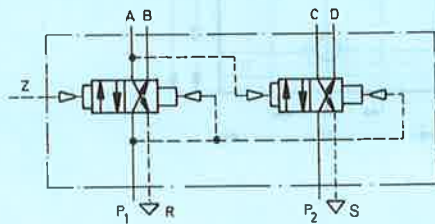


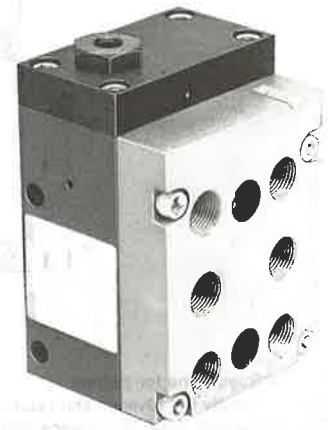
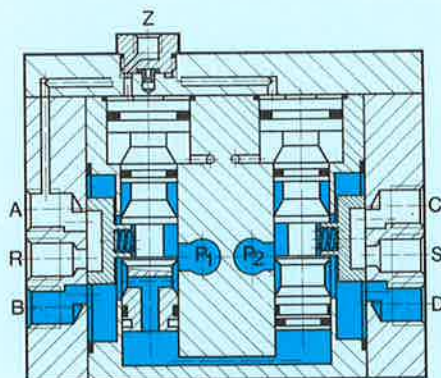
Single pilot valve,
spring return,
for pneumatic feed unit
Type VL-8-³/₈-B



This valve can be used to control functions of FESTO pneumatic feed units, such as the feed movement and alternating clamping.

In order to obtain a high clamping force together with a small feed force, different pressures can be applied at P₁ or P₂.

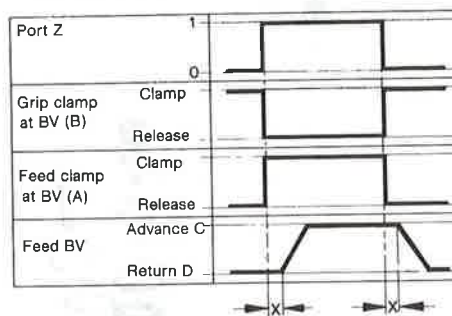
In order to achieve a high switching frequency, the length of the control line to port Z should not be more than 2 m.



The 2 × 4/2-way valve is reversed for as long as a signal is applied to port Z. The flow of the first 4/2-way valve changes from P₁→B to P₁→A. If a pressure rise has taken place in line A equal to at least 50% of the pressure of P₁, the second 4/2-way valve is reversed and the flow changes from P₂→D to P₂→C. The return of 4/2-way valves occurs in a similar manner, by means of a differential piston, after the signal at Z is cancelled. The delay between the switching sequences of the 4/2-way valves means that, with pneumatic feed units, first the clamps are changed over and then the feed or return movement is executed.

9

Valve sequence

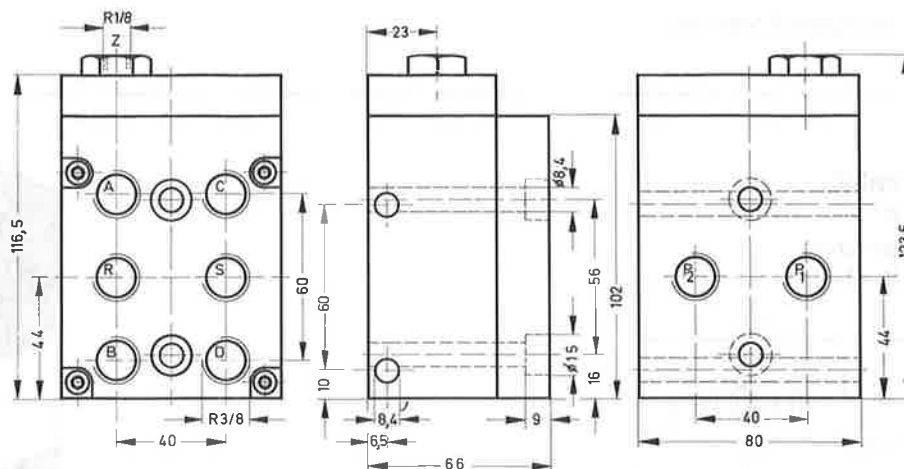


X = Delay between the switching sequences

- (P₁) = Supply line for clamps
- (P₂) = Supply for advance and return stroke
- (D, C) = Cylinder lines for advance and return stroke
- (B, A) = Cylinder lines for feed and grip clamps
- (R, S) = Exhaust
- (Z) = Pilot line

Order code	Part No./Type	4802 VL-8- ³ / ₈ -B
Medium		Compressed air, filtered and lubricated
Design		Piston slide valve
Mounting		Through-holes in housing
Connection	Working lines	G ³ / ₈
	Pilot line	G ¹ / ₈
Nominal size		9 mm
Standard nominal flow rate (P→A)		1800 l/min
Pressure range		2 to 10 bar
Min. pilot pressure range at 6 bar		3 bar
Response time at 6 bar		75 ms
Temperature range		-20 to +80° C
Materials		Housing: hard anodized aluminium; seals: perbunan
Weight		1.320 kg

Type VL-8-³/₈-B



- (P₁) = Supply line for clamps
- (P₂) = Supply for advance and return stroke
- (D, C) = Cylinder lines for advance and return stroke
- (B, A) = Cylinder lines for feed and grip clamps
- (R, S) = Exhaust
- (Z) = Pilot line

Wearing parts kit

For type	VL-8- ³ / ₈ -B
Order code	104 213

