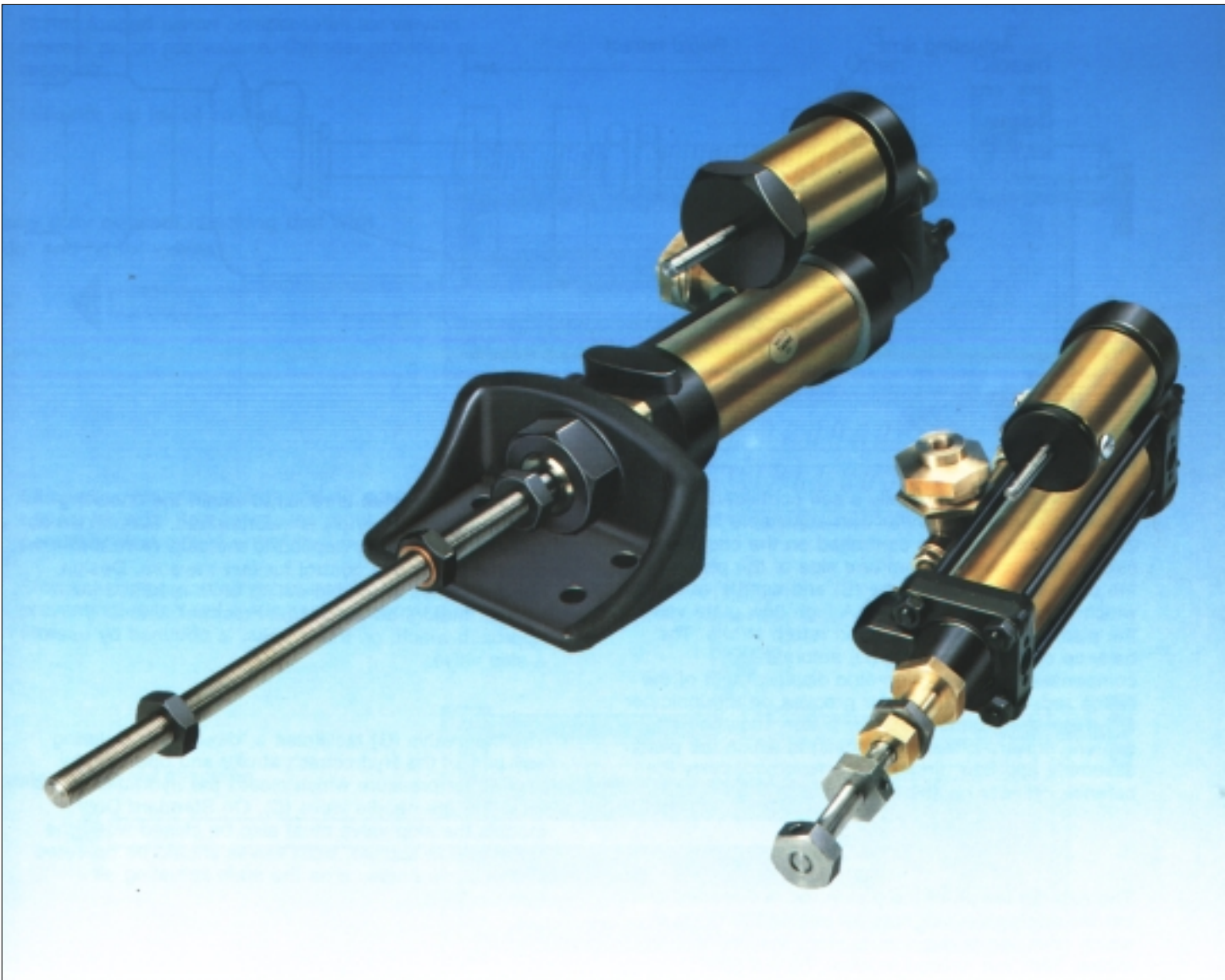


Hydrochecks

*Self contained hydraulic
checking units*

Catalogue no: 2117 GB-ca



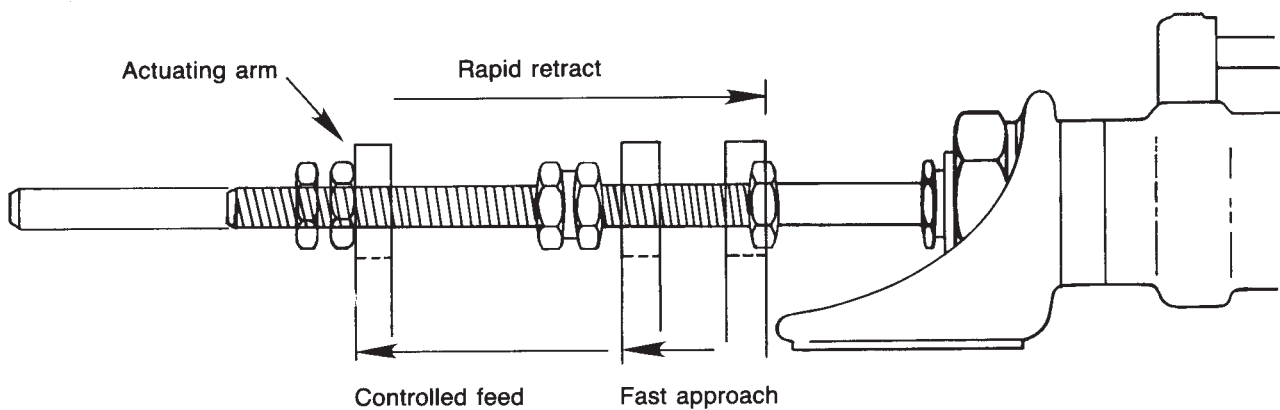
Hydrochecks

Hydrochecks are precision built self contained hydraulic control units designed to smooth out pneumatic cylinder-movements over any distance within their own stroke length, up to 450mm.

Basic single acting models provide adjustable speed control over the full outward or inward stroke, and fast return, with the facility for rapid approach to the controlled stroke, by the adjustment of the piston rod engaging nuts.

By the incorporation of 'skip' or 'stop' valves virtually any combination of fast - slow, start - stop motions can be obtained. Similar functions can also be provided on the inward and outward strokes of double acting models.

Fig 1.



Flow schematic

The Hydrocheck is basically a self contained hydraulic damping cylinder with adjustable flow. (Fig 2). The piston speed is controlled on the checking stroke by pushing oil from one side of the piston (A) to the other via a transfer tube (B) and needle valve (C) which adjusts checking rate. A high flow plate valve in the piston lifts to permit a rapid return stroke. The balance cylinder assembly (D) automatically compensates for the volumetric displacement of the piston rod; the three annular grooves on the indicator rod (E) of the balance cylinder piston show the oil content. Inward checking models, in which the piston assembly and flow direction are reversed, carry the balance cylinder on the front head.

The exterior length of the piston rod is threaded and carries adjustable lock nuts for setting the point at which checking is required to start, the permanently locked back nut is used to reset the rod (Fig 1).

Where fast traverse is required within the checking stroke a 'skip' valve (F) is incorporated. Maintained air pressure is normally applied to the skip valve and relieved by remote control for fast traverse. Design characteristics of double acting units mounted inline with air motors do not permit mechanical fast approach which, on these units, is obtained by use of a skip valve.

The stop valve (G) facilitates a 'dwell' period during any part of the Hydrocheck stroke and operates by applied air pressure which closes the hydraulic circuit ahead of the needle valve (C). On Standard Duty models the skip valve must also be closed when the stop valve is applied. Both valves should be operated by the same pressure as the main actuating air cylinder feed.

