

## 1. Description

The Retractable Locating Pin is a high-power tool designed for use in locating points in the processing of sheet metal. It consists of a pneumatic cylinder and a housing in square design with integrated piston rod guiding and square connection surface.

The Retractable Locating Pin is fitted with an inductive set, which allows positioning to be controlled with inductive switches.

## 2. Safety

The Retractable Locating Pin was not conceived as a full tool supplied ready for independent use and has therefore not been fitted with its own safety equipment. Only when it is correctly installed in a production system and a corresponding safety control system is added, all safety requirements will be met.

Should any faults occur that place personnel at risk, the Retractable Locating Pin is to be switched off immediately. Maintenance measures are only to be undertaken when the machine is at a complete standstill and by suitably qualified specialists.

After maintenance work has been carried out, the protection devices are to be refitted in the correct way.

## 3. Assembly of the Retractable Locating Pin

- The Retractable Locating Pin is installed by means of six head cap screws on the front side of the housing.
- The attachment of the customers connection to piston rod can be implemented by two M10 cap screws and two D8 dowel pins to any side of the piston rod or by four M8 screws at the top of the piston rod

**Caution:** The Retractable Locating Pin was not provided with means of adjustment. This must be taken into account when designing / manufacturing the consoles / braces.

- Create supply of compressed air between pneumatic control and Retractable Locating Pin (connections "N"). At cylinder head the connections can be chosen on each side. At cylinder bottom there is an additional connection option underneath the cylinder.

**Caution:** For fine adjustment of speed of positioning operation use of external regulating valves is recommended.

### A. Inductive limit switch set (T12)

Set plug on socket "C" according to the electrical design of the pneumatic clamp (see circuit diagrams), and tighten.

**Caution:** Operation with incorrect or too high voltage can lead to short circuiting and danger to personnel.

Function control with integrated LED as follows:

green ..... operation voltage  
yellow ..... cylinder down  
red ..... cylinder up

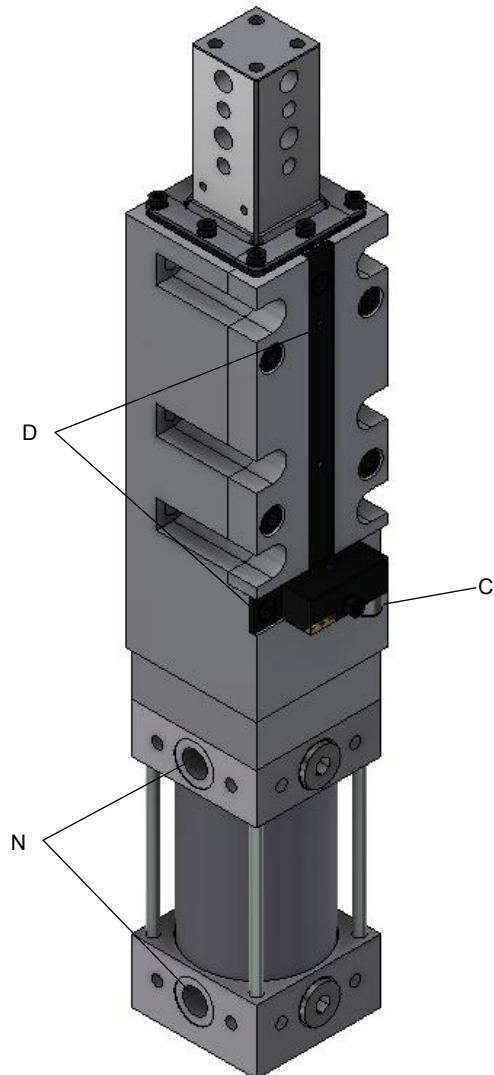
## 4. Replacement of limit switch cartridge

