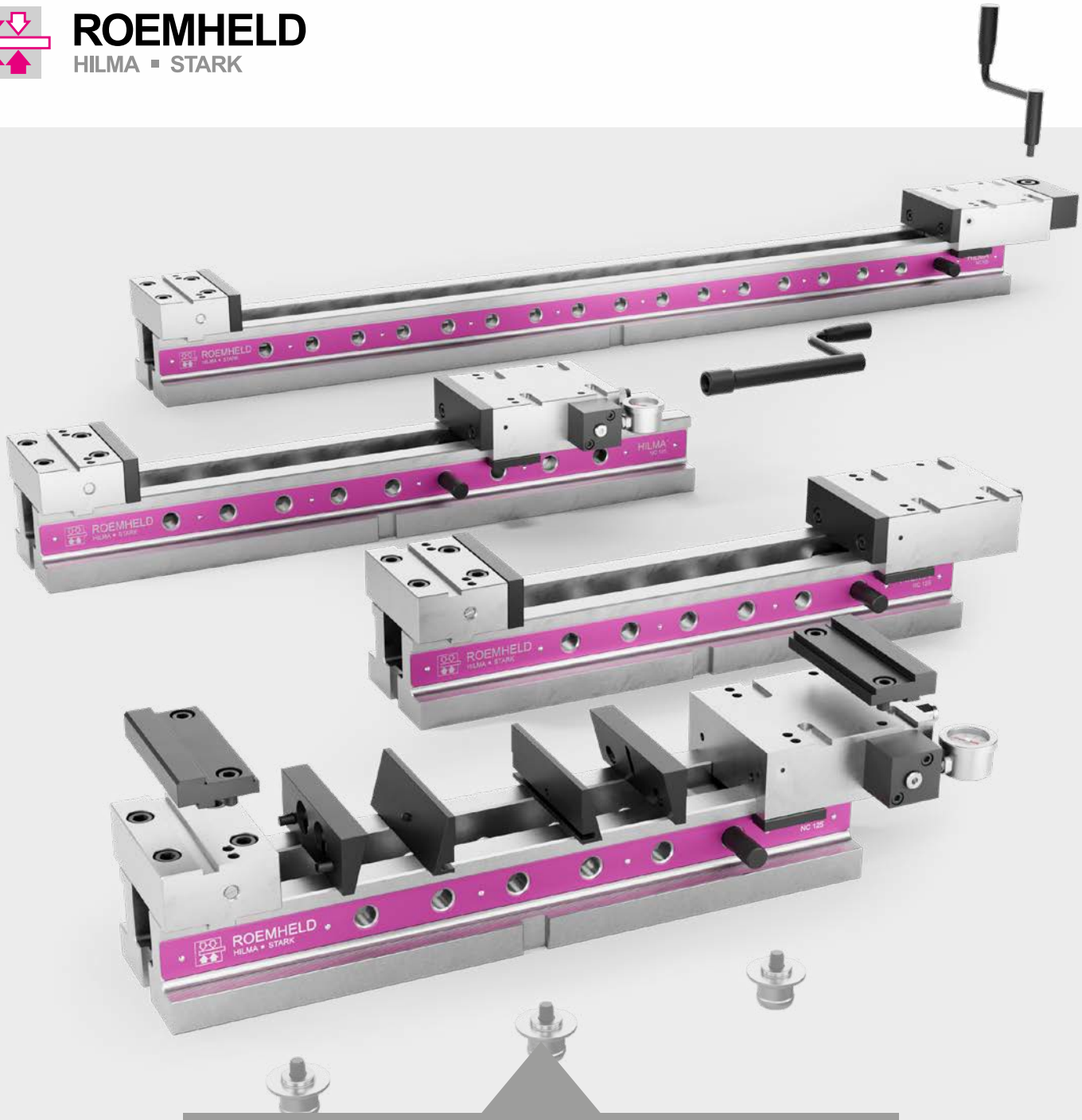
ROEMHELD
HILMA ▪ STARK



HILMA.NC

Modular machine vice for flexible production

jaw widths 100, 125 and 160 mm

WM-021-002-en

STARK Spannsysteme
stark-roemheld.com

ROEMHELD
HILMA ▪ STARK





STARK

INNOVATIVE
PROFICIENT
INDIVIDUAL
SAFE

The high-tech company STARK Spannsysteme was established in 1977 in Rankweil, Austria. It manufactures zero point clamping systems and vices of the highest quality and precision for international clients in the automotive, aviation and medical industries, for example.

STARK Spannsysteme products are a byword for minimal set-up times, faster production and high flexibility.

HILMA vices can be complemented and combined perfectly with STARK zero point clamping systems.






AUTOMOTIVE

AVIATION

MACHINE AND TOOL CONSTRUCTION

MEDICINE

FOCUS ON INDUSTRIES & MARKETS.

Every customer has specific requirements. Our established and extensive industry expertise allows us to offer you the best solutions, services and products for sustainable and efficient use in your market.

HILMA.NC

ADAPTED	three jaw widths and variable base lengths
MODULAR	extensive range of jaws and accessories
FIXED	optimal possibilities for fixation
SAFE	precise and constant clamping force
CLEAN	easy cleaning

HILMA.NC

HILMA.DS

HILMA.KNC

VERTICAL MACHINING

HORIZONTAL MACHINING

5-AXIS MACHINING

AUTOMATION

HILMA.ASH

HILMA.SCT

HILMA

Workpiece clamping systems

More productivity through:

- maximum flexibility in production
- highest process reliability
- reduced manufacturing costs through set-up time optimisation

HILMA.TS Vector

HILMA.ASE

HILMA.TS TriStar

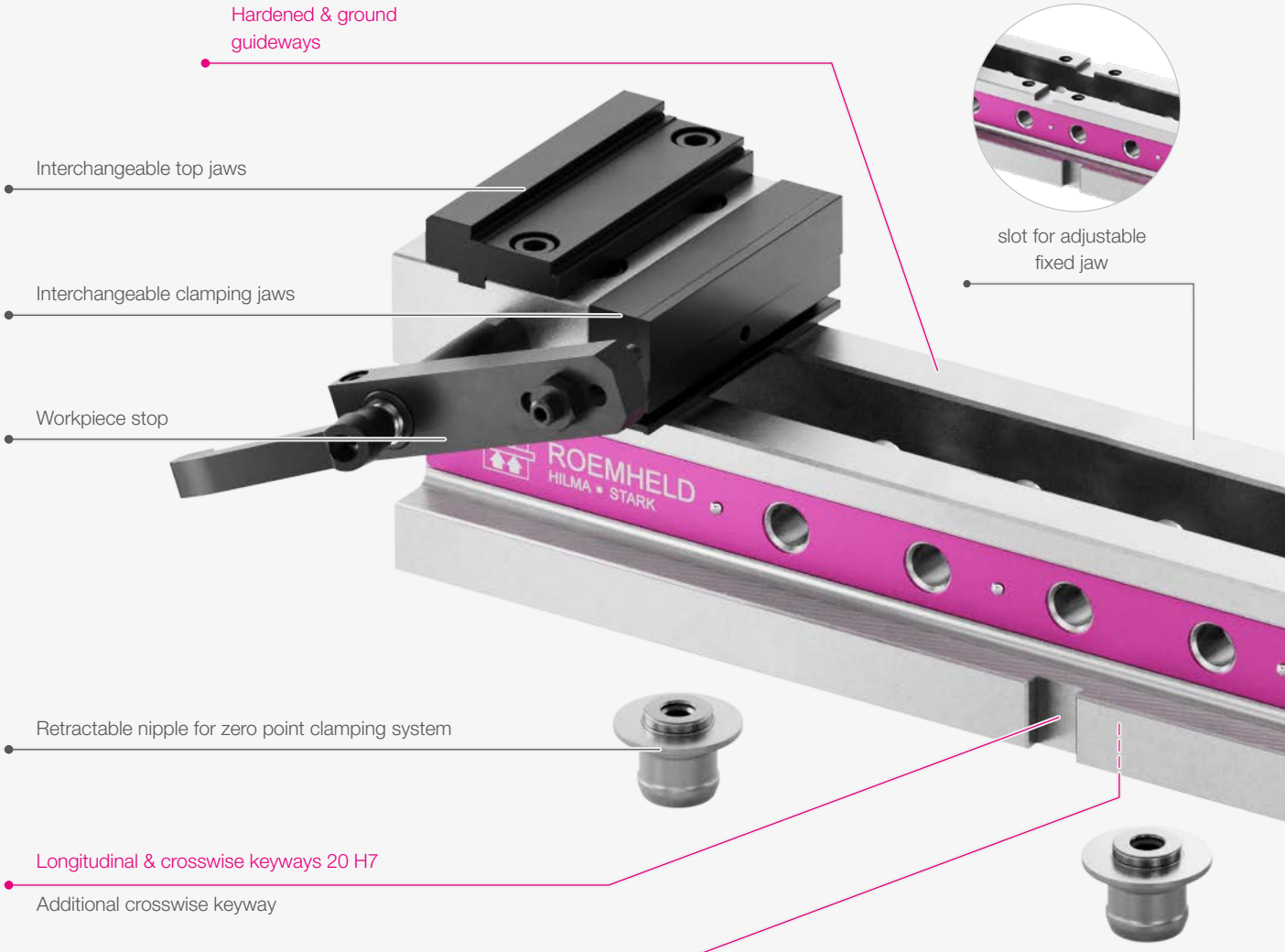
HILMA.MCP

HILMA.UC

HILMA.SCS

HILMA.NC TABLE OF CONTENTS

HILMA.NC
Modular machine vice



Basic machine vice

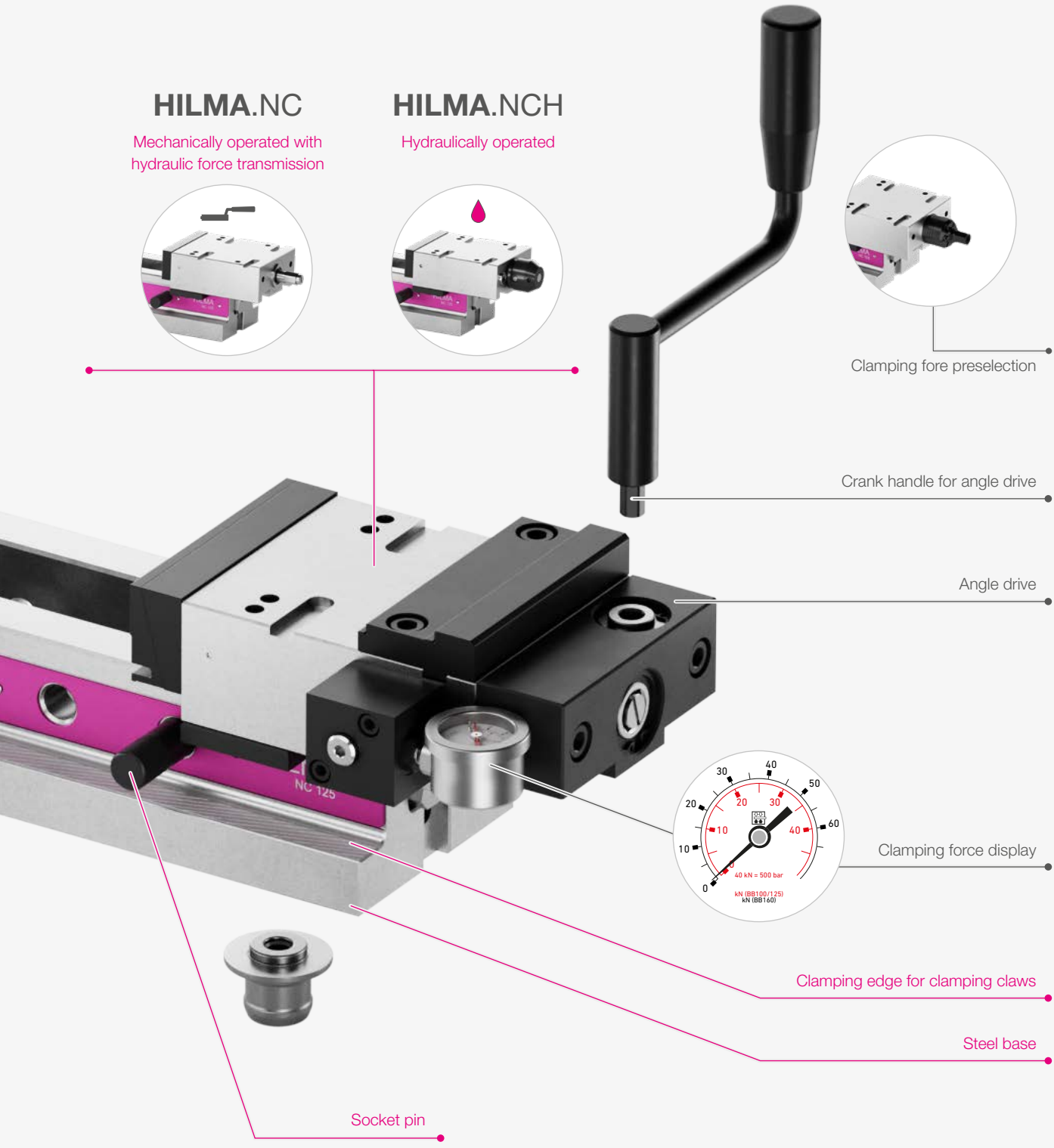
Customised rework or optional accessories

HILMA.NC

Mechanically operated with hydraulic force transmission

HILMA.NCH

Hydraulically operated



THE VARIABLE BASIS

The **HILMA.**NC machine vice

The modular system of the **HILMA**.NC series is preferably used on vertical machining centres.

