

INTRODUCTION ON THE PRELOAD FUNCTION

As indicated in the general characteristics, for the correct functioning of the cylinder it is necessary to bring the piston to the most extreme forward end stroke position.

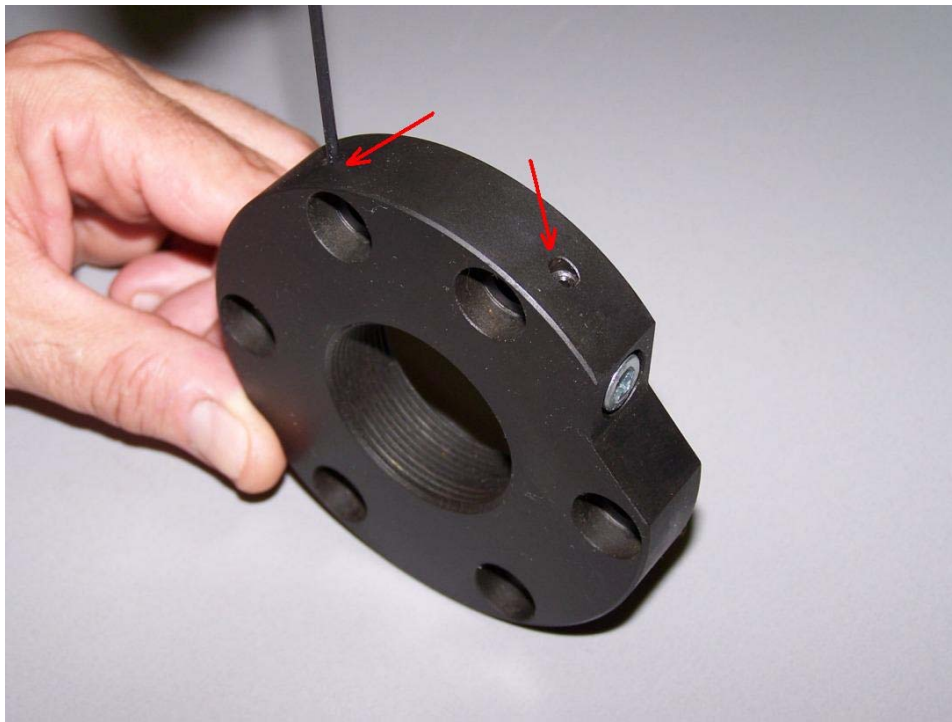
For common applications on moulds, for punches and plugs which are to be fixed at the end on the matrix, this could cause material infiltrations during the injection phase.

In order to avoid such infiltrations it is possible to make a preload, this operation could be considered in project phase by making the position of the cylinder on the mould with a reductions of the L2 length equal to the maximum preload indicated in a table pg.F5 of the Vega's catalogue, or, in phase of the setting mould, it will be necessary to verify the position of the "0" point of the punches in matrix, and after to grind the plate or cylinder's fixing flange.

The easiest and immediately solution is the fixing flange with the adjustable preload system.
(see the Vega's catalogue pg.F8)

