

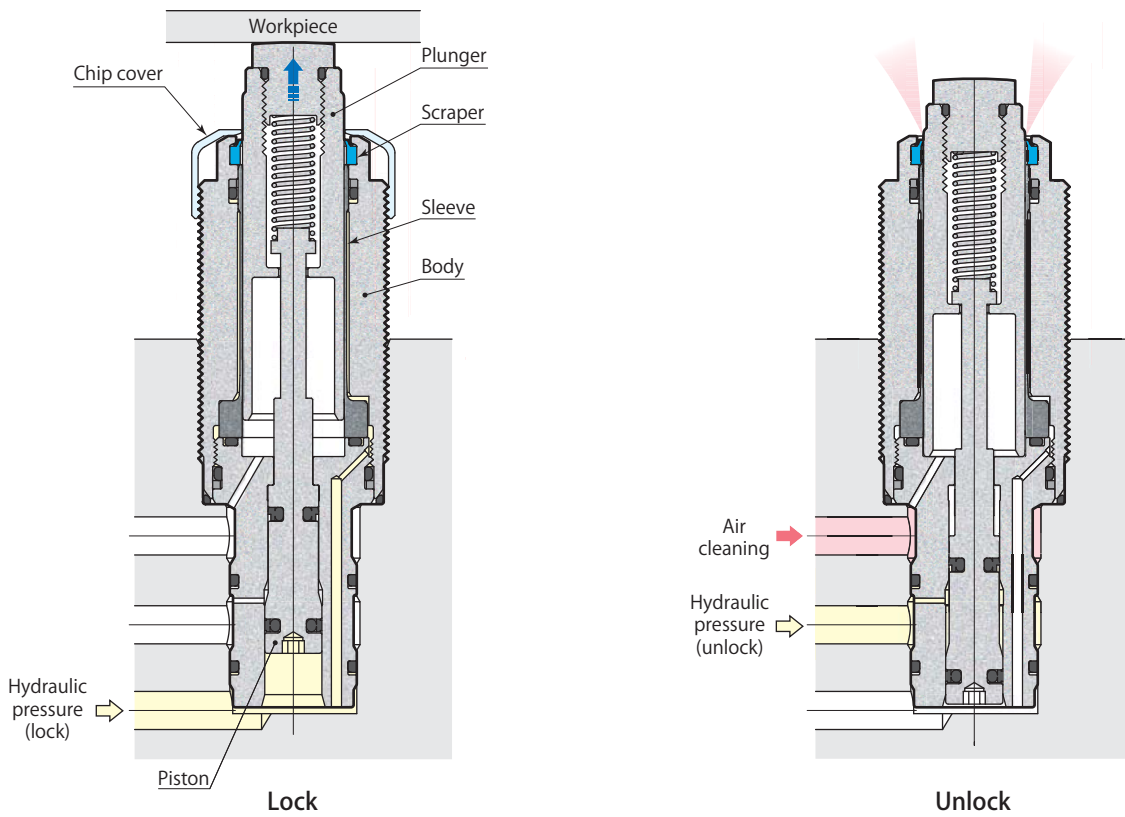
Double acting

model CSW-D □ M- □

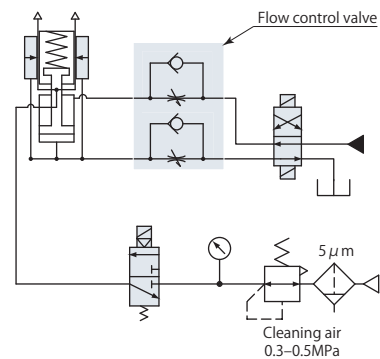


Work support

CSW-D Hydraulic lift



Hydraulic and pneumatic circuit diagram



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Specifications

Size: 06, 10, 16, 25

Plunger stroke: L (Standard stroke), D (Long stroke only for CSW-D06)

CSW-D M- indicates made to order.