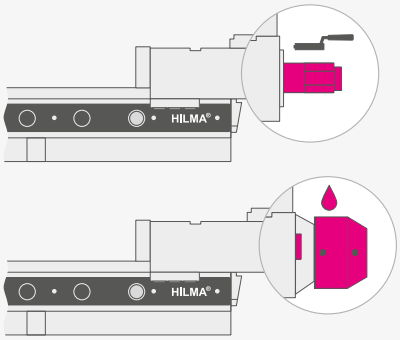
Depending on the machining strategy and degree of automation, the clamping force can be applied manually by means of a crank handle (**HILMA**.NC) or hydraulically by means of a power unit (**HILMA**.NCH).

Different jaw widths & variable base lengths ensure optimum adaptation to the existing circumstances such as machining task, machine & environment.

The extensive range of jaws rounds off the flexible clamping system.

The base of the vice can be fixed to the machine table by means of a zero point clamping system, clamping claws or screws and pins.

Optional rework on the base of the machine vice allows additional positioning and fixation options.



Operation options

HILMA.NC

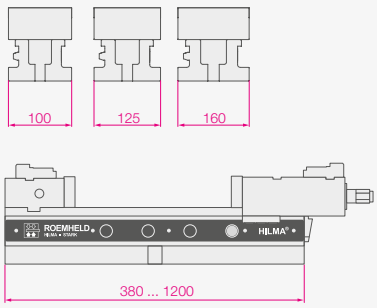
more on page 10

- Manually by means of crank handle and hydraulic force transmission
- \+ Linear, continuously variable force build-up by means of a crank handle

HILMA.NCH

more on page 12

- Hydraulically using a power unit, e.g. by means of a hand/foot switch, Machine-controlled
- \+ Semi-automated processes, improved ergonomics, short clamping and release times



Jaw widths & base lengths

- Three jaw widths 100, 125 and 160 mm
- Up to five standard lengths per jaw width from 380 to 1200 mm
- \+ Optimum adaptation of the clamping system to the machine and clamping task

- Individual desired lengths up to 1200 mm possible

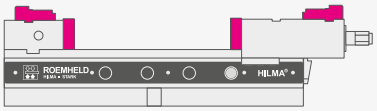
more on page 23

Range of jaws

- Very extensive standard range of jaws for the most diverse clamping tasks
+ Blank and finished part clamping
+ For workpieces in all shapes from round to square and from small to large

- Magnetic quick-change jaws (QIS - Quick Insert System)
+ Jaw change in seconds without tools with QIS jaws

- Customised clamping jaws on request

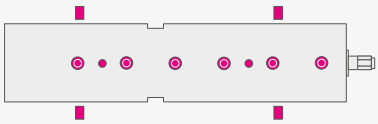


more on page 24

Fixation, positioning & quick change

- Fixation using lateral clamping claws
- Fixation from above through the base by means of screws and pins
- Quick change by means of retractable nipple directly or using adapter plate in the zero point clamping system
- Customised fixation and positioning bore holes in the base of the vice at the factory according to parameter specifications or as rework possible

- Retractable nipple bore holes in the base as standard
- Standard fast closing plates available



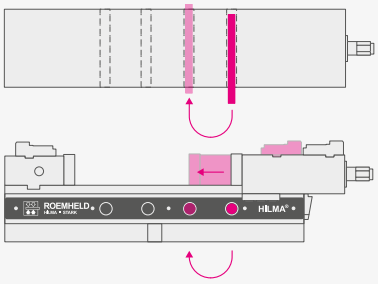
more on page 36

Socket pin

Pulling out the socket pin allows the clamping slide to move freely:

- A coarse adjustment of the clamping range
+ Quick slide adjustment, without prolonged actuation of the crank handle

- Easy removal of the clamping slide
+ Without clamping slide, the base can be cleaned easily and quickly
+ Easy to service



MECHANICALLY OPERATED MACHINE VICE

Function & advantages **HILMA**.NC

The **HILMA**.NC mechanical/hydraulic machine vice is designed for tool, mould and fixture construction as well as for production and is suitable for small to medium batch sizes.

Mechanical operation with hydraulic force transmission

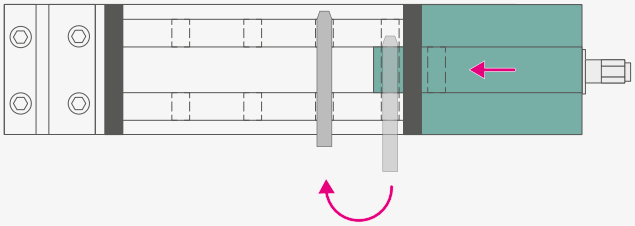
- Requires a minimum cranking force
- No external pressure generator necessary
- Hydraulic slides can be retrofitted

Optional accessories

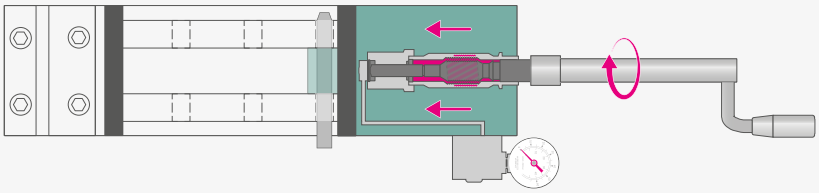
- Clamping force display
- Clamping force preselection
- Angle drive, ...

INFO

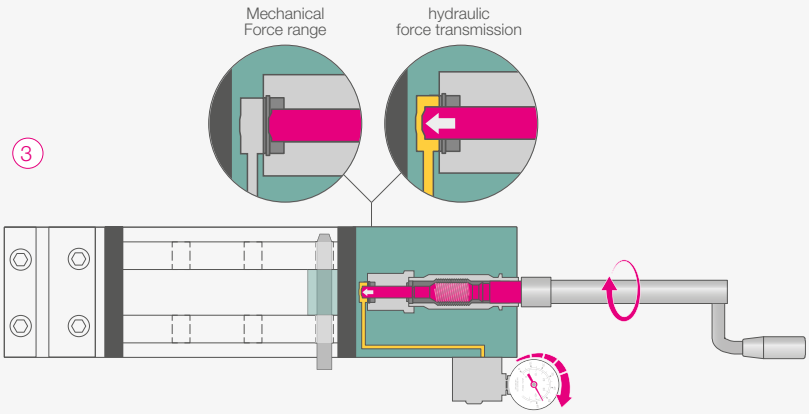
Hydraulic force transmission for mechanical operation

① 

① By pulling out the socket pin, the clamping slide can be moved freely and allows a coarse adjustment of the clamping range.

② 

② The workpiece is finely adjusted manually using a threaded spindle (crank handle By turning the threaded spindle clockwise, the slide is mechanically fed to the component. Clamping is not yet established.

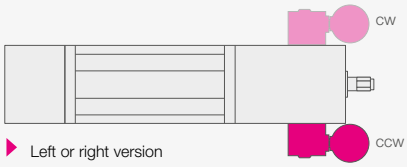
③ 

③ After a noticeable resistance (disengagement of the index bolt), the hydraulic clamping force builds up (linearly up to the maximum) and ensures a tight fit of the workpiece. Cranking requires little effort due to the hydraulic clamping force build-up.

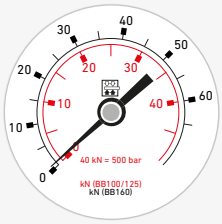
- Release: By turning the crank handle anti-clockwise until the the index bolt engages causes a continuous reduction of the clamping force. When turning further, the machine vice is opened.

Clamping force display

- Continuous display of the clamping force
- Continuous and exact application of the clamping force
- When using clamping jaws with a coating or grip serration, controlled clamping is only possible in conjunction with a clamping force display
+ Optimisation of operation through precise reproducibility of the clamping force
+ No deformation of the workpieces due to exact application of the clamping force
+ High process reliability - continuous clamping force display
+ Roughing and finishing in one arrangement

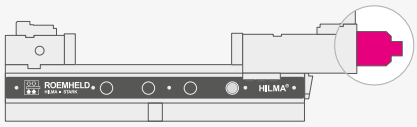


▸ Left or right version



Clamping fore preselection

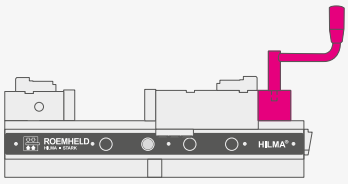
- Mechanical limitation of the clamping force build-up to a fixed value in 6 steps
+ reduces the deformation of the components and reduces operating errors

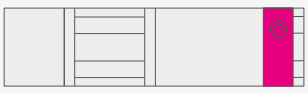


Angle drive

The alternative actuation option using the angle drive with crank handle enables ergonomic operation when access is difficult.

- Recommended from a base length of 540 mm
- Retrofittable





▸ Clamping force display, clamping force preselection and angle drive only for mechanically operated series, not for **HILMA**.NCH

HYDRAULICALLY OPERATED, SINGLE-ACTING MACHINE VICE

Function & advantages **HILMA**.NCH

The **HILMA.**NCH hydraulic machine vice is designed for use in semi-automated operation and series production and is preferably used on vertical machining centres.

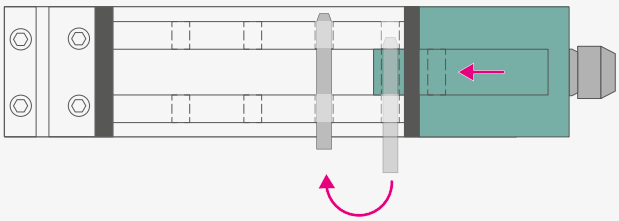
The hydraulic series has advantages for medium to large batch sizes with short machining cycles.

Hydraulic operation
- Single-acting
- Connection to power unit or machine hydraulics
- By means of foot switch, hand switch, machine control system
- 5 mm stroke for jaw widths 100, 125
  7 mm stroke for jaw width 160

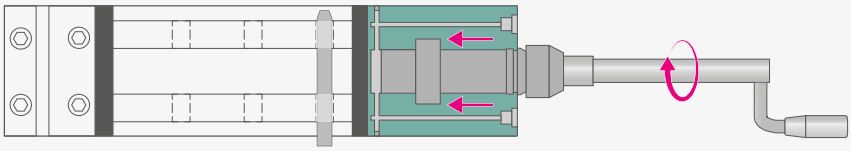
Optional accessories
for safe and easy handling
- Crank handle extension
- Hydraulic units, ...

INFO Hydraulic operation

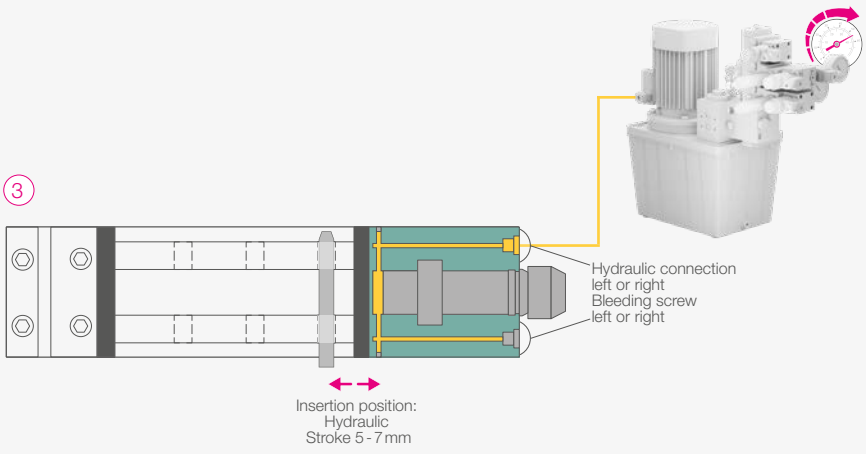
1



2



3



① By pulling out the socket pin, the clamping slide can be moved freely and allows a coarse adjustment of the clamping range.

