

Work supports

	▼ series	▼ page	
Work support range overview		44 - 45	
Hydraulic advance work supports	WF	46 - 47	
Spring advance work supports	WS	48 - 49	
Work support mounting dimensions	WF, WS	50 - 51	

Work Supports

Enerpac's line of work support cylinders gives you maximum holding force in a compact package. Incorporating innovative material combinations, our work supports feature the lowest lock-up pressures in the industry. Also, the use of corrosion resistant materials enables Enerpac work supports to stand up time and time again to even the most abrasive applications.



Technical support

Refer to the "Yellow Pages" of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

197 ►

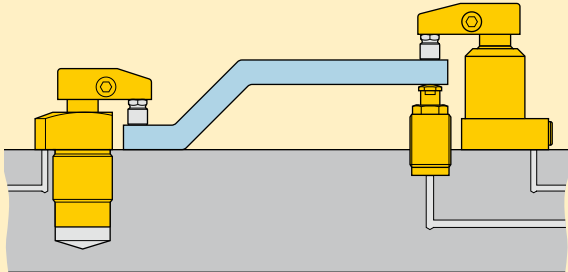
Work supports *Application & Selection*

Shown: WFL-112, WFC-72, WFL-442



▶ The Enerpac work support is a hydraulic means of positively supporting the workpiece to minimize deflections.

The work support automatically adjusts to the contour of the workpiece, and then locks in position. This support then adds rigidity to the fixtured component to minimize machining variations.



■ Lower flange work supports, placed close to the machining area to minimize deflection of the workpiece.

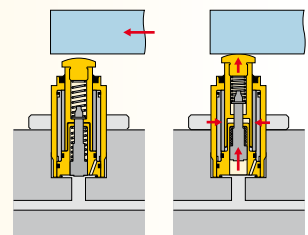
Wide range of sizes and types to efficiently support workpiece

- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials, compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants from being drawn into the system
- Minimized deflection increases machining accuracy
- Multiple mounting configurations allow design flexibility

i Select your work support method:

WF series, Hydraulic advance

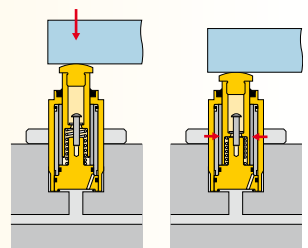
- Retracted plunger allows unobstructed workpiece loading.
- Internal hydraulic plunger advances allowing external plunger to advance under spring load. Bronze sleeve squeezes and holds plunger in fixed position.



46 ▶

WS series, Spring advance

- Workpiece weight compresses the spring of the extended plunger.
- When pressurized, the internal bronze sleeve squeezes and holds the plunger in fixed position.
- Can be operated as air advance.



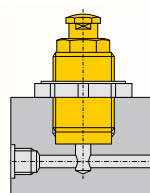
48 ▶



Select your mounting method:

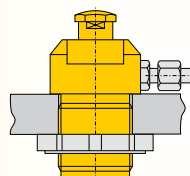
Manifold mount

- Does not require external plumbing
- Compact design, when space is at a premium
- Internal plunger thread for optional contacts



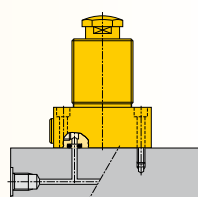
Threaded body

- Ability to adjust height
- Plumbed from either side or bottom
- Internal plunger thread for optional contacts



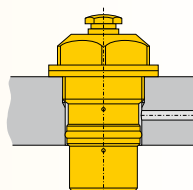
Lower flange

- Plumbed directly or manifold mounted
- No fixture hole required
- Easy to assemble or disassemble
- Internal plunger thread for optional contacts



Cartridge style

- Does not require external plumbing
- Allows close clustering of work supports
- Compact design, when space is at a premium
- Internal plunger thread for optional contacts



Force: 7,3 - 44,5 kN

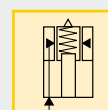
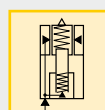
Stroke: 9,1 - 16,8 mm

Pressure: 48 - 350 bar

E Cilindros de soporte

F Vérin anti-vibreux

D Abstützzylinder



Options

Swing cylinders

22 ▶



Accessories

86 ▶



In-line filters

193 ▶



Sequence valves

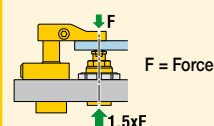
152 ▶



Important

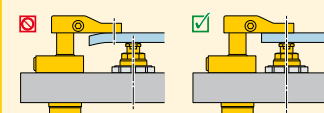
WARNING!

