

Frequently Asked Questions

B-25



U.S. Patent No.
8,444,128

We are already using Double Acting Work Supports; why would we need to use the Return Position Sensor?

Extended Work Supports could cause a crash. Use the Return Position Sensor in any automated system where work support retraction is critical before the unload/load cycle begins. Monitor the position of Work Supports and confirm all is clear before unloading/loading the part.

Does the Return Position Sensor also tell me that the work support is extended and locked?

No, the Return Position Sensor only communicates that the Work Supports have retracted. Even though the pressure drops when the supports extend, it does not indicate that all the Work Supports have extended or are locked.

Can I add a Return Position Sensor to my existing double-acting work support?

No, adding the Return Position Sensor requires a specific body, a longer plunger and different contact spring. Adding the Return Position Sensor also increases the work support length from the mounting flange to the contact bolt. Please contact your Vektek Customer Support Specialist for more information.

How many Work Supports with Return Position Sensors can I put on one pneumatic circuit?

The maximum number of Return Position Sensors in one circuit is a function of the circuit design and pressure drop over the length of the circuit path. Vektek has tested ten devices plumbed in parallel with excellent results.

What if I want to run a different pneumatic pressure switch than what Vektek engineers recommend?

Any programmable pneumatic switch that interfaces with the machine tool logic can monitor air pressure in the Return Position Sensor circuit. Also see Air Sensing Control Kit 50-8240-00.

Is it okay to route my air through a rotary union?

Yes, size the rotary union so that there is a separate path for the air circuit.

Do I need a pneumatic pressure switch for each work support on my fixture?

No, connect all the Work Supports (that are on the same hydraulic circuit) with an air circuit feeding the Return Position Sensor to one pneumatic pressure switch.

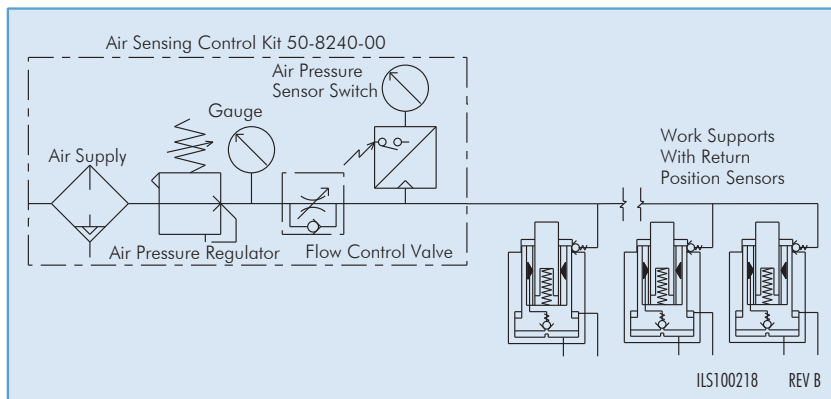


Device Operation

The Return Position Sensor unit requires continuous and regulated air pressure. In the retracted position, air pressure will build in the system to the regulated set pressure. An air logic switch detects the "retracted" pressure condition and signals the controller that Work Supports have retracted. When the work support extends, the internal check opens and vents air from the device. The system air pressure falls to the "extended" preset pressure and an air logic switch resets. When the support retracts, the internal check closes and air pressure again builds to the regulated value. The air pressure switch detects "retracted" pressure and again signals the controller that the device is in the retracted position.

