

E214 ENERPAC 



WORKHOLDING CATALOG

A global resource of workholding solutions

Model number index

series ▼	page ▼	series ▼	page ▼	series ▼	page ▼	series ▼	page ▼
A		H		Q		V	
A	156	H	156	QDH	68-69	V	140-142
ACBS	150-151	HCS	68-69			VA	142
ACCB	146	HF	157	R		VC	132-135
ACL	150-151	HLS	156	RA	116-117	VD	126
ACM	150-151	HP	69	*RD/BRD	76-77	VE	128-131
*AD/BAD	76-77	HV	140	REB	75	VFC	123, 128
AH	156			REP	75	VM	132-135
AHB	114-115	I		RFL	142	VMMD	127
AMP	149	IC	152	*RW/BRW	74-75	VMTD	127
AP	150	L		RWH	68-69	VP	122
AR	156	LCAL	46-47	S		VR	142
ASC	21	LCAS	46-47	SC	20	VSS	126
AT	147	LUCD/LUCS	44-45	SCLD	18-19	VST	126
AW	79			SCLS	18-19		
B		M		SCRD	18-19	W	
B	114-117	MB	129	SCRS	18-19	WA	150-151
*BAD/AD	76-77	*MCA/WCA	146-147	SCSD	18-19	WAT	151
BFZ	159-160	MF	79	SCSS	18-19	*WCA/MCA	146-147
BK	131	MHV	140	SLLD	14-15	WED	111-112
*BRD/RD	76-77	*MPA/WPA	146-147	SLLS	14-15	WEJ	111-112
*BRW/RW	74-75	*MPFC/MPFC	72-73	SLRD	14-15	WEM	111-112
BS	78	*MPFL/MPFL	24-25	SLRS	14-15	WER	111-112
		*MPFR/MPFR	24-25	SLSD	14-15	WES	111-112
		*MPFS/MPFS	38-39	SLSS	14-15	WFC	33-35
C		*MPTC/WPTC	72-73	SP	113	WFL	33-35
CA	23, 26-27	*MPTL/WPTL	24-25	STLD	16-17	WFM	33-35
CAC	28-29	*MPTR/WPTR	24-25	STLS	16-17	WFT	33-35
CAL	26-27	*MPTS/WPTS	38-39	STRD	16-17	WM	125
CAPT	28-29	MRS	70-71	STRS	16-17	WMT	58-59
CAS	26-27	MV	137	STSD	16-17	*WPA/MPA	146-147
CAU	30-31	MVM	137	STSS	16-17	*WPFC/MPFC	72-73
CDB	62-65	MVPM	136	SULD	12-13	*WPFL/MPFL	20-21
CDT	56-57			SULD	12-13	*WPFR/MPFR	20-21
CR	148-149	N		SULS	12-13	*WPFS/MPFS	38-39
CRV	148-149	NV	155	SURD	12-13	*WPTC/MPTC	72-73
CSB	62-65			SURDL	12-13	*WPTL/MPTL	20-21
CSM	60-61	P		SURS	12-13	*WPTR/MPTR	20-21
CST	56-57	P	113	SUSD	12-13	*WPTS/MPTS	38-39
CY	68-69	PA	92	SUSD	12-13	WRT	58-59
CYDA	58	PACG	88-91	SUSDL	12-13	WTR	22-23
		PAMG	88-91	SUSS	12-13	WSC	33, 36-37
D		PARG	88-91			WSL	33, 36-37
DGR	153	PASG	88-91	T		WSM	33, 36-37
		PATG	88-91	T	156	WST	33, 36-37
E		PB	125	TRCM	80-82	WUD	108-109
ECH	66-67	PID	118-119	TRFM	80-81, 83	WVP	136
ECM	66-67	PLSD	52-53	TRFL	80-81, 84		
		PLSS	52-53	TRRC	85	Y	
F		PLV	124-125	TRRE	85	Y	78
FL	157	PRV	124, 139	TRAC	85		
FM	155	PSCK	123, 152	TRK	125	Z	
FN	78	PTSD	54-55			Z	97-98
FZ	158-160	PTSS	54-55			ZW	94-96, 100-107
		PUSD	50-51				
G		PUSS	50-51				
G	154						
GA	155						
GS	155						

* These models are only shown in imperial versions in this catalog. Contact Enerpac to order metric models.

Yellow Pages

Refer to the “Yellow Pages” of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

Product index

product description ▼	series ▼	page ▼
Swing cylinders & Work supports 8-41		
Clamp Arms.....	CA	23, 26
Pivoting T-Arms.....	CAC, CAPT	28
Swing Cylinders.....	SC	20
Swing Cylinders.....	ASC	21
Swing Cylinders, Cartridge Body.....	SC	18
Swing Cylinders, Collet Lok®.....	WP	24
Swing Cylinders, Lower Flange.....	SL	14
Swing Cylinders, Threaded Body.....	ST	16
Swing Cylinders, Upper Flange.....	SU	12
Three Position Swing Cylinder.....	WTR/CA	22
Upreach Clamp Arms.....	CAU	30
Work Supports, Collet Lok®.....	WP	38
Work Supports, Fluid Advance.....	WF	34
Work Supports, Spring Advance.....	WS	36
Linear cylinders 42-85		
Cylinder Accessories.....	AW/B/BS/FN/JN/Y	78
Cylinders, Block.....	CDB/CSB	62
Cylinders, Hollow Plunger.....	CY/QDH/RWH/HCS	68
Cylinders, Manifold Mount.....	CSM	60
Cylinders, Positive Locking.....	MRS	70
Cylinders, Pull Down.....	ECH/ECM	66
Cylinders, Tie Rod.....	TR	80
Cylinders, Threaded Body.....	CST/CDT	56
Cylinders, Threaded Body.....	CYDA/WMT/WRT	58
Cylinders, Universal Double-acting.....	RD/AD	76
Cylinders, Universal Single-acting.....	RW	74
Linear Cylinders, Collet Lok®.....	WP	72
Link Clamp.....	LU	44
Link Clamp Arms.....	LCAS/LCAL	46
Pull Cylinders, Lower Flange.....	PL	52
Pull Cylinders, Threaded Body.....	PT	54
Pull Cylinders, Upper Flange.....	PU	50
Power sources 86-119		
Activator Wand and Booster.....	B/RA	116
Air Hydraulic Boosters.....	AHB/B	114
Air Hydraulic Pumps.....	PA	88
Continuous Connection Pumps.....	ZW	102
Electric Pumps, Economy.....	WU	108
Electric Submerged Pumps.....	WE	110
Electric Driven Pumps.....	ZW	94
Hand Pump.....	P/SP	113
Heat Exchangers.....	ZHE	97
Hydraulic Intensifiers.....	PID	118
Level/Temperature Switch.....	ZLS	98
Manual Powered Pumps.....	P/SP	113
Pressure Switch Kits.....	ZPT/ZPS	98
Pallet De-Coupling Pumps.....	ZW	100
Pump Filter Kit.....	ZPF	97
Single Station DO3 Pumps.....	ZW	104
Turbo Air Pumps.....	PAC/PAT/PAM/PAS/PAR	88
Valve Manifold.....	ZW	99
Valves 120-143		
3-Way Manual Valves.....	VM/VC	132
4-Way Manual Valves.....	VM/VC	134
Accessory Valves.....	V/MHV/HV/PLV	140
Air Valves and Accessories.....	VA/VR/RFL	142
Valves, Directional and Accessories.....	VE,VD,PRV	128
Electric and Air Poppet Valves.....	VAVS/VD	126
Electric Shear Seal Valves.....	VE/BK/VS	130
Flow Control Valve Pressure Switches.....	PSCK/VFC	123, 152
Inline Flow Control Valves.....	VFC	123, 128
Manual Directional Valves.....	VMMD/VMTD	127
Modular Directional Valves.....	VP/PSCK/VFC	122

Section index

product description ▼	series ▼	page ▼
Pressure Reducing Valves.....	PRV	124/139
Sequence and Pilot Operated.....	WVP/MVPM	
Check Valves.....	V/MVM	136
Valve Manifolds and Mounting.....	PB/WM/TRK/MB	125
System components 144-160		
Accumulators and Control Units ACL/ACBS/ACM/WA.....		150
Auto Coupler System.....	WCA/WPA/ACCB/AT	146
Digital Gauges.....	DGR	153
Fittings.....	FZ/BFZ	158
Gauges and Accessories.....	G/GA/GS/NV/V/FM	154
Manifolds, Couplers, Hoses,.....	A/AH/FL/HF/	
Oil, Filters and Tubing.....	HLS/T	156
Pressure Switches.....	IC/PSCK	152
Rotary Couplers.....	CR/CRV	148
Yellow pages 161-192		
Safety Instructions.....		162-163
Basic Hydraulics.....		164-165
Basic System Setup.....		166-169
Clamping Technology.....		170-173
Cutting Force Technology.....		174-176
Conversion Factors.....		177
Best Practices.....		178
Hydraulic Symbols.....		179-183
Valving Technology.....		184-187
FMS.....		188-189
Mechanical Clamping.....		190-192
Global Warranty and Disclaimer.....		193



**Swing cylinders
& Work supports**
8-41



Linear cylinders
42-85



Power sources
86-119



Valves
120-143



**System
Components**
144-160



Yellow Pages
161-192

Whether your workpiece needs to be clamped, punched, pressed, positioned or pulled, Enerpac Workholding is there to provide innovative solutions to increase your product quality and production output.

All over the world, Enerpac Workholding products are used to provide powerful clamping and positioning force to every type of manufacturing process. Enerpac cylinders are used for punching and clamping in automotive manufacturing. Work supports prevent deflection in aerospace production machining. From the simplest fixture to robotic assisted machining centers, Enerpac cylinders provide the holding and support force to keep the world moving.

Enerpac power units provide the power needed to clamp parts consistently again and again. Incorporating the latest technology and highest quality components, along with the widest variety of accessories, Enerpac power units are designed for every application.



of Enerpac

10 Good Reasons to Work with Enerpac

Working with us couldn't be easier!

2D and 3D CAD files of Enerpac Workholding products are available on-line (www.enerpac.com). This service includes swing cylinders, work supports, and other clamping cylinders, along with all accessories. Catalogs in other languages and service information, including spare parts lists, are also available upon request through the Enerpac website.

1. **Expert Design**
2. **Quality**
3. **Innovative Products**
4. **Reliability**
5. **Service Excellence**
6. **Availability**
7. **Value**
8. **Application Support**
9. **Global Vision**
10. **Worldwide Experience**



Total Quality

Every product we produce is individually tested to the most exacting standards. Only in this way, can we guarantee that we will meet the quality, price, and performance requirements of the markets we serve around the globe.

An ISO 9001 certificate confirms that Enerpac's manufacturing and quality control procedures are precisely adhered to.



Logistics Excellence

Enerpac is a truly global partner, meeting the needs of local and multi-national customers. Maintaining service excellence in the changing world of modern distribution is one of Enerpac's missions. This demands the highest expertise in logistics around the world.



The Right Products for the Job

The key to optimizing productivity is finding the right clamping products for the job. Take the time to page through the new Enerpac Workholding catalog, and discover how easy it is to arrive at the right selection of products for your job. Our Yellow Pages Section provides helpful applications and design information.

ISO 9001 Quality System Certified
ENERPAC, Columbus WI USA



A Guide to Your New Enerpac Workholding Catalog

The New Enerpac Workholding catalog;

**... helps you design more efficient workholding fixtures,
... is a global resource of workholding solutions.**

**This catalog is set-up
in two main sections:**

1 Imperial hydraulic product data section

All Enerpac hydraulic workholding products shown with imperial based specifications and dimensions.

2 Yellow Pages section

Your guide to safety, basic hydraulics and application suggestions.

**Selecting the right product
for your application:**

1. Select your main product category from the *main index* on page 3. This index shows page numbers of product offerings in the catalog.
2. From here you go to the selected product *range overview*. For an example see pages 8 and 9 for the swing cylinders and work supports overview. On this page you will find the main groups with regard to functional and mounting style options.
3. Proceed to pages 10 and 11 to narrow down your selection with regard to function, mounting style and clamping capacity. These application & selection pages offer a brief overview of an entire range of products within one group. Note that these pages have *yellow* columns on both sides of the spread.
4. Once you have made your product selection you can proceed to the product data pages, 12 and onwards, of the specific product series of your choice. These pages have *gray* columns on both sides of the spread.

Swing cylinders

Swing Cylinders

Enerpac's complete line of swing cylinders provide maximum clamping force in the smallest possible package. With several mounting and operation styles available, Enerpac can fit any clamping need you can think of. Our unique patented clamp arm design is an industry exclusive, and makes Enerpac's swing cylinder line more versatile than ever before. Made to the highest quality standards, Enerpac swing cylinders will provide maximum performance and trouble free operation.

Work Supports

Enerpac's line of work support cylinders gives you maximum holding force in a compact package. Incorporating innovative material combinations, our work supports feature the lowest lock-up pressures in the industry. Also, the use of corrosion resistant materials enables Enerpac work supports to stand up time and time again to even the most abrasive applications.

Technical support

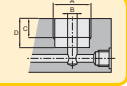
Refer to the "Yellow Pages" of this catalog for:

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- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

 161 ►



& Work supports

	▼ series	▼ page	
Swing cylinder range overview		10 - 11	
Upper flange swing cylinders	SU	12 - 13	
Lower flange swing cylinders	SL	14 - 15	
Threaded body swing cylinders	ST	16 - 17	
Cartridge model swing cylinders	SC	18 - 19	
Additional swing cylinders	SC, ASC WTR	20 - 23	
Positive locking swing cylinders <i>[Collet-Lok®]</i>	WP	24 - 25	
Clamp arms	CA	26 - 27	
Pivoting T-arms	CAC CAPT	28 - 29	
Upreach clamp arms	CAU	30 - 31	
Work support range overview		32 - 33	
Hydraulic advance work supports	WF	34 - 35	
Spring advance work supports	WS	36 - 37	
Positive locking work supports <i>[Collet-Lok®]</i>	WP	38 - 39	
Work support mounting dimensions	WF, WS	40 - 41	

Swing cylinders *Application & selection*

Shown: SCRD-122, STLD-21, WPFL-50

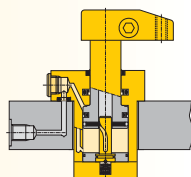
Swing cylinders
Work supports



Enerpac swing cylinders allow unobstructed part fixturing and placement. The plunger rod and the attached clamp arm rotate 90 degrees in either a clockwise or counter-clockwise direction, then travel down an additional distance to clamp against the fixtured part. Upon release of clamping pressure, the clamp arm rotates back 90 degrees in the opposite direction to allow for part removal and new part placement.

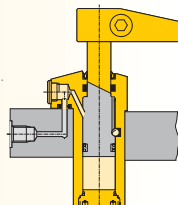
Roller in groove

- Double index provides low height design to minimize fixture height
- Overload clutch allows clamp to disengage if needed to prevent damage due to improper part loading



Ball in groove

- Rotation direction can be changed on-site to reduce spare inventory by 2/3 (67%)
- Ball and cam rotation ensures smooth accurate operation



Swing cylinders used in conjunction with work supports and other Enerpac components to positively hold the workpieces during machining operations.



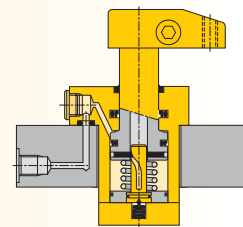
Compact and full featured design

- Compact design allows for efficient fixture layout
- Variety of mounting styles to meet design needs
- Double and single-acting cylinders to suit a variety of hydraulic requirements
- Choice of porting styles to meet system and design requirements
- All cylinders are available as left and right turning models
- Large ball and cam design on 21, 51 and 121 models allows swing rotation to be changed easily
- Kick-out mechanism on 92, 201, and 351 models prevents damage to cylinder from high flow rates or misapplication

Select your swing cylinder type:

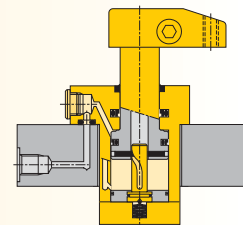
Single acting

- The obvious choice when there are few system restrictions, and there are not many units retracting simultaneously
- Fewer valving requirements which results in a less complex circuit
- Innovative clamp arm design allows quick and secure arm positioning



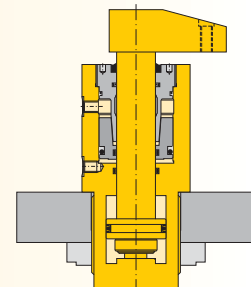
Double acting

- Used when greater control is required during the unclamp cycle
- When timing sequences are critical: less sensitive to system back pressures, resulting from long tube lengths or numerous components being retracted at the same time
- Innovative clamp arm design allows quick and secure arm positioning



Collet-Lok® positive locking

- Enerpac Collet-Lok® positive locking cylinders are designed to mechanically hold the workpiece while hydraulic pressure is removed. After machining, hydraulic pressure is applied to unclamp the workpiece
- Used when live hydraulics are not available during the clamp cycle or when parts must be held for long periods of time
- This design is an industry exclusive



For Collet-Lok® positive locking swing cylinders, see 24 ▶

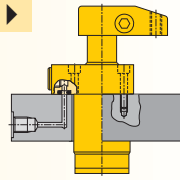


Select your mounting method:

SU series, Upper flange mounting

- Flexible design allows for manifold or threaded oil port connection
- Fixture hole does not require tight tolerances
- Easy installation with only 3 or 4 mounting bolts

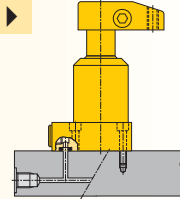
12 ▶



SL series, Lower flange mounting

- Flexible design allows for manifold or threaded port connection
- No fixture hole required
- Easy installation with only 3 or 4 mounting bolts

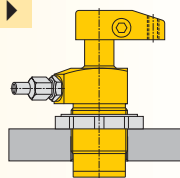
14 ▶



ST series, Threaded body mounting

- Body thread for precise cylinder height positioning
- Threaded oil port connection
- Can be threaded directly into the fixture and secured in position by means of standard flange nuts

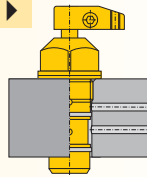
16 ▶



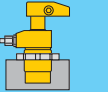
SC series, Cartridge mounting

- Minimal space required on fixture
- External plumbing not required
- Allows close positioning of adjoining units
- Cylinder can be completely recessed in fixture

18 ▶



Product selection

Clamping force ¹⁾	Stroke		Upper flange	Lower flange	Threaded body	Cartridge
	lbs	in clamping total				
▼ Single acting						
			Model number ²⁾			
475	.32	.65	SURS-21	SLRS-21	STRS-21	SCRS-22
1100	.39	.89	SURS-51	SLRS-51	STRS-51	SCRS-52
1800	.47	.87	SURS-92	SLRS-92	STRS-92	-
2400	.50	1.12	SURS-121	SLRS-121	STRS-121	SCRS-122
3900	.55	1.10	SURS-201	SLRS-201	STRS-201	-
7450	.63	1.18	SURS-351	SLRS-351	STRS-351	-
▼ Double acting						
			Model number ²⁾			
500	.32	.65	SURD-21	SLRD-21	STRD-21	SCRD-22
1250	.39	.89	SURD-51	SLRD-51	STRD-51	SCRD-52
2025	.47	.87	SURD-92	SLRD-92	STRD-92	-
2025	1.26	1.65	SURDL-92*	-	-	-
2600	.50	1.12	SURD-121	SLRD-121	STRD-121	SCRD-122
2600	1.25	1.87	SURDL-121	-	-	-
4200	.55	1.10	SURD-201	SLRD-201	STRD-201	-
7600	.63	1.18	SURD-351	SLRD-351	STRD-351	-
7600	1.25	1.83	SURDL-351*	-	-	-
▼ Collet Lok® positive locking						
			Model number ²⁾			
1000	.32	.94	-	WPFR-50	-	-
2000	.47	1.10	-	WPFR-100	WPTR-100	-
8500	.39	1.65	-	WPFR-300*	WPTR-300*	-

¹⁾ With standard clamp arm. Clamp arms are sold separately (126). Clamping forces for single-acting models are reduced in order to overcome return spring force. ²⁾ For left turning swing cylinders replace the R in the model number for an L. **Note:** Call Enerpac to order models with metric thread and BSPP port connections.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Force: 500 - 8500 lbs

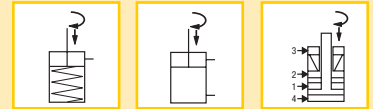
Stroke: .32 - 1.87 inch

Pressure: 500 - 5000 psi

E Cilindros giratorios

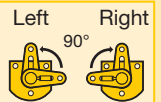
F Vérins de bridage pivotants

D Schwenkspannzylinder



Options

Available as both left and right turning



Clamp arms

26 ▶



Work supports

32 ▶



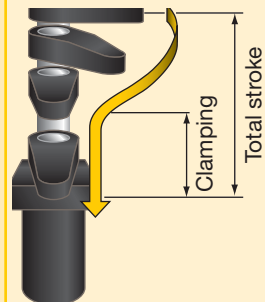
Accessories

78 ▶



Important

Actual clamping may only take place when the cylinder has completed its 90° swing.



All swing cylinders have swing angle repeatability of ± 1°.

Other swing angles available upon request.

Contact Enerpac for info.

Swing cylinders - Upper flange model

Shown: SURS-201, SURS-51

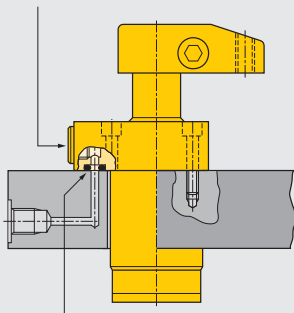
Swing cylinders
Work supports



SU series

The Enerpac upper flange swing cylinders are designed for integrated manifold mounting solutions. Hydraulic connections are made through SAE or BSPP oil connection or the standard integrated O-ring ports.

SAE oil connection



Integrated O-ring port

■ Enerpac upper flange swing clamps integrated into a fully automated machining system.



Minimal mounting height

...when space is at a premium

- Flexible design allows for manifold or threaded port connection
- Low profile mounting style allows body to be below mounting surface
- Simple mounting preparation and easy installation – 3 or 4 mounting bolts
- Double oil connection – threaded port or manifold mount
- Symmetrical rectangular flange design enables clamping at three sides of the cylinder
- 30, 45, and 60 degree swing angles available on request

Product selection

Clamping force ¹⁾	Stroke		Left turning 90° 	Right turning 90° 	Cylinder effective area		Oil capacity		Max. oil flow ¹⁾	Standard clamp arm
	in				in ²		in ³			
	lbs	Clamp			Clamp	Un-clamp	Clamp	Un-clamp		
▼ Single acting			Model number ²⁾							
475	.32	.65	SULS-21	SURS-21	.12	–	.08	–	12	CAS-21
1100	.39	.89	SULS-51	SURS-51	.28	–	.25	–	25	CAS-51
1800	.47	.87	SULS-92	SURS-92	.49	–	.42	–	60	CAS-92
2400	.50	1.12	SULS-121	SURS-121	.63	–	.70	–	100	CAS-121
3900	.55	1.10	SULS-201	SURS-201	1.10	–	1.22	–	140	CAS-201
7450	.63	1.18	SULS-351	SURS-351	1.92	–	2.27	–	240	CAS-351
▼ Double acting			Model number ²⁾							
500	.32	.65	SULD-21	SURD-21	.12	.24	.08	.16	12	CAS-21
1250	.39	.89	SULD-51	SURD-51	.28	.59	.25	.53	25	CAS-51
2025	.47	.87	SULD-92	SURD-92	.49	1.25	.42	1.08	60	CAS-92
2025	1.26	1.65	SULD-92*	SURDL-92*	.49	1.25	.81	1.86	60	CAS-92
2600	.50	1.12	SULD-121	SURD-121	.63	1.23	.70	1.40	100	CAS-121
2600	1.25	1.87	SULD-121	SURDL-121	.63	1.23	.97	2.30	100	CAS-121
4200	.55	1.10	SULD-201	SURD-201	1.10	2.35	1.22	2.60	140	CAS-201
7600	.63	1.18	SULD-351	SURD-351	1.92	3.68	2.27	4.35	240	CAS-351
7600	1.25	1.83	SULD-351*	SURDL-351*	1.92	3.68	3.53	6.77	240	CAS-351

¹⁾ With standard clamp arm. Clamp arms are sold separately (□ 26). Clamping forces for single-acting models are reduced in order to overcome return spring force.

²⁾ For models with straight plunger movement, replace L or R with S.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Note: Call Enerpac to order models with BSPP port connections.

Dimensions in inches []

Left turning models	A	B	C	C1	D	D1	D2	F	H	K	M
					Ø			Ø			
▼ Single acting											
SULS-21	4.41	2.32	1.04	1.69	1.10	1.86	1.77	.39	.43	.63	–
SULS-51	5.31	2.71	1.08	1.97	1.37	2.13	2.25	.63	.39	.75	–
SULS-92	5.67	3.00	1.10	1.97	1.88	2.76	2.13	.98	.51	.98	.61
SULS-121	6.75	3.37	1.06	2.18	1.87	2.63	2.88	.87	.39	1.19	–
SULS-201	6.57	3.46	1.10	2.20	2.46	3.35	2.76	1.26	.51	1.18	.93
SULS-351	7.46	3.97	1.10	2.28	3.02	3.94	3.50	1.50	.51	1.58	1.10
▼ Double acting											
SULD-21	4.41	2.32	1.04	1.69	1.10	1.86	1.77	.39	.43	.63	–
SULD-51	5.31	2.71	1.08	1.97	1.37	2.13	2.25	.63	.39	.75	–
SULD-92	5.67	3.00	1.10	1.97	1.88	2.76	2.13	.98	.51	.98	–
SULD-92*	7.24	3.78	1.10	2.75	1.88	2.76	2.13	.98	.51	.98	–
SULD-121	6.75	3.37	1.06	2.18	1.87	2.63	2.88	.87	.39	1.19	–
SULD-121	9.00	4.12	1.06	2.93	1.87	2.62	2.88	.87	.39	1.19	–
SULD-201	6.56	3.45	1.10	2.20	2.46	3.35	2.76	1.26	.51	1.18	–
SULD-351	7.45	3.96	1.10	2.28	3.02	3.94	3.50	1.50	.51	1.58	–
SULD-351*	8.69	4.58	1.10	2.93	3.02	3.94	3.50	1.50	.51	1.58	–

NOTE: dimensions shown with standard clamp arm.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

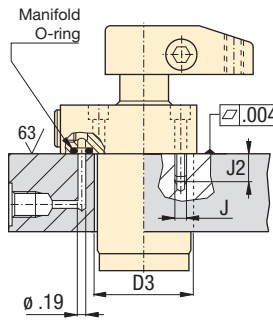


Installation dimensions in inches

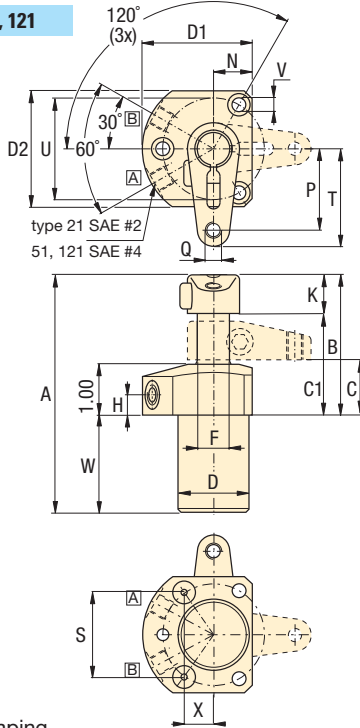
Clamping force ¹⁾ lbs	Fixture hole Ø D3	Mounting thread J UNF	Min. depth J2	Manifold O-ring ²⁾ ARP number or inside Ø x thickness
500	1.110	#10-32	.65	568-010
1250	1.380	.250-28	.65	568-011
2025	1.895	M6	.59	.17 x .139
2600	1.880	.312-24	.80	568-011
4200	2.475	.312-24	.67	.17 x .139
7600	3.035	.375-24	.74	.17 x .139

¹⁾ With standard clamp arm.

²⁾ Polyurethane, 92 Durometer

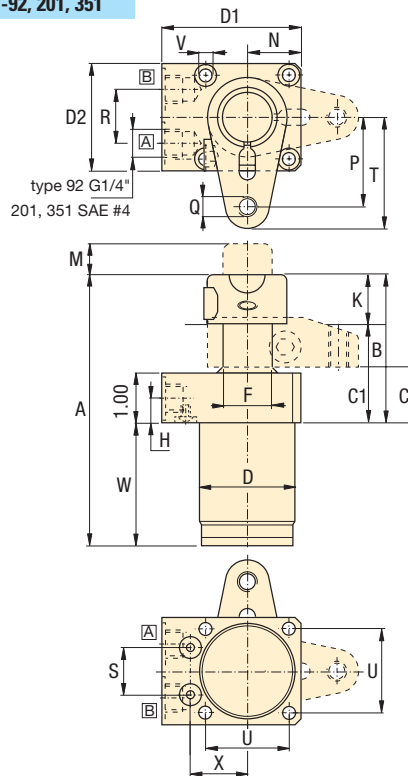
Note: Mounting bolts and O-rings included.


-21, 51, 121



A = Clamping
B = Unclamping
(venting)

-92, 201, 351

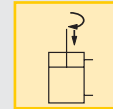
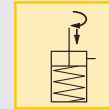


Force: 500 - 7600 lbs

Stroke: .32 - 1.87 inch

Pressure: 500 - 5000 psi

- E** Cilindros giratorios
- F** Vérins de bridage pivotants
- D** Schwenkspannzylinder



Options

Clamp arms

26 ▶



Work supports

32 ▶


Collet-Lok®
swing cylinders

24 ▶



Accessories

78 ▶



Important

30, 45, and 60 degree rotations are available upon request. Add -30, -45 or -60 to end of standard model number to order directly from Enerpac. To order rotation limiter separately, see page 26.

Custom cylinders including longer stroke lengths are available on request.

In case there is a risk of machining coolants and debris being inhaled via the breather vent, it is recommended to pipe this port to an area outside the fixture that is protected from machining coolants and debris.

Do not exceed maximum flow rates.

N	P	Q	R	S	T	U	V	W	X	Right turning models
UN						Ø				lbs
Single acting ▼										
.61	.96	.250-20	-	0.825	1.20	1.58	.225	2.09	0.714	1.0 SURS-21
.75	1.58	.312-18	-	1.614	1.90	1.97	.268	2.60	0.565	2.5 SURS-51
1.06	1.77	M10x1,5	1.02	0.934	2.20	1.65	.270	2.68	1.128	4.4 SURS-92
1.00	2.00	.375-16	-	2.048	2.40	2.50	.347	3.38	0.717	3.5 SURS-121
1.38	2.17	.500-13	1.02	1.145	2.80	2.16	.335	3.11	1.382	7.7 SURS-201
1.75	2.68	.625-11	1.02	1.370	3.30	2.76	.425	3.48	1.634	12.1 SURS-351
Double acting ▼										
.61	.96	.250-20	-	0.825	1.20	1.58	.225	2.09	0.714	1.0 SURD-21
.75	1.58	.312-18	-	1.614	1.90	1.97	.268	2.60	0.565	2.5 SURD-51
1.06	1.77	M10x1,5	1.02	0.934	2.20	1.65	.270	2.68	1.128	4.4 SURD-92
1.06	2.00	M10x1,5	1.02	0.934	2.20	1.65	.270	3.46	1.128	5.7 SURDL-92*
1.00	2.00	.375-16	-	2.048	2.40	2.50	.347	3.38	0.717	3.5 SURD-121
1.00	2.00	.375-16	-	2.048	2.40	2.50	.347	4.88	0.717	4.0 SURDL-121
1.38	2.17	.500-13	1.02	1.145	2.80	2.16	.335	3.11	1.382	7.7 SURD-201
1.75	2.68	.625-11	1.02	1.370	3.30	2.76	.425	3.48	1.634	12.1 SURD-351
1.75	2.68	.625-11	1.02	1.370	3.30	2.76	.425	4.11	1.634	15.1 SURDL-351*

NOTE: U = bolt circle

Swing cylinders - Lower flange models

Shown: SLRD-51, SLRS-201

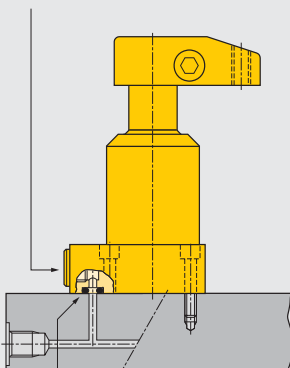
Swing cylinders
Work supports



SL series

Enerpac lower flange series swing cylinders can be bolted to the fixture, allowing easy installation of the unit and does not require machined fixture holes. Hydraulic connections are made through SAE or BSPP oil connection or the standard integrated O-ring ports.

SAE oil connection



Integrated O-ring port

■ Lower flange swing cylinders mounted to the face of the fixture.



No fixture hole required

...cylinder can be bolted directly to fixture

- Flexible design allows for manifold or threaded port connection
- No fixture hole preparation required
- Easiest mounting preparation in the swing cylinder line
- Symmetrical rectangular flange design enables clamping at three sides of the cylinder
- Allows extra large parts to be clamped
- 30, 45 and 60 degree swing angles available on request

Product selection

Clamping force ¹⁾		Stroke	Left turning 90° 	Right turning 90° 	Cylinder effective area		Oil capacity		Max. oil flow ¹⁾	Standard clamp arm Sold separately  26 ▶	
lbs	Clamp	Total			in ²	Un-clamp	in ³	Un-clamp			
▼ Single acting											
					Model number ²⁾						
475	.32	.65	SLLS-21	SLRS-21	.12	–	.08	–	12	CAS-21	
1100	.39	.89	SLLS-51	SLRS-51	.28	–	.25	–	25	CAS-51	
1800	.47	.87	SLLS-92	SLRS-92	.49	–	.42	–	60	CAS-92	
2400	.50	1.12	SLLS-121	SLRS-121	.63	–	.70	–	100	CAS-121	
3900	.55	1.10	SLLS-201	SLRS-201	1.10	–	1.22	–	140	CAS-201	
7450	.63	1.18	SLLS-351	SLRS-351	1.92	–	2.27	–	240	CAS-351	
▼ Double acting			Model number ²⁾								
500	.32	.65	SLLD-21	SLRD-21	.12	.24	.08	.15	12	CAS-21	
1250	.39	.89	SLLD-51	SLRD-51	.28	.59	.25	.52	25	CAS-51	
2025	.47	.87	SLLD-92	SLRD-92	.49	1.25	.42	1.08	60	CAS-92	
2600	.50	1.12	SLLD-121	SLRD-121	.63	1.23	.70	1.40	100	CAS-121	
4200	.55	1.10	SLLD-201	SLRD-201	1.10	2.35	1.22	2.60	140	CAS-201	
7600	.63	1.18	SLLD-351	SLRD-351	1.92	3.68	2.27	4.35	240	CAS-351	

¹⁾ With standard clamp arm. Clamp arms are sold separately (26). Clamping forces for single-acting models are reduced in order to overcome return spring force.

²⁾ For models with straight plunger movement, replace L or R with S.

Note: Call Enerpac to order models with BSPP port connections.

Dimensions in inches []

Left turning models	A	C	C1	D	D1	D2	F	H	K	M	
				Ø				Ø			
	▼ Single acting										
SLLS-21	4.41	3.13	3.78	1.10	1.86	1.77	.39	.54	.63	–	
SLLS-51	5.31	3.68	4.57	1.37	2.13	2.25	.63	.55	.75	–	
SLLS-92	5.94	4.09	4.96	1.88	2.76	2.13	.98	.49	.98	.61	
SLLS-121	6.75	4.44	5.56	1.87	2.63	2.88	.87	.62	1.19	–	
SLLS-201	6.88	4.48	5.63	2.51	3.35	2.76	1.26	.49	1.18	.93	
SLLS-351	7.77	4.85	5.94	3.14	3.94	3.50	1.50	.49	1.58	1.10	
▼ Double acting											
SLLD-21	4.41	3.13	3.78	1.10	1.86	1.77	.39	.54	.63	–	
SLLD-51	5.31	3.68	4.57	1.37	2.13	2.25	.63	.55	.75	–	
SLLD-92	5.94	4.09	4.96	1.87	2.76	2.13	.98	.49	.98	–	
SLLD-121	6.75	4.44	5.56	1.87	2.63	2.88	.87	.62	1.19	–	
SLLD-201	6.88	4.48	5.63	2.51	3.35	2.76	1.26	.49	1.18	–	
SLLD-351	7.77	4.85	5.94	3.14	3.94	3.50	1.50	.49	1.58	–	

NOTE: dimensions shown with standard clamp arm.



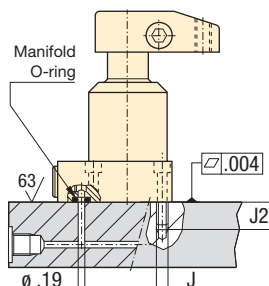
Installation dimensions in inches

Clamping force ¹⁾ lbs	Mounting thread J	Minimum thread depth J2	Manifold O-ring ²⁾ ARP number or inside Ø x thickness
500	#10-32	.65	568-010
1250	.250-28	.65	568-011
2025	M6	.59	.17 x .139
2600	.312-24	.80	568-011
4200	.312-24	.67	.17 x .139
7600	.375-24	.74	.17 x .139

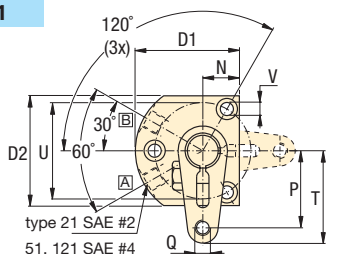
¹⁾ With standard clamp arm.

²⁾ Polyurethane, 92 Durometer

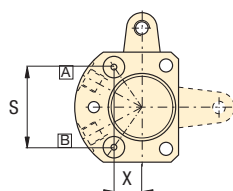
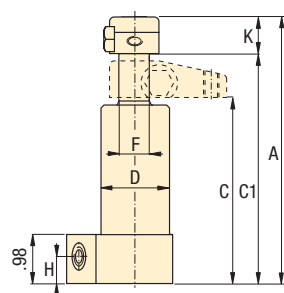
Note: Mounting bolts and O-rings included.



-21, 51, 121

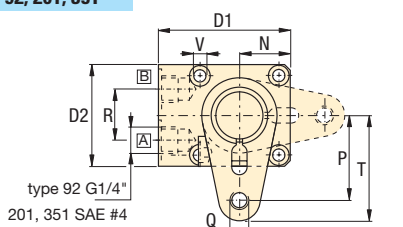


type 21 SAE #2
51, 121 SAE #4

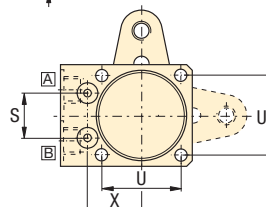
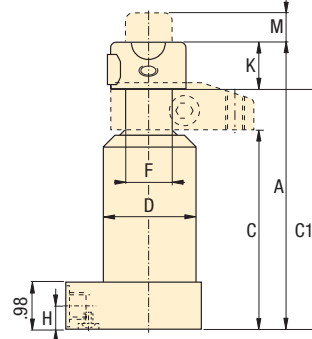


[A] = Clamping
[B] = Unclamping (venting)

-92, 201, 351



type 92 G1/4"
201, 351 SAE #4



Force: 500 - 7600 lbs

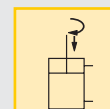
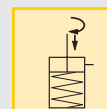
Stroke: .32 - 1.18 inch

Pressure: 500 - 5000 psi

E Cilindros giratorios

F Vérins de bridage pivotants

D Schwenkspannzylinder



Options

Clamp arms

26 ▶



Work supports

32 ▶



Collet-Lok®
swing cylinders

24 ▶



Accessories

78 ▶



Important

30, 45, and 60 degree rotations are available upon request. Add -30, -45 or -60 to end of standard model number to order directly from Enerpac. To order rotation limiter separately, see page 26.

Custom cylinders including longer stroke lengths are available on request.

In case there is a risk of machining coolants and debris being inhaled via the breather vent, it is recommended to pipe this port to an area outside the fixture that is protected from machining coolants and debris.

Do not exceed maximum flow rates.

N	P	Q	R	S	T	U	V	X		Right turning models
UN									ø	lbs
Single acting ▼										
.61	.96	.250-20	–	0.825	1.22	1.58	.22	0.714	1.0	SLRS-21
.75	1.58	.312-18	–	1.614	1.89	1.97	.27	0.565	2.5	SLRS-51
1.06	1.77	M10x1,5	1.02	0.934	2.20	1.65	.27	1.128	4.4	SLRS-92
1.00	2.00	.375-16	–	2.048	2.43	2.50	.35	0.717	3.5	SLRS-121
1.38	2.17	.500-13	1.02	1.145	2.76	2.16	.33	1.382	7.7	SLRS-201
1.75	2.68	.625-11	1.02	1.370	3.27	2.76	.42	1.634	12.1	SLRS-351
Double acting ▼										
.61	.96	.250-20	–	0.825	1.22	1.58	.22	0.714	1.0	SLRD-21
.75	1.58	.312-18	–	1.614	1.89	1.97	.27	0.565	2.5	SLRD-51
1.06	1.77	M10x1,5	1.02	0.934	2.20	1.65	.27	1.128	4.4	SLRD-92
1.00	2.00	.375-16	–	2.048	2.43	2.50	.35	0.717	3.5	SLRD-121
1.38	2.17	.500-13	1.02	1.145	2.76	2.16	.33	1.382	7.7	SLRD-201
1.75	2.68	.625-11	1.02	1.370	3.27	2.76	.42	1.634	12.1	SLRD-351

NOTE: U = bolt circle

Swing cylinders - Threaded body models

Shown: STRD-51, STRD-201

Swing cylinders
Work supports



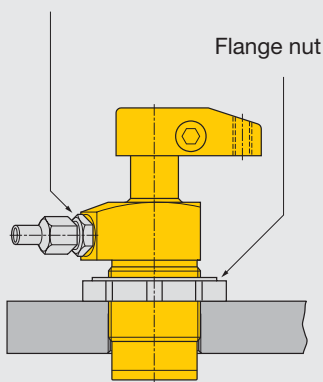
ST series

Enerpac threaded body swing cylinders are threaded directly into the fixture.

The cylinder height is adjusted to the appropriate height, and then locked in place using a flange nut (□78).

SAE oil connection

Flange nut



■ Threaded body swing cylinders allow the clamp to be buried in the fixture to minimize the required area, while the height remains adjustable.



Cylinders can be threaded directly into fixture

...can be secured at any height

- Body thread for precise cylinder height positioning
- Threaded port connection
- Easy installation and removal
- Greatest flexibility in fixture design
- 30, 45 and 60 degree swing angles available on request

Product selection

Clamping force ¹⁾	Stroke		Left turning 90°	Right turning 90°	Cylinder effective area		Oil capacity		Max. oil flow ¹⁾	Standard clamp arm
	lbs	Clamp			in ²	Un-clamp	in ³	Un-clamp		
					Clamp	Clamp	Clamp	Clamp	in ³ /min	Sold separately □26 ▶
▼ Single acting										
			Model number ²⁾							
475	.32	.65	STLS-21	STRS-21	.12	–	.08	–	12	CAS-21
1100	.39	.89	STLS-51	STRS-51	.28	–	.25	–	25	CAS-51
1800	.47	.87	STLS-92	STRS-92	.49	–	.42	–	60	CAS-92
2400	.50	1.12	STLS-121	STRS-121	.63	–	.70	–	100	CAS-121
3900	.55	1.10	STLS-201	STRS-201	1.10	–	1.22	–	140	CAS-201
7450	.63	1.18	STLS-351	STRS-351	1.92	–	2.27	–	240	CAS-351
▼ Double acting										
			Model number ²⁾							
500	.32	.65	STLD-21	STRD-21	.12	.24	.08	.15	12	CAS-21
1250	.39	.89	STLD-51	STRD-51	.28	.59	.25	.52	25	CAS-51
2025	.47	.87	STLD-92	STRD-92	.49	1.25	.42	1.08	60	CAS-92
2600	.50	1.12	STLD-121	STRD-121	.63	1.23	.70	1.40	100	CAS-121
4200	.55	1.10	STLD-201	STRD-201	1.10	2.35	1.22	2.60	140	CAS-201
7600	.63	1.18	STLD-351	STRD-351	1.92	3.68	2.27	4.35	240	CAS-351

¹⁾ With standard clamp arm. Clamp arms are sold separately (□26). Clamping forces for single-acting models are reduced in order to overcome return spring force.

²⁾ For models with straight plunger movement, replace L or R with S.

Note: Call Enerpac to order models with BSPP port connections.

Dimensions in inches [□]

Left turning models	A	B	C	C1	C2	D	D1	D2	F	H	J1
						Ø			Ø		
▼ Single acting											
STLS-21	4.41	2.32	1.04	1.69	.98	1.125-16 UNF	1.55	1.30	.39	.39	2.09
STLS-51	5.31	2.71	1.08	1.97	.98	1.375-18 UNF	1.87	1.50	.63	.38	2.60
STLS-92	5.67	3.20	1.30	2.17	1.18	M48 x 1,5	2.46	1.89	.98	.51	1.69
STLS-121	6.75	3.37	1.06	2.18	1.00	1.875-16 UNF	2.38	2.00	.87	.38	3.38
STLS-201	6.57	3.74	1.38	2.48	1.26	2.500-16 UNF	2.99	2.56	1.26	.51	2.06
STLS-351	7.46	4.24	1.38	2.56	1.27	3.125-16 UNF	3.48	3.15	1.50	.51	2.57
▼ Double acting											
STLD-21	4.41	2.32	1.04	1.69	.98	1.125-16 UNF	1.55	1.30	.39	.39	2.09
STLD-51	5.31	2.71	1.08	1.97	.98	1.375-18 UNF	1.87	1.50	.63	.38	2.60
STLD-92	5.67	3.20	1.30	2.17	1.18	M48 x 1,5	2.46	1.89	.98	.51	1.69
STLD-121	6.75	3.37	1.06	2.18	1.00	1.875-16 UNF	2.38	2.00	.87	.38	3.38
STLD-201	6.57	3.74	1.38	2.48	1.26	2.500-16 UNF	2.99	2.56	1.26	.51	2.06
STLD-351	7.46	4.24	1.38	2.56	1.27	3.125-16 UNF	3.48	3.15	1.50	.51	2.57

NOTE: dimensions shown with standard clamp arm.



Accessory Chart

Model Nos.		Mounting flange	Flange nut
Left turning	Right turning		
	 90°	Sold Separately □ 79	Sold Separately □ 78

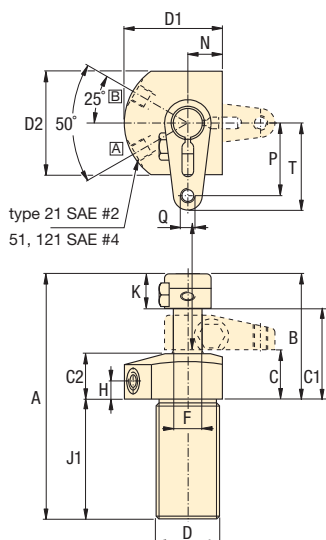
▼ Single acting

STRS-21	STRS-21	—	MF-281	FN-281
STRS-51	STRS-51	AW-5	MF-351	FN-351
STRS-92	STRS-92	—	MF-482	FN-482
STRS-121	STRS-121	AW-89	MF-481	FN-481
STRS-201	STRS-201	AW-19	MF-651	FN-651
STRS-351	STRS-351	AW-90	MF-801	FN-801

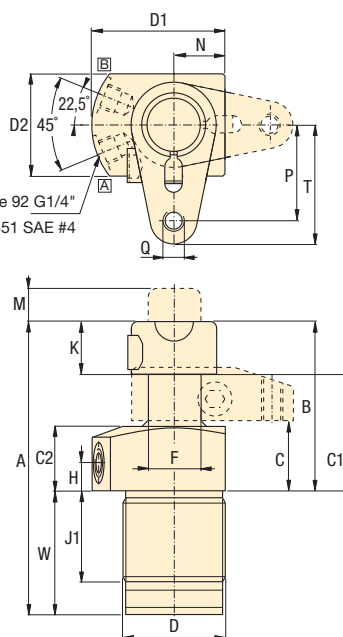
▼ Double acting

STRD-21	STRD-21	—	MF-281	FN-281
STRD-51	STRD-51	AW-5	MF-351	FN-351
STRD-92	STRD-92	—	MF-482	FN-482
STRD-121	STRD-121	AW-89	MF-481	FN-481
STRD-201	STRD-201	AW-19	MF-651	FN-651
STRD-351	STRD-351	AW-90	MF-801	FN-801

-21, 51, 121

type 21 SAE #2
51, 121 SAE #4

-92, 201, 351

type 92 G1/4"
201, 351 SAE #4

[A] = Clamping
[B] = Unclamping (venting)

	K	M	N	P	Q	T	W	 lbs	Right turning models
Single acting ▼									
	.63	—	.61	.96	.250-20 unc	1.22	—	1.1	STRS-21
	.75	—	.75	1.58	.312-18 unc	1.89	—	2.5	STRS-51
	.98	.61	.94	1.77	M10 x 1,5	2.20	2.48	4.4	STRS-92
	1.19	—	1.00	2.00	.375-16 unc	2.43	—	3.5	STRS-121
	1.18	.93	1.28	2.17	.500-13 unc	2.76	2.83	7.1	STRS-201
	1.58	1.10	1.57	2.68	.625-11 unc	3.27	3.21	12.1	STRS-351
Double acting ▼									
	.63	—	.61	.96	.250-20 unc	1.22	—	1.1	STRD-21
	.75	—	.75	1.58	.312-18 unc	1.89	—	2.5	STRD-51
	.98	—	.94	1.77	M10 x 1,5	2.20	2.48	4.4	STRD-92
	1.19	—	1.00	2.00	.375-16 unc	2.43	—	3.5	STRD-121
	1.18	—	1.28	2.17	.500-13 unc	2.76	2.83	7.7	STRD-201
	1.58	—	1.57	2.68	.625-11 unc	3.27	3.21	12.1	STRD-351

Force: 500 - 7600 lbs

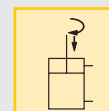
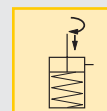
Stroke: .32 - 1.18 inch

Pressure: 500 - 5000 psi

E Cilindros giratorios

F Vérins de bridage pivotants

D Schwenkspannzylinder



Options

Clamp arms

□ 26 ▶



Work supports

□ 32 ▶



Collet-Lok® swing cylinders

□ 24 ▶



Accessories

□ 78 ▶



Important

30, 45, and 60 degree rotations are available upon request. Add -30, -45 or -60 to end of standard model number to order directly from Enerpac. To order rotation limiter separately, see page 26.

Custom cylinders including longer stroke lengths are available on request.

In case there is a risk of machining coolants and debris being inhaled via the breather vent, it is recommended to pipe this port to an area outside the fixture that is protected from machining coolants and debris.

Do not exceed maximum flow rates.

Swing cylinders - Cartridge models

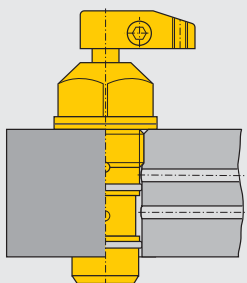
Shown: SCRD-122, SCRD-52



SC series

Enerpac cartridge swing cylinders are designed for integrated manifold mounting. This eliminates the need for fittings and tubing on the fixture.

Cartridge swing cylinders simplify mounting and optimize clamping effectiveness.



Hydraulic fixture with components on two faces for more efficient production.

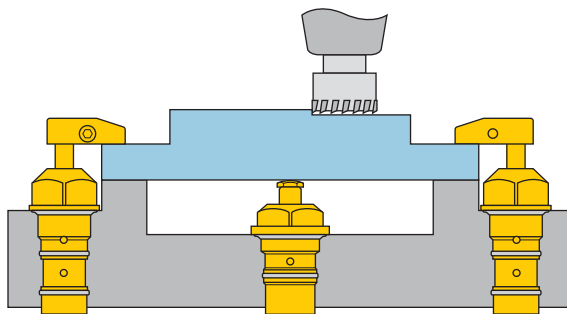


Eliminates the need for tubing and fittings

...cylinders can be designed into narrow fixture plates as thru-hole mounting is fully functional

- Minimal space required on fixture
- Can be completely recessed in fixture
- External plumbing not required
- Allows close positioning of adjoining units
- 30, 45 and 60 degree swing angles available on request

i Enerpac compact design cartridge model swing cylinders used in conjunction with a cartridge model work support in a typical clamping application.



Product selection

Clamping force ¹⁾		Stroke	Left turning		Right turning		Cylinder effective area		Oil capacity		Max. oil flow ¹⁾	Standard clamp arm	
in					90°			in ²		in ³		Sold separately	
lbs	Clamp	Total						Clamp	Un-clamp	Clamp	Un-clamp	in ³ /min	 26 ▶
▼ Single acting			Model number ²⁾										
475	.32	.65	SCLS-22	SCRS-22	.12	-	.08	-	12	CAS-21			
1100	.39	.89	SCLS-52	SCRS-52	.28	-	.25	-	25	CAS-51			
2400	.50	1.12	SCLS-122	SCRS-122	.63	-	.70	-	100	CAS-121			
▼ Double acting			Model number ²⁾										
500	.32	.65	SCLD-22	SCRD-22	.12	.24	.08	.15	12	CAS-21			
1250	.39	.89	SCLD-52	SCRD-52	.28	.59	.25	.52	25	CAS-51			
2600	.50	1.12	SCLD-122	SCRD-122	.63	1.23	.70	1.40	100	CAS-121			

¹⁾ With standard clamp arm. Clamp arms are sold separately (□26). Clamping forces for single-acting models are reduced in order to overcome return spring force.

²⁾ For models with straight plunger movement, replace L or R with S.

Dimensions in inches [□]

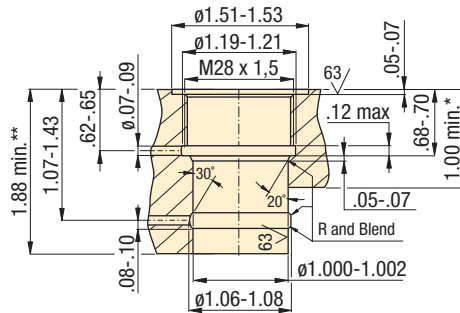
Left turning models	A	B	C	C1	C2	D1	D2	E	F
						Ø	Ø	hexagon	
▼ Single acting									
SCLS-22	4.41	2.18	.90	1.55	.84	1.50	1.00	1.38	.39
SCLS-52	5.31	3.13	1.49	2.25	1.27	2.25	1.37	2.00	.63
SCLS-122	6.75	3.69	1.38	2.50	1.32	3.00	2.25	2.75	.87
▼ Double acting									
SCLD-22	4.41	2.18	.90	1.55	.84	1.50	1.00	1.38	.39
SCLD-52	5.31	3.00	1.36	2.25	1.27	2.25	1.37	2.00	.63
SCLD-122	6.75	3.69	1.38	2.50	1.32	3.00	2.25	2.75	.87

NOTE: dimensions shown with standard clamp arm.

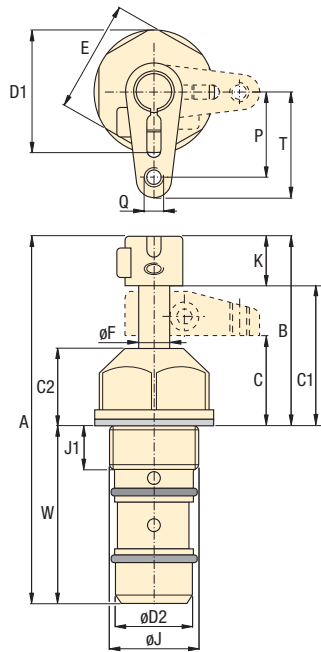


Installation dimensions in inches

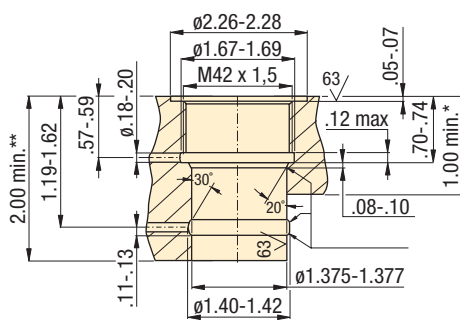
-22 models



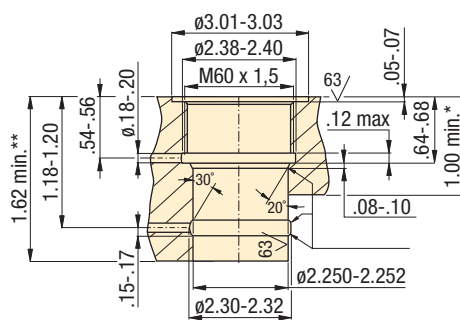
-22, 52, 122 models



-52 models



-122 models



* Minimum plate height for single-acting models.

** Minimum plate height for double-acting models.

J	J1	K	P	Q	T	W	lbs	Right turning models
								Single acting ▼
M28 x 1,5	.59	.63	.96	.250-20 UNC	1.22	2.23	1.0	SCRS-22
M42 x 1,5	.66	.75	1.58	.312-18 UNC	1.89	2.31	2.0	SCRS-52
M60 x 1,5	.62	1.19	2.00	.375-16 UNC	2.43	2.94	5.5	SCRS-122
								Double acting ▼
M28 x 1,5	.59	.63	.96	.250-20 UNC	1.22	2.23	1.0	SCRD-22
M42 x 1,5	.66	.75	1.58	.312-18 UNC	1.89	2.31	2.0	SCRD-52
M60 x 1,5	.62	1.19	2.00	.375-16 UNC	2.43	2.96	5.5	SCRD-122

Force: 475 - 2600 lbs

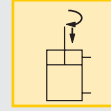
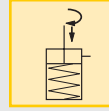
Stroke: .65 - 1.12 inch

Pressure: 500 - 5000 psi

E Cilindros giratorios

F Vérins de bridage pivotants

D Schwenkspannzylinder



Options

Clamp arms

26 ▶



Work supports

32 ▶



Collet-Lok® swing cylinders

24 ▶



Accessories

78 ▶



Sequence valves

136 ▶



Important

30, 45, and 60 degree rotations are available upon request. Add -30, -45 or -60 to end of standard model number to order directly from Enerpac. To order rotation limiter separately, see page 26.

Custom cylinders including longer stroke lengths are available on request.

In case there is a risk of machining coolants and debris being inhaled via the breather vent, it is recommended to pipe this port to an area outside the fixture that is protected from machining coolants and debris.

Do not exceed maximum flow rates.

Shown: SC-3, SC-1

Swing cylinders
Work supports

09-0203



SC series

These swing cylinders rotate 90° as they begin their stroke, continuing without rotation for the final clamping stroke. Cylinders can be changed to left swing, right swing, or pull applications by loosening the side plug and then rotating the plunger to a desired position.

The **SC-1** and **SC-3** include a retract spring for single-acting operation. Both cylinders can be operated as double-acting cylinders by connecting a retract line to the vent port.

Changeable swing function

...with 360° fully adjustable clamp arm

- Changeable swing function: clamp arm movement can be adjusted to left or right swing, or straight pull function
- 88-92° clamp arm swing arc
- Easy installation: built-in mountings and brackets
- Compact design for use in limited space applications
- Easy and precise locating of arm for clamp positioning
- Single or double-acting cylinders to suit variety of hydraulic requirements

Force: 500 - 2100 lbs

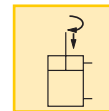
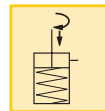
Stroke: .25 - .50 inch

Pressure: 1500 - 3000 psi

E Cilindros giratorios

F Vérins de bridage pivotants

D Schwenkspannzylinder



Selection chart

Clamping force ¹⁾	Stroke		Model number	Cylinder effective area		Oil capacity	
	lbs	in		in ²	in ³	in ³	in ³
2164	.50	1.50	SC-1	.98	1.767	1.47	2.65
500	.25	.75	SC-3	.245	.442	.184	.331

¹⁾ With standard clamp arm (included with cylinder).

Note: - Long clamps arms can be fabricated by the user.
- For long clamp arms, use VFC series flow control valves.

SC-1

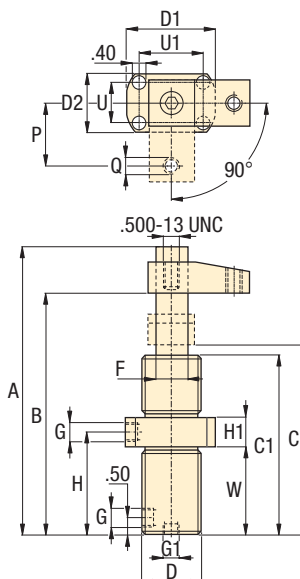
Arm length in	Max. pressure psi	Clamping force lbs
-	3000	2640
2.00 ²⁾	3000	2164
3.00	3000	1960
4.00	3000	1740
5.00	2400	1200
6.00	2000	840

SC-3

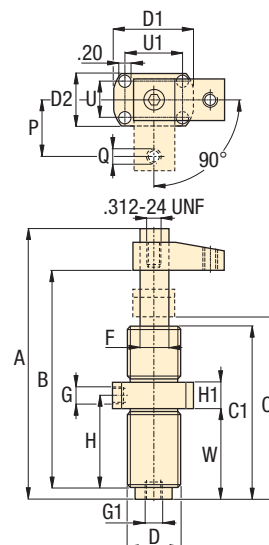
Arm length in	Max. pressure psi	Clamping force lbs
-	3000	700
1.00 ²⁾	3000	500
2.00	2000	250

²⁾ Standard clamp arm (included).

SC-1



SC-3



Product dimensions in inches []

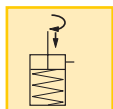
Model number	A	B	C	C1	D	D1	D2	F	G	G1	H	H1	P	Q	U	U1	W	lbs
					UN				NPT	NPT				UN				
SC-1	8.88	7.37	5.87	5.74	1.875-16	2.90	1.88	1.00	.250-18	.125-27	3.31	.88	2.00	.38-16	1.28	2.06	2.87	6
SC-3	5.27	4.26	3.71	3.48	1.00-12	2.00	1.13	.50	.125-27	.125-27	2.15	.63	1.00	.250-20	.75	1.50	2.03	2

Force: 1375 - 4375 lbs

Stroke: .25 - .43 inch

Pressure: 1200 - 2500 psi

- (E) Cilindros giratorios
- (F) Vérins de bridage pivotants
- (D) Schwenkspannzylinder

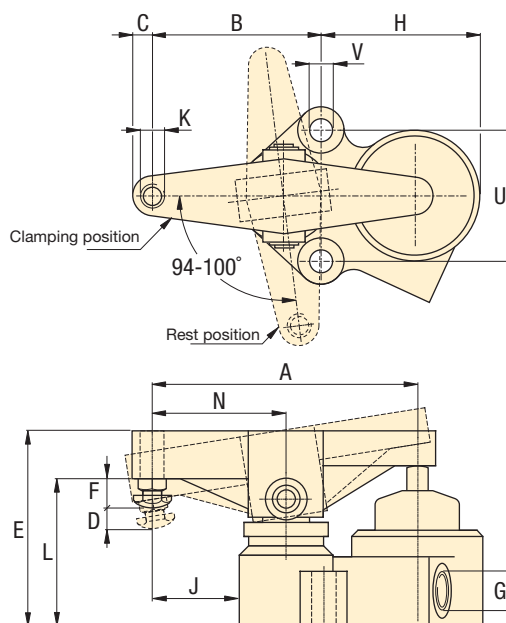


Adjustable clamping stroke

...turns clockwise or counter-clockwise

- Adjustable bolt in clamp arm for clamping stroke adjustment
- Low profile, ideal for limited space applications
- Quick swing action allows clamp arm to swing free of cutter and reclamp after it has passed
- 94-100° clamp arm swing arc

ASC-30, -100



Selection chart

Cylinder capacity	Stroke	Model number	Operating pressure	Cylinder effective area	Oil capacity	Max. oil flow	
lbs	in		psi	in ²	in ³	in ³ /min	lbs
1375	.25	ASC-30	1200 - 2500	.55	.30	115	6
4375	.43	ASC-100	1200 - 2500	1.76	1.22	115	18

Product dimensions in inches []

Model number	A	B	C	D	E	F	G	H	J	K	L	N	U	V
					NPT				UN				Ø	
ASC-30	5.00	3.38	.50	.25	3.50	.75	.125-27	2.75	1.63	.500-13	2.75	2.50	2.50	.41
ASC-100	7.00	4.50	.53	.43	5.25	.73	.125-27	4.25	2.25	.500-13	4.00	3.50	3.50	.63

Shown: ASC-30



ASC series

Clamping arm rotates 97° clockwise or counter-clockwise (requires easily changed rotation spring) to position itself over the workpiece. Then, a vertical plunger exerts an upward thrust on the back end of the swing arm providing a powerful downward pressure to clamp the workpiece.

Important

For high cycle applications use double-acting cylinders.

View of a machining fixture with ASC-30 clamping cylinders.



Three-position swing cylinder *Application & selection*

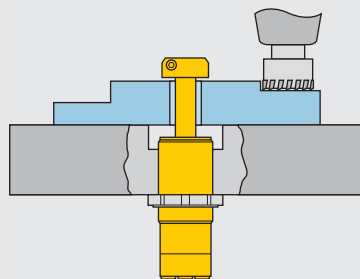
Shown: WTR-24

Swing cylinders
Work supports



WTR series

The three position swing cylinder rotates 90° only after the plunger has completely extended. This feature allows the clamp to be mounted beneath the workpiece, where the clamp travels through the part for clamping.

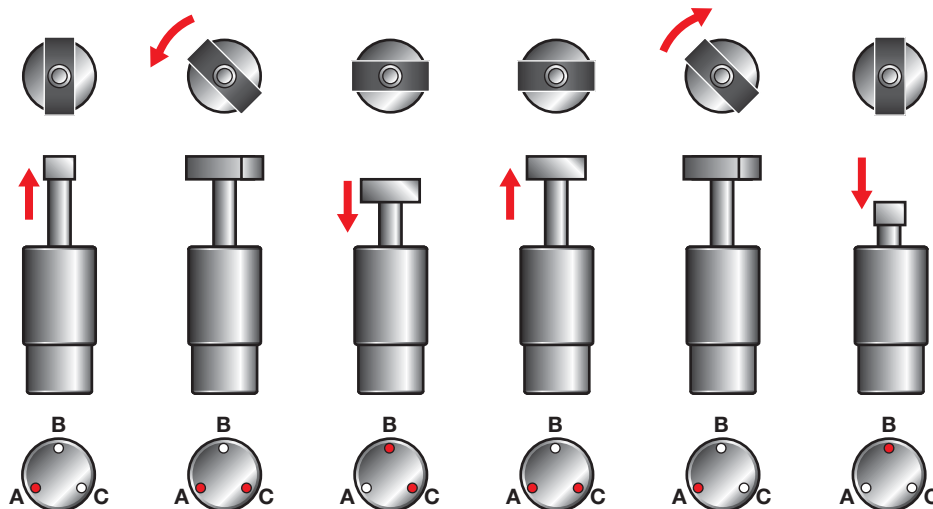


Unobstructed part loading

- Plunger rotates only when cylinder is fully extended, to minimize obstructions
- Ideal for mounting beneath the fixture, as the clamp does not rotate until the workpiece has been cleared
- Stainless steel body for additional corrosion resistance
- Three port design for fewer hydraulic connections
- Fully threaded body for easy installation
- Standard two sided clamp arm included
- Clamp arm design makes mounting easy

Operation sequence

The three position swing cylinder is ideal for parts which have a through hole. The clamp allows completely unobstructed part loading.



Step 1

Pressurize port A. Plunger extends through workpiece.

Step 2

Keep port A pressurized. Pressurize port C. Plunger makes 90° flat rotation.

Step 3

Keep port C pressurized. Pressurize port B. Plunger retracts: clamp force is applied.

Step 4

Keep port C pressurized. Pressurize port A. Plunger extends: clamp force is released.

Step 5

Keep port A pressurized. Depressurize port C. Plunger makes 90° flat rotation.

Step 6

Pressurize port B. Plunger retracts through workpiece.

Selection chart

Clamping force ¹⁾	Stroke	Model number ²⁾	Cylinder effective area		Oil capacity		Max. oil flow	Maximum cycle rate
			in ² Clamp.	in ² Unclamp.	in ³ Clamp.	in ³ Unclamp.	in ³ /min	cycles /min
5000 lbs	2.50 in	WTR-24*	.98	1.77	2.5	4.4	116	4

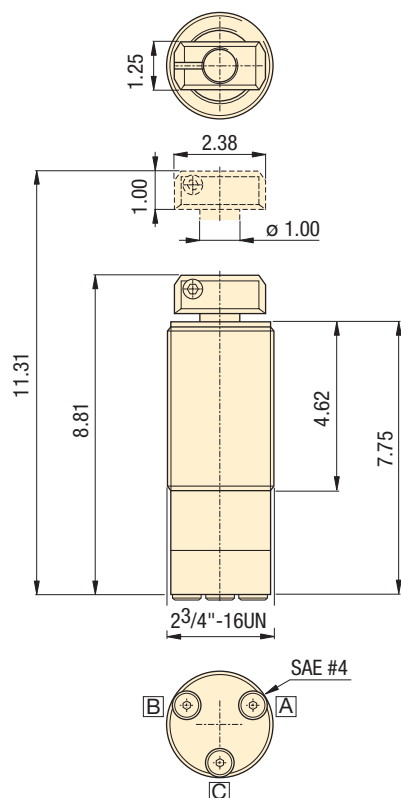
¹⁾ When using optional CA-28 clamp arm, max. operating pressure is 2000 psi.

²⁾ Standard clamp arm included.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



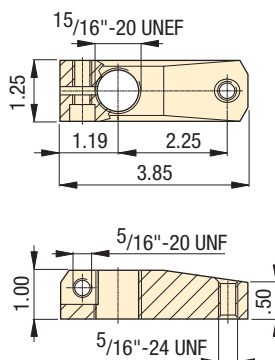
WTR-24



- A** = Advance
- B** = Retract
- C** = Rotate 90°

i Optional CA-28 clamp arm

The WTR-24 has a two-sided standard clamp arm included. The CA-28 clamp arm can be used to secure the workpiece on one side only, though the clamping pressure must be reduced to 2000 psi maximum.

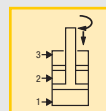


Force: 1960 - 5000 lb

Stroke: 2.50 inch

Pressure: 2000 - 5000 psi

- E** Cilindros giratorios
- F** Vérins de bridage pivotants
- D** Schwenkspannzylinder



Options

High pressure filters

157 ▶



Fittings

158 ▶



Valves

122 ▶



! Important

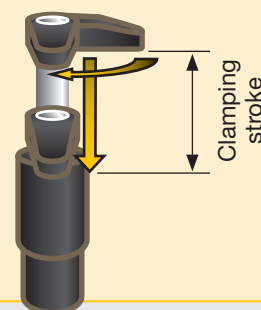
It is highly recommended that system filtration be used to ensure reliable operation.

Do not exceed maximum pressure and flow rates.

For recommended valving schemes, please refer to our "Yellow pages"

161 ▶

Clamp arm movement:
90° ± 3° flat rotation.



Swing cylinders - Collet-Lok® design

Shown: WPFR-100, WPTR-100

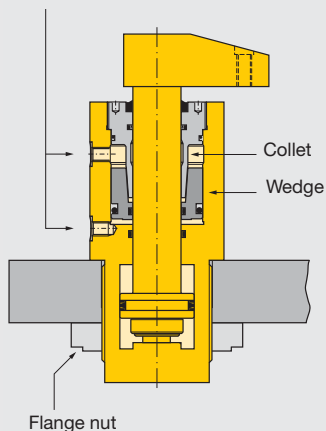
Swing cylinders
Work supports



WP series

Enerpac Collet-Lok® cylinders are designed to mechanically hold the workpiece after hydraulic pressure is removed. Clamping capacities range from 1000 lbs. to 8500 lbs.

SAE oil connection



Hydraulic pressure pushes the collet up a wedge, locking the plunger in the clamping position.

■ Lower flange Collet-Lok® swing cylinder mounted on a pallet.



Ideal when live hydraulics are not available

...clamping is maintained mechanically so live hydraulics are not required during the machining cycle

- Double acting Collet-Lok® action allows fully automated operation
- Additional level of safety since live hydraulics are not required to maintain clamping force
- Collet-Lok® swing cylinders can be mounted by the flange, or threaded into the fixture. Flanged models for manifold mount are available as a custom option.

Selection chart

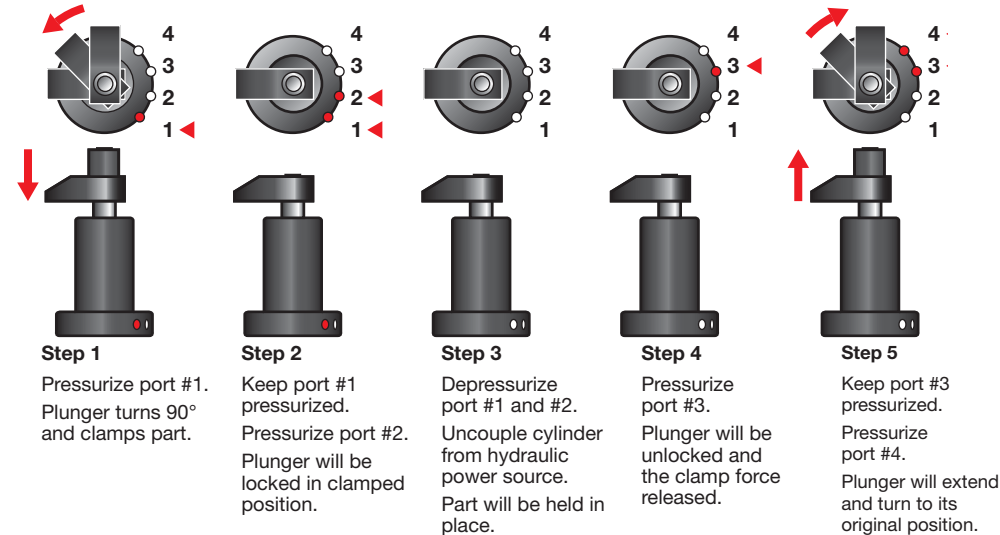
Clamping force ¹⁾		Stroke		Left turning 	Right turning 	Cylinder effective area		Oil capacity		Max. oil flow ¹⁾	Standard clamp arm	
in		in ²				in ³		Sold separately				
lbs	Clamp	Total	Clamp			Un-clamp	Clamp	Un-clamp	in ³ /min			 26 ▶
▼ Lower flange			Model number									
1000	.32	.94	WPFL-50	WPFR-50	.25	.71	.24	.67	122	CA-540		
2000	.47	1.10	WPFL-100	WPFR-100	.50	1.11	.55	1.22	305	CA-1050		
8500	.39	1.65	WPFL-300*	WPFR-300*	2.05	3.45	3.40	5.70	600	CA-3070		
▼ Threaded body			Model number									
2000	.47	1.10	WPTL-100	WPTR-100	.50	1.11	.55	1.22	305	CA-1050		
8500	.39	1.65	WPTL-300*	WPTR-300*	2.05	3.45	3.40	5.70	600	CA-3070		

¹⁾ Using standard clamp arm. Clamp arms are sold separately ( 26).

Note: - Call Enerpac for models with metric thread and BSPP port connections.
- Minimum working pressure for Collet-Lok® system is 1400 psi.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Collet-Lok® sequence



Product dimensions in inches []

Left turning models	A	B	C	C1	D Ø	D1 Ø	F Ø	H1	H2	H3
▼ Lower flange										
WPFL-50	7.91	6.97	5.79	.98	2.28	3.35	.75	.39	.50	-
WPFL-100	8.78	7.68	6.50	.98	2.68	3.94	.88	.39	.50	-
WPFL-300*	12.63	11.02	9.17	.98	3.54	5.19	1.38	.43	.50	-
▼ Threaded body										
WPTL-100	8.39	7.29	3.68	3.56	1.875-16 un	2.76	.88	1.24	2.63	2.96
WPTL-300*	12.21	10.55	4.78	4.53	3.125-16 un	3.66	1.38	1.50	3.60	3.96

Note: Dimensions shown with standard clamp arm.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



Installation dimensions in inches

Clamping force ¹⁾ lbs	Fixture hole Ø D3	Mounting thread J mm	Minimum depth J2
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▼ Lower flange

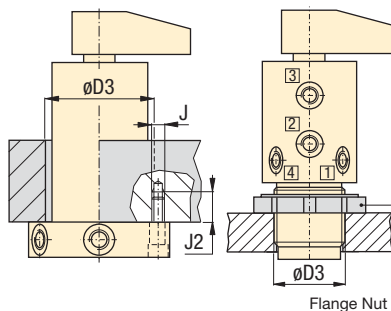
1000	2.301 ±.012	M6 x 1,00	.68
2000	2.701 ±.012	M8 x 1,25	.72
8500	3.565 ±.012	M10 x 1,50	.72

Clamping force ¹⁾ lbs	Fixture hole Ø D3	Mounting flange Sold separately 79 ▶	Mounting nut Sold separately 78 ▶
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▼ Threaded body

2000	1.875-16 un	MF-481	FN-481
8500	3.125-16 un	MF-801	FN-801

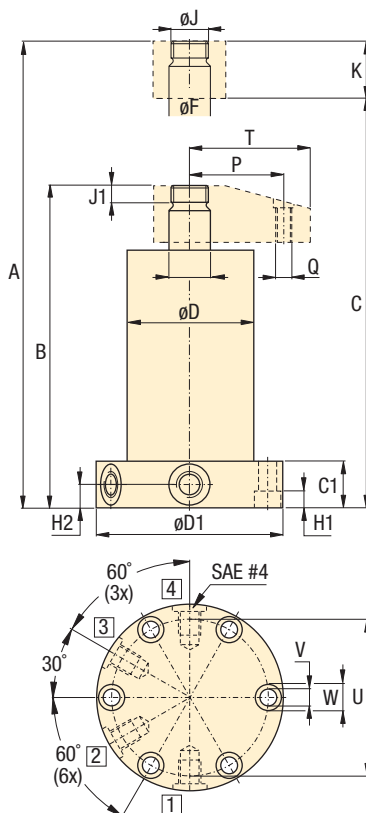
¹⁾ With standard clamp arm.



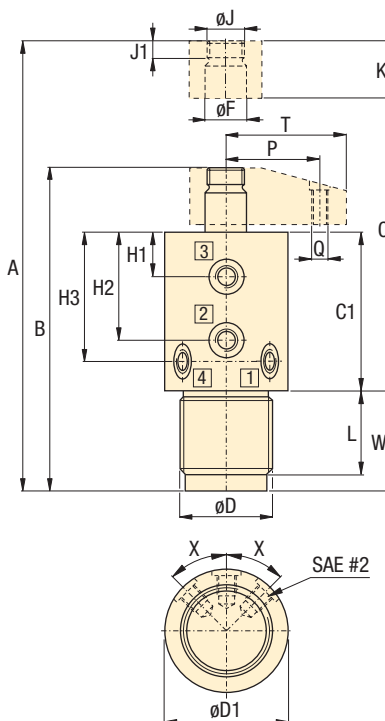
Oil port functions

- 1 90° Rotation and clamp
- 2 Locks system
- 3 Unlocks system
- 4 Unclamp and 90° rotation

WPF models



WPT models



X = 45° WPT-100 models

X = 30° WPT-300 models

Force: 1000 - 8500 lbs

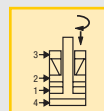
Stroke: .94 - 1.65 inch

Pressure: 1400 - 5000 psi

E Cilindros giratorios

F Vérins de bridage pivotants

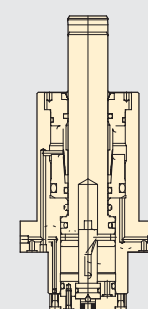
D Schwenkspannzylinder



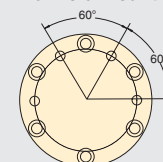
Custom Options Available

Intermediate capacities

Different flange locations



Manifold mounting



FS Flexible Machining Systems
See Yellow Pages (184)

Options

Clamp arms

78 ▶



Collet-Lok®
work supports

78 ▶



Sequence
valves

136 ▶



Accessories

78 ▶



Important

Minimum unlock pressure
must be at least 1500 psi
above lock pressure.

