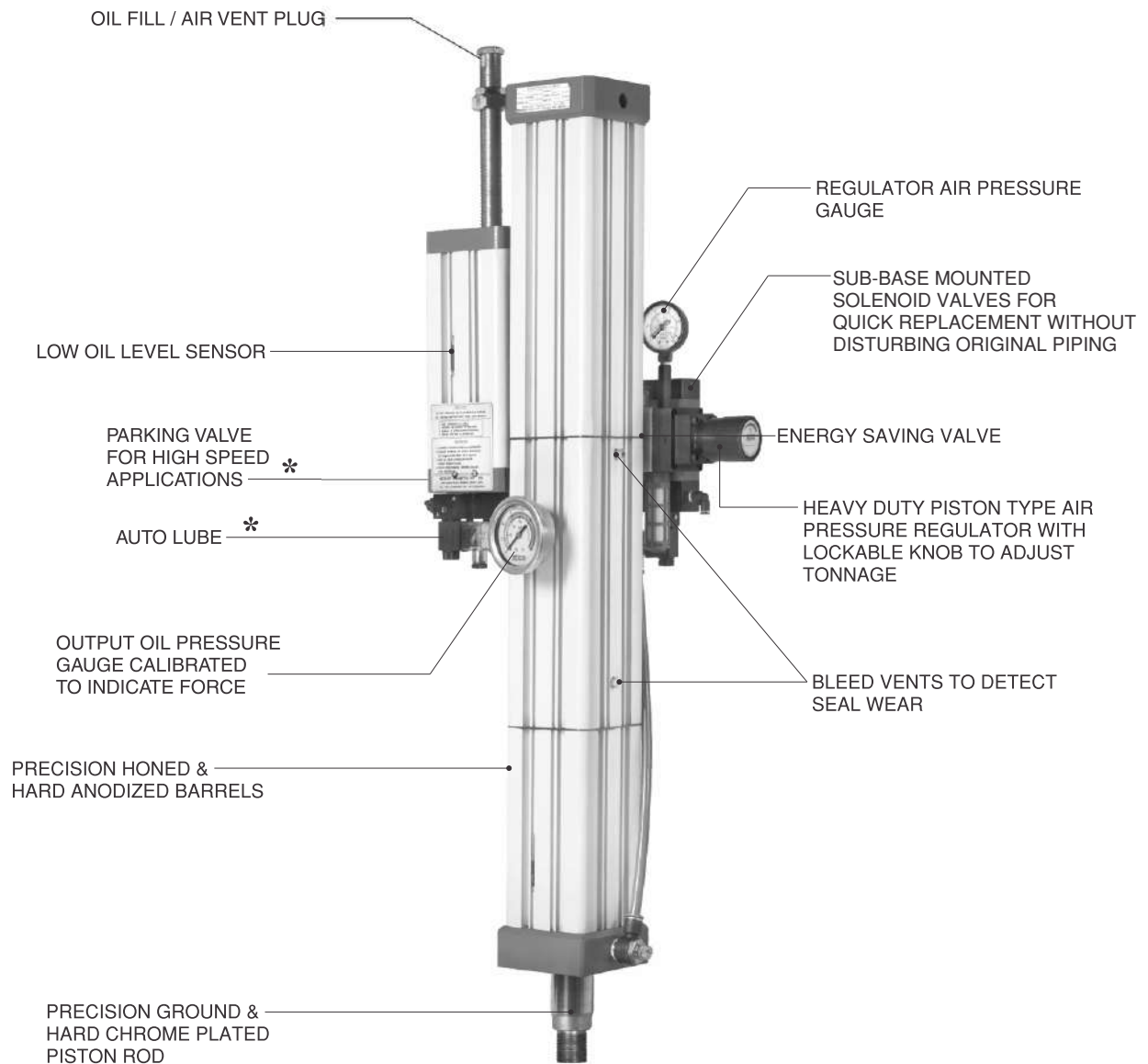


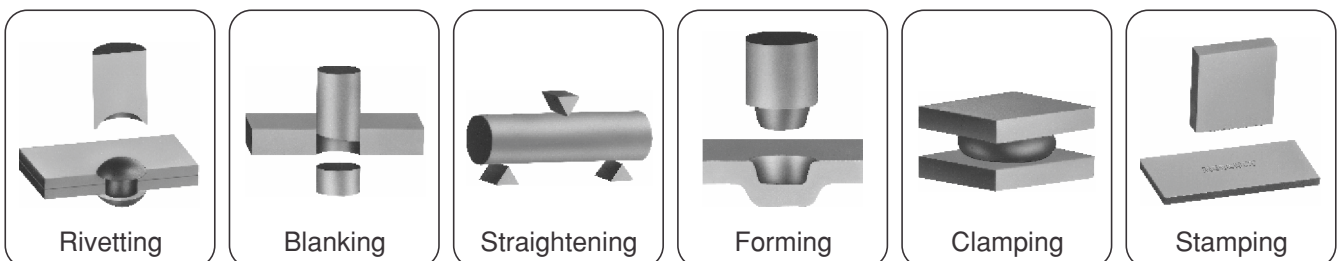


### Hydro Pneumatic Press Cylinder



### Typical Applications

“MERCURY” Hydro Pneumatic Presses are ideal machines for any application requiring pressing force from 0.4 tonnes to 30 tonnes.



