

# STANDARD PNEUMATIC CIRCUIT BOARDS



## CM-033

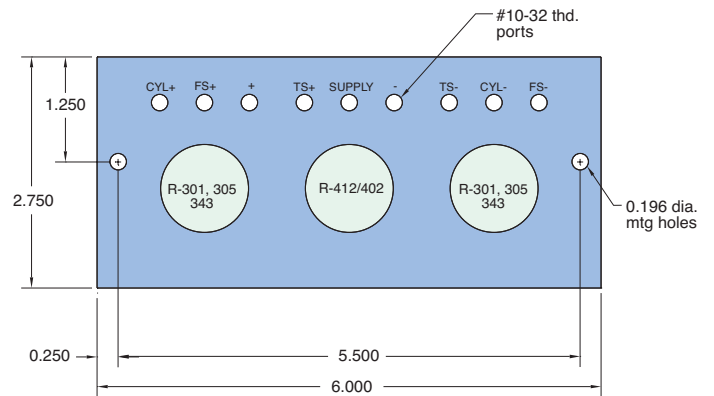
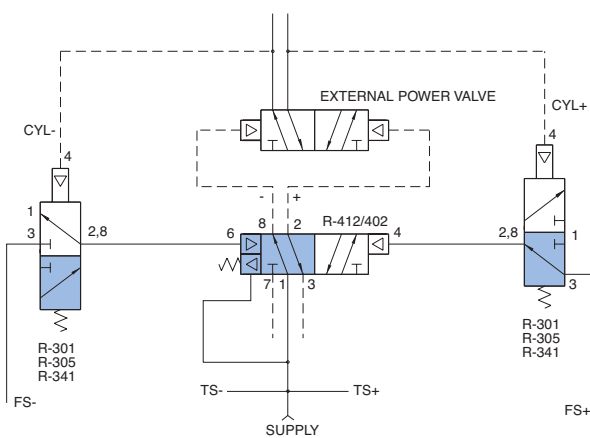
### Cycling Without Limits with External Power Valve

Size: 6" x 2 3/4" x 9/16" thick - 3 modules



**Use:** When cycling without limits function is desired from cylinder with bore or stroke requiring very high flow rates to achieve desired cycle speed.

**Operation:** Similar to CM-06 except output of R-402 is used to pilot a larger pneumatically piloted power valve. Operates as either a straight back pressure sensing system or the use of an R-341 will provide time delay after pressure decay.



## CM-034

### Subplate for Back Pressure Latched with Clamp Operated with CM-023

Size: 4 1/4" x 2 1/2" x 13/16" thick - 2 modules

**Use:** For operation of a clamp or collet system where two hand no tie down input is required to be held continuously until clamp is fully engaged. Two hand no tie down circuit is reengaged to release the clamp mechanism.

**Operation:** Output of the CM-023 goes to port 1 or R-431 (a). This provides output at port 8 which latches in port 6 and port 5 of R-431 (b). R-431 (b) output shifts to port 2 giving clamp close output and also gives output to LV supply. The CM-023 must remain actuated until the valve is actuated or the spring on the R-431 will return both valves to the clamp open position. When the clamp has fully closed the limit valve is actuated and its output enters at limit input piloting ports 4 of both R-431 (a) and (b). This now latches both valves in the clamp closed position. A new input from the CM-023 now sends a signal from port 1 through port 2 of R-431 (a) which latches port 5 of R-431 (a) and pilots port 6 of R-431 (b). Power output from (b) now shifts to port 8 to unclamp. When the CM-023 palm buttons are released, both valves return to the starting position as shown and the circuit is ready for another operation.