② Fine adjustment up to the hydraulic stroke is achieved by means of a crank handle. By turning the threaded spindle clockwise, the slide is mechanically fed. Clamping is not yet established.

③ Actuation is achieved using an external pressure generator. This can be the machine hydraulics or a separate power unit. By switching on the hydraulics, the clamping force is built up according to the preadjusted operating pressure (bar).

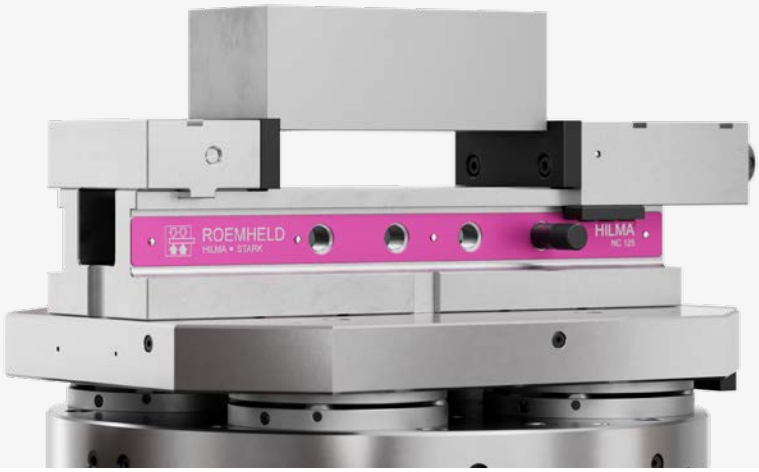
- Insertion position: fast, automated release and clamping with hydraulic stroke

Semi-automated workpiece change in series production

The semi-automatic workpiece change in production enables fast, efficient and safe handling of workpieces, resulting in higher productivity and quality.

- Several clamping locations on a machine table can be actuated simultaneously via a trigger - with process reliability and repeat accuracy.
- Actuation by means of the foot switch enables two-handed loading and unloading of large-volume or heavy workpieces.

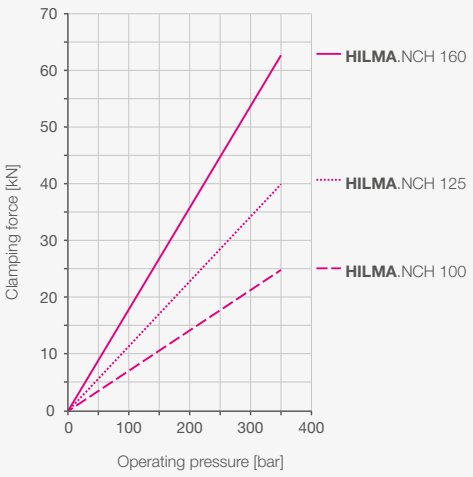
+ Improved working conditions and ergonomics: the operator's workload is reduced
+ Efficient production: increased throughput, time and cost savings, minimised downtime
+ Flexible production: quick changes between different workpieces
+ Higher product quality due to semi-automated handling



Clamping force/clamping pressure

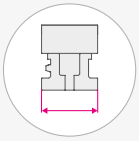
- The clamping force is set on the hydraulic unit via the hydraulic pressure

+ The clamping force is applied with repeat accuracy, operating errors are minimised
+ Increased process reliability - the clamping force is monitored on the power unit and corrected if the clamping situation eases off

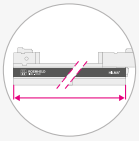


MACHINE VICE
MECHANICALLY OPERATED WITH HYDRAULIC FORCE TRANSMISSION

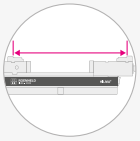
HILMA.NC series



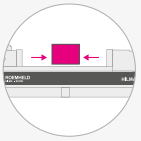
Jaw width



Base lengths*



max.
Jaw openings



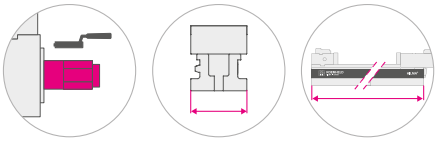
Clamping force

HILMA.NC 100 	100 mm	380 mm 540 mm	386 mm 546 mm	25 kN
HILMA.NC 125 	125 mm	430 mm 560 mm 720 mm 1000 mm 1200 mm	431 mm 561 mm 721 mm 1001 mm 1201 mm	40 kN
HILMA.NC 160 	160 mm	550 mm 750 mm 1000 mm 1200 mm	572 mm 772 mm 1022 mm 1222 mm	50 kN

* Customised base versions and intermediate lengths possible ▶ more on page 22 & 23

HILMA.NC 100

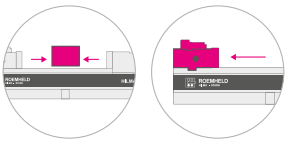
The **HILMA**.NC 100 is a mechanical/hydraulic machine vice with a jaw width of 100 mm.



Operation
Mechanical

Jaw width
100 mm

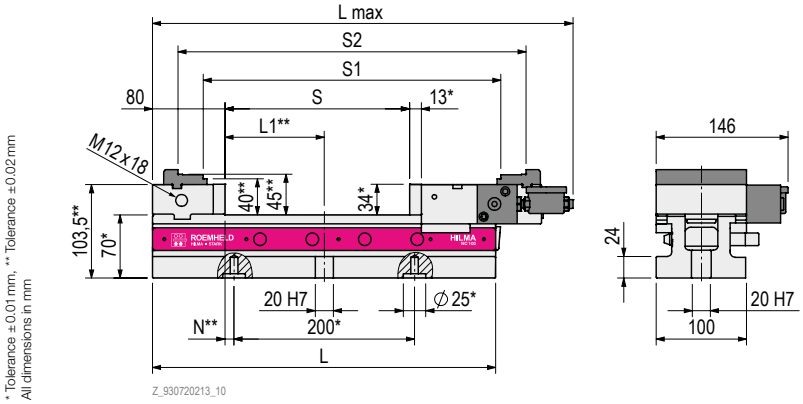
Base length
380 - 540 mm



Clamping
force
25 kN

Clamping
principle
Fixed jaw

Figure: 930720203
Standard scope of supply
Machine vice incl. crank handle and clamping jaws

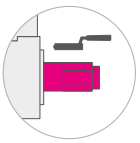


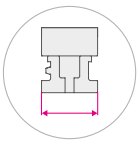
Series		HILMA.NC 100.380	HILMA.NC 100.540
Operation		mechanical	
Base length L[1]	[mm]	380	540
Clamping force	[kN]	25	
Clamping principle		against fixed jaw	
Clamping range S[2]	[mm]	0–205	0–365
Clamping range S1[3]	[mm]	125–330	125–490
Clamping range S2[3]	[mm]	181–386	181–546
Max total length L	[mm]	466	626
Partial length L1	[mm]	110	190
Retractable nipple bore hole	[mm]	25	
Retractable nipple bore holes	[pcs.]	2	3
Retractable nipple bore spacing	[mm]	200	
Retractable nipple bore hole for fixed jaw N	[mm]	10	-10
Weight with standard clamping jaws	[kg]	18.5	23.5
Part no.		930720203	930720303
Order no. with clamping force display L		930720213	930720313
Order no. with clamping force displayR		930720214	930720314

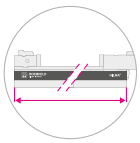
[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

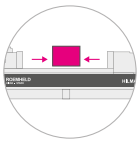
HILMA.NC 125

The **HILMA**.NC 125 is a mechanical/hydraulic machine vice with a jaw width of 125 mm.


Operation
Mechanical

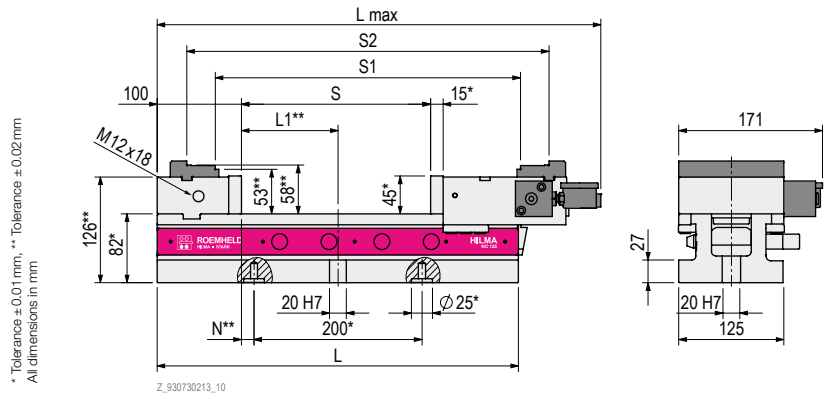

Jaw width
125 mm


Base length
430 - 1200 mm


Clamping
force
25 kN


Clamping
principle
Fixed jaw

Figure: 930730203
Standard scope of supply
Machine vice incl. crank handle and clamping jaws

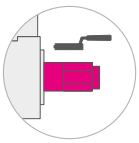


Series		HILMA.NC 125,430	HILMA.NC 125,560	HILMA.NC 125,720	HILMA.NC 125.1000	HILMA.NC 125.1200
Operation		mechanical				
Base length L[1]	[mm]	430	560	720	1000	1200
Clamping force	[kN]	40				
Clamping principle		against fixed jaw				
Clamping range S[2]	[mm]	0–225	0–355	0–515	0–795	0–995
Clamping range S1[3]	[mm]	138–363	138–493	138–653	138–933	138–1133
Clamping range S2[3]	[mm]	206–431	206–561	206–721	206–1001	206–1201
Max total length L	[mm]	528	658	818	1098	1298
Partial length L1	[mm]	115	180	260	400	500
Retractable nipple bore hole	[mm]	25				
Retractable nipple bore holes	[pcs.]	2	3	3	4	5
Retractable nipple bore hole spacing	[mm]	200				
Retractable nipple bore hole for fixed jaw N	[mm]	15	-20	60	100	100
Weight with clamping jaws	[kg]	32.5	38.5	45.5	58.5	67.5
Part no.		930730203	930730303	930730403	930730803	930730903
Order no. with clamping force display L		930730213	930730313	930730413	930730813	930730913
Order no. with clamping force display R		930730214	930730314	930730414	930730814	930730914

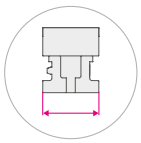
[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

HILMA.NC 160

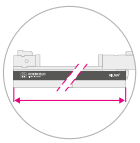
The **HILMA**.NC 160 is a mechanical/hydraulic machine vice with a jaw width of 160 mm.



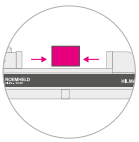
Operation
Mechanical



Jaw width
160 mm



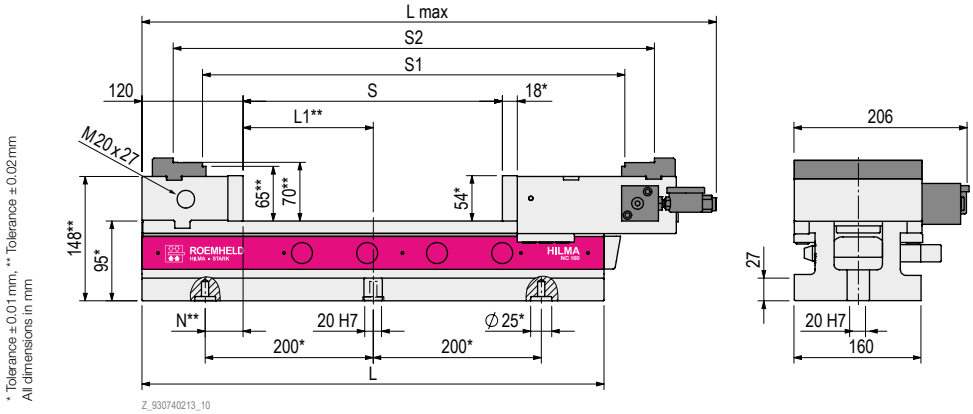
base length
550 - 1200 mm



Clamping
force
25 kN

Clamping
principle
Fixed jaw

Figure: 930740203
Standard scope of supply
Machine vice incl. crank handle and clamping jaws

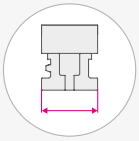


Series		HILMA.NC 160.550	HILMA.NC 160.750	HILMA.NC 160.1000	HILMA.NC 160.1200
Operation		mechanical			
Base length L[1]	[mm]	550	750	1000	1200
Clamping force	[kN]	50			
Clamping principle		against fixed jaw			
Clamping range S[2]	[mm]	0–308	0–508	0–758	0–958
Clamping range S1[3]	[mm]	194–502	194–702	194–952	194–1152
Clamping range S2[3]	[mm]	264–572	264–772	264–1022	264–1222
Max total length L	[mm]	684	884	1134	1334
Partial length L1	[mm]	155	255	380	480
Retractable nipple bore hole	[mm]	25			
Retractable nipple bore holes	[pcs.]	3	3	4	5
Retractable nipple bore hole spacing	[mm]	200			
Retractable nipple bore hole for fixed jaw N	[mm]	-45	55	80	80
Weight with clamping jaws	[kg]	59	71.5	87	99.5
Part no.		930740203	930740303	930740803	930740903
Order no. with clamping force display L		930740213	930740313	930740813	930740913
Order no. with clamping force display R		930740214	930740314	930740814	930740914

[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

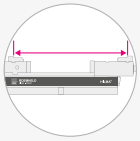
MACHINE VICE
HYDRAULICALLY OPERATED, SINGLE-ACTING

HILMA.NCH series

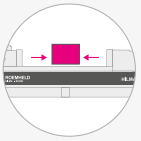


Jaw width

Base lengths*



max.
Jaw openings



Clamping force

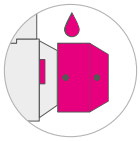
HILMA.NCH 100 	100 mm	380 mm 540 mm	390 mm 550 mm	25 kN/350 bar
HILMA.NCH 125 	125 mm	430 mm 560 mm 720 mm 1000 mm 1200 mm	434 mm 564 mm 724 mm 1004 mm 1204 mm	40 kN/350 bar
HILMA.NCH 160 	160 mm	550 mm 750 mm 1000 mm 1200 mm	577 mm 777 mm 1027 mm 1227 mm	63 kN/350 bar

* Customised base versions and intermediate lengths possible ▶ more on page 22 & 23

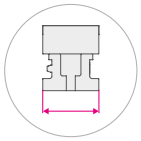
HILMA.NCH 100

The **HILMA**.NCH 100 is a hydraulic, single-acting vice with a jaw width of 100 mm.

