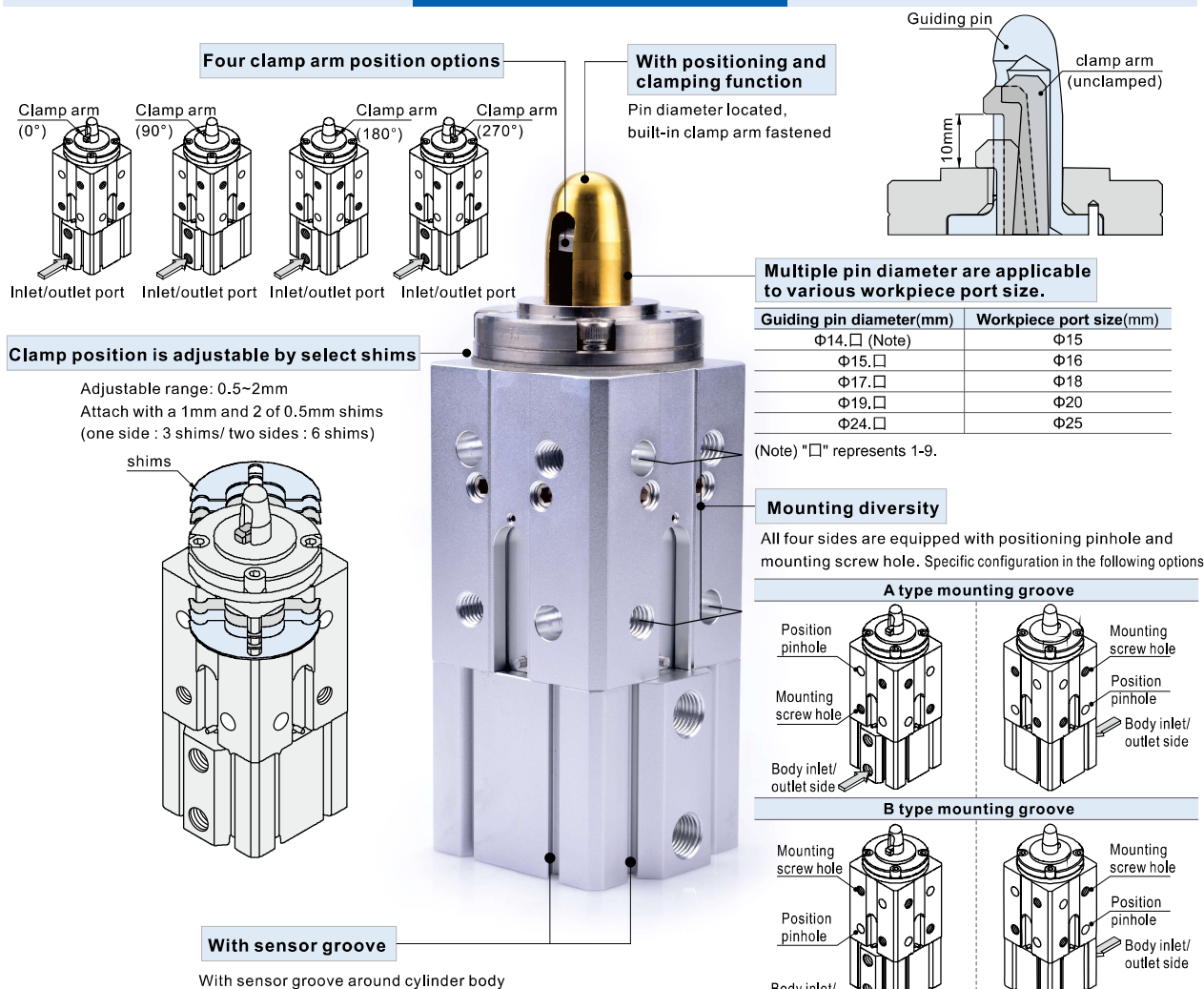




# Pin clamp cylinder—AQK Series

## Compendium of AQK Series



## Installation instructions (general)



1. Before piping is connected, it should be thoroughly blown out with air (flushing) or washed to remove chips, cutting oil and other debris inside the pipe.
2. operating fluid need to be filtered by 40μm filter element.
3. During low temperature environment, cryogenic measures should be taken to prevent freezing water in the system.
4. Beware of the surface rust on the cylinder after disassemble for a long time. Dust cover should be added on inlet port and apply anti-rust oil on rod and action part.
5. Please attach a meter-out controller at the port to protect product life of cylinder and jig.



