

Series 1325-1326-1345-1347, twin rod cylinders

Construction characteristics

Front end cap	anodised aluminium
Rear end cap	UNI 5079 aluminium alloy casting
Rod	C43 chromed steel stainless steel
Barrel	RA=0.3-0.5 anodised aluminium
Cushion bushings	hard aluminium
Piston	vulcanized rubber block on steel core with incorporated permanent magnet, or without magnet for non magnetic version (plus spacer).
Flange	zinc plated steel
Rod seal	PUR
Other seals	NBR 80 shore rubber
Cushioning adjustment screw	nickel-plated steel

Operational characteristics

Fluid	Filtered air. No lubrication needed, if applied it shall be continuous.
Max. pressure	10 bar
Working temperature	-5°C - +70°C

Please follow the suggestions below to ensure a long life for these cylinders:

- use clean and lubricated air
- correct alignment during assembly with regard to the applied load so as to avoid radial components or bending the rod.
- avoid high speeds together with long strokes and heavy loads: this would produce kinetic energy which the cylinder cannot absorb, especially if used as a limit stop (in this case use mechanical stop device)
- evaluate the environmental characteristics of cylinder used (high temperature, hard atmosphere, dust, humidity etc.)

Please note: air must be dried for applications with lower temperature.

Use hydraulic oils H class (ISO VG32) for correct continued lubrication.
Our Technical Department will be glad to help.

Cushioning lengths

Bore	Ø	32	40	50	63	80	100
Front length	mm	22	22	24	32	32	32
Rear length	mm	28	32	32	40	44	50

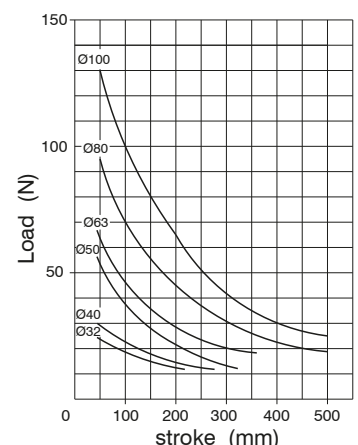
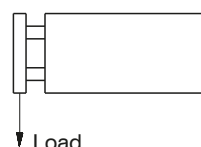
Standard strokes

Ø32	25 - 50 - 75 - 100 - 150 - 200 mm
Ø40	25 - 50 - 75 - 100 - 150 - 200 - 250 mm
Ø50	25 - 50 - 75 - 100 - 150 - 200 - 250 - 300 mm
Ø63	25 - 50 - 75 - 100 - 150 - 200 - 250 - 300 - 350 mm
Ø80	25 - 50 - 75 - 100 - 150 - 200 - 250 - 300 - 350 - 400 - 500 mm
Ø100	25 - 50 - 75 - 100 - 150 - 200 - 250 - 300 - 350 - 400 - 500 mm

On request are available strokes up to 1000 mm

Stroke tolerance (ISO 15552)

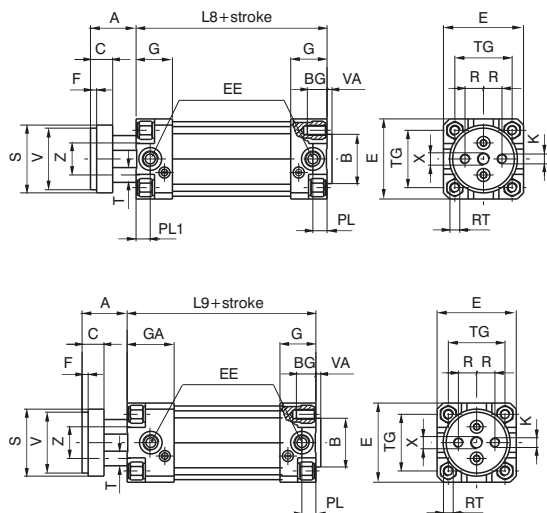
Bore	Stroke	Tolerance
32 - 40 - 50	up to 500 mm	+2 0
63 - 80 - 100		



Basic version

Ordering code

1325.Ø.stroke.01 magnetic
1326.Ø.stroke.01 non magnetic
1325.Ø.stroke.01X magnetic stainless steel rod
1326.Ø.stroke.01X non magnetic stainless steel rod



