

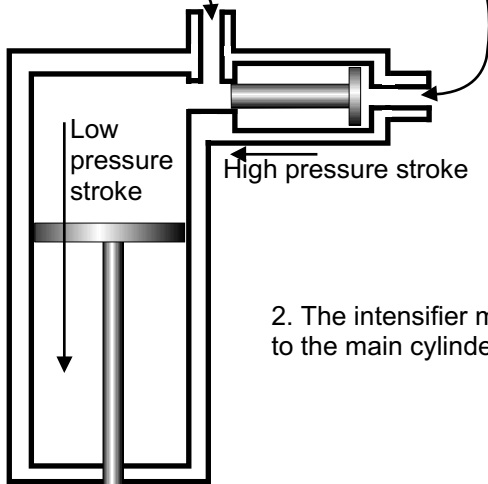
Fitup problems are bad with Air-over-oil Cylinders.

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1. Air-over-oil cylinders have two pressures:

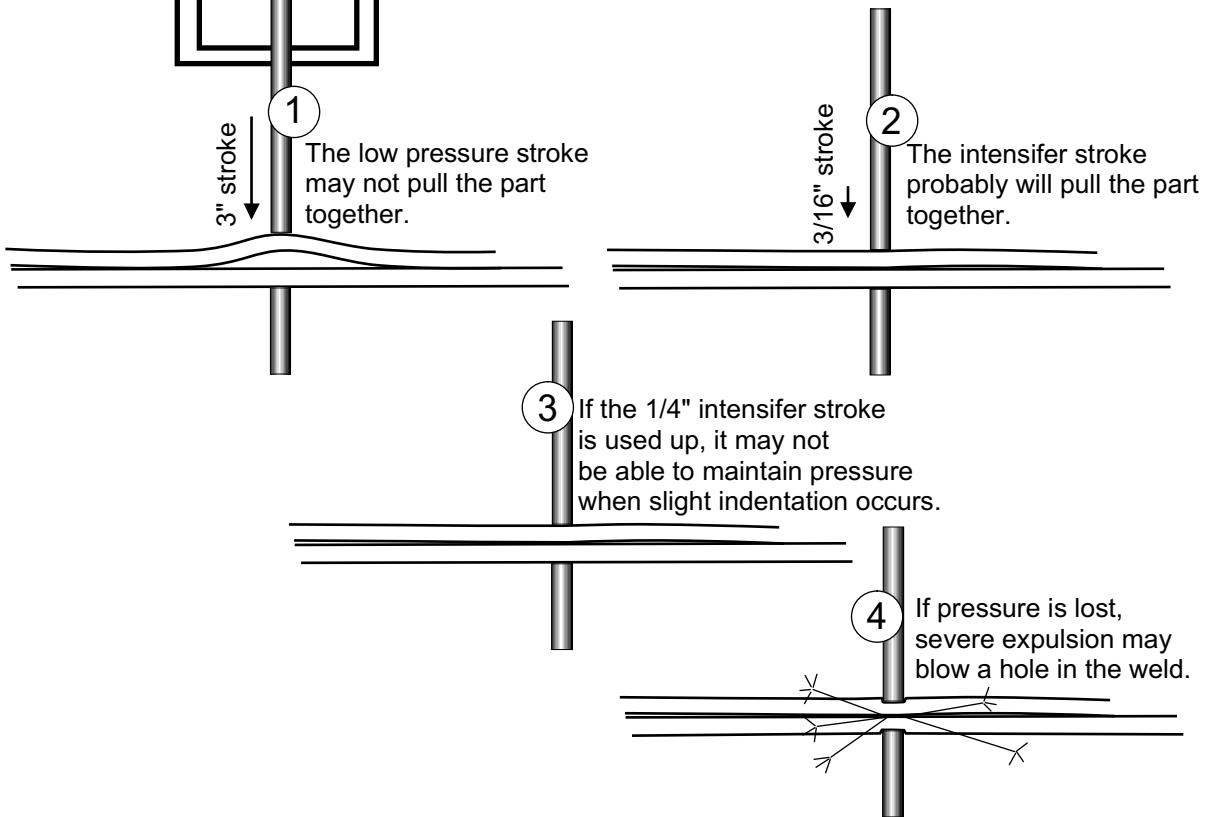
- A. They close under low pressure.
- B. They "intensify" to high pressure before welding.



Time is allowed by the control to complete the low pressure stroke.

Then the "intensification" stroke follows, and the intensifier seals off the oil passage for the low pressure stroke.

2. The intensifier mechanism can only add 1/4" to the main cylinder stroke, then it bottoms out.



Air-over-oil cylinders are available with a 1/2" intensifier stroke, but due to lack of understanding of this they are rarely used. Shame, as they cost only a little more.

Some success has been experienced by cycling the intensifier twice. This gives a chance to get a little more oil into the main cylinder.