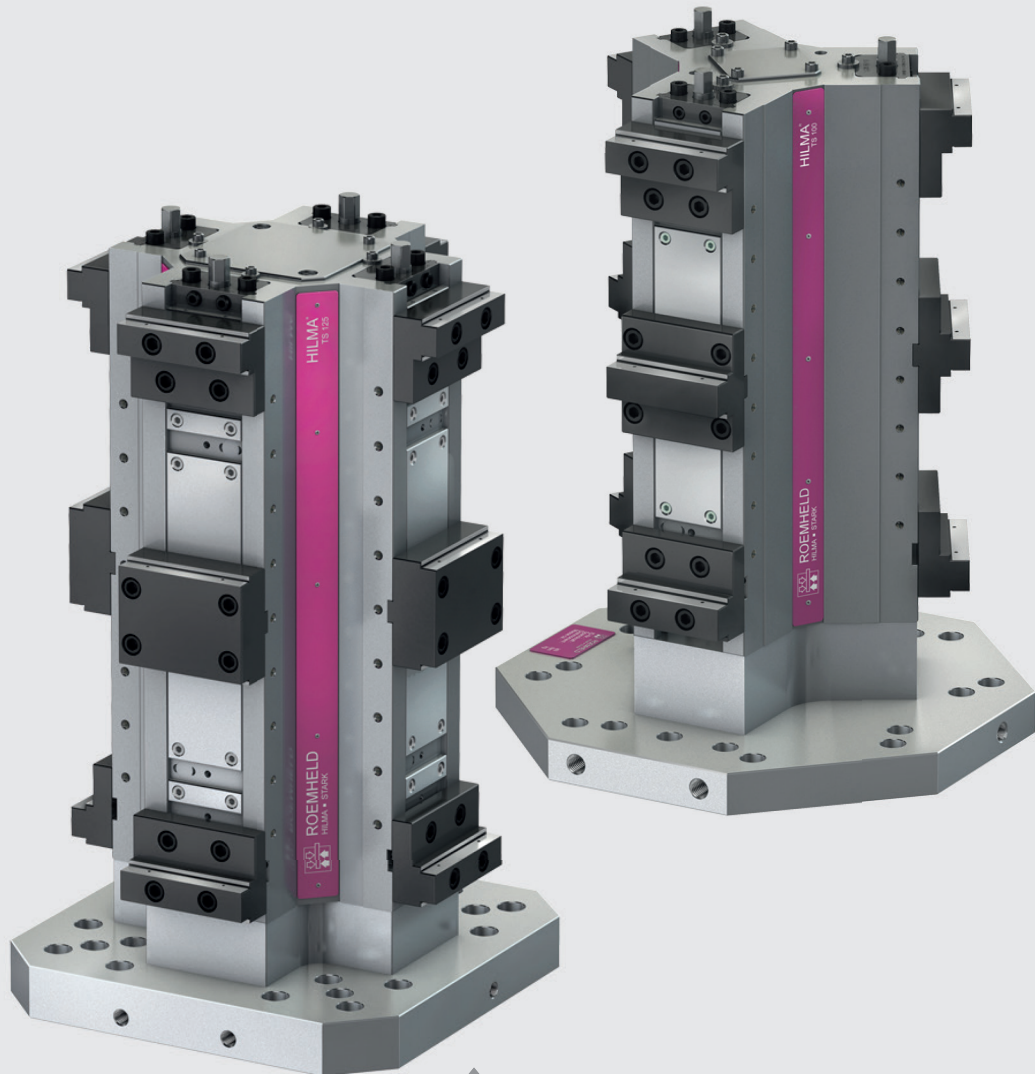




ROEMHELD
HILMA ■ STARK



HILMA.TS

Tower Workholding System

Jaw widths 100 and 125 mm

WS 4.3301, WS 4.3302, WS 4.330Z



ROEMHELD
HILMA ■ STARK

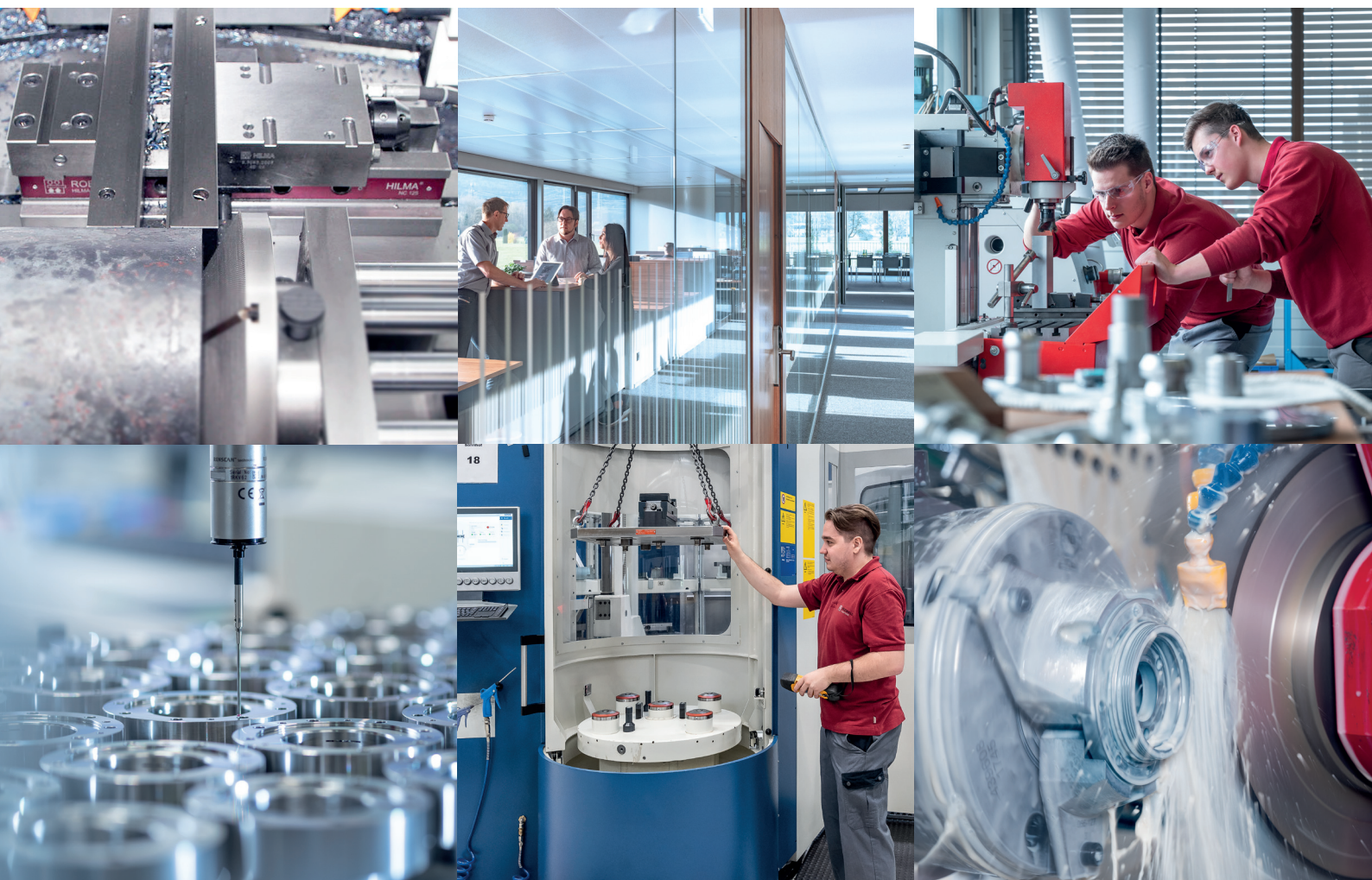


STARK INNOVATIVE PROFICIENT INDIVIDUAL SAFE

The high-tech company STARK Spannsysteme was established in 1977 in Rankweil, Austria. It manufactures zero point clamping systems and vices of the highest quality and precision for international clients in the automotive, aviation and medical industries, for example.

