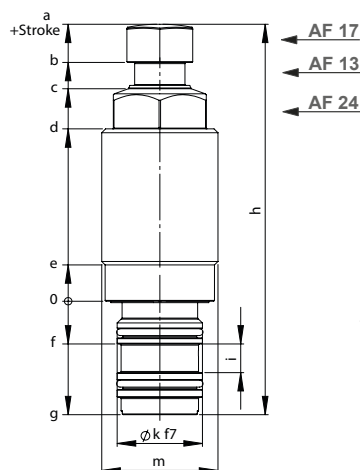


# Work supports with threaded body

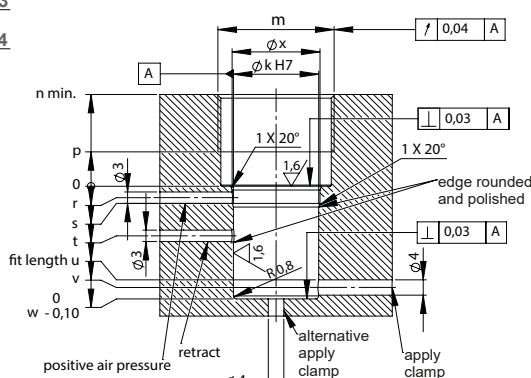
actuation double acting hydraulically, contact by spring force, pmax. 500 bar, positive air pressure

**280-3**

Issue: 08/2025



## Installation contour



Webcode: 028003

## Technical data:

Support bolt stroke	[mm]	8	15
Support bolt Ø	[mm]	16	16
perm. support load at 500 bar	[kN]	9	9
Oil pressure, min. (clamping)	[bar]	100	100
Oil pressure, min. (retract)	[bar]	20	20
Tightening torque	[Nm]	60	60
Spring force, min./max.	[N]	12/28	9/20
perm. volume flow	[cm³/s]	25	25
Operating temperature, max.	[°C]	+80	+80
Elastic Length Change at load and 500 bar	[µm/kN]	5	5
a	[mm]	72.5	79.5
b	[mm]	62.5	69.5
c	[mm]	55.6	62.5
d	[mm]	45.1	52.5
e	[mm]	9.5	9.5
f	[mm]	10	10
g	[mm]	29.5	33.5
h	[mm]	102.5	113
i	[mm]	7.5	8
k	[mm]	22	22
m	[mm]	M30x1.5	M30x1.5
n	[mm]	24	24
p	[mm]	9	9
r	[mm]	3	3
s	[mm]	4.5	4.5
t	[mm]	13	14.5
u	[mm]	24.5	31.5
v	[mm]	26.5	33.5
w	[mm]	29.5	36.5
x	[mm]	22.7	22.7
Weight approx.	[kg]	0.32	0.36
Order no.		ASE-016-08-03-003	ASE-016-15-03-003

Kantseal included in the scope of delivery.

## Mode of operation:

A spring is preloaded via a double-acting piston, which applies the support bolt to the workpiece. When the pressure rises above 50 bar, the support bolt is clamped. The support bolt is also retracted hydraulically.

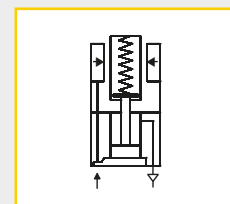
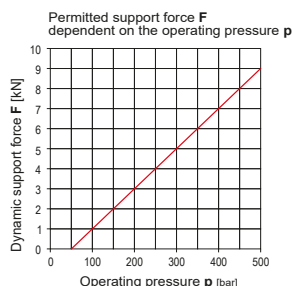
## Basic information:

Support bolts must not be subjected to transverse or tensile forces at any time. Machining and clamping forces can add up and should not exceed the pressure-dependent support force. A safety factor of min. 1.5 is recommended.

Chip nests in the area of the support bolt compromise the safe function and must be avoided.

## Positive air pressure:

To provide better protection for the work support against liquid ingress, it is recommended to apply a maximum overpressure of 0.5 bar. The positive air pressure should only be switched on after the plunger has been extended and switched off again before it is retracted.



## Description:

If vibration and deflection must be avoided while machining workpieces, these work supports are the ideal solution.

The threaded body elements allow horizontal and vertical mounting into the clamping fixture.

There for space-saving arrangements can be implemented even in cramped installation conditions.

Due to the double-acting function (apply/clamp and retract), which is performed with hydraulic oil via drilled channels, the retraction of the support bolt is performed quickly and safely.

## Advantages:

- Application always via spring force
- protective metal wiper
- space-saving installation possibilities
- Installation possible horizontally/vertically
- clamping separately or combined with clamping possible
- More safety due to double acting function.
- Supporting force up to 9 kN

We also design and manufacture customized variants!



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