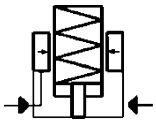
No. 6964H

CAD

Support Element, base-flange-mounting

Normally retracted. Hydraulic advanced. Spring force for contact, max. operating pressure 350 bar, min. operating pressure 50 bar.



Order no.	Article no.	Contact force F1 [N]	Support force at 350 bar [kN]	Stroke C [mm]	Q max. [l/min]	Vol. [cm³]	Weight [g]
66746	6964H-11-2	13,5-44,5	11	6,5	2,13	3,0	845
325878	6964H-17-3	26,5 - 53,5	17	12,5	2,13	10,5	1920

Design:

Cylinder body from steel, hardened. Support pin with internal thread case hardened and ground. Wiper to protect against dirt and cooling water. Internal parts from stainless steel. Oil supply via threaded port.

Application:

The support element is used as an extra support to prevent sagging and vibration of a workpiece.

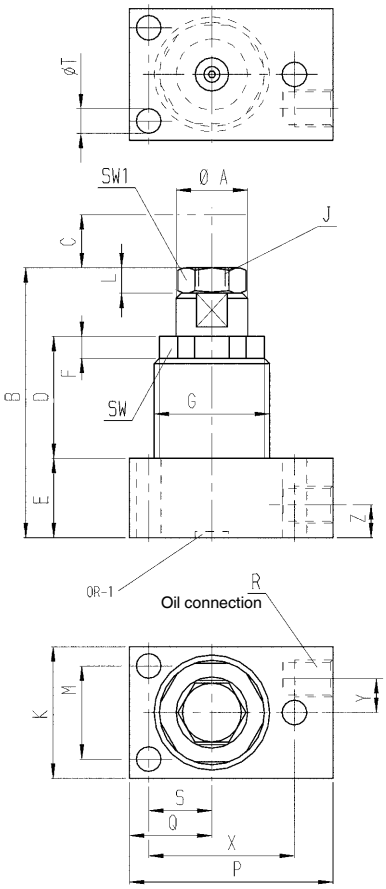
Features:

Element with high load capacity and low height. Hydraulic and spring: the plunger is normally retracted. When pressure is applied, the support pin advances with a weak spring-applied force to contact the workpiece. The spring force varies with the stroke. As the hydraulic pressure rises, the support plunger is hydraulically clamped. When the pressure is released, the support plunger returns to the retracted position. Very high repeatability ensures optimum production quality.

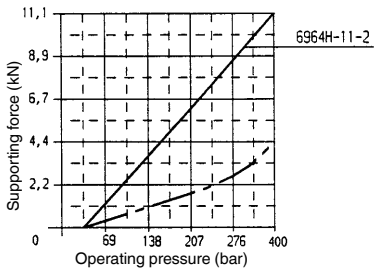
Note:

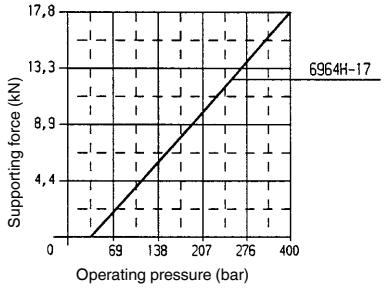
Support pin must be protected against the entry of dirt and splash water by fitting a set screw or plug. When placing into operation, ensure that all air is bled from the system. Failure to do so can cause destruction of the clamping element by the escaping diesel effect.

The supporting force should be matched to the clamping force in order to absorb machining forces.
The supporting force should always be at least twice as high as the clamping force.



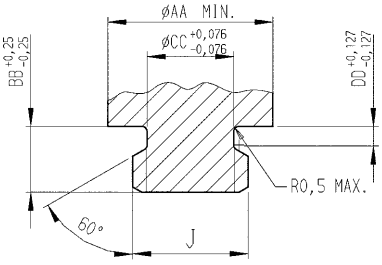
Diagrams:

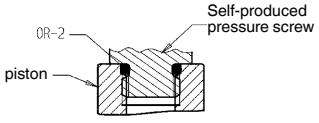




0,004 mm/kN elastic change in length under load

Production dimensions with self-production of the clamping screw for support element:





Dimensions:

Order no.	Article no.	dia. A	B	D	E	F	G	SW	SW1	J x depth	K	L	M	P	Q	R	S	dia. T	X	Y	Z	ØAA	BB	dia. CC	DD	OR-1 O-ring Order No.	OR-2 O-ring Order No.
66746	6964H-11-2	20,5	82,5	34	31,5	9,0	M35x1,5	30	19	M12x6,5	41,5	5	30,2	58,5	24,0	G1/8	18,3	7,1	43,1	10,5	10,5	14,1	6,35	9,91	1,78	330803	335422
325878	6964H-17-3	38,0	82,5	40	25,0	12,5	M60x1,5	54	19	M12x6,5	73,0	5	52,4	81,0	36,5	G1/8	26,2	7,1	62,6	16,0	10,5	14,1	6,35	9,91	1,78	330803	335422

Subject to technical alterations.