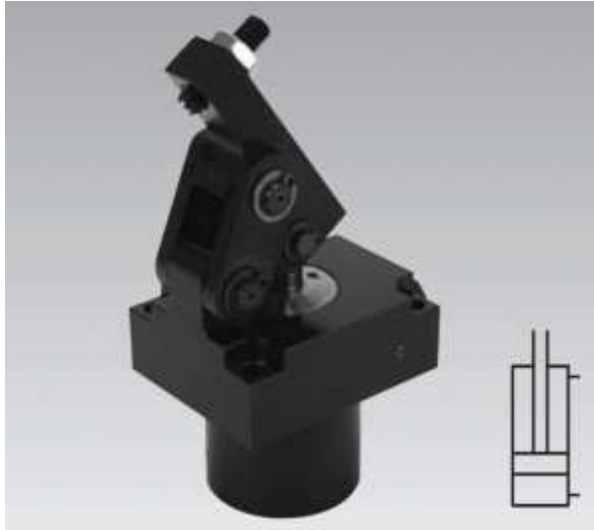




Hinge Clamps 70 bar

with metallic wiper edge and optional position monitoring,
double acting, max. operating pressure 70 bar



1 Description of the product

When pressurising the element, the piston moves upwards and swivels the clamping lever over the hinges forwards and at the same time downwards onto the workpiece.

The piston force is deviated by 180° and is available as clamping force with virtually no loss of efficiency. If the level of the clamping surface is exactly on height h, no side loads are introduced into the workpiece.

The bodies are recessible in the fixture up to the flange. As an alternative the connection by pipe thread or drilled channels is possible. All connections of the delivered element are closed. All versions are optionally available with extended piston rod and with inductive or pneumatic position monitoring.

2 Validity of the documentation

This document applies to the following products:

Hinge clamps of data sheet B 1.8267. The following types or part numbers are concerned:

Part-no. without switch rod

- without switch rod
1826 7130, -7230, -7330, -7430, -7530
- with clamping lever (contact bolt)
1826 7131, -7231, -7331, -7431, -7531
- with long clamping lever
1826 7132, -7232, -7332, -7432, -7532

Part-no. with switch rod

- without clamping lever
1826 7140, -7240, -7340, -7440, -7540
- with clamping lever (contact bolt)
1826 7141, -7241, -7341, -7441, -7541
- with long clamping lever
1826 7142, -7242, -7342, -7442, -7542

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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 Safety instructions

DANGER

Danger of life / heavy health damages

Stands for an imminent danger.

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

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

WARNING

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

- Improper connection can lead to escapes of oil under high pressure at the connections.
- Mounting or dismounting of the element must only be made in depressurised mode of the hydraulic system.
- Connection of the hydraulic line as per DIN 3852/ISO 1179.
- Unused connections have to be locked professionally.
- Use all mounting holes.

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

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

- Before using them make a visual control.

Injury by falling parts!

- Keep hands and other parts of the body out of the working area.
- Wear personal protection equipment!

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

Great weight may fall

Some product types have a considerable weight. These have to be secured against working free during transport.

Weight specifications see chapter "Technical characteristics".

Side loads and forced conditions acting on the piston lead to increased wear

- Provide external guides.
- Avoid forced conditions (overdetermination) of the piston.