Support force and clamping force must be matched. Support force should be at least 150% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Always center load over work support.



Product selection

Maximum support force	Stroke	Manifold mount	Threaded body	Lower flange	Cartridge style
kN	mm				
▼ Hydraulic advance		Model number			
7,3	9,9	WFM-72	-	-	-
7,3	10,1	-	WFT-72	-	-
11,1	10,1	-	-	WFL-112	-
22,2	10,4	-	-	WFL-222	-
33,4	13,5	-	-	WFL-332	-
44,5	16,5	-	-	WFL-442	-
7,3	9,9	-	-	-	WFC-72
11,1	9,1	-	-	-	WFC-112
22,2	10,4	-	-	-	WFC-222
▼ Spring advance		Model number			
7,3	9,7	WSM-72	-	-	-
7,3	9,7	-	WST-72	-	-
11,1	9,7	-	-	WSL-112	-
22,2	9,7	-	-	WSL-222	-
33,4	13,7	-	-	WSL-332	-
44,5	16,8	-	-	WSL-442	-
7,3	9,7	-	-	-	WSC-72
11,1	9,7	-	-	-	WSC-112
22,2	11,9	-	-	-	WSC-222

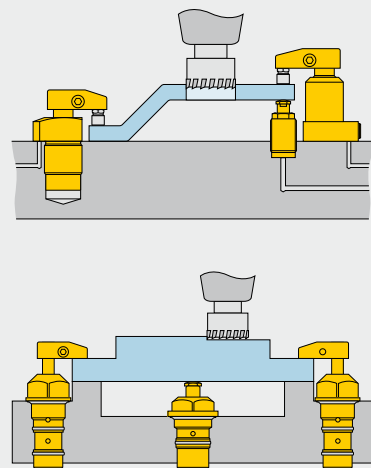
Work supports - Hydraulic advance

Shown: WFM-72, WFL-112



WF series

Enerpac work supports provide either additional non-fixed location points to the clamps, or support to larger or thin section workpiece components, always in order to minimize workpiece deflection during machining.



In order to load the workpiece sideways over the work supports, hydraulic advanced models are being used.



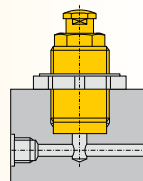
For unobstructed part loading

- Plunger stays retracted until pressure is applied allowing unobstructed loading
- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials – compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants and debris from being ingested into the mechanism
- Minimized deflection increases machining accuracy
- Multiple mounting configurations for design flexibility
- Contact bolt included

Four mounting styles

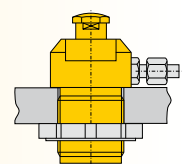
WFM series, Manifold models

Eliminates the need for fittings and tubing on the fixture.



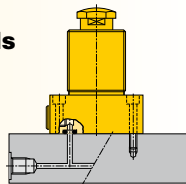
WFT series, Threaded models

Offers the flexibility of side or bottom porting.



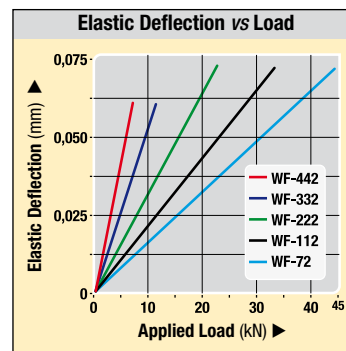
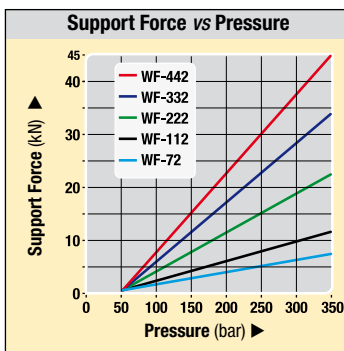
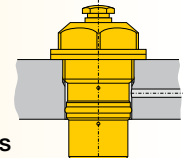
WFL series, Lower flange models

Plumbed directly – no fixture hole required.



