



## Built-in elements

piston and threaded bushing, complete with seals for block cylinder,  
double-acting, max. operating pressure 500 bar



### 1 Description of the product

The built-in elements consist of piston and threaded bushing. The piston is inserted into the location hole of the fixture.

Then the built-in bushing is screwed into the fixture body. The bushing is let-in flush to the housing. Tightening of the threaded bushing is made with a pin-type face spanner.

Sealing with minimum leakage at the piston rod is obtained by two independent sealing steps. In addition, a wiper protects against contaminations. Sealing in the fit hole is made by an O-ring/back-up ring combination.

### 2 Validity of the documentation

This document applies to the following products:

Built-in elements of data sheet B1.5401. The following types or part numbers of piston and rod  $\varnothing$  are concerned:

- **16/10** - Part-no.: 0350-110, -111, -112, -113, 0131-151, -440, 0154-110, -111,
- **25/16** - Part-no. 0350-114, -115, -116, -117, -118, -119, 0131-154, -441, 0154-310, -311
- **32/20** - Part-no. 0350-005, -006, -120, -121, -122, -123 0154-410 0154-411 0131-156 0131-442
- **40/25** - Part-no. 0350-124, -125, -126, -127, -128, -129 0154-510, -511, 0131-158, -443
- **50/32** - Part-no. 0350-130, -131, -132, -133, -134, -135 0154-610, -611, 0131-160, -444
- **63/40** - Part-no. 0350-136, -137, -138, -139, -140, -141 0154-710, -711, 0131-166, -445
- **80/50** - Part-no. 0350-142, -143, -144, -145, -146, -147, 0154-810, -811, 0131-167, -446
- **100/63** - Part-no. 0350-148, -150, 0154-910, -911, 0131-168, -447

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### 3 Target group of this document

- Specialists, fitters and set-up men of machines and installations with hydraulic expert knowledge.

#### Qualification of the personnel

**Expert knowledge** means that the personnel must

- be in the position to read and completely understand technical specifications such as circuit diagrams and product-specific drawing documents,
- have expert knowledge (electric, hydraulic, pneumatic knowledge, etc.) of function and design of the corresponding components.

An **expert** is somebody who has due to its professional education and experiences sufficient knowledge and is familiar with the relevant regulations so that he

- can judge the entrusted works,
- can recognize the possible dangers,
- can take the required measures to eliminate dangers,
- knows the acknowledged standards, rules and guidelines of the technology.
- has the required knowledge for repair and mounting.

### 4 Symbols and signal words

#### **WARNING**

##### Person damage

Stands for a possibly dangerous situation.

If it is not avoided, death or very severe injuries will result.

#### **CAUTION**

##### Easy injuries / property damage

Stands for a possibly dangerous situation.

If it is not avoided, minor injuries or material damages will result.

##### **Hazardous to the environment**



The symbol stands for important information for the proper handling with materials that are hazardous to the environment.

Ignoring these notes can lead to heavy damages to the environment.



##### **Mandatory sign!**

The symbol stands for important information, necessary protection equipment, etc.

#### **NOTE**

- This symbol stands for tips for users or especially useful information. This is no signal word for a dangerous or harmful situation.

### 5 For your safety

#### 5.1 Basic information

The operating instructions serve for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with these operating instructions, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.

#### 5.2 Safety instructions

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual, in order to avoid personal damage or material damage.

- Read these operating instructions thoroughly and completely, before you work with the product.
- Keep these operating instructions so that they are accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer in order to exclude danger to persons because of not suited spare parts.
- Respect the intended use.
- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.
- Perform a risk analysis for the incomplete machine, or the machine.

Due to the interactions between the product and the machine/fixture or the environment, risks may arise that only can be determined and minimized by the user, e.g. :

- generated forces,
- generated movements,
- Influence of hydraulic and electrical control,
- etc.

## 6 Application

### 6.1 Intended use

The products are used in industrial applications to transform hydraulic pressure to a linear movement and /or force. They must only be operated with hydraulic oil.

Furthermore the following belongs to possible uses:

- Use within the capacity indicated in the technical characteristics (see data sheet).
- Use as per operating instructions.
- Compliance with service intervals.
- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.

### 6.2 Misapplication

#### **⚠ WARNING**

##### **Injuries, material damages or malfunctions!**

- Do not modify the product!