INSTRUCTIONS OPERATIVE FOR V260 FIXING FLANGE PRELOAD SETTING

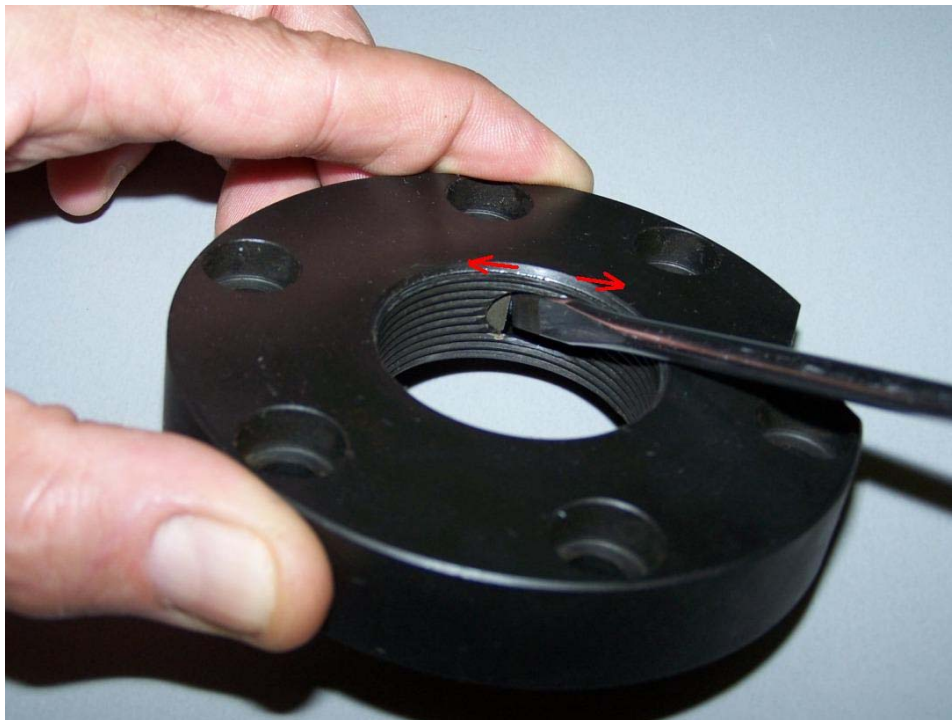




1) Loose the lock compass-flange grub screws



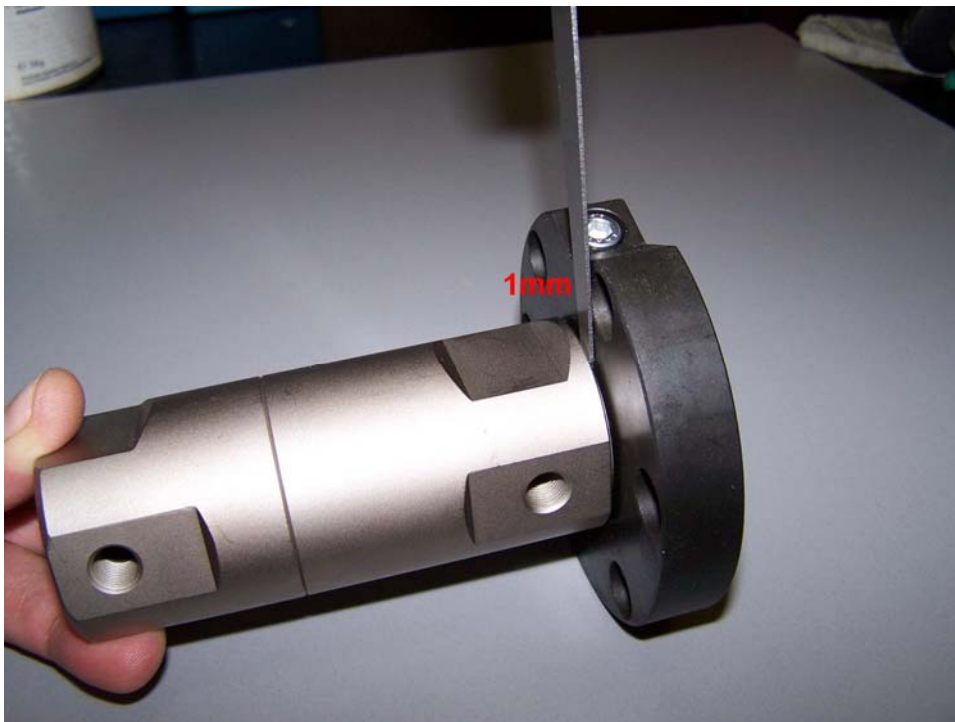
2) Loose the flange/cylinder fixing screw