STARK Spannsysteme products are a byword for minimal set-up times, faster production and high flexibility.

HILMA vices can be complemented and combined perfectly with STARK zero point clamping systems.



AUTOMOTIVE



AVIATION



MACHINE AND TOOL
CONSTRUCTION



MEDICINE

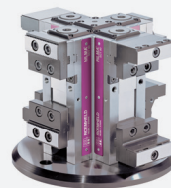
FOCUS ON INDUSTRIES & MARKETS.

Every customer has specific requirements. Our established and extensive industry expertise allows us to offer you the best solutions, services and products for sustainable and efficient use in your market.

HILMA.TS



HILMA.TS



HILMA.SCT

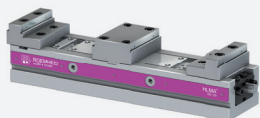
HORIZONTAL MACHINING



HILMA.KNC



HILMA.NC



HILMA.DS

VERTICAL MACHINING

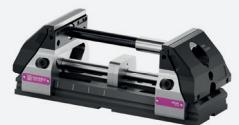
HILMA

Workpiece clamping systems

More productivity through:

- maximum flexibility in production
- highest process reliability
- reduced manufacturing costs through set-up time optimisation

5-AXIS MACHINING



HILMA.UC



HILMA.MCP



HILMA.SCS

AUTOMATION



HILMA.ASE



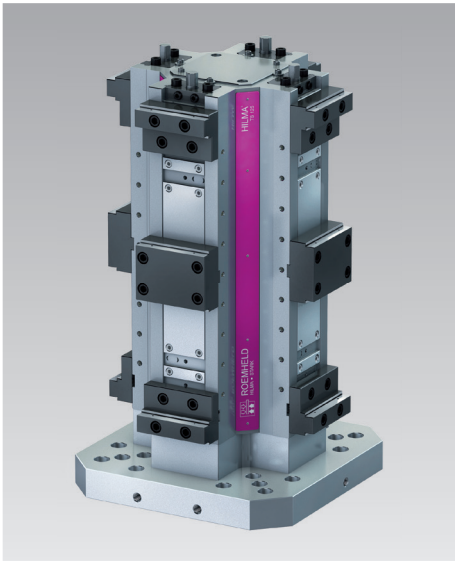
HILMA.ASH



Tower Workholding Systems HILMA.TS

clamping against the fixed jaw, mechanically operated

jaw widths 100 and 125 mm, with 4 clamping sides



Advantages

- 2 sizes for optimum design to the machining centre
- Clamping of 4, 8 or 16 workpieces with standard jaws
- Clamping of different workpiece dimensions also on one side
- Purely mechanical build up of the clamping force
- Easy and safe operation
- Large jaw openings and high flexibility due to extensive range of clamping jaws
- Highest stability by design as a monoblock
- Optimum protection against contamination and wear through patented guidance and sealing
- Process-safe application of clamping force, also when using grip jaws

Technical data

Clamping sides:	4 - arrangement 4 x 90°
Operation:	mechanically with a torque wrench
Clamping:	against central jaw or fixed jaw arranged on one side

HILMA.TS 100

Jaw width:	100 mm
Clamping force:	25 kN at 55 Nm
Max. jaw opening:	1 x 343 mm 2 x 156 mm

HILMA.TS 125

Jaw width:	125 mm
Clamping force:	40 kN at 115 Nm
Max. jaw opening:	1 x 476 mm 2 x 226 mm 4 x 108 mm

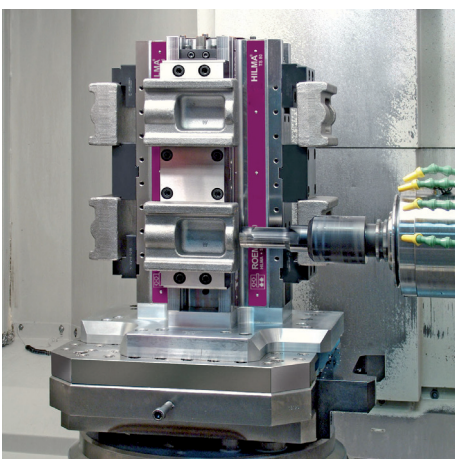
Application

HILMA.TS tower workholding systems are used on horizontal machining centres, in vertical machining in connection with 4th axis, but also on 5-axis machining centres. The applications range from manually equipped machines to pallet stations and fully automated systems.

Customised versions

An experienced team of designers is at your disposal to solve your individual clamping task and to develop customised versions. Please contact us.

Application example



Tower workholding system HILMA.TS 125 with 3rd-hand function

Description

The tower workholding systems HILMA.TS convince with their durability and precision. The patented guidance and sealing principle works without any delicate sheet metal covers or plastic wipers. The design as a monoblock, without interfaces to individually screwed workholding systems, stands for high stability and high accuracy. The centrally arranged fixed jaw as a central jaw is without load and thus absolutely zero point stable. The workpieces are positioned close to each other, thus reducing the travel paths of the machining centre to a minimum. The purely mechanical operation enables clamping also with low and always reproducible clamping forces. These characteristics turn the tower workholding systems HILMA.TS into a flexible standard fixture for a wide variety of applications in modern production.

Accessories

The extensive range of clamping jaws see data sheet 4.330Z.

Handling systems can optionally be used for operation. They increase the user-friendliness and improve the ergonomics. We are pleased to offer you the right system for your machine on request.

Consultation

Extensive information such as drawings and CAD models are available on request. Our experts will be pleased to advise you also on site, and work with you to find the correct clamping solution.

Versions

The optimum adaptation to the machining centre and the machining task is facilitated by 2 versions of the HILMA.TS workholding systems.

Version with 3rd-hand function

The operation is made with only one spindle per clamping side.

The upper and lower clamping jaw are operated together by means of a spindle and clamp against a fixed central jaw or a fixed jaw arranged on one side.

The integrated 3rd-hand function enables to only hold the lower workpiece by operating the spindle. Only after the insertion of the second workpiece above and operating again the spindle, both workpieces are clamped as defined.

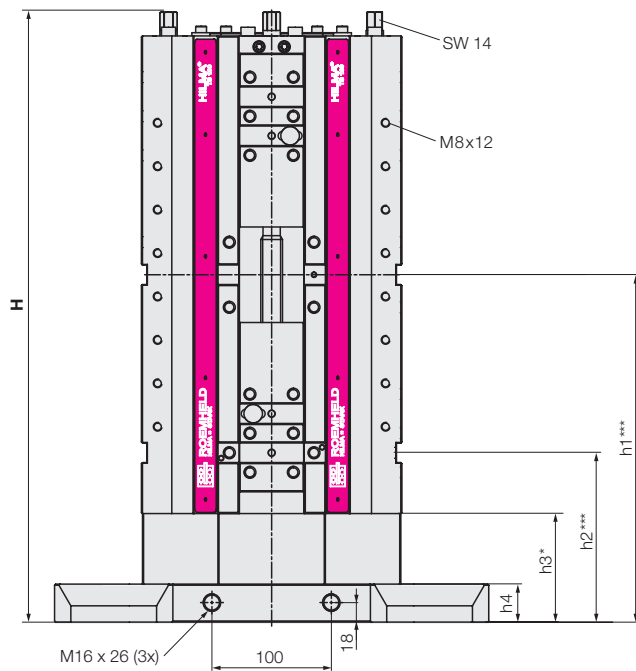
Version Vector in 2 variants

Variant 1: central jaw as fixed jaw

Variant 2: 2 x fixed jaw

The operation is made with two spindles per clamping side. The 3rd-hand function is omitted. The Vector versions are particularly suitable for clamping of high workpiece weights (> 15 kg). When used as double workholding system, the upper and lower clamping points can be pressurised with different clamping forces.

