



## Hinge Clamps

with metallic wiper edge and optional position monitoring,  
double acting, max. operating pressure 250 bar



### Advantages

- Compact design
- Body partially recessible
- Oil supply alternatively via pipe threads or drilled channels
- Unimpeded loading and unloading of the fixture
- Clamping lever can be swivelled into small recesses
- Clamping possible without side loads
- Long clamping lever adaptable to the workpiece
- Lever mechanism easy to clean
- Standard metallic wiper edge
- Standard FKM seals
- Inductive or pneumatic control of the clamping position and the clamping range optional

### Application

The hinge clamp is a low-cost hydraulic clamping element with many installation and connecting possibilities.

If the clamping lever is completely retracted, unimpeded loading and unloading of the fixture can be effected. A clamping recess in the workpiece a little bit wider than the clamping lever is sufficient as clamping surface.

The special kinematics allow clamping nearly without side loads of workpieces which are very sensitive against deformation.

### Description

When pressurising the element, the piston moves upwards and swivels the clamping lever over the hinges forwards and at the same time downwards onto the workpiece.

The piston force is deviated by 180° and is available as clamping force with virtually no loss of efficiency.

If the level of the clamping surface is exactly on height *h* (see page 2), no side loads are introduced into the workpiece.

The bodies are recessible in the fixture up to the flange. Alternatively intermediate plates are available for height adjustment.

All versions are optionally available with extended piston rod and with inductive or pneumatic position monitoring.

### Important notes!

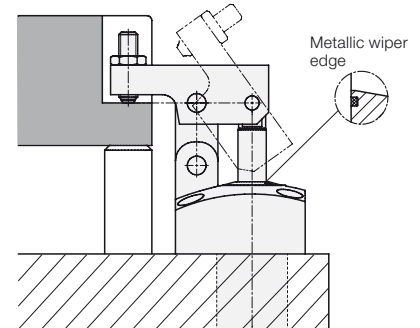
Hinge clamps must only be used for clamping of workpieces in industrial applications and may only be operated with hydraulic oil.

Hinge clamps can generate very high forces. The workpiece, the fixture or the machine must be in the position to compensate these forces. Considerable injuries can be caused to fingers during clamping and unclamping in the effective area of the clamping lever.

The manufacturer of the fixture or the machine is obliged to provide effective protective measures.

Hinge clamps have to be checked regularly on contamination by swarf and have to be cleaned.

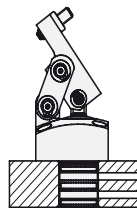
Operating conditions, tolerances and other data see data sheet A 0.100.



### Installation and connecting possibilities

#### Cartridge type

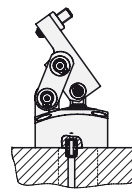
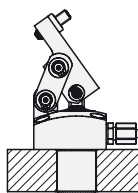
for horizontally-drilled channels



#### Pipe thread at the back / Plug-type connector

Fitting connection, at the back

for vertically-drilled channels

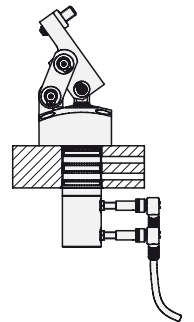
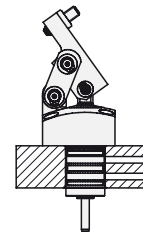


### Option

#### Extended piston rod

for all versions available without position monitoring

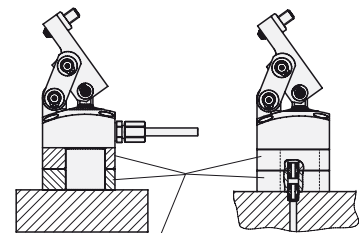
with position monitoring



### Accessories

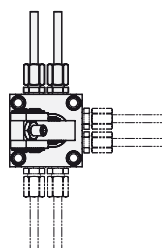
#### Intermediate plates

for all versions with pipe thread



Intermediate plates

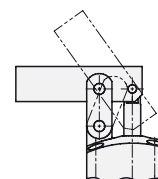
### Pipe thread at 3 sides



### Option

#### Long clamping lever

for all versions available.