3) Widen the lock compass with the help a screw driver



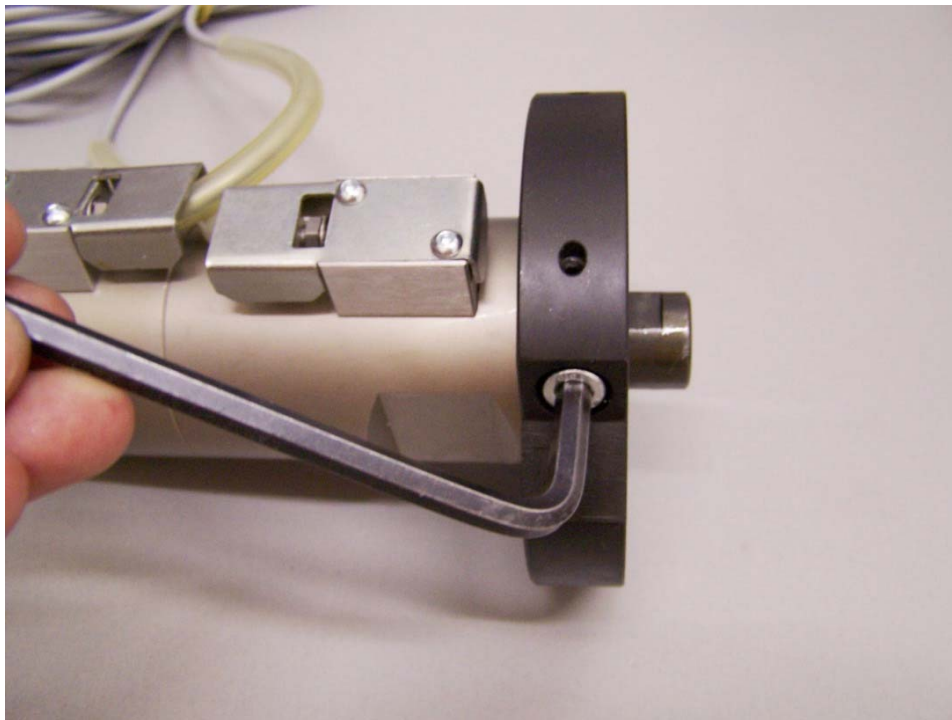
4) Screw on the fixing flange on the cylinder



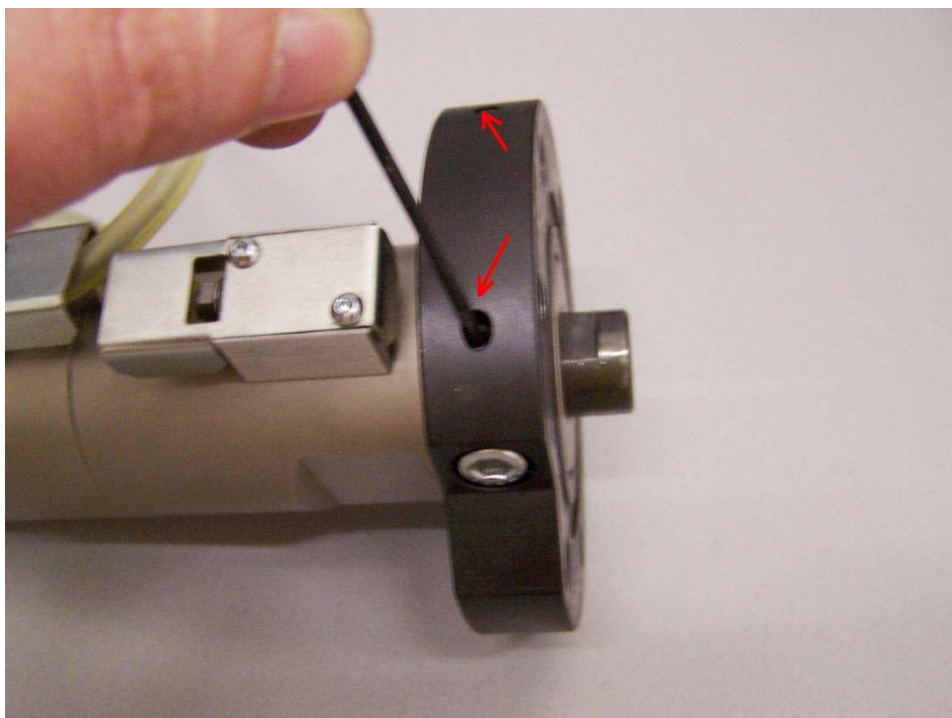
5) Leave 1 mm from the fixing flange to the end of the cylinder's body thread

