

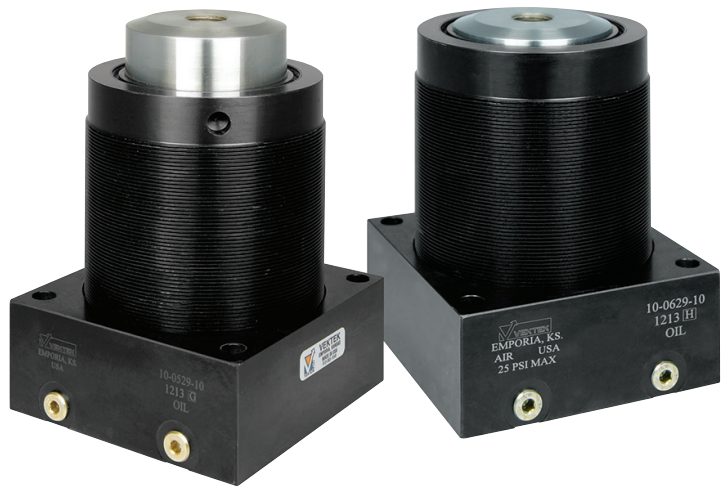
# Work Supports

20,000 lb. Spring and Air Advance

## Spring and Air Advance Models

B-19

- 20,000 lb. Work Support Capacity.
- Available in Spring and Air Advance.
- Clamp over with confidence.
- Large castings, no problem.
- Handles extra cutting loads effectively and efficiently
- Single Acting.
- Air Advance unit is an excellent "air spring".
- Spring Advance extended plungers maintain contact with the part during loading, exerting only spring force against the part. When hydraulic pressure is applied the plunger freezes without exerting any additional force on the part.



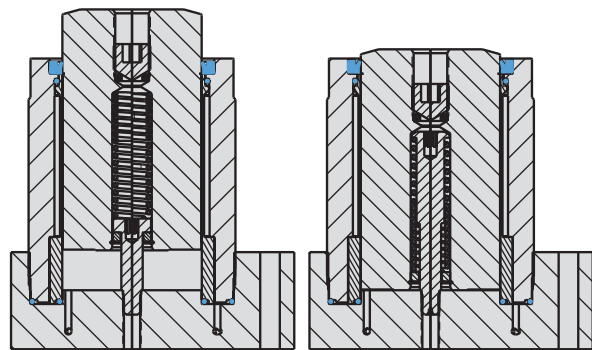
Precision fit plunger/sleeve assemblies allow VektorFlo® Work Supports to begin to lock at lower pressures and build support faster.

Consider Air Advance in flood coolant environments. Attach tubing to the vent port and route to clean dry air keeping coolant from being drawn in and becoming sticky on internal surfaces.

Special large diameter plungers and sleeves provide greater rigidity.

Stainless steel plunger and sleeve assemblies help guard against corrosion in most machining environments.

Standard SAE porting located in the base of the support for bolt down installation.



20,000 lb  
SPRING ADVANCE

20,000 lb  
AIR ADVANCE

ILS100605 REV B

Model No.	Support Capacity (lb.)*	Mounting Style	Hydraulic Connection	Contact Force (lb.)**	Stroke (in.)	Base Dimensions (in.)	Extended Height (in.)	Retracted Height (in.)	Oil Capacity (cu. in.)
<b>Spring Advance Work Supports, spring lifts plunger, part weight depresses plunger, hydraulic pressure locks in place.</b>									
10-0529-10	20000	Base	SAE Ports	38-72	0.82	1.99 x 4.75 x 4.88	6.97	6.15	3.37
<b>Air Advance Work Supports, air pressure lifts plunger against part; hydraulic pressure locks in place, spring retracts plunger</b>									
10-0629-10	20000	Base	SAE Ports	116	1.00	1.99 x 4.75 x 4.88	7.15	6.15	3.37

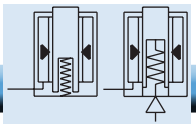
\* Support capacities are listed at 5,000 psi maximum operating pressure. Support capacities for other pressures must be determined by consulting the capacity graph on page B-20.

\*\* The maximum air pressure recommended for advancing the Air Advance Work Support plunger is 25 psi. Order air regulator Model No. 50-0440-01 (0 to 25 psi) to more precisely control plunger advance force.

