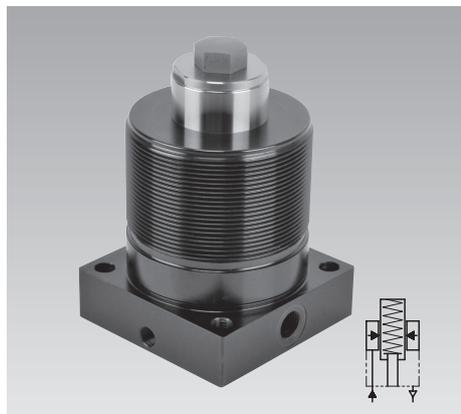


**Work Supports**

**Off-position extended – contact by spring force, single acting, max. operating pressure 500 bar**



**Application**

Hydraulic work supports are used to provide a self-adjusting rest for the workpiece during the machining operations. They compensate the workpiece surface irregularities, also deflection and vibration under machining loads.

**Description**

The spring-loaded support plunger positions itself against the workpiece with a light spring force.

Hydraulic locking is made together with hydraulic clamping of the workpiece, or independently. The support plunger is provided with female thread to enable the use of threaded pieces for height adjustment. Oil supply can alternatively be effected from the side or from below. The internal part of the work support is protected against dust and swarf by a sintered metal air filter.

Spring force 10 – 90 N, adjustable depending on the stroke.

**Important notes**

If there is any danger of fluids being sucked into the filter, a vent hose has to be connected.

Spring force should not be used to lift workpieces.

Contact bolts and extensions with large weight can influence the functions of this component.

Work supports are not suitable to compensate side loads.

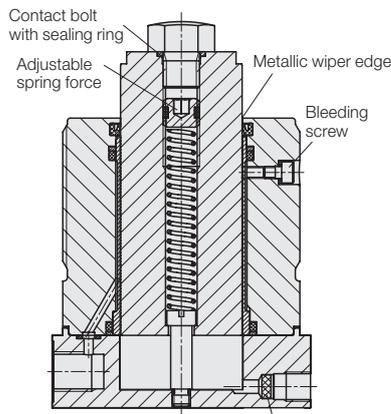
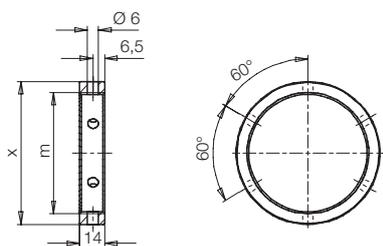
Work supports must only be operated with a sealed contact bolt.

In dry machining applications, with minimum quantity lubrication or in case of accumulation of very small swarf, there can be a swarf holdup in the area of the metallic wiper edge.

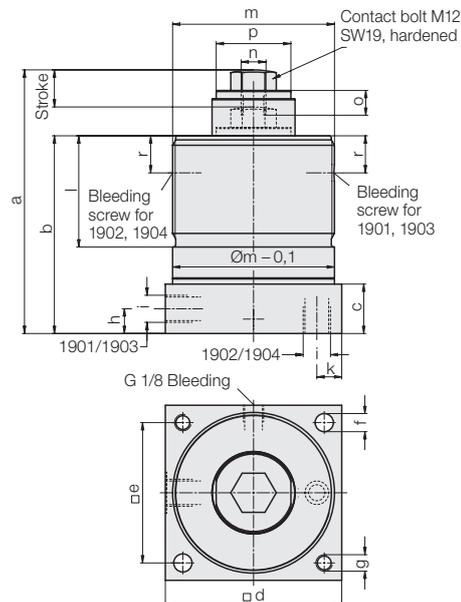
Remedy: Regular cleaning.

**Accessory**

Capstan nut



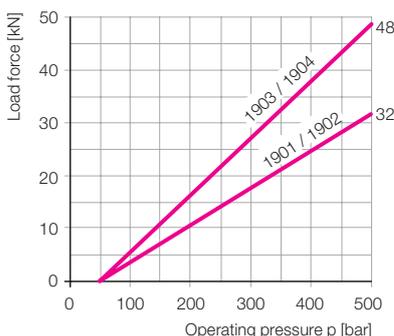
Sintered metal air filter  
G1/8 connection for ventilation  
(see data sheet A 0.110)



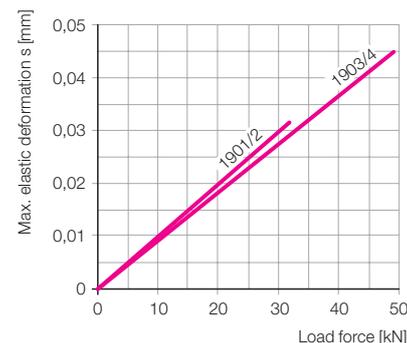
Connection		at the side	at the bottom	at the side	at the bottom
Bolt Ø	[mm]	32	32	40	40
Stroke	$\begin{matrix} +0.8 \\ -0.6 \end{matrix}$ [mm]	16	16	18	18
Adm. load force	[kN]	32	32	48	48
Recom. mini. pressure	[bar]	100	100	100	100
a	$\begin{matrix} +1.4 \\ -1.2 \end{matrix}$ [mm]	122	122	127.8	127.8
b	[mm]	90	90	96	96
c	[mm]	24	24	24	24
d	[mm]	75	75	85	85
e	[mm]	57	57	68	68
Øf	[mm]	7	7	8.8	8.8
g	[mm]	M 6	M 6	M 8	M 8
h	[mm]	12	–	12	–
i		G 1/4	G 1/4	G 1/4	G 1/4
k	[mm]	–	12	–	12
l	[mm]	40	40	54	54
m	[mm]	M 68 x 2	M 68 x 2	M 78 x 2	M 78 x 2
n	[mm]	M 12	M 12	M 12	M 12
o	[mm]	12	12	12	12
p	[mm]	27	27	36	36
r	[mm]	20	20	18	18
x	[mm]	Ø 80	Ø 80	Ø 90	Ø 90
Weight, approx.	[kg]	2.75	2.75	3.8	3.8
<b>Part no.</b>		<b>1901002</b>	<b>1902002</b>	<b>1903002</b>	<b>1904002</b>
<b>Accessory</b> Capstan nut		<b>3522008</b>	<b>3522008</b>	<b>3522007</b>	<b>3522007</b>

Article available on request

**Admissible load F as a function of the operating pressure p**



**Max. elastic deformations s as a function of support force F max. operating pressure 500 bar**



Operating conditions, tolerances and other data see data sheet A 0.100.