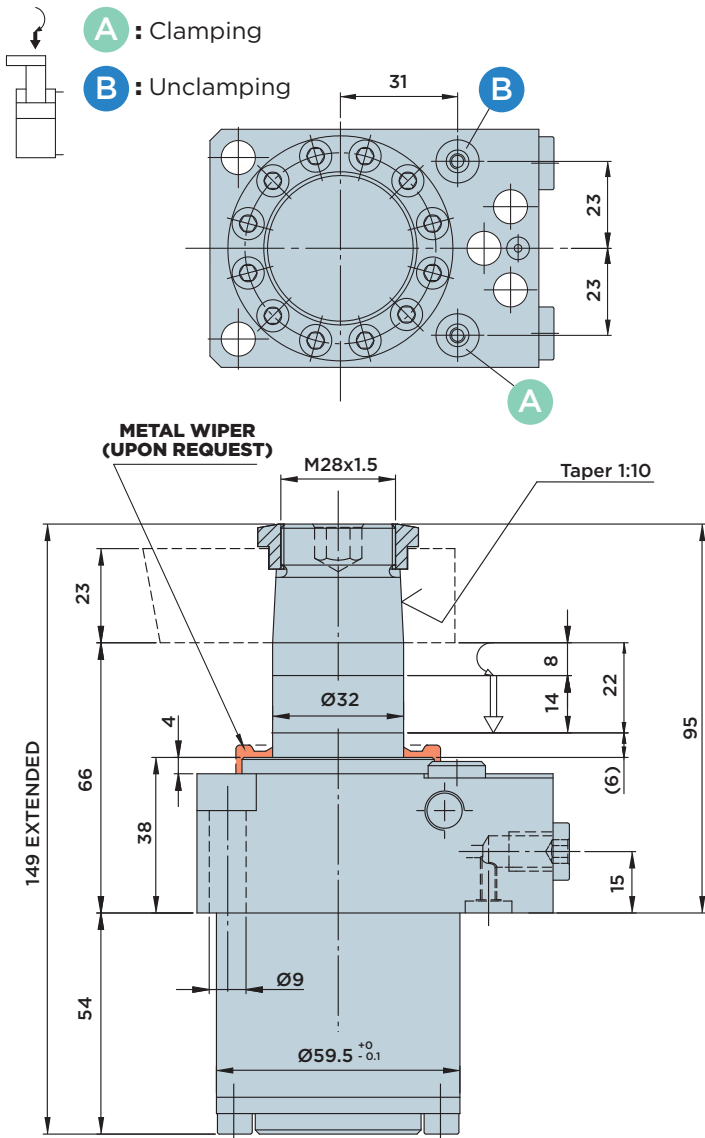


SR32.22 FD

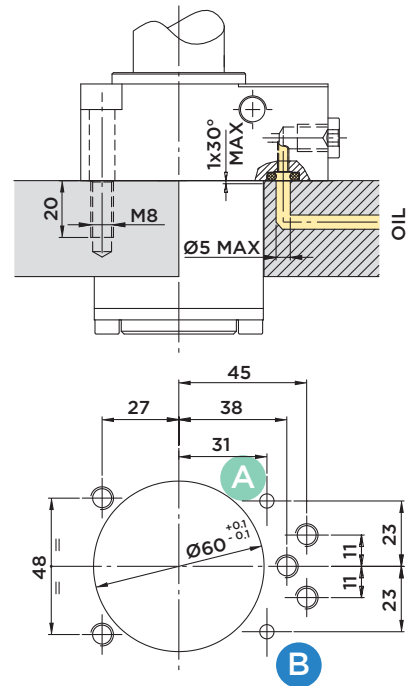


DOUBLE-ACTING SWING CLAMP CYLINDER WITH **UPPER FLANGE**

MAX. OPERATING PRESSURE = 500BAR



INSTALLATION DIMENSIONS WITH O-RING CONNECTION



Included in the scope of supply:

- Mounting screws M8x40 DIN 912/12.9 grade
- O-Rings Ø4.34x3.53

Material:

- Piston/rod: Case-hardened steel, ground
- Body: Free machining steel, nitrocarburized

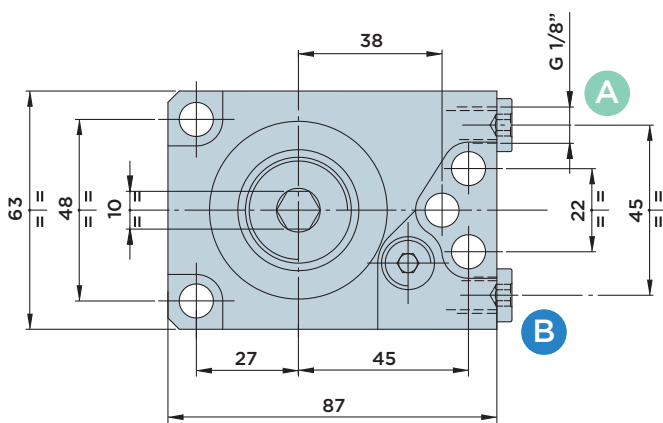
Cylinder with COMPENSATION SYSTEM

Note:

Order code, see page 38

Clamp arms, see page 149

Clamping force diagram, see page 148



	STROKE mm	EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
		CLAMP.	UNCLAMP.	CLAMP.	UNCLAMP.
TOTAL	22	4.52	12.56	10	27.6
SWINGING	8				
CLAMPING	14				



HYDROBLOCK

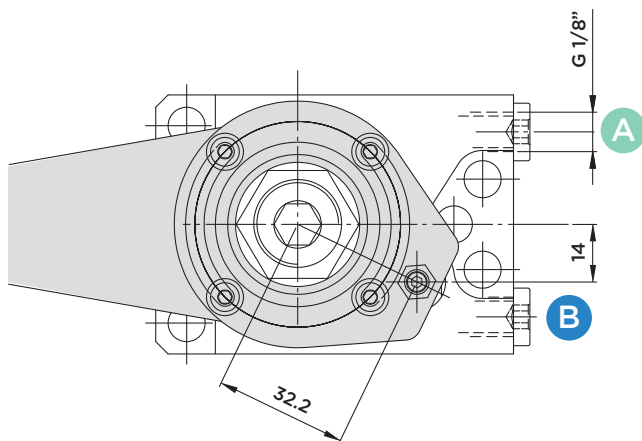
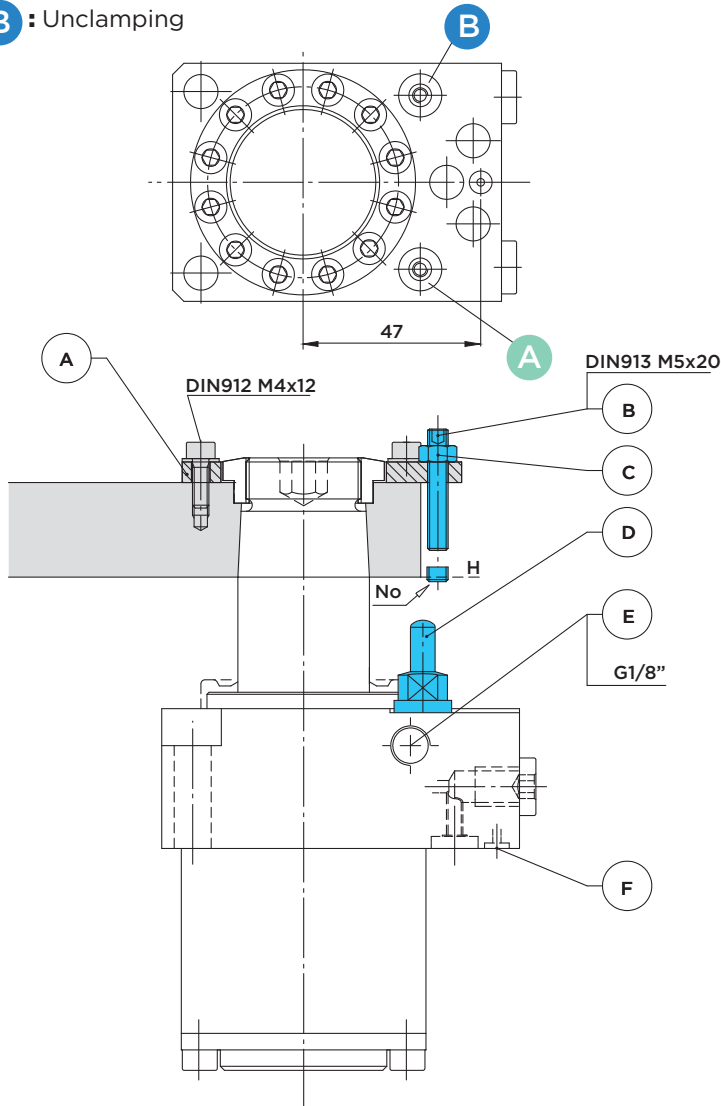
SR32.22 FDV