# Pin clamp cylinder

## AQK Series



### Specification

<b>Bore size(mm)</b>	<b>50</b>	
Acting type	Double acting	
Fluid	Air(to be filtered by 40μm filter element)	
Operating pressure	0.15~1.0MPa(22~145psi)	
Proof pressure	1.5MPa(215psi)	
Temperature °C	-20~70	
Cushion type	Bumper	
Clamp stroke	Without shims: 10 <sup>0</sup> <sub>-0.5</sub> mm	With shims: 10~12mm
Port size [Note]	1/4"	

[Note] PT thread is available.

Please refer to page 362 for sensor applications.

### Product feature

1. According to JIS standards
2. Pin surface adopted titanium alloy processing to enhance friction resistance.
3. Part of cylinder front cover has equipped with metallic rod wiper that can effectively remove slag and debris etc.
4. Possible to mount on 4 surfaces.
5. With sensor groove around cylinder body, easy to mount sensors.

### Ordering code

**AQK50 S A A A □ □-177X340**

① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨

① <b>Model</b>	AQK : Pin clamp cylinder			
② <b>Bore size</b>	50			
③ <b>Magnet</b>	S : With magnet			
④ <b>Install dim.</b>	A : Mounting screws M10X1.5/ pinhole diameter Φ10		B : Mounting screws M12X1.75/ pinhole diameter Φ10	
⑤ <b>The relative position of screw surface and pinhole</b>	A:A type mounting groove	B:B type mounting groove	C:C type mounting groove	D:D type mounting groove
⑥ <b>Clamp arm position</b>	A : Clamp arm same side with inlet port	B : Clamp arm at 90° with inlet port	C : Clamp arm at 180° with inlet port	D : Clamp arm at 270° with inlet port
⑦ <b>Adjusting shims</b>	Blank: Without adjustable shims			2 : With adjusting shim 2mm (2 of 0.5mm+1 of 1mm)
⑧ <b>Thread code</b>	Blank: PT1/4			
⑨ <b>Guide pin specification code</b>	Code [Note]	Pin height (without shims)	Code	Pin height (with shims)
	14□X290	29	14□X310	31
	15□X290	29	15□X310	31
	17□X340	34	17□X360	36
	19□X340	34	19□X360	36
	24□X340	34	24□X360	36
		Pin diameter	Workpiece port size	
		Φ14.□	Φ15	
		Φ15.□	Φ16	
		Φ17.□	Φ18	
		Φ19.□	Φ20	
		Φ24.□	Φ25	

[Note] "□" means 1-9. Take 177X340 for example, 177 means pinhole diameter 17.7mm, 340 means guiding pin height 34mm.

