

CONTROLLABLE GAS SPRINGS



CONTROLLABLE GAS SPRINGS

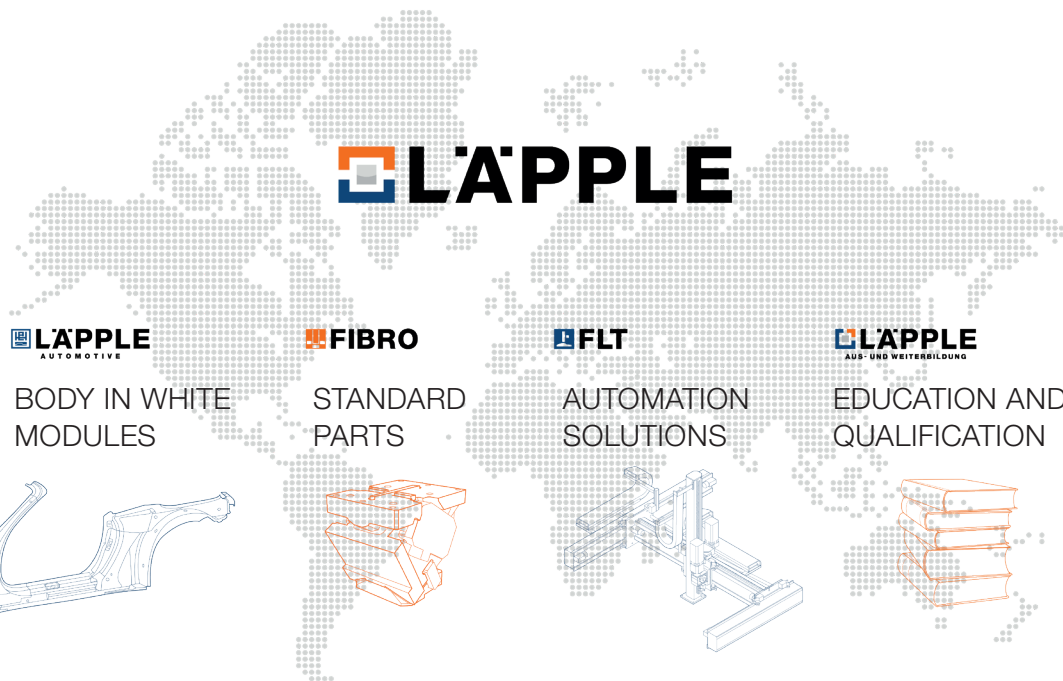
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The product range is tailored to customers in the tool, mold, machine, and system engineering industries.

They include steel die sets, guide elements, oilless guide elements and precision components such as punches and matrixes, special steel compression springs, gas springs, forming materials, metal bonding agents, moulding resins, peripheral equipment for pressing and tool making, tool slides with cam or roller slides and hydraulic cam systems.

subject to alterations



CONTROLLABLE GAS SPRINGS

INTRODUCTION, PLEASE NOTE

Controllable gas springs (KF springs) are gas springs which can be locked in their bottom position. The timing of the return stroke can be controlled to suit the application.

Controllable gas springs are available in 15 kN, 30 kN, 50 kN and 75 kN versions.

For best results the stroke length must always be used to the full with a tolerance of ± 0.5 mm.

For this reason the springs are available with any stroke length from 4 to 167 mm in 1 mm increments.

The gas spring return stroke can be controlled electrically or pneumatically from either the tool or the press end.

In the basic version of the gas spring (KF), it returns about 1 mm before it is held in the bottom position. This spring back effect can be eliminated, if required, by connecting the KF gas spring to a passive gas spring (KP) via a valve block. This is known as a KF + KP system. Both variants are illustrated in this brochure.

You can ensure system safety and reliability by supplying FIBRO with the application data and drawings of the installation arrangements for checking.

Please note that the number of the screwed connections and the hose lengths for installation in the system must be determined.



Assembly, commissioning, maintenance and servicing of controllable gas springs require special knowledge and may only be carried out by FIBRO appropriately trained, specialist personnel.

You can arrange for the work to be completed by a FIBRO customer service engineer, the invoiced cost including the assembly kits.

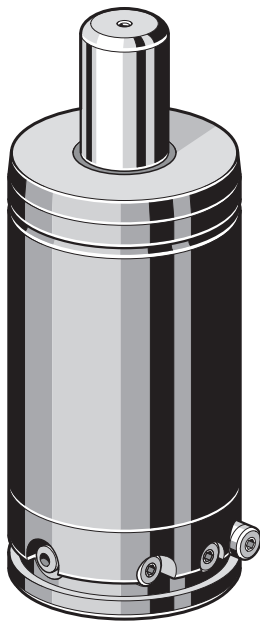
Just contact us to schedule the work for you. We shall be pleased to answer any technical queries you may have, now or at any time in the future.



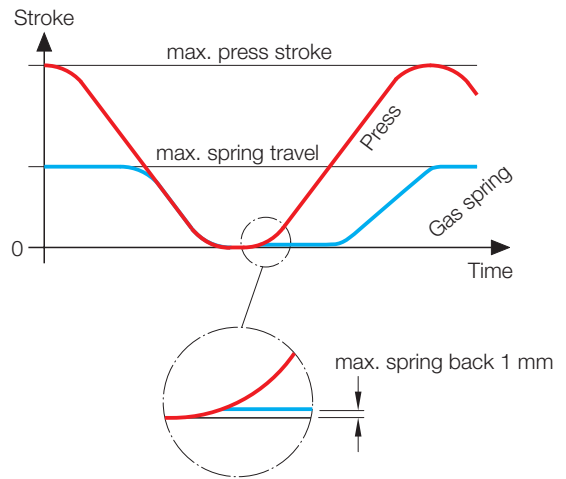
As controllable gas springs include parts which are specially made to specific stroke length, we recommend that you keep reserve systems in stock to avoid the risk delay when the need arises.

2489.14.

KF (max. spring back 1 mm)

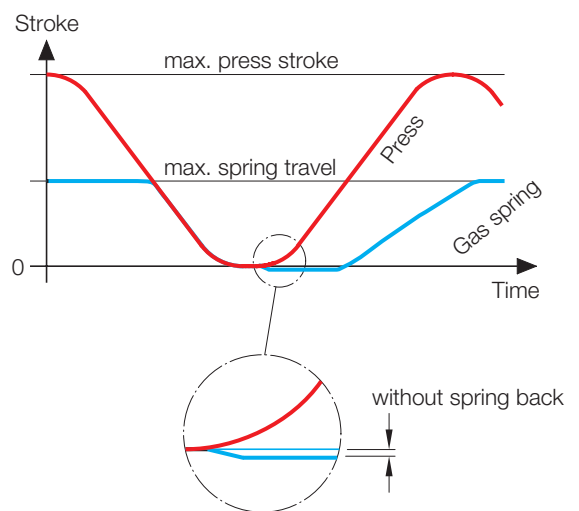
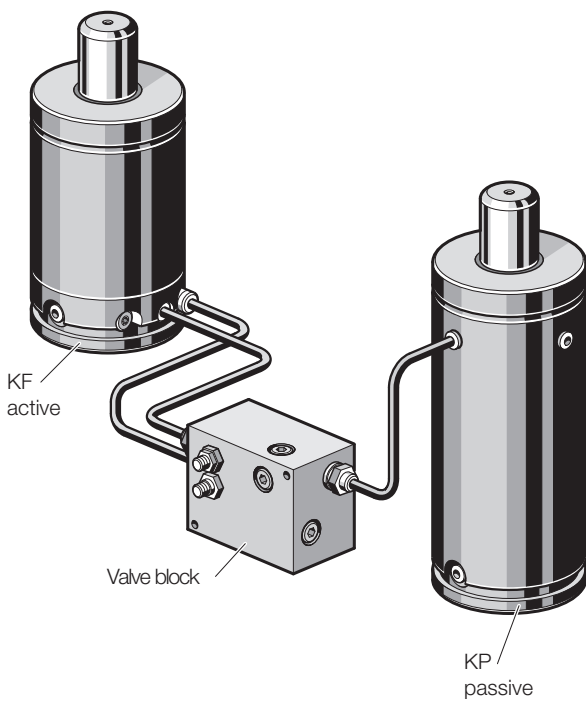


KF



2489.14. + 2489.16.

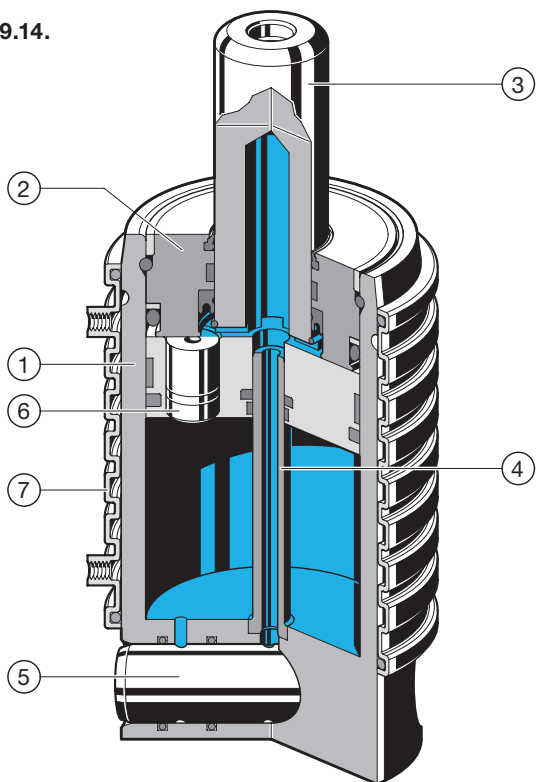
KF + KP system (without spring back)



CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE COMPONENTS

2489.14.



DESCRIPTION OF THE COMPONENTS

ACTIVE GAS SPRING (KF) 2489.14.

The KF controlled gas spring 2489.14. can be locked in its bottom position.

The gas spring consists of a cylinder (1), a guide (2), the piston and piston rod assembly (3), return valves (6), and internal piston rod (4) and a cartridge valve in the bottom of the gas spring (5).

There is also a version with a cooling jacket (7) (see pp 15 & 60).

2489.14.



There are three ports in the base of the gas spring: two nitrogen (1) and (3), connected to the gas cavities in the gas spring, and a compressed air port (4) for the compressed air to operate the cartridge valve.

Connection (1) is used to fill the gas spring (nitrogen). The passive gas spring (KP) is connected via connection (3).

Compressed air applied at port (4) closes the cartridge valve. In the absence of air pressure the valve opens.

CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE COMPONENTS

PASSIVE GAS SPRING (KP) 2489.16.

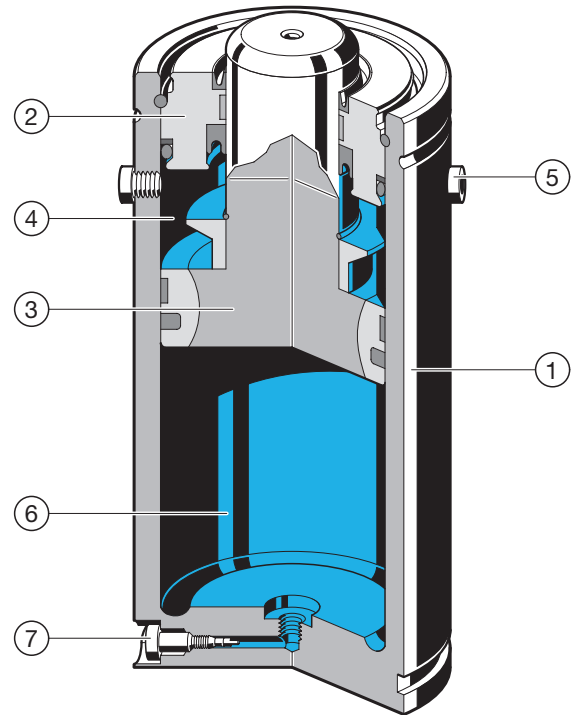
The passive KP gas spring 2489.16 is used to prevent the KF gas spring(s) springing back.



The KP gas spring must not be used in the operational working area of the tool, but must be compressed by the tool.

The passive gas spring consists of one cylinder (1), a guide (2) and piston and piston rod (3). The piston divides the gas spring into two gas compartments, the upper (4) and the lower (6). The upper compartment has four G1/8 ports (5), the lower a G1/8 gasfilling port (7).

2489.16.



CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE COMPONENTS

Valve block 2489.00.47.01



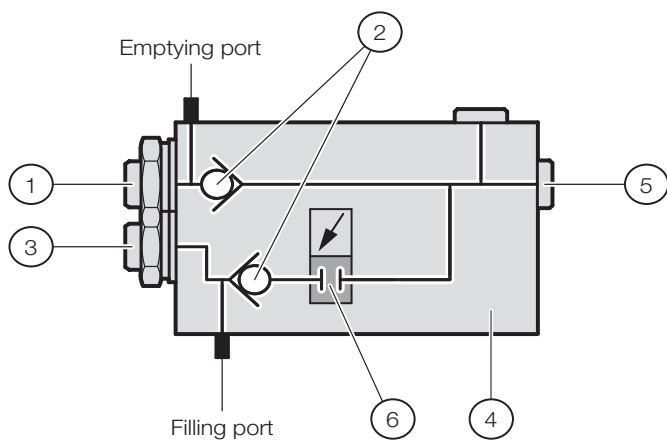
VALVE BLOCK (2489.00.47.01)

This valve block is used for controlling the flow of gas from the KF gas spring to the KP gas spring.

This valve block must be used with control fitting 2480.00.31.01.1 for filling or emptying nitrogen.

The valve block consists of a block (4), return valves (2) and a cartridge valve (6). The block has two ports (1,3) for connecting to the KF gas spring(s) and a port (5) for connecting the passive KP spring.

The compressed air port (C) is used for controlling the cartridge valve.



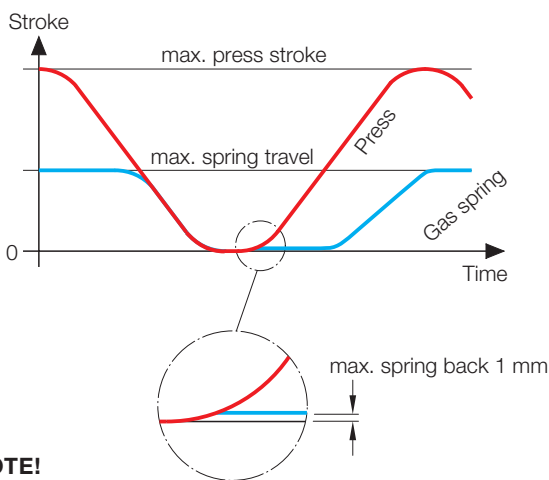
CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE FUNCTIONS

DESCRIPTION OF THE FUNCTIONS

CONTROLLABLE GAS SPRING KF 2489.14.

The KF gas spring has a locking function at the bottom position. Before the gas spring is held completely at the bottom position there is a slight spring back of 1 mm (or less). The complete stroke must be used, with a tolerance of ± 0.5 mm.



NOTE!



If the full stroke length is not used the spring back is more than 1 mm.

DOWN STROKE

The KF gas spring has two compartments, an upper one (1) and a lower one (2) which are separated by the piston of the gas return spring. The gas flow between these two compartments is as follows:

Fig. A shows the gas spring piston down stroke. During the down stroke the gas flows unimpeded through the return valve of the piston (3) from the lower (2) to the upper (1) gas compartment of the gas spring. The cartridge valve (4) in the base of the spring is closed.

As soon as the press and the gas spring reach the bottom position the return valves (3) close. (Fig. B). The gas spring is now "locked".

The pressure of the gas above and below the piston is the same. But as the surface exposed to the gas on the underside of the piston is larger than that on the upper side, there is a greater force applied. On the return stroke of the press (relief of spring) this force is released and causes the spring to return 1 mm. This results in a reduction of the pressure under the piston as the gas has been allowed to expand. The pressure in the upper compartment increases until there is a state of equilibrium. At this moment the gas spring stops completely.

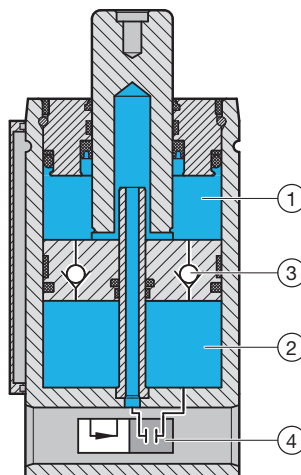


Fig. A, Down stroke

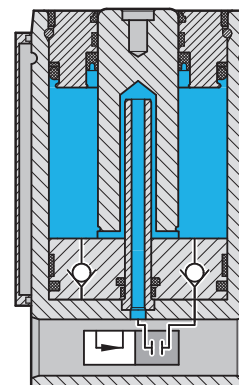


Fig. B, gas spring at bottom position

CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE FUNCTIONS

RETURN STROKE

The gas spring is released from its locked position when the cartridge valve (4) in the gas spring base is opened by the removal of pressure. (Fig. C). This causes the gas to flow through the piston rod (5) from the upper compartment (1) via the cartridge valve (4) back into the lower chamber (2).

The speed of the upstroke is approximately 0.2 m/s in models 2489.14.01500. and .03000. and approximately 0.08 - 0.15 m/s in models 2489.14.05000. and .07500.

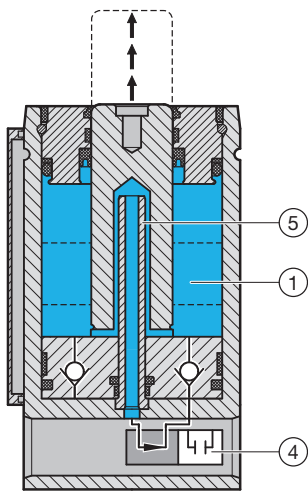
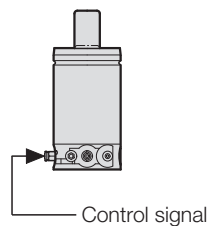
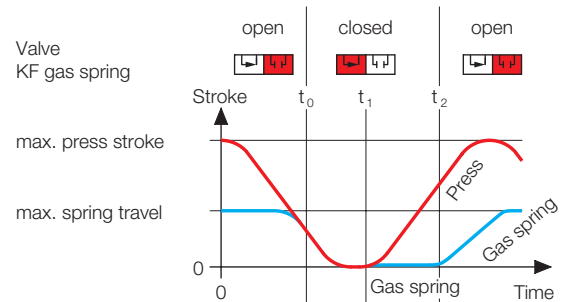


Fig. C, Return stroke



KF CONTROL SYSTEM

As described above, the return stroke of the gas spring is controlled by the cartridge valve in the base of the gas spring. The valve is closed by compressed air and opened by the absence of pressure.

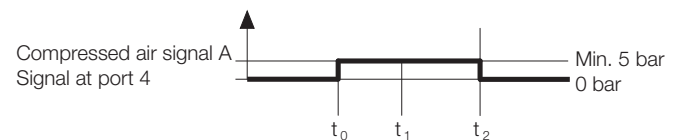


t_0 = before BDC bottom dead center of the press (0° - 90° press angle)
 t_1 = UT of the press
 t_2 = beginning of return stroke of gas spring

Pneumatic control

(controlled compressed air available from the press)

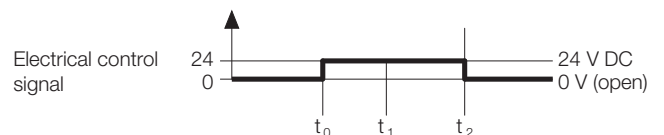
If there is a line for controlled compressed air from the press, this can be used directly to operate the cartridge valve.



Electric control

(electric control signal from the press available)

If there is an electrical control signal available from the press then the 2480.00.41.33 electro-pneumatic control valve can be used to convert the electrical signal into a pneumatic one.



A constant supply of compressed air is required for both the pneumatic and the electro-pneumatic valves. The required minimum pressure is 5 bar.



A control valve can control up to 6 gas springs.

The control signals for the gas springs and the valves are shown in the diagrams.

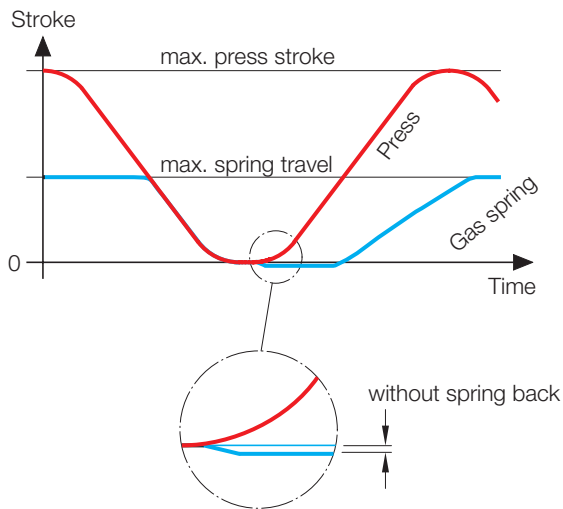
CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE FUNCTIONS

CONTROLLABLE GAS SPRING 2489.14. + 2489.16.

KF + KP SYSTEM WITHOUT SPRING BACK

In a KF + KP system the locking function can be arranged that a spring back is completely eliminated.



Between one and four controlled gas springs (1) can be connected to a passive KP gas spring (2) via a valve block (3). The KF spring is connected to the valve block by 2 hoses. The valve block has a hose connection to the upper gas compartment. There is the same gas pressure in all parts of the system at the start of the working cycle.

During the down stroke the KF gas spring works as described on page 11.

At the end of the press stroke the KP gas spring is compressed. This increases the volume of the upper gas compartment in the KP gas spring with a resultant decrease in pressure. The gas pressure has increased in the KF gas spring(s) as the gas has been compressed.

Fig. A

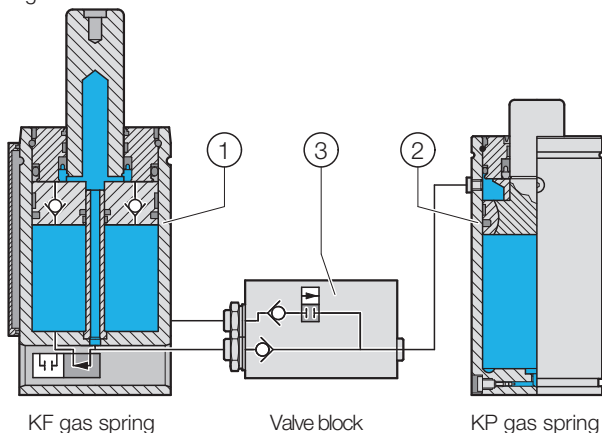
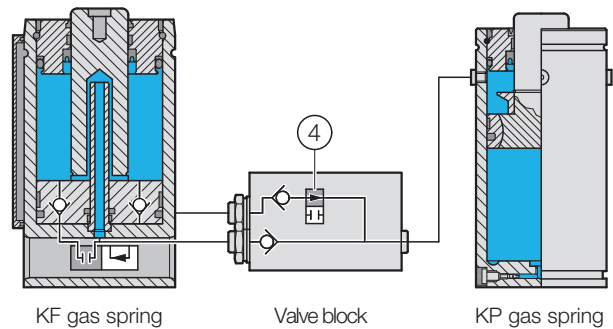


Fig. B



At bottom dead center (Fig. B) the cartridge valve (4) in the valve block opens so that the gas from the bottom gas compartment of the KF gas spring can flow into the upper compartment of the KP gas spring.

There is a resultant decrease in pressure in the bottom compartment of the KF gas spring, so that the force pushing the piston of the KF gas spring upwards is less than that from the upper compartment acting in a downward direction.

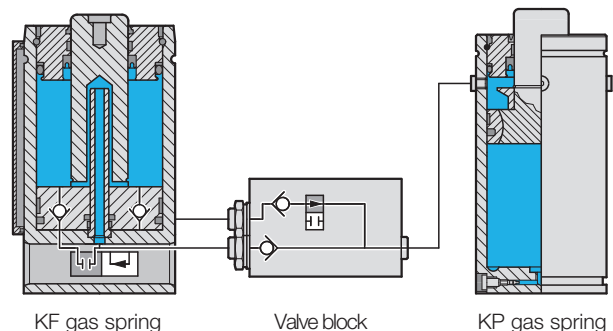
This means there is no spring back of the KF spring when the press relieves the load. The KP gas spring follows the press stroke to its home position (Fig. C).

The return stroke of the KF spring is as described on page 12.



To ensure the effectiveness of the locking function, the supply to the KP gas spring must be separate from the supply to the KF gas spring. This means that unlike the KF gas spring, the KP gas spring must not be used in the operational working area.

Fig. C



CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE FUNCTIONS

KF + KP CONTROL SYSTEM

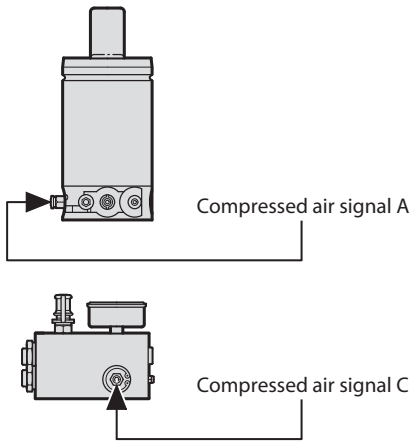
The control signals for a KF + KP system are shown in the diagram.

The system function, as described, is controlled by the cartridge valves in the base of the KF gas spring(s) and in the valve block. These two valves are not opened and closed simultaneously.

Pneumatic control

(controlled compressed air available from the press)

If there are two lines for controlled compressed air from the press, these can be used directly to operate the cartridge valves.



Electric control

(electric control signal from the press available)

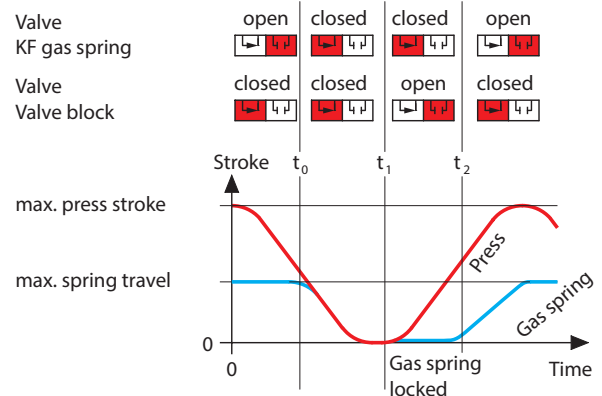
If there are two electrical control signals from the power press, two 2489.00.41.33 electro-pneumatic control valves can be used to convert the electrical signals into pneumatic ones.

A constant supply of compressed air is required for both the pneumatic and the electro-pneumatic valves. The required minimum pressure is 5 bar.

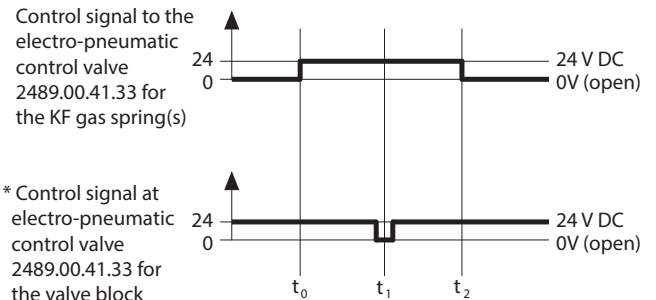
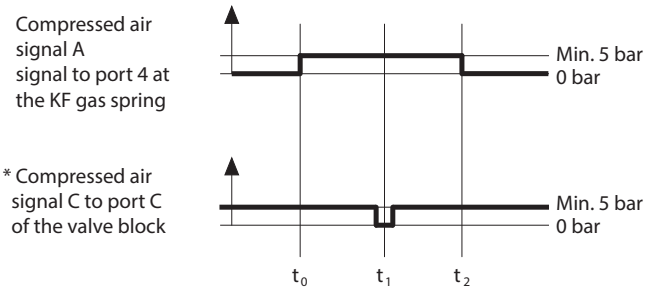
The control signals for the gas springs and the valves are shown in the diagrams in the next column.



Up to four KF gas springs can be connected to one KP gas spring. The stroke length of the KP gas spring does not depend on the stroke length of the KF gas spring(s), but on the quantity of the springs." (see page 29)



t_0 = before BDC bottom dead center of the press (0° - 90° press angle)
 t_1 = UT of the press
 t_2 = beginning of return stroke of gas spring



* Actuation at approx. 178° degree (approx. 2 mm before BDC bottom dead center), reset at approx. 182° degree (approx. 2 mm after BDC bottom dead center).

CONTROLLABLE GAS SPRINGS

DESCRIPTION OF THE FUNCTIONS

IN-TOOL CONTROL SYSTEM

The control system required for locking the KF gas spring can be integrated in the tool as a mechanical pressure switch.

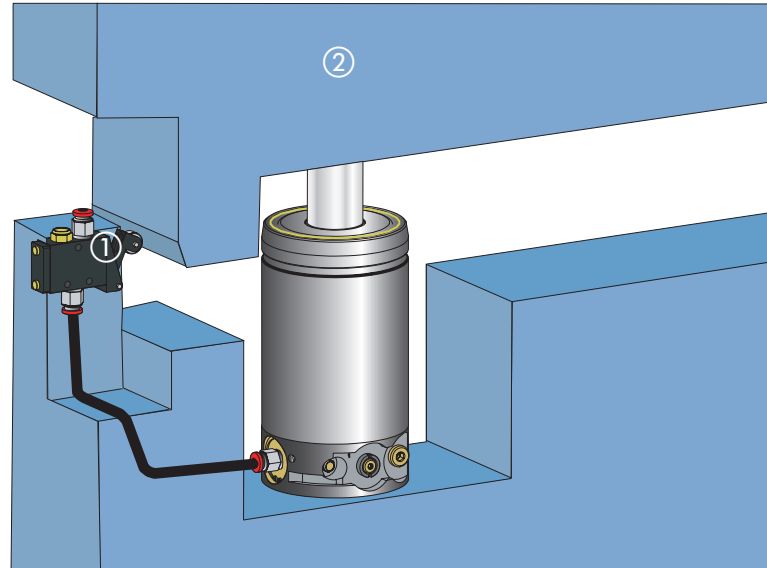
Then the control system required for locking and unlocking the KF gas spring(s) is independent of the press control system.