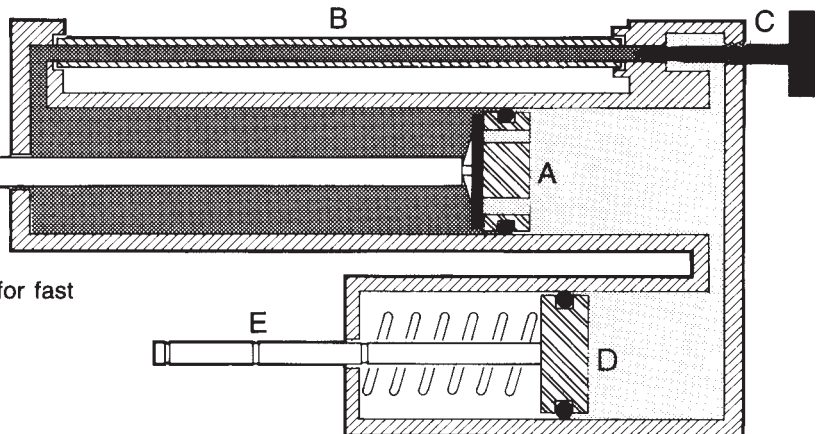
Note:

Thrust loads must not exceed 5337N (1200 lb f) for Standard Units or 13344N (3000 lb f) for Heavy Duty Models.

Schematic diagrams showing oil Flow and working principles of Hydrochecks.

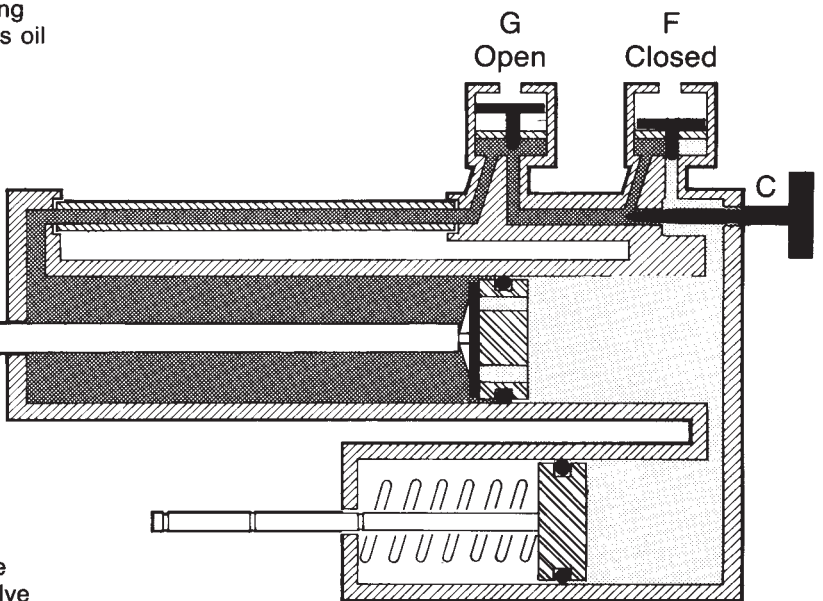
Fig 2.

Basic outward checking unit



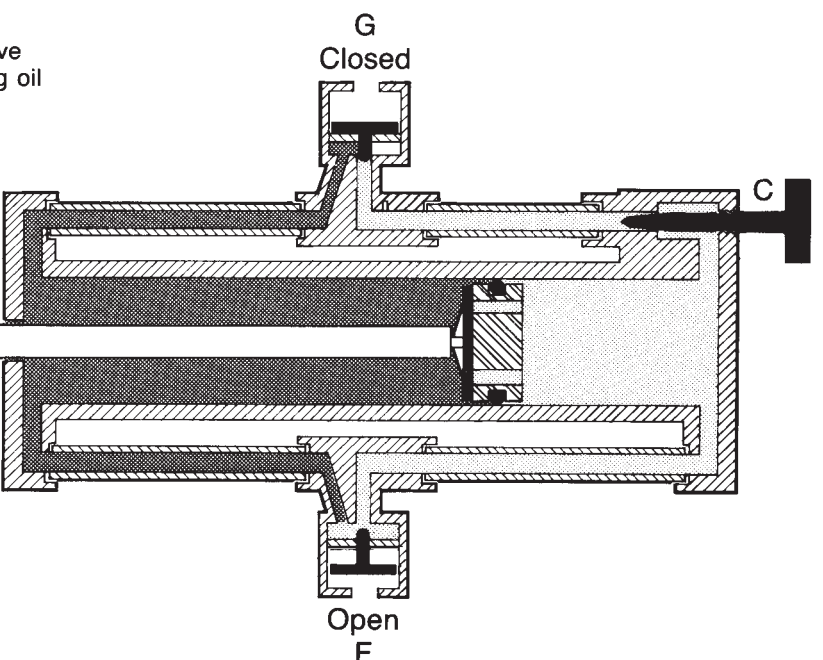
- A. Piston with plate valve to permit rapid flow for fast retract.
- B. Oil transfer tube.
- C. Manually set speed regulator needle valve.
- D. Spring loaded piston compensates for varying internal piston rod volume. Cylinder provides oil reservoir.
- E. Indicator rod for oil content.