Swing cylinders
Work supports

Linear cylinders

Power sources

Valves

System
components

Yellow pages

Clamp arms *for swing cylinders*

Shown: CAL-122, CAS-121

Swing cylinders
Work supports



Patented Design

- Easy and precise location of the clamp arm in any position
- Arm can be easily installed and fastened while the cylinder is mounted in the fixture to allow exact arm positioning
- Vise not required for fastening arms



Pressure vs clamping force

The use of different length clamp arms requires reduction in applied pressure and resulting clamp force. The charts below show this relationship.

Energac's patented clamp arm design attaches to the hydraulic swing cylinder, allowing parts to be clamped at various distances from the hydraulic cylinder. Clamp arms are available in a variety of lengths, or you can use custom machining dimensions to create your own clamp arm configuration.

Ordering rotation limiting spacers

BUILD YOUR PART NUMBER:

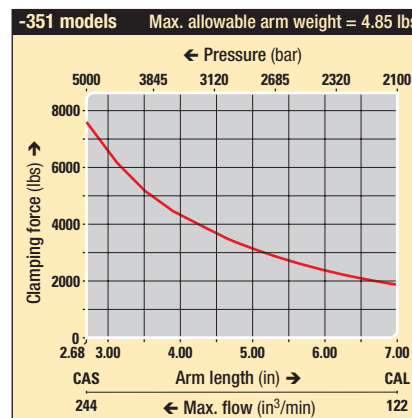
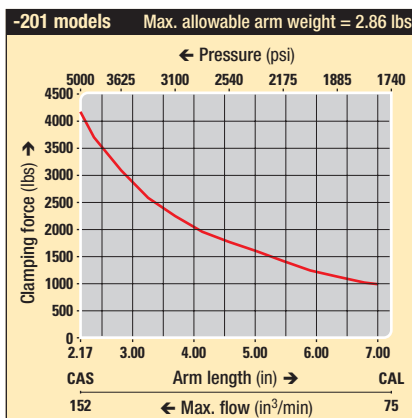
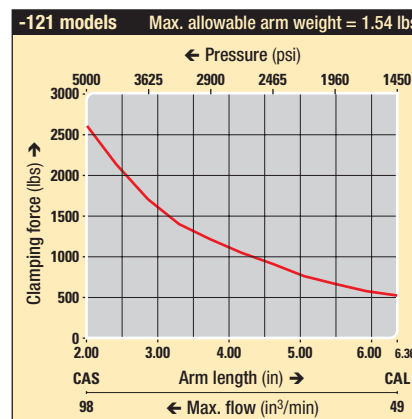
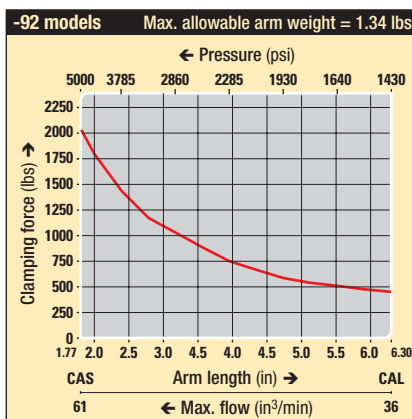
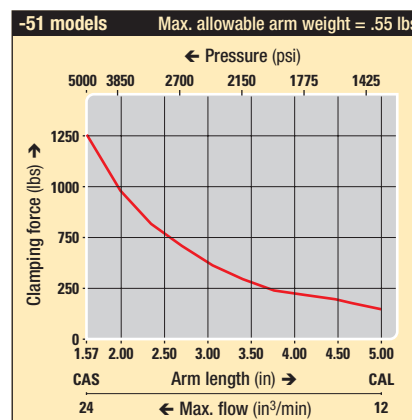
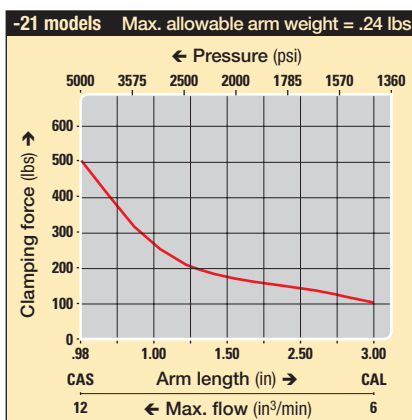
SP	186
Clamp force	Angle

02 = 500 lbs	30
05 = 1250 lbs	45
09 = 2025 lbs	60
12 = 2600 lbs	
20 = 4200 lbs	
35 = 7600 lbs	

Example:

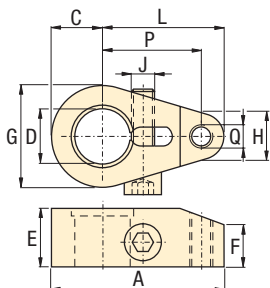
SP-12 45-186 converts a 2600 lb. swing cylinder to 45 degree rotation.

The addition of this spacer requires minor disassembly of the clamp. If you are uncomfortable doing this, please contact an authorized Energac Service Center.

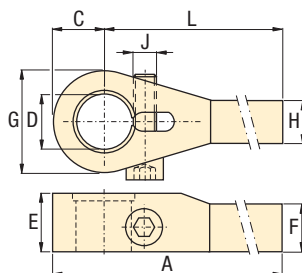




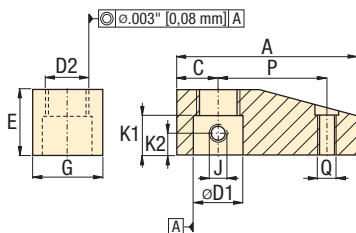
CAS models Standard clamp arms



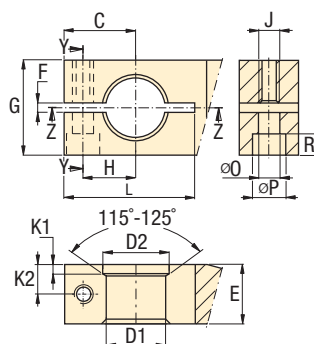
CAL models Long clamp arms



CA models Positive locking



Custom design (for SU, SL, ST and SC models only)



Dimensions in inches [$\varnothing$]

Clamp. force lbs	Model number	A	C	D	E	F	G	H	J	L	P	Q	lbs
------------------------	-----------------	---	---	---	---	---	---	---	---	---	---	---	-----

▼ Standard clamp arms

500	CAS-21	1.60	.38	.392-.396	.63	.40	.76	.50	.250-28 UNF	1.22	.98	.250-20	.1
1250	CAS-51	2.39	.50	.628-.632	.75	.45	1.00	.62	.312-24 UNF	1.89	1.57	.312-18	.8
2025	CAS-92	2.99	.79	.982-.986	.98	.63	1.57	.89	M10x1,25	2.20	1.77	M10x1,5	.7
2600	CAS-121	3.13	.70	.873-.877	1.19	.63	1.39	.82	.375-24 UNF	2.43	2.00	.375-16	1.0
4200	CAS-201	3.71	.95	1.257-1.261	1.18	.82	1.90	1.20	.500-20 UNF	2.76	2.17	.500-13	1.0
7600	CAS-351	4.65	1.38	1.494-1.498	1.58	1.16	2.76	1.24	.625-18 UNF	3.27	2.68	.625-11	3.0

▼ Long clamp arms

500	CAL-22	2.85	.30	.392-.396	.63	.40	.76	.44	M6x1	3.25	-	-	.2
1250	CAL-52	5.81	.50	.628-.632	.75	.45	1.00	.55	M8x1	5.31	-	-	1.0
2025	CAL-92	7.09	.79	.982-.986	.98	.63	1.57	.71	M10x1,25	6.30	-	-	1.2
2600	CAL-122	7.06	.70	.873-.877	1.19	.63	1.39	.72	M10x1,5	6.36	-	-	1.5
4200	CAL-202	7.95	.95	1.257-1.261	1.18	.82	1.90	1.00	M12x1,25	7.00	-	-	1.5
7600	CAL-352	8.47	1.38	1.494-1.498	1.58	1.33	2.76	1.18	M16x1,50	7.09	-	-	4.2

Clamp. force lbs	Model number	A	C	D1	D2	E	G	J	K1	K2	P	Q	lbs
------------------------	-----------------	---	---	----	----	---	---	---	----	----	---	---	-----

▼ Positive locking clamp arms

1000	CA-540	2.84	.71	.749-.750	.63-18	1.18	1.26	.313-24	.75	.39	1.57	.313-24	1.2
2000	CA-1050	3.27	.75	.878-.879	.75-16	1.18	1.38	.313-24	.71	.39	1.97	.375-24	1.2
8500	CA-3070	5.04	1.38	1.377-1.378	1.25-12	1.85	2.32	.313-24	1.26	.67	2.76	.625-18	5.0

Clamp. force lbs	C	D1 ¹⁾	D2	E	F	G	H	J	K1	K2	L	O	P	R
------------------------	---	------------------	----	---	---	---	---	---	----	----	---	---	---	---

▼ Custom design clamp arms ²⁾ (Recommended machining dimensions)

500	.61	.393-.394	.495-.497	.63	.06-.12	.79	.37	M5x0,8	.122-.138	.33	.98-1.10	.22	.49	.22
1250	.79	.623-.631	.727-.729	.75	.06-.12	1.18	.53	M6x1,0	.161-.177	.39	1.38-1.57	.26	.43	.26
2025	1.18	.984-.985	1.096-1.100	.98	.06-.12	1.57	.87	M8x1,25	.154-.165	.49	2.17-2.36	.35	.55	.35
2600	1.12	.8756-.8766	1.002-1.006	1.18	.06-.12	1.38	.70	.375-24 UNF	.272-.287	.50	2.05-2.25	.39	.63	.31
4200	1.38	1.260-1.261	1.398-1.402	1.18	.06-.12	2.36	.98	M10x1,5	.201-.217	.59	2.44-2.64	.43	.67	.43
7600	1.57	1.496-1.497	1.634-1.638	1.57	.06-.12	2.76	1.18	M10x1,5	.193-.209	.79	3.15-3.35	.43	.67	.43

¹⁾ Surface roughness for D1 should be 63 micro inches.

²⁾ Not for use with positive locking cylinders.

Force: 500 - 8500 lbs

Stroke: 500 - 5000 psi

E Brazos de amarre

F Bras de bridage

D Spannarme

Options

Gauges

154 ▶



Flow control
valves

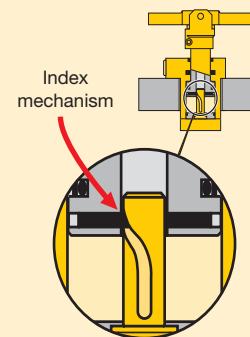
138 ▶



Important

Do not exceed maximum oil flow.

If flow rates are exceeded, swing cylinder indexing mechanism may be permanently damaged.



When designing custom clamp arms, the flow rates must be further reduced. This rating should be in proportion to the mass and the center of gravity of the clamp arm.

Example:

If the mass of the arm is twice that of the long arm, flow rates must be reduced by 50%.

Pivoting T-Arms *for double-acting swing cylinders*

Shown: CAC-202, CAPT-202; CAC-352, CAPT-352

Swing cylinders
Work supports



01_001_1

▶ Clamp arms are used to transmit the force generated by the swing cylinder to the workpiece. The T-arm clamps two workpieces simultaneously with one swing cylinder. Enerpac recommends using the pivoting T-arms with double-acting swing cylinders of the SU, SL, ST and SC-series.

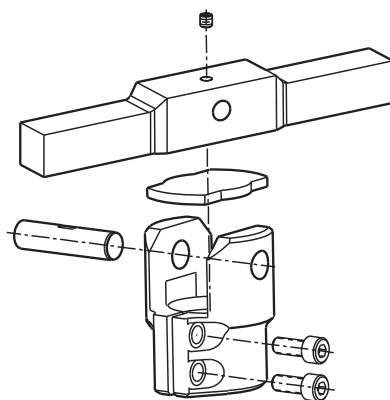
Clamping two workpieces with one cylinder

...quick and precise clamp arm positioning

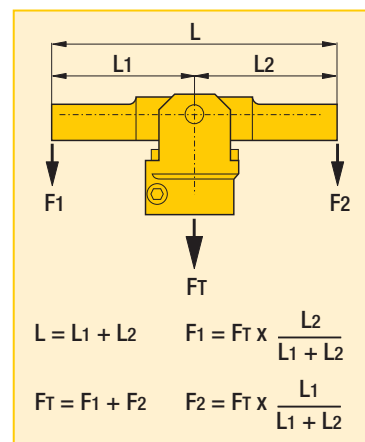
- Easy and precise location of the clamp arm in any position
- Arm can be easily installed and fastened while the cylinder is mounted in the fixture to allow exact arm positioning
- Vise not required for fastening arms or threaded into the fixture
- CAC-92, -202 and -352 are only to be used on double-acting cylinders

i Allowable flow vs arm length

The distribution of the clamp arm force is based upon the length of the T-arm as measured from the pivoting point.



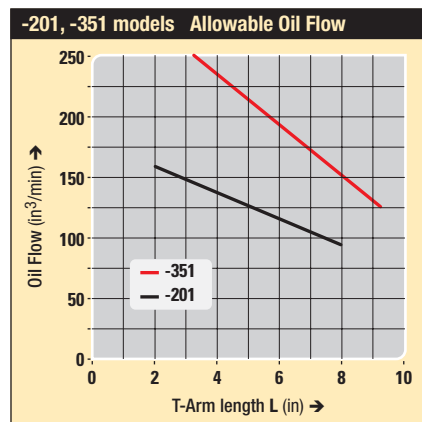
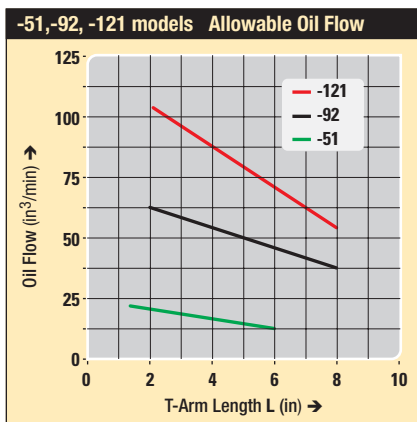
! Important



■ Two workpieces are clamped simultaneously with one double-acting swing cylinder by using the Enerpac pivoting T-arm.



01_0002



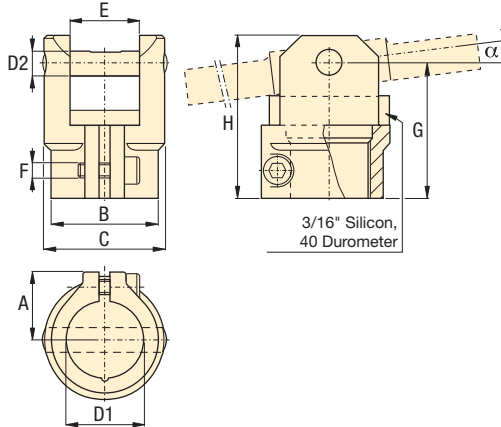


Shown: CAC-202



CA models

Collars for T-arms



Collars - Dimensions in inches [$\nabla \oplus$]

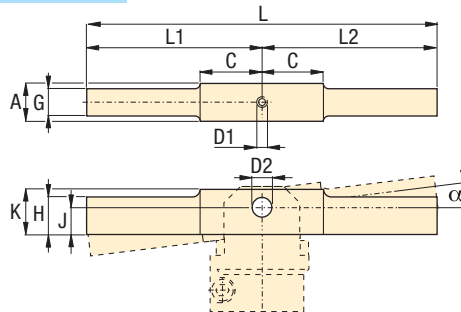
Clamp. force lbs	Model number	Max. tilt angle α	A	B	C	D1	D2	E	F	G	H	lbs
									mm			
▼ Collars for T-arms												
1250	CAC-52	20°	.65	.95	1.10	.63	.24	.63	M4x0,7	1.26	88	.20
2025	CAC-92	14°	.87	1.36	1.54	.99	.32	.89	M5x0,8	1.70	115.72	.44
2600	CAC-122	14°	.87	1.36	1.54	.88	.32	.89	M5x0,8	1.70	115.72	.44
4200	CAC-202	10°	1.07	1.84	2.15	1.26	.39	1.13	M6x1,0	2.02	138.60	1.03
7600	CAC-352	10°	1.34	2.15	2.48	1.50	.55	1.39	M8x1,25	2.50	173.80	1.76

Shown: CAPT-202



CAPT models

T-arms (for SU, SL, ST and SC swing cylinders)



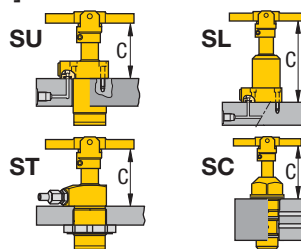
T-arms - Dimensions in inches [$\nabla \oplus$]

Clamp. force lbs	Model number	A	C	D1*	D2	G	H	J	K	L	L1	L2	lbs
▼ Pivoting T-arms													
1250	CAPT-52	.61	1.00	M3x0,5	.237-.241	.50	.50	.39	.75	6.00	3.00	3.00	.59
2025	CAPT-92	.87	1.50	M4x0,7	.316-.320	.72	.72	.59	.87	8.01	4.00	4.00	1.45
2600	CAPT-122	.87	1.50	M4x0,7	.316-.320	.72	.72	.59	.87	8.01	4.00	4.00	1.45
4200	CAPT-202	1.12	1.25	M6x1,0	.395-.399	.87	.87	.64	1.13	8.01	4.00	4.00	2.11
7600	CAPT-352	1.37	.99	M6x1,0	.552-.556	1.18	1.18	.73	1.37	9.01	4.50	4.50	3.92

* Note: D1 equals set screw thread size. Set screw must be long enough to secure the pivot pin.

Installation dimensions in inches [$\nabla \oplus$]

Clamping force lbs	T-arm model	SU- series C	SU-L- series C	SL- series C	ST- series C	SC- series C
▼ T-arm installation dimensions - Fully unclamped position						
1250	-52	2.90	-	5.50	2.90	3.19
2025	-92	3.13	3.91	6.13	3.32	-
2600	-122	3.55	4.28	6.93	3.55	3.87
4200	-202	3.57	-	6.99	3.97	-
7600	-352	4.04	4.69	7.84	4.31	-



Force: 1250 - 8500 lbs

Stroke: 500 - 5000 psi

E Brazos de amarre

F Bras de bridage

D Spannarme

Options

Gauges

154 ▶



Flow control
valves

138 ▶



Download CAD
files from
www.enerpac.com



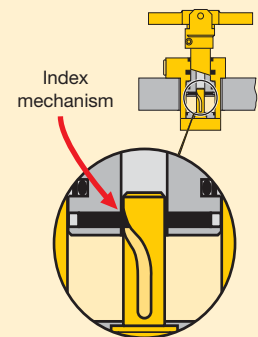
30, 45, and 60 degree
rotations are available
upon request.

Important

For high cycle applications
use double-acting cylinders.

Do not exceed
maximum oil flow.

If flow rates are exceeded, swing
cylinder indexing mechanism may
be permanently damaged.



When designing custom clamp
arms, the flow rates must be
further reduced. This rating
should be in proportion to the
mass and the center of gravity
of the clamp arm.

Example:

If the mass of the arm is twice that
of the long arm, flow rates must be
reduced by 50%.

Upreach clamp arms *for swing cylinders*

Shown: CAU-352, CAU-122, CAU-22

Swing cylinders
Work supports

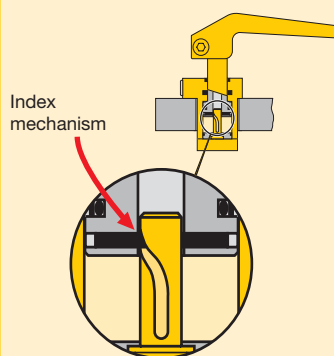


Energy Enerpac's patented upreach clamp arm design attaches to the hydraulic swing cylinder, allowing parts to be clamped at various distances from the hydraulic cylinder. Clamp arms are available in an extended length which can be machined to fit your unique requirements.

Important

Do not exceed maximum oil flow.

If flow rates are exceeded, swing cylinder indexing mechanism may be permanently damaged.



When designing custom clamp arms, the flow rates must be further reduced. This rating should be in proportion to the mass and the center of gravity of the clamp arm.

Example:

If the mass of the arm is twice that of the long arm, flow rates must be reduced by 50%.

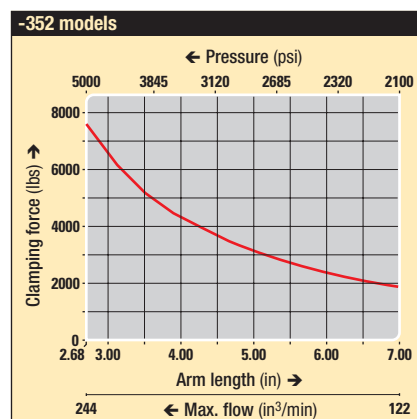
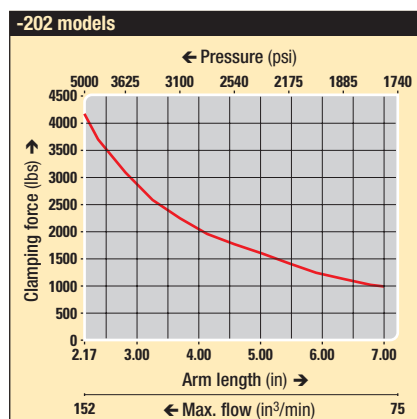
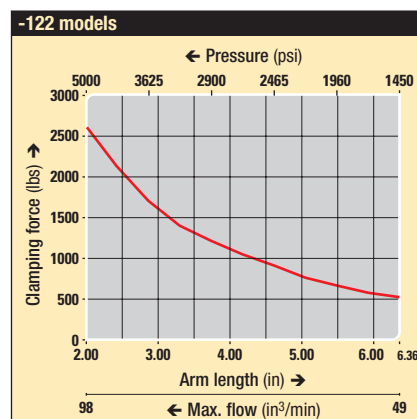
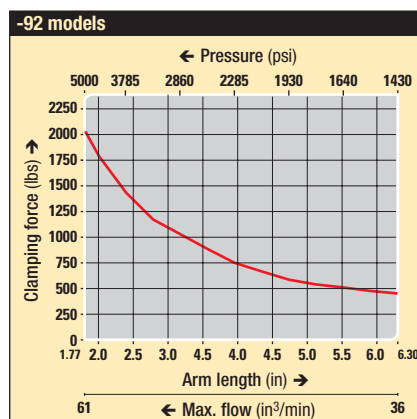
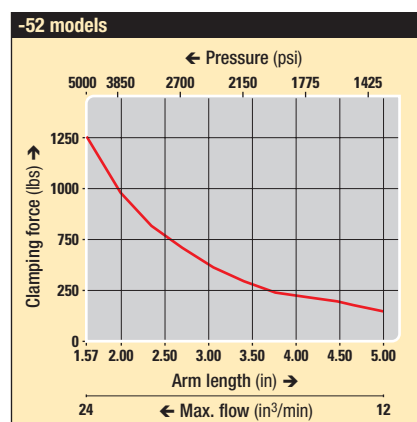
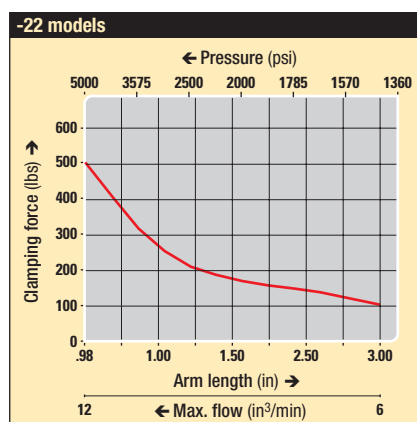
Patented Design

- Upreach design allows more flexible part clamping
- Arm can be easily installed and fastened while the cylinder is mounted in the fixture to allow exact arm positioning
- Vise not required for fastening arms
- Arm length can be cut to desired size
- Angled arm with minimal deflection achieves maximum workpiece contact



Pressure vs clamping force

The use of different length clamp arms requires reduction in applied pressure and resulting clamp force. The charts below show this relationship.



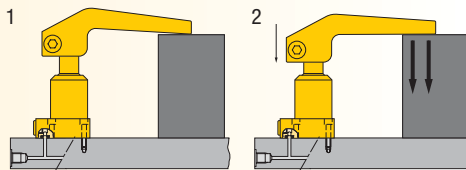


Angled arms use deflection to improve clamping

Angled arms

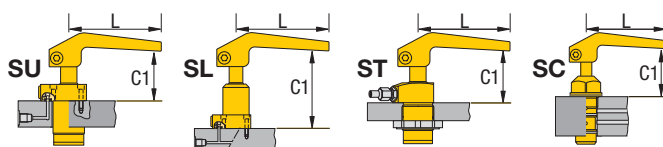
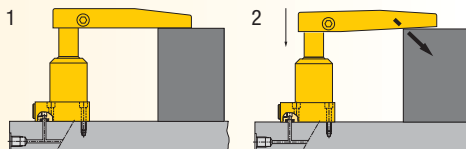
Tip engages part first and contact increases as clamping force is applied.

Eliminates "push" effect caused by straight arms deflecting under load.



Straight Arms

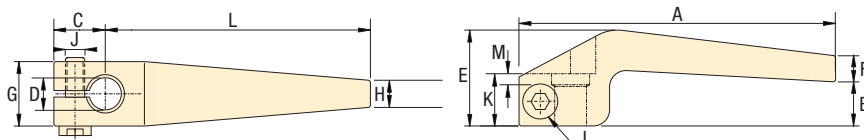
Great for most applications, but standard deflection can cause part movement and lower the true clamping force.



Installation dimensions in inches []

Model number	Clamp force	L	SU-Series C1	SL-Series C1	ST-Series C1	SC-Series C1
▼ Stock length dimensions						
CAU-22	100	3.25	2.23	4.32	2.23	2.09
CAU-52	200	5.31	2.82	5.42	2.82	3.10
CAU-92	450	6.30	2.90	5.89	3.10	-
CAU-122	500	6.36	3.29	6.67	3.29	3.61
CAU-202	1000	6.99	3.47	6.90	3.75	-
CAU-352	1900	7.09	3.90	7.56	4.18	-
▼ Minimum length dimensions						
CAU-22	500	0.98	2.35	4.44	2.35	2.21
CAU-52	1250	1.57	3.02	5.62	3.02	3.30
CAU-92	2025	1.77	3.14	6.13	3.34	-
CAU-122	2600	2.00	3.52	6.90	3.52	3.84
CAU-202	4200	2.17	3.72	7.15	4.00	-
CAU-352	7600	2.68	4.21	7.87	4.49	-

CAU models Upreach clamp arms



Dimensions in inches []

Model number	A	B	B	C	D	E	F	F	G	H	H	J	K	L	L	M	lbs
		Std.	Min.				Std.	Min.		Std.	Min.			Std.	Min.		
CAU-22	3.88	0.54	0.66	0.63	.393-.394	1.17	0.32	0.54	0.79	0.33	0.82	M6X1.0	0.64	3.25	0.98	0.04	0.3
CAU-52	6.10	0.85	1.05	0.79	.630-631	1.65	0.26	0.57	1.18	0.47	1.25	M6X1.0	0.75	5.31	1.57	0.05	0.9
CAU-92	7.48	0.93	1.17	1.18	.985-.986	1.89	0.43	0.76	1.57	0.57	1.61	M8X1.25	0.98	6.30	1.77	0.09	1.7
CAU-122	7.48	1.11	1.34	1.12	.876-.877	2.25	0.50	1.15	1.50	0.65	1.56	M10X1.5	1.18	6.36	2.00	0.15	2.2
CAU-202	8.37	1.27	1.52	1.38	1.260-1.261	2.41	0.52	0.96	2.36	0.68	2.14	M10X1.5	1.18	6.99	2.17	0.11	3.7
CAU-352	8.66	1.62	1.93	1.57	1.497-1.498	3.14	0.74	1.35	2.60	0.62	2.13	M10X1.5	1.58	7.09	2.68	0.07	5.9

Refer to clamping force charts on page 30 of E214.
Never cut shorter than indicated minimum length.

Force: 100 - 7600 lbs

Pressure: 500 - 5000 psi

E Brazos de amarre

F Bras de bridage

D Spannarme

Options

Sequence valves

136 ▶



Flow control valves

138 ▶



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Swing cylinders
Work supports

Linear cylinders

Power sources

Valves

System
components

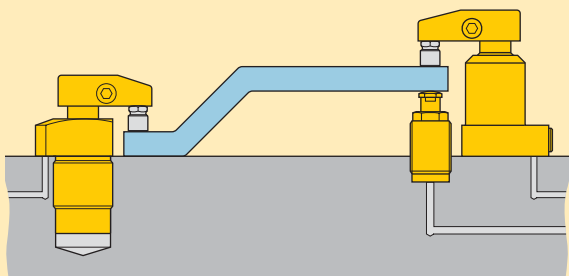
Yellow pages

Shown: WPFS-100, WFL-111, WFC-72, WFL-441



▶ The Enerpac work support is a hydraulic means of positively supporting the workpiece to minimize deflections.

The work support automatically adjusts to the contour of the workpiece, and then locks in position. This support then adds rigidity to the fixtured component to minimize machining variations.



■ Lower flange work supports, placed close to the machining area to minimize deflection of the workpiece.

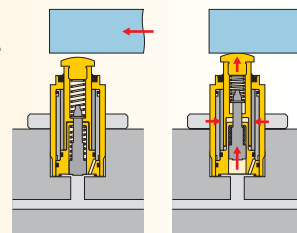
Wide range of sizes and types to efficiently support workpiece

- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials, compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants from being drawn into the system
- Minimized deflection increases machining accuracy
- Multiple mounting configurations allow design flexibility
- Collet-Lok® positive locking models: Hydraulic actuation / mechanical holding allows for palletized systems which do not permit live hydraulics

i Select your work support method:

WF series, Hydraulic advance

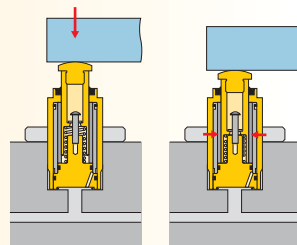
- Retracted plunger allows unobstructed workpiece loading.
- Internal hydraulic plunger advances allowing external plunger to advance under spring load. Bronze sleeve squeezes and holds plunger in fixed position.



34 ▶

WS series, Spring advance

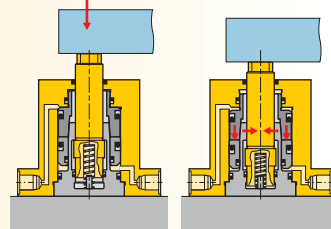
- Workpiece weight compresses the spring of the extended plunger.
- When pressurized, the internal bronze sleeve squeezes and holds the plunger in fixed position.
- Can be operated as air advance.



36 ▶

WP series, Collet-Lok® positive locking

- Unique in the industry.
- Allows the work support to maintain support after pressure has been removed.
- Extremely low deflections due to the structural design of the collet system.
- Low lockup pressure.



38 ▶

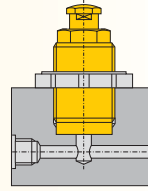




Select your mounting method:

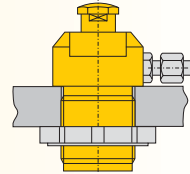
Manifold mount

- Does not require external plumbing
- Compact design, when space is at a premium
- Internal plunger thread for optional contacts



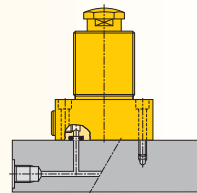
Threaded body

- Ability to adjust height
- Plumbed from either side or bottom
- Internal plunger thread for optional contacts



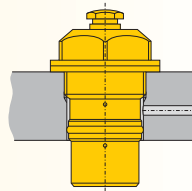
Lower flange

- Plumbed directly or manifold mounted
- No fixture hole required
- Easy to assemble or disassemble
- Internal plunger thread for optional contacts



Cartridge style

- Does not require external plumbing
- Allows close clustering of work supports
- Compact design, when space is at a premium
- Internal plunger thread for optional contacts



Product selection

Maximum support force	Stroke	Manifold mount	Threaded body	Lower flange	Cartridge style
lbs	in				
▼ Hydraulic advance					
		Model number			
1650	.38	WFM-71	WFT-71	-	WFC-72
2500	.38	-	-	WFL-111	WFC-112
5000	.41	-	-	WFL-221	WFC-222
7500	.53	-	-	WFL-331	-
10,000	.65	-	-	WFL-441	-
▼ Spring advance					
		Model number			
1650	.38	WSM-71	WST-71	-	WSC-72
2500	.38	-	-	WSL-111	WSC-112
5000	.41	-	-	WSL-221	WSC-222
7500	.53	-	-	WSL-331	-
10,000	.65	-	-	WSL-441	-
▼ Positive locking					
		Model number			
2000	.39	-	WPTS-100	WPFS-100	-
4000	.39	-	WPTS-200	WPFS-200	-

Force: 1650 - 10,000 lbs

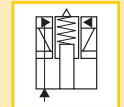
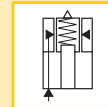
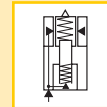
Stroke: .38 - .65 inch

Pressure: 700 - 5000 psi

E Cilindros de soporte

F Vérin anti-vibreur

D Abstützzylinder



Options

Swing cylinders

10 ▶



Accessories

78 ▶



In line filters

157 ▶



Sequence valves

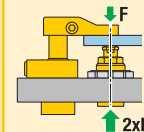
136 ▶



Important

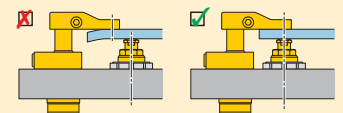
WARNING!

Support force and clamping force must be matched. Support force should be at least 200% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Always center load over work support.



Work supports - Hydraulic advance

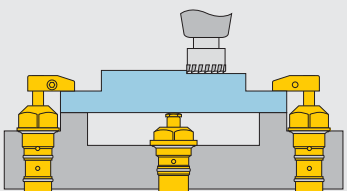
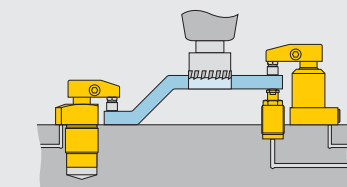
Shown: WFM-71, WFL-111

Swing cylinders
Work supports



WF series

Enerpac work supports provide either additional non-fixed location points to the clamps, or support to larger or thin section workpiece components, always in order to minimize workpiece deflection during machining.



In order to load the workpiece sideways over the work supports, hydraulic advanced models are being used.



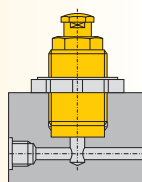
For unobstructed part loading

- Plunger stays retracted until pressure is applied allowing unobstructed loading
- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials – compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants and debris from being ingested into the mechanism
- Minimized deflection increases machining accuracy
- Multiple mounting configurations for design flexibility
- Contact bolt included

Four mounting styles

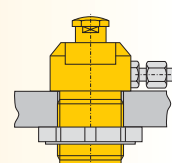
WFM series, Manifold models

Eliminates the need for fittings and tubing on the fixture.



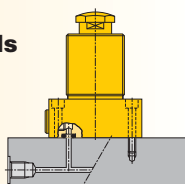
WFT series, Threaded models

Offers the flexibility of side or bottom porting.



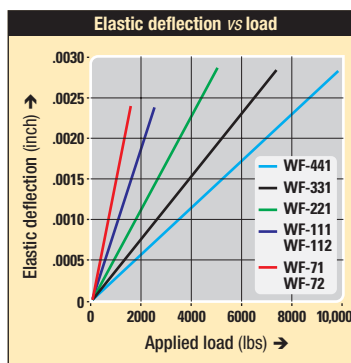
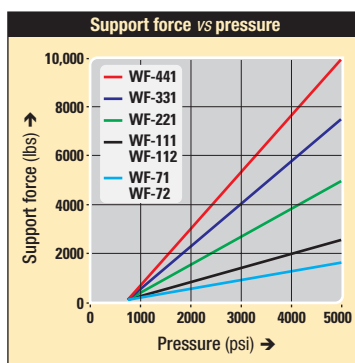
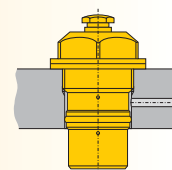
WFL series, Lower flange models

Plumbed directly – no fixture hole required.



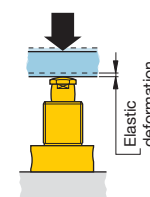
WFC series, Cartridge models

Can be designed into narrow fixture plates as thru-hole mounting is fully functional.



Deflection chart:

Elastic deformation of the work support resulting from the application of load.



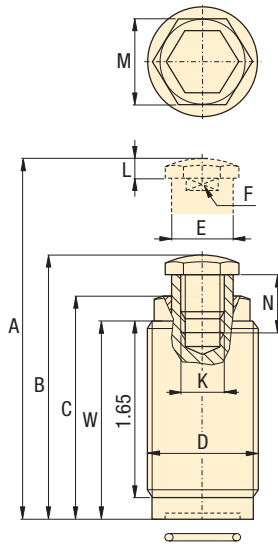
Product selection

Max. support force	Support plunger stroke	Manifold mount	Threaded body	Lower flange	Cartridge style	Operating pressure	Plunger contact spring force	Oil capacity	Max. oil flow
lbs	in					psi min. max.	lbs ext. retr.	in ³	in ³ /min
1650	.38	WFM-71	WFT-71	-	WFC-72	700 5000	2.0 5.8	.04	40
2500	.32	-	-	WFL-111	WFC-112	700 5000	3.4 5.2	.06	60
5000	.41	-	-	WFL-221	WFC-222	700 5000	2.1 19.5	.19	190
7500	.53	-	-	WFL-331	-	700 5000	4.0 17.5	.24	240
10,000	.65	-	-	WFL-441*	-	700 5000	3.3 22.0	.30	300

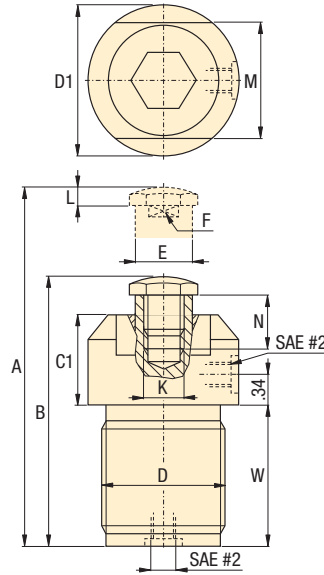
* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



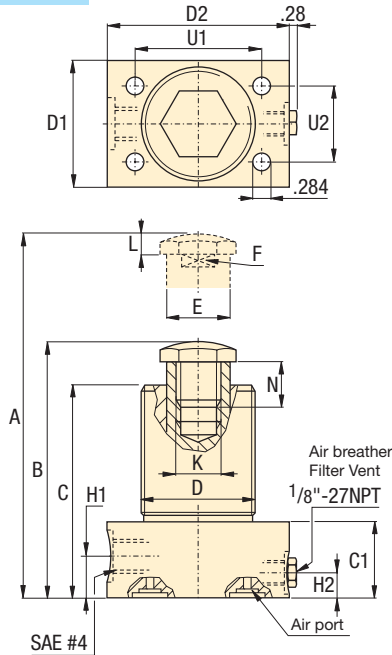
WFM series



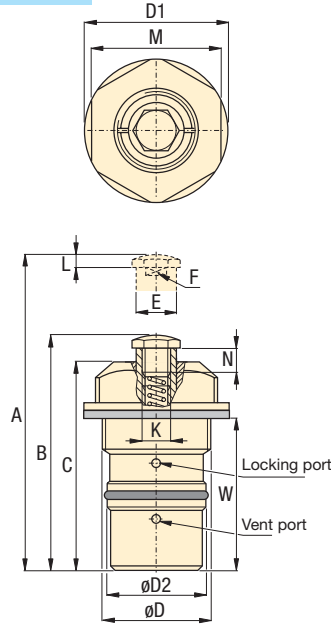
WFT series



WFL series



WFC series



Force: 1650 - 10,000 lbs

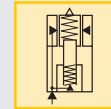
Stroke: .38 - .65 inch

Pressure: 700 - 5000 psi

E Cilindros de soporte

F Vérin anti-vibreur

D Abstützzylinder



Options

Accessories

78



In-line filters

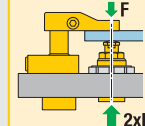
157



Important

WARNING!

Support force and clamping force must be matched. Support force should be at least 200% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Custom cylinders including longer stroke lengths are available on request.

Product dimensions in inches []

Model number	A	B	C	C1	D	D1	D2	E	F	H1	H2	K	L	M	N**	U1	U2	W	lbs
	mm																		
WFM-71	3.00	2.62	2.16	—	1.250-16 UN	—	—	.591	.51	—	—	M10x1,5	.18	.94	.53	—	—	1.96	.5
WFT-71	3.51	3.13	—	1.02	1.375-18 UNEF	1.71	—	.591	.51	—	—	M10x1,5	.18	1.34	.53	—	—	1.65	.5
WFL-111	3.91	3.53	3.10	1.08	1.375-18 UNEF	1.50	2.38	.629	.49	.56	.70	M10x1,5	.18	—	.73	1.62	.94	—	1.4
WFL-221	4.02	3.73	3.07	1.04	2.625-20 UN	2.75	3.25	1.496	1.00	.54	.52	M20x2,5	.24	—	.31	2.18	2.18	—	4.8
WFL-331	4.40	3.87	3.46	1.06	2.88	3.00	3.50	1.771	1.18	.53	.42	M20x2,5	.24	—	.31	2.44	2.44	—	6.3
WFL-441*	5.07	4.42	4.05	1.18	3.38	3.50	4.00	2.165	1.44	.53	.42	M20x2,5	.24	—	.62	2.94	2.94	—	9.5
WFC-72	3.20	2.82	2.46	—	M33x1,5	1.62	1.16	.591	.51	—	—	M10x1,5	.18	1.50	.53	—	—	1.98	.9
WFL-112	4.03	3.65	3.23	—	M42x1,5	2.25	1.44	.630	.49	—	—	M10x1,5	.18	2.00	.73	—	—	2.38	2.0
WFC-222	4.52	4.11	3.60	—	M60x1,5	3.00	2.25	1.496	1.00	—	—	M20x2,5	.24	2.75	.31	—	—	2.70	4.0

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

** Note: Dimension N is factory set. May change on types 221, 331 and 441 due to adjusted contact spring force.

Note: For manifold mounting dimensions (40).

Mounting dimensions 40

Work supports - Spring advance

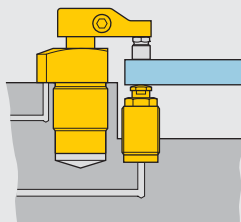
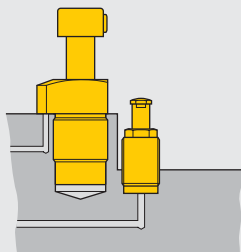
Shown: WSL-111, WST-71

Swing cylinders
Work supports



WS series

Enerpac work supports provide either additional non-fixed location points to the clamps, or support to larger or thin section workpiece components, always in order to minimize workpiece deflection during machining.



Spring advance work supports with extended plungers, waiting for the next workpiece.



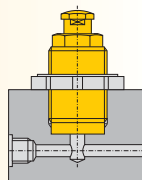
Spring advance work support contacts workpiece as it is loaded into fixture

- Low pressure lock-up capability enables the use of machine tool hydraulic systems
- High rated support capacities allow for more compact fixture design
- Corrosion resistant materials, compatible with most coolants and environments
- Threaded and manifold air vent ports allow fixturing that prevents coolants from being drawn into the system
- Minimized deflection increases machining accuracy
- Multiple mounting configurations allow design flexibility
- Can be operated as air advance by removing the spring and applying air pressure on the vent port

Mounting style

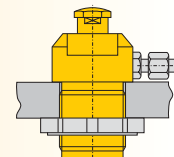
WSM series, Manifold mount

Eliminates the need for fittings and tubing on the fixture.



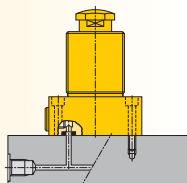
WST series, Threaded body

Offers the flexibility of side or bottom porting.



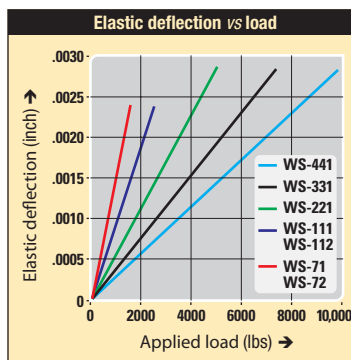
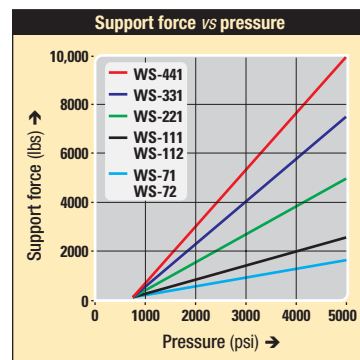
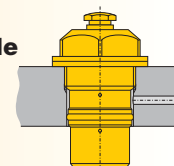
WSL series, Lower flange

Plumbed directly – no fixture hole required.



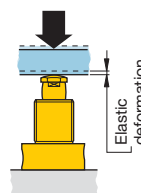
WSC series, Cartridge mount style

Can be designed into narrow fixture plates as thru-hole mounting is fully functional.



Deflection chart:

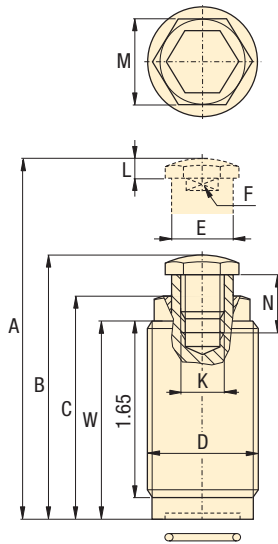
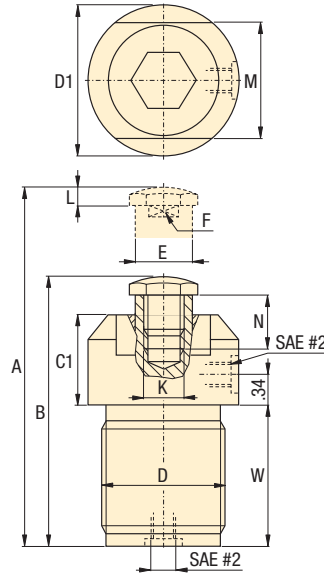
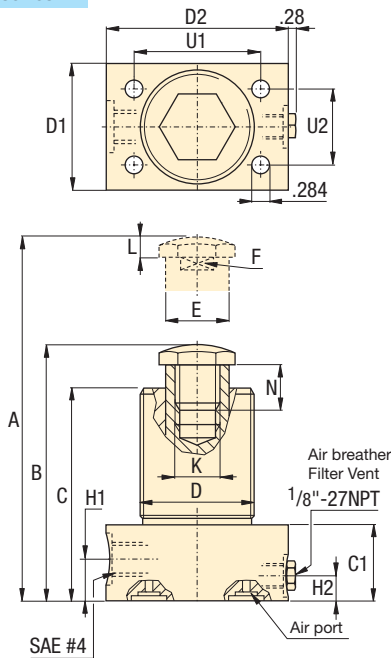
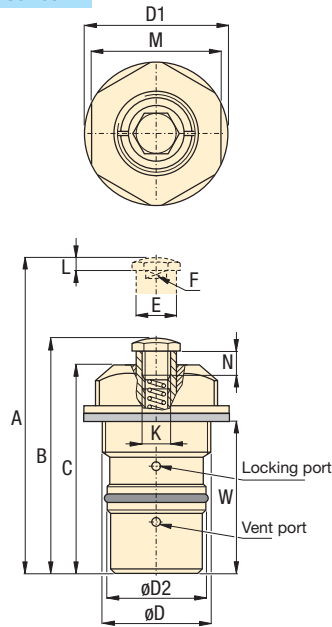
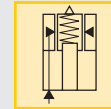
Elastic deformation of the work support resulting from the application of load.



Product selection

Max. support force	Support plunger stroke	Manifold mount	Threaded body	Lower flange	Cartridge style	Operating pressure	Plunger contact spring force	Oil capacity	Max. oil flow
lbs	in					psi min. max.	lbs ext. retr.	in ³	in ³ /min
1650	.38	WSM-71	WST-71	-	WSC-72	700 5000	2.0 5.8	.04	40
2500	.38	-	-	WSL-111	WSC-112	700 5000	3.4 5.2	.06	60
5000	.41	-	-	WSL-221	WSC-222	700 5000	2.1 19.5	.19	190
7500	.53	-	-	WSL-331	-	700 5000	4.0 17.5	.24	240
10,000	.65	-	-	WSL-441*	-	700 5000	3.3 22.0	.30	300

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.


WSM series

WST series

WSL series

WSC series

Force: 1650 - 10,000 lbs
Stroke: .38 - .65 inch
Pressure: 700 - 5000 psi
E Cilindros de soporte
F Vérin anti-vibreur
D Abstützzylinder

Options
Accessories

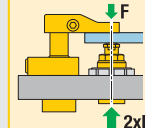
78 ▶


In-line filters

157 ▶


! Important
WARNING!

Support force and clamping force must be matched. Support force should be at least 200% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Custom cylinders including longer stroke lengths are available on request.

Product dimensions in inches []

Model number	A	B	C	C1	D	D1	D2	E	F	H1	H2	K	L	M	N**	U1	U2	W	lbs
	mm																		
WSM-71	3.00	2.62	2.16	—	1.250-16 UN	—	—	.591	.51	—	—	M10x1,5	.18	.94	.53	—	—	1.96	.5
WST-71	3.51	3.13	—	1.02	1.375-18 UNEF	1.71	—	.591	.51	—	—	M10x1,5	.18	1.34	.53	—	—	1.65	.5
WSL-111	3.35	2.97	2.54	.94	1.375-18 UNEF	1.50	2.38	.629	.49	.44	.30	M10x1,5	.18	—	.73	1.62	.94	—	1.4
WSL-221	3.80	3.39	2.95	.98	2.625-20 UN	2.75	3.25	1.496	1.00	.48	.40	M20x2,5	.24	—	.31	2.18	2.18	—	4.8
WSL-331	4.28	3.75	3.36	1.06	2.88	3.00	3.50	1.771	1.18	.53	.42	M20x2,5	.24	—	.31	2.44	2.44	—	6.3
WSL-441*	4.98	4.33	3.95	1.18	3.38	3.50	4.00	2.165	1.44	.53	.42	M20x2,5	.24	—	.62	2.94	2.94	—	9.5
WSC-71	3.20	2.82	2.46	—	M33x1,5	1.62	1.16	.591	.51	—	—	M10x1,5	.18	1.50	.53	—	—	1.98	.9
WSC-112	3.36	2.98	2.56	—	M42x1,5	2.25	1.50	.630	.49	—	—	M10x1,5	.18	2.00	.73	—	—	2.38	2.0
WSC-222	3.96	3.51	3.00	—	M60x1,5	3.00	2.21	1.496	1.00	—	—	M20x2,5	.24	2.75	.31	—	—	2.10	4.0

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

** Note: Dimension N is factory set. May change on types 221, 331 and 441 due to adjusted contact spring force.

Note: For manifold mounting dimensions (40).

Mounting dimensions 40 ▶

Work supports - Collet-Lok® design

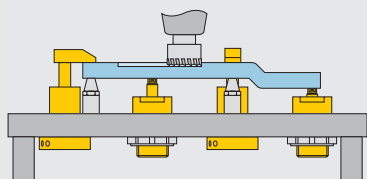
Shown: WPFS-100, WPTS-100

Swing cylinders
Work supports



WP series

Enerpac work supports provide either additional non-fixed location points to the clamps, or support to larger or thin section workpiece components, always in order to minimize workpiece deflection during machining. The Collet-Lok® design does not require hydraulic system pressure to maintain support position.



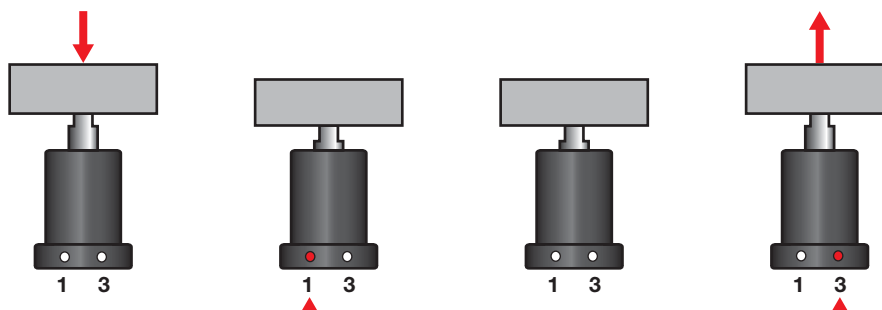
While pallet No. 1 is in the machining chamber, a new work piece is loaded on to pallet No. 2.



Hydraulically locked, mechanically maintained work support

- Collet-Lok® design allows the work support to maintain support position after the hydraulic pressure is removed
- Collet Lok® maintains a higher level of safety, as it is not dependent on hydraulic supply pressure
- Low deflection: lowest deflection of any work support available
- Threaded or flanged body increases mounting flexibility
- Capacities up to 10,000 lbs available on request

Collet-Lok® sequence



Step 1

Install the workpiece on the support cylinder. The plunger position will adjust to the contour of the workpiece.

Step 2

Pressurize oil port #1. The plunger will be locked in the supporting position.

Step 3

Depressurize oil port #1. Cylinder can be uncoupled from hydraulics and still support the workpiece.

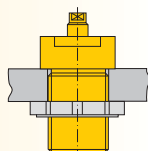
Step 4

Pressurize oil port #3. The plunger will be unlocked. When the workpiece is removed, plunger will extend into its original position.

Mounting style

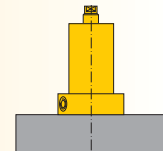
WPT series, Threaded mount

Offers the flexibility of side or bottom porting.



WPF series, Flange models

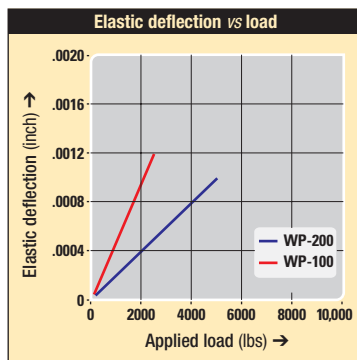
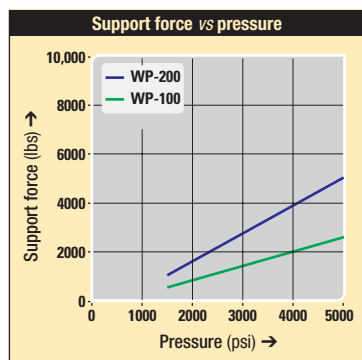
Plumbed directly, no fixture hole required



Product selection

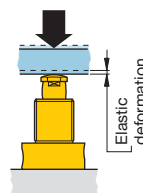
Max. support force	Support plunger stroke	Flange models	Threaded models	Operating pressure		Locking system displacement		Plunger contact spring	Max. oil flow
				min.	max.	ext.	retr.		
lbs	in								
2000	.39	WPFS-100	-	1450	5000	.24	.24	4.50	400
4000	.39	WPFS-200	-	1450	5000	.37	.37	7.90	400
2000	.39	-	WPTS-100	1450	5000	.24	.24	3.37	400
4000	.39	-	WPTS-200	1450	5000	.37	.37	6.74	400

Capacities up to 10,000 lbs. available on request.

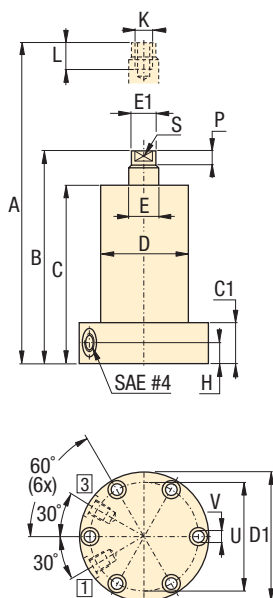


Deflection chart:

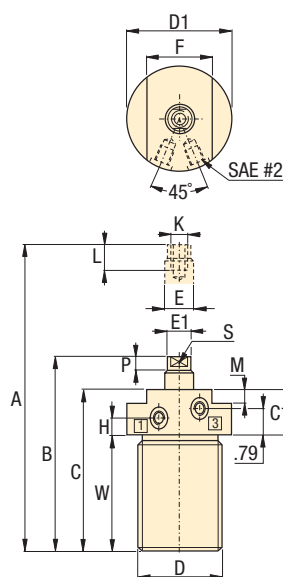
Elastic deformation of the work support resulting from the application of load.



WPFS-100, -200



WPTS-100, -200



Product dimensions in inches []

Model number	A	B	C	C1	D	D1	E	E1	F	H	K	L	M	P	S	U	V	W	lbs
UNF																			
▼ Flange models																			
WPFS-100	4.88	4.49	4.17	.98	2.99	4.33	.62	.55	—	.49	.313-24	.59	—	.20	.47	3.70	.35	—	8.8
WPFS-200	4.88	4.49	4.17	.98	3.62	5.12	.98	.90	—	.49	.500-20	.79	—	.20	.75	4.41	.35	—	13.2
▼ Threaded models																			
WPTS-100	4.84	4.45	4.13	1.50	2.375-12	2.94	.62	.55	2.16	.62	.313-24	.59	.79	.20	.47	—	—	2.63	6.6
WPTS-200	4.92	4.53	4.13	1.50	3.125-16	3.74	.98	.90	2.75	.62	.500-20	.79	.79	.26	.75	—	—	2.63	8.8

Force: 2000 - 4000 lbs

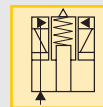
Stroke: 0.39 inch

Pressure: 1450 - 5000 psi

E Cilindros de soporte

F Vérin anti-vibreur

D Abstützzylinder



Options

Collet-Lok® swing cylinders

24 ▶



Autocouplers

146 ▶



Positive clamping cylinders

70 ▶



Sequence valves

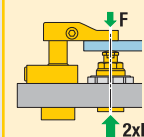
136 ▶



Important

WARNING!

Support force and clamping force must be matched. Support force should be at least 200% of clamping force.



For proper application, clamp force, pressures and timing, consult Enerpac for support.

Mounting dimensions *for work supports*

Shown: WFL-111 holding a casting in place.

Swing cylinders
Work supports



Mounting work supports

Enerpac work supports are offered in a wide variety of mounting styles. Dimensions for fixture holes and cavity preparation are specified for each mounting style separately.

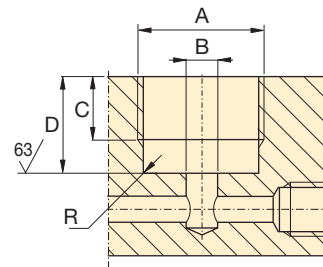
■ The combination of Enerpac swing cylinders and work supports guarantee clamping without deformation.



Manifold work support mounting dimensions

Eliminates the need for fittings and tubing on the fixture. Use a flange nut to secure your manifold work support.

WFM/WSM



Product dimensions in inches []

Model number	A	B	C	D	R	Manifold O-ring ¹⁾	Flange nut
	ø						
▼ For manifold mount work supports							
WFM-71	1.250-16 UN 2B	.37-.39	.58-.60	.93-.95	.015	ARP-017	FN-301
WSM-71	1.250-16 UN 2B	.37-.39	.58-.60	.93-.95	.015	ARP-017	FN-301

¹⁾ Polyurethane 92 duro.

Threaded work support mounting dimensions

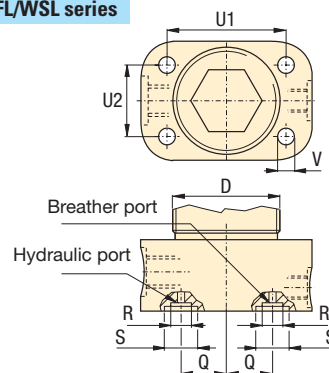
Threaded body work supports can be mounted directly into a fixture. The thread size (D) can be found in the dimension charts on  35 (WFT) and  37 (WST models). Use a flange nut to secure your threaded work support in the required position.

Lower flange work support mounting dimensions

Lower flange work supports can be bolted straight onto a fixture, or can be mounted into a fixture. Flange nuts can be used to secure the cylinders at the required height.

Note: It is critical to keep breather port open to clean dry location.

WFL/WSL series



Product dimensions in inches []

Model numbers	D	Q	R	S	U1	U2	V	Manifold O-ring ¹⁾	Flange nut
			ø	ø					
▼ For lower flange work supports									
WFL-111	1.375-18UNEF	.57	.23	.37	1.62	.94	.284	ARP-010	FN-351
WFL-221	2.625-20UN	1.08	.34	.56	2.18	2.18	.284	ARP-110	—
WFL-331	2.88	1.20	.34	.56	2.44	2.44	.284	ARP-110	—
WFL-441	3.38	1.44	.34	.56	2.94	2.94	.284	ARP-110	—
WSL-111	1.375-18UNEF	.57	.23	.34	1.62	.94	.284	ARP-010	FN-351
WSL-221	2.625-20UN	1.08	.34	.56	2.18	2.18	.284	ARP-110	—
WSL-331	2.88	1.20	.34	.56	2.44	2.44	.284	ARP-110	—
WSL-441	3.38	1.44	.34	.56	2.94	2.94	.284	ARP-110	—

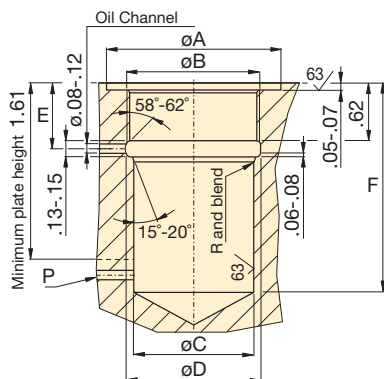
¹⁾ Polyurethane 92 duro.



Cartridge work support mounting dimensions

Can be designed onto narrow fixture plates as thru-hole mounting is fully functional.

WFC/WSC



Dimensions in inches []

Model numbers	A	B	C	D	E	F	Ventilation below F required
	mm						min.
▼ Hydraulic advance							
WFC-72	1.68-1.70	M33x1,5	1.182-1.184	1.31-1.33	.62-.68	2.08	No
WFC-112	2.26-2.28	M42x1,5	1.499-1.501	1.67-1.69	.69-.75	2.46	Yes
WFC-222	3.01-3.03	M60x1,5	2.249-2.251	2.38-2.40	.69-.72	2.80	Yes
▼ Spring advance							
WSC-72	1.68-1.70	M33x1,5	1.182-1.184	1.31-1.33	.62-.68	2.08	No
WSC-112	2.26-2.28	M42x1,5	1.499-1.501	1.67-1.69	.69-.75	1.80	Yes
WSC-222	3.01-3.03	M60x1,5	2.249-2.251	2.38-2.40	.69-.72	2.20	Yes

Note: Ventilation required on WFC-112, 222 below 1.61 inch when mounted in blind cavity.

Positive locking work support mounting dimensions

Positive locking work support mounting dimensions are indicated in the dimension chart on [39](#). For threaded models, use a flange nut to secure the work support in the required position.

Force: 1650 - 10,000 lbs

Stroke: .38 - .65 inch

Pressure: 700 - 5000 psi

E Cilindros de soporte

F Vérin anti-vibreur

D Abstützzylinder

Options

Accessories

[78](#)



In-line filters

[157](#)



Fittings

[158](#)



Swing cylinders

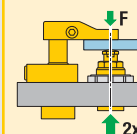
[10](#)



Important

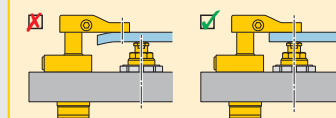
WARNING!

Support force and clamping force must be matched.
Support force should be at least 200% of clamping force.



Do not exceed maximum flow rates to avoid premature lockup.

Always center load over work support.



Linear cylinders

Linear Cylinders

A wide variety of styles and features make Enerpac's linear cylinder line the most complete in the industry. Ranging from compact short stroke spring return cylinders to heavy-duty industrial grade double-acting automation cylinders, Enerpac has the cylinder to meet every application need. Whether you have to push it, pull it, clamp it, punch it, stamp it, press it, or hold it in place for days at a time, Enerpac has the cylinder to meet your need.

Technical support

Refer to the "Yellow Pages" of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

 161 ►



	▼ series	▼ page	
Link clamp / Link clamp arms	LU LCA	44 - 45 46 - 47	
Pull cylinder range overview		48 - 49	
Upper flange pull cylinders	PU	50 - 51	
Lower flange pull cylinders	PL	52 - 53	
Threaded body pull cylinders	PT	54 - 55	
Linear cylinders		56 - 85	
Threaded cylinders	CST, CDT	56 - 57	
Additional threaded cylinders	CYDA, WRT, WMT	58 - 59	
Manifold cylinders	CSM	60 - 61	
Block cylinders	CSB CDB	62 - 65	
Pull down clamps	ECH, ECM	66 - 67	
Hollow plunger cylinders	CY, HCS, QDH, RWH	68 - 69	
Positive clamping cylinders	MRS	70 - 71	
Positive locking push cylinders (<i>Collet-Lok®</i>)	WP	72 - 73	
Single-acting universal cylinders	BRW, MRW, RW	74 - 75	
Double-acting universal cylinders	RD, AD	76 - 77	
Cylinder accessories		78 - 79	
Tie rod cylinder	TR	80 - 85	

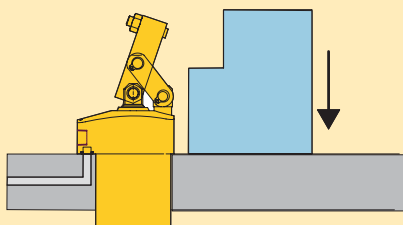
Link clamp *Application & selection*

Shown: LUCS-31

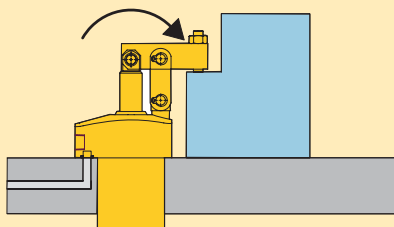


Link clamp allows unobstructed part loading and high clamping forces. The hydraulic cylinders extend to provide clamping force, and retract to allow part removal.

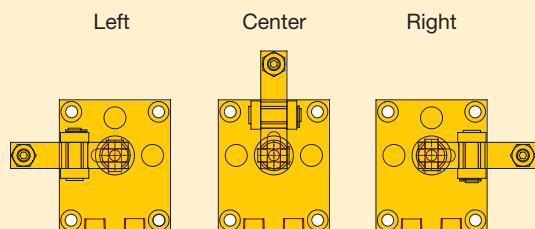
Arm completely retracts to allow part loading.



As cylinder extends, arm rotates to clamp part in place.



Arm location is changed easily without the use of tools.



Quick and accurate clamping action

- Hydraulic cylinder pushes linkage, rotating clamp arm into position
- Design ensures repeatable clamping location
- Linkage can be re-positioned to clamp at 90, 180, or 270 degrees from ports
- Clamps can be mounted using supplied bolts or held in place with flange nut
- Standard arm or long arm ordered separately

Product selection

Clamping force ¹⁾	Stroke	Model number	Cylinder effective area	Oil capacity	Standard clamp arm (Sold separately)	Long clamp arm (Sold separately)
lbs	in		in ²	in ³		

▼ Single acting

675	0.73	LUCS-31	0.19	0.14	LCAS-32	LCAL-32
1750	0.93	LUCS-81	0.48	0.44	LCAS-82	LCAL-82
2650	1.20	LUCS-121	0.64	0.77	LCAS-122	LCAL-122
4200	1.40	LUCS-191	0.99	1.38	LCAS-192	LCAL-192
6100	1.85	LUCS-281*	1.49	2.76	LCAS-282	LCAL-282

▼ Double acting

700	0.73	LUCD-31	0.19	0.14	LCAS-32	LCAL-32
1800	0.93	LUCD-81	0.48	0.44	LCAS-82	LCAL-82
2700	1.20	LUCD-121	0.64	0.77	LCAS-122	LCAL-122
4300	1.40	LUCD-191	0.99	1.38	LCAS-192	LCAL-192
6300	1.85	LUCD-281*	1.49	2.76	LCAS-282	LCAL-282

Contact Enerpac for models with metric threads and BSPP ports.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Dimensions in inches []

Model number	Port Size	C1	C2	C3	D	D1	D2	E
--------------	-----------	----	----	----	---	----	----	---

▼ Single acting

LUCS-31	SAE#2	1.10	1.44	2.17	1.875-16UN	2.44	2.20	28.0°
LUCS-81	SAE#2	1.18	1.56	2.48	2.50-16UN	3.23	2.76	25.4°
LUCS-121	SAE#4	1.46	1.95	3.15	3.125-16 UN	4.02	3.46	27.1°
LUCS-191	SAE#4	1.57	2.30	3.70	3.50-16 UN	4.69	4.02	27.1°
LUCS-281*	SAE#4	1.97	2.60	4.45	4.125-16 UN	5.31	4.72	27.1°

▼ Double acting

LUCD-31	SAE#2	1.10	1.44	2.17	1.875-16 UN	2.44	2.20	28.0°
LUCD-81	SAE#2	1.18	1.56	2.48	2.50-16 UN	3.23	2.76	25.4°
LUCD-121	SAE#4	1.46	1.95	3.15	3.125-16 UN	4.02	3.46	27.1°
LUCD-191	SAE#4	1.57	2.30	3.70	3.50-16 UN	4.69	4.02	27.1°
LUCD-281*	SAE#4	1.97	2.60	4.45	4.125-16 UN	5.31	4.72	27.1°

Contact Enerpac for models with metric threads and BSPP ports.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



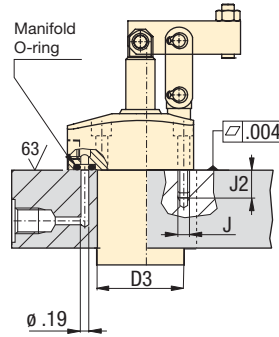
Installation dimensions in inches

Pull ¹⁾ force lbs	Fixture hole Ø D3	Mounting thread J UNF	Min. depth J2	Manifold O-ring ²⁾ ARP No. or Inside Ø x thickness
700	1.885	.250-28	0.65	-010
1800	2.510	.312-24	0.75	-010
2700	3.135	.312-24	0.75	-010
4300	3.515	.375-24	0.88	-010
6300	4.140	.500-20	0.94	-010

¹⁾ With standard clamp arm.

²⁾ Polyurethane, 92 Durometer

Note: Mounting bolts and O-rings included.



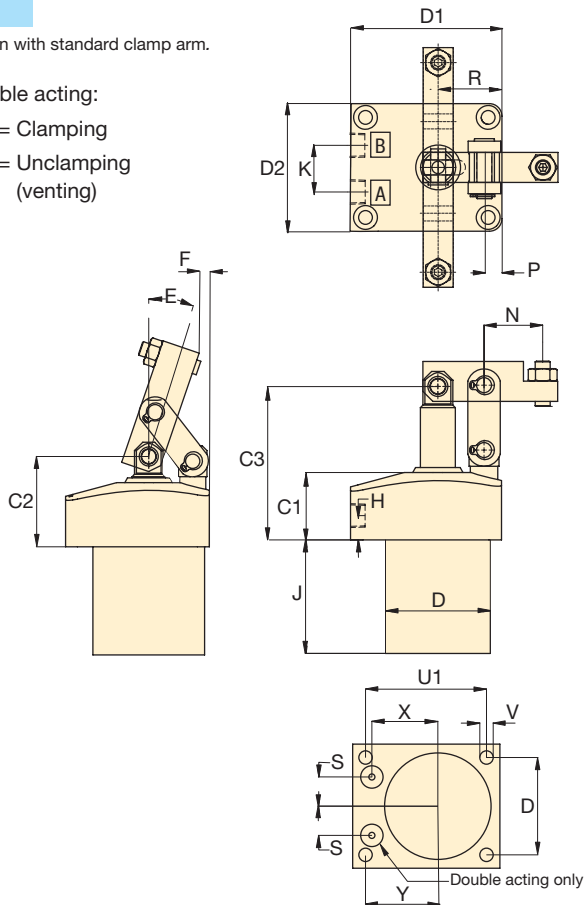
all models

Dimensions shown with standard clamp arm.

Double acting:

[A] = Clamping

[B] = Unclamping
(venting)



Clamp force: 700-6300 lbs

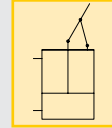
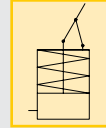
Stroke: 0.73-1.85 inch

Pressure: 500-5000 psi

E Cilindros Amarre de enlace

F Bride basculante

D Gelenkspanner



Options

Clamp arms

44 ▶



Work supports

30 ▶



Important

Single-acting cylinders use a regenerative circuit; oil is sent to both sides of the piston at the same time. This eliminates the breather port, reducing damage from coolant and contamination.

Clamp arm should be parallel to cylinder mounting surface within 3° to avoid damage to cylinder and linkage. Use the included set screw to adjust clamp arm alignment.

F	H	J	K	N	P	R	S	U1	U2	V	X	Y	lbs
---	---	---	---	---	---	---	---	----	----	---	---	---	-----

Single acting ▼

0.04	0.41	1.85	-	0.93	0.33	1.10	0.412	2.05	1.81	0.28	1.130	1.14	2.7
0.01	0.43	2.56	-	1.26	0.35	1.38	0.552	2.68	2.20	0.32	1.517	1.57	5.5
0.03	0.47	2.80	-	1.48	0.47	1.73	0.633	3.46	2.91	0.32	1.739	2.01	10.0
0.09	0.59	3.46	-	1.63	0.59	2.01	0.714	3.98	3.23	0.41	1.961	2.32	15.2
0.11	0.79	3.90	-	2.01	0.63	2.36	0.821	4.53	3.94	0.51	2.257	2.52	25.9

Double acting ▼

0.04	0.41	1.85	0.79	0.93	0.30	1.10	0.857	2.05	1.81	0.28	0.799	1.14	2.7
0.01	0.43	2.56	0.94	1.26	0.41	1.38	1.000	2.68	2.20	0.32	1.191	1.57	5.5
0.03	0.47	2.80	1.18	1.48	0.55	1.73	1.039	3.46	2.91	0.32	1.484	2.01	10.0
0.09	0.59	3.46	1.30	1.63	0.57	2.01	1.112	3.98	3.23	0.41	1.926	2.32	15.2
0.11	0.79	3.90	1.50	2.01	0.61	2.36	1.181	4.53	3.94	0.51	2.046	2.52	25.9

Clamp arms *for link clamps*

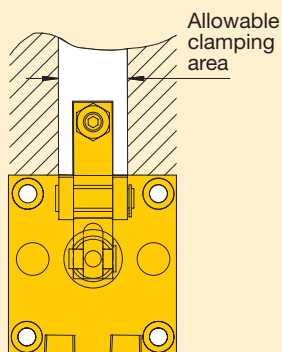
Shown: LCAS-31



Standard arms are readily available from Enerpac to meet most applications. In applications that require a custom designed arm, the machining information is supplied on page 45.

Important

Clamp point must be within the boundaries of the anchor links on the clamp. Clamping outside of this area will cause damage to the linkage, leading to premature failure.

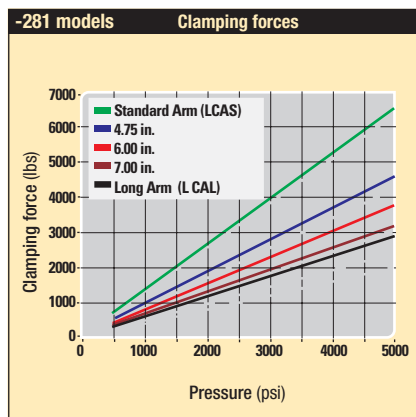
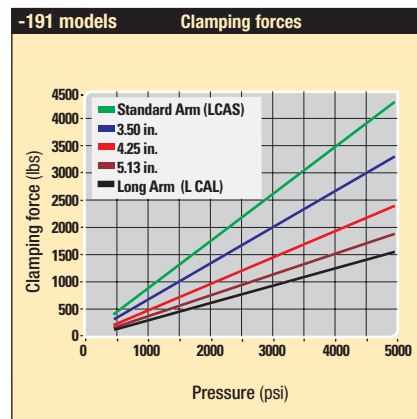
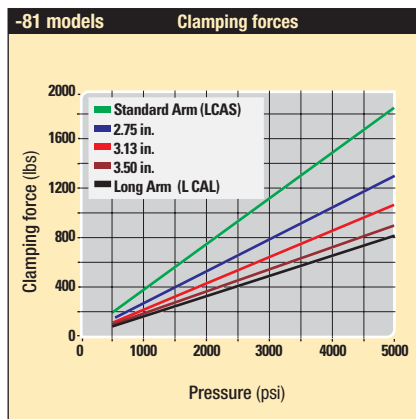
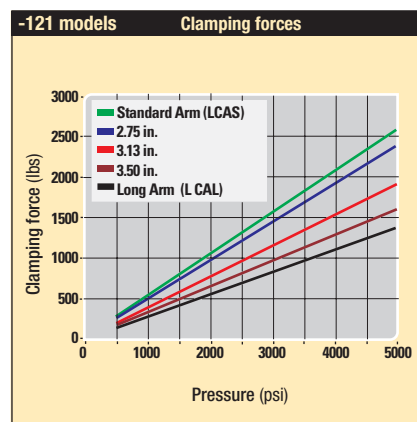
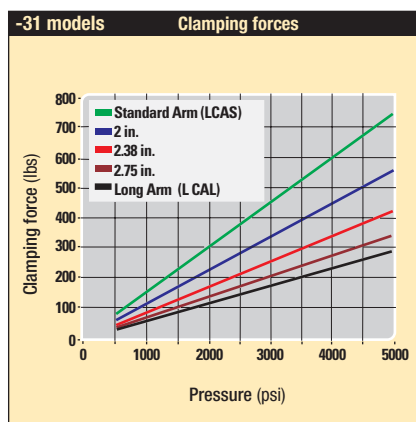


Standard or custom built

- Available from Enerpac in standard or extended length
- Standard arm includes set screw and lock nut
- Long arm can be machined on-site to match your needs
- Make your own custom arm to suit specific applications

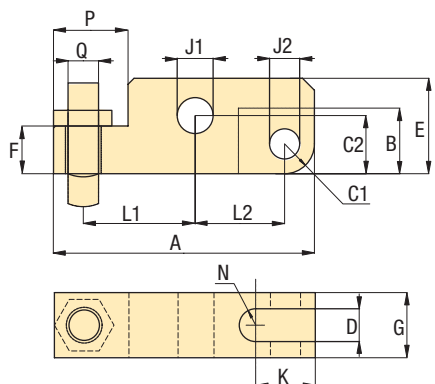
Pressure vs clamping force

Different length clamp arms will determine the amount of clamping force transferred to the workpiece. As the length increases, the clamping force decreases.





