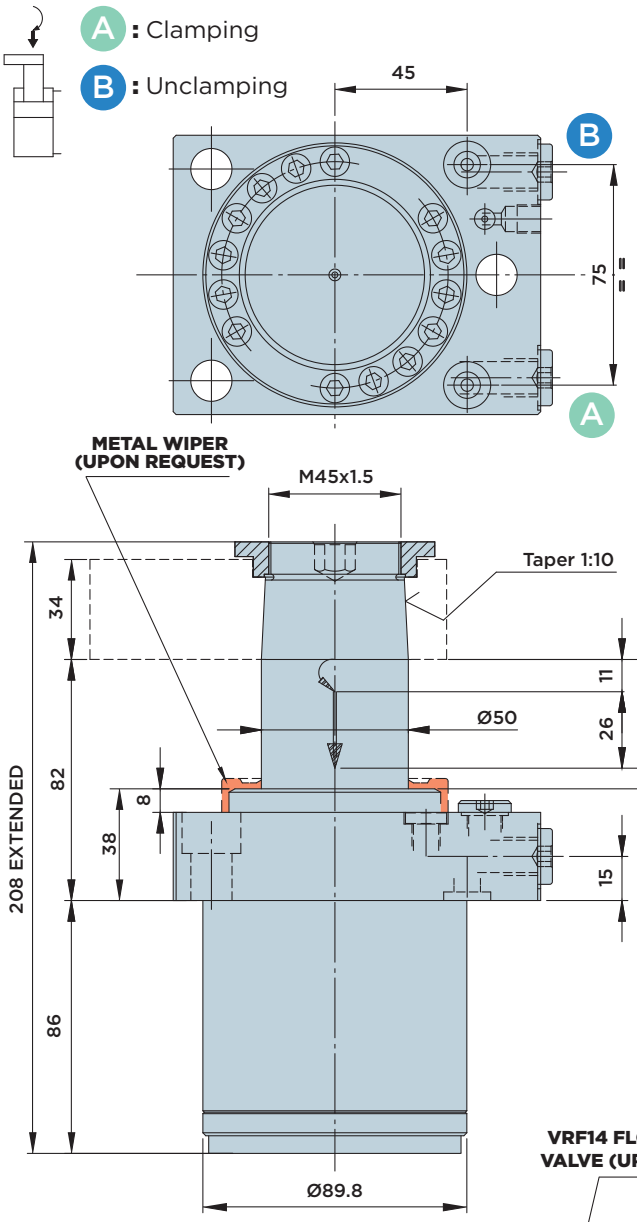
SR50.37 **FD**

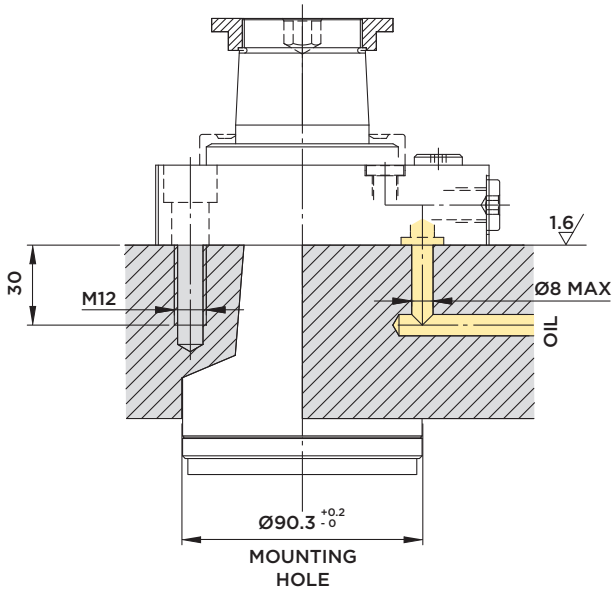
COMPENSATION SYSTEM

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 M12x35 DIN 912/12.9 grade
- O-Rings Ø10.78x2.62

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 155
Clamping force diagram, see page 154

STROKE mm		EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
		Cm²		Cm³	
TOTAL	37	CLAMP.	UNCLAMP.	CLAMP.	UNCLAMP.
SWINGING	11	11.54	31.17	42.7	115.3
CLAMPING	26				

