

User manual for Manifold Block

1. Hydraulic oil

- Type

Petroleum based hydraulic oil	The equivalent of ISO VG32 46 68
Synthetic hydraulic oil	Phosphate ester polyol ester
Flame retardant hydraulic oil	Water ethylene glycol

- Viscosity and temperature

Viscosity: 150 ~ 400cSt

Temperature: -15 ~ 70°C

- Cleanliness

In order to extend the service life of hydraulic components, the cleanliness of the oil should be kept within NAS 1638-12 level, and a pipeline oil filter with a filtration clarity of 25µm or more should be used.

Maximum working pressure: 31.5MPa

- Processing requirement

1. Deburring, chamfering edges C1, blunting sharp edges, deburring at the intersection of through holes.
2. Screw port spacing tolerance ± 0.1 , port edge chamfer 90 °, oil port spacing tolerance ± 0.05 .
3. The tolerance between adjacent vertical planes is 0.05. The parallelism tolerance of two parallel surfaces is 0.05.
4. The depth of the port does not include the drill tip, and chamfering is required before tapping the thread.
5. Surface smoothness of manifold block is Ra3.2.
6. Pay attention to the verticality and sealing of the BSPP thread.
7. Surface treatment is black coating.