ATTENTION

In project phase it could be important predict an increasing L2 length + 1 mm



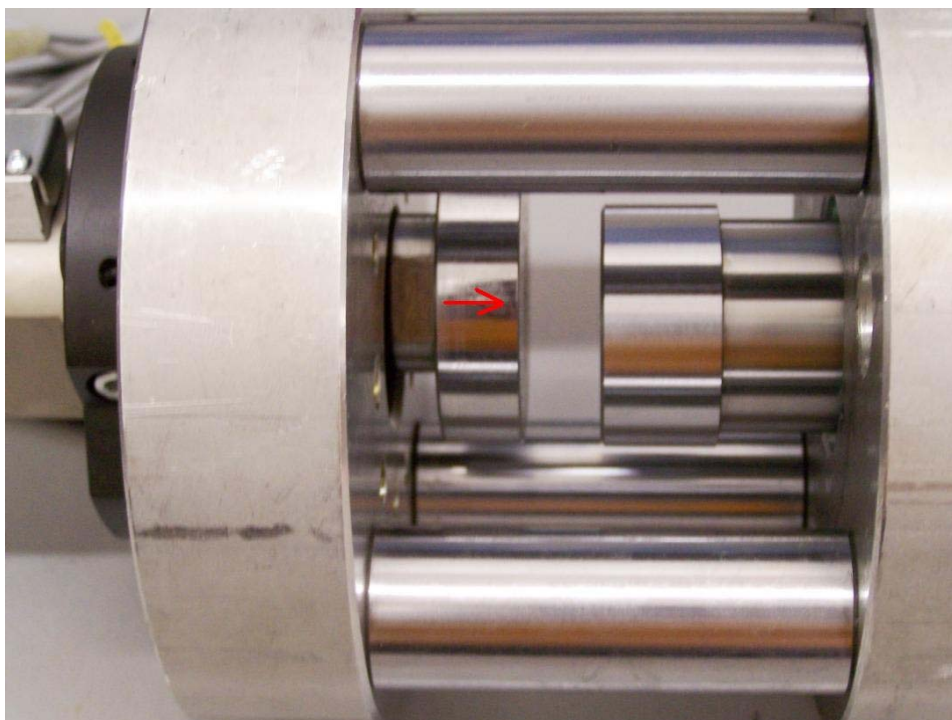
6) Screw and lock the fixing screw flange/cylinder