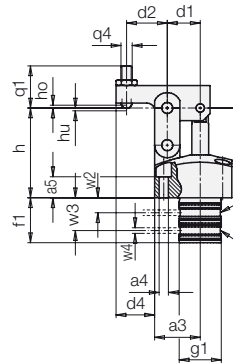
Alternatively all versions are also available without clamping lever.

## Dimensions Accessories

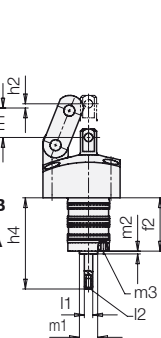
### Cartridge type

Clamping lever with swivel contact bolt

1825-X11

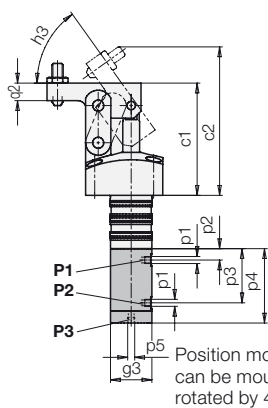


1825-X20



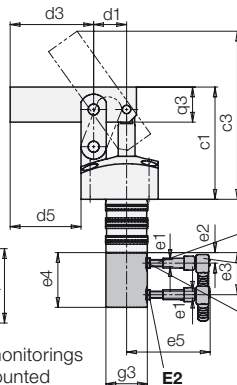
### Optionally with pneumatic position monitoring

1825-X21P

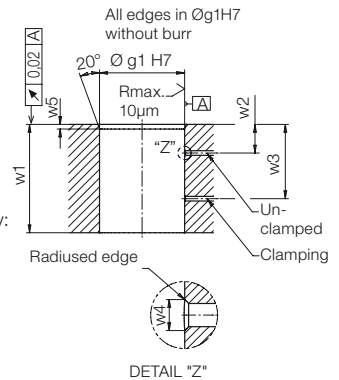


### Optionally with inductive position monitoring/ long clamping lever

1825-X22E

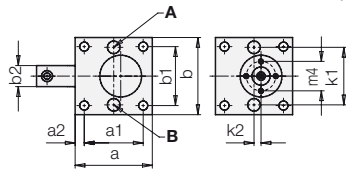


### Location hole for cartridge type



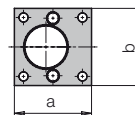
### Pipe thread at the back / plug-type connector

Clamping lever with swivel contact bolt without clamping lever extended piston rod

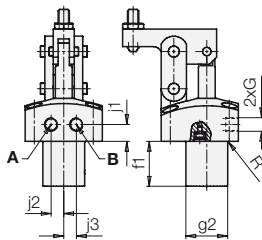


**A** = Clamping  
**B** = Unclamping  
**E1** = Clamping range, inductive  
**E2** = Unclamped, inductive  
**P1** = Clamping range, pneum.  
**P2** = Unclamped, pneum.  
**P3** = Outlet air, pneum. position monitoring

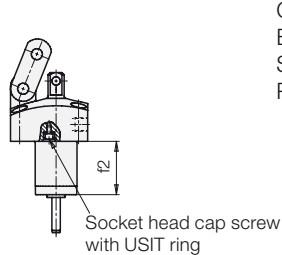
**Accessory:**  
Intermediate plates for versions with pipe threads



1825-X31



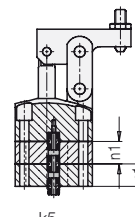
1825-X40



### Material

Clamping lever: C45 + C (1.0503)  
Body: steel  
Sealings: FKM  
Piston: high alloy steel