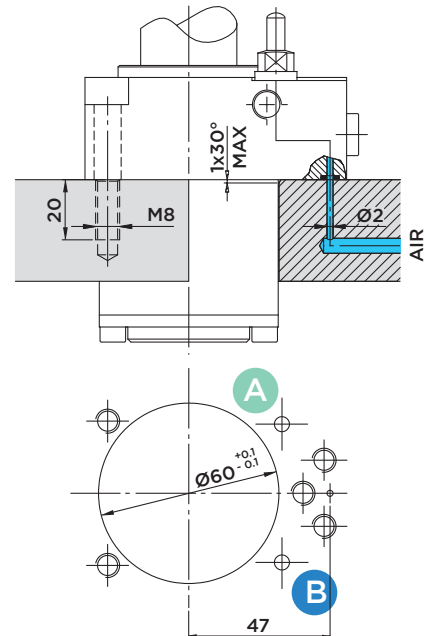
DOUBLE-ACTING SWING CLAMP CYLINDER WITH **UPPER FLANGE**
AND **CLAMP ARM POSITION CONTROL VALVE**

A : Clamping

B : Unclamping



INSTALLATION DIMENSIONS WITH O-RING CONNECTION



Included in the scope of supply:

- O-Rings Ø2.90x1.78

Valve adjustment:

To adjust the clamp arm position control valve, please proceed as follows:

- 1) Pressurize the cylinder to move the clamping arm into clamping position.
- 2) Adjust the plate (A) to the exact radial position to ensure that the set-screw (B) is in line with the valve.
- 3) Supply the circuit with air at 1÷6 bar through the port (F). The valve bolt (D) is completely extended and air escapes from the bore (E).
- 4) Screw in the set-screw (B) with the workpiece being clamped until the air flow is interrupted. Then tighten the screw by another 2÷4 rotations (*) and lock the screw by means of the nut (C). The pressure switch indicates that the pneumatic circuit is closed and enables the machine cycle start.

* (The additional 2÷4 rotations are required to compensate thickness variations caused by rough surfaces.)

Note: After the adjustment, the tip of the set-screw (B) must not project beyond the lower end of the clamp arm (level H).



