

# PROPORTIONAL OPERATED SYSTEM FOR EDGEWHEEL GRINDERS WORKTABLE



## Characteristics

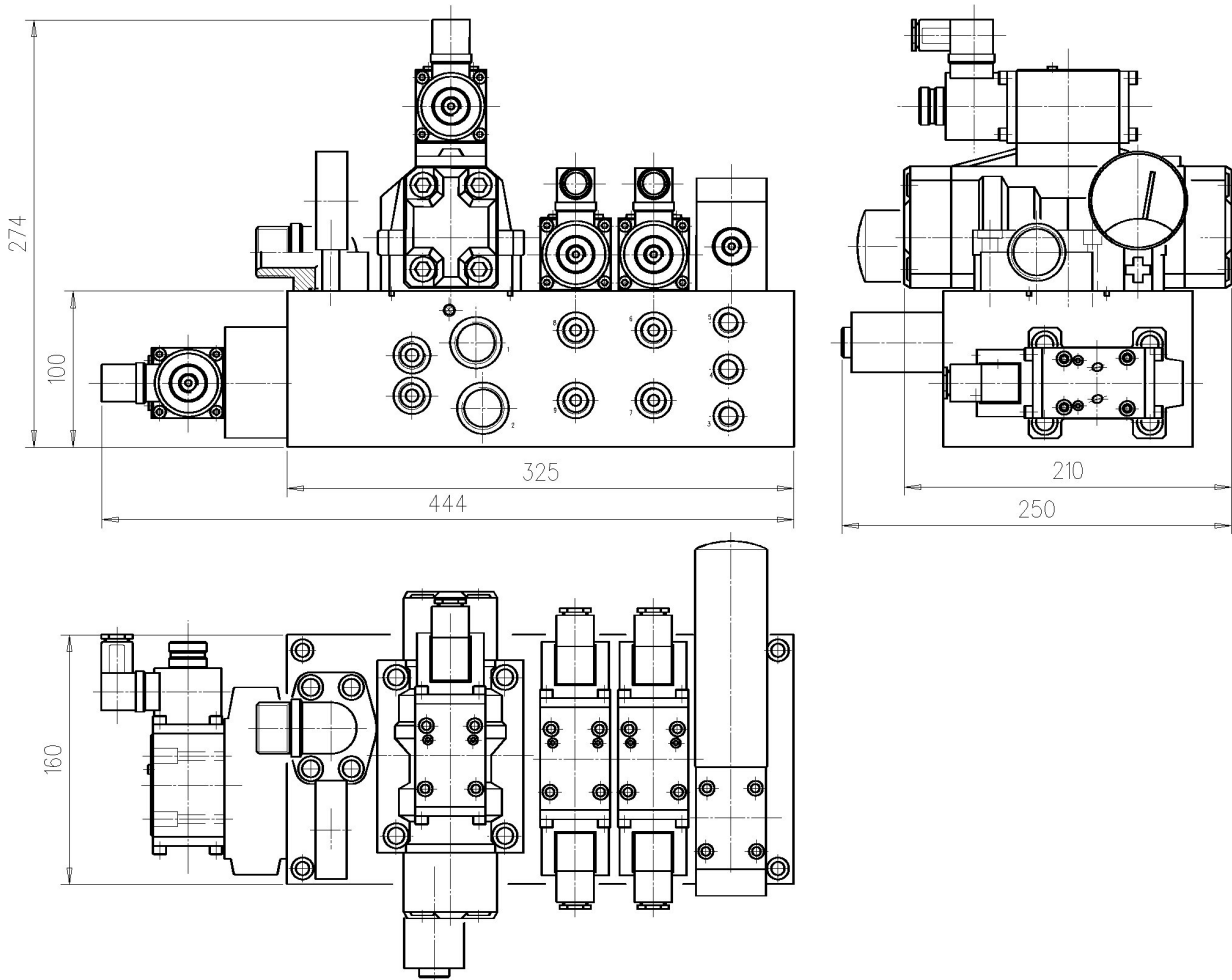
TYPE	FLOW	PRESSURE	P	T-T2	T1	T3	A-B uses	A-B proportional	U1-U2-U3
IC-399	60-100 l./min.	20-30 bar	3/4"	3/4"	1"	3/8"	3/8"	3/4"	1/4"

**Description** The main characteristic lies in the type of control of worktable translation cylinders. In fact, it is manufactured with CETOP-07 size proportional distributor, especially designed for controlling worktable direction and speed by means of a unique valve. Furthermore, it allows the sweetest worktable reverse movement.

The block integrates a pressure control valve, a dump valve of the pump, an on-off valve of the pump and other uses.

The group is compact shaped and easy to be installed because especially designed for such purpose.