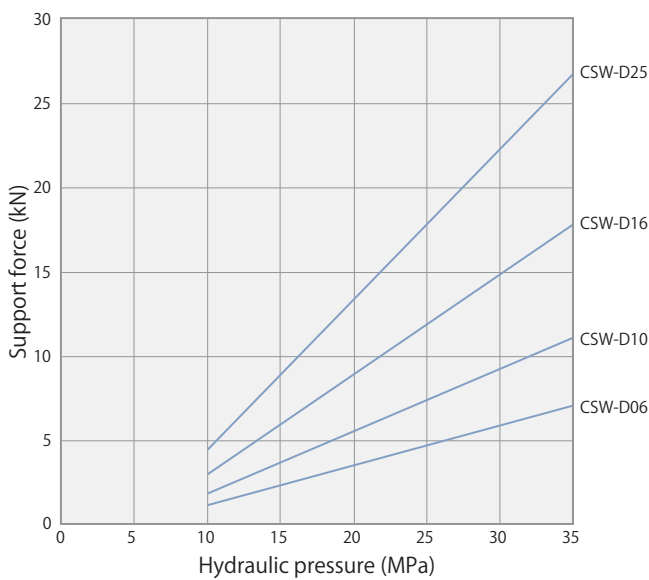
Model		CSW-D06M-L	CSW-D06M-D	CSW-D10M-L	CSW-D16M-L	CSW-D25M-L
		8 mm stroke	15 mm stroke			
Support force (hydraulic pressure 35MPa)*1	kN	7.1		11.1	17.8	26.7
Cylinder capacity	cm <sup>3</sup>	1.5	2.0	2.9	5.5	5.7
Lift spring force*2	N	6-11	4-11	10-16	16-29	25-45
Plunger stroke	mm	8	15	10	10	13
Max. allowable mass of head cap	kg	0.1		0.1	0.2	0.2
Mass	kg	0.30	0.34	0.47	1.00	2.01
Recommended tightening torque of body	N·m	35	35	60	130	250

- Pressure range: 10-35 MPa    ● Proof pressure: 52.5 MPa    ● Max. allowable back pressure: 0.05 MPa
- Operating temperature: 0-70°C    ● Fluid used: General mineral based hydraulic oil (ISO-VG32 equivalent)
- Seals are resistant to chlorine-based cutting fluid. (not thermal resistant specification)

\*1: When work support and clamp are used facing each other, work support and clamp must be selected in such a way that the support force is 1.5 times the applied load (clamping force + machining force).

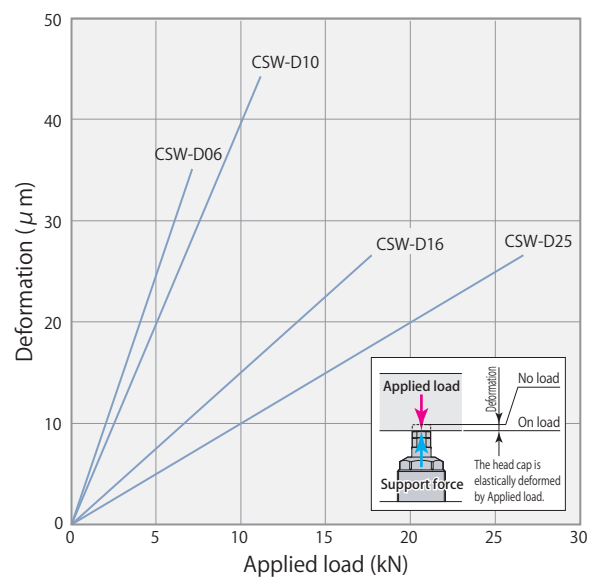
\*2: Figures are for "upper end to lower end" of plunger action.

