



Selection of Clamping Cylinders

1. Type of cylinder

- **Single acting, spring return cylinders**

These cylinders are used with hydropneumatic intensifier. They are not recommended with hydraulic power unit.

- **Double acting cylinders**

These cylinders are normally used with hydraulic power unit. These can be used with hydropneumatic intensifier by using air-oil pressure converter for return stroke.

2. Clamping force of cylinder

Stud-bolt size used in the existing fixture with manual clamping is the best clue for selecting the clamping force.

STUD SIZE	M 6	M 8	M 12	M 16	M 20	M 24
CLAMPING FORCE	2.5 kN	5 kN	10 kN	20 kN	30 kN	40 kN