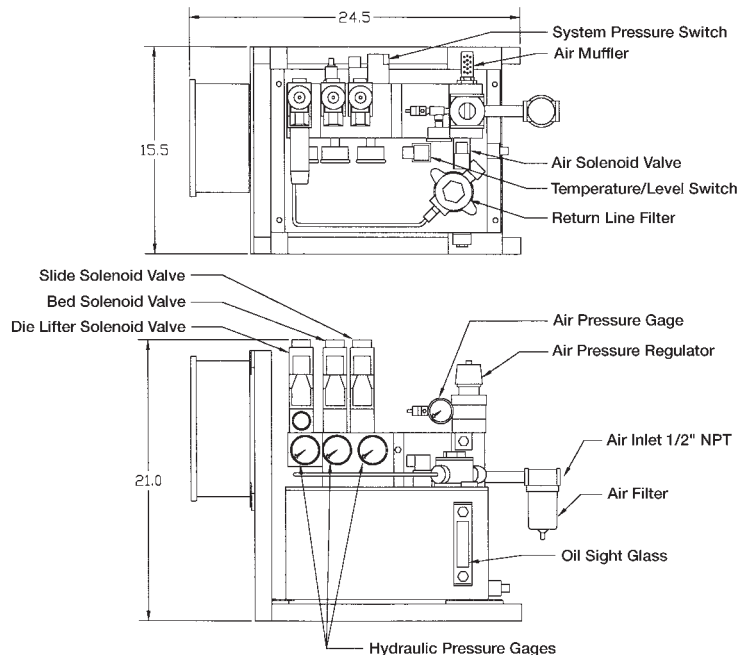


Air/Oil Power Unit

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 to keep the die lifters 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 (Avg)	(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
Output Ports		#6 SAE

Solenoid data

Voltage	VAC	110
Current	Amps	0.2
Duty cycle	continuous	

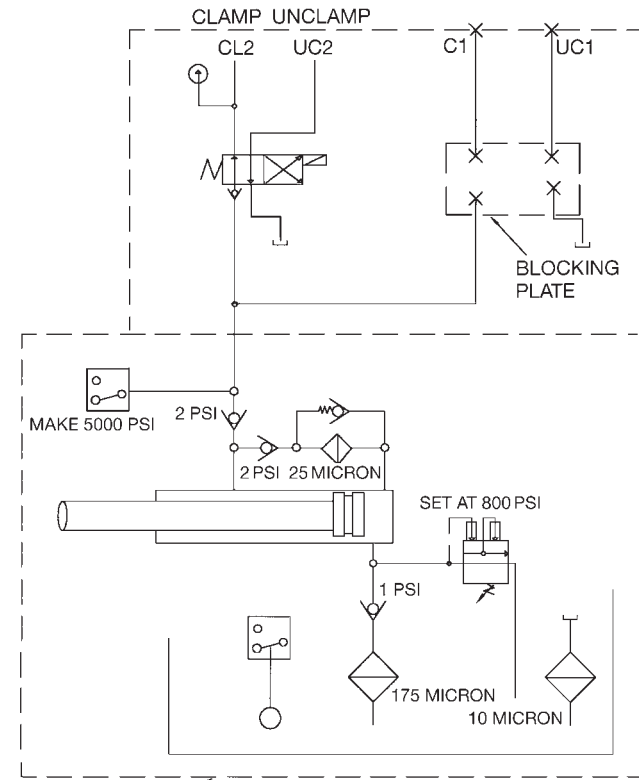
Pressure Switch data

Adjustable pressure setting	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

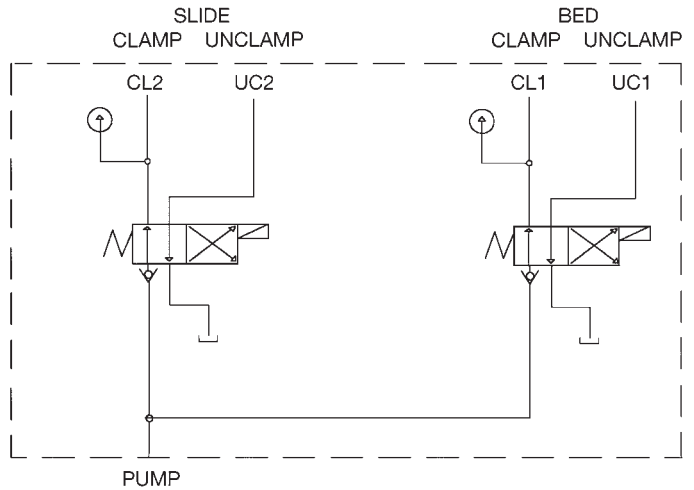
PART NO.	CLAMP CIRCUITS	DIE LIFTER CIRCUIT		PENDANT KEY SWITCHES
		Reduced Pressure 400-2175-PSI	System Pressure 5800 PSI MAX	
HCR-PA-51510	1			1
HCR-PA-51511	1	1		2
HCR-PA-51511-H	1		1	2
HCR-PA-51520	2			2
HCR-PA-51521	2	1		3
HCR-PA-51521-H	2		1	3

* Add 1 to part number to order without pendant station.

