HYDROK

Convincing in performance

HAINBUCH SYSTEM

Hydraulic stationary chuck HYDROK

5-axis machining or efficient multiple clamping – with the HYDROK we offer a hydraulically actuated stationary chuck that provides even more implementation possibilities. Depending on the size, you can use it with all clamping device adaptations, such as the MANDO Adapt mandrel-in-clamping device or the jaw module. In the future you can also rely completely on the intelligent HAINBUCH SYSTEM, also for your stationary clamping device.

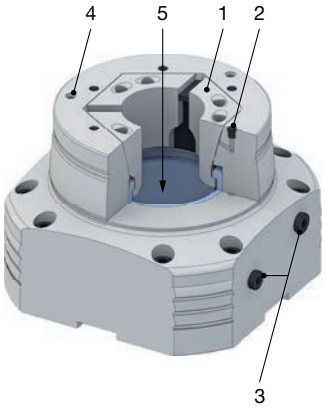
Our smallest modules: HYDROK 40 SE and 32 RD. Their modular base plates can be easily fitted together and enable multiple clamping setups with incredible holding forces in the most confined spaces. And with an additional tandem cylinder you can even generate the full clamping force with a weaker hydraulic unit.

Key advantages

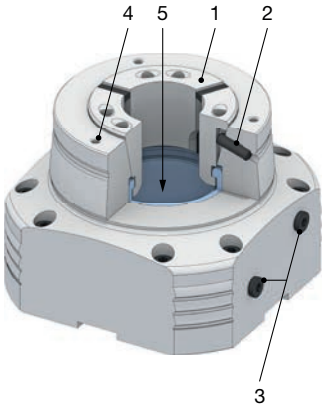
- Ideal for automated clamping
- Angular contour requires less space
- Multiple clamping made possible in the smallest space
- Ideal for 5-sided machining
- Clamping is possible with workpiece end-stop or front end-stop
- Adaptation devices possible [HAINBUCH SYSTEM]

HYDROK hydraulic stationary chuck in use

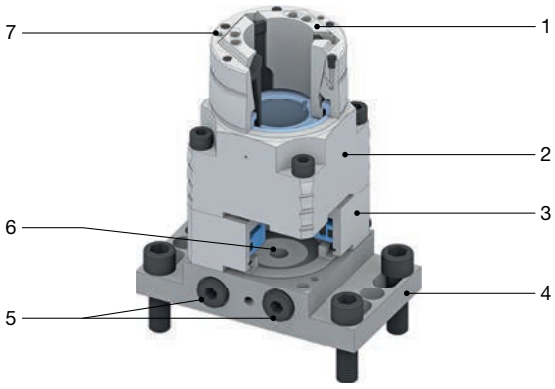
HYDROK SE in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 Central grease nipple, optimum tool life and holding power due to perfect lubrication 3 Side and/or bottom hydraulic connections available 4 Reception for front end-stop 5 Full passage available	

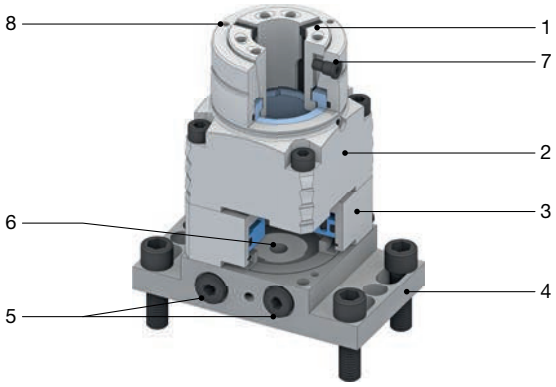
HYDROK RD in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Side and/or bottom hydraulic connections available 4 Reception for front end-stop 5 Full passage available	

HYDROK SE size 40 in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 HYDROK SE 40 3 Tandem cylinder, insert at low actuation pressure [optional] 4 Modular base plate, several adaptation possibilities for multiple clamping [optional] 5 Hydraulic connections 6 Location for depth end-stop 7 Reception for front end-stop	

HYDROK RD size 32 in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 HYDROK RD 32 3 Tandem cylinder, insert at low actuation pressure [optional] 4 Modular base plate, several adaptation possibilities for multiple clamping [optional] 5 Hydraulic connections 6 Location for depth end-stop 7 Torsional safety lock of the clamping head 8 Reception for front end-stop	