HYDROBLOCK

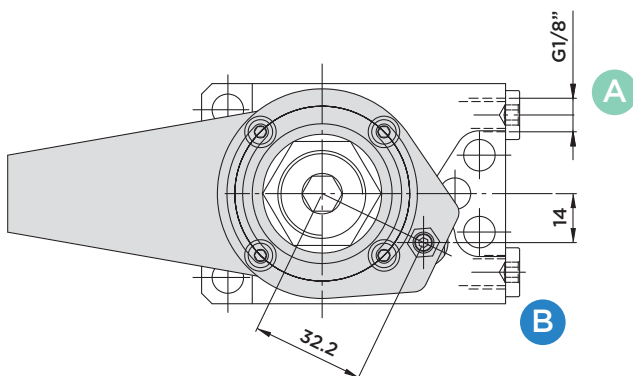
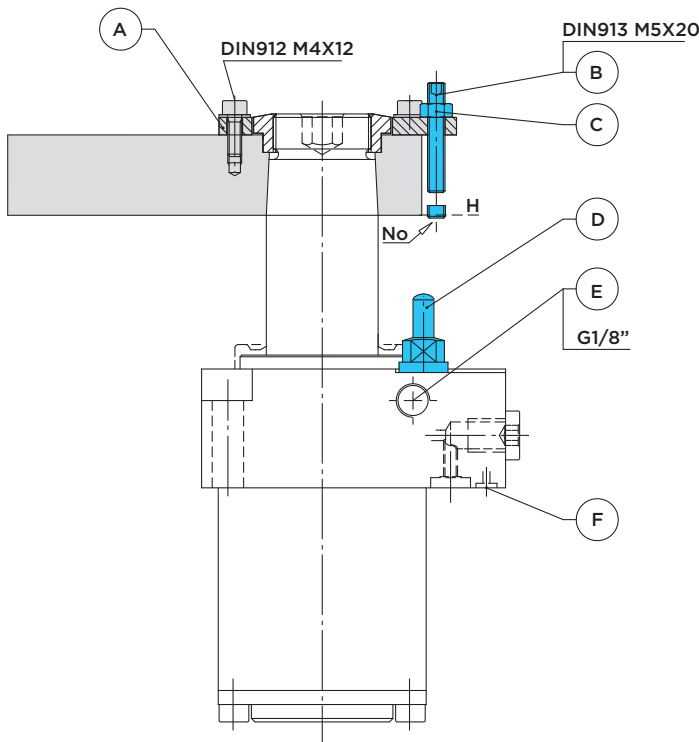
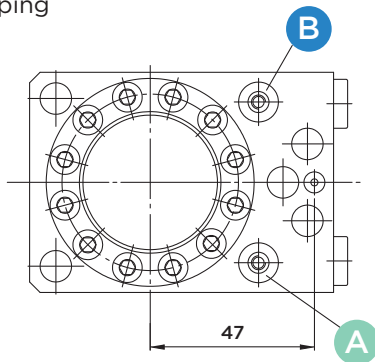
SR32.35 FDV



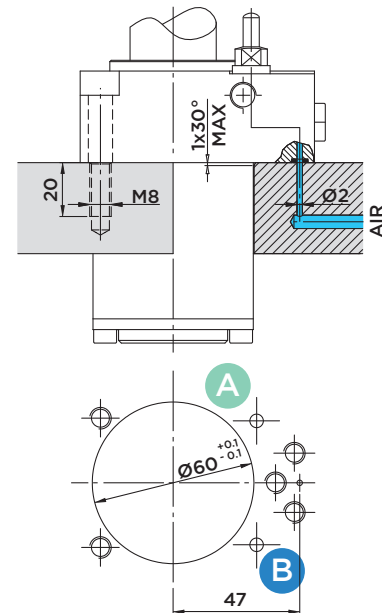
DOUBLE-ACTING SWING CLAMP CYLINDER WITH **UPPER FLANGE**
AND **CLAMP ARM POSITION CONTROL VALVE**

A : Clamping

B : Unclamping



INSTALLATION DIMENSIONS WITH O-RING CONNECTION



Included in the scope of supply:

- O-Rings Ø2.90x1.78

Valve adjustment:

To adjust the clamp arm position control valve, please proceed as follows:

- 1) Pressurize the cylinder to move the clamping arm into clamping position.
- 2) Adjust the plate (A) to the exact radial position to ensure that the set-screw (B) is in line with the valve.
- 3) Supply the circuit with air at 1÷6 bar through the port (F). The valve bolt (D) is completely extended and air escapes from the bore (E).
- 4) Screw in the set-screw (B) with the workpiece being clamped until the air flow is interrupted. Then tighten the screw by another 2÷4 rotations (*) and lock the screw by means of the nut (C). The pressure switch indicates that the pneumatic circuit is closed and enables the machine cycle start.

