

PD500 Mega Cylinder Safety Instructions

Model 500 Mega Cylinder Lock Safety Requirements

WARNING

The quick-change cylinder lock requires strict adherence to the installation specifications below. Divergence from these requirements could result in damage to machinery and components, or cause severe personal injury or death.

- 1** Each PD500 Mega Cylinder is engineered to locate and lock very large, heavy tooling and is rated at 25,000 lbs holding capacity. When the cylinder locks are used to suspend tools in a vertical or inverted position, a safety reinforcement system should be implemented to prevent the tools from falling in the event of an accidental release of the knobs from their cylinders.
- 2** A lock-out air terminal box should be used to help prevent accidental actuation of the cylinder locks. The cylinders remain safely locked until air pressure is applied; once energized, they unlock and the tooling is free to release.
- 3** Quick-change cylinder locks must be mounted flush to the platen surface. Because the cylinder locks carry a mounting tolerance of +0.000" to -0.002", cylinders must never protrude above the platen surface and must not be recessed more than 0.002" below it.
- 4** The true position of any knob relative to its respective cylinder must be held to a maximum deviation of no more than ± 0.002 ".
- 5** Contact Tooling Tech Group to discuss the location accuracy of the Model 500 Mega Cylinders and Knobs for your proposed application.
- 6** A minimum of 80 lbs of air pressure is required to fully actuate the PD500 cylinder locks.

Thermal Expansion — Allow a Cool-Down Period

Thermal expansion should always be taken into consideration before aligning, locking or releasing warm tools. As the quick-change knobs move in unison with the growing surface of their assigned tool, they become more snug inside their cylinders until the tool contracts back to normal size. A cool-down period is strongly recommended before attempting to disengage the knobs and remove the locked tool from the machine.

Note: Installation sheets with specific mounting and plumbing information for each cylinder lock are available at toolingtechgroup.com.