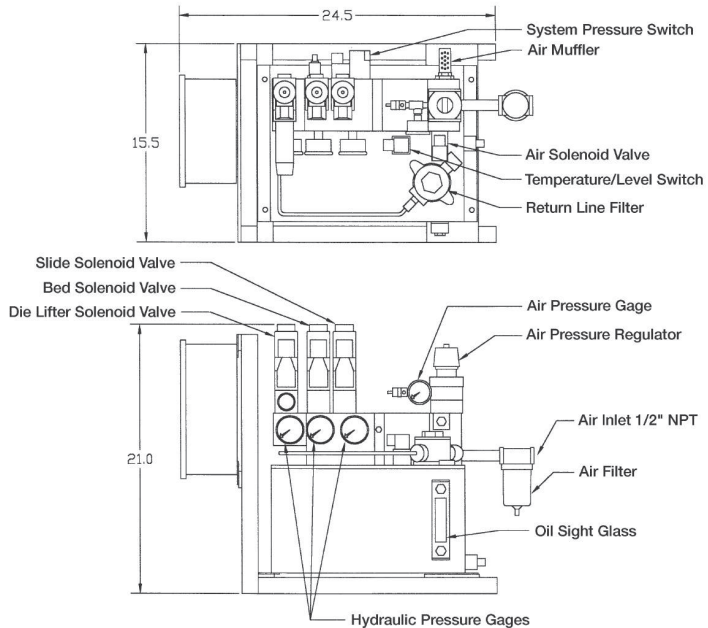




Air/oil power unit modular power unit with solenoid valves



Application:

These air powered hydraulic units have been developed for the mid-sized to large hydraulic die clamp and lift systems.

Description:

The power units with safety circuits have been developed in view of the special requirements of hydraulic die clamping on presses. The pumps are supplied complete with required valves, pressure switches and electrical controls ready for connections to the press.

The pumps are assembled from standard modular components. This provides a selection of the proper combination of hydraulic and electrical controls for most die clamping applications.

The die lifter circuit provides an adjustable pressure reducer with circuit relief and a return line check valve. This keeps the die lifters that are not under the die up during stamping.

Power unit comes complete in a protective frame with a remote pendant with key switches.

Special power units available on request.

Separate clamp circuit pressure switches on request.

Advantages:

- ◆ fast clamp/unclamp times
- ◆ pressure filter
- ◆ return line filter
- ◆ temp/level switch
- ◆ system pressure switch

Technical data

Hydraulic			
Max. clamping pressure	psi		5,800
Flow rate (average)	(cu in/min)		220
Reservoir capacity	gal		5
Reservoir usable capacity	(cu/in)		847
Pressure filter	micron		25
Suction strainer	micron		175
Return line filter	micron		10
air/oil ratio, stage 1			20:1
air/oil ratio, stage 2			75:1
Air requirement		80 psi, 1/2" NPT inlet	
Clamp output ports			#6 SAE
Die lifter output port			#4 SAE

Solenoid data			
Voltage	VAC		110
Current	Amps		0.2
Duty cycle		continuous	

Pressure Switch data			
Adjustable pressure settings	psi		750 to 5,800
Average pressure differential			
at 1,450 psi	psi		350 ± 73
at 7,250 psi	psi		750 ± 116
Switch NO/NC			single pole
Contact rating	VAC		5A at 250
	VDC		3A at 30

Part No.	Clamp Circuits	Die Lifter Circuit		Pendant Key Switches
		Reduced Pressure 400-2, 175-PSI	System Pressure 5,800 PSI max	
HCR-PA-51510	1			1
HCR-PA-51511	1	1		2
HCR-PA-51511-H	1		1	2
HCR-PA-51520	2			2
HCR-PA-51521	2	1		3
HCR-PA-51521-H	2		1	3

* Add -1 to end of part number to order without pendant station.

* 24 VDC solenoid voltage upon request.

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modular power unit with
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