## General Description

“MERCURY” series “A” range of Hydro-Pneumatic Presses, combines the advantages of efficient, low cost pneumatics, to achieve the large output forces associated with hydraulics. The system operates on normal compressed air pressure of 5 bar, using standard pneumatic controls, thus completely eliminating the use of expensive hydraulic power pack and associated control equipment.

The **SALIENT** features of Series “A” Hydro-Pneumatic Presses are :-

- (i) **Very low air consumption**, resulting in energy saving of up to 80% over equivalent pneumatic cylinders and 50% over equivalent hydraulic systems. The **Speed of Operation** is also much higher than an equivalent standard pneumatic or hydraulic System.
- (ii) **Compact Cylinder** design, which **can be mounted in any position**.
- (iii) **Compact, Lightweight Press Frames**, which can be mounted on a light work bench.
- (iv) **Simple Design** for easy maintenance.
- (v) **High stroke frequency** because of shorter oil path between the oil reservoir and the output hydraulic cylinder.
- (vi) **Force** and **Speed** can be infinitely adjusted.
- (vii) **Rapid, pneumatically operated approach stroke and return stroke**. In the Series “A” the return force is larger than the approach force, resulting in the loading of heavier tools for respective tonnages.
- (viii) **Absolute separation of air and oil chambers**. This has been achieved by providing bleed holes between the pneumatic and hydraulic seals. In the event of failure of pneumatic seals, the air escapes to atmosphere through a bleed hole and does not mix with the hydraulic oil. If the hydraulic seals fail, oil escapes from its bleed hole, indicating deterioration of the seal, which can be procured and replaced well before total breakdown occurs.
- (ix) **New Automatic Lubrication**. Our new **Auto lubrication** feature has greatly enhanced the reliability of our presses. After a set (with jumper on PCB) number of cycles, the auto lube solenoid comes on for a short time. This actuates a built-in pump which injects, under high pressure, about 2 drops of oil from the reservoir. This high pressure injection ensures complete lubrication of the entire pneumatic components.  
The advantage of this system is that lubrication is positive and not dependent on air flow volume as in a standard lubricator of a FRL set. Also the quantity of lubrication is positive and not dependent on any arbitrary setting by machine operator.
- (x) **New low oil level sensing system** ensures that the machine comes to a stop when oil level reaches minimum. This eliminates product rejections due to reduction in tonnage caused by low/insufficient oil in the reservoir.

## Sequence of Operation

The sequence of operation is outlined in Fig. 1 & Fig. 2

There are three stages of operation :-

- (a) Initial Low force, Large travel, Rapid Approach.
  - (b) High Force, Short travel, Power Stroke.
  - (c) Low Force, Rapid Retraction.
- (i) In the retracted position air is admitted to ports 'B' and 'D' and exhausted from port 'C' through **Valve Regulator Assembly**. Port 'A' is also exhausted.
  - (ii) When an electrical supply is provided, the **Approach Solenoid** is switched "ON". This causes air to be admitted to port 'C' and air present in port 'D' is exhausted. The output shaft extends rapidly, with a low force due to the air pressure acting on top of the approach piston through port 'C'. The speed of extension can be varied infinitely by adjusting the Flow Control Valve 'F'.
  - (iii) When the output shaft touches the workpiece, the **Power Stroke Solenoid** is switched "ON". The change over from approach to power stroke depends on the setting of the delay between the two solenoid coils. This causes air to be admitted to port 'A' and exhaust from port 'B'. The Intensifier Piston extends and causes the pressure of the oil in the hydraulic chamber to rise. The intensified oil pressure acts on the Hydraulic Shaft, generating the high force "**Power-Stroke**". The output force can be varied by adjusting the Air Pressure Regulator 'R'.
  - (iv) The "**POWER STROKE**" is applied for the set time. When this time has elapsed, both the **Approach and Power Stroke Solenoid** are switched "OFF". This causes air to be admitted to ports 'B' and 'D' and exhausted from Ports 'A' and 'C'. The Approach and Intensifier Pistons retract rapidly and oil is transferred back to the reservoir.
  - (v) The cylinder is now ready for the next cycle.

