



Threaded coupling elements

max. operating pressure 500 bar



1 Description of the product

Application

Compared to other coupling elements the threaded coupling elements are very compact devices.

If the slide movement of the workpiece carrier is to be used or if a fixture is to be connected to the base plate without lines, the threaded nipple and the coupling mechanisms can be directly screwed into the parts which are to be connected. The coupling mechanisms have the advantage that they are flush-faced in uncoupled mode.

Flange-type housings are available to simplify the manufacture or the fixture mounting holes.

In cramped conditions it is possible to make and install the flange-type housing retrospectively.

The fixture bodies which are to take up the coupling parts have to be guided 2-3 mm parallelly before they are coupled.

The axial forces which arise during the pressure build-up in coupled mode have to be absorbed outside the coupling parts.

The threaded nipples, which are installed into the tank lines, are equipped with a pre-loaded valve (VSV). The pre-loaded valve limits a possible pressure build-up in the return line to approx. 5 bar by causing internal leakage in the hydraulic clamping elements. In coupled mode the pre-loaded valve is not effective.

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1	2 Validity of the documentation
1	This document applies to the following products:
2	The threaded coupling elements as per data sheet F 9.430.
2	The following types or part numbers are concerned:
2	Threaded nipple can be coupled against pressure
2	Threaded nipple / screw tool
	• 0460-727 / 2010-900
	• 0460-638 / 2010-901
3	Threaded nipple can only be coupled in depressurised mode
4	Threaded nipple / screw tool
	• 0460-731 / 2010-900
	• 0460-740 / 2010-901
5	Threaded nipple with preloaded valve (VSV) can only be coupled in depressurised mode
5	Threaded nipple with VSV / screw tool
	• 0460-728 / 2010-900
	• 0460-637 / 2010-901
5	Coupling mechanism can be coupled against pressure
5	Coupling mechanism / screw tools
	• 0460-725 / 2010-900
	• 0460-735 / 2010-901
6	Coupling mechanism can only be coupled in depressurised mode
6	Coupling mechanism / screw tools
	• 0460-730 / 2010-900
	• 0460-736 / 2010-901
	Coupling mechanism

Coupling mechanism can only be coupled in depressed mode

Coupling mechanism / screw tools

- 0460-763 / 2010-901

3 Target group of this document

- Specialists, fitters and set-up men of machines and installations with hydraulic expert knowledge.

Qualification of the personnel

Expert knowledge means that the personnel must

- be in the position to read and completely understand technical specifications such as circuit diagrams and product-specific drawing documents,
- have expert knowledge (electric, hydraulic, pneumatic knowledge, etc.) of function and design of the corresponding components.

An **expert** is somebody who has due to its professional education and experiences sufficient knowledge and is familiar with the relevant regulations so that he

- can judge the entrusted works,
- can recognize the possible dangers,
- can take the required measures to eliminate dangers,
- knows the acknowledged standards, rules and guidelines of the technology.
- has the required knowledge for repair and mounting.

4 Safety instructions

DANGER

Danger of life / heavy health damages

Stands for an imminent danger.

If it is not avoided, death or very severe injuries will result.

WARNING

Person damage

Stands for a possibly dangerous situation.

If it is not avoided, death or very severe injuries will result.

CAUTION

Easy injuries / property damage

Stands for a possibly dangerous situation.

If it is not avoided, minor injuries or material damages will result.

Hazardous to the environment



The symbol stands for important information for the proper handling with materials that are hazardous to the environment.

Ignoring these notes can lead to heavy damages to the environment.



Mandatory sign!

The symbol stands for important information, necessary protection equipment, etc.

Note

This symbol stands for tips for users or especially useful information. This is no signal word for a dangerous or harmful situation.

5 For your safety

5.1 Basic information

The operating instructions serve for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with these operating instructions, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.

5.2 Safety instructions

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual, in order to avoid personal damage or material damage.

- Read these operating instructions thoroughly and completely, before you work with the product.
- Keep these operating instructions so that they are accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer in order to exclude danger to persons because of not suited spare parts.
- Respect the intended use.

- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.

- Perform a risk analysis for the incomplete machine, or the machine.

Due to the interactions between the product and the machine/fixture or the environment, risks may arise that only can be determined and minimized by the user, e.g. :

- generated forces,
- generated movements,
- Influence of hydraulic and electrical control,
- etc.

