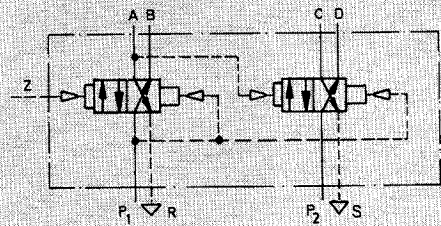


Single Pilot Valve,

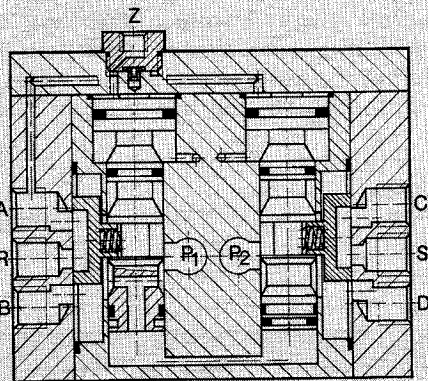
Spring Return for Pneumatic Feed Unit
 Type VL-8-3/8-B



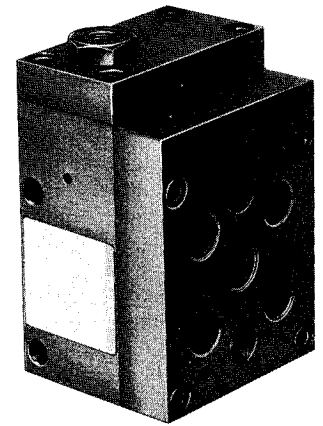
This valve is used to control feed motion and alternate clamping on FESTO strip feed units.

Different feed and clamping pressures are possible by varying pressures to P₁ and P₂.

To achieve a high switching frequency, the length of the control line to connection Z should not exceed 6 feet / 2 meters.

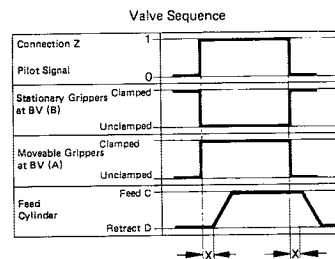


- P₁ = Supply to Clamping Cylinder
- P₂ = Supply to Feed Cylinder
- D, C = Ports for Feed Cylinder
- B, A = Ports for Clamping Cylinder
- R, S = Exhaust
- Z = Pilot Line



The 2 x 4 way, 2 position directional control valve remains shifted while pilot pressure is applied at Z. The flow in the first four-way, two-position valve changes from P₁ → B to P₁ → A. When the pressure in line A builds up to at least 50% of the pressure at P₁, the second four-way, two-position valve will be shifted. The flow changes from P₂ → D to P₂ → C. Similarly, the four-way, two-position directional control valves are returned by a differential piston area after pilot pressure at Z is removed. In this way the delay between shifting of the two 4 way, 2 position valves allows the clamping jaws to be reversed first, followed by extension or retraction of feed cylinders in the strip feeding unit.

Valve Movement



X = Feed Cylinder Delayed Action

| | | |
|--|---|-----------|
| Order Number | 4802 VL-8-3/8-B | |
| Medium | Compressed air (filtered, lubricated) | |
| Mounting | Through-holes in housing | |
| Connection | Working Ports | G 3/8 ISO |
| | Pilot Port | G 1/8 ISO |
| Orifice Size | 0.35 in / 9 mm | |
| C _v Factor (P → A) | 1.80 C _v / 1800 l/min | |
| Pressure Range* | 30-150 psi / 2-10 bar | |
| Min Pilot Pressure Range at 90 psi / 6 bar | 45 psi / 3 bar | |
| Response Time at 90 psi / 6 bar | 75 ms | |
| Design | Slide valve | |
| Materials | Housing: Al, hard coat anodized. Seals: Buna N. | |
| Weight | 2.910 lb / 1.320 kg | |

* -4 to +176°F / -20 to +80°C