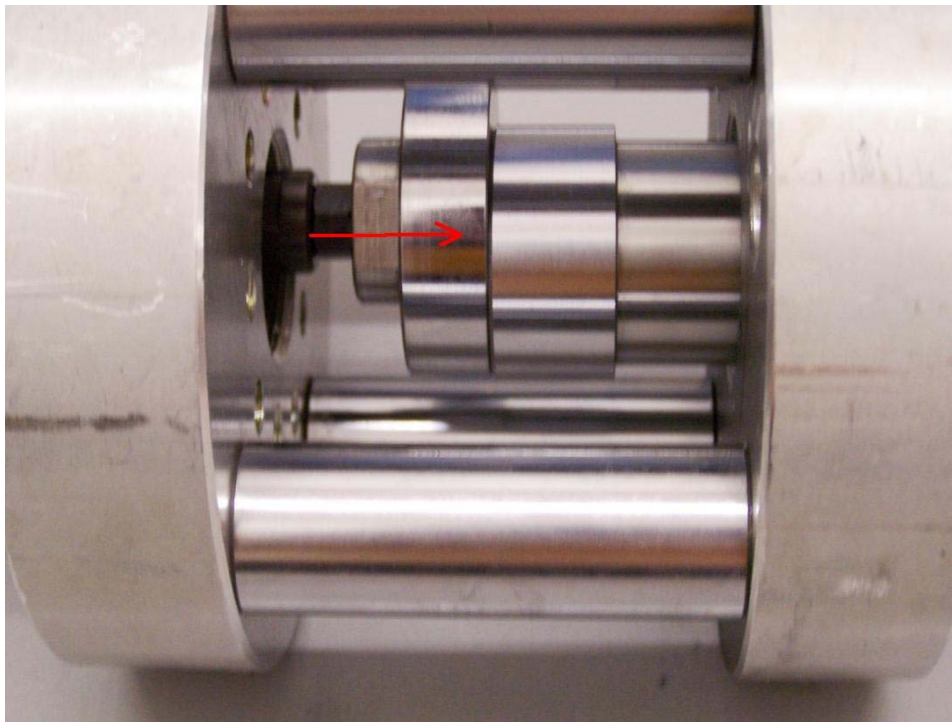


7) Lock the compass grub screws

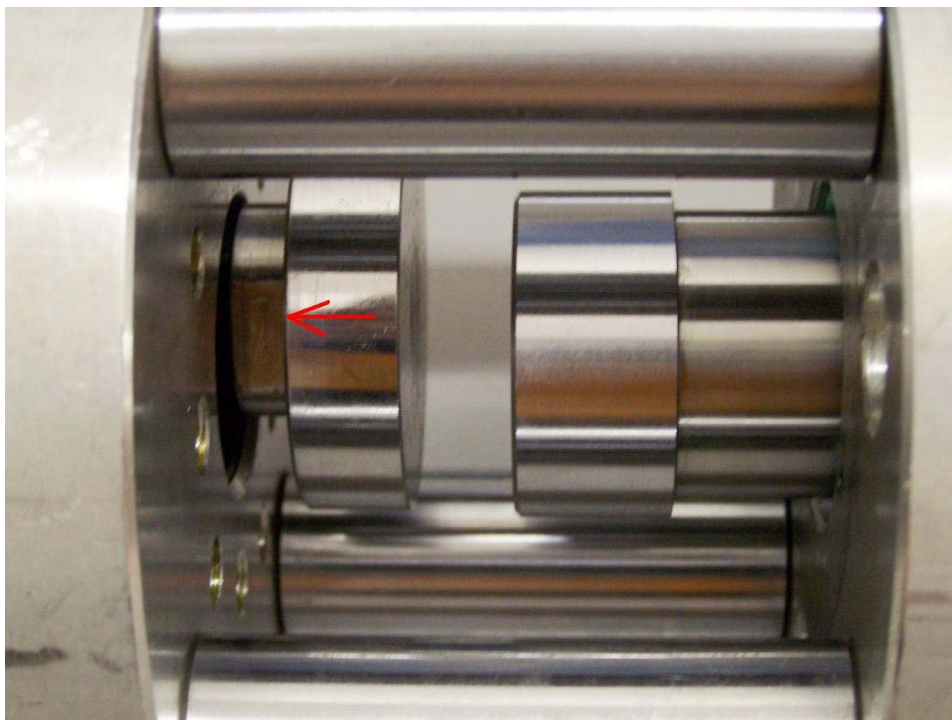


8) Fixing the flange on the mould