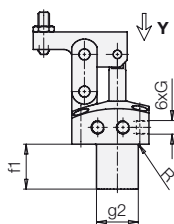
**Accessory:**  
Plug-type connector



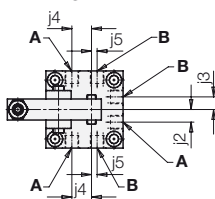
### Pipe thread at 3 sides

1825-X51

Clamping lever with swivel contact bolt



### View Y



## Technical data Dimensions

Size			1	2	3	4
Clamping force at a length of clamping lever	d2 and 250 bar	[kN]	3.8	9.7	14.4	21.5
Clamping force at a length of clamping lever with extended piston rod	d2 and 250 bar	[kN]	3.3	9.1	13.9	21
Oil volume clamping		[cm³]	4.8	16.9	31.1	61.6
Oil volume clamping with extended piston rod		[cm³]	4.1	16.0	30.0	60.2
Oil volume unclamping		[cm³]	2.1	10.0	19.0	37.5
Admissible flow rate		[cm³/s]	15.7	24.5	24.5	55
a		[mm]	55	70	85	100
a1		[mm]	42	56	69	81
a2		[mm]	6.5	7	8	9.5
a3		[mm]	32.5	46	52	60
a4		[mm]	4 x Ø 6.6	4 x Ø 9	4 x Ø 11	4 x Ø 13.5
a5		[mm]	15	18	21.5	30
b		[mm]	55	70	85	100
b1		[mm]	42	56	69	81
b2		[mm]	15	20	25	30
c1		[mm]	80	116	143	163
c2		[mm]	106	150	185	208
c3		[mm]	120	171	208	238.8
d1		[mm]	23.5	33	37	43.5
d2		[mm]	29	39.5	49	60.5
d3		[mm]	59.5	81.5	98	114
d4		[mm]	27.5	37.5	47.5	57.5
d5		[mm]	50.5	68.5	83	97.5
e1			M5 x 0.5	M5 x 0.5	M5 x 0.5	M5 x 0.5
e2		[mm]	7.5	9.7	11.6	14.5
e3		[mm]	30	41.9	46	58.3
e4		[mm]	39	49	55	68.5
e5		[mm]	approx. 60	approx. 60	approx. 60	approx. 60
f1		[mm]	32	43	44.5	52.5
f2		[mm]	38	49	50.5	58.5
G			G 1/8	G 1/8	G 1/4	G 1/4
Max. size of connecting fitting			6 L	8 S	10 L	10 L
g1		[mm]	Ø 30 f7	Ø 42 f7	Ø 52 f7	Ø 65 f7
g2		[mm]	Ø 29.8	Ø 41.8	Ø 51.8	Ø 64.8
g3		[mm]	Ø 29.5	Ø 39	Ø 39	Ø 39
h ideal clamping point		[mm]	64	92.5	113	128
ho upper end of the clamping range		[mm]	2	2.7	3.5	4.5
hu lower end of the clamping range		[mm]	2	2.7	3.5	4.5
h1 piston stroke up to ideal clamping point		[mm]	21	30	33.5	41.5
h2 piston stroke up to the end of the clamping stroke		[mm]	3	4.5	5.2	7.5
h3		[°]	54.5	55.5	56	58.2
h4		[mm]	65	86.5	93	111
j1		[mm]	12	16	17	20
j2		[mm]	9	13.5	15.5	22
j3		[mm]	9	13.5	15.5	22
j4		[mm]	14	20	25	32
j5		[mm]	4	2	6	12
k1		[mm]	41 ± 0.02	55 ± 0.02	68 ± 0.02	80 ± 0.02
k2		[mm]	5 ± 0.05	0 ± 0.05	0 ± 0.05	0 ± 0.05
k3		[mm]	6.5	6.5	6.5	8
k4		[mm]	1.5	1.5	1.5	1.5
k5		[mm]	Ø 8 H7	Ø 8 H7	Ø 8 H7	Ø 10 H7
k6		[mm]	5.5	5.5	5.5	7
l1		[mm]	Ø 6 f7	Ø 6 f7	Ø 6 f7	Ø 6 f7
l2			M4 x 7.5 deep	M4 x 7.5 deep	M4 x 7.5 deep	M4 x 7.5 deep
m1		[mm]	Ø 13 f7	Ø 13 f7	Ø 13 f7	Ø 13 f7
m2		[mm]	2	2	2	2
m3			M4 x 6 deep	M4 x 6 deep	M4 x 6 deep	M4 x 6 deep
m4		[mm]	21	27	27	27
n1		[mm]	16	21.5	22.5	26.5
p1			M5	M5	M5	M5
p2		[mm]	8.5	10.6	12.3	15.2
p3		[mm]	38.6	50.9	55.1	66.5
p4		[mm]	53	73	77	84
p5			M5	G 1/4	G 1/4	G 1/4
q1		[mm]	30	40	50	50
q2		[mm]	12.5	20	25	28
q3		[mm]	25	40	50	55
q4			M8	M12	M16	M16
R		[mm]	0.8	0.8	1	0.8
w1		[mm]	min. 31.5	min. 41.5	min. 43.5	51.5
w2		[mm]	10.6	14.3	14.8	18
w3		[mm]	23.4	30.7	31.9	37.5
w4		[mm]	max. Ø 4	max. Ø 5.5	max. Ø 5.5	max. Ø 5.5
w5		[mm]	2.5 – 0.5	2.5 – 0.5	2.5 – 0.5	2.5 – 0.5
x1		[mm]	7	7	8	8
Weight approx.	1825-XX0	[kg]	1.0	2.3	3.8	6.1
	1825-XX1	[kg]	1.1	2.7	4.6	7.3
	1825-XX2	[kg]	1.2	3.0	5.1	8.1

