

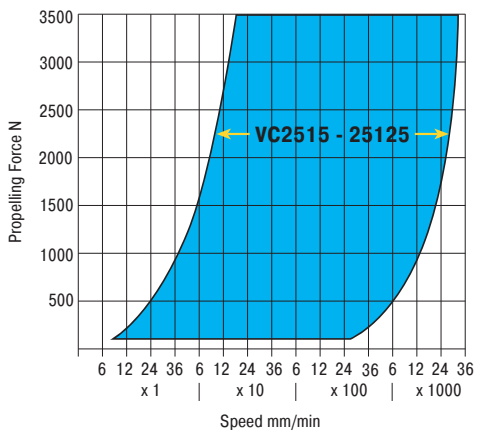
Calculation and dimensioning

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.

Operating Range VC



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.

WARNING

- ⚠ Loosening the screw at the adjustment segment leads to oil leakage!

Operating temperature range: 0 °C to 60 °C

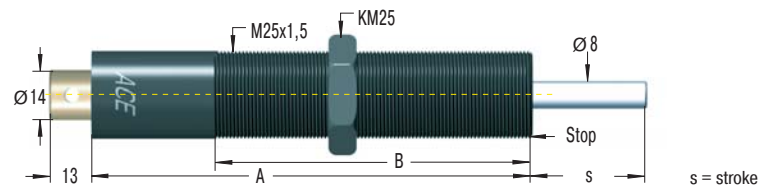
Mounting: In any position, but always so that the forces can be guided centrally via the piston rod.

Adjustment: Lead pin or screwdriver through the opening at the adjustment knob and adjust the feed rate by turning the adjuster (0 = fast, 20 = slow).

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 i.e. 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°.
- ⚠ Do not rotate piston rod, if excessive rotation force is applied rolling seal may rupture.

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.



Dimensions

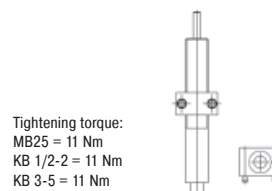
Type Part Number	s (stroke)	A	B
VC2515EUFT	15	128	80
VC2530EUFT	30	161	110
VC2555EUFT	55	209	130
VC2575EUFT	75	283	150
VC25100EUFT	100	308	150
VC25125EUFT	125	333.5	150

FT = M25x1,5 threaded body

F = plain body 23.8 mm dia. (without thread) also available, with optional clamp type mounting block

Mounting Options

Usage of the clamp mounts MB or KB



Tightening torque:
MB25 = 11 Nm
KB 1/2-2 = 11 Nm
KB 3-5 = 11 Nm

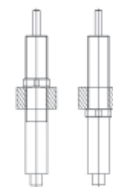
Cylinder head screws
DIN 912 (Quality 10.9) for
the types MB and KB are
included.

Mounting the feed control in the tapped hole with two locknuts



Tightening torque:
KM25 = 19-21 Nm

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



Tightening torque:
KM25 = 19-21 Nm

Minimum thread
depth: 1.5 x thread
diameter

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 VC 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.

Issue 8.2010 Specifications subject to change

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