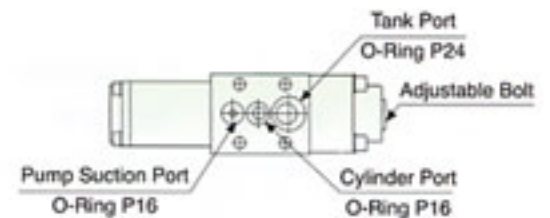
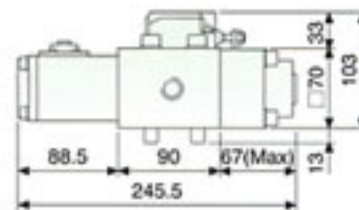
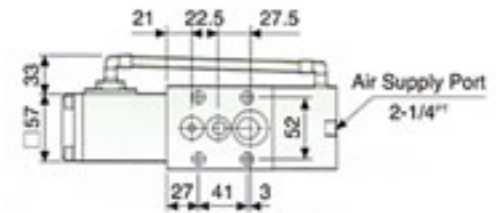
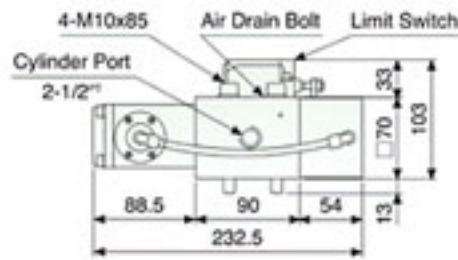
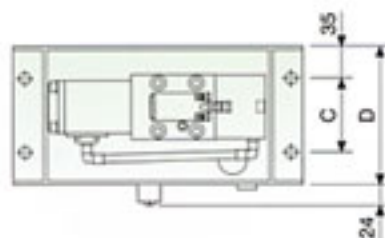
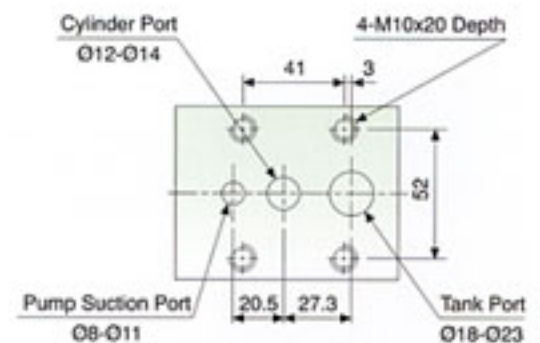
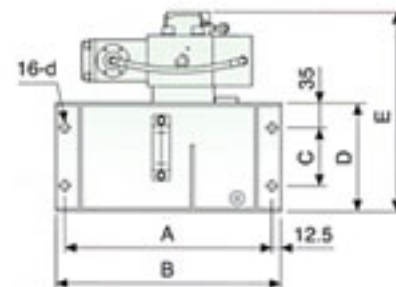


AIR PRESSURE SPRING CONTROL SERIES / 系列產品

Model **VA06M / VS06M**



Include Oil Tank / 含油箱



Model	A	B	C	D	E	d	Volume
VA06M-□□1 VS06M-□□1	206	230	50	100	226	Ø11	1.2 ℓ
VA06M-□□3 VS06M-□□3	285	310	80	150	276	Ø13	4.0 ℓ