Bore	32	40	50	63	80	100
A	26	30	37	37	46	51
AM	22	24	32	32	40	40
B	30	35	40	45	45	55
BG	12	12	16	16	20	20
C	15	15	18	22	22	22
E	46	52	65	75	95	115
EE	G 1/8"	G 1/4"	G 1/4"	G 3/8"	G 3/8"	G 1/2"
F	4	4	5	5	5	5
G	25	29	29,5	36	36	40
GA	50	54	54,5	61	61	65
K	M6	M8	M8	M10	M12	M12
L8	94	105	106	121	128	138
L9	119	130	131	146	153	163
PL	9	11,5	13	14	16	18
PL1	9,5	11	10,5	14	13	15
R	9,5	11,25	15	19	25	35
RT	M6	M6	M8	M8	M10	M10
S	35	45	55	70	85	105
T	8	10	12	16	20	20
TG	32,5	38	46,5	56,5	72	89
V	32	40	50	63	80	100
VA	4	4	4	4	4	4
Z	18	22	26	35	40	50
WH	26	30	37	37	46	51
X	M8	M10	M10	M12	M14	M14
Weight	Stroke	Basic version				
g	0	Extended ver.				
	every 10 mm	20	26	30	40	80
		560	810	1380	2300	3680
		650	950	1500	2500	4100
						5740
						6300
						90

Extended front cap

1345.Ø.stroke.01 magnetic
1347.Ø.stroke.01 non magnetic
1345.Ø.stroke.01X magnetic stainless steel rod
1347.Ø.stroke.01X non magnetic stainless steel rod

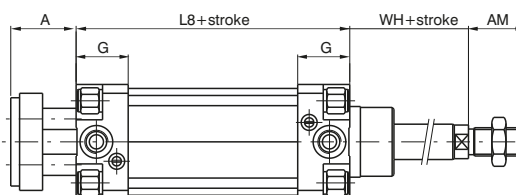
Through rod cylinder version with ISO standard

Ordering code

1325.Ø.stroke.02 magnetic
1326.Ø.stroke.02 non magnetic

Rods options

1325.Ø.stroke.02X magnetic stainless steel rod
1326.Ø.stroke.02X non magnetic stainless steel rod



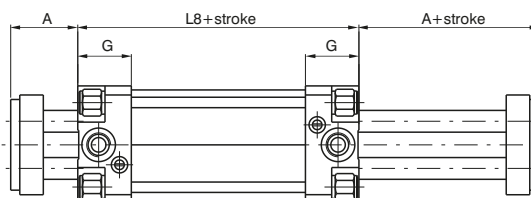
Through rod twin cylinder version

Ordering code

1325.Ø.stroke.06 magnetic
1326.Ø.stroke.06 non magnetic

Rods options

1325.Ø.stroke.06X magnetic stainless steel rod
1326.Ø.stroke.06X non magnetic stainless steel rod



Magnetic sensors

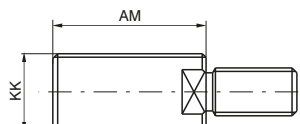
For sensor and sensor support bracket please refer to the 1319 and 1320 series.

Accessories

All of the attachments of the ISO 15552 can be mounted, with the exclusion of the front flange and the foot mounting bracket that, although they are part of the same series, need a small adjustment in the exit zone of the rods. For these there is a different code and the dimensions are indicated below.

Threaded Nipple

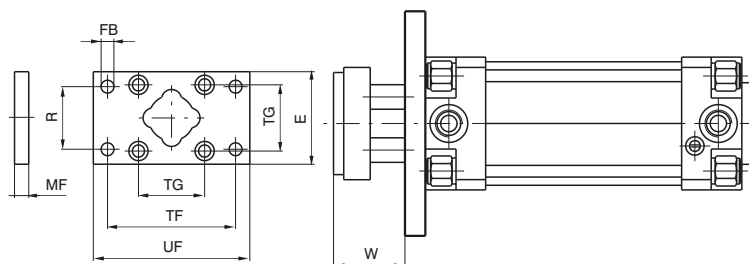
Ordering code
1325.Ø.17F



Bore	32	40	50	63	80	100
AM	22	24	32	35	40	40
KK	M10x1,25	M12x1,25	M16x1,5	M16x1,5	M20x1,5	M20x1,5
Weight g	17	27	63	65	110	110

