



**ROEMHELD**  
HILMA ■ STARK

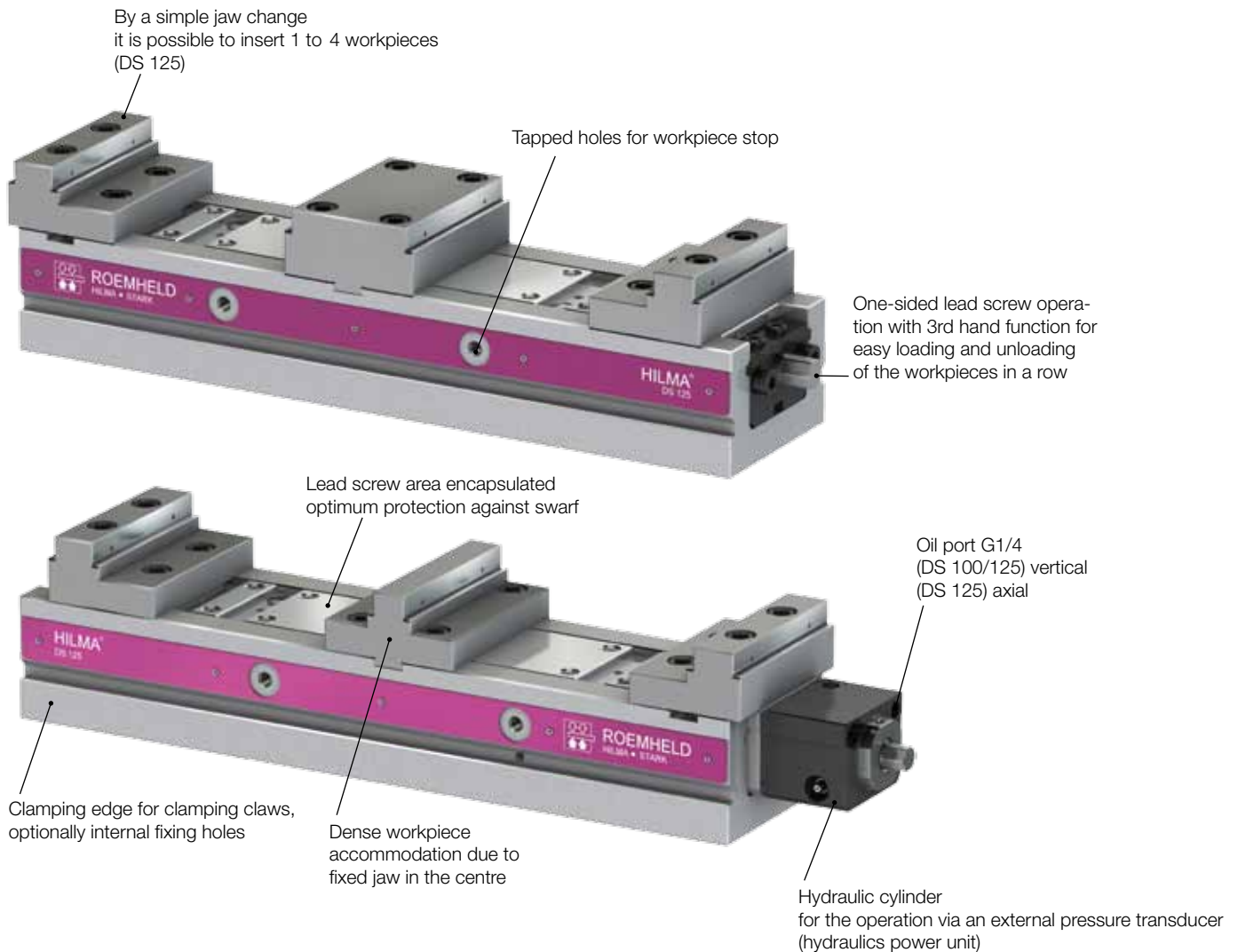


**Workholding Systems**

# HILMA DS

3.3660

3.3680



## Your benefits at a glance:

- ★ Flexible use
- ★ User friendly
- ★ Fixing on the machine table
- ★ High efficiency
- ★ Operation



DS 100 hydraulic



DS 125 mechanical  
with floating central jaws



DS hydraulic arranged in a row for clamping of workpieces which require several clamping points. Can be automated.

