

No. 6918-80-10

Sequence valve

for O-ring joint, Pressure-time delayed, max. operating pressure 250 bar, min. operating pressure 40 bar.



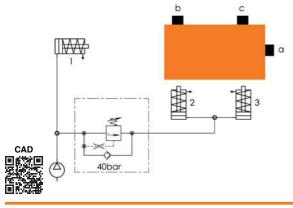


Clamping	procedure:
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- 1. Cylinder 1 presses workpiece against stop a.
- 2. Valve opens A-line after the set time 1-10 sec.
- Cylinder 2 and 3 run out with a time delay and press workpiece against stops b and c.

Hydraulic diagram:

Sequential control as parallel circuit



Order no.	Article no.	Q	Delay setting range	Direction of flow	OR-1 O-ring	Weight
		[l/min]	[s]		Order No.	[g]
326280	6918-80-10	8	1-10	P-A	161810	1500

Design:

Cylinder body made of steel, burnished. Connection diagram, NW 5, is not standardised. Hardened control piston and check valve.

Oil supply takes place through drilled channels in the clamping device.

Application:

The adjustable switch delay permits a time-dependent switching sequence of hydraulic elements within a hydraulic circuit, independent of the hydraulic pressure. The valve can be operated from 40 bar to max. 250 bar.

A parallel or series circuit of several valves is possible. The compact size permits the valve to be flanged directly to the clamping fixture. If the valve should be connected to a pipeline, an adapter plate is available.

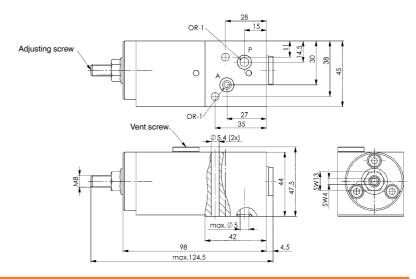
Features:

The hydraulic oil at the valve is guided in the body from the connection P through a throttle to a differential piston. At the same time, the hydraulic pressure is present at an integrated check valve, which blocks the flow to the connection A. Depending on the setting of the setting screw, the differential piston moves forward in a specific time and opens a check valve. This releases the flow from connection P to connection A, and the following hydraulic components are supplied with compressed oil.

If the hydraulic pressure is removed, a spring returns the differential piston to the initial position. The hydraulic oil flowing out is guided through a check valve to the connection P.

Note:

Observe installation instructions with construction notes for the fixture manufacturer. Operating pressure, volume flow, temperature and viscosity can result in changes to the switching sequence. The valve may be used up to a system pressure of maximum 250 bar. The switching intervals should be greater than 10 sec. to guarantee proper function.



No. 6918A-80-10 Connecting plate



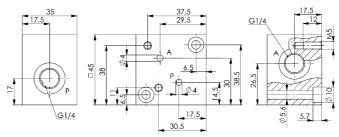
Order no.	Article no.	LxWxH	Connection	Weight
				[g]
327692	6918A-80-10	45x45x35	2 x G1/4	495

Design:

Steel, TEM-deburred and phosphated.

Application:

For line connection of sequence valve 6918-80-10. Reduction for M5 screw for fastening on the fixture.





Subject to technical alterations.