7.1 Design

7.1.1 Design of cartridge-type version

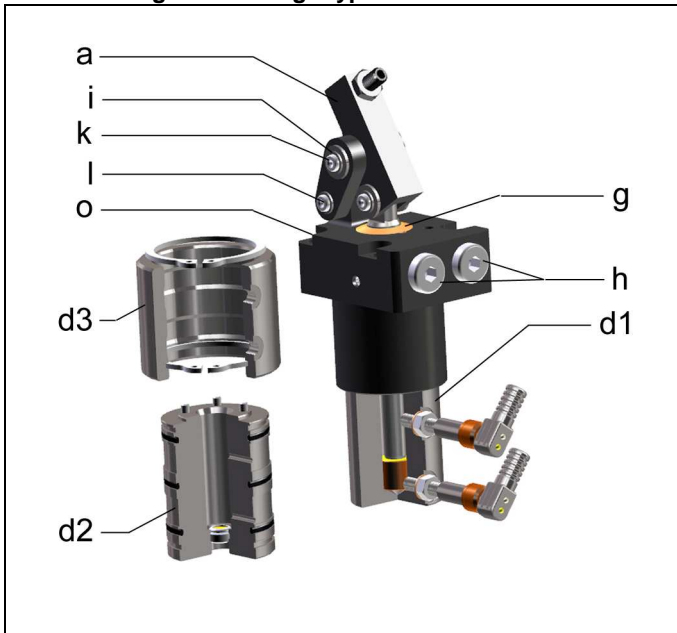


Figure 1: Components

d1 Inductive position monitoring	a Clamping lever with adjustable contact bolt or long clamping lever
d2 Pneumatic position monitoring cartridge-type	g Piston
d3 Pneumatic position monitoring mounting body pipe thread	i Safety ring
h Plugs	l Swing bolt down
	k Swing bolt up
	o Fixing screws "not represented"

7.2 Mounting types

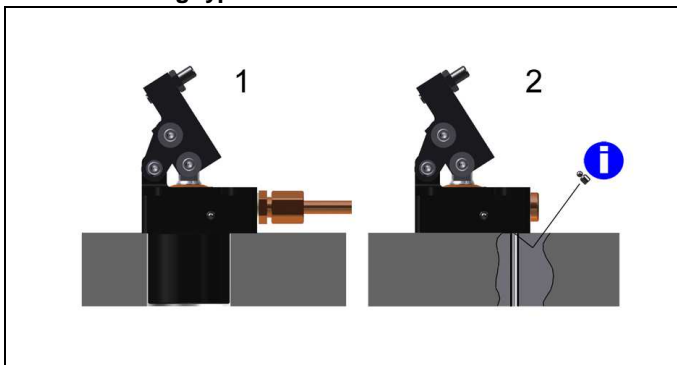


Fig. 2: Mounting types

1 In through hole with pipe thread at the back	2 In through hole with oil supply by O-rings
--	--

CAUTION

Set screw and ball

Have to be removed for connection with O-rings.

7.3 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.

7.3.1 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:

$$Q_p \leq 0,06 \cdot \dot{V}_z \cdot n \text{ and/or } Q_p \leq 6 \cdot v_z \cdot A_K \cdot n$$

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 [cm³/s]

Q_p = Flow rate of the pump in [l/min]

A_K = Piston area in [cm²]

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



7.3.2 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.

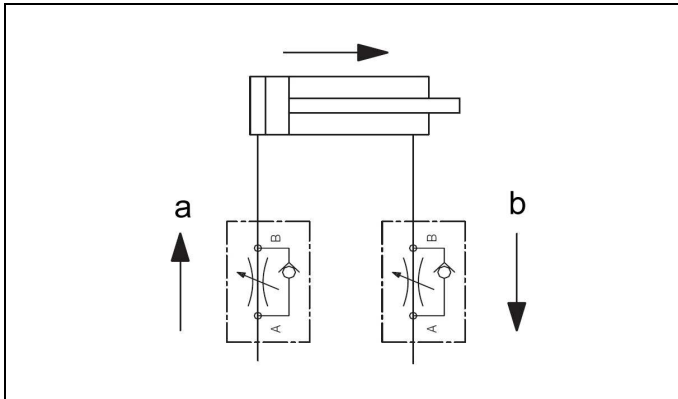


Figure 3: Hydraulic circuit diagram without flow control valves

a Throttling direction	b Free flow
------------------------	-------------

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.