Hydraulic pressure & support force



Hydraulic pressure MPa	Support force kN			
	CSW-D06	CSW-D10	CSW-D16	CSW-D25
10	1.2	1.9	3.0	4.5
15	2.3	3.7	6.0	8.9
20	3.5	5.6	8.9	13.4
25	4.7	7.4	11.9	17.8
30	5.9	9.3	14.8	22.3
35	7.1	11.1	17.8	26.7

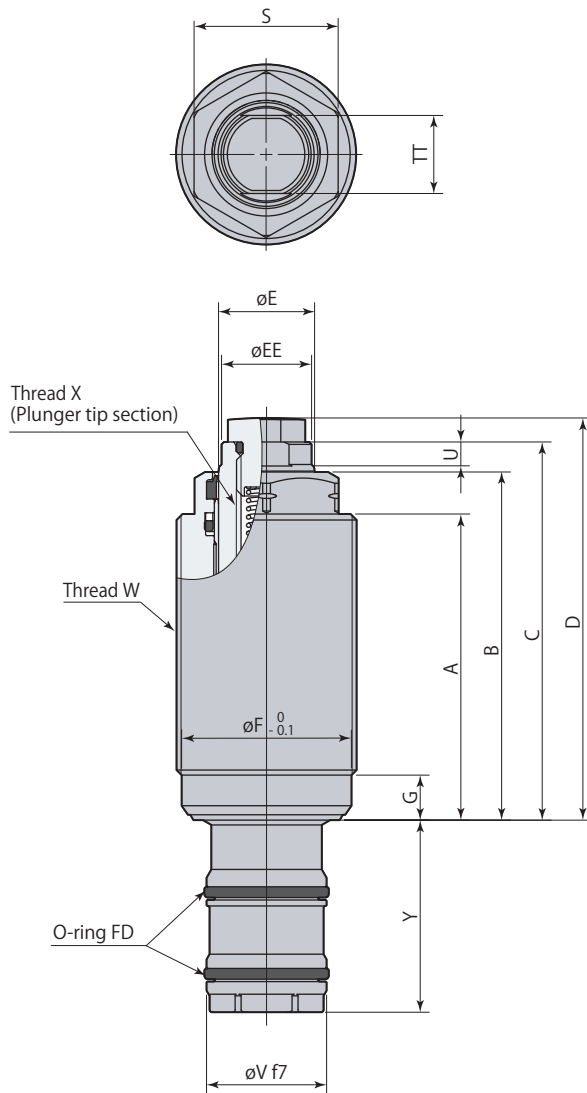
Applied load & deformation



Applied load kN	Deformation μm			
	CSW-D06	CSW-D10	CSW-D16	CSW-D25
0	0	0	0	0
5	25	20	7.5	5
10	40	15	10	10
15	22.5	15	15	15
20	20	20	20	20
25	25	25	25	25
30	30	30	30	30

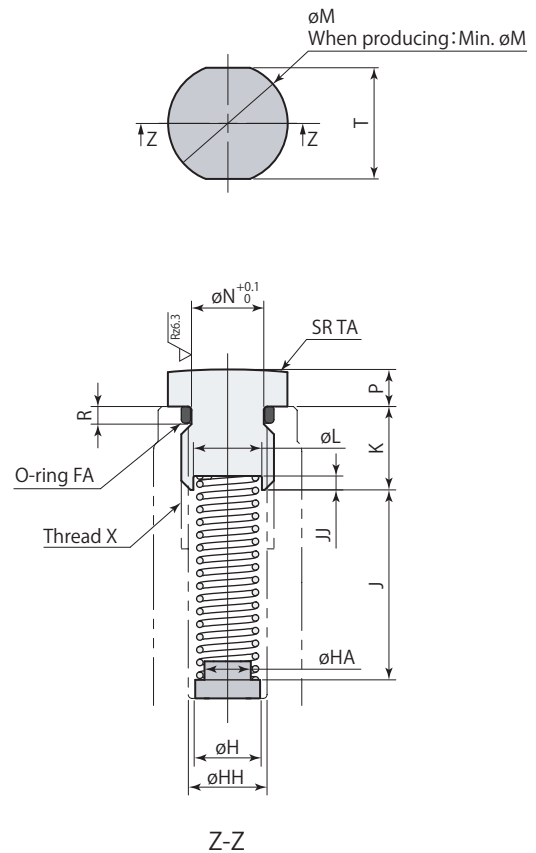
Held with hydraulic pressure of 35 MPa.