## Dimensions

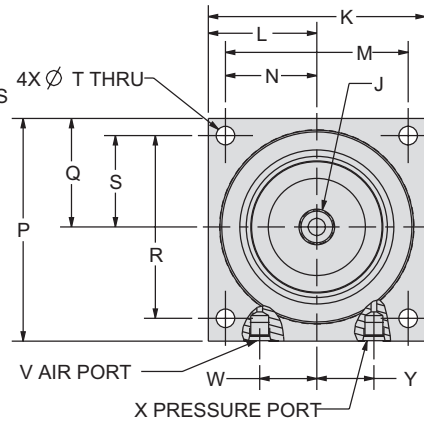
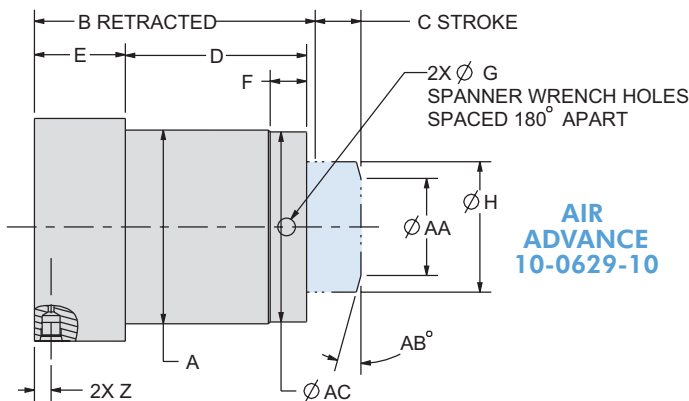
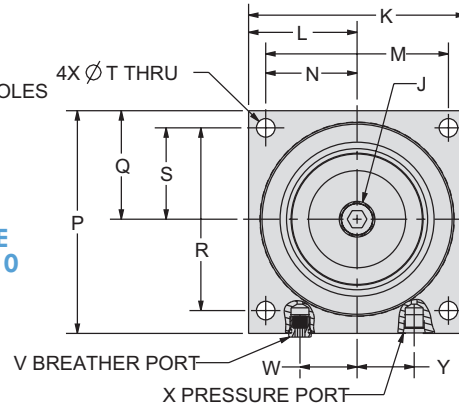
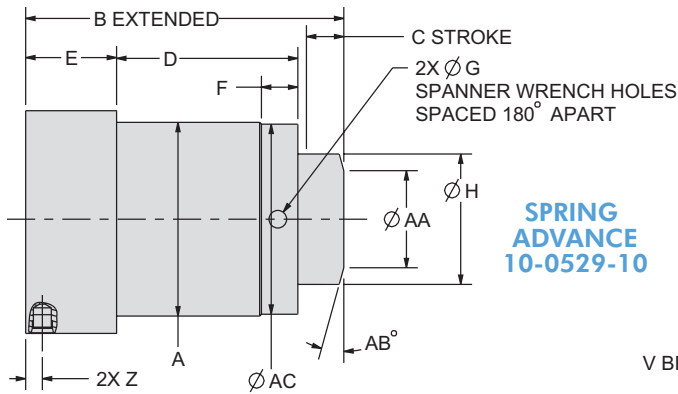
Model No.	A	B	C	D	E	F	G	H	J	K	L	M	N
<b>Spring Advance Work Supports, spring lifts plunger, part weight depresses plunger, hydraulic pressure locks in place.</b>													
10-0529-10	4 1/4-16	6.96	0.82	3.97	1.99	0.80	0.39	2.85	3/4-16 X 0.87	4.75	2.38	4.00	2.00
<b>Air Advance Work Supports, air pressure lifts plunger against part; hydraulic pressure locks in place, spring retracts plunger</b>													
10-0629-10	4 1/4-16	6.15	1.00	3.97	1.99	0.80	0.39	2.85	3/4-16 X 0.87	4.75	2.38	4.00	2.00