7.4 Installation of manifold-mounted types

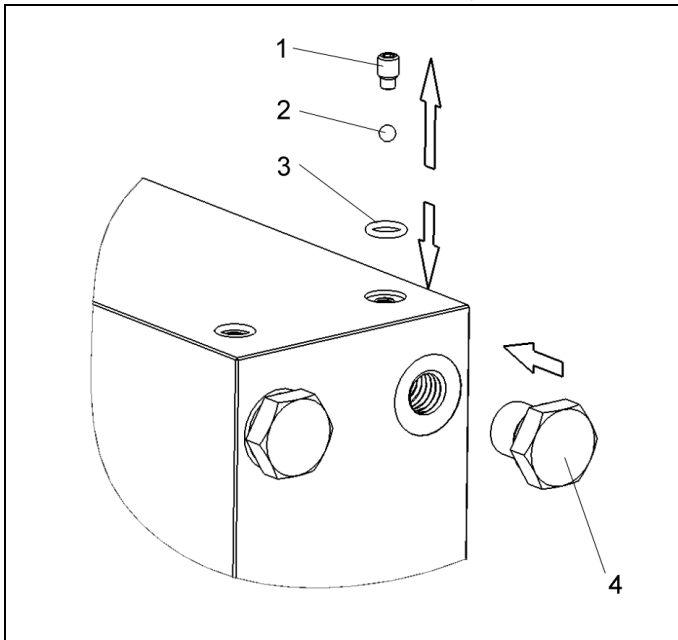


Figure 4: Example of the preparation for hydraulic ports with set screw and ball

1 Set screw	3. O-ring (accessory)
2 Ball	4. Screw plug (accessory, if required)

1. Drill the holes for hydraulic oil supply and return in the fixture (see also data sheet).

2. Grind or finish mill flange surface ($Ra \leq 0.8$ and plane, marks, scratches, shrink holes, concentric machining marks are not admissible).
3. Remove set screw and ball.
4. Seal pipe ports with screw plug (accessory, if required)
5. Close hydraulic port by means of screw plug.
6. Clean the support surfaces.
7. Position and fix on the fixture.
6. Install bleeding screws at the upper ends of the piping.

NOTE

Tightening torques

- The tightening torques for the fixing screws have to be designed with reference to the application (e. g. as per VDI 2230).

Proposals and approximate values for the tightening torques see chapter "Technical characteristics".

7.5 Installation of pipe-mounted types

1. Clean the support surfaces.
2. Fasten the element support at the flange surface (see figure "Mounting types").

WARNING

Injury by falling products!

Safety shoes have to be worn to avoid injuries due to falling objects.

NOTE

Tightening

- To determine the tightening torque of the fixing screws a screw calculation as per VDI 2230 page 1 has to be effected. The screw material is indicated in the chapter "Technical characteristics".

NOTE

Tightening torques

- The tightening torques for the fixing screws have to be designed with reference to the application (e. g. as per VDI 2230).

Proposals and approximate values for the tightening torques see chapter "Technical characteristics".

7.6 Installation of manifold-mounted types

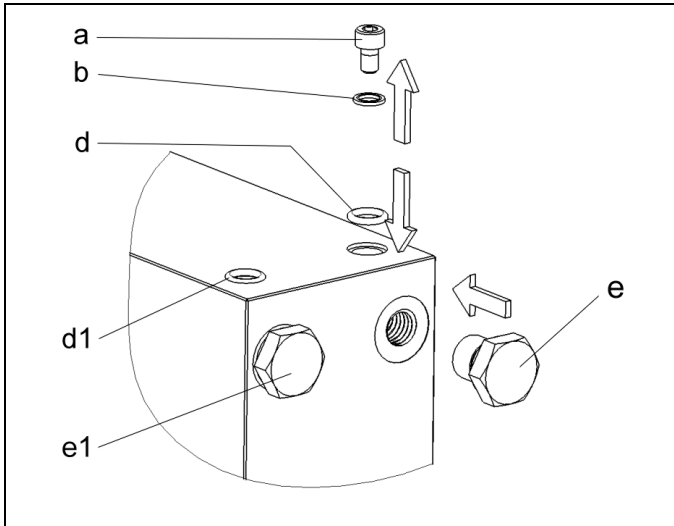


Figure 5: Example, preparation for hydraulic ports without pipes

NOTE

The arrangement of the ports

- The shown figure is a schematic diagram. The arrangement of the ports depends on the respective product (see chapter "Design").

a	Socket head cap screw	d1	Mounted O-ring
b	Sealing ring	e	Screw plug (accessory)
d	O-ring (accessory, depending on the version)	e1	Mounted screw plug

- Drill the holes for hydraulic oil supply and return in the fixture (see also data sheet).
- Grind or finish mill the manifold-mounting surface ($Ra \geq 0.8$ and a flatness of 0.04 mm to 100 x 100 mm, marks, scratches, shrink holes, concentric machining marks are inadmissible).

For some versions:

- Remove socket head cap screws and sealing rings, insert o-rings (accessories, if required).
 - Tighten pipe ports with screw plugs (accessories, if required)
- Clean the support surfaces.
 - Position and fasten on the fixture.
 - Install bleeding screws at the upper ends of the piping.