Dimensions

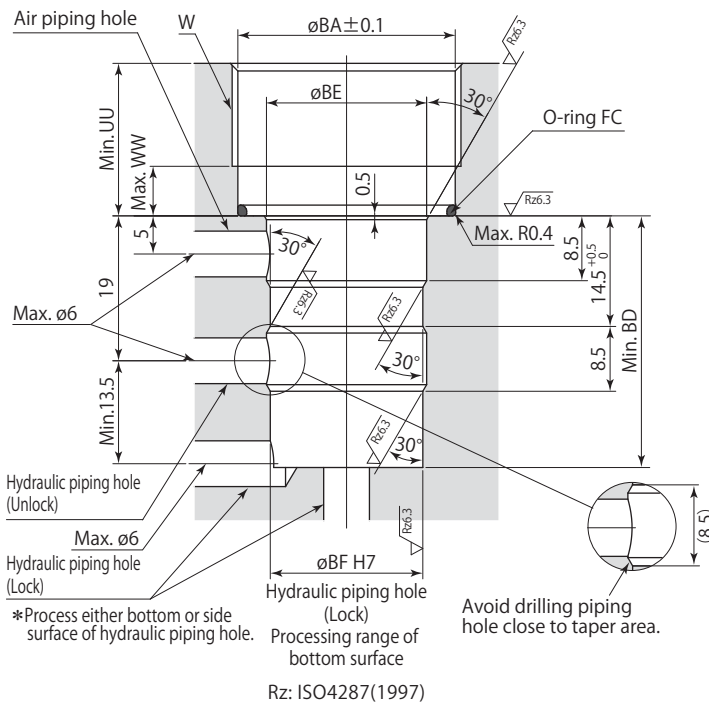


Head cap details

Hardness: HRC52



Mounting details



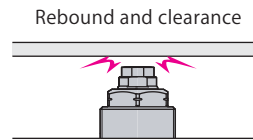
- When fixing the hexagon part of body with a vise, etc., make sure the tightening force is 2.5 kN or less.
- Always attach head cap (lift spring cannot be retained). When fabricating head cap, ensure that O-ring slot, spring spot facing and guide are made by referring to head cap details. Be sure to always use O-ring.
- When fabricating a lift spring, determine dimensions by referring to head cap details. Furthermore, rustproofing must be implemented (however, there is no guarantee for operation).
- Install O-ring FC at the bottom of the hole. The O-ring FC is packed with a work support.
- This diagram indicates a situation where head cap has been fitted into plunger with no pressure applied.

Model	mm				
	CSW-D06M-L	CSW-D06M-D	CSW-D10M-L	CSW-D16M-L	CSW-D25M-L
A	51	58	58	59.5	68.5
B	58	65	67	71.8	82
C	63	70	73	78	89
D	67	74	77	84	96
øE	16	16	20	30	40
øEE	15	15	19	29	39
øF	28.3	28.3	33.2	48.2	63.2
G	7.5	7.5	7.5	7.5	8
øH	7	7	7	8.5	10
øHA	5	5	5	6	7.5
øHH	8.5	8.5	10.3	14	14
J	20.5	21.3	25.5	25	32.5
JJ	1.5	1.5	3.5	1.5	1.5
K	9	9	11	12	11
øL	7.4	7.4	7.6	9.2	11.2
øM	12.9	12.9	16.9	23	30
Min. øM	12.5	12.5	16	21	21
øN	7.8	7.8	8.9	13.3	13.3
P	4	4	4	6	7
R	1.9	1.9	3	2.4	2.4
S	24	24	30	41	55
T (width across flats)	12	12	14	19	24
TA	70	70	90	110	140
TT (plunger width across flats)	13	13	17	24	32
U	4	4	5	5	5.7
UU	15.5	15.5	15.5	15.5	20
øV	20 <sup>-0.020</sup> <sub>-0.041</sub>	20 <sup>-0.020</sup> <sub>-0.041</sub>	22 <sup>-0.020</sup> <sub>-0.041</sub>	27 <sup>-0.020</sup> <sub>-0.041</sub>	30 <sup>-0.020</sup> <sub>-0.041</sub>
W	M30×1.5	M30×1.5	M35×1.5	M50×1.5	M65×1.5
WW	6.5	6.5	6.5	6.5	7
X (recommended tightening torque)	M10×1.5 depth 13 (30 N·m)	M10×1.5 depth 13 (30 N·m)	M12×1.75 depth 16 (50 N·m)	M16×2 depth 20 (100 N·m)	M16×2 depth 20 (100 N·m)
Y	32	33	34	35	38
O-ring FA (fluorocarbon hardness Hs70)	S8	S8	P9	AS568-014	AS568-014
O-ring FC (fluorocarbon hardness Hs90)	AS568-022	AS568-022	AS568-025	S45	AS568-036
O-ring FD (Urethane hardness Hs90)	AS568-017	AS568-017	AS568-018	AS568-021	AS568-023
BA	28.5	28.5	33.5	48.5	63.5
BD	33	34	35	36	39
BE	21	21	23	28	31
BF	20 <sup>+0.021</sup> <sub>0</sub>	20 <sup>+0.021</sup> <sub>0</sub>	22 <sup>+0.021</sup> <sub>0</sub>	27 <sup>+0.021</sup> <sub>0</sub>	30 <sup>+0.021</sup> <sub>0</sub>