With a corresponding jaw selection 1 to 4 workpieces (DS 125), also of different dimensions, can be clamped. This allows a high flexibility in series production.

The operation of all clamping points is made via one lead screw side. The 3rd hand function ensures a user-friendly and safe clamping of workpieces arranged in a row.

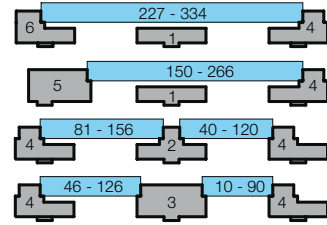
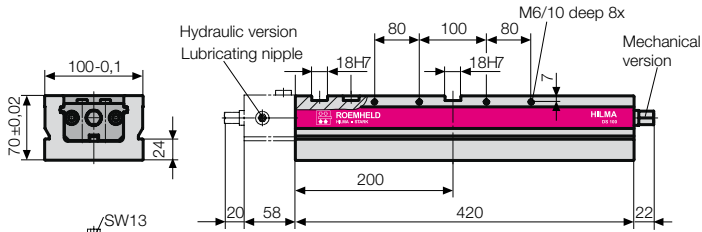
By means of the insertion of fixing holes, the double clamping system DS can be directly clamped through the base onto the machine table. Thus, disruptive clamping jaws are no longer required and a closer side-by-side arrangement of the clamping systems is possible.

The arrangement of a central fixed jaw does not only provide high precision (cancellation of clamping forces) but also results in considerable cost reduction due to less jaws.

For medium and large series with preferably short cycle times, the double clamping system DS enables the operation by a separate pressure transducer (hydraulic power unit). Therefore a user-friendly operation by means of a manual switch or foot switch is possible.



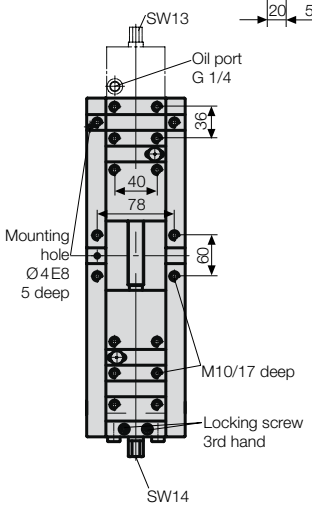
**Double clamping system DS 100, hydraulically or mechanically operated**



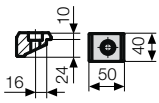
DS 100	mechanical	hydraulic
Clamping force / torque	25 kN / 55 Nm	25 kN / 400 bar
Clamping stroke per slide	44 mm	44 mm
Power stroke / oil volume	-	10 mm/8 cm <sup>3</sup> 5 mm/side
Weight without clamping jaws	19.5 kg	21 kg
Part no. standard	<b>9.3665.0101</b>	<b>9.3685.0101</b>
Part no.	Planned variant for customer-specific mounting and fixation on request.	

Pos.	Part no.	Description
1	<b>9.3791.5140</b>	Guide plate
2	<b>9.3791.5111</b>	Central step jaw 26 mm
3	<b>9.3791.5121</b>	Central step jaw 86 mm
4	<b>9.3791.5211</b>	Reversible step jaw
5	<b>9.3791.5341</b>	Fixed step jaw
6	<b>9.3791.5311</b>	Fixed step jaw

The standard clamping jaws allow the accommodation of 1 to 2 workpieces with identical or different dimensions.