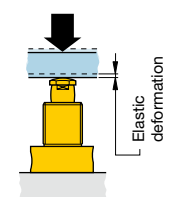
WFC series, Cartridge models

Can be designed into narrow fixture plates as thru-hole mounting is fully functional.



Deflection chart:

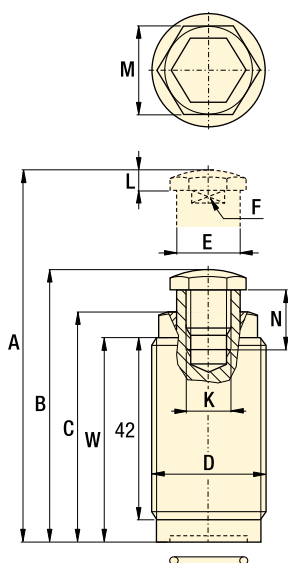
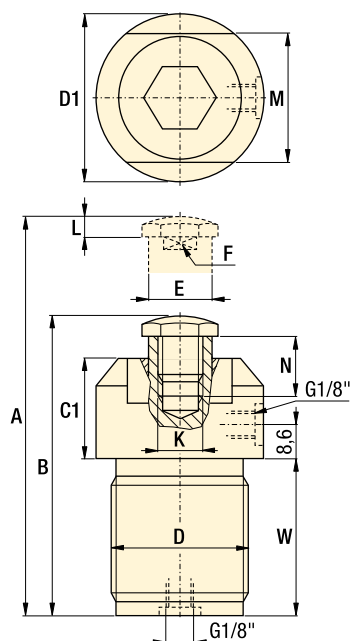
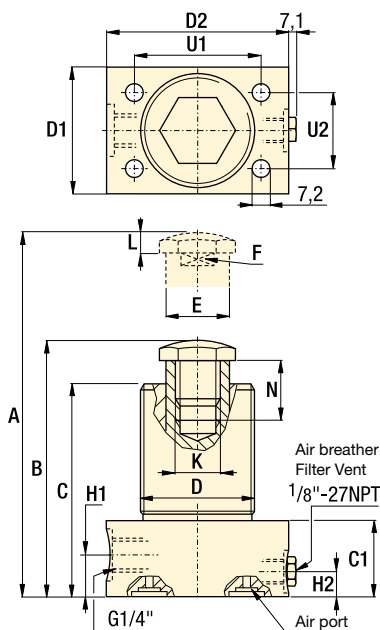
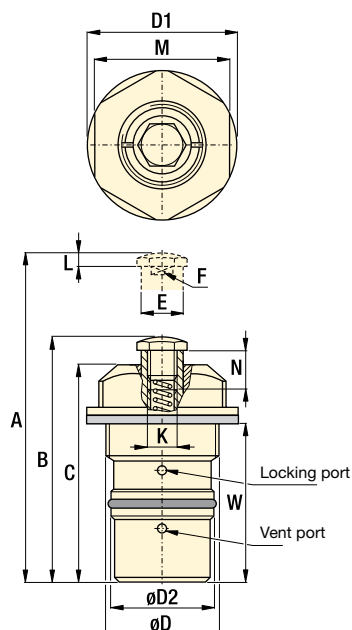
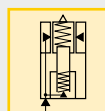
Elastic deformation of the work support resulting from the application of load.



