

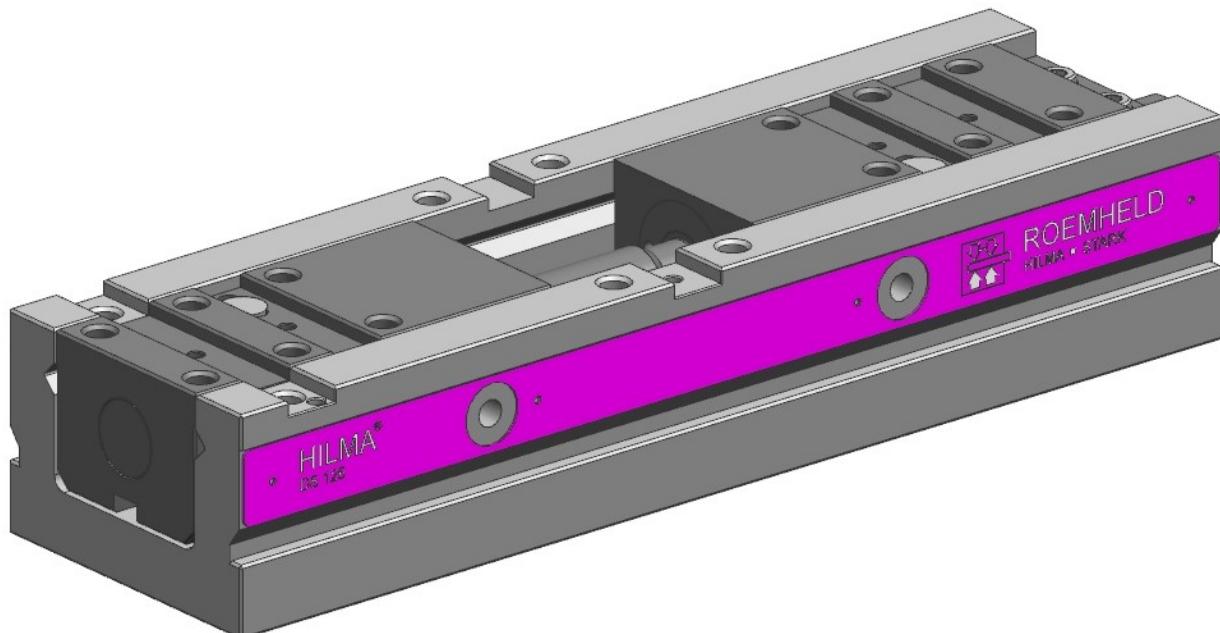


# Operating Manual

incl. declaration of incorporation and installation instructions  
for incomplete machines as per machinery directives 2006/42/EC