Dimensions HILMA.TS 100



Series **HILMA.TS 100**

Jaw width 100 mm

Clamping force 25 kN at 55 Nm

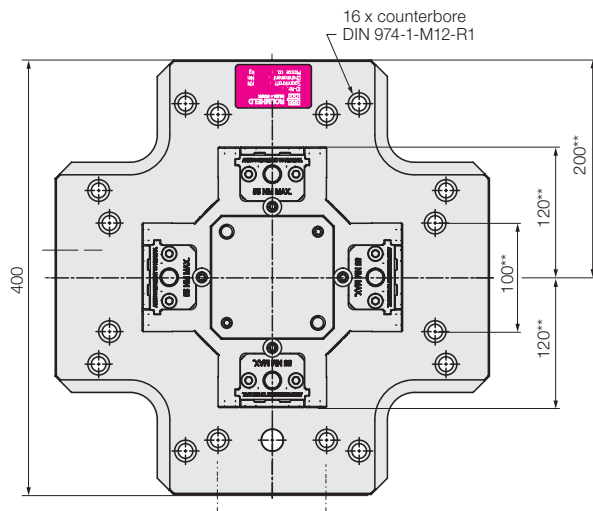
Clamping jaws and the associated jaw openings see data sheet WS 4.330Z

Dimensions in mm

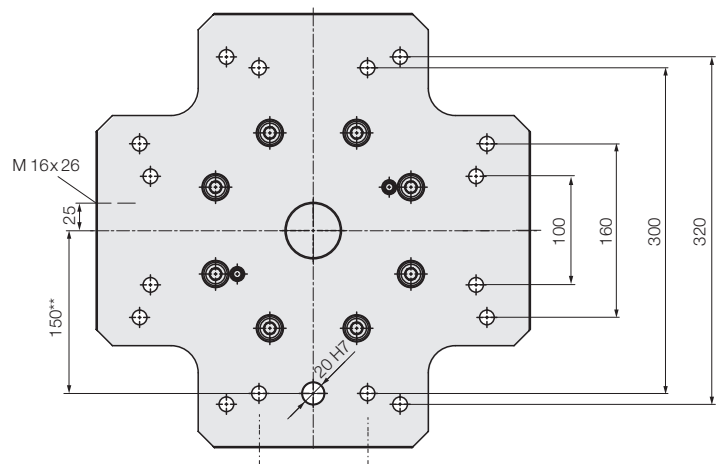
* Tolerance ± 0.01 mm

** Tolerance ± 0.02 mm

*** Tolerance ± 0.03 mm

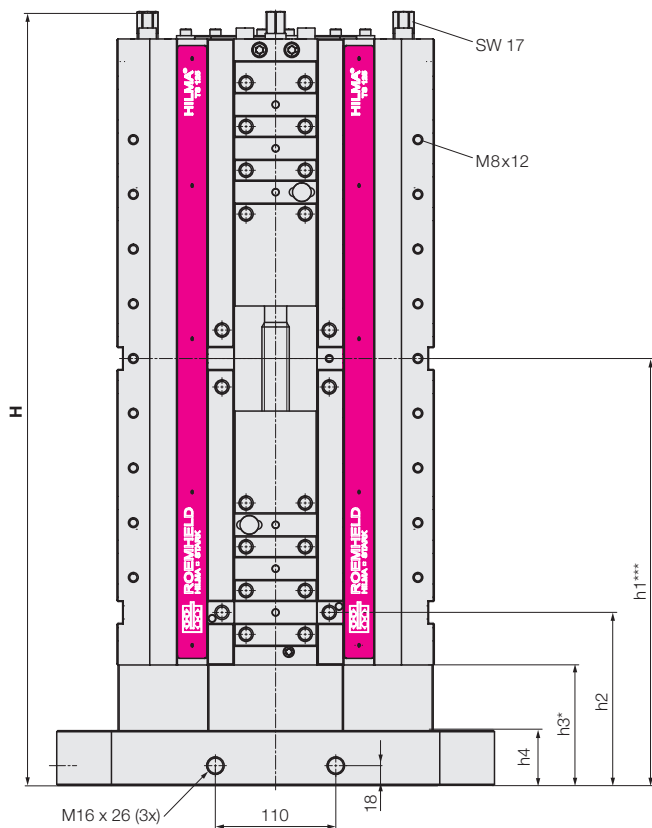


View from below



Series		HILMA.TS 100		
Version		3rd-hand	Vector	Vector
Variant			1 x central jaw	2 x fixed jaw
H	[mm]	562	599	599
Stroke	[mm]	2 x 44	2 x 44	2 x 40
h1	[mm]	320	320	360
h2	[mm]	156	156	146
h3	[mm]	100	100	100
h4	[mm]	35	35	35
Weight without clamping jaws	[kg]	109	116	115
Part no. without clamping jaws		933650202	933750202	933950202

Dimensions HILMA.TS 125



Series **HILMA.TS 125**

Jaw width 125 mm

Clamping force 40 kN at 115 Nm

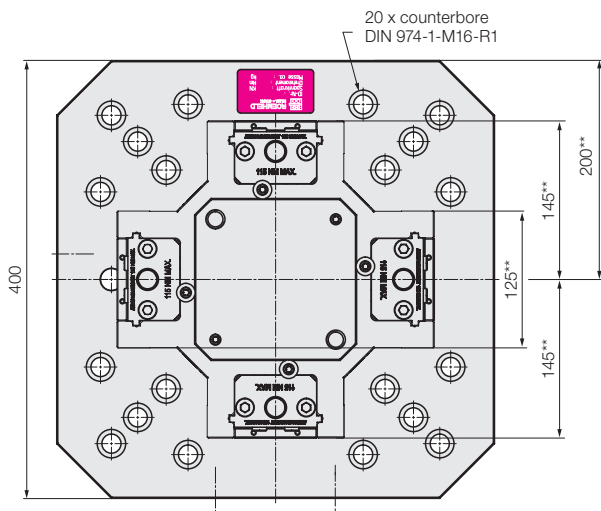
Clamping jaws and the associated jaw openings see data sheet WS 4.330Z

Dimensions in mm

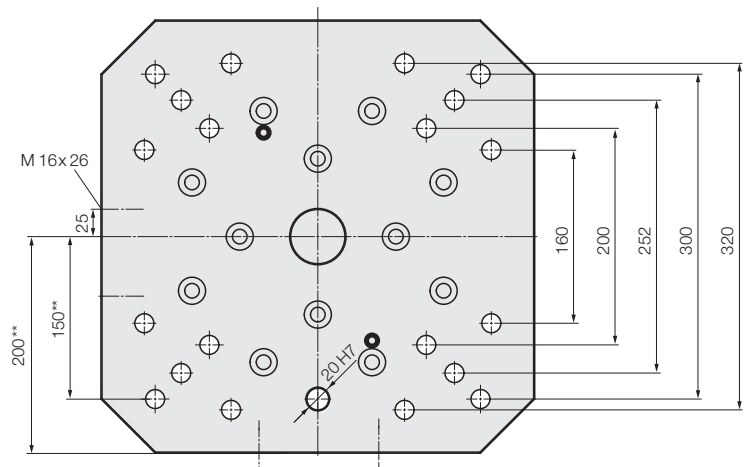
* Tolerance ± 0.01 mm

** Tolerance ± 0.02 mm

***Tolerance ± 0.03 mm



View from below



Series		HILMA.TS 125		
Version		3rd-hand	Vector	Vector
Variant			1 x central jaw	2 x fixed jaw
H	[mm]	707	750	745
Stroke	[mm]	2 x 48	2 x 47	2 x 47
h1	[mm]	390	390	436
h2	[mm]	158	158	154
h3	[mm]	110	110	110
h4	[mm]	50	50	50
Weight without clamping jaws	[kg]	214	228	224
Part no. without clamping jaws		933660302	933760302	933960302