SR50.37 **FDV**

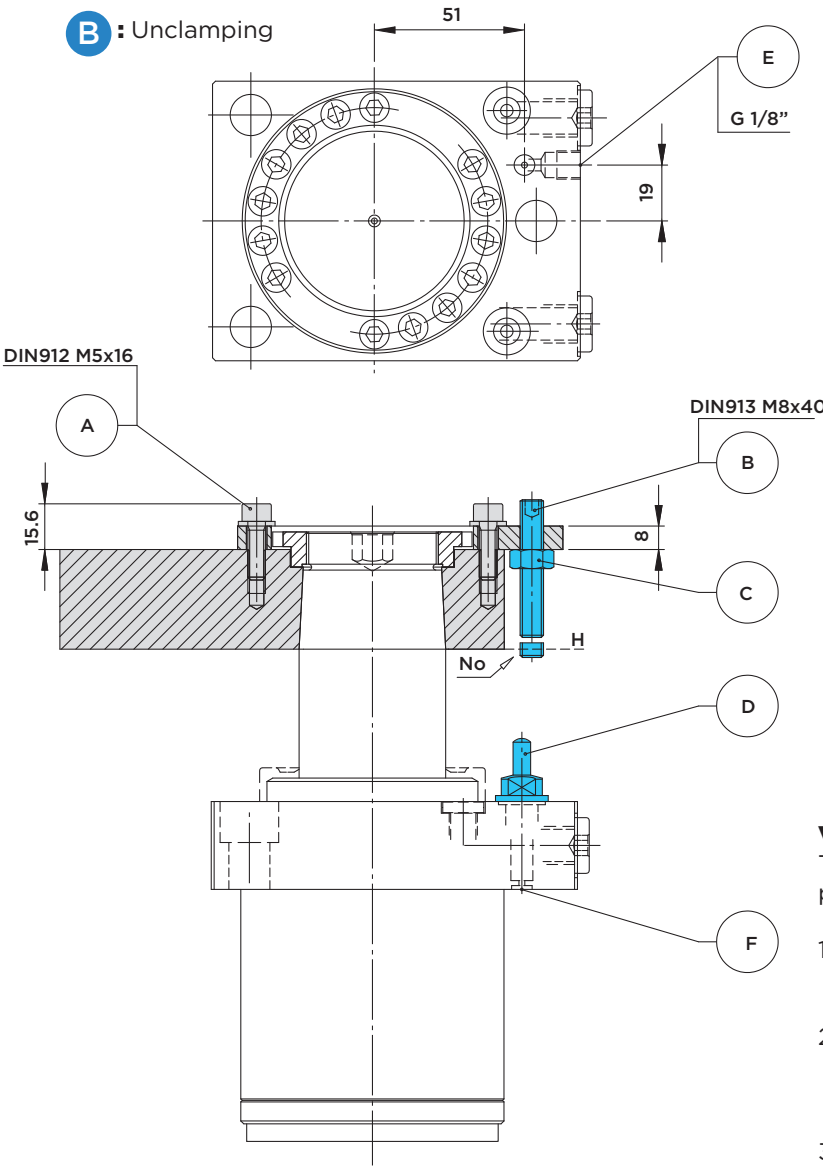
COMPENSATION SYSTEM

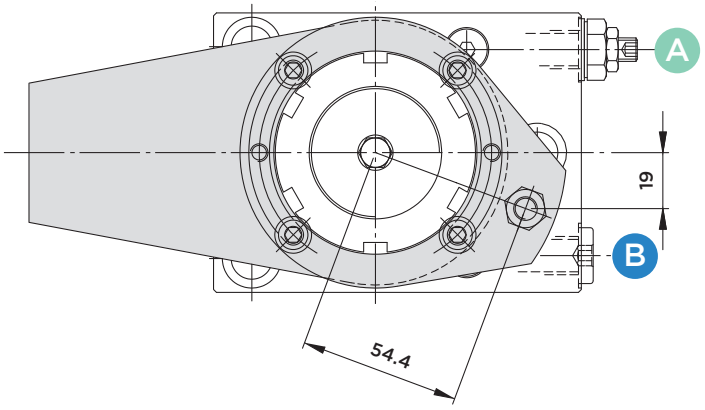
DOUBLE-ACTING SWING CLAMP CYLINDER WITH **UPPER FLANGE**

AND **CLAMP ARM POSITION CONTROL VALVE**

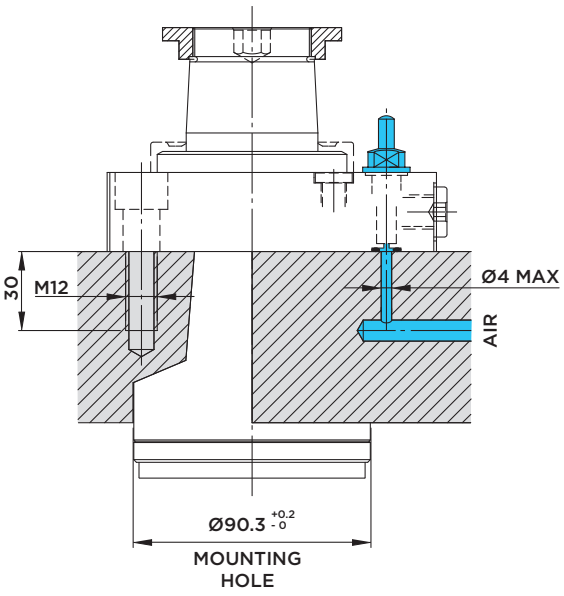
A : Clamping

B : Unclamping





INSTALLATION DIMENSIONS WITH O-RING CONNECTION



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.)

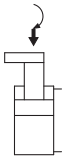
Note: After the adjustment, the tip of the set-screw **(B)** must not project beyond the lower end of the clamp arm **(level H).**