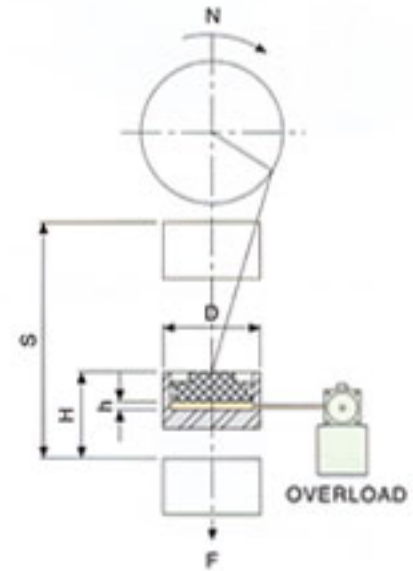
Model / 型式	Releasing flow rate 洩放流量 (cm ³ /sec)	Area of orifice 制流孔面積 (cm ²)	Pressure setting 壓力設定方式	Pressure setting range 壓力設定範圍 (kgf/cm ²)	Air supply 使用空氣壓力 (kgf/cm ²)
VA06M-760	13000	0.5	Air pressure	210 ~ 350	3 ~ 5
VA06M-960	11500	0.4		270 ~ 450	
VS06M-760	13000	0.5	Spring adjust	210 ~ 350	
VS06M-960	11500	0.4		270 ~ 450	

- Suitable for press tons : 200 tons & down / 適用沖床 : 200 噸 (含) 以下
- Air consumption : 220(Nl/min) / 空氣消耗量
- Max. noise : 77(dB) / 音量
- Hydraulic oil : ISO-VG-32 or equivalent / 使用液壓油

Selection Basis / 選用依據

• Specification & Parameter of Press 沖床規格參數：

- F : press rated capacity 沖床能力 (tons)
- S : stroke length 滑塊行程(mm)
- N : stroke per minute 每分鐘行程數(SPM)
- H : rated tonnage point 能力發生點(mm)
- D : cylinder diameter 油缸直徑(cm)
- n : cylinder number 油缸個數(pc)
- h : cylinder stroke 油缸之活塞行程(cm)
- m : ratio of overload hydraulic pressure 超負荷壓力倍數



• Calculation Formulas for Model Selection 型式選用計算流程：

- $A = (\pi D^2/4) \times n$ (cm²) cylinder area 油缸面積
- $P = F \times 1.1 \times 1000 / A$ (kgf/cm²) hydraulic pressure setting of overload (VS model) 超負荷設定的油壓壓力
- $P_a = P / m$ (kgf/cm²) air pressure setting of overload (VA model) 超負荷設定的空氣壓力
- $V = N \sqrt{SH - H^2} / 87.5$ (cm/sec) drop speed of slide 滑塊下降速度
- $Q = A \times V$ (cm³/sec) releasing flow rate 超負荷發生時的洩放流量
- $L \geq 4 \times A \times h$ (cm³) volume of oil tank 油箱容量

※ Releasing flow rate (Q) of overload protector, which you choose has to be more than of cylinder volume.
If releasing flow rate isn't enough, please use two sets of overload protector.

• Example 範例：(model:VA(VS)08-7□□)

- F = 160 tons $A = (\pi 26^2/4) \times 1 = 531$ (cm²)
- S = 200 mm $P = 160 \times 1.1 \times 1000 / 531 \approx 332$ (kgf/cm²) -----VS model
- N = 40 SPM $P_a = 332 / 70 \approx 4.75$ (kgf/cm²) -----VA model
- H = 6 mm $V = 40 \sqrt{200 \times 6 - 6^2} / 87.5 = 15.6$ (cm/sec)
- D = 26 cm $Q = 531 \times 15.6 = 8284$ (cm³/sec)
- n = 1 pc $L \geq 4 \times 531 \times 1 \geq 2120$ (cm³)
- h = 1 cm

Note

1. Hydraulic pressure (P) and air pressure (Pa) of overload protector, should be choose as higher as possible.
(Example : P=335 kgf/cm² or Pa=4.8 kgf/cm²)
2. Hydraulic piping size :

VA (VS) 08 - □□□ - □□□		VA (VS) 12 - □□□ - □□□	
Size (I.D./O.D.)	Work pressure (maxi.)	Size (I.D./O.D.)	Work pressure (maxi.)
12/18 mm	400 kgf/cm ²	14/22 mm	400 kgf/cm ²
13/18 mm	320 kgf/cm ²	16/22 mm	300 kgf/cm ²
14/18 mm	250 kgf/cm ²	18/22 mm	200 kgf/cm ²

3. Inside diameter of air piping must be more than 6 mm.