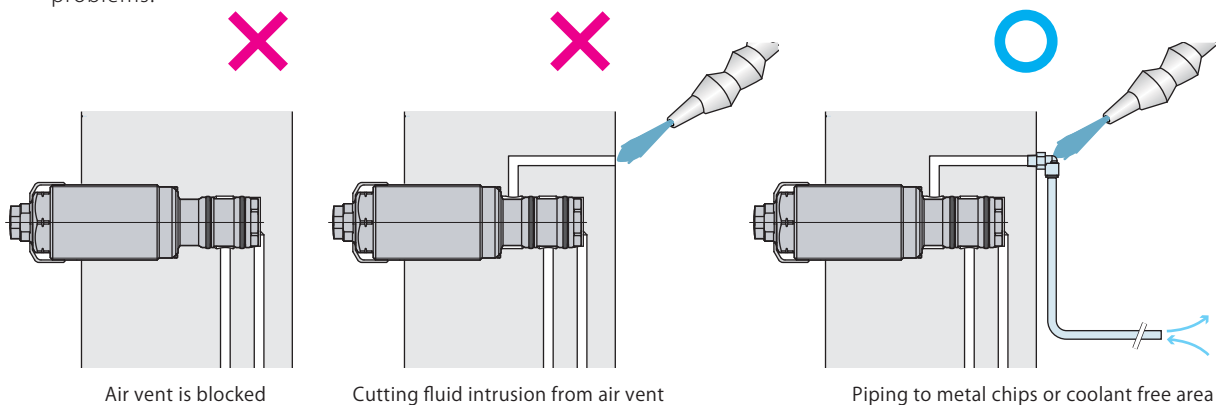
### Caution in use

- The lift spring in the plunger may push the workpiece upward if it is light weight and seating detection cannot be complete. Review the weight of workpiece or lift spring force and make it appropriate to seat the workpiece perfectly and acutate the work support.
- Set the plunger lifting time to 0.2 seconds or longer by adjusting the flow control valve with check valve (meter-in). Reasonable plunger ascending speed can prevent the parts from breakage also curbs plunger contact false. Use a flow control valve with cracking pressure of 0.05MPa or less, in order to shorten plunger descending speed.

If the plunger ascends to reach a workpiece too fast, it rebounds after hitting the workpice and will create a small clearance between the two. The clearance may cause a supporting fault of the workpiece.



- Avoid following usages. These may cause sleeve deformation that could lead to malfunction of plunger or decreased support force.
  - ✗ Applying eccentric load on plunger.
  - ✗ Applying load that exceeds rated support force.
  - ✗ Rotating plunger when locked.
- Air vent must be opened to atmosphere. Any blockage on the vent results in malfunction. Provide the piping if there is a risk of coolant or metal chips intrusion. Allowing intrusion of cutting fluid may cause rusting and other problems.



- Air (oil free) must be fed through a  $5\ \mu\text{m}$  filter that is connected to an air vent port for air cleaning. Perform air cleaning only when replacing workpiece. Plunger will rise during air cleaning.