## Pneumatic Circuit Diagram (Standard)

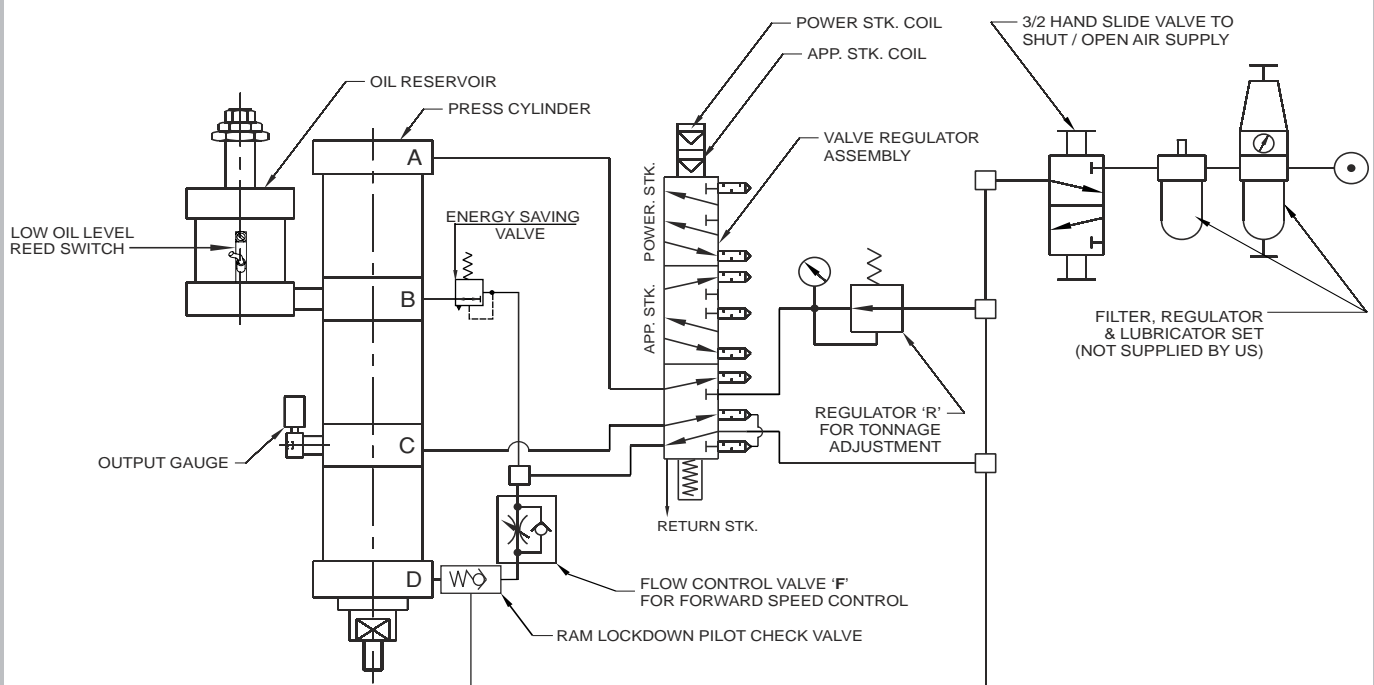


FIG. 1

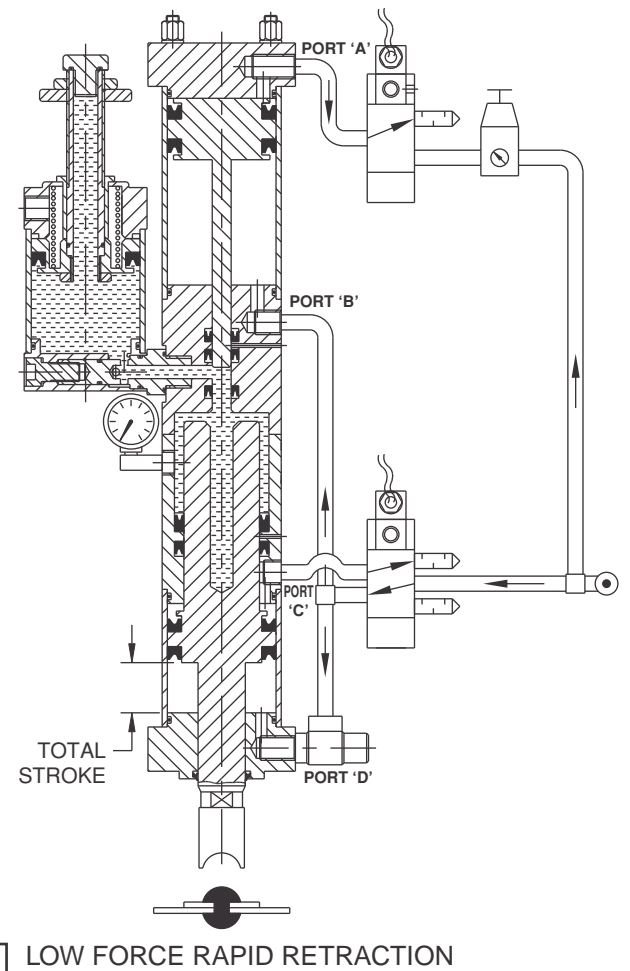
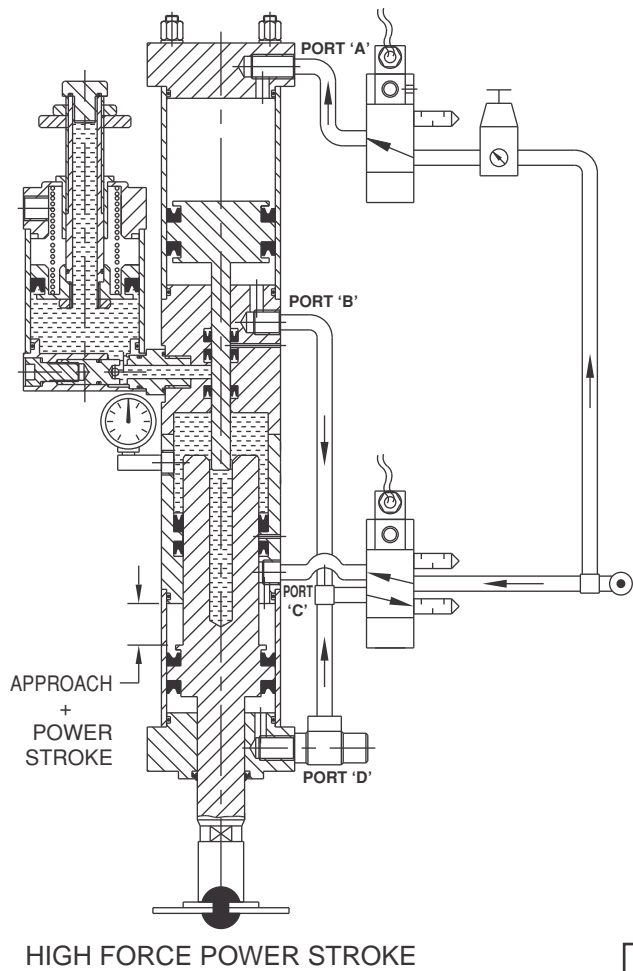
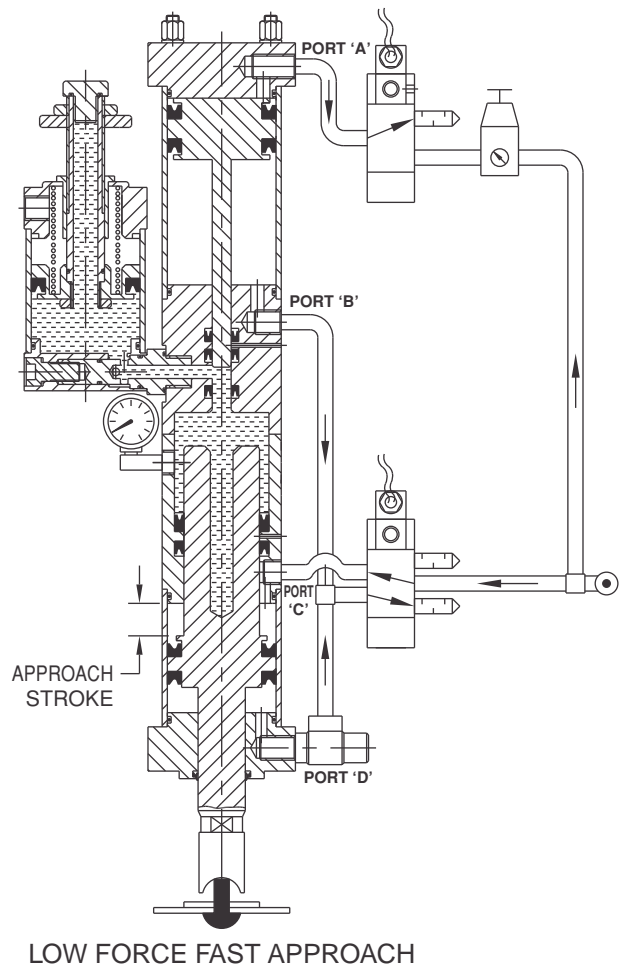
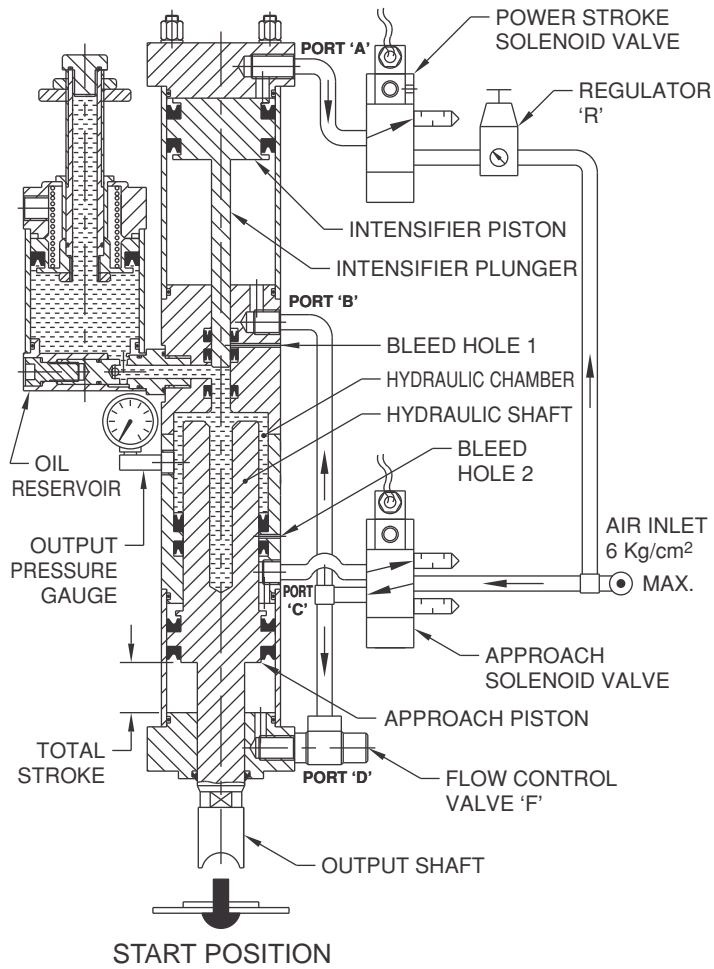