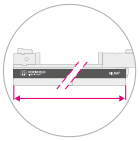
Figure: 930820203
Standard scope of supply
Machine vice incl. crank handleand clamping jaws



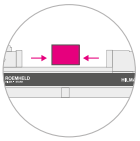
Operation
Hydraulic



Jaw width
100 mm

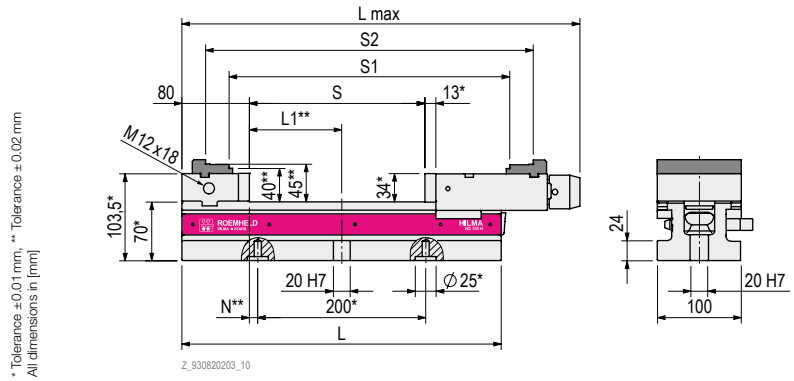


Base length
380 - 540 mm



Clamping
force
25 kN

Clamping
principle
Fixed jaw



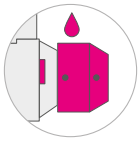
Series		HILMA.NCH 100.380	HILMA.NCH 100.540
Operation		hydraulic	
Base length L[1]	[mm]	380	540
Clamping force/operating pressure	[kN/bar]	25/350	
Clamping principle		Fixed jaw	
Clamping range S[2]	[mm]	0–209	0–369
Clamping range S1[3]	[mm]	125–334	125–494
Clamping range S2[3]	[mm]	181–390	181–550
Clamping stroke	[mm]	5	
Max total length L	[mm]	474	634
Partial length L1	[mm]	110	190
Retractable nipple bore hole	[mm]	25	
Retractable nipple bore holes	[pcs.]	2	3
Retractable nipple bore hole spacing	[mm]	200	
Retractable nipple bore hole for fixed jaw N	[mm]	10	-10
Weight with clamping jaws	[kg]	18.5	23.5
Part no.		930820203	930820303

[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

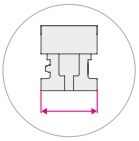
HILMA.NCH 125

The **HILMA**.NCH 125 is a hydraulic, single-acting vice with a jaw width of 125 mm.

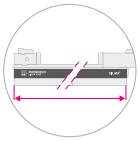
Figure: 930830203
Standard scope of supply
Machine vice incl. crank handle and clamping jaws



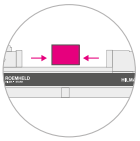
Operation
Hydraulic



Jaw width
125 mm

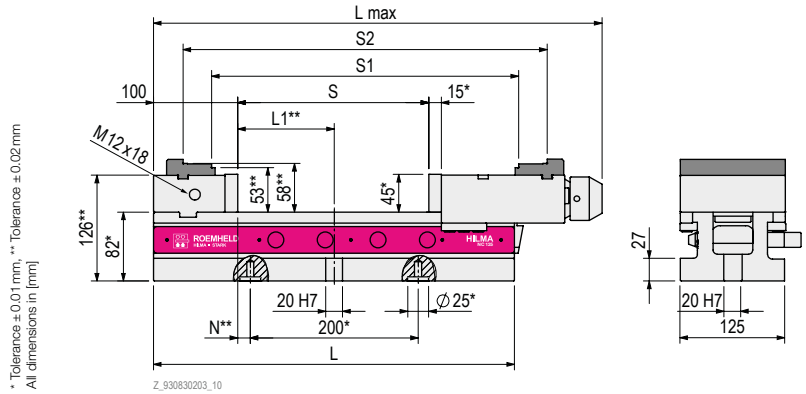


Base length
430 - 1200 mm



Clamping
force
40 kN

Clamping
principle
Fixed jaw



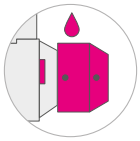
Series		HILMA.NCH 125.430	HILMA.NCH 125.560	HILMA.NCH 125.720	HILMA.NCH 125.1000	HILMA.NCH 125.1200
Operation				hydraulic		
Base length L[1]	[mm]	430	560	720	1000	1200
Clamping force/operating pressure	[kN/ bar]			40/350		
Clamping principle				Fixed jaw		
Clamping range S[2]	[mm]	0–228	0–358	0–518	0–798	0–998
Clamping range S1[3]	[mm]	138–366	138–496	138–656	138–936	138–1016
Clamping range S2[3]	[mm]	206–434	206–564	206–724	206–1004	206–1204
Clamping stroke	[mm]			5		
Max total length L	[mm]	534	665	824	1104	1304
Partial length L1	[mm]	115	180	260		
Retractable nipple bore hole	[mm]			25		
Retractable nipple bore holes	[pcs.]	2	3	3	4	5
Retractable nipple bore hole spacing	[mm]			200		
Retractable nipple bore hole for fixed jaw N	[mm]	15	-20	60	100	100
Weight with clamping jaws	[kg]	32.5	38.5	45.5	58.5	67.5
Part no.		930830203	930830303	930830403	930830803	930830903

[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

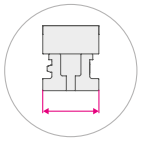
HILMA.NCH 160

The **HILMA**.NCH 160 is a hydraulic, single-acting vice with a jaw width of 160 mm.

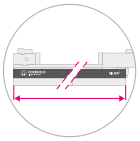
Figure: 930840203
Standard scope of supply
Machine vice incl. crank handle and clamping jaws



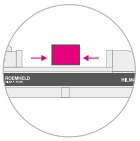
Operation
Hydraulic



Jaw width
160 mm

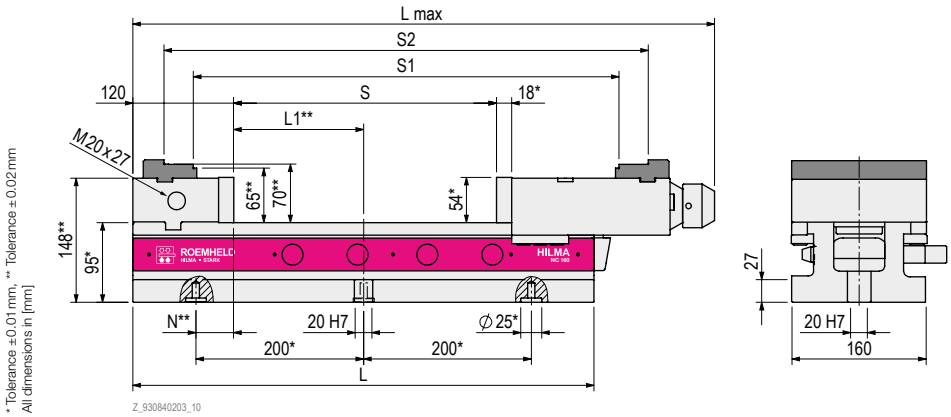


Base length
550 - 1200 mm



Clamping
force
63 kN

Clamping
principle
Fixed jaw



Series		HILMA.NCH 160.550	HILMA.NCH 160.750	HILMA.NCH 160.1000	HILMA.NCH 160.1200
Operation		hydraulic			
Base length L[1]	[mm]	550	750	1000	1200
Clamping force/operating pressure	[kN/bar]	63/350			
Clamping principle		Fixed jaw			
Clamping range S[2]	[mm]	0–313	0–513	0–763	0–963
Clamping range S1[3]	[mm]	194–507	194–707	194–1027	194–1157
Clamping range S2[3]	[mm]	264–577	264–777	264–1027	264–1227
Clamping stroke	[mm]	7			
Max total length L	[mm]	694	894	1144	1344
Partial length L1	[mm]	155	255	380	480
Retractable nipple bore hole	[mm]	25			
Retractable nipple bore holes	[pcs.]	3	3	4	5
Retractable nipple bore hole spacing	[mm]	200			
Retractable nipple bore hole for fixed jaw N	[mm]	-45	55	80	80
Weight with clamping jaws	[kg]	59	71.5	87	99.5
Part no.		930840203	930840303	930840803	930840903

[1] Customised base versions and intermediate lengths possible ▶ more on page 22 & 23
[2] with standard clamping jaws (scope of supply)
[3] with top jaws ▶ more on page 32

STANDARDISED ADDITIONAL OPTIONS

Flat rate reworking

The standard base of the **HILMA**.NC series can be adapted to specific machine requirements through various rework operations. The standardised additional options are offered at an attractive flat rate price.

Supplementary order numbers

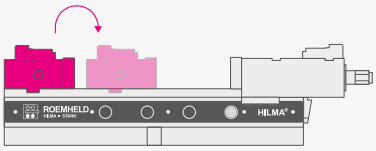
For standardised reworking
- slot for adjustable fixed jaw
- Additional crosswise keyway
- Threaded fastening holes

The supplementary order numbers according to the table apply to the **HILMA**.NC. Feasibility and implementation can be clarified in consultation.

HILMA.NC 100 **HILMA.**NCH 100	**HILMA.**NC 125 **HILMA.**NCH 125	**HILMA.**NC 160 **HILMA.**NCH 160
930PNA100*	930PNA125*	930PNA160*

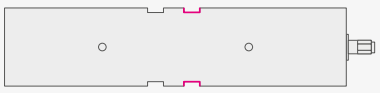
* The supplementary order number stands for all rework. Details on implementation and feasibility on request.

Additional slot for displaceable fixed jaw



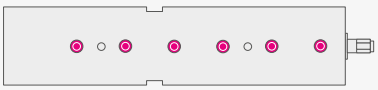
Optionally, the fixed jaw can be adjusted by means of an additional slot in the slide guide surface. The adjustable fixed jaw enables operator-friendly set-up for workpieces of different sizes. Recommended for ergonomic operation with large base lengths and smaller clamping ranges.

Additional crosswise keyway for Positioning



An additional crosswise keyway is used for optimum positioning on the machine table. The position of the additional crosswise keyway can be freely selected after consultation and verification of feasibility.