Double Workholding System DS 100  
Double Workholding System DS 125

Type 9.3665.xxxx  
Type 9.3666.xxxx



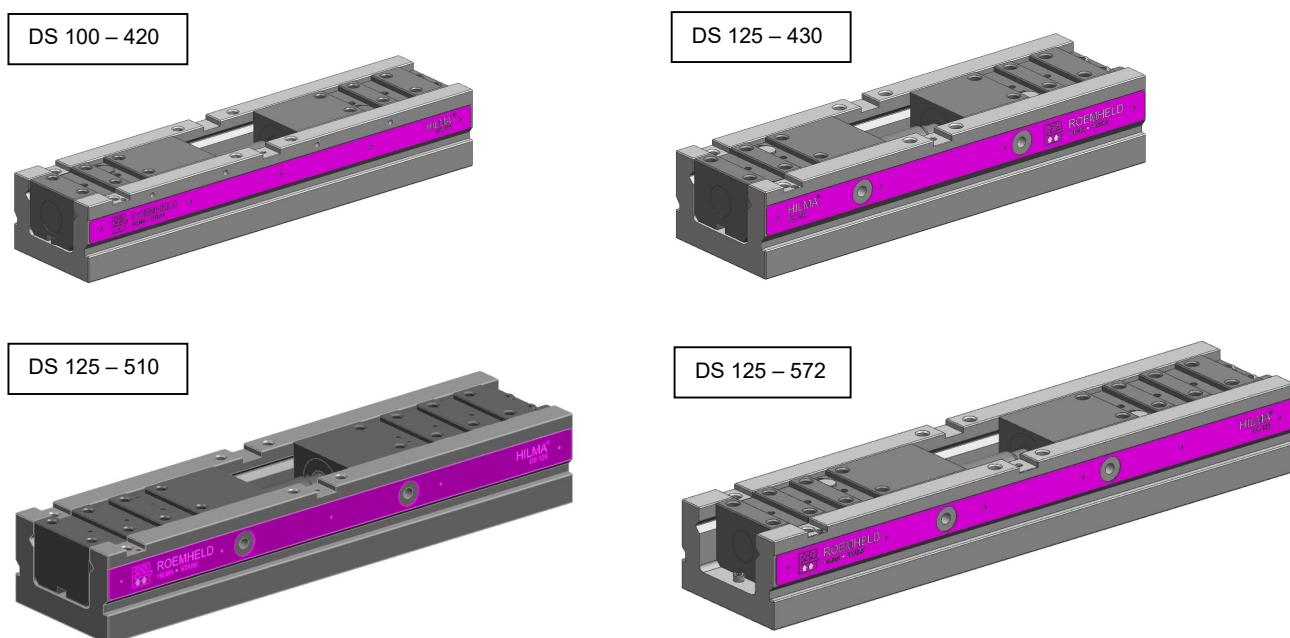
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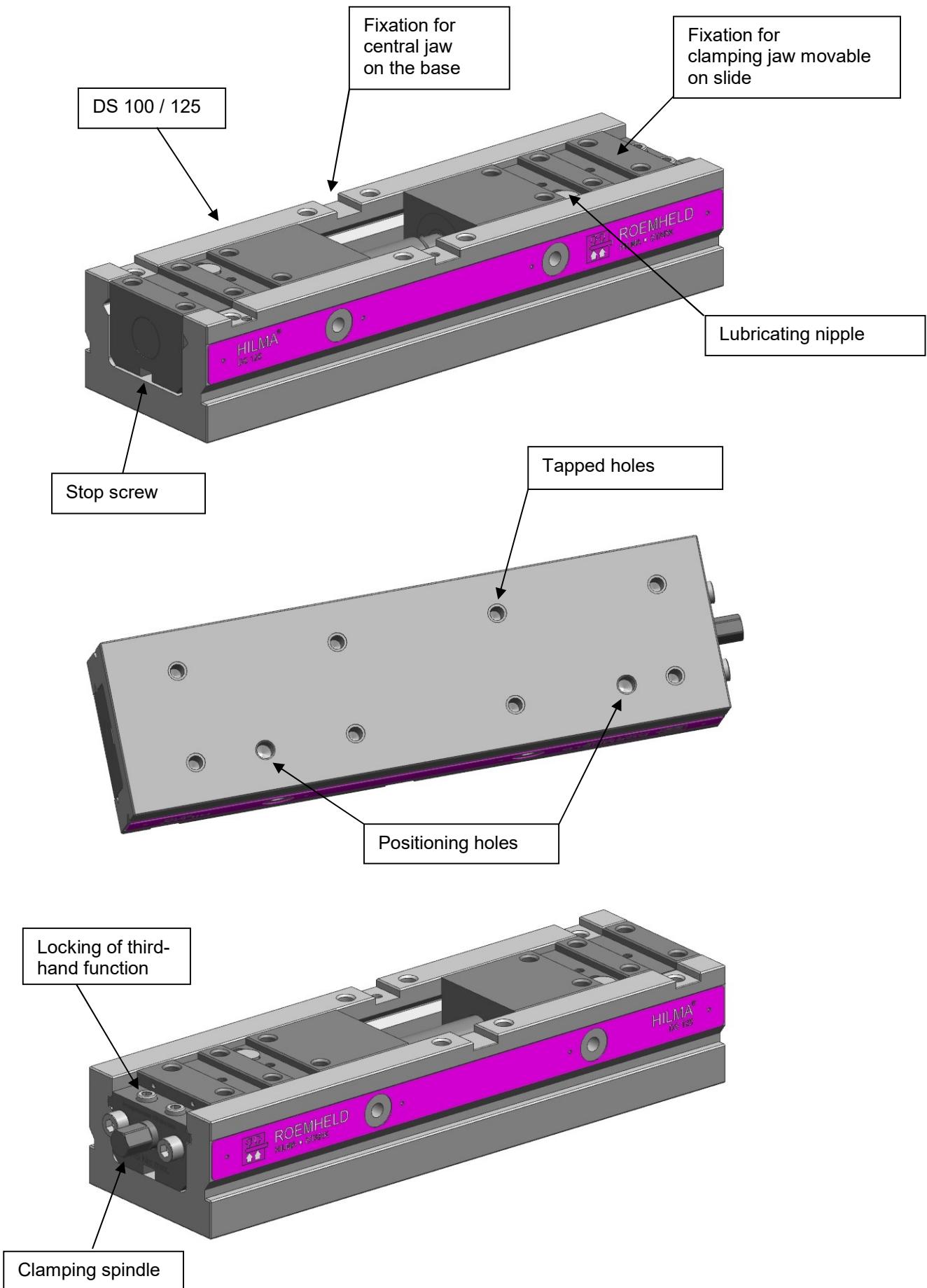