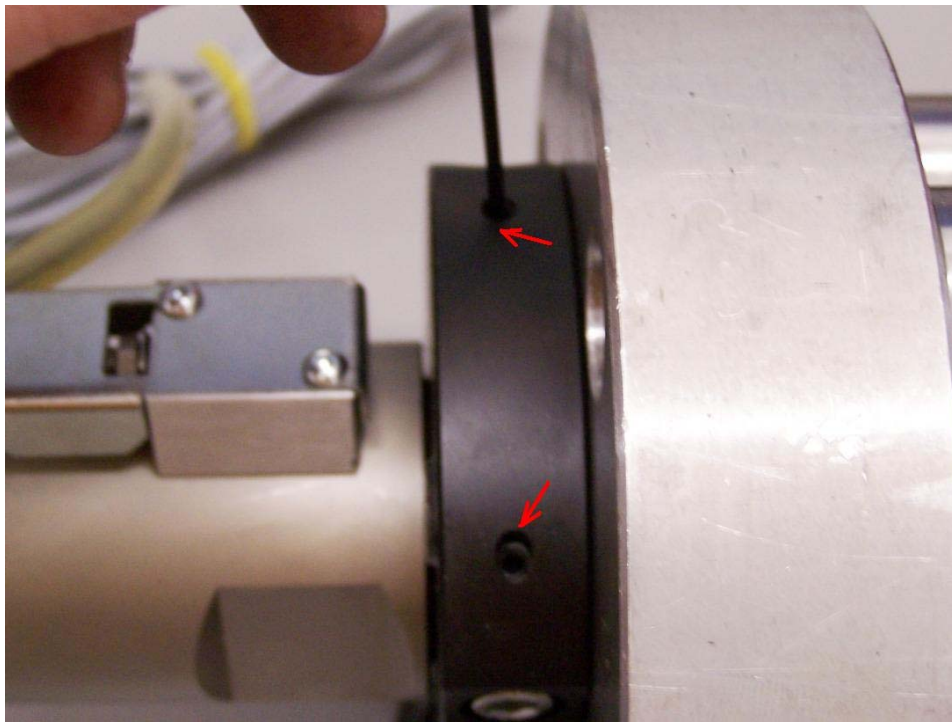




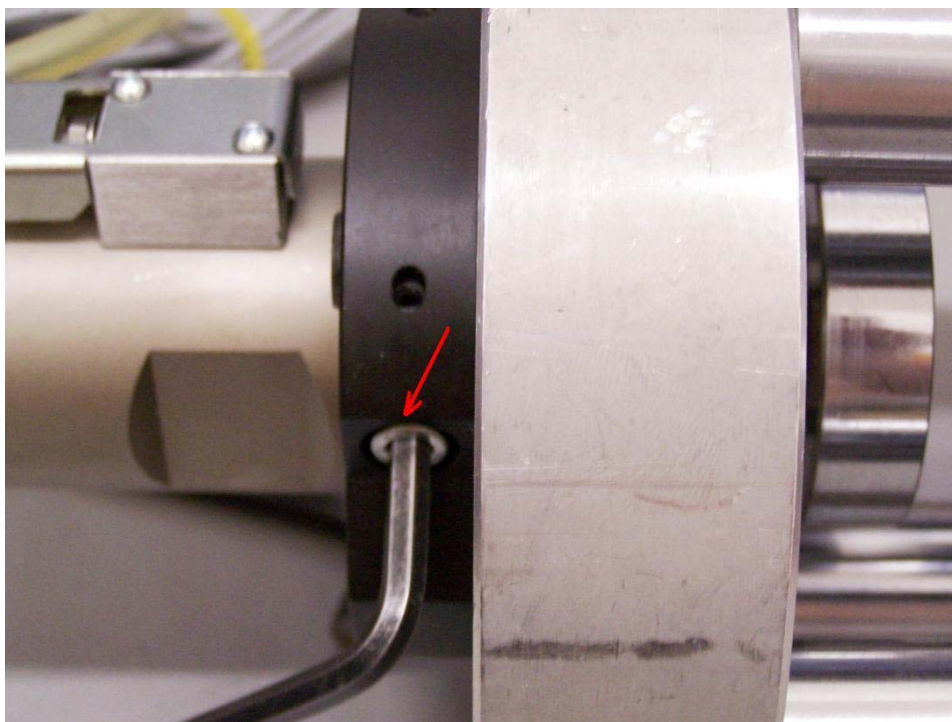
- 9) Extend the cylinder's rod in forward and verify the position of the "0" point of the punches in matrix