LCAS models Standard Arm

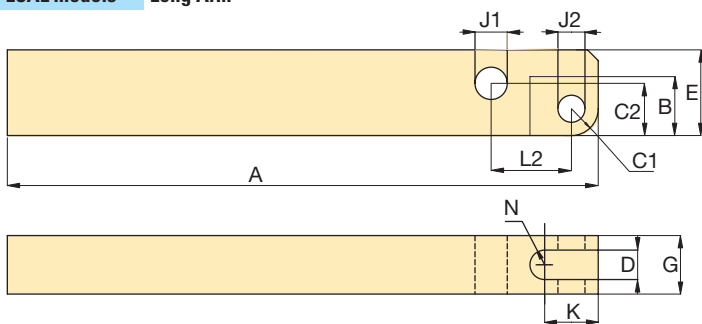


Dimensions in inches []

Clamp capacity lbs	Model number	A	B	C1	C2	D	E	F	G
▼ Standard clamp arms									
700	LCAS-32	2.13	0.51	0.24	0.37	0.24	0.63	0.31	0.47
1800	LCAS-82	2.93	0.69	0.31	0.61	0.39	0.98	0.51	0.74
2700	LCAS-122	3.44	0.87	0.39	0.77	0.43	1.26	0.63	0.86
4300	LCAS-192	4.04	1.02	0.43	0.94	0.51	1.50	0.87	0.98
6300	LCAS-282	4.92	1.20	0.51	1.14	0.63	1.77	1.06	1.25

Clamp capacity lbs	Model number	J1	J2	K	L1	L2	N	P	Q
▼ Standard clamp arms									
700	LCAS-32	0.237-0.239	0.237-0.239	0.51	0.93	0.73	0.12	0.51	M6 x 1,0
1800	LCAS-82	0.396-0.398	0.317-0.319	0.63	1.26	0.96	0.20	0.87	M10 x 1,5
2700	LCAS-122	0.474-0.476	0.396-0.398	0.79	1.48	1.18	0.22	0.98	M12 x 1,75
4300	LCAS-192	0.593-0.595	0.474-0.476	0.94	1.63	1.42	0.26	1.22	M16 x 2,0
6300	LCAS-282	0.711-0.713	0.593-0.595	1.10	2.01	1.73	0.31	1.50	M20 x 2,5

LCAL models Long Arm



NOTE: Custom arms should be manufactured using this print. Make sure to follow all precautions listed.

Dimensions in inches []

Clamp capacity lbs	Model number	A	B	C1	C2	D	E	G	J1	J2	K	L2	N
▼ Long clamp arms													
800	LCAL-32	3.35	0.51	0.24	0.37	0.24	0.63	0.47	0.237-0.239	0.237-0.239	0.51	0.73	0.12
1800	LCAL-82	4.13	0.69	0.31	0.61	0.39	0.98	0.74	0.396-0.398	0.317-0.319	0.63	0.96	0.20
2700	LCAL-122	4.33	0.87	0.39	0.77	0.43	1.26	0.86	0.474-0.476	0.396-0.398	0.79	1.18	0.22
4300	LCAL-192	6.30	1.02	0.43	0.94	0.51	1.50	0.98	0.593-0.595	0.474-0.476	0.94	1.42	0.26
6300	LCAL-282	8.66	1.20	0.51	1.14	0.63	1.77	1.25	0.711-0.713	0.593-0.595	1.10	1.73	0.31

Force: 700-6300 lbs

Pressure: 500-5000 psi

- E** Brazos de amarre
- F** Bras de bridage
- D** Spannarme

Options

Work supports

30 ▶



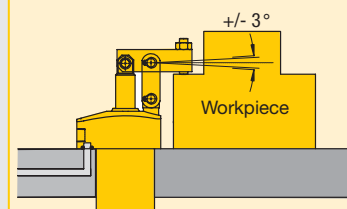
Accessories

76 ▶



Important

Clamp arm should be parallel to cylinder mounting surface within 3° to avoid damage to cylinder and linkage. Use the included set screw to adjust clamp arm alignment.



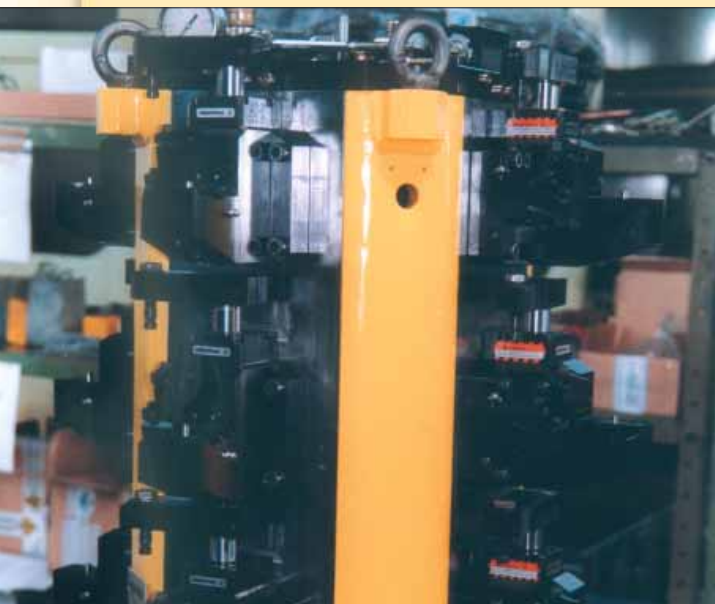
Shown: PLSS-121, WPTC-110, PUSD-121



Hydraulic pull cylinders utilize hydraulic pressure to hold down parts in a fixture. The guided plunger maintains orientation during the full clamping cycle, eliminating the need for an external guide. Internally threaded plunger ends accept various custom attachments to assist in the clamping process.

Enerpac offers both single- and double-acting pull cylinders, with capacities ranging from 600 to 9600 lbs. for pulling and 1,200 to 18,400 lbs. for pushing applications.

Hydraulic fixture with pull and swing cylinders, manifold and threaded cylinders for positioning and holding the work piece during milling process of gun breeches.



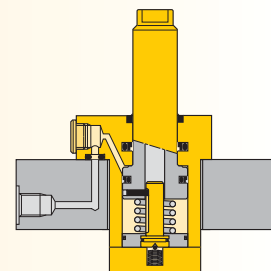
Compact and full featured design

- Guided linear plunger movement
- Compact design allows for efficient fixture layout
- Variety of mounting styles to meet design needs
- Internal plunger thread and flats across plunger top allow easy mounting of attachments
- Choice of porting styles to meet system and design requirements
- Single- and double-acting cylinders to suit a variety of hydraulic requirements

Select your pull cylinder type:

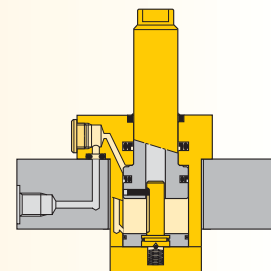
Single acting

- The obvious choice when there are few system restrictions, and there are not many units retracting simultaneously
- Fewer valving requirements which results in a less complex circuit



Double acting

- When greater control is required during the unclamp cycle
- When heavy attachments are being used
- When timing sequences are critical: less sensitive to system back pressures resulting from long tube lengths or numerous components being retracted at the same time



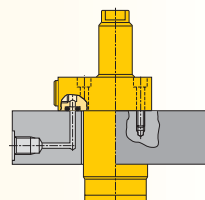
For Collet-Lok® push cylinders, see 54 ▶



Select your mounting method:

PU series, Upper flange mounting

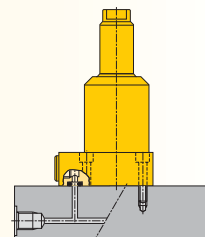
- Flexible design allows for manifold or threaded oil port connection
- Fixture hole does not require tight tolerances
- Easy installation with only 3 or 4 mounting bolts



48 ▶

PL series, Lower flange mounting

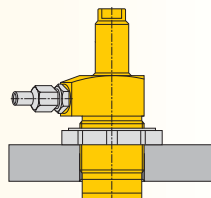
- Flexible design allows for manifold or threaded port connection
- No fixture hole required
- Easy installation with only 3 or 4 mounting bolts



50 ▶

PT series, Threaded body mounting

- Body thread for precise cylinder height positioning
- Threaded oil port connection
- Can be threaded directly into the fixture and secured in position by means of standard flange nuts



52 ▶

Product selection

Cylinder capacity		Stroke	Upper flange	Lower flange	Threaded body
lbs		in			
Pull	Push				
▼ Single acting			Model number		
1250	–	.89	PUSS-51	PLSS-51	PTSS-51
2950	–	1.12	PUSS-121	PLSS-121	PTSS-121
▼ Double acting			Model number		
1400	2950	.89	PUSD-51	PLSD-51	PTSD-51
2475	6300	.87	PUSD-92	PLSD-92	PTSD-92
3150	6150	1.12	PUSD-121	PLSD-121	PTSD-121

Note: - Call Enerpac to order models with metric thread and BSPP port connections.
- Pull forces for single-acting cylinders reduced to overcome spring force.

Pull force: 1250-3150 lbs

Push force: 2950-6300 lbs

Stroke: 0.87-1.12 inch

Pressure: 500-5000 psi

E Cilindros de tracción

F Verins traction

D Zugzylinder



Linear cylinders

Power sources

Valves

Valves

System components

Yellow pages

Options

Accessories

76 ▶



Collet-Lok® push cylinders

54 ▶



Work supports

30 ▶



Swing cylinders

10 ▶



Sequence valves

120 ▶



Pull cylinders - Upper flange models

Shown: PUSS-51, PUSD-121

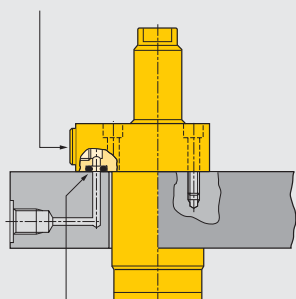


PU series

Upper flange pull cylinders are designed for integrated manifold mounting solutions.

Hydraulic connections are made through SAE or BSPP oil connection or the standard integrated O-ring ports.

SAE oil connection



Integrated O-ring port

■ Enerpac upper flange pull cylinders in a fixture for gun breech production.



Minimal mounting height

...when space is at a premium

- Guided linear plunger movement
- Flexible design allows for manifold or threaded port connection
- Low profile mounting style allows body to be below mounting surface
- Internal plunger thread allows easy mounting of attachments
- Simple mounting preparation
- Easy to machine fixture hole: does not require tight tolerances
- Easy assembly: 3 or 4 mounting bolts
- Double oil connection: threaded port or manifold mount

Product selection

Cylinder capacity		Stroke	Model number	Cylinder effective area		Oil capacity	
lbs	Push	in		in ²	Push	in ³	Push
Pull	Push			Pull	Push	Pull	Push
▼ Single acting							
1250	–	.89	PUSS-51	.28	–	.25	–
2950	–	1.12	PUSS-121	.63	–	.70	–
▼ Double acting							
1400	2950	.89	PUSD-51	.28	.59	.25	.53
2475	6300	.87	PUSD-92	.49	1.25	.42	1.08
3150	6150	1.12	PUSD-121	.63	1.23	.70	1.40

Note: - Call Enerpac to order models with BSPP oil connections.
- Pull forces for single-acting cylinders reduced to overcome spring force.

Dimensions in inches []

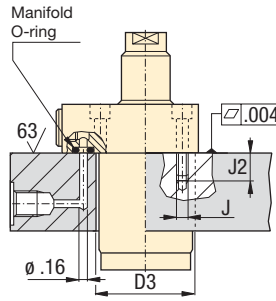
Model number	A	B	C1	D	D1	D2	E	E1	F	H
					ø			ø	ø	ø
▼ Single acting										
PUSS-51	5.06	4.17	.98	1.37	2.13	2.25	.63	.59	.52	.39
PUSS-121	6.31	5.19	1.00	1.88	2.63	2.88	.87	.82	.68	.38
▼ Double acting										
PUSD-51	5.06	4.17	.98	1.37	2.13	2.25	.63	.59	.52	.39
PUSD-92	5.12	4.25	.98	1.88	2.76	2.12	.98	.93	.71	.51
PUSD-121	6.31	5.19	1.00	1.88	2.63	2.88	.87	.82	.68	.38



Installation dimensions in inches

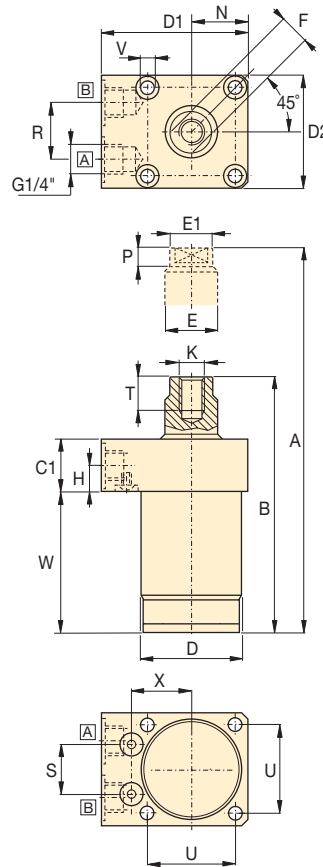
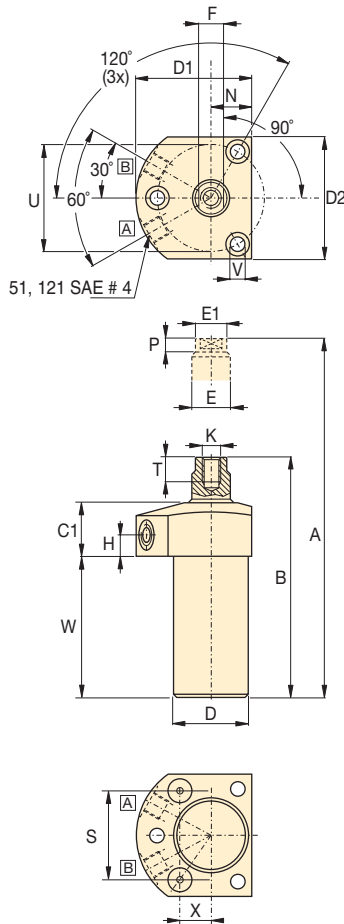
Pull force lbs	Fixture hole Ø D3	Mounting thread J UNF	Min. depth J2	Manifold O-ring ¹⁾ ARP numbers or Inside Ø x thickness
1400	1.39	.250-28	.65	568-011
2475	1.93	M6	.59	.17 x .139
3150	1.89	.312-24	.80	568-011

¹⁾ O-ring material: polyurethane, 92 Durometer



-51, 121

-92



[A] = Pull
[B] = Push (venting)

Pull force: 1250-3150 lbs

Push force: 2950-6300 lbs

Stroke: .87-1.12 inch

Pressure: 500-5000 psi

E Cilindros de tracción

F Verins traction

D Zugzylinder



Options

Accessories

76



Collet-Lok® push cylinders

54



Swing cylinders

10



Sequence valves

120



Important

Single-acting cylinders
can be vented through the
manifold port.

The upper flange pull cylinder
has a bolt pattern which
is identical to its lower
flange equivalent, enabling
interchangeability.

In case there is a risk of
machining coolants and
debris being inhaled via
the breather vent, it is
recommended to pipe this
port to an area outside the
fixture that is protected
from machining coolants
and debris.

K	N	P	R	S	T	U	V	W	X	lbs	Model number
Single acting ▼											
.312-24 UNF	.75	.23	—	1.614	.62	1.97	.27	2.60	0.565	2.5	PUSS-51
.500-20 UNF	1.00	.38	—	2.048	.75	2.50	.35	3.38	0.717	3.5	PUSS-121
Double acting ▼											
.312-24 UNF	.75	.23	—	1.614	.62	1.97	.27	2.60	0.565	2.5	PUSD-51
M10 x 1,50	1.06	.41	1.02	.93	.63	1.65	.27	2.67	1.128	4.4	PUSD-92
.500-20 UNF	1.00	.38	—	2.048	.75	2.50	.35	3.38	0.717	3.5	PUSD-121

NOTE: U= bolt circle

Pull cylinders - Lower flange models

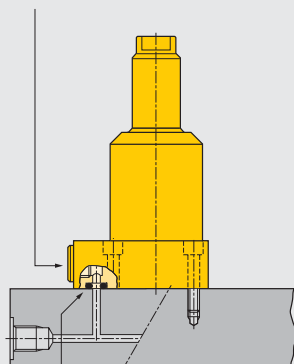
Shown: PLSD-51, PLSD-121



PL series

The lower flange cylinders are designed for integrated manifold mounting solutions. Hydraulic connections are made through SAE or BSPP oil connection or the standard integrated O-ring ports.

SAE oil connection



Integrated O-ring port

Minimal mounting height

...when space is at a premium

- Guided linear plunger movement
- Flexible design allows for manifold or threaded port connection
- Low profile mounting style allows body to be below mounting surface
- Internal plunger thread allows easy mounting of attachments
- Easiest mounting preparation in the line
- Easy to machine fixture hole: does not require tight tolerances
- Easy assembly: 3 or 4 mounting bolts
- Double oil connection: threaded port or manifold mount

Product selection

Cylinder capacity		Stroke	Model number	Cylinder effective area		Oil capacity	
lbs	Push	in		in ²	Push	in ³	Push
Pull				Pull		Pull	
▼ Single acting							
1250	–	.89	PLSS-51	.28	–	.25	–
2950	–	1.12	PLSS-121	.63	–	.70	–
▼ Double acting							
1400	2950	.89	PLSD-51	.28	.59	.25	.53
2475	6300	.87	PLSD-92	.49	1.25	.42	1.08
3150	6150	1.12	PLSD-121	.63	1.23	.70	1.40

Note: - Call Enerpac to order models with BSPP oil connections.
- Pull forces for single-acting cylinders reduced to overcome spring force.

Dimensions in inches []

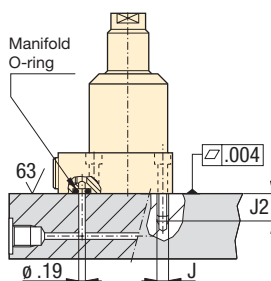
Model number	A	B	C	C1	D	D1	D2	E	E1	F	H
					ø			ø			
▼ Single acting											
PLSS-51	5.06	4.17	3.33	.98	1.37	2.13	2.25	.63	.59	.52	.55
PLSS-121	6.31	5.19	4.38	1.00	1.88	2.63	2.88	.87	.82	.68	.62
▼ Double acting											
PLSD-51	5.06	4.17	3.33	.98	1.37	2.13	2.25	.63	.59	.52	.55
PLSD-92	5.43	4.57	4.00	.98	1.88	2.76	2.12	.98	.93	.71	.51
PLSD-121	6.31	5.19	4.38	1.00	1.88	2.63	2.88	.87	.82	.68	.62



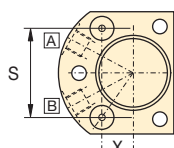
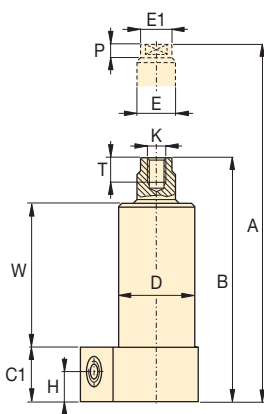
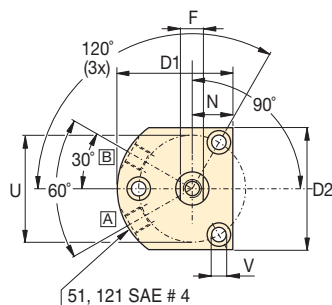
Installation dimensions in inches

Pull force lbs	Mounting thread J UNF	Minimum depth J2	Manifold O-ring ¹⁾ ARP numbers or inside Ø x thickness
1400	.250-28	.65	568-011
2475	M6	.59	.17 x .139
3150	.312-24	.80	568-011

¹⁾ O-ring material: polyurethane, 92 Durometer

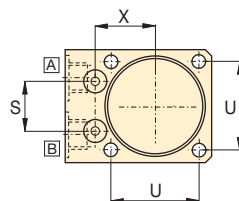
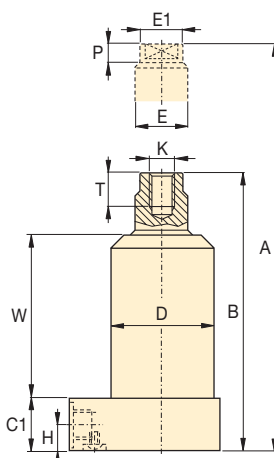
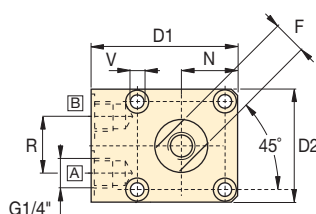


-51, 121



A = Pull
B = Push (venting)

-92



Pull force: 1250-3150 lbs

Push force: 2950-6300 lbs

Stroke: .87-1.12 inch

Pressure: 500-5000 psi

E Cilindros de tracción**F** Verins traction**D** Zugzylinder

Options

Accessories

76 ▶

Collet-Lok®
push cylinders

54 ▶

Swing
cylinders

10 ▶

Sequence
valves

120 ▶



Important

Single-acting cylinders
can be vented through the
manifold port.

The lower flange pull cylinder
has a bolt pattern which
is identical to its upper
flange equivalent, enabling
interchangeability.

In case there is a risk of
machining coolants and
debris being inhaled via
the breather vent, it is
recommended to pipe
this port to an area outside
the fixture that is protected
from machining coolants
and debris.

K	N	P	R	S	T	U	V	W	X	lbs	Model number
						Ø			Ø		
											Single acting ▼
.312-24 UNF	.75	.23	—	1.614	.62	1.97	.27	2.69	0.565	2.5	PLSS-51
.500-20 UNF	1.00	.38	—	2.048	.75	2.50	.35	3.48	0.717	3.5	PLSS-121
											Double acting ▼
.312-24 UNF	.75	.23	—	1.614	.62	1.97	.27	2.69	0.565	2.5	PLSD-51
M10 x 1.50	.41	1.06	1.02	.93	.63	1.65	.27	3.09	1.128	4.4	PLSD-92
.500-20 UNF	1.00	.38	—	2.048	.75	2.50	.35	3.48	0.717	3.5	PLSD-121

Pull cylinders - Threaded body models

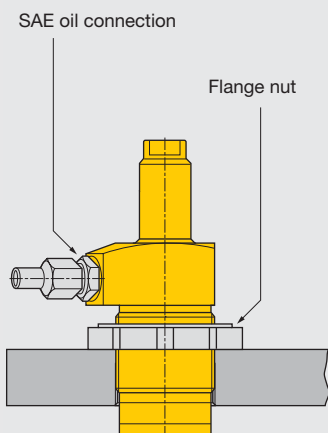
Shown: PTSD-51



PT series

The threaded body pull cylinders can be bolted to the fixture. This allows easy installation or removal of the unit and does not require machined fixture holes.

The cylinder is adjusted to the appropriate height, and then locked in place using a flange nut (□78).



■ Threaded body pull cylinder with modified clamp arm, mounted on a frame-straightening fixture.



Threaded directly into the fixture

...can be secured at any height

- Guided linear plunger movement
- Threaded port connection
- Internal plunger thread allows easy mounting of attachments
- Simple mounting preparation
- Easy installation and removal
- Greatest flexibility in fixture design

Product selection

Cylinder capacity		Stroke	Model number	Cylinder effective area		Oil capacity	
lbs	Push	in		in ²	Push	in ³	Push
Pull				Pull		Pull	
▼ Single acting							
1250	–	.89	PTSS-51	.28	–	.25	–
2950	–	1.12	PTSS-121	.63	–	.70	–
▼ Double acting							
1400	2950	.89	PTSD-51	.28	.59	.25	.53
2475	6300	.87	PTSD-92	.49	1.25	.42	1.08
3150	6150	1.12	PTSD-121	.63	1.23	.70	1.40

Note: - Call Enerpac to order models with BSPP oil connections.

- Pull forces for single-acting cylinders reduced to overcome spring force.

Dimensions in inches []

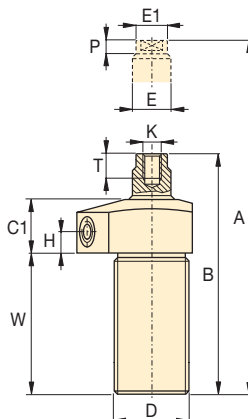
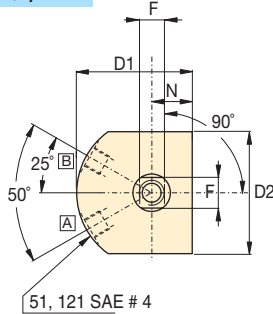
Model number	A	B	C	C1	D	D1	D2
					ø		
▼ Single acting							
PTSS-51	5.06	4.17	3.33	.98	1.375-18 UNEF	1.97	1.50
PTSS-121	6.31	5.19	4.38	.98	1.875-16 UN	2.38	2.00
▼ Double acting							
PTSD-51	5.06	4.17	3.33	.98	1.375-18 UNEF	1.97	1.50
PTSD-92	5.12	4.25	3.66	.98	M48 x 1,5	2.46	1.89
PTSD-121	6.31	5.19	4.38	.98	1.875-16 UN	2.38	2.00



Installation dimensions in inches

Pull force lbs	Fixture hole thread size D3
1400	1.375-18 UNEF
2475	M48 x 1,5
3150	1.875-16 UNF

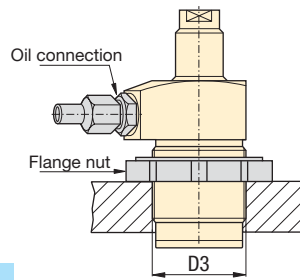
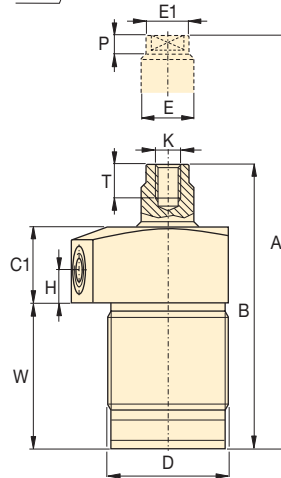
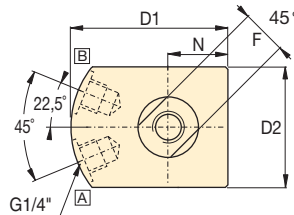
-51, 121



[A] = Pull

[B] = Push (venting)

-92



Pull force: 1250-3150 lbs

Push force: 2950-6300 lbs

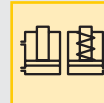
Stroke: .87-1.12 inch

Pressure: 500-5000 psi

E Cilindros de tracción

F Verins traction

D Zugzylinder



Options

Accessories

76 ▶



Collet-Lok® swing cylinders

54 ▶



Swing cylinders

10 ▶



Sequence valves

120 ▶



Accessory chart

Model number	Mounting flange Sold separately 79 ▶	Flange nut Sold separately 78 ▶
--------------	--	---------------------------------------

▼ Single acting

PTSS-51	MF-351	FN-351
PTSS-121	MF-481	FN-811

▼ Double acting

PTSD-51	MF-351	FN-351
PTSD-92	MF-482	FN-482
PTSD-121	MF-481	FN-481

E	E1	F	H	K	N	P	T	W	lbs	Model number
ø	ø									
Single acting ▼										
.63	.59	.52	.39	.312-24 UNF	.75	.23	.62	2.60	2.5	PTSS-51
.87	.82	.68	.38	.500-20 UNF	1.00	.38	.75	3.38	3.5	PTSS-121
Double acting ▼										
.63	.59	.52	.39	.312-24 UNF	.75	.23	.62	2.60	2.5	PTSD-51
.98	.93	.71	.51	M10 x 1,5	.94	.41	.63	2.47	4.4	PTSD-92
.87	.82	.68	.38	.500-20 UNF	1.00	.38	.75	3.38	3.5	PTSD-121

Important

Single-acting cylinders can be vented through the manifold port.

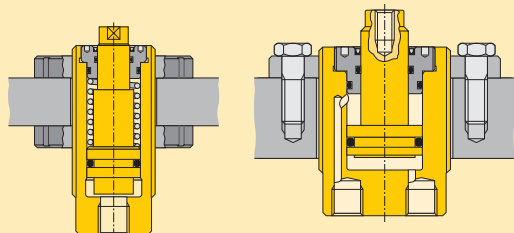
In case there is a risk of machining coolants and debris being inhaled via the breather vent, it is recommended to pipe this port to an area outside the fixture that is protected from machining coolants and debris.

Threaded cylinders *Application & selection*

Shown: CST-9381, CST-571, CST-18251, CDT-18131, CDT-40251



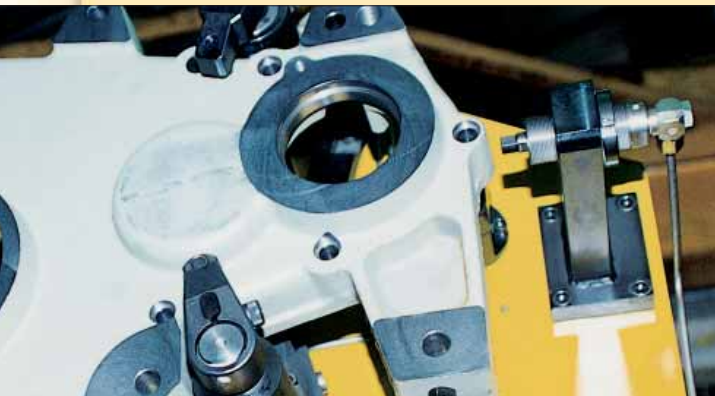
Threaded cylinders are designed for workpiece positioning, holding and ejecting applications where space is at a premium. Double-acting models are also suited to manufacturing applications, such as production punching.



Accessory chart

Body thread	Mounting flange Sold Separately 79 ▶	Flange nut Sold Separately 78 ▶	Plunger thread	Contact bolt 78 ▶
D			K	
0.500-20 UN	MF-121	FN-121	#6-32 UN	BS-21
0.750-16 UN	MF-201	FN-201	#8-32 UN	BS-41
1.000-12 UN	MF-251	FN-251	0.250-28 UN	BS-61
1.313-16 UN	MF-331	FN-331	0.313-24 UN	BS-81
1.625-16 UN	MF-421	FN-421	0.375-16 UN	BS-91
1.875-16 UN	MF-481	FN-481	0.500-13 UN	BS-101
2.125-16 UN	MF-551	FN-551		
2.500-16 UN	MF-651	FN-651		

Threaded cylinder, mounted with horizontal bracket to position the workpiece against the stops. Enerpac swing cylinders are then activated to clamp the work piece before machining operations begin.



High clamping forces in a compact body

- Minimum cylinder diameter combined with maximized clamping forces
- Threaded body allows fine positioning and easy installation
- Internal plunger wipers allow maintenance-free, high-cycle performance
- Center-tapped plungers will hold workpiece contact buttons
- Single-acting models with spring return simplify hydraulic tubing requirements
- Double-acting models are recommended for high-cycle applications

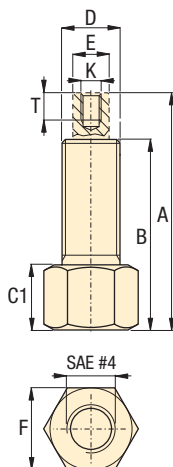
Product selection

Cylinder capacity at 5000 psi lbs		Nominal stroke	Model number	Effective area		Oil capacity	
push	pull	in		in ² push	pull	in ³ push	pull
▼ Single acting							
380	–	0.28	CST-271	0.08	–	0.02	–
380	–	0.39	CST-2101	0.08	–	0.03	–
380	–	0.51	CST-2131	0.08	–	0.04	–
980	–	0.28	CST-471	0.20	–	0.05	–
980	–	0.51	CST-4131	0.20	–	0.10	–
980	–	0.75	CST-4191	0.20	–	0.15	–
980	–	0.98	CST-4251	0.20	–	0.19	–
980	–	1.50	CST-4381	0.20	–	0.29	–
1950	–	0.28	CST-971	0.39	–	0.11	–
1950	–	0.51	CST-9131	0.39	–	0.20	–
1950	–	0.75	CST-9191	0.39	–	0.29	–
1950	–	0.98	CST-9251	0.39	–	0.38	–
1950	–	1.50	CST-9381	0.39	–	0.58	–
3950	–	0.51	CST-18131	0.79	–	0.40	–
3950	–	0.98	CST-18251	0.79	–	0.78	–
3950	–	1.50	CST-18381	0.79	–	1.18	–
3950	–	1.97	CST-18501	0.79	–	1.56	–
6110	–	0.59	CST-27151	1.22	–	0.72	–
6110	–	0.98	CST-27251	1.22	–	1.20	–
6110	–	1.97	CST-27501	1.22	–	2.40	–
8800	–	0.51	CST-40131	1.76	–	0.90	–
8800	–	0.98	CST-40251	1.76	–	1.73	–
8800	–	1.50	CST-40381	1.76	–	2.63	–
8800	–	1.97	CST-40501	1.76	–	3.46	–

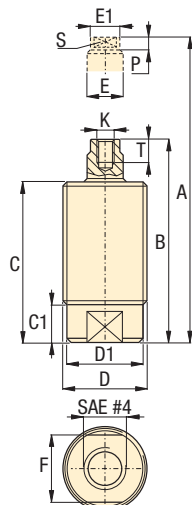
Note: - Seal material: Buna-N, Polyurethane.
- Minimum operating pressure for single-acting models (to overcome return spring force) is 580 psi.



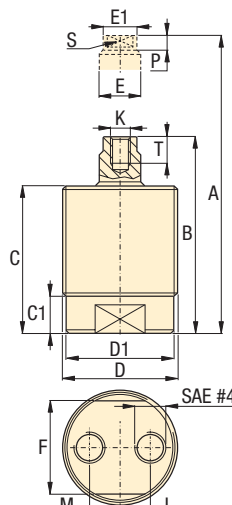
CST-271, -2101, -2131



Other CST models



CDT models



Force: 380-8800 lbs

Stroke: 0.28-1.97 inch

Pressure: 580-5000 psi

E Cilindros roscados

F Vérins corps filetés

D Einschraubzylinder



Options

Accessories



Product dimensions in inches []

Model number	A Ext. height	B Retr. height	C	C1	D ø	D1 ø	E ø	E1 ø	F	K thread	L	M	P	S	T	lbs
▼ Single acting																
CST-271	1.89	1.65	—	0.59	.500-20 UN	—	0.19	—	0.63	#6-32 UN	—	—	—	—	0.19	0.2
CST-2101	2.13	1.78	1.65	0.59	.500-20 UN	—	0.19	—	0.63	#6-32 UN	—	—	—	—	0.19	0.3
CST-2131	2.55	2.03	—	0.59	.500-20 UN	—	0.19	—	0.63	#6-32 UN	—	—	—	—	0.19	0.3
CST-471	2.15	1.87	1.71	0.35	.750-16 UN	0.65	0.27	0.27	0.62	#8-32 UN	—	—	0.16	0.24	0.28	0.4
CST-4131	2.72	2.21	2.05	0.35	.750-16 UN	0.65	0.27	0.27	0.62	#8-32 UN	—	—	0.16	0.24	0.28	0.3
CST-4191	3.37	2.62	2.46	0.35	.750-16 UN	0.65	0.27	0.27	0.62	#8-32 UN	—	—	0.16	0.24	0.28	0.4
CST-4251	3.95	2.97	2.81	0.35	.750-16 UN	0.65	0.27	0.27	0.62	#8-32 UN	—	—	0.16	0.24	0.28	0.5
CST-4381	5.77	4.27	4.11	0.35	.750-16 UN	0.65	0.27	0.27	0.62	#8-32 UN	—	—	0.16	0.24	0.28	0.7
CST-971	2.53	2.25	2.03	0.32	1.000-12 UN	0.88	0.47	0.39	0.79	.250-28 UN	—	—	0.22	0.32	0.39	0.6
CST-9131	3.01	2.50	2.28	0.32	1.000-12 UN	0.88	0.47	0.39	0.79	.250-28 UN	—	—	0.22	0.32	0.39	0.7
CST-9191	3.87	3.11	2.89	0.32	1.000-12 UN	0.88	0.47	0.39	0.79	.250-28 UN	—	—	0.22	0.32	0.39	0.8
CST-9251	4.43	3.43	3.21	0.32	1.000-12 UN	0.88	0.47	0.39	0.79	.250-28 UN	—	—	0.22	0.32	0.39	0.9
CST-9381	5.63	4.12	3.97	0.32	1.000-12 UN	0.88	0.47	0.39	0.79	.250-28 UN	—	—	0.22	0.32	0.39	1.0
CST-18131	3.26	2.75	2.50	0.49	1.313-16 UN	1.22	0.63	0.59	1.06	.313-24 UN	—	—	0.26	0.50	0.47	1.2
CST-18251	4.50	3.52	3.27	0.49	1.313-16 UN	1.22	0.63	0.59	1.06	.313-24 UN	—	—	0.26	0.50	0.47	1.3
CST-18381	5.78	4.27	4.02	0.49	1.313-16 UN	1.22	0.63	0.59	1.06	.313-24 UN	—	—	0.26	0.50	0.47	1.5
CST-18501	6.87	4.90	4.65	0.49	1.313-16 UN	1.22	0.63	0.59	1.06	.313-24 UN	—	—	0.26	0.50	0.47	1.7
CST-27151	3.46	2.87	2.62	0.53	1.625-16 UN	1.52	0.71	0.67	1.37	.375-16 UN	—	—	0.26	0.57	0.47	1.4
CST-27251	4.66	3.68	3.43	0.53	1.625-16 UN	1.52	0.71	0.67	1.37	.375-16 UN	—	—	0.26	0.57	0.47	2.0
CST-27501	7.71	5.74	5.49	0.53	1.625-16 UN	1.52	0.71	0.67	1.37	.375-16 UN	—	—	0.26	0.57	0.47	2.9
CST-40131	3.52	2.94	2.70	0.43	1.875-16 UN	1.79	0.78	0.75	1.63	.500-13 UN	—	—	0.31	0.66	0.47	2.2
CST-40251	4.76	3.71	3.46	0.43	1.875-16 UN	1.79	0.78	0.75	1.63	.500-13 UN	—	—	0.31	0.66	0.47	2.6
CST-40381	6.49	4.93	4.69	0.43	1.875-16 UN	1.79	0.78	0.75	1.63	.500-13 UN	—	—	0.31	0.66	0.47	3.3
CST-40501	7.44	5.41	5.16	0.43	1.875-16 UN	1.79	0.78	0.75	1.63	.500-13 UN	—	—	0.31	0.66	0.47	3.9
▼ Double acting																
CDT-18131	3.55	2.68	2.42	0.63	1.875-16 UN	1.73	0.63	0.59	1.61	.313-24 UN	0.53	0.39	0.26	0.50	0.47	2.4
CDT-18251	4.57	3.23	2.97	0.63	1.875-16 UN	1.73	0.63	0.59	1.61	.313-24 UN	0.53	0.39	0.26	0.50	0.47	2.9
CDT-18381	5.18	3.68	3.42	0.63	1.875-16 UN	1.73	0.63	0.59	1.61	.313-24 UN	0.53	0.39	0.26	0.50	0.47	3.4
CDT-18501	6.12	4.15	3.90	0.63	1.875-16 UN	1.73	0.63	0.59	1.61	.313-24 UN	0.53	0.39	0.26	0.50	0.47	3.9
CDT-27151	3.39	2.80	2.54	0.67	2.125-16 UN	2.02	0.71	0.67	1.87	.375-16 UN	0.65	0.39	0.26	0.62	0.47	2.6
CDT-27251	4.21	3.23	2.97	0.67	2.125-16 UN	2.02	0.71	0.67	1.87	.375-16 UN	0.65	0.39	0.26	0.62	0.47	3.1
CDT-27501	6.18	4.21	3.96	0.67	2.125-16 UN	2.02	0.71	0.67	1.87	.375-16 UN	0.65	0.39	0.26	0.62	0.47	4.1
CDT-40131	3.60	3.09	2.78	0.69	2.500-16 UN	2.38	0.87	0.83	2.25	.500-13 UN	0.80	0.39	0.31	0.66	0.59	4.0
CDT-40251	4.54	3.56	3.25	0.69	2.500-16 UN	2.38	0.87	0.83	2.25	.500-13 UN	0.80	0.39	0.31	0.66	0.59	4.6
CDT-40381	5.57	4.07	3.76	0.69	2.500-16 UN	2.38	0.87	0.83	2.25	.500-13 UN	0.80	0.39	0.31	0.66	0.59	5.6
CDT-40501	6.89	4.92	4.61	0.69	2.500-16 UN	2.38	0.87	0.83	2.25	.500-13 UN	0.80	0.39	0.31	0.66	0.59	6.6

Threaded cylinders *Application & selection*

Shown: WRT-22, CYDA-15, WMT-39



▶ Threaded cylinders for workpiece positioning, holding and ejecting applications where space is at a premium. The advance and retract mode of double-acting models allow installation of clamping accessories to the plunger for pull and push action. Cylinders can be mounted with horizontal bracket to position the workpiece against the stops. Ideal for supporting or positioning a part.

Fine positioning and convenient installation

...can be fixtured into manual strap
or bridge clamp assemblies

- Maximum clamping force in a compact design
- Threaded body allows exact positioning and easy installation
- Center-tapped plungers allow a variety of attachments
- Single-acting spring return models simplify hydraulic tubing requirements
- Double-acting models are ideal for applications requiring powered pulling or fast automated control
- Removable base allows CYDA-15 to be threaded into a custom manifold

i Single or Double acting

Single acting

- The obvious choice when there are few system restrictions, and there are not many units retracting simultaneously
- Fewer valving requirements which results in a less complex circuit

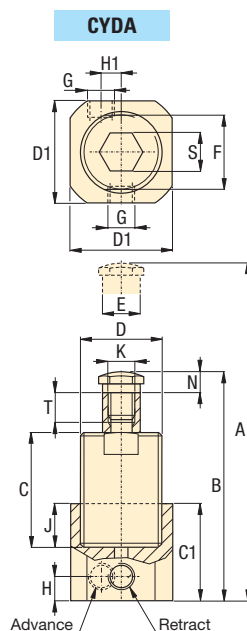
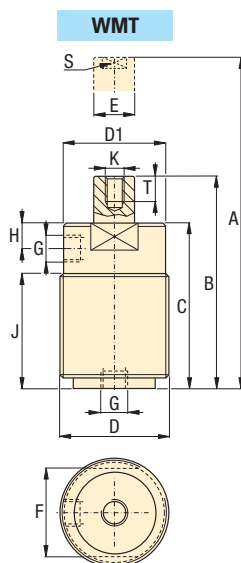
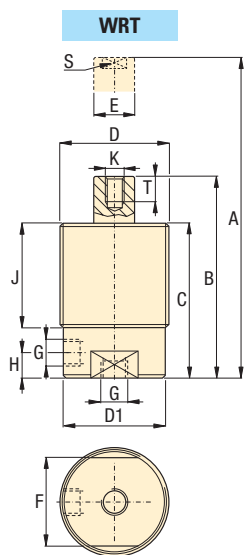
Double acting

- Used when greater control is required during the unclamp cycle
- When timing sequences are critical
- Less sensitive to system back pressures, resulting from long tube lengths or numerous components being retracted at the same time

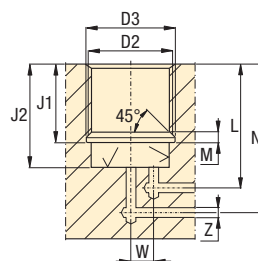
Product selection

Cylinder capacity at maximum pressure		Stroke	Model number	Effective area		Oil capacity		Operating pressure
lbs				in ²		in ³		
push	pull	in		push	pull	push	pull	psi
▼ Single acting								
3900	–	.50	WRT-21	.79	–	.39	–	150-5000
3900	–	1.00	WRT-22	.79	–	.79	–	150-5000
▼ Double acting								
1200	600	1.56	CYDA-15	.41	.20	.62	.31	150-3000
3900	2700	.50	WMT-39	.79	.54	.39	.27	150-5000
3900	2700	1.00	WMT-40	.79	.54	.79	.54	150-5000

Note: - Seal material CYDA-15: Buna-N, Polyurethane
- Seal material WMT and WRT series: Buna-N, Polyurethane, Teflon.



Manifold dimensions using CYDA-15 without base



Surface roughness must be 63 micro-inches

Manifold dimensions in inches

Cylinder capacity lbs	D2	D3	J1	J2	L	M	N	W	Z
	UNF								

▼ For using CYDA-15 without base

1200	1.000-12	1.02	.775-.790	1.00	1.19	.12	1.94	.259	.09
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Accessory chart

Body Thread	Mounting Flange	Flange Nut	Plunger Thread	Contact Bolt
	Sold Separately	Sold Separately		
D	79	78	K	
1.000-12 UN	MF-251	FN-251	0.250-28 UN	BS-61
1.375-18 UN	MF-351	FN-351	0.313-24 UN	BS-81

Product dimensions in inches []

Model number	A	B	C	C1	D	D1	E	F	G	H	H1	J	K	N	S	T	 lbs
UN																	
UNF																	
▼ Single acting																	
WRT-21	3.75	3.25	2.95	–	1.375-18	1.23	.75	.50	SAE #2	.62	–	1.7	.250-28	–	.50	.32	1.2
WRT-22	4.75	3.75	3.45	–	1.375-18	1.23	.75	.50	SAE #2	.62	–	2.2	.250-28	–	.50	.32	1.4
▼ Double acting																	
CYDA-15	5.97	4.41	2.97	1.75	1.000-12	1.25	.50	.88	.125-27 NPT	.38	.20	1.00	.313-24	.31	.50	.50	1.2
WMT-39	3.76	3.26	2.99	–	1.375-18	1.30	.56	1.06	.125-27 NPT	.73	–	2.05	.250-28	–	.50	.39	1.0
WMT-40	4.78	3.78	3.51	–	1.375-18	1.30	.56	1.06	.125-27 NPT	.73	–	2.56	.250-28	–	.50	.39	1.2

Force: 600-3900 lbs

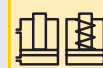
Stroke: .50-1.56 inch

Pressure: 150-5000 psi

E Cilindros roscados

F Vérins corps filetés

D Einschraubzylinder



Linear cylinders

Power sources

Valves

System components

Yellow pages

Options

Cylinder accessories

78



Important

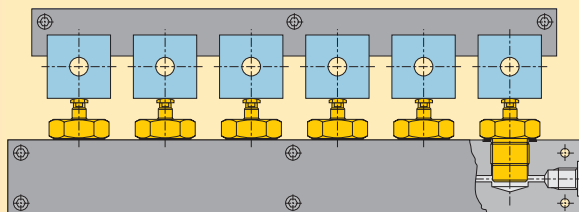
Apply Loctite 222 or equivalent to threads and torque CYDA-15 in cavity to 72-96 in-lbs.
Cavity must be designed to withstand hydraulic forces.

Manifold cylinders *Application & selection*

Shown: CSM-10131, CSM-571, CSM-18251

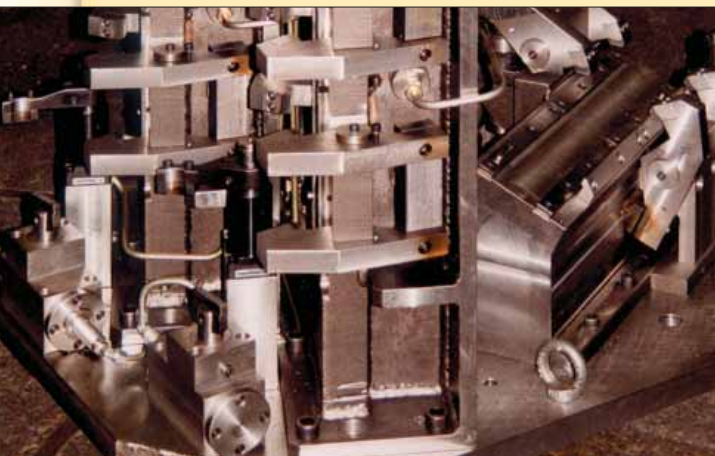


These compact, fixture-integrated cylinders are designed for workpiece positioning, holding and ejecting applications where space is at a premium. No exposed tubing.



Six CSM series manifold cylinders are used to clamp piston blocks for machining. The hydraulic flow to the cylinders is side-ported in order to minimize the required manifold thickness.

Threaded cylinders are used here to position engine manifolds for drilling, tapping and mill finish.

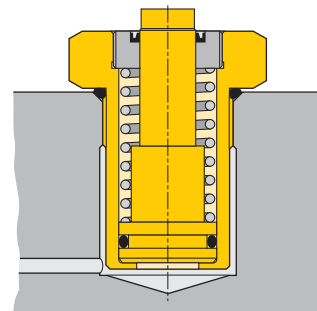


Compact, fixture-integrated positioning and holding

- Design eliminates the need for fittings and tubing, minimizing space requirements and facilitating easy removal of chips and dirt
- Minimal cylinder height enables extremely compact fixture designs
- Cylinder body is fully recessed within the fixture allowing the workpiece to be positioned near-flush with the fixture surface, saving space
- Nitro carburized bodies and internal plunger wipers allow maintenance-free, high cycle performance
- Center-tapped plungers will hold workpiece contact buttons
- Standard SAE bodies make manifold cavity preparation easy

Manifold mount

Manifold cylinders are designed to be screwed directly into a manifold or fixture. Enerpac's manifold cylinders feature SAE dimensions, enabling the use of standard SAE porting tools for easy cavity preparation. An SAE O-ring, included with each cylinder, provides an effective seal between the cylinder and manifold.



Product selection

Cylinder capacity at 5000 psi	Stroke	Model number	Effective area	Oil capacity
lbs	in		in ²	in ³
380	0.28	CSM-271	0.08	0.02
380	0.51	CSM-2131	0.08	0.04
1190	0.28	CSM-571	0.24	0.07
1190	0.51	CSM-5131	0.24	0.12
2590	0.28	CSM-1071	0.50	0.14
2590	0.51	CSM-10131	0.50	0.26
2590	0.75	CSM-10191	0.50	0.38
3900	0.51	CSM-18131	0.79	0.40
3900	0.98	CSM-18251	0.79	0.77
6110	0.59	CSM-27151	1.22	0.72
6110	0.98	CSM-27251	1.22	1.20

Note: - Seal material: Buna-N, Polyurethane.

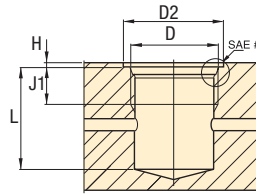


Installation dimensions in inches []

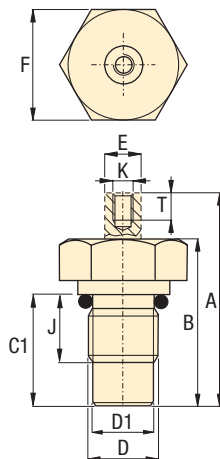
Model number	D thread SAE	D2 min. ø	H max.	J1 min.	L min.
CSM-271	SAE#6 (9/16"-18 UN)	0.97	0.097	0.50	.96
CSM-2131	SAE#6 (9/16"-18 UN)	0.97	0.097	0.50	1.45
CSM-571	SAE#10 (7/8"-14 UN)	1.34	0.100	0.66	1.20
CSM-5131	SAE#10 (7/8"-14 UN)	1.34	0.100	0.66	1.53
CSM-1071	SAE#12 (1-1/16"-12 UN)	1.63	0.130	0.75	1.20
CSM-10131	SAE#12 (1-1/16"-12 UN)	1.63	0.130	0.75	1.44
CSM-10191	SAE#12 (1-1/16"-12 UN)	1.63	0.130	0.75	2.05
CSM-18131	SAE#16 (1-5/16"-12 UN)	1.91	0.130	0.75	1.57
CSM-18251	SAE#16 (1-5/16"-12 UN)	1.91	0.130	0.75	2.34
CSM-27151	SAE#20 (1-5/8"-12 UN)	2.27	0.132	0.75	1.66
CSM-27251	SAE#20 (1-5/8"-12 UN)	2.27	0.132	0.75	2.38

Note: - O-rings included. For additional cavity machining information, refer to SAE standards for straight internal thread, O-ring boss, or call Enerpac's Technical Service Department.

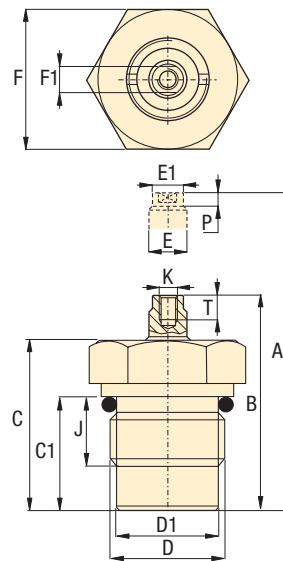
Installation dimensions



CSM-271, -2131



other models



Product dimensions in inches []

Model number	A Ext. height	B Retr. height	C	C1	D thread	D1 Ø	E Ø	E1 Ø	F	F1	J	K thread	P	T	lbs
CSM-271	1.56	1.28	—	0.98	.563-18 UN	0.47	0.19	—	0.75	—	0.47	#6-32 UN	—	0.19	0.2
CSM-2131	2.20	1.69	—	1.38	.563-18 UN	0.47	0.19	—	0.75	—	0.47	#6-32 UN	—	0.19	0.3
CSM-571	1.78	1.50	1.34	0.93	.875-14 UN	0.75	0.27	0.27	1	0.25	0.51	#8-32 UN	0.16	0.28	0.4
CSM-5131	2.34	1.83	1.67	1.26	.875-14 UN	0.75	0.27	0.27	1	0.25	0.51	#8-32 UN	0.16	0.28	0.6
CSM-1071	2.15	1.87	1.65	1.14	1.062-12 UN	0.94	0.47	0.43	1.25	0.38	0.59	.312-24 UN	0.22	0.39	1.1
CSM-10131	2.62	2.11	1.89	1.38	1.062-12 UN	0.94	0.47	0.43	1.25	0.38	0.59	.312-24 UN	0.22	0.39	1.3
CSM-10191	3.47	2.72	2.50	1.99	1.062-12 UN	0.94	0.47	0.43	1.25	0.38	0.63	.312-24 UN	0.22	0.39	1.4
CSM-18131	2.88	2.37	2.11	1.55	1.312-12 UN	1.18	0.63	0.59	1.61	0.63	0.63	.312-24 UN	0.26	0.47	1.1
CSM-18251	4.11	3.13	2.89	2.30	1.312-12 UN	1.18	0.63	0.59	1.61	0.63	0.63	.312-24 UN	0.26	0.47	1.3
CSM-27151	3.15	2.56	2.31	1.60	1.625-12 UN	1.52	0.71	0.67	2.17	0.59	0.79	.375-16 UN	0.26	0.47	1.50
CSM-27251	4.29	3.31	3.06	2.33	1.625-12 UN	1.52	0.71	0.67	2.17	0.59	0.79	.375-16 UN	0.26	0.47	2.00

Force: 380-6110 lbs

Stroke: .28-.98 inch

Pressure: 580-5000 psi

E Cilindros para colector

F Vérins pour bloc foré

D Einbauszylinder



Accessory chart

Plunger Thread K	Contact Bolt 78 ▶
#6-32 UN	BS-21
#8-32 UN	BS-41
0.313-24 UN	BS-81
0.375-16 UN	BS-91

Options

Accessories
Contact bolts

78 ▶



Important

Tighten manifold cylinders according to specifications in the instruction sheet.

Return springs in single-acting cylinders should not be used to pull back heavy attachments consistently.

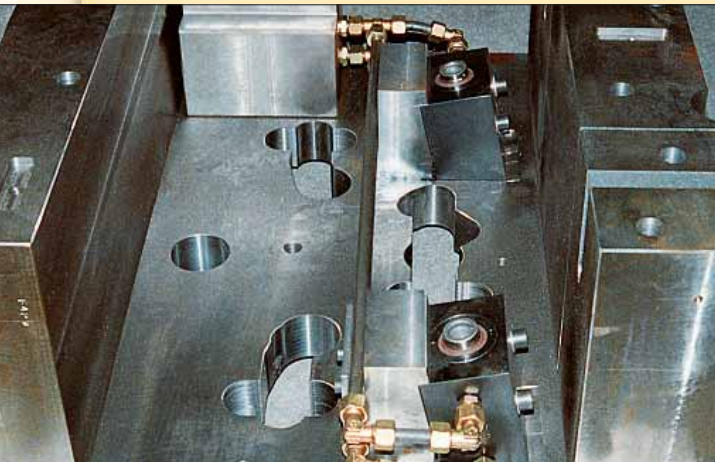
Block cylinders *Application & selection*

Shown: CDB-10162, CDB-70502, CSB-18252



 Block cylinders are used for punching, pressing, riveting and bending applications. In general, these cylinders are used for moving, positioning, lifting, opening and closing.

■ The versatile Enerpac block cylinders, fixture mounted for clamping applications.



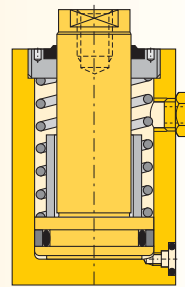
Versatile, all purpose cylinder

- Six clamping capabilities enable you to choose the right size for your application
- Variety of strokes, to meet design needs
- Double acting and Single acting (spring return), allows selection of cylinder that best conforms to your hydraulic system
- Oil connection alternatives: cylinders incorporate both manifold mount and plumbed options to meet your fixturing needs
- Compact cylinder design does not require large amounts of space on your fixture
- Integral wiper ring, keeps contaminants out of cylinder to extend life

Select your block cylinder type:

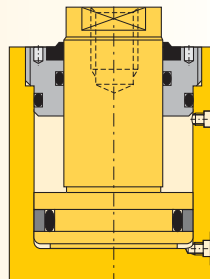
CSB series, Single acting

- Internal threaded plunger
- Manifold O-ring ports
- Black oxide base
- Hard chrome-plated plunger
- BSPP oil port
- Strong return spring
- Filtered vent plug



CDB series, Double acting

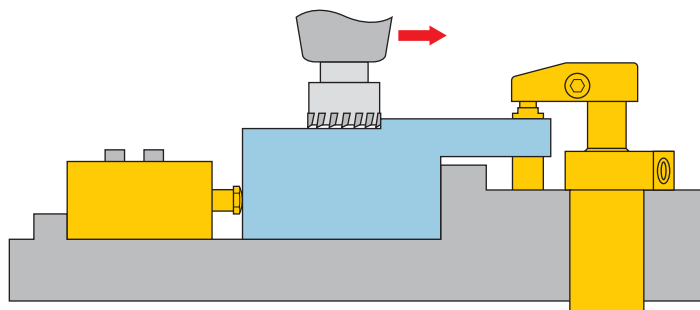
- Internal threaded plunger
- Manifold O-ring ports
- Black oxide base
- Hard chrome-plated plunger
- BSPP oil port





i Application example

Block cylinder positions workpiece against fixed point with further clamping coming from an Enerpac swing cylinder.



Force: 2400-60,850 lbs

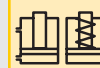
Stroke: .63-2.20 inch

Pressure: 580-5000 psi

E Cilindros tipo bloque

F Vérins cube

D Blockzylinder



Linear cylinders

Power sources

Valves

System components

Yellow pages

i Accessory chart

Plunger Thread K	Contact Bolt 78 ▶
M6 X 1,0	BS-62
M8 X 1,25	BS-82
M16 X 2,0	BS-16
M20 X 2,5	BS-20
M30 X 3,5	BS-30
M36 X 4,0	BS-36

i Product selection

Piston Ø	Rod Ø	Clamping force at 5000 psi		Stroke	Model number	Cylinder effective area		Cylinder oil capacity		Minimum spring return force		
in	in	lbs		in		in²		in³		lbs	lbs	
		push	pull			push	pull	push	pull			
▼ Single acting												
.79	.47	2400	–	.71	CSB-10182	.48	–	.35	–	24	2.6	
.98	.63	3800	–	.98	CSB-18252	.76	–	.75	–	35	4.0	
1.57	.98	9750	–	.98	CSB-40252	1.95	–	1.92	–	85	5.9	
1.97	1.26	15,200	–	.98	CSB-70252	3.04	–	3.00	–	96	9.7	
▼ Double acting												
.79	.47	2400	1550	.63	CDB-10162	.48	.31	.31	.20	–	2.0	
.79	.47	2400	1550	1.42	CDB-10362	.48	.31	.69	.44	–	2.6	
.98	.63	3800	2250	.79	CDB-18202	.76	.45	.60	.35	–	2.9	
.98	.63	3800	2250	1.97	CDB-18502	.76	.45	1.50	.90	–	4.0	
1.57	.98	9750	4900	.98	CDB-40252	1.95	.98	1.92	.96	–	4.2	
1.57	.98	9750	4900	1.97	CDB-40502	1.95	.98	3.83	1.93	–	5.7	
1.97	1.26	15,200	9000	.98	CDB-70252	3.04	1.80	3.00	1.77	–	7.1	
1.97	1.26	15,200	9000	1.97	CDB-70502	3.04	1.80	5.99	3.54	–	9.5	
3.15	1.97	38,900	23,700	.98	CDB-180252	7.80	4.74	7.66	4.67	–	20.5	
3.15	1.97	38,900	23,700	1.97	CDB-180502*	7.80	4.74	15.33	9.34	–	25.4	
3.94	2.48	60,850	36,650	2.20	CDB-280562*	12.17	7.33	26.83	16.18	–	40.1	

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Block cylinders *Application & selection*

Shown: CDB-10162, -70502, CSB-18252



CDB, CSB series

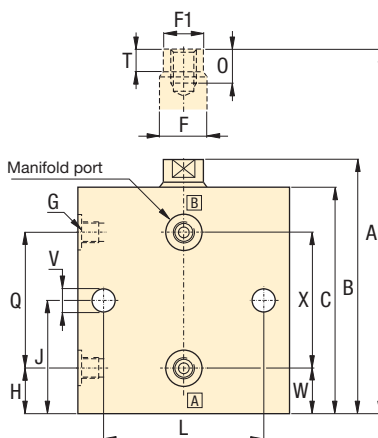
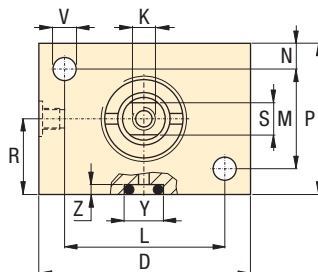
These compact block cylinders are easily mounted in horizontal or vertical position for a range of special tooling applications.

They can be used for positioning, clamping, pushing, pressing or punching operations. The plunger has an internal thread to accommodate accessories such as contact bolts.

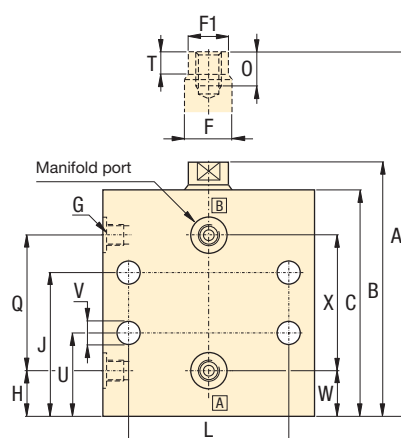
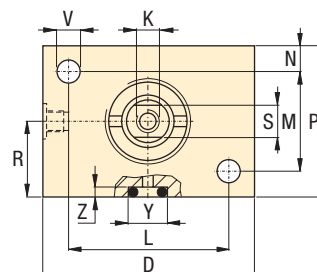
■ Block cylinder used for punching applications.



CDB-10162, -18202, -40252, -70252, -180252



All other models



Dimensions in inches []

Model number	A	B	C	D	F	F1	G	H	J	K	L	M
					ø	ø				ø		
▼ Single acting												
CSB-10182	3.94	3.23	2.91	2.36	.47	.43	G1/8"	.47	1.73	M6 x 1,0	1.77	.98
CSB-18252	4.92	3.94	3.62	2.56	.63	.59	G1/8"	.47	2.24	M8 x 1,25	1.97	1.18
CSB-40252	5.12	4.13	3.66	3.15	.98	.94	G1/8"	.35	2.24	M16 x 2,0	2.36	1.38
CSB-70252	5.63	4.65	4.09	3.94	1.26	1.22	G1/4"	.47	2.52	M20 x 2,5	3.15	1.77
▼ Double acting												
CDB-10162	3.03	2.40	2.17	2.36	.47	.43	G1/8"	.47	.97	M6 x 1,0	1.77	.98
CDB-10362	4.65	3.23	2.91	2.36	.47	.43	G1/8"	.47	1.75	M6 x 1,0	1.77	.98
CDB-18202	3.54	2.76	2.44	2.56	.63	.59	G1/8"	.47	1.06	M8 x 1,25	1.97	1.18
CDB-18502	5.91	3.94	3.62	2.56	.63	.59	G1/8"	.47	2.24	M8 x 1,25	1.97	1.18
CDB-40252	4.13	3.15	2.68	3.15	.98	.94	G1/8"	.35	1.26	M16 x 2,0	2.36	1.38
CDB-40502	6.10	4.13	3.66	3.15	.98	.94	G1/8"	.35	2.24	M16 x 2,0	2.36	1.38
CDB-70252	4.53	3.54	2.99	3.94	1.26	1.22	G1/4"	.51	1.42	M20 x 2,5	3.15	1.77
CDB-70502	6.61	4.65	4.09	3.94	1.26	1.22	G1/4"	.47	2.51	M20 x 2,5	3.15	1.77
CDB-180252	5.16	4.17	3.50	5.51	1.97	1.93	G1/4"	.59	1.63	M30 x 3,5	4.33	3.15
CDB-180502*	7.28	5.31	4.65	5.51	1.97	1.93	G1/4"	.47	2.78	M30 x 3,5	4.33	3.15
CDB-280562*	8.19	5.98	5.24	6.69	2.48	2.44	G1/4"	.71	3.06	M36 x 4,0	5.31	3.54

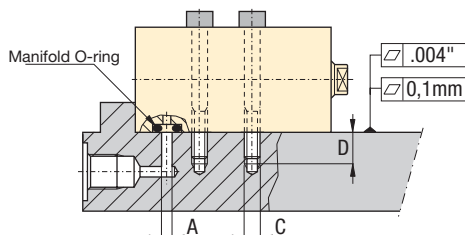


Installation instructions

When operating above 2000 psi in applications as shown in the figure below, provide cylinder back-up using a support to eliminate shear loads on the mounting bolts.

Manifold mounting

When hydraulic connections are made through the standard integrated O-ring ports as shown in figure, the sealing surface must have a roughness of 63 micro-inches.



Single-acting cylinders

If the risk of machining coolants or debris being entering via the breather vent (port B) exists, it is recommended that this port be connected to a clean, remote termination point.

Installation dimensions in inches []

Clamping capacity	Oil channel diameter	Mounting thread	Min. thread length	Torque (bolt type 12.9 DIN 912)	Manifold O-ring ¹⁾	
lbs	A	C	D	Ft.lbs	Inside Ø x thickness	ARP No.
2400	.20	M6	.43	13	.31 x .06	568-011
3800	.20	M8	.51	30	.31 x .06	568-011
9750	.20	M10	.63	63	.31 x .06	568-011
15,200	.20	M12	.75	107	.31 x .06	568-011
38,900	.31	M16	.94	260	.38 x .09	568-110
60,850	.31	M20	1.10	498	.38 x .09	568-110

¹⁾ Manifold O-rings include

N	O	P	Q	R	S	T	U	V	W	X	Y	Z	Model number
mín.													
													Single acting ▼
.31	.39	1.57	1.77	.79	.35	.22	.94	.28	.47	1.77	.43	.05	CSB-10182
.31	.47	1.77	2.36	.91	.51	.24	1.06	.35	.47	1.97	.43	.05	CSB-18252
.39	.98	2.17	2.44	1.06	.87	.37	1.06	.39	.39	2.36	.43	.05	CSB-40252
.39	1.18	2.60	2.68	1.30	1.06	.43	1.14	.47	.59	2.55	.43	.05	CSB-70252
													Double acting ▼
.28	.39	1.57	.98	.79	.35	.22	—	.28	.47	.98	.43	.05	CDB-10162
.31	.39	1.57	1.77	.79	.35	.22	.94	.28	.47	1.77	.43	.05	CDB-10362
.31	.47	1.77	1.18	.91	.51	.24	—	.35	.47	1.18	.43	.05	CDB-18202
.31	.47	1.77	2.36	.91	.51	.24	1.06	.35	.47	2.36	.43	.05	CDB-18502
.39	.98	2.17	1.50	1.06	.87	.37	—	.39	.37	1.50	.43	.05	CDB-40252
.39	.98	2.17	2.44	1.06	.87	.37	1.06	.39	.39	2.46	.43	.05	CDB-40502
.43	1.18	2.60	1.54	1.30	1.06	.43	—	.47	.47	1.57	.43	.05	CDB-70252
.39	1.18	2.60	2.68	1.30	1.06	.43	1.14	.47	.59	2.56	.43	.05	CDB-70502
.59	1.77	4.33	1.77	2.17	1.61	.57	—	.67	.59	1.77	.43	.07	CDB-180252
.59	1.77	4.33	3.03	2.17	1.61	.57	1.22	.67	.79	2.76	.43	.07	CDB-180502*
.71	1.97	4.92	3.15	2.44	1.97	.67	1.50	.83	.71	3.15	.43	.07	CDB-280562*

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Force: 2400-60,850 lbs

Stroke: .63-2.20 inch

Pressure: 580-5000 psi

E Cilindros tipo bloque

F Vérins cube

D Blockzylinder



Important

Must include shear back-up with ability to withstand full load.

Linear cylinder support is required at operating pressures above 2000 psi. Follow the instructions on this page.

Options

Contact bolts

78



Fittings

158



Pressure gauges

154



High pressure filters

157

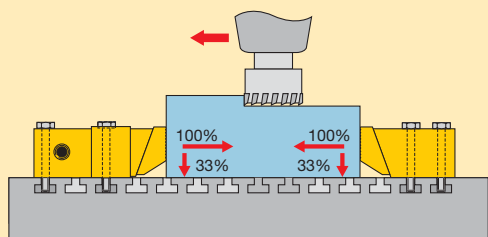


Pull down clamps *Application & selection*

Shown: ECM-20, ECH-202, ECM-5, ECH-52

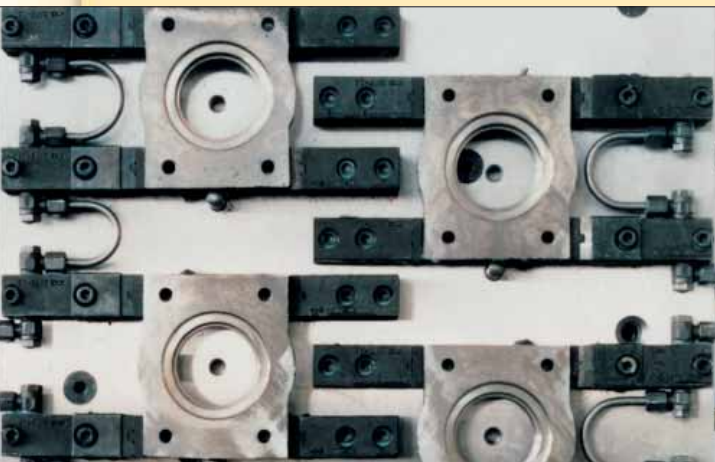


⚡ Enerpac pull down clamps are designed to allow unobstructed top face machining. Independent horizontal and vertical movement achieves high lateral and pull down forces to hold the workpiece firmly down against the machine table or fixture. The pull down forces are approximately 33% of the clamping force.



The pull down clamps can be permanently mounted using the supplied mounting bolts. Optional T-nuts can be used for adapting to varying workpiece sizes.

■ Enerpac hydraulic pull down clamps and their mechanical counter parts used to manufacture tie-rod cylinder end caps.

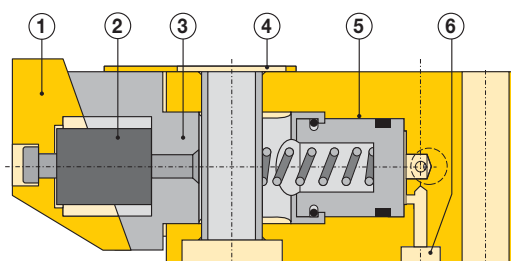


Low profile clamp

.....for unobstructed top face machining

- Independent horizontal and vertical movement for a true pull down effect
- Compact size and low height allows more flexible and economic mounting than comparable dedicated vise
- Manifold and BSPP porting
- Investment high-alloy cast, heat-treated clamping jaw and plunger
- Contamination resistant design for low maintenance, removable guard for chip removal
- Oil ports on both sides for mounting flexibility
- Optional mechanical counter hold provides pull down on end stop for large parts
- Mounting bolts included for ease of installation

i Pull down clamp operation



The moveable jaw (1) and the flexible connection design (2) allows lateral movement and eliminate any bending moment. Roller finished cylinder bore (3) improves seal life. The removable guard (4) prevents the entry of chips and allows easy cleaning. Heat treated, centerless ground plunger (5) for extremely close tolerances and long life. The clamps feature both manifold mount (6) and plumbed oil connection.

Product selection

Lateral clamping force at 5000 psi	Pull down force at 5000 psi	Stroke	Model number	Effective area	Oil capacity	Mounting bolts ¹⁾ (included)
lbs	lbs	in		in ²	in ³	mm

▼ Hydraulic pull down clamps

870	290	.20	ECH-52	.18	.03	M8 x 45
3900	1300	.31	ECH-202	.78	.24	M12 x 80

Holding force	For pull down clamp model number	Model number	Mounting bolts included ¹⁾ number	Replaceable ribbed jaws model
lbs			mm	

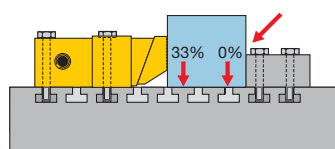
▼ Mechanical counter holds

870	ECH-52	ECM-5	M8 x 35	ECJR-5
3900	ECH-202	ECM-20	M12 x 65	ECJR-20

¹⁾ Torque M8 with 18 Ft.lbs, M12 with 63 Ft.lbs. The use of T-nuts requires longer bolts.



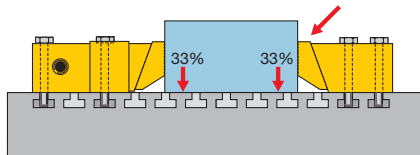
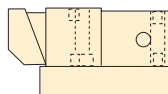
Pull down force



Fixed stop set-up

A very workable set-up for workpieces that are not larger or wider than twice the width of the edge clamp. The pull down force of the hydraulic actuated edge clamp is sufficient to pull down and hold the product during actual machining.

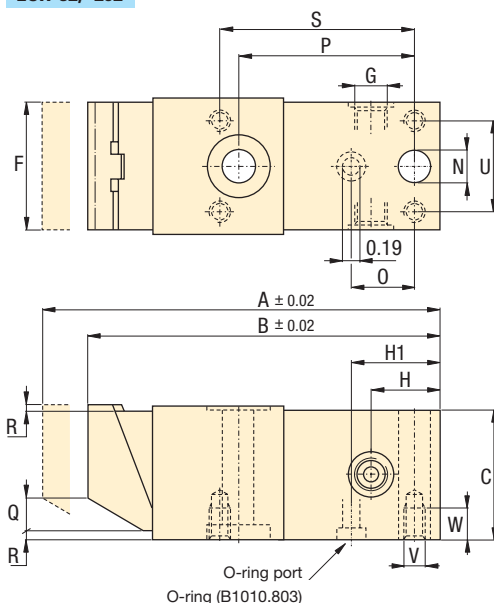
The mounting surface must extend out under the jaw.



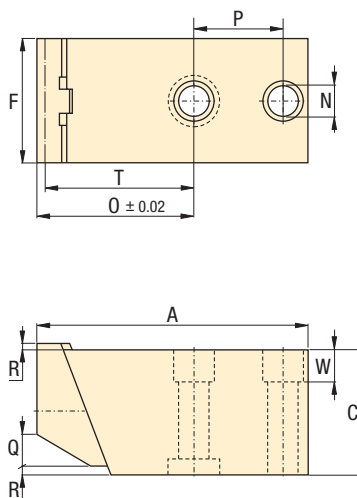
Counter hold set-up

For workpieces larger than twice the width of the edge clamp used, it is recommended to install a mechanical counter hold. The counter hold also produces a pull down force equal to 1/3 of the lateral force of the hydraulic edge clamp applied. In this way the grip on the workpiece is very tight. Another advantage of this set-up is the repeated accuracy of machining results.

ECH-52, -202



ECM-5, -20



Force: 870-3900 lbs

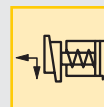
Stroke: .20-.31 inch

Pressure: 225-5000 psi

E Garras de empuje oblicuo

F Crampons plaqueurs

D Niederzugspanner



Options

Fittings

158 ▶



Threaded cylinders

56 ▶



Positive clamping cylinders

70 ▶



Important

Threaded push cylinders (CST, CDT, CSM series) or spring loaded cylinders (MRS-series) can be used to hold the workpiece against the side locators during part clamping.

Do not allow the clamping jaw to extend below the lower surface of the clamp body.

Product dimensions in inches []

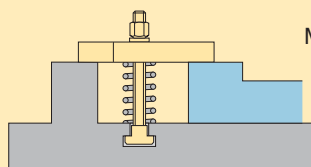
Model number	A	B	C	F	G	H	H1	N	O	P	Q	R	S	T	U	V	W	
																mm	lbs	
▼ Hydraulic pull down clamps																		
ECH-52	4.14	3.94	1.18	1.18	G1/8"	.75	.74	.33	.46	2.09	.12	.08	2.32	–	.87	M5 x 0,8	.24	1.5
ECH-202	5.62	5.31	1.97	1.97	G1/4"	.98	.93	.49	.54	2.64	.55	.12	2.91	–	1.42	M8 x 1,25	.47	5.5
▼ Mechanical counter holds																		
ECM-5	3.11	–	1.18	1.18	–	–	–	.33	1.65	1.02	.12	.08	–	1.61	–	–	.31	1.3
ECM-20	4.02	–	1.97	1.97	–	–	–	.49	2.36	1.18	.55	.12	–	2.32	–	–	.51	4.1

Hollow plunger cylinders *Application & selection*

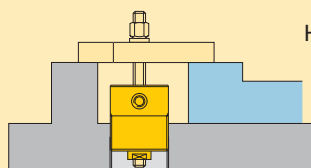
Shown: HCS-20, RWH-121, RWH-202



These cylinders are regularly used for upgrading mechanical clamping to faster and easier hydraulic clamping. Other typical applications include production pressing, punching and crimping operations.



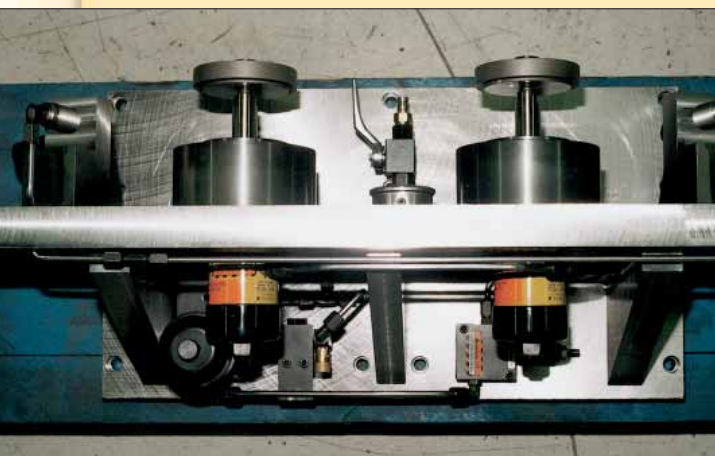
Mechanical set-up



Hydraulic set-up

Traditional mechanical elements in a clamping fixture are replaced by a hollow plunger hydraulic cylinder.