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**For safe and functional operation, it is imperative to read the operating manual before installation and start-up!**

**1.1 Series**





## **1.3 Description of the workholding system**

The product is designed for universal workpiece clamping on machine tools and for simultaneous clamping of one to four workpieces. The clamping points can be loaded with differently-sized workpieces. The clamping range setting allows both clamping slides to be opened evenly and thus allows an undisturbed workpiece change.

The third-hand function allows the workpiece insertion in sequence, which is particularly advantageous for "top-heavy" parts.

When the clamping jaws are mounted, the slides are guided without play and the spindle moves smoothly.

Construction easy to maintain. After disassembly of the clamping jaws and a stop screw, the slide unit can be removed from the base.

## **1.4 For your safety**

### **Basic information**

The operating manual serves for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with this operating manual, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.
- Before start up, carry out a collision check taking into account the working space of the machine.
- Screw the workholding system immovably onto the machine table.
- The workpiece clamping forces must be high so that the machining forces cannot move the workpiece.
- During start up and in continuous operation, suitable measures must be taken to prevent any danger of crushing due to the slide stroke.
- For safe clamping, only part of the hydraulic power stroke may be used as the insertion clearance.
- Check clamping force regularly using a force measuring gauge.
- Install protective guards or provide two-hand control to prevent hazards (crushing).

### **Safety instructions**

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual to avoid personal or material damage.

- Read this operating manual thoroughly and completely, before you work with the product.
- Keep this operating manual so that it is accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer to exclude danger to persons because of not suited spare parts.
- Respect the intended use.
- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.
- Perform a risk analysis for the incomplete machine, or the machine.

Interactions between the product and the machine/fixtures or its environment may result in risks, which may only be identified and minimized by the user, e.g.:

- Forces generated,
  - Movements initiated,
  - Influence of hydraulic and electrical control,
  - etc.
- Use of personal protective equipment is to be considered for all work steps.



## Use

### Intended use

The products are exclusively designed for clamping workpieces in industrial applications. They must only be operated with hydraulic oil.

In addition, use in compliance with the intended purpose includes:

- Use within the capacity limits specified in the technical data (see data sheet).
- Use as described in this operating manual.
- Compliance with maintenance intervals.
- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.
- Only HLP hydraulic oils may be used.
- Only clamping jaws may be moved.

### Inappropriate use



#### WARNING

**Injuries, material damages or malfunctions!**

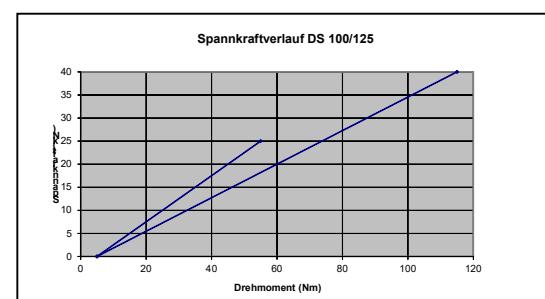
- Do not modify the product!