# Calculations • Clamping force diagrams Code for part numbers • Accessories

## Calculations

1. Length L of clamping lever is known

1.1 Admissible operating pressure

$$p_{adm} = \frac{B}{\frac{C}{L} + 1} \leq 250 \text{ bar} \quad [\text{bar}]$$

1.2 Effective clamping force

$$p_{adm} > 250 \text{ bar} \rightarrow F_{sp} = \frac{A}{L} \cdot 250 \text{ [kN]}$$

$$p_{adm} < 250 \text{ bar} \rightarrow F_{sp} = \frac{A}{L} \cdot p_{adm} \text{ [kN]}$$

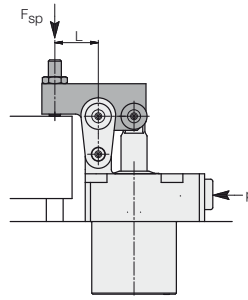
2. Min. length of clamping lever

$$L_{min.} = \frac{C}{\frac{B}{p} - 1} \text{ [mm]}$$

L, L<sub>min.</sub> = Length of clamping lever [mm]

p, p<sub>adm.</sub> = Operating pressure [bar]

A, B, C, = Constants as per chart



## Constant

	1825-1	1825-2	1825-3	1825-4
A	0.449	1.54	2.827	5.193
A*	0.386	1.45	2.728	5.076
B	442.45	448.42	429.34	429.75
B*	514.86	475.83	444.98	420.08
C	22.325	31.35	35.15	43.5

A\*, B\* for version with switch rod

**Example 1:** Hinge clamp 1825-111

Operating pressure 200 bar

Standard clamping lever L = 29 mm

Effective clamping force

$$F_{sp} = \frac{A}{L} \cdot p = \frac{0.449}{29} \cdot 200 = 3.1 \text{ kN}$$

**Example 2:** Hinge clamp 1825-110

Operating pressure 200 bar

Min. length of clamping lever

$$L_{min} = \frac{C}{\frac{B}{p} - 1} = \frac{22.325}{\frac{442.45}{200} - 1} = 18.4 \text{ mm}$$

Effective clamping force

$$F_{sp} = \frac{A}{L} \cdot p = \frac{0.449}{18.4} \cdot 200 = 4.9 \text{ kN}$$

**Example 3:** Hinge clamp 1825-210

Special clamping lever L = 30 mm

Admissible operating pressure

$$p_{adm} = \frac{B}{\frac{C}{L} + 1} = \frac{448.42}{\frac{31.35}{30} + 1} = 219 \text{ bar}$$

Effective clamping force

$$F_{sp} = \frac{A}{L} \cdot p_{adm} = \frac{1.54}{30} \cdot 219 = 11.25 \text{ kN}$$

**Example 4:** Hinge clamp 1825-310

Special clamping lever L = 118 mm

Admissible operating pressure

$$p_{adm} = \frac{B}{\frac{C}{L} + 1} = \frac{429.34}{\frac{35.15}{118} + 1} = 330.8 > 250 \text{ bar}$$