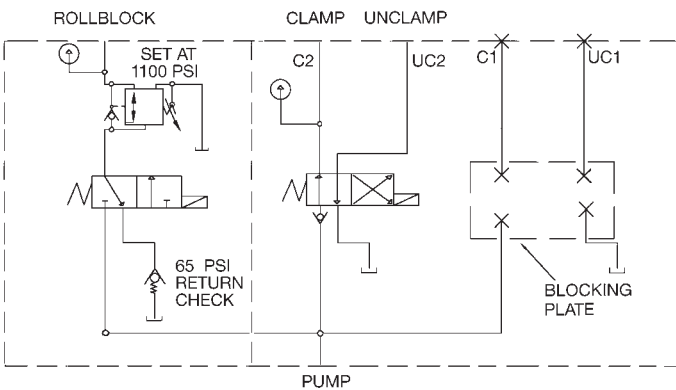
Subject to change without notice



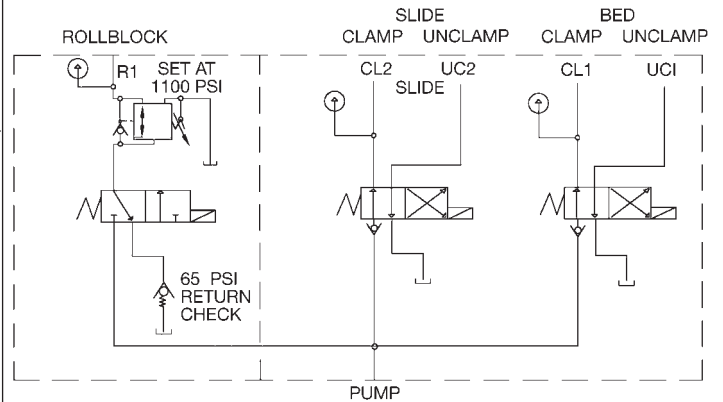
PUMP TYPICAL **HCR-PA-51510**



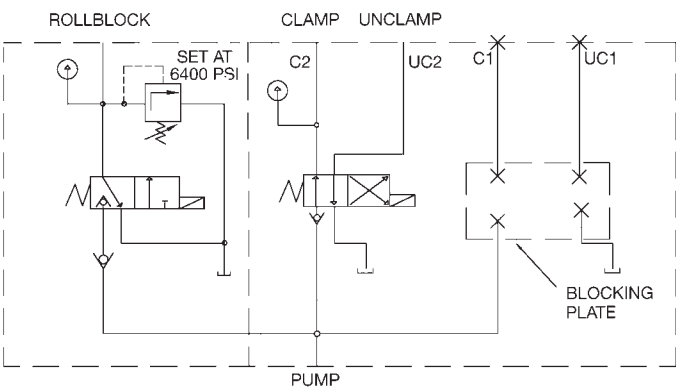
HCR-PA-51520



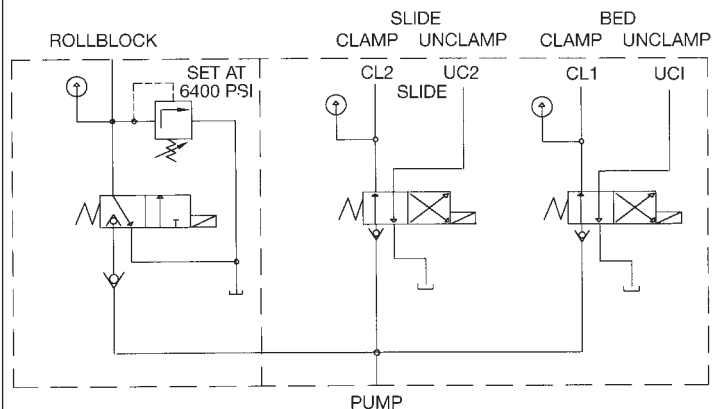
HCR-PA-51511



HCR-PA-51521



HCR-PA-51511-H



HCR-PA-51521-H