The use of these products is not admitted:

- For domestic use.
- On pallets or machine tool tables in primary shaping and metal forming machine tools.
- If due to physical/chemical effects (vibrations, welding currents or others), damages of the products or seals can be caused.
- In machines, on pallets or machine tool tables that are used to change the characteristics of the material (magnetize, radiation, photochemical procedures, etc.).
- In areas for which special guidelines apply, especially installations and machines:
  - For the use on fun fairs and in amusement parks.
  - In food processing or in areas with special hygiene regulations.
  - For military purposes.
  - In mines.
  - In explosive and aggressive environments (e.g. ATEX).
  - In medical engineering.
  - In the aerospace industry.
  - For passenger transport.
- For other operating and environmental conditions e.g.:
  - Higher operating pressures than indicated on the data sheet or installation drawing.
  - With hydraulic fluids that do not correspond to the specifications.
  - Higher flow rates than indicated on the data sheet or installation drawing.

## 1.5 Technical data

Jaw width mm	Length mm	Clamping force kN	Torque N	Clamping stroke per slide	Weight kg
100	420	25	55	44	20
125	430	40	115	44	29
125	510	40	115	44	35
125	572	40	115	48	39



## 1.6 Delivery

The workholding system is supplied in assembled condition including operating manual.



## 2.1 Fixing on the machine table

The workholding systems must be fixed in such a way that they cannot be displaced by machining forces.

- Unevenness and swarf between the contact surface and the base surface shall be removed.
- Before start up, carry out a collision check taking into account the working space of the machine.
- Alignment
  - with the dial gauge
  - with positioning pins.
- Fixing
  - with screws

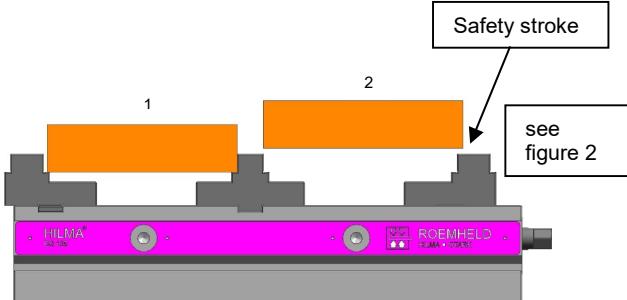
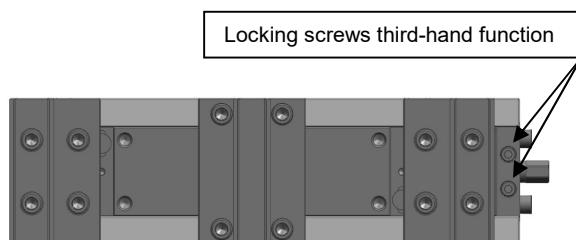
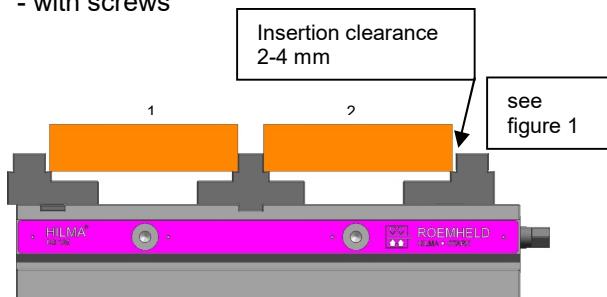
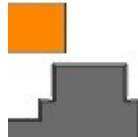
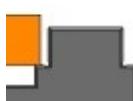