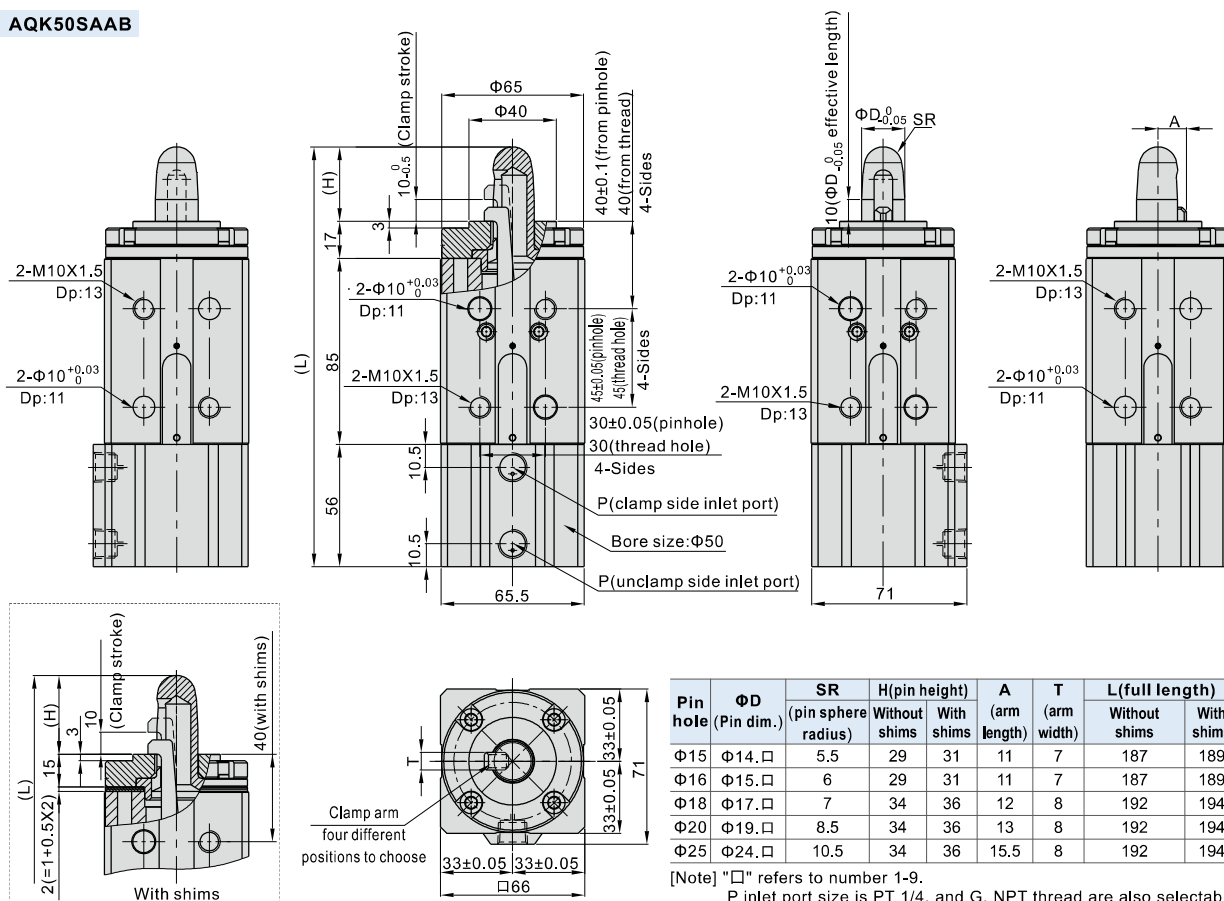
## AQK Series

[illegible]

NO.	Item	Material	NO.	Item	Material
1	back cover	Aluminum alloy	17	guiding pin	Alloy steel
2	body	Aluminum alloy	18	lever	die steel
3	Bumper	NBR	19	socket set screws	Alloy steel
4	Piston	Aluminum alloy	20	spring washer	Spring steel
5	wear ring	Wear resistant material	21	screws	Alloy steel
6	Piston packing	NBR	22	pin	Stainless steel
7	magnet	plastic	23	cap	Alloy steel
8	magnet holder	Aluminum alloy	24	Pin	Stainless steel
9	rod	S45C hard chrome plating bar	25	pin body	Aluminum alloy
10	o ring	NBR	26	socket set screws	Alloy steel
11	bushing	Wear resistant material	27	wiper ring	Stainless steel
12	C clip	Spring steel	28	spool packing	NBR
13	Pin	Stainless steel	29	front cover	Aluminum alloy
14	dedust gate	Aluminum alloy	30	gasket 1	Stainless steel
15	E clip	Spring steel	31	gasket 2	Stainless steel
16	PIN	S45C grinded bar			

Note: inner structure & material data sheet is based on certain bore size.  
Please contact AirTAC if you need inner structure & material data sheet for specific bore size.