Two Enerpac RWH-121 hollow cylinders mounted at the back side of a fixture.



For high force push and pull applications on and around the fixture

- Load can be attached to either end of the cylinder, providing a choice of push or pull actions - both realizing full cylinder capacity
- Very high cylinder capacities contained within small dimensions allow compact fixture designs
- Spring return operation allows for easy unloading of the workpiece
- Threaded collars and base mounting holes allow mounting flexibility, including table-top surfaces and T-slots
- Nickel-plated plungers, plunger wipers and internal venting prevent corrosion and support longer operation life on all HCS models
- The CY series hollow plunger cylinders can be manifold mounted (except for CY-1254-25)

Product selection

Cylinder capacity ¹⁾	Stroke	Center hole diameter	Model number	Effective area	Oil capacity	Operating pressure
lbs	in	in		in ²	in ³	psi
2610	.25	.39	CY1254-25	.87	.22	3000
4000	.31	.53	RWH-20	1.33	.41	3000
4000	.31	.53	RWH-21	1.33	.41	3000
4830	.39	.43	HCS-20*	.96	.38	5000
7410	.31	.76	CY2129-25	2.47	.77	3000
7410	.63	.76	CY2129-5	2.47	1.56	3000
12,660	.47	.51	HCS-50*	2.52	1.19	5000
13,320	.63	.89	CY2754-5	4.44	2.80	3000
13,800	.31	.77	QDH-120	2.76	.86	5000
13,800	.31	.77	RWH-120	2.76	.86	5000
13,800	1.00	.77	RWH-121	2.76	2.76	5000
18,180	.55	.67	HCS-80*	3.63	1.99	5000
23,500	.50	1.06	RWH-200	4.74	2.37	5000
23,500	2.00	1.06	RWH-202	4.74	9.48	5000
25,490	.63	.83	HCS-110*	5.06	3.19	5000
36,000	.50	1.31	RWH-300	7.22	3.60	5000
36,000	1.00	1.31	RWH-301	7.22	7.22	5000
36,000	2.50	1.31	RWH-302	7.22	18.00	5000

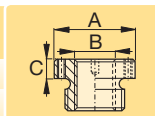
¹⁾ At maximum operating pressure. **Note:** Seal material Buna-N, Polyurethane, Teflon.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



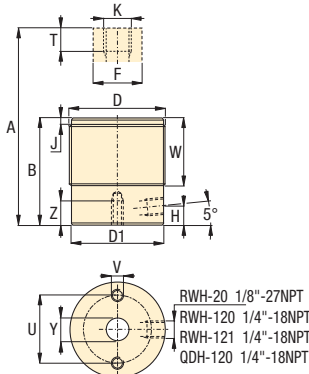
Optional Heat Treated Hollow Saddles

Saddle type	Cylinder model number	Saddle model No.	Saddle Dimensions		
			A	B	C
Threaded hollow	RWH-200, 202	HP-2015	2.11	1" - 8	.38
	RWH-300, 301, 302	HP-3015	2.49	1 1/4" - 7	.38

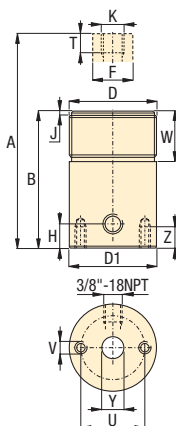


Smooth hollow saddles are standard on all RWH 20 and 30 ton models (12 ton models are not equipped with saddles).

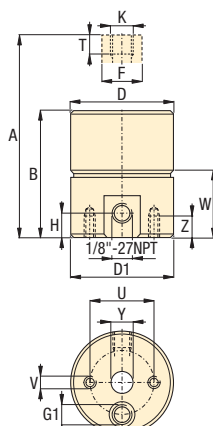
RWH-20, 120, 121, QDH-20



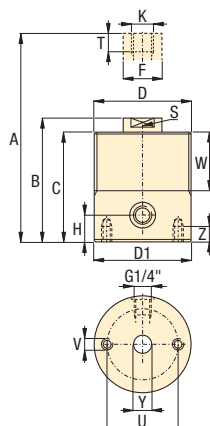
other RWH model



CY models



HCS models



Force: 2610-36,000 lbs

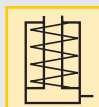
Stroke: .25-2.50 inch

Pressure: 800-5000 psi

E Cilindros de émbolo hueco

F Vérins a piston creux

D Hohlkolbenzylinder



Options

Flange nuts

78



Important

Use Grade 8 (DIN12.9) bolt quality or better for pulling.
Use Grade B7 (DIN10.9) threaded rod quality or better for pulling applications.

RWH cylinders can be used up to 10,000 psi maximum working pressure (except RWH-20).

Product dimensions in inches []

Model number	A	B	C	D Ø	D1 Ø	F Ø	H	J	K Ø	S	T	U Ø	V Ø	W	Y Ø	Z	lbs
CY1254-25	2.25	2.00	—	1.75	1.75	.56	.29	—	.375-16 UNC	—	.62	1.25	.250-20 UNC	.91	.39	.38	1.0
RWH-20	2.38	2.06	—	1.875-16 UN	1.79	1.00	.28	.12	0.53	—	.88	1.38	.250-20 UNC	1.50	.500-20 UNF	.25	1.4
RWH-20U001	2.38	2.06	—	1.875-16 UN	1.79	1.00	.28	.12	.500-20 UNF	—	.88	1.38	.250-20 UNC	1.50	.53	.25	1.4
HCS-20*	3.31	2.92	2.60	M58 x 1,5	2.28	.63	.43	—	M10 x 1,5	.55	1.02	1.57	M6 x 1,0	1.57	.43	.39	2.4
CY2129-25 ¹⁾	2.31	2.00	—	2.63	2.63	1.13	.31	—	.750-10 UNC	—	1.13	1.75	.375-16 UNC	.75	.76	.38	2.5
CY2129-5 ¹⁾	3.36	2.73	—	2.63	2.63	1.13	.31	—	.750-10 UNC	—	1.13	1.75	.375-16 UNC	1.48	.76	.44	3.0
HCS-50*	3.78	3.31	2.95	M65 x 1,5	2.56	1.10	.55	—	M12 x 1,75	.87	.96	1.77	M8 x 1,25	1.77	.51	.47	3.3
CY2754-5 ¹⁾	3.63	3.00	—	3.50	3.50	1.25	.31	—	.875-9 UNC	—	1.20	2.12	.375-16 UNC	1.55	.89	.44	6.0
QDH-120	2.50	2.19	—	2.750-16 UN	2.75	1.38	.39	.19	.750-10 UNC	—	.63	2.00	.312-18 UNC	1.19	.77	.25	3.0
RWH-120	2.50	2.19	—	2.750-16 UN	2.75	1.38	.39	.19	.750-16 UNF	—	.63	2.00	.312-18 UNC	1.19	.77	.25	3.1
RWH-121	4.19	3.19	—	2.750-16 UN	2.75	1.38	.53	.19	.750-16 UNF	—	1.00	2.00	.312-18 UNC	1.19	.77	.25	4.8
HCS-80*	4.29	3.74	3.35	M75 x 1,5	2.95	1.26	.67	—	M16 x 2,0	.94	1.28	2.16	M8 x 1,25	1.97	.67	.47	5.1
RWH-200	5.31	4.81	—	3.875-12 UN	3.88	2.13	.75	.19	1.562-16 UN	—	.75	3.25	.375-16 UNC	1.50	1.06	.38	13.6
RWH-202	8.31	6.00	—	3.875-12 UN	3.88	2.13	.75	.19	1.562-16 UN	—	.75	3.25	.375-16 UNC	1.50	1.06	.38	17.0
HCS-110*	4.72	4.09	3.66	M90 x 2,0	3.54	1.57	.75	—	M20 x 2,5	1.26	1.43	2.56	M10 x 1,5	2.36	.83	.59	7.9
RWH-300	5.50	4.62	—	4.500-12 UN	4.50	2.50	.85	.19	1.812-16 UN	—	.88	3.62	.375-16 UNC	1.66	1.31	.62	19.0
RWH-301	6.12	5.12	—	4.500-12 UN	4.50	2.50	.85	.19	1.812-16 UN	—	.88	3.62	.375-16 UNC	1.66	1.31	.62	21.5
RWH-302	9.12	6.62	—	4.500-12 UN	4.50	2.50	.85	.19	1.812-16 UN	—	.88	3.62	.375-16 UNC	1.66	1.31	.62	24.0

¹⁾ For these models G1 = manifold and .125-27 NPTF

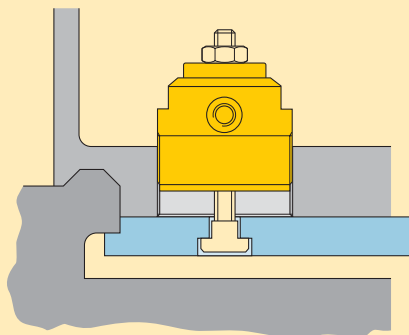
Positive clamping cylinder *Application & selection*

Shown: MRS-1, MRS-1001, MRS-5001



These cylinders are designed for prolonged clamping applications in moveable machine parts, tools, fixtures, pallets and workpieces.

The mechanical clamping force of this cylinder is ideal for FMS applications. Hydraulic pressure is used to release the workpiece and is not required to maintain the clamping force on the workpiece. Internal high strength springs produce the required clamping force.



When pressure is released, the Enerpac MRS cylinders clamp the workpiece by pushing it against the frame that is attached to the fixture.

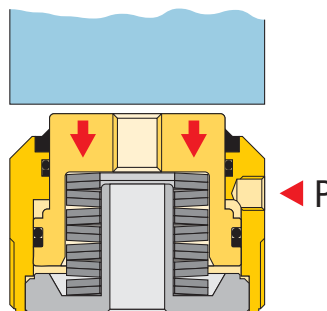
Ideal for palletized applications

- Heavy disk springs maintain the clamping force - hydraulic pressure is used for release
- Single-acting design allows easy setup of hydraulic system
- Hollow plunger design allows easy retrofit for mechanical clamping
- Custom buttons can be fitted into the plunger for clamping directly against a workpiece
- Threaded body allows easy cylinders mounting directly into fixture plate
- Internal threaded plunger allows accessories to be used easily for retrofit applications

Positive clamping operation

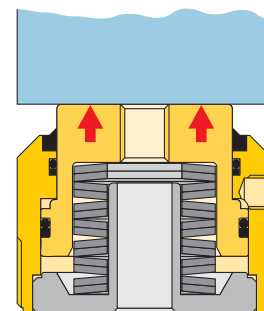
The applied clamping force is determined by how far the cylinder's plunger is being retracted when engaging contact with the workpiece (referred to as the effective clamping stroke).

Use the diagrams on the next page as a guide to your fixture set-up. Note that in order to load and unload the workpiece, the plunger must be retracted somewhat further than the effective clamping stroke.



Hydraulic pressure applied

- Plunger retracts
- Work piece is released
- New work piece is loaded



Hydraulic pressure released

- Springs apply force
- Workpiece is clamped
- Machining can take place

Product selection

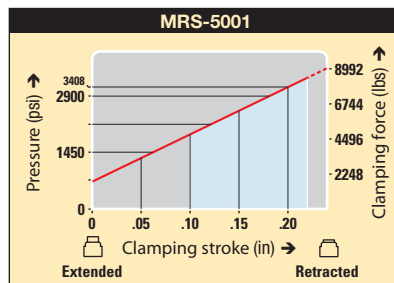
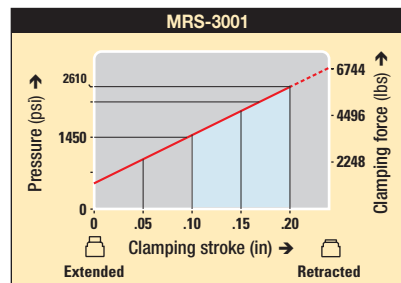
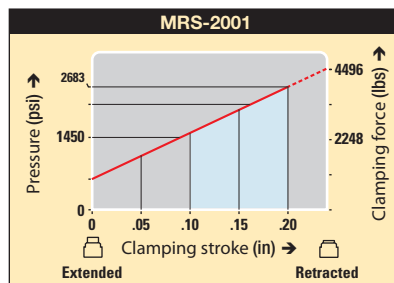
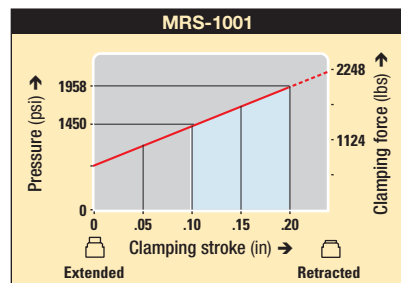
Cylinder capacity at 5000 psi	Effective clamping stroke	Model number	Required operating pressure ¹⁾	Max. tensioning stroke	Oil capacity
lbs	in		psi	in	in ³
2700	.09	MRS-1	5000	.09	.05
6000	.09	MRS-2	5000	.09	.26
11,500	.09	MRS-5	5000	.09	.50
1900	.10	MRS-1001	2000	.20	.54
3700	.10	MRS-2001	2700	.20	.73
5800	.10	MRS-3001	2600	.20	1.22
8500	.12	MRS-5001	3400	.22	1.35

¹⁾ Minimum operating pressure to fully retract the plunger.

Note: Seal material Buna-N, Polyurethane.

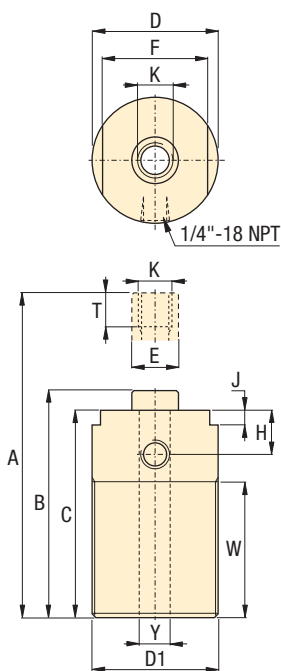


Stroke/force diagrams for MRS-1001, -2001, -3001, -5001

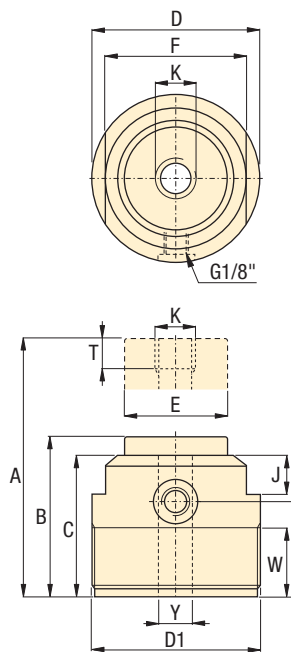


■ = SUGGESTED CLAMPING RANGE

MRS-1, 2, 5



other MRS models



Product dimensions in inches [$\varnothing$]

Model number	A	B	C	D	D1	E	F	H	J	K	T	W	Y	lbs
MRS-1	3.35	3.26	3.11	1.42	M36 x 1,5	.50	1.18	.71	.24	M8 x 1,25	1.42	1.97	.35	1.1
MRS-2	3.54	3.46	3.31	1.89	M48 x 1,5	.68	1.57	.79	.28	M10 x 1,50	1.50	1.97	.43	2.0
MRS-5	4.92	4.83	4.69	2.36	M60 x 2,0	.87	1.97	.83	.28	M16 x 2,0	1.57	3.35	.67	4.0
MRS-1001	2.44	2.24	2.09	2.56	M65 x 1,5	1.57	2.17	1.38	.59	M12 x 1,75	.79	.98	.51	2.6
MRS-2001	2.56	2.36	2.24	3.15	M80 x 2,0	2.16	2.56	1.50	.59	M 16 x 2,0	.79	1.14	.67	4.6
MRS-3001	2.91	2.72	2.60	3.74	M95 x 2,0	2.36	3.15	1.81	.67	M20 x 2,5	.79	1.46	.83	6.6
MRS-5001	3.78	3.56	2.66	3.74	M95 x 2,0	2.36	3.15	1.81	.67	M20 x 2,5	.79	1.46	.83	7.7

Force: 1900-11,500 lbs

Stroke: .09-.22 inch

Pressure: 2000-5000 psi

- E Cilindros de amarre
- F Vérins de bridage positif
- D Federspannzylinder



Options

Buttons

78 ▶



Flange nuts

78 ▶



Collet-Lok® work supports

38 ▶



Important

Be sure to refer to the force/stroke chart when selecting cylinders for an application. Piece parts with a large variation at the clamping point may be prone to having variations in clamping force.

Depending on the cycle usage of the application and amount of deflection, the internal disk springs may need to be replaced at scheduled intervals.

Push cylinders - Collet-Lok® design

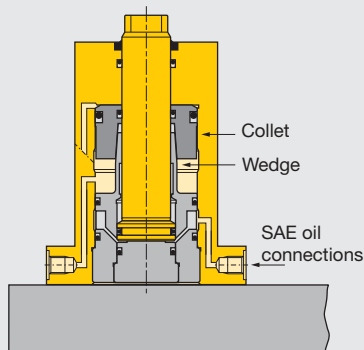
Shown: WPTC-110, WPFC-210



WP series

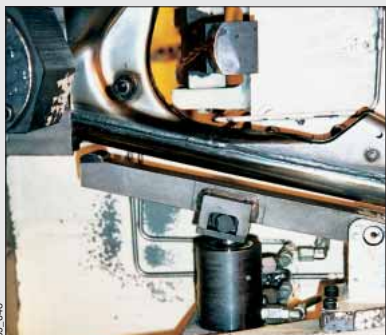
Collet-Lok® positive locking push cylinders are designed to mechanically hold the workpiece after hydraulic pressure is removed.

Push capacities range from 2500 lbs. to 5000 lbs.



Hydraulic pressure pushes the collet up a wedge, locking the plunger in the clamping position.

■ Lower flange Collet-Lok® push cylinder used for positioning a motorcycle frame.



Ideal when live hydraulics are not available

...clamping is sustained mechanically so live hydraulics are not required during the machining cycle

- Double-acting Collet-Lok® action allows fully automated operation
- Additional level of safety since live hydraulics are not required
- Collet-Lok® push cylinders can either be mounted by the flange, or threaded into the fixture
- The Collet-Lok® design is an industry exclusive
- Capacities up to 8800 lbs. available on request

Collet-Lok® sequence



Step 1

Pressurize port #1. Plunger extends and clamps workpiece.



Step 2

Keep port #1 pressurized. Pressurize port #2. Plunger will be locked in clamped position.



Step 3

Depressurize port #1 and #2. Cylinder should now be uncoupled from hydraulic power source and will maintain the clamped position.



Step 4

Pressurize port #3. Plunger will be unlocked and the plunger will be released to its original position.

Product selection

Max. push force	Hydr. plunger stroke	Lower flange	Threaded body	Operating pressure	Hydraulic effective area	Oil capacity	Max. oil flow
lbs	in			min. max.	psi adv. adv.	in ² unlock retr.	in ³ /min
2500	.59	WPFC-110	WPTC-110	725 5000	.50 .30	.37 .24	600
5000	.59	WPFC-210	WPTC-210	725 5000	.99 .61	.61 .37	600

Maximum cycle rate: 8 cycles/min.

Note: Call Enerpac to order models with metric thread and BSPP port connections. Capacities up to 8800 lbs. available on request.

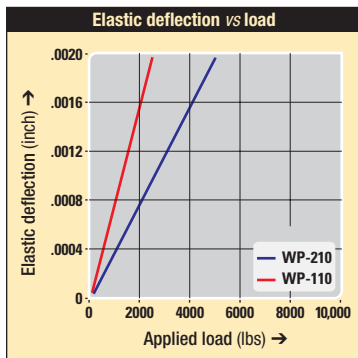
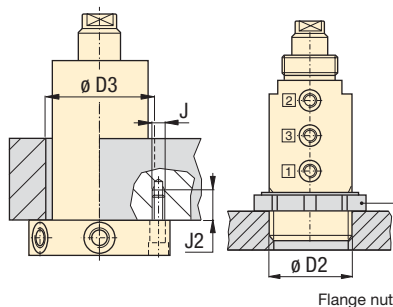
Dimensions in inches []

Model number	A	B	C	C1	D	D1	D2	E	E1	F
					Ø	Ø		Ø	Ø	Ø
▼ Lower flange										
WPFC-110	6.08	5.49	5.16	—	2.76	3.94	—	.62	.59	—
WPFC-210	6.79	6.20	5.87	—	3.07	4.33	—	.87	.79	—
▼ Threaded body										
WPTC-110	6.06	5.47	5.12	.75	2.375-12 UN	2.52	1.500-12 UNF	.62	.59	1.81
WPTC-210	6.73	6.14	5.83	.71	2.750-16 UN	2.91	1.875-16 UN	.87	.79	2.16



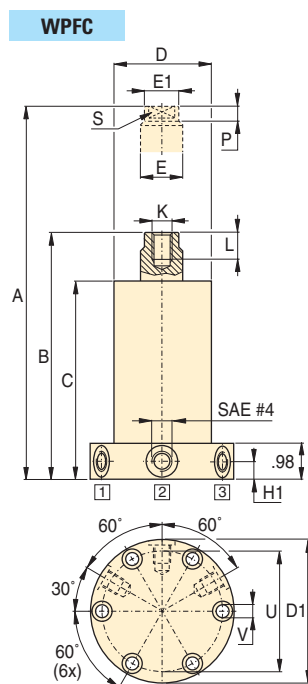
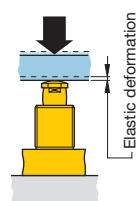
Installation dimensions in inches

Push force lbs	Fixture hole øD3	Mounting thread J	Minimum depth J2
▼ Lower flange			
2500	2.79	M6	.68
5000	3.10	M8	.72
▼ Threaded body			
2500	2.375 12 UN	—	—
5000	2.750 16 UN	—	—



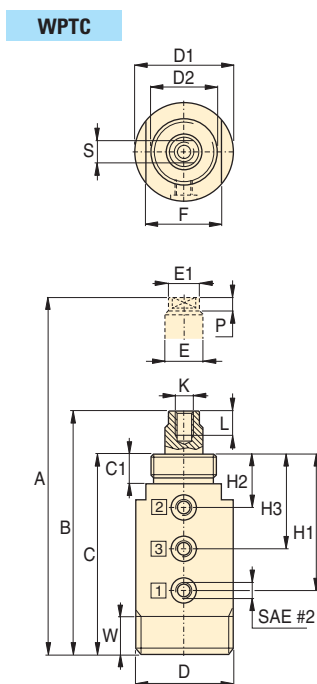
Deflection chart:

Elastic deformation of the plunger resulting from the application of load.



Oil port functions

- 1 Clamp
- 2 Lock
- 3 Unlock/Retract



H1	H2	H3	K	L Ø	P	S	U Ø	V	W	lbs	Model number
Lower flange ▼											
.49	—	—	.313-24 UNF	.59	.27	.47	3.31	.28	—	8.8	WPFC-110
.49	—	—	.375-24 UNF	.79	.35	.63	3.70	.35	—	11.0	WPFC-210
Threaded body ▼											
3.78	1.30	2.56	.313-24 UNF	.59	.27	.47	—	—	.73	6.6	WPTC-110
4.37	1.26	2.83	.375-24 UNF	.79	.35	.63	—	—	.79	7.5	WPTC-210

Push force: 2500-5000 lbs

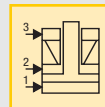
Stroke: .59 inch

Pressure: 725-5000 psi

E Cilindros de empuje

F Vérins pousseurs

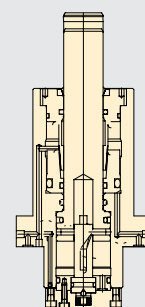
D Gesicherter Druckzylinder



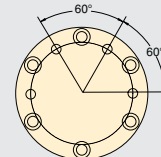
Custom Options Available

Intermediate capacities

Different flange locations



Manifold mounting



Options

Auto couplers

146



Sequence valves

136



Accessories

78



Swing cylinders

10



Important

For proper application, clamp force, pressures and timing, consult Enerpac for support.

Universal cylinders - Single acting *Application & selection*

Shown: RW-50, RW-104



Used when high cylinder forces or long strokes are required in a confined area. Can handle a wide range of production tooling applications.

■ Enerpac RW-101 cylinders used in a high pressure toggle style clamping set-up.



Heavy-duty cylinders

...handle a variety of applications

- High pressure design when additional force is required
- Long stroke lengths in a compact design, well suited for welding applications
- Collar mounting threads and base mounting holes allow flexible mounting options
- Cylinders are provided with hardened saddles for additional plunger protection
- Snap-in saddles are easily removed for adapting to different plunger devices
- Chrome plated plunger with bronze upper and lower bearing provides a long cylinder life

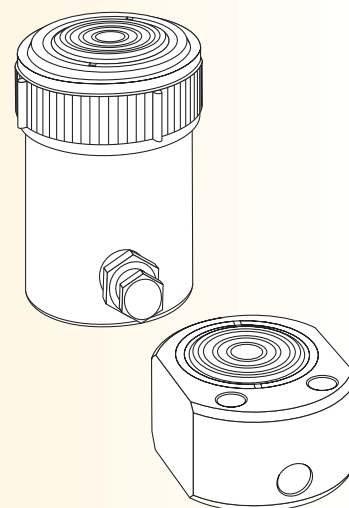
i Block and cylindrical models

Cylindrical models

- Long stroke
- Flexible in fixture design
- Variety of attachments

Block models

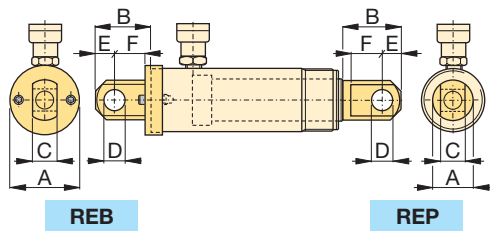
- Easily mounted
- Compact design



globe Product selection

Cylinder capacity at 5000 psi	Stroke	Model number	Effective area	Oil capacity	Operating pressure
lbs	in		in ²	in ³	psi
▼ Block models					
4970	.62	RW-41	.99	.62	85-8000
4970	.62	RW-50	.99	.62	600-10,000
▼ Cylindrical models					
4970	1.00	RW-51	.99	.99	600-10,000
4970	3.00	RW-53	.99	2.97	600-10,000
4970	5.00	RW-55	.99	4.95	600-10,000
11,180	1.00	RW-101	2.23	2.23	600-10,000
11,180	2.13	RW-102	2.23	4.75	600-10,000
11,180	4.13	RW-104	2.23	9.21	600-10,000
11,180	6.13	RW-106	2.23	13.67	600-10,000

Note: Seal material: Buna-N, Polyurethane, Teflon.



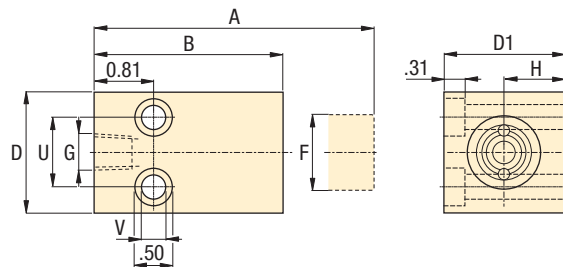
Type	Model number	A	B	C	D	E	F	Pin to pin* in.
Base ¹⁾	REB-5	1.75	1.88	.56	.63	.63	1.00	2.37
	REB-10	2.50	2.63	1.00	.88	1.00	1.38	3.07
Plunger	REP-5	1.13	1.62	.56	.63	.63	.75	—
	REP-10	1.69	2.43	1.00	.88	1.00	1.13	—

* Pin to Pin- REB and REP Clevises fitted. Add cylinder stroke length.

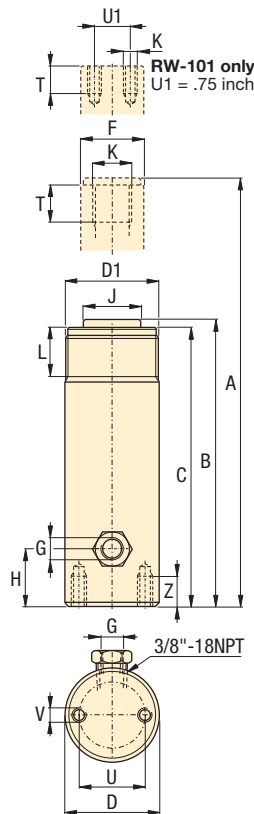
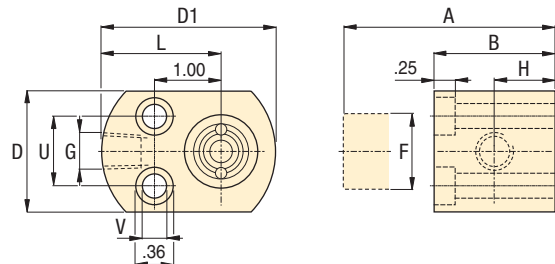
¹⁾ Mounting screws are included.

RW-51, -106

RW-41



RW-50



Force: 4970-11,180 lbs

Stroke: .62-10.13 inch

Pressure: 600-5000 psi

E Cilindros universales

F Vérins universels

D Universelle Linearzylinder



Options

Cylinder accessories

78



Important

These cylinders are intended for medium cycle applications. The return spring is intended for retracting the plunger and heavy devices should not be attached to it.

Plungers should be shielded in welding applications to prevent splatter from sticking to chrome plating.

Do not use these cylinders continuously at full stroke or damage to return spring may result.

Product dimensions in inches []

Model number	A	B	C	D	D1	F	G	H	J	K	L	T	U	V	Z	lbs
▼ Block models																
RW-41	3.18	2.56	—	1.62	1.62	1.00	.250-18	.81	—	—	—	—	1.00	.34	—	1.8
RW-50	2.25	1.63	—	1.62	2.31	1.12	.375-18	.75	—	—	1.50	—	1.12	.22	—	1.8
▼ Cylindrical models																
RW-51	5.34	4.34	4.09	1.50	1.500-16 UN	1.00	.250-18	.75	1.00	.750-16 UN	1.13	.56	1.00	.250-20 UN	.56	2.1
RW-53	9.50	6.50	6.25	1.50	1.500-16 UN	1.00	.250-18	.75	1.00	.750-16 UN	1.13	.56	1.00	.250-20 UN	.56	3.1
RW-55	13.50	8.50	8.25	1.50	1.500-16 UN	1.00	.250-18	.75	1.00	.750-16 UN	1.13	.56	1.00	.250-20 UN	.56	3.9
RW-101	4.53	3.53	3.28	2.25	2.250-14 UN	1.50	.250-18	.75	—	#10-24 UN	1.06	.25	1.56	.312-18 UN	.50	3.8
RW-102	6.91	4.78	4.53	2.25	2.250-14 UN	1.50	.250-18	.75	1.38	1.000-8 UN	1.13	.75	1.56	.312-18 UN	.50	4.9
RW-104	10.88	6.75	6.50	2.25	2.250-14 UN	1.50	.250-18	.75	1.38	1.000-8 UN	1.13	.75	1.56	.312-18 UN	.50	7.0
RW-106	15.88	9.75	9.50	2.25	2.250-14 UN	1.50	.250-18	.75	1.38	1.000-8 UN	1.13	.75	1.56	.312-18 UN	.50	9.6

Universal cylinders - Double acting *Application & selection*

Shown: RD-2510, RD-96, RD-256, RD-41, RD-166



Used when high cylinder forces with a powered return stroke is required in a confined area.

Cylinders can push or pull a workpiece into position and the threaded plunger allows adapting standard clevis attachments.

Clamping application using Enerpac RD cylinders (with clevis eye attachments on both ends) for their high pressure capability and mounting flexibility.



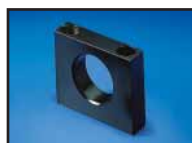
Heavy-duty cylinders

...provide push as well as pull forces

- High pressure design when additional force is required for push or pull applications
- Long strokes in a compact design are well suited for custom toggle style clamping
- Various features for mounting
- Threaded plunger allows a wide range of mounting adapter devices
- Chrome plated plunger provides a long cylinder life

Optional cylinder attachments

For added cylinder flexibility, a selection of interchangeable mountings is available to fit plunger or cylinder threads.



Foot mounting

Mounts onto cylinder collar thread. Retainer nut included.



Flange mounting

Mounts onto cylinder collar thread. Retainer nut included.



Retainer nut

Locking foot or flange mountings. Mounts onto cylinder base or collar threads. Included with foot and flange mountings.

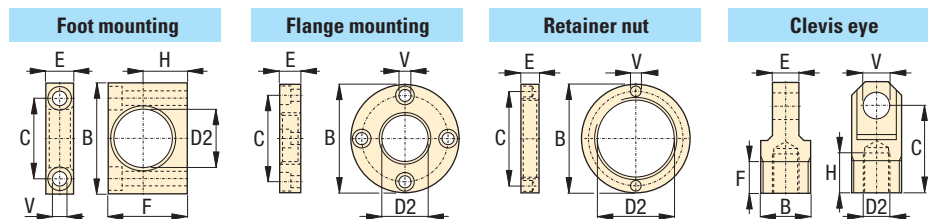


Clevis eye

Threads onto plunger or base.

Product selection

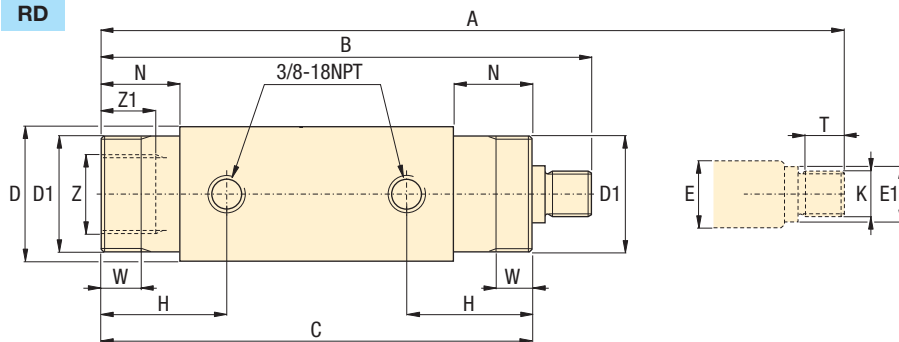
Cylinder capacity at 5000 psi		Stroke	Model number	Effective area		Oil capacity	
push	pull			push	pull	push	pull
lbs	lbs	in		in ²	in ²	in ³	in ³
3900	1720	1.13	RD-41	.79	.34	.89	.40
3900	1720	3.13	RD-43	.79	.34	2.47	1.10
3900	1720	6.13	RD-46	.79	.34	4.84	2.10
9000	4910	1.13	RD-91	1.77	.98	2.00	1.10
9000	4910	3.13	RD-93	1.77	.98	5.54	3.00
9000	4910	6.13	RD-96	1.77	.98	10.88	6.00
9000	4910	10.13	RD-910	1.77	.98	17.94	9.90
15,500	8300	6.25	RD-166	3.15	1.66	19.67	10.40
15,500	8300	10.25	RD-1610	3.15	1.66	32.26	17.00
24,500	10,750	6.25	RD-256	4.92	2.15	30.73	13.40
24,500	10,750	10.25	RD-2510	4.92	2.15	50.40	22.00



Cylinder attachments in inches []

Cylinder capacity at 5000 psi 10,000 psi lbs lbs		D2	Model number	B	C	E	F	H	V	lbs
▼ Foot mounting with retainer nut										
3900	7800	1.38	AD-141	3.00	2.00	.76	2.25	1.25	.41	.9
9000	18,000	2.00	AD-171	4.00	2.88	1.00	3.25	1.75	.53	2.6
15,500	31,000	2.63	AD-181	5.00	3.76	1.38	4.00	2.06	.78	6.4
24,500	49,000	3.25	AD-191	6.26	4.62	1.76	4.88	2.50	1.03	9.9
▼ Flange mounting with retainer nut										
3900	7800	1.38	AD-142	3.88	3.09	.75	—	—	.41	2.2
9000	18,000	2.00	AD-172	4.75	3.88	1.00	—	—	.41	4.6
15,500	31,000	2.63	AD-182	5.63	4.56	1.38	—	—	.53	8.4
24,500	49,000	3.25	AD-192	6.50	5.34	1.75	—	—	.66	13.2
▼ Retainer nut										
3900	7800	1.375-12UN	AD-143	2.25	1.81	.38	—	—	.25	.2
9000	18,000	2.000-12UN	AD-173	3.00	2.50	.50	—	—	.27	.7
15,500	31,000	2.625-16UN	AD-183	3.63	3.12	.75	—	—	.27	1.3
24,500	49,000	3.250-16UN	AD-193	4.25	3.75	1.00	—	—	.27	1.8
▼ Clevis eye										
3900	7800	.500-20UN	AD-150	1.125-20UN	1.12	.63	.75	.94	.63	.5
9000	18,000	.750-16UN	AD-151	1.688-18UN	1.31	1.00	1.00	.94	.75	1.3
15,500	31,000	1.125-12UN	AD-152	2.187-16UN	1.88	1.25	1.00	1.19	1.00	2.9
24,500	49,000	1.500-12UN	AD-153	2.750-16UN	2.00	1.50	1.00	1.06	1.25	4.6

RD



Product dimensions in inches []

Model number	A	B	C	D	D1	E	E1	H	K	N	T	W	Z	Z1	lbs
					UN				UN				UN		
RD-41	8.44	7.31	6.38	2.00	1.375-12	.75	.69	1.84	.500-20	1.13	.75	.44	1.125-20	.35	4.8
RD-43	12.44	9.31	8.38	2.00	1.375-12	.75	.69	1.84	.500-20	1.13	.75	.44	1.125-20	.35	6.4
RD-46	18.44	12.31	11.38	2.00	1.375-12	.75	.69	1.84	.500-20	1.13	.75	.44	1.125-20	.35	9.0
RD-91	9.88	8.75	7.80	2.50	2.000-12	1.00	.94	2.25	.750-16	1.50	.75	.56	1.688-18	.55	9.0
RD-93	13.91	10.78	9.80	2.50	2.000-12	1.00	.94	2.25	.750-16	1.50	.75	.56	1.688-18	.55	11.0
RD-96	19.91	13.78	12.80	2.50	2.000-12	1.00	.94	2.25	.750-16	1.50	.75	.56	1.688-18	.55	14.0
RD-910	27.91	17.78	16.81	2.50	2.000-12	1.00	.94	2.25	.750-16	1.50	.75	.56	1.688-18	.55	19.0
RD-166	21.56	15.31	14.13	3.00	2.625-16	1.38	1.26	2.88	1.125-12	2.13	1.00	.88	2.187-16	.94	22.0
RD-1610	29.56	19.31	18.11	3.00	2.625-16	1.38	1.26	2.88	1.125-12	2.13	1.00	.88	2.187-16	.94	29.0
RD-256	22.94	16.69	15.63	3.63	3.250-16	1.88	1.77	3.50	1.500-12	2.75	1.00	1.13	2.750-16	1.02	36.0
RD-2510	30.94	20.69	19.61	3.63	3.250-16	1.88	1.77	3.50	1.500-12	2.75	1.00	1.13	2.750-16	1.02	46.0

Force: 3900-24,500 lbs

Stroke: 1.13-10.25 inch

Pressure: 500-10,000 psi

E Cilindros universales

F Vérins universels

D Universelle Linearzylinder



Options

Cylinder
accessories

78 ▶



Important

Be certain that the mounting
devices can handle the forces in
the push and pull direction.

RD series cylinders are
designed for a maximum
operating pressure of
10,000 psi.

When applying 10,000 psi
cylinder capacities
double as well.

Cylinder accessories

Shown: Cylinder accessories



▶ These accessories are provided so that you can effectively position, mount and actuate Enerpac hydraulic cylinders according to your specific fixturing or production applications.

For optimum mounting and fixture flexibility

...to match specific applications

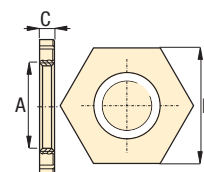
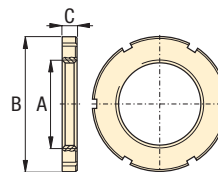
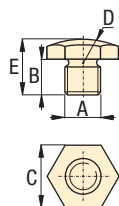
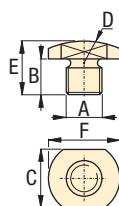
- **Contact bolts**
Allow cylinders to act as a datum point in your clamping applications, and protect the piston when cylinders are used for pushing applications
- **Cylindrical flange nuts**
For mounting threaded body cylinders in any position
- **Mounting brackets**
For bolting cylinders to suit the application

BS-21, -41, -42, -61, -62, -82

other BS models

all others

FN-121, 201, 251



Product dimensions in inches []

A thread	Model number	B	C	D	E	F
▼ Spherical contact bolts						
#6-32 UN	BS-21	.20	.18	.18	.45	.25
#8-32 UN	BS-41	.28	.25	.24	.56	.31
M4 x 0.7	BS-42	.20	.24	.39	.31	.31
.250-28 UN	BS-61	.25	.35	.59	.39	.47
M6 x 1.0	BS-62	.25	.35	.59	.39	.47
.313-24 UN	BS-81	.27	.56	.79	.28	—
M8 x 1.25	BS-82	.25	.51	.79	.41	.63
.375-16 UN	BS-91	.50	.50	.50	.75	—
.500-13 UN	BS-101	.49	.87	1.18	.73	—
M10 x 1.5	BS-102	.25	.67	.91	.43	—
M16 x 2.0	BS-162	.47	.87	.87	.94	—
M20 x 2.5	BS-202	.47	.94	.87	.94	—

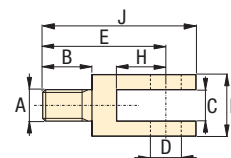
A thread	Model number	B	C
▼ Jam nuts			
0.500-20 UN	FN-121	0.75	0.31
M12 x 1.5	FN-122	1.10	0.24
0.750-16 UN	FN-201	1.13	0.42
M20 x 1.5	FN-202	1.12	0.42
1.000-12 UN	FN-251	1.50	0.55
1.125-16 UN	FN-281	1.75	0.38
M28 x 1.5	FN-282	1.97	0.39
1.250-16 UN	FN-301	1.97	0.39
M30 x 1.5	FN-302	1.97	0.39
1.313-16 UN	FN-331	1.88	0.25
1.375-18 UN	FN-351	1.88	0.25
M35 x 1.5	FN-352	2.17	0.43
1.625-16 UN	FN-421	2.25	0.33
M42 x 1.5	FN-422	2.44	0.47
1.875-16 UN	FN-481	2.50	0.50
M48 x 1.5	FN-482	2.95	0.51
2.125-16 UN	FN-551	3.13	0.38
M55 x 1.5	FN-552	3.15	0.51
2.500-16 UN	FN-651	3.25	0.38
M65 x 1.5	FN-652	3.74	0.55
3.125-16 UN	FN-801	4.13	0.50
M80 x 2.0	FN-802	4.53	0.63

■ Enerpac worksupport locked in position using an FN series self-locking flange nut.



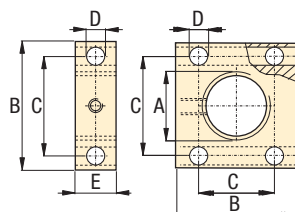
Product dimensions in inches []

A thread	Model number	B	C	D	E	F	H	J
▼ Yoke								
.312-24 UN	Y-3121	.50	.31	.31	1.25	.63	.50	1.88

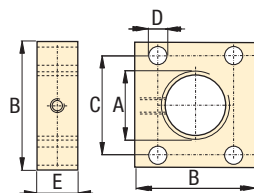




MF and AW-51 models



other AW models



- E** Accesorios de cilindro
- F** Accessoires pour vérins
- D** Zubehör für Zylinder

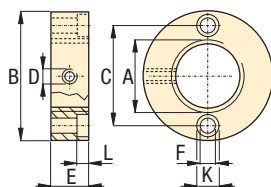
Product dimensions in inches [$\triangle \oplus$]

A	Model number	B	C	D	E
thread				ø	

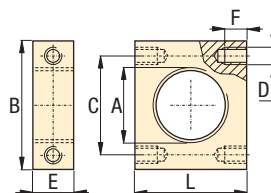
▼ Mounting flanges – Rectangular

1.375-18 UN	AW-5	1.70	1.34	0.27	0.50
1.500-16 UN	AW-51	2.75	2.12	.41	1.00
1.875-16 UN	AW-89	2.25	1.77	0.34	1.00
2.500-16 UN	AW-19	3.25	2.17	0.34	1.00
3.125-16 UN	AW-90	3.75x4.75	2.38x3.50	0.64	1.25
0.500-20 UN	MF-121	1.50	1.00	0.25	1.00
M12 x 1,5	MF-122	1.57	0.98	0.25	0.98
0.750-16 UN	MF-201	2.25	1.50	0.38	1.50
M20 x 1,5	MF-202	2.56	1.75	0.40	1.57
1.000-12 UN	MF-251	2.50	1.75	0.38	1.50
1.125-16 UN	MF-281	2.75	2.00	0.38	1.50
M28 x 1,5	MF-282	2.95	2.00	0.40	1.57
1.313-16 UN	MF-331	3.00	2.25	0.38	1.50
1.375-18 UN	MF-351	3.00	2.25	0.38	1.50
M35 x 1,5	MF-352	3.15	2.25	0.40	1.57
1.625-16 UN	MF-421	3.25	2.50	0.38	1.50
M42 x 1,5	MF-422	3.54	2.50	0.40	1.57
1.875-16 UN	MF-481	3.50	2.75	0.38	1.50
M48 x 1,5	MF-482	3.74	2.75	0.40	1.57
2.125-16 UN	MF-551	4.00	3.00	0.44	1.75
M55 x 1,5	MF-552	4.33	3.25	0.44	1.75
2.500-16 UN	MF-651	4.50	3.50	0.44	1.75
M65 x 1,5	MF-652	4.53	3.50	0.44	1.75
3.125-16 UN	MF-801	5.00	4.00	0.44	1.75
M80 x 2,0	MF-802	5.31	4.25	0.44	1.75

AW-53, -121



AW-102



Product dimensions in inches [$\triangle \oplus$]

A	Model number	B	C	D	E	F	K	L
thread				thread				

▼ Mounting flanges – Cylindrical

1.500-16 UN	AW-53	2.76	2.25	.250-20 UN	.75	.28	.41	.31
2.750-16 UN	AW-121	4.50	3.00	.250-20 UN	.75	.34	.50	.38

▼ Mounting flanges – Rectangular

2.250-14 UN	AW-102	3.25	3.00	.437-20 UN	1.25	.62	–	4.00
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5000 psi Tie Rod Cylinders *Application & selection*

Shown: TRFM-1506, TRFL-3210 and TRCM-3206



Enerpac 5000 psi Tie Rod cylinders provide a variety of mounting options for pushing and positioning workpieces and fixtures on a machine.

Enerpac tie rod cylinders are designed to the highest industry standards to provide long life and worry-free performance in the most demanding applications.

Standard bore sizes

Bore diameter in	Rod diameter in	Capacity at 5000 psi		Effective area	
		Push lbs	Pull lbs	Push in ²	Pull in ²
1.50	1.00	8,850	4,900	1.77	0.98
2.00	1.38	15,700	8,300	3.14	1.66
2.50	1.75	24,550	12,500	4.91	2.50
3.25	2.00	41,500	25,800	8.30	5.16
4.00	2.50	62,850	38,300	12.57	7.66

Additional bore sizes

Bore diameter in	Rod diameter in	Capacity at 5000 psi	
		Push lbs	Pull lbs
5.00	3.50	98,170	50,060
6.00	4.00	141,400	78,550
7.00	5.00	192,400	94,220
8.00	5.50	251,400	132,600

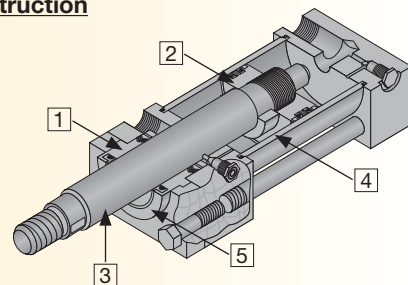
Contact Enerpac for ordering information on additional bore sizes.

Performance tested design features at 5000 psi

- Rod seal (1) uses spring loaded multiple lip vee rings, a supporting bronze bearing ring bushing and a double lip wiper
- Piston seal (2) combines two bi-directional sealing cast iron piston rings with two block vee seals with back-up rings
- Hardened chrome plated piston rod (3) resists scoring and corrosion, assuring maximum life
- Steel tubing barrel (4), honed to a fine finish assures superior sealing, minimum friction and maximum seal life
- Rod bushing and seals can be serviced by merely removing the retainer plate (5) on most models

Tie Rod cylinder construction

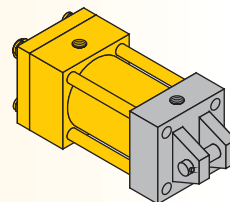
- 1 Rod Seal
- 2 Piston Seal
- 3 Piston Rod
- 4 Barrel
- 5 Retainer Plate



Tie Rod cylinder mounting styles

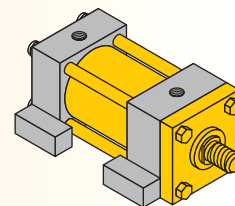
Clevis Mount – TRCM Series

- NFPA style MP1
- Allows cylinder to pivot
- Requires provision for pivoting on rod end



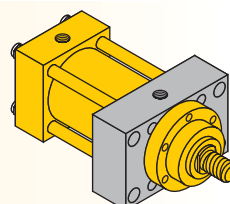
Foot mount – TRFM series

- NFPA style MS2
- Allows easy mounting with only four bolts
- Backup key included in design to ensure long life



Flange mount – TRFL series

- NFPA style ME5
- Allows cylinder length to be buried in machine
- Strongest, most rigid mount





Product selection

Piston diameter	Rod diameter	Stroke	Clevis mount	Foot mount	Flange mount
in	in	in			
1.50	1.00	2	TRCM-1502	TRFM-1502	TRFL-1502
1.50	1.00	4	TRCM-1504	TRFM-1504	TRFL-1504
1.50	1.00	6	TRCM-1506	TRFM-1506	TRFL-1506
1.50	1.00	10	TRCM-1510*	TRFM-1510	TRFL-1510
1.50	1.00	12	TRCM-1512*	TRFM-1512	TRFL-1512
2.00	1.38	2	TRCM-2002	TRFM-2002	TRFL-2002
2.00	1.38	4	TRCM-2004	TRFM-2004	TRFL-2004
2.00	1.38	6	TRCM-2006	TRFM-2006	TRFL-2006
2.00	1.38	10	TRCM-2010	TRFM-2010	TRFL-2010
2.00	1.38	12	TRCM-2012	TRFM-2012	TRFL-2012
2.50	1.75	2	TRCM-2502	TRFM-2502	TRFL-2502
2.50	1.75	4	TRCM-2504	TRFM-2504	TRFL-2504
2.50	1.75	6	TRCM-2506	TRFM-2506	TRFL-2506
2.50	1.75	10	TRCM-2510	TRFM-2510	TRFL-2510
2.50	1.75	12	TRCM-2512	TRFM-2512	TRFL-2512
3.25	2.00	2	TRCM-3202	TRFM-3202	TRFL-3202
3.25	2.00	4	TRCM-3204	TRFM-3204	TRFL-3204
3.25	2.00	6	TRCM-3206	TRFM-3206	TRFL-3206
3.25	2.00	10	TRCM-3210	TRFM-3210	TRFL-3210
3.25	2.00	12	TRCM-3212	TRFM-3212	TRFL-3212
4.00	2.50	2	TRCM-4002	TRFM-4002	TRFL-4002
4.00	2.50	4	TRCM-4004	TRFM-4004	TRFL-4004
4.00	2.50	6	TRCM-4006	TRFM-4006	TRFL-4006
4.00	2.50	10	TRCM-4010	TRFM-4010	TRFL-4010
4.00	2.50	12	TRCM-4012	TRFM-4012	TRFL-4012

Cushions are available for all cylinder models. Cushions slow down heavy loads prior to end of stroke, preventing damage to the cylinder or the machine. To add cushions to your Enerpac Tie Rod cylinder, simply add the letter "C" to the end of any model number. Note: The addition of cushions does not affect the outside dimensions of the cylinder.

* These models are only rated to 4000 psi due to constraints on the mechanical properties of the rod.



Custom build your Tie Rod cylinder

TR	CM	15	12	C
1	2	3	4	5
1 Product Type TR = Tie Rod		3 Bore Diameter 15 = 1.5" 20 = 2.0" 25 = 2.5" 32 = 3.25" 40 = 4.0"	4 Stroke 02 = 2" 04 = 4" 06 = 6" 10 = 10" 12 = 12"	5 Cushions Blank = None C = Cushions both ends
2 Mounting CM = Clevis Mount FM = Foot Mount FL = Flange Mount				

Seal and repair kits

Seal kits include piston, rod and barrel seals. Repair kits include seal kit plus rod bushing and rear bearing ring.



Product dimensions in inches

Bore diameter in	Rod diameter in	Seal kit	Repair kit
1.50	1.00	TR15SK	TR15RK
2.00	1.38	TR20SK	TR20RK
2.50	1.75	TR25SK	TR25RK
3.25	2.00	TR32SK	TR32RK
4.00	2.50	TR40SK	TR40RK

Capacity: 8850-62,850 lbs.

Stroke: 2-12 in.

Pressure: 500-5000 psi

E Cilindros Atirantados

F Vérins à tirants

D Zugankerzylinder



Options

Accessories

85 ▶



ZW Series Pumps

94 ▶



VP Series Valves

122 ▶



Fittings

158 ▶



Important

Consult individual product selection pages for application and installation criteria specific to each mounting style. If you are unsure of an application, contact Enerpac directly.

Enerpac can provide many other tie rod cylinders in a wide variety of mounting styles, bore and stroke sizes. Contact Enerpac directly and talk to our Custom Products group for a quotation.

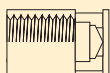
Shown: TRCM-3204



TR series clevis mount

Enerpac clevis mount 5000 psi Tie Rod cylinders provide for motion in two axis, increasing the range of motion on your machine with only one cylinder.

Special rod ends

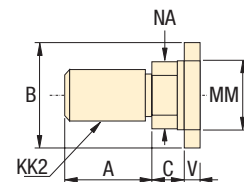
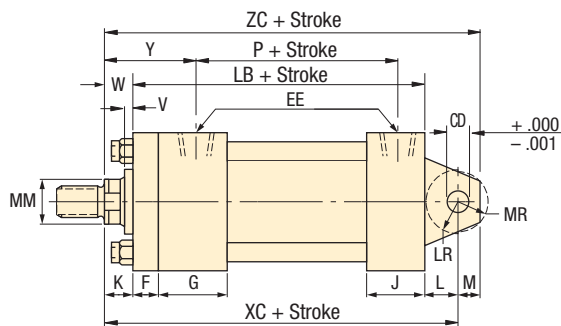
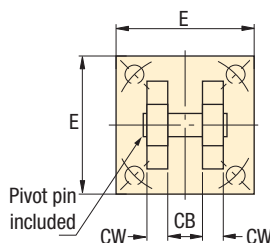


- Either internal or external threads available
- Custom designs to match your tooling requirements

Flexibility of motion

- Clevis mount cylinders include pivot pin for mounting in your machine
- Standard rod eyes and rod clevises available for each bore size.
- NFPA style MP1
- Designed to carry shear loads
- Pivot pins should be carried by rigidly held bearings and closely fit for the entire length of the pin

TRCM models Clevis mount



Capacity: 8850-62,850 lbs.

Stroke: 2-12 in.

Pressure: 500-5000 psi

E Cilindros Atirantados

F Vérins à tirants

D Zugankerzylinder

Options

Accessories

85 ▶

ZW Series Pumps

94 ▶

VP Series Valves

122 ▶

Fittings

158 ▶

Dimensions in inches []

Bore diameter	Rod diameter	Model number	A	B	C	CB	CD	CW	D*	E	EE	F	G	J	K
1.50	1.00	TRCM-15xx**	1.13	1.50	0.50	0.75	0.50	0.50	0.88	2.50	SAE #10	0.38	1.75	1.50	0.50
2.00	1.38	TRCM-20xx	1.63	2.00	0.63	1.25	0.75	0.63	1.13	3.00	SAE #10	0.63	1.75	1.50	0.63
2.50	1.75	TRCM-25xx	2.00	2.38	0.75	1.25	0.75	0.63	1.50	3.50	SAE #10	0.63	1.75	1.50	0.63
3.25	2.00	TRCM-32xx	2.25	2.63	0.88	1.50	1.00	0.75	1.69	4.50	SAE #12	0.75	2.00	1.75	0.75
4.00	2.50	TRCM-40xx	3.00	3.13	1.00	2.00	1.38	1.00	2.06	5.00	SAE #12	0.88	2.00	1.75	0.75

* D = Distance across plunger wrench flats.

** 10 and 12 inch models are rated at only 4000 psi.

Bore diameter	Rod diameter	Model number	KK2	L	LB	LR	M	MM	MR	NA	P	V	W	XC	Y	ZC	
1.50	1.00	TRCM-15xx	3/4"-16	0.75	5.00	0.63	0.50	1.00	0.66	0.97	2.13	0.50	1.00	6.75	2.38	7.25	lbs
2.00	1.38	TRCM-20xx	1"-14	1.25	5.25	1.13	0.75	1.38	0.94	1.34	2.88	0.38	1.00	7.50	2.63	8.25	***
2.50	1.75	TRCM-25xx	1-1/4"-12	1.25	5.38	1.13	0.75	1.75	0.94	1.70	3.00	0.50	1.25	7.88	2.88	8.63	***
3.25	2.00	TRCM-32xx	1-1/2"-12	1.50	6.25	1.25	1.00	2.00	1.19	1.95	3.59	0.38	1.25	9.00	3.09	10.00	***
4.00	2.50	TRCM-40xx	1-7/8"-12	2.13	6.63	1.88	1.38	2.50	1.38	2.45	3.88	0.38	1.38	10.13	3.31	11.50	***

*** For product weights, please reference the price list or contact Enerpac customer service for more information.

Capacity: 8850-62,850 lbs.

Stroke: 2-12 in.

Pressure: 500-5000 psi

E Cilindros Atirantados

F Vérins à tirants

D Zugankerzylinder



Options

Accessories

85 ▶



ZW Series Pumps

94 ▶



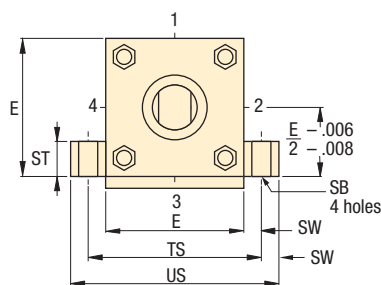
VP Series Valves

122 ▶

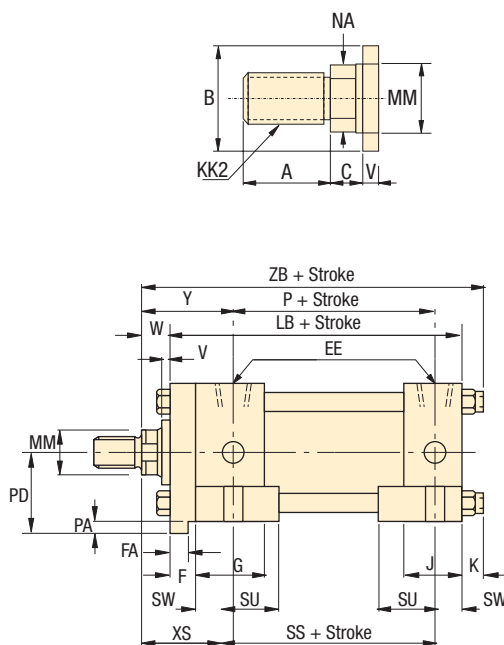


Fittings

158 ▶



TRFM models Foot Mount



Dimensions in inches []

Bore diameter	Rod diameter	Model number	A	B	C	D*	E	EE	F	FA	G	J	K	KK2	LB	MM
1.50	1.00	TRFM-15xx	1.13	1.50	0.50	0.88	2.50	SAE #10	0.38	0.310-0.312	1.75	1.50	0.50	3/4"-16	5.00	1.00
2.00	1.38	TRFM-20xx	1.63	2.00	0.63	1.13	3.00	SAE #10	0.63	0.560-0.562	1.75	1.50	0.63	1"-14	5.25	1.38
2.50	1.75	TRFM-25xx	2.00	2.38	0.75	1.50	3.50	SAE #10	0.63	0.560-0.562	1.75	1.50	0.63	1-1/4"-12	5.38	1.75
3.25	2.00	TRFM-32xx	2.25	2.63	0.88	1.69	4.50	SAE #12	0.75	0.684-0.687	2.00	1.75	0.75	1-1/2"-12	6.25	2.00
4.00	2.50	TRFM-40xx	3.00	3.13	1.00	2.06	5.00	SAE #12	0.88	0.809-0.812	2.00	1.75	0.75	1-7/8"-12	6.63	2.50

* D = Distance across plunger wrench flats.

Bore diameter	Rod diameter	Model number	NA	P	PA	PD	SB	SS	ST	SU	SW	TS	US	V	W	XS	Y	ZB	
1.50	1.00	TRFM-15xx	0.97	2.88	0.19	1.44	0.44	3.88	0.50	0.94	0.38	3.25	4.00	0.50	1.00	1.75	2.38	6.50	lbs
2.00	1.38	TRFM-20xx	1.34	2.88	0.31	1.81	0.56	3.63	0.75	1.25	0.50	4.00	5.00	0.38	1.00	2.13	2.63	6.88	***
2.50	1.75	TRFM-25xx	1.70	3.00	0.31	2.06	0.81	3.38	1.00	1.56	0.69	4.88	6.25	0.50	1.25	2.56	2.88	7.25	***
3.25	2.00	TRFM-32xx	1.95	3.59	0.38	2.63	0.81	4.13	1.00	1.56	0.69	5.88	7.25	0.38	1.25	2.69	3.09	8.25	***
4.00	2.50	TRFM-40xx	2.45	3.88	0.44	2.94	1.06	4.00	1.25	2.00	0.88	6.75	8.50	0.38	1.38	3.13	3.31	8.75	***

*** For product weights, please reference the price list or contact Enerpac customer service for more information.

Ease of installation

- Foot mount cylinders provide simplest mounting option with just four bolt holes required
- Standard key mount is included ensuring proper mounting and adding rigidity
- NFPA style MS2
- Compact mounting fits in tight spaces where other cylinders cannot

Shown: TRFM-1506



TR series foot mount

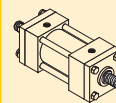
Enerpac foot mount 5000 psi Tie Rod cylinders provide a high quality positioning solution using a minimal amount of space.



Important

Some custom options may require reduction of working pressure or special installation considerations. Contact Enerpac Technical Service to discuss your application.

Special rod ends



Double rod ends

- Available on all models except clevis mounts
- The two rod ends can be different on the same cylinder

Shown: TRFL-3206



TR series flange mount
Enerpac flange mount 5000 psi Tie Rod cylinders provide the most rigid mounting ensuring long life and high accuracy on your machine.

Special rod ends

Rod boots

- Rod boots are made from neoprene coated fabric
- Impervious to oil grease and water
- Rated for temperatures from 0° F to 200° F

Metallic wipers

- Recommended in applications where contaminants tend to cling to the rod surface
- Available on all rod diameters

Extra strong

- Flange mount is part of the cylinder end cap, providing maximum strength and rigidity
- Allows length of cylinder to be mounted inside the machine
- NFPA style ME5
- Simple four bolt mounting pattern makes installation easy
- Mounting is best suited for tension applications

Capacity: 8850-62,850 lbs.

Stroke: 2-12 in.

Pressure: 500-5000 psi

E Cilindros Atirantados

F Vérins à tirants

D Zugankerzylinder

Options

Accessories

85 ▶

ZW Series Pumps

94 ▶

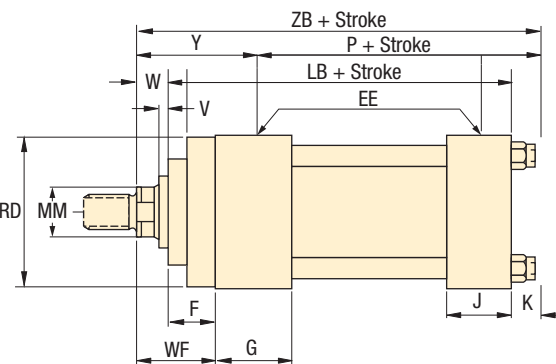
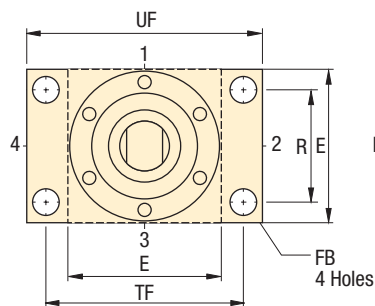
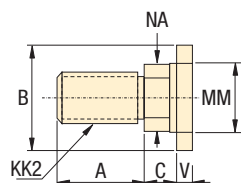
VP Series Valves

122 ▶

Fittings

158 ▶

TRFL models Flange Mount



Dimensions in inches []

Bore diameter	Rod diameter	Model number	A	B	C	D*	E	EE	F	FB	G	J	K	KK2
1.50	1.00	TRFL-15xx	1.13	1.50	0.50	0.88	2.50	SAE #10	0.38	0.44	1.75	1.50	0.50	3/4"-16
2.00	1.38	TRFL-20xx	1.63	2.00	0.63	1.13	3.00	SAE #10	0.63	0.56	1.75	1.50	0.63	1"-14
2.50	1.75	TRFL-25xx	2.00	2.38	0.75	1.50	3.50	SAE #10	0.63	0.56	1.75	1.50	0.63	1-1/4"-12
3.25	2.00	TRFL-32xx	2.25	2.63	0.88	1.69	4.50	SAE #12	0.75	0.69	2.00	1.75	0.75	1-1/2"-12
4.00	2.50	TRFL-40xx	3.00	3.13	1.00	2.06	5.00	SAE #12	0.88	0.69	2.00	1.75	0.75	1-7/8"-12

* D = Distance across plunger wrench flats.

Bore diameter	Rod diameter	Model number	LB	MM	NA	P	R	RD	TF	UF	V	W	WF	Y	ZB	lbs
1.50	1.00	TRFL-15xx	5.00	1.00	0.97	2.88	1.63	-	3.44	4.25	0.50	1.00	1.38	2.38	6.50	***
2.00	1.38	TRFL-20xx	5.25	1.38	1.34	2.88	2.50	-	4.13	5.13	0.38	1.00	1.63	2.63	6.88	***
2.50	1.75	TRFL-25xx	5.38	1.75	1.70	3.00	2.55	-	4.63	5.63	0.50	1.25	1.88	2.88	7.25	***
3.25	2.00	TRFL-32xx	6.25	2.00	1.95	3.59	3.25	4.00	5.88	7.13	0.38	1.25	2.00	3.09	8.25	***
4.00	2.50	TRFL-40xx	6.63	2.50	2.45	3.88	3.82	4.50	6.38	7.63	0.38	1.38	2.25	3.31	8.75	***

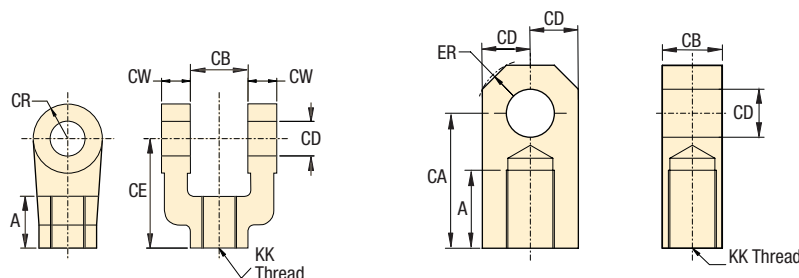
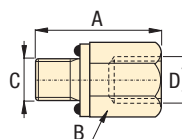
*** For product weights, please reference the price list or contact Enerpac customer service for more information.

For high production applications

- Fit any style of Enerpac tie-rod cylinder
- Rod eyes and rod clevises
 - Required for proper mounting of TRCM series cylinders
 - Pivot pins supplied separately
- Pivot pins for rod eyes and clevises
 - Provided with cotter pins
 - Must be ordered separately
- Linear alignment coupler
 - Prevents binding caused by misalignment
 - Reduces rod seal and bearing wear

Fittings dimensions in inches []

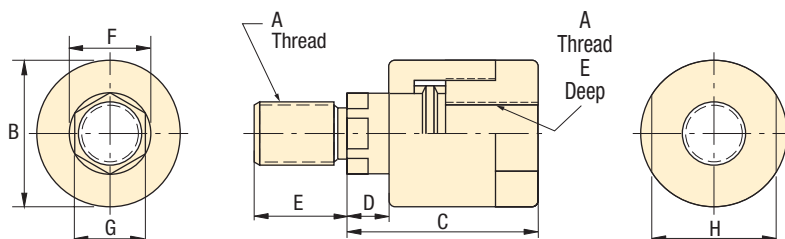
From	To	Model number	A	B	C	D
SAE #10	3/8" NPT	FZ2077	1.31	1.00	SAE #10	3/8" NPT
SAE #12	3/8" NPT	FZ2078	1.00	1.25	SAE #12	3/8" NPT
SAE #10	SAE #6	FZ2079	1.26	1.00	SAE #10	SAE #6
SAE #12	SAE #6	FZ2080	1.00	1.25	SAE #12	SAE #6



Rod Clevis and Rod Eye dimensions in inches []

Rod clevis model number	Rod eye model number	Maximum tension load lbs	KK	A	CA	CB	CD	CE	CR	CW	ER	Clevis Pin
TRRC-15	TRRE-15	12,372	3/4"-16	1.13	2.06	1.25	0.75	2.38	0.75	0.63	0.94	TRPP-15
TRRC-20	TRRE-20	20,433	1"-14	1.63	2.81	1.50	1.00	3.13	1.00	0.75	1.13	TRPP-20
TRRC-25	TRRE-25	30,483	1-1/4"-12	2.00	3.44	2.00	1.38	4.13	1.38	1.00	1.56	TRPP-25
TRRC-32	TRRE-32	49,479	1-1/2"-12	2.25	4.00	2.50	1.75	4.50	1.63	1.25	1.88	TRPP-32
TRRC-40	TRRE-40	70,095	1-7/8"-12	3.00	5.00	2.50	2.00	5.50	2.00	1.25	2.00	TRPP-40

* Operating pressures above 5000 psi require high-pressure fittings or intensifier models with BSPP ports. Contact Enerpac for details.



Linear Alignment Coupler in inches []

Model number	Maximum tension load lbs	A	B	C	D	E	F	G	H
TRAC-15	8500	3/4"-16	1.75	2.31	0.50	1.13	0.97	0.88	1.50
TRAC-20	16,000	1"-14	2.50	2.94	0.50	1.63	1.38	1.16	2.25
TRAC-25	19,500	1-1/4"-12	2.50	2.94	0.50	1.63	1.38	1.16	2.25
TRAC-32	33,500	1-1/2"-12	3.25	4.38	0.81	2.25	1.75	1.50	3.00
TRAC-40	60,000	1-7/8"-12	3.75	5.44	0.88	3.00	2.00	1.88	3.50

Shown: RRE-15, TRCC-15, TRPP-15, TRAC-15



 Enerpac 5000 psi Tie-Rod cylinder accessories allow you to complete your design making installation on your machine a simple project.

Power sources

Power sources

Whether you need to run your parts once a day or 24 hours a day, Enerpac has the power source to help you get the job done. Power sources range from simple manual pumps to air operated, to fully customizable electric motor driven units.

With a wide variety of accessories to choose from, Enerpac power units are easily the most versatile and reliable in the industry.



Technical support

Refer to the “Yellow Pages” of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

 161 ►

	▼ series	▼ page	
Turbo II air-hydraulic pumps	PA	88 - 91	
Air-hydraulic pumps	PA	92	
Choosing a pump		93	
Electric pumps	ZW	94 - 96	
Return line filter kit and heat exchanger kits	ZPF, ZHE	97	
Level/temp switch and pressure transducer	ZLS ZPT, ZPS	98	
Valve manifold	ZW	99	
Pallet de-coupling pumps	ZW	100 - 101	
Continuous connection pumps	ZW	102 - 103	
Single station DO3 pumps	ZW	104 - 105	
Electric pump ordering matrix	ZW	106	
Enerpac system solutions	ZW	107	
Economy electric pumps	WU	108 - 109	
Electric submerged pumps and ordering matrix	WE	110 - 112	
Hand pumps	P, SP	113	
Air-hydraulic boosters	AHB, B	114 - 115	
Activator wand & boosters	B, RA	116 - 117	
Pressure intensifiers	PID	118 - 119	

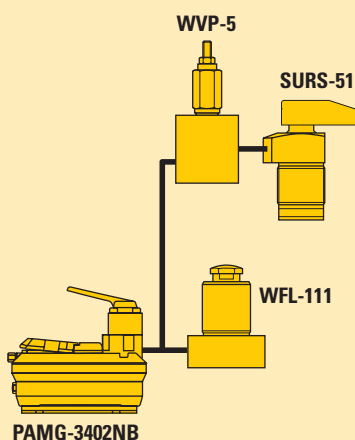
Turbo II air-hydraulic pumps *Application & selection*

Shown: PAMG-5402NB, PACG-3102NB, PATG-3102NB, PATG-5105NB



▶ Turbo II air hydraulic pumps generate the hydraulic pressure you need using the air pressure you have available. The Air Saver Piston reduces air consumption and operating costs.

They are ideal for providing the power and speed desired in simple clamping circuits. Turbo II air-hydraulic pumps are best suited to medium and lower cycle applications. At only 75 dBA, the Turbo II series help to keep noise level to a minimum.



Quick and powerful hydraulic supply in an economical air-powered unit

- On-demand stall-restart operation maintains system pressure, providing clamping security
- External adjustable pressure relief valve (behind sight glass)
- Internal pressure relief valve provides overload protection
- Reduced noise level to 75 dBA
- Operating air pressure: 50-125 psi – enables pump to start at low air pressure
- Reinforced heavy-duty lightweight reservoir for applications in tough environments
- Five valve mounting options provide flexibility in setup and operation
- Fully serviceable air motor assembly

Select the required output

3000 series

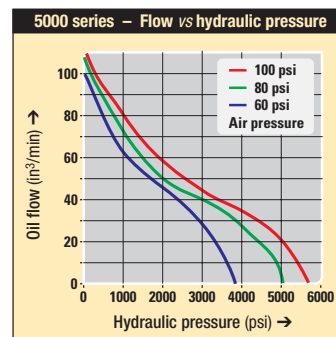
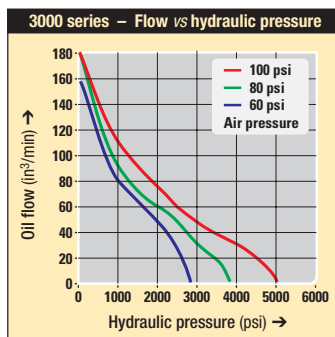
- Hydraulic to air ratio: 45:1

5000 series

- Hydraulic to air ratio: 60:1

**** NOTE:** From 50-125 psi air inlet pressure. Performance is significantly diminished below 50 psi. Performance may vary compared to listed values due to seal friction, internal pressure drops and manufacturing tolerances. Be sure to allow some flexibility on air inlet pressure.

Output oil flow

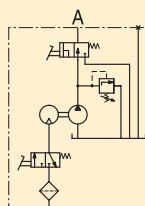




Select the required output:

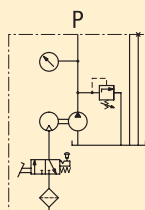
PATG series

- Momentary air inlet treadle for operation of single-acting cylinders
- Provides advance, hold and retract functions



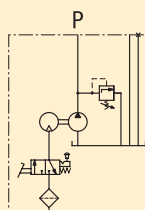
PACG series

- Momentary or continuous air inlet treadle
- A remote valve is required for operation of cylinders



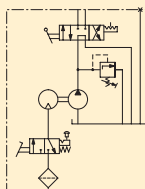
PASG series

- Momentary or continuous air inlet treadle
- Suitable for mounting any single- or double-acting valve with a DO3 mounting configuration
- Available with multiple valve manifold



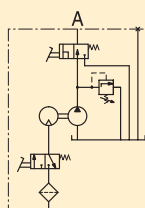
PAMG series

- Momentary or continuous air inlet treadle
- Manual 4-way, 3-position, tandem center valve for single- or double-acting operation



PARG series

- Includes 15 ft. air pendant for remote control of single-acting cylinders
- Provides advance, hold and retract functions



Oil Flow: 180 in³/min

Pressure: 1250-5000 psi

Sound level: 75 dBA

Air: 12 scfm

Reservoir: 70-462 in³

- E** Bombas hidroneumáticas
- F** Pompes hydro-pneumatiques
- D** Lufthydraulische pumpen

Options

Gauges and accessories

154 ▶



Regulator-filter-lubricator

142 ▶



Important

For high cycle applications electric pumps are recommended.

Power sources

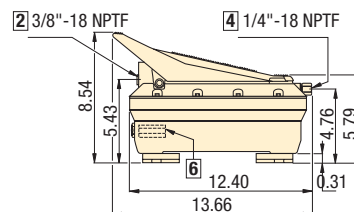
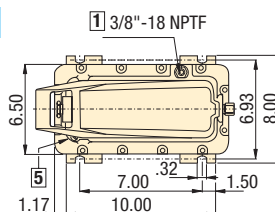
Valves

System components

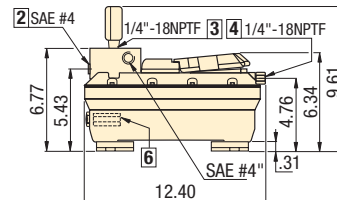
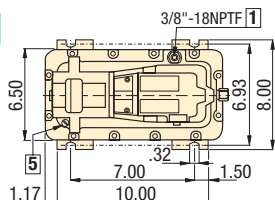
Yellow pages

2-Liter reservoir

PATG series

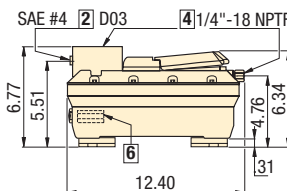
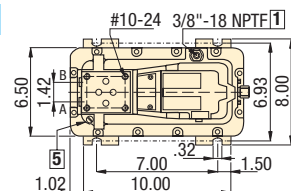


PACG series

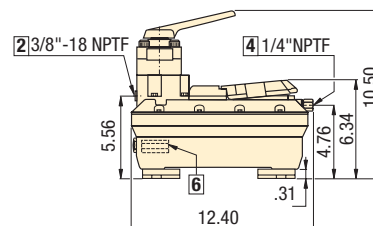
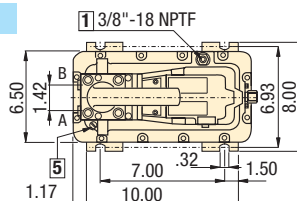


PACG series include pressure gauge G-2517L.