Order overview.
Hydraulic stationary chuck HYDROK SE

Product line	Size	Material no.	In stock	Clamping elements and adaptations: Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	40	10001416	✔	✔				
	52	10001415	✔	✔	✔	✔		✔
	65	10001407	✔	✔	✔	✔	✔	✔
	100	10001412	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

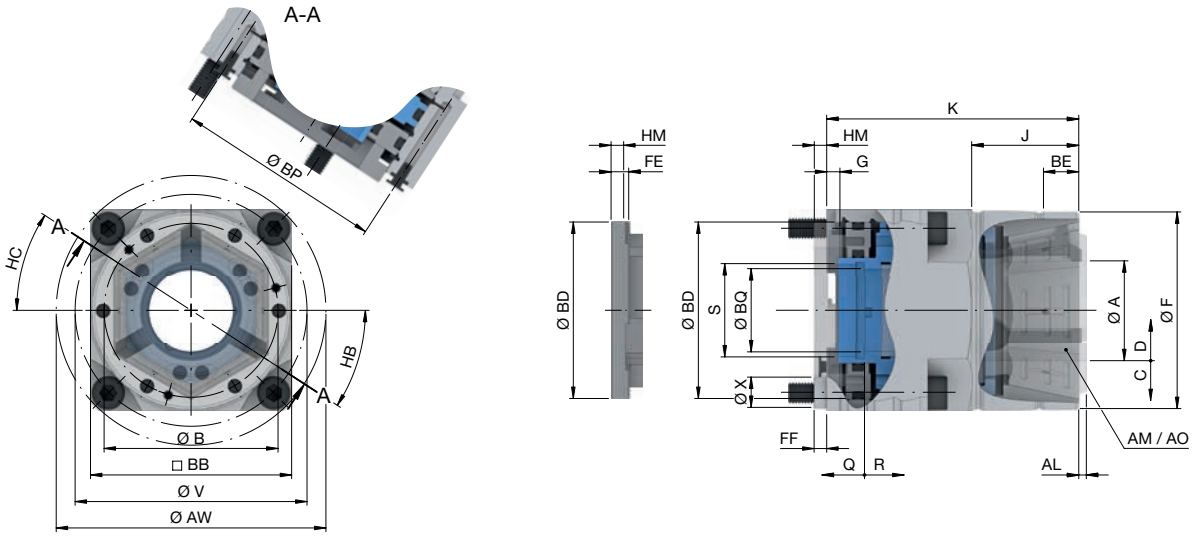
Order overview.
Hydraulic stationary chuck HYDROK RD

Product line	Size	Material no.	In stock	Clamping elements and adaptations: Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	32	10001414	✔	✔				
	42	10001408	✔	✔	✔	✔		
	52	10001409	✔	✔	✔	✔		✔
	65	10001406	✔	✔	✔	✔	✔	✔
	80	10001410	✔	✔	✔	✔	✔	✔
	100	10001411	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Scope of delivery
- Stationary chuck

HYDROK SE size 40. Technical data



Product line		SE
Size		**40**
Clamping range [mm]	A	3 – 40
Repeatability ≤ [mm]		0,010
Max. axial drawtube force [pull / push] [kN]		27
Max. radial clamping force [kN]		75
Max. actuating pressure [bar]		110
Release stroke in Ø [mm]	C	0,5
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	0,8
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2
Location front end-stop	F	Ø 78 f7
Length flange location [mm]	BE	14
Bolt hole circle end-stop	B	LK Ø 69 [3 x M4]
Ø Capacity [mm]	BQ	33
Height [mm]	J	42,5
Overall height [mm]	K	100
Outer variant [mm]	BB	79,8
Connecting position [mm]	BP	82
Outer Ø [mm]	AW	106 h7
Bolt hole circle	V	LK Ø 92 [4 x M8]
Clamping via base plate [°]	HB	33
Release via base plate [°]	HC	33
Clamping head serrated	AM	TOP 40
Clamping head protrusion length serrated [mm]	AL	3
Clamping head smooth	AO	TOP 40 G
Centering height 1 [mm]	FE	7
Centering height 2 [mm]	FF	5
Interface	X	Ø 12 H7
Flange location	BD	Ø 70 H7/g7
Connecting thread inside	S	M38 x 1
Centering length [mm]	G	5
Installation depth [mm]	HM	5 +0,05
Weight [kg]		2,79
In stock		✔
Material no.		10001416