SR50.37 **PD**

COMPENSATION SYSTEM

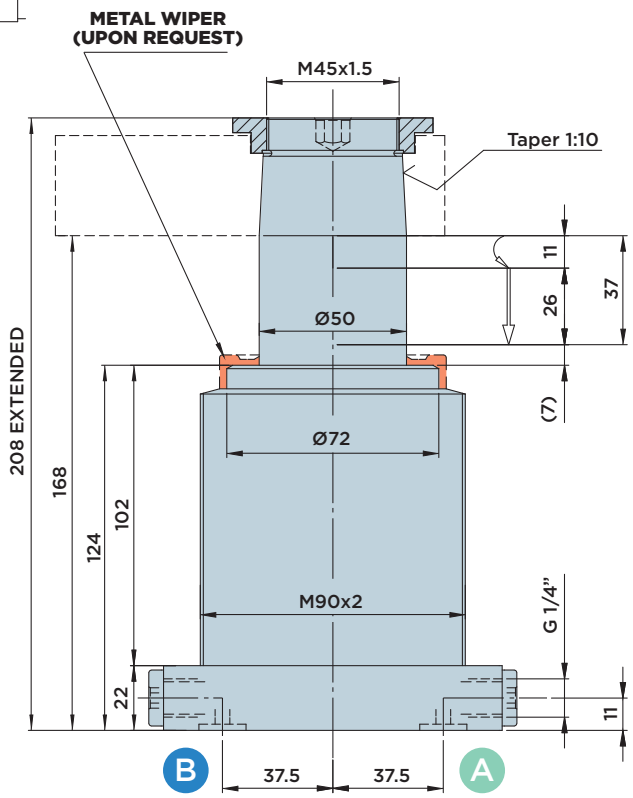
DOUBLE-ACTING SWING CLAMP CYLINDER WITH **LOWER FLANGE**

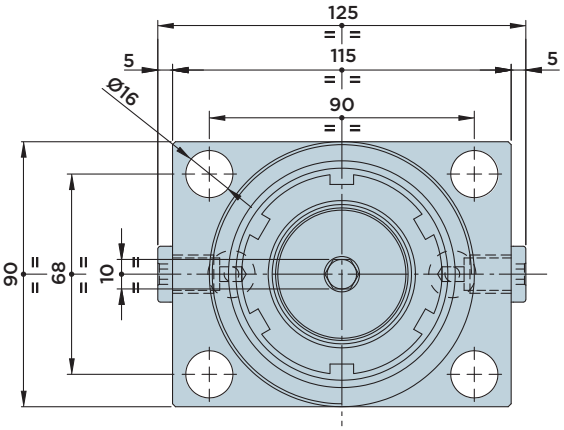
MAX. OPERATING PRESSURE = 500BAR



A : Clamping

B : Unclamping



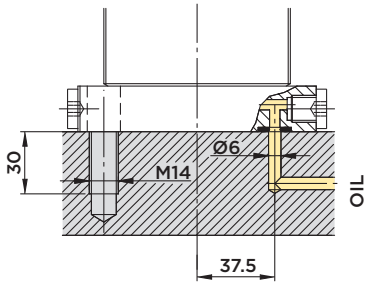


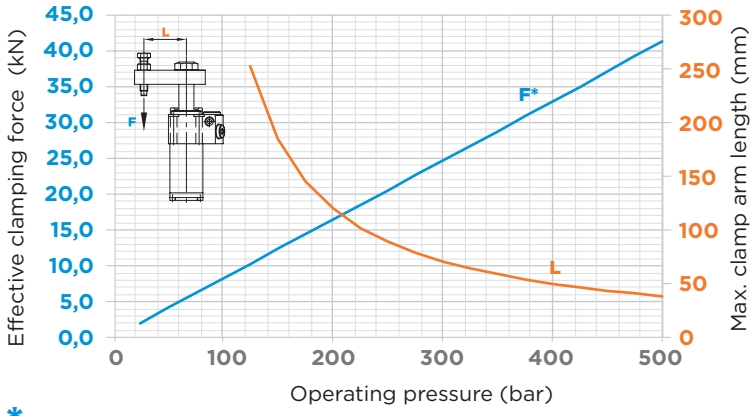
Cylinder with COMPENSATION SYSTEM

Included in the scope of supply:
- Mounting screws M14x50 DIN 912/12.9 grade
- O-Rings Ø10.78x2.62

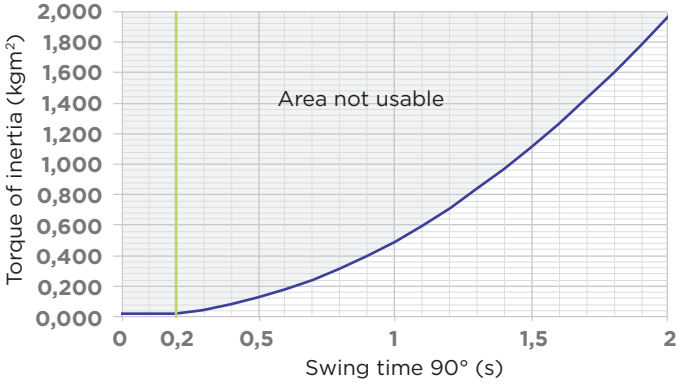
Note:
Order code, see page 38

INSTALLATION DIMENSIONS SR50.37 PD/ SR50.62 PD





* = The effective clamping force **F** in the above diagram was determined using the standard clamp arms of type 01 and 04.



STROKE mm		EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
		Cm²		Cm³	
TOTAL	37	CLAMP.	UNCLAMP.	CLAMP.	UNCLAMP.
SWINGING	11	11.54	31.17	42.7	115.3
CLAMPING	26				

