

Hydraulic Lever Clamp

Longer Stroke / Block-Fixed

Model GBQ

New Model



Longer stroke allows for variation in die clamping thicknesses.

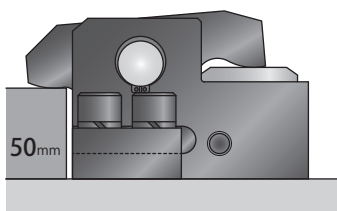
Fixed with bolts and easy to install on a press without T-slots.

Advantages

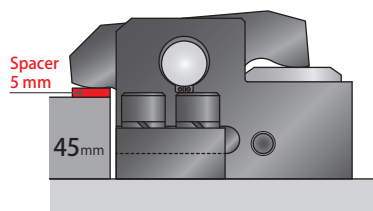
Standard Clamp

Requires a spacer at the die clamping site in order to standardize the thickness.

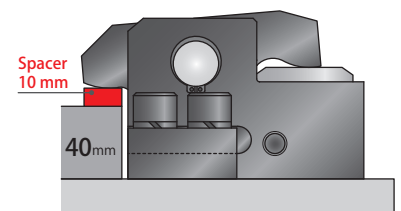
Clamping Thickness : 50mm



Clamping Thickness : 45mm



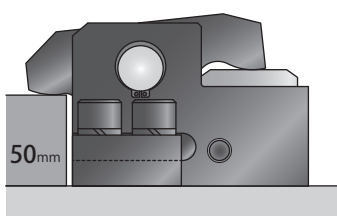
Clamping Thickness : 40mm



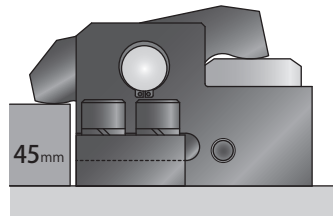
GBQ Clamp

Is able to clamp dies with a thickness variance up to 10 mm. There is no need to install spacers and no accidents caused by incorrect spacer thickness.

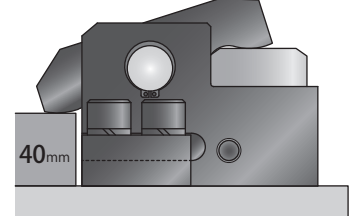
Clamping Thickness : 50mm



Clamping Thickness : 45mm



Clamping Thickness : 40mm



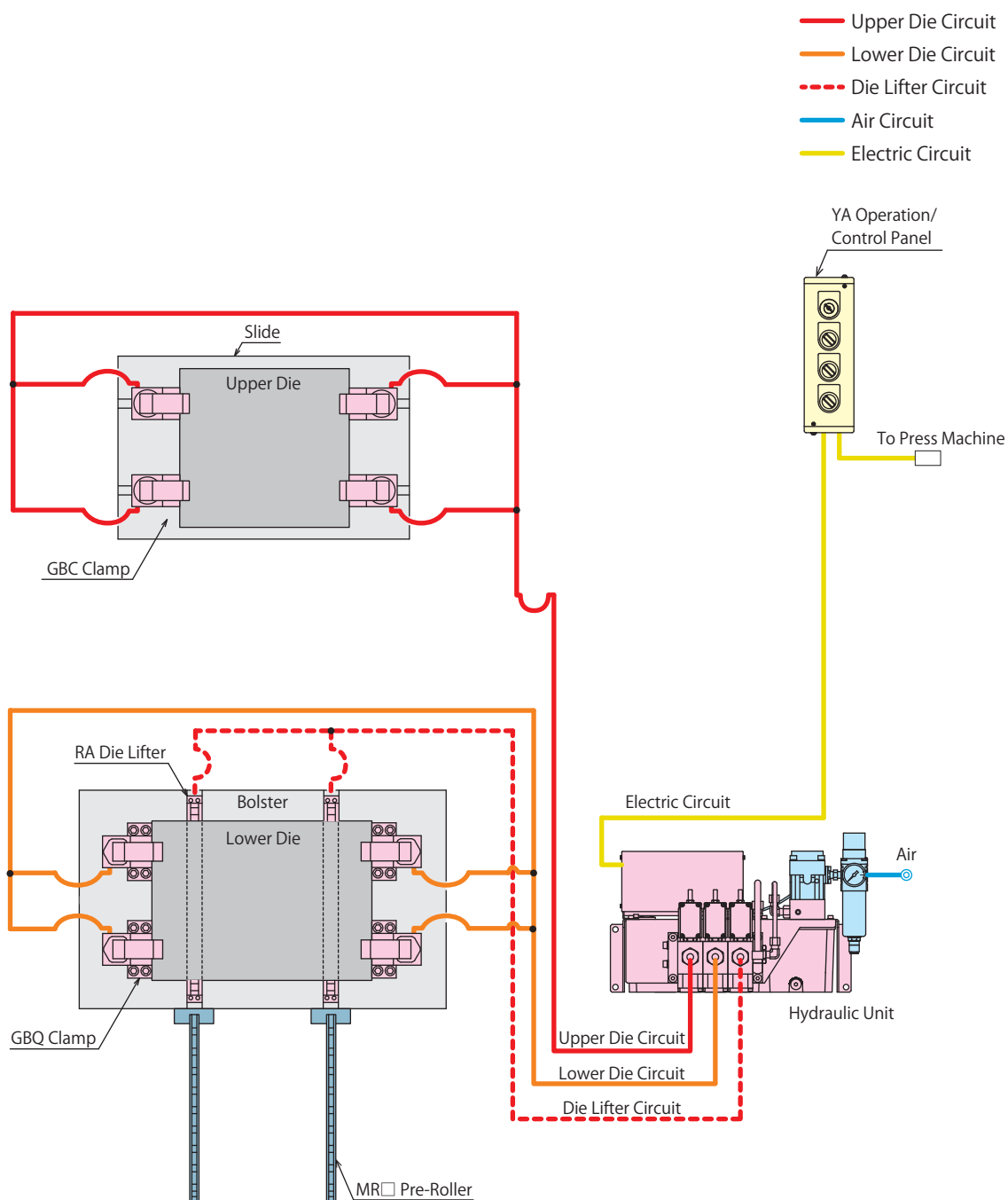
- Notes:
1. We provide GBQ clamp according to the die clamping thickness and T-slot dimension. Please refer to the external dimensions for detail.
 2. Die clamping thickness varies depending on the clamp size.

