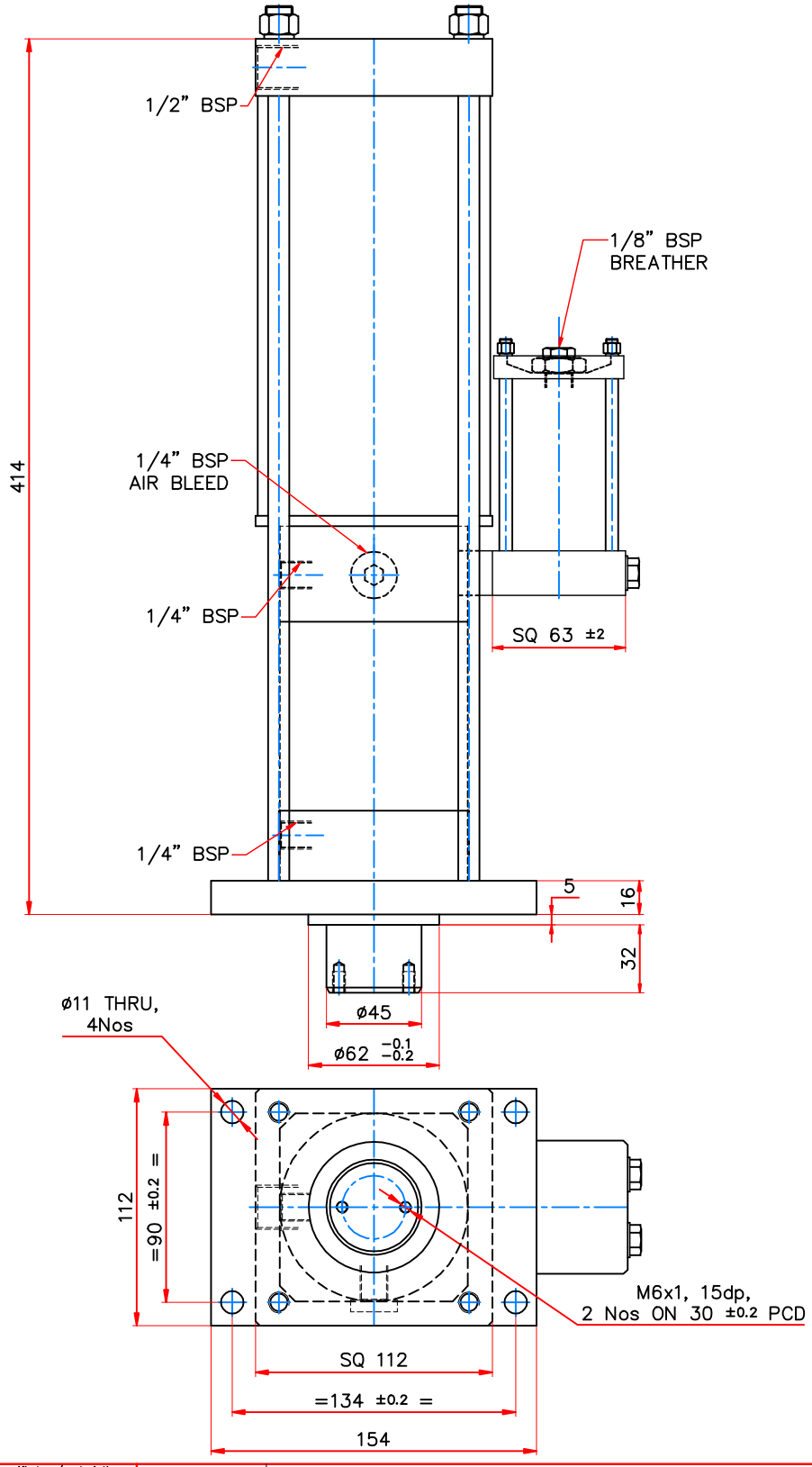
DO NOT MEASURE DRAWING . IF IN DOUBT PLEASE ASK.



Surface Finish	Ra Value-μ	Roughness No.
▽	50	N12
	25	N11
	12.5	N10
▽▽	6.3	N9
	3.2	N8
	1.6	N7
▽▽▽	0.8	N6
	0.4	N5
	0.2	N4
▽▽▽▽	0.1	N3
	0.05	N2
	0.025	N1

Unspecified m/c deviations (med to IS 2102)		
Linear–Length or Diameter		
Over	Upto & inc.	TOL
–	6	±0.1
6	30	±0.2
30	120	±0.3
120	315	±0.5
315	1000	±0.8
1000	2000	±1.2
Length of shorter side of angle		
Over	Upto & inc.	TOL
–	6	±1°
6	30	±30'
30	120	±20'
120	315	±10'

TITLE	HYDRO–PNEUMATIC TOOL DECLAMP CYLINDER
MODEL	PCS4–10045–VC13
STROKE	13
INT. RATIO	1:16
MOUNTING	FRONT FLANGE
RATED PR.	7 kg/cm²
THEORETICAL THRUST @ 4 kg/cm²	3200 kgf
THEORETICAL THRUST @ 5 kg/cm²	4000 kgf
THEORETICAL THRUST @ 6 kg/cm²	4800 kgf

QTY
SCALE NTS

DRAWN	RBP	04/06/15
CHKD	RKS	04/06/15
APPD	RKS	04/06/15

Note: Remove all sharp corners 0.5x45°
All dimensions are in mm unless specified

ALTERATION

ORSETT HYDRAULICS PVT. LTD.
AHMEDABAD INDIA