Heavy duty outward checking unit with 'skip' and 'stop' valves



- F. Skip valve: relieving maintained air pressure opens valve, oil flow by-passes regulator valve permitting fast movement of piston rod.
- G. Stop valve: applying air pressure closes valve preventing piston rod movement by stopping oil flow.

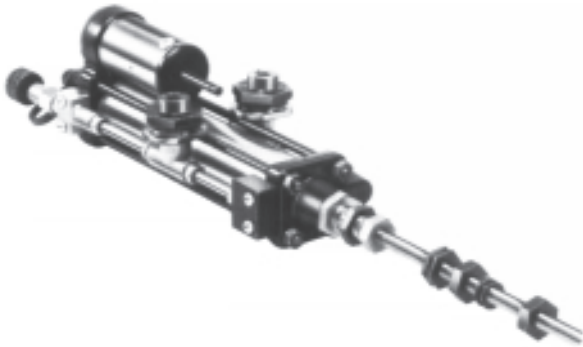
Standard outward checking



-  oil under checking load
-  low pressure oil

Hydrochecks

Standard duty series



How to order

B181 - XX11 - XXX

Direction		Control		Stroke mm
1	Outward check	1	Standard	050
2	Inward check	2	STD + Skip	075
		3	STD + Stop	100
		4	STD + Skip/Stop	150
				225
				300
				375
				450

e.g. B181-1311-150 = Standard Duty Outward Checking Model with Stop Valve x 150mm stroke.

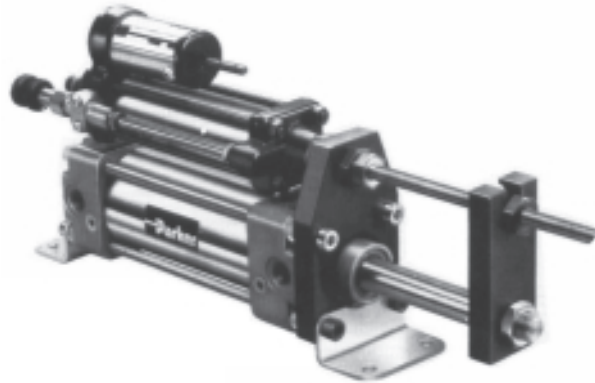
Note:
Minimum stroke available with skip or stop facility is 100mm.

Repair kit

Part no.	B732-504
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Hydrocheck mounting kit

For New Generation I.S.O. Cylinders



How to order

Part Nos.