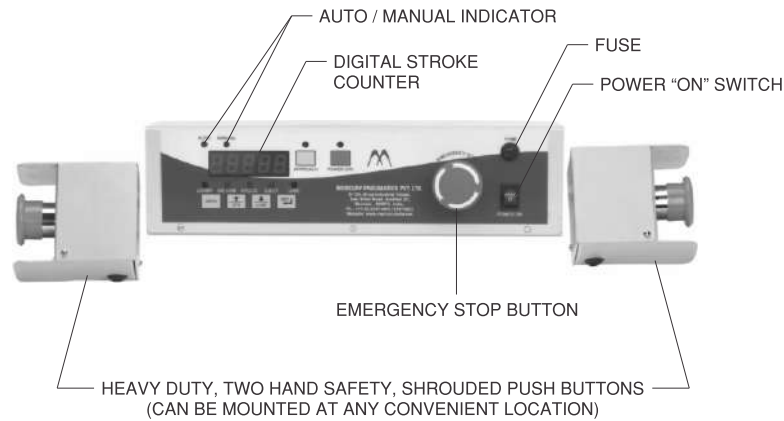


FIG. 2



## Standard Control Panel

- 1) True, 2 hand “Non Tie Down” controls. If the 2 push buttons are not actuated within 1 sec., The press will not start.
- 2) Compact, yet easy to service.
- 3) Status LED indicators for each stage of sequence.



