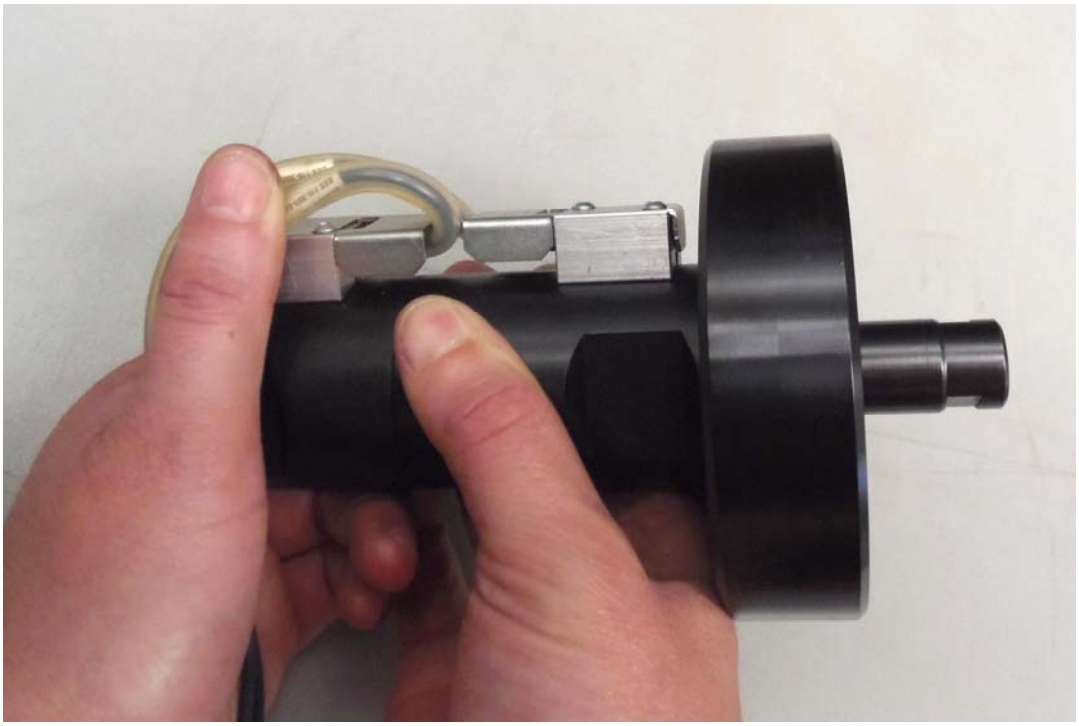
INTRODUCTION ON THE PRELOAD FUNCTION

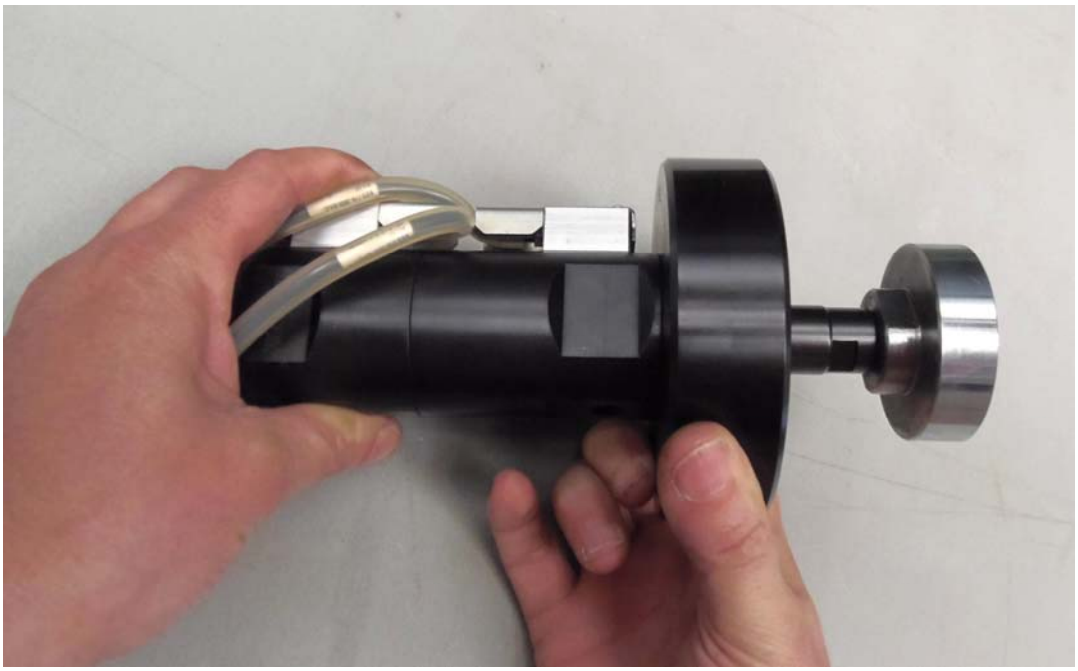
As indicated in the general characteristics, for the correct functioning of the cylinder it is necessary to bring the piston to the most extreme forward end stroke position.
For common applications on moulds, for punches and plugs which are to be fixed at the end on the matrix, this could cause material 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 grinding the fixing flange.

