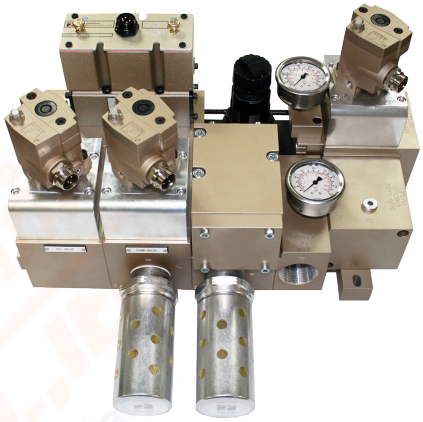
NEW

PRODUCT DATA SHEET INFORMATION

AUTOMATIC DIE CUSHION CONTROL SYSTEMS

Automatic Systems Series Valve Manifold Assemblies for Automatic Pressure Control Press Metal Forming Applications



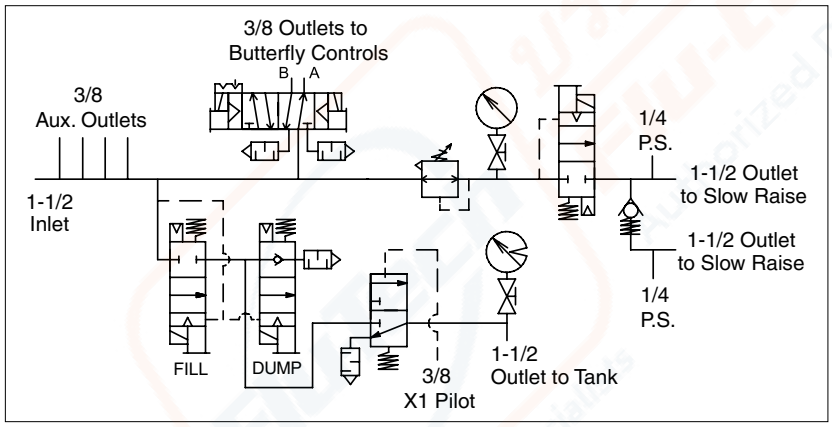
ROSS automatic die cushion control systems integrate modern air valve technology with electrical controls to monitor and control pressure in the die cushion.

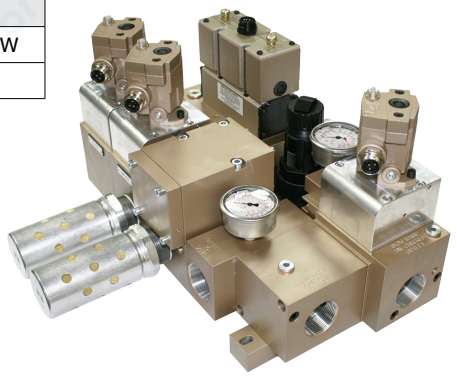
Die cushion requirements can vary depending upon the tooling and parts. An automatic die cushion control assembly can quickly and easily control pressure in the cushion accumulator tank, open and close a large butterfly valve between the tank and cushion cylinder and provide a slow raise function that will fully extend the cushion cylinder without excessive, damaging force.

- Fill/Dump Valves Interfaces with controls to monitor/maintain correct die cushion pressures
- Butterfly control valve included
- Slow raise cushion circuit included
- Units furnished with M12 or Brad-Harrison connectors

Die Cushion with Checked & Unchecked Slow Raise Function Butterfly Control Valve

Port Size	Basic Size	Voltage	Connector Type	Model Number	
				NPT Thread	G Thread
1½	20	24 VDC	M12 – 4-pin	3900A1246-4MW	D3900A1246-4MW
		110 VAC	Brad Harrison – 3-pin	3900A1246Z	D3900A1246Z





Port Size	Basic Size	Dimensions inches (mm)		
		Height	Depth	Length
1½	20	11.2 (28.5)	18.7 (47.5)	20.1 (51.1)

STANDARD SPECIFICATIONS

Construction Design	Valve and Regulator Assembly
Mounting Type	Base Mount Manifold
Solenoid	Rated for continuous duty
Voltages	24 volts DC: 110-120 volts AC, 50/60 Hz
Power Consumption (each solenoid)	14 watts on DC; 87 VA inrush, 30 VA holding on 50 or 60 Hz

Temperature	Ambient: 40° to 120°F (4° to 50°C)
	Media: 40° to 175°F (4° to 80°C)
Fluid Media	Filtered air
Operating Pressure	30 to 150 psig (0 to 10.3 bar)