## Low Oil Level Sensing

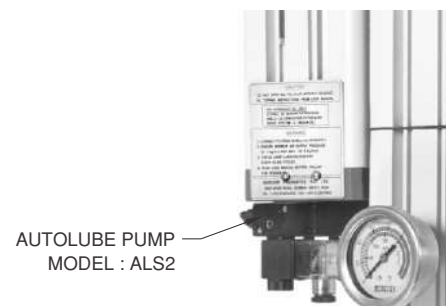
When oil level becomes low (5% reserve capacity) the Reed switch is actuated. This stops operation of the press and “OIL LEVEL LOW” indicator glows. The press can be operated temporarily by pressing 2 hand safety buttons for forward & emergency stop button for return



LOW OIL LEVEL REED SWITCH

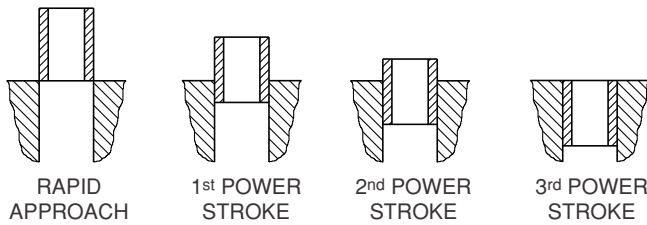
## Programmed Automatic Lubrication

A pneumatically actuated pump is installed below the oil reservoir. This pump injects oil under high pressure directly into cylinder. The no. of strokes after which oil should be injected can be programmed by changing a jumper on the PCB of the panel. Unlike a FRL in which oil flow depends on the flow of air, the direct injection of oil at the top & bottom of the cylinder guarantees proper lubrication.

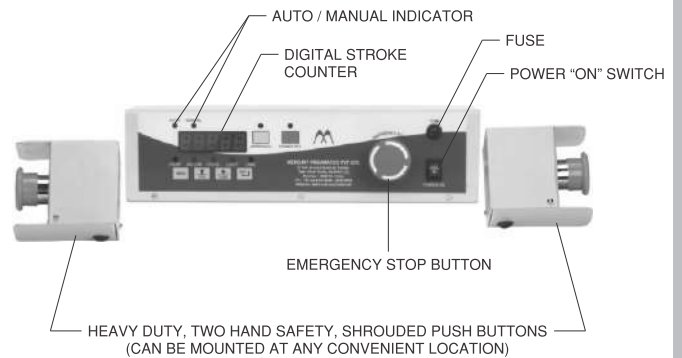




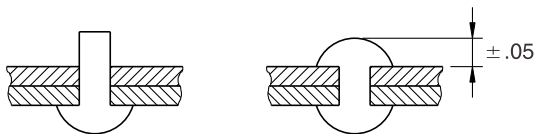
## Automatic Cycling of Power Stroke (Optional)



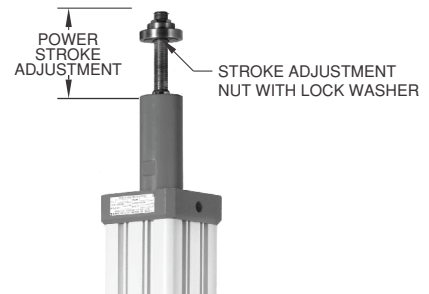
**APPLICATION :-** Bearing and bush pressing. On actuation of 2 hand safety buttons, the ram comes down rapidly and applies power stroke. After an adjustable delay, power stroke is automatically applied a second time. This repeats for the no. of times set (1 to 9) on the counter.



## Power Stroke Depth Control

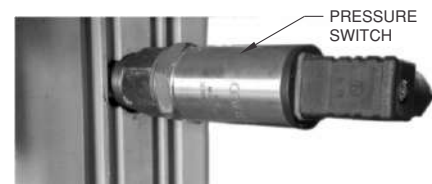


**APPLICATION :-** Useful for toolings in which it is not possible to control the stroke with a mechanical stopper in the tool.



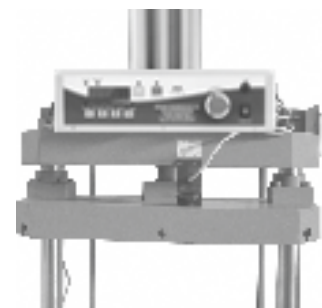
## Pressure Switch Sensing

The press retracts automatically when the set (adjustable) pressure is reached. If for any reason the set pressure is not reached (e.g. oil level low, input air pressure low), the press does not retract. It has to be retracted by pressing emergency stop. This feature ensures on line quality control.