NOTE

Tightening torques

- The tightening torques for the fixing screws have to be designed with reference to the application (e. g. as per VDI 2230).

Proposals and approximate values for the tightening torques see chapter "Technical characteristics".

7.7 Connection of the hydraulic equipment

- 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.

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 070 bar not exceed

The maximum operating pressure of 70 bar must not be exceeded.

- Check tight seating (check tightening torque of the fixing screws, see chapter "Technical characteristics").
- Check tight seating of hydraulic connections (check tightening torque of the hydraulic connections, see chapter "Technical characteristics").
- Bleed the hydraulic system.

NOTE

Clamping time

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

- Start up of position monitoring.

Note

See operating instructions of the position monitoring.

8.1 Bleeding of pipe-mounted types

- Loosen carefully at low pressure union nut of the pipe at the hydraulic ports.
- Pump until bubble free oil comes out.
- Fasten union nuts of the pipe.
- Check tightness.

8.2 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, cleaning must be made at shorter intervals.

Note

Special care must be taken with:

- dry machining
- minimum quantity lubrication and
- small grinding swarf

Small swarf and dust can stick to the rod / plunger of the element and be pulled into the sealing gap of the metallic wiper edge.

Thus, a sticky / pasty mass of swarf / dust can arise that hardens during standstill.

Result: Malfunction due to deadlock / bonding and increased wear.

Remedy: Regular cleaning of the piston rod/support plunger in the effective area of the wiper.

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.

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

Type	Maximum operating pressure	Maximum clamping force
	[bar]	[kN]
1826-71XX	70	2.6
1826-72XX	70	3.5
1826-73XX	70	4.4
1826-74XX	70	7.3
1826-75XX	70	12.1

Proposal, tightening torques for screws of tensile strength 8.8, 10.9, 12.9

NOTE

The indicated values are approximate values and have to be interpreted according to the user's application!

See note!

Thread	Tightening torque [Nm]		
	8.8	10.9	12.9
M6	10	15	18
M8	25	36	45
M10	49	72	84
M12	85	125	145
M14	135	200	235
M16	210	310	365
M20	425	610	710
M24	730	1050	1220
M30	1,450	2100	2450

Note: Valid for workpieces and set screws made of steel with metric thread and connecting surface dimensions as per DIN 912, 931, 933, 934 / ISO 4762, 4014, 4017, 4032

In the table values for tightening torques the following is considered:

Design steel/steel, friction value $\mu_{ges} = 0.14$ - not oiled, utilisation of the minimum yield point = 90%.

NOTE

Further information

- For further technical data see ROEMHELD data sheet.

12 Accessory

NOTE

Accessories

- See data sheet.

12.1 Pneumatic position monitoring

Pneumatic position monitoring to be mounted at products with extended piston rod



12.1.1 Description of the product

The position monitoring is screwed on the cylinder bottom. A control cam is provided at the extended piston rod causing the activation of the pneumatic jets.

12.1.2 Validity of the documentation

These operating instructions apply to the pneumatic position monitoring with the following part number:

- 0353 341, -342, -343, -344, -345

Mounting body for retrofitting of the cartridge type

- 0353 341A, -342A, -343A, -344A, -345A

12.1.3 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.

12.1.4 For your safety

Qualification of the user

All works may only be effected by qualified personnel familiar with the handling of electric components.

12.1.5 Application

12.1.5.1 Intended use

Pneumatic position monitorings are used for industrial applications in order to get a feedback from both end positions of the stroke range of a product.

They are exclusively designed to be mounted at ROEMHELD products and for their control.

In addition, applies the intended use of the products for which they have been designed.

12.1.5.2 Misapplication

Position monitoring systems are not suitable for applications where coolants are used.

12.1.6 Installation

1. Screw on position monitoring at the flange and at the piston rod.
2. Connect both pneumatic ports (**b = unclamping** and **d = clamping range**).
3. If there is any danger of fluids being sucked into the filter, the filter element has to be removed and a vent hose has to be connected.

NOTE

For interpretation of the pneumatic pressure we recommend to use a differential pressure switch.

Parallel connection for up to 8 swing clamps is possible. For a greater number there are special solutions. Please contact us.

NOTE

A signal evaluation with pressure switches is possible.

