



- 1 = Adjustable **Flow** controls for open & closing speeds
- 2 = Adjustable **Cushion** controls for open & closing damping at end of stroke.
- 3 = 1/8bsp port at end, outlet ports for attaching Sensadoor Detection Valve
- 4 = Universal reed switch brackets x 2

Cylinders by other manufacturers and suppliers will have flow controls as shown below. and some may not be fitted with adjustable cushion but pre-fixed.

Typical Pneumatic Cylinder (actuator)

Transport Door Solutions pneumatic cylinder comply with ISO 6431 and DIN 24335 for European automotive supply. They are available all having (2 15/32+) to give the required thrust. All actuators feature:

- Typical TDS cylinders Ø63mm bores x 100mm stroke double acting actuation
- Adjustable speed regulators for open/close.
- Built in cushioning on open/close.
- Some have built in sensor ports on open/close which enable sensing without interference from cushioning and speed adjustment in both directions.
- Stainless Steel piston rod with extra long threaded ± 0.05 to accommodate installation tolerances.
- High fibre nitrile seals.
- Maintenance free factory lubricated for up to eight years or two million cycles.
- Effective thrust 1244N (opening), 1092N (closing) at 5 bar.
- Operating temperatures . 30°C to +80°C



A=4 TURNS



B=4 TURNS



C=4 TURNS



D=3 TURNS



E=3 TURNS



F=3 TURNS

Example. Speed setting is based on a cylinder with a 63mm bore x 100 stroke:-

1/ Air pressure set @ 6.5bar ± 0.5

2/ Double Glider Doors: Cylinders speeds Opening 2.0 to 3.0sec. Closing 2.5 to 3.5sec.

3/ Single Glider Door: Cylinder speeds Opening 2.0 to 3.0sec. Closing 3.0 to 3.5sec.

CYLINDER SPEEDSETTING (FLOW CONTROLS):-

- (i) Turn clockwise untill fully in.
- (ii) Turn anti-clockwise full turns to suit flow control, as shown above.

CUSHION SETTING (END OF STROKE DAMPING):-

- (i) Turn clockwise untill fully in.
- (ii) Turn anti-clockwise One 1/4 turn
- (iii) Turning anti-clockwise =reduces damping & clockwise will increase damping.

IMPORTANT NOTE FOR SPEED & CUSHION CONTROLS

Cushion Controls =Is a very fine adjustment, if turned **clockwise fully in**. This will result in stopping piston (ram) from reacting or extending fully.

Speed Controls =If turned **clockwise fully in**, this will result in stopping piston (ram) from moving.