Through adaptation of the tandem cylinder to HYDROK 40 SE, the maximum clamping force of 75 kN can be achieved, even at 43 bar.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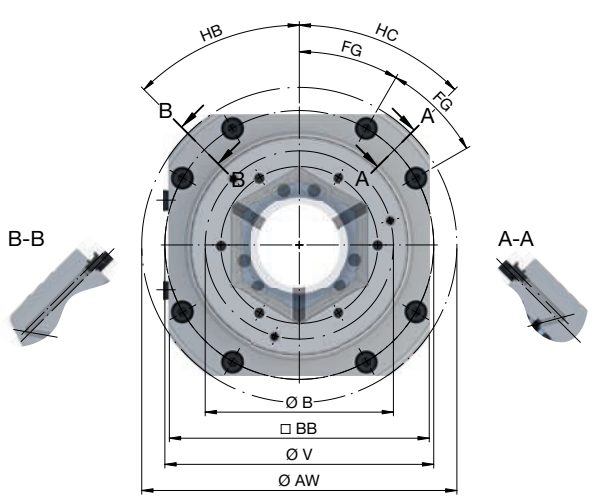
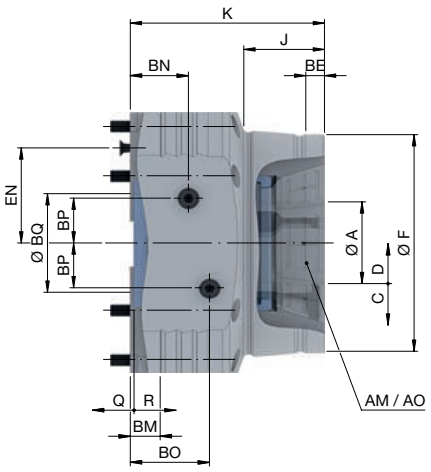
HYDROK SE size 52 - 100. Technical data





Product line		SE		
Size		**52**	**65**	**100**
Clamping range [mm]	A	3 – 52	3 – 65	15 – 100
Repeatability ≤ [mm]		0,010		
Max. axial drawtube force [pull / push] [kN]		35	45	65
Max. radial clamping force [kN]		91	120	172
Max. actuating pressure [bar]		40		
Release stroke in Ø [mm]	C	0,6		2
RPM n max. [1/min.]		1000		
Reserve stroke in Ø [mm]	D	1		1,5
Reserve stroke axial [mm]	Q	2	2,15	3
Release stroke axial [mm]	R	2,5		5
Location front end-stop	F	Ø 125 f7	Ø 145 f5	Ø 215 f7
Length flange location [mm]	BE	9,5	12,5	15,5
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8]
Ø Capacity [mm]	BQ	53	66	108
Height [mm]	J	39,6	54	55
Overall height [mm]	K	120	130	140
Outer variant [mm]	BB	154	174	230
Release	BN	38,1 [1/8"]	38,9 [1/8"]	
Clamping	BO	57,2 [1/8"]	53 [1/8"]	63 [1/8"]
Connecting position [mm]	BP	25	30	
Fluid connection 1 [mm]	EN	55,5	63,6	84,9
Outer Ø [mm]	AW	175 f6	210 f6	270 f6
Bolt hole circle	V	LK Ø 157 [8 x M8]	LK Ø 180 [8 x M8]	LK Ø 240 [8 x M8]
Mounting seat fit length [mm]	BM	20		
Angle position [°]	FG	30		
Clamping via base plate [°]	HB	45		
Release via base plate [°]	HC	45		
Clamping head serrated	AM	TOP 52	TOP 65	TOP 100
Clamping head smooth	AO	TOP 52 G	TOP 65 G	TOP 100 G
Weight [kg]		12	14,5	26
In stock		✔	✔	✔
Material no.		10001415	10001407	10001412