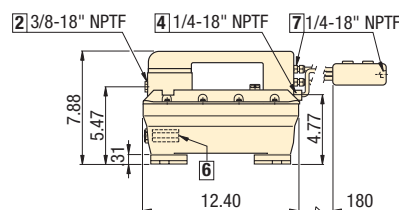
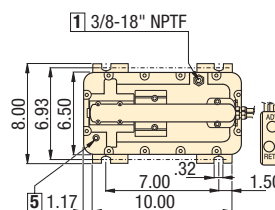
PASG series



PAMG series



PARG series



All dimensions in inches.

- | | |
|---------------------------------|------------------------------------|
| 1 Auxiliary vent/tank fill port | 5 Filtered permanent tank vent |
| 2 Hydraulic output | 6 Adjustable pressure relief valve |
| 3 Gauge mounting port | 7 Air pendant air input |
| 4 Swivel air input with filter | |

Product selection

Description	Model numbers 3000 series	Model numbers 5000 series	Usable oil capacity ²⁾		Air pressure range	Air consumption		
			horizontal mount	vertical mount		scfm	lbs	
	180 in ³ min ⁻¹⁾	120 in ³ min ⁻¹⁾	in ³		psi			
▼ Factory supplied valves								
Hand/foot 3-way	PATG-3102NB	PATG-5102NB	127	70	50-125	12	19	
Hand 4-way	PAMG-3402NB	PAMG-5402NB	127	70	50-125	12	25	
Remote 3-way pendant	PARG3102NB	PARG-5102NB	127	70	50-125	12	23	
▼ User supplied valves								
Remote mount	PACG-3002SB	PACG-5002SB	127	70	50-125	12	19	
Pump mount, single DO3 Valve	PASG-3002SB	PASG-5002SB	127	70	50-125	12	19	

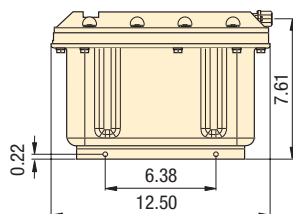
¹⁾ At 0 psi hydraulic and 100 psi air pressure.

²⁾ Turbo air-hydraulic pumps are also available with 305 in³ reservoir. To order replace 2 in model number with 5.

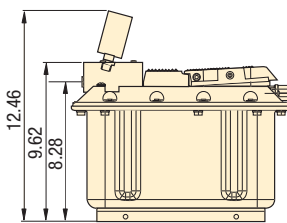
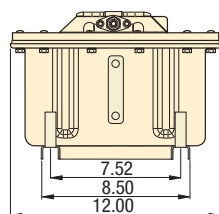


2-Gallon reservoir

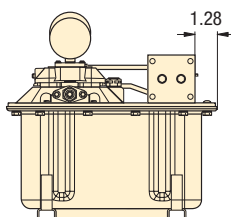
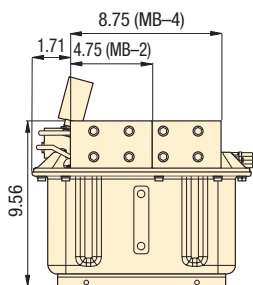
All models



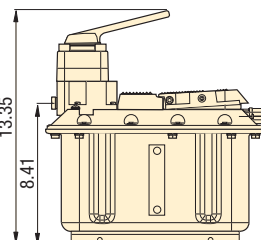
PACG series



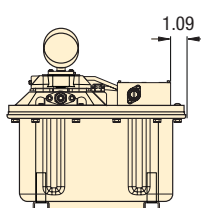
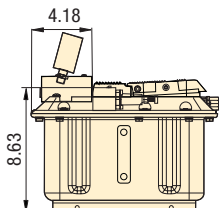
PACG with MB2 or MB4



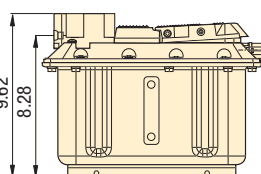
PAMG series



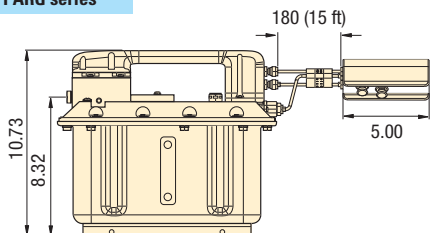
PACG with WM10



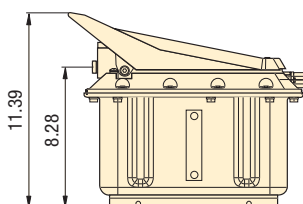
PASG series



PARG series



PATG series


Oil Flow: 180 in³/min

Pressure: 1250 - 5000 psi

Sound level: 75 dBA

Air: 12 scfm

Reservoir: 70-462 in³

- E** Bombas hidroneumáticas
- F** Pompes hydro-pneumatiques
- D** Lufthydraulische pumpen

Options

Gauges and accessories

154 ▶



Regulator-filter-lubricator

142 ▶



Shown: PACG30S8S-WM10



Product selection

Description	Model numbers 3000 series	Model numbers 5000 series	Usable oil capacity	Air pressure range	Air consumption	
	180 in ³ min ¹⁾	120 in ³ min ¹⁾	in ³	psi	scfm	lbs
▼ Factory supplied valves						
Hand/foot 3-way	PATG-31S8N	PATG-51S8N	462	50-125	12	54
Hand 4-way	PAMG-34S8N	PAMG-54S8N	462	50-125	12	60
Remote 3-way pendant	PARG-31S8N	PARG-51S8N	462	50-125	12	58
▼ User supplied valves						
Remote mount	PACG-30S8S	PACG-50S8S	462	50-125	12	54
Pump mount, Single DO3 Valve	PASG-30S8S	PASG-50S8S	462	50-125	12	54
Pump mount, Two DO3 Valves	PACG-30S8S-MB2	PACG-50S8S-MB2	462	50-125	12	58
Pump mount, Four DO3 Valves	PACG-30S8S-MB4	PACG-50S8S-MB4	462	50-125	12	61
Pump mount, (1-8) VP Valves	PACG-30S8S-WM10	PACG-50S8S-WM10	462	50-125	12	56

¹⁾ At 0 psi hydraulic and 100 psi air pressure.

Shown: PA-135, -136



PA series

Compact, lightweight, air driven power source. Treadle start on pump activates pump operation. Best choice for single-acting cylinders.

Portable air hydraulic power

- Patented air saver design - minimal air usage for lower cost operation
- Quiet internal air muffler 80 dBa
- 360° swivel oil and air fittings for easier system setup
- External adjustable relief valve
- Built-in 3-way, 2-position valve provides advance-retract cycle operation for single-acting cylinders

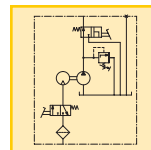
Max. flow: 60-120 in³/min

Pressure: 3000-5000 psi

Air: 12 scfm

Reservoir: 36.6 in³

- Ⓔ Bombas hidroneumáticas
- Ⓕ Pompes hydro-pneumatiques
- Ⓓ Lufthydraulische pumpen



Options

Regulator-filter-lubricator

142 ▶

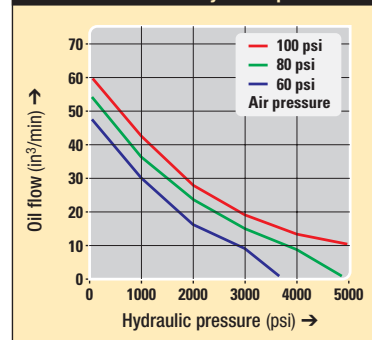


Fittings

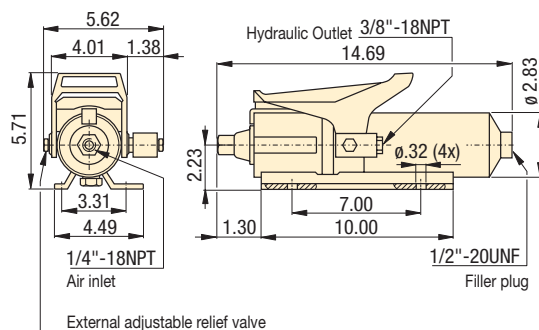
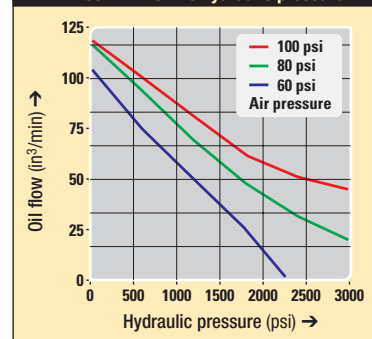
158 ▶



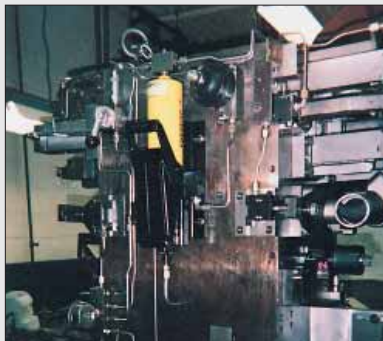
PA-135 - Flow vs hydraulic pressure



PA-136 - Flow vs hydraulic pressure



■ These PA series air hydraulic pumps operate in all positions. Here, a PA-135 is mounted vertically to a clamping fixture.



Product selection

Usable oil capacity	Max. oil flow ¹⁾	Max. hydraulic pressure	Model number	Valve function	Air pressure range	Air consumption	
in ³	in ³ /min	psi			psi	scfm	lbs
36.6	60	5000	PA-135	Advance/Retract	60-100	12	14.3
36.6	120	3000	PA-136	Advance/Retract	60-100	12	14.3

¹⁾ At 0 psi hydraulic pressure.

Note: Seal material: Buna-N, Teflon, Polyurethane.

Select your pump type

Air operated pump

Best choice for large circuits with intermittent or medium duty applications. Air operated pumps have lower flow rates than electric pumps, but are more economical.

 88-89 ▶



Electric operated pump

Best choice for large circuits with medium or high-duty applications. Electric operated pumps have the highest flow rates available and can be configured with many different accessories.

 94-95 ▶



Air hydraulic booster

Best choice for small circuits with intermittent or medium-duty applications. Air hydraulic boosters provide a single shot of oil to your circuit at high pressure.

 114-115 ▶



Oil to oil intensifier

Best choice for small circuits with medium- or high-duty applications. Oil to oil intensifiers use machine tool hydraulic pressure and boost it to higher clamping pressure directly on the fixture.

 118-119 ▶



Select your pump options

Reservoir size

Choose a reservoir size that holds enough oil to fill all of your lines, manifolds and cylinders, with enough reserve for future needs. Each Enerpac cylinder has an oil capacity listed on its product page, and each power unit has a reservoir capacity listed.

Valve type

Directional valves allow you control over what portion of the circuit receives oil. Valves can be operated manually, by electric solenoid or by air pilot pressure. Multiple valves can be used with one power unit to control multiple circuits.

Accessories

For increased automation, electric pumps can be outfitted with additional accessories, including pressure switches, level switches, and control pendants. These options can either be factory installed or added to an existing power unit in the future.

Pressure: 960-10,000 psi

Flow rate: 40-640 in³/min

Reservoir: Up to 10 gal

Options

Manual valves

 127, 132-135 ▶



Electric valves

 119, 120, 122-123 ▶



Air operated valves

 126 ▶



Important

231 cubic inches = 1 US gal.

61 cubic inches = 1 liter

1 US gallon = 3.785 liters

Shown: ZW5020HB-FT01



Z-Class electric pumps are designed for use in the harshest manufacturing environments. The pumps provide reliable and durable performance in a wide variety of configurations.

The new standard for workholding applications

- Features Z-Class high-efficiency pump design; higher oil flow and by-pass pressure, cooler running and requires 18% less current than comparable pumps
- Totally enclosed, fan cooled industrial electric motors supply extended life and stand up to harsh industrial environments
- Multiple valve and reservoir configurations provide application specific models to match the most demanding workholding applications
- High-strength, molded electrical enclosure protects electronics, power supplies and LCD readout from coolant and contamination

Basic configurations

All pumps listed in this chart include LCD electrical box, 5 gallon reservoir, return line filter and either 0-6000 psi pressure gauge or pressure transducer (solenoid valve models). For additional options, see the complete pump matrix on page 106.

Pump type

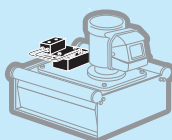
Valve/manifold type

Motor voltage

50/60 Hz

ZW-Series with manifold

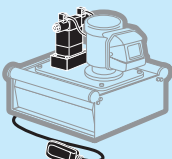
- Used when supplying pressure to multiple valve circuits
- Valves must be supplied separately



Pressure and tank ports	230 VAC, 3 ph
Single station DO3	230 VAC, 3 ph
Enerpac VP-series	230 VAC, 3 ph
Two station DO3	230 VAC, 3 ph
Four station DO3	230 VAC, 3 ph

ZW-Series with pallet de-coupling valve

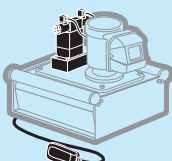
- Provides momentary pressure and flow to fixture
- Ideal for pallet disconnect systems



4-way, 3-pos. solenoid operated	115 VAC, 1 ph
4-way, 3-pos. solenoid operated	230 VAC, 3 ph
4-way, 3-pos. solenoid operated	460 VAC, 3 ph

ZW-Series with continuous connection valve

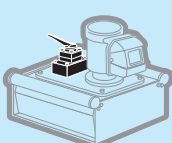
- Provides solenoid control of one single or double-acting circuit
- Control valve supplied with integrated pilot operated check to ensure positive pressure holding



4-way, 3-pos. solenoid operated	115 VAC, 1 ph
4-way, 3-pos. solenoid operated	230 VAC, 3 ph
4-way, 3-pos. solenoid operated	460 VAC, 3 ph

ZW-Series with manual valve

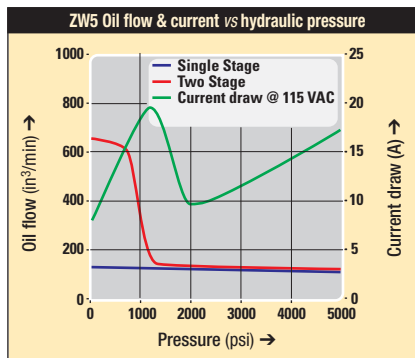
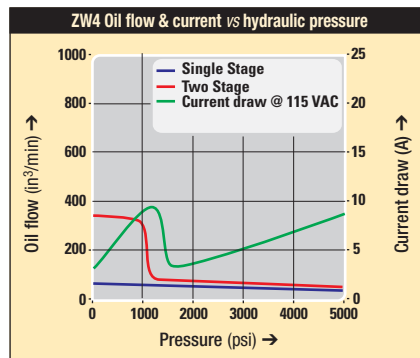
- Provides manual control of one single or double-acting circuit
- Control valve supplied with center holding function to ensure positive position holding



4-way, 3-pos. manually operated	115 VAC, 1 ph
4-way, 3-pos. manually operated	230 VAC, 3 ph
4-way, 3-pos. manually operated	460 VAC, 3 ph



Output oil flow and current draw



Important

Single-stage pumps provide constant flow throughout the entire pressure range via a radial piston pump. Two-stage pumps provide high flow via a gear pump until the bypass pressure is reached. At pressures above the bypass setting, the radial piston pump provides flow to the maximum pressure.

ZW4 Series
Output oil flow at 5000 psi
60 in³/min
LCD Electric Model Number

ZW4020HG-FG01
ZW4020HG-FG11
ZW4020HG-FG12
ZW4020HG-FG21
ZW4020HG-FG41

ZW4420DB-FT
ZW4420DG-FT
ZW4420DJ-FT

ZW4420FB-FT
ZW4420FG-FT
ZW4420FJ-FT

ZW4420LB-FG
ZW4420LG-FG
ZW4420LJ-FG

ZW5 Series
Output oil flow at 5000 psi
120 in³/min
LCD Electric Model Number

ZW5020HG-FG01
ZW5020HG-FG11
ZW5020HG-FG12
ZW5020HG-FG21
ZW5020HG-FG41

ZW5420DB-FT
ZW5420DG-FT
ZW5420DJ-FT

ZW5420FB-FT
ZW5420FG-FT
ZW5420FJ-FT

ZW5420LB-FG
ZW5420LG-FG
ZW5420LJ-FG

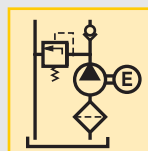
Flow rate: 60-120 in³/min

Pressure: 5000 psi max

Motor: 1.0 & 1.5 hp

Reservoir: 2.5-10 gal

- E** Bombas eléctricas
- F** Centrale hydraulique
- D** Tauchpumpe



Important

All Z-Class electric pumps are CSA and CE compliant.



LCD electrical package is required for pumps utilizing electric valves, or optional accessories such as the pressure transducer, level switch, pressure switch or heat exchanger.

Power sources

Valves

System components

Yellow pages

Electric pumps *Dimensions & options*

Shown: ZW5020HB-FT01



- Efficient design reduces heat generation and reduces power consumption
- Balanced pump section reduces vibration improving durability and sound levels
- Optional back-lit LCD readout provides hour and cycle counts, low voltage warnings and pressure read-out when used with pressure transducer
- Low-voltage pendant on solenoid valve models with sealed switches improves operator safety
- **Z-Class** electric pumps are supplied with factory installed accessories such as valve manifold, pressure transducer, and return line filter, creating a complete power unit solution

Flow rate: 60-120 in³/min

Pressure: 5000 psi

Motor: 1.0 & 1.5 hp

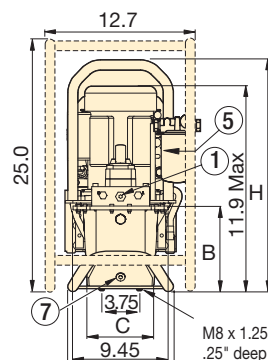
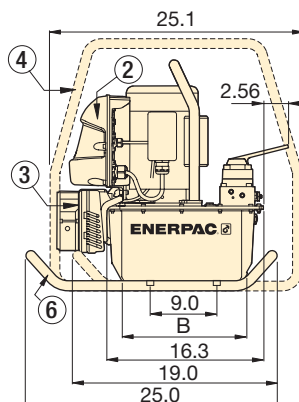
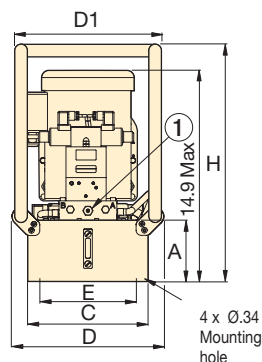
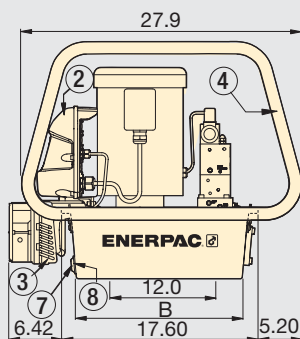
Reservoir: 2.5-10 gallon

- (E) Bombas eléctricas
- (F) Centrale hydraulique
- (D) Tauchpumpe

Options

User adjustable relief valve

All ZW-Series have a user adjustable relief valve to allow the operator to easily set the optimum working pressure.



- ① User adjustable relief valve on all manual and solenoid valves:
 - 3/8" NPTF on A and B ports
 - 1/4" NPTF on auxiliary ports
- ② Electric Box (Optional w/manual valve)
- ③ Heat Exchanger (Optional)
- ④ Roll Bar (Optional)
- ⑤ Return Line Filter (Optional)
- ⑥ Skid Bar (Optional)
- ⑦ Oil Drain
- ⑧ Oil Level/Temperature Switch (Optional)

Product dimensions in inches []

Usable oil capacity	ZW Series pump dimensions (in)							
	gal	A	B	C	D	D1	E	H
1.0	5.6	11.0	6.0	-	-	-	-	20.2
2.0	8.1	11.3	6.6	-	-	-	-	22.6
2.5	6.1	16.5	12.0	15.1	14.6	11.0		23.6
5.0	7.1	16.5	16.6	19.7	19.2	15.6		24.6
10.0	10.6	15.7	19.9	22.7	22.5	18.9		28.1

Product selection

Output flow rate in ³ /min				Pump series	Motor size hp	Relief Valve adjustment range max. psi	Sound level dBA
100 psi	700 psi	3000 psi	5000 psi				
350	305	63	60	ZW4	1.0	1,000-5,000	75
650	602	123	120	ZW5	1.5	1,000-5,000	75

Filtration: 25 micron

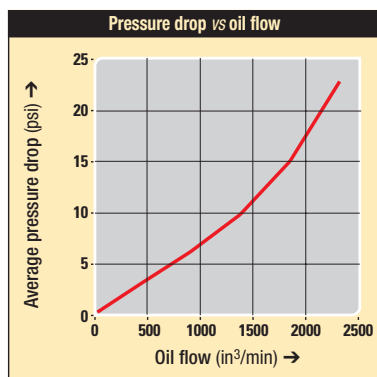
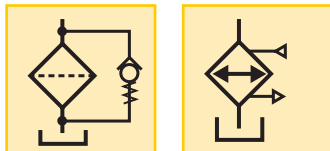
Pressure: max. 200 psi

Max. flow: 12.0 GPM

E Filtro

F Filtre

D Filter



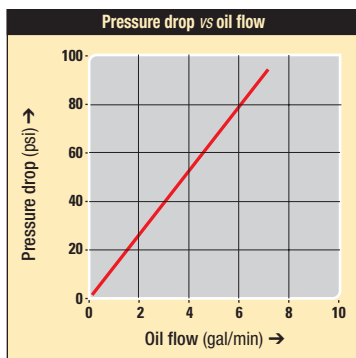
Product selection

Nominal filtration	Model number	Maximum pressure	Maximum oil flow	Bypass pressure setting	Filter gauge service indicator	
micron		psi	gpm	psi		lbs
25	ZPF	200	12.0	25	✓	3.2

Transfer: 900 Btu/h

Pressure: max. 300 psi

Voltage: 24V



Product selection

Voltage	Model number	Thermal transfer*	Amperage draw	Maximum pressure	Maximum oil flow	
		Btu/h kJoule	A	psi	gpm	lbs
24 VDC	ZHE-E10	900 950	.95	300	7.0	9.0

*At 0.5 g/min and ambient temperature of 70° F.

Extend life of hydraulic components

...increase system reliability

- 25 micron nominal filter cleans oil to increase system life
- Internal bypass valve to prevent damage if the filter is dirty
- All installation components included
- Kit assembles quickly and easily to Enerpac pump and manifold
- Maintenance indicator included

Extends system life

- Electrical connector factory installed
- All installation components included
- Stabilizes oil temperature at a maximum of 130° F at 70° F ambient temperature
- Stabilizes oil viscosity, increasing oil life and reduces wear of pump and other hydraulic components

Shown: ZPF



ZPF series

The oil filter kit removes contaminants from the return oil flow before allowing it back into the reservoir, reducing component damage.

Options

PF-25 replacement filter element



For best performance, replace filter element on a regular basis. Change filters when changing oil or four times a year, whichever comes first.

Shown: ZHE-E10



ZHE series

Heat exchanger removes heat from the return oil to provide cooler operation.

Shown: ZLS-U4



ZLS series

Oil level indicator for pump reservoir. If the pump is mounted in a remote area that does not provide visual access to the external oil level sight glass, the level/temp switch will turn off the pump before internal damage can occur due to cavitations.

Electronic level/temp switch for feedback on pump oil level

- Drop-in design allows for easy installation to pump reservoir
- Electrical connector included
- Built-in thermal sensing provides feedback on oil temperature
- Senses low oil level in pump reservoir

Temp. set point: 175 °F

Voltage: 24 VAC/DC

- (E) Indicador del nivel/temp.
- (F) Interrupteur de niveau/temp.
- (D) Ölstand/Temperaturschalter



Product Selection

Fixed temperature signal	Model number	Voltage	Thermostat rating setting	Maximum pressure	
°F			Amps	psi	lbs
175	ZLS-U4	24 VAC/DC	2.6	150	0.11

Shown: ZPT-U4, ZPS-W4



ZPT/ZPS series

ZPT pressure transducer provides constant pressure monitoring for automated pump control. ZPS pressure switch shuts down motor at set pressure.

Control your pump, monitor pressure

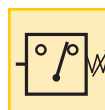
ZPT pressure transducer

- More durable than analog gauges (against mechanical and hydraulic shock)
- More accurate than analog gauges (0.5% full scale)
- Calibration can be fine tuned for certification
- “Auto-mode” provides automatic pressure make-up
- Display pressure in psi, bar or MPa

Pressure: 50-10,000 psi

Voltage: 24 VAC/DC

- (E) Presión transductor
- (F) Pressostats
- (D) Druckschalter



Product Selection

Adjustable pressure range	Electrical specification	Model number	Accuracy (full scale)	Deadband	
psi				psi	lbs
▼ Mechanical adjustment					
50-10,000	4-20 mA	ZPT-U4	0.5%	50	0.3
500-10,000	24 VAC/DC N.O.	ZPS-W4	2%	115-550	2.7

Note: Electrical harness included with kit. ZPS-W4 includes 0-6000 psi pressure gauge.

! Importante

The pressure transducer is factory installed in the “A” port on pumps supplied with valves, and in the “P” port on models with manifolds.

Pressure: 5000 psi

Stations: 1-4 valves horizontal

Stations: 1-8 valves vertical

- E** Colectores
- F** Manifolds
- D** Verkettungsblöcke

Increased flexibility for complex systems

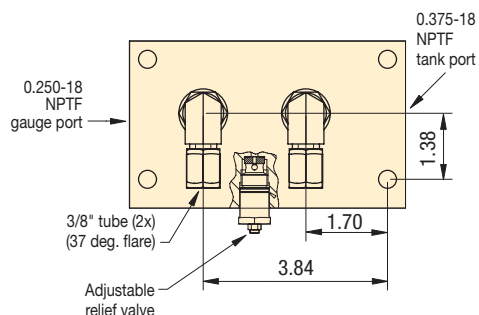
- Manifolds provide hydraulic connection to remote or pump mounted valves
- Used when multiple valves are required for controlling several independent circuits
- Available for 2 and 4 station DO3 as well as Enerpac VP series mounting
- Pressure and tank porting manifold available for use with remote valve sticks
- Manifolds include integrated relief valve for system pressure control

Shown: MB-2, -4

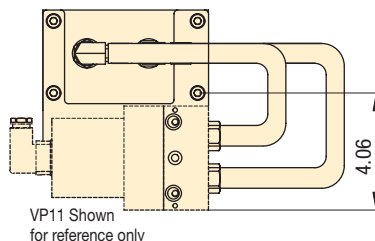


Manifolds allow the use of multiple valves powered by a single hydraulic pump. Manifolds are available factory installed on your Z-Class workholding power unit, or separately for future system upgrades.

Option 01



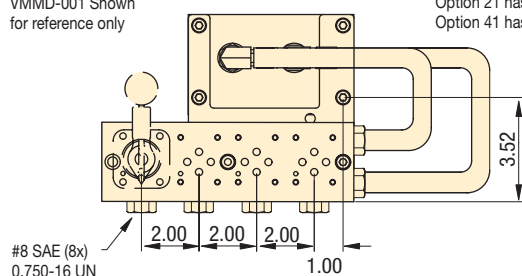
Option 02



Option 21, 41

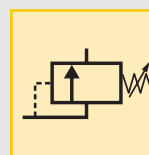
VMMD-001 Shown for reference only

Option 21 has two valve stations
Option 41 has four valve stations



Product Selection

Valve mounting pattern	Option code (see page 106)	Number of stations	Coverplate model number
Porting manifold, SAE ports	01	—	—
Enerpac VP Series	12	1-8	—
2 station DO3	21	2	MC-1
4 station DO3	41	4	MC-1



Options

Pressure transducer

98 ▶



Level switch

98 ▶



■ Enerpac porting manifold provides pressure and tank line to remote mounted valve stack on a machining center.



Pallet de-coupling pumps *Application & selection*

Shown: ZW4420DB-FT



▶ The new Enerpac Pallet De-Coupling Pump provides three modes of operation:

Manual mode

Pump runs as long as operator holds down pendant button.

AUTO mode *without timer*

Pump runs until user-adjustable pressure setting is reached.

AUTO mode *with timer*

Pump runs until pressure setting is reached, and adjustable timer runs out.

■ **ZW5410DB-FT** used to connect and disconnect a palletized fixture.

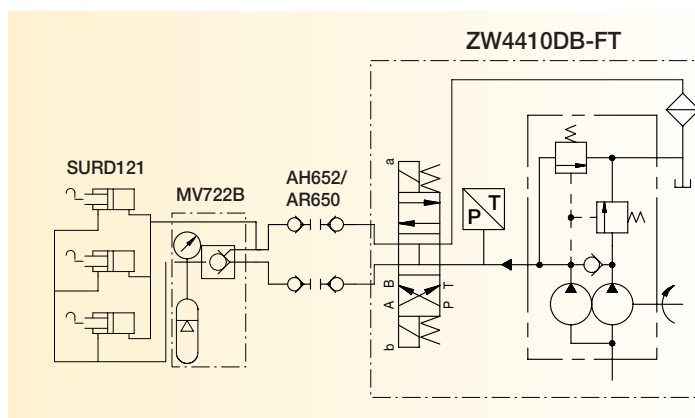


Automatic pressure control for palletized fixtures

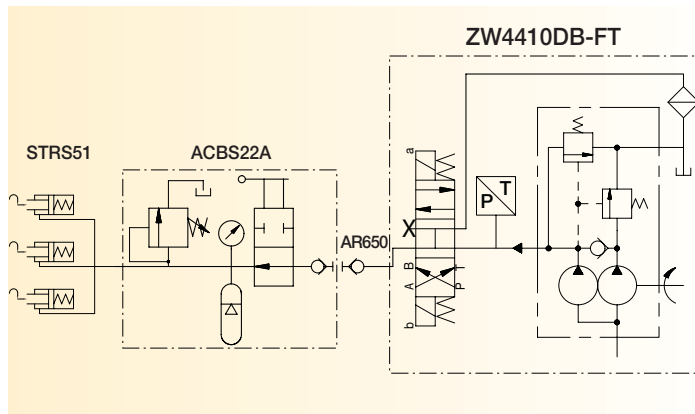
- Programmable clamp and unclamp pressure settings increase automation capability
- Programmable dwell settings ensure desired pressure level is maintained on large circuits or circuits with accumulators
- Low-voltage pendant features sealed switches and operates at 15 VDC for improved operator safety
- Backlit LCD provides pump usage information, hour and cycle counts

Example Circuits

- Double-acting circuit



- Single-acting circuit



Product selection

Output flow rate @ max. pressure	Motor size	Motor voltage	Model number	Pressure range	Sound level	Usable oil capacity	
in ³ /min	hp			psi	dBA	gal	lbs
60	1.0	115-1-60	ZW4410DB-FT	1000-5000	75	2.5	120
		230-3-60	ZW4410DG-FT				
		460-3-60	ZW4410DJ-FT				
120	1.5	115-1-60	ZW5410DB-FT	1000-5000	75	2.5	130
		230-3-60	ZW5410DG-FT				
		460-3-60	ZW5410DJ-FT				



- Efficient design reduces heat generation and power consumption
- Balanced pump section reduces vibration improving durability and sound levels
- Low-voltage pendant with sealed switches improves operator safety
- Available in wide variety of reservoirs sized from 1 to 10 gallons
- Extensive list of accessories including
 - Heat exchanger
 - Roll-bars
 - Pressure transducer
 - Level and temperature switches

Operation – pallet de-coupling pump

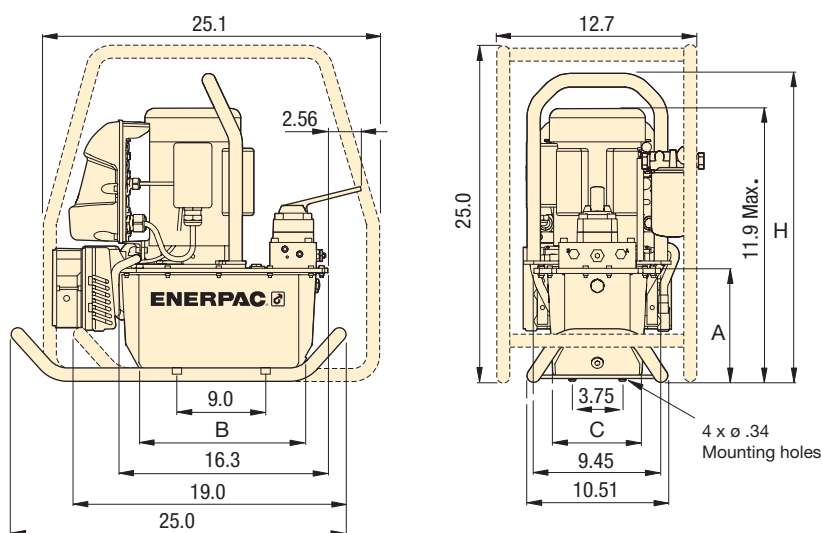
Manual mode

Motor and pump operate only when operator presses and holds the up (or down) arrow on the pendant. When button is released, pressure in the hoses is relieved.

AUTO mode

With DWELL timer set equal to zero, operator starts the motor by pressing and holding the up (or down) arrow on the pendant. Pump builds to pressure on the clamp (or unclamp) circuit until it reaches customer programmed setting. The motor immediately turns off and pressure in the hoses is relieved.

With DWELL timer set greater than zero, operator starts the motor by pressing the up (or down) arrow on the pendant. Once the pump reaches the programmed setting, the DWELL timer starts. When the timer runs out, the motor stops and pressure in the hoses is relieved.



ZW-Series Pumps with 1- and 2-gallon reservoir

Product dimensions in inches []

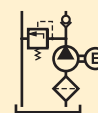
Usable oil capacity	Model number	A	B	C	H	 lbs	
gal						ZW4	ZW5
1.0	ZWxx04xx	5.6	11.0	6.0	20.2	86	96
2.0	ZWxx08xx	8.1	11.0	8.1	22.6	93	103

Flow: 60-120 in³/min

Pressure: 5000 psi max

Motor: 1.0 or 1.5 hp

Reservoir: 1.0-10 gal



Important

Enerpac recommends a pressure differential of no less than 200 psi for most applications. If you believe your application requires a tighter differential, please contact us directly.

Options

Heat exchanger

 97 ▶



Level switch

 98 ▶



Pressure transducer

 98 ▶



Return line filter

 97 ▶



Important

For complete ordering matrix of all factory-installed options visit www.enerpac.com

Continuous connection pumps *Application & selection*

Shown: ZW4420FB-FT



▶ The new Enerpac Continuous Connection Pump provides two modes of operation:

Manual mode

Pump runs continuously, building pressure as long as operator holds down pendant button.

AUTO mode

Pump runs continuously, maintaining user-set pressure window on clamp circuit as long as necessary.

■ **ZW5410FB-FT** used to control clamping cycle on a horizontal machining center.

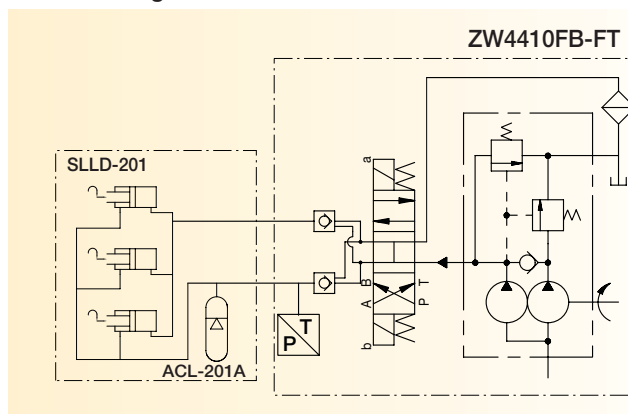


Automatic pressure control for continuous connection fixtures

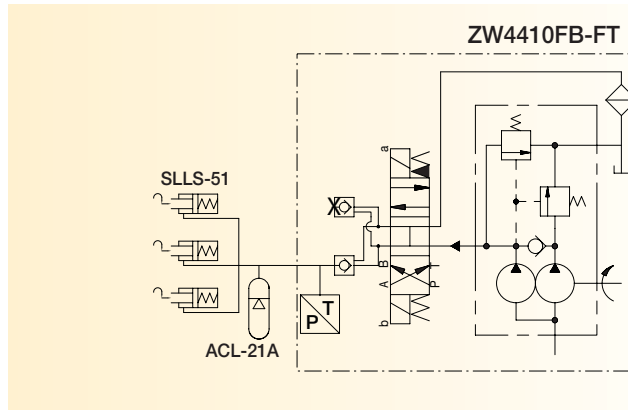
- Programmable pressure setting allows pump to maintain system pressure continuously
- Includes pilot operated check valve ensuring pressure is maintained in circuit
- Z-Class high-efficiency pump design; featuring higher oil flow and by-pass pressure than comparable pumps
- High-strength, molded electrical enclosure protects electronics, power supplies and LCD readout from harsh industrial environments

Example Circuits

- Double-acting circuit



- Single-acting circuit

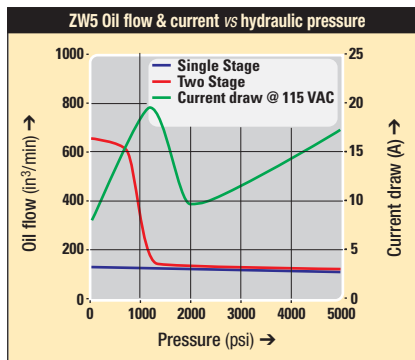
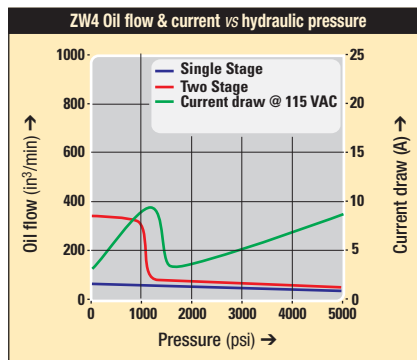


Product selection

Output flow rate @max pressure	Motor size	Motor voltage	Model number	Pressure range	Sound level	Usable oil capacity	
in ³ /min	hp			psi	dBA	gal	lbs
60	1.0	115-1-60	ZW4410FB-FT	1000-5000	75	2.5	125
		230-3-60	ZW4410FG-FT				
		460-3-60	ZW4410FJ-FT				
120	1.5	115-1-60	ZW5410FB-FT	1000-5000	75	2.5	135
		230-3-60	ZW5410FG-FT				
		460-3-60	ZW5410FJ-FT				



Output oil flow and current draw



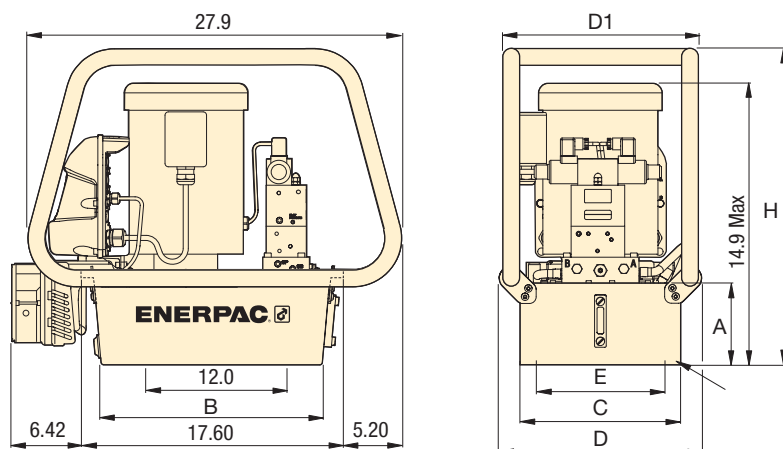
Operation – continuous connection pump

Manual mode

The operator turns the pump motor on, and then presses and holds the up arrow on the pendant. When the button is released, the valve shifts to neutral, but pressure is maintained in the clamp circuit by the pilot-operated check valve. When the operator presses and holds the down arrow on the pendant, pressure in the clamp circuit will release, and the fixture will unclamp.

AUTO mode

The operator turns the pump motor on, and then presses and holds the up arrow on the pendant. When the customer-programmed HI PRESS setting is reached, the valve shifts to neutral, but pressure is maintained in the clamp circuit by the pilot-operated check valve. If pressure drops below the LO PRESS setting, the valve will re-activate and build pressure in the clamp circuit again. The pump will maintain this cycle until the operator presses and holds the down arrow on the pendant. When the down arrow is pressed, pressure in the clamp circuit will release, and the fixture will unclamp.



ZW-Series Pumps with 2.5, 5, 10 gallon reservoir

Product dimensions in inches []

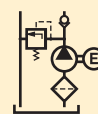
Usable oil capacity	Model number	A	B	C	D	D1	E	H	lbs	
gal									ZW4	ZW5
2.5	ZWxx10xx	6.1	16.5	12.0	15.1	14.6	11.0	23.6	107	115
5.0	ZWxx20xx	7.1	16.5	16.6	19.7	19.2	15.6	24.6	134	142
10.0	ZWxx40xx	10.6	15.7	19.9	22.7	22.5	18.9	28.1	184	192

Flow: 60-120 in³/min

Pressure: 5000 psi max

Motor: 1.0 or 1.5 hp

Reservoir: 1.0-10 gal



Important

Enerpac recommends a pressure differential of no less than 200 psi for most applications. If you believe your application requires a tighter differential, please contact us directly.

Options

Heat exchanger

97 ▶



Level switch

98 ▶



Pressure transducer

98 ▶



Return line filter

97 ▶



Important

For complete ordering matrix of all factory-installed options visit www.enerpac.com

Shown: ZW4020HB-FT21 with VET-11 valve



▶ Pump accepts any industry standard DO3 style directional valve. Also available with 2 station and 4 station manifolds.

⚠ Important

Be aware of leakage rates of any valve installed on an Enerpac pump. Many standard spool valves have excessive leakage rates at higher pressures that can limit the performance of the electric pump. Be sure to consult Enerpac if you are unsure of your choice of valve.

■ ZW5020HB-F11 with customer installed valve used to provide pressure to a clamping fixture.



Industry standard mounting for electric or manual valves

- Highly efficient design provides increased flow rates, reduced heat generation and a decrease in power consumption
- Extensive list of accessories including
 - Heat exchanger
 - Roll-bars
 - Pressure transducer
 - Level and temperature switches
- Replaceable piston check-valves increase service life of major pump components
- Optional backlit LCD provides pump usage information, hour and cycle counts
- Also available with 2 station and 4 station manifolds

i Operation – single station DO3 pumps

The Single Station DO3 pumps are supplied without the standard LCD electrical control. This configuration is intended to be used with user supplied controls. Control requirements include: Motor Starter or Contactor, and remote control of the pump mounted valve. Typical applications include: Special Machines and CNC Machines where the control of the pump and valve will be done by PLC or machine control.

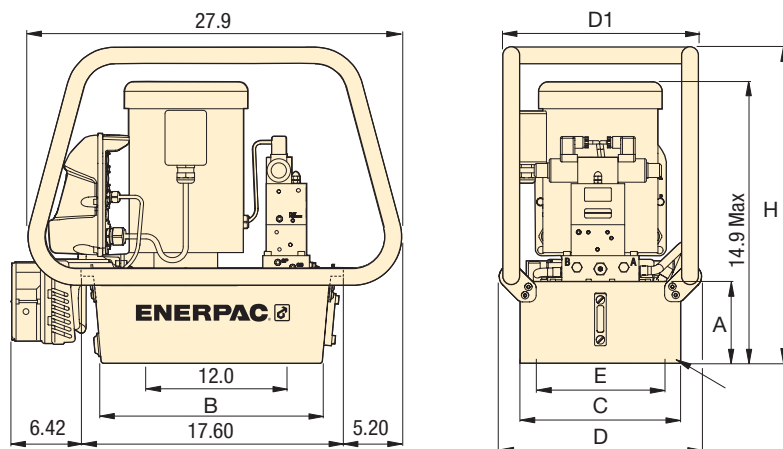
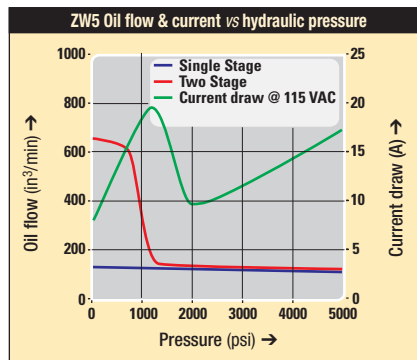
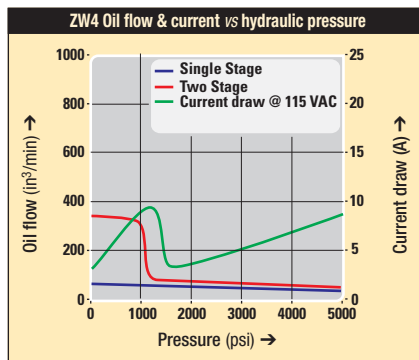
The use of the ZPF Return Line Filter is recommended. If the pump is to be run at pressure at a relief valve setting, the ZHE-E10 Heat Exchanger is also recommended. For monitoring of the oil level and temperature, use the ZLS-U4 Level/Temp Switch. For pump shutdown at pressure, the ZPS-W4 Pressure Switch Kit can provide an input to the customer supplied controls. As these accessories are designed to be used with the standard Enerpac LCD control, the customer assumes responsibility to adapt the standard leads to their controls.

g Product selection

Output flow rate @ max pressure	Motor size	Motor voltage	Model number	Pressure range	Sound level	Usable oil capacity	
in ³ /min	CV			psi	dBA	gal	lbs
60	1.0	115-1-60	ZW4010GB-11	1000-5000	75	2.5	129
		230-3-60	ZW4010GG-11				
		460-3-60	ZW4010GJ-11				
120	1.5	115-1-60	ZW5010GB-FT	1000-5000	75	2.5	137
		230-3-60	ZW5410FG-FT				
		460-3-60	ZW5410FJ-FT				



Output oil flow and current draw



ZW-Series Pumps with 2.5, 5, 10 gallon reservoir

Product dimensions in inches []

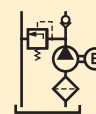
Usable oil capacity	Model number	A	B	C	D	D1	E	H	lbs	
gal									ZW4	ZW5
2.5	ZWxx10xx	6.1	16.5	12.0	15.1	14.6	11.0	23.6	107	115
5.0	ZWxx20xx	7.1	16.5	16.6	19.7	19.2	15.6	24.6	134	142
10.0	ZWxx40xx	10.6	15.7	19.9	22.7	22.5	18.9	28.1	184	192

Flow: 60-120 in³/min

Pressure: 5000 psi max

Motor: 1.0 or 1.5 hp

Reservoir: 1.0-10 gallon



Important

Enerpac recommends a pressure differential of no less than 200 psi for most applications. If you believe your application requires a tighter differential, please contact us directly.

Options

Heat exchanger

☐ 97 ▶



Level switch

☐ 98 ▶



Pressure transducer

☐ 98 ▶



Return-line filter

☐ 97 ▶



VSS, VST solenoid valves

☐ 126 ▶



VMM series manual valves

☐ 127 ▶



Important

For complete ordering matrix of all factory-installed options visit www.enerpac.com

ZW Electric Pump ordering matrix

Swing cylinders
Work supports

Linear cylinders

Power Sources

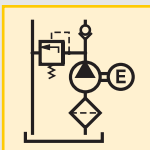
Flow: 60-120 in³/min

Pressure: 5000 psi max

Motor: 1.0 & 1.5 hp

Reservoir: 2.5-10 gal.

- E** Bombas eléctricas
- F** Centrale hydraulique
- D** Modulare Spannpumpe



Example

ZW4020GB-FGS21 is a 60 in³/min, single-stage pump with a 2 station D03 manifold, standard electric, 5 gallon reservoir, 115 volt, 50/60 Hz motor, return line filter and 0-6000 psi pressure gauge.

ZW4410DJ-T is a 60 in³/min, 2-stage pump with a pallet de-coupling valve, LCD electrical box, 2.5 gallon reservoir, 460-480 volt 3-phase motor and pressure transducer.

ZW5040HJ-FGL01 is a 120 in³/min, 2-stage pump with a SAE porting manifold, LCD electrical box, 10 gallon reservoir, 460-480 volt 3-phase motor, return line filter, 0-6000 psi pressure gauge and level and temperature shutdown switch.



Custom build your pump

▼ This is how a ZW series Model number is built:

Z	W	4	0	20	H	G	-FG	01
1	2	3	4	5	6	7	8	9
Product Type	Motor Type	Flow Group	Valve Type	Usable Oil Capacity	Valve Operation	Voltage	Options	Manifold Options

1 Product type

Z = Z-Class Pump

2 Motor type

W = Workholding Electric

3 Flow group

4 = 60 in³/min
5 = 120 in³/min

4 Valve type

0 = No valve or valve manifold
2 = 3-way, 2-position, manual valve
3 = 3-way, 3-position, manual valve
4 = 4-way, 3-position, manual or solenoid valve
6 = 3-way, 3-position, tandem center w/P.O. check (manual only)
8 = 4-way, 3-position, tandem center w/P.O. check (manual only)

5 Usable oil capacity

10 = 10 Liters (2.5 gallon)
20 = 20 Liters (5 gallon)
40 = 40 Liters (10 gallon)

6 Valve operation

D = Solenoid valve (pallet de-coupling) with pendant and LCD (valve type **4**)
F = Solenoid valve (continuous connection) with pendant and LCD (valve type **4**)
G = Valve manifold without LCD (valve type **0**)
H = Valve manifold with LCD (valve type **0**)
L = Manual valve with LCD (without pendant, valve type **2, 3, 4, 6** or **8**)
M = Manual valve without LCD (valve type **2, 3, 4, 6** or **8**)
N = No valve, without LCD (valve type **0**)
W = No valve with LCD (valve type **0**)

7 Power supply

Single Phase
B = 115V, 1 ph, 50-60 Hz³
E = 208-240V, 1 ph, 50-60 Hz European plug
I = 208-240V, 1 ph, 50-60 Hz USA plug
Three Phase
M = 190-200V, 3 ph, 50/60 Hz
G = 208-240V, 3 ph, 50/60 Hz
W = 380-415V, 3 ph, 50/60 Hz
K = 440V, 3 ph, 50/60 Hz
J = 460-480V, 3 ph, 50/60 Hz
R = 575V, 3 ph, 50/60 Hz

8 Options²

F = Return line filter, 25 micron
G = 0-6000 psi pressure gauge, 21/2"⁵
H = Heat exchanger⁴
L = Level/temperature switch⁴
N = No handles (lifting eyes only)²
P = Pressure switch⁴
R = Roll bars
S = Single stage
T = Pressure transducer⁴
U = Foot switch⁴

9 Manifold options⁵ (Pump types G and H only)

01 = SAE porting manifold
11 = Single station D03
12 = VP series manifold
21 = 2 station D03
41 = 4 station D03

*1 Options should be specified in alphabetical order.

*2 Unless specified, all pumps are supplied with reservoir handles.

*3 115 volt pumps are supplied with CE and CSA approved 15 amp plug for intermittent use. 20 A circuit recommended for frequent full pressure use.

*4 These options require LCD electrical package. Pressure switch option only available on manual valves without locking valve. The LCD electrical package can accept either a pressure switch or pressure transducer, but not both.

*5 Pressure gauge not available on pump models with pressure transducer. Pressure transducer provides digital pressure readout on LCD display.



Example

The **ZW5810LG-FT** is a 120 in³/min, 2-stage pump with a manual 4-way, 3 position tandem center valve, integrated P.O. check, LCD electrical box, 2.5 gallon reservoir, 208-240 volt 3-phase motor, return line filter and pressure transducer.

Customized to your application's requirements

- Custom-built power units and valve stacks provide the exact solution you need
- Ideal for control of multiple hydraulic circuits from one pump
- Designed and built to your specifications
- Available as electric or air-powered hydraulic pumps
- Remote or pump-mounted valve stacks

Select your pump type

Air operated pump

Best choice for small to medium circuits with intermittent duty requirements. Air operated pumps have lower flow rates than electric pumps, but are more economical.

 88-89 ▶



Electric operated pump

Best choice for large circuits with high duty requirements. Electric pumps have the highest flow rates and can be configured with many different options.

 94-95 ▶



Contact Enerpac to complete the design

Contact Enerpac at 1-800-433-2766 or at info@enerpac.com and ask to speak to one of our experienced application engineers. They will guide you through the power unit design process. Be prepared to provide answers to the following types of questions:

- What is the duty cycle requirement?
- How many circuits do you want to control?
- What clamping components are in each circuit?
- Do you need electrical controls provided by Enerpac?



Five Enerpac VP-series solenoid valves mounted to a ZW-series electric pump provide complex circuit control in a compact package.



A ZW-series pump, including an unloading circuit, designed to power four separate load stations in a machining center.



A custom PLC with push button controls and power unit to operate an Enerpac automatic coupler system.

Shown: WUD-1301B



▶ The Economy pump is best suited to power small to medium size fixtures. Its lightweight and compact design makes it ideal for applications which require easy transport of the pump. The universal motor works well on long extension cords.

Heavy on performance, light on weight

- Lightweight and compact design, 26 lbs
- Large easy-carry handle for maximum portability
- Two-speed operation reduces cycle times for improved productivity
- 115 VAC 50/60- or 220 VAC 50/60-cycle universal motor will operate on voltage as low as 60 volts
- 24 VDC remote motor control, 10-ft length for operator safety
- Starts under full load
- High strength molded shroud with integral handle, protects motor from contamination and damage
- Designed for intermittent duty cycle

WUD-1100 series

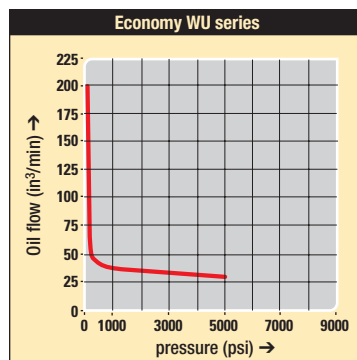
- Provides advance/auto-retract of single-acting cylinders
- 10-foot pendant controls motor and valve operation
- Use with AP500

WUD-1300 series

- Provides advance/hold/retract of single-acting cylinders
- 10-foot pendant controls motor and valve operation
- Ideal for applications requiring remote valve operation
- Use with ACBS22 or ACBS202

Product selection

Model number	Used with cylinder	Pressure rating (psi)	
		1st stage	2nd stage
WUD-1100B	single-acting	200	5,000
WUD-1100E	single-acting	200	5,000
WUD-1300B	single-acting	200	5,000
WUD-1300E	single-acting	200	5,000



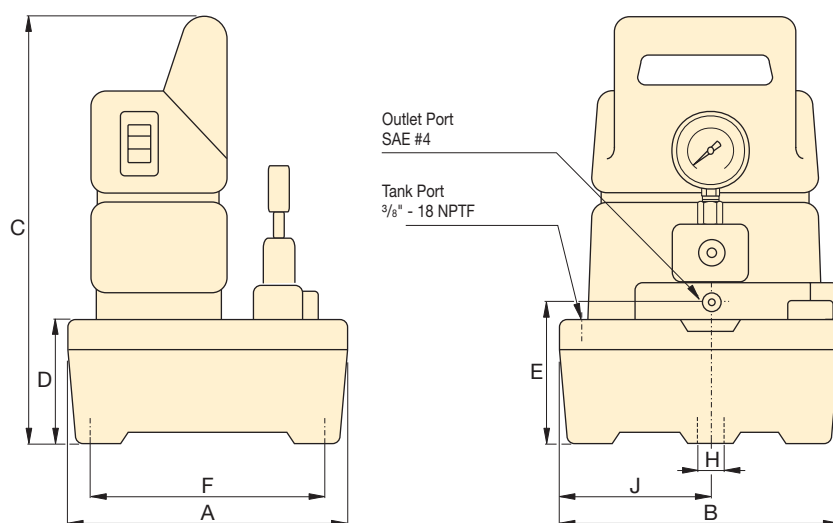
Flow: 25 in³/min

Pressure: 5000 psi max

Motor: .5 hp

Reservoir: 0.5-1 gallon

- E** Bombas eléctricas
- F** Centrale hydraulique
- D** Tauchpumpe



Product dimensions in inches []

Usable oil capacity	Model number	A	B	C	D	E	F	H	J	
gal										lbs
.50	WUD-1100B	9.62	9.62	14.25	4.00	4.72	8.00	.40	5.25	26
.50	WUD-1100E	9.62	9.62	14.25	4.00	4.72	8.00	.40	5.25	26
.50	WUD-1300B	9.62	9.62	14.25	4.00	4.72	8.00	.40	5.25	26
.50	WUD-1300E	9.62	9.62	14.25	4.00	4.72	8.00	.40	5.25	26

Standard equipment

Gauge, filter and pressure switch



Pumps are supplied with a manifold mounted 6000 psi gauge for convenient reading of pump pressure.

A filter at the pressure port helps to protect the pump from contamination.

A manifold mounted adjustable pressure switch provides control of the pump shut-off pressure.

Output flow rate in³/min		Valve type	Current draw amps	Motor voltage VAC	Sound level dBA	Model number
1st stage	2nd stage					
200	25	Dump*	9.5	115	85	WUD-1100B
200	25	Dump*	9.5	220	85	WUD-1100E
200	25	Dump and Hold	9.5	115	85	WUD-1300B
200	25	Dump and Hold	9.5	220	85	WUD-1300E

* Electric dump valve for auto-retract of cylinders.

Electric submerged pumps

Shown: WEM-1401B



WE series

Enerpac two stage electric submerged pumps are a quiet, economical workholding power source. Submerged in oil the motor stays cooler when used on an intermittent basis.

Best performance for mid-range cylinders

- Reduce cycle times for improved productivity
- Two-speed pump unit provides rapid cylinder advance
- Submerged dual voltage induction motor, runs cooler and quieter
- Available with heat exchanger for higher duty cycle applications
- Externally adjustable relief valve – no need to open pump when reducing pressure
- Reservoir mounting holes for easy mounting to fixed surface
- Full length side tube for easy monitoring of oil level
- Auxiliary return port, eliminates the need for a separate adapter

Product selection

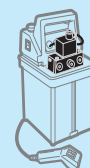
Motor voltage	Motor capacity	Amperage draw	Maximum oil flow at 60Hz in ³ /min		Pressure rating psi		Usable oil capacity	Adjustable relief valve	
50/60 Hz 1 ph	hp	A	1st stage	2nd stage	1st stage	2nd stage	gal	psi	lbs
115V-1ph	.50	13.5	150	40	1000	5000	1.5	1000 - 5000	63 ¹⁾
230V-1ph	.50	6.75	150	40	1000	5000	1.5	1000 - 5000	63 ¹⁾

¹⁾ Weight for WES and WET models is 83 lbs.

Select your pump type

WED-series with dump valve

- For use when load holding is not required
- Ideal for palletized workholding
- Motor is on only during work cycle



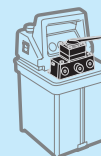
WEJ series with remote jog

- Manual valve control
- Motor can be turned on and off by remote pendant for jogging capability



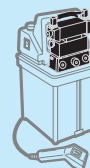
WEM series with manual valve

- Manual valve control
- Manual motor control
- Simple and economical solution to your workholding power source needs



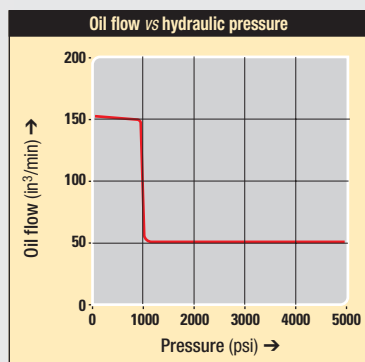
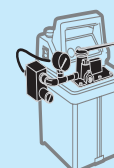
WER series with remote actuated solenoid

- Solenoid directional with shear seal design
- Remote valve operation



WES/WET series with pressure switch

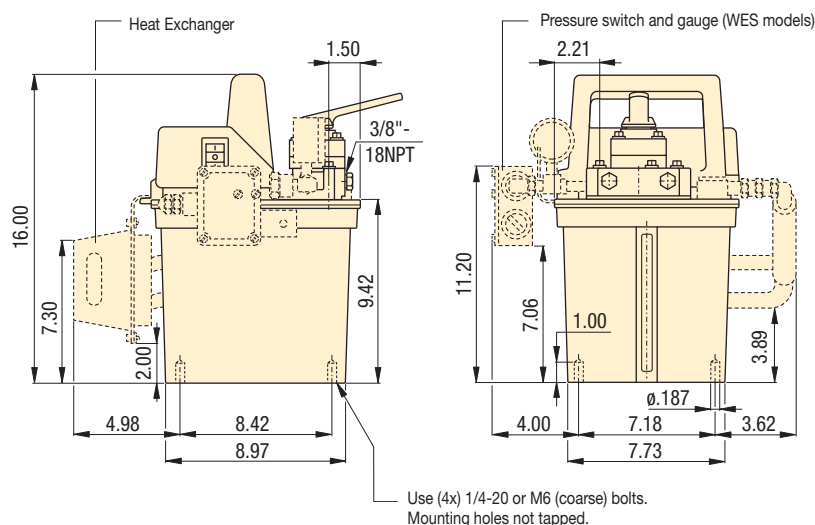
- Pressure switch turns motor on and off
- Used when pressure must be maintained over a period of time
- With pressure gauge



Pressure switch specifications: - Classification NEMA 1
 - Pressure range: IC-51: 3000-7500 psi
 IC-31: 500-3500 psi



WE-series submerged

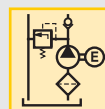
Flow: 40 in³/min

Pressure: 5,000 psi max

Motor: .5 hp

Reservoir: 1.5 gal

- E** Bombas eléctricas
F Centrale hydraulique
D Tauchpumpe



Options

G-series
pressure
gauges

154 ▶

FL-series
high-pressure
filters

157 ▶

FZ-series
fittings

158 ▶

HF-series
hydraulic oil

157 ▶



Important

Oil should be replaced every 500 working hours to ensure long life. Change filters when changing oil or 4 times a year whichever comes first.

Heat exchanger cools oil in pumps used in higher duty cycle applications.

Output flow rate should be matched to hydraulic components used in the system.

Used with cylinder	Valve function	Valve type	Model number	Motor voltage 50/60 Hz	Heat exchanger
Single-Acting	Advance / Retract	Dump	WED-1101B	115V	
Single-Acting	Advance / Retract	Dump	WED-1101E	230V	
Single-Acting	Advance / Retract	Jog	WEJ-1201B	115V	
Single-Acting	Adv. / Hold / Retr.	Jog	WEJ-1301B	115V	
Double-Acting	Adv. / Hold / Retr.	Jog	WEJ-1401B	115V	
Single-Acting	Advance / Retract	Manual 3/2	WEM-1201B	115V	●
Single-Acting	Advance / Retract	Manual 3/2	WEM-1201D	115V	
Single-Acting	Advance / Retract	Manual 3/2	WEM-1201E	230V	
Single-Acting	Advance / Retract	Manual 3/2	WEM-1201F	230V	●
Single-Acting	Adv. / Hold / Retr.	Manual 3/3	WEM-1301B	115V	
Single-Acting	Adv. / Hold / Retr.	Manual 3/3	WEM-1301F	230V	●
Double-Acting	Adv. / Hold / Retr.	Manual 4/3	WEM-1401D	115V	●
Double-Acting	Adv. / Hold / Retr.	Manual 4/3	WEM-1401E	230V	
Single-Acting	Adv. / Hold / Retr.	Solenoid	WER-1301B	115V	
Single-Acting	Adv. / Hold / Retr.	Solenoid	WER-1301D	115V	●
Single-Acting	Adv. / Hold / Retr.	Solenoid	WER-1301E	230V	
Double-Acting	Adv. / Hold / Retr.	Solenoid	WER-1401B	115V	
Double-Acting	Adv. / Hold / Retr.	Solenoid	WER-1401D	115V	●
Double-Acting	Adv. / Hold / Retr.	Solenoid	WER-1401F	230V	●
Single-Acting	Advance / Retract	Manual 3/2	WES-1201B	115V	
Single-Acting	Advance / Retract	Manual 3/2	WET-1201B	115V	
Single-Acting	Adv. / Hold / Retr.	Manual 3/3	WES-1301B	115V	
Single-Acting	Adv. / Hold / Retr.	Manual 3/3	WES-1301E	230V	
Double-Acting	Adv. / Hold / Retr.	Manual 4/3	WES-1401B	115V	
Double-Acting	Adv. / Hold / Retr.	Manual 4/3	WES-1401E	230V	

Shown: WEM-1401B



WER series

Enerpac submerged motor pumps are available in a wide range of configurations to fit any requirement.

Important

WER series pumps use the VE-series valves shown on page 109. WER-13 series uses VEF-series valve. WER-14 series uses VEC-series valve.

WES series pumps use IC-51 pressure switch, adjustable from 3000-7500 psi.

WET series pumps use IC-31 pressure switch, adjustable from 500-3500 psi.



Custom build your submerged pump

▼ This is how a submerged pump model number is built up:

If the submerged pump that would best fit your application cannot be found in the chart on pages 110-111, you can easily build your custom submerged pump here.

W	E	M	-	1	3	01	B
1	2	3		4	5	6	7
Product Type	Motor Type	Pump Type		Pump Series	Valve Type	Res. Capacity	Motor Voltage

1 Product Type

W = Workholding Pump

2 Motor Type

E = Electric motor

3 Pump Type

D = Dump

J = Jog

M = Manual

R = Remote (solenoid)

S = Pressure switch (IC-51)

T = Pressure switch (IC-31)

4 Pump Series

1 = .5 hp 10,000 psi

5 Valve Type

0 = No valve (WER only)

1 = Dump

2 = 3-way, 2-position, normally open

3 = 3-way, 3-position, tandem center

4 = 4-way, 3-position, tandem center

5 = Custom VE-series valve (WER only)
See example 2 below.

6 Reservoir Capacity

01 = 1.5 gallon

7 Motor Voltage and Heat Exchanger

B = 115 V, 1 Ph, 50/60 Hz

D = 115 V, 1 Ph, 50/60 Hz
with heat exchanger

E = 230 V, 1 Ph, 50/60 Hz

F = 230 V, 1 Ph, 50/60 Hz
with heat exchanger

I = 230 V, 1 Ph, 60 Hz*

* To order WER models, for 60 Hz applications, replace the "E" suffix for "I".

Ordering example 1



Examples

Model number:
WER-1301B

The **WER-1301B** is a .5 hp, 5,000 psi, submerged electric pump, with 1.5 gallon usable oil capacity, a 3-way, 3-position modular, remote solenoid valve (VEF-series) and a 115 V, 1 Phase, 50/60 Hz motor.

Ordering example 2

Model number:
WER-1501B-VED15000D

The **WER-1501B** is a .5 hp, 5,000 psi, submerged electric pump, with 1.5 gallon usable oil capacity. The valve, model **VED15000D** is a 115 V, 60 Hz solenoid valve. (For details and options for all VE-series valves see page 128.)

Flow: .055-.250 in³/stroke

Pressure: 3000-10,000 psi

Reservoir: 6.2-55 in³

E Bombas manuales

F Pompes à main

D Handpumpen



Options

Fittings

157 ▶



Hoses

156 ▶



Hydraulic oil

157 ▶



Important

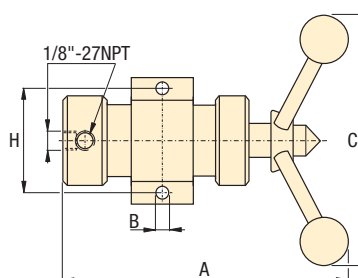
P-141, P-142 and P-202 are designed for a maximum operating pressure of 10,000 psi.

Exclusively from Enerpac

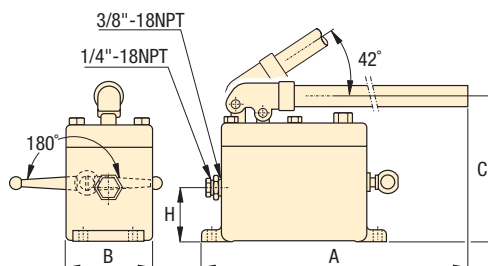
...to power single-acting cylinders

- Internal pressure relief valve (except SP-621) prevents over-pressurization
- Two speed operation reduces handle strokes by as much as 78% over single speed pumps
- Low handle effort minimizes operator fatigue
- Compact size – enables easy conversion of manual fixtures to hydraulic power

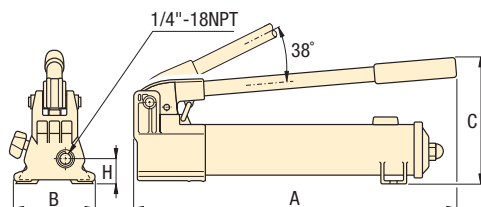
SP-621



P-51



P-141, -142, -202



Product selection

Maximum hydraulic pressure	Usable oil capacity	Model number	Pressure rating		Oil volume per stroke		Piston stroke	Maximum handle effort	Dimensions in inches					
			psi		in³				A	B	C	H		
			1st stage	2nd stage	1st stage	2nd stage							lbs	
psi	in³						in	lbs					lbs	
▼ Single speed														
3000	6.2	SP-621	–	3000	–	1)	1)	60 2)	10.10	.41	12.40	2.81	7.0	
3000	50	P-51	–	3000	–	.25	1.00	61	26.00	3.63	6.31	2.25	12.0	
10,000	20	P-141	–	10,000	–	.055	.50	72	13.25	3.75	5.63	1.13	4.5	
▼ Two speed														
10,000	20	P-142	200	10,000	.221	.055	.50	78	13.25	3.75	5.63	1.13	4.5	
10,000	55	P-202	200	10,000	.221	.055	.50	63	20.06	3.75	5.69	1.13	7.5	

1) Handle travel of SP-621 is 2.50 inches; 25 handle rotations displace 6.2 in³ of oil.

2) Handle effort on SP-621 is 60 ft.lbs at 3000 psi.

Shown: SP-621, P-51, P-142



P series

Single and two-speed hand operated pumps for operation of single-acting cylinders.

SP-621 Screw pump

Single speed non-vented, internally sealed screw pump to operate single-acting cylinders. Can be mounted in any position and used to operate a single fixture. The piston is screwed into the pump, forcing the oil in the hydraulic system.

Air hydraulic boosters *Application & selection*

Shown: AHB-46, B-5003, B-3006



AHB and B series boosters

Large effective area of air piston allows compressed air to generate high output hydraulic pressure.

For high production applications

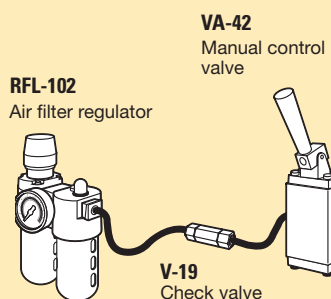
- High speed operation
- Extended service life
- Constant hydraulic output
- Large oil delivery per stroke allows quick filling of cylinders for clamping or punching

AHB series boosters

- Fiberglass wound air chamber eliminates possibility of rust due to moisture in air system
- Designed for fully automated production applications
- Double-acting, one-shot, high speed operation of air piston

B series boosters

- One-shot spring return
- Aluminum construction
- Built-in stroke sensor for automatic cycle operation
 - 30 VDC switch closes 1" before end of full air piston stroke
- Internal self-bleeding
 - Automatically purges air from system when booster piston is at highest point in circuit



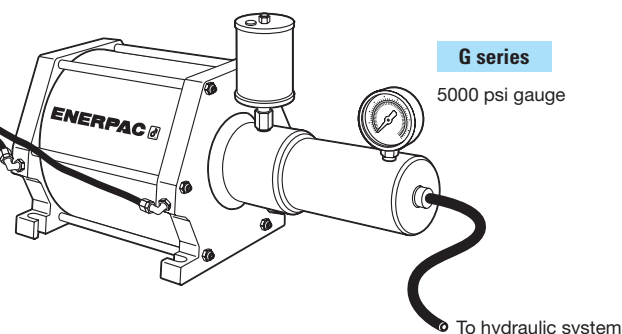
■ In an automated clamping set-up with both hydraulic and pneumatic components, AHB series boosters are used as a power source for the hydraulic system.

AHB series

Air hydraulic booster

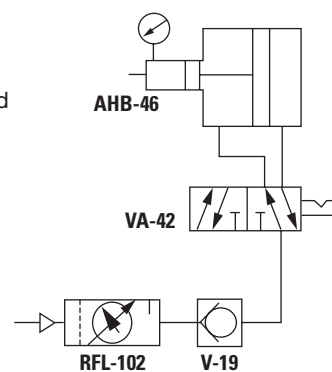
G series

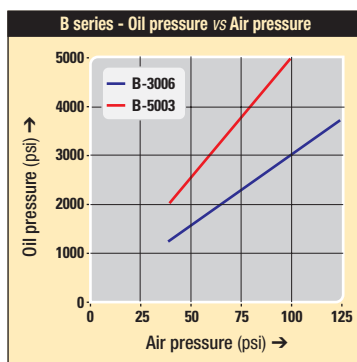
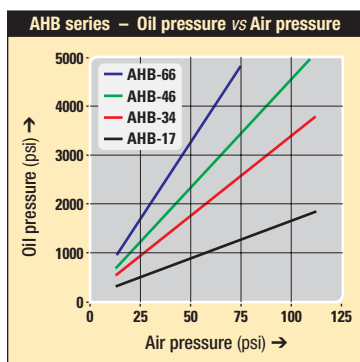
5000 psi gauge



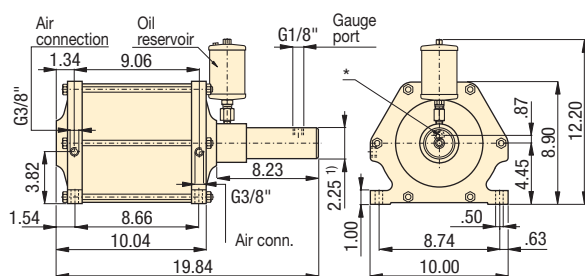
Hydraulic system schematics

Complete power systems eliminate the guesswork of selecting valves and other system components. Plug in your 15 to 115 psi shop air line and connect your hydraulic components for a total system.





AHB series



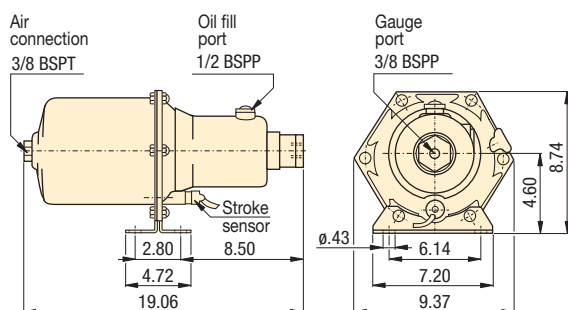
¹⁾ Ø 2.83" for model AHB-17

* Oil connection (G1/4")

*** Adapter to 3/8" NPT air connection is included.

NOTE: FZ-2060 Adaptor available for gauge port.

B series



Selection chart

Oil pressure psi		Oil volume per stroke	Air to oil pressure ratio	Model number	Air consumption per cycle ¹⁾	Air piston diameter	Hydraulic piston diameter	Hydraulic stroke	Air operating pressure	
at 75 psi air pressure	at 100 psi air pressure	in³			ft³ at 85 psi air	in	in	in	psi	lbs
▼ AHB series										
1200	1600	18.0	1:16	AHB-17	2.2	8.00	2.00	5.71	15-115	41.4
2550	3400	8.5	1:34	AHB-34	2.2	8.00	1.38	5.71	15-115	37.2
3450	4600	6.1	1:46	AHB-46	2.2	8.00	1.18	5.71	15-115	36.1
4800	–	4.5	1:64	AHB-66	2.2	8.00	1.00	5.71	15-75	35.4
▼ B series										
2250	3000	6.2	1:30	B-3006	.95	7.10	1.22	5.20	40-125	31.0
3750	5000	3.7	1:50	B-5003	.95	7.10	.94	5.20	40-125	31.0

¹⁾ One cycle = advance + retract stroke.

Note: Seal material: Buna-N, Polyurethane.

Ratio: 1:16-1:64

Pressure: 1600-5000 psi

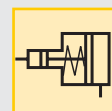
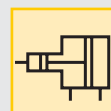
Oil flow: 3.7-18.0 in³/stroke

Air: .95-2.2 scfm/cycle

E Multiplicadores

F Multiplicateurs

D Druckübersetzer



Options

Air valves

142 ▶



Regulator-
filter-lubricator

142 ▶



Fittings

157 ▶



Important

Boosters can provide high oil flow rates based on the volume of in-coming air.

Do not exceed the flow rate requirements of the components being used.

For vertical mounting of booster, an elbow fitting is recommended for the oil reservoir.

Activator wand and booster

Shown: RA-1061, B81



B and RA series

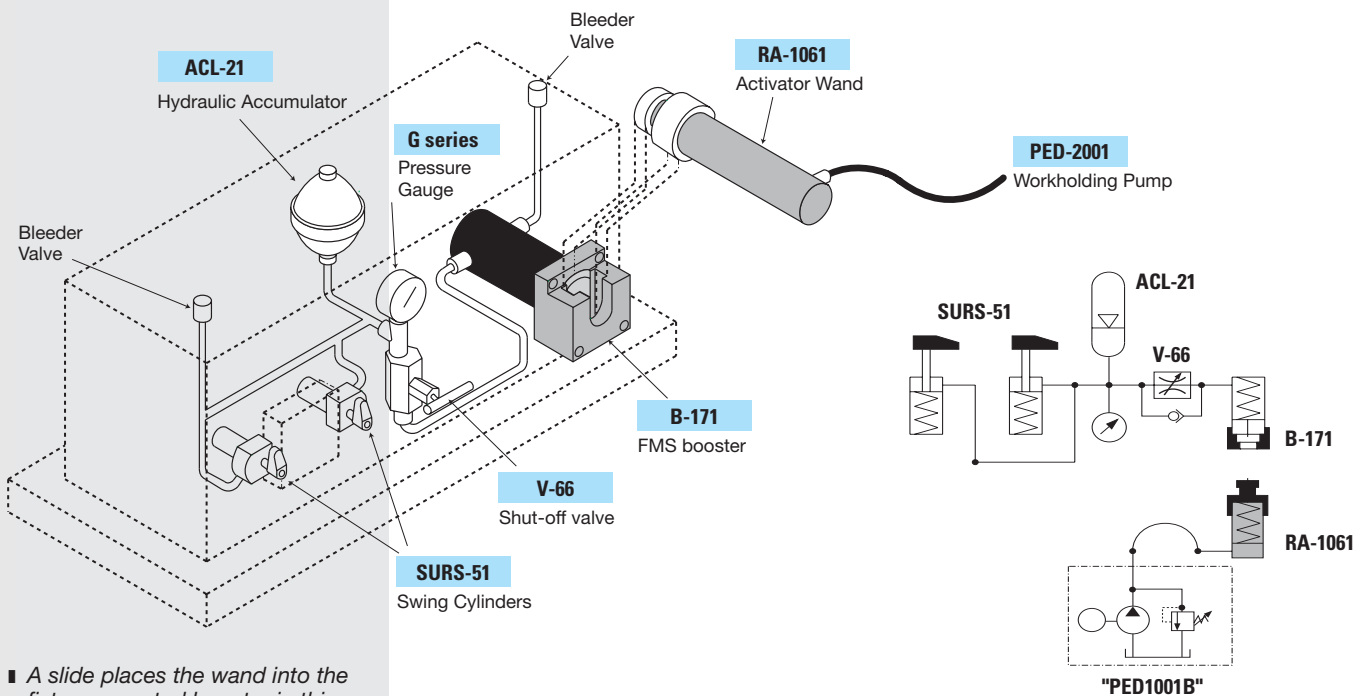
Mechanical energy transfer system uses external cylinder to operate receiver booster.

