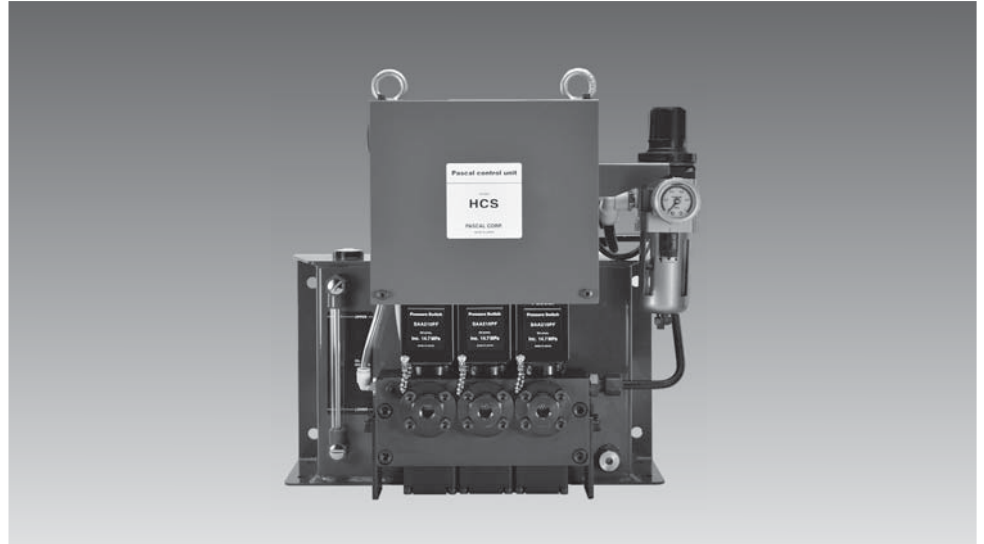


Pascal control unit

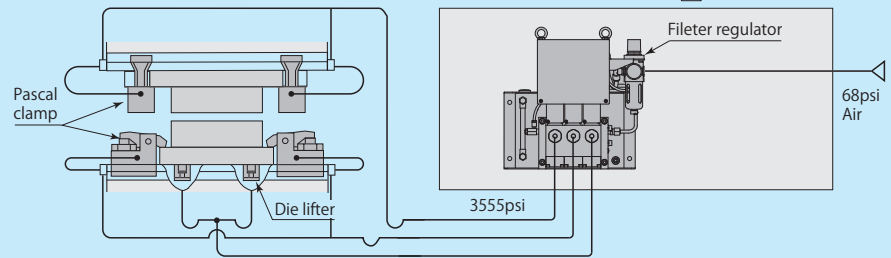
model **HCS** Pneumatic-hydraulic power control unit

Features

Pascal control unit model HCS is a power pack unit consisting of Pascal pump and air solenoid operated non-leak valve with oil tank. Its compact design can fit in limited space of the machine and it is suitable for small size of press machine as a power source of clamp system.



Example of control circuit



Model and specifications

Model	HCS [circuit symbol] -H2 [option symbol] N : NPT port
Pascal pump model	HPX6308U-D
Discharge pressure	3555 psi
Set air pressure	68 psi
Discharge oil volume (at no load)	0.42 US gal/min
Tank capacity	HIGH-LEVEL 0.92 US gal / LOW-LEVEL 0.40 US gal
Applicable examples of Pascal clamps	TXA10 x 8 / TYA10 x 8

- Fluid used : General mineral based hydraulic oil (ISO-VG32 equivalent) ■ Working temperature range : 41~122 °F
- Standard working pressure : 3555 psi ■ Maximum working pressure : 4480 psi (Pilot air pressure 71 psi)
- Orifice diameter : (PH→A) 0.0195 in² (A→R) 0.0456 in² ■ Air consumption : Max.14.12 cfm
- Set pressure of pressure switch : Clamp circuit··INC. 2130 psi Die lifter circuit··DEC. 284 psi

※Electrical power voltage shall be specified as per the following classifications.