Product selection

Max. support force	Support plunger stroke	Manifold mount	Threaded body	Lower flange	Cartridge style	Operating pressure		Plunger contact spring force		Oil capacity	Max. oil flow
						min.	max.	ext.	retr.		
kN	mm					bar		N		cm ³	l/min
7,3	9,9	WFM-72	-	-	-	48	350	8,9	25,8	0,66	0,7
7,3	10,2	-	WFT-72	-	-	48	350	8,9	25,8	0,66	0,7
11,1	10,2	-	-	WFL-112	-	48	350	15,1	23,1	0,98	1,0
22,2	10,4	-	-	WFL-222	-	48	350	9,3	86,8	3,11	3,1
33,4	13,5	-	-	WFL-332	-	48	350	17,8	77,9	3,93	3,9
44,5	16,5	-	-	WFL-442*	-	48	350	14,7	97,9	4,92	4,9
7,3	9,9	-	-	-	WFC-72	48	350	8,9	25,8	0,66	0,7
11,1	9,1	-	-	-	WFC-112	48	350	15,1	23,1	0,98	1,0
22,2	10,4	-	-	-	WFC-222	48	350	9,3	86,8	3,11	3,1

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

WFM series

WFT series

WFL series

WFC series

Force: 7,3 - 44,5 kN
Stroke: 9,1 - 16,5 mm
Pressure: 50 - 350 bar
E Cilindros de soporte
F Vérin anti-vibreux
D Abstützzylinder


Options

Accessories

86 ▶



In-line filters

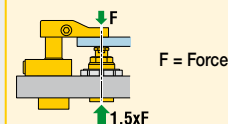
193 ▶



Important

WARNING!

Support force and clamping force must be matched.
Support force should be at least 150% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Custom cylinders including longer stroke lengths are available on request.

Mounting dimensions ▶ 50 ▶

Product dimensions in mm []

Model number	Capacity kN	A	B	C	C1	D	D1	D2	E	F	H1	H2	K	L	M	N**	U1	U2	W	kg
									Ø											
WFM-72	7,3	76,7	66,8	55,9	—	M30x1,5	—	—	15,01	13,0	—	—	M10x1,5	4,6	24,1	13,0	—	—	50,8	0,2
WFT-72	7,3	89,7	79,5	—	26,2	M35x1,5	43,7	—	15,01	13,0	—	—	M10x1,5	4,6	34,0	13,0	—	—	41,9	0,2
WFL-112	11,1	99,8	89,9	78,7	27,4	M35x1,5	38,1	ø60,4	15,98	12,4	14,2	17,8	M10x1,5	4,6	—	18,5	41,1	23,9	—	0,6
WFL-222	22,2	104,9	94,5	78,0	26,4	M68x1,5	69,9	82,6	38,00	25,4	14,0	13,2	M20x2,5	6,1	—	23,4	55,6	55,6	—	2,2
WFL-332	33,4	112,3	98,8	87,9	27,2	ø 73,2	76,2	88,9	44,98	30,0	13,5	10,9	M20x2,5	6,1	—	23,6	62,0	62,0	—	2,9
WFL-442*	44,5	129,3	112,8	103,1	30,2	ø 85,9	88,9	101,6	54,99	36,6	13,5	10,9	M20x2,5	6,1	—	31,5	74,7	74,7	—	4,3
WFC-72	7,3	81,8	71,9	62,5	—	M33x1,5	42,2	30,0	15,01	13,0	—	—	M10x1,5	4,6	38,1	13,0	—	—	50,3	0,4
WFC-112	11,1	102,4	93,2	82,0	—	M42x1,5	57,2	38,1	15,98	12,4	—	—	M10x1,5	4,6	50,8	18,5	—	—	60,2	0,9
WFC-222	22,2	115,8	105,4	91,4	—	M60x1,5	76,2	57,2	38,00	25,4	—	—	M20x2,5	6,1	69,9	23,4	—	—	69,0	1,8

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

** Note: Dimension N is factory set. May change on types **222**, **332** and **442** due to adjusted contact spring force.

Note: For manifold mounting dimensions (▶ 50).