Recommended Pneumatic Circuit Design

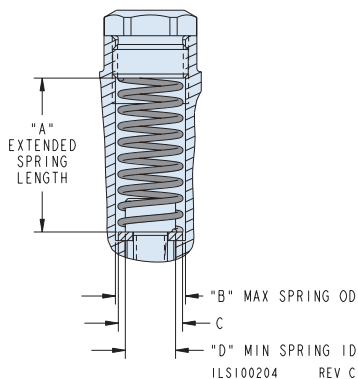
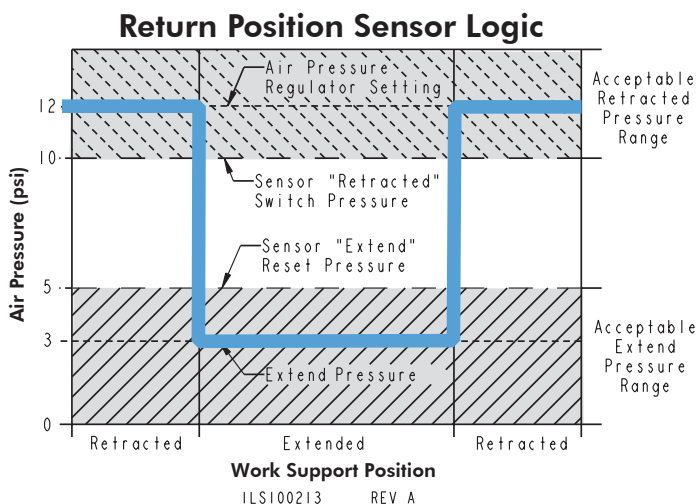
- Use Vekttek Air Sensing Control Kit (Model # 50-8240-00).
- Parallel circuit design with minimum of 0.125" inside diameter feed line size.
- Circuit design should be simple and free from flow restrictions that can cause excessive pressure drop.
- The maximum number of Return Position Sensors in one circuit is a function of the circuit design and pressure drop over the length of the circuit path. Vekttek has tested 10 devices plumbed in parallel with excellent results.



B-26

Recommended System Setup:

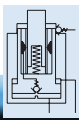
- Set air pressure regulator to 12 psi when all Work Supports in the system are in the retracted position.
- Adjust and set air flow control so that air pressure falls to 3 psi when the work support at the furthest point of the pneumatic circuit is in the extended position and all other supports in the circuit are retracted.
- Set the air pressure sensor "Retract" switch point to 10 psi.
- Set the air pressure sensor "Extend" reset switch point to 5 psi.



Custom Contact Spring

Work Support Series	Cavity Dimensions				Standard Spring			
	A	B	C	D	OD	Wire Ø	Free Length	Rate (lbs/in)
10-0208-00	1.13	0.51	0.46	0.38	0.48	0.045	1.50	9.4
10-0208-01	1.69	0.51	0.46	0.38	0.48	0.051	2.25	9.3
10-0212-00	1.13	0.68	0.62	0.47	0.59	0.055	1.56	10.0
10-0212-01	1.78	0.68	0.62	0.47	0.60	0.059	2.5	9.6

NOTE: Vekttek recommends only 17-7 stainless steel springs. Too light of custom spring force may not actuate the plunger, especially if a custom contact bolt is used. Too heavy of a custom spring may cause damage to the device's internal components. Vekttek cannot guarantee that custom springs will provide proper plunger actuation.

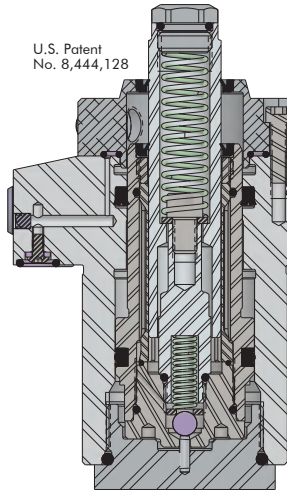


Work Supports / Double Acting, Position Sensing

Top Flange

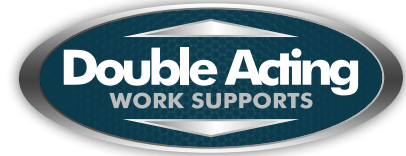
Return Position Sensing for D/A Top Flange Work Support

- The Double Acting Return Position Sensors use air pressure to communicate that the work support has retracted and that the fixture can be unloaded/loaded.
- Sensor monitors work support position to prevent crashes in automated systems.
- Fail safe design requires air pressure to build before sensing the retracted position.
- Dual wipers keep chips and debris from invading support.
- Pressure Relief Vent keeps unit sealed and free from foreign material.
- Air connection through face sealed O-ring of top flange body or externally plumbed through NPT ports on sensor housing.
- Top flange body style allows for hydraulic connection through face sealed o-rings or through SAE ports.
- Aluminum sensor housing is Black anodized for superior corrosion resistance.
- Optional in-port flow control is a meter-in device with reverse free flow check valve.
- Optional in-port sequence valve is a sequencing device with reverse free flow check valve.