12.1.7 Start up

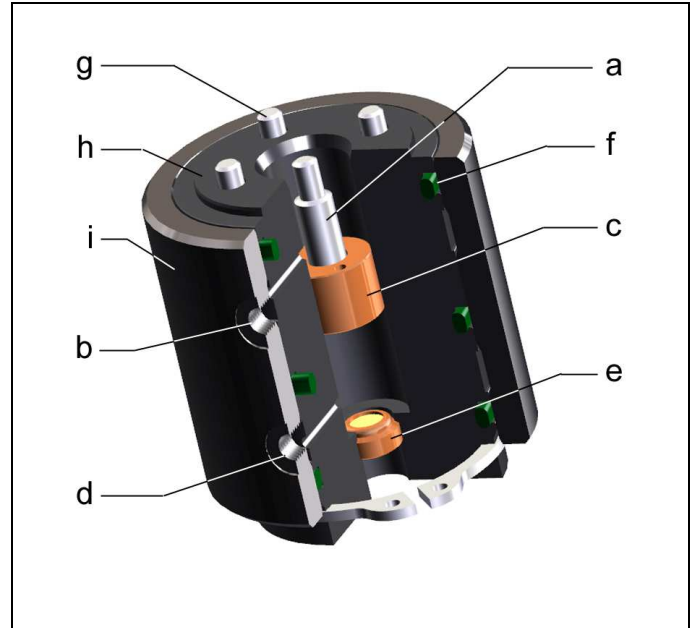


Figure 6: Design

a	Fixation of the signal sleeve	δ	Lower pneumatic port, unclamped
b	Upper pneumatic port, clamping range	e	Venting by means of the filter element
χ	Signal sleeve with control cams	f	O-ring
h	Cartridge type	g	Fixing screw
i	Mounting body		

1. Connect pneumatic ports from the differential pressure switch to the position monitoring.
2. The piston position will be signalled by the pressure build up at the upper or lower pneumatic port:

Pressure built-up and/or signal sleeve is	Piston is
at the top (Fig. Design)	extended
at the bottom	retracted

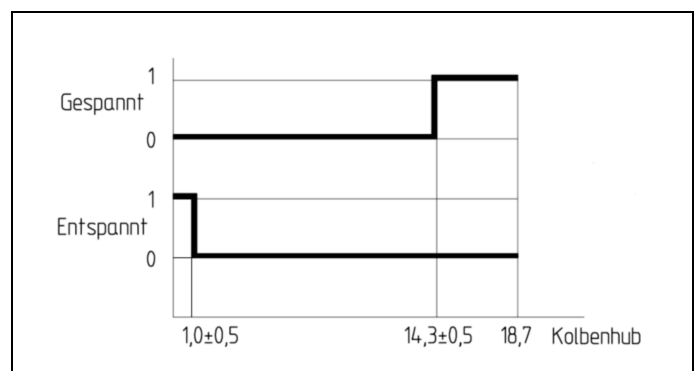


Figure 7: Signal course

1	Signal ON	0	Signal OFF
---	-----------	---	------------

NOTE

Evaluation of the pneumatic pressure

- For interpretation of the pneumatic pressure we recommend to use a differential pressure switch.
- Parallel connection for up to 8 elements is possible. For a greater number there are special solutions. Please contact us.

Signal evaluation

A signal evaluation with pressure switches is possible.

Impurities in the compressed air

- The pollution of the compressed air can lead to interferences in the measurement .

12.1.8 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.

12.1.8.1 Cleaning

The position monitoring must be cleaned at regular intervals.

12.1.8.2 Regular checks

- Check position monitoring if there are damages.
- Check tight seating of the position monitoring.
- The position monitoring itself is maintenance free.

12.1.9 Trouble shooting

Trouble	Cause	Remedy
No signal	Insufficient pressure differential	Throttle flow rate, reduce pressure
	Position monitoring has become loose	Fix again position monitoring
	Leakage in the system	Check supply lines
Incorrect signals:	Position monitoring has become loose	Fix again position monitoring

12.1.10 Technical characteristics

Cylinder body material:	Steel, corrosion resistant
-------------------------	----------------------------

Note

Further technical data with reference to the position monitoring are included in the data sheet.

12.1.11 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.

