

Socket head cap screw M8, 12.9 (25Nm)

752500 Clamping plug

751995 Torx T20, M5 x13/12.9 (8-10 Nm)

751 00091 Circlip $\phi 32$

Caution: Mount in upper groove

751 001 Standard cover

751 002-2 cover with indexing

751 00045 O-Ring $\phi 76 \times 2$



751 00094 Washer $\phi 31 \times 0.5$

Caution: mount only if collar thickness on collet is 3.2mm (older version is 3.7mm)

751 00031 O-Ring $\phi 29.1 \times 1.6$

752 00090 Collet

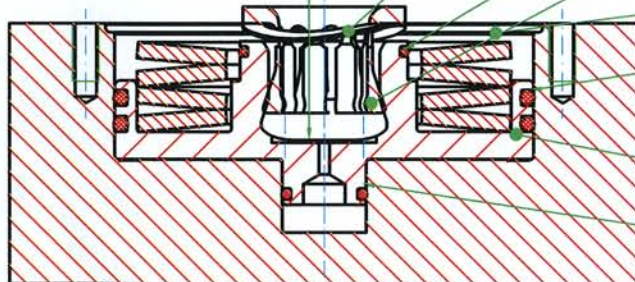
751 00070 Disc-spring $\phi 71 \times 36 \times 3.7$

751 00035 O-Ring $\phi 72.69 \times 2.62$

752 003 Standard piston

752 004 Airblast piston

751 00060 O-Ring $\phi 12.42 \times 1.78$



Dimension A

Checklist for mounting 1T vb Dock-Lock built-in cylinders

1. Double check that all corners and edges meeting with O-rings are faced or lightly rounded (oilstone). Grease slightly for easy mounting (Klüber Iso-Flex NBU15).
2. Dock-Lock cylinders can only be installed horizontally.
3. All bores must be removed from burrs and cleaned from swarf completely.
4. Slide piston with mounted and greased o-rings (752 003 / 752 004) into bore.
5. Slightly grease (NBU15) 4 disk-springs (751 00070). Place disk-spring assembly concentrically into piston (see drawing).
6. Align cover (751 001 / 751 002-2) on screw holes. By using a press push cover into piston bore and tighten with 10pcs. M5 Torx T20 and 8 Nm torque. **Caution: Cover assembly without a press will affect accuracy of the system!**
7. Place collet (752 00090) and washer (751 00094) into clamping chamber and secure with circlip (751 00091) on upper groove.
8. Connect hydraulic. Leak-proof check and bleed system.
9. Function-test by clamping and unclamping the system min. 20 times. Function test air-blow and cartridge-tap.
10. Check dimension <A> without clamping bolt:

with oil-pressure:	27.7mm +0 / -0.2
without oil-pressure:	32.2mm ± 0.2

Caution: Maximum loading capacity per cylinder is 400 kg or 850 lbs

Warning:

Cleaning of the clamping chamber with compressed air can cause a malfunction of the system. Chips must only be removed by a chip vacuum-cleaner.

Weekly maintenance

For secure clamping it is necessary that the clamping chamber is clean and free of chips. In case of dirt accumulation: Circlip (751 00091) and collet (752 00090) must be demounted and cleaned. Check for damage and if necessary replace. Only use original spare parts.

Dimension <A> to be checked without clamping bolt:

with oil-pressure:	27.7mm +0 / -0.2
without oil-pressure:	32.2mm ± 0.2

In case of malfunction due to inappropriate mounting or handling by unauthorised persons vb denies all responsibility.

Max. operating pressure: 70 bar / 1015 psi

Allgemeintoleranzen SN 258440-m

$\pm 5..6 \pm 0.1$	$\pm 30..120 \pm 0.3$	$\pm 400..1000 \pm 0.8$	$\pm ..10 \pm 1^*$	$\pm 50..120 \pm 20^*$
$\pm 6..30 \pm 0.2$	$\pm 120..400 \pm 0.5$	$\pm 1000..2000 \pm 1.2$	$\pm 10..50 \pm 30^*$	$\pm 120..400 \pm 10^*$

Projektion E



Ersatz für:

Ähnliche Zchg: -

Mounting instructions

English

Mafstab	Datum	Name
Bearb.	18.05.2006	st
Gepr.		
Plot Datum: 18.05.2006		

Zeichn.-Nr.

752901 MA d

Schutzvermerk nach DIN 34



Vtscher & Boll AG