All dimensions in mm



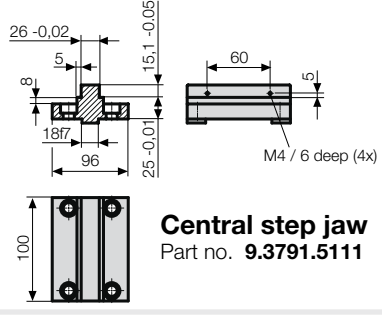
**Set of clamping claws 4 off**  
with 4 screws DIN 912  
Part no. **9.3777.2011**  
for T-slot 14 mm



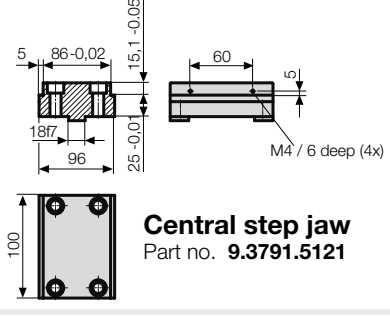
**Torque wrench**  
Part no.. **9.3792.6610**  
20–120 Nm with reversible ratchet and square 1/2" with ball lock  
**SW 14 socket wrench 1.3124.0020 mech.**

**DS 100 standard jaws, case-hardened and ground with 8 mm steps (free space for tools and swarf)**  
Supplied including fixing screws.

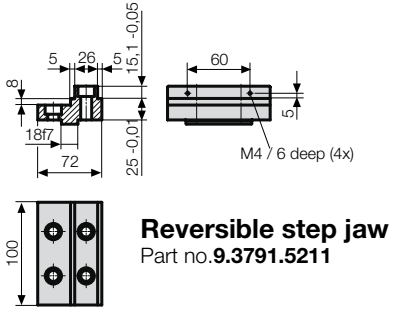
Mounting holes for all jaws KM 10  
All dimensions in mm



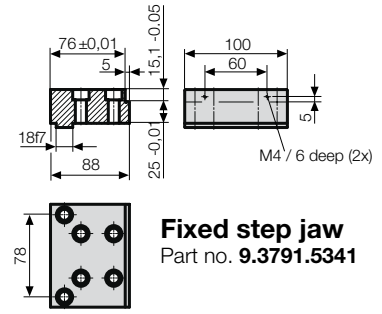
**Central step jaw**  
Part no. **9.3791.5111**



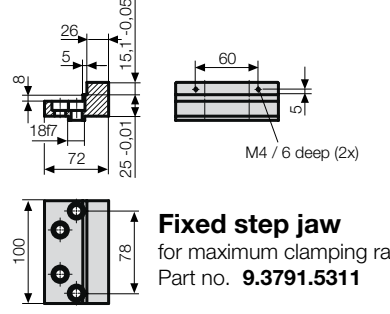
**Central step jaw**  
Part no. **9.3791.5121**



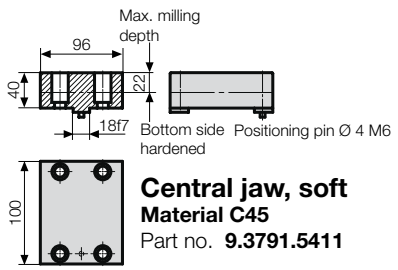
**Reversible step jaw**  
Part no. **9.3791.5211**



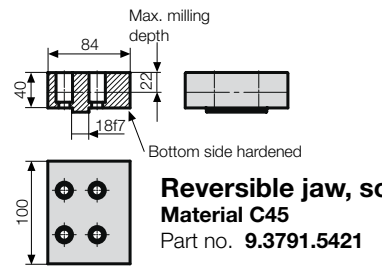
**Fixed step jaw**  
Part no. **9.3791.5341**



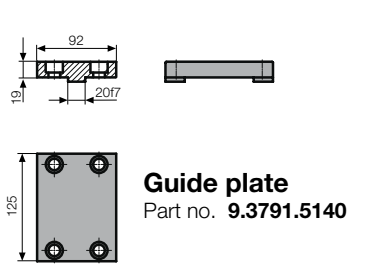
**Fixed step jaw**  
for maximum clamping range  
Part no. **9.3791.5311**



