

# **DESIGN NOTES**

Surface quality

Peak-to-valley heights	R <sub>max</sub>	R <sub>p</sub> /R <sub>z</sub>
Cylinder barrel	≤4 µm	<0,5 µm

tp (25% R<sub>max</sub>) = 50 ... 75%

→ Technical Manual.

# **FITTING & INSTALLATION**

Careful fitting is a prerequisite for the correct function of the seal. → Technical Manual. The Merkel Complete Piston NADUOP is fitted to shouldered end of the piston rod and fastened with washers and a nut. The threaded fitting is to be protected against loosening.

# **PRODUCT DESCRIPTION**

Short Merkel complete piston with steel base plate, vulcanised buffers and sealing lips with special pneumatic sealing edges. Ready to install Merkel complete piston with integrated guide that can be pressurised on both sides.

## **PRODUCT ADVANTAGES**

- Vulcanised buffers for end-position damping of piston in the cylinder
- Radial venting passages for reliable pressure application at the end of the stroke

### **APPLICATION**

Pneumatic cylinders

### MATERIAL

#### Seal

Material	Code	Hardness
Acrylonitrile-butadiene rubber	72 NBR 708	72 Shore A

## Base plate

Material	Code	Hardness
mild steel according to DIN 1624	-	-

### **OPERATING CONDITIONS**

Medium	Prepared, dried and de-oiled com- pressed air (after greasing for fitting)
Operating pressure p	≤1,0 MPa
Temperature T	-20 +100 °C
Running speed v	≤1,0 m/s



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