Tower Workholding Systems HILMA.TS TriStar

clamping against the fixed jaw, mechanically operated

jaw widths 100 and 125 mm, with 3 clamping sides



Advantages

- 3 sizes for optimum design to the machining centre
- Clamping of 3, 6 or 12 workpieces with standard jaws
- Clamping of different workpiece dimensions also on one side
- Purely mechanical build up of the clamping force
- Easy and safe operation
- Large jaw openings and high flexibility due to extensive range of clamping jaws
- Highest stability by design as a monoblock
- Optimum protection against contamination and wear through patented guidance and sealing
- Process-safe application of clamping force, also when using grip jaws
- Optimised accessibility

Technical data

Clamping sides:	3 - arrangement 3 x 120°
Operation:	mechanically with a torque wrench
Clamping:	against central jaw or fixed jaw arranged on one side

HILMA.TS 100 TriStar

Jaw width:	100 mm
Clamping force:	25 kN at 55 Nm
Max. jaw opening:	1 x 343 mm
	2 x 156 mm

HILMA.TS 125 TriStar

Jaw width:	125 mm
Clamping force:	40 kN at 115 Nm
Max. jaw opening:	1 x 476 mm
	2 x 226 mm
	4 x 108 mm

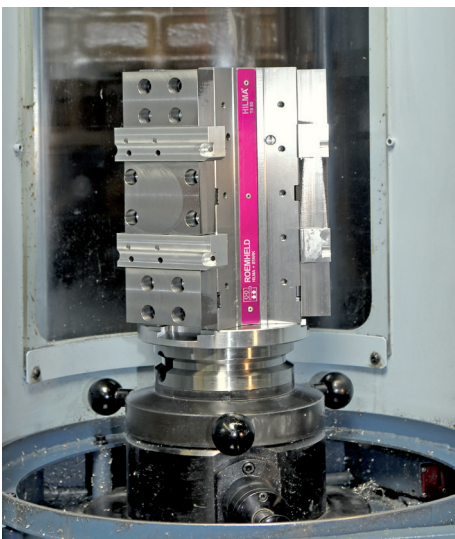
Application

HILMA.TS TriStar tower workholding systems are used on horizontal machining centres, in vertical machining in connection with 4th axis, but also on 5-axis machining centres. The applications range from manually equipped machines to pallet stations and fully automated systems.

Customised versions

An experienced team of designers is at your disposal to solve your individual clamping task and to develop customised versions. Please contact us.

Application example



Tower workholding system HILMA.TS TriStar, a workholding system with connection to Matsuura MAM 72

Description

The tower workholding systems HILMA.TS TriStar convince with their durability and precision. The patented guidance and sealing principle works without any delicate sheet metal covers or plastic wipers. The design as a monoblock, without interfaces to each screwed clamping systems, stands for high stability and high accuracy. The centrally arranged fixed jaw as a central jaw is without load and thus absolutely zero point stable. The workpieces are positioned close to each other, thus reducing the travel paths of the machining centre to a minimum. The purely mechanical operation enables clamping also with low and always reproducible clamping forces. These characteristics turn the tower workholding systems HILMA.TS TriStar into a flexible standard fixture for a wide variety of applications in modern production.

Accessories

The extensive range of clamping jaws see data sheet 4.330Z.

Handling systems can optionally be used for operation. They increase the user-friendliness and improve the ergonomics. We are pleased to offer you the right system for your machine on request.

Consultation

Extensive information such as drawings and CAD models are available on request. Our experts will be pleased to advise you also on site, and work with you to find the correct clamping solution.

Versions

The optimum adaptation to the machining centre and the machining task is facilitated by 2 versions of the HILMA.TS TriStar workholding systems.

Version with 3rd-hand function

The operation is made with only one spindle per clamping side.

The upper and lower clamping jaw are operated together by means of a spindle and clamp against a fixed central jaw or a fixed jaw arranged on one side.

The integrated 3rd-hand function enables to only hold the lower workpiece by operating the spindle. Only after the insertion of the second workpiece above and operating again the spindle, both workpieces are clamped as defined.

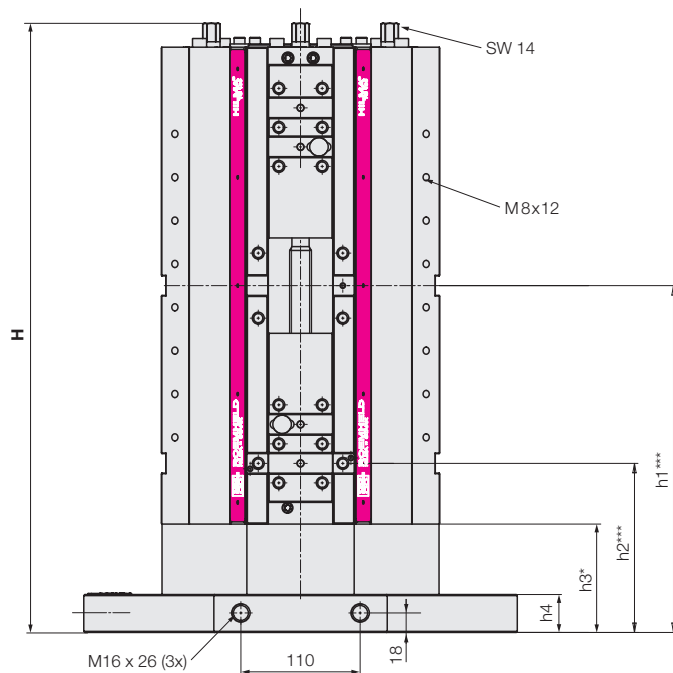
Version Vector in 2 variants

Variant 1: central jaw as fixed jaw

Variant 2: 2 x fixed jaw

The operation is made with two spindles per clamping side. The 3rd-hand function is omitted. The Vector versions are particularly suitable for clamping of high workpiece weights (> 15 kg). When used as double workholding system, the upper and lower clamping points can be pressurised with different clamping forces.

Dimensions HILMA.TS 100 TriStar



Series **HILMA.TS 100 TriStar**

Jaw width 100 mm

Clamping force 25 kN at 55 Nm

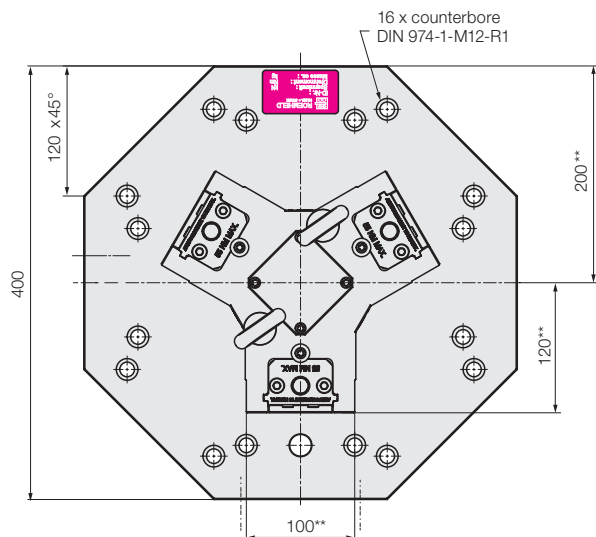
Clamping jaws and the associated jaw openings see data sheet WS 4.330Z

Dimensions in mm

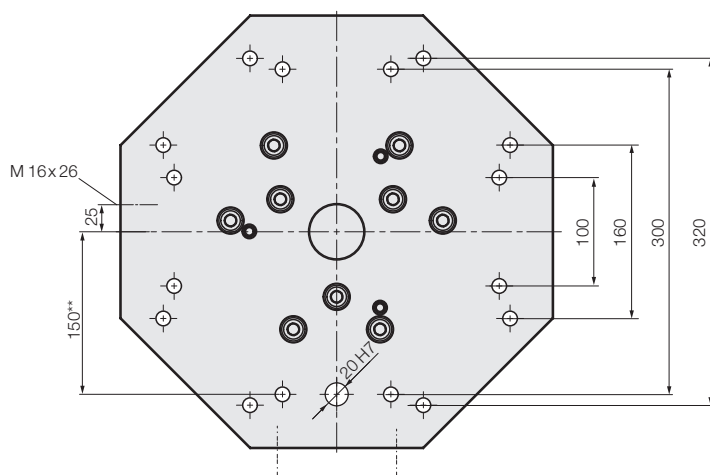
* Tolerance ± 0.01 mm

** Tolerance ± 0.02 mm

*** Tolerance ± 0.03 mm

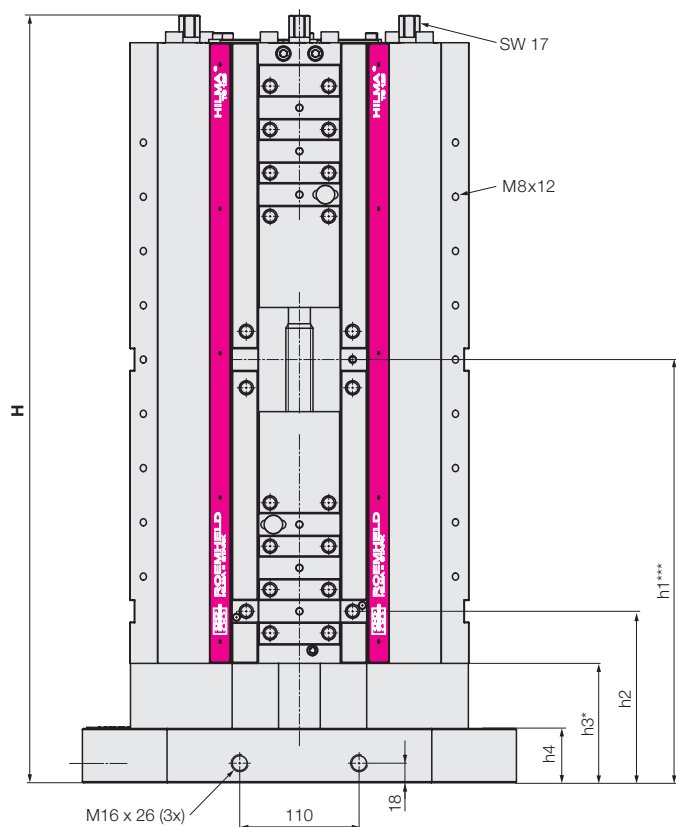


View from below



Series		HILMA.TS 100 TriStar		
Version		3rd-hand	Vector	Vector
Variant			1 x central jaw	2 x fixed jaw
H	[mm]	562	599	599
Stroke	[mm]	2 x 44	2 x 44	2 x 40
h1	[mm]	320	320	360
h2	[mm]	156	156	146
h3	[mm]	100	100	100
h4	[mm]	35	35	35
Weight without clamping jaws	[kg]	104	107	107
Part no. without clamping jaws		933650232	933750232	933950232

Dimensions HILMA.TS 125 TriStar



Series **HILMA.TS 125 TriStar**

Jaw width 125 mm

Clamping force 40 kN at 115 Nm

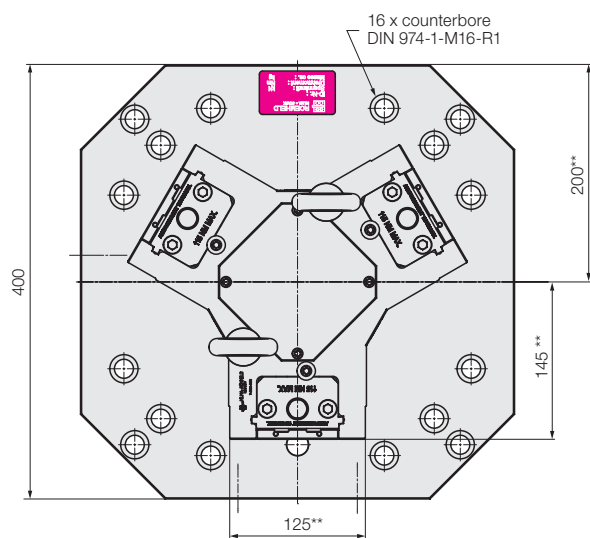
Clamping jaws and the associated jaw openings see data sheet WS 4.330Z

Dimensions in mm

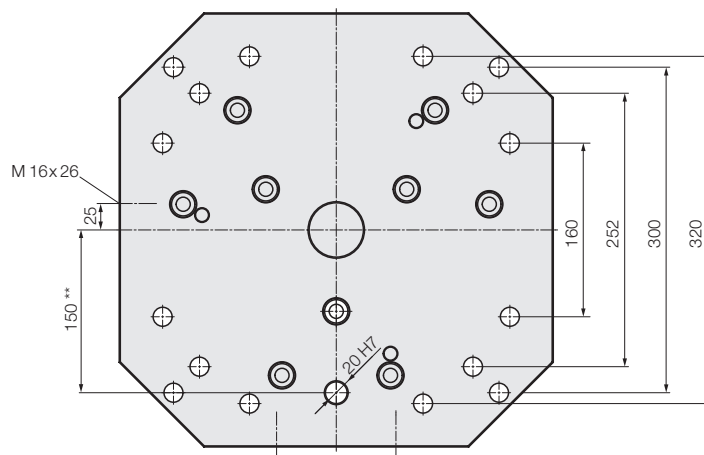
* Tolerance ± 0.01 mm

** Tolerance ± 0.02 mm

*** Tolerance ± 0.03 mm

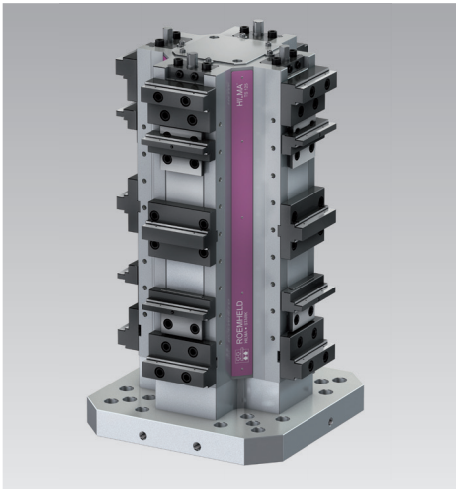


View from below



Series		HILMA.TS 125 TriStar		
Version		3rd-hand	Vector	Vector
Variant			1 x central jaw	2 x fixed jaw
H	[mm]	707	750	745
Stroke	[mm]	2 x 48	2 x 47	2 x 47
h1	[mm]	390	390	436
h2	[mm]	158	158	154
h3	[mm]	110	110	110
h4	[mm]	50	50	50
Weight without clamping jaws	[kg]	174	185	183
Part no. without clamping jaws		933660332	933760332	933960332

Accessories for Tower Workholding Systems
HILMA.TS, HILMA.TS TriStar and HILMA.TS Vector
Clamping jaws and jaw openings - Accessories for operation



Delivery of clamping jaws

All clamping jaws are supplied with the associated fixing screws.
 For clamping jaws with jaw inserts, please make your selection tailored to your application.

Important notes

- By the use of clamping jaws with jaw inserts, the jaw opening is reduced by approx. 4 mm per clamping point.
- When using jaw inserts, the dimension “h” indicated in the figures is increased by 4 mm.
- Technical information and application recommendations for jaw inserts see data sheet [WS 12-SE](#).

