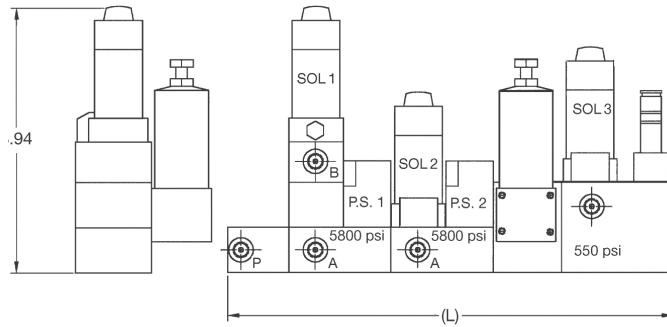
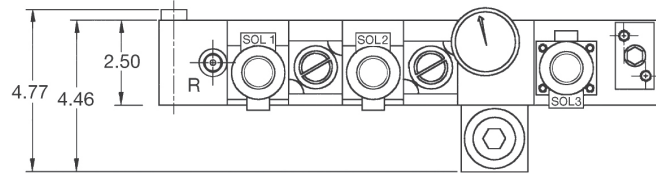
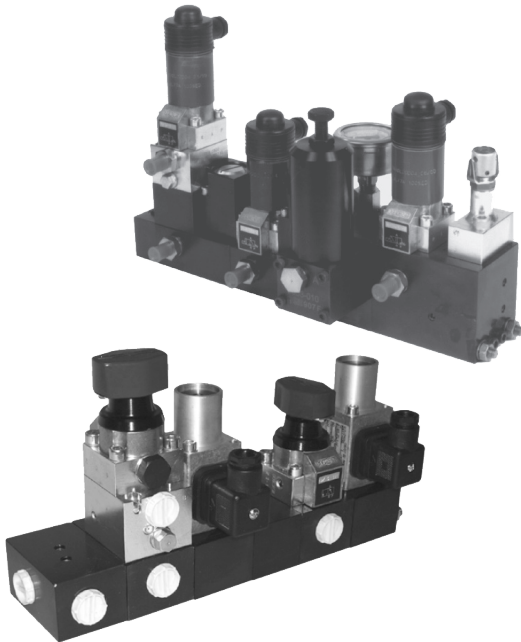




Valve packages manual and solenoid operated



Application:

These modular valve packages provide safe solenoid control of the hydraulic fluid to the die clamps and filters.

Description:

The clamping pressure, as supplied from a separate pump unit and controlled by one of these integrated valve packages, can actuate single or double-acting clamp circuits in the bed and ram. Safety pressure switch in each clamp line provides a signal to the press enable circuit in the event of a pressure loss.

The low pressure die lifter circuit provides an adjustable pressure reducer with circuit relief valve.

The high pressure die lifter circuit, operates at the clamp system pressure and includes a circuit relief valve. This safety valve prevents the rollblocks from being overloaded.

Specials available on request.

Advantages:

- ◆ solenoid valves can be operated via P.L.C. system or manual switch
- ◆ zero-leakage poppet design with built-in check valve
- ◆ very compact
- ◆ suitable for new or existing press room equipment

Technical data

Hydraulic

Max. clamping pressure	psi	7,250
Low pressure die lifter	psi	450-4,600
Max. flow rate	(cu in/min)	490
Ports	BSP	G 1/4

Electrical data

	AC TYPE	DC TYPE
Voltage	110 VAC	24 VDC
Inrush current	.2 A	.83 A
Holding current	.2 A	.83 A
Duty cycle $\leq 104^{\circ}\text{F}$ (40°C)	100%	100%

Pressure switch data

Adjustable pressure setting	psi	750 to 5,800
Average pressure differential		
at 1,450 psi	psi	350 \pm 73
at 7,250 psi	psi	750 \pm 116
Switch NO/NC		single pole
Contract rating	VAC	5 A at 250
	VDC	3 A at 30