**Central jaw, soft Material C45**  
Part no. **9.3791.5411**



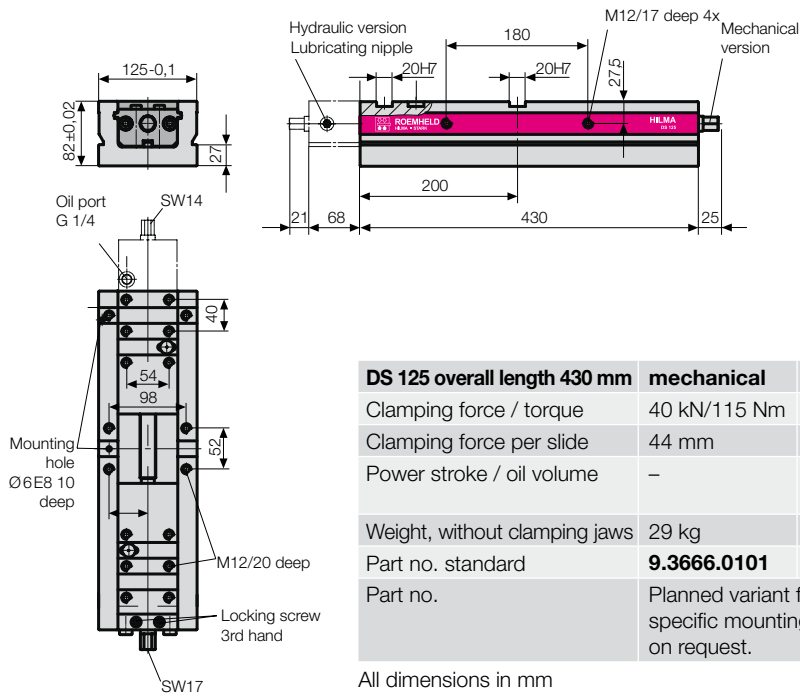
**Reversible jaw, soft Material C45**  
Part no. **9.3791.5421**



**Guide plate**  
Part no. **9.3791.5140**

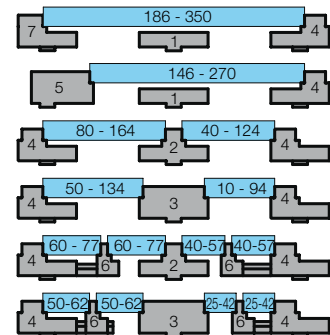


## Double clamping system DS 125, overall length 430 mm, hydraulically or mechanically operated



DS 125 overall length 430 mm	mechanical	hydraulic
Clamping force / torque	40 kN/115 Nm	40 kN/400 bar
Clamping force per slide	44 mm	44 mm
Power stroke / oil volume	-	10 mm/10 cm <sup>3</sup> 5 mm/side
Weight, without clamping jaws	29 kg	32 kg
Part no. standard	<b>9.3666.0101</b>	<b>9.3686.0101</b>
Part no.	Planned variant for customer-specific mounting and fixation on request.	

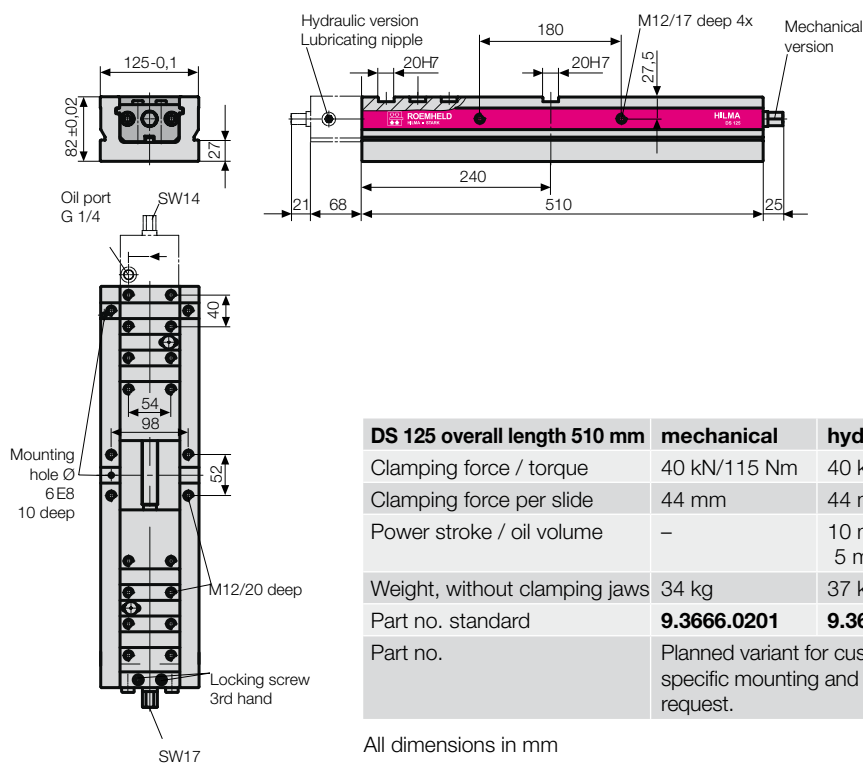
All dimensions in mm



Pos.	Part no.	Description
1	<b>9.3791.6140</b>	Guide plate
2	<b>9.3791.6111</b>	Central step jaw 22 mm
3	<b>9.3791.6121</b>	Central step jaw 82 mm
4	<b>9.3791.6211</b>	Reversible step jaw
5	<b>9.3791.6341</b>	Fixed step jaw
6	<b>9.3791.6541</b>	Floating central jaw
7	<b>9.3791.6311</b>	Fixed step jaw

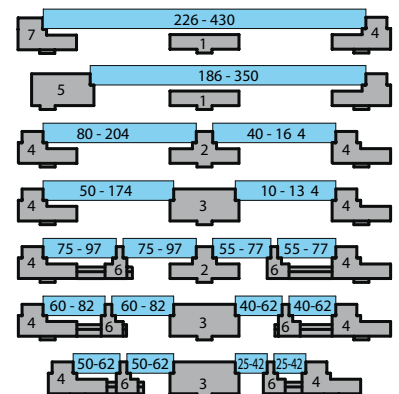
The standard clamping jaws allow the accommodation of 1 to 4 workpieces with identical or different dimensions.

## Double clamping system DS 125, overall length 510 mm, hydraulically or mechanically operated



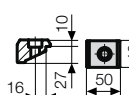
DS 125 overall length 510 mm	mechanical	hydraulic
Clamping force / torque	40 kN/115 Nm	40 kN/400 bar
Clamping force per slide	44 mm	44 mm
Power stroke / oil volume	-	10 mm / 10 cm <sup>3</sup> 5 mm/side
Weight, without clamping jaws	34 kg	37 kg
Part no. standard	<b>9.3666.0201</b>	<b>9.3686.0201</b>
Part no.	Planned variant for customer-specific mounting and fixation on request.	

All dimensions in mm



Pos.	Part no.	Description
1	<b>9.3791.6140</b>	Guide plate
2	<b>9.3791.6111</b>	Central step jaw 22 mm
3	<b>9.3791.6121</b>	Central step jaw 82 mm
4	<b>9.3791.6211</b>	Reversible step jaw
5	<b>9.3791.6341</b>	Fixed step jaw
6	<b>9.3791.6511</b>	Floating central jaw
7	<b>9.3791.6311</b>	Fixed step jaw

The standard clamping jaws allow the accommodation of 1 to 4 workpieces with identical or different dimensions.



**Set of clamping claws 4 off** with 4 screws DIN 912  
Part no. **9.3777.3011** M12 x 45 for T-slot 14 mm  
Part no. **9.3777.3021** M16 x 50 for T-slot 18 mm

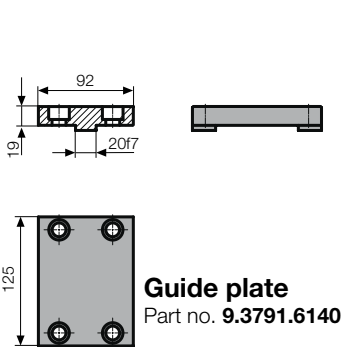


**Torque wrench** Part no. **9.3792.6610**

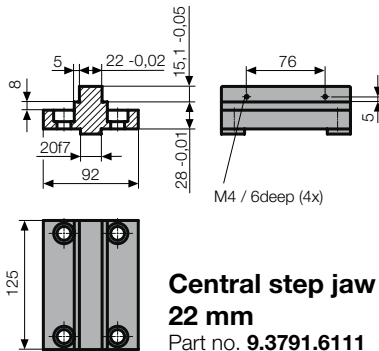
20–120 Nm with reversible ratchet and square 1/2" with ball lock  
SW 14 socket wrench **1.3124.0020** hydr.  
SW 17 socket wrench **1.3124.0017** mech.