Figure 1 insertion clearance

Figure 2 safety stroke

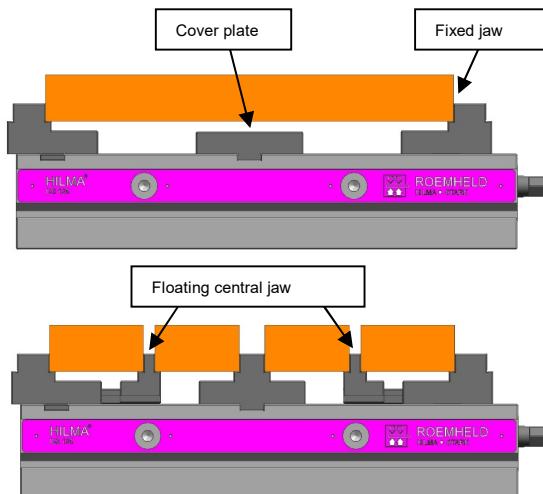


## 2.2 Setting the clamping range and the third-hand function

- By rotating the spindles counterclockwise, open the double workholding system until the stop. (Locking screws of the third-hand function are loosened)
- Select and fix the appropriate set of jaws for the workpieces. Pay attention to the cleanliness between the jaws and the guide.
- Tighten the locking screws third-hand function.
- Insert workpiece 1 and place it against the fixed jaw using the spindle.
- Loosen the locking screws third-hand function.
- Set insertion clearance 2-4 mm for workpiece 2 by rotating the spindle clockwise and tighten the locking screws third-hand function. (Figure 1)
- Check safety stroke (min. 2 mm). To do this, rotate the spindle counter clockwise until clamping point 2 is open. Remove workpiece 2 (workpiece 1 remains clamped). Rotate the spindle clockwise until the clamping jaw for workpiece 2 moves under the workpiece. (Figure 2)
- When adjusting the third-hand function, the workpieces are not clamped (secure the workpieces against falling out when vertically mounted).

## 2.3 Clamping and unclamping

- By rotating the spindle clockwise using a torque wrench, workpiece 1 is first preloaded with 1 kN by the third-hand function.
- Now workpiece 2 is inserted and both workpieces are clamped simultaneously with the same clamping force.
- When unclamping counter clockwise, first workpiece 2 and the workpiece 1 is released. Unlike clamping point 1, clamping point 1 is not limited in its opening stroke.
- **Attention:** Violent rotating will damage the system



## 2.4 Individual clamping

- To do this, mount a fixed jaw that holds the left slide in place and a cover plate.

## 2.5 Quadruple clamping

- Select the guide plates of the floating central jaws suitable for the workpiece size and screw them onto the slide. Clamping and unclamping analogue 2.3

## 2.6 Workpiece support

- The workpieces are always placed on the clamping jaws or on the workpiece supports.
- The guideway of the base is **not** permitted as workpiece support.

## 2.7 Error messages

Trouble	Cause	Remedy
Max. jaw opening is not reached	Locking screw third-hand function tightened	Loosen locking screws third-hand function
Inaccurate angular position of the movable jaw	Due to unclean assembly swarf between jaws and guide	Disassemble jaws, clean, remove if necessary, lubricate and assemble
Workpiece is not clamped despite introduction of the correct torque	Clamping range overlap not sufficient	See 2.2 Setting the clamping range and the third-hand function
Spindle stiff	Grease lubrication washed out by emulsion	Lubricate spindle and bearing

## 2.8 Operation

### ⚠ WARNING

#### Vibration will loosen the product fixture!

Vibration affects the workpiece fixture and results in an improperly fixed workpiece. An improperly fixed workpiece may be catapulted off the product during machining and result in personal injuries or damage to property.

- Exclude vibration on the product if possible.

#### Risks of burns caused by hot workpieces!

Hot workpieces may cause burns on parts of the body.

- Wear heat-resistant protective clothing.

#### Risk of injuries during workpiece clamping!

The workpiece properties may induce personal injuries during clamping if the workpiece is not clamped properly.

- Remove contamination on the clamping surfaces before clamping.
- Observe material properties of the workpiece during clamping.
- Observe workpiece shape during clamping.
- Observe workpiece clamping surface during clamping.
- Observe workpiece inertia during clamping.

## ⚠ CAUTION

### Risk of injuries by crushing of extremities during clamping

The product is to be used in a manner so that the operator's own or other persons' extremities may not be squeezed during clamping.

- Keep your own or other persons' extremities off the clamping area during clamping.

## 2.9. Maintenance

### ⚠ WARNING

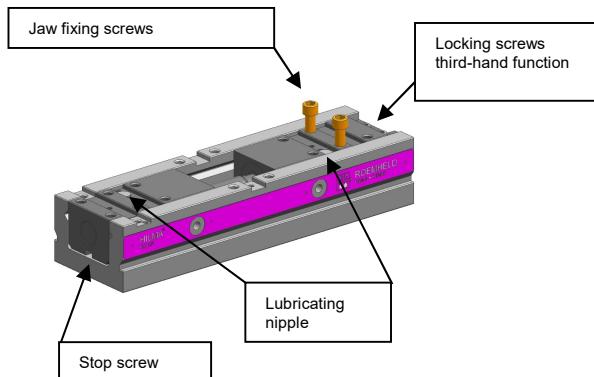
#### Burning due to hot surface!

- In operation, surface temperatures of over 70°C may develop on the product.
- Maintenance and repair work should only be performed in a cooled down condition and/or with protective gloves.

