Calculation and dimensioning

In order to guarantee the long life-time of the precision hydraulic feed control it must be correctly calculated and dimensioned. For that the following parameters must be considered:

- moving mass [kg]
- propelling force [N]
- feed rate [mm/min]
- impact velocity [m/s]
- number of strokes or cycles per hour [1/min]

For the correct calculation of your precision hydraulic feed control, please call our free of charge service hotline: +49-(0)2173-9226-20.

Installation information and initial start-up

Prior to installation and use, check if the identification number on the precision hydraulic feed control or on the package corresponds to the number on the delivery sheet. Precision hydraulic feed controls are maintenance-free and ready-to-fit.

Operating temperature range: 0 °C to 60 °C

Mounting: In any position, but always so that the forces can be guided centrally via the piston rod. The maximum permissible side load of 2° may not be exceeded. An excessive side load generally leads to a reduced lifetime.

Adjustment: After mounting the feed control, the equipment must be traversed several times, and the adjuster turned until the optimum adjustment is reached. A hard impact at the beginning of stroke means: adjustment too hard. Turn the adjuster clockwise (according to model towards 9, i. e. plus). A hard impact at the end of stroke means: adjustment too soft. Turn the adjuster counter-clockwise (towards 0, i. e. minus). The feed control is preset to 5 upon delivery.

WARNING

⚠ **Moving masses can lead to injuries or bodily harm when installing the precision hydraulic feed control.**
Secure moving masses against accidental movement.

⚠ **Exceeding or falling below the maximum or minimum temperatures may lead to the failure of the precision hydraulic feed control.**
The temperature range of 0 °C to 60 °C must be adhered to.

⚠ **Ambient fluids, gases and dirt particles may affect or damage the sealing system and lead to failure of the precision hydraulic feed control.**
Piston rod and sealing system must be protected against foreign substances.

⚠ **Damage to the piston rod surface may destroy the sealing system.**
Do not grease, oil, etc. the piston rod and protect it from dirt particles.

⚠ **The piston rod can be torn out of the precision hydraulic feed control.**
Do not put tensile stress on the piston rod.

⚠ **Jamming and lateral forces may lead to leakage of the precision hydraulic feed control or to the blockage of the piston rod.**
Check mounting and avoid side load angles above 2°.

Disposal of packaging: Dispose packaging in an environmentally safe manner. The recycling of packaging saves raw materials and lowers the amount of waste. The used packaging materials do not contain illegal substances.

Issue 8.2010 Specifications subject to change

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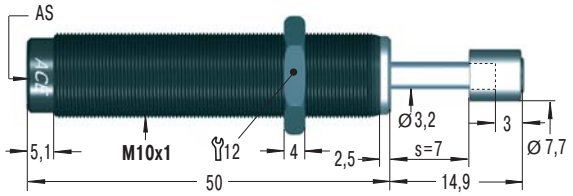
Precision Feed Controls MA50

Mounting Instructions

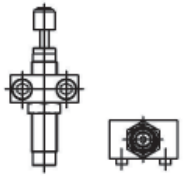
Please note: *The instruction manual can be downloaded at www.ace-ace.com*



s = stroke
AS = adjustment screw

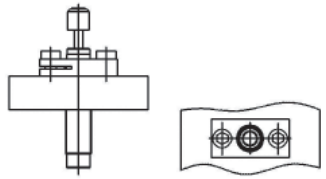
Mounting Options

Usage of the mounting blocks MBSC2

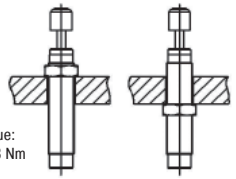


Tightening torque:
KM10 = 4,0-4,3 Nm

Usage of the rectangular flange RF



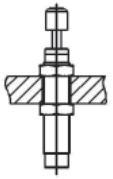
Screwing in the feed control into a tapped hole with an additional locknut



Tightening torque:
KM10 = 4,0-4,3 Nm

Minimum thread depth: 1.5 x thread diameter

Mounting the feed control in the tapped hole with two locknuts



Tightening torque:
KM10 = 4,0-4,3 Nm

Accessories

When using accessories and mounting elements, pay attention to the separate mounting instructions.

EU Marking

Starting with the production date September 2010 (Code IB or 10244) all feed controls MA are to be marked with an additional EU letter code in the identification number. The EU marking refers to the adherence to the required norms, laws, and guidelines of the EU. Only products marked with EU ensure the worldwide standard and the guarantee for liability.

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