The KF gas spring or springs remain locked as long as the mechanical pressure switch [1] is operated by the tool [2].

A control system integral within the tool requires a constant supply of compressed air (at least 5 bar) for the mechanical pressure switch.

Please note!

It can also be used for controlling the valve of the valve block for KF + KP Systems (without spring back).



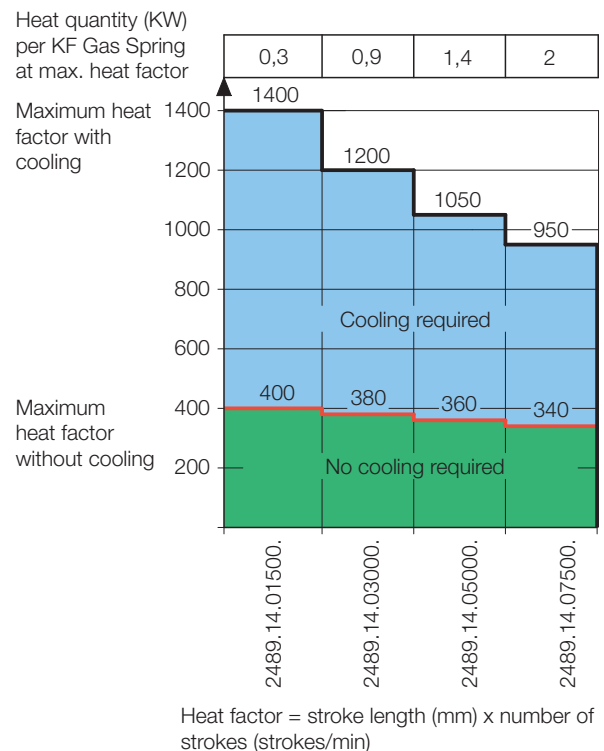
HEATING – COOLING SYSTEM

When a gas spring is compressed, a certain amount of energy is transmitted by the press to the gas spring. This amount of energy can be calculated by multiplying the spring force by the stroke length. In a conventional gas spring, the piston rod follows the gas spring during the press return stroke. The amount of energy generated, excluding any losses due to friction etc, is transmitted back to the press.

If controlled gas springs are used, the active gas spring does not follow the return stroke of the press. Indeed it generally requires a very low energy value for its own return stroke compared to the spring force used during compression. The difference between the amount of energy transmitted to the gas spring during compression and the amount of energy consumed during the return stroke is converted into heat.

This means that in some applications gas springs need cooling to prevent overheating. The amount of cooling required is calculated using the "heat factor".

The heat factor is calculated by multiplying the stroke rate by the stroke length of the gas spring. If this heat factor exceeds the values shown in the diagram opposite for various sizes of gas spring, then the gas spring must be cooled. The heat factor is calculated on the basis of a filling pressure of 150 bar. (See also page 60)



CONTROLLABLE GAS SPRINGS **COMPONENTS**



180°



CONTROLLABLE GAS SPRINGS COMPONENTS

COMPONENTS

This section describes step by step how to select the various components for a complete KF system.

As each tool offers different options, the step by step procedure should be followed in each case.

Select the components for your system. Use the information pages, then decide on the system you need, and the parameters and components. We shall be pleased to answer any queries you may have.

Fill in the order form list (KF on p. 20, KF + KP on p. 21) and for each component you select enter the order code and the number you require.

STEP 1

TYPE OF SYSTEM, KF OR KF + KP

The KF system has a locking function with a maximum spring back of 1 mm. If you need to eliminate spring back totally use a KF + KP system. A KF system can be converted into a KF + KP system by the addition of a KP spring.

STEP 2.1

KF GAS SPRINGS 2489.14.

TECHNICAL DATA

KF gas springs do not work like traditional gas springs. KF springs generate heat which is determined by the force (filling pressure), stroke and stroke rate.



The full stroke length of the KF gas spring must always be used.

STEP 2.2

KP GAS SPRING 2489.16

TECHNICAL DATA

The passive KP gas spring must not be used in a tool. A maximum of four KF gas springs can be linked to one KP gas spring.

STEP 2.3

VALVE BLOCK

Every KP gas spring must have a valve block connected.

Components	Catalogue page
Information to select components	Additional information

Components	Catalogue page
KF - max. 1 mm spring back oder	11 - 12
KF+KP - no spring back	13- 14

Components	Catalogue page
Force per gas spring	24
Number of gas springs	
Filling pressure	
Stroke (4-167 mm)	24
Stroke rate (strokes/min)	
Cooling required	60

Components	Catalogue page
Size of gas spring	25
Stroke used	25

Components	Catalogue page
Valve block	40

CONTROLLABLE GAS SPRINGS COMPONENTS

STEP 3.1

CONTROL SYSTEM

Check whether there is a pneumatic signal or an electrical signal (24 V) available from the press. In either case the control valves need compressed air (at least 5 bar) to control the cartridge valves. Do not connect more than six KF gas springs to one control valve.

Components	Catalogue page
Pneumatic signal from the press or Electrical signal from the press	35
Pneumatic hose, blue	33
Compressed air connections	33 - 34
Example	32

STEP 3.2

OVERHEATING PROTECTION

Fit a thermal relay to protect the gas springs from overheating.

Components	Catalogue page
Thermostatic relay	52

SCHRITT 4.1

FILLING AND EMPTYING GAS, KF SYSTEM

KF gas springs can be used independently of each other or in conjunction with each other. For each KF gas spring two hoses are required: one for filling and one for emptying.

Components	Catalogue page
Control fitting	41
Gauging hose	42 - 43
Gauging coupling	44
Example	37

STEP 4.2

FILLING AND EMPTYING GAS, KF + KP SYSTEM

See example of filling and emptying gas, KF + KP system on page 36.

Components	Catalogue page
Valve block + Control fitting	40 - 41
Control fitting KP gas spring	41
Gauging hose	42 - 43
Gauging coupling	44
24°-cone-hose	48 - 49
Adapter 24°-cone-hose	47
Example	39

STEP 5

FASTENING

We recommend that you use the tapped bore in the base of the gas spring for fixing.

Alternatively you could use the mounting variations 2480.055./057./064./007.

Components	Catalogue page
Fixings	24 - 26
	Main catalogue standard parts

STEP 6

COOLING SYSTEM

2 cooling systems are available.

- Cooling unit, external
- Gas cooler

Choose the cooling system according to the cooling capacity you require.

Components	Catalogue page
Cooling unit 10 kW / 25 kW	68
Gas cooler 1,5 kW	61 - 65
Connections	66, 71
Hose	67, 71
Connector block	70
Quick connector	70

CONTROLLABLE GAS SPRINGS

ORDER LIST KF

Customer: _____

Tool no.: _____

Technical contact: _____

Tel: _____

Fax: _____

Note: _____

STEP 1

KF GAS SPRING, TECHNICAL DATA

Components	information required
Force per gas spring	daN
Number of gas springs	
Filling pressure	bar
Stroke (4-167 mm)	mm
Stroke rate (strokes/min)	
Cooling required	<input type="checkbox"/> yes <input type="checkbox"/> no

STEP 2

KF GAS SPRING

Components	Order number	Quantity
KF gas spring	2489.14.	

STEP 3

CONTROL SYSTEM

Components	Order number	Quantity
Control valve		
electrical/pneumatic		
Compressed air hose, blue	2489.00.42.06.11.xx	m
Compressed air connections		
Compressed air connections		
Compressed air connections		
Compressed air connections		
Thermostatic relay	2489.00.70	

STEP 4

FILLING AND EMPTYING GAS, KF SYSTEM

Components	Order number	Quantity
Control fitting	2480.00.31.01.1	
Gauging hose		
Gauging hose		
Gauging hose		
Gauging hose		
Gauging coupling with valve G1/8	2480.00.24.01	

STEP 5

FASTENING

Components	Order number	Quantity
Fixings		

STEP 6

COOLING SYSTEM

Components	Order number	Quantity
Cooling unit 10 kW	2489.00.50.10	
Cooling unit 25 kW	2489.00.50.25	
Gas cooler 1,5 kW	2489.00.20.15	
Hose connector		
Hose connector		
Hose, blue, ø 16	2489.00.52.16.11	
Hose, red, ø 16	2489.00.52.16.12	
Distributor block	2489.00.54	
Hose, blue, ø 23	2489.00.52.23.11	
Hose, red, ø 23	2489.00.52.23.12	
Connector block	2489.00.55	
Quick connector, plug	2489.00.55	
Quick connector, socket	2489.00.57	

CONTROLLABLE GAS SPRINGS

ORDER LIST KF + KP

Customer: _____

Tool no.: _____

Technical contact: _____

Tel: _____

Fax: _____

Note: _____

STEP 1

KF GAS SPRING, TECHNICAL DATA

Components	information required
Force per gas spring	daN
Number of gas springs	
Filling pressure	bar
Stroke (4-167 mm)	mm
Stroke rate (strokes/min)	
Cooling required	<input type="checkbox"/> yes <input type="checkbox"/> no

STEP 2

KF + KP GAS SPRING GROUPS

Components	Order number	Quantity
KF gas spring		
KP gas spring		
Stroke used		mm
KP gas spring		
Valve block		

STEP 3

CONTROL SYSTEM

Components	Order number	Quantity
Control valve		
Electrical		
Compressed air hose, blue	2489.00.42.06.11.xx	m
Compressed air connections		
Compressed air connections		
Compressed air connections		
Compressed air connections		
Thermostatic relay	2489.00.70	

STEP 4

FILLING AND EMPTYING GAS, KF + KP SYSTEM

Components	Order number	Quantity
Valve block*	2489.00.47.01	
Gauging hose		
Gauging hose		
Gauging hose		
Gauging hose		
Threaded joint G1/8	2480.00.26.03	
Control fitting	2480.00.31.01.1	
24°-cone-hose	2480.00.25.0x.xx	
24°-cone threaded joints		
24°-cone threaded joints		
Threaded joint G1/4	2480.00.26.04	
*Control unit for valve block	2480.00.31.01.1	

STEP 5

FASTENING

Components	Order number	Quantity
Fixings		

STEP 6

COOLING SYSTEM

Components	Order number	Quantity
Cooling unit 10 kW	2489.00.50.10	
Cooling unit 25 kW	2489.00.50.25	
Gas cooler 1,5 kW	2489.00.20.15	
Hose connector		
Hose connector		
Hose, blue, ø 16	2489.00.52.16.11	
Hose, red, ø 16	2489.00.52.16.12	
Distributor block	2489.00.54	
Hose, blue, ø 23	2489.00.52.23.11	
Hose, red, ø 23	2489.00.52.23.12	
Connector block	2489.00.55	
Quick connector, Plug	2489.00.55	
Quick connector, socket	2489.00.57	

CONTROLLABLE GAS SPRINGS

DIMENSIONS AND ORDER NUMBERS



180°



CONTROLLABLE GAS SPRINGS

ACTIVE GAS SPRINGS (KF)

2489.14.



DESCRIPTION:

In some applications it is difficult to establish in advance the exact stroke length required.

We have designed the active gas spring with adjustable stroke length to solve this problem.

The stroke is adjustable by means of four special adjusting washers (2489.14.451.xxxxx.01, 2489.14.451.xxxxx.02, 2489.14.451.xxxxx.04 and 2489.14.451.xxxxx.08) in the gas spring. The total adjustment available is 15 mm (-8 mm and +7 mm relative to rated stroke).

For information on adjusting the stroke length see pages 83/84.

The table on the opposite page shows the stroke length adjustments and the resulting installation heights.

TECHNICAL DATA:

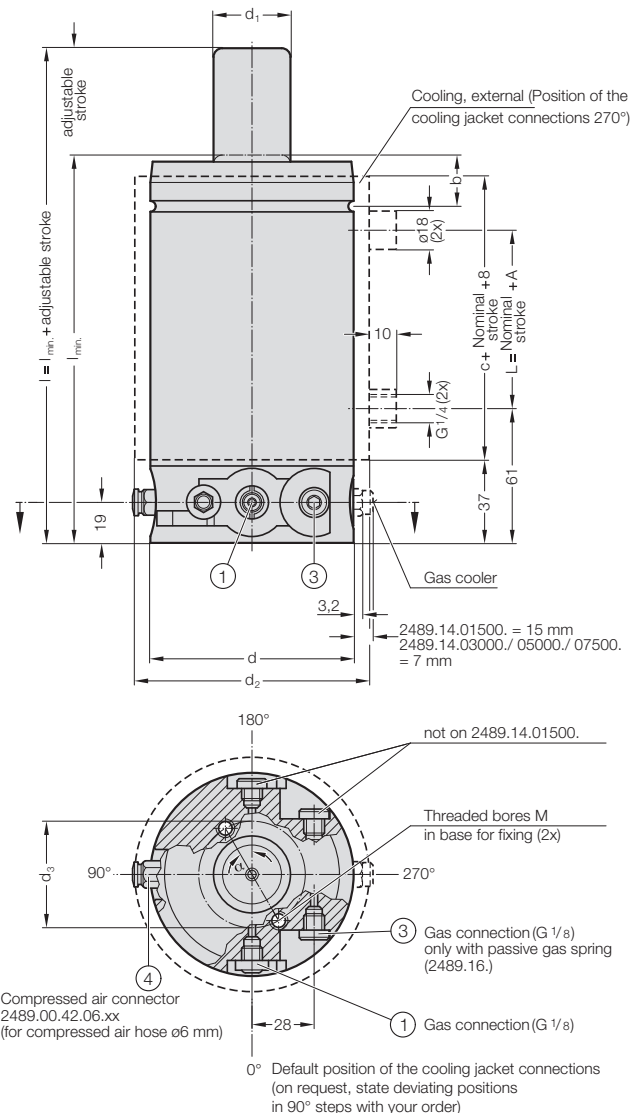
Pressure medium	Nitrogen
Max. filling pressure	150 bar
Min. filling pressure	25 bar
Working temperature	0 up to +80°C
Temperature related force increase	±0,3 %/°C
Max. piston speed	0,8 m/s
max. piston rod return speed*	
2489.14.01500.-.03000.	approx. 0,2 m/s
2489.14.05000.	approx. 0,15-0,12 m/s
2489.14.07500.	approx. 0,13-0,08 m/s

* Longer stroke lengths reduce the return stroke speed

For further information, please contact your contractor, or FIBRO GmbH, Business Area Standart Parts.

ORDERING CODE (EXAMPLE):

Controllable gas spring, active	= 2489.14.	Controllable gas spring, active	= 2489.14.
Initial spring force = 3000 daN	= 03000.	Initial spring force = 3000 daN	= 03000.
Rated stroke = 80 mm	= 080.	Rated stroke = 80 mm	= 080.
Stroke set = 78 mm	= 078	Stroke set = 78 mm	= 078
Liquid cooling (optional)	= K	Gas cooling (optional)	= N
Order No	= 2489.14.03000.080.078K	Order No	= 2489.14.03000.080.078N



NOTE:

For best results, the stroke length of the gas spring must always be fully utilized with a tolerance of ±0.5 mm.

- The gas springs are normally supplied with connections as above and unfilled.
- We recommend that you use the tapped bores in the base of the gas spring for fixing.
- Alternatively the fixing versions 2480.055./057./064./007. can be used
- See Standard Parts Catalogue Chapter F.

CONTROLLABLE GAS SPRINGS

ACTIVE GAS SPRINGS (KF)

ALTERNATIVE MOUNTING

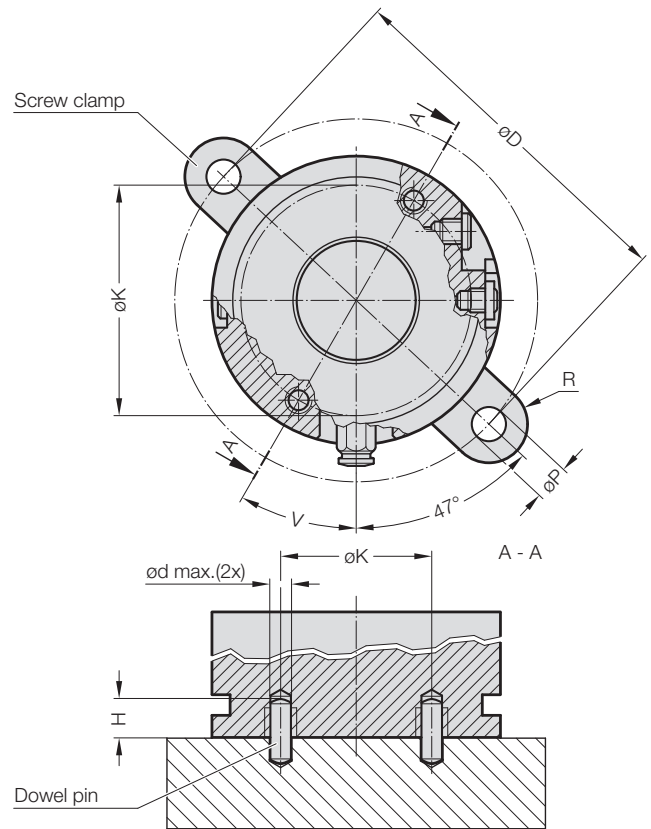
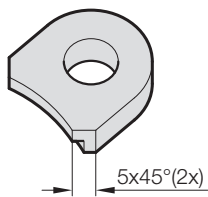
For upside down installations the threaded holes in the base of the 2489.14. should always be used when mounting the controllable gas springs (KF) to the tool.

For upright installations an alternative is to mount the Controllable gas springs using two 2480.007. in combination with dowel pins, as shown below.

The dowel pins will engage the threaded holes in the bottom of the spring (M12 respective M16) and will prevent the spring from moving out of position even if the lugs would come loose. The dowel pins will also ensure that the springs are installed in the correct position.

***ATTENTION:**

The 2480.007.03000 will require a slight modification, according to the sketch, before they can be fitted to the active controllable gas springs (KF) 2489.14.01500.



Modification of screw clamp 2480.007.03000

Spring size	øD	ød max.	H	øK	V	øP	R	No.	Screw clamp
2489.14.01500.	130	8	10	50	60	17.5	20	2	2480.007.03000*
2489.14.03000.	155	8	10	95	30	17.5	25	2	2480.007.05000
2489.14.05000.	195	12	10	110	30	21.5	25	2	2480.007.07500
2489.14.07500.	240	12	10	120	30	21.5	29	2	2480.007.10000

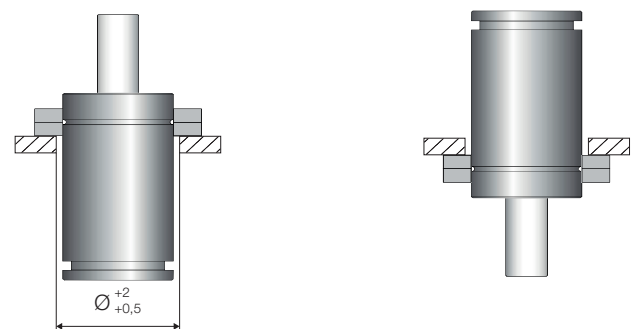
It is also possible to mount the active controllable gas springs (KF) as well as the passive gas springs (KP) using an 2480.055./057./064.

NOTE:

Not for active gas springs with cooling jacket.

Spring size	Clamping flange
2489.14./16.01500.	2480.055./057./064.03000
2489.14./16.03000.	2480.055./057./064.05000
2489.14./16.05000.	2480.055./057./064.07500
2489.14.07500.	2480.057.10000

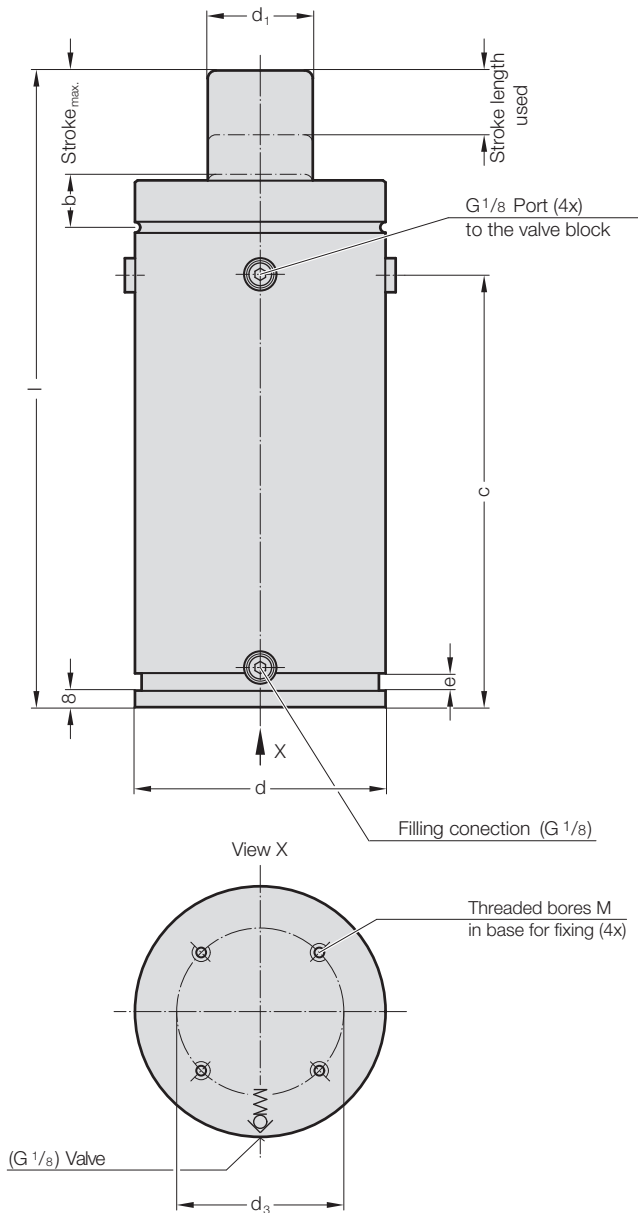
MOUNTING EXAMPLES:



CONTROLLABLE GAS SPRINGS

PASSIVE GAS SPRINGS (KP)

2489.16.



DESCRIPTION:

The same size should be selected for the KP gas spring 2489.16. as for the KF gas spring 2489.14. The only exception is 2489.14.07500 (see below).

The extent to which the KP gas spring has to be compressed depends on the number of KF gas springs in the system. The recommended stroke length is 5 mm per KF gas spring. For example, if there are four KF gas springs in the system then the stroke length used should be $4 \times 5 \text{ mm} = 20 \text{ mm}$.

Use KP 2489.16.05000 for type 2489.14.07500. The stroke used should then be 7.5 mm per KF gas spring in the tool.

The passive gas spring does not need to be cooled and is always connected to a valve block with the 24° conical hose system via one of the four G1/8 connections.

The connection at the base of the gas spring is for filling and emptying the lower gas compartment in the KP gas spring. It must be filled before the KF system is filled. When the KP gas spring is mounted in a tool, a control unit 2480.00.31.01.1 can be used for filling.

The KP gas spring is filled to the same pressure as the KF gas springs in the system, i.e. up to a maximum of 150 bar.

2489.16.

Force in daN for given stroke length in mm*

Order No.	5	10	15	20	25	30	35
2489.16.01500	3600	5200	6700	8200	9900	11900	-
2489.16.03000	6000	8300	10400	12300	14400	16800	-
2489.16.05000	7800	10200	12500	14700	16800	19000	21300

* Forces are calculated on the basis of a filling pressure of 150 bar in the KP and the KF gas springs.

Order No.	d	d_1	d_3	b	e	l	c	Stroke max.	M
2489.16.01500	95	36	60	24	7	220	140	30	M8x12,5
2489.16.03000	120	50	80	25,5	7	220	140	30	M10x16
2489.16.05000	150	65	100	27,5	8	300	182	35	M10x16

TECHNICAL DATA:

Pressure medium	Nitrogen
Max. filling pressure	150 bar
Min. filling pressure	25 bar
Working temperature	0 up to +80°C
Temperature related force increase	±0,3 %/°C
Max. piston speed	0,8 m/s

Additional information is available in Section F gas springs in the Standard Parts main catalogue..

CONTROLLABLE GAS SPRINGS
CONTROL SYSTEM
FILLING AND EMPTYING THE SYSTEM



180°



CONTROLLABLE GAS SPRINGS CONTROL SYSTEM

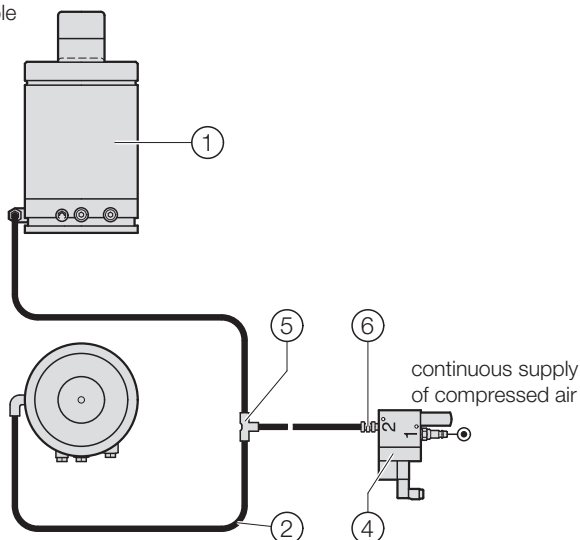
CONTROL SYSTEM

The KF gas springs and the valve block (for KF + KP) are supplied with compressed air connections for DN 6 hose lines. No more than six KF gas springs or one valve block should be controlled by one control valve. Suitable connections must be selected to set up the system. During installation (push-lock plug-in connection), measure the hoses in the tool and assemble them to the correct length. Select the control valve from Side 33 according to the signal from the power press (pneumatic or electric).

The control valve requires a continuous supply of filtered compressed air at a pressure of at least 5 bar. A KF gas spring (or a group of KF gas springs) requires one control valve, but a KF + KP system requires two control valves.

KF gas springs control system

Example

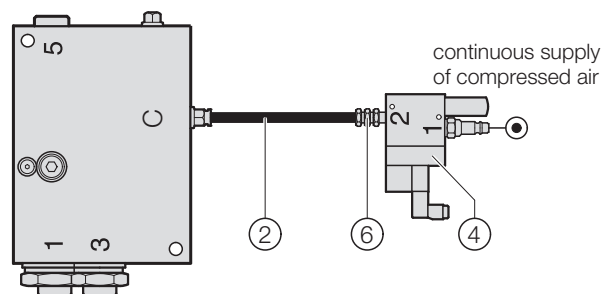


KF-GAS SPRING CONTROL SYSTEM, EXAMPLE

ItemNo.	Description	Order No.	Page
1	2 KF gas spring	2489.14.03000	24
2	3 Compressed air hose, blue	2489.00.42.06.11.xx	31
4	1 Electro-pneumatic valve	2489.00.41.33	33
or			
regulated compressed air from the press			
5	1 Push-in T-connector	2489.00.44.06.05	31
6	1 Push-in fitting straight G1/8	2489.00.43.01.01	31

Control system for valve block for KF + KP system

Example



CONTROL SYSTEM FOR VALVE BLOCK FOR KF + KP SYSTEM, EXAMPLE

Item No.	Description	Order No.	Page
2	1 Compressed air hose, blue	2489.00.42.06.11.xx	31
4	1 Electro-pneumatic valve	2489.00.41.33	33
or			
regulated compressed air from the press			
6	1 Push-in fitting straight G1/8	2489.00.43.01.01	31

CONTROLLABLE GAS SPRINGS CONTROL SYSTEM

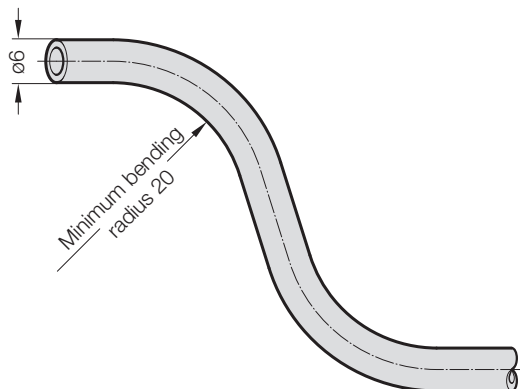
COMPRESSED AIR CONNECTIONS FOR DN 6 HOSE CONNECTIONS

NOTE:

Material	Polyurethane
Maximum temperature	60 °C
Maximum pressure	16 bar

2489.00.42.06.11.

