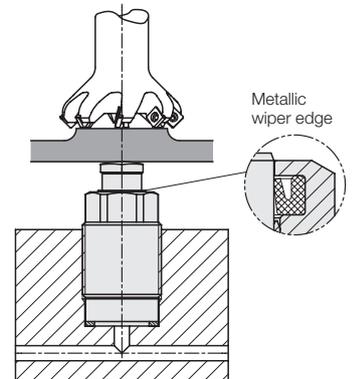


Threaded-Body Work Support M 26 x 1.5, with metallic wiper edge, single acting, max. operating pressure 350 bar



Advantages

- Minimum dimensions
- Space-saving threaded-body version
- Contact force by spring
- Load force up to 4 kN
- Metallic wiper edge and FKM wiper
- Contact bolts sealed
- Corrosion-resistant interior parts



Application

Hydraulic work supports are used to provide a self-adjusting rest for the workpiece during the machining operations. They compensate the workpiece surface irregularities, also vibration and deflection under machining loads.

The threaded-body design allows for space-saving and direct installation into the fixture body. Oil supply is made through drilled channels.

Description

In the body of the threaded-body work support a thin-walled locking bush is integrated, which locks cylindrically around the freely-movable support plunger when pressurising the element with hydraulic oil.

The support plunger is retracted in off-position and is extended by a hydraulically-pressurised small piston and contacts the workpiece with spring force. The support plunger will be locked by the increasing hydraulic pressure and can compensate forces in axis direction.

The elements are protected against penetration of swarf by a metallic wiper edge and sealed against liquids.

Important notes!

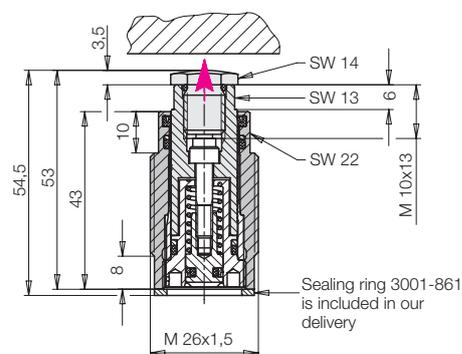
Work supports are not suitable to compensate side loads. The support plunger must not be stressed by tensile load.

The admissible load force is valid for static or dynamic load. Machining forces can generate vibrations, whose amplitude exceeds far an average value, and this can cause yielding of the support plunger. Remedy: increase the safety factor or the number of work supports. In case of accumulation of very small grinding swarf there can be a swarf holdup in the area of the metallic wiper edge.

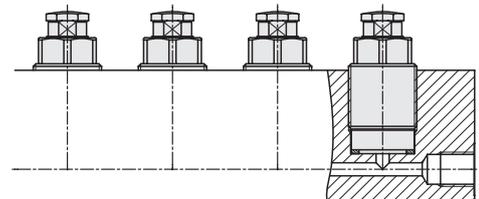
Remedy: regular cleaning in this area. Work supports must only be operated with a sealed contact bolt. For special versions of contact bolts, we can provide you with a drawing showing the interior contour.

Operating conditions, tolerances and other data see data sheet A 0.100.

Part-no. 1942-900



Installation and connecting possibilities Drilled channels

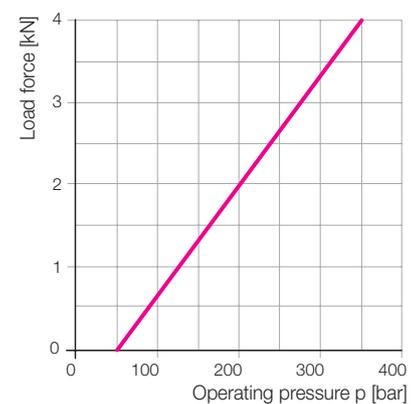


Technical characteristics

Support plunger-Ø	[mm]	16
Stroke	[mm]	6.5
Required oil per stroke	[cm ³]	0.42
Admissible flow rate*	[cm ³ /s]	25
Spring force min./max.	[N]	15/25
Recommended minimum pressure	[bar]	100
Elastic deformation with load and 500 bar	[µm/kN]	3
max. operating temperature	[°C]	80
Seating torque	[Nm]	50
Weight, approx.	[kg]	0.18

* If required insert sharp-edged orifice
Ø 0.5 mm in sealing ring Part-no. 3420-395

Admissible load force F as a function of the operating pressure p



Porting details

