

Clamp control valve

- Mechanical



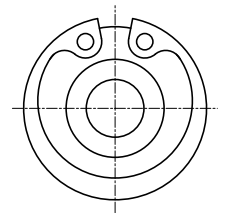
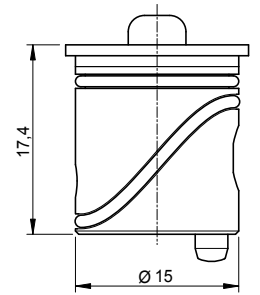
Characteristics:

Control valve for checking for secure clamping.

Application:

The clamping check must be used on all rotary machines!

Particularly important for vertical changing processes and on lathes.

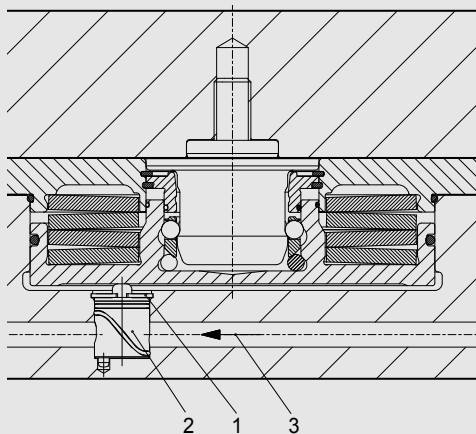


Z 704 210

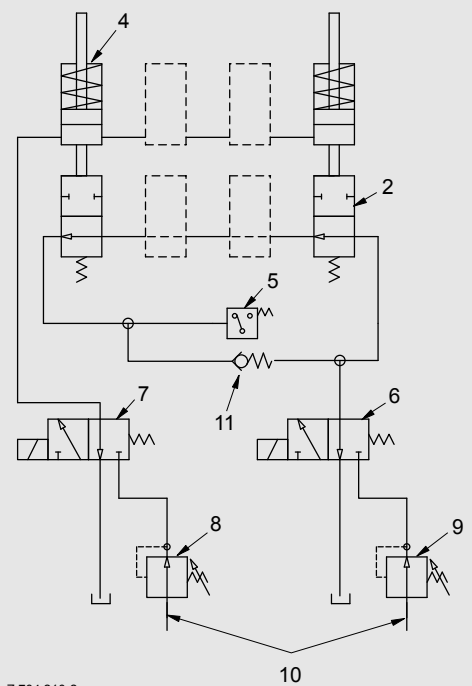
Order no.	Max. pressure	Weight	Data sheet
704 210	10 bar	0.01 kg	D024



Hydraulic schematic



- 1) Locking ring
- 2) Clamp control valve
- 3) Flow direction
- 4) SPEEDY
- 5) Pressure switch for clamping signal
- 6) Hydraulic valve for clamping check
- 7) Hydraulic valve for releasing the SPEEDY
- 8) Pressure limiting valve, 40 bar (80 bar)
- 9) Pressure limiting valve, 8 bar
- 10) Oil supply from machine
- 11) Non-return valve (bypass)



Z 704 210-2



Explanation of function

The correct and safe clamping of the fast closing clamp is checked on each clamping action by using the mechanical clamp control valve (item 2). If a retractable nipple is not clamped or is not clamped correctly, the piston moves past the normal position and with the clamp control valve inhibits the flow in the hydraulic pipe (item 3). This signal can be easily integrated into the control system, e.g. hydraulic unit, external evaluation of machine control system.

On plates or in towers all fast closing clamps are polled in series – as a result the exact clamping of all fast closing clamps can be checked at any time.