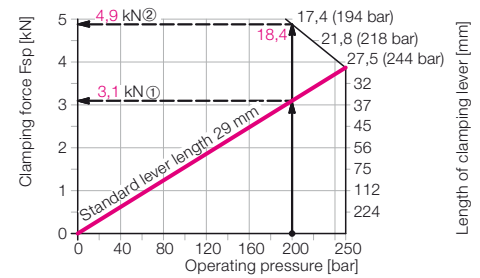
Effective clamping force

The max. operating pressure is 250 bar, thus

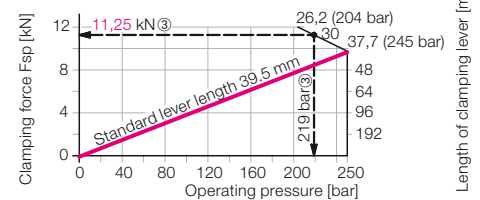
$$F_{sp} = \frac{A}{L} \cdot 250 = \frac{2.827}{118} \cdot 250 = 6 \text{ kN}$$

## Clamping force diagrams

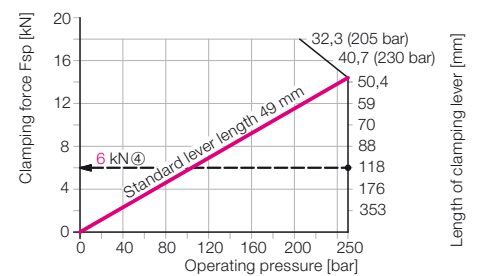
### Size 1



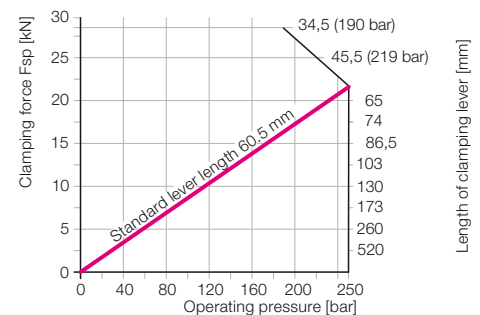
### Size 2



### Size 3



### Size 4



## Code for part numbers

- 1 = Size 1
- 2 = Size 2
- 3 = Size 3
- 4 = Size 4

- 1 = cartridge-type
- 2 = cartridge-type with extended piston rod \*)
- 3 = pipe thread at the back / plug-type connector
- 4 = pipe thread at the back / plug-type connector with extended piston rod \*)
- 5 = pipe threads at three sides
- 6 = pipe threads at three sides with extended piston rod \*)

\*) A prerequisite for mounted position monitoring (addition: E or P)

Basic type

1825 -

X X X X

E = mounted position monitoring, inductive (without proximity switch)

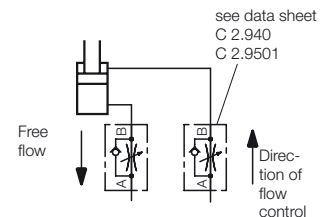
P = mounted position monitoring, pneumatic

0 = without clamping lever

1 = clamping levers with swivel contact bolt

2 = long clamping lever, unmachined

Material: C45 + C (1.0503)



## Important note

Longer special clamping levers have a higher weight. Therefore the flow rate has to be considerably reduced to avoid damage of the mechanics in the stroke end positions.

A flow rate throttling always has to be effected in the supply line to the hinge clamp.

## Technical data for inductive proximity switches 3829-198

Operating voltage UB	10 ... 30 V DC
Switching function	Interlock
Output	PNP
Body material	Steel, corrosion resistant
Protection as per DIN 40050	IP 67
Environmental temperature	-25 ... +70 °C
Connection type	Plug
LED Function display	Yes
Constant current max.	150 mA
Rated operating distance	0.8 mm
Protected against short circuits	yes

Accessories	Size	1	2	3	4
Intermediate plate (not for cartridge-type version)		3456-449	3456-468	3456-489	3456-534
Plug-type connector		9210-145	9210-145	9210-145	9210-132
Plug, flush screwable with hexagon socket		0361-986	0361-986	0361-987	0361-987
Screw plug with hexagon head		3610-047	3610-047	3300-821	3300-821
Pneumatic position monitoring, complete **)		0353-845	0353-853	0353-855	0353-962
Weight [kg]		0.18	0.42	0.46	0.74
Inductive position monitoring, without ind. proximity switch **)		0353-846	0353-854	0353-856	0353-963
Weight [kg]		0.26	0.62	0.65	0.58
Inductive proximity switch		3829-198	3829-198	3829-198	3829-198
Plug and cable for inductive proximity switch		3829-099	3829-099	3829-099	3829-099

\*\*) Only mountable at 1825-X2X, -X4X, -X6X.