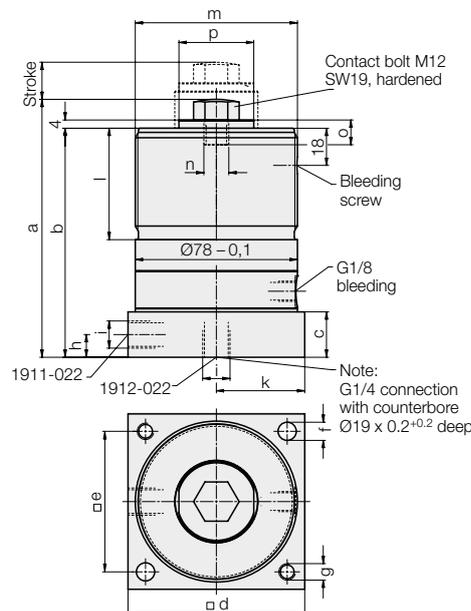
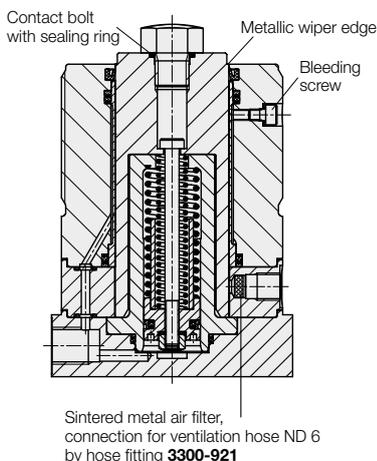


## Work Supports

Extending hydraulically – contact by spring force, single acting with spring return, max. operating pressure 500 bar



### Application

Hydraulic work supports are used to provide a self-adjusting rest for the workpiece during the machining operations. They compensate the workpiece surface irregularities, also deflection and vibration under machining loads.

### Description

The support plunger is retracted in off-position. When pressurised, the support plunger moves against the inserted workpiece by means of spring force. With increasing oil pressure, the support plunger locks hydraulically. After the system has been unclamped, the support plunger returns to the off-position.

The support plunger is provided with female thread to enable the use of threaded pieces for height adjustment.

Oil supply can alternatively be effected from the side or from below.

The internal part of the work support is protected against dust and swarf by a sintered metal air filter.

### Important notes!

If there is any danger of fluids being sucked into the filter, a vent hose has to be connected.

Spring force should not be used to lift workpieces.

Contact bolts and extensions with large weight can influence the functions of this component. Work supports are not suitable to compensate side loads.

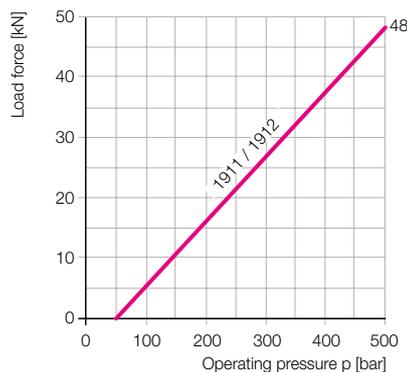
Work supports must only be operated with a sealed contact bolt.

In dry machining applications, with minimum quantity lubrication or in case of accumulation of very small swarf, there can be a swarf hold-up in the area of the metallic wiper edge.

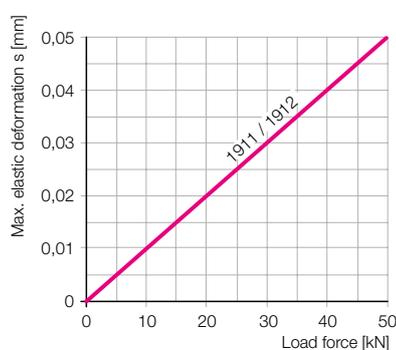
Remedy: Regular cleaning.

Operating conditions, tolerances and other data see data sheet A 0.100.

### Admissible load F as a function of the operating pressure p



### Max. elastic deformations s as a function of support force F max. operating pressure 500 bar



Connection		at the side	at the bottom
Bolt Ø	[mm]	40	40
Stroke	<sup>+0.4</sup> <sub>-0.2</sub> [mm]	18	18
Adm. load force	[kN]	48	48
Oil volume/stroke	[cm <sup>3</sup> ]	5.7	5.7
Max. flow rate	[cm <sup>3</sup> /s]	70	70
Recom. mini. pressure	[bar]	100	100
Plunger contact force	[N]	(60 – 100)*	
a	<sup>+1.2</sup> <sub>-0.9</sub> [mm]	125	130.5
b	[mm]	111	116.5
c	[mm]	22	26.5
d	[mm]	85	85
e	[mm]	68	68
Øf	[mm]	8.8	8.8
g	[mm]	M 8	M 8
h	[mm]	11	–
i		G 1/4	G 1/4
k	[mm]	–	42.5
l	[mm]	54	54
Ø m	[mm]	M78x2	M78x2
n	[mm]	M12	M12
o	[mm]	12	12
p	[mm]	36	36
Weight	[kg]	4.2	4.2
<b>Part no.</b>		<b>1911-022</b>	<b>1912-022</b>

\* stroke-dependent

### Accessory

Capstan nut

**Part no.** 3522-007 3522-007