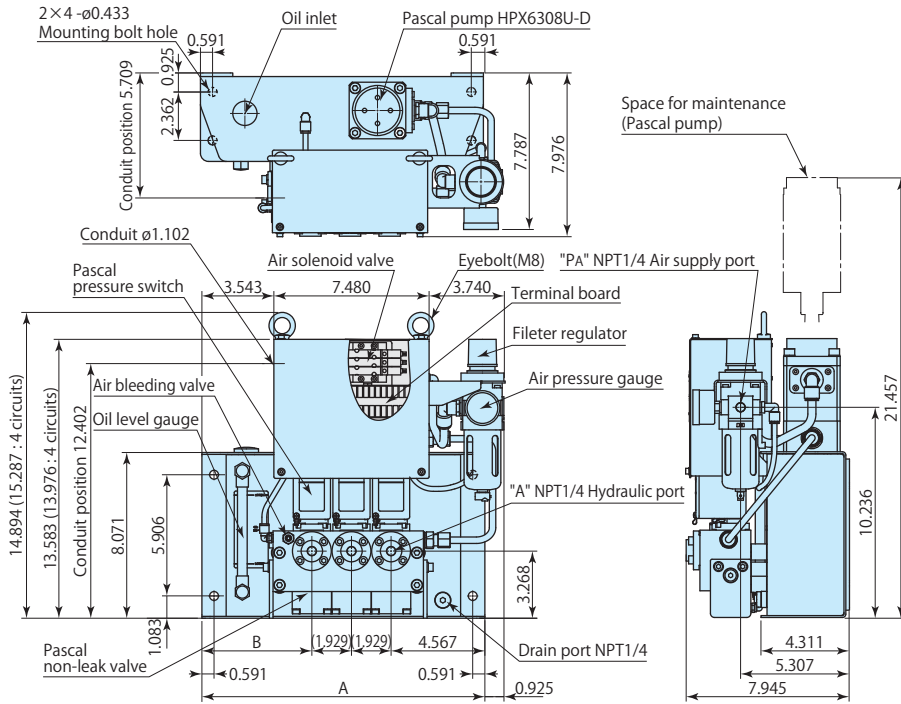
	Electrical power	Hydraulic circuit specifications	Symbol	
A	AC100V	Clamp	Single solenoid	D
B	AC200V		Double solenoid	L
C	AC110V	Die lifter	Single solenoid	F
D	DC 24V		Double solenoid	J
E	AC220V			

Upper clamp	Lower clamp	Die lifter	Pascal pump Model x quantity	Solenoid valve	
				Single solenoid	Double solenoid
	1	—	HPX6308 x 1	HCS [circuit symbol] - H2 D - N	HCS [circuit symbol] - H2 L - N
1	1	—		HCS [circuit symbol] - H2 DD - N	HCS [circuit symbol] - H2 LL - N
2	1	—		HCS [circuit symbol] - H2 DDD - N	HCS [circuit symbol] - H2 LLL - N
2	2	—		HCS [circuit symbol] - H2 DDDD - N	HCS [circuit symbol] - H2 LLLL - N
1	1	1		HCS [circuit symbol] - H2 DDF - N	HCS [circuit symbol] - H2 LLJ - N
2	1	1		HCS [circuit symbol] - H2 DDDF - N	HCS [circuit symbol] - H2 LLLJ - N

Pascal control unit

model **HCS**

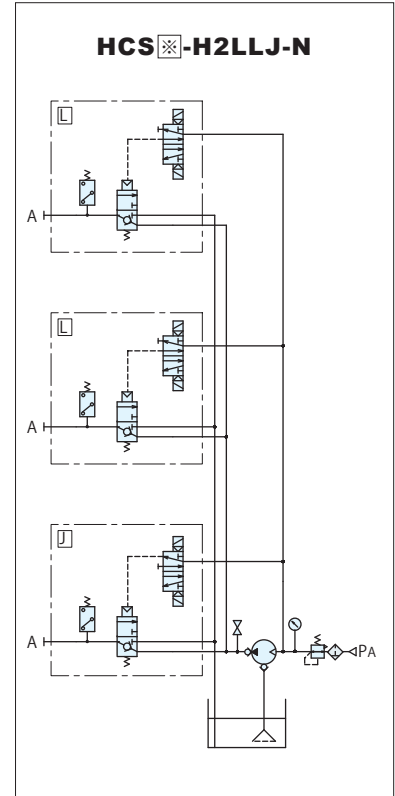
Dimension (Unit : inch)



Number of hydraulic circuit	A (inch)	B (inch)	Mass (lbs)
1	13.780	9.213	37.5
2	13.780	7.283	44.1
3	13.780	5.354	48.5
4	15.748	5.394	57.3

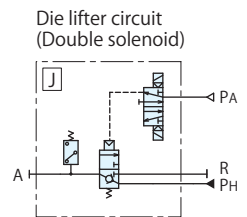
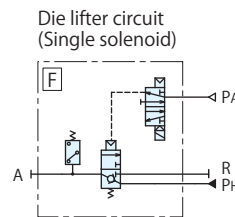
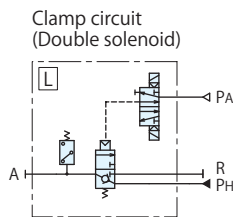
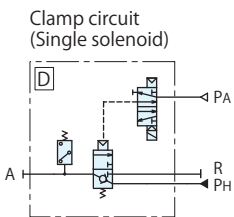
Refer to separate document for details the details of hydraulic circuit and option.

Circuit diagrams



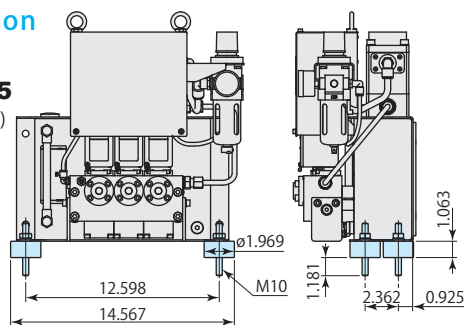
Option	Symbol
Oil pressure gauge for each circuit	U

Circuit symbols



Antivibration rubber

model **ZPS-B5**
(Option 4 pieces)



Stand

model **ZPS-S0**
(Option)