The use of these products is not admitted:

- For domestic use.
- On pallets or machine tool tables in primary shaping and metal forming machine tools.
- If due to vibrations or other physical / chemical effects damages of the products or seals can be caused.
- In machines, on pallets or machine tool tables that are used to change the characteristics of the material (magnetise, radiation, photochemical procedures, etc.).
- In areas for which special guidelines apply, especially installations and machines:
  - For the use on fun fairs and in leisure parks.
  - In food processing or in areas with special hygiene regulations.
  - For military purposes.
  - In mines.
  - In explosive and aggressive environments (e.g. ATEX).
  - In medical engineering.
  - In the aerospace industry.
  - For passenger transport.
- For other operating and environmental conditions e.g.:
  - Higher operating pressures than indicated on the data sheet or installation drawing.
  - With hydraulic fluids that do not correspond to the specifications.
  - Higher flow rates than indicated on the data sheet or installation drawing.

#### **Side load acting on the piston rod**

The application of side loads to the piston rod as well as the use of the product as a guiding element is inadmissible.

**Special solutions are available on request!**

## 7 Installation

### 7.1 Design

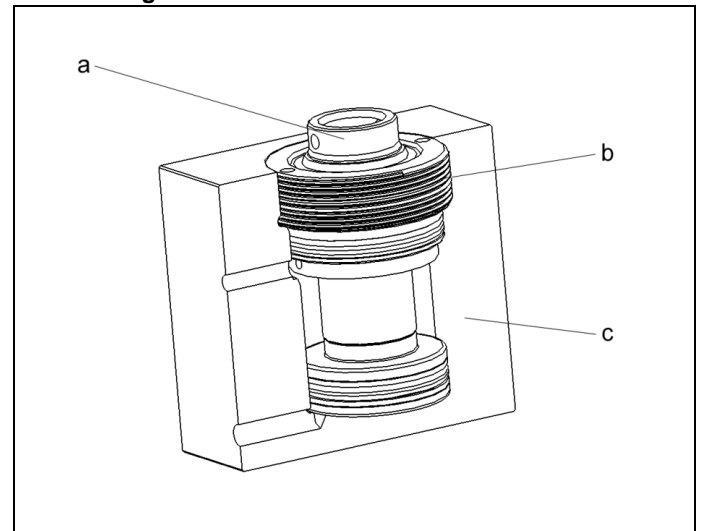


Figure 1: Components

a	Piston rod complete with seals	c	Fixture with location hole (dimensions etc. see data sheet)
b	Threaded bushing complete with seals		

### 7.2 Admissible oil flow rate

#### **⚠ WARNING**

##### **Injury due to overload of the element**

##### **High-pressure injection (squirting out of hydraulic oil under high pressure) or flying components!**

- Due to throttling or closing of ports a pressure intensification can occur.
- Connect the ports professionally!

#### **⚠ CAUTION**

##### **Maximum flow rates do not exceed**

The maximum flow rate must not be exceeded.

#### 7.2.1 Calculation of the admissible flow rate

##### **Admissible oil flow rate**

The admissible flow rate or the admissible stroke speed is valid for vertical mounting positions in combination with standard add-on parts as clamping arms or contact bolts, etc.

In case of other mounting positions and/or add-on parts the flow rate has to be reduced.

If the pump flow rate divided by the number of elements is larger than the admissible flow rate of one element, the flow rate has to be throttled.

This prevents an overload and therewith an early failure.

The flow rate can be checked as follows:

$$Q_p \leq 0,06 \cdot \dot{V}_Z \cdot n \quad \text{and/or} \quad Q_p \leq 6 \cdot v_Z \cdot A_K \cdot n$$

for clamping elements and work supports (indicated on the data sheets)

### Maximum piston speed

At specified pump flow rate **Q** and with the effective piston area **A** the piston speed can be calculated as follows:

$$v_m < \frac{Q_p}{6 \cdot A_K \cdot n}$$

### Legend

- $\dot{V}_Z$  = Admissible flow rate of the element in [cm<sup>3</sup>/s]
- $Q_p$  = Flow rate of the pump in [l/min]
- $A_K$  = Piston area in [cm<sup>2</sup>]
- $n$  = Number of elements, same dimensions
- $v_Z = v_m$  = Admissible/maximum stroke speed in [m/s]

### NOTE

#### Oil volume

- The maximum oil volume and/or the maximum stroke speed depend on the corresponding product.
- For clamping cylinders see data sheet A 0.100.
- or clamping elements, work supports, hydraulic valves, power units and other hydraulic elements indicated on the corresponding data sheets.