12.1.12 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

These operating instructions apply to the pneumatic position monitoring with the following part number:

- 0353 808, -809, -810

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, 28.01.2014

12.2 Electrical position monitoring

Electrical position monitoring to be mounted at products with switch rod



12.2.1 Description of the product

The position monitoring is screwed on the cylinder bottom. A control cam is fixed at the switching disk causing the activation of the inductive proximity switches. The minimum distance to the positions to be monitored depends on the switch type and is indicated in the chart. Different versions are available according to the application conditions. The position monitoring is delivered without proximity sensors; sensors are available as accessory.

12.2.2 Validity of the documentation

These operating instructions apply to the electrical position monitoring with the following part numbers:

without switch

- 0353 351, -352, -353, -354, -355

with switch and plug

- 0353 351S, -352S, -353S, -354S, -355S

12.2.3 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.

12.2.4 For your safety

Qualification of the user

All works may only be effected by qualified personnel familiar with the handling of electric components.

12.2.5 Application

12.2.5.1 Intended use

Position monitorings are used for industrial applications in order to get an electrical feedback from both end positions or intermediate positions of a product.

They are exclusively designed to be mounted at ROEMHELD products and for their control.

In addition, applies the intended use of the products for which they have been designed.

12.2.5.2 Misapplication

Position monitoring systems are not suitable for applications where coolants are used, since swarf can influence the function of the magnetic sensors.

12.2.6 Installation

1. Screw on position monitoring at the flange and at the piston rod.
2. Connect both proximity switches E1 and E2 as per electrical circuit diagram.

NOTE

Application of Position Control

- Position monitoring is not suitable for applications where coolants and lubricants are used.
- Install protection covers against possible swarf.

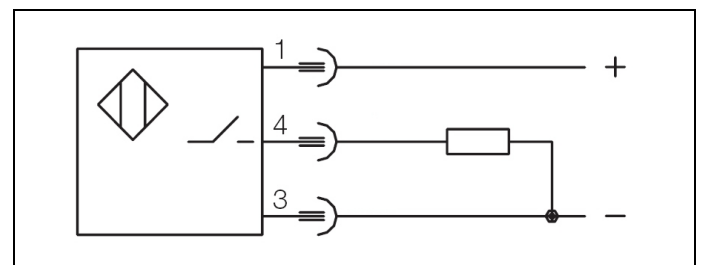


Fig. 8: circuit diagram for pnp (+) magnetic sensor

- | | |
|---|---------|
| 1 | brown + |
| 3 | blue - |
| 4 | black |

12.2.7 Start up

12.2.7.1 Electrical position monitoring

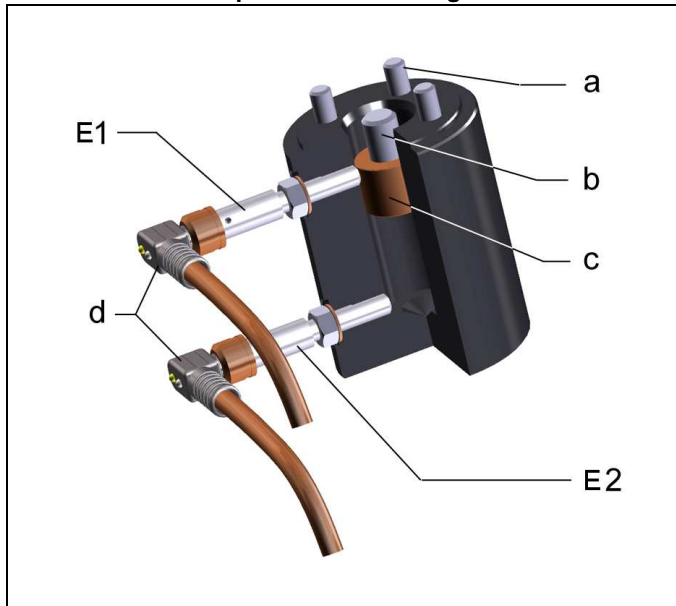


Figure 9: Design of the electrical position monitoring

d Proximity switch E2 (un-clamped)	b Fixing screw (signal sleeve)
d Proximity switch E1 (clamping range)	c Signal sleeve
a Fixing screws (position monitoring)	

Adjustment of proximity switches

1. Unclamp piston.
2. Screw in proximity switch E2 up to the stop on the signal sleeve and turn back 1/2 rotation. Tighten safety nut at the proximity switch.
3. Clamp piston.
4. Screw in proximity switch E1 up to the stop on the signal sleeve and turn back 1/2 rotation. Tighten safety nut at the proximity switch.