6 Application

6.1 Intended use

These products are used in the industrial sector, to transfer hydraulic oil or compressed air from the machine table to the fixture. An example would be a machine tool with palette changing systems.

Furthermore the following are intended uses:

- Use within the capacity indicated in the technical characteristics (see data sheet).
- Use as per operating instructions.
- Compliance with service intervals.

- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.

6.2 Misapplication

⚠️ WARNING

Injuries, material damages or malfunctions!

- Do not modify the product!

The use of these products is not admitted:

- For domestic use.
- On pallets or machine tool tables in primary shaping and metal forming machine tools.
- If due to vibrations or other physical / chemical effects damages of the products or seals can be caused.
- In machines, on pallets or machine tool tables that are used to change the characteristics of the material (magnetise, radiation, photochemical procedures, etc.).
- In areas for which special guidelines apply, especially installations and machines:
 - For the use on fun fairs and in leisure parks.
 - In food processing or in areas with special hygiene regulations.
 - For military purposes.
 - In mines.
 - In explosive and aggressive environments (e.g. ATEX).
 - In medical engineering.
 - In the aerospace industry.
 - For passenger transport.
- For other operating and environmental conditions e.g.:
 - Higher operating pressures than indicated on the data sheet or installation drawing.
 - With hydraulic fluids that do not correspond to the specifications.

Special solutions are available on request!

7 Installation

⚠️ WARNING

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

- Improper connection can lead to escapes of oil under high pressure at the connections.
- Mounting or dismounting of the element must only be made in depressurised mode of the hydraulic system.
- Connection of the hydraulic line as per DIN 3852/ISO 1179.
- Unused connections have to be locked professionally.
- Use all mounting holes.

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil under high pressure.

- Before using them make a visual control.

Poisoning due to contact with hydraulic oil!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

7.1 Design

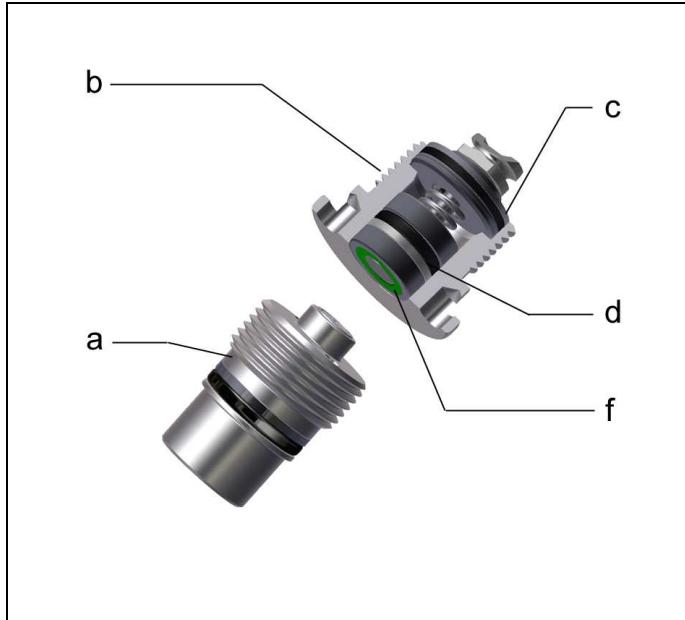
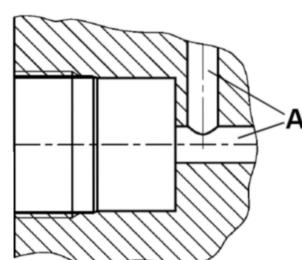


Figure 1: Components and accessories

a Body (threaded nipple)	c Built-in coupling mechanism
b Body (threaded coupling mechanism)	d O-ring/back-up ring
	f Sealing ring

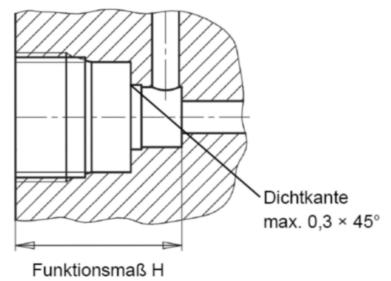
7.2 Installation

Nippel:



Aufnahmehole
Einschraubausführung

Mechanik:



Dichtkante
max. 0,3 x 45°

Figure 2: Location hole threaded-body type

Threaded-body type:

Machine the location hole with utmost accuracy (see also functional dimension H). Before screwing-in of the coupling, check that O-rings and back-up rings are in perfect condition.