Further " things worth knowing about hydraulic cylinders, basics, detailed knowledge and calculations on hydraulic cylinders" see in the [Technical library](#) on the internet!

or download



### 7.2.2 Throttling of the flow rate

The throttling always has to be effected in the supply line to the swing clamp. Only thus pressure intensification and thereby pressures exceeding the operating pressure are avoided. The hydraulic circuit diagram shows flow control valves which allow oil return from the element without any impediments.

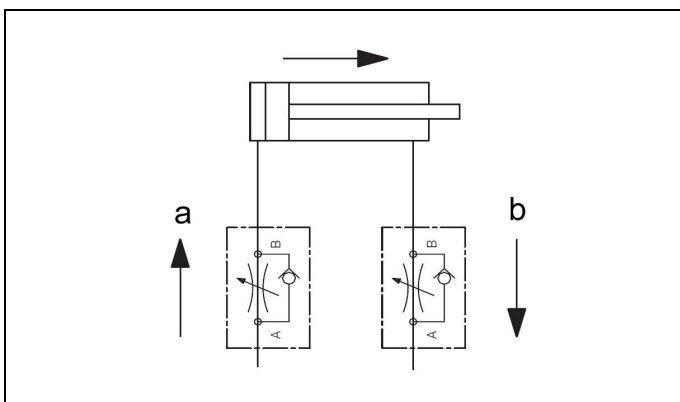


Figure 2: Hydraulic circuit diagram without flow control valves

a Throttling direction	b Free flow
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If a return-flow throttling is required due to a negative load, it must be guaranteed that the max. operating pressure (see technical characteristics) will not be exceeded.

## 7.3 Installation of products with external sealing

### 7.3.1 Design

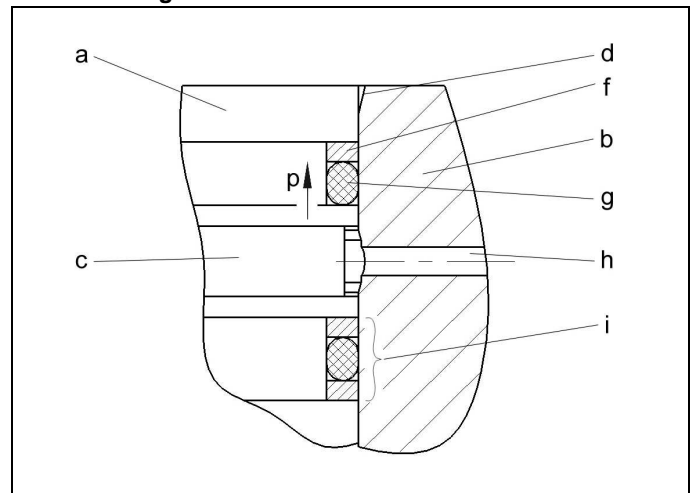


Figure 3: Components

a Body of the element	g O-ring seal
b Fixture body	h Supply bore holes in the fixture body
c Slot to transmit the hydraulic fluid	i Combination for pressure supply from both sides
d Insertion chamfer	p Pressure direction
f Back-up ring remote from the pressure side	

### 7.3.2 Installation

#### WARNING

#### Injury by crushing!

- Due to protruding components there can be pinch points during installation.
- Keep hands and fingers away from pinch points!

#### Injury by cutting!

- Sharp-edged threads can cause cut injuries.
- Wear personal protection equipment!



**For works at and with the product, wear protective gloves!**

Before starting the installation check the following:

- Is the location hole made as per data sheet?
  - Are the indicated tolerances and surfaces kept?
  - Is the wall thickness in the fixture sufficient?
- Are the tapers in the fixture made as per drawing?
- Are the bore holes in the installation geometry are deburred and round?
- Are machining residues as swarf, dirt and foreign particles removed?
- Are crests of threads covered?
- Are seals and components greased or lubricated before installation?
  - Pay attention to compatibility of seals with the medium!
  - It is recommended to use the medium to be sealed for lubrication.
- Do not use grease with additions of solids as molybdenum sulphite or zinc sulphite.
- Do not use sharp objects for installation!
- Pay attention to protruding back-up rings. Use aids for correct positioning.
- Use always installation aids, if possible.