#### Risk of injuries by breaking product parts!

Due to overload or faulty operation during operation, product parts may break, and this may cause personal injuries.

- Observe maintenance intervals for all parts pursuant to this Operating Manual.



### 2.9.1 Maintenance and care

- In addition to normal cleaning of the spindle and bearings, lubricate with grease at regular intervals via the grease nipples (e.g.: BP Energearse LS-EP 2).
- For basic cleaning, unscrew the jaws, after removing the stop screw, remove the slide system from the base using two jaw fixing screws. Then clean and lubricate

## 2.10 Maintenance plan

Maintenance works	Interval	Realisation
Cleaning	As required	Operator
Regular checks	daily	Operator
Regular lubrication (with bed way oil, e.g. Vactra 2)	At the latest after 5,000 clamping cycles Alternatively 1 per week	<b>⚠ Caution!</b> If this lubrication will not be made, this can lead to a failure of the fixture clamp!
Repair		Qualified personnel

## 2.11 Cleaning

### ⚠ CAUTION

#### Damage to moving components!

Avoid damage to moving components (rods, plungers, bolts, etc.) as well as wipers and seals.

#### Aggressive cleaning agents

The product must not be cleaned with:

- corrosive or caustic substances or
- organic solvents as halogenated or aromatic hydrocarbons and ketones (cellulose thinner, acetone, etc.), since this can damage the seals.

The element must be cleaned at regular intervals. Especially the clamping slide and the housing have to be cleaned of swarf and other liquids.

In the case of heavy contamination, cleaning must be made at shorter intervals.



## Regular checks

1. Check tightness of hydraulic connections (visual control).
2. Leakage control at the housing and the clamping slide.
3. Clamping force control by pressure control.
4. Check the observance of the maintenance intervals.

## **2.12 Service / maintenance service**

### 1. In Germany

Maintenance by manufacturer

Please send the workholding system carriage paid.

Maintenance at customer workshop:

Please call maintenance service - information 12.3011.

Service phone: 02733 – 281 150

### 2. Internationally

Please contact the HILMA-RÖMHELD general importer or your local dealer.

## **Proposal, tightening torques for screws of tensile strength 8.8, 10.9, 12.9**

### **NOTE**

- The indicated values are approximate values and have to be interpreted according to the user's application!  
See note!

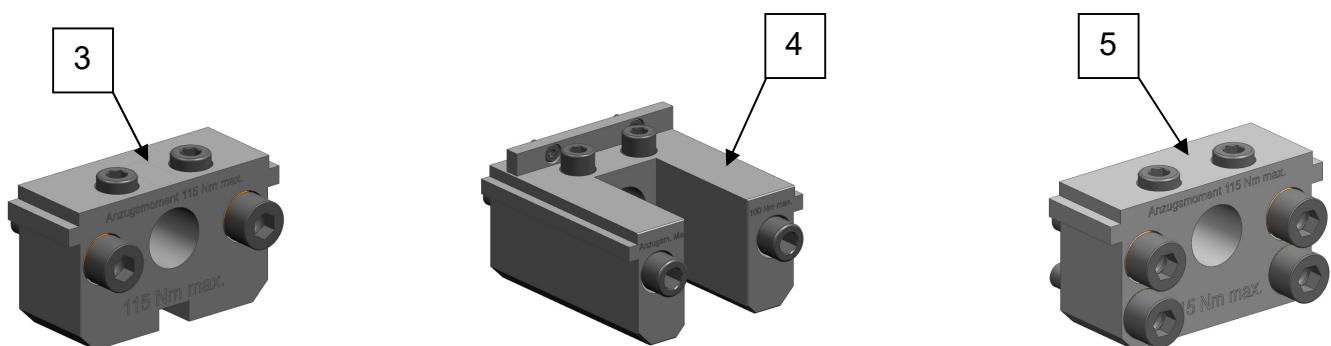
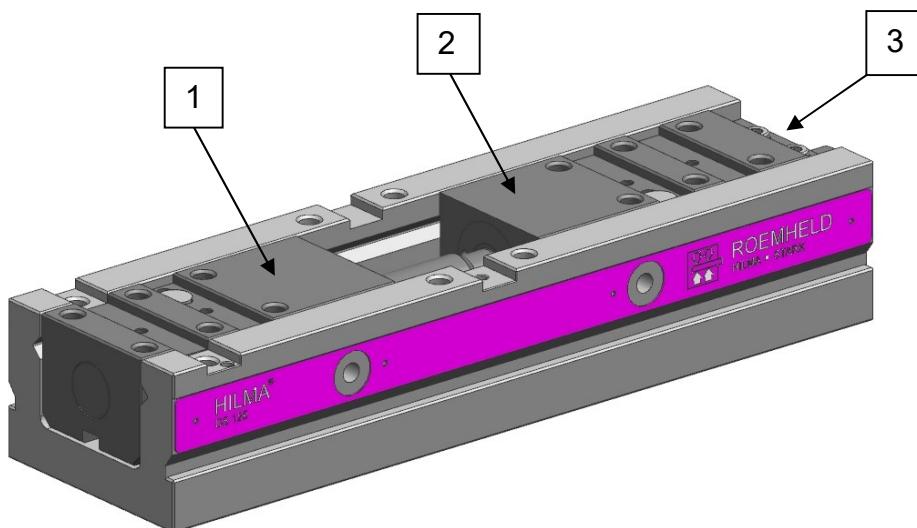
Thread	Tightening torque (MA) [Nm]		
	8.8	10.9	12.9
M6	10	15	18
M8	25	36	45
M10	49	72	84
M12	85	125	145
M14	135	200	235
M16	210	310	365
M20	425	610	710