- Provide the threads in the fixture.
- Drill the holes for hydraulic oil supply (selectable ports **A**) in the fixture (see also ROEMHELD data sheet F 9.428).
- Clean the fixture.
- Mount the threaded-body coupling into the fixture. Pay attention to the seating torque.

1 Note

Lubricate slightly the location hole, but do not lubricate O-rings and back-up rings!

7.3 Operation**⚠ WARNING****Injuries due to non-compliance of the operating instructions!**

- The product may only be operated, if the operating instructions - especially the chapter "Safety instructions" have been read and understood.

⚠ CAUTION**Risk of injury!**

Due to spring-loaded components hand or fingers can be squeezed.

- Wear personal protection equipment!

Material damage

Product and customer's installation can be damaged due to penetrating dirt.

- Last clean the nipple with compressed air before coupling is made.

Function

The coupling elements lock automatically during uncoupling. The built-in types are designed for mounting in plates. The threaded-body types can be screwed in directly in the fixture body and therefore optimum line connections between two components. For transmission of vacuum only coupling elements for depressurised coupling are to be used.

1 Note**Material damage**

With hydraulic pressure very high forces are generated. The fixture or machine must be in the position to compensate these forces.

The coupling elements installed in the coupling carrier and nipple carrier open each other. Therefore the two halves have to effect the complete coupling stroke when moving together to guarantee the maximum flow.

8 Maintenance**8.1 Cleaning****⚠ CAUTION****Avoid damages of the moved components**

Avoid damages of the moved components (rods, plungers, bolts, etc.) as well as of wiper and seal.

Aggressive cleaning agents

The product must not be cleaned with:

- Corrosive or corroding components or
- Organic solvents as halogen or aromatic hydrocarbons and ketones (cellulose thinner, acetone, etc.),

because this can destroy the seals.

The sealing surfaces on the face of the coupling elements have to be cleaned before coupling, to ensure the tightness in coupled condition. We recommend to wash the elements and finally clean them with compressed air. Protection covers should be used as far as possible. Previous cleaning of the smooth sealing areas is possible by means of rubber wipers.

In the case of heavy contamination, the cleaning has to be made in shorter intervals.

8.2 Regular checks**1 Note****Life**

In order to obtain a long life, sealing surfaces should be free of contamination.

Swarf or contamination in the hydraulic oil lead to increased wear or damage at the guides, running surfaces and seals. Position tolerances have to be kept (parallel working)!

⚠ CAUTION**Material damage!**

If the coupling is not guided in parallel, coupling nipple and coupling mechanism will be damaged.

- The axial forces generated in the coupling situation have to be compensated externally positively or non-positively.
- According to the version the coupling elements can be coupled and uncoupled against pressure or only in depressurised mode.
- Use hydraulic oil as per ROEMHELD data sheet A 0.100.

8.3 Exchange seal kit

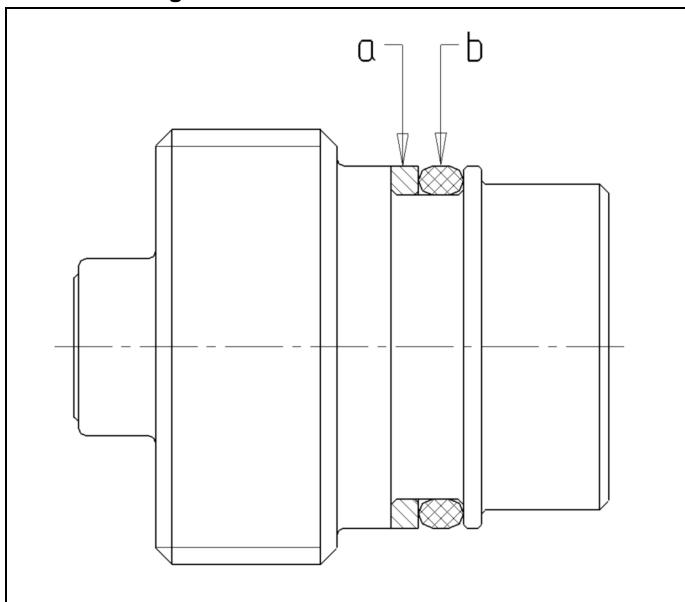


Figure 3: Position of the seal kit.

a Back-up ring b O-ring

The exchange of the seal kit has to be made in case of external leakages. For high availability we recommend to regularly change the seals, but at least after 2 years.