* (The additional 2÷4 rotations are required to compensate thickness variations caused by rough surfaces.)

Note: After the adjustment, the tip of the set-screw (**B**) must not project beyond the lower end of the clamp arm (**level H**).

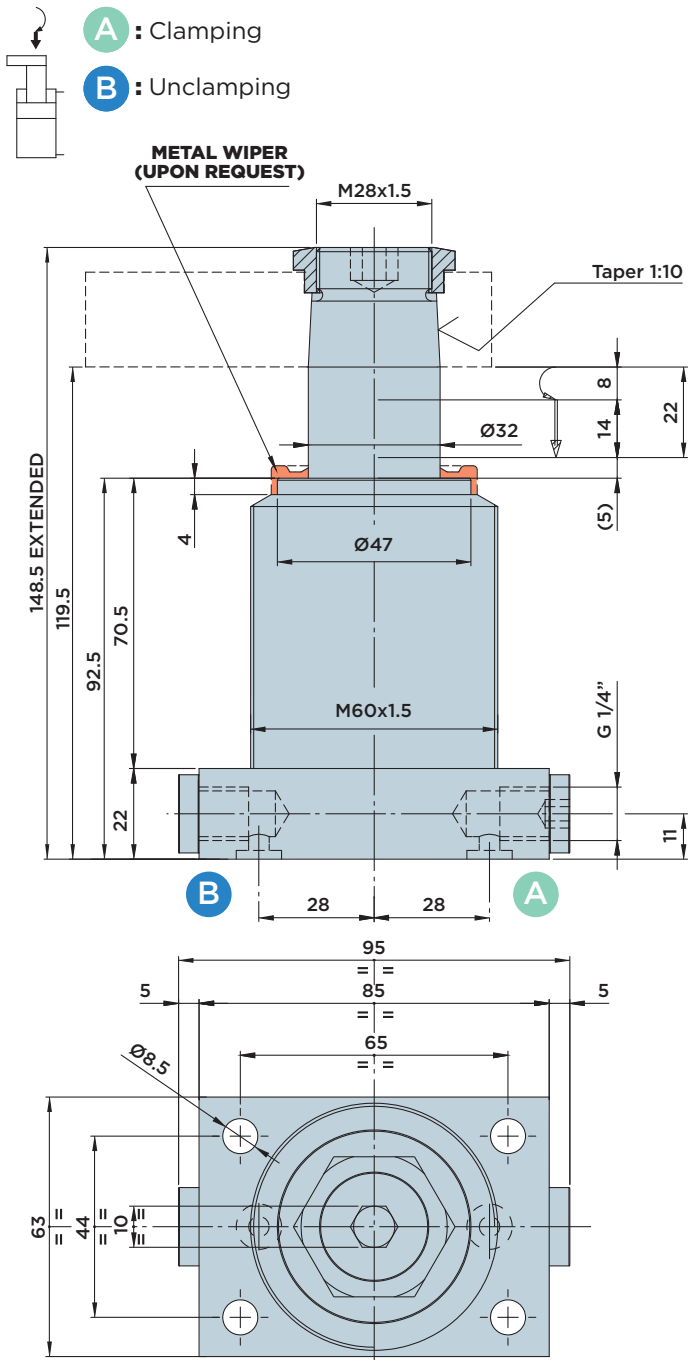


SR32.22 PD

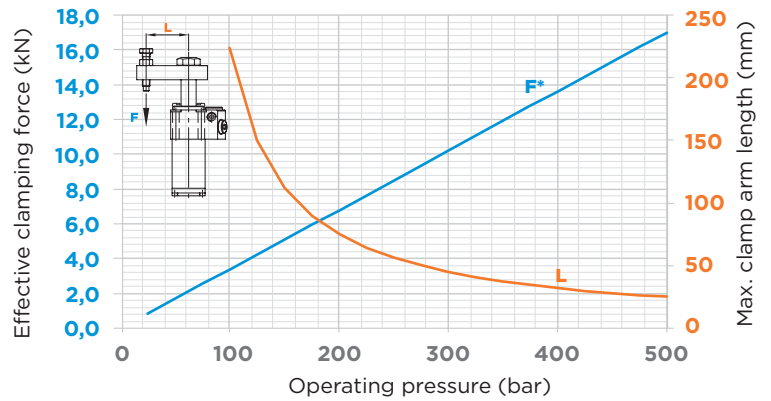
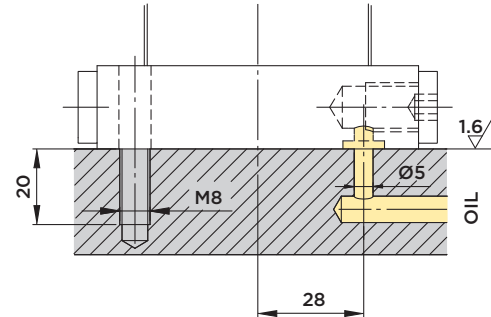


DOUBLE-ACTING SWING CLAMP CYLINDER WITH **LOWER FLANGE**

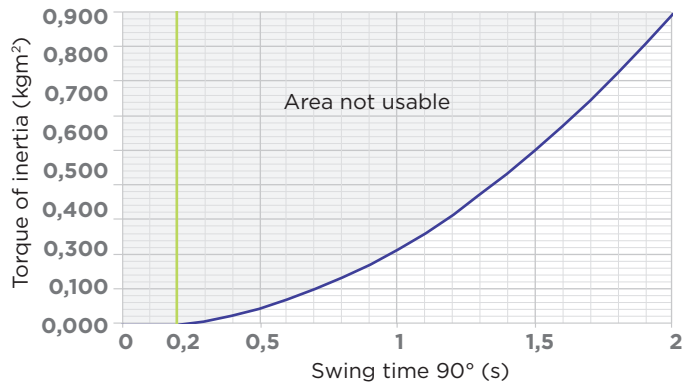
MAX. OPERATING PRESSURE = 500BAR



INSTALLATION DIMENSIONS SR32.22 PD / SR32.35 PD



* = The effective clamping force F in the above diagram was determined using the standard clamp arms of type O1 and O4.



NOTE: Please specify in your order whether the flange connections with O-ring (O at the end of the order no.) or the G1/4" ports (P at the end of the order no.) will be used. See page 38.

Included in the scope of supply:

- Mounting screws M8x35 DIN 912/12.9 grade
- O-Rings Ø6.02x2.62

	STROKE mm	EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
		Cm ²		Cm ³	
TOTAL	22	CLAMP.	UNCLAMP.	CLAMP.	UNCLAMP.
SWINGING	8	4.52	12.56	10	27.6
CLAMPING	14				