**Procedure for installation**

1. Insert seals.
2. Insert or screw in into location hole.
3. Screw in or fasten, pay attention to smooth running. Pay attention that the seals will not be damaged.
4. Fasten with corresponding tightening torque (see general characteristics).  
See chapter Technical characteristics.

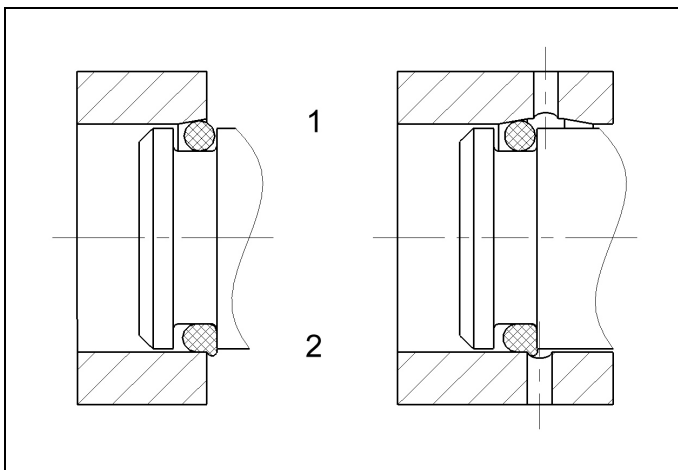


Figure 4: Installation with insertion chamfer and cross hole

1 Correct with chamfer	2 Incorrect without chamfer
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**7.4 Connection of the hydraulic equipment**

1. Connect hydraulic lines to qualifying standards and pay attention to scrupulous cleanness (A = Extend, B = Retract)!

**NOTE**

**More details**

- See ROEMHELD data sheets A 0.100, F 9.300, F 9.310 and F 9.360.

**Screwed Plug**

- Use only fittings "screwed plug B and E" as per DIN 3852 (ISO 1179).

**hydraulic connection**

- Do not use sealing tape, copper rings or coned fittings.

**Pressure fluids**

- Use hydraulic oil as per ROEMHELD data sheet A 0.100.

**7.5 Leakage due to the system**

The piston rod is set in motion by the hydraulic oil to perform the clamping task.

The hydraulic oil must be sealed at the piston rod to the atmosphere. During extension of the piston rod, the hydraulic oil must remain in the cylinder.

For ROEMHELD products, sealing systems are used for the piston rod, generally consisting of several sealing elements. Those sealing systems enable the sealing points to be absolutely leak-proof in the total specified pressure area, when the system is not in operation. Neither does oil escape at the piston rod, nor is oil transferred from the piston side and piston rod side.

**Important:** ROEMHELD products do not leak oil when static.

To ensure an adequate working life, the sealing systems must be lubricated by the hydraulic fluid while in motion, in dynamic operation. Since the hydraulic fluid must reach the sealing lip, a certain amount of oil is lost from leakage, in the process .

According to the used sealing and the corresponding application conditions the amount can be very different depending on the product group. However the leakage should be very little (see A 0.100 General characteristics of hydraulic equipment).

**Leakage-free cylinders (leakage re-circulation or special sealing) are available on request.**

## 8 Start up

### **⚠ WARNING**

#### **Poisoning due to contact with hydraulic oil!**

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

### **⚠ CAUTION**

#### **Operating pressure of 500 bar does not exceed**

The maximum operating pressure of 500 bar must not be exceeded.

1. Check tight seat.
2. Check tight seat of the hydraulic ports (check tightening torque of the hydraulic ports).
3. Bleed the hydraulic system.

### **ℹ NOTE**

#### **Clamping time**

- Without bleeding the clamping time will be considerably prolonged and function problems may occur.

### 8.1 Bleeding of manifold-mounted types

1. Loosen carefully the bleeding screws of the fixture at low pressure.
2. Pump until bubble free oil comes out.
3. Fasten the bleeding screws.
4. Check correct function.
5. Check sealing of the hydraulic connections!

## 9 Maintenance

### **⚠ WARNING**

#### **Burning due to hot surface!**

- In operating conditions, surface temperatures of more than 70 °C can appear at the product.
- All maintenance and repair works must only be effected in cooled mode or with safety gloves.

### 9.1 Cleaning

### **⚠ CAUTION**

#### **Avoid damages of the moved components**

Avoid damages of the moved components (rods, plungers, bolts, etc.) as well as of wiper and seal.

