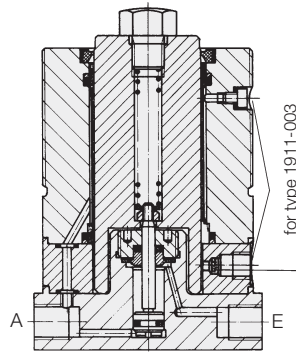


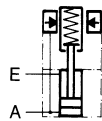
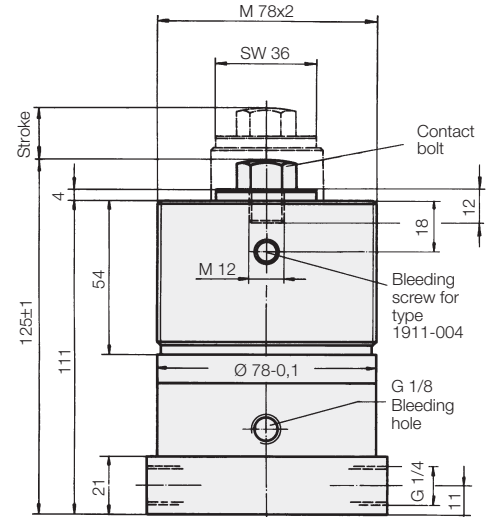


Work Supports

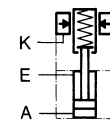
extending hydraulically – contact by spring force
double acting, max. operating pressure 500 bar



Sintered metal air filter
Connection for ventilation hose ND 6
by hose fitting 3300-921



A = Extending
+ locking
E = Retracting



A = Extending
E = Retracting
K = Locking

Part-no.	
1911-003	1911-004

Teflon wiper
for high loads
available on request

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 1911-004 it is possible to effect locking separately through port “K”.

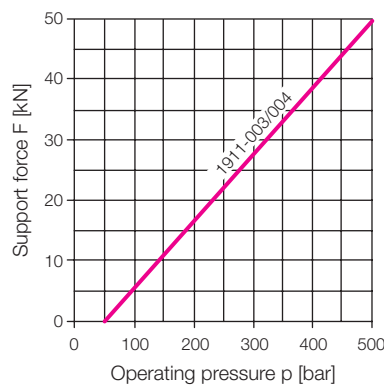
Important notes

The internal part of the work support is protected against dust and swarf by a sintered metal air filter. If there is any danger of fluids being sucked into the filter, a vent hose has to be connected and laid it in a safe place. The contact bolt must only be removed if it is replaced by another contact bolt with 12 mm thread length. Operating conditions, tolerances and other data see data sheet A 0.100.

Important note

Spring force should not be used to lift work-pieces. Contact bolts and extensions with large weight can influence the functions of this component.

Admissible load F as function of the operating pressure p



Plunger Ø	[mm]	40
Plunger stroke	[mm]	18 ±1
Adm. support force	100 bar [kN]	5
	500 bar [kN]	48
Plunger contact force	[N]	50–100
Min. oil pressure	[bar]	100
Oil for full stroke	[cm³]	2
Max. oil flow rate	[cm³/s]	25
Weight	[kg]	4.1

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