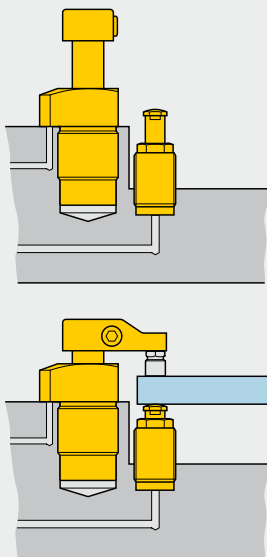
Work supports - Spring advance

Shown: WSL-112, WSM-72



WS series

Enerpac work supports provide either additional non-fixed location points to the clamps, or support to larger or thin section workpiece components, always in order to minimize workpiece deflection during machining.



Spring advance work supports with extended plungers, waiting for the next workpiece.



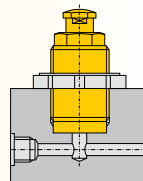
Spring advance work support contacts workpiece as it is loaded into fixture

- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials, compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants from being drawn into the system
- Minimized deflection increases machining accuracy
- Multiple mounting configurations allow design flexibility
- Can be operated as air advance by removing the spring and applying air pressure on the vent port

Mounting style

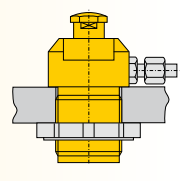
WSM series, Manifold mount

Eliminates the need for fittings and tubing on the fixture.



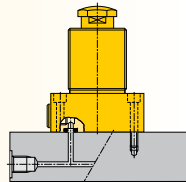
WST series, Threaded body

Offers the flexibility of side or bottom porting.



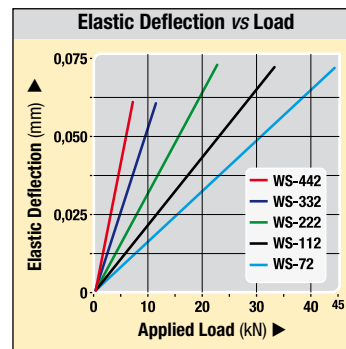
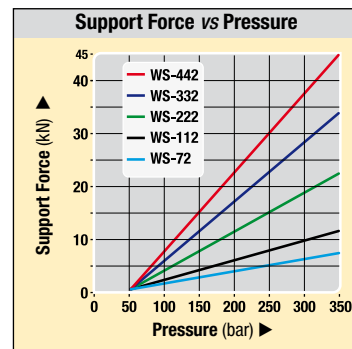
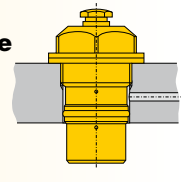
WSL series, Lower flange

Plumbed directly – no fixture hole required.



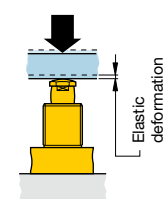
WSC series, Cartridge mount style

Can be designed into narrow fixture plates as thru-hole mounting is fully functional.



Deflection chart:

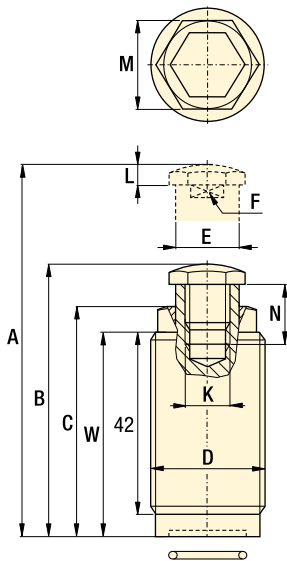
Elastic deformation of the work support resulting from the application of load.