Front Flange

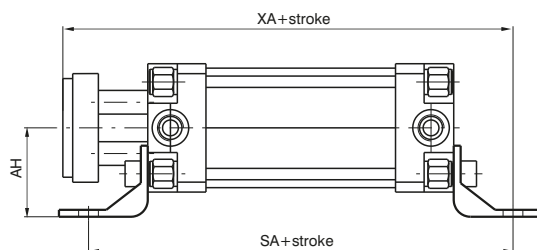
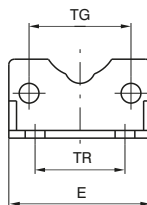
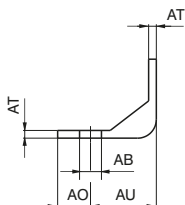
Ordering code
1325.Ø.03F



Bore	32	40	50	63	80	100
E	45	52	65	75	95	115
FB (H13)	7	9	9	9	12	14
MF (JS 14)	10	10	12	12	16	16
R (JS 14)	32	36	45	50	63	75
TF (JS 14)	64	72	90	100	126	150
TG	32,5	38	46,5	56,5	72	89
UF	80	90	110	120	150	170
W	16	20	25	25	30	35
Weight g	160	250	480	620	1430	3500

Front foot mounting bracket (short)

Ordering code
1325.Ø.05/1F (1 piece)



Bore	32	40	50	63	80	100
AB (H14)	7	9	9	9	12	14
AH (JS 15)	32	36	45	50	63	71
AO ($\pm 0,2$)	11	8	13	13	14	15
AT	3,5	3,5	3,5	4,5	5	5
AU	24	28	32	32	41	41
E	45	52	65	75	95	115
SA	142	161	170	185	210	220
TG	32,5	38	46,5	56,5	72	89
TR (JS 14)	32	36	45	50	63	75
XA	144	163	175	190	215	230
Weight g	50	70	120	180	320	400



Series 1370 - 1371 - 1372 - 1373 - ECOFLAT

General

Profiled tube has two "T" slots on the side hosting sensors 1580._, MRS._, MHS._ without adaptors.
 Two additional connections are also available on rear cover for cylinder feeding.

Construction characteristics

End caps	aluminium anodised
Rod	C43 chromed steel or stainless steel
Barrel	aluminium alloy anodised
Piston	acetal resin, aluminium on request
Piston-seal	PUR
Rod-seal	PUR (FPM upon request)
Adjusting screw	zinc plated steel
Shock absorber	NBR

Operational characteristics

Fluid	Filtered air. No lubrication needed, if applied it shall be continuous.
Max. pressure	10 bar
Operating temperature	-5°C - +70°C

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- use clean and lubricated air
- correct alignment during assembly with regard to the applied load so as to avoid radial components or bending the rod;
- avoid high speeds together with long strokes and heavy loads: this would produce kinetic energy which the cylinder cannot absorb, especially if used as a limit stop (in this case use mechanical stop device and aluminium piston);
- evaluate the environmental characteristics of cylinder used (high temperature, hard atmosphere, dust, humidity etc.)

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Maximum standard strokes

Size 25	200 mm
Size 32 - 63	320 mm

Sections (cm²)

Size	25	32	40	50	63
Out stroke (cm ²)	5,28	8,09	13,09	20,28	32,68
In stroke (cm ²)	4,49	6,96	11,08	17,14	29,54

In order to calculate the theoretical force generated by the unit, both outstroke and instroke, it is necessary to use the following equation

$$\text{FORCE(Kg)} = \text{Surface (cm}^2\text{)} \times \text{Pressure(bar)}$$

It is also necessary to remember that the theoretical force must be reduced by 10-15% in order to account for the unit internal friction.

Maximum rod radial movement (°)

Size	25	32	40	50	63
Rod radial movement	±0.8	±0.7	±0.6	±0.5	±0.4

Maximum torque applicable on the piston rod (Nm):

Size	25	32	40	50	63
Maximum torque	0.8	1	1,3	1,8	2,1

The maximum torque values must also be accounted for while mounting accessories on the piston rod.