INSTRUCTIONS OPERATIVE FOR V260 SEMI-FINISCHED FIXING FLANGE

1) Tighten completely the flange on the cylinder and lock it.

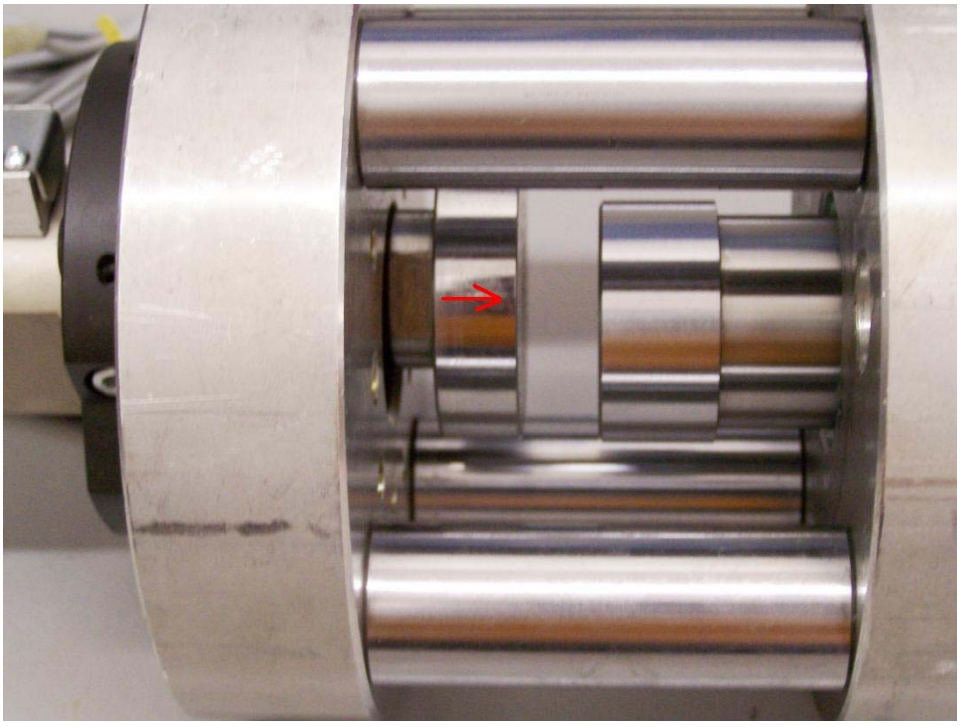


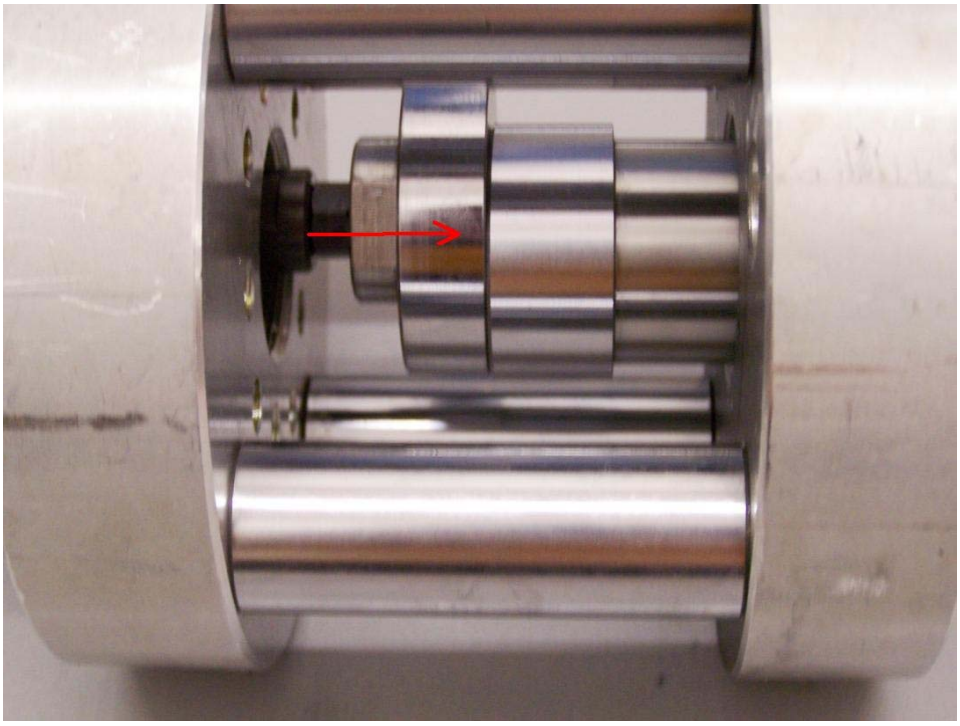
2) Extend the cylinder rod forward.