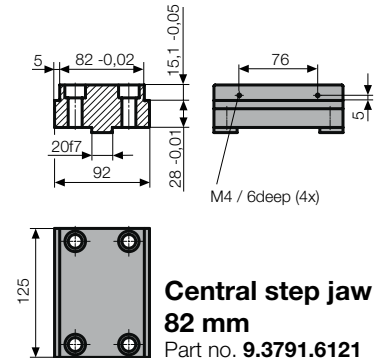
**DS 125 standard jaws, case-hardened and ground with 8 mm steps (free space for tools and swarf). Supplied including fixing screws.**



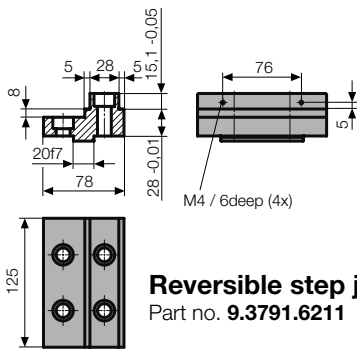
**Guide plate**  
Part no. **9.3791.6140**



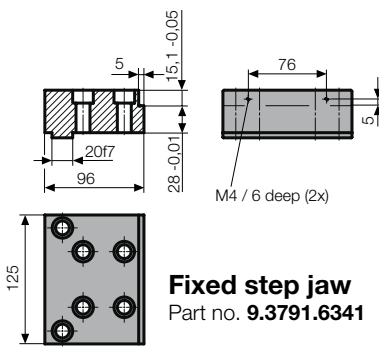
**Central step jaw 22 mm**  
Part no. **9.3791.6111**



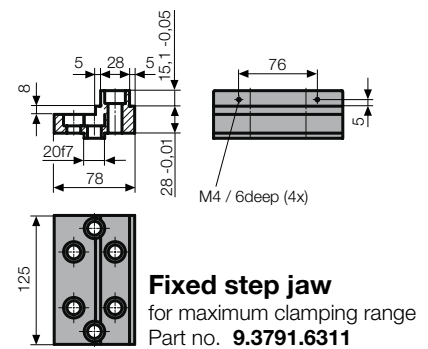
**Central step jaw 82 mm**  
Part no. **9.3791.6121**



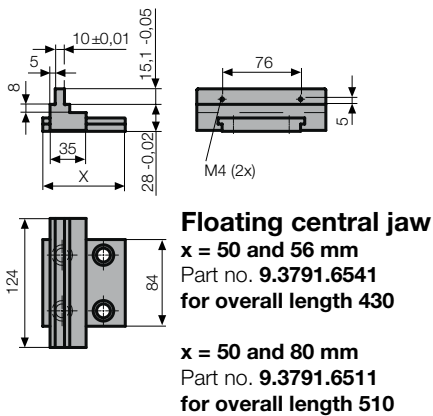
**Reversible step jaw**  
Part no. **9.3791.6211**



**Fixed step jaw**  
Part no. **9.3791.6341**

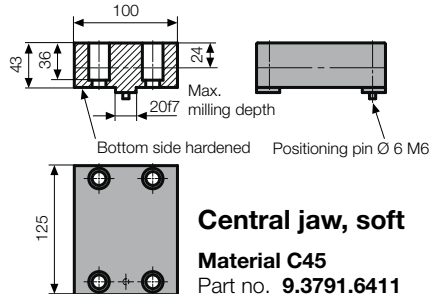


**Fixed step jaw for maximum clamping range**  
Part no. **9.3791.6311**

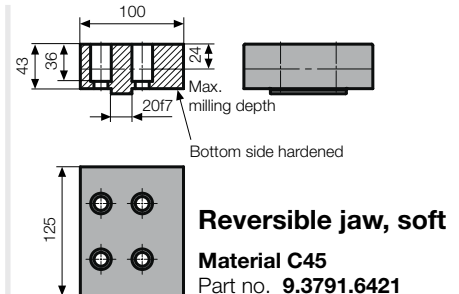


**Floating central jaw**  
**x = 50 and 56 mm**  
Part no. **9.3791.6541**  
for overall length 430  
**x = 50 and 80 mm**  
Part no. **9.3791.6511**  
for overall length 510