**Note:** Applicable to workpieces and set screws made of steel with metric thread and connecting surface dimensions as per DIN 912, 931, 933, 934 / ISO 4762, 4014, 4017, 4032

The tightening torque (MA) values in the table take account of:

Steel/steel design, friction value  $\mu$ ges = 0.14 - not lubricated, utilisation of minimum yield point = 90%.

## 2.13 Spare parts



Clamping system	Slide unit Pos. 1	Slide unit drive Pos. 2	Block third-hand with slot Pos. 3	Block third-hand extended Pos. 4	Block third-hand reinforced Pos. 5
DS 100 – 420 long	7.3365.0001	7.3365.0002	7.3365.0003	-	-
DS 125 – 430 long	7.3366.0019	7.3366.0021	7.3366.0016	7.3366.0017	7.3366.0018
DS 125 – 510 long	7.3366.0001	7.3366.0002	7.3366.0016	7.3366.0017	7.3366.0018
DS 125 – 572 long	7.3366.0013	7.3366.0014	7.3366.0016	7.3366.0017	7.3366.0018



## **3.1. Disposal**



### **Hazardous to the environment**

To avoid potential environmental damage, the individual components have to be disposed of by approved expert companies.

All materials have to be disposed of in compliance with the applicable codes and regulations as well as environment protection regulations.

Particular importance is to be attached to the disposal of components containing residues of pressure liquids. The notes regarding disposal in the safety data sheet have to be observed.

As regards the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) the country-specific statutory requirements and regulations have to be complied with.

## **3.2 Declaration of incorporation**

### **Manufacturer**

Hilma-Römhled GmbH  
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57271 Hilchenbach Germany  
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[www.roemheld-group.com](http://www.roemheld-group.com)

The products are designed and manufactured in line with the relevant versions of the directives **2006/42/CE** (EC-MSRL) and in compliance with the valid technical rules and standards.

In accordance with EC-MSRL, these products are components that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

The products may only be put into operation after it was assessed that the incomplete machine / machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.  
The technical documentation as per appendix VII part B was prepared for the products.

## **3.3 List of the used standards**

Product Safety Act - ProdSG; November 2011

**DIN EN ISO 12100**, 2011-03, Safety of machinery; Basic concepts, General principles for design (replacement for part 1 + 2)

**DIN EN ISO 13857; 2008-06**, Safety of machinery - Safety distances to prevent hazard zones being reached by upper and lower limbs.  
(replaces: DIN EN 294)

**DIN EN 349**, 2008-09, Safety of machinery - Minimum gaps to avoid crushing of parts of the human body

**DIN EN 81714-2**, 2007-08, Design of graphical symbols for use in the technical documentation of products

**DIN EN 82079; 2010-10**, Preparation of instructions, structuring, content and presentation - Part 1

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Hilchenbach, July 8, 2020