System Structure Example

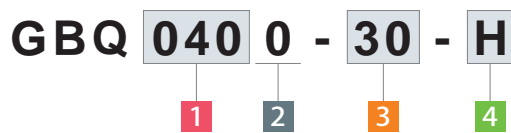
The basic structure with GBQ clamps that do not require T-slot by fixing with bolts. This system is able to control the upper die circuit, lower die circuit, and RA die lifter circuit individually by using a three-circuit hydraulic unit.

Upper Clamp	: GBC Clamp
Lower Clamp	: GBQ Clamp
Loading / Unloading the Die	: MR□ Pre-Roller + RA Die Lifter
Hydraulic Source	: CP□ Unit / CQ□ Unit

We are able to provide different models of clamp for the upper die and lower die.
Please contact us for further information.



● Model No. Indication



1 Clamping Force

- | | |
|-----------------------------------|------------------------------------|
| 010 : Clamping Force= 10kN | 100 : Clamping Force= 100kN |
| 016 : Clamping Force= 16kN | 160 : Clamping Force= 160kN |
| 025 : Clamping Force= 25kN | 250 : Clamping Force= 250kN |
| 040 : Clamping Force= 40kN | |
| 063 : Clamping Force= 63kN | |

2 Design No.

- 0** : Revision Number

3 Die Clamping Thickness

- 30** : Die Clamping Thickness h=30mm
50 : Die Clamping Thickness h=50mm

Note:

※ The maximum difference of the die clamping thickness.
 When the difference is 30mm~40mm, it is "h=40".

4 Option ※ Please contact us for specifications / external dimensions.

- Blank** : Standard
- G** : Gasket Mounting
- H** : Extra Height Body (When h dimension is more than max. h dimension shown in the external dimension.)
- J** : Low Lever (When h dimension is less than min. h dimension shown in the external dimension.)
- K** : Rear Port
- L□** : Wide Lever (For U-Cut of Die) ※¹
- N** : NPT Port ※²
- U** : With Grease Nipple
- V** : High Temperature (0~120°C)
- X** : With Cover

Notes:

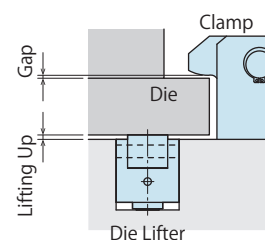
- ※1. Please indicate the U-cut dimension of the die.
- ※2. Dimensions in the specification sheet and other documents are in inches.
 Only die clamping thickness is indicated by the symbol which is converted into millimeters.
- 1. Please contact us for specifications and external dimensions for these options.
- 2. Allowable range of die clamping thickness differs depending on the clamping force.