U.S. Patent No. 8,444,128

ILS100209 REV E



Model No.**	Support Capacity (lbs.)*	Contact Force (lbs.)	Work Support Stroke (in.)	Shuttle Stroke (in.)	Body Dia.	Piston Area (sq. in.)		Oil Capacity (cu. in.)		Max Oil Flow Rate (cu. in./min.)	Port X Depth for Optional In-Port Valves***
						Extend	Retract	Extend	Retract		
Double Acting (D/A)						Cylinders, actuated hydraulically both directions.					
10-0208-01	2750	5.2-8.6	0.38	0.50	2.12	1.62	0.52	0.81	0.26	70	SAE 4 X .58
10-0212-01	5500	6.9-10.5	0.38	0.50	2.99	3.55	0.79	1.78	0.40	150	SAE 4 X .58

* Support capacities are listed at 5,000 psi maximum operating pressure. Support capacities for other pressures must be determined by consulting the capacity graph at the start of Section B.
 ** Use Return Position Sensor to monitor retracted position only and not plunger advance or plunger lock.
 *** In-Port valves requires the use of manifold mount ports.



Device Operation

The return position sensor unit requires continuous regulated air pressure. In the retracted position, air pressure will build in the system to the regulated set pressure. The air logic switch detects "retracted" pressure and signals that work supports have retracted. When the work support extends, the internal check is opened and air vents from the device. The system air pressure falls to the "extended" pressure and the air logic switch resets. When the support is then retracted, the internal check is closed and air pressure again builds to regulated value. Air pressure switch detects "retracted" pressure and again signals device is in retracted position.

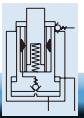
Dimensions

Model No.***	A	B*	C**	D	E	F	G	H	J	K	L	M	N	P	Q
Double Acting (D/A) ***															
10-0208-01	3.19	0.38	0.50	2.32	1.72	1.91	2.12	1.25	0.75	2.90	1.13	2.25	1.13	0.94	2.25
10-0212-01	3.41	0.38	0.50	2.69	1.72	1.91	2.99	2.00	1.25	3.69	1.56	3.13	1.56	1.28	3.12

* Plunger Stroke "B" is the available work zone of the plunger. The workpiece must be positioned inside this window to prevent part ejection.
 ** Shuttle Stroke "C" is the stroke the shuttle travels to position the work support plunger relative to the workpiece. The shuttle moves the full range of this stroke every cycle.
 *** The difference between "C" and "B" (C-B) equals the minimum distance the plunger is below the workpiece in the retracted position.