Bore size	Kit part no.
50	50-2800H
63	63-2800H
80	80-2800H*

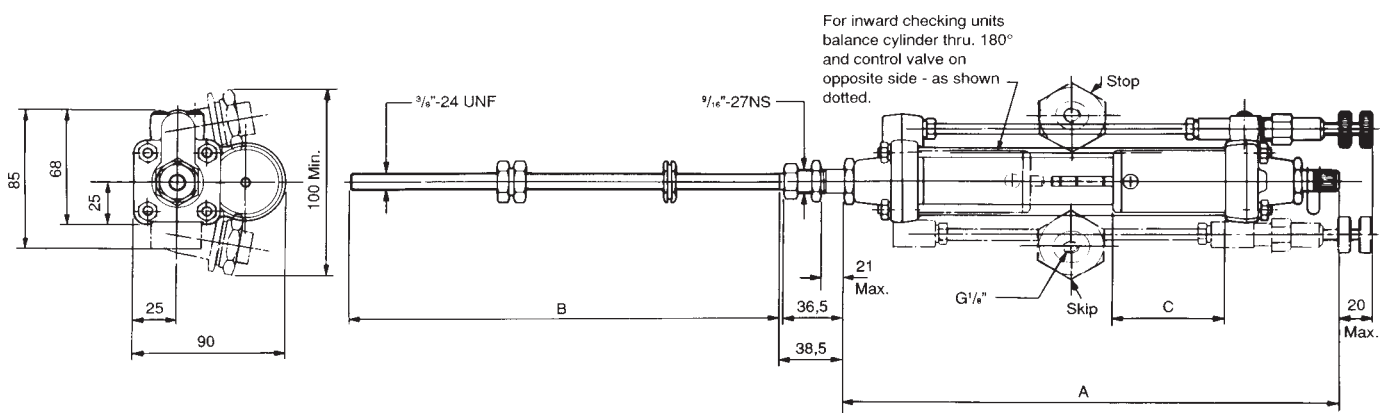
Note:
The hydrocheck mounting kit is suitable for 50mm, 63mm and 80mm bore sizes only.

The kit contains: 1 mounting plate
1 actuator arm
1 spacer
4 mounting bolts.

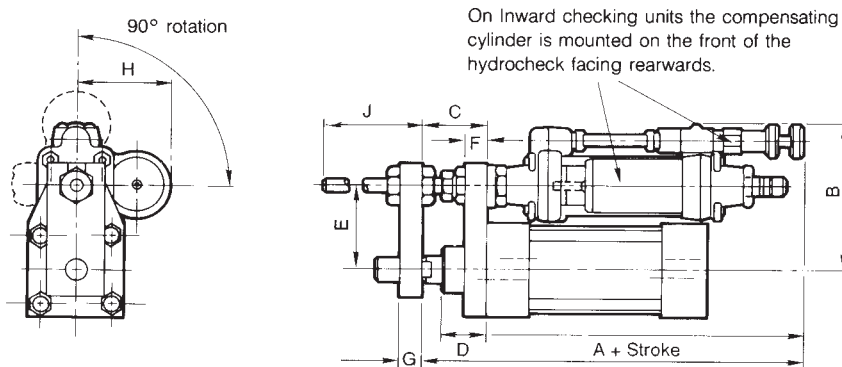
Dimensions (mm)

Standard duty

Part number	A	B Thread	C
B181-xxxx-050	200	254	67
B181-xxxx-075	226		
B181-xxxx-100	251		
B181-xxxx-150	302		
B181-xxxx-225	378		
B181-xxxx-300	454	305	168
B181-xxxx-375	530	381	
B181-xxxx-450	606	457	



Hydrocheck mounting kits



Dimensions (mm)

Cyl. Ø	A + stroke	B	C	D	E	F	G	H
50	213,5	105	37	29	60	16	16	65
63	213,5	110	37	29	65	16	16	65
80	232,5	123	46	35	78	16	16	65

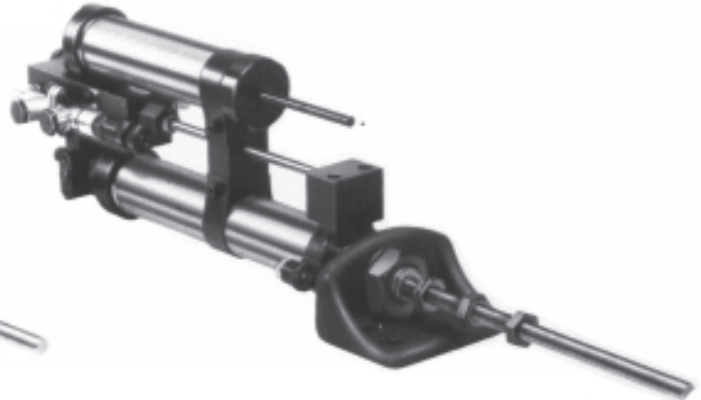
Strokes	J
50-225	240
300	291
375	367
450	443