**Standard clamping jaws, soft, for milling of workpiece contours, steps, stops, etc. Supplied including fixing screws.**

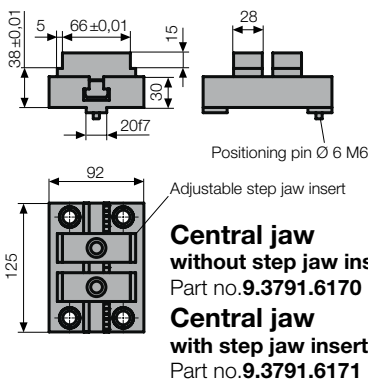


**Central jaw, soft**  
Material C45  
Part no. **9.3791.6411**

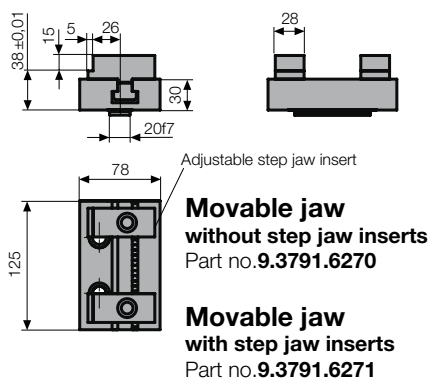


**Reversible jaw, soft**  
Material C45  
Part no. **9.3791.6421**

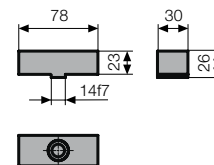
**SlimFlex jaw system, case-hardened and ground with 8 mm steps (free space for tools and swarf). Supplied including fixing screws. The continuously adjustable jaw inserts ensure optimum tool access without the risk of collision. Smallest clamping dimension 26 mm.**



**Central jaw without step jaw inserts**  
Part no. **9.3791.6170**  
**Central jaw with step jaw inserts**  
Part no. **9.3791.6171**



**Movable jaw without step jaw inserts**  
Part no. **9.3791.6270**  
**Movable jaw with step jaw inserts**  
Part no. **9.3791.6271**



**Jaw insert made of C45 steel soft, for SlimFlex jaw system for self-production of any step dimensions**  
Part no. **9.3285.8009**

Mounting holes for all jaws KM 12 all dimensions in mm



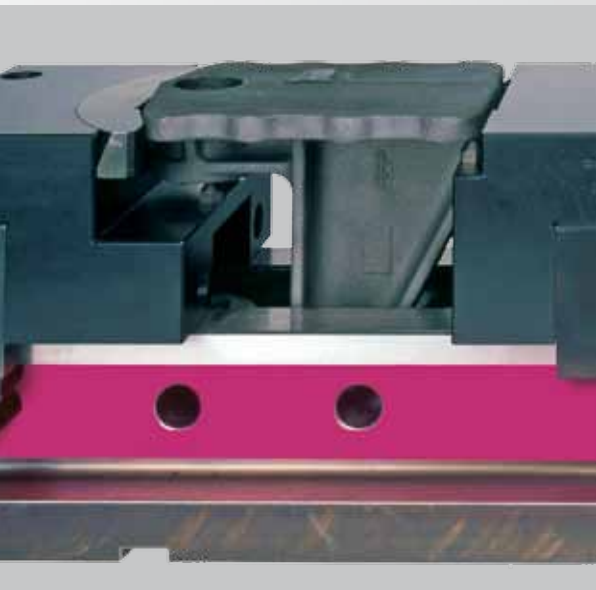


**ROEMHELD**  
HILMA ■ STARK

KNC back to back



NC with clamping force display



NC with special clamping jaws



MC for 5-sided machining

**Hilma-Römheld GmbH**

Schützenstraße 74 · 57271 Hilchenbach, Germany  
Phone: +49 27 33 / 281-0 · Fax: +49 27 33 / 281-169  
E-mail: info@hilma.de · www.roemheld-group.com