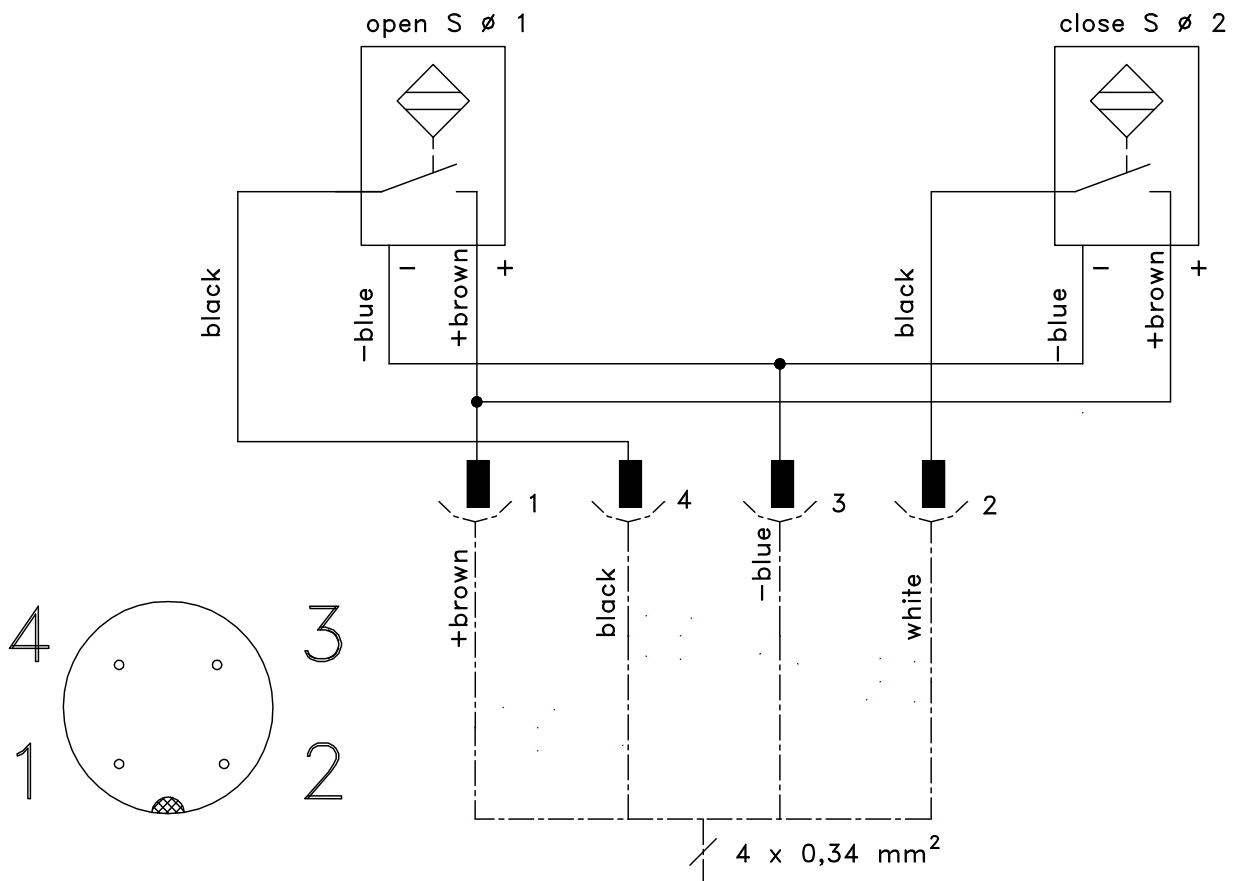
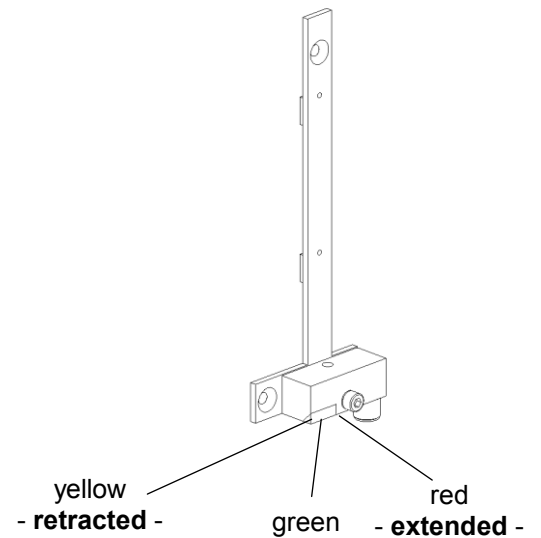
- Remove limit switch cartridge by releasing the screws "D".
- Set new limit switch cartridge and assemble.

## 5. Maintenance

The Retractable Locating Pin is fitted with a view to application in series production with low-maintenance bearings and guides. Because of the closed structure of the Retractable Locating Pin no special maintenance is necessary.

**Caution:** Damage can be caused to the Retractable Locating Pin by cleaning with steam-jet or dry ice.





## Technical specifications

Inductive switch (standard version)

Short circuit proof

Rated voltage 10-30 V

Working current 32 mA (one initiator connected with PLC)

Closer PNP exit



Subject to technical modifications.

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