Compressed air hose

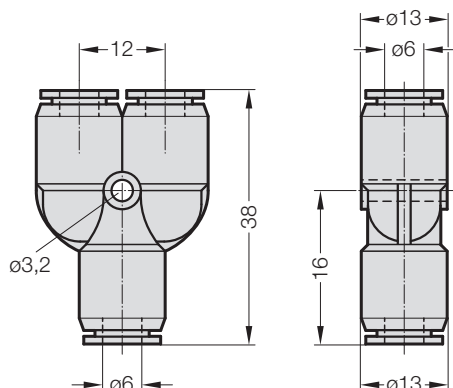


Order No.	Colour	Minimum bending radius
2489.00.42.06.11.xx	blue	20

Lenght .xx, order in metres [m]

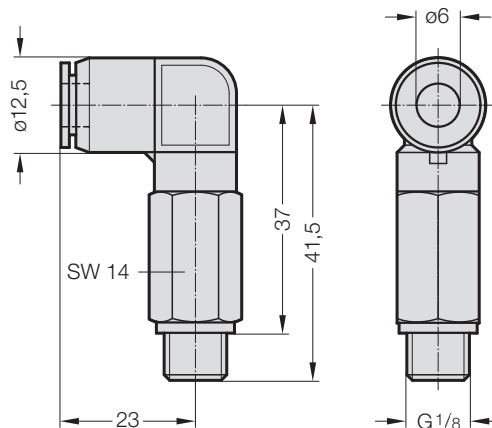
2489.00.44.06.06

Push-in Y-connector (hose to hose)



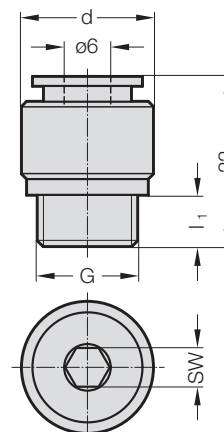
2489.00.43.01.02

Push-in fitting 90°, orientable - G1/8



2489.00.43.XX.01

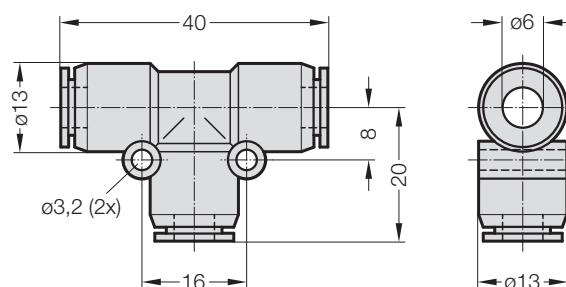
Push-in fitting straight



Order No.	G	d	I ₁	SW
2489.00.43.01.01	1/8	13	4,6	4
2489.00.43.02.01	1/4	17	6,6	4

2489.00.44.06.05

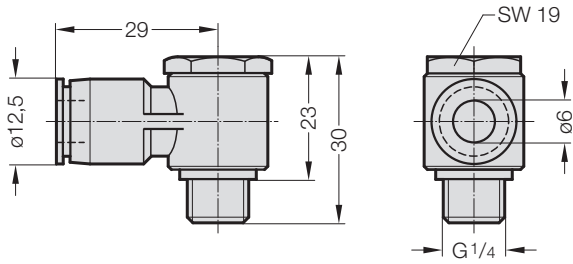
Push-in T-connector (hose to hose)



CONTROLLABLE GAS SPRINGS CONTROL SYSTEM

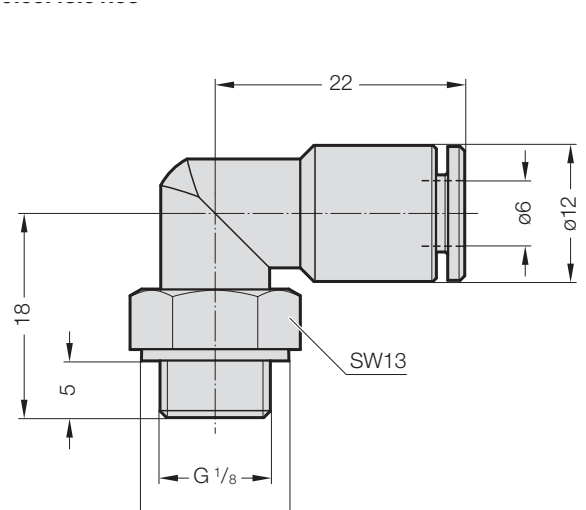
2489.00.43.02.02

Push-in fitting 90°, orientable - G1/4



2489.00.43.01.03

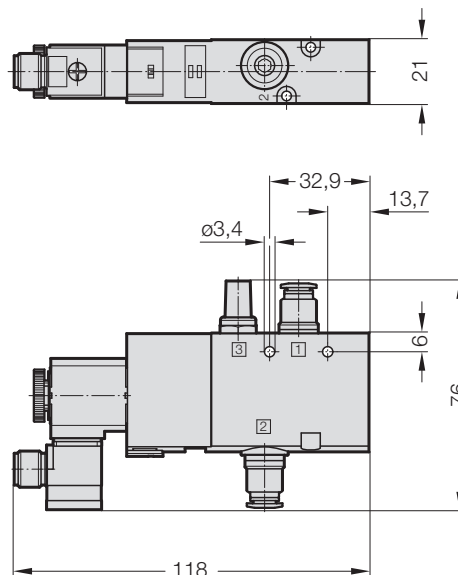
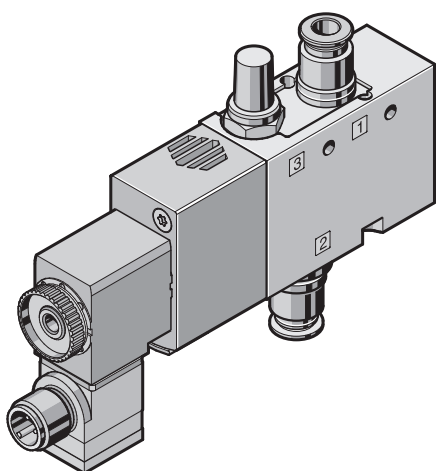
Push-in fitting 90°, orientable - G1/8



CONTROLLABLE GAS SPRINGS CONTROL SYSTEM

2489.00.41.33

3/2 way valve, electro-pneumatic



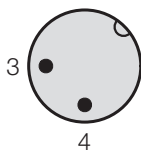
TECHNICAL DATA:

Fluid: Air or inert gas, filtered oily or dry

Voltage: 24V DC – (2,6 W)

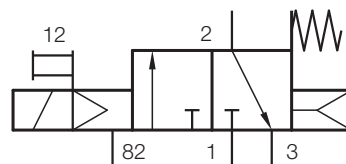
- One valve can control up to 6 gas springs or one valve block (KF + KP system).

ELECTRICAL CONNECTION PORT



CONNECTION SYMBOL: VALVE

Initial position closed



CONNECTION CABLE STRAIGHT

order separately

Order No		l [m]
2489.00.41.00.01	M12x1, 3-pole end open	2,50

CONNECTION CABLE 90°

order separately

Order No		l [m]
2489.00.41.00.02	M12x1, 3-pole end open	2,50

CONTROLLABLE GAS SPRINGS

FILLING AND EMPTYING GAS, KF SYSTEM

FILLING AND EMPTYING GAS, KF SYSTEM

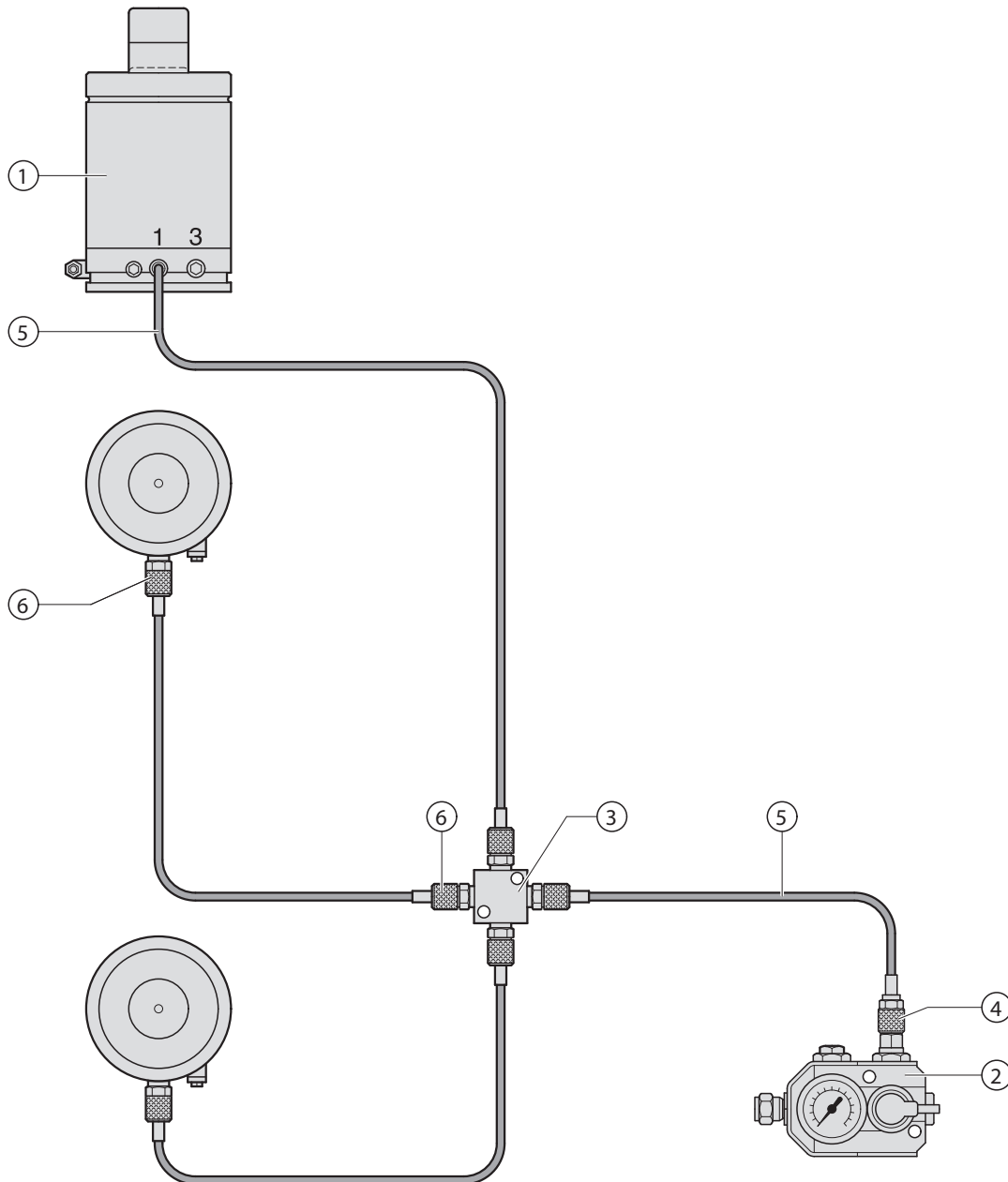
KF gas springs have to be connected to a control fitting for filling and checking the gas pressure. For each KF gas spring one hose is required for filling and emptying.

This hose is connected to the control fitting via a distributor block.

We recommend the use of the micro hose system (2480.00.23./24. see pp. 40-41) and the correct connectors. As supplied, connections 1 & 3 of the KF gas spring are closed off with blanking plugs. The filling valve in connection 1 must be removed before the hose system is installed.

CONTROLLABLE GAS SPRINGS FILLING AND EMPTYING GAS, KF SYSTEM

EXAMPLE OF A MICRO HOSE SYSTEM (2480.00.23./24.) FOR THREE KF GAS SPRINGS



Item	No.	Description	Order No.	Page
1	3	KF gas spring	2489.14.01500.030.031	24
2	1	Control fitting	2480.00.31.01.1	41
3	1	Distributor block G1/8 with 4 ports	2480.00.24.34	46
4	1	Gauging coupling with valve G1/4	2480.00.24.02	44
5	4	Gauging hose both ends straight	2480.00.23.01.xxxx	42
6	7	Gauging coupling with valve G1/8	2480.00.24.01	44

CONTROLLABLE GAS SPRINGS

FILLING AND EMPTYING GAS, KF + KP SYSTEM

FILLING AND EMPTYING GAS, KF + KP SYSTEM

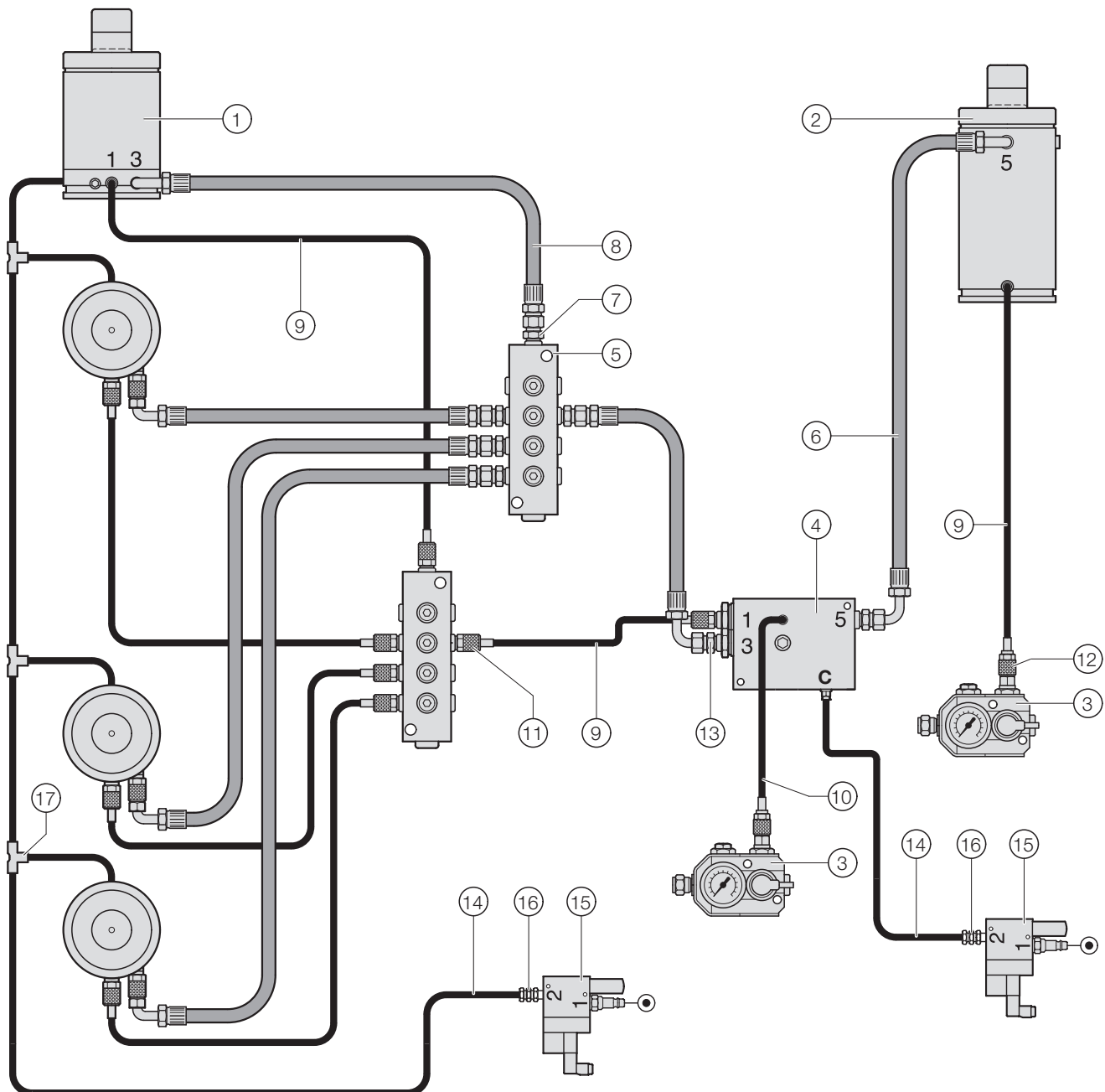
These have to be connected to each other for checking or modifying the filling pressure of KF gas springs. There are two hoses for each KF gas spring - one to fill it and one to empty it. The micro hose system (2480.00.23./24. see page 42-44) is used for port 1. A more robust hose is required for the connection between port 3 of the KF gas spring, the valve block and port 5 of the KP gas spring. We recommend our 24° cone hose system (2480.00.25./26. see page 47-49).

A KF + KP system is filled in two stages. First the lower gas compartment of the KP gas spring is filled and then the KF gas springs. If the valve block and the KP gas spring are mounted in a tool, control units may be used to make the job of filling and emptying the system easier. As supplied, connections 1 & 3 of the KF gas spring are closed off with blanking plugs. The filling valve in connection 1 must be removed before the hose system is installed.

Item	No.	Description	Order No.	Page
1	4	KF gas spring	2489.14.01500.030.031	24
2	1	KP gas spring	2489.16.01500	27
3	2	Control fitting	2480.00.31.01.1	39
4	1	Valve block without pressure gauge	2489.00.47.01	38
5	2	Distributor G1/8	2480.00.24.33	43
6	1	24°-cone-hose 90°/90°	2480.00.25.03.xxxx	46
7	10	Threaded joint G1/8	2480.00.26.03	45
8	5	24°-cone-hose 90°/straight	2480.00.25.02.xxxx	46
9	6	Gauging hose both ends straight	2480.00.23.01.xxxx	40
10	1	Gauging hose one end straight / 90°	2480.00.23.02.xxxx	40
11	11	Gauging coupling with valve G1/8	2480.00.24.01	42
12	3	Gauging coupling with valve G1/4	2480.00.24.02	42
13	2	Threaded joint G1/4	2480.00.26.04	45
14	2	Compressed air hose, blue	2489.00.42.06.11.xx	31
15	2	Electro-pneumatic valve	2489.00.41.33	33
16	2	Push-in fitting straight G1/8	2489.00.43.01.01	31
17	3	Push-in T-connector	2489.00.44.06.05	31

CONTROLLABLE GAS SPRINGS FILLING AND EMPTYING GAS, KF + KP SYSTEM

EXAMPLE OF A KF + KP SYSTEM WITH FOUR ACTIVE GAS SPRINGS AND ONE PASSIVE GAS SPRING



CONTROLLABLE GAS SPRINGS

VALVE BLOCK WITHOUT MANOMETER

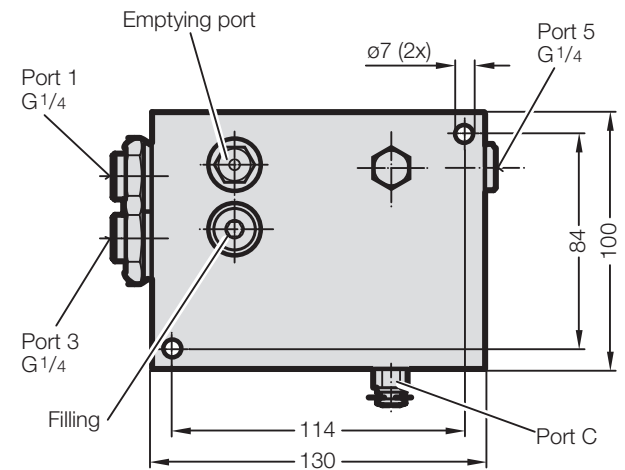
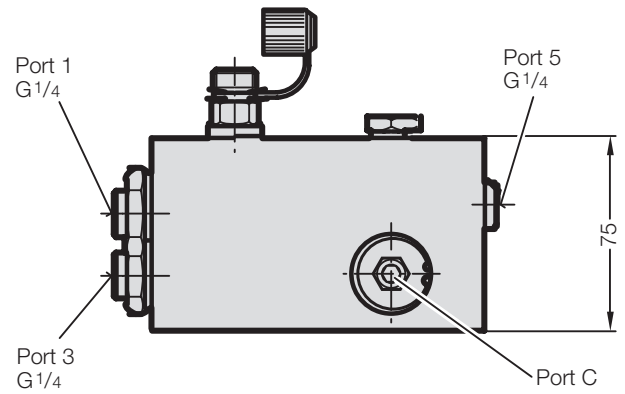
VALVE BLOCK WITHOUT MANOMETER

Valve block without facility for emptying and filling

Order No.: 2489.00.47.01 (Filling pressure 25 – 150 bar)



2489.00.47.01

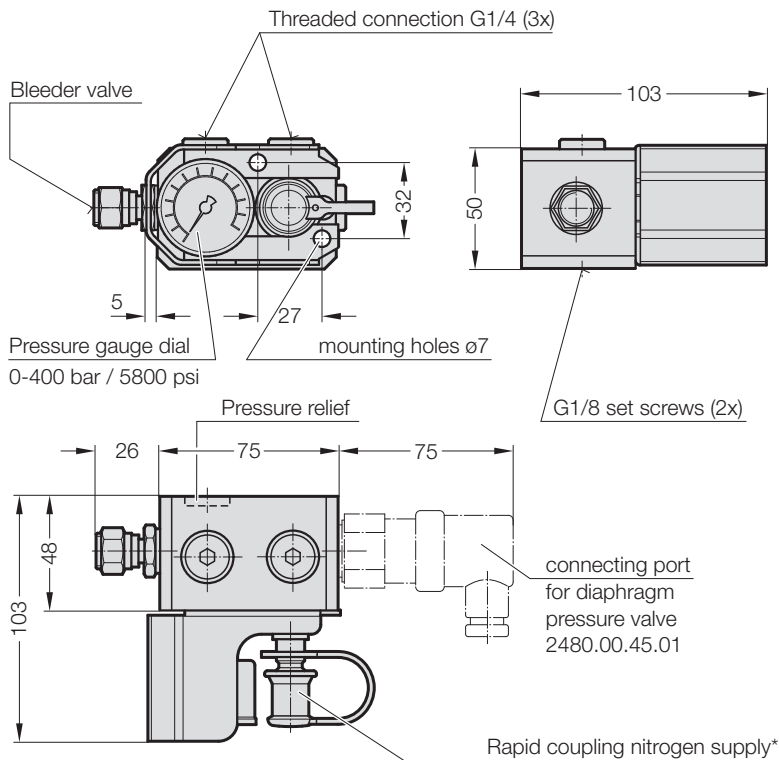


CONTROLLABLE GAS SPRINGS

CONTROL FITTING

CONTROL FITTING

- 2480.00.31.01.1 without pressure switch
- 2480.00.31.06.1 with pressure switch
- 2480.00.31.07.1 without pressure switch and with pressure relief
- 2480.00.31.08.1 with pressure switch, with pressure relief



DESCRIPTION:

The control unit 2480.00.31.0x.1 provides continuous monitoring of the filling pressure of the KF + KP gas springs.

During operation the pressure can be checked in two ways:

- a) by watching the pressure display
- b) by automatic monitoring using a membrane pressure switch. This turns the machine off or triggers a signal if the pressure drops.

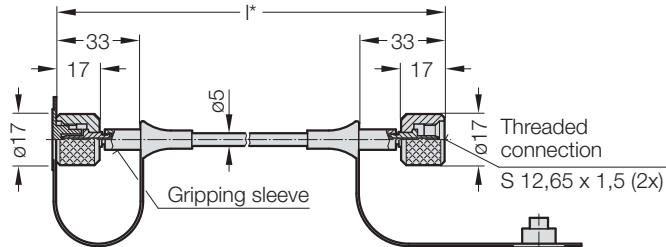
NOTE:

- * 2m long filling hose with quick release coupling and gas bottle connector Order no: 2480.00.31.02 (order separately)

CONTROLLABLE GAS SPRINGS GAUGING HOSES

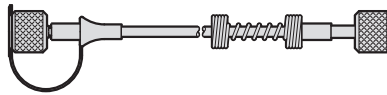
2480.00.23.01.

Gauging hose -
both ends straight



2480.00.23.01.-----1

Antikink spiral, at one end



2480.00.23.01.-----2

Antikink spiral, at both ends

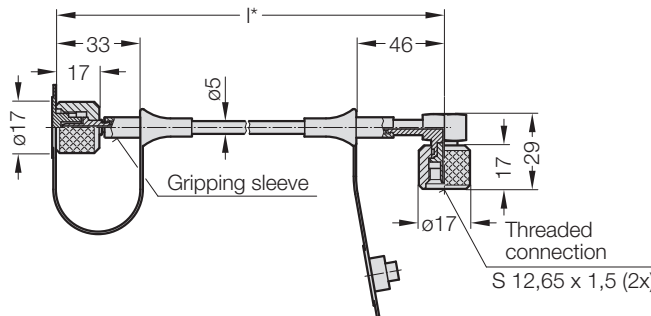


ORDERING CODE (EXAMPLE):

Gauging hose Mini, both ends straight	= 2480.00.23.01.	Gauging hose Mini, both ends straight	= 2480.00.23.01.
l = 90 mm	= 0090	l = 150 mm	= 0150.
Order No	= 2480.00.23.01.0090	Bend protection on one side	= 1
		Order No	= 2480.00.23.01.0150. 1

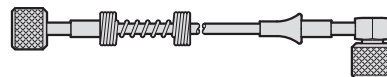
2480.00.23.02.

Gauging hose -
one end straight
90°-angle



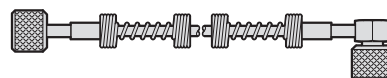
2480.00.23.02.-----1

Antikink spiral, at one end, straight



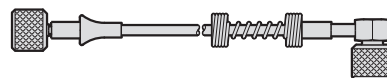
2480.00.23.02.-----2

Antikink spiral, at both ends



2480.00.23.02.-----3

Antikink spiral, at one end, 90°



BESTELL-BEISPIEL:

Gauging hose Mini, one end straight / 90°-angle	= 2480.00.23.02.	Gauging hose Mini, one end straight / 90°-angle	= 2480.00.23.02.
l = 90 mm	= 0090	l = 150 mm	= 0150.
Order No	= 2480.00.23.02. 0090	Bend protection on one side	= 1
		Order No	= 2480.00.23.02. 0150. 1

ORDER EXAMPLE:

Shortest factory length:

90 mm excl. bend protection

150 mm bend protection on one side

300 mm bend protection on both sides

Minimum bending radius: R20 mm

*Measuring hose available in the
following lengths:

5 mm step range ≤ 1000 mm

10 mm step range > 1000 mm

100 mm step range > 4000 mm

500 mm step range > 6000 mm

ORDER EXAMPLE:

Shortest factory length:

90 mm excl. bend protection

150 mm bend protection on one side

300 mm bend protection on both sides

Minimum bending radius: R20 mm

*Measuring hose available in the
following lengths:

5 mm step range ≤ 1000 mm

10 mm step range > 1000 mm

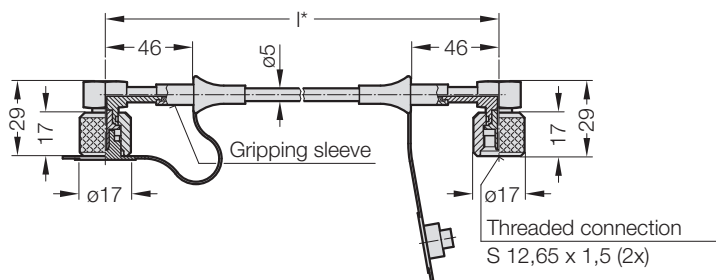
100 mm step range > 4000 mm

500 mm step range > 6000 mm

CONTROLLABLE GAS SPRINGS GAUGING HOSES

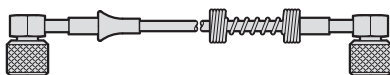
2480.00.23.03.

Gauging hose -
both ends
90°-angle



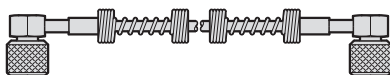
2480.00.23.03.-----3

Antikink spiral, at one end



2480.00.23.03.-----2

Antikink spiral, at both ends



ORDER EXAMPLE:

Shortest factory length:

90 mm excl. bend protection

150 mm bend protection on one side

300 mm bend protection on both sides

Minimum bending radius: R20 mm

*Measuring hose available in the
following lengths:

5 mm step range ≤ 1000 mm

10 mm step range > 1000 mm

100 mm step range > 4000 mm

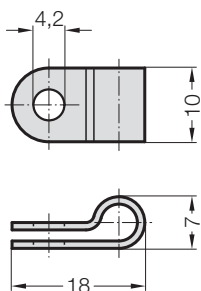
500 mm step range > 6000 mm

ORDERING CODE (EXAMPLE):

Gauging hose Mini, both ends 90°-angle	= 2480.00.23.03.	Gauging hose Mini, both ends 90°-angle	= 2480.00.23.03.
l = 90 mm	= 0090	l = 150 mm	= 0150.
Order No	= 2480.00.23.03.0090	Bend protection on one side	= 3
		Order No	= 2480.00.23.03.0150.3

2480.00.23.12.01

Hose clamp
for gauging hose
DN2 (Ø5 mm)



MATERIAL:

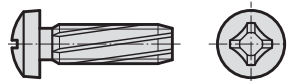
Polyamide

NOTE:

Supplied without screws

2192.50.04.012

Self-tapping screw
DIN 7516 - M4x12



NOTE:

self-tapping
Diameter of hole for
self-tapping screw = 3.6
mm

2480.00.23.13.

Anti-scuff spiral
for subsequent installation over hoses and tubing



MATERIAL:

Polyamide

DESCRIPTION:

The anti-scuff spiral is
used to protect against
abrasion, is resistant to air,
water, oil, hydraulic fluids
petrol and other liquids.

Inner ø	7 mm
For hose external ø	max. 5-11 mm
Temperature range	-30°C up to +100°C

Order No.	l [m]
2480.00.23.13.0001	1
2480.00.23.13.0002	2
2480.00.23.13.0005	5
2480.00.23.13.0010	10

CONTROLLABLE GAS SPRINGS

GAUGING COUPLING

GAUGING COUPLING

FOR CONNECTION TO GAS SPRINGS

2480.00.24.01 with valve

2480.00.24.03 without valve

GAUGING COUPLING

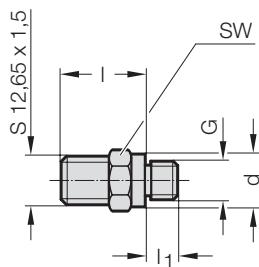
FOR CONNECTION TO CONTROL FITTING

2480.00.24.02 with valve

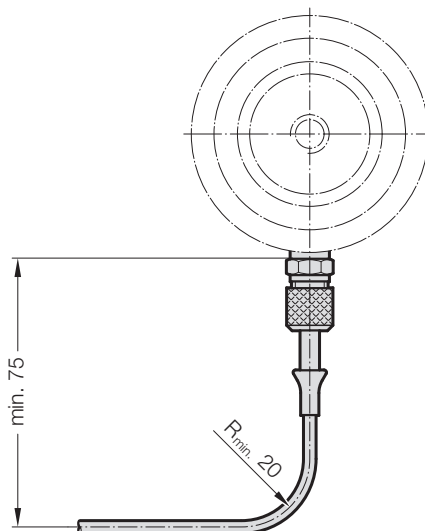
2480.00.24.04 without valve

NOTE:

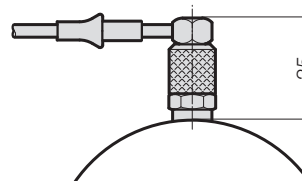
The measuring coupling with valve is used for standard assembly layouts. Where the system requires frequent filling pressure changes (e.g. die drawing cushions), the measuring coupling is used without a valve.



