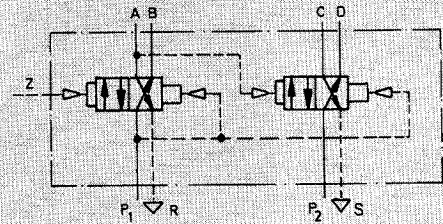


## Single Pilot Valve,

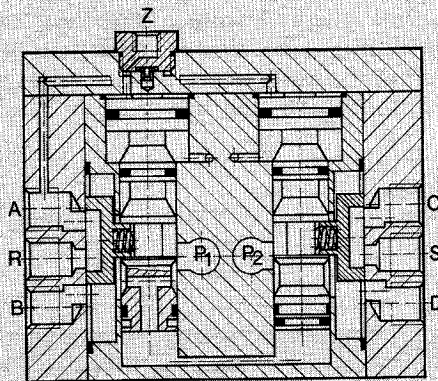
Spring Return for Pneumatic Feed Unit  
Type VL-8-3/8-B



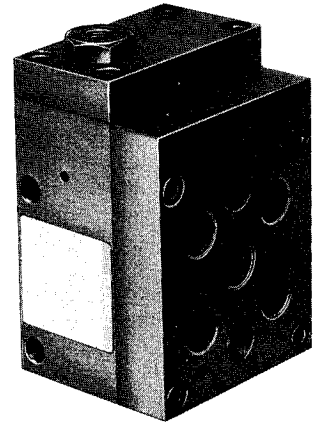
This valve is used to control feed motion and alternate clamping on FESTO strip feed units.

Different feed and clamping pressures are possible by varying pressures to  $P_1$  and  $P_2$ .

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

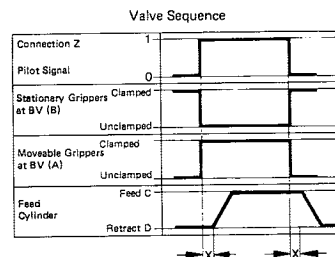


$P_1$  = Supply to Clamping Cylinder  
 $P_2$  = Supply to Feed Cylinder  
D, C = Ports for Feed Cylinder  
B, A = Ports for Clamping Cylinder  
R, S = Exhaust  
Z = Pilot Line



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  $P_1 \rightarrow B$  to  $P_1 \rightarrow A$ . When the pressure in line A builds up to at least 50% of the pressure at  $P_1$ , the second four-way, two-position valve will be shifted. The flow changes from  $P_2 \rightarrow D$  to  $P_2 \rightarrow C$ . 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 ( $P \rightarrow A$ )	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

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