Additional threaded fastening holes & retractable nipple bore holes



Customised threaded fastening holes and positioning bore holes in the base of the vice at the factory according to parameter specifications or as reworking are possible

Further information at www.stark-roemheld.com
STARK Spannsysteme | +43 5522 37400 | info@stark-roemheld.com

BASE OF VICE ACCORDING TO CUSTOMER REQUIREMENTS

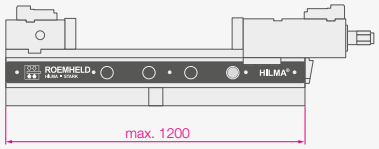
Customised designs

In addition to the standard versions of the modular **HILMA**.NC series, customised base versions can be realised. This means that the machine vice can be manufactured to fit precisely for individual travel paths, working spaces, clamping surfaces and machining tasks. Possible options and designs include:

- Freely selectable intermediate lengths
- Segment design
  Fixed jaws - & clamping segment
- Multiple clamps
- Larger heights
- Own spacing for retractable nipple

Freely selectable base intermediate lengths

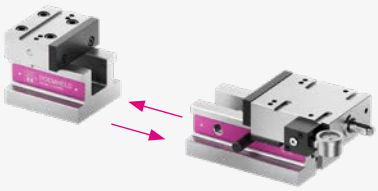
In addition to the standard lengths, customised intermediate lengths can be ordered. The length of the base of the vice can be designed as desired up to the largest standard length of the respective jaw width.



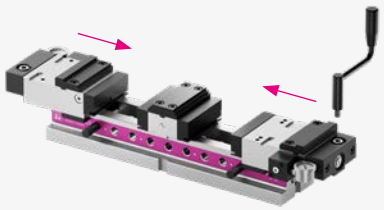
	HILMA.NC 100 **HILMA.**NCH 100	**HILMA.**NC 125 **HILMA.**NCH 125	**HILMA.**NC 160 **HILMA.**NCH 160
Optional intermediate lengths (max)*	to 540 mm	to 1200 mm	up to 1200 mm
Standard Base lengths	380 mm 540 mm	430 mm 560 mm 720 mm 1000 mm 1200 mm	550 mm 750 mm 1000 mm 1200 mm

* Details on implementation and feasibility on request.

Further examples of vice designs



Segmental design
The segments can be placed anywhere on the machine table and are mainly used on large machining centres. Large working spaces can be optimally used with standard clamping systems and complex devices for workpiece clamping are no longer required.



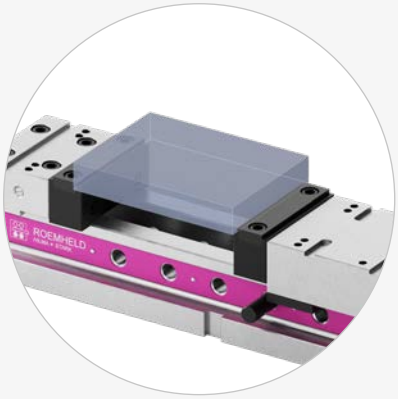
Multiple clamps
Flexible dual clamping systems enable the efficient double machining of workpieces with the same or different dimensions. Both clamping locations work independently of each other.

THE OPTIMUM JAW FOR EVERY WORKPIECE

Extensive range of jaws

High clamping quality ▶ High clamping safety

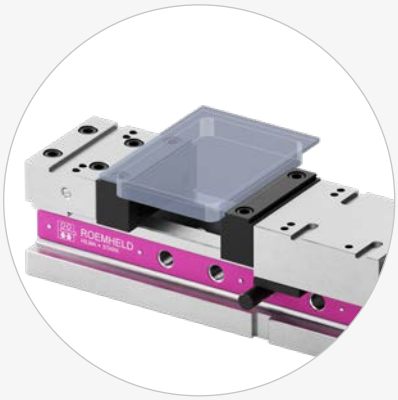
The jaws used have a major influence on the machining result.
The extensive range of jaws enables reliable blank and finished part clamping in all shapes from round to square and from small to large. All jaws are hardened on the reference surfaces and ground with high precision (except soft clamping jaw).



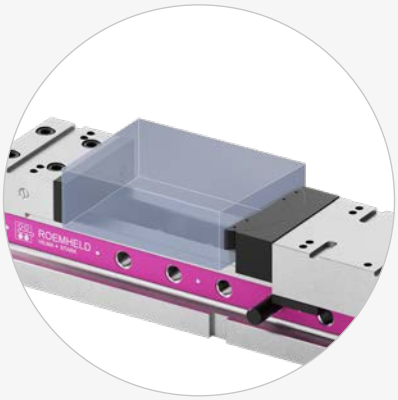
Blanks
Jaws with interchangeable insert
Page 29

Blanks
Claw jaws with fine grade
Page 27

Blanks
Top jaw segments
Page 33



Finished parts, second side
Jaws with interchangeable insert
Page 29



Compensation of angular errors
pendulum jaws
Page 28

Round blanks
Top jaw segments
Page 33

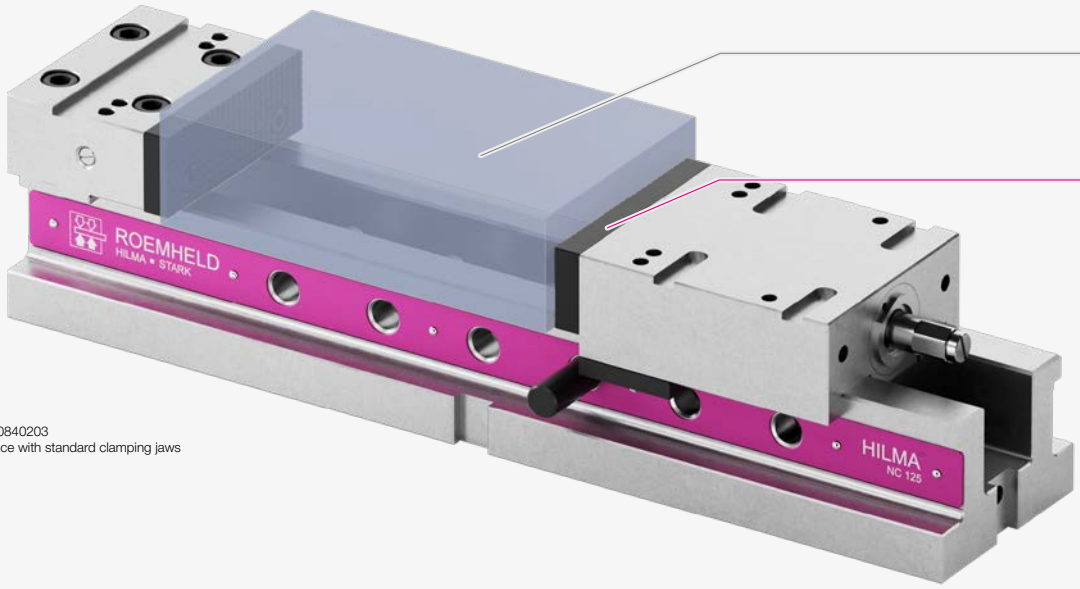


Figure: 930840203
Machine vice with standard clamping jaws

Narrow parts
SlimFlex - with step inserts
Page 31

Large parts
Top jaws
Page 32

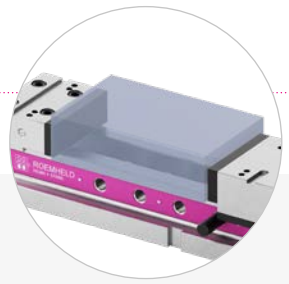
Flexible production for finished parts
PinFlex clamping jaws for steps and angles
Page 30

Cylindrical parts - vertical
Vee jaws
Page 28

Cylindrical parts - horizontal
Vee jaws
Page 28

Jaw change without tools
QIS quick-change jaws
Page 34

Clamping jaws

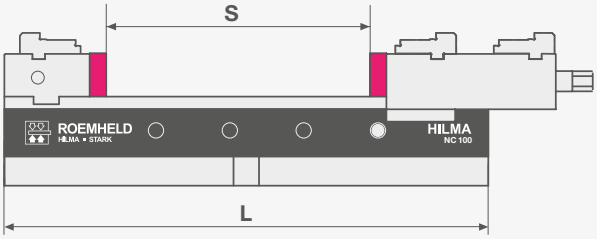


The clamping jaws of the **HILMA**.NC machine vices are designed as exchangeable clamping bars. Using clamping jaws or jaw inserts with coating or grip serrated, the retention forces for safe clamping of workpieces can be considerably increased.

- The **HILMA**.NC and **HILMA**.NCH series are delivered with smooth/serrated clamping jaws.

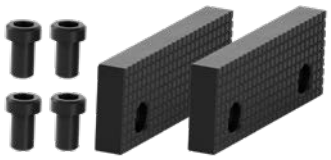
- When using inserts or clamping jaws with a coating or grip serration, controlled clamping is only possible in conjunction with a clamping force display.

INFO Length & clamping range

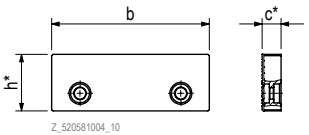


Smooth/serrated clamping jaws

Standard reversible clamping jaw with one side ground smooth for clamping finished parts and one side serrated for clamping blanks. **HILMA**.NC and **HILMA**.NCH are included in the standard scope of supply.
Scope of supply: Set with 2 clamping jaws and 4 fixing screws



Type	Part no.	Dimensions			Base length	Clamping range
		b	c	h	L	S
NC 100	932711201	100	13	34	380	0–205
					540	0–365
NC 125	932711301	125	15	45	430	0–225
					560	0–355
					720	0–515
					1000	0–795
					1200	0–995
NC 160	932711401	160	18	54	550	0–308
					750	0–508
					1000	0–758
					1200	0–958

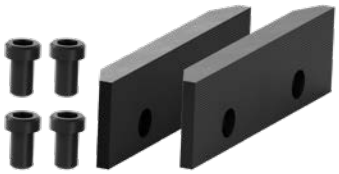


Z_520581004_10

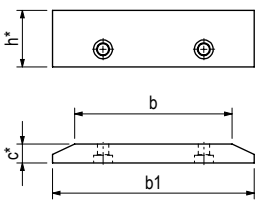
* Tolerance ±0.01 mm
All dimensions in [mm]
fastening material included in scope of supply

Clamping jaws extra large, serrated, hardened and ground

For clamping workpieces that exceed the normal jaw width.
Used in pairs only.
Scope of supply: Set with 2 clamping jaws and 4 fixing screws



Type	Part no.	Dimensions				Base length	Clamping range
		b	b1	c	h	L	S
NC 100	932721201	100	125	13	34	380	0–205
						540	0–365
NC 125	932721301	125	160	15	45	430	0–225
						560	0–355
						720	0–515
						1000	0–795
						1200	0–995
NC 160	932721401	160	200	20	54	550	0–304
						750	0–504
						1000	0–754
						1200	0–954



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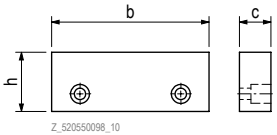
* Tolerance ±0.01 mm
All dimensions in [mm]
fastening material included in scope of supply

Clamping jaws, soft

Soft jaw for quick insertion of workpiece-specific clamping or contact points as well as contours. Used in pairs only.
Scope of supply: Set with 2 clamping jaws and 4 fixing screws

Type	Part no.	Dimensions b	c	h	Base length L	Clamping range S
NC 100	932731201	100	20	36	380	0–191
					540	0–351
NC 125	932731301	125	25	47	430	0–205
					560	0–335
					720	0–495
					1000	0–775
					1200	0–975
NC 160	932731401	160	30	56	550	0–284
					750	0–484
					1000	0–734
					1200	0–934

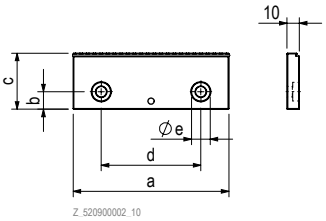


All dimensions in [mm]
fastening material included in scope of supply

Claw jaws with fine grade

For blank clamping. A clamping depth of 2.5 mm (pull-down effect) results in little material loss on the workpiece. 5 sides can be machined in a single clamping operation without pre-stamping. A clamping force display is recommended. Used in pairs only.
Scope of supply: Set with 2 claw jaws and 4 fixing screws

Type	Part no.	Clamping depth	Support	Dimensions a	b	c	d	e	Base length L	Clamping range 932871X01	932871X11
NC 100	932871201	2,5	2,0	100	11	34	65	6,6/11	380	4–215	
									540	4–375	
NC 125	932871301	2,5	2,0	125	14	45	80	8,5/15	430	4–239	6–241
									560	4–369	6–371
									720	4–529	6–531
	932871311	5	3						1000	4–809	6–811
									1200	4–1009	6–1011
NC 160	932871401	2,5	2,0	160	17	54	100	10,5/18	550	4–328	6–330
									750	4–528	6–530
	932871411	5	3						1000	4–778	6–780
									1200	4–978	6–980

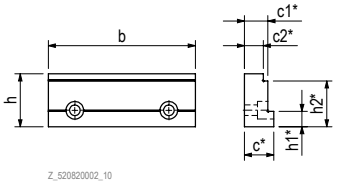


All dimensions in [mm]
fastening material included in scope of supply

Hardened and ground precision step jaws

Preferably used for clamping pre-machined workpieces for precision manufacturing (parallelism accuracy). Used in pairs only.
Scope of supply: Set with 2 precision step jaws and 4 fixing screws