INSTALLATION DIMENSIONS 1



INSTALLATION DIMENSIONS 2

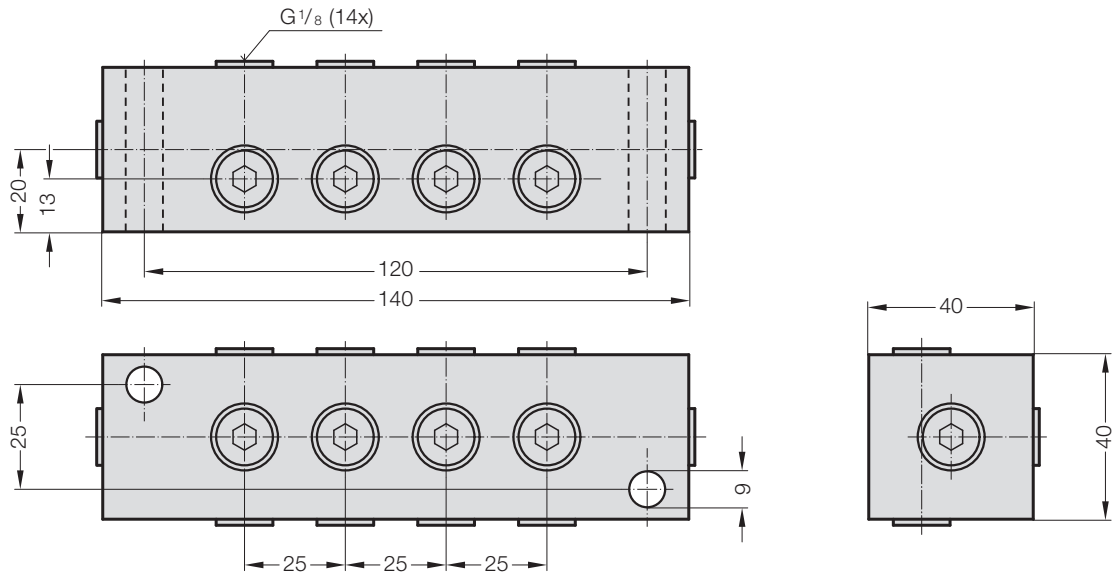


Order No.	G	d	SW	l	l ₁
2480.00.24.01	G1/8	14	14	22	8
2480.00.24.02	G1/4	19	19	21	10
2480.00.24.03	G1/8	14	14	22	8
2480.00.24.04	G1/4	19	19	21	10

CONTROLLABLE GAS SPRINGS DISTRIBUTOR

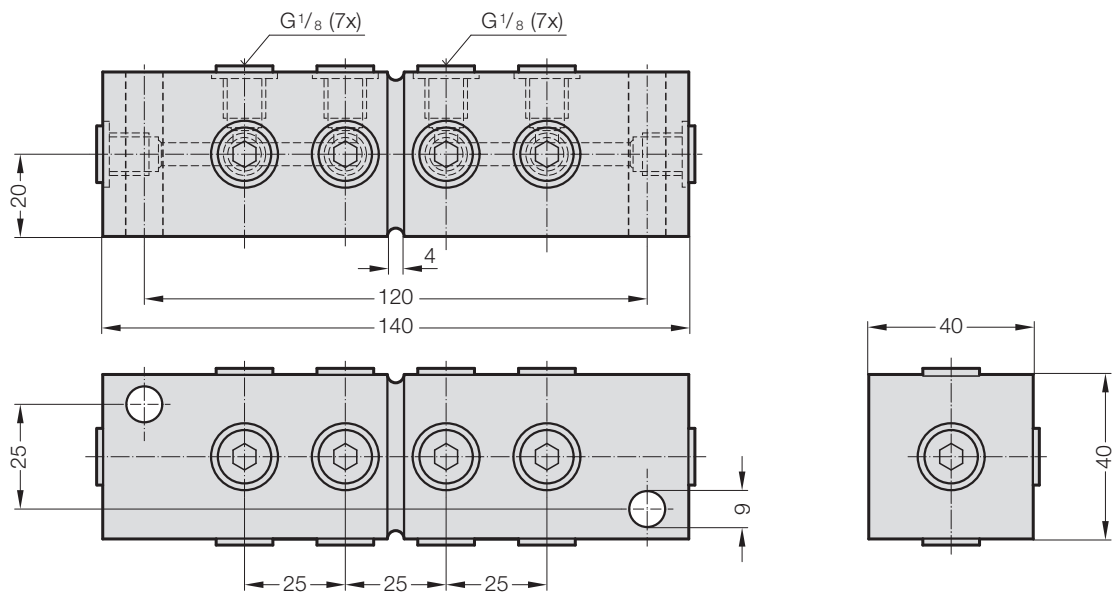
2480.00.24.33

Distributor G1/8, 14 ports



2489.00.24.33.01

Distributor G1/8, 2x7 ports

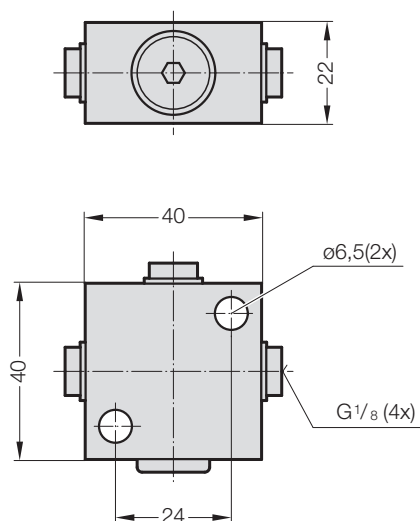


CONTROLLABLE GAS SPRINGS

DISTRIBUTOR BLOCK

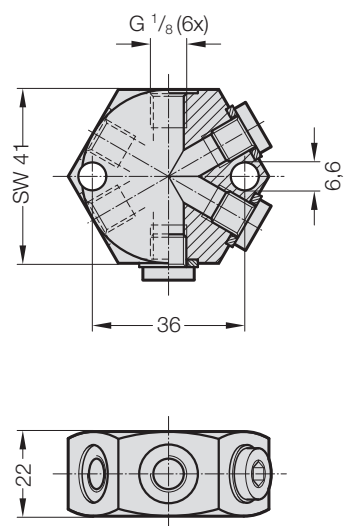
2480.00.24.34

Distributor block G1/8, 4 ports



2480.00.24.31

Distributor block G1/8, 6 ports

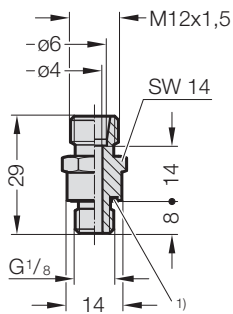


CONTROLLABLE GAS SPRINGS

24°-CONE THREADED JOINTS (DIN 2353/DIN EN ISO 8434-1)

2480.00.26.03

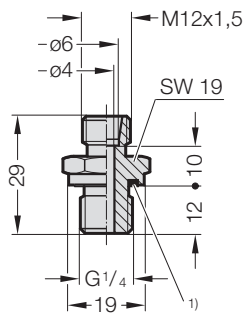
Screw connection GE-24°
conus, DN5 G1/8



1) Eolastic-Seal ED

2480.00.26.04

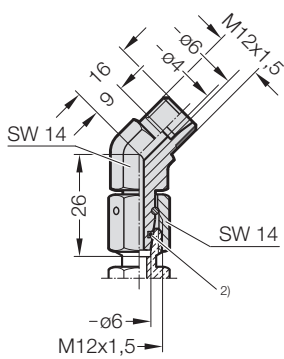
Screw connection GE-24°
conus, DN5 G1/4



1) Eolastic-Seal ED

2480.00.26.21

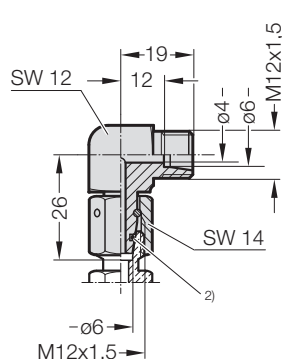
Screw connection 45°-24°
conus, DN5, adjustable



2) O-ring

2480.00.26.22

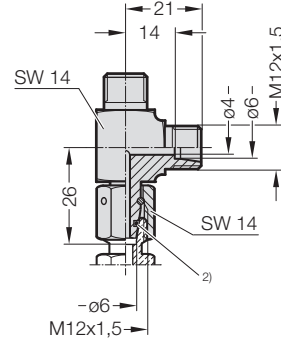
Screw connection 90°-24°
conus, DN5, adjustable



2) O-ring

2480.00.26.23

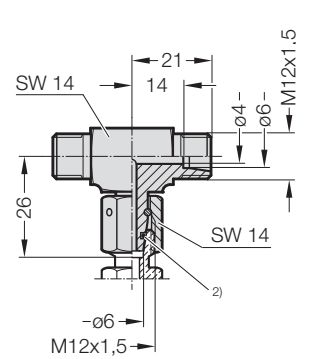
Screw connection L-24°
conus, DN5, adjustable



2) O-ring

2480.00.26.24

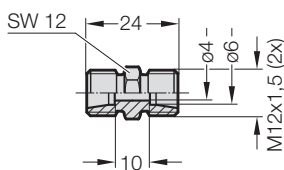
Screw connection T-24°
conus, DN5, adjustable



2) O-ring

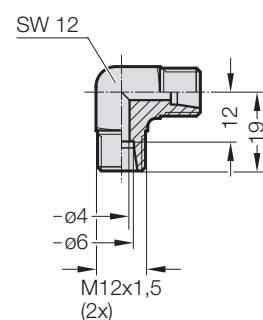
2480.00.26.25

Adapter GE-24° conus,
hose - hose, DN5



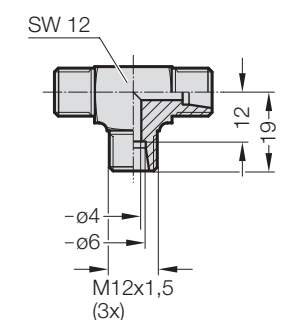
2480.00.26.26

Adapter 90°-24° conus,
hose - hose, DN5



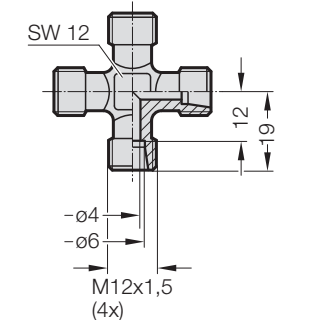
2480.00.26.27

Adapter T-24° conus, hose
- hose, DN5



2480.00.26.28

Adapter K-24° conus, hose
- hose, DN5

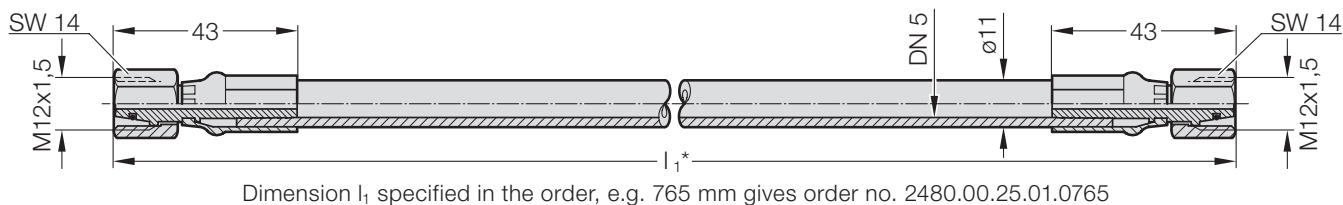


CONTROLLABLE GAS SPRINGS

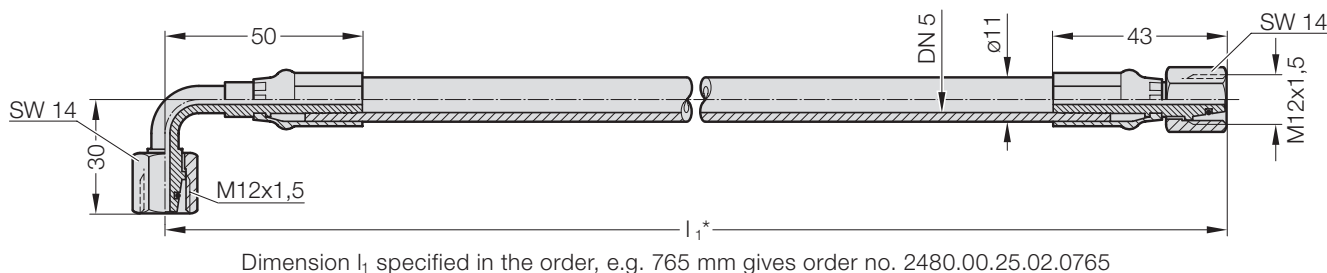
24°-CONE CONNECTION HOSES

(DIN 2353/DIN EN ISO 8434-1)

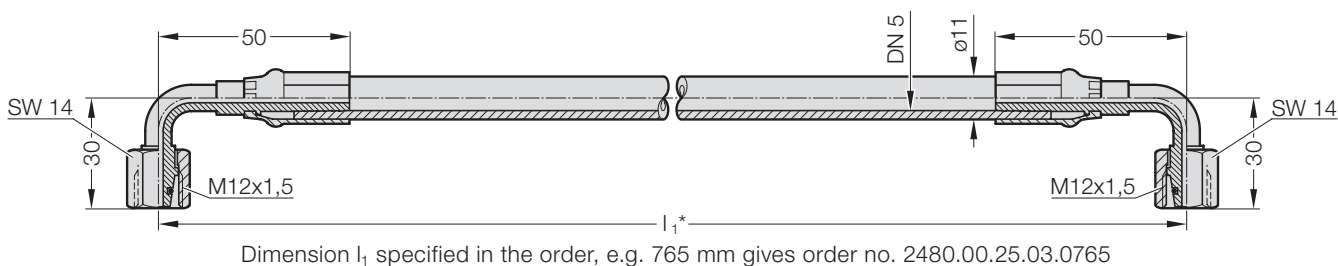
2480.00.25.01. Hose – conical seals with union nuts and O-Ring (straight/straight)



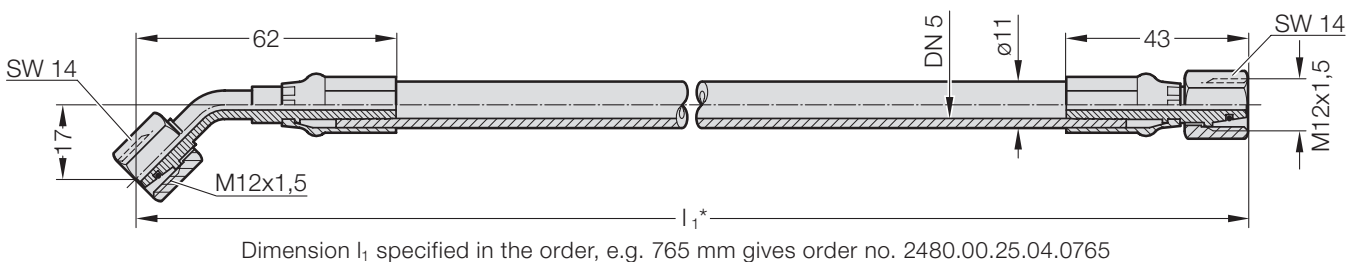
2480.00.25.02. Hose – conical seals with union nuts an O-Ring (90° bend/straight)



2480.00.25.03. Hose – conical seals with union nuts and O-Ring (90° bend/both ends)



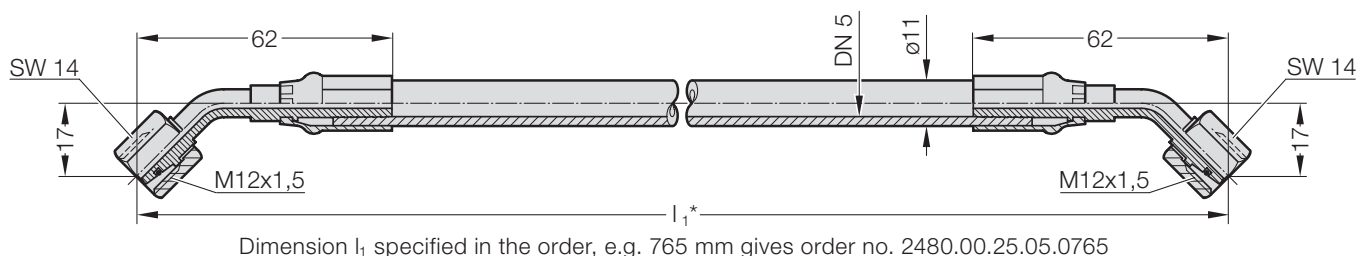
2480.00.25.04. Hose – conical seals with union nuts and O-Ring (45° bend/straight)



CONTROLLABLE GAS SPRINGS 24°-CONE CONNECTION HOSES (DIN 2353/DIN EN ISO 8434-1)

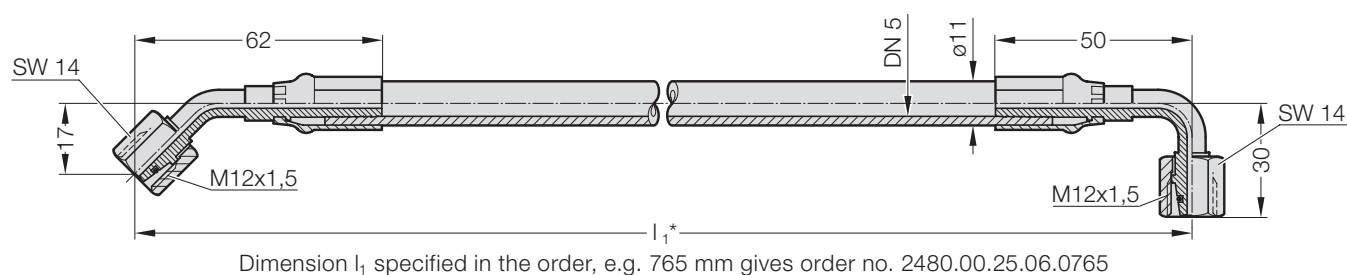
2480.00.25.05.

Hose – conical seals with union nuts and O-Ring (45° bend/both ends)



2480.00.25.06.

Hose – conical seals with union nuts and O-Ring (45° bend/ 90° bend)



ORDER EXAMPLE:

Shortest factory length: 140 mm

Minimum bending radius: R40

*24°-cone connection hoses available in the following

lengths:

5 mm step range ≤ 1000 mm

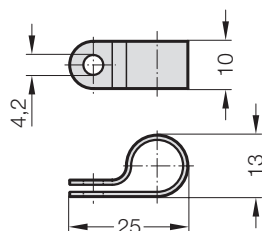
10 mm step range > 1000 mm

100 mm step range > 4000 mm

500 mm step range > 6000 mm

2480.00.25.12.01

Hose clamp
for gauging hose
DN5 (Ø 11 mm)



MATERIAL:

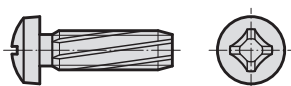
Polyamide

NOTE:

Supplied without screws

2192.50.04.012

Self-tapping screw
DIN 7516 - M4x12



NOTE:

self-tapping
Diameter of hole for
self-tapping screw = 3.6
mm

2480.00.23.13.

Anti-scuff spiral
for subsequent installation over hoses and tubing



MATERIAL:

Polyamide

DESCRIPTION:

The anti-scuff spiral is used to protect against abrasion, is resistant to air, water, oil, hydraulic fluids petrol and other liquids..

Inner ø	7 mm
For hose external ø	max. 5-11 mm
Temperature range	-30°C up to +100°C

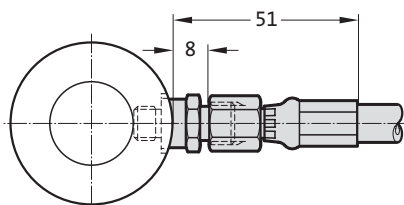
Order No.	l [m]
2480.00.23.13.0001	1
2480.00.23.13.0002	2
2480.00.23.13.0005	5
2480.00.23.13.0010	10

CONTROLLABLE GAS SPRINGS

DIRECT CONNECTION DIMENSIONS 24°-CONE THREADED JOINTS

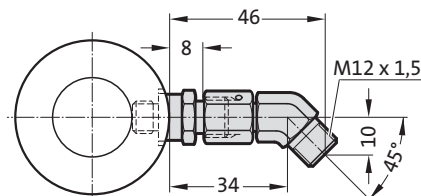
DIRECT CONNECTION

hose straight with adaptor 2480.00.26.03



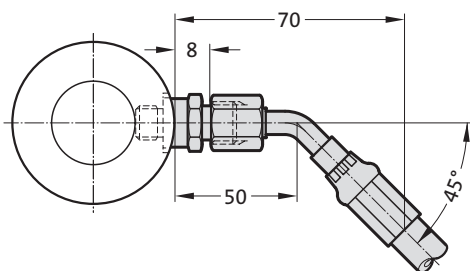
DIRECT CONNECTION

with elbow adaptor 45° 2480.00.26.21



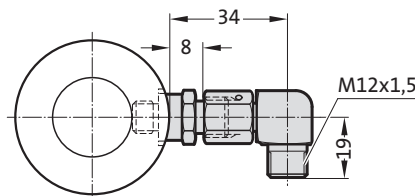
DIRECT CONNECTION

45° hose with adaptor 2480.00.26.03



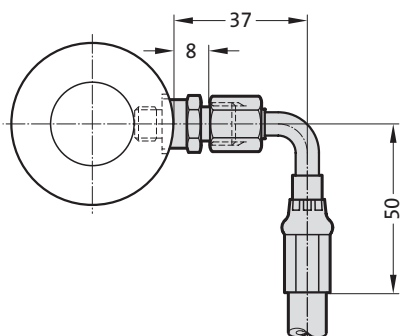
DIRECT CONNECTION

with elbow adaptor 90° 2480.00.26.22



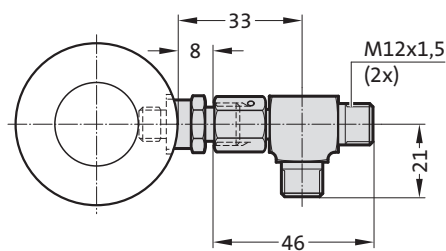
DIRECT CONNECTION

90° hose with adaptor 2480.00.26.03



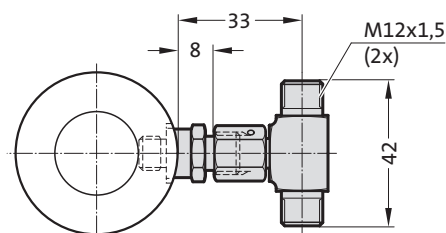
DIRECT CONNECTION

with L-coupling 2480.00.26.23



DIRECT CONNECTION

with T-coupling 2480.00.26.24



CONTROLLABLE GAS SPRINGS **MONITORING PROCESS SAFETY**



180°



CONTROLLABLE GAS SPRINGS

PROCESS SAFETY

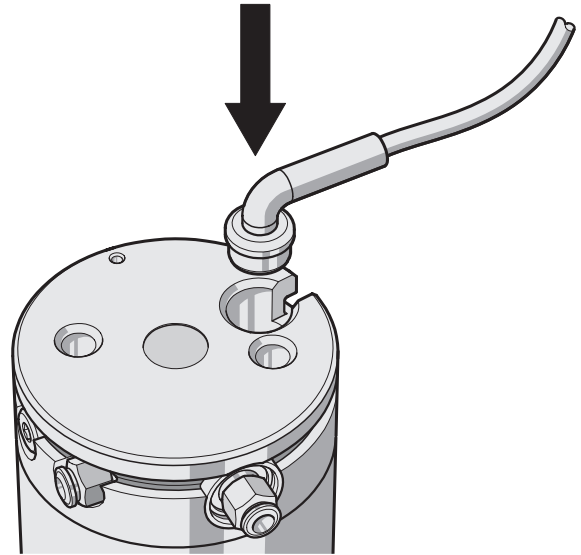
OVERHEATING PROTECTION

To protect against superheating, a thermal relay (bimetal) should be used to stop the power press or prevent the KF gas springs from being blocked. If the gas spring temperature exceeds a value of 80°C, the thermal relay opens. The thermal relay automatically closes again when the temperature falls below this limit value. Operating the gas spring at higher normal temperatures will significantly shorten its service life.

In a gas spring system without cooling it is sufficient to fit one gas spring with a thermostatic relay.

The thermostatic relay is supplied with the active gas spring (KF). In a cooled gas spring system each spring must have a thermostatic relay. The thermostatic relays must then be switched sequentially.

When using a gas cooling system, the thermal relay is installed in the gas cooler.

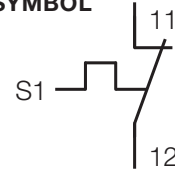


The thermostatic relay is a push fit in the base of the gas spring.

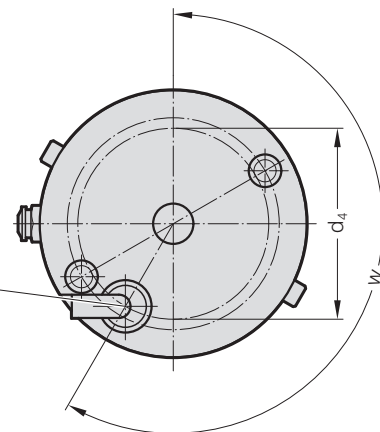
TECHNICAL DATA:

Initial position	closed
Trigger temperature	83 ±3 °C
Hysteresis	< 7 °C
Maximum voltage	110 V ~
Supplied with a 1500 mm electrical cable.	

CONNECTION SYMBOL



Position of the thermostatic relay

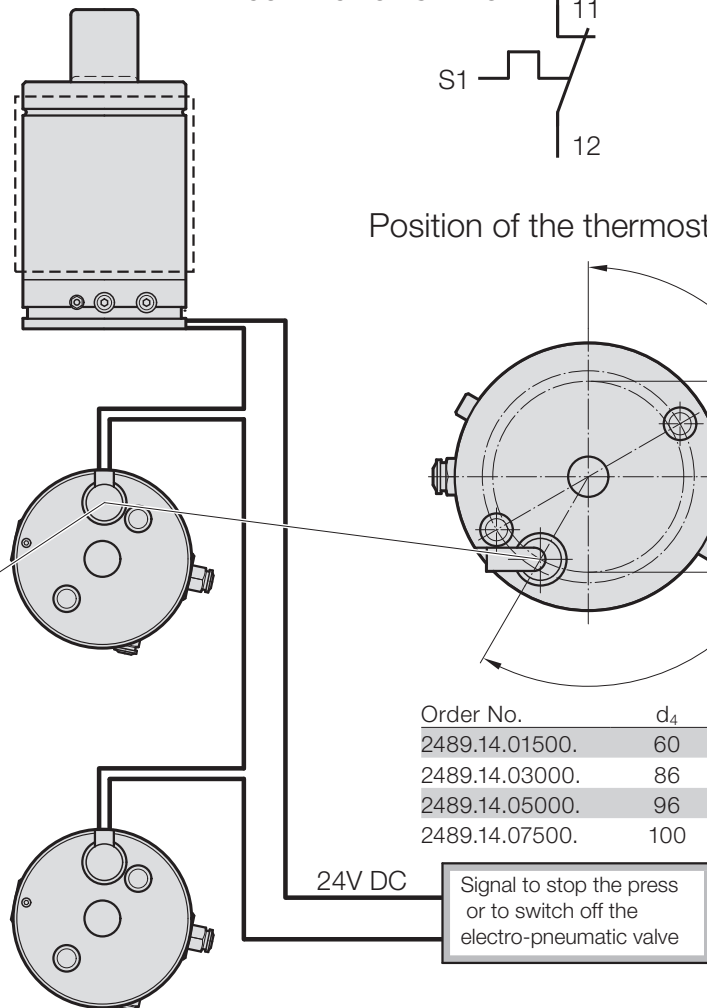
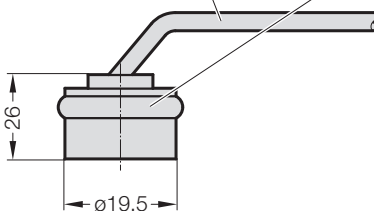


Order No.	d ₄	w
2489.14.01500.	60	170°
2489.14.03000.	86	210°
2489.14.05000.	96	305°
2489.14.07500.	100	305°

THERMOSTATIC RELAY 2489.00.70

(Order No. for repeat-order)

Electric cable

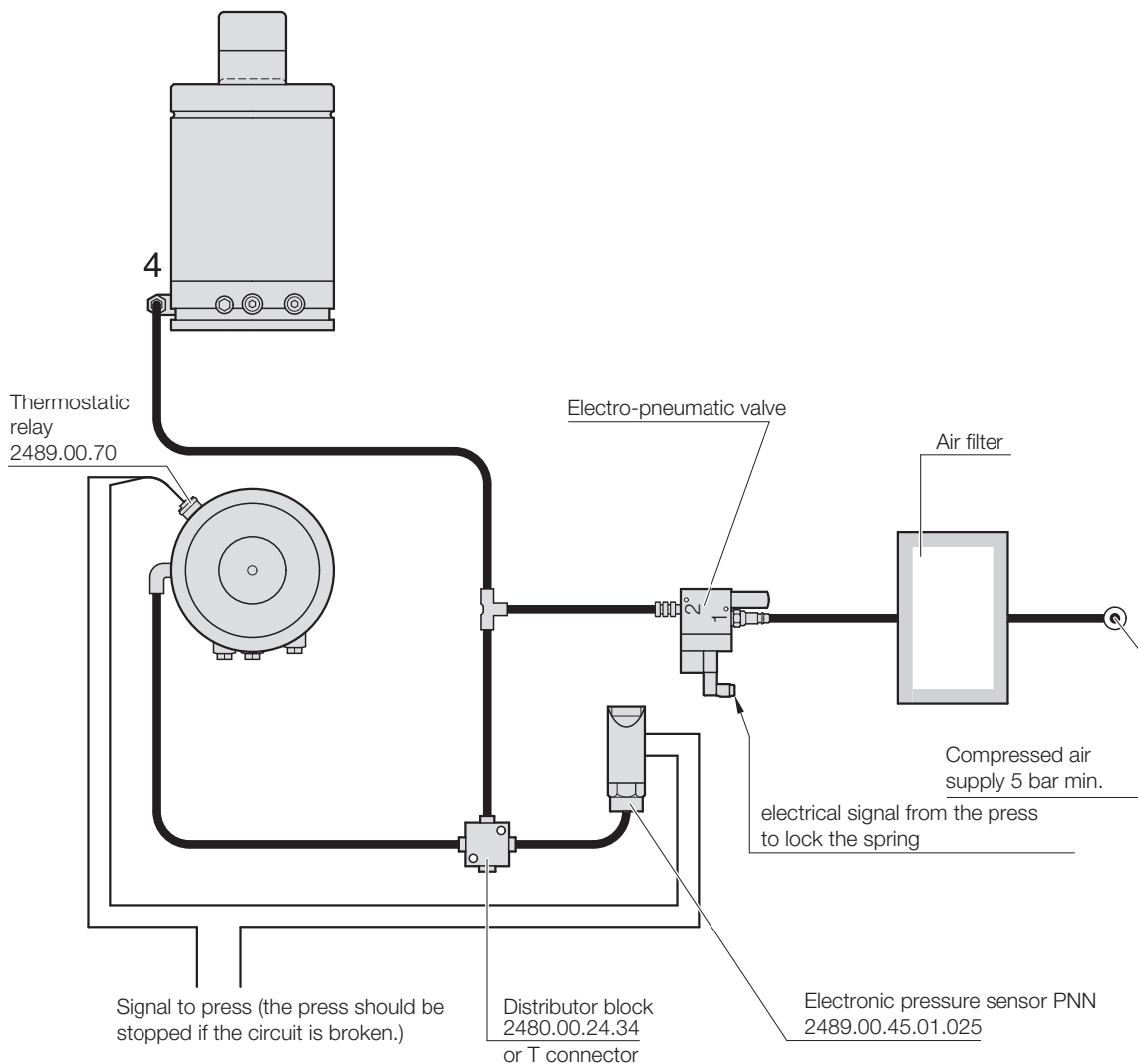


CONTROLLABLE GAS SPRINGS

PROCESS SAFETY

MONITORING AIR PRESSURE

A pressure sensor can be used to ensure that gas springs receive the locking signal. If the pressure sensor is linked to the compressed air supply at port 4 of the gas springs, the press can be stopped if the KF gas springs have not received the locking signal or the control pressure is too high or too low.