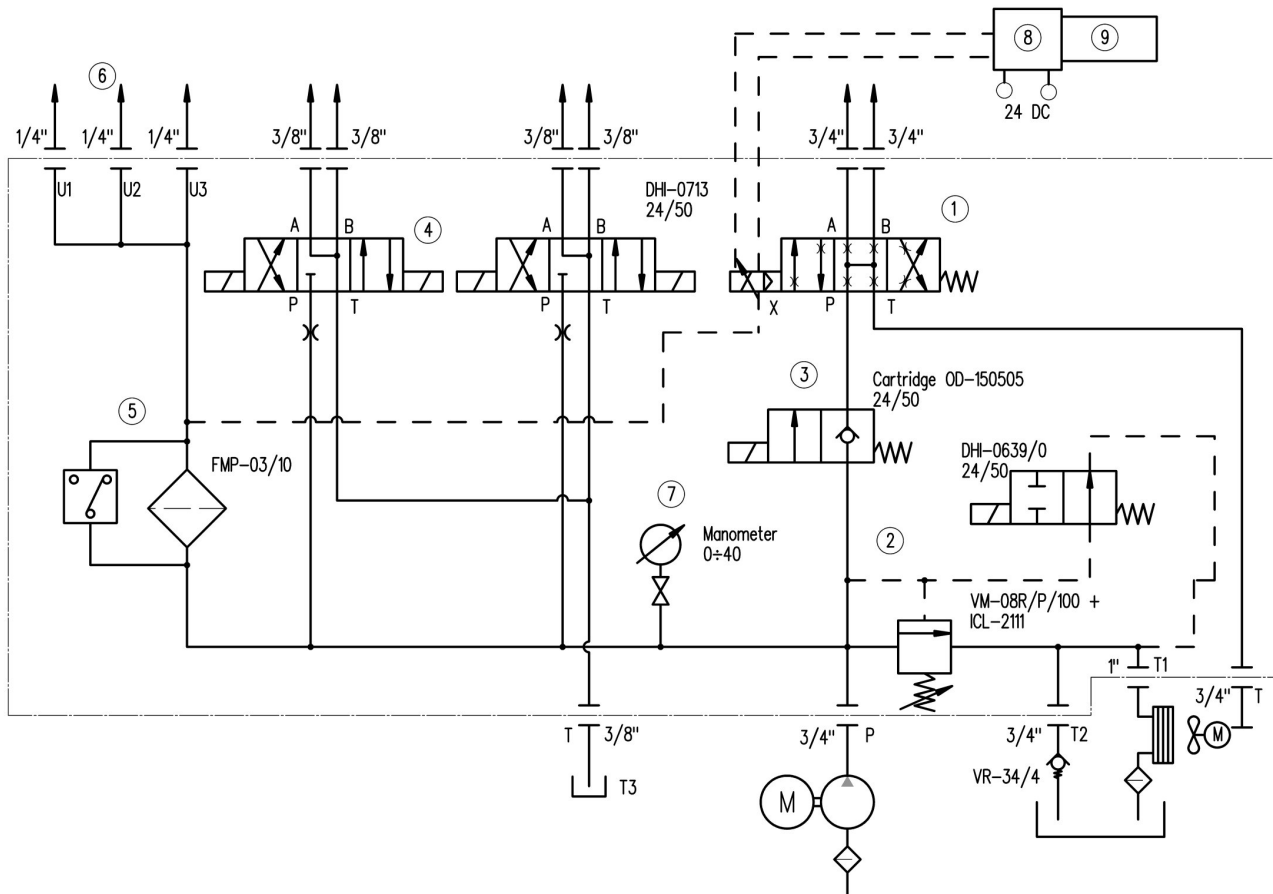
## Dimensions



# PROPORTIONAL OPERATED SYSTEM FOR EDGEWHEEL GRINDERS WORKTABLE



## Symbol



## Components

- |  |  |
|--|--|
| 1) Proportional control electro distributor                    | It allows direction and speed control, reverse speed without bumps during reverse movement of the table.   |
| 2) Pressure relief valve with pump dump valve                  | It allows the pump discharge when the plant is in stand-by.  |
| 3) Electric control block valve                                | It blocks the supply oil passage of proportional valve during the stop of the machine. It is used as safety element that is enabled only when the entrance protection table is closed. |
| 4) Secondary uses  | Diamond-dressing machine and wheelhead increment control.  |
| 5) Modular pressure filter                                     | It has the function of filtering the lubricating and system oil of the guides and to ensure the proper filtering of supply oil of proportional valve pilot.                            |
| 7) Manometer with shut-off valve                               | It allows to display the pressure value of the plant.  |
| 8) Electronic regulator for single solenoid proportional valve | It is provided with UNDECAL base connection that allows to control the proportional valve direction and flow.  |
| 9) Potentiometer   | It allows the reverse speed of the table in the two directions.  |

## Installation rules

- Fluid to be used: hydraulic oil in compliance with DIN 51524 rules, viscosity between 30 and 100 mm<sup>2</sup>/s (cSt) at 40°C
- Recommended filtration: 25μ - for proportional valve piloting: 10 μ
- Hydraulic fluid temperature: from -20° to +75°C

## Ordering code

IC-399

Control system for worktable of edgewheel grinders