Hydrochecks

Heavy duty series



Heavy duty single barrel double acting series



How to order

B181 - XXX1 - XXX

Direction		Control		Stroke mm
5	Outward check	11	Standard	050
6	Inward check	21	STD + Skip	075
		31	STD + Stop	100
		41	STD + Skip/Stop	150
				225
				300
				375
				450

How to order

B181-9XX1-XXX

Inward & Outward Checking	Standard	Advance return			Stroke mm
		Skip	Stop	Skip	
	01	-	-	-	100
	03	X	-	-	150
	05	-	X	-	225
	07	X	X	-	300
	09	-	-	X	375
	11	X	-	X	450
	13	-	X	X	
	15	X	X	X	
	17	-	-	-	X
	19	X	-	-	X
	21	-	X	-	X
	23	X	X	-	X
	25	-	-	X	X
	27	X	-	X	X
	29	-	X	X	X
	31	X	X	X	X

e.g. B181-5111-450 = Heavy Duty Outward Checking Model + 450mm stroke.

e.g. B181-9311-375 = Double Acting Model with skip and stop on both advance and return strokes + 375mm stroke.

Repair kit

Part no.	B732-505	Heavy duty
Part no.	B732-507	Heavy duty double acting

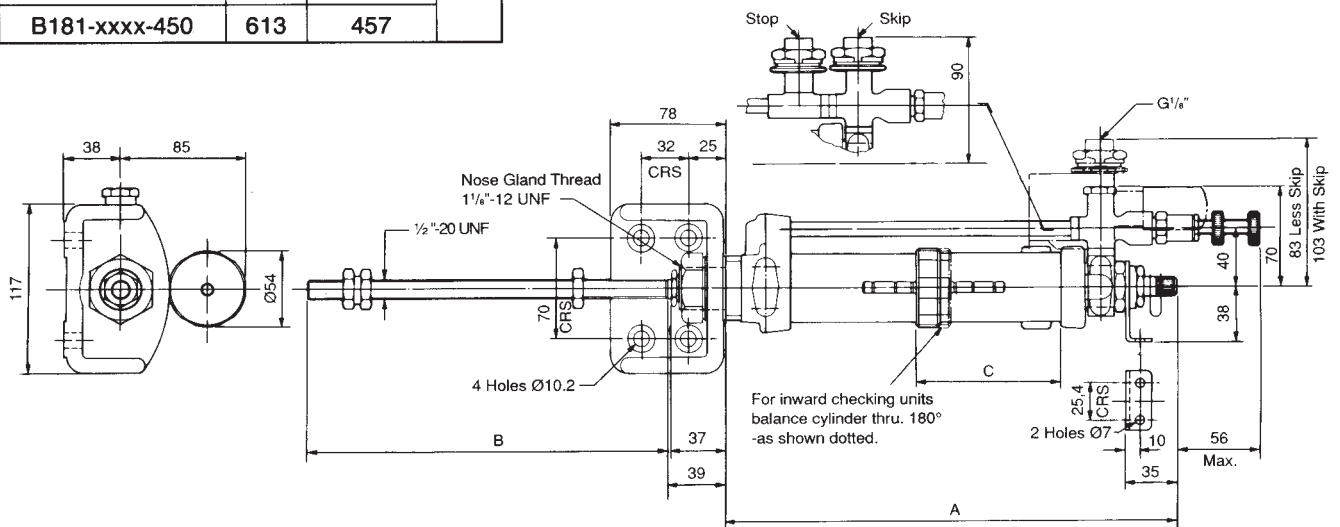
Note:

Minimum stroke available with skip or stop valves is 100mm

Dimensions (mm)

Heavy duty

Part number	A	B Thread	C
B181-xxxx-050	206	254	78
B181-xxxx-075	323		
B181-xxxx-100	257		
B181-xxxx-150	308		
B181-xxxx-225	384	305	192
B181-xxxx-300	460		
B181-xxxx-375	537		
B181-xxxx-450	613	457	



Heavy duty single barrel double acting

Part number	A	B Thread	C
B181-9xxx-100	257	257	78
B181-9xxx-150	308		
B181-9xxx-225	384		
B181-xxxx-300	454	305	168
B181-xxxx-375	530	381	
B181-xxxx-450	606	457	