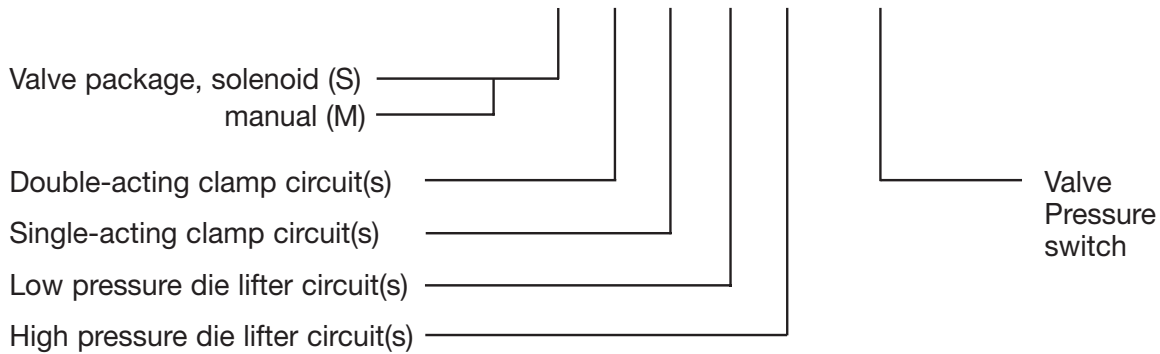
Adapter fittings available

CLR-816-F	G 1/4 to 1/4 JIC
CLR-807-F	G 1/4 to 5/16 JIC
CLR-806-F	G 1/4 to 1/4 compression
CLR-802-F	G 1/4 to 1/4 compression



Ordering example

HCR-VP-S2001-1



Control Configuration

	Double clamp circuit	Single clamp circuit	Die Lifter		Application, Description	Approx. weight lbs	(L) Approx. length (inches)
			Low Pressure 550-1100 psi	High Pressure 5800 psi			
0100	0	1	0	0	1 single-acting clamp circuit	8	5.75
0101	0	1	0	1	1 single-acting clamp circuit and high pressure die lift circuit	18	9.44
0110	0	1	1	0	1 single-acting clamp circuit and low pressure die lift circuit	26	11.69
1000	1	0	0	0	1 double-acting clamp circuit	11	5.75
1001	1	0	0	1	1 double-acting clamp circuit and high pressure die lift circuit	21	9.44
1010	1	0	1	0	1 double-acting clamp circuit and low pressure die lift circuit	29	11.69
1100	1	1	0	0	1 double-acting clamp circuit and 1 single-acting clamp circuit	25	9.12
1101	1	1	0	1	1 double-acting, 1 single-acting clamp circuit and 1 high pressure die lift circuit	35	12.81
1110	1	1	1	0	1 double-acting, 1 single-acting clamp circuit and 1 low pressure die lift circuit	43	15.06
2000	2	0	0	0	2 double-acting clamp circuits	19	9.12
2001	2	0	0	1	2 double-acting clamp circuits and 1 high pressure die lift circuit	29	12.81
2010	2	0	1	0	2 double-acting clamp circuits and 1 low pressure die lift circuit	47	15.06

Valve Pressure Switch

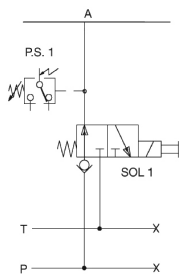
	Valve Voltage		Manual Valve	Press Enable Pressure Switch(s)
	110 VAC	24 VDC		
0				
1	✓			
2	✓			✓
3		✓		
4		✓		✓
5			✓	
6			✓	✓

Directional seat valves:

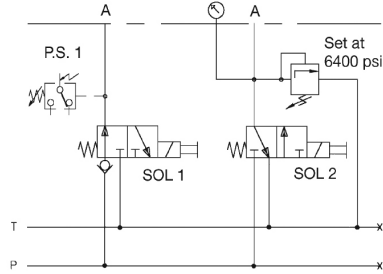
- with HAWE hole patterns, mounting dimensions as per HAWE spec sheet D7300, size 1

Machine Safety:

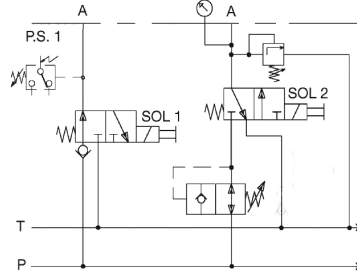
Pressure switch connected to the press enable circuit. Switch setting is 15% (min.) below clamping pressure. Press operation is allowed only when set pressure is reached. If pressure drops below setting the press is automatically stopped.