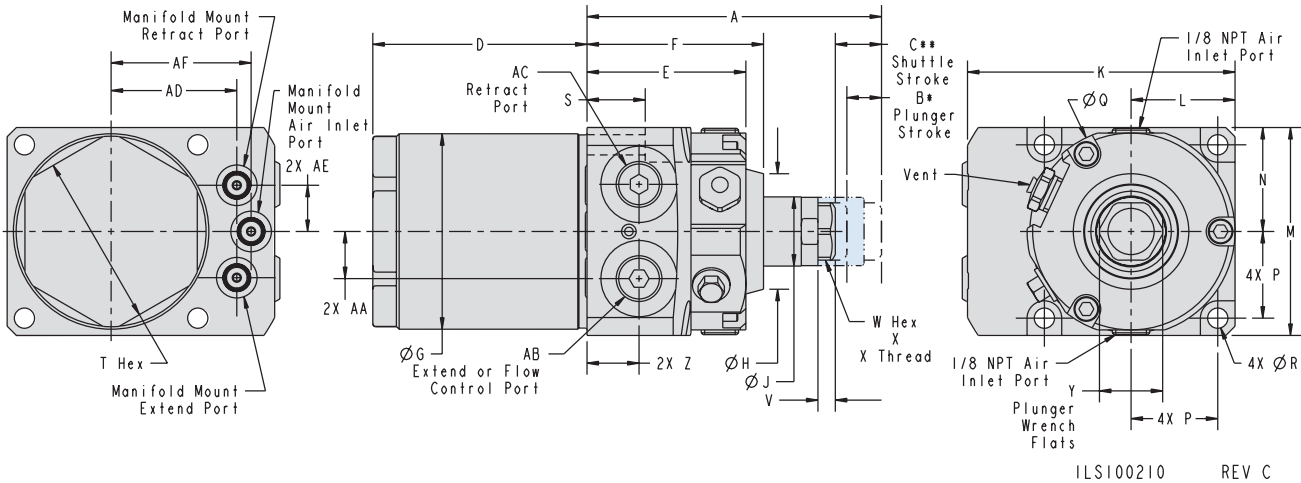


Work Supports / Double Acting, Position Sensing

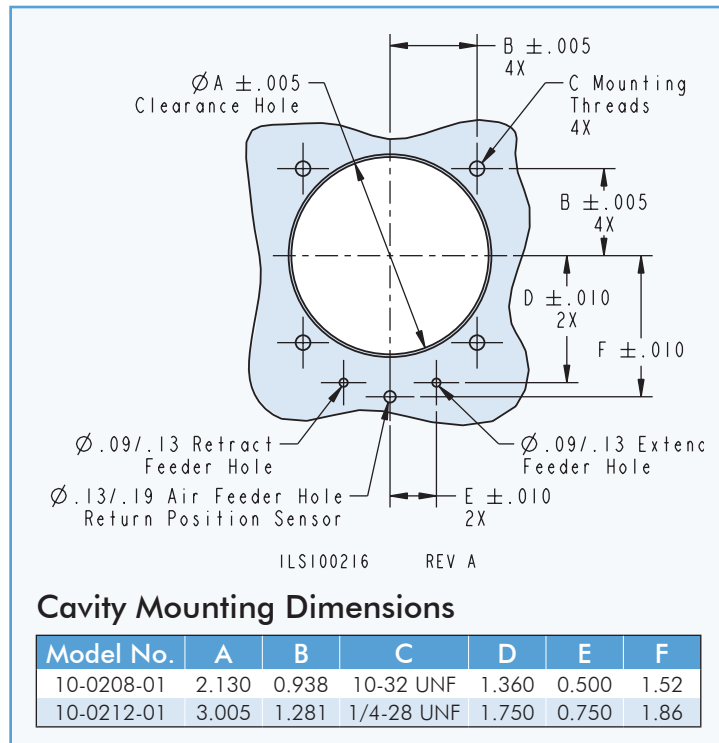


Top Flange

B-28



For proper sealing, mating surface must be flat within 0.003 in with a maximum 63 μ in. R_a surface finish.



Cavity Mounting Dimensions

Model No.	A	B	C	D	E	F
10-0208-01	2.130	0.938	10-32 UNF	1.360	0.500	1.52
10-0212-01	3.005	1.281	1/4-28 UNF	1.750	0.750	1.86

R	S	T	V	W	X	Y	Z	AA	AB	AC	AD	AE	AF
Cylinders, actuated hydraulically both directions.													
0.22	0.63	1.88	0.19	0.63	9/16-18 X 0.31	0.69	0.56	0.51	SAE 4	SAE 4	1.36	0.50	1.52
0.28	0.70	N/A	0.25	1.00	3/4-16 X 0.50	1.13	0.56	0.63	SAE 4	SAE 4	1.75	0.75	1.86

Note: If you would like to produce your own springs for these Work Supports see dimensions drawing on Page B-6

