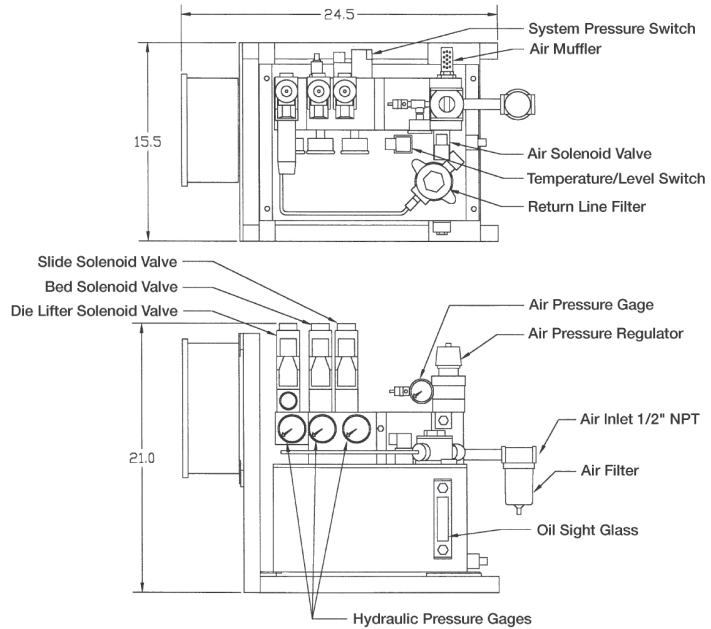




Air/oil power unit modular power unit with solenoid valves



Application:

These air-powered hydraulic units have been developed for the mid-sized to large hydraulic die clamp and lift systems.

Description:

The power units with safety circuits have been developed in view of the special requirements of hydraulic die clamping on presses. The pumps are supplied complete with required valves, pressure switches and electrical controls ready for connections to the press.

The pumps are assembled from standard modular components. This provides a selection of the proper combination of hydraulic and electrical controls for most die clamping applications.

The die lifter circuit provides an adjustable pressure reducer with circuit relief and a return line check valve. This keeps the die lifters that are not under the die up during stamping.

Power unit comes complete in a protective frame with a remote pendant with key switches.

Special power units available on request.

Separate clamp circuit pressure switches on request.

Advantages:

- ◆ fast clamp/unclamp times
- ◆ pressure filter
- ◆ return line filter
- ◆ temp/level switch
- ◆ system pressure switch

Technical data

| Hydraulic | | |
|---------------------------|------------------------|--------|
| Max. clamping pressure | psi | 5,800 |
| Flow rate (average) | (cu in/min) | 220 |
| Reservoir capacity | gal | 5 |
| Reservoir usable capacity | (cu/in) | 847 |
| Pressure filter | micron | 25 |
| Suction strainer | micron | 175 |
| Return line filter | micron | 10 |
| air/oil ratio, stage 1 | | 20:1 |
| air/oil ratio, stage 2 | | 75:1 |
| Air requirement | 80 psi, 1/2" NPT inlet | |
| Clamp output ports | | #6 SAE |
| Die lifter output port | | #4 SAE |

| Solenoid data | | |
|---------------|------------|-----|
| Voltage | VAC | 110 |
| Current | Amps | 0.2 |
| Duty cycle | continuous | |

| Pressure Switch data | | |
|-------------------------------|-----|--------------|
| Adjustable pressure settings | psi | 750 to 5,800 |
| Average pressure differential | | |
| at 1,450 psi | psi | 350 ± 73 |
| at 7,250 psi | psi | 750 ± 116 |
| Switch NO/NC | | single pole |
| Contact rating | VAC | 5A at 250 |
| | VDC | 3A at 30 |

| Part No. | Clamp Circuits | Die Lifter Circuit | | Pendant Key Switches |
|----------------|----------------|---------------------------------|-------------------------------|----------------------|
| | | Reduced Pressure 400-2, 175-PSI | System Pressure 5,800 PSI max | |
| HCR-PA-51510 | 1 | | | 1 |
| HCR-PA-51511 | 1 | 1 | | 2 |
| HCR-PA-51511-H | 1 | | 1 | 2 |
| HCR-PA-51520 | 2 | | | 2 |
| HCR-PA-51521 | 2 | 1 | | 3 |
| HCR-PA-51521-H | 2 | | 1 | 3 |

* Add -1 to end of part number to order without pendant station.

* 24 VDC solenoid voltage upon request.

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modular power unit with
solenoid valves**



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