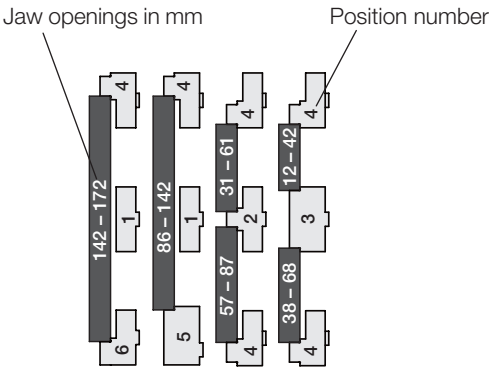
Clamping jaws

HILMA.TS 80 and HILMA.TS 80 TriStar

Design: with 3rd-hand function

Position	Description	Part no.
1	Guide plate	937914140
2	Central step jaw 16 mm	937914111
3	Central step jaw 54 mm	937914121
4	Reversible step jaw	937914211
5	Fixed step jaw	937914341
6	Fixed step jaw	937914311

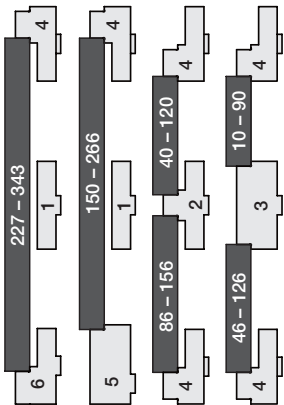
Jaw openings



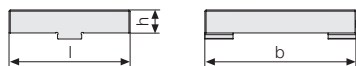
HILMA.TS 100 and HILMA.TS 100 TriStar

Designs: 3rd-hand function and Vector with 1 central jaw

Position	Description	Part no.
1	Guide plate	937915140
2	Central step jaw 26 mm	937915111
3	Central step jaw 86 mm	937915121
4	Reversible step jaw	937915211
5	Fixed step jaw	937915341
6	Fixed step jaw	937915311
Position	Clamping jaws for jaw inserts	
2	Central step jaw for 1 jaw insert	937915711
3	Central step jaw for 2 jaw inserts	937915721
4	Reversible step jaw for 1 jaw insert	937915811
5	Fixed step jaw for 1 jaw insert	937915941
6	Fixed step jaw for 1 jaw insert	937915911



Dimensions of clamping jaws

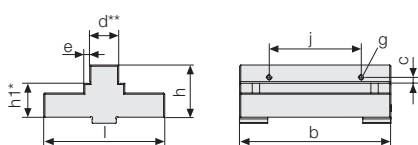


Position 1: Guide plates for 3rd-hand function and Vector
Design with 1 central jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	12							937914140
TS 100	96	100	16							937915140
TS 125	100	125	19							937916142

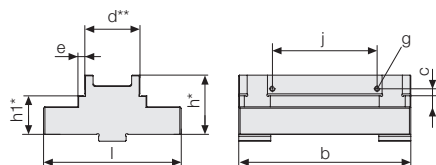
Position 1: Guide plates for Vector
Design with 2 fixed jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	16							937915143
TS 125	78	125	19							937916143



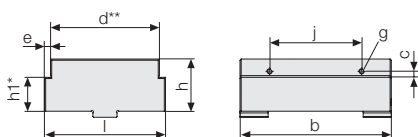
Position 2: Central step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	16	5	M4x6	50	937914111
TS 100	96	100	40	25	5	26	5	M4x6	60	937915111
TS 125	100	125	43	28	5	24	5	M4x6	76	937916151



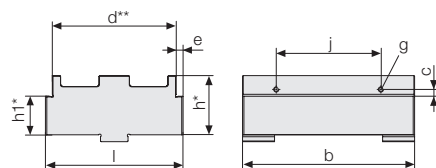
Position 2: Central step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	34	3	M4x6	60	937915711
TS 125	100	125	43	28	5	40	5	M4x6	76	937916751



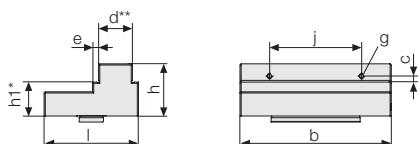
Position 3: Central step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	54	5	M4x6	50	937914121
TS 100	96	100	40	25	5	86	5	M4x6	60	937915121
TS 125	100	125	43	28	5	90	5	M4x6	76	937916161



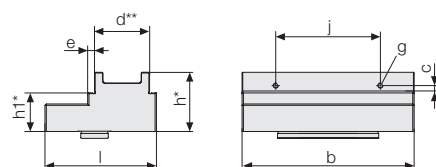
Position 3: Central step jaws for 2 jaw inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	90	3	M4x6	60	937915721
TS 125	100	125	43	28	5	90	5	M4x6	76	937916761



Position 4: Reversible step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	48.5	80	28	16	5	18	5	M4x6	50	937914211
TS 100	72	100	40	25	5	26	5	M4x6	60	937915211
TS 125	78	125	43	28	5	28	5	M4x6	76	937916211



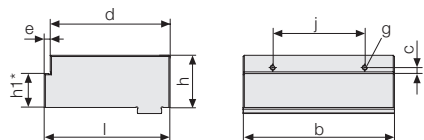
Position 4: Reversible step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	40	25	5	34	3	M4x6	60	937915811
TS 125	81	125	43	28		40	5	M4x6	76	937916811

* Tolerance ± 0.01 mm
 ** Tolerance ± 0.02 mm

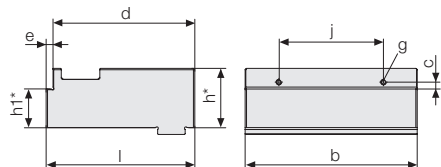
Accessories

Clamping jaws and clamping jaws for jaw inserts



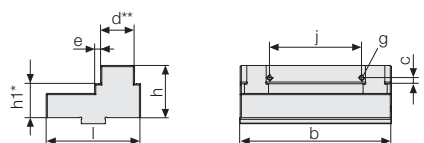
Position 5: Fixed step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	71	80	28	16	5	66	5	M4x6	50	937914341
TS 100	88	100	40	25	5	83	5	M4x6	60	937915341
TS 125	104	125	43	28	5	99	5	M4x6	76	937916351



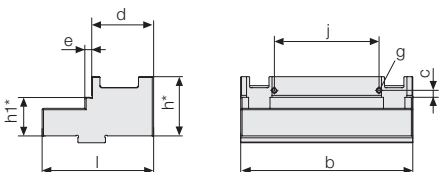
Position 5: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	90	100	40	25	5	85	5	M4x6	60	937915941
TS 125	108	125	43	28	5	103	5	M4x6	76	937916951



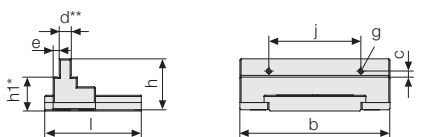
Position 6: Fixed step jaws, used for a large clamping range

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	49	80	28	16	5	15	5	M4x6	50	937914311
TS 100	72	100	40	25	5	26	5	M4x6	60	937915311
TS 125	78	125	43	28	5	28	5	M4x6	76	937916311



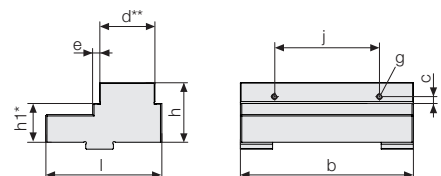
Position 6: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	80	100	40	25	5	34	5	M4x6	60	937915911
TS 125	88	125	43	28	5	40	5	M4x6	76	937916911