Contamination resistant closed hydraulic system

- No-leak palletized system, eliminates oil loss at connection point
- Closed design prevents machining chips and coolant from entering the hydraulic circuit
- Booster can be mounted in either horizontal or vertical position for flexible fixture design

Hydraulic system schematics

The Activator Wand **RA-1061** is placed into the receiver booster **B-81** or **B-171**. The mechanical transfer of force from the activator wand plunger to the booster piston provides oil flow to the system.

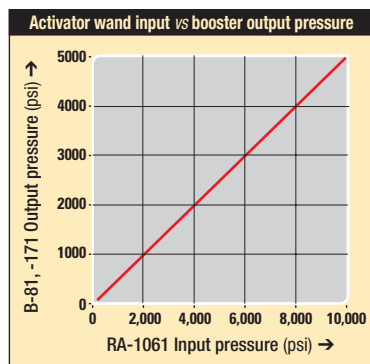


■ A slide places the wand into the fixture mounted booster in this automated application for machining castings.

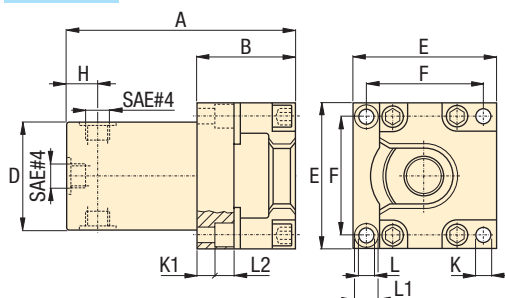


Product selection

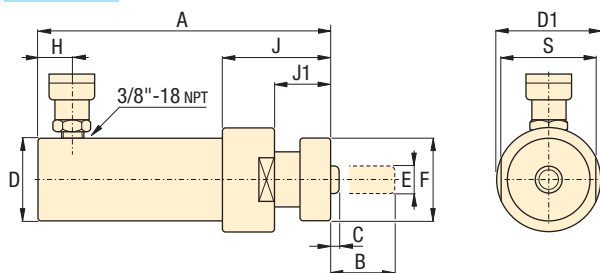
Pressure ratio	Oil flow ratio	Oil volume per stroke in ³	Stroke in	Model number	Effective area in ²	Operating pressure psi	Weight lbs
▼ Receiver booster							
2:1	1.75:1	8.10	2.04	B-81	3.98	400-5000	12.7
2:1	1.75:1	17.10	4.30	B-171	3.98	400-5000	15.7
▼ Activator wand							
—	—	9.90	4.44	RA-1061	2.23	800-10,000	11.3



B-81, -171



RA-1061



Product dimensions in inches []

Model number	A	B	C	D	D1	E	F	H	J	J1	K	K1	L	L1	L2	S
▼ Receiver booster																
B-81	6.86	2.74	1.74	3.00	—	4.00	3.25	1.12	—	—	.41	2.26	.41	.62	.42	—
B-171	9.12	2.74	1.74	3.00	—	4.00	3.25	1.12	—	—	.41	2.26	.41	.62	.42	—
▼ Activator wand																
RA-1061	11.62	4.63	.19	2.25	3.00	.75	2.32	.75	3.02	1.53	—	—	—	—	—	2.75

Ratio: 2:1

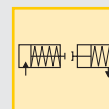
Stroke: 2.04-4.44 in

Pressure: 400-5000 psi

E Multiplicadores

F Multiplicateur

D Betätigungszyylinder und Druckverstärker



Options

Fittings

157 ▶



Hoses

156 ▶



For 10,000 psi pumps, refer to the Enerpac Industrial Tools Catalog E325.



Existing fixtures with manual-connect single-acting circuits can be easily upgraded into the wand and booster.

Important

The activator wand has a 2 to 1 ratio of input pressure versus output pressure.

The booster output flow is 1.75 times the wand input flow.

Mostrados: PID-401



PID series

When hydraulic pressure from an existing power source is limited, Enerpac oil-to-oil intensifiers serve to increase output pressure to satisfy the required application.

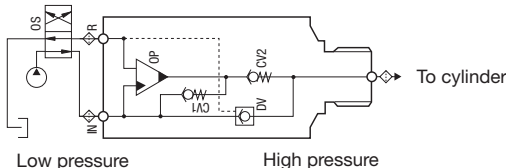
High flow units intensify low inlet oil pressure to high outlet pressure

- Internal bypass valving enables high output flow rates
- Wide range of intensification ratios allows for adapting to various operating pressure requirements
- Compact and self-contained design allows for ease of installation
- Include dump valve eliminating the need for an external pilot check valve
- Select fit of all internal components provides long operating life

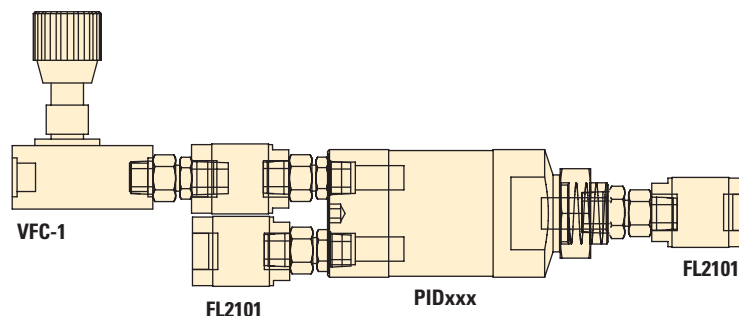
Intensifier principle

- When oil is supplied to the inlet (IN) port it flows freely past the check valves (CV) and the dump valve to the cylinder and advances it.
- As the inlet pressure increases the oscillating pump (OP) automatically increases the outlet pressure by the chosen intensification.
- Once the maximum pressure is reached, the pump frequency lowers and balances at the maximum pressure.
- Free flow from the cylinder to tank occurs when the directional control valve is switched to supply the R-port.
- 10 micron filtration is required on all ports in the circuit to ensure trouble free operation. Filters and flow control included.

PID Series



PID-xxxF intensifier



■ PID-Series intensifier utilizes low pressure machine hydraulics to power clamping cylinders.



Product selection

Maximum pressure	Pressure intensification ratio	Maximum input flow	Maximum output flow	Model number	Inlet pressure range	
psi		in ³ /min	in ³ /min	with dump valve	psi	lbs
10,000	1 : 3.2	610	150	PID-321F	300 - 1560	2.6
10,000	1 : 4.0	580	120	PID-401F	300 - 1250	2.6
10,000	1 : 5.0	550	95	PID-501F	300 - 1000	2.6
10,000	1 : 6.6	530	75	PID-661F	300 - 750	2.6

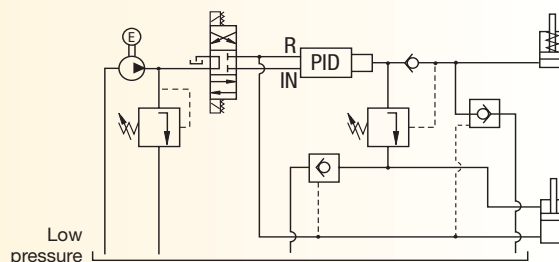
* Operating pressures above 5000 psi require high pressure fittings or intensifier models with BSPP ports. Contact Enerpac for details.



System set-up information:

With dump valve (PID models)

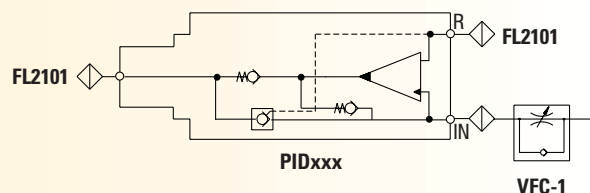
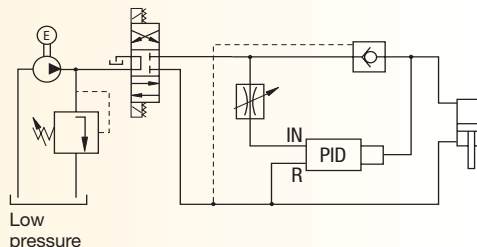
The intensifier with the dump valve is used to achieve high pressure on the advance side of a double-acting cylinder.



With external dump valve

In a circulating system where the pump's oil flow is higher than the maximum inlet oil flow of the intensifier, an external check valve and flow control valve reduces the pump's oil flow.

This application can be set up when machines are equipped with low pressure hydraulics but the pressure to clamp the workpiece must be higher.



Ratio: 1:3.2-1:6.6

Flow: 75-150 in³/min

Pressure: 960-10,000 psi

E Multiplicadores

F Multiplicateur

D Öl-Öl Druckübersetzer



Options

**FL-series,
high-pressure
filters**

157



**Directional
valves**

142



**FZ-series
fittings**

157



Important

Do not exceed maximum allowable inlet pressure.

10 micron filtration is included to ensure trouble-free operation.

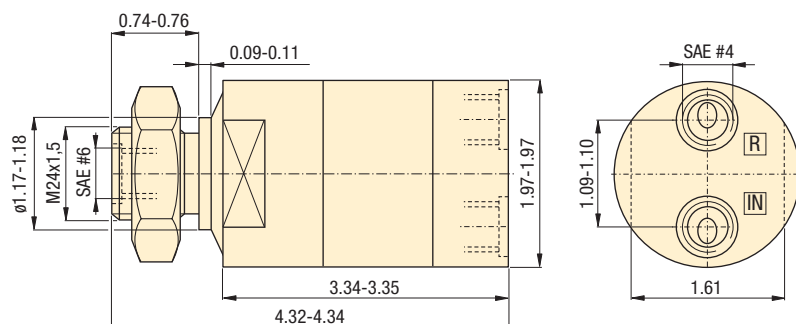
Applications above 5000 psi require high pressure fittings or intensifier models with BSPP ports. Contact Enerpac for details.

PID models with dump valve provide an economical means of relieving pressure from the system.

Can be panel mounted into machine (M24x1,5 thread).

Product dimensions in inches []

PID series



Valves

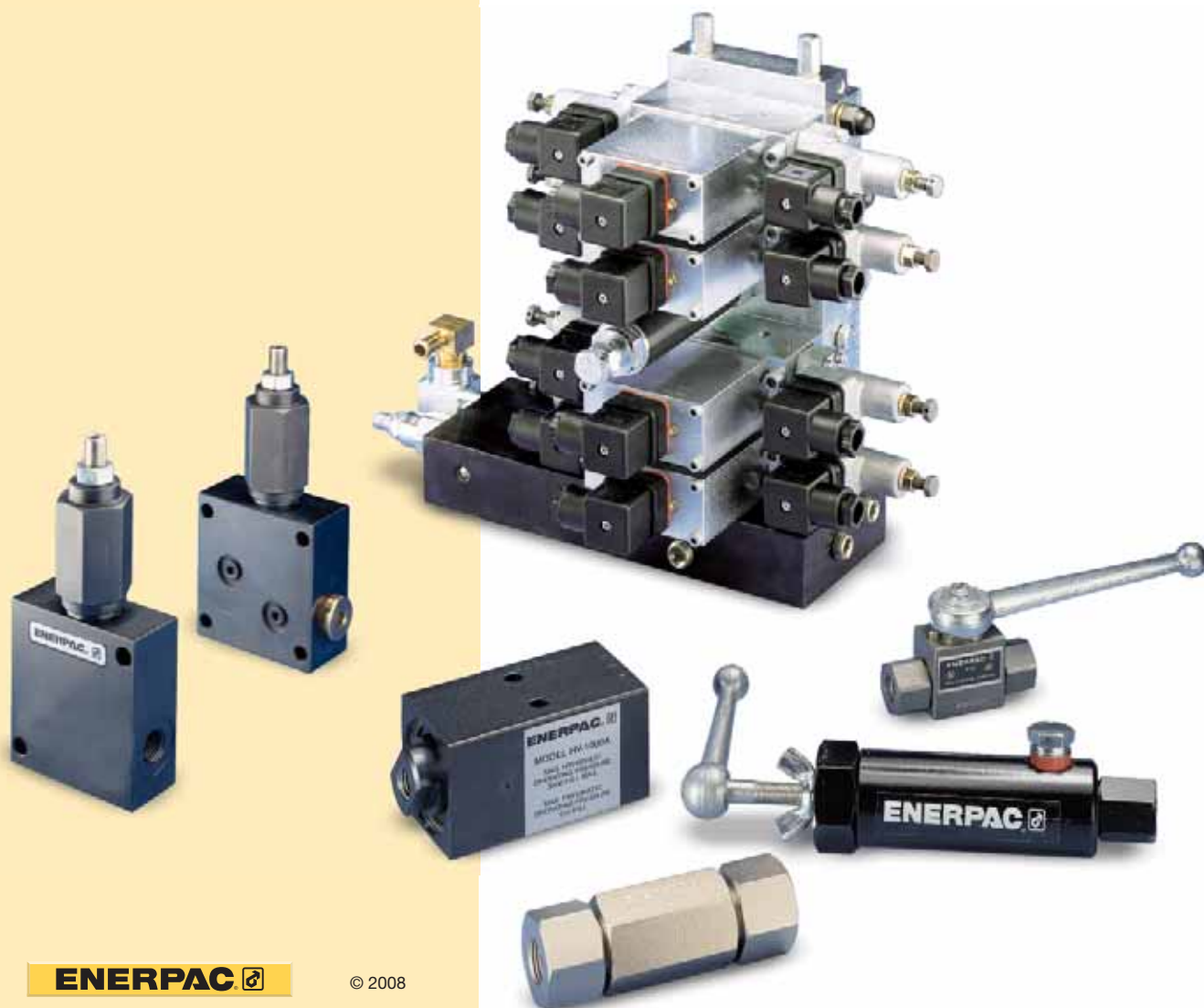
Technical support

Refer to the “Yellow Pages” of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

 161 ▶

Controlling the operation of your clamping system requires the use of many specialized directional, pressure and flow control valves. Enerpac has the complete line of valving components to complement any hydraulic system. Choose from either manual or electric directional valves, and a wide variety of pressure control, flow control and specialty valves to provide the control and automation that your application needs.



	▼ series	▼ page	
Modular directional valves	VP	122	
Pressure switches, Flow control valve	PSCK VFC	123	
Pressure reducing valve	PRV	124, 139	
Tie rod kits, Remote/porting manifolds	TRK WM/PB	125	
Solenoid valves, Inline check valve	VA, VS, VD	126	
4-Way manual control valves	VMM VMT	127	
DO3 Valves and accessories	VE	128	
Valve manifolds	MB	129	
Solenoid modular valves	VE	130 - 131	
3-Way directional manual control valves	V	132 - 133	
4-Way directional manual control valves	V	134 - 135	
Sequence valves	MVP WVP, V	136	
Pilot operated check valves	MV, V	137	
Flow control valves	VFC	138	
Accessory valves	MH, HV PLV, V	140 - 141	
Air valves and accessories	VA, VR RFL	142 - 143	

Shown: VP-12



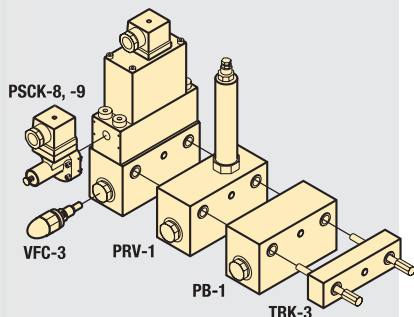
VP-series

Solenoid directional valves control the direction of the oil flow to each cylinder port.

Application

With the use of a -12 manifold, these valves allow quick and easy assembly of hydraulic control valves on your Enerpac ZW-series pump. For remote mounting of these valves use a WM-10 manifold.

VP-series



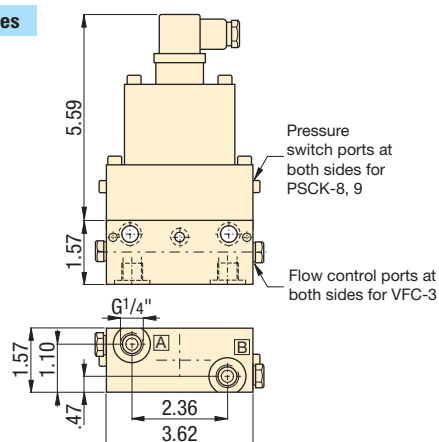
■ Enerpac VP-series valves mounted on -12 manifold, mounted on a ZW-series workholding pump.



Solenoid directional valves

- Dual poppet valve design for zero internal leakage
- Inlet check-valve standard
- High cycle switching
- Stackable to 8 valve stations high
- 250-5000 psi operational pressure
- Oil flow capacity 427 in³/min @ 5000 psi
- Oil flow capacity 915 in³/min @ 0 psi
- G1/4" oil connections and integrated filtration
- Multiple voltage options

VP series



Product selection

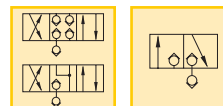
Voltage @ current	Model number	Flow path	Used with cylinder(s)
at 50/60 Hz			
▼ 4/3 Closed center			
24 VDC @ 1.13 A	VP-11		1x Dbl-act. / 2x Sgl-act.
110 VAC @ 500 mA	VP-12		1x Dbl-act. / 2x Sgl-act.
▼ 4/3 Float center			
24 VDC @ 1.13 A	VP-21		1x Dbl-act. / 2x Sgl-act.
110 VAC @ 500 mA	VP-22		1x Dbl-act. / 2x Sgl-act.
▼ 3/2 Normally closed			
24 VDC @ 1.13 A	VP-31		1x Dbl-act. / 2x Sgl-act.
110 VAC @ 500 mA	VP-32		1x Dbl-act. / 2x Sgl-act.
▼ 3/2 Normally open			
24 VDC @ 1.13 A	VP-41		1x Dbl-act. / 2x Sgl-act.
110 VAC @ 500 mA	VP-42		1x Dbl-act. / 2x Sgl-act.
▼ 3/2 1 port normally closed, 1 port normally open			
24 VDC @ 1.13 A	VP-51		1x Dbl-act. / 2x Sgl-act.
110 VAC @ 500 mA	VP-52		1x Dbl-act. / 2x Sgl-act.

Note: DIN 43650 electrical connector included. Valve weight 6.5 lbs (3,0 kg.).

Pressure: 5000 psi

Max. Flow: 915 in³/min

- (E) Válvulas de control
- (F) Electro distributeurs
- (D) Wegesitzventile



Options

WM-10 series manifolds

125 ▶

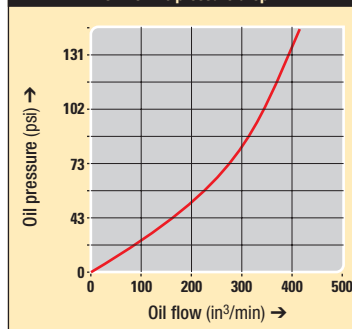


Tie rod kits

125 ▶



Oil flow vs pressure drop



Pressure: 5000 psi

Flow: 427 in³/min @ 5000 psi

Voltage: 115 VAC, 24 VDC

- E** Presostatos
- F** Pressostats
- D** Druckschalter



To control your hydraulic system

- Mounts directly into VP-series modular valves
- In-line installation
- Cartridge type flow control valve and pressure switches can be manifold mounted for remote use
- Lockable adjustment screw on PSCK models

Options

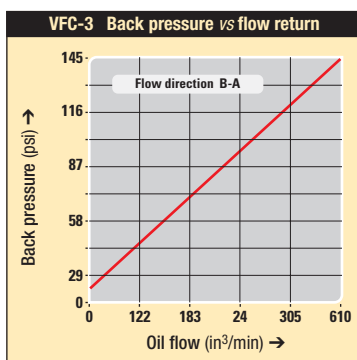
PB-1 Auxiliary block

125 ▶

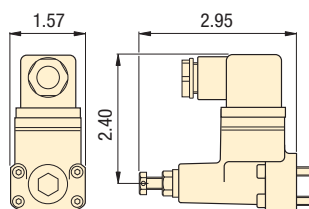


Pressure reducing valves

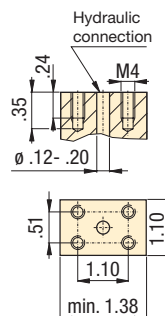
124/139 ▶



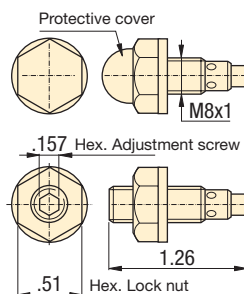
PSCK-8, 9



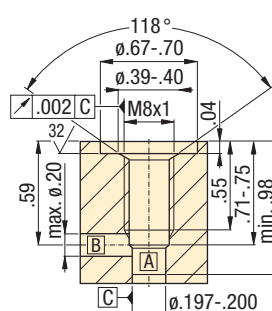
mounting dim.



VFC-3



VFC-3 mounting dimensions



Product selection

Solenoid voltage @ current	Model number	Hydraulic scheme	Pressure range	Deadband	Maximum oil flow
at 50/60 Hz			psi	psi	in ³ /min
▼ Pressure switch					
24 VDC @ 2 A	PSCK-8		1450 - 5000	261 - 501	427
115 VAC @ 2 A					
▼ Pressure switch					
24 VDC @ 2 A	PSCK-9		290 - 3045	87 - 218	427
115 VAC @ 2 A					
▼ Flow control valve					
screw-in	VFC-3		0-5000	-	427
throttle					
valve					

Shown: PSCK-8, VFC-3



PSCK-8, 9

Adjustable pressure switches will open or close electrical contacts when the desired pressure value is reached.

Application

To open or close an electric circuit when a preset pressure value is reached. The electrical circuit is used to control further working cycles, such as actuating control valves or to terminate a working cycle. Directly mounted into Enerpac VP-series valves.

VFC-3

Screw-in throttle type valve to control the amount of oil flow to the hydraulic cylinder.

Application

Used to control cylinder speed in hydraulic circuits. Directly mounted into Enerpac VP-series valves or custom made manifolds for remote applications.

■ PSCK-8 and VFC-3 directly mounted on VP-valves.



Shown: PRV-1



PRV series

These valves regulate system pressure for all subsequent valves, according to the adjusted pressure. Maintains a constant pressure in a secondary circuit. Includes a check valve that prevents pressure drop on secondary side.

Application

Used when a hydraulic supply with a higher pressure (primary side) must also be used for another circuit with a lower pressure (secondary circuit). PRV-1 can be stack built between VP-series valves.

■ PRV-1 connected with remote manifold WM-10.



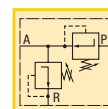
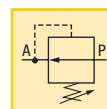
Precise control of hydraulic pressure

- Stackbuilding with VP series modular valves
- Stackable for multiple pressures on one valve stack assembly
- Tool adjustable knob can be locked
- Precise control of pressure

Pressure: 5000 psi

Flow: 417 in³/min

- Ⓔ Válv. reguladora de presión
- Ⓕ Valve de pression réglable
- Ⓖ Druckreduzierventil



Options

VP-Modular valves

122 ▶



Pressure switches

123 ▶

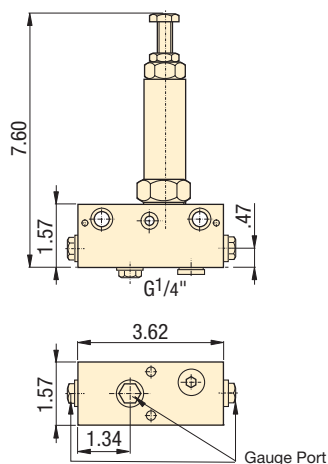


Tie rod kits

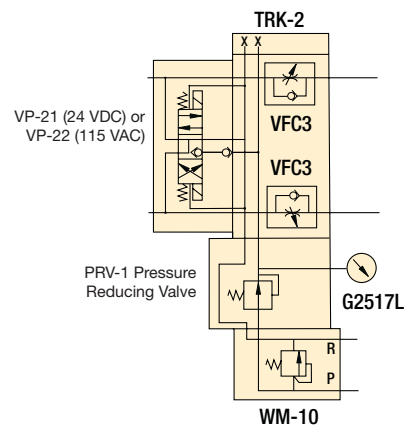
125 ▶



PRV-1, PRV-5



Valve stacking example



Product selection

Mounting style	Adjustable pressure range	Maximum pressure	Model number	Oil ports	Maximum oil flow	
	psi	psi		BSPP	in ³ /min	lbs
VP-series	435 - 4350	5000	PRV-1	G1/4"	427	3.5
VP-series	75 - 2000	5000	PRV-5	G1/4"	427	3.5

Mounting: 1-8 VP valve stations

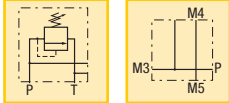
Pressure: 5000 psi max.

Flow: 915 in³/min

E Pernos de montaje de válv.

F Vis de montaje de distrib.

D Zugstangen



Options

Pressure switches

123 ▶



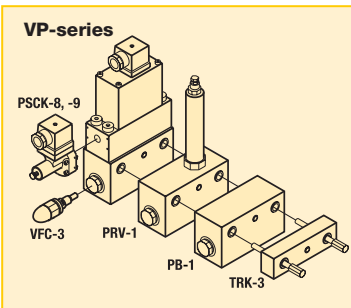
VP-series directional valves

122 ▶



Gauges

153 ▶



Simplifies valve and accessory mounting

TRK-series tie rods

- Connects 1 to 8 VP-series valves station high
- Provide leak-free sealing valves
- G1/4" oil connection

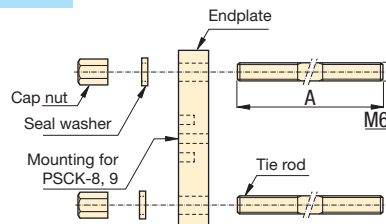
WM-10 remote manifold

- Allows remote VP-series valve mounting
- Adjustable relief valve incorporated
- G1/4" oil connection

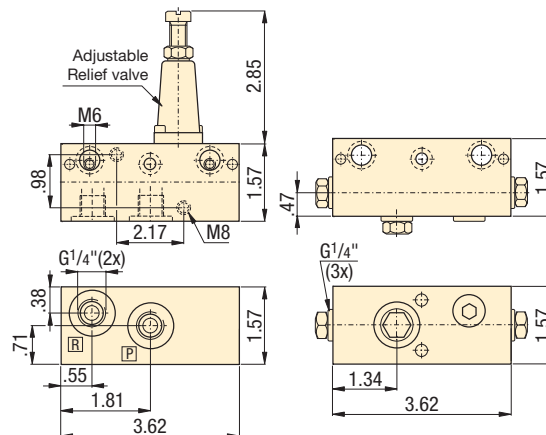
PB-1 porting manifold

- Provide 3 auxiliary pressure lines
- G1/4" oil connection

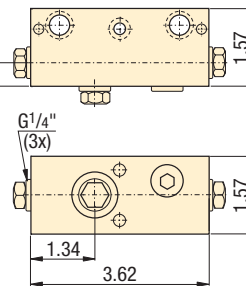
TRK



WM-10



PB-1



Product selection

Quantity of stackable VP-series directional valves	Model number	Tie rod length A	Mounting thread
		inch	mm

▼ Tie rod kits

1	TRK-1	3.45	M6
2	TRK-2	4.92	M6
3	TRK-3	6.50	M6
4	TRK-4	8.07	M6
5	TRK-5	9.65	M6
6	TRK-6	11.22	M6
7	TRK-7	12.80	M6
8	TRK-8	14.37	M6

Product selection

Oil ports	Model number	Hydr. schematic	Maximum pressure
BSP			psi

▼ Remote manifold with pressure relief

2x G1/4"	WM-10		5000
----------	-------	---	------

▼ Porting manifold (P port connection)

3x G1/4"	PB-1		5000
----------	------	---	------

Shown: WM-10, TRK-4, PB-1



TRK-series

Tie Rod Kits mount Enerpac VP-series modular valves to the WM-10 manifold and can accommodate one to eight VP-valve stations.

WM-10

Remote manifold allows mounting of VP-series modular valves to a remote location from the pumping unit. This manifold has a built-in adjustable relief valve.

PB-1

Porting manifold provides three pressure ports for auxiliary lines or accessories, such as a pressure gauge. Mounts between VP-series modular valve stations using TRK-series tie rod kits.

■ Tie rods mount VP-series valves and accessories to manifold, providing leak-free sealing.



Shown: VST-1401D, VSS-2210D



VSS, VST-series

Solenoid and air piloted directional control valves. Poppet design for zero leakage promote system efficiency. Increases the life of your workholding pump by decreasing internal valve leakage.

Application

Advance and retract for single- and double-acting cylinders. The valves require check valves for positive load holding and can be installed for the same independent operation with single-acting cylinders by blocking the B port.

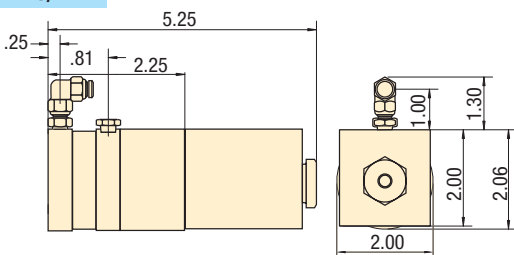
■ VSS-2210D mounted directly on a Turbo II air pump for use on positive clamping fixture.



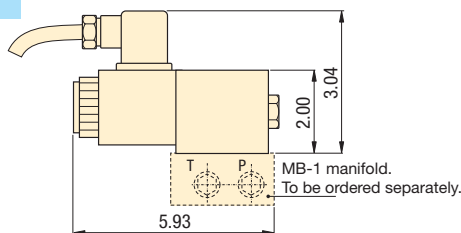
Zero leakage poppet valves increase efficiency

- Poppet valve design for zero leakage
- 4-way, 2-position float offset or normally open
- DO3 mounting pattern
- DIN-standard rectifier plugs for easy connection to power source
- Air operated models eliminate need for electricity
- Including O-rings and mounting bolts
- SAE manifold ports simplify plumbing
- Inline check valve provides positive load holding

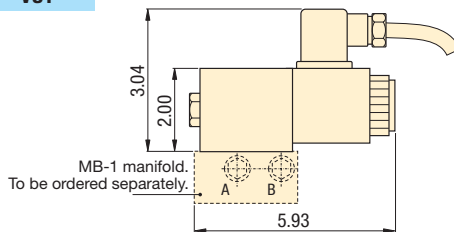
VAS/VAT



VSS



VST

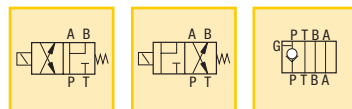


Pressure: 0-5000 psi

Flow: 690 in³/min max.

Voltage: 115 VAC, 24 VDC

- Ⓔ Electroválvulas
- Ⓕ Electro distributeurs
- Ⓖ Elektromagnetische Ventile



Options

DO3 Manifolds MB-series

129

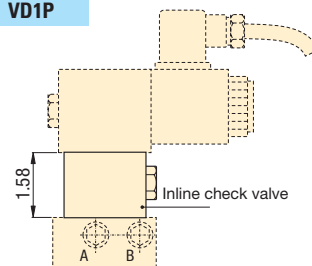
Fittings

158

Important

For multiple circuit applications, the VD1P inline check valve is recommended to prevent pressure drop on the holding circuit.
Order bolt kit F107028-5 to mount VD1P with VMMD.

VD1P



Product selection

Valve flow path	Solenoid voltage @ current at 50/60 Hz	Model number	Hydr. symbol	Pressure range psi	Pressure drop ¹⁾ psi	Max. oil flow in ³ /min
▼ Solenoid poppet valves – Normally open						
4-way, 2 position	60-100 psi max.	VAS-0710D		0-5000	180	690
4-way, 2 position	24VDC @ 1.60 A	VSS-1410D		0-5000	180	690
4-way, 2 position	115VAC @ .40 A	VSS-2210D		0-5000	180	690
▼ Solenoid poppet valves – Normally closed						
4-way, 2 position	60-100 psi max.	VAT-0710D		0-5000	180	690
4-way, 2 position	24VDC @ 1.60 A	VST-1410D		0-5000	180	690
4-way, 2 position	115VAC @ .40 A	VST-2210D		0-5000	180	690
▼ Inline check valve						
–	–	VD1P		0-5000	0	690

¹⁾ Pressure drop from P-A or P-B at maximum oil flow of 690 in³/min.

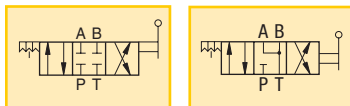
Pressure: 5000 psi

Flow: 1040 in³/min

E Válvulas de control de 4 vías

F Distributeurs à 4 voies

D 4-Wege-Ventiler



Options

VD1P, Inline check valve

◀ 126

DO3 Manifolds

129 ▶

Hoses and couplers

156 ▶

Fittings

158 ▶

Important

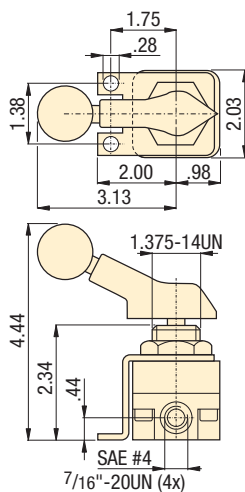
For multiple circuit applications, the VD1P inline check valve is recommended to prevent pressure drop on the holding circuit.
Order bolt kit F107028-13 to mount VD1P with VMMD.

Pressure on return side (tank) should not exceed 250 psi.

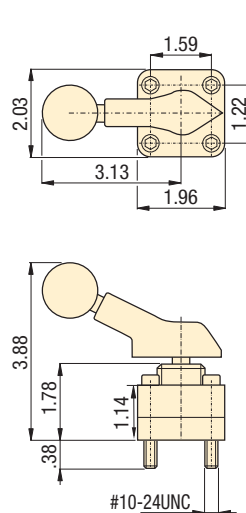
Manual control of single and double-acting cylinders

- Near zero leakage pressure seal design
- 4-way, 3-position
- Detented handle positions
- Low handle effort 12 lbs, even at full pressure
- Handle can be repositioned for side by side valve mounting
- Compact size for directly mounting on fixture for individual circuit control

VMTD-001, 003



VMMD-001, -003



Product selection

Valve mounting pattern	Mounting bolts included	Oil ports	Model number	Hydraulic symbol	Pressure range	Pressure drop ¹⁾	Max. oil flow
					psi	psi	in ³ /min
▼ 4-way, 3-position control valves							
Panel mtg.	—	SAE #4	VMTD-001		0-5000	70	1040
DO3	#10-24UN	—	VMMD-001		0-5000	70	1040
Panel mtg.	—	SAE #4	VMTD-003		0-5000	70	1040
DO3	#10-24UN	—	VMMD-003		0-5000	70	1040

¹⁾ Pressure drop from P-A or P-B at maximum oil flow of 1040 in³/min.
Seal material: Buna-N, Polyurethane.

Shown: VMMD-001, VMTD-001



VMM and VMT-series

Manual directional control valves for single- and double-acting cylinder control. Lapped pressure seal surface provide near zero leakage.

The VMTD series has threaded port connections and removable holding bracket for panel mounting.

Application

Panel mounting on fixtures for control of individual circuits. The blocked pressure port in the center position allows demand style pumps to stall out, saving energy.

The valves require check valves for positive load holding.

■ Several VMTD-001 valves mounted on fixture waiting to be transferred to machine.



Shown: VEX-11 valve



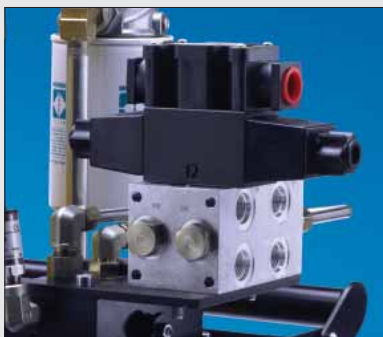
VE-series

Spool style solenoid valves and control modules are used in circuits that do not require zero leakage.

Application

Used to control the advance and retract of single acting and double acting cylinders. The dual check valve can be used to lock pressure in a group of cylinders. The dual flow control offers independent control of cylinder advance and retract speeds. The pressure reducing valve sets a circuit pressure lower than the main pump pressure.

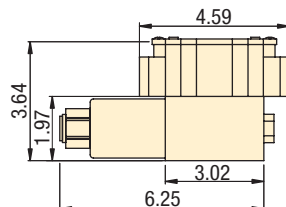
■ VEX-11 valve on ZW5020HG-FT21 pump.



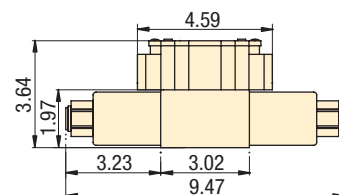
DO3 Direction Valve and accessories

- DO3 mounting pattern
- Directional valves
- Pilot operated check valve
- Dual flow control
- Pressure reducing valve

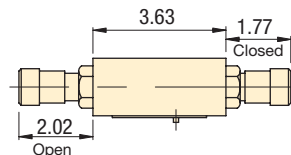
VEW-11



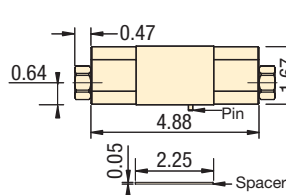
VET-11, VEX-11



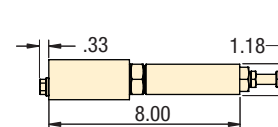
VFC-4



VD2P



PRV-6



Pressure: 0-5000 psi

Flow: 3-15 gpm

Voltage: 24 VDC

- Ⓔ Electroválvulas
- Ⓕ Electro distributeurs
- Ⓓ Elektromagnetische Ventile

Options

DO3 Manifolds MB-series

129



Fittings

158



Important

To hold the pressure in a clamping circuit, use the VEX11 valve with the VD2P check module. Do not use DO3 spool valves with pressure shutdown pumps.

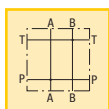
Product selection

Valve flow path	Solenoid voltage 50/60 hz	Model number	Hydraulic symbol	Pressure range	Pressure	Maximum
				psi	psi	gpm
2-position/4 way	24 VDC	VEW-11		0-5000	125	8
	1.32 Amps					
3-position/4 way, Closed center	24 VDC	VET-11		0-5000	150	8
	1.32 Amps					
3-position/4 way, Float center	24 VDC	VEX-11		0-5000	165	8
	1.32 Amps					
Dual flow control	—	VFC-4		0-5000	—	10
Dual pilot operated check valve	—	VD2P		0-5000	200	15
Pressure reducing valve	—	PRV-6		0-5000	—	3

Mounting: 1-6 DO3 type valves

Pressure: 5000 psi max.

- E** Colectores
- F** Manifolds
- D** Verkettungsblöcke



When independent control of multiple cylinders is required

- Multi-station manifolds with SAE porting – minimizes plumbing
- Mounting pattern for DO3 valves and Enerpac VSS and VST Positive Seal Control Valves and VMMD manual valves
- Manifolds allow use of accessories, such as pressure switches and gauges

Options

VSS, VST, VMMD-series valves

126 ▶



Pressure switches

152 ▶



Gauges

154 ▶



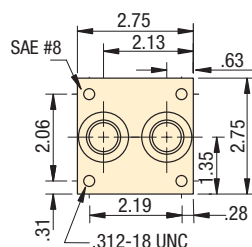
Fittings

158 ▶

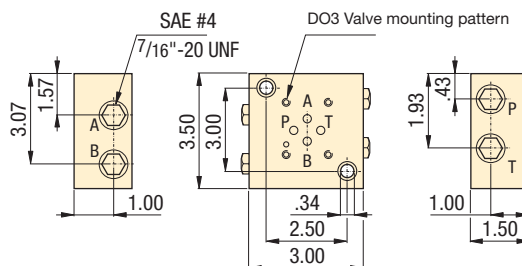


Important

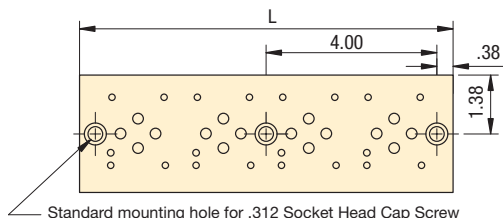
Use MC-1 cover plates to seal non-used manifold stations.



MB-1



MB-2, -4



Product selection

Valve mounting pattern	Amount of valve stations	Model number	Oil ports cover plate	Optional length model number*	Manifold	
					L	
					in	lbs
▼ Single station manifold						
DO3, Enerpac VSS, VST valves	1	MB-1	SAE #4	–	–	1.0
▼ Multiple station manifolds						
DO3, Enerpac VSS, VST valves	2	MB-2	SAE #8	MC-1	4.75	3.3
DO3, Enerpac VSS, VST valves	4	MB-4	SAE #8	MC-1	8.75	6.1

*Note: - MC-1 manifold cover plate must be ordered separately. Includes gasket and mounting bolts.

Shown: MB-4, MB-1



MB-series

Single or multiple station manifolds allow installation of VSS and VST-series positive seal control valves or other DO3 valves. Ideal in applications where independent control of multiple cylinders is required.

Each non-used valve station on manifolds must be sealed with MC-1 cover plate.



Shown: VEC-15600D, VEC-15000B, VEK-15000B



VE-series

Solenoid modular valves are especially well suited for workholding and production applications. With 11 possible flowpaths and 2 manifolds, for either Enerpac's submerged pump or a remote NPT mount, you can "custom build" a valve for almost any application.

Application

Ideal when mounted on remote manifold for applications where independent control of multiple cylinders is required.

Unmatched combination of possibilities

- Relief valve and pilot-operated check accessory valves are stackable eliminating external plumbing
- Remote and pump mounting
- Mounting bolts included with each modular valve

Select the required valve flow path

Valve flow path	For cylinder	Valve code	Hydraulic symbol
▼ 2-way, 2-position (2/2)			
Normally closed	Unloading *	VEH	
Normally open	Unloading *	VEK	
▼ 3-way, 2-position (3/2)			
Normally open	Single-acting	VEP	
▼ 3-way, 3-position (3/3)			
Tandem center	Single-acting	VEF	
Closed center	Single-acting	VEG	
▼ 4-way, 2-position (4/2)			
Crossover offset	Double-acting	VEE	
Float offset	Double-acting	VEM	
▼ 4-way, 3-position (4/3)			
Open center	Double-acting	VEA	
Closed center	Double-acting	VEB	
Tandem center	Double-acting	VEC	
Float center	Double-acting	VED	

* VEH and VEK valve models require the use of tank port for dump or unloading.

Product specifications

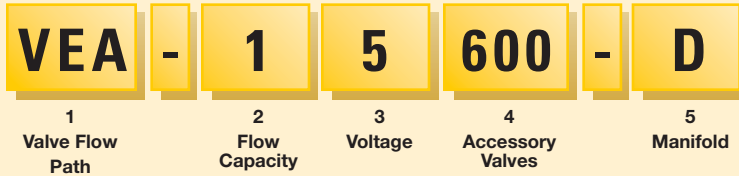
Pressure range	Maximum oil flow	Voltage @ Hz	Amperage draw	
psi	in ³ /min		Amps inrush	holding
0-10,000	920	24 VDC @ 50/60 Hz	—	2.5
0-10,000	920	115 VAC @ 60 Hz	3.6	1.0
0-10,000	920	220/240 VAC @ 50 Hz	1.3/1.4	.45/.53
0-10,000	920	230 VAC @ 60 Hz	1.8	.50 A

Note: Seal material: Buna-N, Polyurethane.
DIN43650 Valve plug included on remote mounted valves.



Custom build your modular valves

▼ This is how a Solenoid Modular Valve Model Number is built up:



1 Modular valve code

- A = 4/3 Open center
- B = 4/3 Closed center
- C = 4/3 Tandem center
- D = 4/3 Float center
- E = 4/2 Crossover offset
- F = 3/3 Tandem center
- G = 3/3 Closed center
- H = 2/2 Normally closed
- K = 2/2 Normally open
- M = 4/2 Float offset
- P = 3/2 Normally open

2 Oil flow capacity

- 1 = 920 in³ per minute

3 Solenoid voltage

- 1 = 24 VDC, 50 / 60 Hz
- 2 = 230 V, 1 ph, 50 Hz
- 5 = 115 V, 1 ph, 60 Hz
- 6 = 230 V, 1 ph, 60 Hz

4 Accessory valves

- 000 = No accessory valves
- 100 = VS-11 Relief valve only
- 150 = VS-11 Relief valve and VS-51 3-way pilot operated check valve VEF/VEG only
- 160 = VS-11 Relief valve and VS-61 4-way pilot operated check valve VEA/VEB/VEC/VED only
- 500 = VS-51 3-way pilot operated check valve VEF/VEG only
- 600 = VS-61 4-way pilot operated check valve VEA/VEB/VEC/VED only

5 Manifold

- A = No manifold
- B = Remote mounted manifold
- D = Pump mounted manifold VEA/VEC/VEF only

Example

The **VEA-15600-D** is a modular valve with a 4-way, 3-position open center flowpath, 115 VAC, and an integrated pilot-operated check valve, for mounting on an Enerpac pump.

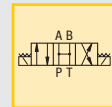
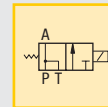
Bolt Kit **BK-2** is included.

Pressure: 0-10,000 psi

Flow max.: 920 in³/min

Voltage: 24, 115, 230 V

- E** Válvulas de control
- F** Electro distributeurs
- D** Wegesitzventile



Options

Gauges and accessories

154 ▶



Fittings

158 ▶



Accessory Valves and Bolt Kits

Use **VS-11** relief valve to add system pressure control to VE-series valves.

Use **VS-51** 3-way pilot operated check valve to convert 3-way VE-valve into load-holding valve.

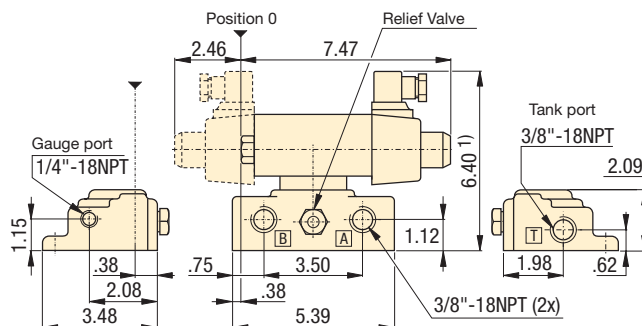
Use **VS-61** 4-way pilot operated check valve to convert 4-way VE-valve into load-holding valve.

To install accessory valves to stack build modular valves use bolt kits:

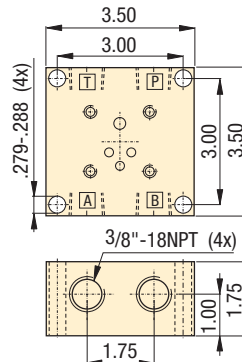
- BK-2** for 1 VS valve;
- BK-3** for 2 VS valves.

VE series

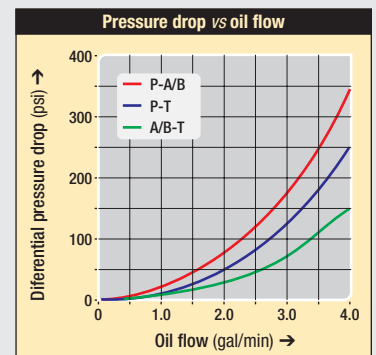
Modular Valve Pump Mounted



Modular Valve Remote Mounted



¹⁾ add 1.85 inch for each Accessory Valve.
Note: BK-1 Bolt Kit is included with each modular valve.



3-way directional manual control valves *Application & selection*

Shown: VM-2, VM-3



V-series

Manual operated 3-way, 2-position and 3-way, 3-position directional control valves for operation of single-acting cylinders. Remote mount valves include return line kit for connecting the valves to pump reservoir.

Application

Pump mounted valves provide centralized control of pump output for cylinder cycling. Remote mounted at any convenient point along the system where control of cylinders is needed.

■ Four VC-15 Enerpac manual valves mounted on fixture to give independent control of several hydraulic circuits.



Reliable control of single-acting cylinders

- Directional control valves provide advance/hold/retract operation for use with single-acting cylinders
- Remote or pump mounting on most Enerpac pumps
- Return line kit included with remote valves
- Available "locking" option on VC and VM-series valves for load-holding applications



Select the required center position

Non-locking

- Use in simple clamping circuits. Has interflow between ports when shifted.

Closed center

- For multiple valve and cylinder operation. All ports blocked in the center position.

Locking center

- For positive load holding without loss of pressure. Cylinder travel can only resume by shifting valve from hold position.

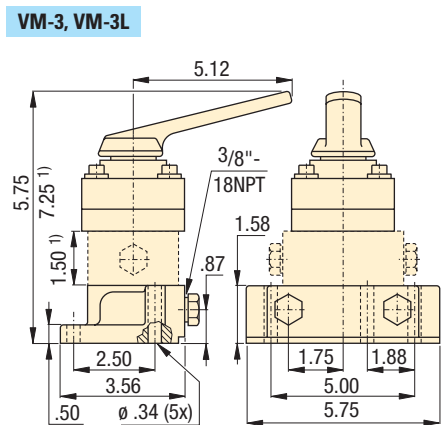
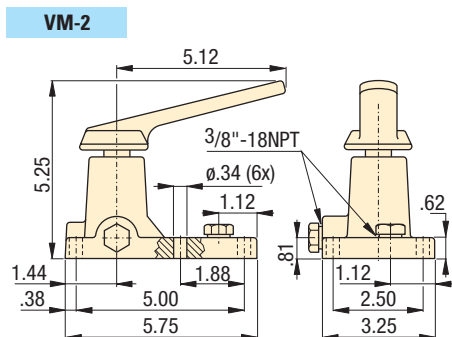
Tandem center

- For one or multiple cylinder operation. Pump flow is directed back to tank in the center position.

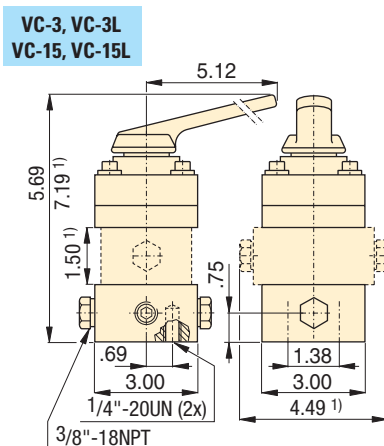


Product selection

Valve type	Valve mounting location	Model number	Hydraulic symbol
▼ Manual 3-way, 2-position (3/2)			
–	Pump	VM-2	
▼ Manual 3-way, 3-position (3/3)			
Tandem center	Pump	VM-3	
Tandem center	Remote	VC-3	
▼ Manual 3-way, 3-position (3/3)			
Tandem center, locking	Pump	VM-3L	
Tandem center, locking	Remote	VC-3L	
Closed center	Remote	VC-15	
Closed center, locking	Remote	VC-15L	

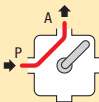
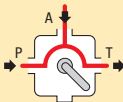
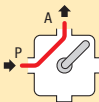
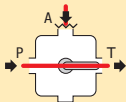
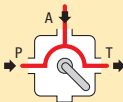
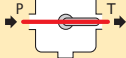
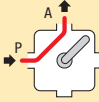
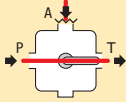
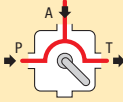
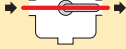
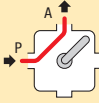
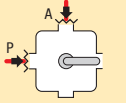
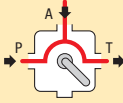
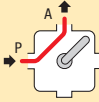
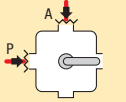
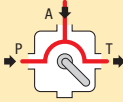


¹⁾ VM-3L only



¹⁾ VC-3L and VC-15L only

Product specifications

Model number	Pressure range	Used for cylinder	Schematic flowpath			
	psi		Advance	Hold	Retract	lbs
▼ Manual 3-way, 2-position (3/2)						
VM-2	0-10,000	Single-acting		—		4.8
▼ Manual 3-way, 3-position (3/3)						
VM-3	0-10,000	Single-acting				4.6
VC-3	0-10,000	Single-acting				6.4
▼ Manual 3-way, 3-position (3/3)						
VM-3L	0-10,000	Single-acting				8.6
VC-3L	0-10,000	Single-acting				10.3
VC-15	0-10,000	Single-acting				6.4
VC-15L	0-10,000	Single-acting				10.3

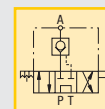
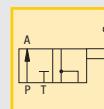
Pressure: 0-10,000 psi

Flow max.: 1040 in³/min

E Válvulas de control

F Distributeurs à 3 voies

D 3-Wege-Ventile



Options

Gauges and accessories

154 ▶



Hoses and couplers

156 ▶



Fittings

158 ▶



Important

Locking Valves

For applications that require positive load holding, most VM and VC valves are available with pilot operated check valve. This option provides hydraulic locking of the load until valve is shifted into retract position. To order this feature, place an "L" at the end of the model number.

Valving help

See Basic System Set-up and Valve information in our "Yellow Pages".

184 ▶

4-way directional manual control valves *Application & selection*

Shown: VC-20, VM-4



V-series

Manual operated 4-way, 3-position directional control valves for operation of double-acting or two single-acting cylinders. Remote mount valves include return line kit for connecting the valves to pump reservoir.

Application

Pump mounted valves provide centralized control of pump output for cylinder cycling. Remote mounted at any convenient point along the system where control of cylinders is needed.

■ *Enerpac VC-4 manual valves mounted to control hydraulic circuit on pallet fixture*



Reliable control of double-acting cylinders

- Directional control valves provide advance/hold/retract operation for use with double-acting or two single-acting cylinders
- Remote or pump mounting on most Enerpac pumps
- Return line kit included with remote valves
- Available "locking" option on VC and VM-series valves for load-holding applications



Select the required center position

Non-locking

- Use in simple clamping circuits. Has interflow between ports when shifted.

Closed center

- For multiple valve and cylinder operation. All ports blocked in the center position.

Locking center

- For positive load holding without loss of pressure. Cylinder travel can only resume by shifting valve from hold position.

Tandem center

- For one or multiple cylinder operation. Pump flow is directed back to tank in the center position.



Product selection

Valve type	Valve mounting location	Model number	Hydraulic symbol
▼ Manual 3-way, 2-position (3/2)			
Tandem center	Pump	VM-4	
Tandem center	Remote	VC-4	
Tandem center, locking	Pump	VM-4L	
Tandem center, locking	Remote	VC-4L	
Closed center	Remote	VC-20	
Closed center, locking	Remote	VC-20L	



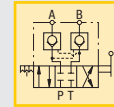
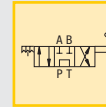
Pressure: 0-10,000 psi

Flow max.: 1040 in³/min

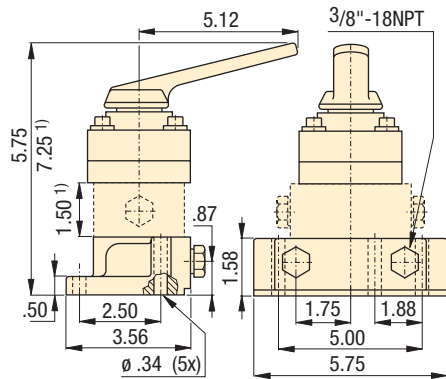
E Válvulas de control

F Distributeurs à 4 voies

D 4-Wege-Ventile

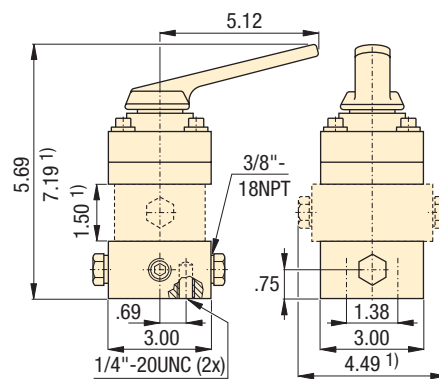


VM-4, VM-4L



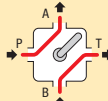
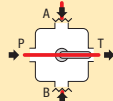
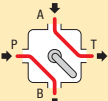
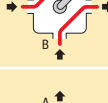
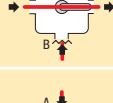
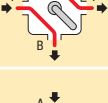
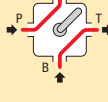
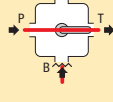
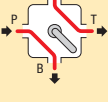
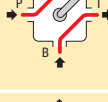
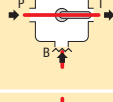
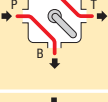
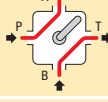
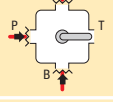
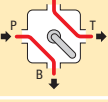
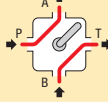
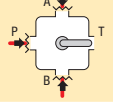
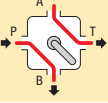
¹⁾ VM-4L only

VC-4, VC-3L
VC-20, VC-20L



¹⁾ VC-4L and VC-20L only

Product specifications

Model number	Pressure range	Used for cylinder	Schematic flowpath			
	psi		Advance	Hold	Retract	lbs
▼ Manual 4-way, 3-position (4/3)						
VM-4	0-10,000	Double-acting				4.6
VC-4	0-10,000	Double-acting				6.4
VM-4L	0-10,000	Double-acting				8.6
VC-4L	0-10,000	Double-acting				10.3
VC-20	0-10,000	Double-acting				6.4
VC-20L	0-10,000	Double-acting				10.3

Options

Gauges and accessories

154 ▶



Hoses and couplers

156 ▶



Fittings

158 ▶



Important

Locking Valves

For applications that require positive load holding, most VM and VC valves are available with pilot operated check valve. This option provides hydraulic locking of the load until valve is shifted into retract position. To order this feature, place an "L" at the end of the model number.

Valving help

See Basic System Set-up and Valve information in our "Yellow Pages".

184 ▶

Shown: WVP-5, MVPM-5



Sequence valves

Sequence valves block the oil to a secondary hydraulic circuit until pressure in the primary circuit reaches a preset level. The sequence valves have a built-in check system to allow the oil to flow back without external piping.

Pressure settings for the V-2000 can be adjusted by screwing the slotted pin in or out. The pressure settings for the other models is adjusted by loosening the jam nut and turn the set screw to reach your setting.

Application

The sequence valves can be mounted in-line or fixture mounted using mounting bolts.

A typical application for the sequence valve would be to build pressure within work supports before the swing cylinders are applied to the supported part, to prevent deflection in the part.

- Two WVP-5 sequence valves used in conjunction with Enerpac WCA-series Auto Coupler to provide system automation.



Pressure dependent sequence control

MVPM-5, WVP-5

- Direct accurate pressure setting
- Pressure setting between 500-5000 psi for secondary circuit is secured with lock nut
- Mounting holes on WVP-5, manifold mounting ports on MVPM-5

V-2000

- Direct accurate pressure setting
- Pressure setting between 200-2000 psi for secondary circuit
- Flag indicator appears everytime the valve is operated

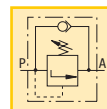
Pressure: 5000 psi

Flow: 250-366 in³/min max.

(E) Válvulas de secuencia

(F) Valve de séquence

(D) Folgeventil



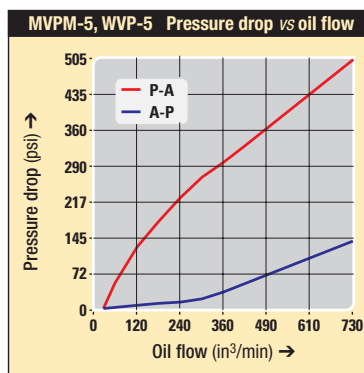
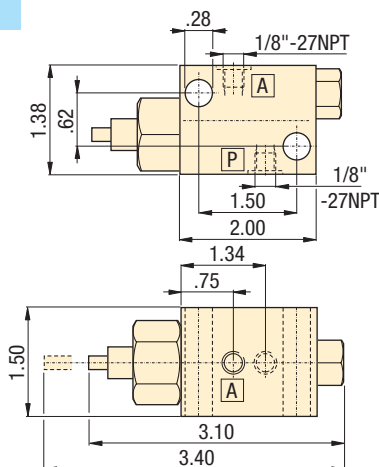
Options

Gauges

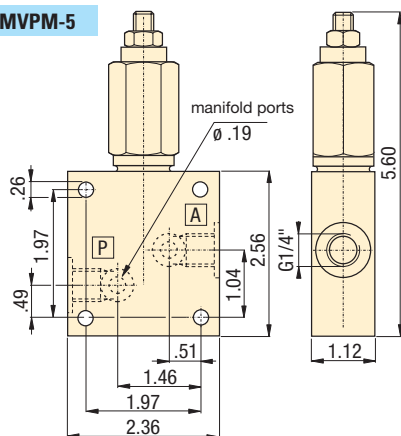
154 ▶



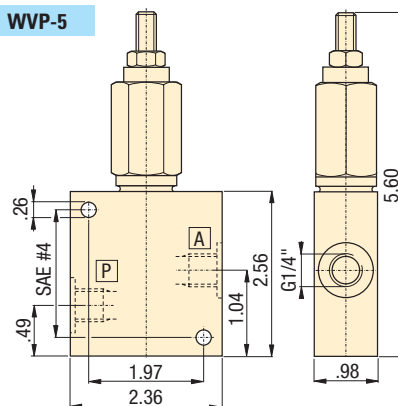
V-2000



MVPM-5



WVP-5



Product selection

Pressure adjustment range	Maximum pressure	Maximum oil flow	Model number	Oil ports	Opening pressure check valve	
psi	psi	in ³ /min			psi	lbs
200-2000	2000	250	V-2000	1/8"-27 NPT	—	2.0
500-5000	5000	366	MVPM-5	G 1/4"	20	2.9
500-5000	5000	366	WVP-5	SAE #4	20	1.8

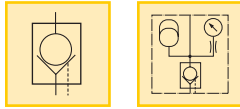
Seal material: Buna-N.

Manifold O-rings included with MVPM-5. For manifold mounting installation information consult Enerpac for surface preparation.

Pilot ratio: 7:1

Flow: 10 gpm max.

- E** Válvulas antirretorno pilotada
- F** Clapets antiretour piloté
- D** Rückschlagventile



To hold cylinder load and ensure remote unlocking

- Fast check-off response
- Hardened seats ensure long life and positive pressure holding
- Built-in accumulator to maintain system pressure
- Mounting holes
- Manifold mount body MVM-72



Options

Fittings

158 ▶

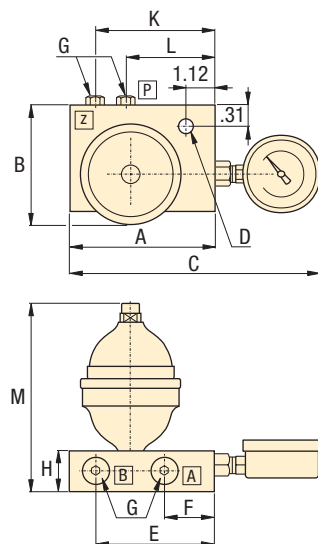


Product selection

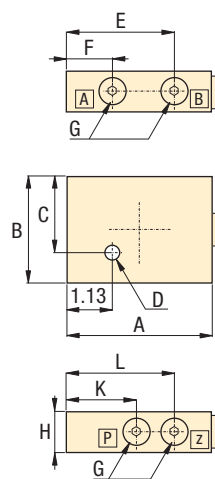
Pilot ratio	Accumulator included	Maximum oil flow	Maximum pressure	Model number	Oil ports	Optional charging tool for ACL	Weight
		GPM	psi				lbs
7 : 1	—	10	5000	V-72	SAE #4	—	4.0
7 : 1	ACL-22	10	5000	MV-722B	G 1/4"	WAT-2	6.0
7 : 1	ACL-202	10	5000	MV-7202B	G 1/4"	WAT-2	7.5
7 : 1	—	10	5000	MVM-72	G 1/4"	—	3.0

For more information on ACL-series Accumulators see page 150.

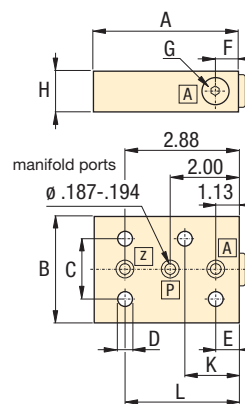
MV-722B, -7202B



V-72



MVM-72



- A** = Cylinder advance
- B** = Cylinder retract
- P** = Pressure
- Z** = Pilot



Product dimensions in inches []

Model number	A	B	C	D	E	F	G	H	K	L	M
V-72	3.50	2.50	2.19	.28	2.88	1.13	SAE #4	1.25	2.00	2.88	—
MV-722B	3.50	2.80	7.25	.28	2.88	1.12	G1/4"	1.25	2.88	2.00	5.71
MV-7202B	3.50	3.64	7.13	.28	2.88	1.12	G1/4"	1.25	2.88	2.00	7.28
MVM-72	3.50	2.50	1.50	.28	1.13	1.12	G1/4"	1.25	1.75	2.88	—

Seal material: Buna-N.

Manifold O-rings included with MVM-72. For manifold mounting installation information consult Enerpac for surface preparation.

© 2008

Shown: V-72



MV and V-series

Pilot operated check valves check the oil flow with a built-in pilot circuit providing fast, automatic check-off for your workholding applications.

The pilot operated check valves with built-in accumulator help to maintain system pressure due to minor oil loss.

Application

Added capability to open with pilot pressure to allow cylinders to retract. By using a pilot operated check valve, cylinder retraction can be accomplished automatically without operator activity.

Shown: VFC-1, VFC-2



VFC-series

Provide repeatable oil flow control. The internal check valve allows metered flow in one direction and free flow in the opposite direction. Precise control is achieved with a micro-meter style adjustment knob, which can be locked with the set screw.

Application

Use VFC-series flow control valves in-line with the Enerpac WE-series workholding pump to protect your components from damage due to high flow rates.

■ In-line installation of a VFC-1 flow control valve.



Regulate the flow of oil

- Poppet valve design for zero leakage
- Color coded flow indicator
- Free flow return
- Fine metering capability
- Lockable
- Standard Viton seals

Max. Flow: 10 gpm

Pressure: 0-5000 psi

Ⓔ Válv. reguladoras de caudal

Ⓕ Valves de control débit

Ⓓ Stromregelventile



Options

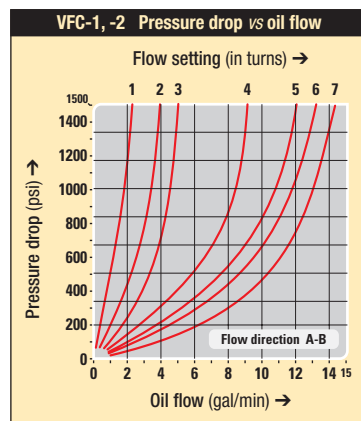
Fittings

158 ▶

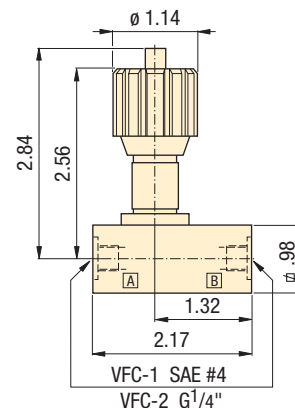


High pressure filter

157 ▶



VFC-1, -2



Product selection

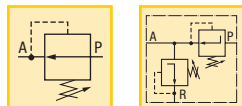
Maximum oil flow	Pressure range	Oil ports	Model number	Flow path	Maximum pressure drop	
gpm	psi				psi	lbs
▼ Flow control valves						
10	0-5000	SAE #4	VFC-1		1500	1.8
10	0-5000	G 1/4"	VFC-2		1500	1.8

Seal material: Viton

Pressure: 5000 psi

Flow: 417 in³/min

- E** Válv. reguladora de presión
- F** Valve de pression réglable
- D** Druckreduzierventil



Precise control of hydraulic pressure

- Tool adjustable knob can be locked
- Precise control of pressure
- G1/4" oil connection
- Remote mount

Options

VP-Modular valves

122 ▶



Pressure switches

152 ▶

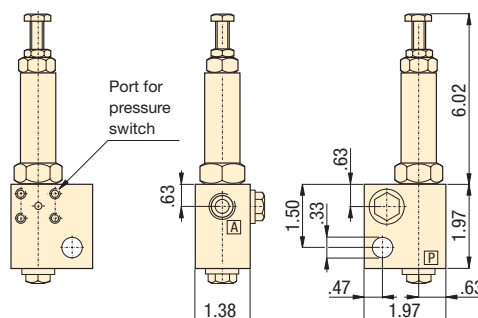


Tie rod kits

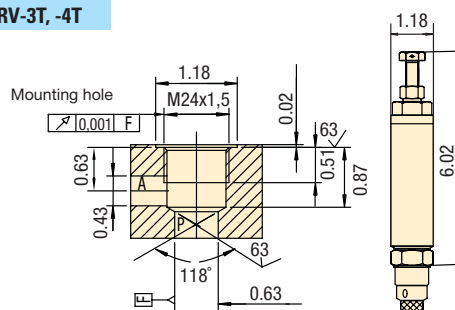
125 ▶



PRV-3, -4



PRV-3T, -4T



Shown: PRV-3



PRV series

These valves regulate system pressure for all subsequent valves, according to the adjusted pressure. Maintains a constant pressure in a secondary circuit. Includes a check valve that prevents pressure drop on secondary side.

Application

Used when a hydraulic supply with a higher pressure (primary side) must also be used for another circuit with a lower pressure (secondary circuit).

PRV-3 and 4 are for remote mounting. The cartridge from PRV-3 and 4 can be removed from manifold for direct integration into gundrilled fixture. Order the cartridge separately as PRV-3T or PRV-4T.

Valves

System components

Yellow pages

Product selection

Mounting style	Adjustable pressure range	Maximum pressure	Model number	Oil ports	Maximum oil flow	
	psi	psi		BSPP	in ³ /min	lbs
Remote	435 - 4350	5000	PRV-3	G1/4"	427	2.9
Cartridge	435 - 4350	5000	PRV-3T	—	427	1.5
Remote	75 - 2000	5000	PRV-4	G1/4"	427	2.9
Cartridge	75 - 2000	5000	PRV-4T	—	427	1.5

Shown: HV-1000A, V-17, V-10, V-12, V-152



Accessory valves

Enerpac accessory valves are available in a wide variety and many configurations to control hydraulic pressure or oil flow. These valves are used in conjunction with other valves and system components to provide full automation and control.

Application

Accessory valves are used to automate clamp cycles, prevent pressure loss and provide additional operator and component safety.

Your hydraulic control solution

- Regulate oil flow or system pressure
- All valves feature NPT or SAE porting to insure against leakage at rated pressure
- Can easily be installed in any system
- All valves are painted, coated or plated for corrosion resistance

Product selection

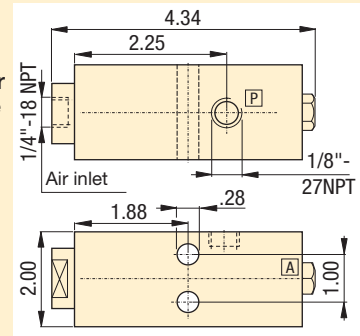
Valve type	Maximum pressure psi	Model number	Oil ports
Holding valve, air pilot	3000	HV-1000A	1/8" NPT
Holding valve, modular	3000	MHV-1	1/8" NPT
Pressure limiting valve	3000	PLV-40013B	1/8" NPT
Manual shut-off valve	5000	V-12	SAE #4
Auto-damper valve	10,000	V-10	1/2" NPT
Safety check valve	10,000	V-17	3/8" NPT
Pressure relief valve	10,000	V-152	3/8" NPT

Product specification

HV-1000A

Air pilot holding valve

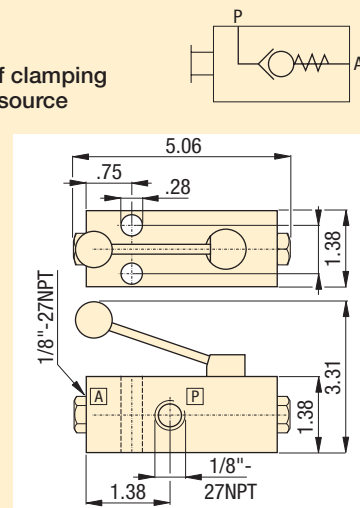
- Holds fluid under pressure offering independent control of different branches of the same fixture
- Valve can control the pilot air and the booster in sequence
- Max. oil flow 305 in³/min
- Works with the VA-42 four-way air valve and a booster



MHV-1

Modular holding valve

- Allows separate operation of clamping fixtures with a single power source
- Ideal for applications when fluid feed lines are impractical. If system pressure is interrupted, the MHV-1 will hold the pressure beyond the valve
- Max. oil flow 305 in³/min
- To release system pressure, rotate valve handle in either direction 90° to release and retract system pressure



■ V-17 Safety check valve installed on a fixture.

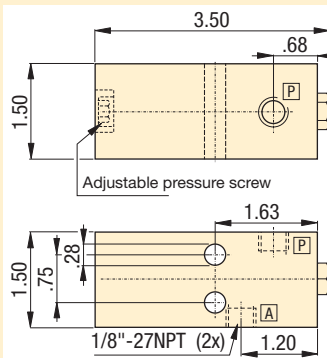
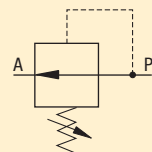




PLV-40013B

Pressure limiting valve

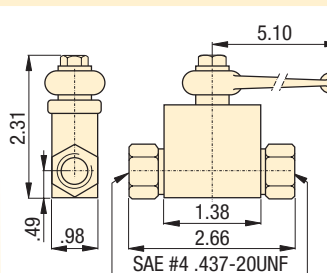
- Allows precise control of pressures reaching specific clamps
- When pressure build-up reaches a preset level, the valve closes, stabilizing pressure to that section of the fixture
- Pressure adjustment between 200 to 1500 psi
- Max. oil flow 305 in³/min



V-12

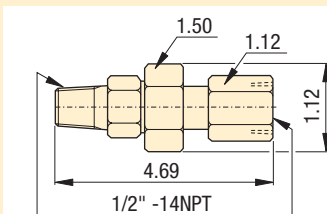
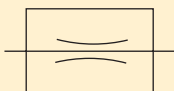
Manual shut-off valve

- Ball type valve can be used for the master system shut-off or for isolating separate circuits on a fixture
- Viton seals standard
- Straight through design for easy system plumbing and installation
- Fully open allows high flow return of oil
- Max. oil flow 732 in³/min



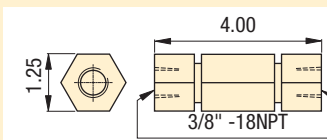
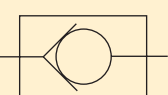
V-10 Auto-damper valve

- To protect gauge during high cycle applications
- Creates a flow resistance when load is released suddenly
- No adjustments are necessary
- Fits directly into GA-series gauge adaptor



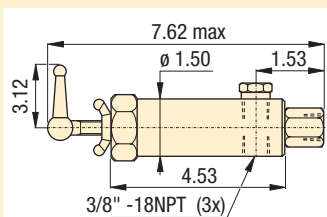
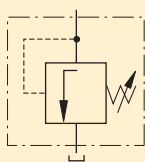
V-17 Safety check valve

- Ruggedly built to resist shock and operate with low pressure drop
- Closes smoothly without pounding
- Max. oil flow 1830 in³/min



V-152 Pressure relief valve

- Limits pressure developed by the pump in hydraulic circuit, thus limiting the force imposed on other components
- 800-10,000 psi adjustment range; $\pm 3\%$ repeatability
- Valve opens whenever preset pressure is reached. To increase pressure setting, turn handle clockwise
- Max. oil flow 1830 in³/min
- Includes 3 ft. return line hose kit



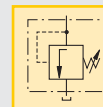
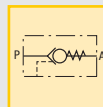
Pressure: 0-10,000 psi

Flow max.: 305-1830 in³/min

E Válvulas de control

F Valves de contrôle

D Regelventile



Options

VA-42
Air valve

142 ▶



Gauges
and adaptors

154 ▶



Hoses
and couplers

156 ▶



Fittings

158 ▶



Important

Valving help
See Basic System Set-up
and Valve information in our
"Yellow Pages".

184 ▶

Shown: VA-42, VAS-42



Air valves

Enerpac's line of directional air valves and accessories complete your workholding system. Used to control air operated hydraulic units, they increase your productivity and efficiency.

Application

VA-series directional air valves provide either manual or electric control to air operated hydraulic units. Accessories such as rapid exhaust, check valves, silencers and regulators complete the air control system.

- Accessory valves provide greater safety and more efficient clamping cycles
- Recommended for use with all air powered units
- Directional valves to control booster and pump air supply
- Remote air valve permits either hand or foot operation

Important

Valving help
See Basic System Set-up and Valve information in our "Yellow Pages".

184 ▶

To control and regulate air supply

VA-42 Manual operated air valve 5-way, 2-position

- For control of boosters
- Viton seals standard

VAS-42 Solenoid operated air valve 5-way, 2-position

- For control of pump and boosters air supply
- Viton seals standard
- Solenoid: 120 VAC, 50/60Hz
Amperage: inrush .11 Amps, holding .07 Amps
- Maximum cycle rate: 600 cycles per minute

VR-3 Rapid exhaust valve

- Enables booster to advance and retract faster
- Instantly exhaust air supply from booster to atmosphere

V-19 Air check valve

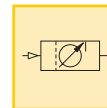
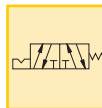
- Prevent rapid drop of air pressure to the booster in the event of sudden loss of input air

RFL-102 Regulator-Filter-Lubricator

- Regulates air pressure
- Filter air input
- Lubricates air motors with a fine oil vapor mist
- Maximum air flow 48 scfm

Air Pressure: 0-150 psi

- E Válvulas de aire
- F Valves à air
- D Luftventile



Options

Gauges and adaptors

154 ▶



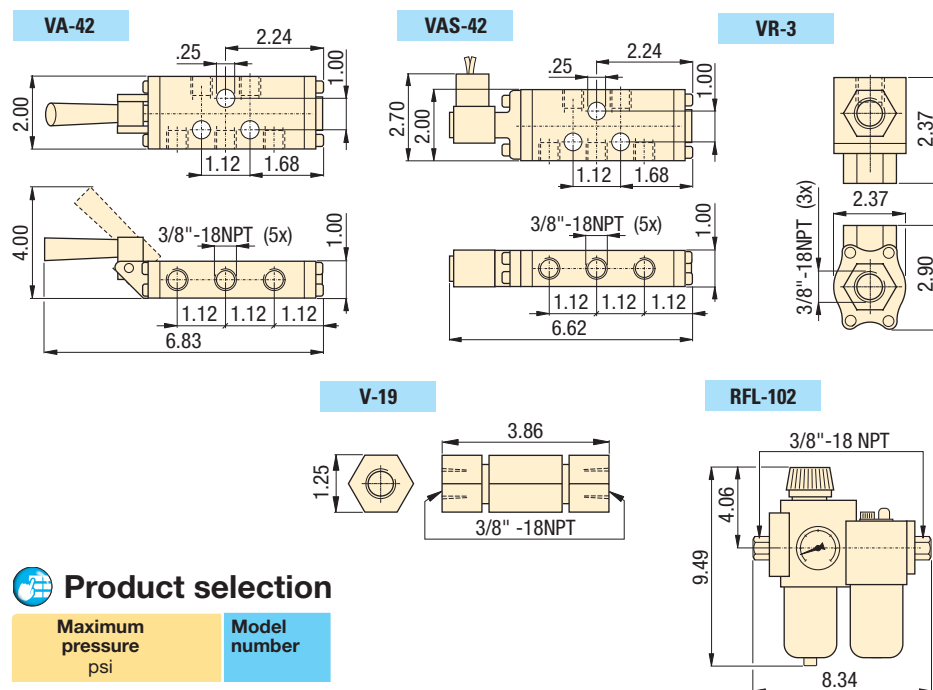
Hoses and couplers

156 ▶



Fittings

158 ▶



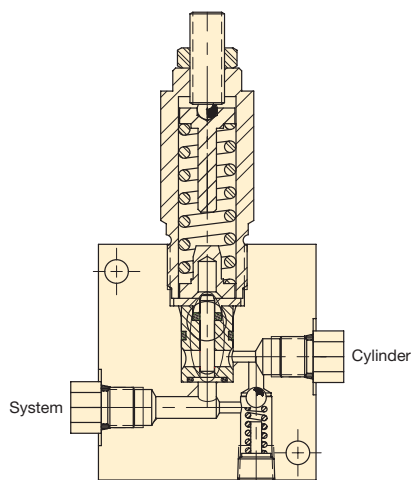
Product selection

Maximum pressure psi	Model number
▼ Air valves	
30-150	VA-42
30-150	VAS-42
0-100	VR-3
0-100	V-19
▼ Accessories	
0-125	RFL-102

Valve Cutaways

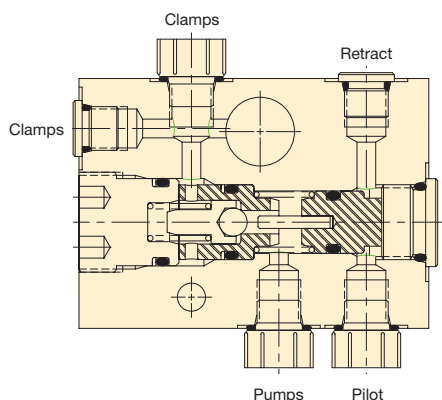
WVP-5

The opening point is set by the adjustment spring. Incoming pressure is blocked by the valve spindle in the orifice plate. When opening pressure is reached, the spindle is pushed up until fluid will pass. The system pressure level is maintained as pressure builds in the downstream circuit. Reverse flow is through a reverse check valve.