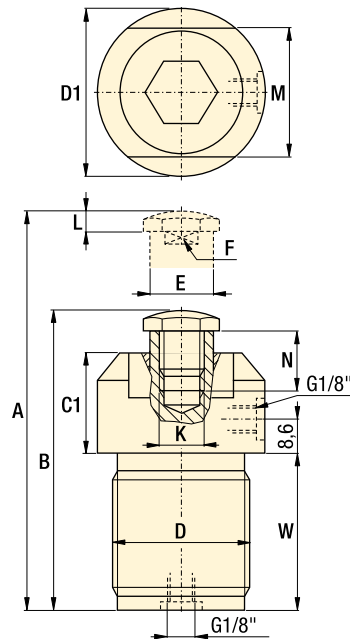
Product selection

Max. support force	Support plunger stroke	Manifold mount	Threaded body	Lower flange	Cartridge style	Operating pressure		Plunger contact spring force		Oil capacity	Max. oil flow
						min.	max.	ext.	retr.		
kN	mm					bar		N		cm ³	l/min
7,3	9,7	WSM-72	-	-	-	48	350	8,9	25,8	0,66	0,7
7,3	9,7	-	WST-72	-	-	48	350	8,9	25,8	0,66	0,7
11,1	9,7	-	-	WSL-112	-	48	350	15,1	23,1	0,98	1,0
22,2	9,7	-	-	WSL-222	-	48	350	9,3	86,8	3,11	3,1
33,4	13,7	-	-	WSL-332	-	48	350	17,8	77,9	3,93	3,9
44,5	16,8	-	-	WSL-442*	-	48	350	14,7	97,9	4,92	4,9
7,3	9,7	-	-	-	WSC-72	48	350	8,9	25,8	0,66	0,7
11,1	9,7	-	-	-	WSC-112	48	350	15,1	23,1	0,98	1,0
22,2	11,9	-	-	-	WSC-222	48	350	9,3	86,8	3,11	3,1

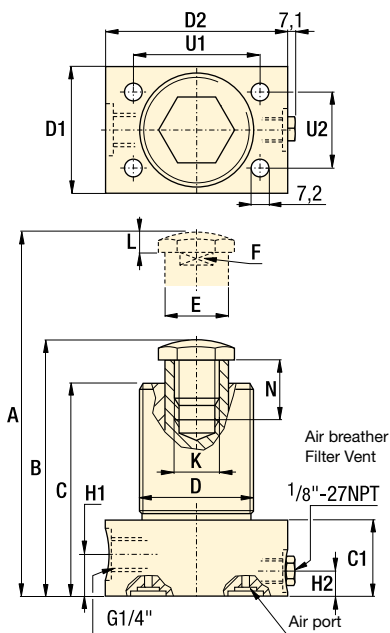
WSM series



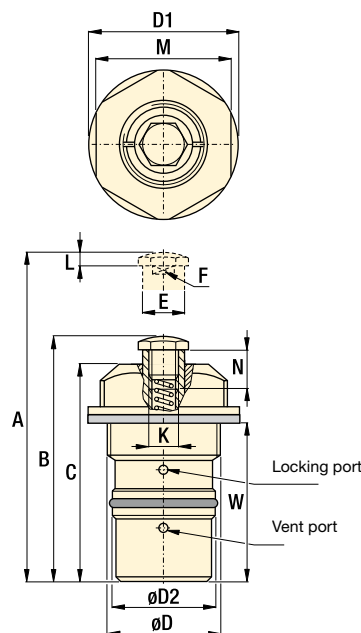
WST series



WSL series



WSC series

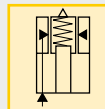


Force: 7,3 - 44,5 kN

Stroke: 9,7 - 16,8 mm

Pressure: 50 - 350 bar

- E** Cilindros de soporte
- F** Vérin anti-vibreur
- D** Abstützzylinder



Options

Accessories

86 ▶



In-line filters

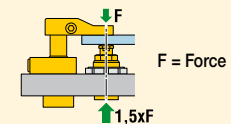
193 ▶



Important

WARNING!

Support force and clamping force must be matched. Support force should be at least 150% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Custom cylinders including longer stroke lengths are available on request.