● Specifications

Model No.		GBQ0100	GBQ0160	GBQ0250	GBQ0400	GBQ0630	GBQ1000	GBQ1600	GBQ2500
Clamping Force	kN	10	16	25	40	63	100	160	250
Working Pressure	MPa	25 (For Rated Clamp Force)							
Withstanding Pressure	MPa	37							
Full Stroke	mm	8	9	10	12	15	15.5	16	16
Clamp Stroke ^{※3}	mm	0.5	1	1.5	3.5	1	1.5	2	2
Extra Stroke	mm	7.5	8	8.5	8.5	14	14	14	14
Cylinder Capacity (At Full Stroke)	cm ³	4	6	10	19	38	63	105	160
Operating Temperature ^{※4}	°C	0~70 (High temperature option is available for 0~120°C)							
Use Frequency ^{※5}		Less than 20 Cycles / Day [※]							
Pressurizing Agent ^{※6 ※7 ※8}		General Hydraulic Oil Equivalent to ISO-VG-32							

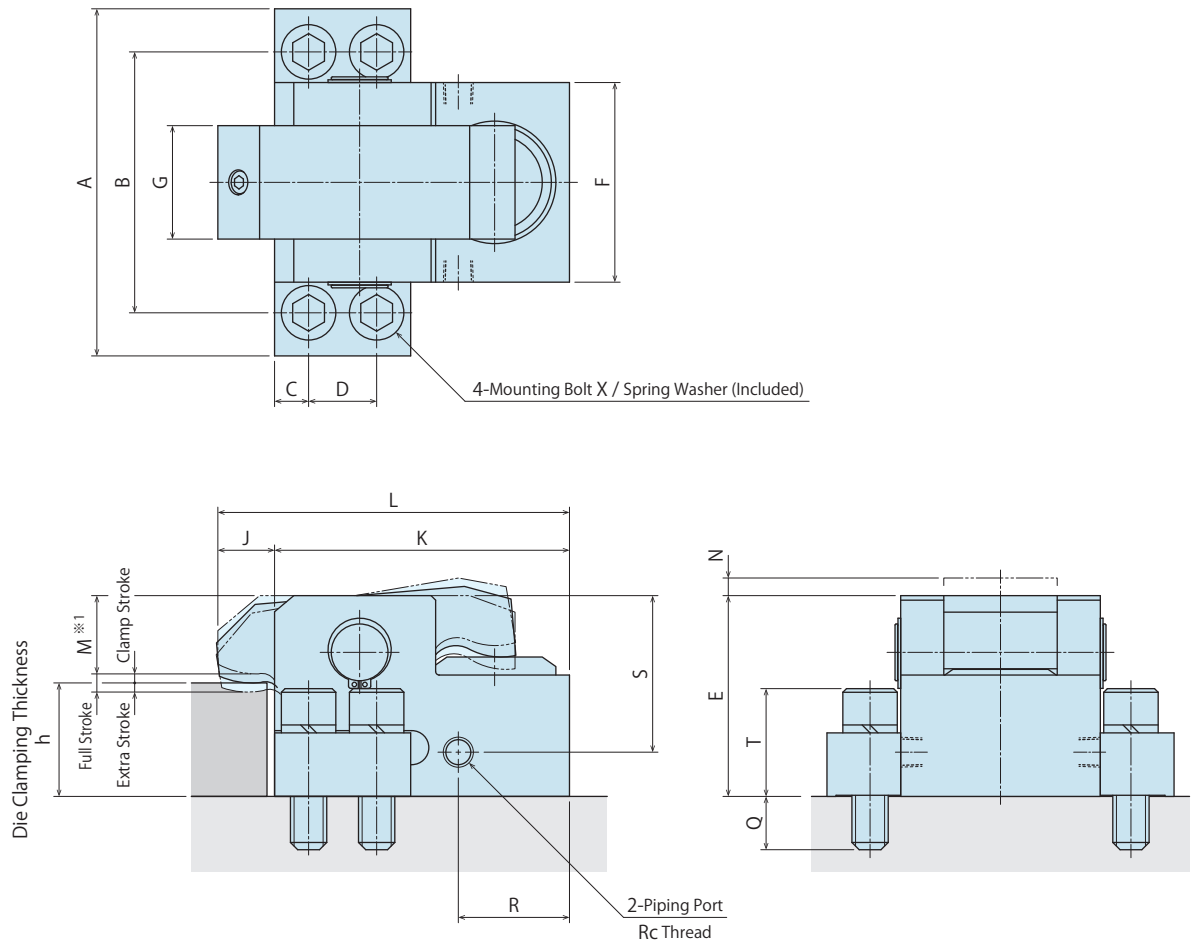
Notes:

- ※3. For using GBQ Clamp with Die Lifter, make sure there is a gap between the die and clamp when Die Lifter lifts up.
- ※4. Option V: High Temperature (0~120°C) is for operating in temperatures of 70°C or more.
- ※5. Please contact us for more frequent use.
- ※6. Please contact us for fluids other than those mentioned on the list.
- ※7. If hydraulic viscosity is higher than specified, action time will be longer.
- ※8. If using it at low temperature, action time will be longer because the viscosity of hydraulic oil becomes higher.



External Dimensions

※ This drawing shows GBQ0100 ~ GBQ2500 standard model.
 Contact us for external dimensions for options.



Notes:

1. Do not exceed the clamping force on the specification.
2. Specifications/Contents in this catalog are subject to change without prior notice. Ask for the approval drawing before deciding to purchase.

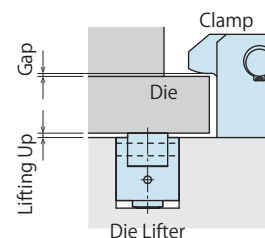
External Dimensions

(mm)

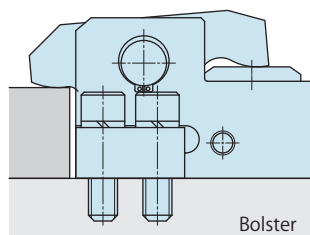
Model No.	GBQ0100	GBQ0160	GBQ0250	GBQ0400	GBQ0630	GBQ1000	GBQ1600	GBQ2500
Full Stroke	8	9	10	12	15	15.5	16	16
Clamp Stroke ^{※2}	0.5	1	1.5	3.5	1	1.5	2	2
Extra Stroke	7.5	8	8.5	8.5	14	14	14	14
A	72	90	106	123	153	180	219	270
B	53	66	78	92	115	129	155	199
C	8.5	10	12	13	15	18	22	30
D	15	18	20	26	30	36	46	50
min. E	50.5	57	67	76	93.5	119	137.5	159.5
F	38	48	58	68	88	97	117	144
G	20	26	32	38	50	53	60	73
J	15	17	19	22	25	30	30	30
K	58	70	84	105.5	130	159	199	240
L	73	87	103	127.5	155	189	229	270
max. N	8	9	9.5	11	14.5	15	18	19
Q	12	14.5	20.5	23	23.5	29.5	33	43
R	7	9	10	12	49	68	73	69.5
S	41.5	48	55	59	76.5	102	118.5	137.5
T	26	30.5	36.5	41	47.5	60.5	71	87
X (Designated Maker)	M8 x 1.25 x 30	M10 x 1.5 x 35	M12 x 1.75 x 45	M14 x 2 x 50 (Unbrako)	M16 x 2 x 55 (Unbrako)	M20 x 2.5 x 70 (Unbrako)	M24 x 3 x 80 (Unbrako)	M30 x 3.5 x 100 (Unbrako)
Rc	Rc1/8	Rc1/8	Rc1/4	Rc1/4	Rc1/4	Rc1/4	Rc1/4	Rc1/4
min. h	25	25	30	30	35	45	45	50
max. h	40	40	50	50	60	70	80	90

Notes:

- ※1. M dimension (Lever Thickness) in the drawing varies depending on variation in h dimension (Die Clamping Thickness). Please contact us for further information.
- ※2. For using GBQ Clamp with Die Lifter, make sure there is a gap between the die and clamp when Die Lifter lifts up.
 1. If you would like to change the ratio of clamp stroke and extra stroke, please contact us.
 2. Clamp mounting surface should be smooth without any bumps.
If the clamp mounting surface has bumps or is not smooth, excessive stress will be applied on the clamp lever leading to release error or deformation of the lever and lever pin.



GBQ Clamp The Allowable Protrusion Amount



The guide block should be within the platen.

Note:

1. The guide block of GBQ clamp should be within the platen when mounting.

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