CONTROLLABLE GAS SPRINGS

PROCESS SAFETY

MECHANICAL CONTROL SYSTEM

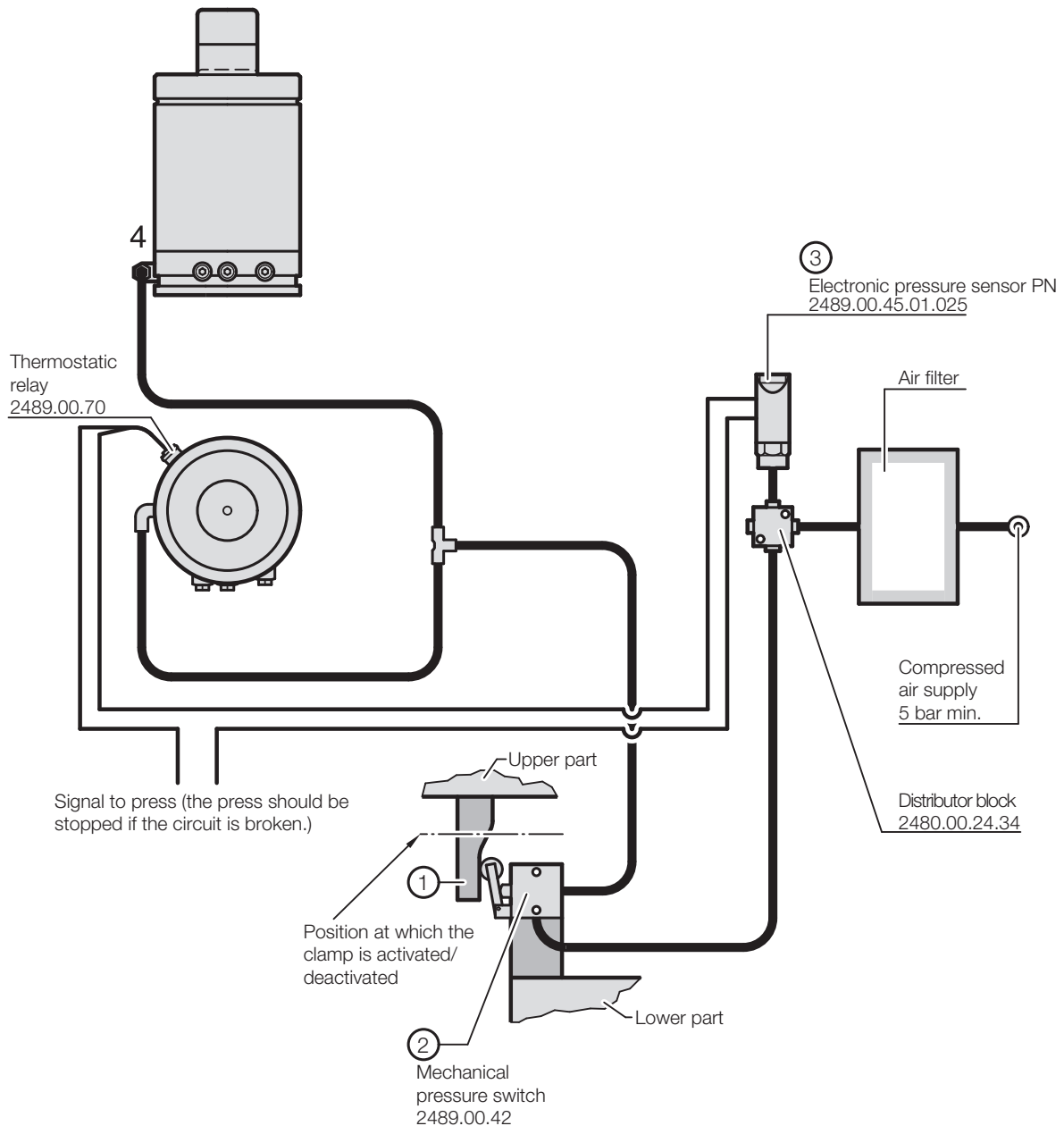
This system does not require a control signal from the press. The locking function control is integrated completely in the tool. The KF gas springs remain locked as long as the mechanical pressure switch (2) is activated by the tool (1).

A pressure sensor is included to ensure that the compressed air supply is working. The pressure sensor (3) should be connected in series with the thermostatic relay in the gas spring(s).

PLEASE NOTE:



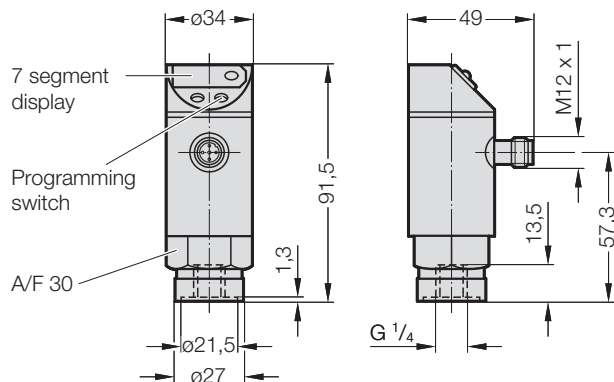
Up to 6 KF gas springs or valve blocks can be controlled with one mechanical pressure switch. The mechanical pressure switch requires a continuous supply of filtered compressed air at a pressure of at least 5 bar.



CONTROLLABLE GAS SPRINGS PRESSURE SENSOR AND ACCESSORIES

2489.00.45.01.025

Electronic pressure sensor PN

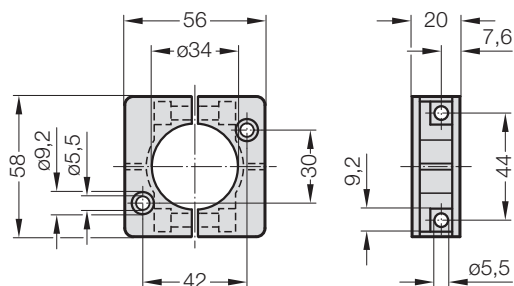


TECHNICAL DATA:

Measuring range	0...25 bar
Permitted overload pressure	100 bar
Setting range:	
Switching point sP1	1,25...25 bar
Release point rP1	0,75...24,5 bar
Switching increments	0,25 bar
Protection type	IP 65
Repeat accuracy	< ± 1,0%
Ambient temperature	- 25°C...+ 80°C
Operating voltage [V]	18...30 DC

2489.00.45.01.01

Mounting for pressure sensor 2489.00.45.01.025

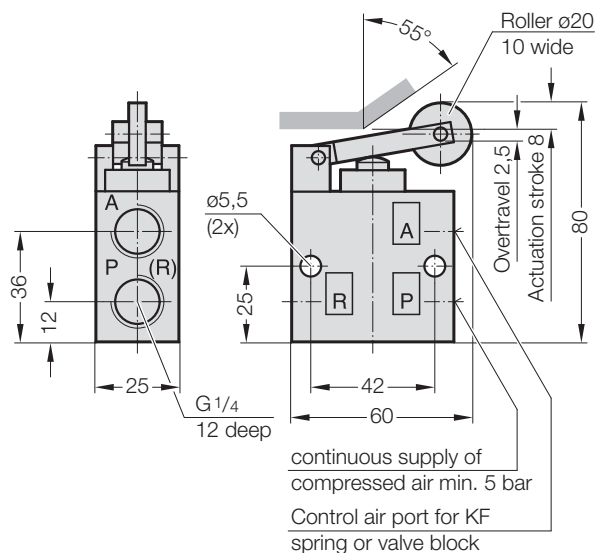


CONTROLLABLE GAS SPRINGS

PRESSURE SWITCHES ET ACCESSORIES

2489.00.42

Pressure switch



TECHNICAL DATA:

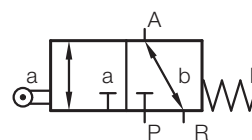
Aluminium casing

Min. permitted pressure pe 0 bar

Rated pressure pe 10 bar

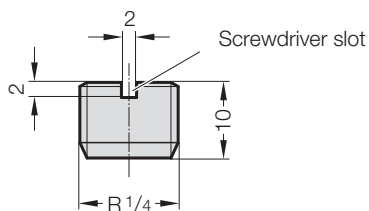
Ambient temperature 80 °C

PRESSURE SWITCH WITH SENSING ROLLER 3/2 WAY VALVE NG 6 (G 1/4) MECHANICAL




2489.00.42.01

Muffler for pressure switch



CONTROLLABLE GAS SPRINGS ID PLATE

We recommend that the ID plate should be mounted in an easily visible position on the tool when controllable gas springs are incorporated.

Controllable gas spring systems					
Tool no.				The following must be checked before the start of production or after a fault: <ol style="list-style-type: none"> 1. Filling pressure of the gas spring 2. Compressed air pressure 3. Compressed air signal or electrical signal from the press 4. Temperature of gas spring (max. 70 °C) 	
Number of active KF gas springs		pcs.			
max. KF spring force		daN			
Stroke KF		mm			
Number of KP passive gas springs					
Size KP					
Stroke length used					
max. stroke rate		Strokes/min			
Filling pressure - active gas springs KF	min.	bar	max. bar		
Pressure of filtered compressed air	min.	5 bar	max. 10 bar		
Attention! NEVER WORK INSIDE THE TOOL WHEN THE GAS SPRING IS LOCKED					
Note: - The thermostatic relay must be in use.					
FIBRO GmbH · Business Area Standard Parts · D-74855 Hassmersheim · August-Läpple-Weg · T+49 6266 73-0* · Made in Germany					

DIN dimension: 105 x 210 mm, holes-Ø 3,6 mm, hole pitch 85/190 mm

ORDER NUMBER:

ID plate = 2489.00.110.150.1

To be affixed to all machines wich incorporate KF gas springs.

CONTROLLABLE GAS SPRINGS **COOLING SYSTEM**

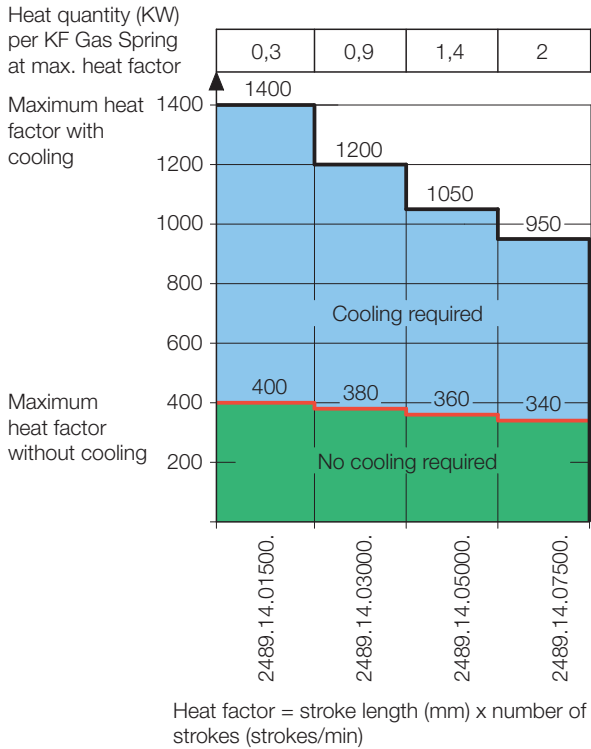


180°



CONTROLLABLE GAS SPRINGS

COOLING SYSTEM



COOLING SYSTEM

In every cycle energy is transferred from the press to the gas cylinder. This energy is converted into heat on the gas spring return stroke after locking.

The heat factor is calculated by multiplying the stroke rate by the stroke length of the gas spring. The gas spring requires cooling if the heat factor for a specific gas spring exceeds the values shown in the diagram.

EXAMPLE:

Let us take a gas spring KF 2489.14.03000.060 with a stroke of 60 mm. The number of strokes is 8 strokes per minute. The heat factor is:

$$\text{Stroke length} \times \text{Stroke rate} = 60 \times 8 = 480.$$

As can be seen from the diagram below, cooling is required when the heat factor exceeds 380, so cooling is necessary for this KF 2489.14.03000.060.

METHOD FOR REDUCING THE COOLING REQUIREMENT

The cooling requirement reduces in the case of a larger gas spring operating at a lower pressure.

The example above could for example be resolved in this way: We can use the next larger gas spring KF 2489.14.05000. instead of the KF 2489.14.03000.

The pressure in the KF 2489.14.05000. is reduced to bring the gas spring force down from 5000 daN to 3000 daN.

The new filling pressure is $3000/5000 \times 150 \text{ bar} = 90 \text{ bar}$.

The cooling requirement for the 5000 gas spring reduces by the same proportion as the filling pressure.

$$\text{Heat factor} = 60 \times 8 \times 3000/5000 = 288$$

The heat factor is under 360, the maximum for the 5000 gas spring, so no cooling is required.

CONTROLLABLE GAS SPRINGS COOLING SYSTEM

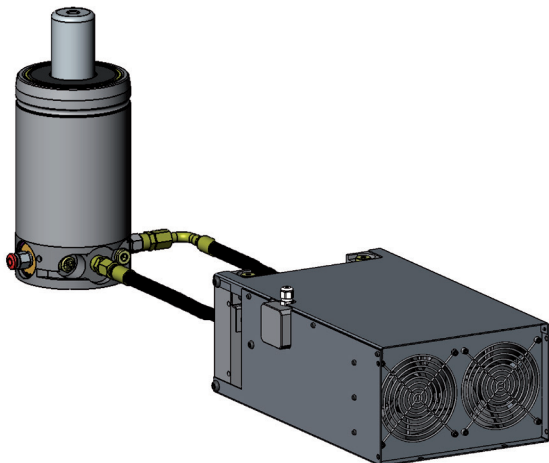
The table below compares the different cooling versions.

Opt.	Advantages	Difficulties
1	+ No additional hoses required	- Risk of overheating
2	+ Cooling integrated in the tool + Up to 4 active gas springs can be used	- 60% slower return stroke speed
3	+ Can be used for several active gas springs + High cooling capacity (up to 25 kW)	- External cooling unit required



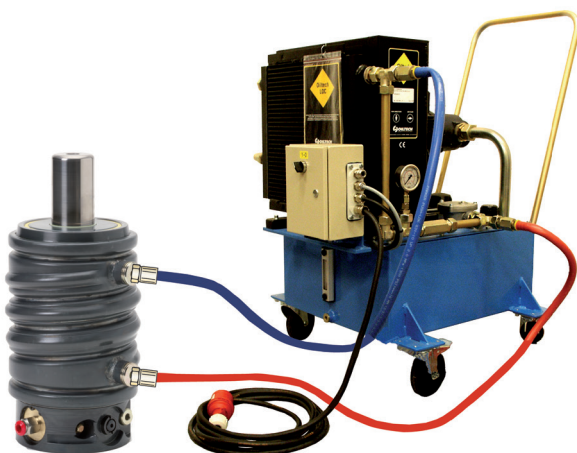
1. ACTIVE GAS SPRINGS 2489.14. WITHOUT COOLING

Controllable gas springs can be operated autonomously or combined like standard gas springs. The stroke of the active spring 2489.14 can be adjusted. Very easy installation in the tool. For applications with a short stroke length or low stroke frequency.



2. ACTIVE GAS SPRINGS 2489.14. ...N WITH GAS COOLER 2489.00.20.15

Gas coolers 2489.00.20.15 can optimally be used where a few active gas springs are operated at a higher production rate (longer stroke length and/or higher stroke frequency) or where not sufficient space for an external liquid cooling system is available.



3. ACTIVE GAS SPRINGS 2489.14. ...K WITH LIQUID COOLING SYSTEM 2489.00.50.

For applications with several active gas springs at a high production rate (longer stroke length and/or higher stroke frequency). 10 kW and 25 kW cooling systems are available depending on the required cooling capacity.

CONTROLLABLE GAS SPRINGS

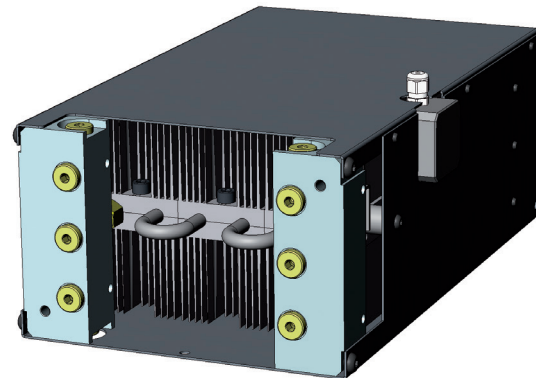
GAS COOLER

Gas coolers have been developed for integrating the cooling of active gas springs in the tool for high production rates.

The gas cooler has a very compact design and a cooling capacity of 1.5 kW. Up to 4 active gas springs can be cooled per gas cooler.

For connecting a gas cooler to the active gas springs, the mounted standard cartridge valve must initially be replaced by a special cartridge valve provided with an additional gas connection.

Active gas springs 2489.14. with article numbers ending with "...N" can be ordered with a factory-mounted special cartridge valve. Alternatively, existing springs can easily be refitted with conversion kit 2489.14.1001. .N.



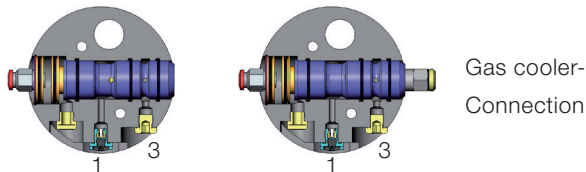
Gas cooler
Order No. 2489.00.20.15

ORDER EXAMPLE FOR ACTIVE GAS SPRINGS WITH GAS COOLER CONNECTION:

2489.14.xxxxx.xxx.xxx N

Initial spring force: Gas cooler
 Set stroke length
 Nominal stroke length
 1500 daN
 3000 daN
 5000 daN
 7500 daN

CARTRIDGE VALVE DESIGN



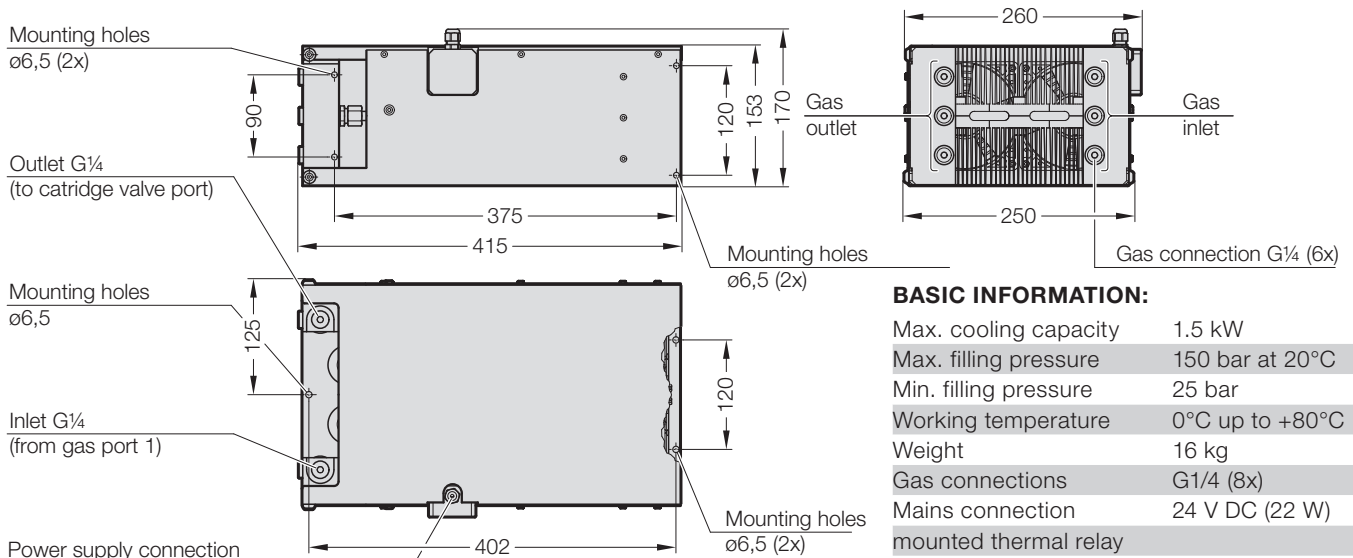
Cartridge valve Standard 2489.14.1001 Cartridge valve Gas cooling 2489.14.1001. .N

ORDER EXAMPLE FOR THE GAS COOLING CONVERSION KIT

Gas cooling conversion kit	for gas spring
2489.14.1001.015.N	2489.14.01500.
2489.14.1001.030.N	2489.14.03000.
2489.14.1001.050.N	2489.14.05000.
2489.14.1001.075.N	2489.14.07500.

DIMENSIONS

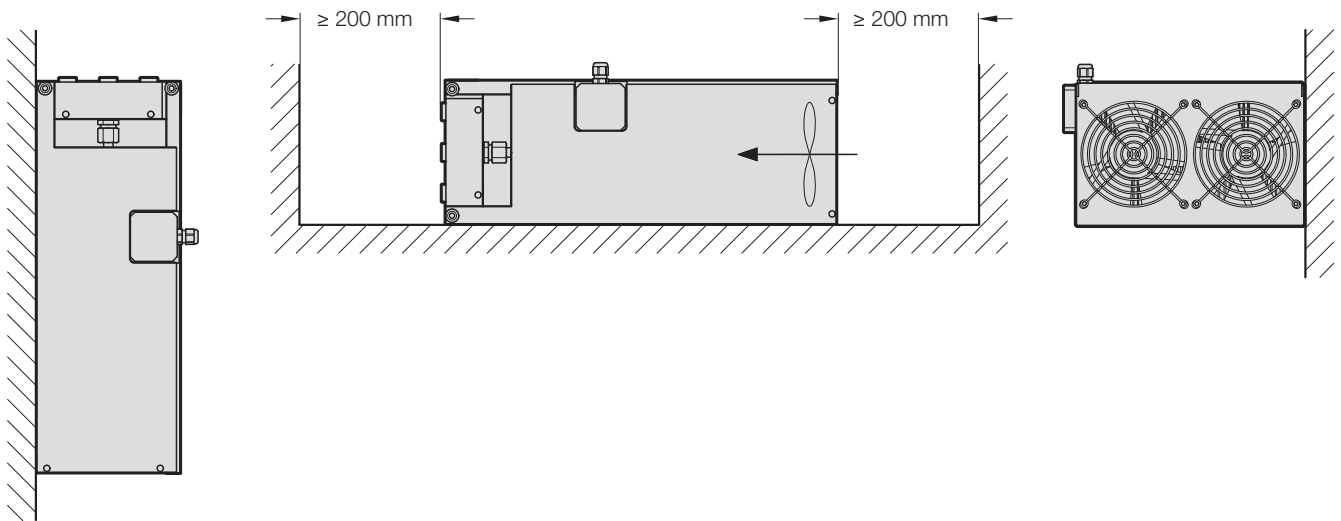
The gas cooler 2489.00.20.15 is operated at 24 Volt DC (22 W). It can be installed both vertically and horizontally in or outside the tool. The gas cooler 2489.00.20.15 has been approved according to protection class IP 64 and does not have to be removed when the tool is cleaned.



CONTROLLABLE GAS SPRINGS GAS COOLER

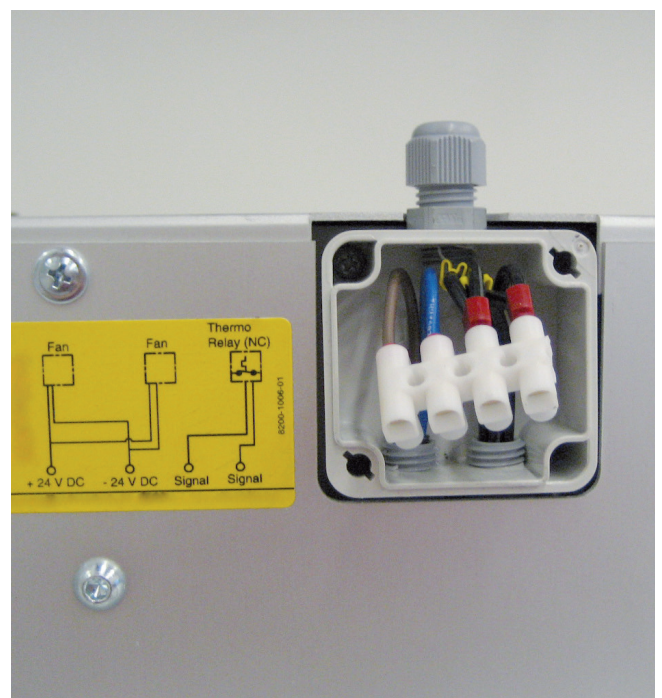
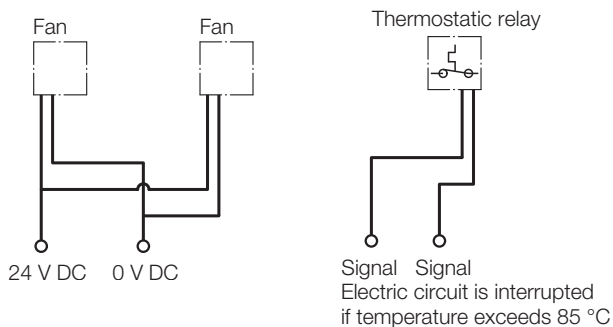
INSTALLATION OPTIONS

The gas cooler can be installed both vertically and horizontally. During installation, make sure NOT to obstruct air circulation to the gas cooler. Reduced air supply to the ventilator will reduce performance.



ELECTRICAL CONNECTION PORT

Below is the connection diagram of the gas cooler. The connection diagram is also attached on the side next to the electrical connection box. The gas cooler includes a mounted thermal relay. When a temperature of 85 °C ($\pm 5\%$) is exceeded, the thermal relay will interrupt the electric circuit. To prevent overheating of the controllable gas springs, the thermal relay should be connected to the press control.



CONTROLLABLE GAS SPRINGS

GAS COOLER

GAS COOLER PERFORMANCE DATA

Depending on the heat that is generated by the gas springs in the tool, up to four gas springs can be connected to one gas cooler. The following diagrams show the max. number of strokes/min. for the use of 1, 2, 3 or 4 active gas springs 2489.14. ...N for a filling pressure of 150 bar (connected to a gas cooler). The four curves show the upper limit value of a thermal output of 1.5 kW of the gas cooler for the respectively connected number of springs. Each diagram serves for selecting the number of active springs 2489.14. ...N to be connected to a gas cooler. The curve may not be exceeded for each stroke length specified, depending on the strokes/min.