Please note: At adaptation size 52 the adaptation for jaw clamping cannot be used.
Size 100 is also available in lightweight design [14 kg].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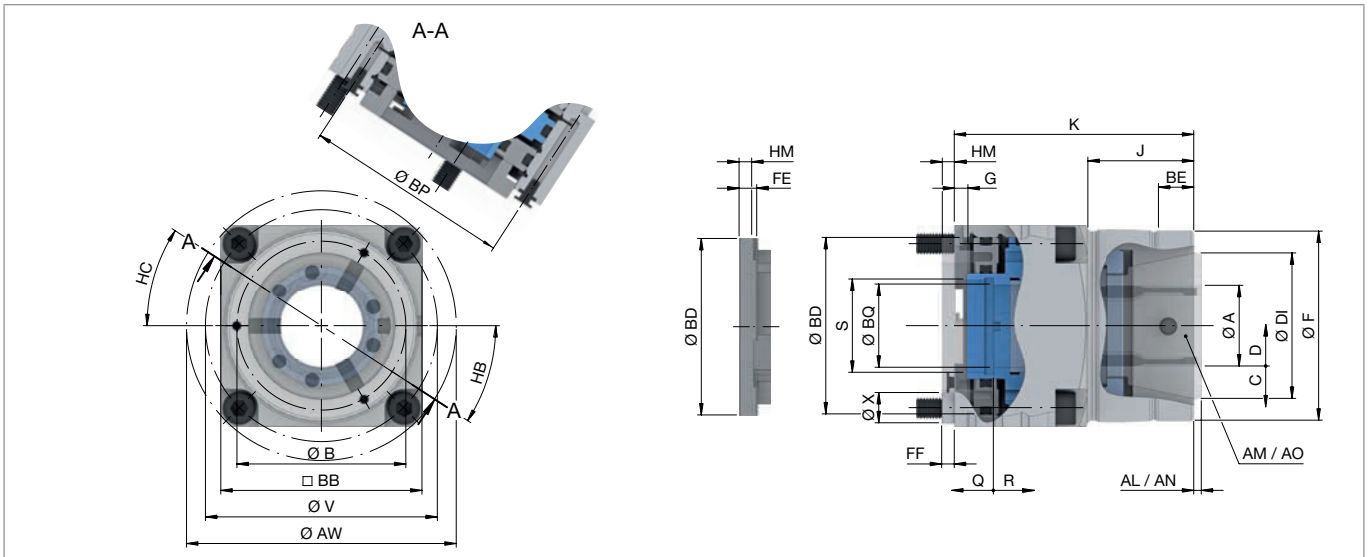
HYDROK RD size 32. Technical data



Product line		RD
Size		**32**
Clamping range [mm]	A	3 – 32
Repeatability ≤ [mm]		0,010
Max. axial drawtube force [pull / push] [kN]		25
Max. radial clamping force [kN]		70
Max. actuating pressure [bar]		100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2,5
Release stroke axial [mm]	R	3
Location front end-stop	F	Ø 75 f7
Length flange location [mm]	BE	15
Bolt hole circle end-stop	B	LK Ø 67 [3 x M4]
Ø Capacity [mm]	BQ	33
Height [mm]	J	42
Overall height [mm]	K	95
Outer variant [mm]	BB	79,8
Connecting position [mm]	BP	82
Outer Ø [mm]	AW	106 h7
Bolt hole circle	V	LK Ø 92 [4 x M8]
Clamping via base plate [°]	HB	33
Release via base plate [°]	HC	33
Head Ø [mm]	DI	58
Clamping head serrated	AM	SK 32 BZI
Clamping head protrusion length serrated [mm]	AL	6
Clamping head smooth	AO	SK 32 BZIG
Clamping head protrusion length smooth [mm]	AN	3
Centering height 1 [mm]	FE	7
Centering height 2 [mm]	FF	5
Interface	X	Ø 12 H7
Flange location	BD	Ø 70 H7/g7
Connecting thread inside	S	M38 x 1
Centering length [mm]	G	5
Installation depth [mm]	HM	5 +0,05
Weight [kg]		2,69
In stock		✔
Material no.		10001414