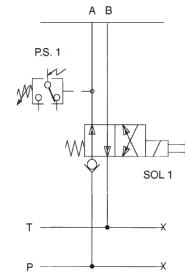
HCR-VP-S0100-X
(1) Single acting clamp



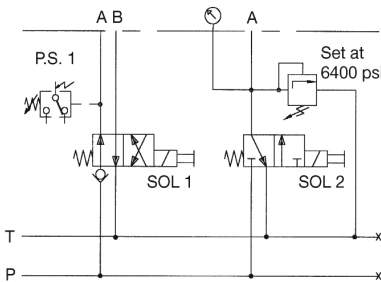
HCR-VP-S0101-X
(1) Single acting clamp
(1) High pressure die lift



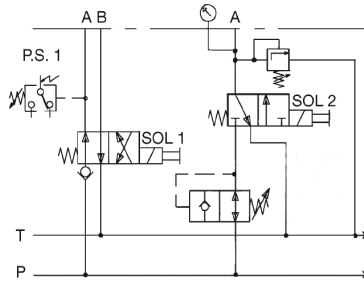
HCR-VP-S0110-X
(1) Single acting clamp
(1) Low pressure die lift



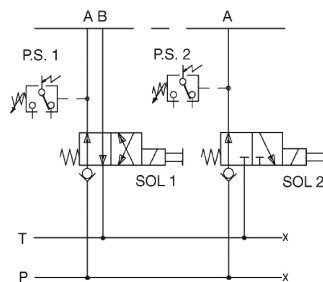
HCR-VP-S1000-X
(1) Double acting clamp



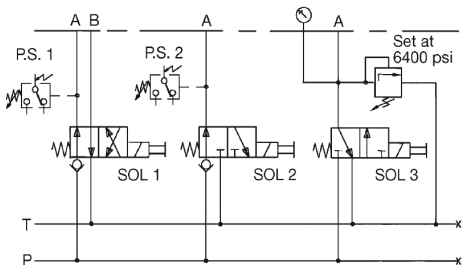
HCR-VP-S1001-X
(1) Double acting clamp
(1) High pressure die lift



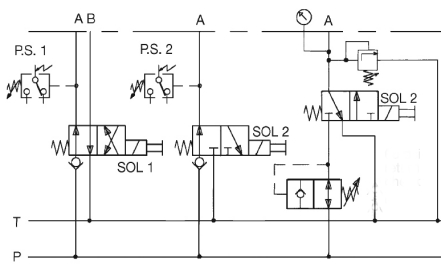
HCR-VP-S1010-X
(1) Double acting clamp
(1) Low pressure die lift



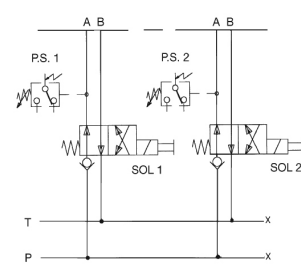
HCR-VP-S1100-X
(1) Double acting clamp
(1) Single acting clamp



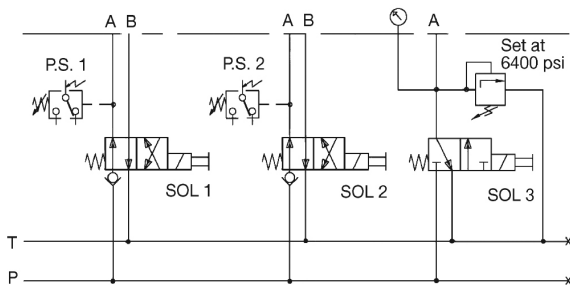
HCR-VP-S1101-X
(1) Double acting clamp
(1) Single acting clamp
(1) High pressure die lift



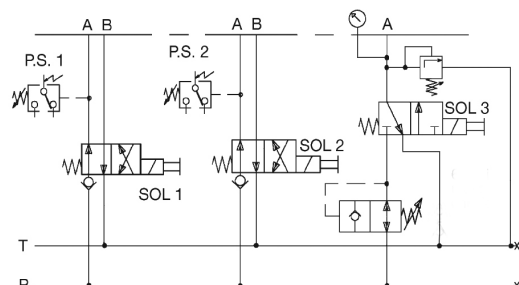
HCR-VP-S1110-X
(1) Double acting clamp
(1) Single acting clamp
(1) Low pressure die lift



HCR-VP-S2000-X
(2) Double acting clamp



HCR-VP-S2001-X
(2) Double acting clamp
(1) High pressure die lift



HCR-VP-S2010-X
(2) Double acting clamp
(1) Low pressure die lift

Solenoid Symbol Shown