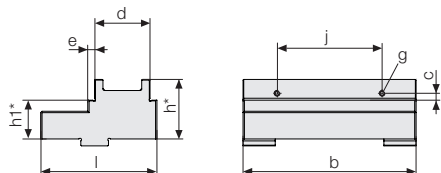
Position 7: Floating central jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	50/80	124	43	28	5	10	5	M4x6	76	937916511



Position 8: Fixed reversible step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	40	25	5	26		M4x6	60	937915371
TS 125	78	125	43	28	5	28		M4x6	76	937916371



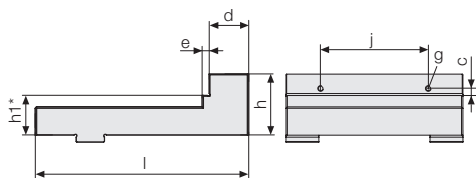
Position 8: Fixed reversible step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	81	100	40	25	5	34	5	M4x6	60	937915971
TS 125	88	125	43	28	5	40	5	M4x6	76	937916971

* Tolerance ± 0.01 mm
** Tolerance ± 0.02 mm

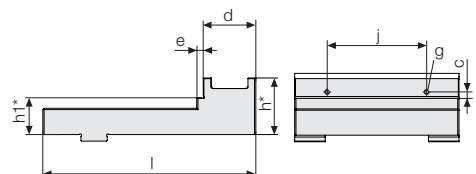
Accessories

Clamping jaws and clamping jaws for jaw inserts



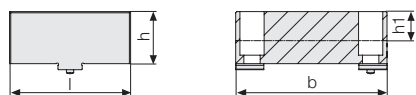
Position 9: Fixed step jaws, long, for HILMA.TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	937915381
TS 125	164	125	43	28	5	40	5	M4x6	76	937916381



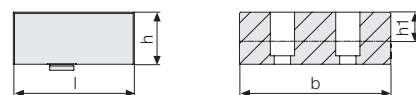
Position 9: Fixed step jaws, long, for 1 jaw insert for HILMA.TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	937915981
TS 125	164	125	43	28	5	40	5	M4x6	76	937916981



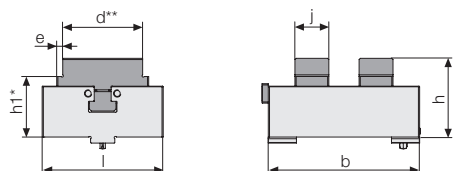
Central jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	35	21						937914411
TS 100	96	100	40	23						937915411
TS 125	100	125	43	24						937916411



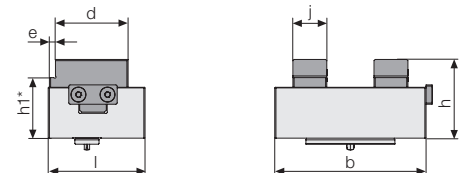
Reversible jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	56	80	35	21						937914421
TS 100	84	100	40	23						937915421
TS 125	100	125	43	24						937916421



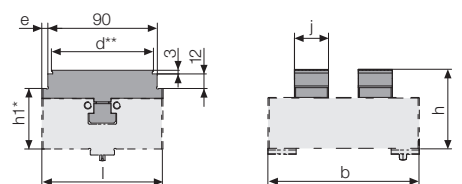
SlimFlex central jaws with retaining pieces

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	100	125	65	50		66	5		28	937916173



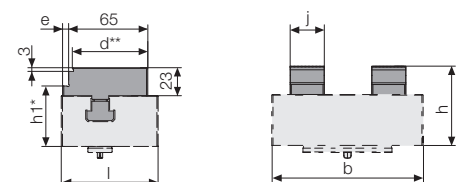
SlimFlex clamping jaws with retaining pieces

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	80	125	65	50		60	5		28	937916273



Universal retaining piece with step grip and smooth, for SlimFlex central jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	100	125	65	50		84	5		28	737918173



Universal retaining piece with step grip and smooth, for SlimFlex clamping jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	80	125	65	50		62	5		28	737918174

* Tolerance ±0.01 mm
** Tolerance ±0.02 mm

Accessories for operation

Torque wrench



Type	Part no.	Torque [Nm]
TS 80	937926600	5–60
TS 100	937926610	20–120
TS 125	937926610	20–120

Socket for torque wrench



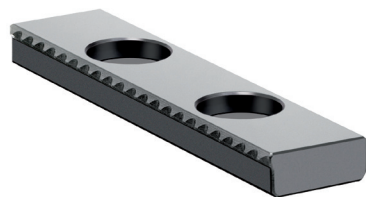
Type	Part no.	SW
TS 80	131240021	12
TS 100	131240020	14
TS 125	131240017	17

Allen wrench for clamping jaws and jaw inserts



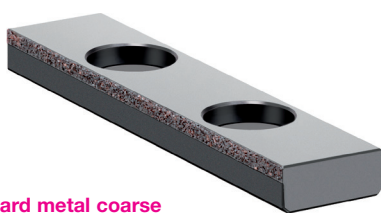
Type	Part no.	SW
TS 100	169110003	8
TS 125	169110005	10

Jaw inserts grip serrated

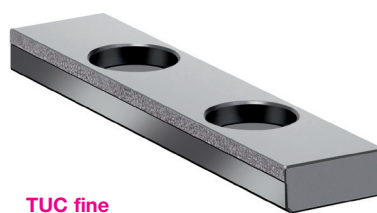


Grip

Jaw inserts with coatings



Hard metal coarse



TUC fine

Jaw inserts, see also data sheet WS 12-SE: Technical information "Jaw inserts for clamping jaws"

Recommendation for jaw inserts to increase the retention forces

Workpiece material	Workpiece surface	rolled / cast / forged	drawn	sawn	milled	ground
Steel, e.g. C45, 20 Mn Cr 5, 31 Cr Mo V9		HM coarse, grip	TUC	HM coarse, grip	TUC	TUC
Heat-treated steel e.g. C45 induction-hardened, 20 Mn Cr 5 case-hardened, 31 Cr Mo V9 nitrided					TUC	TUC
Cast e.g. GG, red bronze		HM coarse, grip			TUC	TUC
Titanium			TUC		TUC	TUC
Aluminium		HM coarse, grip		Grip		TUC
Non-ferrous metals				Grip		TUC

Part numbers for jaw inserts

Jaw inserts for HILMA.TS 100 and HILMA.TS 100 Vector jaw width 100

Designation	Part no. for reversible step jaws	Part no. for fixed jaws and central jaws
Jaw inserts Grip / smooth	5 5050 0632	5 5050 0548
Jaw inserts Grip / Grip	-	5 5050 0630
Jaw inserts HM coarse / smooth	5 5050 0631	5 5050 0749
Jaw inserts HM coarse / HM coarse	-	5 5050 0629
Jaw inserts TUC / smooth	5 5050 0770	5 5050 0769
Jaw inserts TUC / TIC	-	5 5050 0768
Jaw inserts smooth / smooth	-	5 5050 0628

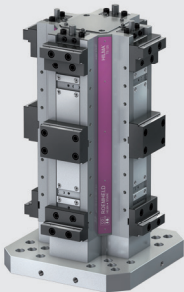


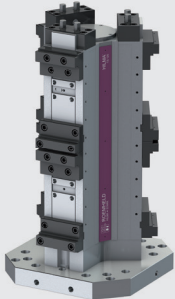
Jaw inserts for HILMA.TS 125 jaw width 125

Designation	Part no. for reversible step jaws	Part no. for fixed jaws and central jaws
Jaw inserts Grip / smooth	5 5050 0627	5 5050 0729
Jaw inserts Grip / Grip	-	5 5050 0625
Jaw inserts HM coarse / smooth	5 5050 0626	5 5050 0694
Jaw inserts HM coarse / HM coarse	-	5 5050 0624
Jaw inserts TUC / smooth	5 5050 0767	5 5050 0777
Jaw inserts TUC / TIC	-	5 5050 0768
Jaw inserts smooth / smooth	-	5 5050 0623