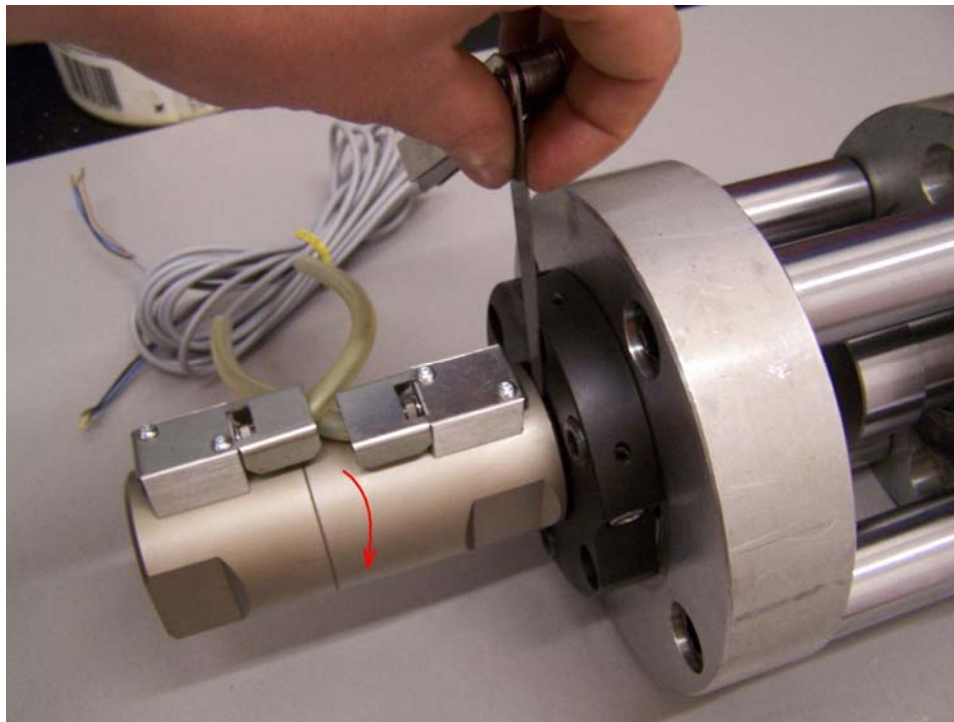
- 10) Retract the cylinder's rod



11) Loose the lock compass-flange grub screws



12) Loose the flange/cylinder fixing screw

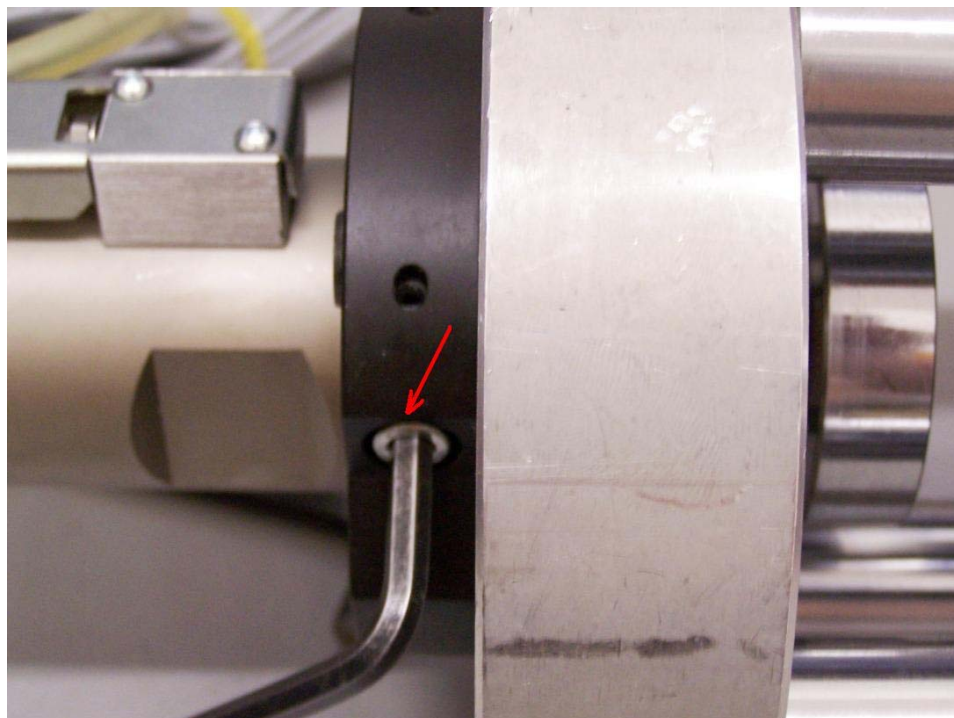


- 13) Rotate the cylinder in hour direction with help of laminated shims, make the preload as the measure indicated in a table pg.F5 of the Vega's catalogue