## Continuous Cycling

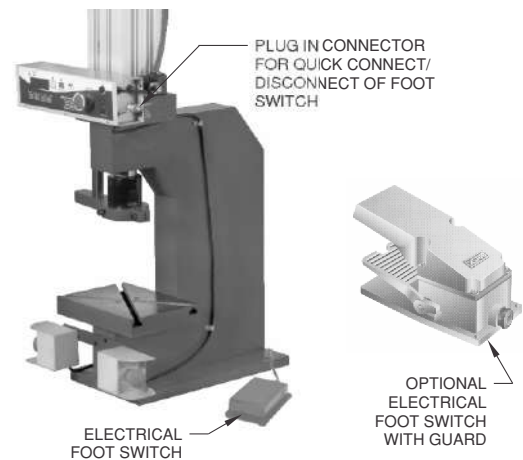
- (a) This feature integrates the press to feeding devices. The return position of the press gives a signal for the feeder to start and the end stroke of the feeder gives a signal for the press to start.
- (b) Can be made to stroke continuously as in mechanical power presses.



## Foot Switch Operation

A momentary press of the foot pedal initiates the press cycle. The return is automatic after the set time.

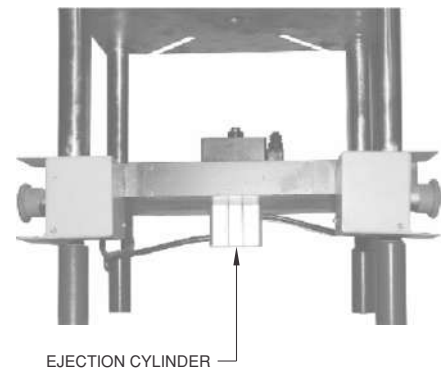
**IMPORTANT NOTE** :- There is no safety in foot operation mode. The foot switch is connected to the control panel through a Plug-In connector for easy removal. It is the responsibility of the management to ensure that the foot switch is unplugged whenever the press is operated in 2 hand safety mode and foot operation is not required.



## Ejection Cylinder

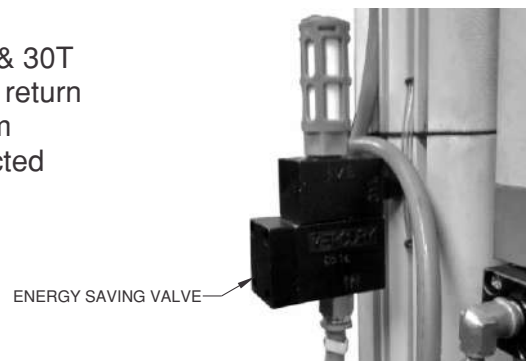
**APPLICATION** :- For ejecting components out of the die when press is retracting. The control panel has as standard 2 terminals for switching a solenoid valve with off delay timer to operate the ejection cylinder.

The size of the cylinder can be ordered as per customer requirement of the ejection force.



## Low Energy System

This is useful for saving compressed air in 8T, 15T & 30T presses operated at more than 15 strokes/min. The return of the cylinder force can be adjusted to the minimum pressure required to retract the cylinder and connected tooling.



## Dual Force Systems for Online Quality Control

**APPLICATION** :- For critical pressing such as press fitting of bearing, shear pins etc., under close tolerance.

The machine can be set for "LOW" & "HIGH" level pressing forces, the difference of which can be as low as 1000N (100 kgf.)

The Press first applies the "LOW" force. If the job is pressed then it is loose and machine stops.

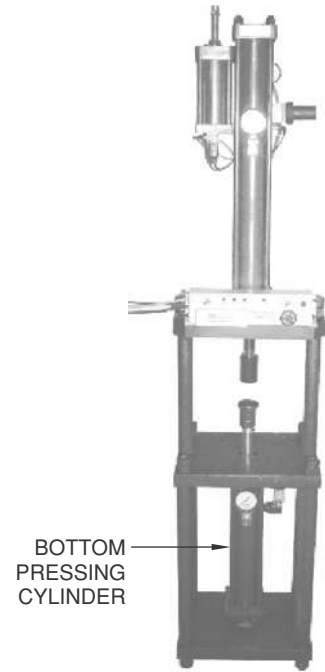
If pressing force is within the set limit, then the press operates normally.

If job is not pressed when "HIGH" force is applied then it is tight and machine stops.

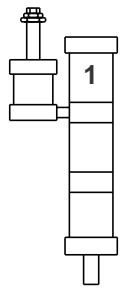
## Double Action Press

APPLICATION :- For jobs which need pressing from top and bottom such as powder compacting, deep drawing etc.

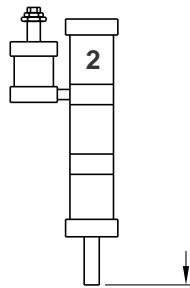
These special purpose presses are designed as per customer requirement.



## Parking Feature



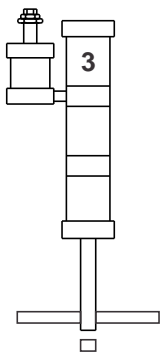
CYLINDER FULLY RETRACTED



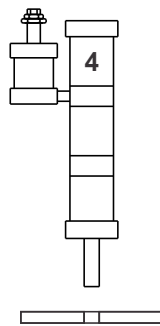
CYLINDER IN PARKED POSITION  
NOTE : TRAVEL 'X' SHOULD BE LESS THAN TOTAL POWER STROKE TRAVEL