The seal kit is available as spare part (see data sheet).

Exchange seal kit

Procedure

- Remove old O-ring and back-up ring
- Clean the slot of contamination and swarf
- Insert O-ring and back-up ring. Pay attention to correct position.

Note

Seal Kits

- Do not install seal kits which were exposed to light for a longer time.
- Pay attention to the storage conditions (see chapter "Technical characteristics").
- Only use original seals.

9 Trouble shooting

Trouble	Cause	Remedy
No flow	Functional dimension H is not correct	Correct installation situation
	Not sufficiently together	Correct coupling stroke
	Coupling lifts off	Axial or coupling force higher than the retention force of the system
Coupling is leaky	Knife edge not correctly made	Knife edge not correctly made
	Flat seal defect	If possible exchange seal or return for repair
In uncoupled mode leaky	Internal seal defect due to swarf	Exchange element

10 Technical characteristics

Note

Further information

- For further technical data see ROEMHELD data sheet.

11 Accessory

Note

Accessories

- See data sheet.

12 Storage

CAUTION

Storage of components!

- The product may not be exposed to direct solar radiation, because the UV light can destroy the seals.
- A storage differing from the storage conditions is inadmissible.
- In case of improper storage, the seals can embrittle and resinification of the anti-corrosive oil or corrosion at the element can occur.

The elements are tested by default with mineral oil. The exterior of the elements is treated with a corrosion inhibitor.

The oil film remaining after the test provides for a six-month interior corrosion protection, if stored in dry and uniformly tempered rooms.

For longer storage times, the element has to be filled with a non-resinifying corrosion inhibitor and the outside surfaces must be treated.

13 Disposal

DANGER

Hazardous to the environment



Due to possible environmental pollution, the individual components must be disposed only by an authorised expert company.

The individual materials have to be disposed as per the existing regulations and directives as well as the environmental conditions.

Special attention has to be drawn to the disposal of components with residual portions of hydraulic fluids. The instructions for the disposal at the material safety data sheet have to be considered.

For the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) country-specific legal regulations and specifications have to be kept.

14 Declaration of manufacture

Manufacturer

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Declaration of manufacture of the products

The threaded coupling elements as per data sheet F 9.430.
The following types or part numbers are concerned:

Threaded nipple can be coupled against pressure

Threaded nipple / screw tool

- 0460-727 / 2010-900
- 0460-638 / 2010-901

Threaded nipple can only be coupled in depressurised mode

Threaded nipple / screw tool

- 0460-731 / 2010-900
- 0460-740 / 2010-901

Threaded nipple with preloaded valve (VSV) can only be coupled in depressurised mode

Threaded nipple with VSV / screw tool

- 0460-728 / 2010-900
- 0460-637 / 2010-901

Coupling mechanism can be coupled against pressure

Coupling mechanism / screw tools

- 0460-725 / 2010-900
- 0460-735 / 2010-901

Coupling mechanism can only be coupled in depressurised mode

Coupling mechanism / screw tools

- 0460-730 / 2010-900
- 0460-736 / 2010-901

Coupling mechanism

Coupling mechanism can only be coupled in depressurised mode

Coupling mechanism / screw tools

- 0460-763 / 2010-901

They are designed and manufactured in line with the relevant versions of the directives **2006/42/EC** (EC MSRL) and in compliance with the valid technical rules and standards.

In accordance with EC-MSRL and EN 982, these products are components that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

According to the pressure equipment directives the products are not to be classified as pressure reservoirs but as hydraulic

placing devices, since pressure is not the essential factor for the design, but the strength, the inherent stability and solidity with regard to static or dynamic operating stress.

The products may only be put into operation after it was assessed that the incomplete machine/machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.

The technical documentation as per appendix VII part B was prepared for the products.

Responsible person for the documentation:
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Römheld GmbH

Friedrichshütte

Laubach, 17.07.2013