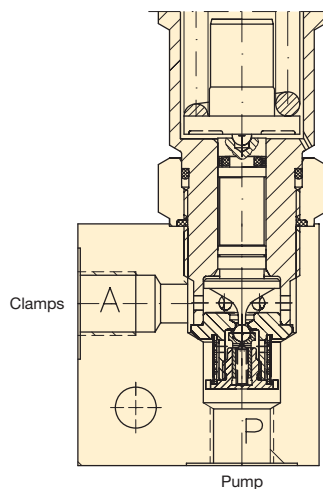
V-72

System pressure enters through the "Pump" port, flows through the check seat and past the check valve into the cylinder circuit. When system pressure drops, the check ball closes off the seat, blocking flow. To release the cylinder pressure, the "Pilot" port is pressurized, and the pilot piston pushes the check ball off of the seat, allowing reverse flow.



PRV-3

A check ball is held off of the check seat by a spring loaded spindle. The spring setting determines the closing point of the valve. As pressure builds in the cylinder side of the circuit, the spindle is lifted, and the check seats. Closing off further flow through the valve provides a reduced pressure to the cylinder.



System

System Components

From the simplest to the most complex hydraulic system, Enerpac's system components help you complete your design. Gauges, pressure switches, couplers and hoses are simple but necessary items for any hydraulic system, and Enerpac can provide the full range. And more specialized components such as accumulators and automatic coupler systems ensure that whatever your need, Enerpac can help.



Technical support

Refer to the "Yellow Pages" of this catalog for:

- Safety instructions
- Basic hydraulic information
- Advanced hydraulic technology
- FMS (Flexible Machining Systems) technology
- Conversion charts and hydraulic symbols

161 ►

components

	▼ series	▼ page	
Auto-coupler systems	WCA, WPA ACCB	146 - 147	
Rotary couplers	CR CRV	148 - 149	
Accumulators	AC WA	150 - 151	
Pressure switches	IC PSCK	152	
Digital pressure gauges	DG	153	
Pressure gauges	G	154	
Gauge accessories	GA, GS V, NV	155	
Manifolds, couplers, hoses, tubing	A, AH/R HLS, T	156	
High pressure filters, hydraulic oil	FL, HF	157	
High pressure fittings	BFZ, FZ	158 - 160	

Shown: WCA-62, WPA-62



The automatic coupler system allows connection and disconnection of palletized hydraulic circuits. This system eliminates the direct intervention of an operator, allowing hands free, safe functioning of the process. Typical systems include one base station located at the load/unload station operating one or more pallet receivers.

■ ACCB-2 Control shown with ZW4020HJ-FHLT12U300 Pump.



■ A 4-way auto coupler is connected to the receiver, mounted on the side of a palletized fixture.



For automated coupling of hydraulic circuits on palletized systems

- Sensing feedback of coupler position allows for fully automated applications
- Horizontal or vertical mounting for flexible installation on machine tools
- Available as 2 or 4 port model to provide a solution to various hydraulic circuit needs
- Adjustment stroke allows clearance for pallet indexing
- Coupler elements supplied with air blow-off nozzles to prevent damage from contamination
- Automatic coupler control box provides pre-programmed safety features to insure proper sequencing of automatic coupler and fixture operations



ACCB-2, Automatic coupler control box

147 ▶

- Provides automatic or manual control of your 2 or 4 port auto coupler station.
- Panel view informs when auto coupler is retracted or advanced and whether fixture is unclamped or clamped.
- Includes 2 pressure switches, 3 proximity switches.
- Pressure switches monitor clamping and unclamping system pressure.
- Proximity switches inform PLC when auto coupler is advanced or retracted and when pallet is in position for the auto coupling.
- Integrates with ZW4020HJ-FHILTU300 and ZW4020HJ-FHLT300 pumps.



Product selection

Station position	Model number ¹⁾	Adjustable stroke	Oil capacity		Maximum oil flow ²⁾
			in ³		
			in	advance retract	
▼ 2 port auto coupler					
Base	WCA-62	.20 - .59	.66	.66	60
Base	WCA-82*	4.10 - 4.48	.66	.66	60
Pallet	WPA-62	—	—	—	—
▼ 4 port auto coupler					
Base	WCA-64*	.20 - .59	.66	.66	60
Pallet	WPA-64*	—	—	—	—

¹⁾ For additional pallet clearance, WCA-82 long stroke model are available.

²⁾ Maximum oil flow of coupler elements is 4.3 GPM.

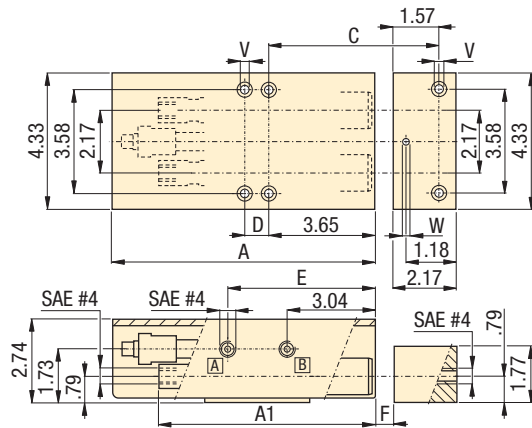
* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.



Product specifications

Model number	Required radial alignment accuracy in	Operating pressure psi	Hydraulic nozzle fitting model number (included)	Air blow-off fitting model No. (included)	Recommended alignment tool
▼ 2 port auto coupler					
WCA-62	± .02	580 - 5000	CDF-6	FZ-2050	AT-1
WCA-82	± .02	580 - 5000	CDF-6	FZ-2050	AT-2
WPA-62	± .02	580 - 5000	CDM-6	FZ-2050	AT-1
▼ 4 port auto coupler					
WCA-64	± .02	580 - 5000	CDF-6	FZ-2050	AT-1
WPA-64	± .02	580 - 5000	CDM-6	FZ-2050	AT-1

WCA-62, -82



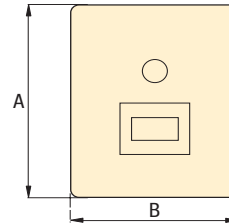
WPA-62

Model number	Voltage / Current
▼ Automatic Coupler Control Box	
ACCB-2	115 VAC / 10 A

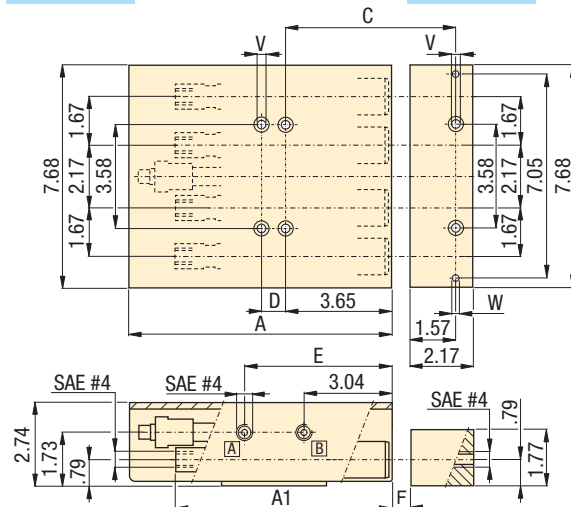
Note: Enclosure rating NEMA 12.

ACCB-2

Operator Station



WCA-64



WPA-64

Product dimensions in inches []

Model number	A	A1	B	C	D	E	F max.	V ¹⁾ for mounting bolts thread x length	W ²⁾	lbs
▼ 2 port auto couplers										
WCA-62	8.86	7.48	—	5.42	.83	5.09	.394-.413	.312-18UN x 3.00	—	16.8
WCA-82*	15.67	14.03	—	9.36	3.94	8.20	3.70	.312-18UN x 3.00	—	28.8
WPA-62	—	—	—	—	—	—	—	.375-16UN x 2.00	.23	4.0
▼ 4 port auto couplers										
WCA-64*	8.86	7.48	—	5.42	.83	5.09	.394-.413	.312-18UN x 3.00	—	29.1
WPA-64*	—	—	—	—	—	—	—	.375-16UN x 2.00	.23	6.6
▼ Automatic coupler control box ³⁾										
ACCB-2	13.78	—	11.81	—	—	—	—	—	—	30.0

¹⁾ Mounting bolts are not included. ²⁾ Drill dowel pin holes after installing WPA.

* This product is made to order. Please contact Enerpac for delivery information before specifying in your design.

Connection: 2-4 ports

Stroke: .20-4.48 inch

Pressure: 580-5000 psi

E Acopladores automáticos

F Coupleurs automatiques

D Automatische Kupplungen

Options

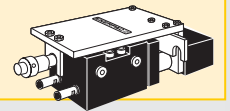
High pressure filters

157 ▶



AT series alignment tool

Use the AT series alignment tool to adjust the position of the pallet station in relation to the base station.



Hoses

156 ▶



Important

Use high pressure filters on pallet station outlet ports, to avoid contamination of pallet mounted valves and cylinders.

To guarantee leakage free connections, accurate positioning of the pallet and base stations is crucial. Carefully read the instruction manual included with the product.

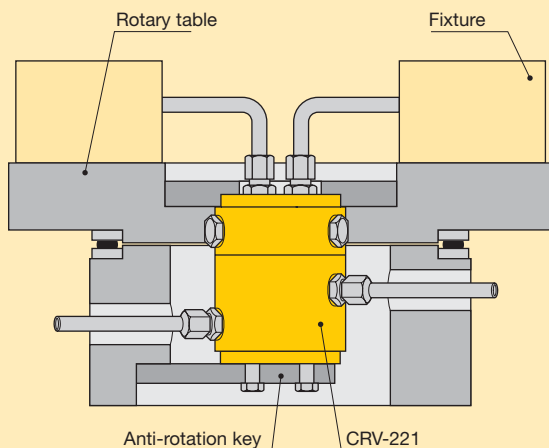
Do not couple or uncouple with the hydraulic nozzles under pressure. This could damage the internal coupler seals.

Do not exceed maximum flow and pressure.

Shown: CRV-221, CR-111



Rotary couplers are specially designed unions to transfer pressurized fluid from a stationary supply line to a rotating device. Used for workholding or clamping device such as fixtures installed on rotating index tables.

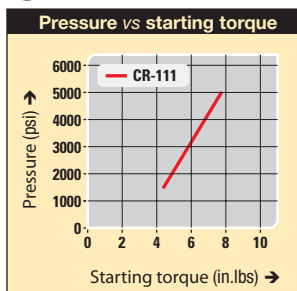


In this application eight CRV-221 rotary couplers are installed to power the individual presses of an eight station rotary press table.

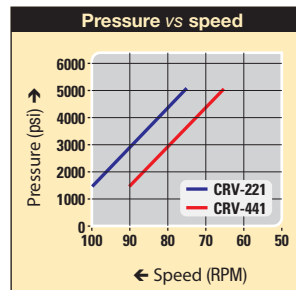
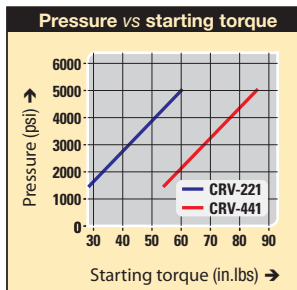
Permanent hydraulic connection on indexing and rotating work stations

- High rotation per minute
- Low starting torque
- Internal oil bearings for increased lifetime
- Manifold mounting adaptors available to reduce fixture plumbing

Starting torque and speed diagrams



Max. operating speed = 30 RPM.



Oil loss CRV-221 = 1.22 in³/h, CRV-441 = 2.44 in³/h

Product selection

No. of radial passages	Model number ¹⁾	Operating pressure range	Maximum speed		Starting torque	
			RPM		in.lbs	
		psi	1500 psi	5000 psi	1500 psi	5000 psi
1	CR-111	1500-5000	30	30	4.5	8
2	CRV-221	1500-5000	100	75	27	60
4	CRV-441	1500-5000	90	65	53	182

¹⁾ Before selecting, note the starting torque and speed diagrams above.

Manifold mounting adaptor



Mounting adaptor AMP-2, AMP-4

Mounts onto end of two and four passage rotary unions. Allows O-ring mounting directly to fixture.

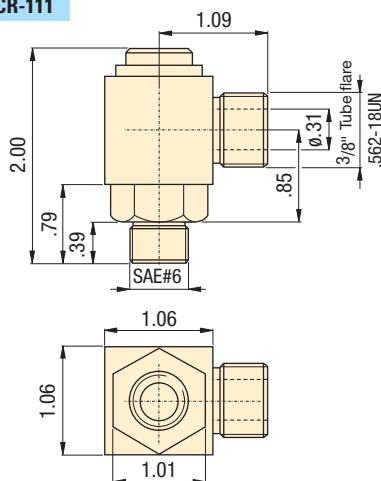
Product selection

Number of radial passages	Model number	Operating pressure range	Used with
		psi	
2	AMP-2	1500-5000	CRV-221
4	AMP-4	1500-5000	CRV-441

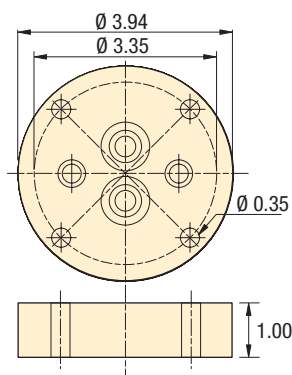
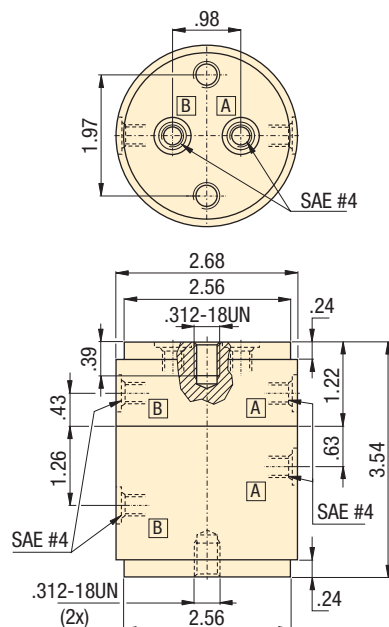


 Product dimensions in inches []

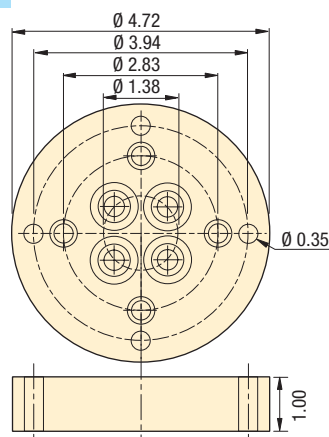
CR-111



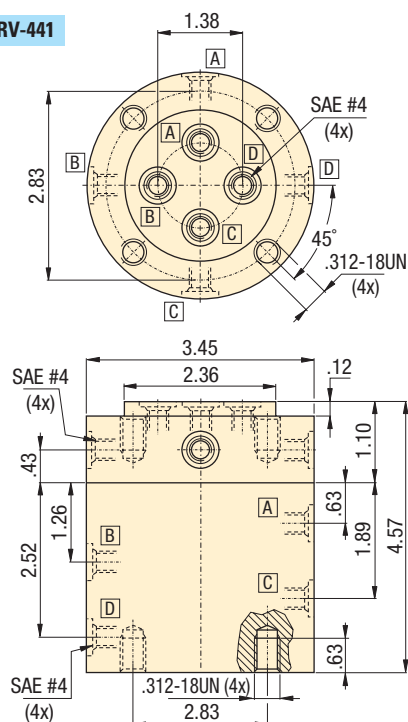
AMP-2

**CRV-221**

AMP-4



CRV-441

**Passages: 1-4 lines**

Speed: 30-100 RPM max.

Pressure: 1500-5000 psi

E Acoplamiento giratorio

F Joints tournants

D Drehdurchführungen

 **Options**

Fittings

158 ▶



Couplers

156 ▶



Hoses and couplers

156 ►



 Important

Before selecting, note the pressure versus starting torque diagrams.

Rotary couplers must be mounted in the center of rotation of the installation.

Anti-rotation keys should be utilized.

For proper application, clamp force, pressures and timing, consult Enerpac for support.

Shown: ACM-1, ACBS-22, ACL-201



► Enerpac accumulators supply auxiliary pressure to dampen shock loads or to compensate pressure drop in applications where system pressure needs to be maintained.

Accumulator packages will help maintain system pressure to your fixture when separated from the hydraulic source. The gauge will display system pressure after the circuit is disconnected.

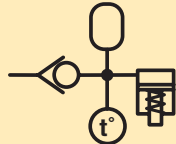
Accumulator applications:

- Energy storage
- Circuit pulsation dampening
- Thermal expansion compensation

Pulse dampening



Thermal expansion



■ ACBS-202 Accumulator package used to maintain pressure on a machine tool fixture



Accumulators

...maintain circuit pressure

- Ideal for high frequency and rapid discharge applications
- ACL series are pre-charged to 1450 psi
- Corrosion resistant bodies on ACL series
- Spring actuated accumulator for ACM-1
- High energy storage capacity in a compact package

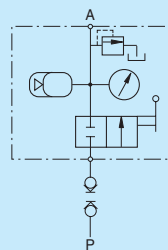
Accumulator coupler packages

...compact design for easy use of accumulators

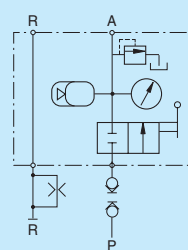
- Single design accommodates both single-acting or double-acting circuit
- Relief valve fitted and ball check shut-off
- Glycerin-filled gauge included
- Supplied standard with one male coupler (AH-652)
- Optional manifold mounting. O-ring seals located on bottom of block only for single-acting circuit

i Accumulator coupler package circuits

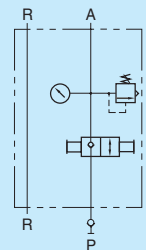
Single-acting circuit
ACBS series



Double-acting circuit
ACBS series



Single- or
double-acting circuit
AP-500



Product selection

Operating pressure	Model number	Max. rated oil volume	Gas volume	Pre-charged nitrogen pressure	Usable oil capacity
psi		in ³	in ³	psi	in ³ at 5000 psi

▼ Pre-charged accumulators

0-3000	ACM-1	.10	—	—	—
1500-5000	ACL-21A	.90	1.22	1450	.53
1500-5000	ACL-201A	7.70	10.37	1450	4.51
1500-5000	ACL-502A	20.60	27.46	1450	12.0

▼ Accumulator coupler packages

1500-5000	ACBS-22A	0.90	1.22	1450	.53
1500-5000	ACBS-202A	7.70	10.37	1450	4.51
0-5000	AP-500	AP-500 uses WA-502 or WA-5010			

▼ Uncharged accumulators

0-5000 ¹⁾	WA-502	2.50	2.50	—	2.50
0-5000 ¹⁾	WA-5010	10.00	10.00	—	7.50

¹⁾ See pre-charge chart on the next page for hydraulic operating pressures.

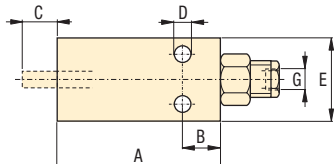


Recommended pre-charge

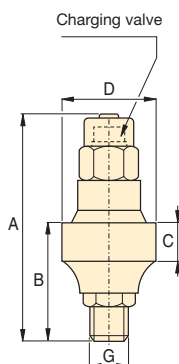
Operating pressure psi	Model number	Nitrogen pressure psi	Usable oil capacity ¹⁾ in ³
0-1000	WA-502	500	1.50
1000-3000	WA-502	1000	2.00
3000-5000	WA-502	1200	2.50
0-1000	WA-5010	500	5.50
1000-3000	WA-5010	1000	6.50
3000-5000	WA-5010	1200	7.50

¹⁾ At maximum operating pressure.

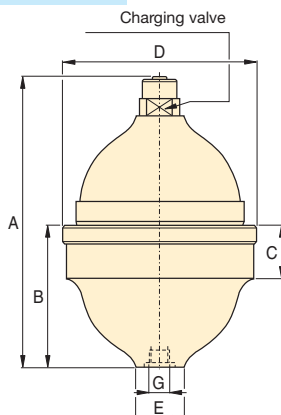
ACM-1



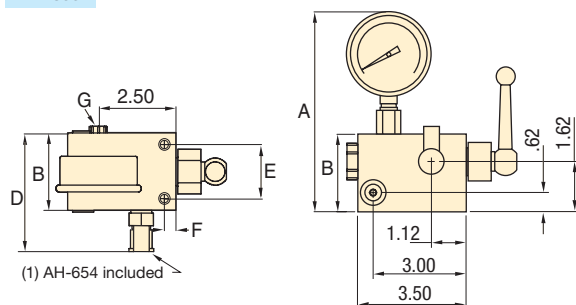
ACL-21A



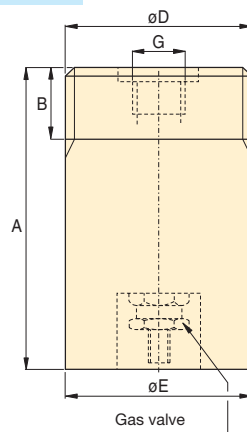
ACL-201A, 502A



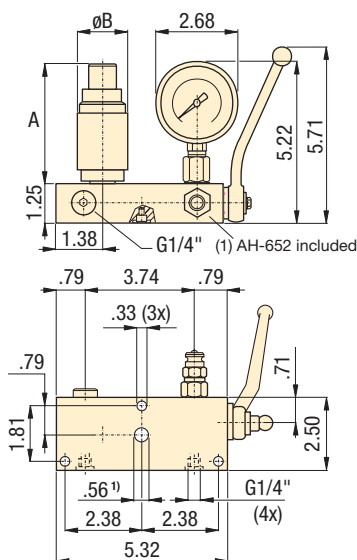
AP-500



WA



ACBS



¹⁾ Manifold hole should not exceed Ø .30 inch when port is utilized.

Pressure: 0-5000 psi

Oil volume: .10-20.60 in³

Gas volume: 1.22-27.46 in³

E Acumuladores

F Accumulateurs

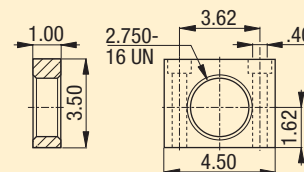
D Druckspeicher



Options

AW-50 Mounting block

For WA series accumulators.



Couplers

156 ▶



High pressure filters

157 ▶



Hydraulic oil

157 ▶



Fittings

158 ▶



Product dimensions in inches []

Model number	A	B	C	D	E	F	G	Recommended charging tool	lbs
▼ Pre-charged accumulators									
ACM-1	5.25	.75	.50	.265	1.75	—	.125-27 NPT	—	2.1
ACL-21A	4.14	1.46	.71	1.69	—	—	SAE #4	WAT-2	1.0
ACL-201A	5.39	2.72	1.14	3.33	1.14	—	SAE #6	WAT-2	2.7
ACL-502A	6.73	3.50	1.38	4.49	1.57	—	G3/8"	WAT-2	6.2
▼ Pre-charged accumulator coupler packages									
ACBS-22A	2.69	1.65	—	—	—	—	G1/4"	WAT-2	10.1
ACBS-202A	4.18	3.33	—	—	—	—	G1/4"	WAT-2	11.8
AP-500	6.44	2.50	3.50	3.84	1.75	0.38	SAE #4	WAT-2	11.8
▼ Uncharged accumulators									
WA-502	4.69	1.19	—	2.750-16 UN	2.75	—	SAE #8	WAT-1	7.0
WA-5010	7.13	1.19	—	2.750-16 UN	2.75	—	SAE #8	WAT-1	11.5

Important

Enerpac high pressure in-line filters are required for use with these control units to prevent damage that can be caused by contaminants that have penetrated your hydraulic fluid system.

Order an additional male coupler (AH-652 or AH-654) for use in double-acting hydraulic circuits.

Shown: PSCK-8, IC-51



Enerpac remote mounted pressure switches monitor the hydraulic system to determine any change of pressure. The signal can then be used to control the pump, or other peripheral devices.

IC-series

The IC-series electrical pressure switches provide pressure readings for monitoring and/or control of hydraulic system pressure in workholding systems.

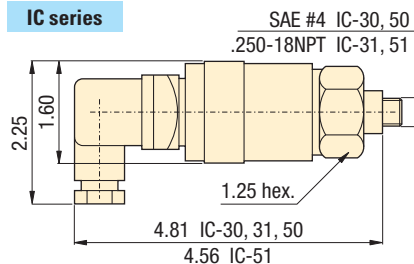
Integrated in your hydraulic system, the pressure switch can be used to automate your clamping cycles.



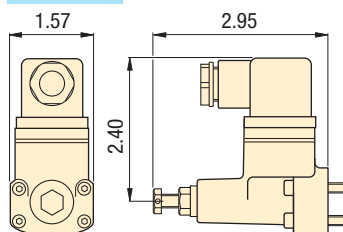
Reliable electrical control of hydraulic power

- Compact design minimizes space requirements on fixture
- Switch is easily adjustable to meet system requirements

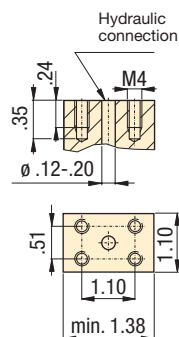
IC series



PSCK-8, 9



mounting dimensions



Pressure: 500-7500 psi

Accuracy: 2%

- (E) Presostatos
- (F) Pressostats
- (D) Druckschalter



Options

Fittings

158 ▶



Gauges

154 ▶



Important

Do not exceed the maximum pressure.

Product selection

Adjustable pressure range	Electrical specifications	Model number	Deadband	Switch point repeatability	Oil port	
psi	at 50/60 Hz		psi	% of range		lb
▼ Electrical pressure switches						
500-3500	125 VAC @ 5 A	IC-30	100 - 500	+/-2	SAE #4	1.0
500-3500	125 VAC @ 5 A	IC-31	100 - 500	+/-2	.250-18 NPT	1.0
3000-7500	125 VAC @ 5 A	IC-50	250 - 800	+/-2	SAE #4	1.0
3000-7500	125 VAC @ 5 A	IC-51	250 - 800	+/-2	.250-18 NPT	1.0
1450-5000	115 VAC @ 2 A	PSCK-8	250 - 800	+/-2	Manifold mount	0.8
290-3045	115 VAC @ 2 A	PSCK-9	250 - 800	+/-2	Manifold mount	0.8

¹⁾ Electrical harness included with kit.

Pressure: 0-15,000 psi

Accuracy: $\pm 0.2\%$

Voltage: 3 VDC (battery)

E Manómetros digitales

F Manomètres digitaux

D Digitale Manometer

Options

Fittings

158 ▶

Gauge adaptors

155 ▶

Easy and precise pressure monitoring

DGR-1

- Rated for system pressure up to 15,000 psi
- Displays in psi, bar, MPa, kPa, mbar/hPa
- Zero reset – ensures that gauge reads actual system pressure
- Protective cover can be ordered separately
- 3 VDC battery included – DGR-1B
 - 1400 hours continuous operation in standard mode
 - IP65 protection
- Two modes
 - Automatic shut off (15 min)
 - Continuous display

Important

Do not exceed the maximum pressure.

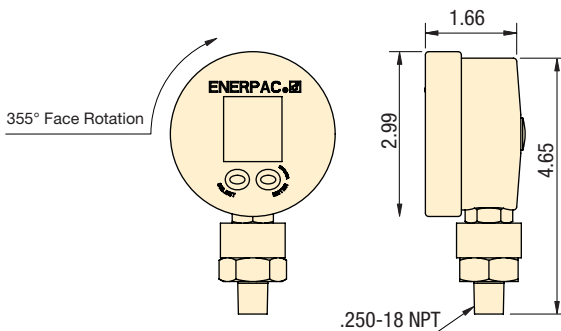
Gauges can be easily plugged into the hydraulic system using GA-3 gauge adaptor.

Protective Cover

Fits over face of gauge for protection in harsh environments.
Order Model No. **DGR-1PC**.

Replacement Battery

Spare battery for preventative maintenance program. Battery has 1400 hours of life in continuous operation.
Order Model No. **DGR-1B**



Shown: DGR-1



E Enerpac digital pressure gauges offer greater accuracy and are easier to read than conventional dial gauges, greatly enhancing your ability to monitor and control hydraulic system pressure.

DGR-1 Remote Operation

Battery operated for additional flexibility. Includes maximum and minimum pressure capture.

Product selection

Pressure rating		Model number	Pressure rating		Pressure rating		Pressure rating		Pressure rating		
psi			bar		kPa		MPa		mbar		
Range	Interval		Range	Interval	Range	Interval	Range	Interval	Range	Interval	
0-15.000	3	DGR-1	0-1000	0.2	0-20.000	20	0-100	0.02	0-20.000	200	0.5

Pressure gauges and accessories *Application & selection*

Shown: GS-2, G-2512L, GS-3



Enerpac gauges provide a safe and inexpensive monitoring system for your hydraulic circuit

Highly reliable and accurate pressure sensing

- $\pm 1.5\%$ accuracy of full scale
- All pressure sensing parts sealed and dampened by glycerine for long life
- Includes safety blow-out disk and pressure equalizing membrane to prevent overpressurization
- Copper alloy, coiled safety Bourdon tube for 1000 psi and higher
- Dual psi and bar scale readings, 2.5 inch gauge face

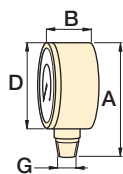
Gauge accessories for easy installation

- Needle valves providing positive shut-off
- 303 stainless steel stem (NV-25)
- Snubber valves to control pressure surges between gauge and hydraulic system
- Gauge adaptors – male end screws into pump or cylinder, female port accepts hose or coupler, the third port is for gauge connection
- FM-25NG for panel mounting of 2.50 inch diameter gauges

Product selection

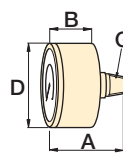
Pressure gauge mounting style	Pressure range		Model number	PSI graduation		Bar graduation		A	B	D	G
	psi	bar		Major psi	Minor psi	Major bar	Minor bar	in	in	in	

▼ Pressure gauge – Lower mount



0-100	0-7	G-2509L	10	2	1	0.01	3.31	1.46	2.50	1/4" NPT
0-160	0-11	G-2510L	10	2	1	0.02	3.31	1.46	2.50	1/4" NPT
0-200	0-14	G-2511L	50	5	1	0.02	3.31	1.46	2.50	1/4" NPT
0-300	0-20	G-2512L	50	5	5	0.05	3.31	1.46	2.50	1/4" NPT
0-600	0-40	G-2513L	100	10	10	1	3.31	1.46	2.50	1/4" NPT
0-1000	0-70	G-2514L	100	20	10	1	3.31	1.46	2.50	1/4" NPT
0-2000	0-140	G-2515L	500	50	10	2	3.31	1.46	2.50	1/4" NPT
0-3000	0-200	G-2516L	500	50	50	5	3.31	1.46	2.50	1/4" NPT
0-6000	0-400	G-2517L	1000	100	100	10	3.31	1.46	2.50	1/4" NPT
0-10,000	0-700	G-2535L	2000	200	100	10	3.31	1.46	2.50	1/4" NPT
0-1000	0-70	G-2514SL	100	20	10	1	3.66	1.23	2.50	SAE#4
0-3000	0-200	G-2516SL	500	50	50	5	3.66	1.23	2.50	SAE#4
0-6000	0-400	G-2517SL	1000	100	100	10	3.66	1.23	2.50	SAE#4
0-10,000	0-700	G-2535SL	2000	200	100	10	3.66	1.23	2.50	SAE#4

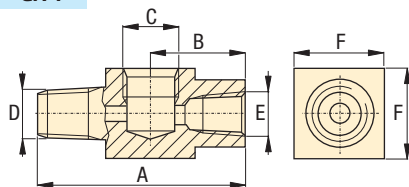
▼ Pressure gauge – Rear mount



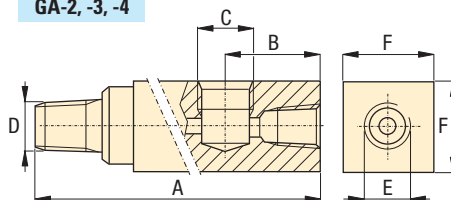
0-1000	0-70	G-2531R	100	20	10	1	2.48	1.46	2.50	1/4" NPT
0-6000	0-400	G-2534R	1000	100	100	10	2.48	1.46	2.50	1/4" NPT
0-10,000	0-700	G-2537R	2000	200	100	10	2.48	1.46	2.50	1/4" NPT
0-1000	0-70	G-2531SR	100	20	10	1	2.46	1.23	2.50	SAE #4
0-3000	0-200	G-2533SR	500	50	50	5	2.46	1.23	2.50	SAE #4
0-6000	0-400	G-2534SR	1000	100	100	10	2.46	1.23	2.50	SAE #4
0-10,000	0-700	G-2537SR	2000	200	100	10	2.46	1.23	2.50	SAE #4
0-1000	0-70	1531R	100	20	10	1	1.99	0.98	1.50	1/8" NPT
0-3000	0-200	1533R	500	100	50	10	1.99	0.98	1.50	1/8" NPT
0-6000	0-400	1534R	1000	100	100	10	1.99	0.98	1.50	1/8" NPT
0-10,000	0-700	1537R	2000	200	100	10	1.99	0.98	1.50	1/8" NPT



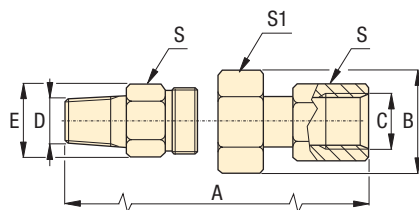
GA-1



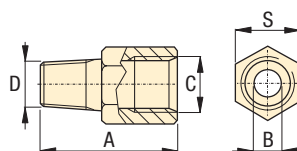
GA-2, -3, -4



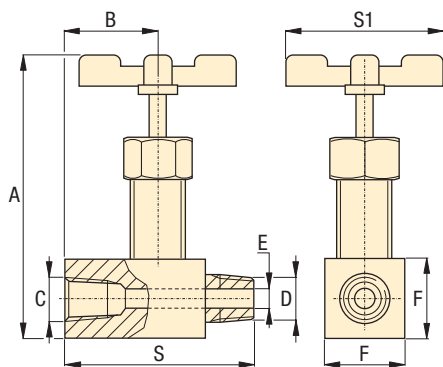
GA-918



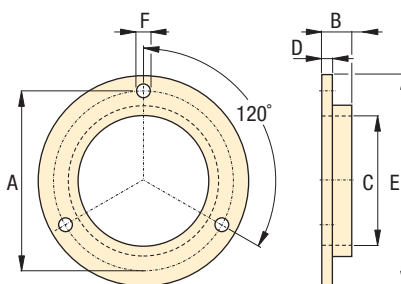
GS-2, -3



NV-25, V-9



FM-25NG



Product dimensions in inches []

Gauge port NPT	Max. pressure psi	Model number	Dimensions							
			A	B	C	D	E	F	S	S1
▼ Gauge adaptors										
1/2"	10,000	GA-1	2.81	1.24	1/2"NPT	3/8"NPT	3/8"NPT	1.25	–	–
1/2"	10,000	GA-2	6.10	1.38	1/2"NPT	3/8"NPT	3/8"NPT	1.25	–	–
1/4"	10,000	GA-3	5.25	1.38	1/4"NPT	3/8"NPT	3/8"NPT	1.25	–	–
1/2"	10,000	GA-4	4.38	1.38	1/2"NPT	1/4"NPT	3/8"NPT	1.25	–	–
▼ Swivel gauge adaptor										
1/2"	10,000	GA-918	2.25	1.72	1/2"NPT	1/2"NPT	1.30	–	1.13	1.50
▼ Gauge shut-off valves										
1/4"	10,000	NV-25	3.50	1.06	1/4"NPT	1/4"NPT	2.50	.88	2.13	2.50
1/2"	10,000	V-9	3.63	1.25	1/2"NPT	1/2"NPT	2.50	1.00	2.13	2.50
▼ Gauge snubber valves										
1/4"	5000	GS-2	1.63	.018	1/4"NPT	SAE #4	–	–	.75	–
1/4"	5000	GS-3	1.63	.018	1/4"NPT	G1/4"	–	–	.75	–
▼ Flange mounting for panel mounting of G series gauges										
–	–	FM-25NG	2.95	.17	2.51	.07	3.35	.14	–	–

Pressure: 0-10,000 psi

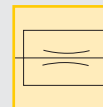
Accuracy: 1.5% /full scale

Gauge face: ø 2.5 inch

E Manómetros

F Manomètres

D Manometer



Options

Hoses and
couplers

156 ▶



Digital gauges

153 ▶



Pressure
switches

152 ▶



V-10 Auto
Damper® valve

140 ▶



Important

Do not exceed
maximum pressure.

Gauge snubbers or needle
valves are recommended for
high cycle applications.

Do not keep gauges
under permanent pressure.
The use of shut-off valves is
recommended.

For basic system set-up
information, refer to our
"Yellow Pages" section.

161 ▶

Manifolds, couplers, hoses, tubing

Shown: HLS, HF, AH, AR, FL, T, A-series



Use genuine Enerpac manifolds, couplers, hoses and tubings to connect your workholding cylinders or fixtures to the hydraulic power source.

A series, Manifolds

For multiple hydraulic line connections at one central location directing oil to or from a pressure source.

AH/AR series, Couplers

Quick disconnect low leakage couplers for easy connection of hydraulic circuits.

HLS series, Hoses

High pressure hydraulic hoses, featuring a heavy-duty protective plastic coating.

T series, Tubing

High pressure steel tubing, available in 5 ft. lengths.

Manifolds

- Easy to connect
- Mounting holes on all models

Couplers

- Spee-D-Coupler® design allows cylinder to be connected and disconnected in seconds
- For more safety: couplers cannot be connected or disconnected while under hydraulic pressure

Hydraulic hoses and tubings

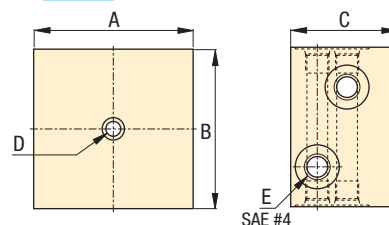
- Heavy-duty coating for abrasion resistance
- Resistant against mineral based hydraulic oil as well as water glycols
- High pressure steel tubing for permanent installations

Important

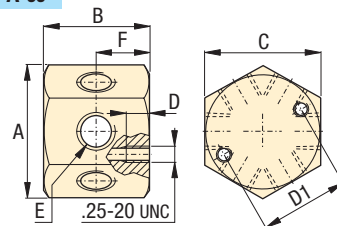
Do not exceed the maximum pressure.

Inspect hoses and tubing frequently and replace as required.

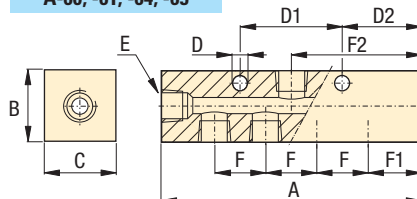
A-63



A-66



A-60, -61, -64, -65



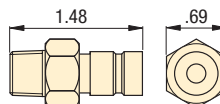
Manifolds dimensions in inches []

Number of ports	Model number	A	B	C	D	D1	D2	E	F	F1	F2	lbs
2 x 4	A-63	3.00	3.00	2.00	.25	—	—	SAE #4	—	—	—	2.0
5	A-60	3.50	1.25	1.25	.28	1.50	1.00	SAE #4	1.50	1.00	1.75	1.0
7	A-61	6.50	1.25	1.25	.28	1.50	1.25	SAE #4	1.00	1.25	3.25	1.4
7	A-64	7.00	1.25	1.25	.25	3.00	1.25	.375-18 NPT	1.50	1.25	3.50	3.3
7	A-65	14.5	1.25	1.25	.25	8.00	1.25	.375-18 NPT	4.00	1.25	7.25	6.1
6	A-66	2.30	1.63	2.00	.52	1.50	—	.375-18 NPT	—	—	—	1.8

Couplers

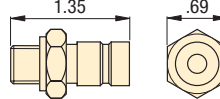
AH-650

Male coupler half
.250-18 NPT



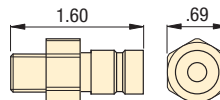
AH-652

Male coupler half
G1/4" BSPP



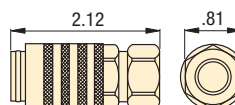
AH-654

Male coupler half
SAE #4 .437-20 UNF



AR-650

Female coupler half
.250-18 NPT



Hoses

Length ft	Model number	Internal diameter in	Maximum pressure psi
▼ 1/4", 37° flare			
1	HLS-512	.19	5000
2	HLS-524	.19	5000
3	HLS-536	.19	5000
4	HLS-548	.19	5000
5	HLS-560	.19	5000
10	HLS-5120	.19	5000
▼ 3/8" NPT			
3	H-9203	.25	10,000
6	H-9206	.25	10,000
10	H-9210	.25	10,000

Tubing

Length ft	Model number	Internal diameter in	External diameter in	Maximum pressure psi
5	T-2560	.152	.25	5000

Options

Fittings

158 ▶





High-pressure filters

- Keep your hydraulic system clean
- Pleated stainless steel wire mesh screen construction provides large filter area in a compact size
- Rated for full system pressure up to 5000 psi
- Bi-directional design allows filtration of oil in either flow direction
- Two piece body construction for easy replacement of filter elements
- High flow rates are obtainable with a minimum pressure drop
- Threaded port connections on each end simplify installation

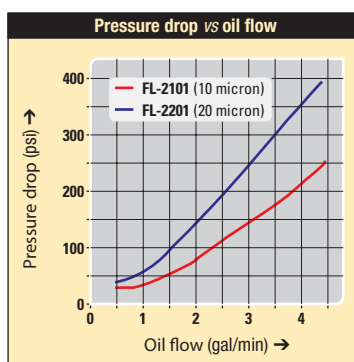
Hydraulic oil

- Ensures effective lubricity
- Protects essential parts

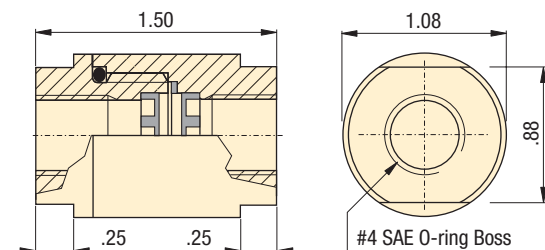
Filtration

20 micron filter provides the longest service life before element replacement

10 micron filter recommended for more sensitive hydraulic components



FL series



High in line pressure filters

Model number	Filtration		Filter element set	
	Nominal	Absolute		
FL-2101	10	25	FL-2101K	.4
FL-2201	20	40	FL-2201K	.4

Hydraulic oil

Contents	Model number	Specifications genuine Enerpac hydraulic oil			
Gal					
.25	HF-100	0 °F	<12,000 S.U.S	Flash, C.O.C.	400°F
1	HF-101	100 °F	150/165 S.U.S	Pour point	-25 °F
5	HF-102	210 °F	42/45 S.U.S	Aniline point	210/220 °F
55	HF-104				

Note: Viscosity index: 100 min

- E** Mangueras, Filtros Acoplamiento, Aceite
- F** Flexibles, Filtres Raccords, Huile
- D** Schläuche, Filter Kupplungen, Öl

High-pressure filters

Compact in line high pressure filters prevent chips and debris that have entered the hydraulic fluid system from damaging hydraulic system components.

Hydraulic oil

Use only genuine Enerpac hydraulic oil to guarantee optimal performance and long life of your hydraulic equipment.

Options

Fittings

158 ▶



Important

Do not exceed the maximum pressure.

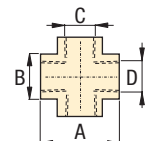
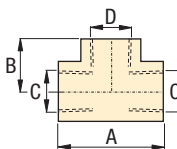
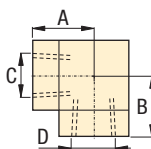
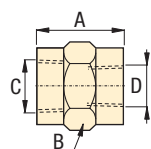
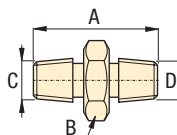
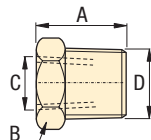
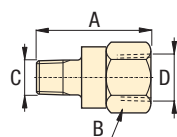
Hydraulic power is distributed by manifolds and transported by hoses and tubing.



Shown: FZ-2023, -2054, -2052



▶ Fittings are used to connect all cylinders, components, power sources, tubes, gauges and hoses in a hydraulic system. Enerpac fittings provide flexible, safe and leak-free connections.



■ Multiple hydraulic line connections are easily installed with Enerpac fittings and manifolds.



Proper connection for hydraulic components

- Male and female BSPP, UNF, NPT threaded fittings in common sizes allow easy connection of all components.
- BFZ and FZ-1000 models are 10,000 psi maximum pressure
- FZ-2000 models are 5000 psi maximum pressure

Product selection

From	To	Max. pressure	Model number	Dimensions			
				A	B	C	D
		psi					
▼ Adapters							
Female	Male						
1/4" NPT	1/8" NPT	10,000	FZ-1642	1.18	3/4"	1/8" NPT	1/4" NPT
3/8" NPT	1/4" NPT	10,000	FZ-1055	1.75	15/16"	1/4" NPT	3/8" NPT
1/2" NPT	1/4" NPT	10,000	FZ-1633	1.69	1 1/8"	1/4" NPT	1/2" NPT
1/2" NPT	3/8" NPT	10,000	FZ-1634	1.69	1 1/8"	3/8" NPT	1/2" NPT
1/4" NPT	SAE #8	5000	FZ-2067	1.06	7/8"	3/4"-16	1/4" NPT
3/8" NPT	SAE #8	5000	FZ-2069	1.22	7/8"	3/4"-16	3/8" NPT
▼ Reducers							
Female	Male						
1/4" NPT	3/8" NPT	10,000	FZ-1630	.75	9/16"	1/4" NPT	3/8" NPT
1/4" NPT	1/2" NPT	10,000	FZ-1661	1.09	7/8"	1/4" NPT	1/2" NPT
SAE #6	SAE #8	5000	FZ-2029	1.38	1 1/16"	3/4"-16	9/16"-18
▼ NPT Male Nipples							
1/4" NPT	1/4" NPT	10,000	FZ-1608	1.50	9/16"	1/4" NPT	1/4" NPT
3/8" NPT	3/8" NPT	10,000	FZ-1617	1.50	3/4"	3/8" NPT	3/8" NPT
3/8" NPT	3/8" NPT	10,000	FZ-1619	2.00	3/4"	3/8" NPT	3/8" NPT
3/8" NPT	G1/4"	10,000	BFZ-305	1.42	3/4"	3/8" NPT	G1/4"
▼ NPT Female Connectors							
1/4" NPT	1/4" NPT	10,000	FZ-1605	1.10	3/4"	1/4" NPT	1/4" NPT
3/8" NPT	1/4" NPT	10,000	FZ-1615	1.13	1"	3/8" NPT	1/4" NPT
3/8" NPT	3/8" NPT	10,000	FZ-1614	1.44	15/16"	3/8" NPT	3/8" NPT
1/2" NPT	3/8" NPT	10,000	FZ-1625	1.88	29 mm	1/2" NPT	3/8" NPT
▼ NPT Elbows							
1/4" NPT	1/4" NPT	10,000	FZ-1638	1.42	.94	1/4" NPT	1/4" NPT
3/8" NPT	3/8" NPT	10,000	FZ-1610	1.31	.81	3/8" NPT	3/8" NPT
▼ NPT Tee							
1/4" NPT	1/4" NPT	10,000	FZ-1637	1.77	.94	1/4" NPT	1/4" NPT
3/8" NPT	3/8" NPT	10,000	FZ-1612	1.77	1.00	3/8" NPT	3/8" NPT
▼ NPT Cross							
3/8" NPT	3/8" NPT	10,000	FZ-1613	1.77	1.00	3/8" NPT	3/8" NPT



Product selection

From	To	Max. pressure	Model number	Dimensions in inches			
		psi		A	B	C	D

▼ Adapters

Male	Female						
1/8" NPT	SAE #4	5000	FZ-2075	1.06	11/16"	1/8" NPT	7/16"-20
1/4" NPT	SAE #4	5000	FZ-2042	1.31	11/16"	1/4" NPT	7/16"-20
1/4" NPT	G1/4"	10,000	BFZ-16411	1.38	3/4"	1/4" NPT	G1/4"
SAE #4	1/8" NPT	5000	FZ-2008	.97	9/16"	7/16"-20	1/8" NPT
SAE #4	1/4" NPT	5000	FZ-2007	1.14	3/4"	7/16"-20	1/4" NPT
SAE #2	SAE #4	5000	FZ-2022	1.13	11/16"	5/16"-24	7/16"-20
SAE #6	1/4" NPT	5000	FZ-2056	1.16	3/4"	9/16"-18	1/4" NPT
SAE #8	1/4" NPT	5000	FZ-2067	1.13	7/8"	3/4"-16	1/4" NPT
SAE #8	3/8" NPT	5000	FZ-2069	1.28	7/8"	3/4"-16	3/8" NPT
G 1/8"	1/8" NPT	5000	FZ-2055	.95	3/4"	G 1/8"	1/8" NPT
G 1/8"	1/4" NPT	5000	FZ-2060	1.21	3/4"	G 1/8"	1/4" NPT
G 1/8"	#4 SAE	5000	FZ-2066	1.00	11/16"	G 1/8"	7/16"-20
G 1/4"	1/4" NPT	5000	FZ-2023	1.26	7/8"	G 1/4"	1/4" NPT
G 1/4"	#4 SAE	5000	FZ-2065	1.11	3/4"	G 1/4"	7/16"-20

▼ Straight union

SAE #4	SAE #4	5000	FZ-2005	1.22	9/16"	7/16"-20	7/16"-20
SAE #6	SAE #6	5000	FZ-2028	1.41	11/16"	9/16"-18	9/16"-18
SAE #8	SAE #8	5000	FZ-2040	1.17	7/8"	3/4"-16	3/4"-16

▼ Straight union to tube ends

ø.25	ø.25	5000	FZ-2033*	1.38	9/16"	7/16"-20	7/16"-20
ø.25	ø.25	5000	FZ-2013**	1.19	9/16"	ø.25**	ø.25

▼ Adaptors to tube end

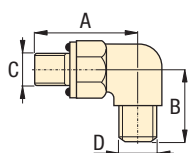
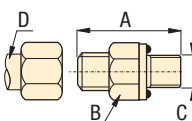
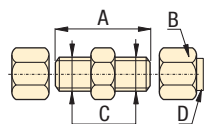
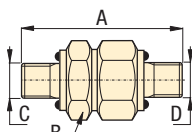
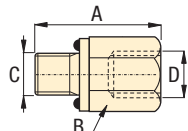
Male	Tube size						
1/8" NPT	ø.25	5000	R-1054*	1.28	1/2"	1/8" NPT	ø.25
1/4" NPT	ø.25	5000	FZ-2020*	1.41	9/16"	1/4" NPT	ø.25
1/4" NPT	ø.375	5000	FZ-2072*	1.43	9/16"	1/4" NPT	ø.375
1/4" NPT	ø.25	5000	FZ-2012**	1.33	9/16"	1/4" NPT	ø.25
3/8" NPT	ø.25	5000	FZ-2061*	1.44	3/4"	3/8" NPT	ø.25
3/8" NPT	ø.375	5000	FZ-2068*	1.44	3/4"	3/8" NPT	ø.375
SAE #2	ø.25	5000	FZ-2025*	1.24	9/16"	5/16"-24	ø.25
SAE #4	ø.25	5000	FZ-2019*	1.22	9/16"	7/16"-20	ø.25
SAE #4	ø.25	5000	FZ-2001**	1.13	9/16"	7/16"-20	ø.25
SAE #6	ø.25	5000	FZ-2059*	1.30	11/16"	9/16"-18	ø.25
SAE #8	ø.25	5000	FZ-2039*	1.37	7/8"	3/4"-16	ø.25
SAE #8	ø.375	5000	FZ-2070*	1.38	7/8"	3/4"-16	ø.375
G1/8"	ø.25	5000	FZ-2053*	1.18	16 mm	G1/8"	ø.25
G1/4"	ø.25	5000	FZ-2054*	1.26	19 mm	G1/4"	ø.25
G1/4"	ø.375	5000	FZ-2064*	1.42	22 mm	G1/4"	ø.375

▼ Elbow to tube end

Male	Tube size						
11/8" NPT	ø.25	5000	FZ-2074*	.78	0.89	1/8" NPT	ø.25
1/4" NPT	ø.25	5000	FZ-2073*	1.09	1.05	1/4" NPT	ø.25
1/4" NPT	ø.375	5000	FZ-2072*	1.09	1.06	1/4" NPT	ø.375
1/4" NPT	ø.25	5000	FZ-2076**	1.09	1.03	1/4" NPT	ø.25
SAE #2	ø.25	5000	FZ-2024*	.92	0.89	5/16"-24	ø.25
SAE #4	ø.25	5000	FZ-2035*	1.03	0.89	7/16"-20	ø.25
SAE #4	ø.25	5000	FZ-2002**	1.03	0.89	7/16"-20	ø.25
SAE #8	ø.375	5000	FZ-2071*	1.36	1.25	3/4"-16	ø.375
G1/8"	ø.25	5000	FZ-2051*	.89	1.03	G1/8"	ø.25
G1/4"	ø.25	5000	FZ-2052*	1.25	0.89	G1/4"	ø.25
ø.25**	ø.25	5000	FZ-2014**	.89	.89	ø.25**	ø.25

*Flared

**Flareless



Pressure: 0-10,000 psi

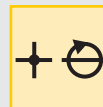
Threads: NPT, UNF, BSPP

For tubing: .25 inch / 8mm

E Acoplamiento

F Raccords

D Verschraubungen



Options

Gauges

154 ▶



Manifolds, couplers, hoses, tubing

156 ▶



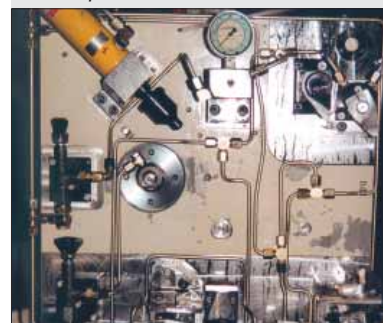
! Important

Do not exceed the maximum pressure.

Use fittings and tubing in high cycle applications and areas having excessive heat or weld splatter.

To seal NPT threads use anaerobic thread sealers or Teflon paste. apply Teflon tape one thread from the end of the fitting, to prevent it from winding up in the hydraulic system.

High pressure hydraulic fittings allow connection of many components with minimum effort.



Pressure: 0-5000 psi

Threads: NPT, UNF, BSPP

For tubing: .25 inch / 8mm

- E** Acoplamiento
- F** Raccords
- D** Verschraubungen



Options

Manifolds,
couplers,
hoses, tubing

156 ▶



Important

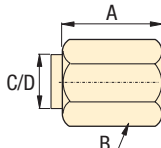
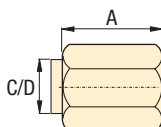
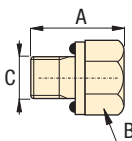
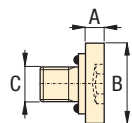
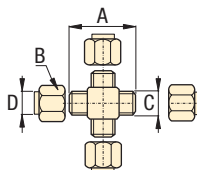
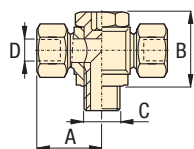
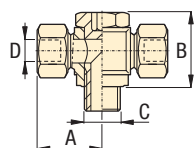
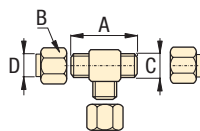
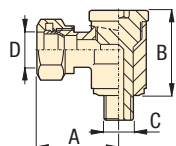
Do not exceed
maximum pressure.

Use fittings and tubing in
high cycle applications and
areas having excessive heat
or weld splatter.

High pressure fittings enable the
design of hydraulic systems to
meet a variety of applications.



90-000



Product selection

From	To	Max. pressure	Model number	Dimensions in inches			
psi				A	B	C	D
▼ Swivel banjo BSPP to tube							
Male	Tube size						
G1/4"	ø 8mm	10,000	BFZ-307	1.10	1.18	G1/4"	ø 8mm
▼ Union tee							
ø.25	ø.25	5000	FZ-2021*	1.78	0.89	7/16"-20	ø.25
ø.25	ø.25	5000	FZ-2015**	1.78	0.89	7/16"-20	ø.25
▼ Branch tee							
Male	Tube size						
SAE #4	ø.25	5000	FZ-2036*	1.78	1.03	7/16"-20	ø.25
SAE #4	ø.25	5000	FZ-2004**	1.78	1.03	7/16"-20	ø.25
▼ Swivel T-banjo BSPP to tube							
Male	Tube size						
G 1/4"	ø 8mm	10,000	BFZ-309	1.10	1.18	G 1/4"	ø 8mm
▼ Cross							
ø.25	ø.25	5000	FZ-2034*	1.78	9/16"	7/16"-20	ø.25
ø.25	ø.25	5000	FZ-2016**	1.78	9/16"	ø.25	ø.25
▼ SAE Plug							
SAE #4		5000	FZ-2006	.10	.56	7/16"-20	
SAE #6		5000	FZ-2003	.10	.69	9/16"-18	
▼ SAE Hex Plug							
SAE #8		5000	FZ-2041	.73	7/8"	3/4"-16	
▼ Nut and Sleeve for Tubing							
ø.25		5000	FZ-2037*	.61	9/16"	37°	ø.25
▼ Cap for Tubing							
ø.25		5000	FZ-2038*	.67	9/16"	37°	ø.25
ø.25		5000	FZ-2017**	.73	9/16"	ø.25	ø.25
ø.375		5000	FZ-2011*	.81	11/16"	37°	ø.375

*Flared

**Flareless



Enerpac "Yellow Pages" *stand for* Hydraulic Information!

If selecting hydraulic equipment is not your daily routine, then you will appreciate these pages. The "Yellow Pages" are designed to help you work with hydraulics. They will help you better understand the basics of hydraulic system set-ups and the most commonly used hydraulic techniques. By making an educated selection of equipment, you will receive greater benefits from your hydraulic system.

Take the time to go through these "Yellow Pages" and you will benefit even more from Enerpac hydraulic workholding.

GLOBAL LIFETIME WARRANTY STATEMENT



www.enerpac.com

Visit our web site for the complete Global Lifetime Warranty or call your Authorized Service Center.

Enerpac products are warranted to be free of defects in materials and workmanship. Any product that does not conform to specification will be repaired or replaced at Enerpac's expense, anywhere in the world; simple as that!

This warranty does not cover ordinary wear and tear, abuse, misuse, alterations, or the use of improper fluids. Determination of the authenticity of a warranty claim will be made only by Enerpac or its Authorized Service Centers.

Enerpac is certified for several quality standards. These standards require compliance with standards for management, administration, product development and manufacturing.



Enerpac worked hard to earn the quality rating ISO 9001, in its ongoing pursuit of excellence.

UL approved

All electrical components used on Enerpac products carry the UL rating when possible.

Index

▼ page

Safety instructions

162 - 163

Basic hydraulics

164 - 165

Basic system set-up

166 - 169

Clamping technology

170 - 173

Cutting tool technology

174 - 176

Conversion factors and
hydraulic symbols

177 - 183

Valving technology

184 - 187



Flexible machining systems

188 - 189

Converting from mechanical clamping
to hydraulic clamping

190 - 192

Canadian Standards Association



Where specified, Enerpac electric pump assemblies meet the design, assembly and test requirements of the Canadian Standards Association.

Product Design Criteria

All hydraulic components are designed and tested to be safe for use at maximum 350 bar/5,000 psi pressure unless otherwise specifically noted.

EMC Directive 89/336/EEC

Where specified, Enerpac electric power pumps meet the requirements for Electromagnetic Compatibility per EMC Directive 89/336/EEC.

World Standard Guarantee



All Enerpac products are guaranteed against defects in workmanship and materials for as long as you own them. Replace worn or damaged parts with genuine Enerpac parts. These are designed to fit properly and withstand rated loads.

CE Marking & Conformity



Enerpac provides a Declaration of Conformity and CE marking for products that conform with the European Community Directives.



Hydraulic clamping can increase your machine shop's efficiency by reducing setup time. Power clamping can also maximize output by reducing employee lost time due to the injuries that can occur with manual clamping.

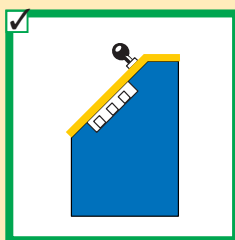
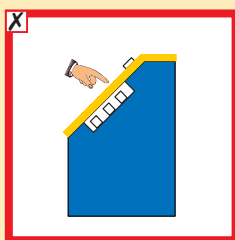
Although hydraulic operation moves the control of the clamping fixture to an area of greater safety, operators must still be alert to several common sense practices. And to that end we offer some DOs and DON'Ts, simple common sense points which apply to all Enerpac hydraulic products.

The line drawings and application photos of Enerpac products throughout this catalog are used to portray how some of our customers have used hydraulics in industry. In designing similar systems, care must be taken to select the proper components that provide safe operation and fit your needs.

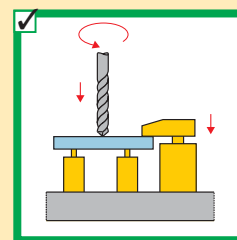
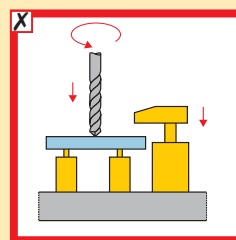
Check to see if all safety measures have been taken to avoid the risk of injury and property damage from your application or system.

Enerpac can not be held responsible for damage or injury, caused by unsafe use, maintenance or application of its products. Please contact the Enerpac office or a representative for guidance when you are in doubt as to the proper safety precautions to be taken in designing and setting up your particular system.

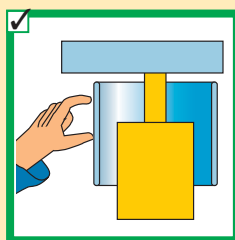
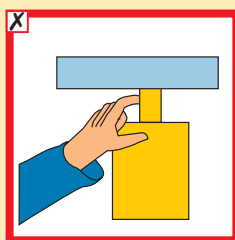
In addition to these tips, every Enerpac product comes with instructions spelling out specific safety information. Please read them carefully.



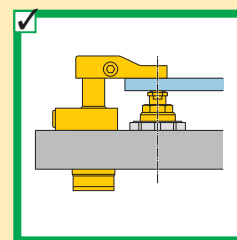
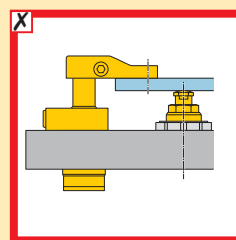
Prevent inadvertent activation of the control units of power operated clamping systems.



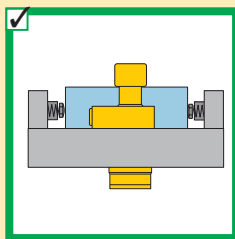
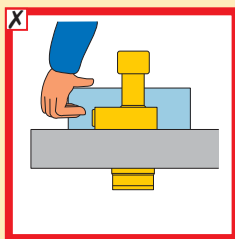
Clamping devices must be activated before main spindle can be started.



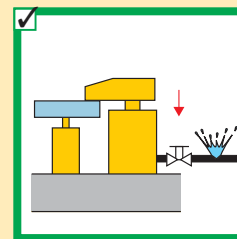
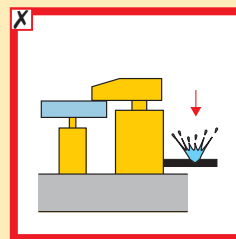
Maintain a safe distance from clamping elements and workpiece to avoid personal injury.



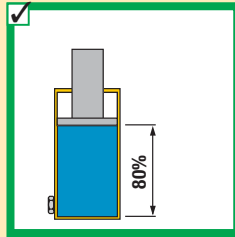
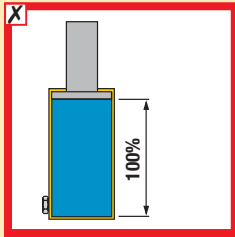
Do not apply off-center load. Clamping force must be directly over the support point.



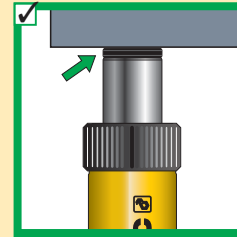
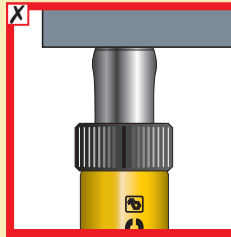
Use mechanical devices and not fingers to hold part until the hydraulics are activated.



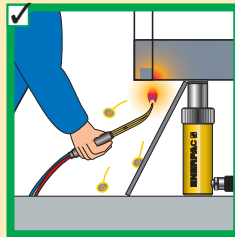
Use check valves to maintain hydraulic pressure to clamping devices in the event of a hydraulic line failure.



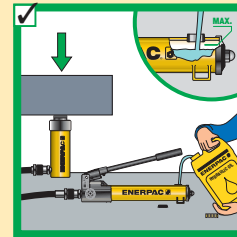
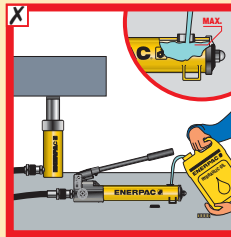
Do not operate cylinders beyond limits of rated stroke or pressure. Use only 80% of usable stroke.



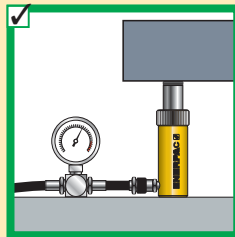
Use saddles or buttons to prevent mushrooming of plungers. Saddles distribute load evenly on the plunger.



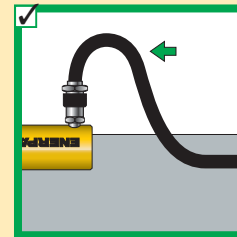
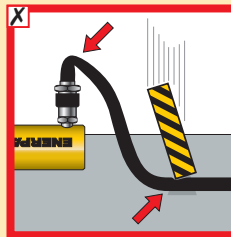
Keep hydraulic equipment away from open fire and temperatures above 150 °F / 65 °C.



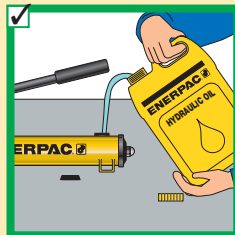
Fill pump only to recommended level. Fill only when connected cylinders are fully retracted.



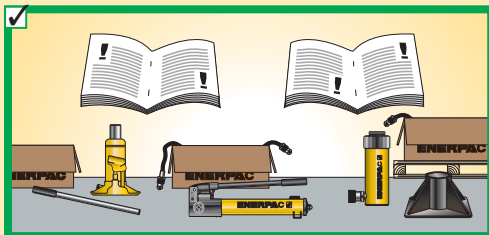
Do not override the factory setting of pressure relief valves. Always use a gauge to check system pressure.



Do not kink hoses. Bending radius must be at least 4.5 inch (115 mm). Do not drive over or drop heavy objects on hoses. Use high pressure tubing in high cycle applications.



Use genuine Enerpac hydraulic oil. Wrong fluid destroys seals and pump, will render your warranty null and void your guarantee.



Always read instructions and safety warnings that come with your Enerpac hydraulic equipment.



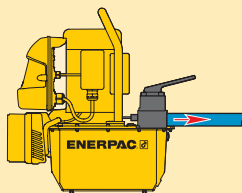
Oil Flow

A hydraulic pump produces flow. Flow is the amount of fluid coming out of the pump.

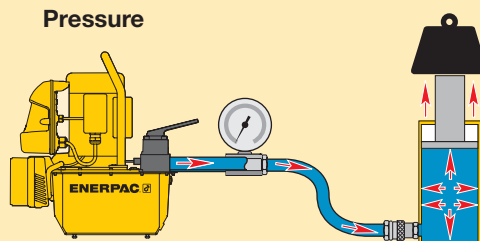
Pressure

Pressure occurs when there is resistance to flow.

Oil Flow



Pressure



Pascal's Law

Pressure applied at any point upon a confined liquid is transmitted undiminished in all directions (Fig.1). This means that when more than one hydraulic cylinder is being used, each cylinder will pull or push at its own rate, depending on the force required to move the load at that point (Fig. 2).

Cylinders with the lightest load will move first and cylinders with the heaviest load will move last (Load A), if the cylinders have the same capacity.

To have all cylinders operate uniformly so that the load is being pulled or pushed at the same rate at each point, control valves (see Valve section) must be added to the system (Load B).

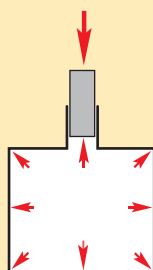


Figure 1



INCORRECT



CORRECT

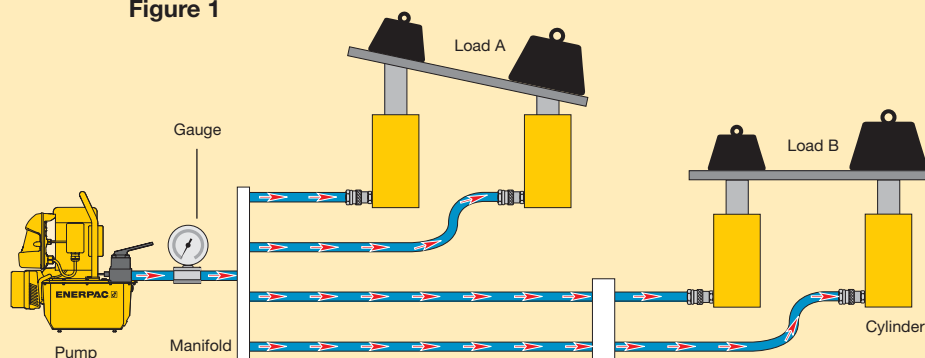


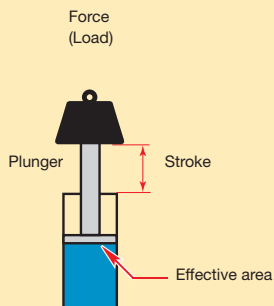
Figure 2

Control valve to provide uniform clamping of the work piece

Force

The amount of force a hydraulic cylinder can generate is equal to the hydraulic pressure times the "effective area" of the cylinder (see cylinder selection charts).

Use the formula $F = P \times A$ to determine either force, pressure or effective area if two of the variables are known.

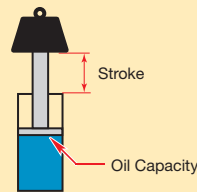


Force	=	Hydraulic Working Pressure	X	Cylinder Effective Area
F	=	P	X	A



Cylinder Oil Capacity

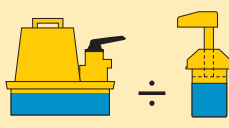
The volume of oil required for a cylinder (cylinder oil capacity) is equal to the effective area of the cylinder times the stroke.

$$\begin{array}{|c|} \hline \text{Cylinder Oil Capacity} \\ \hline \text{in}^3 \\ \text{(cm}^3\text{)} \\ \hline \end{array} = \begin{array}{|c|} \hline \text{Cylinder Effective Area} \\ \hline \text{in}^2 \\ \text{(cm}^2\text{)} \\ \hline \end{array} \times \begin{array}{|c|} \hline \text{Cylinder Stroke} \\ \hline \text{in}^3 \\ \text{(cm}^3\text{)} \\ \hline \end{array}$$


The diagram shows a hydraulic cylinder with a piston rod. A red arrow indicates the 'Stroke' (the distance the piston moves). A blue shaded area at the bottom of the cylinder is labeled 'Oil Capacity'.

Usable Oil Capacity

The amount of hydraulic oil in the pump's reservoir which can be used to activate one or more cylinders.

$$\begin{array}{|c|} \hline \text{Pump Usable Oil Capacity} \\ \hline \text{in}^3 \\ \text{(cm}^3\text{)} \\ \hline \end{array} \div \begin{array}{|c|} \hline \text{Cylinder Oil Capacity} \\ \hline \text{in}^3 \\ \text{(cm}^3\text{)} \\ \hline \end{array} = \begin{array}{|c|} \hline \text{Total Number of Cylinders} \\ \hline \end{array}$$


The diagram shows a yellow hydraulic pump on the left and a blue hydraulic cylinder on the right. A division symbol (÷) is placed between them.

Cylinder Speed

Pressure applied at any point Cylinder speed is determined by dividing the pump flow rate by the cylinder effective area.

$$\begin{array}{|c|} \hline \text{Cylinder Clamp Speed} \\ \hline \text{(mm/sec)} \\ \hline \end{array} = \frac{\text{Pump Flow Rate (cm}^3\text{/min)}}{\text{Cylinder Effective Area (cm}^2\text{)}} \times \frac{10}{60}$$

Seals

Various seal types are used in our hydraulic equipment: O-rings, U-cups, Quad-rings and T-rings for static and dynamic applications such as rod-seal, piston-seal and wipers. Buna-N (nitrile rubber) and Polyurethane basic compounds are most frequently used - they offer the best performance and durability for most applications.

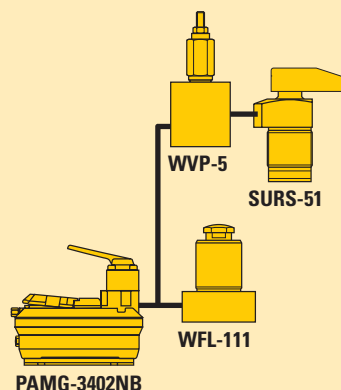
Heat is a crucial factor in seal life. Maximum temperature for good seal life is 150°F (65°C). This is also the maximum temperature of Enerpac hydraulic oil. Above 150°F, the use of Viton and high temperature oil is necessary. Viton has a maximum temperature which is much higher than nitrile or polyurethane. Viton is however an extremely quick wearing material. In many cases Viton seals will have a short working life due to abrasive wear.

Not all machine tool coolants are compatible with standard Enerpac seals. While most are, there are coolants that can harden or soften seals, which may result in free entry of contamination into the hydraulic cylinder. Using a high water based coolant may cause severe corrosive damage. This will often occur on fixtures where coolant has been allowed to pool for an extended period of time and evaporation has allowed it to concentrate. Drain and clean fixtures after use.

Often Viton seals are an immediate cure for coolant attack on standard Enerpac seals. When using Viton seals in cylinders, seals in the power source must also be replaced by Viton because inevitably some coolant will enter the hydraulic system. Consult the coolant manufacturer to verify compatibility with any seal material. Cutting fluid suppliers will provide an application book on the compatibility of their fluids. If problems arise after previous successful use, or if problems persist, contact Enerpac.



Building the right workholding system for a specific production tooling requirement is best achieved by observing the following basic steps – three steps deal with equipment selection, one with system connection.



Step 1

Selecting the type of cylinders, determined by shape and size of workpiece and the machining process involved, is the critical factor in any workholding system. For that reason, Enerpac offers an exceptionally broad range of production tooling cylinders – in terms of type, stroke and force rating.

Positioning and push cylinders are designed to position the workpiece and to push-clamp it securely in that position.

Down-holding cylinders are designed to clamp the positioned workpiece firmly to the fixture or worktable. The range of Enerpac swing cylinders and edge-clamps meet virtually any down-holding requirement.

Pull cylinders are used where the workpiece shape or fixture dictates clamping by pull forces, this type of cylinder with hydraulic or spring return can be selected to match particular needs.

Work support cylinders are designed to maintain the workpiece accurately on the prescribed plane throughout the machining operation. These support cylinders preclude both vibration and distortion problems.

Step 2

Select cylinder force and stroke, and choose single- or double-acting operation. The choice of force and stroke is largely dependent on size and shape of the workpiece and machining operation involved. Another factor to be considered is working space or clearance around the job, fixture or worktable.

Where a machining operation requires positive hydraulic return action, double-acting cylinders should be specified. Where spring-return action is sufficient, single-acting cylinders or a combination of the two can be used.

Step 3

Select the power source. The power source for an automatic workholding system can accurately be matched to the requirements. Enerpac pumps span a wide range of sizes and capacities – in compressed air or electric-driven configurations.

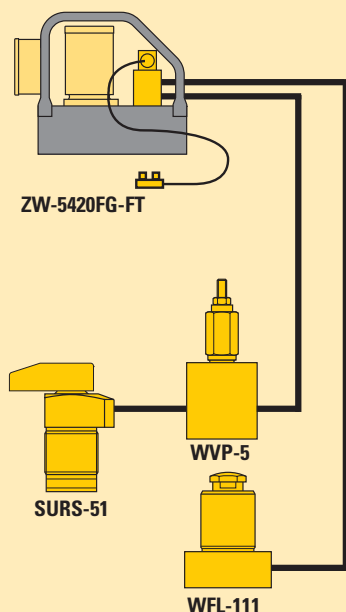
Step 4

Connect the system. Getting your workholding system together for operation means connecting the pump to the various control valves and cylinders through a circuit of hoses and/or piping, fittings, gauges and other accessories.

For example, two swing cylinders and work support cylinders working in sequence, powered by an electric-drive hydraulic pump unit would require the following components:

1. ZW Workholding pump
2. GA Gauge adaptor
3. G Pressure gauge
4. H Hoses
5. FZ Fittings
6. SU Swing cylinders
7. WFL Work support cylinders
8. WVP-5 Sequence valve

Select all these components from their respective catalog sections.





Swing cylinders and work supports

The combined use of clamping cylinders and work supports in fixturing has become indispensable.

Swing cylinders have become important clamping components for fixturing applications where unrestricted loading and unloading of the workpiece is required. Enerpac offers the most complete, comprehensively featured and compact swing cylinder line.

Work supports are widely used to support critical workpiece areas to prevent them from bending and/or vibrating during the machining process. This minimizes the deflection of the workpiece, improving its quality and assuring a high degree of repeatability.

The combination of swing cylinders and work supports provides substantial time savings and quality improvements in the machine tool industry.

