

020 SERIES

Hydraulic Power Clamps | Thru-Hole Hydraulic Ram Product Overview

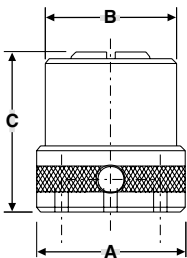
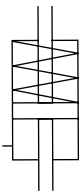
By inserting a rod through the hollow piston, these cylinders can be used to push or pull depending on the orientation of the ram. They will actuate a rod of any length or shape and are extremely effective in translating power to a remote location. Greater forces are generated in these thru-hole rams because of their larger piston area.

Features:

- Larger piston diameter for greater clamping forces
- Hardened steel piston and rod
- Single-acting for simple plumbing
- Optional threaded inserts
- Optional mounting plate (permits mounting ram with a single cap screw)



Symbol



Model no.	RAM I.D.*	Port	Stroke	Force at 3,000 PSIG	Oil Displacement	Dimensions		
						A	B	C
020-011-011DE	0.38	SAE #2	0.38	4,380 lbs.	0.547 cu. in.	2.13	1.88	2.25
020-012-021DE	0.50	SAE #4	0.50	8,100 lbs.	1.35 cu. in.	3.00	2.63	2.88
020-013-031DE	0.63	SAE #4	0.63	12,066 lbs.	2.51 cu. in.	3.25	3.00	3.63

* Clearance for rod or bolt of given dimension.

Maximum input pressure 3,500 PSIG.

Accessories

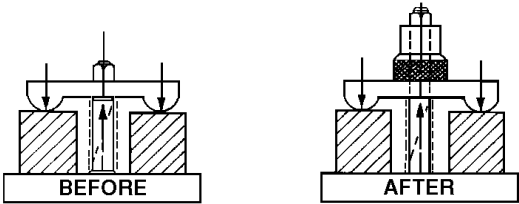
All size thru-hole rams are supplied with a thru-hole insert threaded into the top.

RAM no.	Thru-Hole Insert (supplied)
020-011-011DE	705384
020-012-021DE	705512
020-013-031DE	705634

Loads Transmitted by Various Diameter Screws		
Bolt Size	Wrench Length	F-lbs. (Average)
1/4 UNF	4.00	2,400 lbs.
1/4 UNF	4.00	1,920 lbs.
3/8 UNF	5.75	3,000 lbs.
3/8 UNF	5.75	2,920 lbs.
1/2 UNF	8.00	4,200 lbs.
1/2 UNF	8.00	3,640 lbs.
5/8 UNF	9.00	5,600 lbs.
5/8 UNF	9.00	5,600 lbs.
3/4 UNF	9.00	4,800 lbs.
3/4 UNF	11.00	4,200 lbs.
7/8 UNF	12.00	50,400 lbs.

To determine how much force is needed to replace a manual clamp, use this chart as a guide.

A thru-hole ram easily converts a manual strap clamp into an automatic hydraulic powered clamp. Usually a longer bolt is the only part needed to make this conversion.



Calculation of Forces Using Straps and Levers

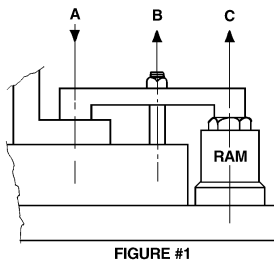


FIGURE #1

Figure #1

When the distance AB is equal to the distance BC the force upward from Model 020-011-011DE Ram "C" is equal to the downward force "A" on the part.

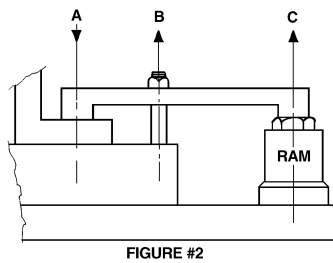


FIGURE #2

Figure #2

The downward force "A" is equal to the upward force "C" times a ratio of the distance BC:AB.

Example:

AB = 2", BC = 4", Force "C" = 1,000 lbs.

$$\text{Force "A"} = \text{Force "C"} \times \frac{BC}{AB}$$

$$\text{"A"} = 1,000 \text{ lbs.} \times \frac{4}{2}$$

$$\text{"A"} = 2,000 \text{ lbs.}$$

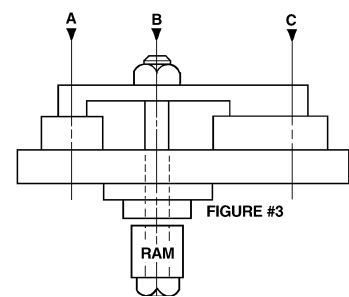


FIGURE #3

Figure #3

When Force "B" from Model 020-011-011DE Hollow Bore is divided between "A" & "C", the forces at "A" & "C" are in inverse ratio to the distance AB & BC respectively.

$$\text{Force "A"} = \text{Force "B"} \times \frac{BC}{AB}$$

$$\text{Force "C"} = \text{Force "B"} \times \frac{AB}{AC}$$

Example:

AB = 2", BC = 4", Force "B" = 1,000 lbs.

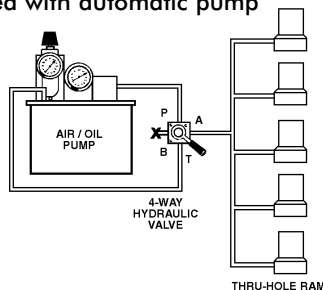
$$\text{Force "A"} = 1,000 \text{ lbs.} \times \frac{4}{6} = 666.7 \text{ lbs.}$$

$$\text{Force "C"} = 1,000 \text{ lbs.} \times \frac{2}{6} = 333.3 \text{ lbs.}$$

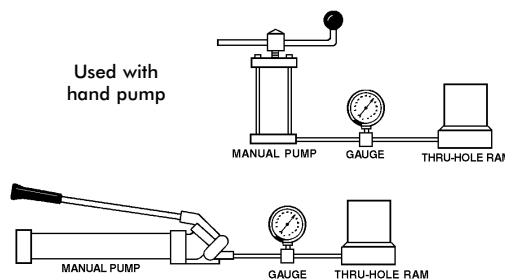
Power Sources

Thru-hole Rams can be powered by automatic pumps, hand pumps, boosters or existing machine hydraulics.

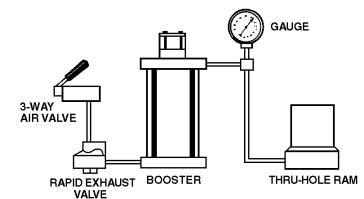
Used with automatic pump



Used with hand pump



Used with booster



Multiple Uses

Thru-hole Rams can be used to push or pull depending on the position of the ram.