#### **Aggressive cleaning agents**

The product must not be cleaned with:

- Corrosive or corroding components or
- Organic solvents as halogen or aromatic hydrocarbons and ketones (cellulose thinner, acetone, etc.), because this can destroy the seals.

The product must be cleaned at regular intervals, especially the area of the piston or the plunger housing has to be cleaned from swarf and other liquids.

In the case of heavy contamination, the cleaning has to be made in shorter intervals.

### 9.2 Regular checks

1. Check tightness of hydraulic connections (visual control).
2. Check running surfaces (of the piston rod or bolt) if there are marks and scratches. Traces of marks can be an indication for a contaminated hydraulic system or an inadmissible side load of the block cylinder.
3. Leakage check at the housing - piston rod, bolt or flange.
4. Clamping force control by pressure control.
5. Check if the maintenance intervals are kept.

### 9.3 Exchange seal kit

The exchange of the seal kit is made in case of external leakages. For high availability, the seals have to be changed at the latest after 500,000 cycles or 2 years.

The seal kit is available as spare part. An instruction for the exchange of the seal kit is available on request.

### **ℹ NOTE**

#### **Seal Kits**

- Do not install seal kits which were exposed to light for a longer time.
- Pay attention to the storage conditions (see chapter "Technical characteristics").
- Only use original seals.

## 10 Trouble shooting

Trouble	Cause	Remedy
Piston does not extend:	hydraulic oil supply or return is impeded	check and blow through tubes or channels
Piston extends jerkily:	air in the hydraulic system	hydraulic bleeding
System pressure reduces:	hydraulic port leaky	seal
	wear of seals	replace seals

## 11 Technical characteristics

### **General characteristics**

Technical data and installation dimensions on request

## 12 Accessory

### **ℹ NOTE**

#### **Accessories**

- See data sheet.



### 13 Storage

#### CAUTION

##### Storage of components!

- The product may not be exposed to direct solar radiation, because the UV light can destroy the seals.
- A storage differing from the storage conditions is inadmissible.
- In case of improper storage, the seals can embrittle and resinification of the anti-corrosive oil or corrosion at the element can occur.

The elements are tested by default with mineral oil. The exterior of the elements is treated with a corrosion inhibitor.

The oil film remaining after the test provides for a six-month interior corrosion protection, if stored in dry and uniformly tempered rooms.

For longer storage times, the element has to be filled with a non-resinifying corrosion inhibitor and the outside surfaces must be treated.

### 14 Disposal



#### Hazardous to the environment

Due to possible environmental pollution, the individual components must be disposed only by an authorised expert company.

The individual materials have to be disposed as per the existing regulations and directives as well as the environmental conditions.

Special attention has to be drawn to the disposal of components with residual portions of hydraulic fluids. The instructions for the disposal at the material safety data sheet have to be considered.

For the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) country-specific legal regulations and specifications have to be kept.

### 15 Declaration of manufacture

#### Manufacturer

Römheld GmbH Friedrichshütte  
 Römheldstraße 1-5  
 35321 Laubach, Germany  
 Tel.: +49 (0) 64 05 / 89-0  
 Fax: +49 (0) 64 05 / 89-211  
 E-mail: info@roemheld.de  
 www.roemheld.com

#### Declaration of manufacture of the products

Built-in elements of data sheet B1.5401. The following types or part numbers of piston and rod  $\varnothing$  are concerned:

- **16/10** - Part-no.: 0350-110, -111, -112, -113, 0131-151, -440, 0154-110, -111,
- **25/16** - Part-no. 0350-114, -115, -116, -117, -118, -119, 0131-154, -441, 0154-310, -311
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- **100/63** - Part-no. 0350-148, -150, 0154-910, -911, 0131-168, -447

They are designed and manufactured in line with the relevant versions of the directives **2006/42/EC** (EC MSRL) and in compliance with the valid technical rules and standards. In accordance with EC-MSRL and EN 982, these products are components that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

According to the pressure equipment directives the products are not to be classified as pressure reservoirs but as hydraulic placing devices, since pressure is not the essential factor for the design, but the strength, the inherent stability and solidity with regard to static or dynamic operating stress.

The products may only be put into operation after it was assessed that the incomplete machine/machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.

The technical documentation as per appendix VII part B was prepared for the products.

Responsible person for the documentation:

Dipl.-Ing. (FH) Jürgen Niesner, Tel.: +49(0)6405 89-0.

**Römheld GmbH**

**Friedrichshütte**

Laubach, 29.11.2013