NOTE:

When using the gas cooler, the return stroke speed of the piston rod changes as follows:

2489.14.01500. ...N	approx. 0,08 m/s
2489.14.03000. ...N	approx. 0,08 m/s
2489.14.05000. ...N	approx. 0,04 – 0,05 m/s
2489.14.07500. ...N	approx. 0,03 – 0,08 m/s

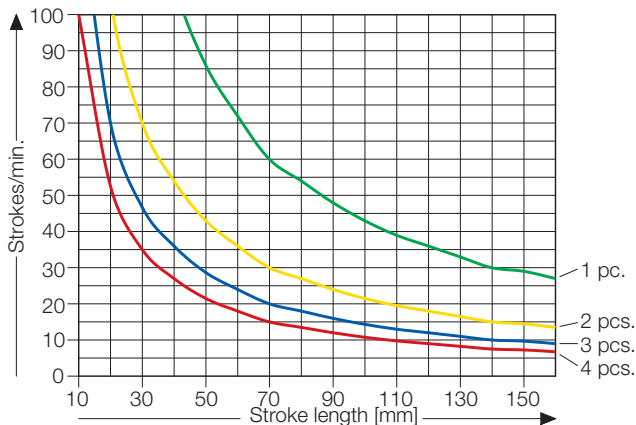
The piston rod return stroke speeds depend on the filling pressure.

ATTENTION:

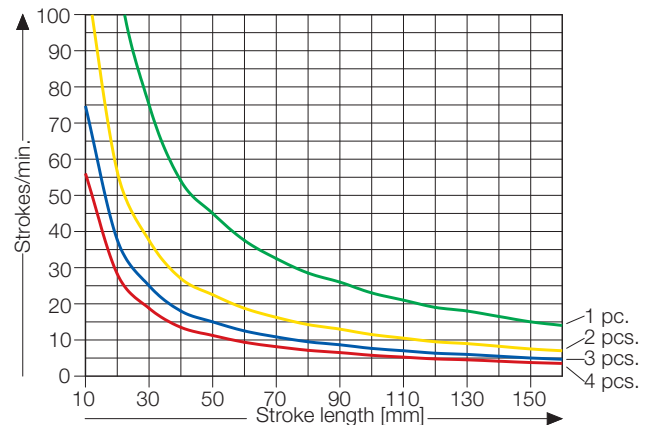


**The piston rod return stroke speeds apply to cooling hose lengths up to 1.5 m.
Longer cooling hose lengths slow down the piston rod return stroke.**

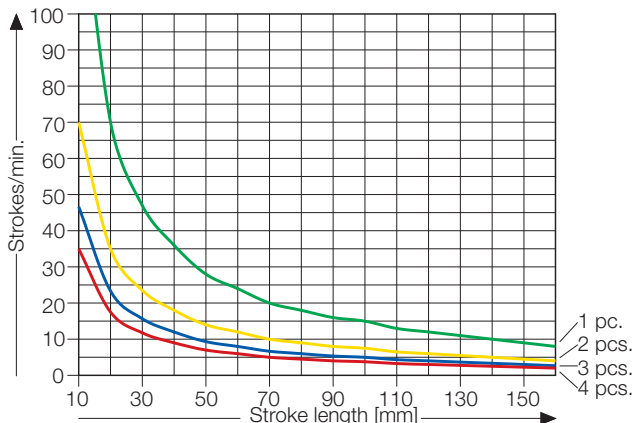
2489.14.01500.



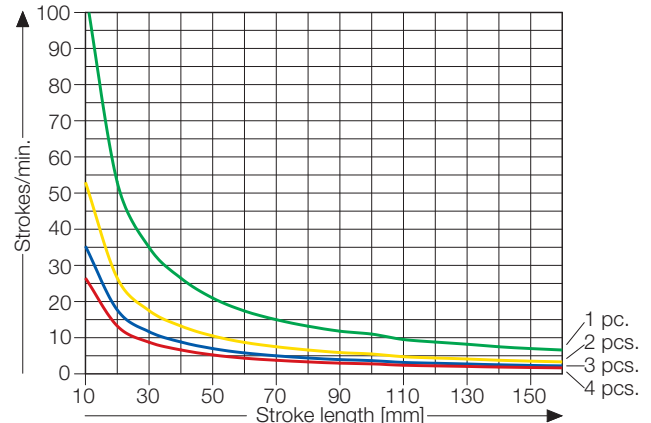
2489.14.03000.



2489.14.05000.



2489.14.07500.



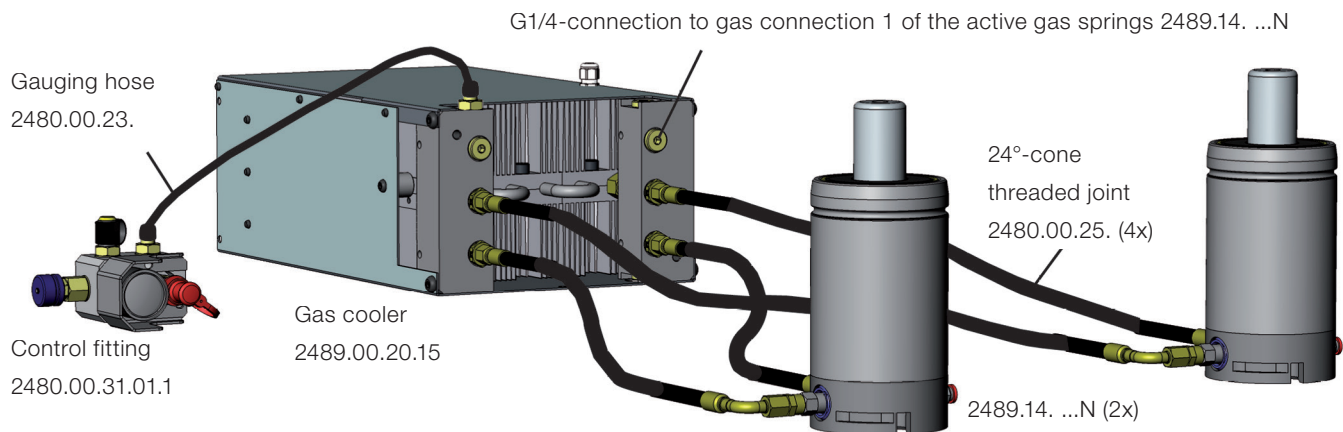
CONTROLLABLE GAS SPRINGS GAS COOLER

CONNECTION EXAMPLES

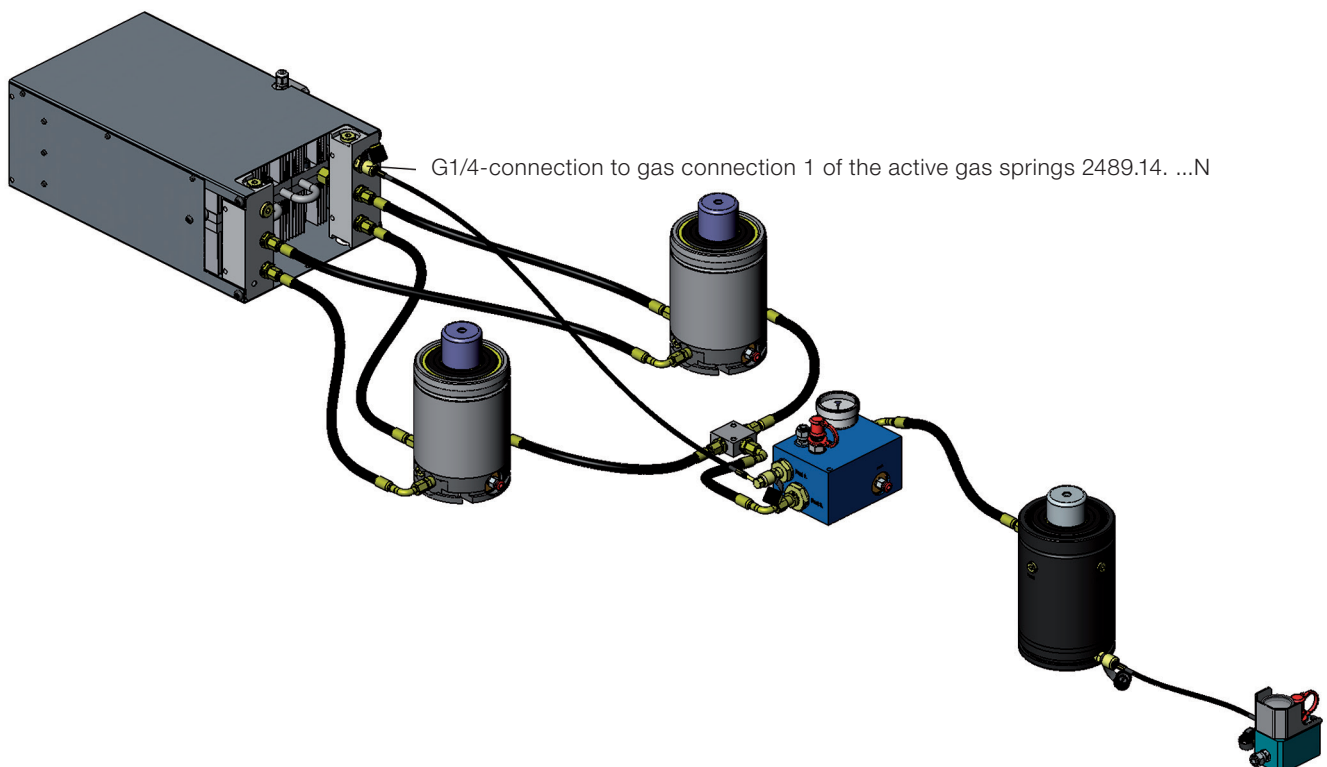
The active gas springs 2489.14. ...N are provided with an additional connection for the gas cooler.
This connection is attached to one of the output connections of the gas cooler.

ATTENTION!

The active gas springs 2489.14. ...N must be connected in parallel to the gas cooler:



Gas cooler 2489.00.20.15 can also be used with a KF + KP system.
The picture shows the connection for a KF + KP system.



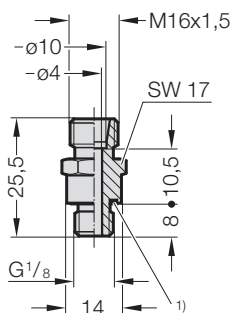
CONTROLLABLE GAS SPRINGS

GAS COOLING

24°-CONE THREADED JOINTS (DN10) (DIN 2353/DIN EN ISO 8434-1)

2480.00.26.03.10

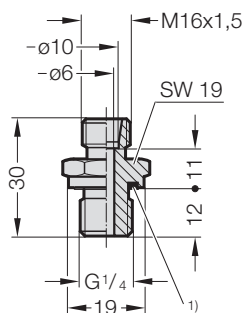
Screw connection GE-24°
conus, DN10 G1/8



1) Eolastic-Seal ED

2480.00.26.04.10

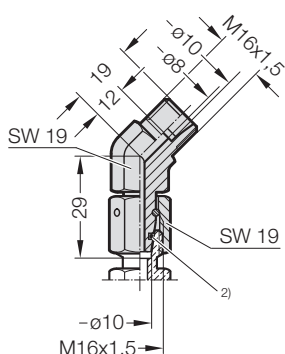
Screw connection GE-24°
conus, DN10 G1/4



1) Eolastic-Seal ED

2480.00.26.21.10

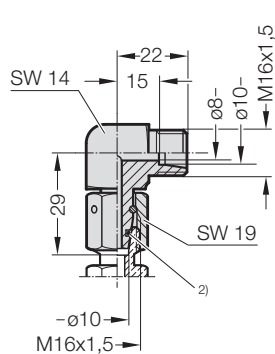
Screw connection 45°-24°
conus, DN10, adjustable



2) O-ring

2480.00.26.22.10

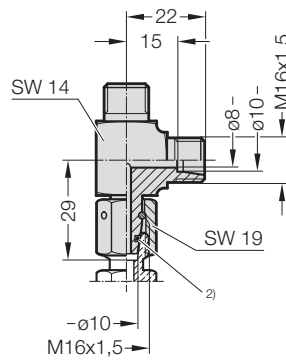
Screw connection 90°-24°
conus, DN10, adjustable



2) O-ring

2480.00.26.23.10

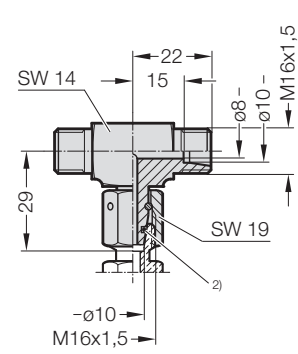
Screw connection L-24°
conus, DN10, adjustable



2) O-ring

2480.00.26.24.10

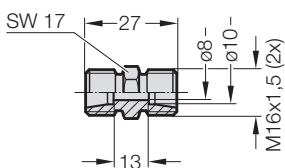
Screw connection T-24°
conus, DN10, adjustable



2) O-ring

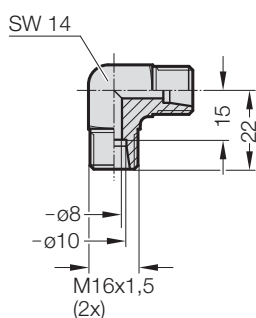
2480.00.26.25.10

Adapter GE-24° conus,
hose - hose, DN10



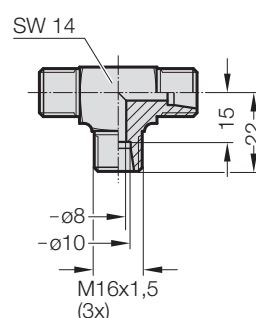
2480.00.26.26.10

Adapter 90°-24° conus,
hose - hose, DN10



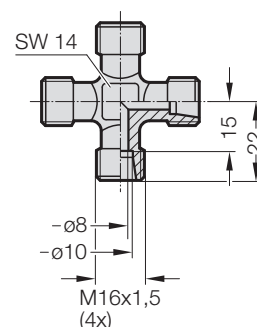
2480.00.26.27.10

Adapter T-24° conus, hose
- hose, DN10



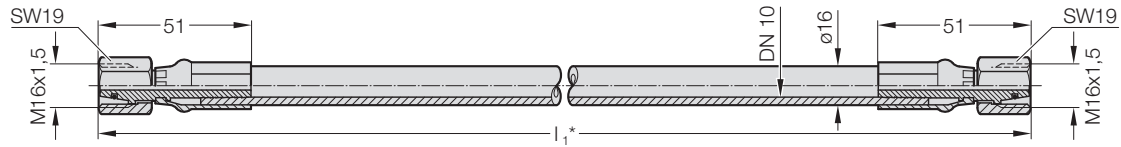
2480.00.26.28.10

Adapter K-24° conus, hose
- hose, DN10



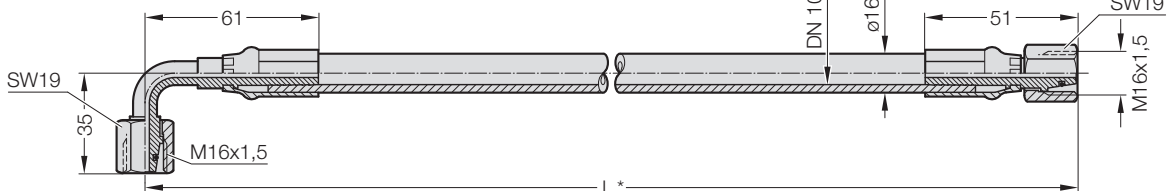
CONTROLLABLE GAS SPRINGS GAS COOLING 24°-CONE CONNECTION HOSES (DN10) (DIN 2353/DIN EN ISO 8434-1)

2480.00.25.01.10. CONNECTING HOSE DN10 WITH 24° CONE, STRAIGHT/STRAIGHT - SEAL CONES WITH UNION NUTS AND O-RING shortest factory lengths: 150 mm
Minimum bending radius R64 mm



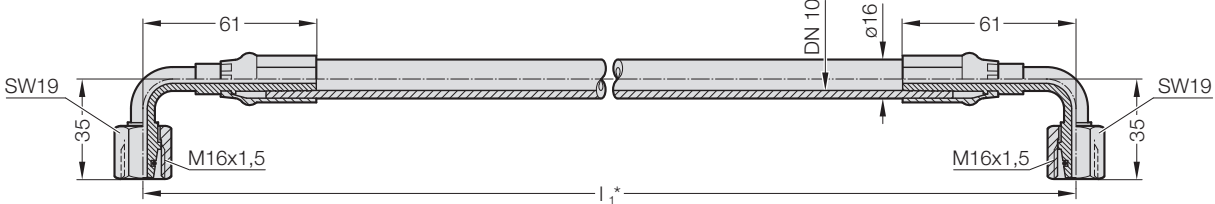
Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.01.10.0760

2480.00.25.02.10. CONNECTING HOSE DN10 WITH 24° CONE, STRAIGHT/90° - SEAL CONES WITH UNION NUTS AND O-RING



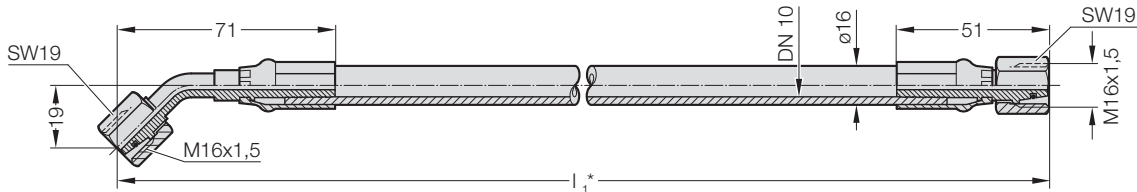
Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.02.10.0760

2480.00.25.03.10. CONNECTING HOSE DN10 WITH 24° CONE, 90°/90° - SEAL CONES WITH UNION NUTS AND O-RING



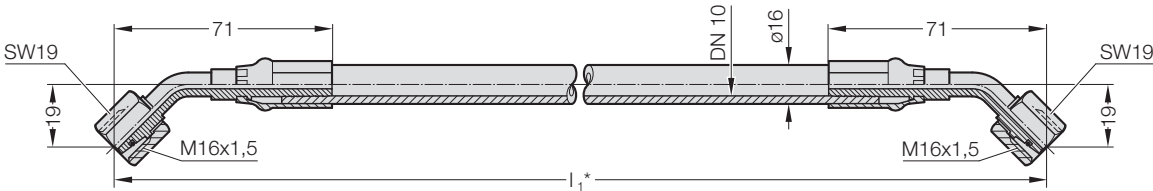
Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.03.10.0760

2480.00.25.04.10. CONNECTING HOSE DN10 WITH 24° CONE, STRAIGHT/45° - SEAL CONES WITH UNION NUTS AND O-RING



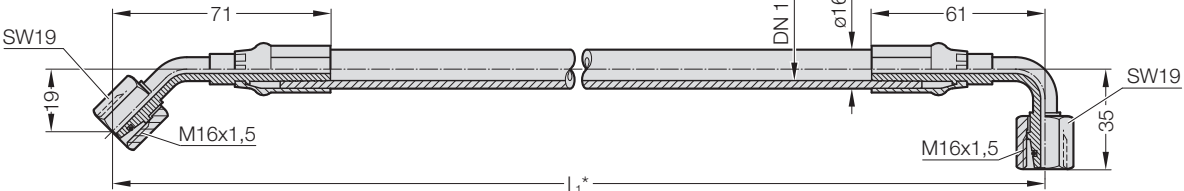
Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.04.10.0760

2480.00.25.05.10. CONNECTING HOSE DN10 WITH 24° CONE, 45°/45° - SEAL CONES WITH UNION NUTS AND O-RING



Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.06.10.0760

2480.00.25.06.10. CONNECTING HOSE DN10 WITH 24° CONE, 45°/90° - SEAL CONES WITH UNION NUTS AND O-RING



Dimension l1 specified in the order (Gradation: 10 mm; l1 > 1500 mm: 50 mm), e.g. 760 mm, gives order no. 2480.00.25.06.10.0760

CONTROLLABLE GAS SPRINGS

LIQUID COOLING

COOLING UNIT FOR CONTROLLABLE GAS SPRINGS

2489.00.50.10 COOLING UNIT FOR CONTROLLABLE GAS SPRINGS, KF (10KW)

Dimensions	H	=	1000
	L	=	900
	B	=	700
Circulation rate		=	40 l/min
Tank capacity (Filling amount)		=	ca. 60 l
Electric motor		=	1,5 kW
Supply voltage		=	380 V AC
Weight		=	170 kg

2489.00.50.25 COOLING UNIT FOR CONTROLLABLE GAS SPRINGS, KF (25KW)

Dimensions	H	=	1070
	L	=	1070
	B	=	890
Circulation rate		=	60 l/min
Tank capacity (Filling amount)		=	ca. 90 l
Electric motor		=	3 kW
Supply voltage		=	380 V AC
Weight		=	220 kg

PRESSURE GAUGE

for monitoring system pressure

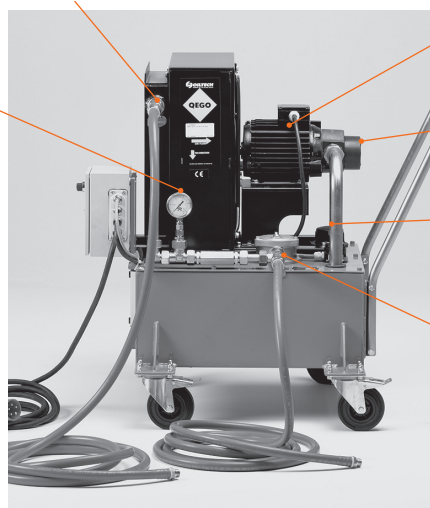
FLOW CONNECTOR red

ELECTRIC MOTOR

380 V ~ 1,5 / 3 kW

NOTE!

Never start the cooling unit without coolant in it. Running the unit without coolant may cause damage.



CIRCULATION PUMP

Check direction of rotation on start.

FILTER

RETURN FLOW CONNECTOR blue

COOLING UNIT

SWITCH

On/off button

FLUID LEVEL GAUGE

DRAIN CONNECTION

POWER PLUG

380V AC



COOLANT FILLER

Coolant 60 / 90 l

THERMOSTATIC VALVE

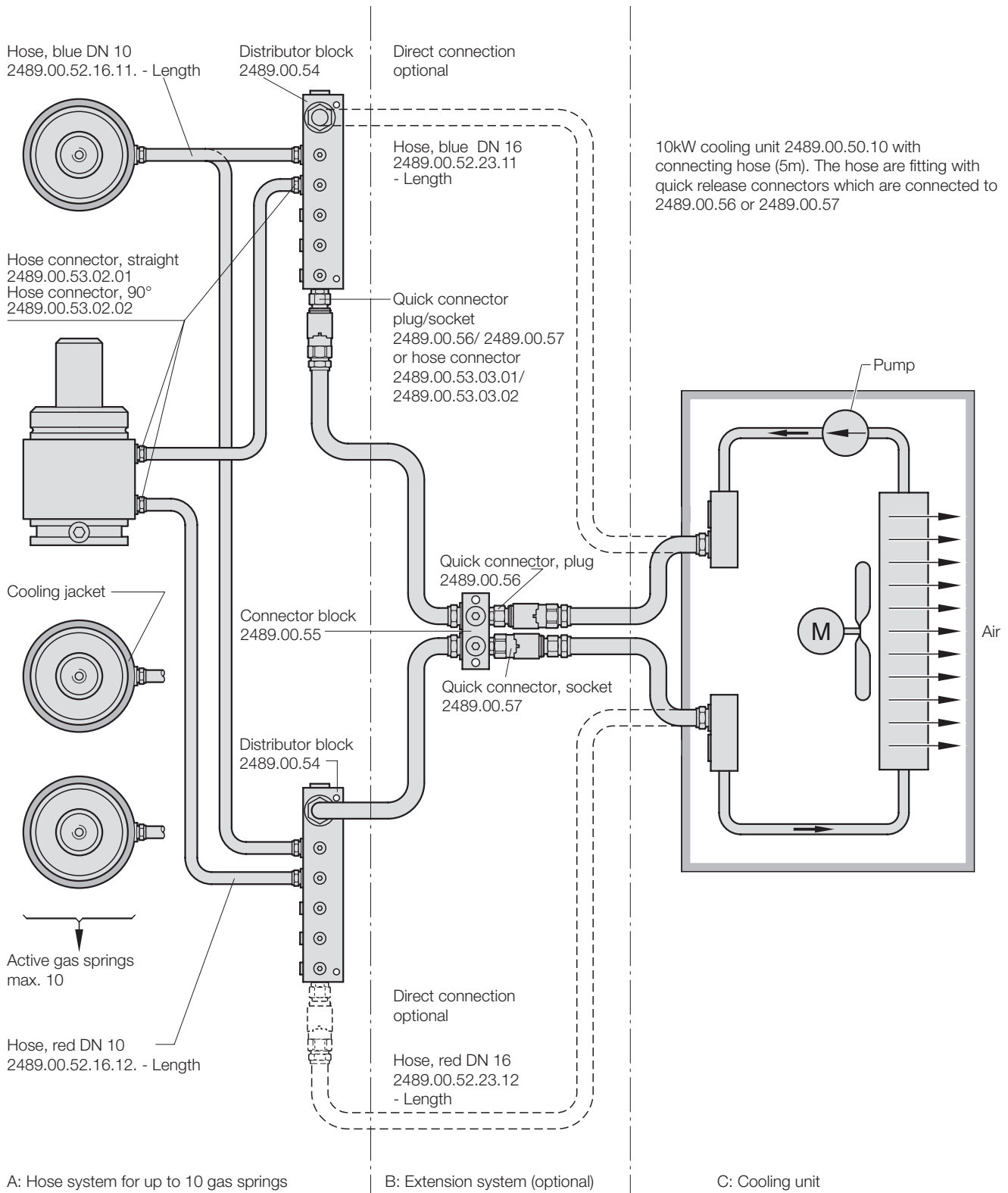
max. temp. = 70°C

COOLANT

The cooling unit is supplied without coolant. The cooling unit must always be run using a special coolant which is available from FIBRO, part no. 281.620.05 (5 litres), 281.620.10 (10 litres) or 281.620.50 (50 litres).

CONTROLLABLE GAS SPRINGS LIQUID COOLING COOLING UNIT FOR CONTROLLABLE GAS SPRINGS

EXAMPLE OF A COOLING SYSTEM ARRANGEMENT



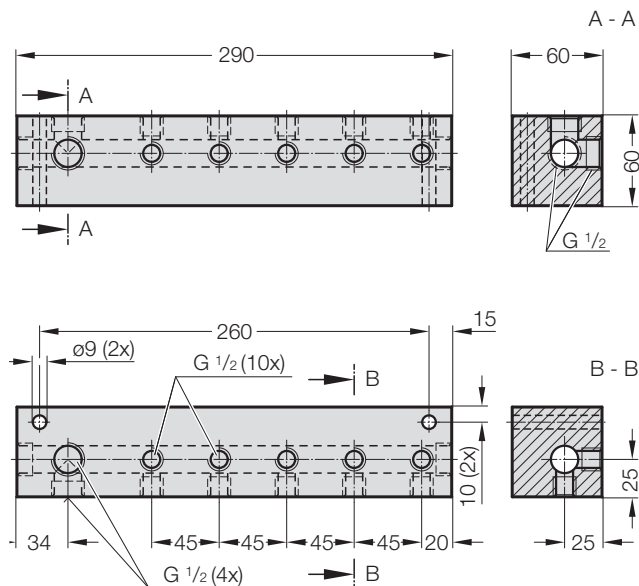
CONTROLLABLE GAS SPRINGS

LIQUID COOLING

CONNECTION ELEMENTS

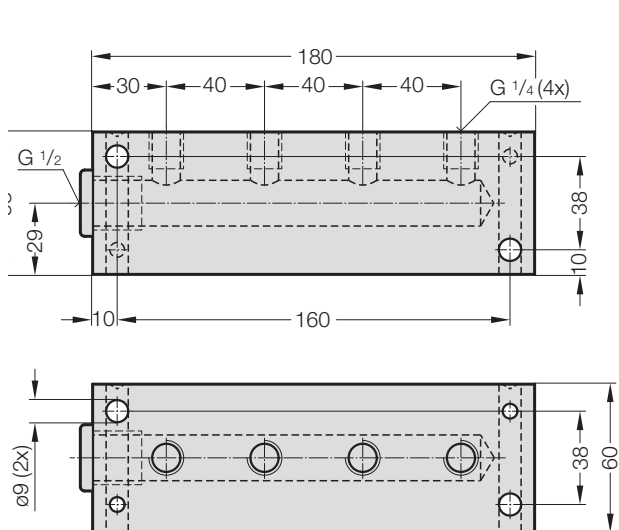
2489.00.54

DISTRIBUTOR BLOCK 10X



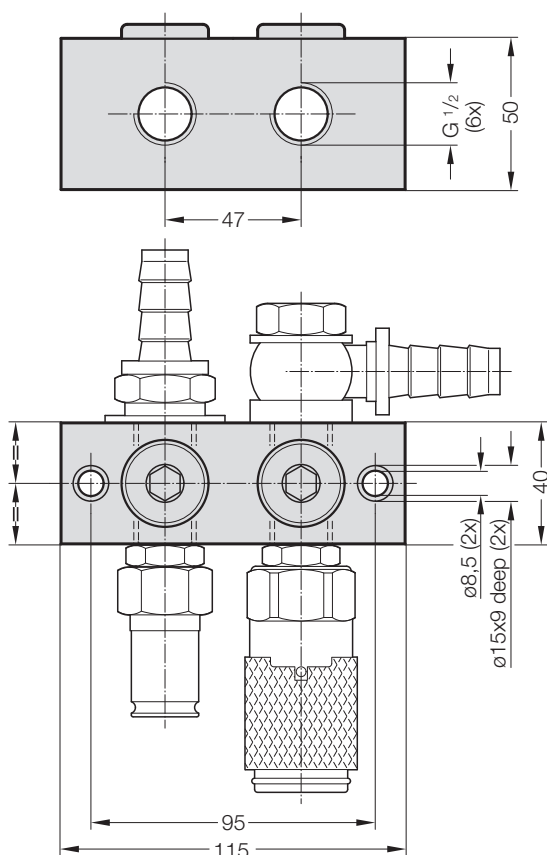
2489.00.54.04

DISTRIBUTOR BLOCK 4X



2489.00.55

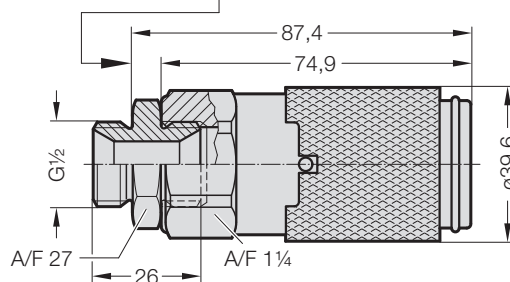
CONNECTOR BLOCK



2489.00.57

QUICK CONNECTOR, SOCKET

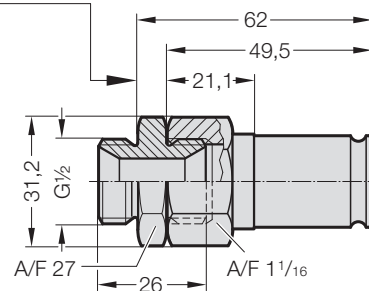
Connector block 2489.00.55 or
Distributor block 2489.00.54



2489.00.56

QUICK CONNECTOR, PLUG

Connector block 2489.00.55 or
Distributor block 2489.00.54

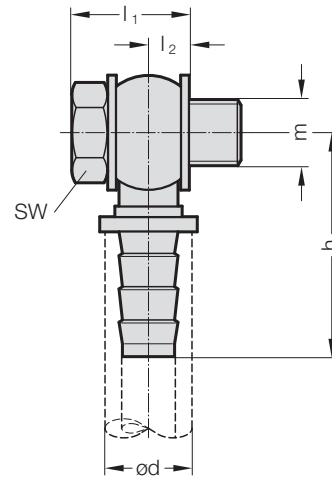


CONTROLLABLE GAS SPRINGS LIQUID COOLING CONNECTION ELEMENTS

2489.00.53.xx.02

HOSE CONNECTOR, 90°

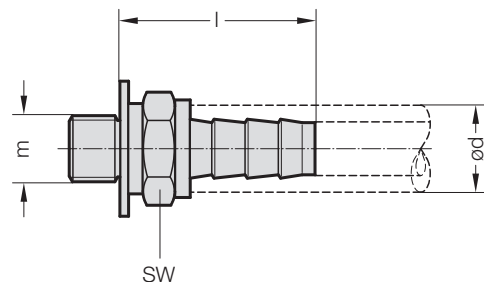
Order No.	m	l_1	l_2	h	$\varnothing d$	SW
2489.00.53.02.02	G1/4	23	8	44	16	19
2489.00.53.03.02	G1/2	30	12	68	23	27



HOSE CONNECTOR, STRAIGHT

Order No.	m	$\varnothing d$	l	SW
2489.00.53.02.01	G1/4	16	28	19
2489.00.53.03.01	G1/2	23	58	27

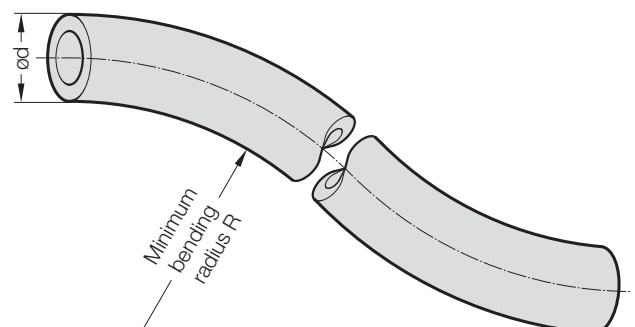
2489.00.53.xx.01



HOSE (FOR WATER COOLING)

Order No.	$\varnothing d$	DN	Colour	R_{min}
2489.00.52.16.11.	16	10	blue	75
2489.00.52.16.12.	16	10	red	75
2489.00.52.23.11.	23	16	blue	150
2489.00.52.23.12.	23	16	red	150

2489.00.52.



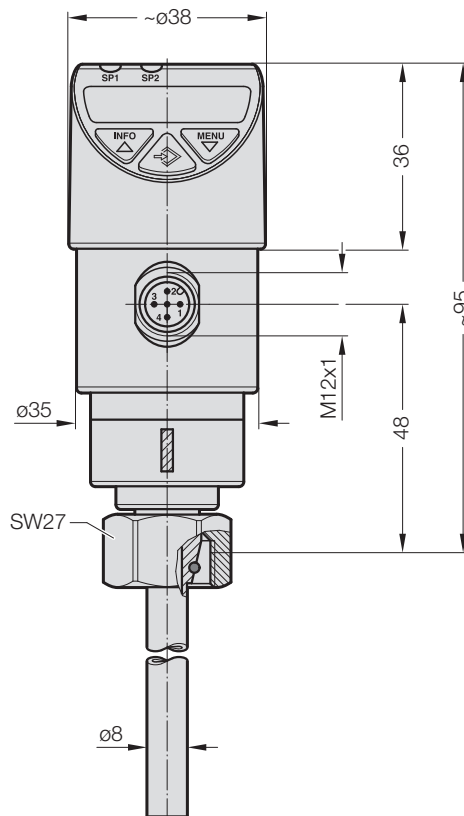
ORDERING CODE (EXAMPLE):

Hose (for water cooling) DN10	=	2489.00.52.16.11.
Colour blue	=	
Length 10 m	=	10
Order No	=	2489.00.52.16.11. 10

CONTROLLABLE GAS SPRINGS FLOW SWITCH, ELECTRONIC



2489.00.75



Pin assignment



1	U+	Supply connection, positive
2	SP2	Switch output 2
3	U-	Supply connection, negative
4	SP1	Switch output 1

TECHNICAL DATA:

Electrical connection

electrical connection port M12x1 (4-pin)

Electrical safety

Short-circuit proof:	S+ / SP1 / SP2 against U-
Reverse polarity protection:	U+ against U-
Insulation voltage:	DC 500 V
Overvoltage protection:	DC 40 V

Operating conditions

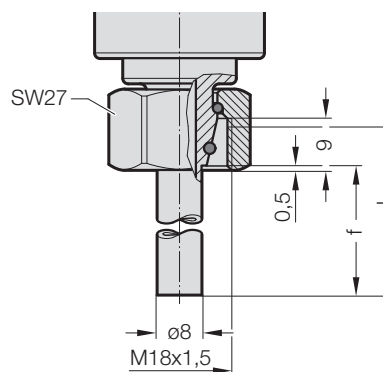
Permitted temperature ranges	
Measuring material:	-20 ... +85 °C (-4 ... +185 °F)
Environment:	-20 ... +80 °C (-4 ... +176 °F)
Storage:	-20 ... +80 °C (-4 ... +176 °F)

Max. working pressure Seal

30 bar (435 psi)	FPM/FKM
------------------	---------

Process connections

Standard	Thread	Sensor length f	Installation length l
ISO 225-1	M18x1,5	45 mm	~52 mm



CONTROLLABLE GAS SPRINGS

FLOW SWITCH, ELECTRONIC

NOTE:

Order connecting cable 2191.00.12.04.030, straight, 3m long separately.

APPROVALS:



DESCRIPTION:

EU Declaration of Conformity

- EMC Directive EN 61326 Emission (Group 1, Class B) and Immunity (Industrial)
- RoHS Guideline

COUNTRY:

European Union



UL

- Safety (e.g. electrical safety, excessive pressure, ...)

USA and Canada

OUTPUT SIGNALS:

Switch output

Standard PNP

Switch output

SP1 SP2

Flow Temperature

DESCRIPTION:

Flow monitoring for liquid cooling system 2489.00.50.

Flow switch, electronic 2489.00.75 enables reliable and process-capable flow monitoring for liquid cooling system 2489.00.50. If the flow falls below or exceeds the set flow, the switching output activates the downstream control or press control. This prevents damage and production losses due to overheated controllable gas springs in the tool.

Temperature monitoring

By means of a temperature output, the coolant temperature can be monitored without having to equip another measuring point.

Measuring ranges

Flow

Water: 0,05 ... 1,50 m/s

Oil: 0,03 ... 3,00 m/s

The factory calibration is carried out with the medium water. Adjustment via the menu to the min/max flows of the system is recommended.

Temperature (Option)

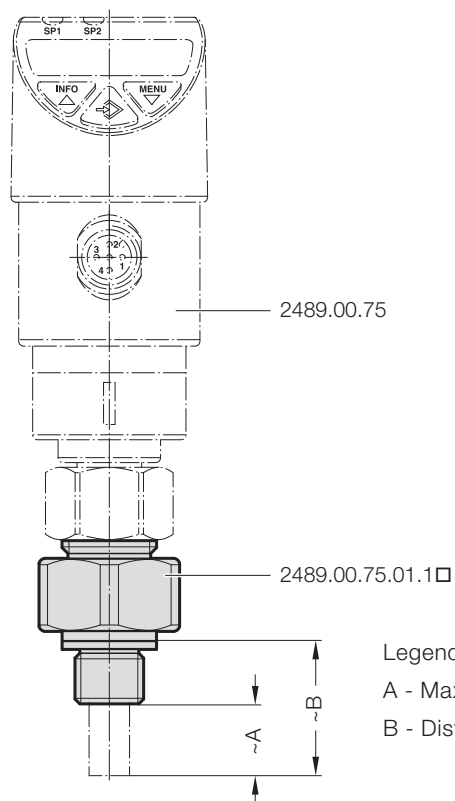
-20 ... +85 °C (-4 ... +185 °F)

Display

14-segment LED, red, 4-digit, character height 9 mm (0.35 in) – display can be rotated electronically by 180°.

CONTROLLABLE GAS SPRINGS ADAPTER FOR FLOW SWITCH, ELECTRONIC

ADAPTER FOR FLOW SWITCH, ELECTRONIC



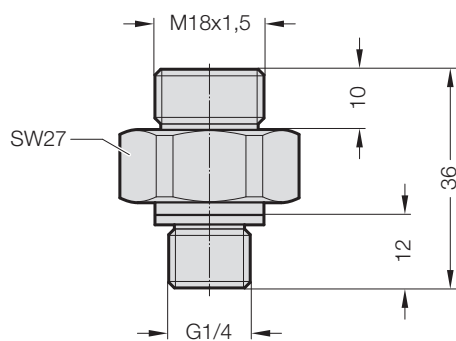
Legend:

A - Maximum sensor immersion depth

B - Distance from sealing surface to sensor tip

2489.00.75.01.14

Adapter for flow switch, electronic



DESCRIPTION:

for connection G1/4

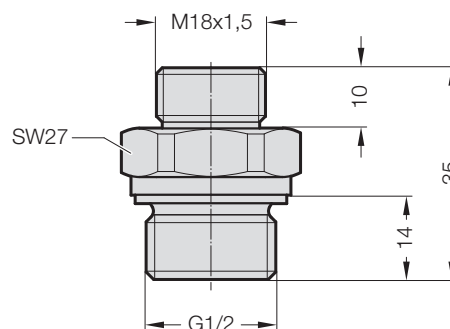
NOTE:

A = 16 mm

B = 28 mm

2489.00.75.01.12

Adapter for flow switch, electronic



DESCRIPTION:

for connection G1/2

NOTE:

A = 17 mm

B = 31 mm

CONTROLLABLE GAS SPRINGS **HOT FORMING**



CONTROLLABLE GAS SPRINGS

HOT FORMING

DESCRIPTION

In hot forming processes, the heating and cooling of the sheet metal part in the tool results in contamination due to the formation of scaling. If this scaling reaches the controllable gas springs, this can have a negative effect on the service life.

The sharp-edged hard particles of the scaling layers cause premature absorption of the piston rod wiper and can, therefore, lead to impurities being drawn into the gas springs and to failure of the internal sealing elements.

Fine impurities can also reach the cartridge valve (2489.14.1001) via the air connectors and impair its function.

To counteract these negative influences due to the high degree of contamination in the hot forming process, we recommend:

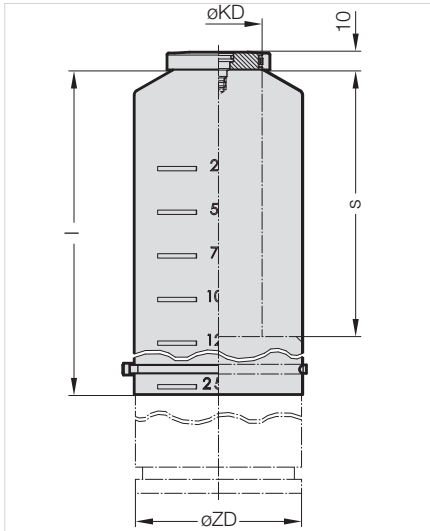
1. Use of the piston rod guard, FIBRO-TEX 2480.081. (see page 75)
2. Additional air connector to the cartridge valve airing (see page 31)
3. Use of an upstream compressed air maintenance unit (filter, water separator, oiler) on the control air line



CONTROLLABLE GAS SPRINGS HOT FORMING PISTON ROD PROTECTION, FIBRO-TEX®

2480.081.

MOUNTING EXAMPLE



DESCRIPTION:

The FIBRO-TEX® protects the piston rod of the gas spring against negative influences, such as:

- drawing in dirt
- damage to the surface of the piston rod
- adhesion of dirt particles
- drawing in oil and/or emulsion

The FIBRO-TEX® breathable material doesn't require additional ventilation.

Due to the piston rod protection, FIBRO-TEX®, increases the lifetime of the gas spring under rough operating conditions.

NOTE:

Included with this part number is the piston rod protection FIBRO-TEX®, with the necessary washer with screw and o-ring, preassembled with cable ties (to piston rod), cable tie (for gas spring housing) is added separately.

The piston rod protection has a length of 250 mm. The length of the piston rod protection is shortened individually to the stroke length of the gas spring.

TECHNICAL DATA:

Material:	Piston rod protection:	Polytetrafluoroethylene (ePTFE)
	Washer:	Steel, burnished
	Cable tie (piston rod side):	Polyamide
	Cable tie (cylinder tube side):	Polyamide
Working temperature:		0°C - 80°C
Temperature resistance:		-35°C - 200°C
Chemical resistance:	Acids:	very good
	Alkalines:	very good
	Solvent:	very good
Weather-resistance:	Sunlight (UV):	very good
	Ozone:	very good
	Water:	very good
Oil resistance:	mineral:	very good
	synthetic:	very good

2480.081. PISTON ROD PROTECTION, FIBRO-TEX®

Type of gas spring

2489.14.01500. 2489.14.03000. 2489.14.05000.

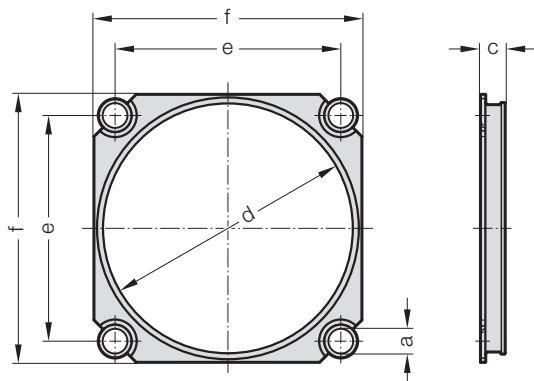
Order number	øKD	øZD	s	l			
2480.081.095.050.250	50	95	10 - 250	250	●		
2480.081.120.065.250	65	120	10 - 250	250		●	
2480.081.150.065.250	65	150	10 - 250	250			●

CONTROLLABLE GAS SPRINGS

HOT FORMING

RETAINING PLATE FOR CLAMPING FLANGE, CABLE TIE PLIERS

2480.081.00.057.



DESCRIPTION:

When the gas spring is mounted with a clamping flange, an additional retainer plate can be used. The retainer plate is mounted on the upper side of the clamping flange with fastening screws.

MATERIAL:

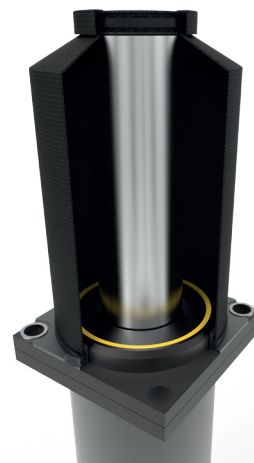
Retainer plate: Plastic

Discs: Steel

ATTENTION:

The retainer plate is determined by the cylinder tube diameter of the gas spring.

MOUNTING EXAMPLE



2480.081.00.057.

RETAINING PLATE FOR CLAMPING FLANGE

Order number	Cylinder pipe- \varnothing	a	c	d	e	f
2480.081.00.057.095	95	12	12	96.2	92	110
2480.081.00.057.120	120	12	12	121.2	109.5	130
2480.081.00.057.150	150	16	11	151.2	138	162

DESCRIPTION:

We recommend to use a cable tie plier (tong) to mount the cable ties

NOTE:

Order Number for spare part cable ties

2480.081.00.006.1 (piston rod)

2480.081.00.006.2 (gas spring housing))

Minimum tensile strength 220 up to 540 N

Cable tie width 4,8 up to 7,6 mm

Stroke length 25,4 mm

2480.081.00.007 CABLE TIE PLIERS



CONTROLLABLE GAS SPRINGS HOT FORMING CONTROL SYSTEM

CONTROL SYSTEM

The KF gas springs are supplied with a compressed air connector on the cartridge valve side for DN 6 hose lines.

The vent plug pos. 3 is removed and replaced by a compressed air connection.

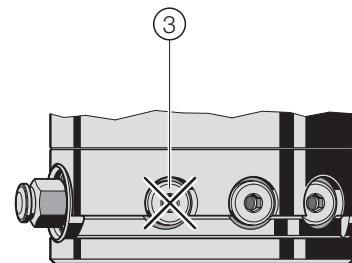
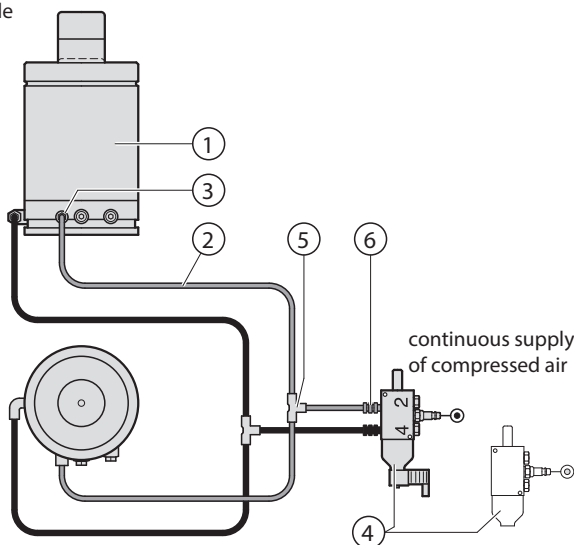
No more than four KF gas springs should be controlled by one control valve.

Suitable connections must be selected to set up the system. Cut hoses to correct length during installation (push-lock connector).

Select the control valve from Side 78 according to the signal from the power press (pneumatic or electric). For the control valve, the continuous supply of filtered compressed air with a pressure of at least 5 bar must be ensured.

KF gas springs control system

Example



CONTROL SYSTEM KF GAS SPRINGS, EXAMPLE

Item	No.	Description	Order No.
1	2	KF gas spring	2489.14.03000
2	6	Compressed air hose, blue	2489.00.42.06.11.xx
3	1	straight push-in fitting G1/4"	2489.00.43.02.01
4	1	electro-pneumatic valve or pneumatic-pneumatic valve	2489.00.41.52 or 2489.00.40.52
5	2	T fender filler	2489.00.44.06.05
6	2	straight push-in fitting G1/4"	2489.00.43.02.01

CONTROLLABLE GAS SPRINGS

HOT FORMING

CONTROL SYSTEM

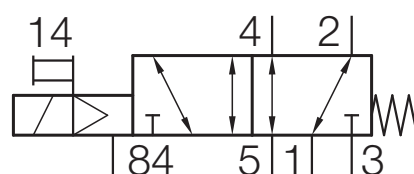
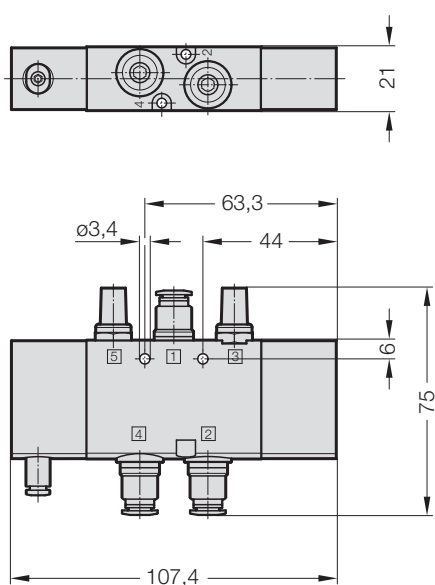
PNEUMATIC-PNEUMATIC VALVE

2489.00.40.52

5/2 way valve, pneumatic

NOTE:

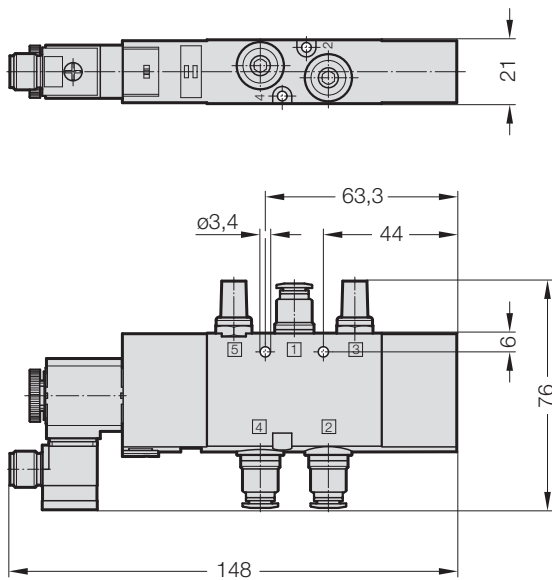
Fluid: Air or inert gas, filtered oily or dry



CONTROLLABLE GAS SPRINGS HOT FORMING CONTROL SYSTEM ELECTRO-PNEUMATIC VALVE

2489.00.41.52

5/2 way valve, electro-pneumatic



NOTE:

Fluid: Air or inert gas, filtered oily or dry

Voltage: 24V DC – (2,6 W)

CONNECTION CABLE STRAIGHT

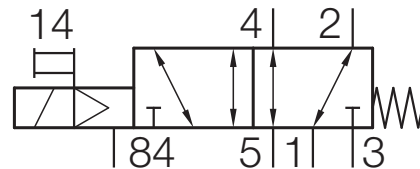
order separately

Order No		l [m]
2489.00.41.00.01	M12x1, 3-pole end open	2,50

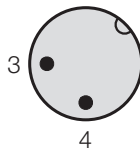
CONNECTION CABLE 90°

order separately

Order No		l [m]
2489.00.41.00.02	M12x1, 3-pole end open	2,50



ELECTRICAL CONNECTION PORT



CONTROLLABLE GAS SPRINGS

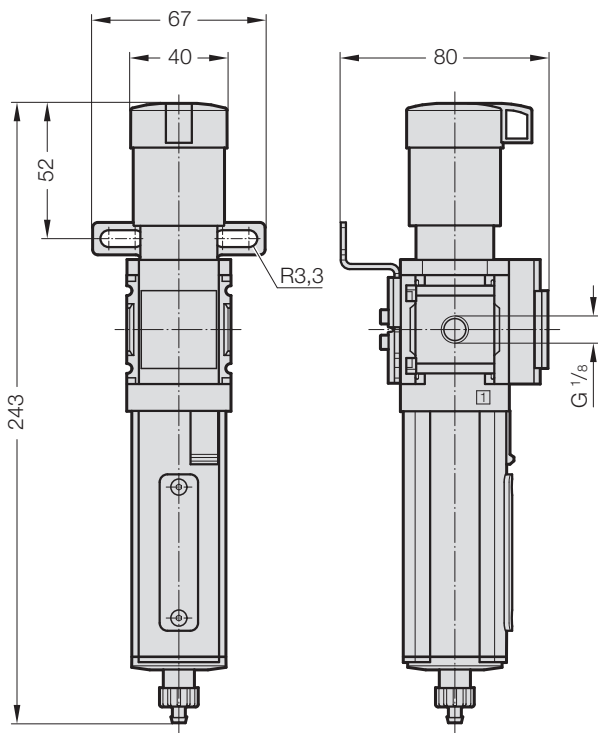
HOT FORMING

CONTROL SYSTEM

COMPRESSED AIR MAINTENANCE UNIT

2489.00.48

Compressed air maintenance unit



Compressed air maintenance unit for cleaning and regulating the control air of the cartridge valve in the active gas spring.

TECHNICAL DATA:

Filter unit 40 mm

Operating pressure 0,8 bar up to 14 bar

Ambient temperature -10°C up to 60°C

NOTE:

Order number for replacement filter cartridge: 2489.00.48.1

We recommend changing the filter cartridge every 200 operating hours or at least 1x per year.

In case of high water content or high contamination of the conveyed compressed air, the cycle must be adjusted.

CONTROLLABLE GAS SPRINGS

APPLICATION EXAMPLES



180°



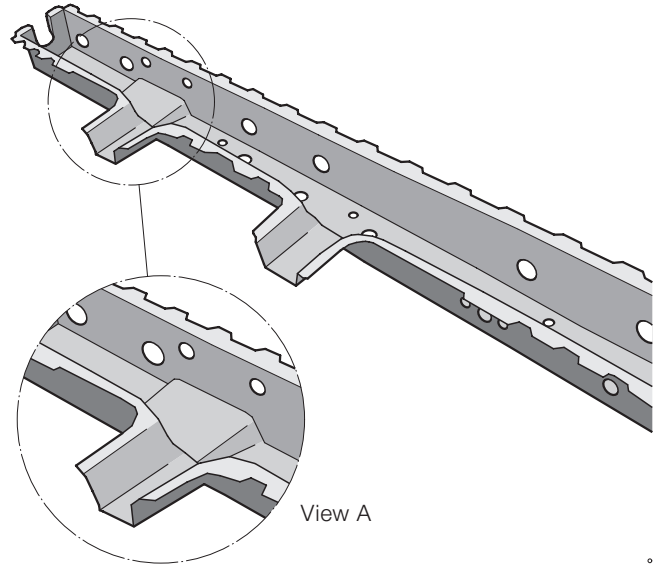
CONTROLLABLE GAS SPRINGS

APPLICATION EXAMPLES

EXAMPLE OF APPLICATION WITH KF GAS SPRING SYSTEM (1 MM RETURN)

Dies are used for drawing a beam (detail A). The dies have to be locked at the bottom position to avoid distortion of the workpiece on the return stroke.

In this application a KF gas spring is used for each drawing die.

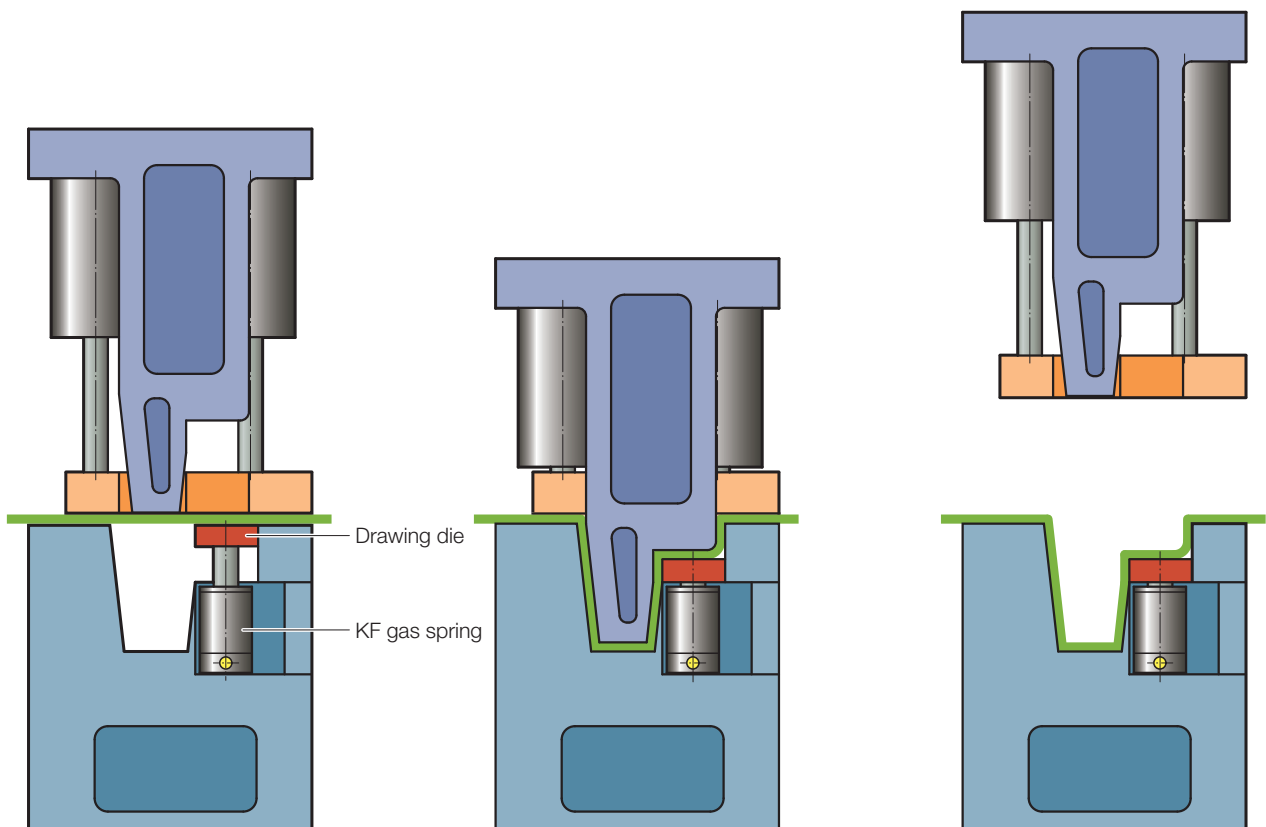


WORKING CYCLE:

The drawing die (1) is activated when the upper part of the tool descends.

