

1. Description

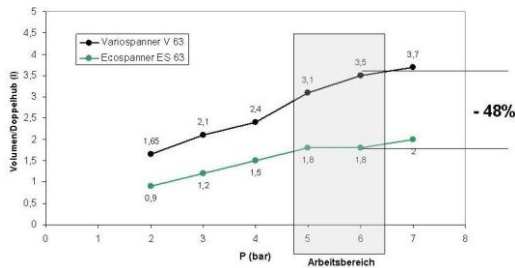
The retractable pin package is a high-power tool designed for use in locating points in the processing of sheet metal. It consists of a pneumatic cylinder in flat design with mountings at the front and the cylinder head and a non-twist receiver for the centring pin "A".

The retractable pin package is fitted with an inductive set, which allows positioning to be controlled with inductive switches.

2. Function of the SZE

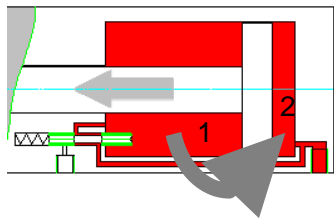
The Compressed Air Saver Clamp

- Integrated valve reduces compressed air requirement in pre-stroke.
- Full clamping force is available in the operating range
- Up to 50 % of air and operation costs are saved



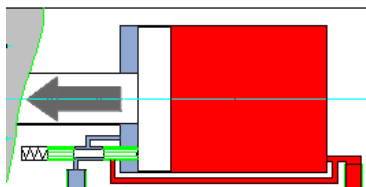
- = pressurised
- = vented

Clamping process initialised



- Both cylinder chambers (1 and 2) are pressurised.
- The air which in the case of usual cylinders is discharged to atmosphere (chamber 1) is recycled and diverted into chamber 2.

Onset of clamping force



- Ring area is vented.
- The full cylinder force affects the piston rod – onset of clamping force.
- Only the residual air (blue) is discharged to atmosphere.

3. Safety

The retractable pin package was not conceived as a full tool supplied ready for independent use and has therefore not been fitted with its own safety equipment. Only when it is correctly installed in a production system and a corresponding safety control system is added, will all safety requirements be met.

Should any faults occur that place personnel at risk, the retractable pin package is to be switched off immediately. Maintenance measures are only to be undertaken when the machine is at a complete standstill and by suitably qualified specialists. After maintenance work has been carried out, the protection devices are to be refitted in the correct way.

4. Assembly of the retractable pin package

- The retractable pin package is installed by means of four head cap screws on the front side of the cylinder area or on the cylinder head.
- The centering pin manufactured by the customer is secured in the piston rod receiver with a threaded pin M6X10. **Caution:** The retractable pin package was not provided with means of fine adjustment. This must be taken into account when designing / manufacturing the consoles / braces.
- Create supply of compressed air between pneumatic control and retractable pin package (connections "N"). **Caution:** For fine adjustment of speed of positioning operation use of external regulating valves is recommended.
- Set angle plug of the retractable pin package on socket „C“ and tighten.

5. Maintenance

The retractable pin package is fitted with a view to application in series production with low-maintenance bearings and guides. Because of the closed structure of the retractable pin package no special maintenance is necessary.

Caution: Damage can be caused to the retractable pin package by cleaning with steam-jet or dry ice.