Type	Part no.	Dimensions b	c	c1	c2	h	h1	h2	Base length L	Clamping range Step h1	Step h2
NC 100	932741201	100	19	15	11	35	10	29	380	8–201	16–209
									540	8–361	16–369
NC 125	932741301	125	25	20	16	45	13	39	430	10–215	18–223
									560	10–345	18–353
									720	10–505	18–513
									1000	10–785	18–793
									1200	10–985	18–993
NC 160	932741401	160	25	20	16	54	15	45	550	10–304	18–312
									750	10–504	18–512
									1000	10–754	18–762
									1200	10–954	18–962

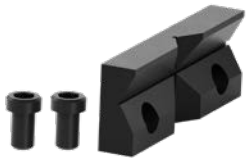


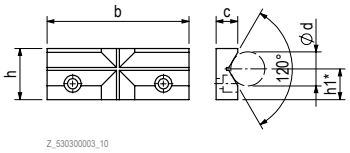
* Tolerance ±0.01 mm
All dimensions in [mm]
Flaxtion material included in scope of supply

Hardened and ground vee jaw

For horizontal and vertical clamping of round workpieces.
Scope of supply: Set with 1 vee jaw and 2 fixing screws

Type	Part no.	Dimensions b	c	h	h1	Clamping diameter d
NC 100	932751201	100	17	34	19	8–35
NC 125	932751301	125	19	45	27	10–50
NC 160	932751401	160	21	54	32	12–60



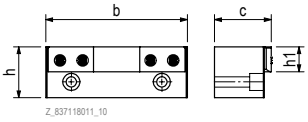


* Tolerance ± 0.01 mm, all dimensions in [mm]
fastening material included in scope of supply

Hardened and ground pendulum jaw with grip inserts

Pendulum jaws are used to compensate angular errors on the workpiece (max. swivel range 5°). They enable the safe clamping of sawn sections, for example, in a simple way. Use only on the clamping slide.
Scope of supply: Set with 1 pendulum jaw and 2 fixing screws

Type	Part no.	Dimensions b	c	h	h1	Base length L	Clamping range S
NC 100	on request	100	35	34	16	380	0–183
						540	0–343
NC 125	937118011	125	50	45	22	430	0–190
						560	0–320
						720	0–480
						1000	0–760
						1200	0–960
NC 160	937118014	160	55	54	26	550	0–271
						750	0–471
						1000	0–721
						1200	0–921



All dimensions in [mm]
fastening material included in scope of supply

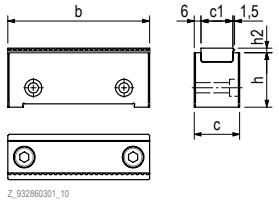
INFO Jaws with interchangeable insert

The clamping jaws can be used universally due to the interchangeable inserts. They can be used for clamping finished parts as well as blank clamping, even with round shapes.

Clamping jaws with grip/smooth interchangeable insert, hardened and ground

The clamping jaws can be used for blank and finished part clamping due to the interchangeable insert. If the grip texture is worn, only the interchangeable insert needs to be replaced. Used in pairs only. Optional clamping force display recommended.
Scope of supply: Set with 2 clamping jaws incl. interchangeable inserts & 8 fixing screws

Type	Part no.	b	b1^{H7}	c	c1	h	h1	h2	Base length L	Clamping range S
NC 100	932861201	100	78	34	22	37	34	4	380	9–172
									540	9–332
NC 125	932861301	125	98	40	28	48	45	4	430	9–184
									560	9–314
									720	9–474
									1000	9–754
									1200	9–954
NC 160	932861401	160	125	46	34	57	54	6	550	9–261
									750	9–461
									1000	9–711
									1200	9–911



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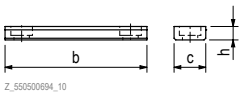
All dimensions in [mm]
fastening material included in scope of supply

Grip/smooth interchangeable insert, hardened and ground

Scope of supply: Set with 1 interchangeable insert and 2 fixing screws

Type	Part no.	Dimensions b	c	h	Base length L	Clamping range S
NC 100	932862201	100	22	10	380	12–175
					540	12–335
NC 125	932862301	125	28	12	430	12–187
					560	12–317
					720	12–477
					1000	12–757
					1200	12–957
NC 160	932862401	160	34	16	550	12–264
					750	12–464
					1000	12–714
					1200	12–914



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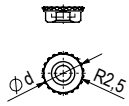
All dimensions in [mm]
fastening material included in scope of supply

Round, grip interchangeable insert, hardened and ground

The round interchangeable inserts are used for blank clamping. For example, they allow three-point clamping as well as the clamping of round workpieces. Optional clamping force display recommended.
Scope of supply: Set with 1 interchangeable insert and 1 fixing screw

Type	Part no.	Dimensions b	c	c1	Ød	h	h2	Base length L	Clamping range Ø
NC 100	932863201	100	34	22	27	10	4	380	40–185
								540	40–345
NC 125	932863301	125	40	28	33	12	4	430	52–202
								560	52–332
								720	52–492
								1000	52–772
								1200	52–972
NC 160	932863401	160	46	34	39	14	4	550	60–280
								750	60–480
								1000	60–730
								1200	60–930



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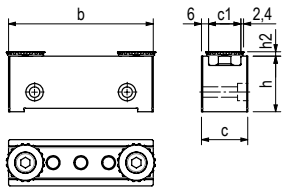

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All dimensions in [mm]
Fastening material included in scope of supply

PinFlex clamping jaws

+ Flexible without end

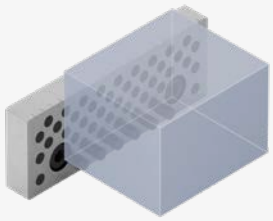
The use of PinFlex clamping jaws allows fast and precise alignment of workpieces. This is supported by horizontal and vertical scaling.

- Workpiece support steps
- Clamping depths
- Angle, contours
- Workpiece stop

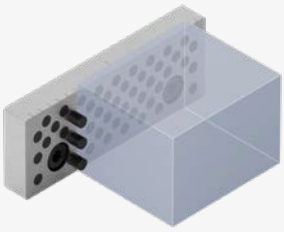
Dropping workpiece supports and disturbing workpiece stops are no longer required.

Function:
The pins are extended in rows with the aid of compressed air (e.g. compressed air gun) and pushed back individually depending on the application.

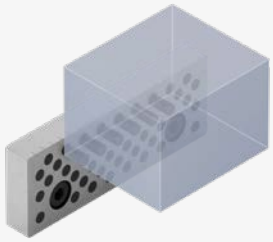
INFO PinFlex applications



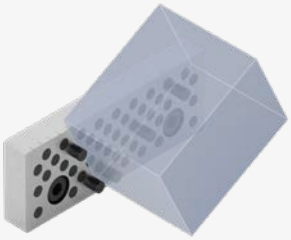
Depth clamping



Workpiece stop



Height clamping

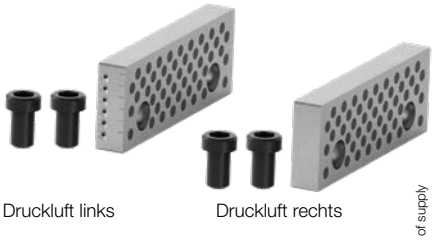


angle bracket

Hardened and ground PinFlex clamping jaw

Scope of supply: Set with 1 PinFlex clamping jaw (compressed air, left or right) and 2 fixing screws

Type	Order no. left	Order no. right	Dimensions b	c	h	Base length L	Clamping range S
NC 100	938282670	938282691	100	13	34	380	0–205
						540	0–365
NC 125	938282660	938282682	125	15	45	430	0–225
						560	0–355
						720	0–515
						1000	0–795
						1200	0–995
NC 160	938282680	938282701	160	18	54	550	0–308
						750	0–508
						1000	0–758
						1200	0–958



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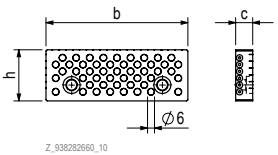

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All dimensions in [mm]
Fastening material included in scope of supply

SlimFlex jaw system

+ sma clamped

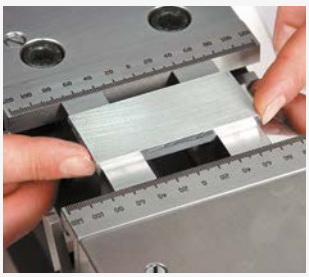
Optimised 3-sided machining of workpieces in one clamping operation

The SlimFlex jaw system allows 3-sided machining of centrally clamped workpieces that are dimensionally below the jaw width of the clamping device. Due to the step inserts, the workpiece is free to move against the base jaws and thus make it optimally accessible for the work spindle from 3 sides.

- No asymmetrical loading of the workpiece
- Simple adjustment of different jaw widths

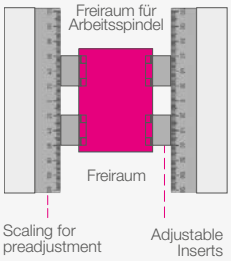
INFO SlimFlex operation

1. The blank is approx. 2 mm above the finished dimension



3. Insert workpiece blank centrally by sight and clamp

2. Set the outer edges of the inserts approx. 2 mm below the finished dimension.

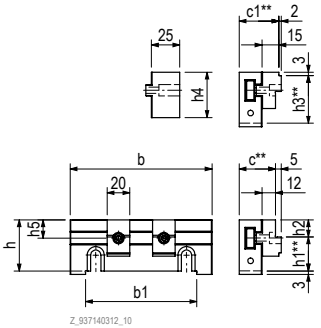


SlimFlex jaw system

without step inserts

with step inserts

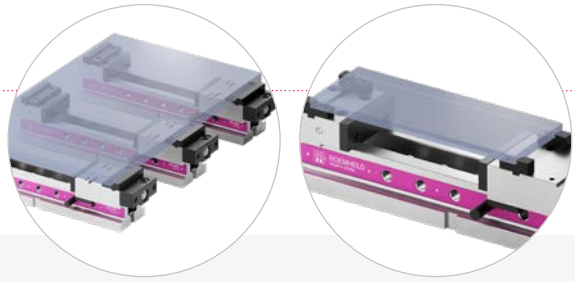
Used in pairs only. Scope of supply: Set with 2 SlimFlex jaws and 4 fixing screws with or without step inserts



* Tolerance ± 0.01 mm, ** Tolerance ± 0.02 mm
All dimensions in [mm]
Fastening material included in scope of supply

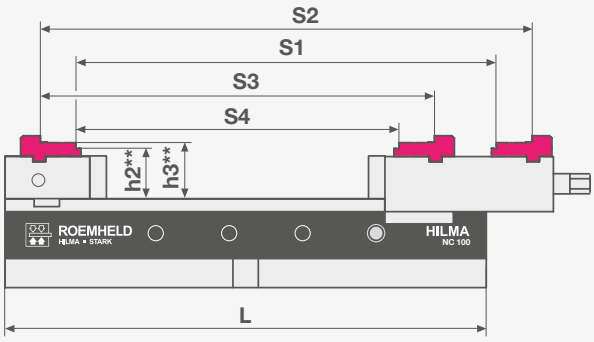
Type	Order no. without step inserts	Order no. with step inserts	Part no. Insert C45 soft	Dimensions b	b1 H7	c	c1	h	h1	h2	h3	h4	h5	Base length L	Clamping range S
NC 100	937141201	937142201	550500123	100	78	30	33	34	24	10	31	30	11	380	4–165 / 10–171
														540	4–325 / 10–331
NC 125	937141301	937142301	550500099	125	98	32	35	45	30	15	42	40	16	430	4–185 / 10–191
														560	4–315 / 10–321
														720	4–475 / 10–481
														1000	4–725 / 10–761
														1200	4–925 / 10–961
NC 160	937141401	937142401	550500099	160	125	34	37	54	39	15	51	40	16	550	4–271 / 10–277
														750	4–471 / 10–477
														1000	4–721 / 10–727
														1200	4–921 / 10–927

Top jaws



Top jaws are used for clamping large workpieces.

INFO Length & clamping ranges

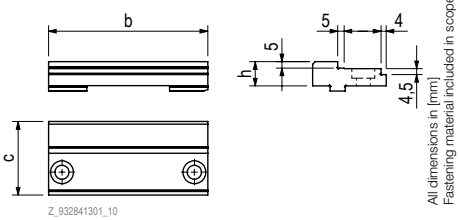


S1: Clamping range for lower step of top jaw
S2: Clamping range for upper step of top jaw
S3: Clamping range for lower step of top jaw
S4: Clamping range for upper step of top jaw
h2: Distance dimension between guideway and lower step of top jaw
h3: Distance dimension between guideway and upper step of top jaw

Hardened and ground top jaws

Top jaws are a simple and effective way to extend the jaw opening. They are used in pairs on slides and fixed jaws. Used for clamping pre-machined or finished workpieces. Used in pairs only.
Scope of supply: Set with 2 top jaws and 4 fixing screws

Type	Part no.	Dimensions			Base length L	Clamping range			
		b	c	h		S4	S3	S1	S2
NC 100	932843201	100	47.8	16.5	380	48–252	76–280	125–329	181–385
					540	48–412	76–440	125–489	181–545
NC 125	932843301	125	57.8	19.0	430	62–287	130–355	138–363	206–431
					560	62–417	130–485	138–493	206–561
					720	62–577	130–645	138–653	206–721
					1000	62–857	130–925	138–933	206–1001
					1200	62–1057	130–1125	138–1133	206–1201
NC 160	932843401	160	63.8	22.0	550	96–404	166–474	194–502	264–572
					750	96–604	166–674	194–702	264–772
					1000	96–854	166–924	194–952	264–1022
					1200	96–1054	166–1124	194–1152	264–1222

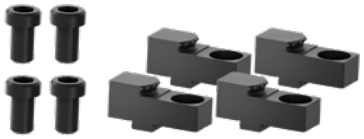


▶ Top jaws for vices before 2023 available on request

INFO New bore holes for top jaws

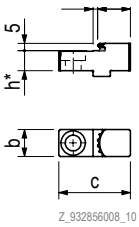
The top jaws listed above are suitable for the reworked fixed jaw. Recognisable from the new borehole pattern (see figure). Reworking of older vices by the customer is possible after consultation.

Grip top jaw segment, hardened and ground



Top jaw segments are used for clamping round blanks, for example.
A clamping force display is recommended. They are used in pairs on slides and fixed jaws.
Scope of supply: Set with 4 segments and 4 fixing screws

Type	Part no.	Dimensions					Base length L	Clamping range	
		b	c	c1	c2	h		S1	S2
NC 100	932851201	15	40	4	17	11.5	380	102–306	179–383
							540	102–466	179–543
NC 125	932851301	19	50	3	23	14	430	124–349	200–425
							560	124–479	200–555
							720	124–639	200–715
							1000	124–919	200–995
							1200	124–1119	200–1195
NC 160	932851401	28	60	6	22	17	550	171–479	269–577
							750	171–679	269–777
							1000	171–929	269–1027
							1200	171–1129	269–1227



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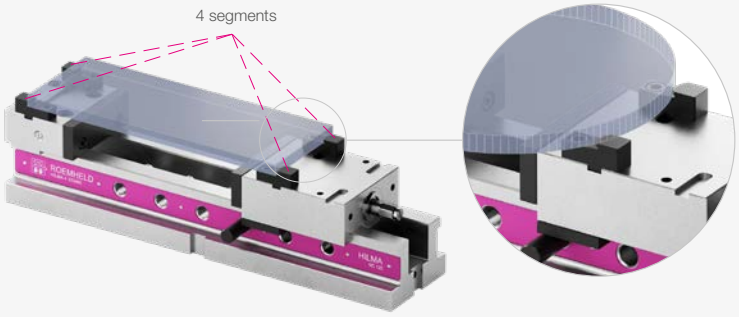
* Tolerance ±0.01 mm
All dimensions in [mm]
Fastening material included in scope of supply

INFO Top jaw segments

Top jaw segments are used with 2 each on the slide and fixed jaw.



QIS quick-change jaws

+ Set-up in record time

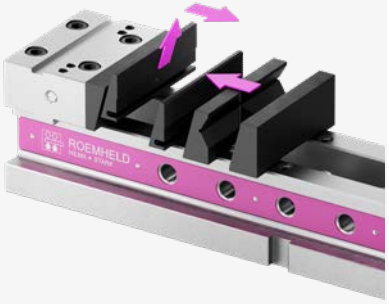
Jaw change in seconds with magnetic QIS jaws (Quick Insert System).

The base jaws of the QIS system are equipped with permanent magnets and are screwed to the fixed jaw or slide.
The QIS interchangeable jaws can be easily and quickly attached to the QIS base jaws without tools.

INFO Operating principle of the quick-change jaws

Mount the magnetic base jaw

Introduce QIS interchangeable jaw in parallel & guide alignment pin

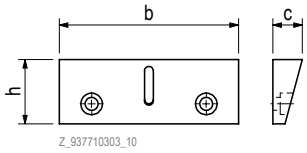


Push the QIS interchangeable jaw up to the end of the slot and tilt

Ground QIS base jaws with permanent magnets

Used in pairs only.
Scope of supply: Set with 2 base jaws and 4 fixing screws

Type	Part no.	Dimensions b	c	h
NC 100	937710213	100	16	34
NC 125	937710313	125	20	45
NC 160	937710413	160	23	54

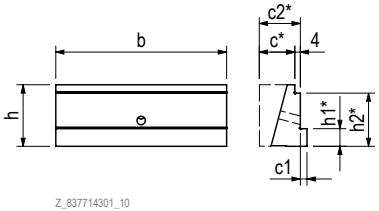


All dimensions in [mm]
Fastening material included in scope of supply

Hardened and ground QIS interchangeable jaw with steps

Used in pairs only.
Scope of supply: 1 interchangeable jaw

Type	Part no.	Dimensions b	c	c1	c2	h	h1	h2	Base length L	Clamping range Step h1	Step h2
NC 100	837714201	100	21	4	25	34	10	29	380	8–181	16–189
									540	8–341	16–349
NC 125	837714301	125	26	5	30	45	13	39	430	10–195	18–203
									560	10–325	18–333
									720	10–485	18–493
									1000	10–765	18–773
									1200	10–965	18–973
NC 160	837714401	160	31	5	35	54	15	45	550	10–274	18–282
									750	10–474	18–482
									1000	10–724	18–732
									1200	10–924	18–932

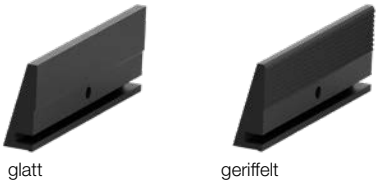


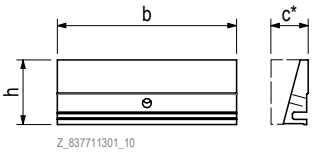
* Tolerance ±0.01 mm
All dimensions in [mm]

Smooth or serrated QIS interchangeable jaw, hardened and ground

For clamping finished parts (smooth) and for clamping blanks (serrated).
Scope of supply: 1 interchangeable jaw

Type	Part no. smooth	Part no. Serrated	Dimensions b	c	h	Base length L	Clamping range S
NC 100	837711201	837712201	100	21	34	380	0–189
						540	0–349
NC 125	837711301	837712301	125	26	45	430	0–203
						560	0–333
						720	0–493
						1000	0–773
						1200	0–973
NC 160	837711401	837712401	160	31	54	550	0–282
						750	0–482
						1000	0–732
						1200	0–932



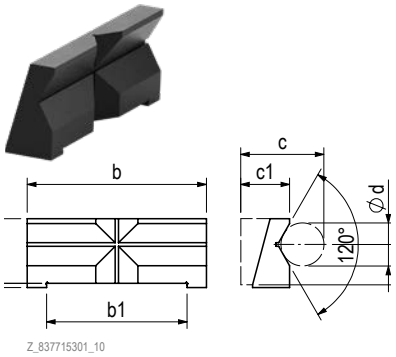


* Tolerance ±0.01 mm
All dimensions in [mm]

Hardened and ground QIS interchangeable jaw with prisms

For horizontal and vertical clamping of round workpieces.
Scope of supply: 1 interchangeable jaw

Type	Part no.	Dimensions b	b1H7	c	c1	h	h1	Clamping diameter d
NC 100	837715201	100	78	53	28.0	34	19	8–35
NC 125	837715301	125	98	58	34.2	45	27	10–50
NC 160	837715401	160	125	60	37.0	54	32	12–60

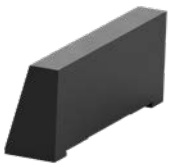


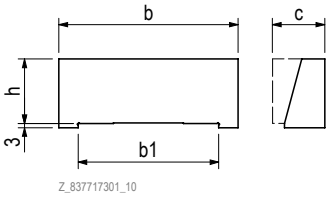
* Tolerance ±0.01 mm
All dimensions in [mm]

QIS interchangeable jaw, soft

Soft jaw for quick insertion of workpiece-specific clamping or contact points as well as contours.
Scope of supply: 1 interchangeable jaw

Type	Part no.	Dimensions b	b1H7	c	h	Base length L	Clamping range S
NC 100	837717201	100	78	30.0	34	380	0–171
						540	0–331
NC 125	837717301	125	98	36.5	45	430	0–182
						560	0–312
						720	0–472
						1000	0–752
						1200	0-952
NC 160	837717401	160	125	47.0	54	550	0–250
						750	0–450
						1000	0–700
						1200	0–900





All dimensions in [mm]

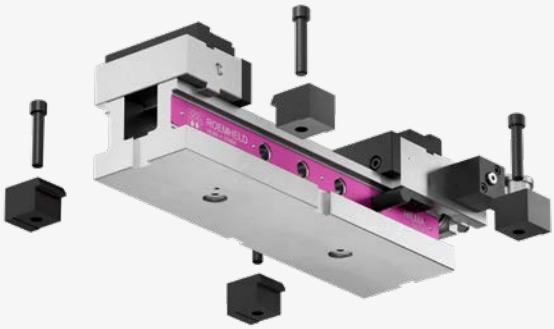
OPTIONS FOR FIXAXTION ON THE MACHINE TABLE

Mounting versions

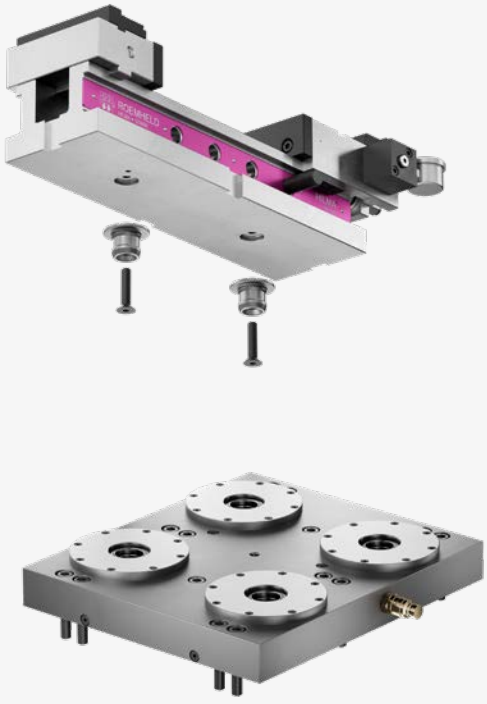
Stable fixation on the machine table is of great importance to ensure precise machining. Depending on the type of machining and the individual requirements, one of the fixation options shown below can be selected.

- Screw connection
- Clamping device such as clamping claws
- Zero point clamping system

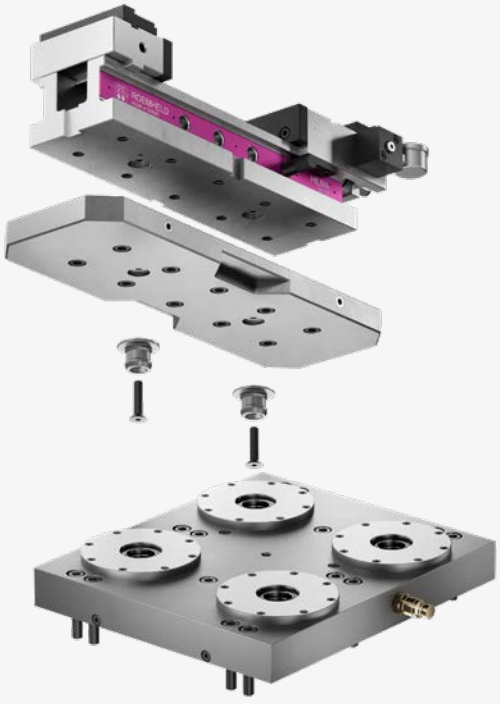
Fixation with screws



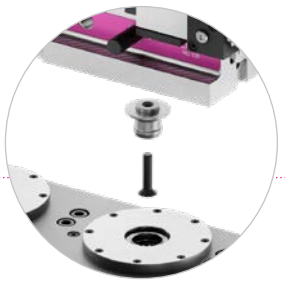
Fixing with clamping claws
(Recommendation: distance of the clamping claws < 200 mm)



Fixation with retractable nipples
directly into the zero point clamping system



Fixation with retractable nipples
using adapter plate
into the zero point clamping system



Retractable nipple for ZPC

Thanks to the integrated retractable nipple bore holes in the base of the vice, HILMA machine vices can be perfectly supplemented and combined with STARK zero point clamping systems.