Mounting dimensions ▶ 50 ▶

Product dimensions in mm [$\pm$]

Model number	Capacity kN	A	B	C	C1	D	D1	D2	E0	F	H1	H2	K	L	M	N**	U1	U2	W	kg
WSM-72	7,3	76,2	66,5	55,9	—	M30x1,5	—	—	15,0	13,0	—	—	M10x1,5	4,6	24,1	13,0	—	—	50,8	0,2
WST-72	7,3	89,2	79,5	—	26,2	M35x1,5	43,6 ϕ	—	15,0	13,0	—	—	M10x1,5	4,6	34,0	13,0	—	—	41,9	0,2
WSL-112	11,1	85,3	75,7	64,5	24,1	M35x1,5	38,1	60,5	16,0	12,4	11,2	9,9	M10x1,5	4,6	—	18,5	41,1	23,9	—	0,6
WSL-222	22,2	99,3	89,7	74,9	24,9	M68x1,5	69,9	82,6	38,0	25,4	12,2	10,2	M20x2,5	6,1	—	23,4	55,6	55,6	—	2,2
WSL-332	33,4	109,0	95,3	85,6	27,2	73,2	76,2	88,9	45,0	30,0	13,0	9,4	M20x2,5	6,1	—	23,6	62,0	62,0	—	2,9
WSL-442*	44,5	126,7	110,0	102,6	30,2	85,6	86,4	101,6	55,0	36,6	13,5	10,9	M20x2,5	6,1	—	31,5	74,7	74,7	—	4,3
WSC-72	7,3	81,3	71,6	62,5	—	M33x1,5	42,4 ϕ	30,0	15,0	13,0	—	—	M10x1,5	4,6	38,1	13,0	—	—	50,3	0,4
WSC-112	11,1	85,9	76,2	65,0	—	M42x1,5	57,1 ϕ	38,1	16,0	12,4	—	—	M10x1,5	4,6	50,8	18,5	—	—	43,1	0,9
WSC-222	22,2	101,0	89,2	76,2	—	M60x1,5	76,2 ϕ	57,2	38,0	25,4	—	—	M20x2,5	6,1	69,9	23,4	—	—	53,9	1,8

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

** Note: Dimension N is factory set. May change on types **222**, **332** and **442** due to adjusted contact spring force.

Note: For manifold mounting dimensions (▶ 50).

Mounting dimensions *for work supports*

Collet-Lok® products

Swing clamps

Work Supports

Shown: WFL-112 holding a casting in place.



Mounting work supports

Enerpac work supports are offered in a wide variety of mounting styles. Dimensions for fixture holes and cavity preparation are specified for each mounting style separately.

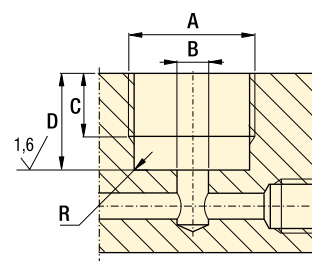
■ The combination of Enerpac swing cylinders and work supports guarantee clamping without deformation.



Manifold work support mounting dimensions

Eliminates the need for fittings and tubing on the fixture. Use a flange nut to secure your manifold work support.

WFM, WSM



Product dimensions in mm [$\varnothing$]

Model number	A	B	C	D	R	Manifold O-ring ¹⁾	Flange nut
	$\varnothing$						
▼ For manifold mount work supports							
WFM-72	M30 x 1,5	9,4-9,9	13,2-13,7	18,8-19,3	0,4	ARP-017	FN-302
WSM-72	M30 x 1,5	9,4-9,9	13,2-13,7	18,8-19,3	0,4	ARP-017	FN-302

¹⁾ Polyurethane 92 duro.

Threaded work support mounting dimensions

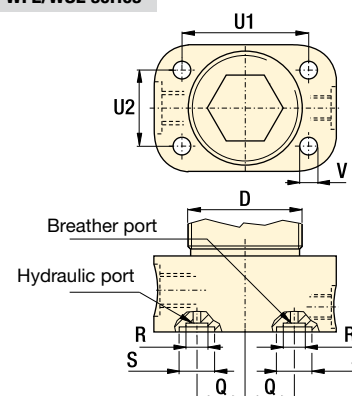
Threaded body work supports can be mounted directly into a fixture. The thread size (D) can be found in the dimension charts on □47 (WFT) and □49 (WST models). Use a flange nut to secure your threaded work support in the required position.

Lower flange work support mounting dimensions

Lower flange work supports can be bolted straight onto a fixture, or can be mounted into a fixture. Flange nuts can be used to secure the cylinders at the required height.