The KF gas springs are locked at the bottom position. Slight spring back will not damage the workpiece in this case.

When the press opens, the clamp releases the workpiece. The workpiece can then be removed and the gas spring unlocked.



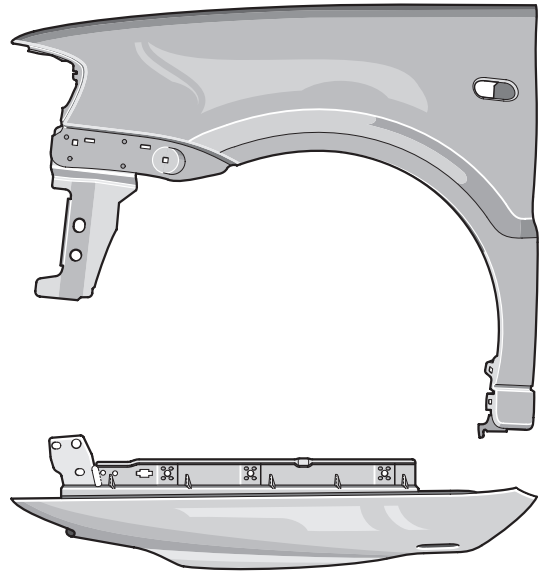
CONTROLLABLE GAS SPRINGS

APPLICATION EXAMPLES

EXAMPLE OF APPLICATION WITH KF + KP GAS SPRING SYSTEM

In the application described below an automobile fender gutter (1) is being shaped. The die (2) has to be locked in the back position to avoid distortion of the tool. In this case the problem was solved by using the KF + KP controlled gas system. The system consists of three KF gas springs connected to a passive KP gas spring.

The illustration shows only the KF gas springs.

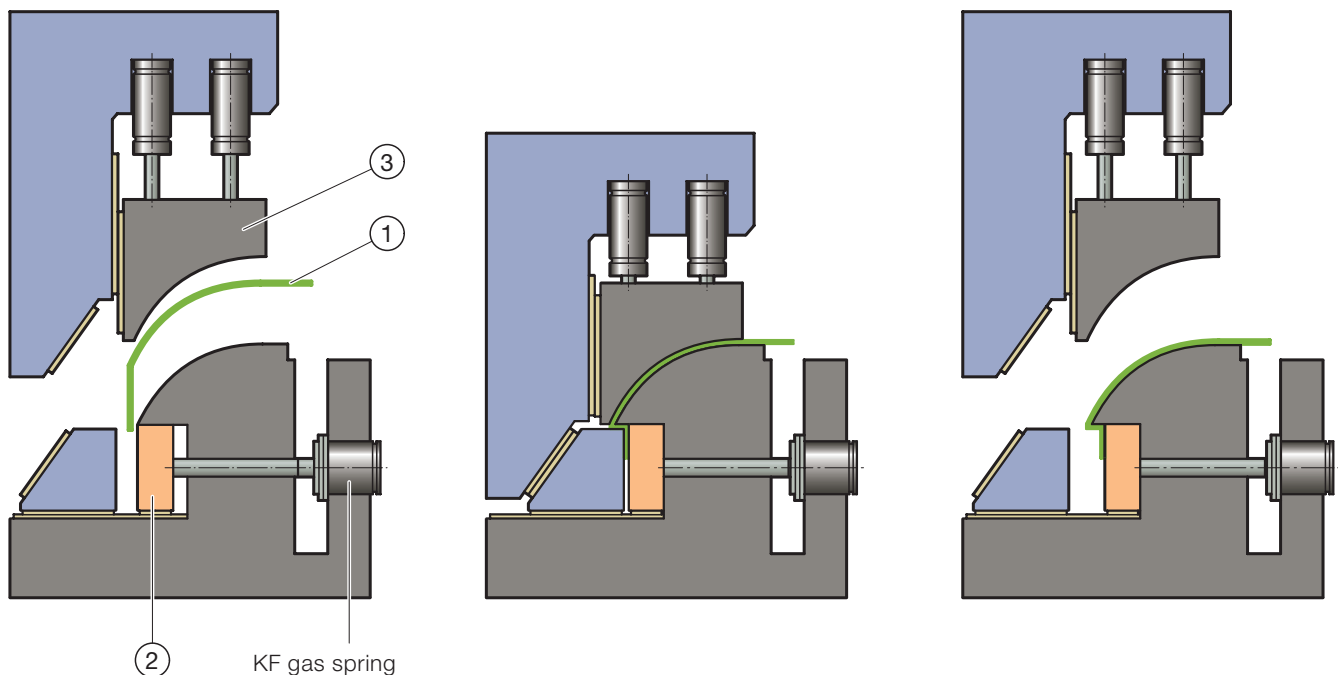


WORKING CYCLE:

When the top part of the tool moves down, it actuates the clamping pad (3) that holds the sheet metal workpiece (1) in position.

At the bottom point the KF gas springs are locked with no spring back and the drawing die (2) remains in the back position. This prevents any deformation of the workpiece.

When the press opens, the clamp releases the workpiece and it can be removed. Then the gas spring is unlocked.



CONTROLLABLE GAS SPRINGS

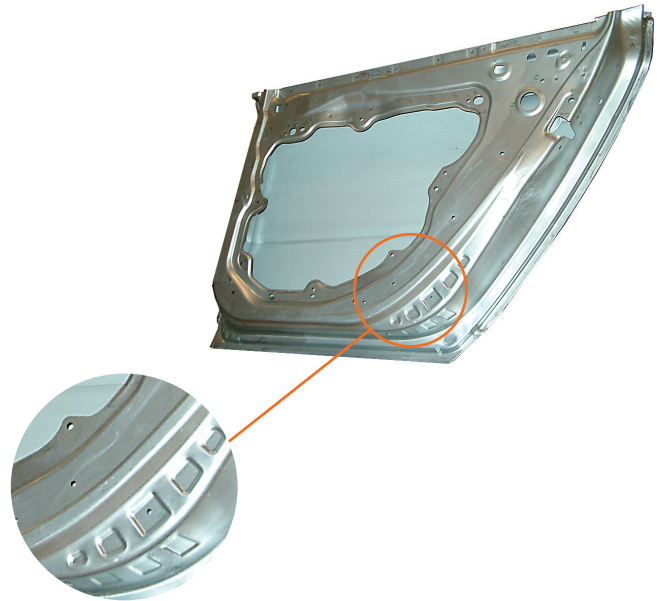
APPLICATION EXAMPLES

EXAMPLE OF APPLICATION WITH KF + KP GAS SPRING SYSTEM

The KF + KP-system is ideal for use in the manufacture of parts where gas springs without spring back are required. The press completes a two-stage drawing process in a single stroke.

The KF + KP-system makes possible the locking of clamps which prevent distortion of the part on the press return stroke.

This large pressing mould for an inner door panel uses a total of 12 KF gas springs in association with 3 KP passive gas springs.

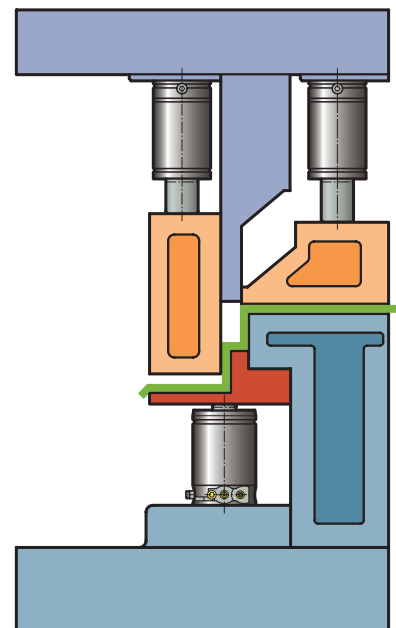
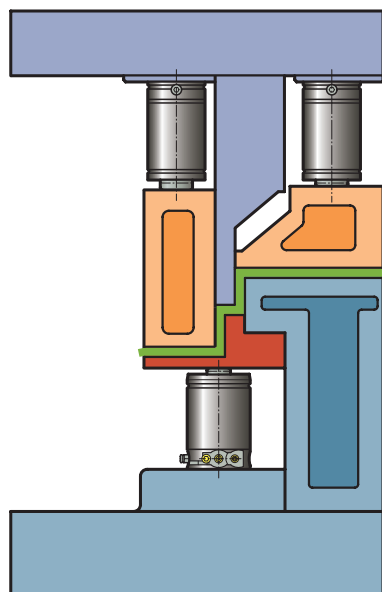
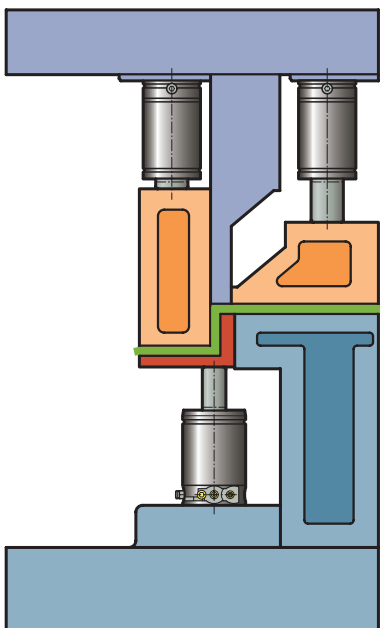


ARBEITSZYKLUS:

The lower part of the tool contains the controllable gas springs KF which provide the active clamping force for the most deeply drawn area of the part.

When the tool is closed, the passive gas springs KP (not shown) are compressed and this provides the necessary counter pressure for locking of the KF gas springs in the bottom part of the tool without spring back.

When the tool opens, the gas springs remain locked until receiving a signal from the press. Then the KF gas springs assist in ejecting the undamaged part from the tool.



KF + KP gas spring system

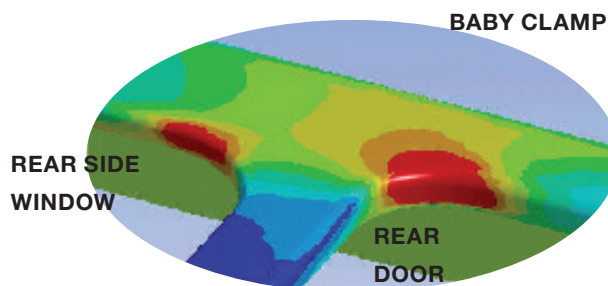
CONTROLLABLE GAS SPRINGS APPLICATION EXAMPLES

EXAMPLE OF APPLICATION WITH KF + KP GAS SPRING SYSTEM

The manufacture of high quality side panels often presents tool manufacturers with a major challenge.

The areas where the side door posts interface with the outer panels are especially problematic. If clamped down too hard, the part may tear, if not clamped down hard enough ripples may occur in the workpiece.

A current solution to this problem is to use "Baby" clamps for these problem areas, whose spring force can be controlled by controllable gas springs. The result is higher quality parts, improved control of the drawing process and a reduction in the number of rejects.



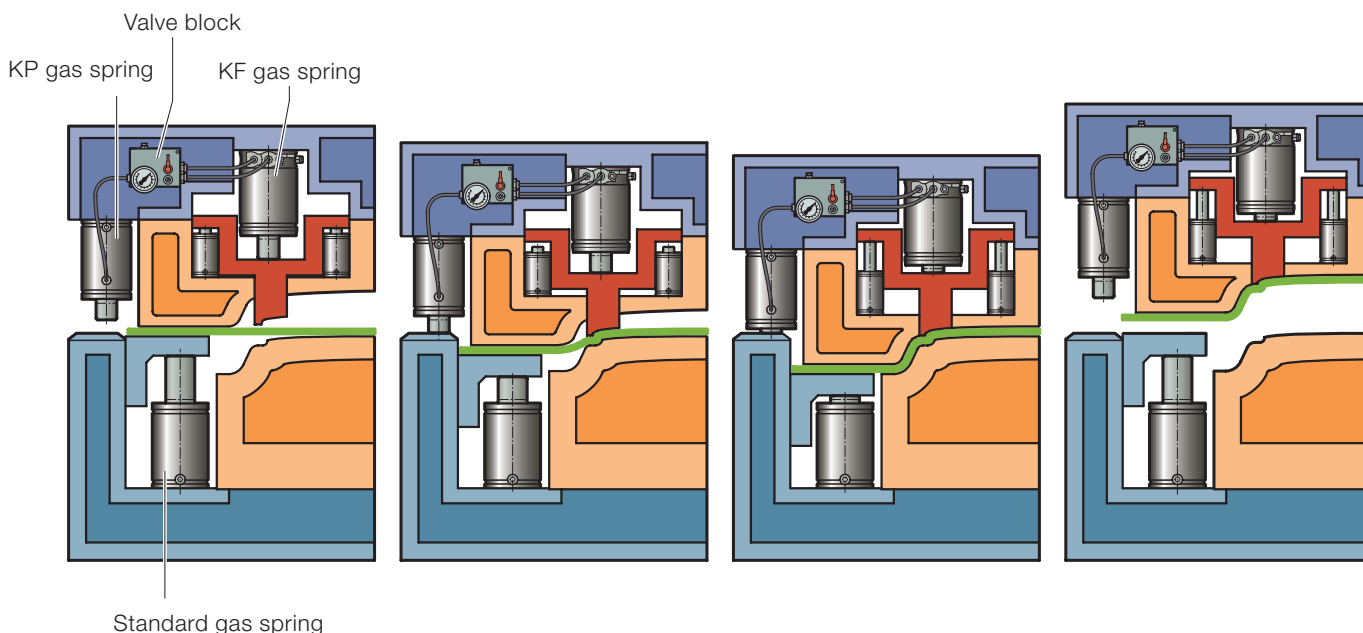
WORKING CYCLE:

The upper part of the tool contains the controllable KF gas springs which provide the clamping force for the "Baby" clamps.

When the tool begins to close, the raw workpiece is first clamped down by the "Baby" clamps in the problem areas.

The valve in the valve block opens at bottom dead centre of the press and the KP gas spring is used to prevent a spring back of the KF gas springs.

When the tool opens, the gas springs remain locked until receiving a signal from the press. Then the KF gas springs assist in ejecting the finished part from the tool.



CONTROLLABLE GAS SPRINGS

FREQUENTLY ASKED QUESTIONS (FAQ)

GENERAL

What is the air pressure required for operating cartridgevalves?	To close the cartridge valve which is normally open (NO) an air pressure of at least 5 bar is required.
What is the maximum recommended pressure for operating cartridge valves?	The maximum permissible air pressure for operating cartridge valves is 10 bar.
What is the expected service life of a controllable gas spring (KF)?	When using a thermostatic relay the life expectancy is typically: For strokes up to 50 mm: 500,000 strokes. For strokes over 50 mm: 50,000 stroke/metres.
Can other hose systems be used?	We cannot guarantee correct functioning of the system if hoses other than those authorized in this manual are used. For further information please contact your agent or FIBRO GmbH, Standard Parts business division.
Can KF gas springs of different ratings be used in the same system?	No. For further information please contact your agent or FIBRO GmbH, Standard Parts business division.
Can an old active KF gas spring (2489.13.) be replaced by a new KF gas spring (2489.14.)?	Yes, but the new KF gas spring (2489.14.) is 7 mm longer. The KF gas spring 2489.13.xxxxx.xxx.E is interchangeable but the stroke is not adjustable.

TO THE KF GAS SPRING SYSTEM

Can the stroke length of the KF gas spring be adjusted or is it necessary always to use 100% of the nominal stroke ± 0.5 mm?	Two types of controllable KF gas springs are available. the standard model 2489.14. (adjustable) and model 2489.13.xxxxx.xxx.E (non adjustable) which can be used as a replacement for the previous 2489.13.
How fast can the KF gas spring be operated?	The maximum compression speed is 0.8 m/sec The maximum stroke count at which a KF gas spring can operate depends on the stroke length of the gas spring and the cooling capacity available. For further information see the section on Cooling.
How can I avoid KF spring back?	When using 100% of the stroke length of the KF gas spring ± 0.5 mm a spring back of up to 1 mm is to be expected. This can be prevented at any time by converting the standard locking arrangement to a forced locking system. For further information please contact your agent or FIBRO GmbH, Standard Parts business division.
Can a controllable KF gas spring be locked in any position?	Theoretically, yes. The less the KF controllable gas spring is compressed, the stronger the spring back. For further information please contact your agent or FIBRO GmbH, Standard Parts business division.

CONTROLLABLE GAS SPRINGS

FREQUENTLY ASKED QUESTIONS (FAQ)

TO THE GAS SPRING SYSTEM, KF + KP

How many KF controllable gas springs can be connected to a KP passive gas spring?	Up to four KF gas springs can be linked to one KP gas spring.
How many valve blocks are needed in the system?	One valve block is needed for each KP passive gas spring in the system.
Can the KP gas spring in the tool be used for pressing?	No. The KP gas spring in the tool cannot be used for any purpose other than preventing spring back of KF gas spring.
Can the mini-measuring hose system be used for connecting the KF + KP-system?	No. The 24° cone hose system (or corresponding product) must be used for connecting the KF gas spring(s), the valve block and the KP passive spring.
Can the 24° cone hose system be used for connecting the KF + KP-system?	Yes.

ON COOLING

Is cooling always necessary?	Not always. Generally speaking, greater stroke lengths and higher stroke counts usually require cooling. For further information see the section on Cooling.
How many KF controllable gas springs can be connected to one cooling unit?	The total maximum heating effect of all the springs must not exceed the cooling capacity of the cooling unit. See tables, pages 15 or 58.
Can other cooling units be used?	Yes. The press cooling system or other cooling units can be used.
What coolant is approved for use?	We recommend a water/glycol based coolant.

CONTROLLABLE GAS SPRINGS

TROUBLE SHOOTING

KF GAS SPRING SYSTEM

PROBLEM	SOLUTION
KF gas spring does not lock.	<p>Ensure that 100% of the nominal stroke of the KF gas spring (± 0.5 mm) is being used.</p> <p>Check that all hose connections are OK.</p>
KF piston rod has more than 1 mm spring back.	<p>Ensure that 100% of the nominal stroke of the KF gas spring (± 0.5 mm) is being used.</p> <p>Ensure that 100% of the nominal stroke of the KF gas spring (± 0.5 mm) is being used.</p>
KF piston rod does not return to its starting point.	<p>Ensure that there is no pressure at compressed air port 4 of the KF gas spring when it is supposed to open.</p> <p>Check whether the piston rod is prevented from returning by obstructions in the tool.</p> <p>Check whether there is gas pressure in the KF Gas Spring.</p>

KF + KP GAS SPRING SYSTEM

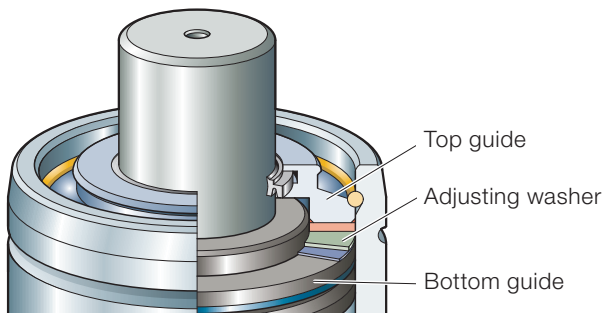
PROBLEM	SOLUTION
KF gas spring does not lock.	<p>Ensure that 100% of the nominal stroke of the KF gas spring (± 0.5 mm) is being used.</p> <p>Check that all hose connections are OK.</p>
KF piston rod has more than 0 mm spring back.	<p>Ensure that the cartridge valve in the valve block is closed during the downward stroke of the press and that the KP passive gas spring is compressed sufficiently for this application.</p> <p>Ensure that 100% of the nominal stroke of the KF gas spring (± 0.5 mm) is being used.</p> <p>Check whether the cartridge valve in the valve block is opening at bottom dead centre. Check that the required gas pressure is present in the KP gas spring.</p>
KF piston rod does not return to its starting point.	<p>Ensure that there is no pressure at compressed air port 4 of the KF gas spring when it is supposed to open.</p> <p>Check whether the piston rod is prevented from returning by obstructions in the tool.</p> <p>Check whether there is gas pressure in the KF Gas Spring.</p>
KP piston rod does not return to its starting point.	<p>Check whether the piston rod is prevented from returning by obstructions in the tool.</p> <p>Check whether there is gas pressure in the KP gas spring.</p>

CONTROLLABLE GAS SPRINGS MATCHING THE STROKE LENGTH IN KF GAS SPRINGS

MATCHING THE STROKE LENGTH IN KF GAS SPRINGS

(2489.14.)

The guide is made up of the following main components:



The length of the guide and the stroke are adapted by adding or removing adjusting washers between the top and bottom guide. The correct stroke can be obtained by adding adjusting washers as in Table 1.

EXAMPLE 1:

The stroke length needs increasing to 4 mm longer than the rated stroke length.

Example 1

SOLUTION:

Open the gas spring and the guide, remove the 4 mm adjusting washer. Leave the 1 mm and the 2 mm adjusting washers in the guide/gas spring

This process is described on the next page.

IMPORTANT!

- Only qualified engineers experienced in the repair and maintenance of gas springs should modify the stroke length.



- The workbench for working on the gas springs must be clean and free from contamination.
- Never work on a gas spring containing air or gas under pressure.

Thickness	FIBRO Order No.
1 mm	2489.14.451.xxxxx.01
2 mm	2489.14.451.xxxxx.02
4 mm	2489.14.451.xxxxx.04
8 mm	2489.14.451.xxxxx.08
(not illustrated)	

TABLE 1

For modifying rated stroke length

Stroke length	Adjusting washer (mm)			
	1	2	4	8
max. +7	0	0	0	0
+6	1	0	0	0
+5	0	1	0	0
+4	1	1	0	0
+3	0	0	1	0
+2	1	0	1	0
+1	0	1	1	0
rated*	1	1	1	0
-1	0	0	0	1
-2	1	0	0	1
-3	0	1	0	1
-4	1	1	0	1
-5	0	0	1	1
-6	1	0	1	1
-7**	0	1	1	1
min. -8**	1	1	1	1

* The rated stroke length is always specified on the gas spring cylinder.

** Not for nominal stroke length of 10 mm.

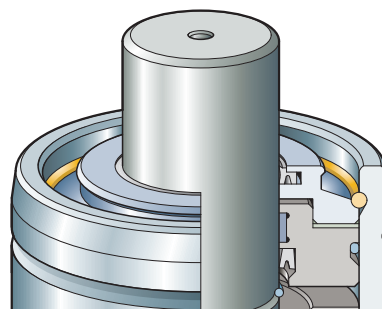
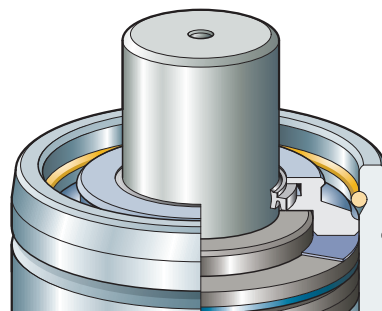
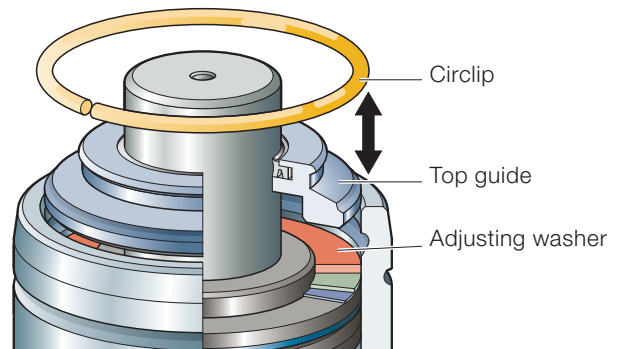
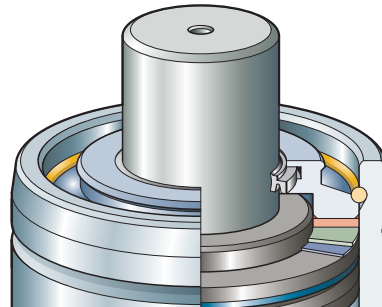
CONTROLLABLE GAS SPRINGS

MATCHING THE STROKE LENGTH IN KF GAS SPRINGS

MATCHING THE STROKE LENGTH IN KF GAS SPRINGS (2489.14.)

INSTRUCTIONS

1. Release any gas from the gas spring.
2. Using an assembly sleeve and a plastic hammer tap down the guide and remove the snap ring.
3. Remove the top guide and insert the combination of adjusting washers to produce the required stroke length.
4. Insert the top guide again and tap down with the assembly sleeve and plastic hammer until the groove is clear for the snap ring.
5. Fit circlip and raise the piston assembly with a T-handle.
6. Ensure that the guide is flush with the top edge of the cylinder. (If not, check that the circlip is correctly seated.)
7. Fill the gas spring with gas.



CONTROLLABLE GAS SPRINGS

CONVERSION OF EXISTING SYSTEMS

DIFFERENCES BETWEEN THE REPLACEMENT MODEL

2489.13.XXXXX.XXX.E AND THE EARLIER KF GAS SPRING 2489.13.:

The replacement model is usually fitted with an opened cartridge valve which has a number of advantages:

- simplified control system
- single port for filling and emptying
- low pressure version no longer necessary
- only 5 bar pressure required

HOW THE REPLACEMENT MODEL IS CONNECTED TO EXISTING KF SYSTEMS:

Controllable gas springs 2489.13.xxxxx.xxx.E are completely compatible with existing KF gas springs (2489.13).

EXAMPLE OF KF GAS SPRING SYSTEM: REPLACING AN EXISTING 2489.13 WITH A REPLACEMENT MODEL

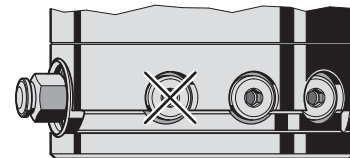
When replacing an existing KF gas spring with a new 2489.13.xxxxx.xxx.E in a standard locking system the only point to note is that the compressed air signal line connected to compressed air port 2 must be closed off.

EXAMPLE OF A KF + KP GAS SPRING SYSTEM: REPLACING AN EXISTING 2489.13 WITH A REPLACEMENT MODEL

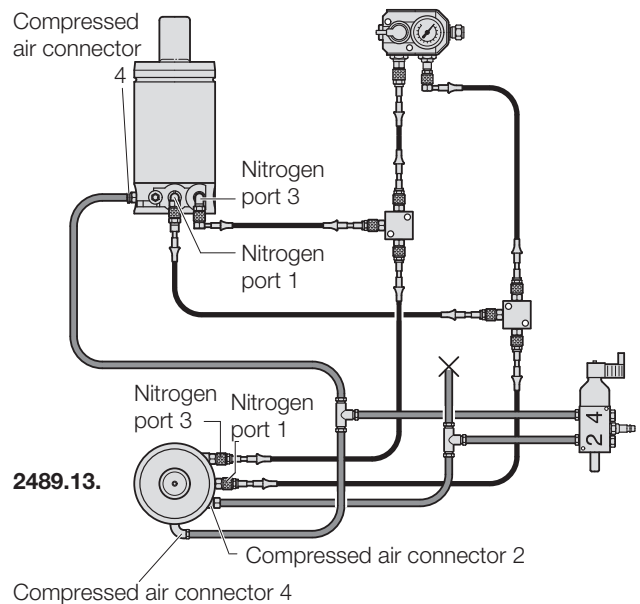
When replacing an existing KF gas spring with a new 2489.13.xxxxx.xxx.E in a KF + KP system the only point to note is that the compressed air signal line connected to compressed air port 2 must be closed off. If a new valve block (2489.00.47.01) is fitted, compressed air port 2 of the corresponding valve must be closed off.



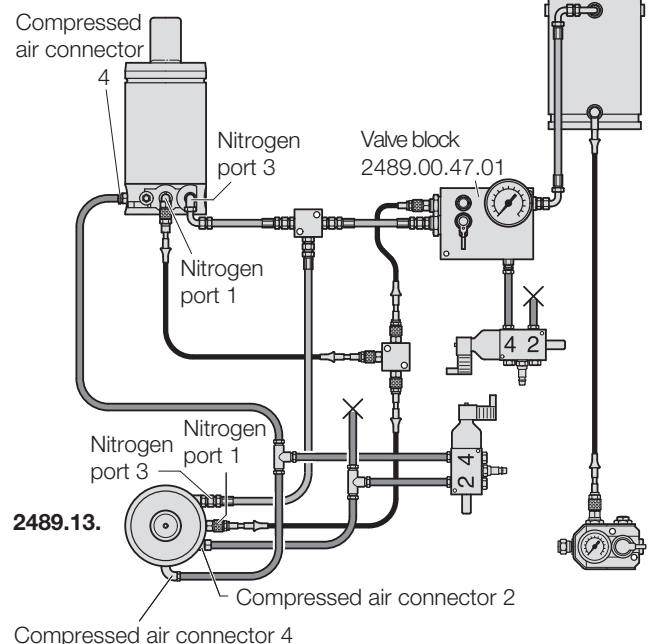
Always remember when replacing the old gas spring type 2489.13 with the KF gas spring 2489.14 (adjustable stroke) that it is 7 mm longer.



2489.13.xxxxx.xxx.E



2489.13.xxxxx.xxx.E



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