A zero point clamping system consists of a fast closing clamp in which the retractable nipples are clamped. In order to compensate for manufacturing tolerances and the necessary "mobility for thermal expansion" on a pallet "temperature variation", three different retractable nipples are combined.

- Retractable nipple with zero point (NP)
- Retractable nipple with equaliser (AG)
- Retractable nipple without centring (OZ)

Retractable nipple for FCP STARK.classic.2

Part no.	Draw-in nipple
S804-470	with zero point STARK.classic.2 NP
S804-471	with compensation STARK.classic.2 AG
S804-472	without centring STARK.classic.2 OZ

Retractable nipple for FCP STARK.basic.M

Part no.	Draw-in nipple
S8000-300	with zero point STARK.basic.M NP
S8000-301	with compensation STARK.basic.M AG
S8000-302	without centring STARK.basic.M OZ

INFO Symbols

with zero point (NP)
without equaliser direction

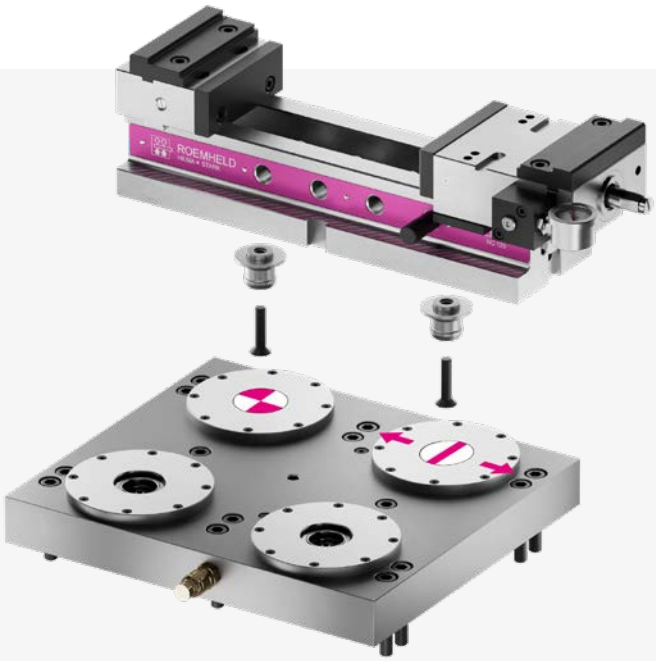
with equaliser (AG)
Compensation of theoretical centre in equaliser direction

without centring (OZ)
Compensation of theoretical centre in all directions

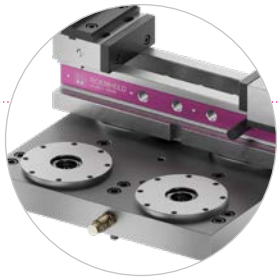
INFO Compensation principle

Depending on the requirement of the clamping situation, there are many options to compensate for tolerances in different materials and fixture sizes with the aid of retractable nipples. The combination of retractable nipples depends on the number of these on the machine vice.

Assignment examples:
- 2× retractable nipples
  NP - AG
- 3× retractable nipples
  NP - OZ - AG
- 4× retractable nipples
  NP - OZ - OZ - AG



Fast closing plate for ZPC

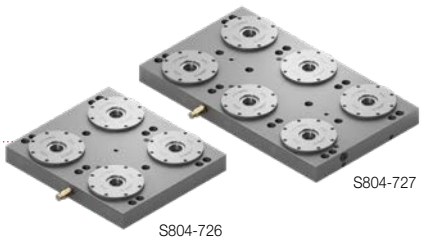


STARK standard fast closing plates (FCP) are a cost-effective entry-level solution for high-quality zero point clamping systems (ZPC) and provide a secure and versatile connection between the machine vice and machine table.

- Fast closing plate made of steel ground on both sides with threaded fastening holes for different slot spacings
- Zero point clamping system is clamped mechanically with spring force and released hydraulically/pneumatically
- Area of application on 3/4/5-axis machines for all common machining machining procedures such as milling, grinding, eroding

STARK.classic standard fast closing plate

- Hydraulic release system
- up to 120 kN active insertion force



S804-727

S804-726

Part no.	Quick-locking plate	Size	Gauge for bore holes
S804-726	Fast closing plate with 4 STARK.classic.2 (S804-452)	4x 396 × 346 × 46 mm	200 × 200 mm
S804-727	Fast closing plate with 6 STARK.classic.2 (S804-452)	6x 596 × 346 × 46 mm	200 × 200 mm

STARK.basic standard fast closing plate

- Pneumatic release system
- up to 54 kN retention force

S805-308

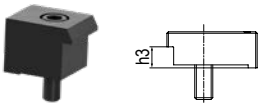
S805-307

Part no.	Quick-locking plate	Size	Gauge for bore holes
S804-307	Fast closing plate with 4 STARK.basic.M (S805-202)	4x 396 × 346 × 46 mm	200 × 200 mm
S805-308	Fast closing plate with 6 STARK.basic.M (S805-202)	6x 596 × 346 × 46 mm	200 × 200 mm

Clamping claws & keyblocks

clamping claws

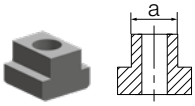
For safe clamping on the machine table.
Scope of supply: 4 clamping claws incl.
4 fixing screws



Part no.	Thread	h3 [mm]
937772011	M12	24
937773011	M12	27
937773021	M16	27

Nuts for T-slots, DIN 508

T-keyblock nuts are simply pushed in sideways to clamp the vice on the machine table.
Scope of supply: 4 keyblocks



Part no.	Thread	Width a
937773211	M12	14
937773231	M12	18
937773311	M16	18

Keyblocks, loose, DIN 6323

Loose keyblocks for precise alignment of the vice on the machine table in the longitudinal or crosswise keyway 20 H7.
Scope of supply: 2x keyblocks, loose

Part no.	Table slot a
939174121	14 h6
939174141	18 h6

ERGONOMIC AND SAFE OPERATON

Accessories for **HILMA.**NC series

Crank handle for **HILMA**.NC

for mechanical/hydraulic design

Type	Part no.	SW
NC 100	420560020	14
NC 125	420560019	17
NC 160	420560021	19

Crank handle for angle drive

Crank handle for angle drive
(only **HILMA**.NC series).
Crank handle is in scope of supply
Angle drive included.

Type	Part no.
Crank	420560031

Crank handle for **HILMA**.NCH

for hydraulic design

Type	Part no.	SW
NCH 100	420560022	8
NCH 125	420560022	8
NCH 160	420560023	10

Crank handle extension for **HILMA**.NC

for mechanical/hydraulic design

Type	Part no.	SW	Extension* [mm]
NC 100.540	520570021	14	154
NC 125.560	520570028	17	121
NC 125.720	520570022	17	268
NC 160.750	520570023	19	178

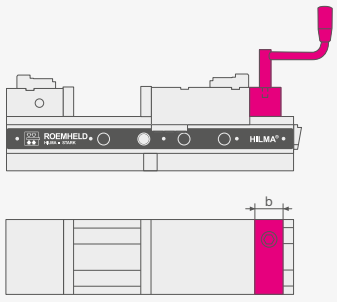
* actual extension after attachment

Angle drive with crank handle for **HILMA**.NC

for mechanical/hydraulic design.

Angle drive Crank handle

Type	Part no.	SW	b	Crank radius
NC 100	932940505	10	39	125
NC 125	932940605	10	43	125
NC 160	932940705	10	46	125



Crank handle extension for **HILMA**.NCH

for hydraulic design

Type	Part no.	SW	Extension* [mm]
NCH 100.540	520570024	8	156
NCH 125.560	520570027	8	141
NCH 125.720	520570025	8	301
NCH 160.750	520570026	10	224

* actual extension after attachment

Precision workpiece stop

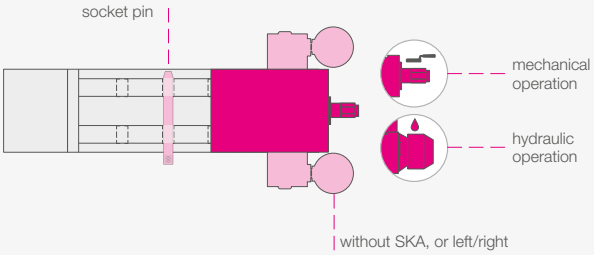
can be swivelled away, with fast clamping and adjustment in 2 planes

Type	Part no.	Thread
NC 100 NC 125	932910201	M12
NC 160	932910401	M20

INFO

Spare slides and slide accessories **HILMA**.NC and **HILMA**.NCH

The slide for mechanical operation, with and without clamping force display (SKA), and for hydraulic operation is available as an accessory. Socket pins and brake set are listed separately.



Spare slide for **HILMA**.NC

The spare slide models of the mechanical-hydraulic machine vice HILMA.NC are categorized according to jaw width (BB) and clamping force display (SKA) design. All slides are supplied without clamping bar, crank handle and socket pins.

Type	Order no. without SKA	Order no. SKA left	Order no. SKA right	Spare slides
NC 100	931220023	931220033	931220034	Slide for BB100 mechanical-hydraulic
NC 125	931230023	931230033	931230034	Slide for BB125 mechanical-hydraulic
NC 160	931240023	931240033	931240034	Slide for BB160 mechanical-hydraulic

Spare slide for **HILMA**.NCH

The spare slide models of the hydraulic machine vice HILMA.NCH are categorized according to jaw width (BB). All slides are supplied without clamping bar, crank handle and socket pins.

Type	Order no.	Spare slides
NCH 100	931320023	Slide for BB100 hydraulic-hydraulic
NCH 125	931330023	Slide for BB125 hydraulic-hydraulic
NCH 160	931340023	Slide for BB160 hydraulic-hydraulic

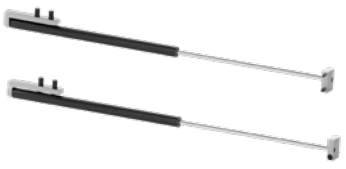
Socket pin

Spare socket pins for the HILMA.NC and HILMA.NCH machine vice are available in jaw widths of 100, 125 and 160 mm.

Type	Order no.	Socket pin
NC/NCH 100	730720006	Socket pin for BB100
NC/NCH 125	730730006	Socket pin for BB125
NC/NCH 160	730740006	Socket pin for BB160

Brake set

A brake can be retrofitted for the vertical set-up of the HILMA.NC, which prevents the clamping slide from being pushed back when the socket pin is pulled. For jaw width (BB) of 160 mm, additional bore holes must be drilled at the side of the base.



Type	Order no.	Brake set
NC 100	931220551	Brake set for BB100
NC 125	931230551	Brake set for BB125
NC 160	937690401	Brake set for BB160

Clamping force preselection, 6-stage

retrofittable for hydro-mechanical vices

Type	Part no.
NC 100	937620100
NC 125	937620125
NC 160	937620160

Oil filling nipple

Retrofittable for mechanical/hydraulic design

Type	Part no.
NC 100 NC 125	530900006
NC 160	530900007

Load cell

for regularly checking the clamping force of hydraulic and mechanical clamping systems

Part no.	Display range [kN]
295010001	0–60

Pump unit - for a single-acting clamping circuit

Flow rate: 0.82 l/min
max. operating pressure: 350 bar
Supply voltage: 3/PE 50Hz 400V
Control voltage: 24 VDC

without valves and manual switch
operation by valve with turning knob
with pressure monitoring

Part no.
6810565

Pump unit - for a single-acting clamping circuit

Flow rate: 0.82 l/min
max. operating pressure: 350 bar
Supply voltage: 3/PE 50Hz 400V
Control voltage: 24 VDC

with 1 manual switch with approx. 3 m cable
with pressure monitoring

Part no.
6810566

Pump unit - for two single-acting clamping circuits

Flow rate: 0.82 l/min
max. operating pressure: 350 bar
Supply voltage: 3/PE 50Hz 400V
Control voltage: 24 VDC

with 2 manual switches with approx. 3 m cable
with pressure monitoring

Part no.
6810567

ROEMHELD power unit product range D 8.0115 (www.roemheld-gruppe.de)

INFO Hydraulic power unit

For the hydraulic supply and control of hydraulic clamping systems, we offer the suitable clamping power units. Completely equipped with the necessary electrical and hydraulic control, the desired operating element such as hand panel or foot switch as well as the integration into the machine control.

Basic unit without directional control valves and remote control
External control via rotary handle valves.

1-circuit version, for clamping and releasing one or more machine vices simultaneously. With plug-in remote control.

2-circuit version, for two separately controllable circuits (pendulum machining). With two remote controls.

Order number list

ROEMHELD
HILMA ▪ STARK

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