Note: It is critical to keep breather port open to clean dry location.

WFL/WSL series



Product dimensions in mm [$\varnothing$]

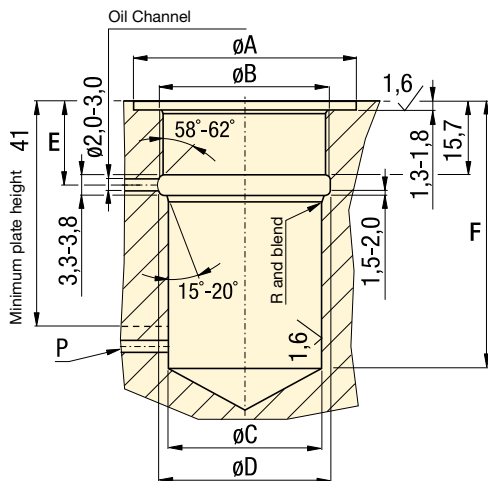
Model numbers	D	Q	R	S	U1	U2	V	Manifold O-ring ¹⁾	Flange nut
			$\varnothing$	$\varnothing$					
▼ For lower flange work supports									
WFL-112	M30 x 1,5	14,5	5,8	9,4	41,1	23,9	7,2	ARP-010	FN-302
WFL-222	M68 x 1,5	27,4	8,6	14,2	55,4	55,4	7,2	ARP-110	—
WFL-332	73,2	30,5	8,6	14,2	62,0	62,0	7,2	ARP-110	—
WFL-442	85,9	36,6	8,6	14,2	74,7	74,7	7,2	ARP-110	—
WSL-112	M35 x 1,5	14,5	5,8	9,4	41,1	23,9	7,2	ARP-010	FN-352
WSL-222	M68 x 1,5	27,4	8,6	14,2	55,4	55,4	7,2	ARP-110	—
WSL-332	73,2	30,5	8,6	14,2	62,0	62,0	7,2	ARP-110	—
WSL-442	85,9	36,6	8,6	14,2	74,7	74,7	7,2	ARP-110	—

¹⁾ Polyurethane 92 duro.

Cartridge work support mounting dimensions

Can be designed onto narrow fixture plates as thru-hole mounting is fully functional.

WFC, WSC



 Dimensions in mm []

Model numbers	A	B	C	D	E	F min	Ventilation below force required
▼ Hydraulic advance							
WFC-72	42,7-43,2	M33 x 1,5	30,02-30,07	33,3-33,8	15,7-17,3	52,8	No
WFC-112	57,4-57,9	M42 x 1,5	38,07-38,13	42,4-42,9	17,5-19,0	62,5	Yes
WFC-222	76,5-77,0	M60 x 1,5	57,12-57,18	60,5-70,0	17,5-18,3	71,1	Yes
▼ Spring advance							
WSC-72	42,7-43,2	M33 x 1,5	30,02-30,07	33,3-33,8	15,7-17,3	52,8	No
WSC-112	57,4-57,9	M42 x 1,5	38,07-38,13	42,4-42,9	17,5-19,0	45,7	Yes
WSC-222	76,5-77,0	M60 x 1,5	57,12-57,18	60,5-70,0	17,5-18,3	55,9	Yes

Note: Ventilation required on WFC-112, 222 below 41 mm when mounted in blind cavity.

Force: 7,3 - 44,5 kN

Stroke: 9,7 - 16,8 mm

Pressure: 48 - 350 bar

- E** Cilindros de soporte
- F** Vérin anti-vibreur
- D** Abstützzyylinder

 Options

Accessories

86 ►



In-line filters

193 ►



Fittings

194 ►



Swing cylinders

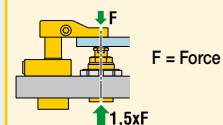
22 ►



 Important

WARNING!

**Support force and clamping force must be matched.
Support force should be at least 150% of clamping force.**



**Do not exceed
maximum flow rates
to avoid premature lockup.**

**Always center load
over work support.**

