



ACE VC Precision Feed Controls are sealed hydraulic units fitted with a high precision metering element. When the piston rod is depressed the hydraulic oil is forced through the adjustable precision metering orifice. This provides a constant and precise feed control throughout the stroke length. The feed rate can be adjusted over a wide range by turning the external adjuster knob at the rear end of the unit. The optional threaded outer body helps to simplify installation and the adjustment of feed control travel limits.

MA and MVC are similar feed control units intended for applications where the higher precision of the VC series is not required.

ACE Precision Feed Controls provide exact speed control for machine motion. They are self-contained, maintenance free, leakproof, temperature stable and stick-slip free. The rolling diaphragm seal, on models 2515 to 2555, provides a hermetically sealed unit and also provides an integral accumulator for the oil displaced during operation. The high precision, adjustable metering system can provide accurate feed rates from as little as 0.47 in/min (12 mm/min) with low propelling forces.

Applications include saws, cutters, drill feeds, grinding and boring machines in the plastics, metal, wood and glass industries.

Technical Data

Feed rate range: min. 0.51 in/min with 90 lbs. (0.013 m/min with 400 N) propelling force. Maximum 1500 in/min with 787 lbs. (38 m/min with 3500 N) propelling force.

Do not rotate piston rod, if excessive rotation force is applied rolling seal may rupture (only applies to VC 2515 to VC 2555).

Outer body: Smooth body standard 0.94 inch (23.8 mm) dia., threaded body optional.

Nylon button part no. 250-0268, can be fitted onto piston rod. Unit may be mounted in any position.

When mounting **take care not to damage the adjuster knob**.

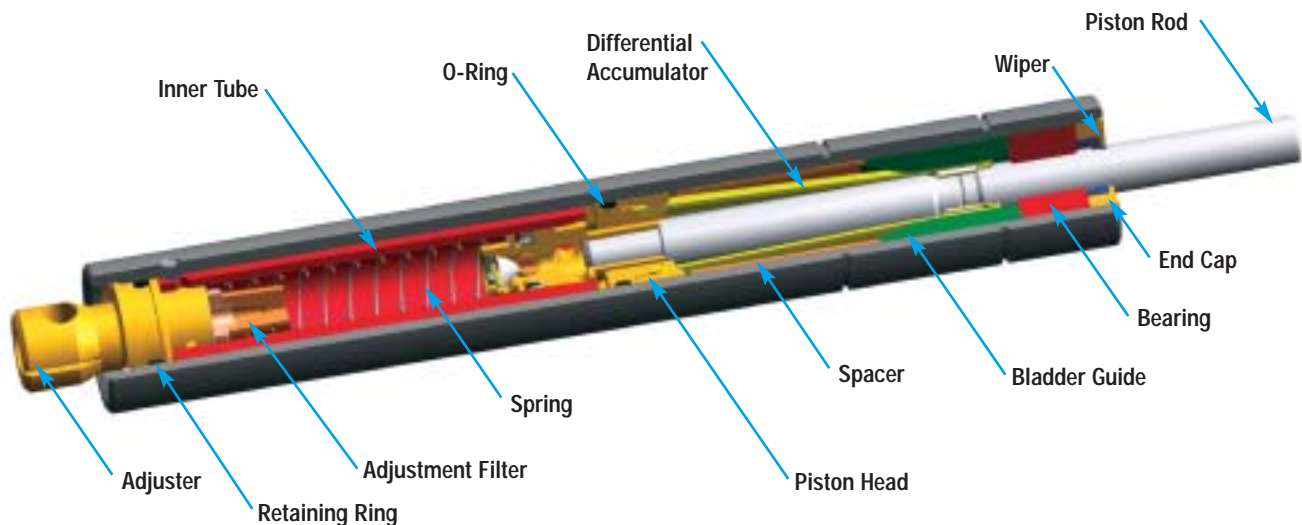
Temperature range: 32° to 140°F (0° to 60°C).

Material: Body heavy duty steel tube with black oxide. Piston rod with hard chrome plating.

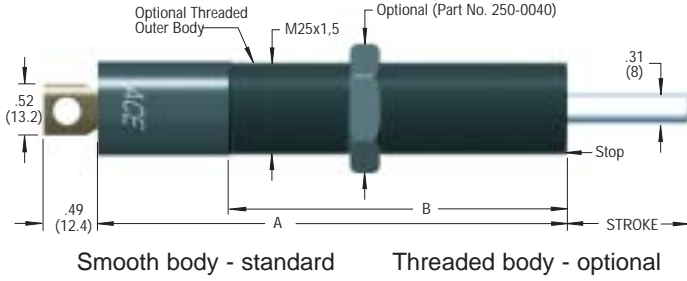
Adjustment: Adjust VC unit by turning adjustment knob at rear. Zero is full open (fast) and 20 is fully closed (slow).