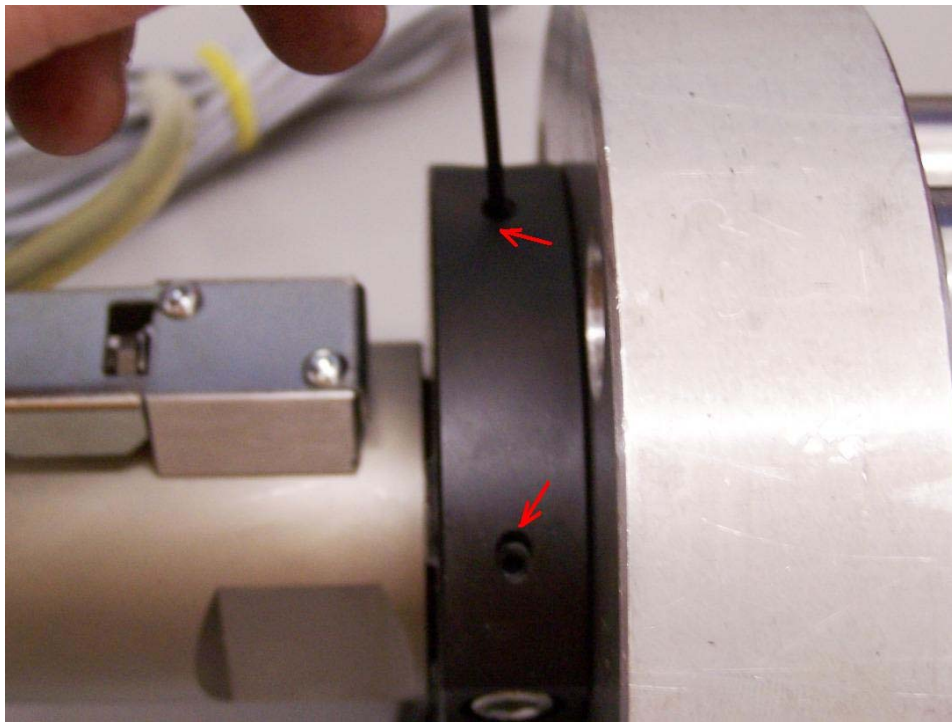
ATTENTION

In case there aren't laminated shims available, it could be possible to regulate the preload using the following indications:

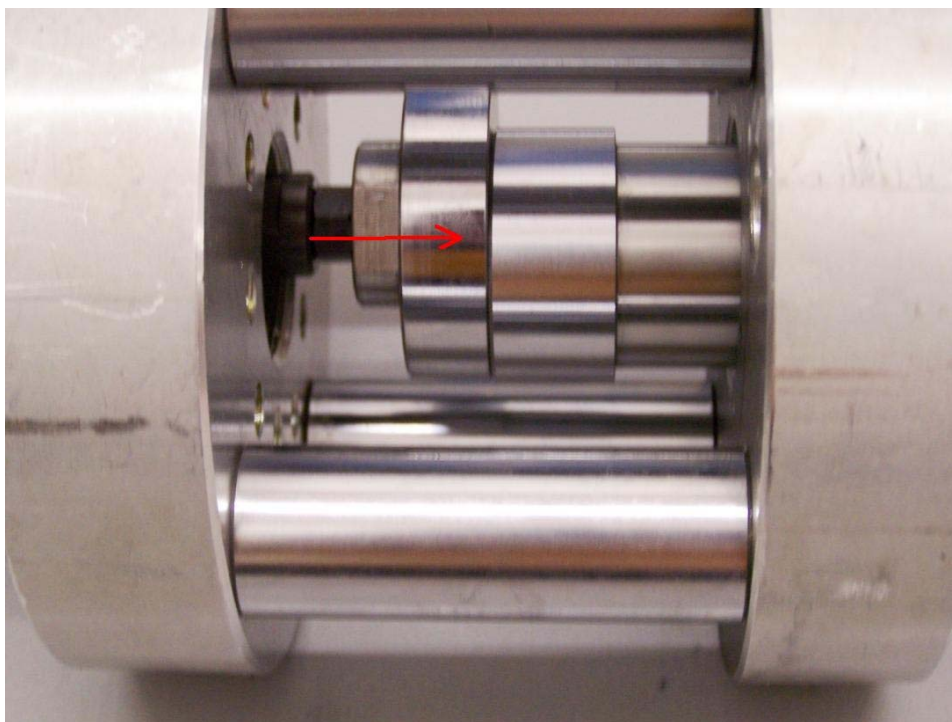
The thread pitch is 1.5, and each thread turn correspond to feed of 1,5 mm, therefore if the preload is 0,12 mm, it's necessary rotate the cylinder 35° in hour direction respect of the origin ("0" point)



- 14) Lock the fixing screw flange/cylinder



15) Lock the compass grub screws



16) Extend the cylinder's rod in forward position and make same print samples to verify if the printing parts is perfect or if there are imperfections caused by material infiltrations during the injection phase.

If the printing parts is not perfect, repeat the procedure from the points 9 to 14 and increase the preload according to the entity of the imperfection, after this, repeat the printing operation.

In case of by increasing the preload increases too the defect, it is possible that the preload is too excessive, and you have to reduce and verify

ATTENTION

For a correct functioning of the locking system, is necessary to keep the pressure of 120 bar inside the cylinder during the injection phase with the hydraulic power plant machine or check valve (see the Vega's catalogue)