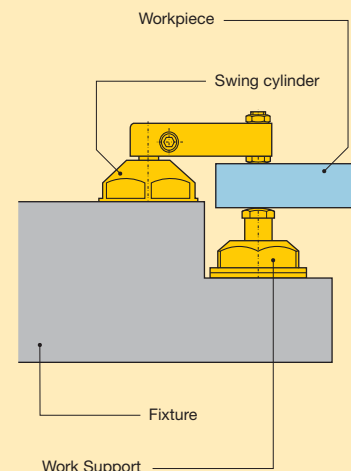


Figure 1
The combined use of clamping cylinders and work supports.

Support forces

When designing a fixture, several products features of swing cylinders and work supports have to be considered. The determination of the necessary support force and the size of the work support is very critical. In principle the work support has to overcome two forces:

- clamping forces
- machining forces (including forces that may be generated by vibrations)

Clamping forces

In practice, as a rule of thumb, the clamping force applied to the work support should not exceed 50% of its capacity at a given operating pressure. For many applications this is sufficient to absorb additional forces like machining forces. This 2 to 1 safety factor may need to be increased to 4 to 1 if extreme vibration or an interrupted cut is used.

The pressure/force diagrams, provided in the product selection pages of this catalog, allow for quick selection of the right combination of swing cylinder and work support.

The recommended ratio between clamping force and support force can be achieved by selecting the right sizes of the clamping components and/or by operating the swing cylinder and the work support with different operating pressures, e.g. the work support will be operated at maximum pressure while the swing cylinder operates at a reduced pressure.



www.enerpac.com

Download the
**Swing Clamp
Selection Tool.**

The size of the swing cylinder that can be used depends on the required force and length of the clamping arm.

With this tool you can determine, based on above mentioned input and type of clamp, which size of clamp can be used.



Point of contact

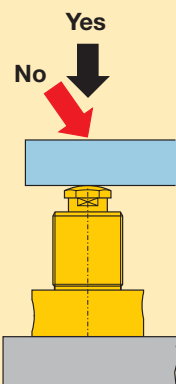


Figure 2

The direction of the clamping force must be axial at the centerline of the work support's plunger for best results in clamping and repeatability of quality.

Side loading of the work support must be avoided in order to ensure reliable and safe function (Figure 2).

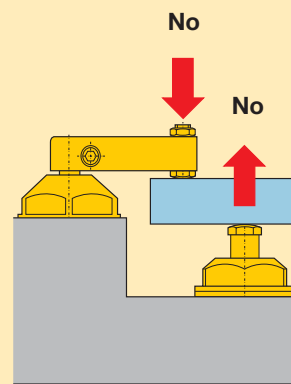


Figure 3

An off-set load will cause bending of the workpiece and uncontrolled deflection (Figure 3).

Hydraulic requirements

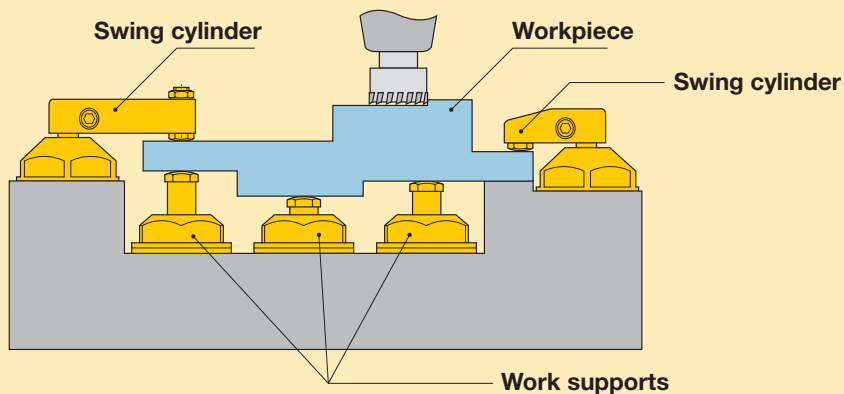


Figure 4

Swing cylinders and hydraulically advancing work supports are very sensitive regarding the oil flow rate applied.

To ensure safe and reliable function of these elements the maximum oil flow rate indicated in the catalog pages and in the instruction literature must not be exceeded. If there is the risk of high oil flow rates it is recommended to use flow control valves to adjust the flow rate.

During the clamping sequence it must be ensured that work supports will be operated only after the workpiece is firmly positioned and held against locators and datums. However, if the cylinder is clamping directly over the work support, the work support should be brought to full pressure before the cylinders clamp. This can be done by using a sequence valve.

Hydraulic requirements (continued)

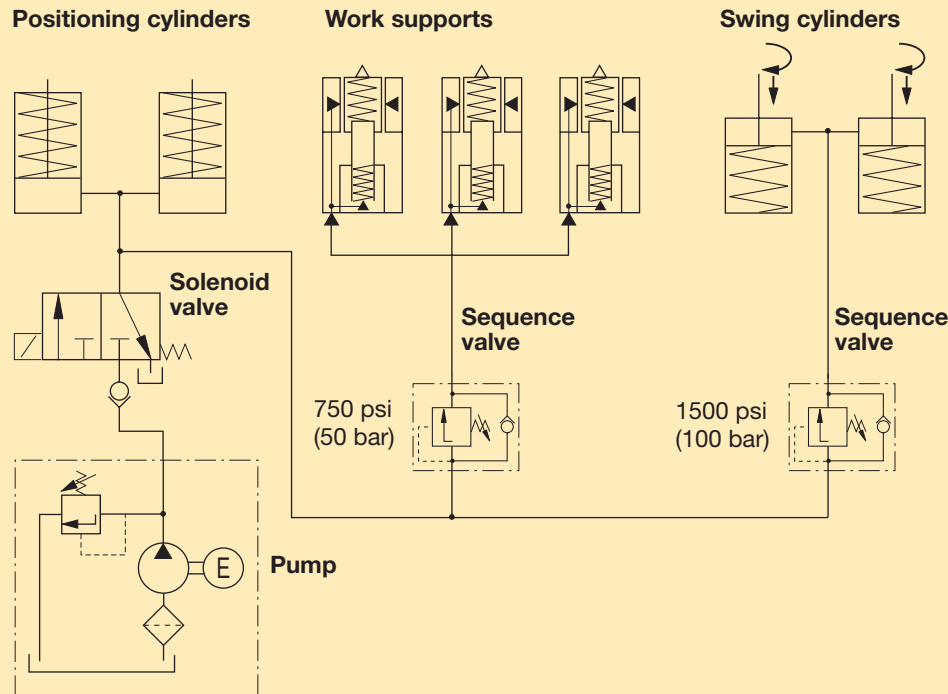


Figure 5

For overhanging areas of the workpiece which have to be supported, the recommended sequence should be as follows (Figure 5):

1. Positioning of the workpiece
2. Actuate work supports
3. Clamp the overhanging area against work support.

The hydraulic sequence can be controlled either by independently controlled hydraulic circuits (Figure 6) or by sequence valves (Figure 7).

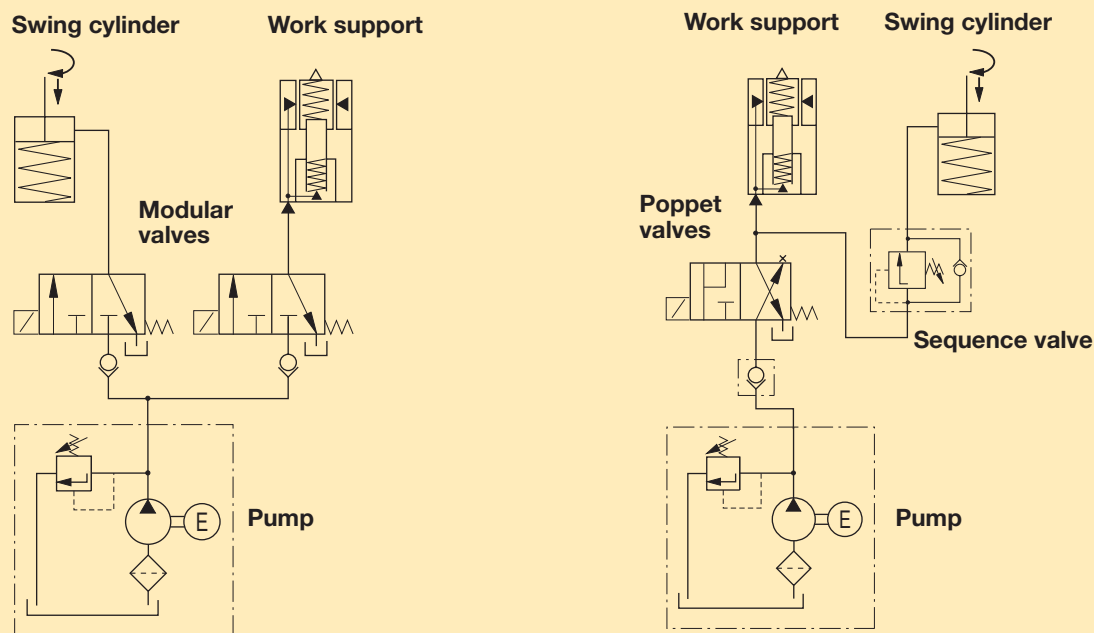


Figure 6

Figure 7

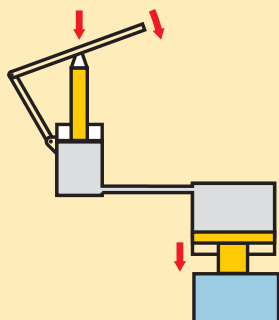


Figure 1
Operating principle of a hydraulic clamping device

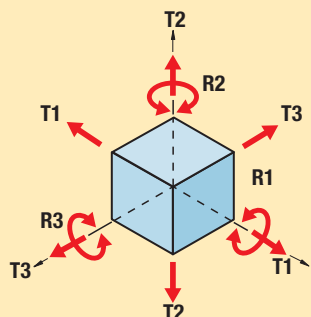


Figure 2
Three-dimensional body

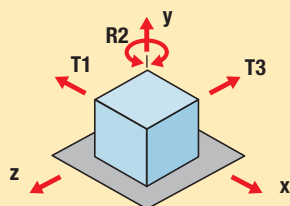


Figure 3a
Three degrees of freedom

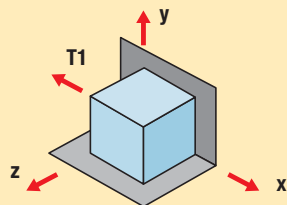


Figure 3b
One degree of freedom

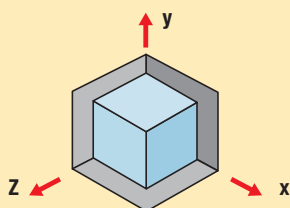


Figure 3c
Zero degree of freedom

1 Basic principles

- 1.1 A simple hydraulic clamping mechanism (Figure 1).
- 1.2 Terms and definitions
 - 1.2.1 Clamping Plunger
A device that applies clamping force to the workpiece.
 - 1.2.2 Workpiece
The part or material that is to be held in place.
 - 1.2.3 Pressure Piston
A device used to apply pressure to a hydraulic medium.
 - 1.2.4 Hydraulic Medium
A fluid used to transmit the pressure created by applying a force to the pressure piston

1.3 Hydraulic clamping process

The hydraulic clamping process consists of properly applying the forces created by a hydraulic clamping system to secure a workpiece. A hydraulic clamping system consists of the components illustrated in Figure 1, which shows the basic arrangement and operating principle of the use of hydraulic media.

Any such process using hydraulic fluids for clamping purposes may be referred to as a hydraulic clamping system. The operating pressure provided by hydraulic fluids in clamping systems can reach a maximum of 5000 psi (350 bar), allowing the application of considerable clamping forces even when using compact clamping cylinders.

When properly designed and controlled, the hydraulic clamping mechanism will prevent the workpiece from moving (sliding, twisting, etc.) when machining or other forces are applied, yet will not cause an unexpected permanent distortion to occur in the workpiece.

2 Assembly of hydraulic clamping devices

2.1 Locating, clamping, and supporting workpieces

2.1.1 Locating a Body

The term "locating" refers to the process of positioning the workpiece inside the clamping device, and holding it in position for the necessary machining. Only workpieces that are correctly held can be consistently machined within specified tolerances.

2.1.2 Limiting the degrees of freedom

The process of locating and holding a workpiece may be referred to as "limiting the degrees of freedom." Any motion of a workpiece in any possible direction is considered to represent one degree of freedom.

A three-dimensional workpiece therefore possesses six degrees of freedom, as shown in Figure 2. These six degrees of freedom consist of the translational motions "T" in x, y, and z direction, and the rotational motions "R" turning about the x, y, and z axes.

The degrees of freedom that a given workpiece or body possesses may be reduced by introducing reference planes that pass through any two axes.

For example, the plane in Figure 3a limits movement to travel in x and z directions and rotation about the y-axis. By defining this fixed plane, the workpiece can thus be limited or constrained to three degrees of freedom.

Another two degrees of freedom may be constrained by introducing a second reference plane, as shown in Figure 3b. This reference plane limits movement to translational motion in the x direction.

Constraining the last degree of freedom can be accomplished by defining a third reference plane as shown in Figure 3c.

2.1.3 Locating a workpiece

The process of locating and holding a necessarily require the elimination of movement in all six degrees of freedom, the following three locating techniques are used in actual practice.

Figure 4a: Semi-constrained Workpiece. The workpiece is held in one plane only (elimination of three degrees of freedom).

Figure 4b: Constrained Workpiece. The workpiece is held by two planes (elimination of five degrees of freedom).

Figure 4c: Fully-constrained Workpiece. The workpiece is held by three planes (elimination of six degrees of freedom).

2.1.4 Avoiding over-location

- Workpiece with locating planes
- Incorrectly located workpiece
- Correctly located workpiece

Over-location of the workpiece occurs when there is more than one locating plane or point for any given degree of freedom.

To prevent bending the b-c rib while machining the piece, a third reference plane (3) is introduced. Placing a workpiece (6) inside the clamping device (4) causes over-location. Since the distance between the locating planes (1) and (3) is constant in this device, the dimension c differs between individual workpieces. This over-location therefore gives rise to machining error.

Figure 5c: Shows how to locate a workpiece correctly. To avoid tilting the workpiece, the torque "M" transferred from the workpiece (5) to the body to be machined (6) must be balanced by an appropriate counter-torque. This counter-torque is created by the clamping force "F."

Over-location may also occur if a workpiece (Figure 5) is limited by too many locating points. The introduction of more than three locating points along the bearing surface, or more than two points in the guide plane, or more than one point in the supporting plane may lead to undesirable workpiece motion, and thus adversely affect the precision of the resulting product. Any additional support points must be adjustable.

If the workpiece to be machined must be supported to avoid deflection, then all other bearing points must be defined as variables and must be determined in relationship to the workpiece being machined.

The location process is subject to a number of design guidelines, but exceptions are possible.

- Always arrange the location points according to the pre-machined condition of the workpiece. Previously machined points have priority as desirable locating points.
- The locating points on the locating plane should be as far away from each other as possible.
- Arrange the clamping points such that the defined position is retained during clamping.
- The locating points should be in line with the clamping points to shorten the force vectors inside the workpiece. Three, two, or even one clamping point may be used to clamp a workpiece against the locating plane.
- Precision surfaces should not be held on a continuous surface, so that an "infinite" number of contact points can be avoided.

3 Clamping

The term "clamping" refers to the secure fastening of an already positioned workpiece in a clamping device for machining purposes. Locating and clamping may be viewed as a combined operation.

Clamping is invariably associated with force transmission through the device. The force vector should, as far as possible, describe a straight line from the application point of the clamping force through the workpiece to the bearing points.

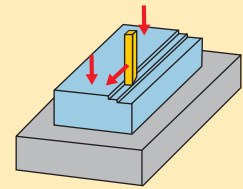


Figure 4a
Semi-constrained Workpiece

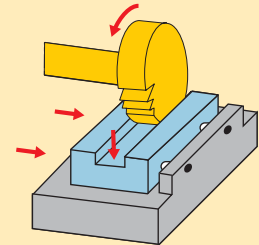


Figure 4b
Constrained Workpiece

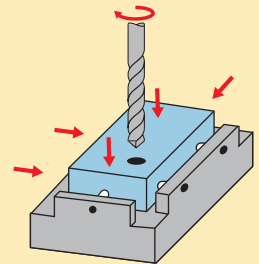


Figure 4c
Fully-constrained Workpiece

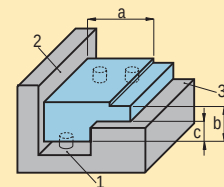


Figure 5a
Workpiece with locating planes

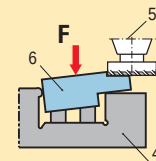


Figure 5b
Incorrectly located workpiece

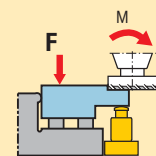


Figure 5c
Correctly located workpiece

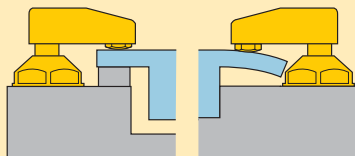


Figure 6
Design guidelines for clamping

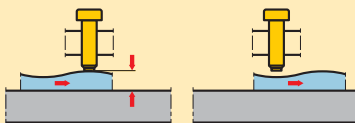


Figure 7
Mechanical clamping

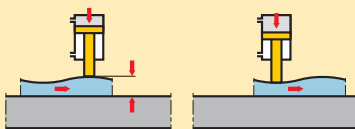


Figure 8
Hydraulic clamping

As with clamping, locating is subject to a number of design guidelines, although exceptions are possible:

- Keep the clamping force vector away from the critical tolerance zones on the workpiece.
- Workpiece deformation and marking due to clamping forces should be avoided or minimized.
- The clamping points on the workpiece should be selected so that the piece can be machined without reclamping or, if this is not feasible, with a minimum of reclamping.
- The required clamping forces should be approximated by rough estimations.
- The clamping dimensions of the workpiece may change due to thermal expansion and vibration resulting from machining.
- The workpiece should only be exposed to a clamping force if it is appropriately supported by a solid bearing point, as illustrated in Figure 6.

The dimensions of clamped workpieces may change due to vibrations and the effects of thermal expansion. Two types of clamping may compensate for these changes.

- Mechanical Clamping
- Hydraulic Clamping

The illustration in Figure 7 (mechanical clamping) demonstrates that tension is relieved as the dimensions of the workpiece in the clamping area change.

In hydraulic clamping, the clamping elements gripping the workpiece adjust to changes while maintaining a constant clamping force. This is illustrated in Figure 8, where the workpiece is elongated due to temperature increases during machining.

Mechanical clamping is accomplished by using the following mechanical clamping elements:

- Clamping Bars
- Clamping Springs
- Clamping Nuts
- Clamping Bolts (Figure 7)

Hydraulic clamping is achieved by:

- Elastometric media
- Clamping with air (pneumatic clamping)
- Clamping with liquids (hydraulic clamping)

Mechanical clamping elements are usually used for simple clamping devices. However, mechanical clamping elements may be converted to hydraulic ones by inserting cylinders between the clamping element and the workpiece. In addition, mechanical elements may also be combined with hydraulic clamping elements.

Clamping may be subject to errors that cause deformation of the clamped workpiece. Since such deformations must not affect the function of the workpiece, all conceivable locating and supporting techniques, as well as the best possible directed transmission of the clamping force through the workpiece, should be considered.

It is recommended that clamping forces be estimated to prevent excessively high clamping forces and possible deformation of the workpiece. Deformation of the workpiece may also be avoided by selecting a suitable shape (for example, a sphere) for the clamping points and the locating points.

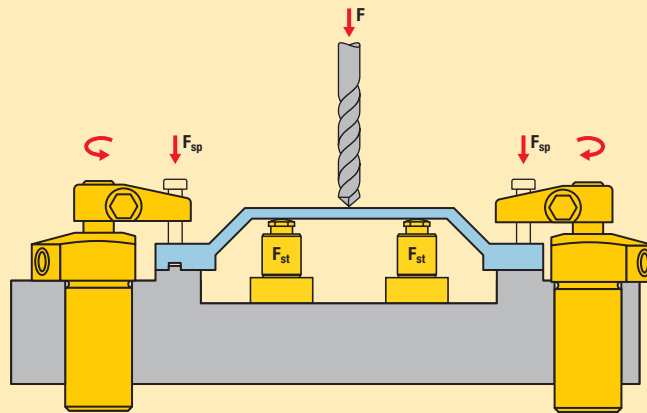


Figure 9
Supported workpieces.

4 Supporting the workpiece

4.1 Supported workpiece

The workpiece requires support to ensure functional force transmission between the tool, the workpiece, and the clamping device, and/or to protect the workpiece from deformation (such as deflection at points with a thin cross-section) due to machining forces, gravitational forces, and clamping forces. Workpiece support also acts to eliminate the resulting machining errors (Figure 9).

In addition, surface quality may be improved and the service life of the tool prolonged with the use of an optimum supporting mechanism. The three-dimensional position of a workpiece, however, should not be defined by its support. It is preceded sequentially by the locating process and also has a lower priority.

4.2 Supporting options for bent workpieces

- Unclamped workpiece
- Clamped workpiece
- Machined workpiece

A workpiece is considered to be supported even if it must be supported by frequently mobile and variable elements surpassing the theoretical maximum number of locating points. An example of this would be an unstable workpiece that easily vibrates.

When a deformed workpiece must be held and clamped in all three planes without altering its shape, it is possible to use a technique involving self-adjusting spherical surfaces. In this

case the bearing surfaces, the close-tolerance bolts, the limit stops, and the vertically adjustable supporting and clamping elements must be equipped with spherical surfaces.

The illustrations in Figure 10 illustrate two different clamping methods. It shows deformation of a workpiece caused by conventional clamping (Figure 10a). As a result of this deformation, the surface area of the workpiece exhibits a greater degree of deformation when unclamped.

This deformation, which is convex in shape, may be attributed to the fact that the workpiece assumes its original, deformed shape (c), as soon as the clamping pressure is released.

The clamping points illustrated in Figure 10b are spherically shaped, and can therefore largely adapt to the workpiece curvatures (b). The machined surface is therefore flat, and the workpiece is only exposed to possible internal stresses that may be released by machining.

4.3 Determination of the clamping force

It is important to ensure that a workpiece that is clamped inside a device is not moved from its position by the clamping force and the subsequent action of the cutting force. This risk of movement may be minimized by applying the clamping force to the solid bearing surfaces of the device (Figure 11).

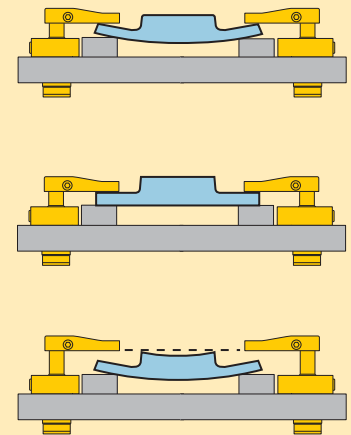


Figure 10a
Deformation caused by conventional clamping

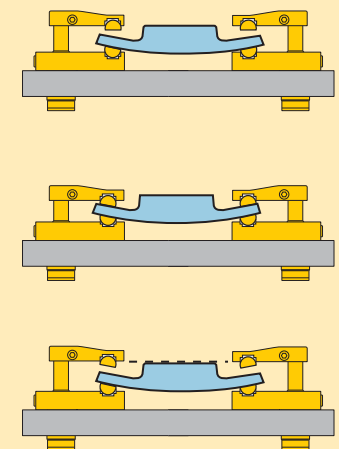


Figure 10b
Eliminate deformation using spherical ball supports

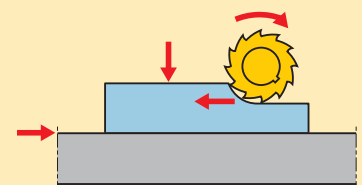
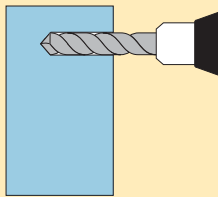
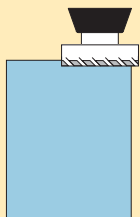


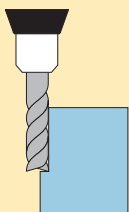
Figure 11
Approximation of the clamping force



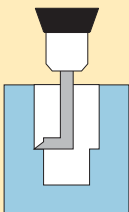
Drilling



Face milling



End mill



Boring

Introduction

This introduction will help you use information provided by tool manufacturers in the application of their tools. Estimating cutting forces being transferred into the workpiece is just one tool to use in a competitive workholding environment.

The information presented here is only to be a guideline and not the final decision. Use this information with a cutting tool brochure you get from your cutting tool supplier as an aid in determining your cutting forces. Much of the calculations presented here are readily available from many sources. Your cutting supplier may even have a slide chart you can obtain to do equations for you.

The operations described here include boring, drilling, end milling and face milling.

Drilling involves using a multi-fluted tool with a helix spiral. The tool is driven in as it is rotated to create a round hole.

End Milling uses a multi-fluted rotary tool with or without removable (inserts) teeth to remove material along the edge of the workpiece. The cut is usually very shallow and the depth is many times the thickness of the cut.

Face Milling involves a very shallow depth, but a very wide cut. Cutters can range up 12 inches (300 mm) or more in diameter and can have many replaceable teeth (inserts).

These examples are only a very small sample of operations that can use hydraulic workholding.

Cutting force determinations

These cutting force examples involve face milling. The largest use of hydraulic workholding is by far for some sort of milling operations.

1 Imperial system

$$\text{Cutting Force (Pounds)} = \text{Spindle Horsepower} \times 26400 \text{ (Horsepower to foot pounds per minute at 80\% efficiency) / Cutting Speed (In tool surface feet per minute)}$$

$$\text{Spindle Horsepower} = \text{Unit Power (Horsepower per cubic inches of material removed per minute)} \times \text{Material removal rate (Cubic Inches per Minute)}$$

$$\text{Material removal rate (Cubic inches per minute)} = \text{Width of the cut (Inches)} \times \text{Depth of the Cut (Inches)} \times \text{Feed per cutter tooth (Inches)} \times \text{Number of cutter teeth} \times \text{Spindle RPM}$$

Example

An 8-inch diameter cutter with 10 teeth (inserts) is machining low silicon aluminum at 3000 SFM (surface feet per minute).

First, you must convert surface feet/minute into tool RPM/Solving

$$\text{Tool RPM} = \text{SFM}$$

$$\text{Diameter (Inch)} \times .2618 = 1432 \text{ Tool RPM}$$

Now you can determine your material removal rate. An independent tool catalog lists a feed per tooth of 0.008" maximum at 3000 SFM at cut depth of 0.1"

$$\begin{aligned} &\text{This gives } 8" \text{ (diameter cutter)} \times 0.100" \text{ (cut depth)} \times 0.008" \text{ (feed per tooth)} \\ &\times 10 \text{ (number of teeth)} \times 1432 \text{ (spindle RPM)} = 91.6 \text{ cubic inches per minute material removal rate.} \end{aligned}$$

Next, spindle horsepower is found using unit HP from the table Spindle Horsepower = 91.6 x 0.4 (Unit Horsepower for Aluminum with a dull tool) = 36.6 HP.

Note this Horsepower is for fixture design and not for machine tool horsepower requirements.

For example a true 40 HP machine can remove aluminum well over 200 cubic inches per minute.

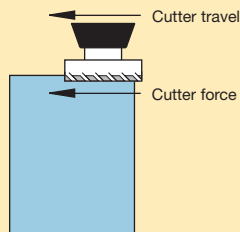


Using the original formula:

36.6 hp x 26,400/3000 SFM = 322 lbs.
3000 SFM of force being transmitted
into the work.

Force is transmitted in the same direction
as the cutter movement. In other
words, if the cutter moves right to left
in the diagram below, the cutter force is
transmitted from right to left.

Using a safety factor of 2 for rigid
clamping gives 644 pounds in line
parallel to the line force and 483
pounds using an elastic medium such
as hydraulics with a safety factor of
1.5. Note this force does not take into
account any sort of friction factors if you
plan on relying on friction force between
a swing cylinder and the workpiece.



For example:

The coefficient of friction for lubricated
aluminum is .12 (flooded with coolant)
this same 483 pounds of force becomes
483/.12 = 4025 pounds. This uses
clamp force only and does not take into
account any direct forces that may be
developed by the cylinders that located
the workpiece against fixed locators.

$$\text{Cutting Force}^{[1]} = \frac{\text{Spindle Hp} \times 26406^{[2]}}{\text{Cutting Speed}^{[3]}}$$

[1] Cutting force in Pounds

[2] Spindle Horsepower to foot-pounds
at 80% efficiency

[3] Cutting tool surface feet per minute

$$\text{MRR}^{[1]} = W \times D \times F \times N \times \text{RPM}^{[2]}$$

[1] Material Removal Rate (in³/min)

[2] W = Width of cut (in)

D = Depth of cut (in)

F = Feed per tooth (in)

N = Number of cutter teeth

RPM = Spindle speed

$$\text{Tool RPM} = \frac{\text{SFM}^{[1]}}{\text{Diameter} \times 0.2618}$$

[1] SFM = Surface Feet per Minute

Unit Power for dull tools [imperial system]

Material	Unit Power hp/in ³ /min			
	Hardness	Turning HSS & Carbide Tools	Drilling HSS Drills	Milling HSS & Carbide Tools
STEELS	85-200 Bhn	1.4	1.3	1.4
Plain carbon	35-40 Rc	1.7	1.7	1.9
Alloy steels	40-50 Rc	1.9	2.1	2.2
Tool steels	50-55 Rc	2.5	2.6	2.6
	55-58 Rc	4.2	3.2	3.2
CAST IRONS	110-190 Bhn	0.9	1.2	0.8
Gray, ductile and malleable	190-320 Bhn	1.7	2.0	1.4
STAINLESS STEELS	135-275 Bhn	1.6	1.4	1.7
	30-45 Rc	1.7	1.5	1.9
TITANIUM	250-375 Bhn	1.5	1.4	1.4
NICKEL ALLOYS	80-360 Bhn	2.5	2.2	2.4
ALUMINUM ALLOYS	30-150 Bhn	0.3	0.2	0.4
MAGNESIUM ALLOYS	40-90 Bhn	0.3	0.2	0.2
COPPER ALLOYS	10-80 Rb	0.8	0.6	0.8
	80-100 Rb	1.2	1.0	1.2



$$\text{Cutting Force}^{[1]} = \frac{\text{Spindle kW} \times 48000^{[2]}}{\text{Cutting Speed}^{[3]}}$$

- [1] Cutting force (N)
[2] Spindle power (kW) required at 80% efficiency
[3] Cutting tool surface speed (m/min)

$$\text{MRR}^{[1]} = \frac{W \times D \times F \times N \times \text{RPM}^{[2]}}{1000}$$

- [1] Material Removal Rate (cm³/min)
[2] W = Width of cut (mm)
D = Depth of cut (mm)
F = Feed per tooth (mm)
N = Number of teeth
RPM = Spindle speed

$$\text{Tool RPM} = \frac{\text{MPM} \times 1000^{[1]}}{\pi \times \text{Tool diameter}^{[2]}}$$

- [1] MPM = Surface speed m/min
[2] Tool diameter in millimeters

Metric System

Cutting Force (Newtons) = Spindle Power (kW) x 48000 (80% efficiency) / Cutting Speed (Meters per minute).

Spindle Power = Unit Power (kilowatts per cubic centimeters of material remove per minute) x Material removal rate (cubic centimeters per minute).

Material removal rate (Cubic centimeters per minute) = Width of cut (mm) x depth of cut (mm) x feed per tooth (mm) x number of teeth x spindle RPM/1000.

Example:

A 200 mm cutter with 10 teeth is machining low silicon aluminum at 1000 MPM (meters per minute).

Solving Tool RPM = MPM x 1000 Diameter (mm) x p (= 1592 Tool RPM

The same tool catalog lists a feed per tooth of 0.2 mm at 1000 MPM and a cutting depth of 2.5 mm. This gives an 200 mm cutter x 2.5 mm depth x 0.2 mm feed x 10 teeth x 1592 Tool RPM/1000 = 1592 cm³/min.

Spindle power = 1592 x 0.018 = 28.7 kW

This too is power from a fixture design standpoint; the actual operation will use less power than indicated here.

Using the original formula transposed is:
Cutting Force 1378 (Newtons) = 28.7 (kW) x 48000 (80% efficiency) / 1000 (MPM cutting speed)

Multiply by a safety factor of 2 for rigid clamping and by 1.5 for elastic clamping (hydraulic).

This calculation does not take into account coefficients of friction when using clamp cylinders. For example, if the aluminum has a coefficient of .12 (flooded with coolant), the clamping force becomes 1378/.12 = 11483 Newtons of force. This calculation does not take into account forces being generated by the fixture positioning cylinders.

Use these numbers and set up your hydraulic system to run at about 50 to 75% of its rated pressure. This leaves some reserve for a later date when the process is optimized and you need more holding/ clampforce for higher speeds and feeds. If you design to the maximum now, you have nothing in reserve.

Unit Power for dull tools [metric system]

Material	Hardness	TURNING P1 HSS AND CARBIDE TOOLS	DRILLING P HSS DRILLS	MILLING P d HSS AND CARBIDE TOOLS
		feed .12 - .50 mm/r	feed .05 - .20 mm/r	feed .12 - .30 mm/r
STEELS, WROUGHT AND CAST				
	85-200 Bhn	0.064	0.059	0.064
Plain Carbon	35-40 Rc	.077	.077	.086
Alloy Steels	40-50 Rc	.086	.096	.100
Tool Steels	50-55 Rc	.114	.118	.118
	55-58 Rc	.191	.146	.146
CAST IRONS	110-190 Bhn	.41	.055	.036
Gray, ductile and malleable	190-320 Bhn	.077	.091	.064
STAINLESS STEELS, WROUGHT AND CAST	135-275 Bhn	.073	.064	.077
Ferritic, austenitic and martensitic 30-45 Rc	.077	.068	.086	
TITANIUM	250-375 Bhn	.068	.064	.064
NICKEL ALLOYS	80-360 Bhn	.114	.100	.109
ALUMINUM ALLOYS	30-150	.014	.009	.018
MAGNESIUM ALLOYS	40-90	.009	.009	.009
COPPER ALLOYS	10-80 R _B	.036	.027	.036
	80-100 R _B	.055	.046	.055



Key to measurements

All capacities and measurements in the catalog are expressed in uniform values.
The conversion chart provides helpful information for their translation into equivalent systems.

Pressure:

1 psi	= .069 bar
1 bar	= 14.50 psi
	= 10 N/cm ²
1 MPa	= 145 psi

Volume:

1 in ³	= 16.387 cm ³
1 cm ³	= .061 in ³
1 liter	= 61.02 in ³
	= .264 gal
1 US gal	= 3,785 cm ³
	= 3.785 l
	= 231 in ³

Weight:

1 pound (lb)	= .4536 kg
1 kg	= 2.205 lbs
1 metric ton	= 2205 lbs
	= 1000 kg
1 ton (short)	= 2000 lbs
	= 907.18 kg

Other measurements:

1 in	= 25.4 mm
1 mm	= .039 in
1 in ²	= 6.452 cm ²
1 cm ²	= .155 in ²
1 hp	= .746 kW
1 kW	= 1.340 hp
1 Nm	= .738 Ft.lbs
1 Ft.lbs	= 1.356 Nm
1 kN	= 224.82 lbs
1 lb	= 4.448 N

Temperature:

To Convert °C to °F:
 $T^{\circ}\text{F} = (T^{\circ}\text{C} \times 1.8) + 32$
 To Convert °F to °C:
 $T^{\circ}\text{C} = (T^{\circ}\text{F} - 32) \div 1.8$

Imperial to metric

Inches	Decimal	Millimeters
1/16	.0625	1.59
1/8	.125	3.18
3/16	.187	4.76
1/4	.250	6.35
5/16	.312	7.94
3/8	.375	9.53
7/16	.437	11.11
1/2	.500	12.70
9/16	.562	14.29
5/8	.625	15.88
11/16	.687	17.46
3/4	.750	19.05
13/16	.812	20.64
7/8	.875	22.23
15/16	.937	23.81
1	1.000	25.40

Metric to imperial

Millimeters	Inches
1	.039
2	.078
3	.118
4	.157
5	.197
6	.236
7	.275
8	.315
9	.354
10	.394
11	.433
12	.472
13	.512

Millimeters	Inches
14	.551
15	.591
16	.630
17	.670
18	.709
19	.748
20	.787
21	.827
22	.866
23	.906
24	.945
25	.983



The following information consists of recommendations, advice and general rules regarding the design of hydraulic workholding systems. These tips apply to just about any system, and are a good starting point if you have questions about what products to use and how to apply them properly.

General design

Double-acting cylinders should always be used in applications where cycle time is critical. While the cylinders are designed with strong return springs, they may not consistently overcome the effects of long runs of tubing, orifices, and other restrictions. Double-acting cylinders help eliminate these effects.

Many hydraulic pumps are rated for substantial flow rates (10 gpm or more) that are far beyond the requirements of a hydraulic workholding system. While these pumps can be used, it is not recommended in general practice. Workholding cylinders are typically very small in comparison to the types of cylinders that these pumps were designed to operate. You will spend a great deal of time and money reducing the flow through the use of valving and still may not have an ideal system. Consider a separate hydraulic pump rated for less flow whenever possible.

Spool valves are very common and inexpensive, but also have their share of issues regarding use in hydraulic workholding systems. Spool valves are designed for use at much higher flow rates than those typically seen in workholding circuits. In fact the acceptable internal leakage in these valves is typically equal to the total amount of flow required for a small workholding circuit. And, the leakage will result in improper function and possible damage to many pumps designed for workholding systems.

Breather vents on cylinders are often overlooked. When you put oil into a single-acting cylinder and it begins to advance, the opposite side of the cylinder is filled with air. This air has to go somewhere. The breather vent provides this path. In turn, when the cylinder is retracting, and oil is leaving the cylinder, a vacuum is created and air needs to re-fill that opposite side of the cylinder. If the breather vent is located in an area that is subject to contamination from coolant, and chips, these items will also get pulled into the cylinder. Make sure the breather vent is plumbed to a clean location at all times.

Swing cylinders

The swing cylinders turn on a mechanical concept of a ball or a pin riding in a hardened groove. Trying to turn this too fast with a large heavy arm will result in enormous pressure on the ball or the pin, causing damage and eventually failure. A large arm also increases the amount of side load introduced into the cylinder. As the length of the arm increases, the allowable clamp load has to decrease accordingly. Follow the one-second rule: it should take at least one full second for the clamp arm to rotate and engage the part. Anything faster can result in damage.

Work supports

Work supports are rated based upon a somewhat constant load. Sharp vibrations from an interrupted cut or a large impact load (such as dropping a part on the fixture) will cause the work support to slip. Because of the design, once the work support has been subjected to a high impact load, it may no longer function. Be aware of this fact and limit impact loading wherever possible.

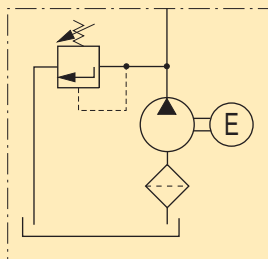
Manifold mounting

Manifold mounting of cylinders significantly decreases the amount of space required on a fixture. It also makes installation and service much simpler. Be sure to clean and de-burr all passages in the fixture manifold. Burrs can break loose over time and be ingested into the hydraulic cylinders, causing severe damage. If you have a long line of cylinders all in the same manifold, route the passages from the center out and use large diameters for the main feed line. The use of small passages everywhere in the manifold will cause drastic back-pressures on single-acting circuits.

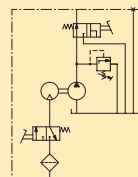
Be sure to include a passage for the breather vents where necessary. This passage should be routed to a large open area, not an enclosed cavity. Eventually, an enclosed cavity may fill up with chips and coolant and begin to work into the cylinders.



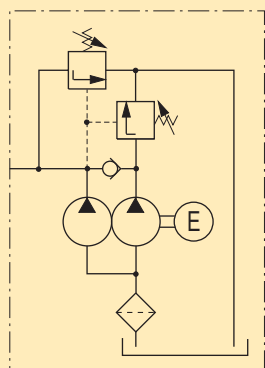
Power sources



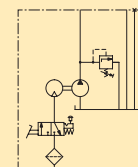
Single-stage electric pump
Example
ZW4010NB-S



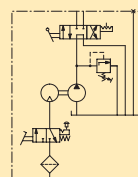
Turbo air pump
Example
PATG-3102NB



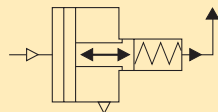
Two-stage electric pump
Example
ZW5020NG



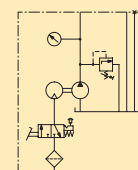
Turbo air pump
Example
PASG-3002SB



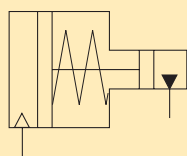
Turbo air pump
Example
PAMG-3402NB



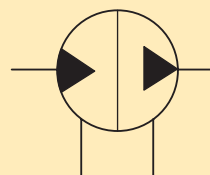
Reciprocating air pump
Example
PA-136



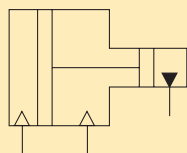
Turbo air pump
Example
PACG-3002NB



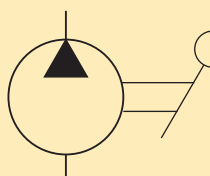
Single-acting booster
Example
B-3006



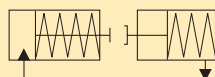
Hydraulic intensifier
Example
PID-321



Double-acting booster
Example
AHB-34



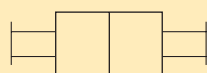
Hand pump
Example
P-142



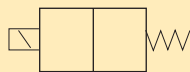
Activator wand and booster
Example
B-171
RA-1061



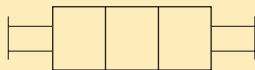
Valves



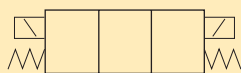
2-position manual



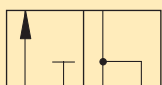
2-position solenoid



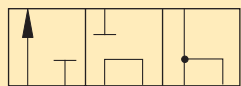
3-position manual



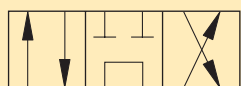
3-position solenoid



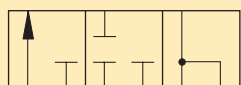
3-way, 2-position, Normally open
Series **V** Example **VM-2**



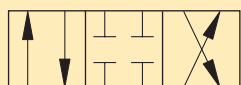
3-way, 3-position, Tandem center
Series **V** Example **VM-3, VC-3**
VE **VEF-15000D**



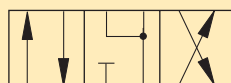
4-way, 3-position, Tandem center
Series **V** Example **VM-4, VC-4**
VE **VEC-15000D**



3-way, 3-position, Closed center
Series **V** Example **VC-15**
VE **VEG-15000A**



4-way, 3-position, Closed center
Series **V** Example **VC-20**
VE **VEB-15000A**



4-way, 3-position, Float center
Series **VE** Example **VED-15000A**
VMM **VMMD-001**



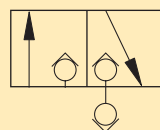
4-way, 2-position, Crossover offset
Series **VE** Example **VEE-15000A**



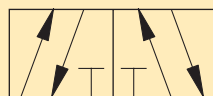
4-way, 2-position, Normally open
Series **VSS/VAS** Example **VSS-1410D**



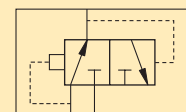
4-way, 2-position, Normally closed
Series **VST/VAT** Example **VST-1410D**



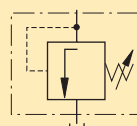
3-way, 2-position, Normally closed
Series **VP** Example **VP-31**



4-way, 2-position, Air valve
Series **VA** Example **VA-42**
VAS-42

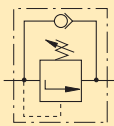


Rapid air exhaust valve
Series **VR** Example **VR-3**



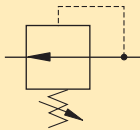
Pressure relief valve
Series **V** Example **V-152**

Valves



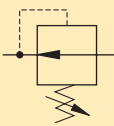
Sequence valve
Series
MVP
WVP

Example
MVPM-5
WVP-5



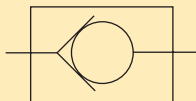
Pressure limiting valve
Series
PLV

Example
PLV-40013B



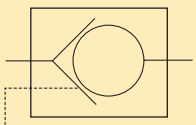
Pressure reducing valve
Series
PRV

Example
PRV-3



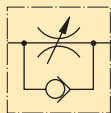
Check valve
Series
V

Example
V-17



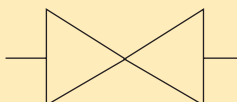
Check valve, Pilot operated
Series
MV
V

Example
MV-72
V-72



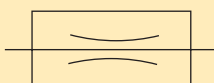
Flow control valve, Free flow check
Series
VFC

Example
VFC-1



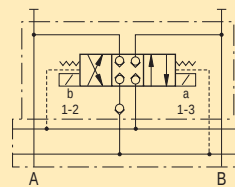
Shut-off valve
Series
V

Example
V-12

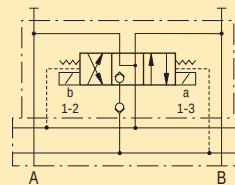


Auto-damper valve
Series
GS, V

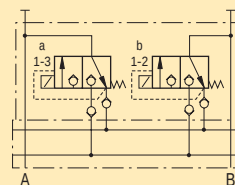
Example
GS-2, V-10



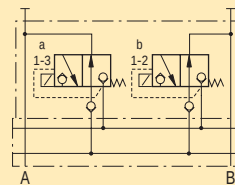
4-way, 3-position, Closed center
Example
VP-11, -12



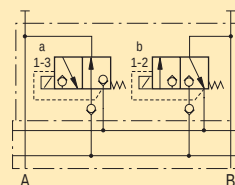
4-way, 3-position, Float center
Example
VP-21, -22



3-way, 2-position, Normally closed
Example
VP-31, -32



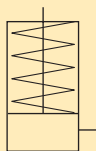
3-way, 2-position, Normally open
Example
VP-41, -42



3-way, 2-position,
one port normally open and
one port normally closed
Example
VP-51, -52



Cylinders



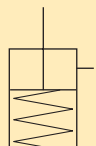
Single-acting cylinder, Push

Example

CSB-18252

CST-5131

CSM-18131



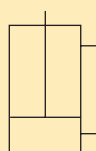
Single-acting cylinder, Pull

Example

PLSS-51

PTSS-51

PUSS-51



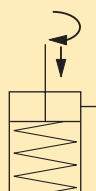
Double-acting cylinder

Example

CDB-18252

RD-96

CDT-18131



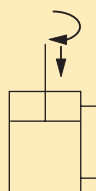
Single-acting swing cylinder

Example

SLRS-92

STRS-92

SURS-92



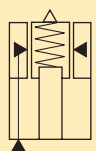
Double-acting swing cylinder

Example

SLRD-92

STRD-92

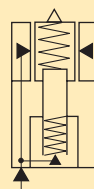
SURD-92



Spring advance work support

Example

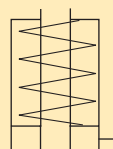
WSL-111



Fluid advance work support

Example

WFL-111



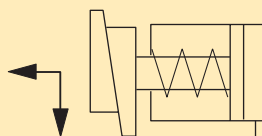
Single-acting hollow plunger cylinder

Example

CY-21295

HCS-80

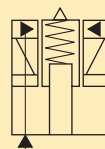
RWH-202



Pull down clamp

Example

ECH-202

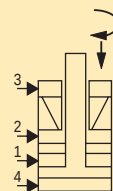


Collet-Lok® work support

Example

WPFS-200

WPTS-200

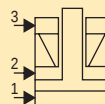


Collet-Lok® swing cylinder

Example

WPFR-100

WPTR-100



Collet-Lok® push cylinder

Example

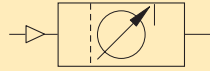
WPFS-100

WPTS-100

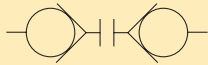
System components



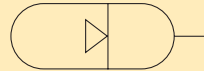
Pressure gauges
Example
DGR-1
G-2534R



Air regulator
Example
RFL-102



Hydraulic couplers, Uncoupled
Example
AH-650
AH-652
AH-654



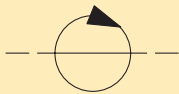
Accumulator, Gas charged
Example
ACL-201
WA-502



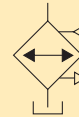
Hydraulic couplers, Coupled
Example
AH-650
AH-652
AH-654



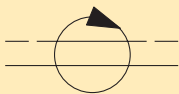
Accumulator, Spring loaded
Example
ACM-1



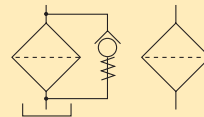
Rotary coupler, Single passage
Example
CR-111



Heat exchanger
Example
ZHE-1



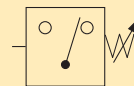
Rotary coupler, Double passage
Example
CRV-221



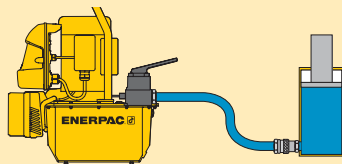
Return line filter,
high pressure filter, in line
Example
PFK-25
FL-2101



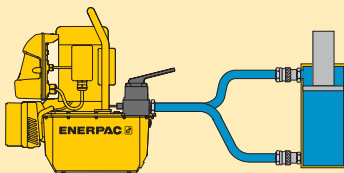
Rotary coupler, Four passage
Example
CRV-441



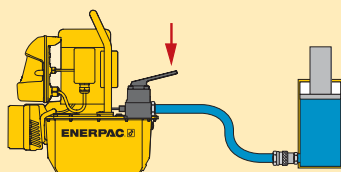
Pressure switch
Example
IC-50



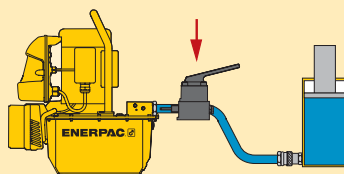
3-way valve used with single-acting cylinder



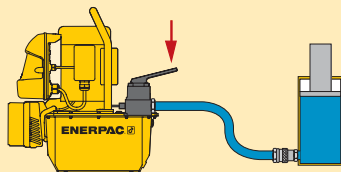
4-way valve used with double-acting cylinder



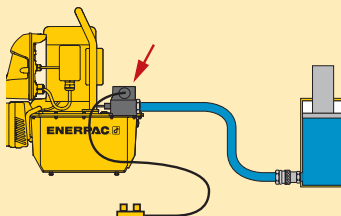
Valves can be **pump mounted**



Valves can be **remote mounted**



Valves can be **manually operated**



Valves can be **solenoid operated**

Valve types and functions

Hydraulic valves can be divided into 3 groups:

1. Directional Control
2. Pressure Control
3. Flow Control

1 Directional control valves

Ways – the (oil) ports on a valve

A 3-way valve has 3 ports: pressure (P), tank (T), and cylinder (A).

A 4-way valve has 4 ports: pressure (P), tank (T), advance (A) and retract (B).

Single-acting cylinders require at least a 3-way valve, and can, under certain instances, be operated with a 4-way valve.

Double-acting cylinders require a 4-way valve, providing control of the flow to each cylinder port.

Positions – the number of control points a valve can provide



A 2-position valve has the ability to control only the advance or retraction of the cylinder. To be able to control the cylinder with a hold position, the valve requires a third position.



The valve position can be **manually operated** with the use of the handle.



The valve position can be **solenoid operated** using power supply.

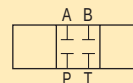
Operation – the way to shift the valve into position

Center configuration

The center position of a valve is the position at which there is no movement required of the hydraulic component, whether a tool or cylinder.



The most common is the **Tandem Center**. This configuration provides for no movement of the cylinder and the unloading of the pump. This provides for minimum heat build-up.



The next most common is the **Closed Center** configuration, which is used mostly for independent control of multi-cylinder applications. This configuration again provides for no movement of the cylinder, but also dead-heads the pump, isolating it from the circuit.

The use of this type of valve requires some means of unloading the pump to prevent heat build-up.



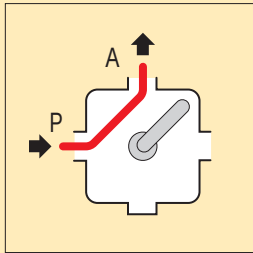
Another commonly used valve configuration is **Float Center**. This type of valve allows the cylinder ports to drain pressure back to tank. Used with a pallet mounted pilot operated check, it allows the hydraulics to be disconnected from the pallet.

**Advance, hold and retract**

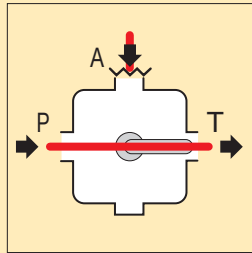
The direction of the oil flow can be controlled depending on valve type, valve positions and port functions.

Single-acting cylinder

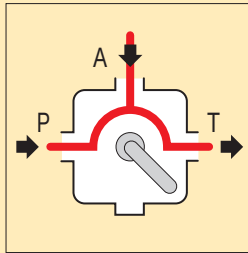
Controlled by a 3-way, 3-position valve.

**Advance**

The oil flows from the pump pressure port P to the cylinder port A: the cylinder plunger will extend.

**Hold (tandem center)**

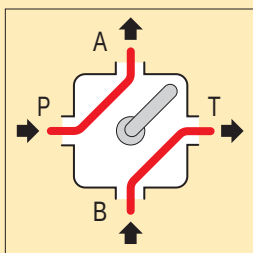
The oil flows from the pump pressure port P to the tank T. The cylinder port A is closed: the cylinder plunger will maintain its position.

**Retract**

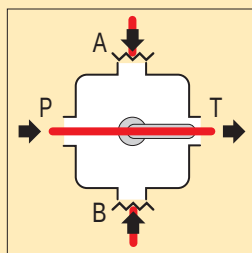
The oil flows from the pump and cylinder port A to the tank T: the cylinder plunger will retract.

Double-acting cylinder

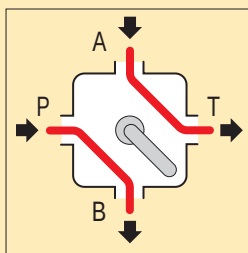
Controlled by a 4-way, 3-position valve.

**Advance**

The oil flows from the pump pressure port P to the cylinder port A and from cylinder port B to tank T.

**Hold (tandem center)**

The oil flows from the pump pressure port P to the tank T. The cylinder ports A and B are closed: the cylinder plunger will maintain its position.

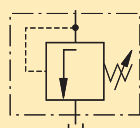
**Retract**

The oil flows from the pump pressure port P to cylinder port B and from cylinder port A to tank T: the cylinder plunger will retract.



2 Pressure control

Relief valve

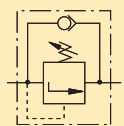


The most common type of pressure control valve is the pressure relief valve. This valve is used to limit the maximum pressure in the

hydraulic circuit. This valve should always be included in any hydraulic system to limit the circuit to a maximum safe pressure. When used in a system, design considerations should be made since the valve does not act instantly. As the pressure approaches the set point the valve will at first only permit a very small amount of oil to pass. It is only when the valve opens farther that the full flow will pass through the valve.

From a practical standpoint, don't set the relief valve with a hand pump and then use it with a power pump and vice versa. The point of operation will vary. Also because of this action, when used in application with a pressure switch, the pressure setting on the pressure switch should be set at least 500 psi (35 bar) lower than the point at which the relief valve opens. This will prevent rapid cycling of the motor on the pump because of the slight pressure loss thorough the relief valve. If the pressure settings must be closer than that the pressure switch should be monitoring the system pressure and a check valve should be added between the pump and the system. This will permit the pressure to bleed down on the pump through the relief and yet the check holds the pressure in the system, which is monitored by the pressure switch.

Sequence valve



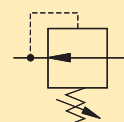
This valve controls the order in which various branches of the hydraulic circuit operate. It sequences the order of the actions. In practice, one part

of the circuit will reach a preset pressure at which point the sequence valve will open and permit oil to flow to the secondary part of the circuit. When the flow to the secondary part of the circuit begins, the pressure in the first part of the circuit will remain at the set point permitting for example a work support to stay at its rated pressure as the swing cylinder clamps.

Enerpac sequence valves have a free flow return check meaning that there is no sequence action when the circuit is unclamping. There is however a small bias spring that will open at about 30 psi (2 bar). This will ensure a positive seal when the valve must provide sequence action in the forward direction. When multiple sequence valves are used they should be used in parallel and not in series. If used in series, these 30 psi (2 bar) bias springs will restrict the flow in an accumulative effect.

For example, if three valves are used, there would be about $3 \times 30 \text{ psi} = 90 \text{ psi}$ (6 bar) of backpressure on components after the sequence valve in the system. While on a 5000 psi (350 bar) system this pressure may not seem like much, it is enough to prevent a single-acting swing from unclamping all the way or possibly cause a work support to not fully release and not properly readjust for the next part.

Pressure reducing valve

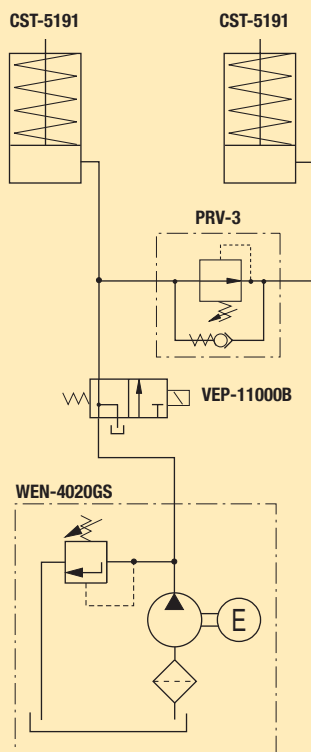
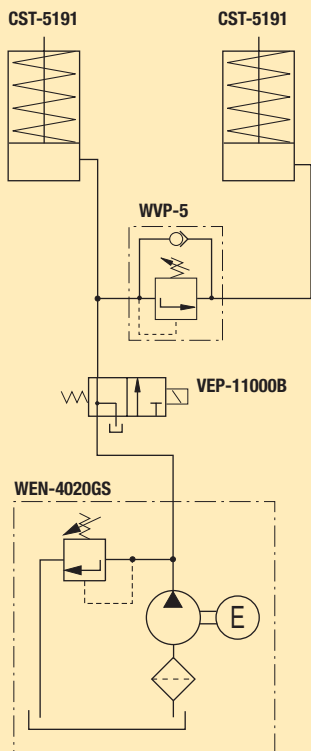


As the name implies, this valve will reduce the pressure to a lower value for a secondary part of the circuit. This is useful, for example,

when you must reduce the capacity of a swing cylinder that might be clamping over a work support. The pressure reducing valve will automatically make-up pressure loss after the valve by permitting a very small amount of oil to the secondary circuit.

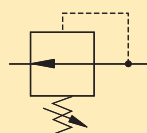
This pressure difference from when the valve first closes to the point it re-opens for pressure make-up is referred as the "deadband" of the valve. For example, on the Enerpac pressure reducing valve, this deadband is about 5% of the system pressure. If your system pressure is 3000 psi (210 bar) and the reduced pressure is 2000 psi (140 bar), the pressure in the secondary part of the circuit would need to drop 5% of the system pressure, [$3000 \times .05 = 150 \text{ psi}$ (10 bar)] before the valve would open.

In this case the secondary part of the circuit would drop to 1850 psi (127.5 bar), before the valve would open and permit oil to flow to the secondary part of the circuit to return the pressure to 2000 psi (140 bar). This valve provides this function in only one direction with free flow in the reverse direction to allow cylinders to unclamp or work supports to unlock.





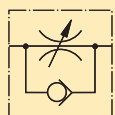
Pressure limiting valve



This valve, like the pressure-reducing valve, will limit the pressure in a secondary part of the circuit to a preset lower setting than the system pressure. This valve functions differently in that once the valve closes, the secondary part of the circuit will not receive any make-up oil for any pressure loss. The system pressure must drop to zero pressure before the valve will open and permit oil to flow to the secondary part of the circuit. There is no pressure make-up capability with a pressure-limiting valve.

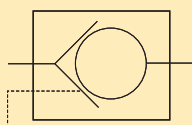
3 Flow control

Flow control valves



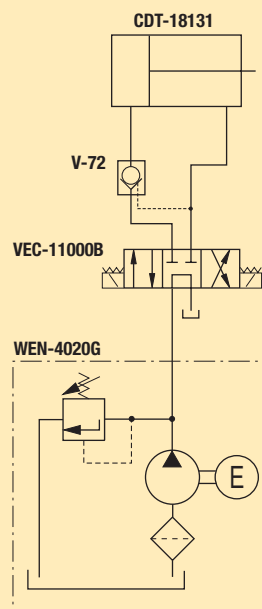
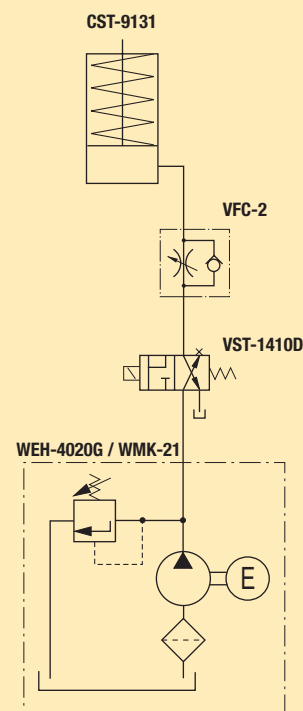
Flow controls permit the change of speed of a hydraulic component through the use of an adjustable orifice. Unlike a regular flow control that provides the same flow restriction in both directions, these flow controls provide a free flow reverse check. This allows restricted flow in one direction and unrestricted flow in the other. This is a very important feature when using a flow control to regulate the speed of a single-acting swing cylinder or work support. The cylinder requires the clamping speed be regulated to a safe value through the use of a flow control to prevent damage to the cylinder. When unclamping, the spring in the cylinder will develop only a small amount of pressure. To ensure rapid unclamp time, back pressure, or resistance, must be minimized. Free flow reverse checks allow you to minimize this resistance.

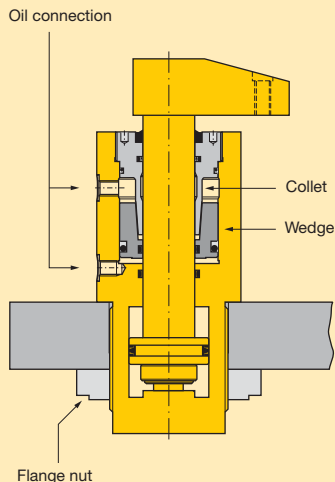
Pilot operated check valves



A check valve only permits the flow of oil in one direction. The pilot operated check valve works

the same as a regular check valve but also has an additional port for a pressure signal. Pressure to this extra port will mechanically open the check valve to permit the oil to flow in both directions. The pilot operated check is useful in holding pressure over a period of time in a remote part of a circuit, but allowing the pressure to be released using a pressure signal to the extra port on the valve. Usually this pressure is much lower than the system pressure you are holding back. Enerpac pilot operated check valves only require 15% of the system pressure you are clamping with to open the check valve, permitting the oil to return from the fixture and unclamp the part.





One of the most important aspects of machining cycle times is the speed and precision of the workpiece positioning, clamping and release.

The speed of these actions is greatly improved through the use of hydraulic workholding components, leading to increased efficiencies and cost savings.

Use of palletized fixtures

Being able to load many parts onto palletized fixtures also greatly increases the productivity and efficiency of the machining cycle. The use of palletized fixtures poses several problems however. The clamping cylinders must be repeatedly connected and disconnected from the hydraulic power source to make use of the flexibility of the pallets.

With conventional hydraulic cylinders, this also requires the use of load holding valves and accumulators to maintain pressure. With proper maintenance, this system of hydraulic workholding is very effective. This type of clamping is also very susceptible to contamination, and additional care must be taken to maintain the filtration and preventive maintenance schedules required.

Enerpac's exclusive Collet-Lok® technology

There is another solution to palletized clamping. Enerpac's exclusive Collet-Lok® technology eliminates the need for live hydraulics to be maintained on the pallet during the machining cycle. Once the part is hydraulically clamped in position for machining, the cylinders are mechanically locked in place. This mechanical lock replaces the accumulators, load holding valves and other requirements of live hydraulic palletized circuits. Once the machining cycle is complete, the mechanical lock is released, and the cylinders can be retracted to allow for the next piece to be loaded.

Enerpac offers swing cylinders, work supports and push cylinders with Collet-Lok® technology incorporated. Used in conjunction with an automatic coupler, pressure switches and proximity sensors, this technology can provide a totally automated and accurate clamping cycle.

On the next page is an example of how this technology works. The Collet-Lok® swing cylinder has four ports.

Port #1 is first pressurized to apply the appropriate clamping force. Once this pressure is reached, a sequence valve opens, sending pressure to Port #2, which mechanically locks a wedge into place. This wedge locks the plunger in place, preventing movement, and maintaining the clamping force on the workpiece. The pressure should now be removed and machining can be performed at any time. This lock can be maintained for minutes, hours, even days, without the need for hydraulic pressure.

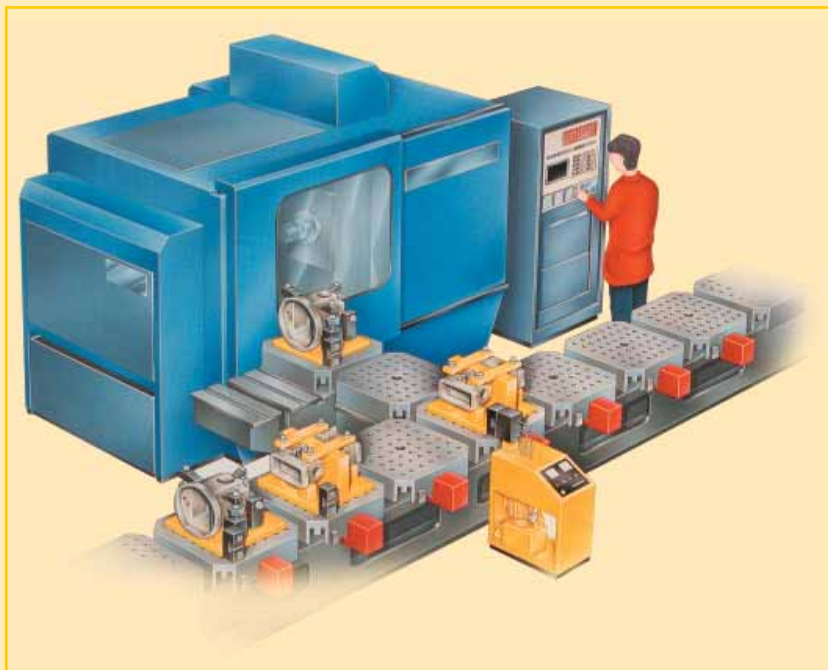
Once the machining cycle is complete, and the workpiece needs to be changed, the lock can be very easily removed. Pressure should be applied to Port #3 to unlock the wedge system. Once the wedge is unlocked, and the plunger is free, pressure can be applied to Port #4 to allow the plunger to retract. With this complete, the machined workpiece can be removed and a new piece can be loaded into the fixture to continue the process.

This system is the ultimate in system automation and positive control in clamping technology. For more information, be sure to consult Enerpac to receive additional literature and installation instructions.

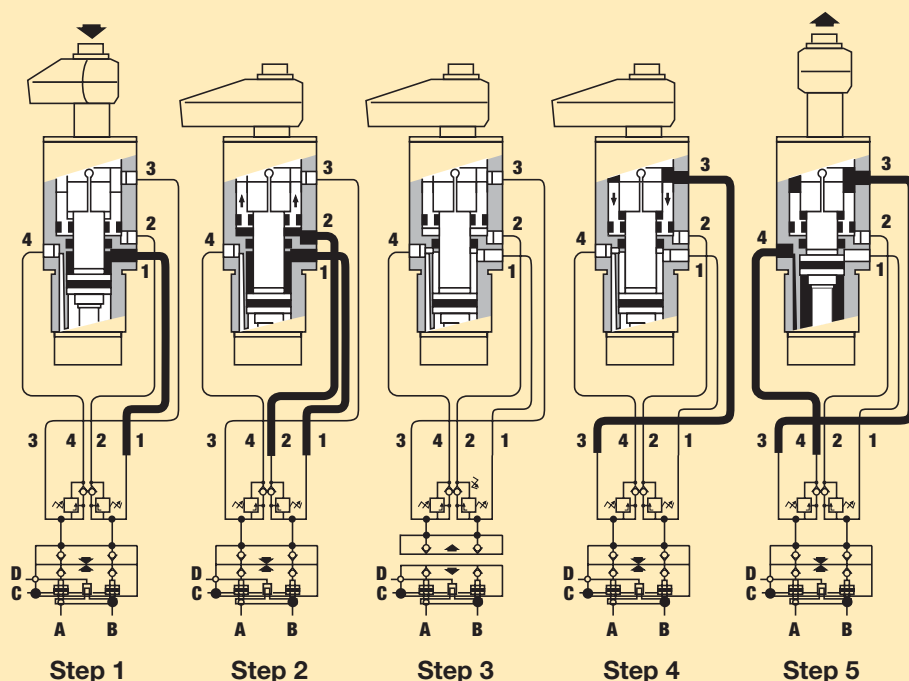
■ Fixture for machining exhaust manifolds.



Palletized machining



Hydraulic Clamping and Hydraulic Mechanical Locking



WPTR-100 Collet-Lok® swing cylinder

- 1 = 90° Rotation + Clamp
- 2 = Lock
- 3 = Unlock
- 4 = Unclamp + 90° Rotation

WCA-62, WPA-62 Auto coupler

- A = Pressure line from pump to swing cylinder
- B = Pressure line from pump to swing cylinder
- C = Auto coupler advance
- D = Auto coupler retract

Step 1

2-way Auto coupler connects external power source with pallet part and the Collet-Lok® cylinder is activated for hydraulic clamping.

Step 2

After reaching maximum clamping pressure the sequence valve is opened and actuates the internal wedge hydraulically.

Step 3

The wedge system secures the plunger position mechanically and the hydraulic pressure is taken off, then the auto coupler retracts. The product on the pallet is now securely clamped, without being connected to a power source.

Step 4

After being in the center of the machine the pallet returns to the loading and unloading position and the auto coupler is connected again to release the wedge.

Step 5

The hydraulic plunger is now retracted and the pallet is free for unloading and loading.

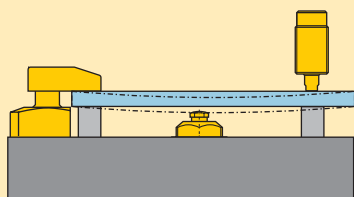


Figure 1
Simple hydraulic fixture with
minimal workpiece deflection

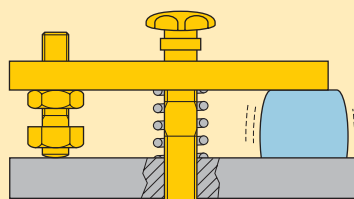


Figure 2
Simple mechanical fixture with
larger workpiece deflection

Mechanical clamping versus hydraulic clamping

Many factors should be taken into account when deciding whether to use mechanical or hydraulic workholding products for clamping your parts. In general, hydraulic clamping should be used in high volume applications, or when critical tolerances need to be held. Mechanical clamping products can be used in shorter production runs, or on rougher procedures where surface finishes and tight tolerances are optional.

For example, using hydraulic workholding products will allow you to maintain within a 1% accuracy on your clamping force. This is through the use of digital pressure switches, electric powered pumps and hydraulic clamping and support cylinders. This type of accuracy may be necessary when machining a surface requiring tight tolerances, less than .001 inch (0,025 mm). The slightest variation in clamping force could result in part movement or deflection greater than the required overall tolerance (Figure 1). In situations like this, the investment in hydraulic clamping is undeniable.

Mechanical clamping products are sufficient when tight tolerances are not required, or when the part is a large casting for example, and no amount of clamping force will distort the part. A typical operator, for example, can tighten a stud over a clamp to a specific torque value with possibly only 10% accuracy using a manual wrench. This could result in significant differences in part height and position on a fixture (Figure 2). However with a rough casting where the required finish is not critical, this may be acceptable. And, for the cost of mechanical clamping compared to hydraulic clamping, the choice is easy.

There are also situations where hydraulic clamping is not only not necessary for accuracy, but also, potentially dangerous. A perfect example of this is a die casting machine. Heat is an enemy of hydraulic components, and die casting obviously generates an enormous amount of heat. Mechanical clamping is an excellent and safe solution to the problem.

Production quantity runs should also be taken into account along with time savings and cost of materials when choosing between hydraulic and mechanical clamping.

Mechanical clamping is typically less expensive but more time consuming compared to hydraulic clamping.

See the examples below for ideal situations in which to use hydraulic or mechanical clamping:

Example 1

Production quantity:	60,000 pieces
Part material cost:	\$25
Machine time cost:	\$150 p/h
Hydraulic fixture and component cost:	\$30,000
Parts per fixture:	4
Load/unload time:	20 seconds
Run time:	720 seconds

The run time and the load/unload time equate to 185 seconds of machine time per part. The machine costs money no matter whether you are actually cutting chips or waiting to cut chips while you are loading the parts. This is why you must take both the load and the run time into account.

This 185 seconds per part equates to being able to run 155 parts per 8 hour day, at an additional cost of \$7.71 per part due to machine time cost of \$150.00 per hour.

The hydraulic fixture cost of \$30,000 divided over 60,000 parts equates to an additional \$0.50 per part. All together, in this very simple example, you have added only \$8.21 to the cost of the part. The \$8.21 equates to only about a 33% increase in cost. Granted, there are more aspects which could be factored in, but you can see the minimal cost added by hydraulics in this example.

Assume that you were only running 3000 parts on a small run. The machine time is the same, but now, the hydraulic fixture and components adds an additional \$10 to the cost of the part (30,000/3000 parts). This is a total of \$17.71 additional cost, or a 71% increase. Hydraulic clamping is much too expensive for such a short run.

Example 2

Production quantity:	3000 pieces
Part material cost:	\$25
Machine time cost:	\$150 p/h
Mechanical fixture and component cost:	\$5000
Parts per fixture:	4
Load/unload time:	240 seconds
Run time:	720 seconds

In this example, the production quantity is much lower, and mechanical clamping is being used. The same part is being machined, on the same machine process. The mechanical clamping fixture is much less expensive, only adding \$1.67 to the cost of each part. However, the load/unload time has increased significantly since the operator has to manually clamp each part. The machine is now only able to produce 120 parts per 8 hour day. This adds \$10 to the cost of each part in machine time cost. All together, \$11.67 has been added to the cost of each part, a 47% increase. While this may seem significant, remember that the cost increase using hydraulic clamping was 71%. Mechanical clamping is a much better choice in the lower production runs, even though it may be slower.

Many factors must be taken into account to decide on either mechanical clamping or hydraulic clamping. For example, taking labor into account can significantly add to the cost of mechanical clamping, since it is a much slower process. These examples are very simple and do not include all of the variable details that could affect your decision. Be sure to account for every situation in making your choice.

Replacing mechanical clamping with hydraulic clamping

In order to properly replace a mechanical clamping set-up with hydraulic cylinders, the most important thing to understand is the amount of clamping force being applied to the part. Figure 3 is an example of a typical mechanical clamping set-up for either one part or two parts. In this situation, the operator tightens the nut on the clamping stud, which in turn applies a holding force to the work piece. In order to convert this set-up to hydraulic clamping, you will need to know some values from Figure 3.

- T = Torque on the clamping stud (ft-lbs or N-m)
- D = Thread diameter and pitch (for example, 3/8-16 or M8)
- L_1 = Distance from center of clamping stud to contact point on the workpiece
- L_2 = Distance from center of clamping stud to reaction point (or contact point on second workpiece)

You will also need to know whether the clamping stud and nut are lubricated or dry. This makes a difference in how much clamping force is generated.

The first thing to know is how tight that nut is being applied to the clamping stud. This is best measured using a torque wrench. Even though the operator may not use a torque wrench in the everyday use of the fixture, it is critical to be able to provide a torque reading when converting to hydraulic clamping.

It may be necessary to use a torque wrench on the part a few times in order to get a good consistent value to be used in calculating the clamping force.

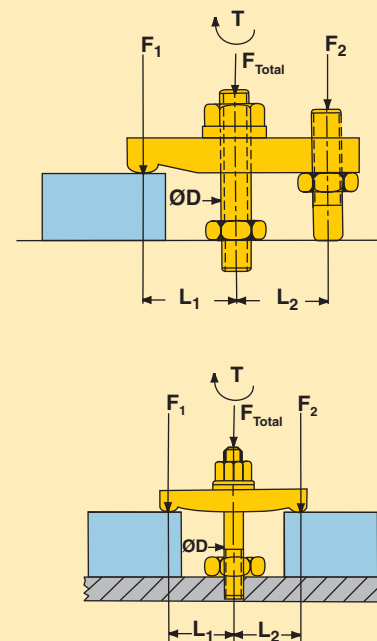


Figure 3
Typical mechanical clamping set-up

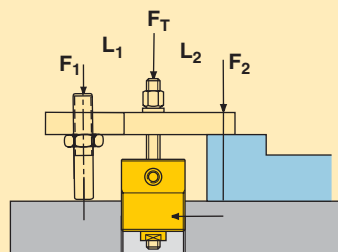


Figure 4
Center-hole cylinder used in
hydraulic clamping set-up

Once you have determined the amount of torque being applied to the clamping stud, and you have measured the diameter of the stud, and the distances L_1 and L_2 , the clamping forces can be calculated.

It is important to understand that the amount of clamping force being put into the clamping stud is not the same amount of force being applied to the part. In this setup, much less force gets applied to the part. You can calculate the force applied to the stud using the table. The force applied to the part is based on the formula.

$$F_1 = L_2 / (L_1 + L_2) * F_T$$

$$F_2 = L_1 / (L_1 + L_2) * F_T$$

When $L_1 = L_2$ (when the clamping stud is exactly halfway between the clamping points), $F_1 = F_2 = 1/2 F_T$

SAE stud sizes

Dry Threads K = 0.20		
Stud size	Torque (ft-lbs)	Applied load (lbs)
1/4" - 20	4	1190
	6	1790
	8	2380
	10	2980
5/16" - 18	14	3250
	16	3720
	18	4180
	20	4640
3/8" - 16	24	4580
	28	5350
	32	6110
	36	6880
1/2" - 13	60	8470
	65	9180
	70	9880
	75	10590
5/8" - 11	125	13980
	135	15100
	145	16220
	155	17340
3/4" - 10	200	18390
	225	20690
	250	22990
	275	25280
7/8" - 9	350	27390
	375	29340
	400	31300
	425	33260
1" - 8	450	30740
	550	37580
	650	44410
	750	51240

Lubricated Threads K = 0.15		
Stud size	Torque (ft-lbs)	Applied load (lbs)
1/4" - 20	4	1590
	6	2380
	8	3180
	10	3970
5/16" - 18	14	4330
	16	4950
	18	5570
	20	6190
3/8" - 16	24	6110
	28	7130
	32	8150
	36	9170
1/2" - 13	60	11290
	65	12230
	70	13170
	75	14120
5/8" - 11	125	18640
	135	20130
	145	21620
	155	23120
3/4" - 10	200	24520
	225	27580
	250	30650
	275	33710
7/8" - 9	350	36520
	375	39130
	400	41730
	425	44340
1" - 8	450	40990
	550	50100
	650	59210
	750	68320

Note: Values in the charts above are based on theoretical values. The chart values are meant to be guidelines in determining equivalent hydraulic cylinders for an application, but are by no means exact. Factors such as lubrication, material, plating and method or torque application can affect the actual clamping force. Please use proper engineering practices when designing a fixture.



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8-41



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42-85



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86-119



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120-143



**System
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144-160



Yellow pages
161-192

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