# Work Supports

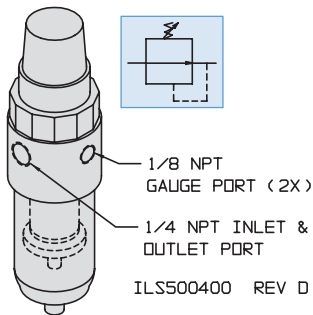


## 20,000 lb. Spring and Air Advance

B-20

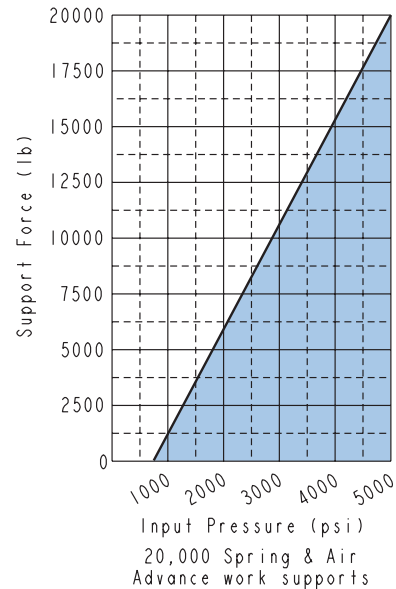


ILS100506 REV B



### Air Filter Regulator

Model No	PSI Output
50-0440-01	0-25 psi



ILS100608 REV A

The maximum air pressure recommended for advancing the Air Advance Work Support plunger is 25 psi. Order air regulator (0 to 25 psi) to more precisely control plunger advance force.

Ask us about air valves to control your work supports either manually or electrically.

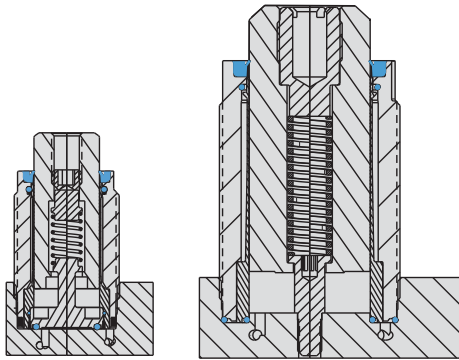
P	Q	R	S	T	V	W	X	Y	Z	AA	AB	AC
Spring Advance Work Supports, spring lifts plunger, part weight depresses plunger, hydraulic pressure locks in place.												
4.88	2.38	4.00	2.00	0.41	SAE 4	1.25	SAE 4	1.25	0.37	2.13	15	4.16
Air Advance Work Supports, air pressure lifts plunger against part; hydraulic pressure locks in place, spring retracts plunger												
4.88	2.38	4.00	2.00	0.41	SAE 4	1.25	SAE 4	1.25	0.37	2.13	15	4.16

# Work Supports

## Features and Capacity Graphs

B-10

### Spring Advance



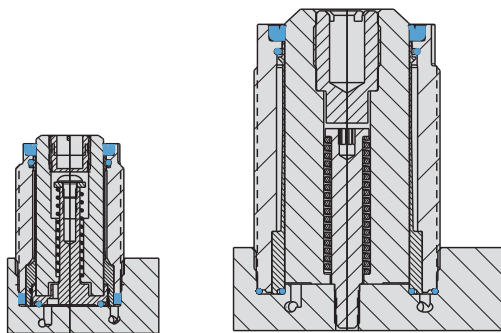
1000 & 2500 lb.

7500 & 12500 lb.

ILS100500 REV K



### Air Advance

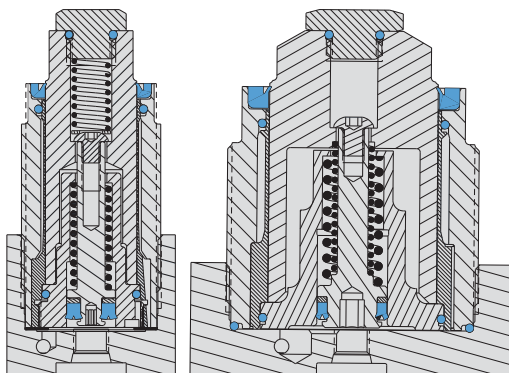


1000 & 2500 lb.

7500 & 12500 lb.

ILS100600 REV K

### Fluid Advance



1000 & 2500 lb.

4000 lb.

ILS100700 REV P

### Standard Features

- Highly repeatable; plus or minus 0.0002 inches.
- Standard Work Supports may be bolted up or down to mount directly on fixture plates. They may also be installed through a hole in the fixture and locked in place using retaining collars for easy adjustment.
- Standard SAE porting is located in the base of the support for easy access to both the clamp and vent ports (bronze filter installed before shipping).
- Design features insure VektorFlo® work supports last longer, stand up to harsh environments and abuse better than other models without these features.
- Proprietary wiper and seal designs reduce contamination and drag for longer lasting, better performing work supports.
- Special corrosion resistant plungers and sleeves reduce the tendency to stick.
- Special large diameter plungers and sleeves provide greater rigidity.
- Cartridge mount work supports available in all styles for installation into customer machined cavities.

