

AIR REST BUTTONS

PLUNGER & BODY: 1144 STEEL, HEAT TREATED RC 40-45, BLACK OXIDE FINISH



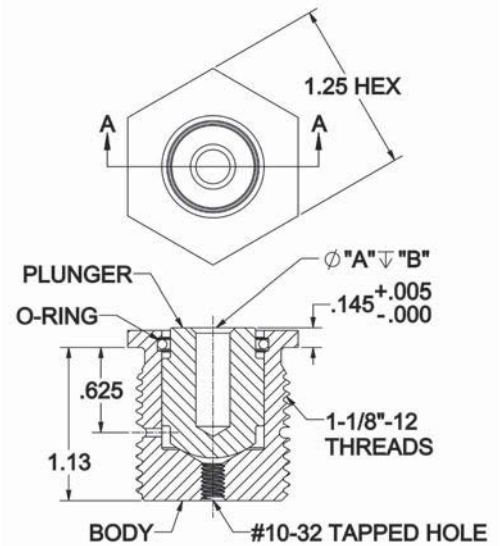
Air Rest Buttons allow using pneumatic position control to detect proper workpiece loading in a machining fixture. These modular units consist of a threaded body installed in a fixture, which holds a precision floating plunger. This plunger has a reamed hole, available in a choice of three diameters, that accepts any height of our standard press-fit-type Rest Buttons.

Proper placement of a workpiece on the Air Rest Button assembly causes the plunger to fully retract into the body. This seals off airflow, which increases the overall pressure of the system (30 psi maximum air pressure). This pressure value can be read using an analog or digital pressure sensor which can then be tied into a PLC or control system. **Patent No. US20190232446A1.**

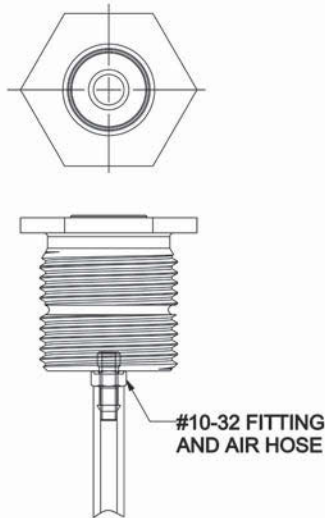
After installation, the retracted plunger's top surface will be .145" above the fixture surface before a Rest Button is installed (the body's top flange is .125" thick, and the plunger protrudes .020" above the flange). If desired to achieve ultimate precision, the top surfaces of all Rest Buttons can be reground after installation of all Rest Button assemblies.

When using pneumatic position control, please consider that keeping the support surfaces reasonably clean is always important. Operations that produce fine chips or grit, such as when machining cast iron, should be avoided. The use of flood coolant, or aggressive coolant, should also be avoided.

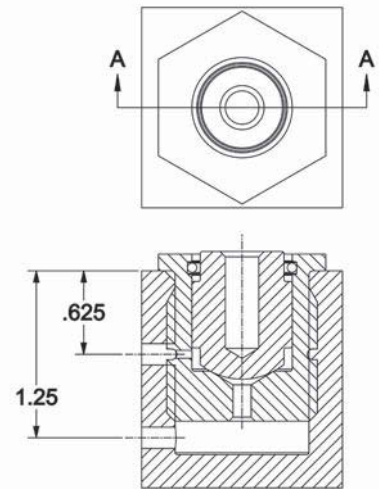
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PART NO.	A DIA		B DIA	MAXIMUM AIR PRESSURE (psi)
	NOMINAL	ACTUAL		
CL-213-ARB	3/16	.1870/.1875	11/16	30
CL-214-ARB	1/4	.2495/.2500		
CL-216-ARB	3/8	.3745/.3750		



Air connection with external fitting



Air connection with drilled manifold passage