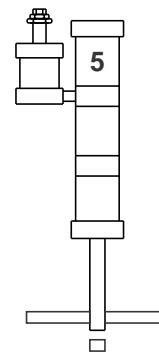
PARKING SCREW



CYLINDER OPERATES ONLY WITHIN POWER STROKE



CYLINDER RETRACTS TO PARKED POSITION

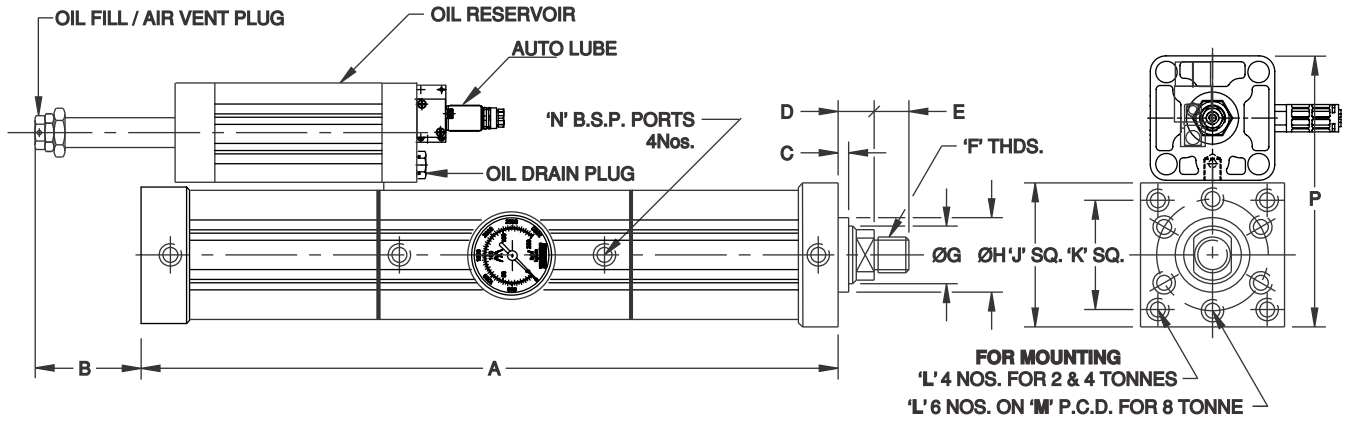


CYLINDER OPERATES AGAIN WITHIN POWER STROKE

APPLICATION :- This feature is useful for applications where the job is automatically fed into the die by press feeders etc. The cylinder is not required to retract/travel fully. This saves cycle time and air consumption considerably.



## Series 'A' Press Cylinder Dimensions



MODEL No.	TON @ 5 BARS	Total Stroke	Power Stroke	A	B	C	D	E	F	ØG	ØH	J SQ.	K SQ.	L	M	N	P	Q (NL) AIR. CONSU. @ 5 BARS
A 016-75	1	75	24	597	80	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	5.3
A 016-100	1	100	24	647	80	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	6.1
A 016-150	1	150	24	747	80	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	7.5
AH 21-50	2.5	50	6	495	97	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	4.1
AH 21-75	2.5	75	6	545	97	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	4.8
AH 21-100	2.5	100	6	595	97	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	5.5
AH 21-150	2.5	150	6	695	97	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	7.0
AH 24-75	2.5	75	12	641	104	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	6.9
AH 24-100	2.5	100	12	691	104	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	7.6
AH 24-150	2.5	150	12	791	104	4	19.0	30	M20x1.5	25	45	80	55	M12x1.75	-	1/4"	158	9.0
A 026-75	2	75	24	628	75	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	10.1
A 026-100	2	100	24	678	75	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	11.2
A 026-150	2	150	24	778	75	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	13.5
A 041-50	4	50	6	512	128	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	6.6
A 041-75	4	75	6	562	128	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	7.7
A 041-100	4	100	6	612	128	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	8.9
A 041-150	4	150	6	712	128	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	11.2
A 044-75	4	75	12	658	44	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	11.1
A 044-100	4	100	12	708	44	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	12.3
A 044-150	4	150	12	808	44	4	22.0	35	M24x2.00	32	55	102	78	M16x2	-	1/4"	200	14.6
A 046-75	4	75	24	713	63	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	18.1
A 046-100	4	100	24	763	63	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	19.8
A 046-150	4	150	24	863	63	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	23.2
A 081-50	8	50	6	571	154	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	11.4
A 081-75	8	75	6	621	154	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	13.2
A 081-100	8	100	6	671	154	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	14.9
A 081-150	8	150	6	771	154	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	18.3
A 084-75	8	75	12	740	41	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	19.6
A 084-100	8	100	12	790	41	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	21.3
A 084-150	8	150	12	890	41	4	25.0	35	M36x2.00	50	75	126	-	M16x2	105	1/2"	245	24.8

### To Calculate Compressor Power Capacity

1HP = 120 litres of Free Air (NL) Per Minute at 5 Bars.

N = Number of Cycles per minute

Q= Free Air Consumed Per Cycle (From Chart) in Normal Litres (NL)

$$\text{Power Required} = \frac{Q \times N}{120} \text{ (H.P.) or } \frac{Q \times N}{120} \times 0.746 \text{ (KW)}$$

Example :- A 4Tonne,50mm stroke with 6mm power stroke press is used at 5 bars to cut Aluminium 'washer from a sheet of 10 pieces per minute.

- 1) From above chart model A41-50 cylinder consumes 6.6 NL of air per cycle
- 2) @ 10 strokes/min air consumption = 6.6 X 10 = 66.0 NLPM
- 3) Electric Power Used = 66.0÷120 =0.55 HP≈0.41 KW
- 4) Cost of electricity @ Rs 10.0 per KWH =0.41 X 10 = Rs 4.10
- 5) Cost of electricity per cur piece = 4.10÷10÷60 = 0.007 Rs i.e 0.70 paise per piece

Note : Due to constant improvements, dimensions and technical specifications are subject to change without notice.



