

Input module
Series module

Part no. 4401-893
Part no. 4401-894

Valve module combination 2-fold
Valve module combination 3-fold
Valve module combination 4-fold

Part no. 6853-912
Part no. 6853-913
Part no. 6853-914

consisting of: 1 input module, 1 series module
consisting of: 1 input module, 2 series modules
consisting of: 1 input module, 3 series modules

Accessories

for pressure adjustment system "Minimess":

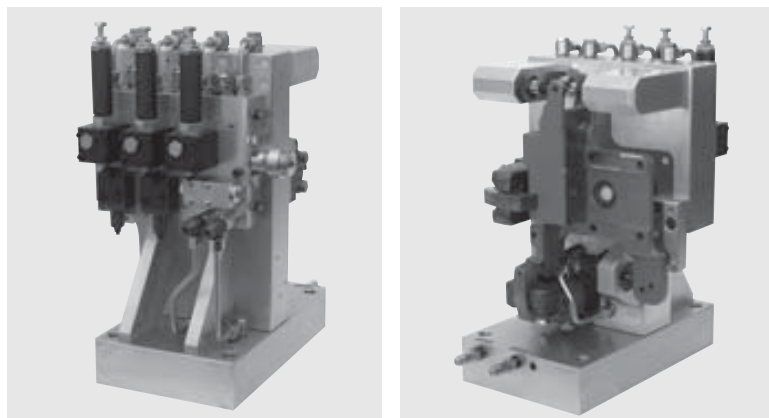
High-pressure hose **Part no. 6355-681**
Pressure gauge union **Part no. 6355-467**
Pressure gauge 400 bar **Part no. 9823-000**

for mounted pressure gauges:

Tube male stud coupling **Part no. 9208-102**
Pressure gauge union **Part no. 9208-041**
Pressure gauge 400 bar resistant to coolant jets **Part no. 9208-041**

Application example

The figure shows a hydraulic clamping fixture for machining of a power unit carrier for an agricultural tractor. The workpiece will be machined from four sides in a horizontal machining centre. Machining of the back of the workpiece is made from the back through the basic body. Clamping elements slide pivot clamps, universal cylinders, work supports and for "floating clamping" of the two upper straps threaded-body cylinders with locking pistons are used. The hydraulic elements are controlled by the valve module combination mounted at the back.



Sequence of the clamping cycle

Step 1:
Clamping with the first slide pivot clamp against fixed datums, as well as lateral positioning by means of an universal cylinder.

Step 2:
First sequence valve opens, work support moves against the lower side of the workpiece and is hydraulically locked.

Step 3:
Second sequence valve opens, two each oppositely arranged threaded-body cylinders with locking piston clamp both upper straps of the workpiece by "floating clamping". At the same time the second slide pivot clamp clamps onto the work support.