Jaw inserts for HILMA.TS 125 Vector with 2 fixed jaws jaw width 125

Designation	Part numbers for reversible step jaws	Part numbers for fixed jaws
Jaw inserts Grip / smooth	5 5050 0627	5 5050 0627
Jaw inserts HM coarse / smooth	5 5050 0626	5 5050 0626
Jaw inserts TUC / smooth	5 5050 0767	5 5050 0767

PROGRAMMÜBERSICHT **HILMA.TS**

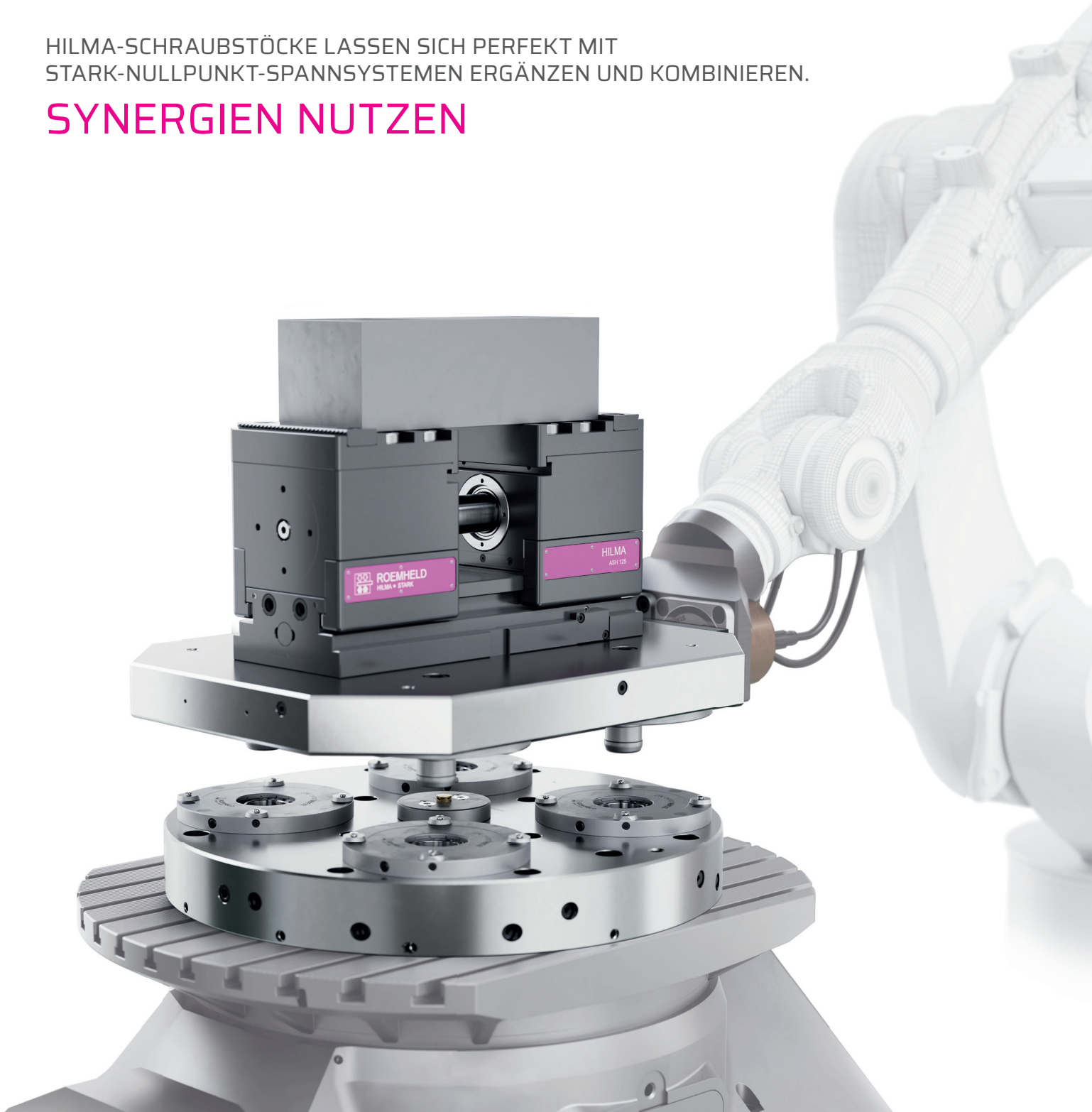
Tower clamping systems for horizontal machining (4-axis)				
Series	HILMA.TS	HILMA.TS TriStar	HILMA.TS Vector	HILMA.TS TriStar Vector
				
Jaw widths (max. clamping force)	100 mm (25 kN) 125 mm (40 kN)	100 mm (25 kN) 125 mm (40 kN)	100 mm (25 kN) 125 mm (40 kN)	100 mm (25 kN) 125 mm (40 kN)
Operation	mechanical	mechanical	mechanical	mechanical
hydraulic	–	–	on request	–
force transmission	clamping against fixed jaw	clamping against fixed jaw	clamping against fixed jaw	clamping against fixed jaw
Clamping principle	manual loading	manual loading	manual loading / automation	manual loading / automation
Application Machining centre	horizontal	horizontal	horizontal	horizontal
Special features / Options	<ul style="list-style-type: none"> · patented guide and sealing system · with 4 clamping sides 4 × 90° · operation with 1 spindle per side · with third-hand function 	<ul style="list-style-type: none"> · patented guide and sealing system · with 3 clamping sides 3 × 120° · operation with 1 spindle per side · with third-hand function 	<ul style="list-style-type: none"> · patented guide and sealing system · with 4 clamping sides 4 × 90° · operation with 2 spindles (introduction of different clamping forces) · with central fixed jaw or 2 × fixed jaws 	<ul style="list-style-type: none"> · patented guide and sealing system · with 3 clamping sides 3 × 120° · Operation with 2 spindles (introduction of different clamping forces) · with central fixed jaw or 2 × fixed jaws
Overall lengths	562 / 707 mm	248 ... 707 mm	599 ... 750 mm	599 ... 750 mm



ROEMHELD
HILMA ■ STARK

HILMA-SCHRAUBSTÖCKE LASSEN SICH PERFEKT MIT
STARK-NULLPUNKT-SPANNSYSTEMEN ERGÄNZEN UND KOMBINIEREN.

SYNERGIEN NUTZEN



- ▶ Automations-Spannsystem HILMA.ASH 125 auf STARK Nullpunkt-Spannsystem
- ▶ STARK Schnellverschlussplatte mit 4 Elementen STARK.classic.NG.2 Twister und Mediendurchführung zum Spannen/Lösen des Schraubstocks
- ▶ Kupplungseinheit mit Nullpunktspannsystem (Vorrichtungspalette - Handlingssystem); 2 Elemente STARK.airtec mit integrierter Abfrage

A COMPANY OF THE
ROEMHELD GROUP

STARK Spannsysteme

The ROEMHELD Group consists of 5 companies at locations in Germany and Austria, each with different products and orientations. With numerous subsidiaries, sales partners and service companies on all continents and in more than 50 countries, rapid and intensive customer support is provided in the mechanical engineering, medical technology, automotive, aviation and agricultural industries.

As part of the ROEMHELD Group, STARK benefits from the security and experience of a family-run traditional company as well as from the worldwide sales and service network. At the same time, this background provides the independence to pursue dynamic and innovative goals for new market-driven developments and customer-specific solutions with which STARK maintains its leading technological position.



ROEMHELD
HILMA ■ STARK

STARK Spannsysteme

A company of the ROEMHELD Group

STARK Spannsysteme GmbH
Römergrund 14 | 6830 Rankweil
Austria

+43 5522 37 400 - 0
info@stark-roemheld.com

stark-roemheld.com