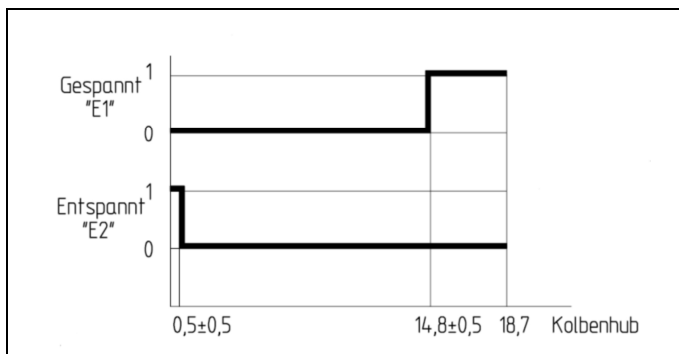


Figure 10: Signal course - clamping

1 Signal ON	0 Signal OFF
-------------	--------------

Figure shows the signal course at both proximity switches during a clamping and unclamping process (max. = total stroke).

12.2.8 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.

12.2.8.1 Cleaning

The position monitoring must be cleaned at regular intervals.

12.2.8.2 Regular checks

- Check position monitoring if there are damages.
- Check tight seating of the position monitoring.
- The position monitoring itself is maintenance free.

12.2.9 Trouble shooting

Trouble	Cause	Remedy
No signal when extending or retracting the piston:	No supply voltage	Check supply voltage and switch on again, if necessary
Incorrect signals:	Proximity switch or position monitoring has become loose	Adjust and fix again proximity switch or position monitoring
No signal:		

12.2.10 Technical characteristics

Operating voltage UB:	10 ... 30 V DC
Residual ripple:	max. 15%
Switching function:	Interlock
Output:	PNP
Cylinder body material:	Steel, corrosion resistant
Protection as per DIN 40050	IP 67

i Note

Further technical data with reference to the position monitoring are included in the ROEMHELD data sheet.

12.2.10.1 Technical data / proximity sensor

Environmental temperature:	-25 °C to +80 °C	-25 °C to +120 °C
Rated operating distance Sn:	1.5 mm	1.5 mm
Secured operating distance:	0 ... 1.2 mm	0 ... 2.0 mm
Hysteresis:	max. 15 %	max. 15 %
Repetitive accuracy:	max. 5%	max. 5%
Body material:	1.4104 steel, corrosion resistant	
Code class:	IP 68	IP 68
Connection type:	plug S4	plug S4
Voltage:	DC	DC
Switching function:	interlock	interlock
Output:	pnp	pnp
Operating voltage UB:	10 ... 30 V	10 ... 30 V
Design voltage:	24 V	24 V
Design current:	200 mA	200 mA
Residual ripple:	max. 15%	max. 15%
Switching frequency	1 kHz	2 kHz
Protection against reverse battery:	installed	installed
Protected against short circuits	yes	yes

12.2.11 Accessory

- Plug with cable
- Spare proximity switch

Note

See ROEMHELD data sheet

12.2.12 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.

12.2.13 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

These operating instructions apply to the electrical position monitoring with the following part numbers:

without switch

- 0353 351, -352, -353, -354, -355

with switch and plug

- 0353 351S, -352S, -353S, -354S, -355S

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, 28.01.2014

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

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 www.roemheld.com

Declaration of manufacture of the products

Hinge clamps of data sheet B 1.8267. The following types or part numbers are concerned:

Part-no. without switch rod

- without switch rod
1826 7130, -7230, -7330, -7430, -7530
- with clamping lever (contact bolt)
1826 7131, -7231, -7331, -7431, -7531
- with long clamping lever
1826 7132, -7232, -7332, -7432, -7532

Part-no. with switch rod

- without clamping lever
1826 7140, -7240, -7340, -7440, -7540
- with clamping lever (contact bolt)
1826 7141, -7241, -7341, -7441, -7541
- with long clamping lever
1826 7142, -7242, -7342, -7442, -7542

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
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 Laubach, 28.01.2014