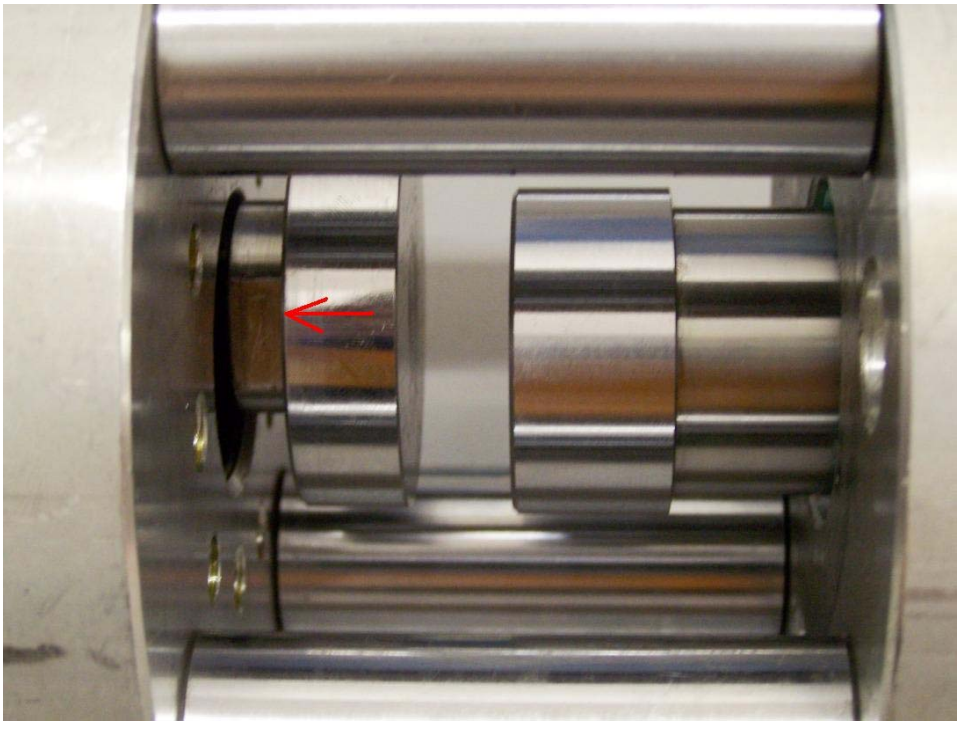
3) Fix the punch on the cylinder rod.

4) Fix the flange on the mould



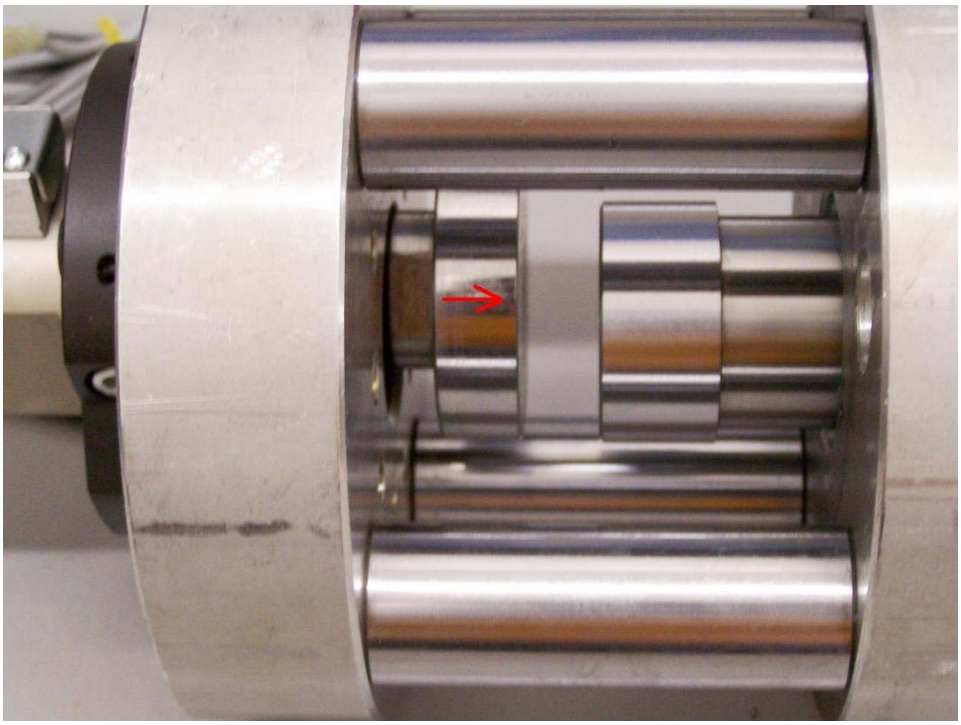


5) Extend the cylinder's rod forward and verify the position of the "0" point of the punches in matrix



6) Retract the cylinder's rod and try to print some pieces and check if they have some imperfections /burrs, if yes it's necessary apply the preload.
See the table on page F5 of the catalogue.

7) If the thickness of burrs is for example 0.1 mm, it's necessary to grind the surface of fixing flange up to 0.1 mm.



8) Install again the cylinder on the mould and try to print some plastic pieces to check if the thickness of burrs is reduced.

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)