Note: If the VC feed control will be in contact with petroleum based oils or cutting fluids, specify optional neoprene rolling seal or install Air Bleed Collar model SP 25 (only applies to VC 2515 to VC 2555).

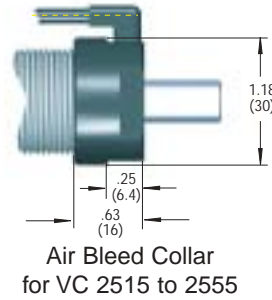
VC Precision Hydraulic Feed Controller, Models 2515-2555



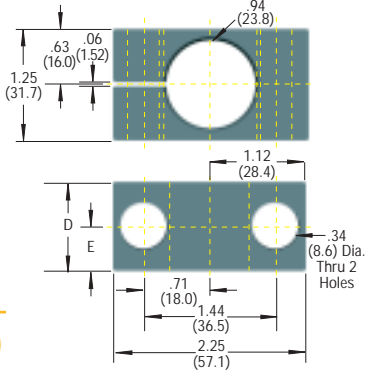
Model VC 25..



Model SP-25
Part No. 10783-000



Clamp Mount
for Smooth Body



VC Dimensions in inches (millimeters)

Standard Model	Threaded Model	Stroke	A	B	Weight lbs. kg
VC 2515-F	VC 2515-FT	0.59 (15)	5.04 (128)	3.15 (80)	0.88 (0.4)
VC 2530-F	VC 2530-FT	1.18 (30)	6.34 (161)	4.33 (110)	1.10 (0.5)
VC 2555-F	VC 2555-FT	2.16 (55)	8.23 (209)	5.19 (130)	1.32 (0.6)
VC 2575-F	VC 2575-FT	2.95 (75)	11.14 (283)	5.90 (150)	1.76 (0.8)
VC 25100-F	VC 25100-FT	3.94 (100)	12.13 (308)	5.90 (150)	1.98 (0.9)
VC 25125-F	VC 25125-FT	4.92 (125)	13.13 (333.5)	5.90 (150)	2.20 (1.0)

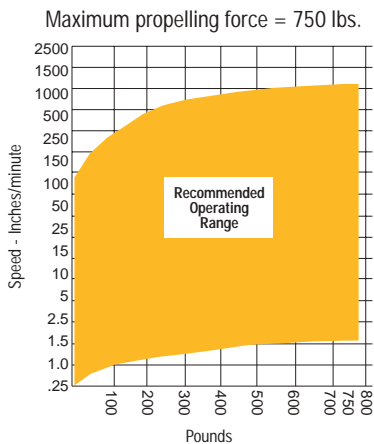
F = fine adjuster/smooth body FT = fine adjuster/threaded body

See chart below for D & E dimensions

VC Specifications

Standard Model	Threaded Model	Propelling Force N		Return Force N		Reset Time seconds
		lbs.	(N)	lbs.	(N)	
VC 2515-F	VC 2515-FT	6.74 - 787	(30 - 3,500)	1.12 - 2.25	(5 - 10)	0.2
VC 2530-F	VC 2530-FT	6.74 - 787	(30 - 3,500)	1.12 - 3.37	(5 - 15)	0.4
VC 2555-F	VC 2555-FT	7.87 - 787	(35 - 3,500)	1.12 - 4.50	(5 - 20)	1.2
VC 2575-F	VC 2575-FT	11.24 - 787	(50 - 3,500)	7.39 - 11.56	(33 - 51)	1.7
VC 25100-F	VC 25100-FT	13.49 - 787	(60 - 3,500)	6.00 - 11.56	(27 - 51)	2.3
VC 25125-F	VC 25125-FT	15.74 - 787	(70 - 3,500)	5.23 - 11.23	(23 - 50)	2.8

Speed Control Chart



Dimensional Chart for Smooth Body Clamp

Model	D	E	Clamp Part No.
VC 2515-F	1.25 (31.7)	.63 (16.0)	250-0465
VC 2530-F			
VC 2555-F			
VC 2575-F	2.00 (50.8)	1.00 (25.4)	250-0466
VC 25100-F			
VC 25125-F			

Mounting Examples



Mounting with Clamp Mount



Installed with Air Bleed Collar SP 25