HYDROBLOCK

SR32.35 PD

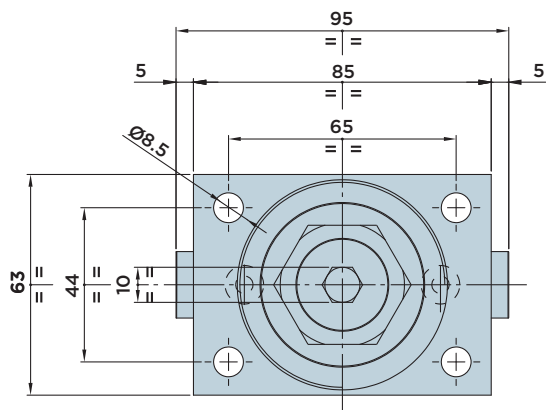
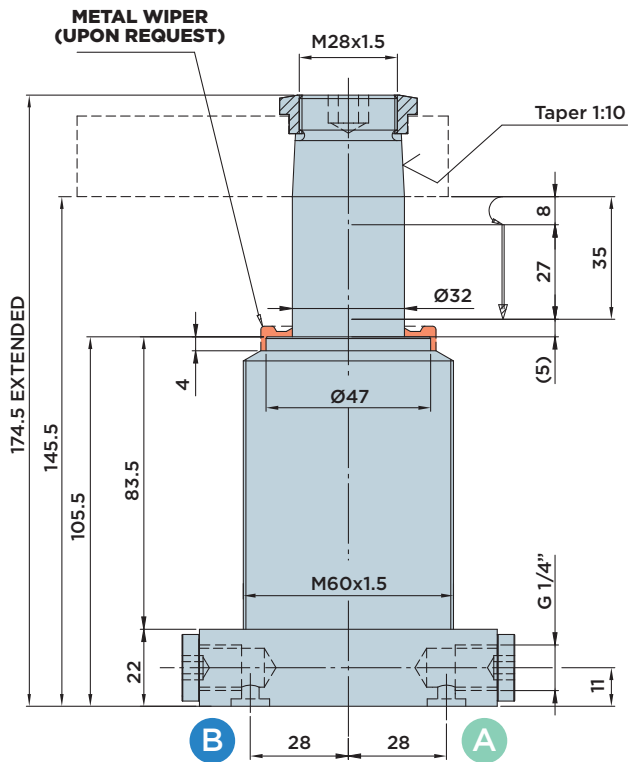


DOUBLE-ACTING SWING CLAMP CYLINDER WITH **LOWER FLANGE**

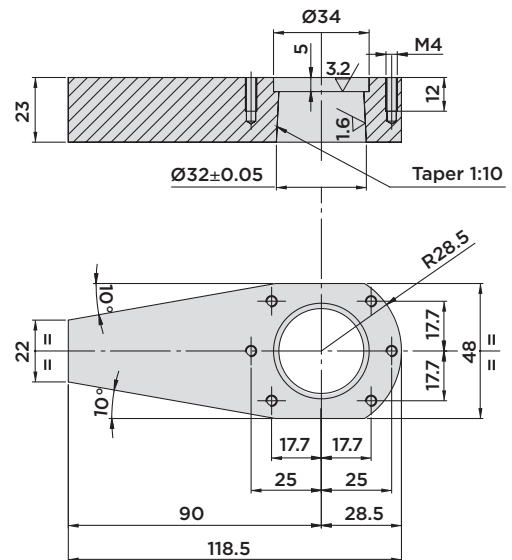
MAX. OPERATING PRESSURE = 500BAR

A : Clamping

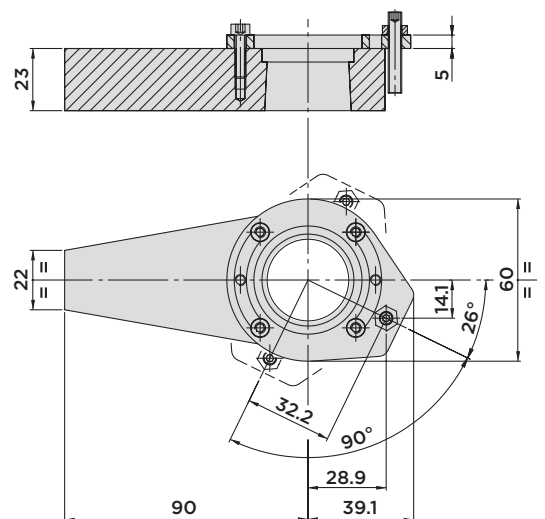
B : Unclamping



CLAMP ARM 01.32



CLAMP ARM 04.32



NOTE: Please specify in your order whether the flange connections with O-ring (O at the end of the order no.) or the G1/4" ports (P at the end of the order no.) will be used. See page 38.

Included in the scope of supply:

- Mounting screws M8x35 DIN 912/12.9 grade
- O-Rings Ø6.02x2.62

STROKE mm	EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
	Cm ²		Cm ³	
TOTAL	35		CLAMP.	UNCLAMP.
SWINGING	8			
		4.52	12.56	15.8
CLAMPING	27			44



HYDROBLOCK