SR50.62 **PD**

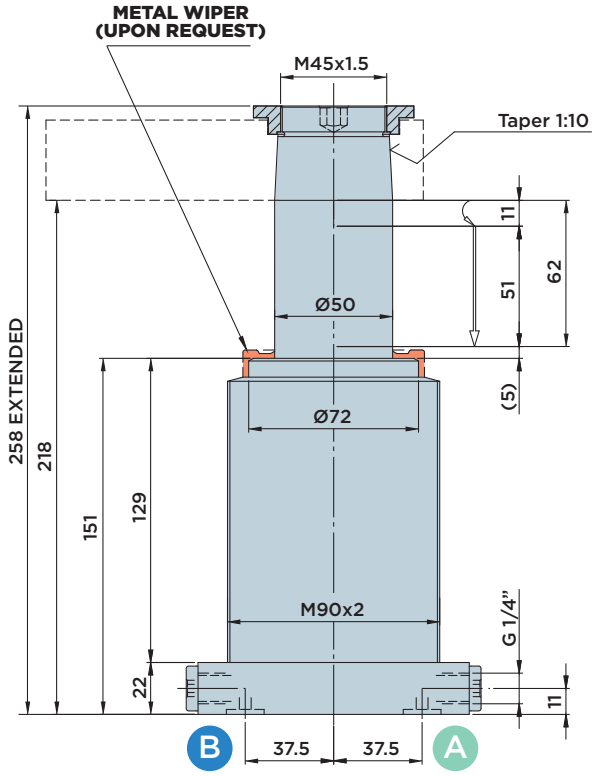
COMPENSATION SYSTEM

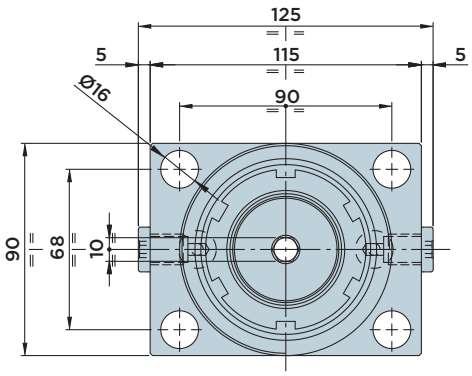
DOUBLE-ACTING SWING CLAMP CYLINDER WITH **LOWER FLANGE**

MAX. OPERATING PRESSURE = 500BAR

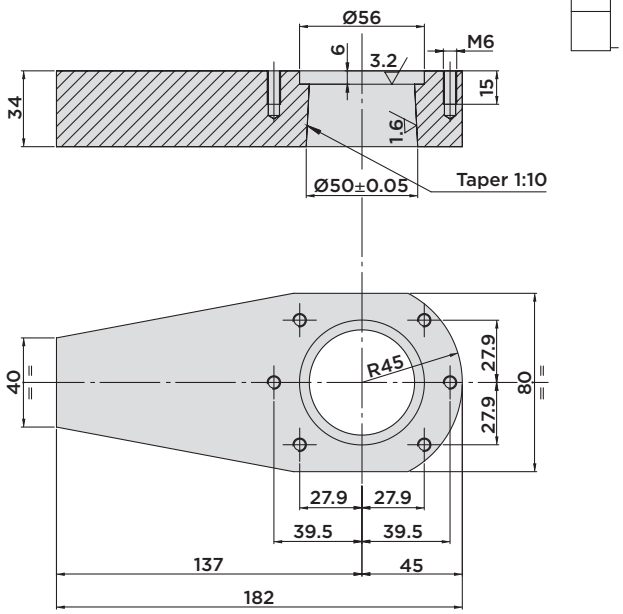
A : Clamping

B : Unclamping

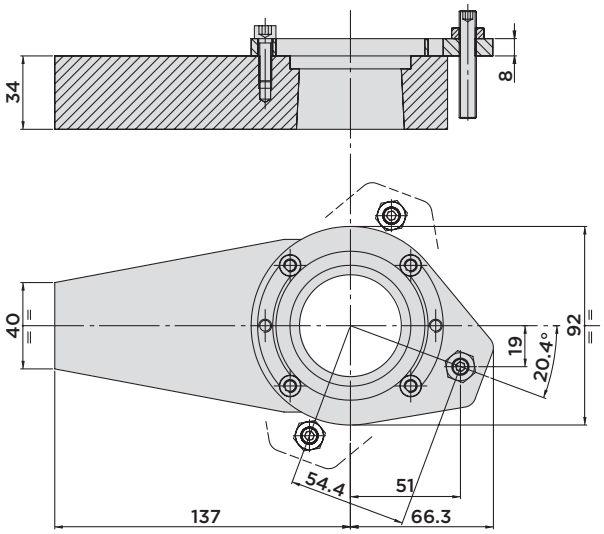




CLAMP ARM 01.50



CLAMP ARM 04.50



Cylinder with COMPENSATION SYSTEM

Included in the scope of supply:
- Mounting screws M14x50 DIN 912/12.9 grade
- O-Rings Ø10.78x2.62

Note:
Order code, see page 38

STROKE mm		EFFECTIVE PISTON AREA		TOTAL OIL VOLUME	
		Cm²		Cm³	
TOTAL	62	CLAMP.	UNCLAMP.	CLAMP.	UNCLAMP.
SWINGING	11	11.54	31.17	71.5	193.2
CLAMPING	51				