



Work Supports

Extending hydraulically – contact by spring force, double acting, max. operating pressure 500 bar



Application

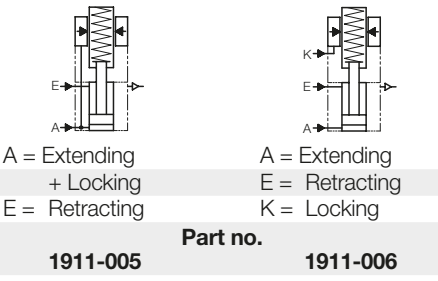
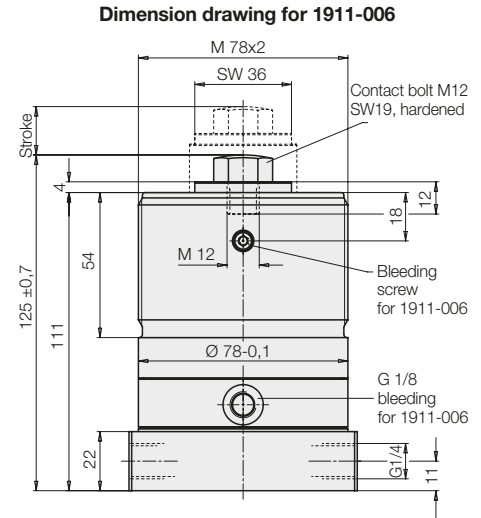
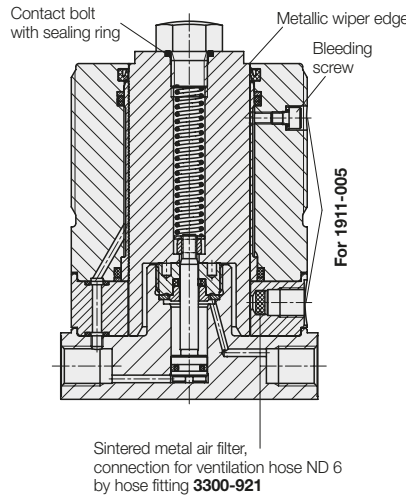
Work supports are used to provide a self-adjusting rest to avoid deflection and vibration of the workpieces during machining. It is recommended to use double-acting elements if applied in larger hydraulic clamping fixtures with long lines, especially if the return oil is cycled and has to return in a predetermined time.

Description

This hydraulic work support contains a double-acting sliding cylinder. If pressurised at port "A" the piston pushes the plunger with little force against the workpiece by means of a spring. As soon as the piston has touched the internal stop, the pressure rises and thus the locking of the plunger. The plunger retracts into de-pressurised mode automatically after the pressure supply has been transferred to port "E". If the admissible flow rate is surpassed, the plunger will lock before it has touched the workpiece. With type 1911-006 it is possible to effect locking separately through port "K". The internal part of the work support is protected against dust and swarf by a sintered metal air filter.

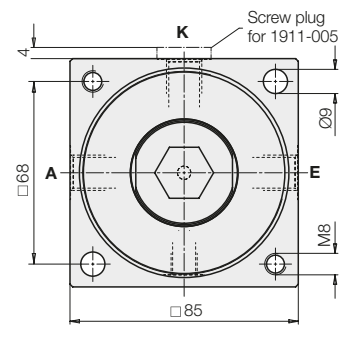
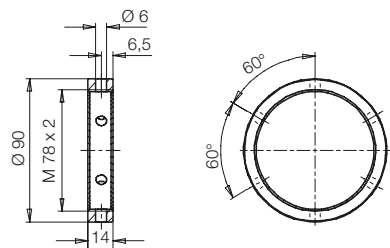
Important notes!

If there is any danger of fluids being sucked into the filter, a vent hose has to be connected. The contact bolt must only be removed if it is replaced by another contact bolt with 12 mm thread length. Spring force should not be used to lift workpieces. Contact bolts and extensions with large weight can influence the function of this component. Work supports are not suitable to compensate side loads. Work supports must only be operated with a sealed contact bolt. In dry machining applications, with minimum quantity lubrication or in case of accumulation of very small swarf, there can be a swarf holdup in the area of the metallic wiper edge. Remedy: Regular cleaning. Operating conditions, tolerances and other data see data sheet A 0.100.



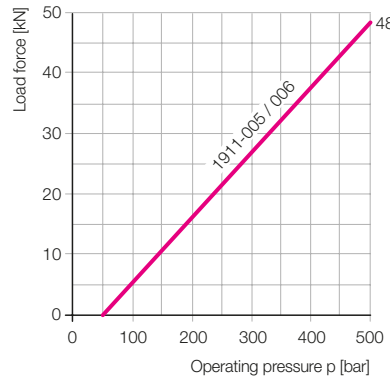
Accessory

Capstan nut	3522-007
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Bolt Ø:	[mm]	40
Stroke	[mm]	18 ^{+0.7} / _{-0.6}
Adm. load force	100 bar [kN]	5
	500 bar [kN]	48
Plunger contact force	[N]	50-100
Min. oil pressure	[bar]	100
Oil volume/stroke	[cm ³]	2
Max. flow rate	[cm ³ /s]	25
Weight	[kg]	4.1

Admissible load F as a function of the operating pressure p



Max. elastic deformations s as a function of support force F

