

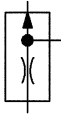
No. 6984-30

Support control, pneumatic



CAD

Order no.	Article no.	Stroke max. [mm]	Input pressure [bar]	Spring force min. [N]	Spring force max. [N]	Weight [g]
325217	6984-30	5	1 - 2	1,9	2,6	36



Design:

Housing from hardened and burnished steel. Pistons are tempered, nitrided and ground. Compression spring from stainless steel.

Application:

The support control is used in fixtures where a signal indicating a correctly supported workpiece is required to enable machining. Lightweight workpieces should be clamped before being pressurised with compressed air.

Features:

The support control works like a pneumatic back-pressure nozzle. The position is extended from its initial position by a pressure spring. Once applied, the air jet flows through the hollow piston and the radial discharge hole on the support control housing to outside. The discharge hole is sealed as soon as a workpiece is mounted and the piston is pushed downwards by min. 1 mm. The air flow backs up, the internal air pressure rises. The pressure value must be transferred to the control by an appropriate pressure signal converter. The system is relatively insensitive to fine chips.

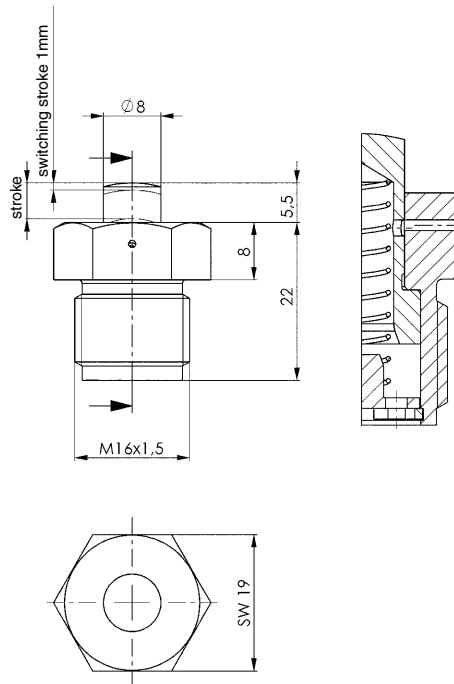
Note:

The pressure signal converter is not included in the supply scope.

Effective piston surface with closed nozzle = 0.95 cm²

Piston force = piston surface x air pressure + spring force

Reduce the input pressure to 1 bar up to a maximum of 2 bar when the air duct is open, e.g. with a throttle check valve. When the air duct is closed, there is a dynamic pressure of approx. 3 bar.



Installation dimensions:

