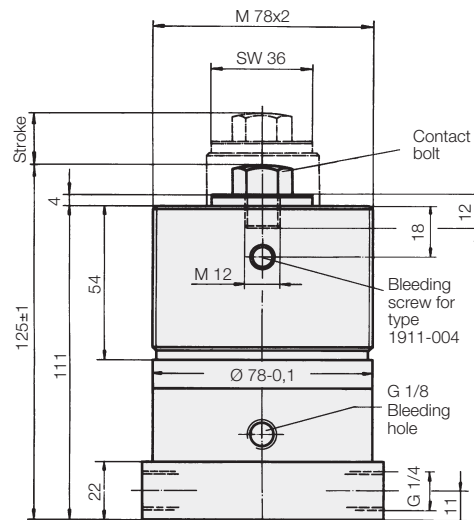
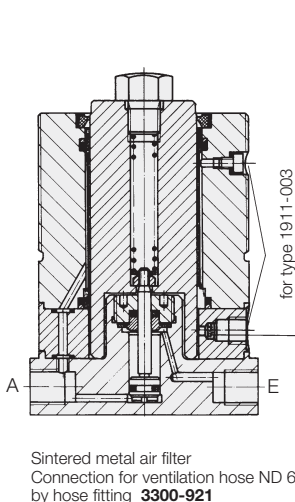




Work Supports

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 when the return flow has to be effected cycle-dependent 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 automatically retracts to the off-position after the pressure supply has been transferred to port “E”.

If the admissible flow rate is exceeded the plunger will be locked before contacting 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.

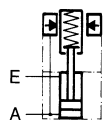
The contact bolt must only be removed if it is replaced by another contact bolt with 12 mm thread length.

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

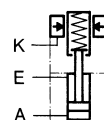
Work supports are not suitable to compensate side loads.

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

It is absolutely necessary to follow the instructions for venting of the spring area on data sheet A 0.110.



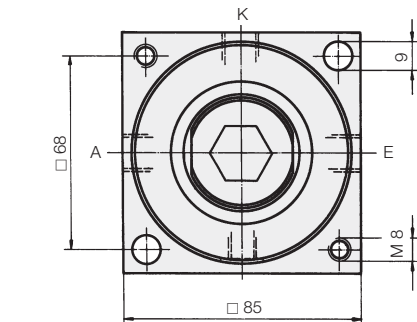
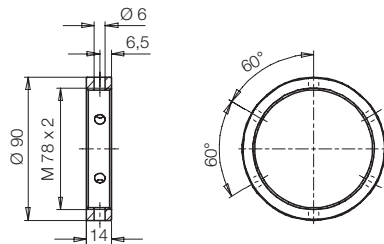
A = Extending + locking
E = Retracting



A = Extending
E = Retracting
K = Locking

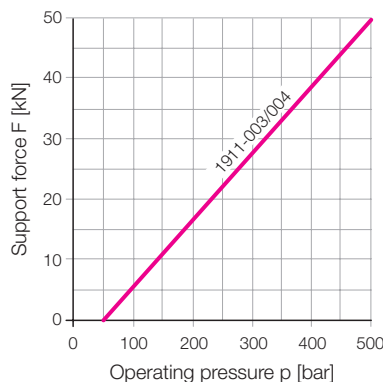
Part-no.	Part-no.
1911-003	1911-004

Accessory
Capstan nut
Part-no. **3522-007**



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	[cm ³]	2
Max. oil flow rate	[cm ³ /s]	25
Weight	[kg]	4.1

Admissible load F as function of the operating pressure p



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