**POWER STROKE SOLENOID VALVE FOR STANDARD PRESS**



PART No.	DESCRIPTION	SEAL KIT No.
NS312EPR	1/4" 3/2 N.C. SOLENOID VALVE WITH EXTERNAL PILOT	SKNS312EPR
NS314EPR	1/2" 3/2 N.C. SOLENOID VALVE WITH EXTERNAL PILOT	SKNS314EPR

**RAPID APPROACH SOLENOID VALVE**



PART No.	DESCRIPTION	SEAL KIT No.
NS612PR	1/4" 5/2 SOLENOID VALVE	SKNS612PR
NS614PR	1/2" 5/2 SOLENOID VALVE	SKNS614PR

**SOLENOID VALVE FOR AUTOMATIC CYCLING OF POWER STROKE**



PART No.	DESCRIPTION	SEAL KIT No.
NS612EPR	1/4" 5/2 SOLENOID VALVE WITH EXTERNAL PILOT	SKNS612EPR
NS614EPR	1/2" 5/2 SOLENOID VALVE WITH EXTERNAL PILOT	SKNS614EPR

**TONNAGE GAUGE WITH ISOLATOR VALVE**



PART No.	DESCRIPTION	PART No.	DESCRIPTION
88-009-2T	FOR 2T 'N' SERIES CYLINDERS	88-009-4TP	FOR 4T 'P' & 'X' SERIES CYLINDERS
88-009-4T	FOR 4T 'N' SERIES CYLINDERS	88-009-8TP	FOR 8T 'P' & 'X' SERIES CYLINDERS
88-009-8T	FOR 8T 'N' SERIES CYLINDERS	88-009-15TP	FOR 15T & 30T 'P' & 'X' SERIES CYLINDERS
88-009-15T	FOR 15T 'N' SERIES CYLINDERS	88-077	FOR 'Z' SERIES CYLINDER, 210 bar
88-009-30T	FOR 30T 'N' SERIES CYLINDERS	88-078	FOR 'Z' SERIES CYLINDER, 350 bar
88-009-2TP	FOR 2T 'P' & 'X' SERIES CYLINDERS		

**AUTOLUBE**



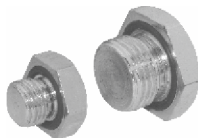
PART No.	DESCRIPTION	SEAL KIT No.
ALS2	AUTOLUBE	SKALS2

**REGULATED AIR PRESSURE GAUGE**



PART No.	DESCRIPTION
20-940	1/8", Ø50, 0-10 bar PNEUMATIC GAUGE FOR ALL PRESS CYLINDER MODELS

**OIL FILL PLUG**



PART No.	DESCRIPTION
86-001	1/4" OIL PLUG WITH 'O' RING FOR 'N' SERIES 2T & 4T
105-036	1/2" OIL PLUG WITH 'O' RING FOR 'N' SERIES 8T, 15T & 30T

**VALVE REGULATOR ASSEMBLY**



PART No.	DESCRIPTION
VRA2	1/4" VALVE-REGULATOR ASSEMBLY
VRA2T	1/4" VALVE-REGULATOR ASSEMBLY WITH TIMER
VRA4	1/2" VALVE-REGULATOR ASSEMBLY
VRA4T	1/2" VALVE-REGULATOR ASSEMBLY WITH TIMER

### LOW OIL LEVEL LIMIT SWITCH



PART No.	DESCRIPTION
71-038	LOW OIL LEVEL SENSING REED SWITCH

### STANDARD & AUTO CYCLING 2 HAND SAFETY CONTROL PANEL



PART No.	DESCRIPTION
N02-E	AUTOMATIC CYCLING OF POWER STROKE PANEL STANDARD CONTROL PANEL

### AIR SILENCERS



PART No.	DESCRIPTION
SL2	1/4" SILENCER
SL4	1/2" SILENCER

### SOLENOID COILS



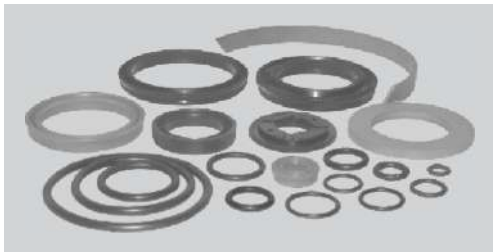
PART No.	DESCRIPTION
M22L	230VAC COIL WITH ILLUMINATED CONNECTOR
M22P	24DC COIL WITH ILLUMINATED CONNECTOR

### ELBOW FLOW CONTROL VALVE



PART No.	DESCRIPTION	SEAL KIT No.
UF2	1/4" SWIVEL ELBOW FLOW CONTROL VALVE FOR 2T & 4T	SKUF2
UF4	1/2" SWIVEL ELBOW FLOW CONTROL VALVE FOR 8T, 15T & 30T	SKUF4

### SPARE SEAL KITS



PART No.	DESCRIPTION
90-127	SEAL KIT FOR PRESS CYLINDER MODEL No. A021 & A024
90-121	SEAL KIT FOR PRESS CYLINDER MODEL No. A041 & A044
90-124	SEAL KIT FOR PRESS CYLINDER MODEL No. A081 & A084
90-142	SEAL KIT FOR PRESS CYLINDER MODEL No. A016
90-141	SEAL KIT FOR PRESS CYLINDER MODEL No. A026
90-124	SEAL KIT FOR PRESS CYLINDER MODEL No. A046