**AQK50SAAB**

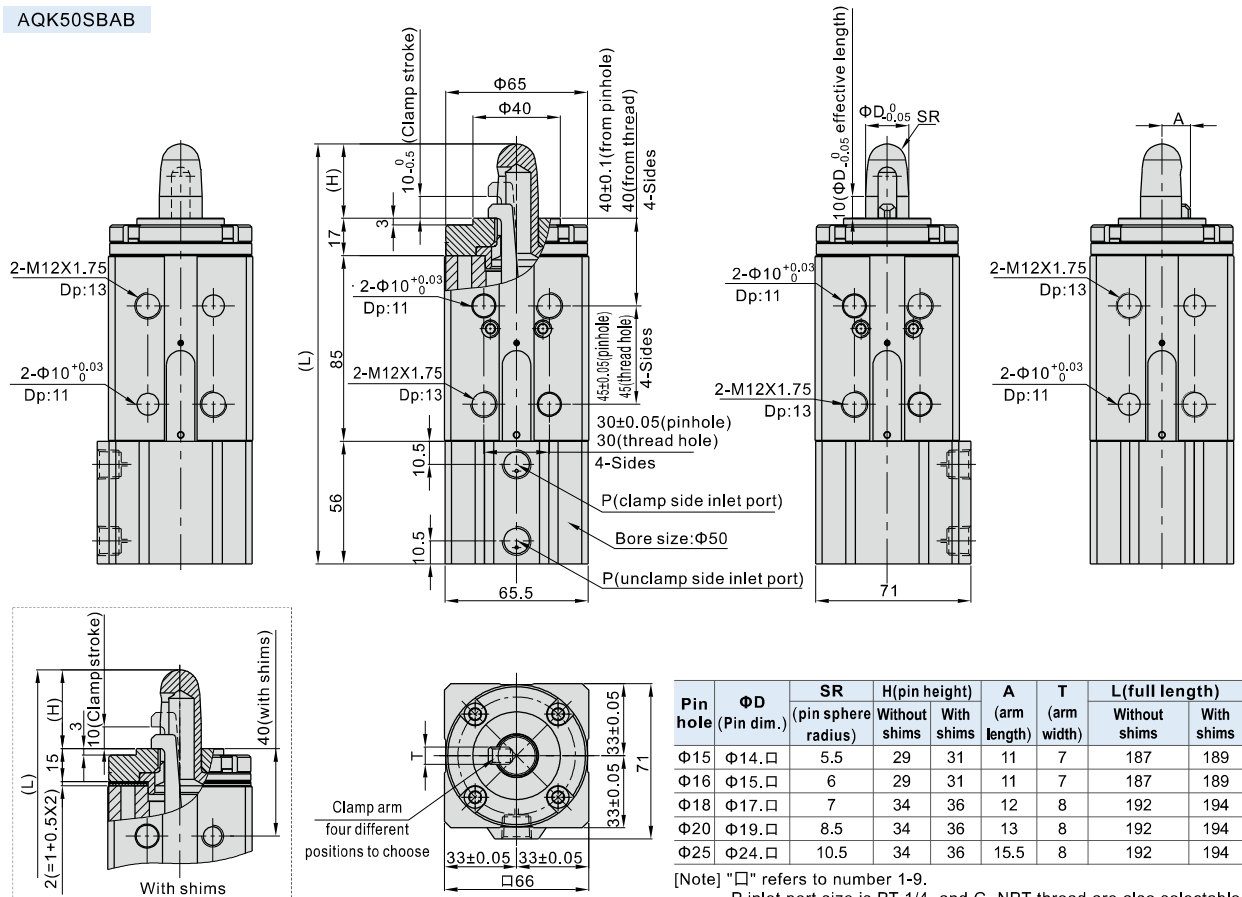


[Note] "□" refers to number 1-9.  
P inlet port size is PT 1/4, and G. NPT thread are also selectable.

# Pin clamp cylinder

## AQK Series

AQK50SBAB



## Installation instruction

### 1. Sensor options and mounting :

Applicable sensors for AQK series are CMSG(DMSG/EMSG). Those sensors can easily fix on the cylinder as the right figure, other accessories are not needed. Loosen the mounting screws on sensor, import it to mounting groove to the suitable position and it can be fixed after tighten screws.

Also: in the power magnetic environment, you should choose the anti-interference sensor, the specific selection of the reference P336 page.

### 2. Since the cylinder performs both positioning and clamping simultaneously, any other application may cause an accident or damage to the cylinder.

### 3. The thickness of clamping workpiece should be under 10mm, the clamping cylinder with shim can clamp up to 12 mm (with all shims removed).

### 4. Only apply to the workpiece has flat side, do not clamp without setting the workpiece.

### 5. Please attach a speed controller and adjust the cylinder speed by meter-out.

### 6. prevent any foreign material, such as machining chips, from entering into internal cylinder.

And the opening part of a guide pin should not face in the same direction as oncoming spatter.

If the spatter enters the cylinder from the opening part of the guide pin, it will shorten the product life and cause a malfunction.

### 7. Consider the welding point of the guide pin when determining the direction of the clamp arm setting.

The clamp arm will be damaged if clamping is performed at the welded point of the guide pin. Therefore, set the clamping directions as illustrated right figure to prevent the clamping damaged from welded point.

### 8. If sparks enters the cylinder body, remove it by first detaching the covers. Do not scratch or make dents on the sliding parts of the piston rod by striking it or grasping them with other objects. Or it may cause seal damage and leakage.

