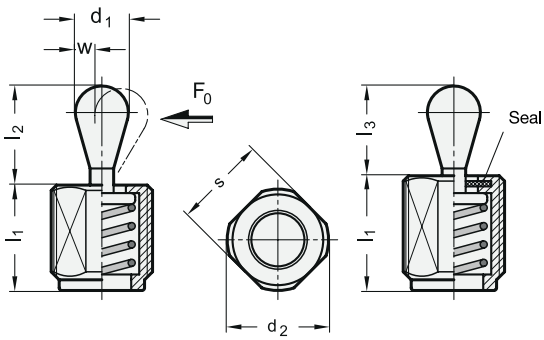
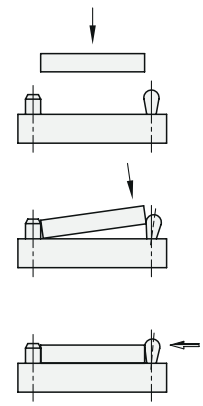
Side Thrust Pins

Steel, with Thread





4 Type

SB Thrust pin steel, with seal

SA* Thrust pin steel, without seal

1 d_1	2 Side thrust force F_0 in N ≈ at l_2			3 l_1 –2			d_2	a_1	a_2
5	20	50	100	11,5	19	26,5*	M 12	2,5	5,7
6	40	75	100	11,5	19	26,5*	M 12	3	7,7
10	100	150	205	18	31,5	45*	M 18 x 1,5	5	10,7

d_1	k	l_2	l_3	s	w	x_1	x_2	Code No. for spanner
5	1,5 x 45°	6,7	6	10	1,6	1,7	1,3	GN 713.1-5.6
6	1,5 x 45°	10,7	10	10	1,8	1,9	1,4	GN 713.1-5.6
10	2 x 45°	16,7	16	16	3,2	3,4	2,7	GN 713.1-10

* not available from stock, requires a minimum order quantity

Specification

Housing
Steel
Zinc plated, blue passivated

Thrust pin
Steel, hardened
Zinc plated, blue passivated

Thrust spring
- Side thrust force light
  Stainless steel AISI 301
- Side thrust force medium
  Spring steel blackened
- Side thrust force heavy
  Spring steel zinc plated, blue passivated

Seal
Chloroprene rubber (CR)

RoHS

Spring loaded side thrust pins GN713 are versatile and practical elements for holding, positioning and clamping workpieces.
They eliminate costly alternatives, are space saving and simple to install. The protruding height of the thrust pin can be adjusted with the threaded body.
For mounting the side thrust pins a suitable mounting tool GN 713.1 is available (see table).

see also...	Page
GN 715 Side Thrust Pins (press on type)	QVX

Technical Information

Technical instructions GN 713 / GN 715	QVX
Plastic Characteristics	QVX

Accessory

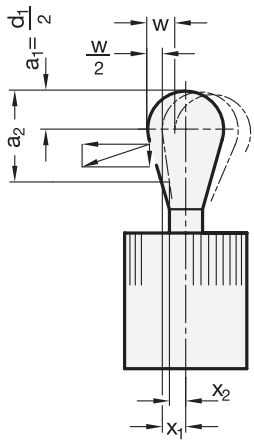
GN 713.1 Mounting Tools (Code no. see table)	QVX

How to order

1 2 3 4
GN 713-6-75-11,5-SB

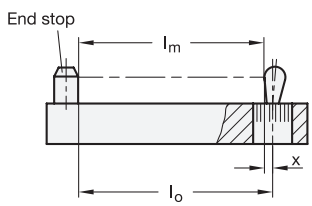
1	d_1
2	Side thrust force F_0
3	l_1
4	Type

Technical and assembly instructions

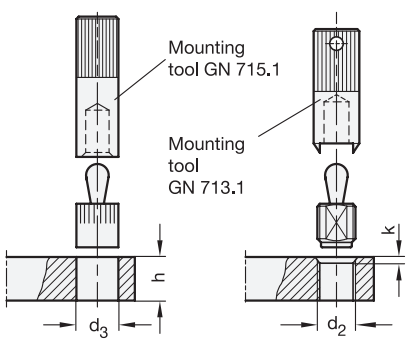


w	=	Movement of pin
F	=	Side thrust in N Initial thrust = F_0 End thrust = 1,1 x F_0
$a_2 - a_1$	=	Clamping range for workpiece
x	=	Distance centre line – Thrust point at $\frac{w}{2}$ x_1 for highest thrust point (a_1) x_2 for lowest thrust point (a_2)
l_0	=	Distance end stop – Bore of side thrust bush pin
l_0	=	$l_m + x$ l_m = average length of workpiece $\frac{l_{max.} + l_{min.}}{2}$

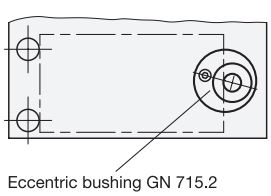
For contact points (workpiece height) between a_1 and a_2 a value for x has to be used lying between x_1 and x_2 (interpolation).



By observing the above values the full movement of the side thrust pin will be available to cover the tolerance of the workpiece.



For inserting the side thrust pins the use of a mounting tool GN 715.1 or GN 713.1 is recommended.



Eccentric bushings GN 715.2 are a tooling accessory for GN 714 / GN 715.

They enable a precise optimum setting of side thrust pins. This allows an adjustment to l_0 to accommodate for instance a larger tolerance range on a workpiece.