By adapting the tandem cylinder on the HYDROK 32 the maximum clamping force of 70 kN can be reached already at 50 bar.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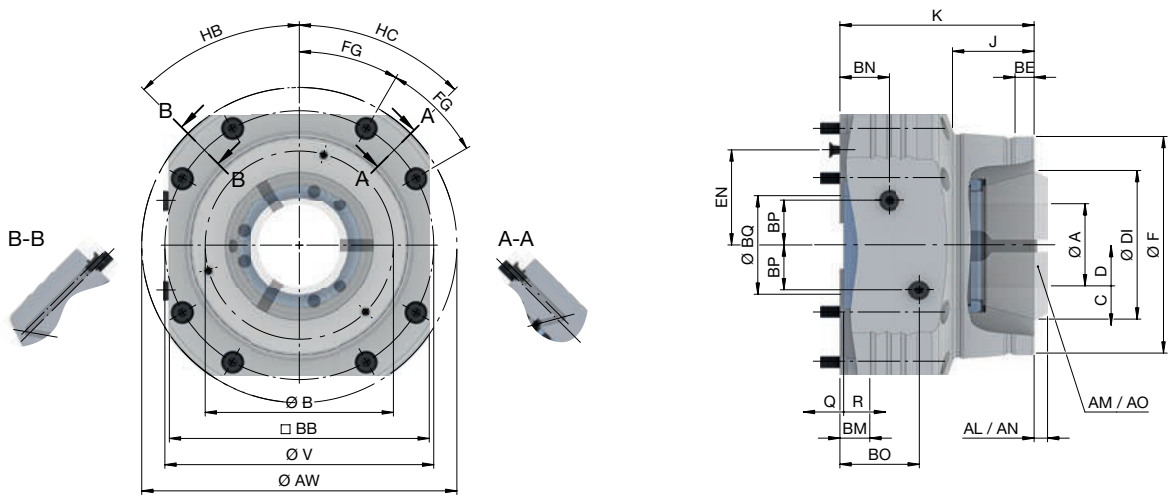
HYDROK RD size 42 - 100. Technical data



Product line		RD				
Size		**42**	**52**	**65**	**80**	**100**
Clamping range [mm]	A	3 – 42	3 – 52	3 – 65	5 – 80	15 – 100
Repeatability ≤ [mm]		0,010				
Max. axial drawtube force [pull / push] [kN]		35		45	50	65
Max. radial clamping force [kN]		80		105	115	150
Max. actuating pressure [bar]		40				
Release stroke in Ø [mm]	C	0,6				2
RPM n max. [1/min.]		1000				
Reserve stroke in Ø [mm]	D	1				1,5
Reserve stroke axial [mm]	Q	2				3
Release stroke axial [mm]	R	2,5				5
Location front end-stop	F	Ø 125 f7		Ø 145 f5	Ø 160 f7	Ø 215 f7
Length flange location [mm]	BE	7,4		12,5	17,5	15,5
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Ø Capacity [mm]	BQ	47	53	66	81	108
Height [mm]	J	39		54		
Overall height [mm]	K	120		130		140
Outer variant [mm]	BB	154		174	186	229
Release	BN	38,1 [1/8"]		33,15 [1/8"]	33 [1/8"]	38,9 [1/8"]
Clamping	BO	57,2 [1/8"]		53,15 [1/8"]	53,5 [1/8"]	63 [1/8"]
Connecting position [mm]	BP	25	30			
Fluid connection 1 [mm]	EN	55,5		63,6	68,6	84,85
Outer Ø [mm]	AW	175 f6		210 f6	215 f6	270 f6
Bolt hole circle	V	LK Ø 157 [8 x M8]		LK Ø 180 [8 x M8]	LK Ø 194 [8 x M8]	LK Ø 240 [8 x M8]
Mounting seat fit length [mm]	BM	20				
Angle position [°]	FG	30				
Clamping via base plate [°]	HB	45				
Release via base plate [°]	HC	45				
Head Ø [mm]	DI	80		99,5	115	144,5
Clamping head serrated	AM	SK 42 BZI	SK 52 BZI	SK 65 BZI	SK 80 BZI	SK 100 BZ
Clamping head protrusion length serrated [mm]	AL	9	4	9	4	
Clamping head smooth	AO	SK 42 BZIG	SK 52 BZIG	SK 65 BZIG	SK 80 BZIG	SK 100 BZG
Clamping head protrusion length smooth [mm]	AN	4				
Weight [kg]		12		15	17,5	29
In stock		✔	✔	✔	✔	✔
Material no.		10001408	10001409	10001406	10001410	10001411

Please note: At adaptation size 42 and 52 the jaw module cannot be used. Size 100 is also available in Lightweight design [14 kg].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