

Produced upon receipt of order

Air Servo Cylinder

Ø125, Ø160, Ø200, Ø250, Ø320



IP67

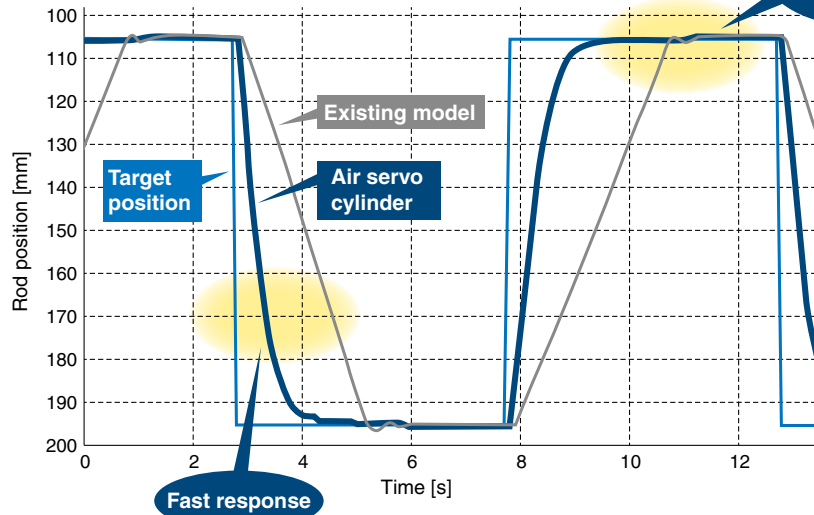
Capable of air cylinder multipoint positioning and control



Fast response and high positioning repeatability

Positioning repeatability: ± 0.5 mm

High positioning repeatability of ± 0.5 mm



Measuring conditions Bore size: Ø200 mm, Cylinder stroke: 200 mm, Load mass: 70 kg

Easier maintenance due to unitization

The valve unit, pilot valve, controller assembly, seal kit, etc., are replaceable.

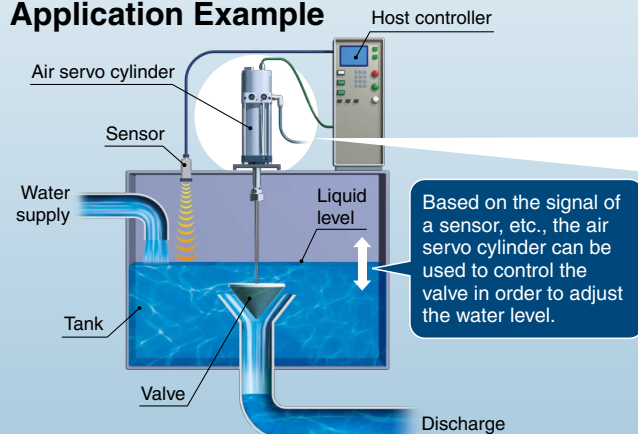
Easy initial setting

Built-in self-diagnosis function (LED lamp and signal output)

Emergency stop of the piston when the air or power supply is cut



Application Example



IN-777



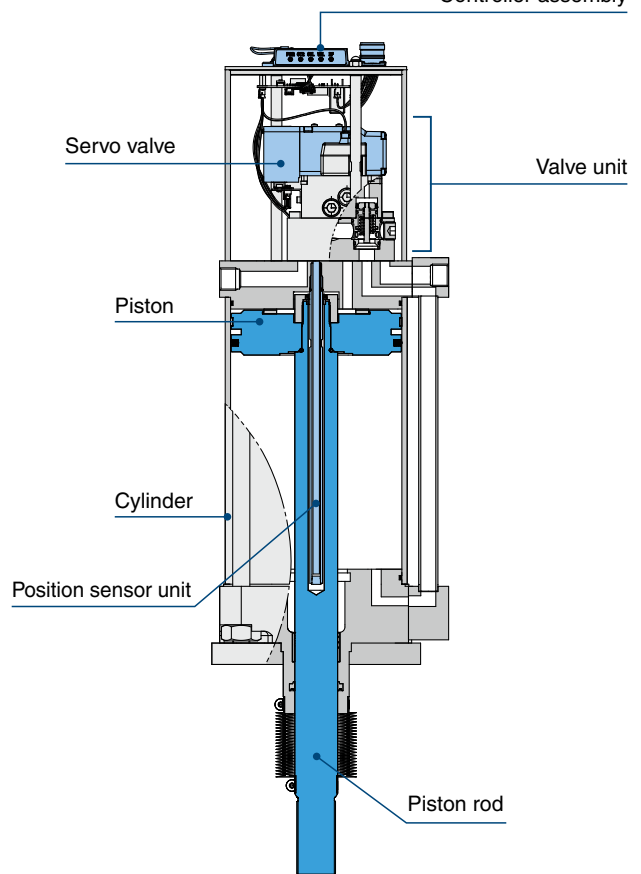
Air Servo Cylinder IN-777

Controller assembly

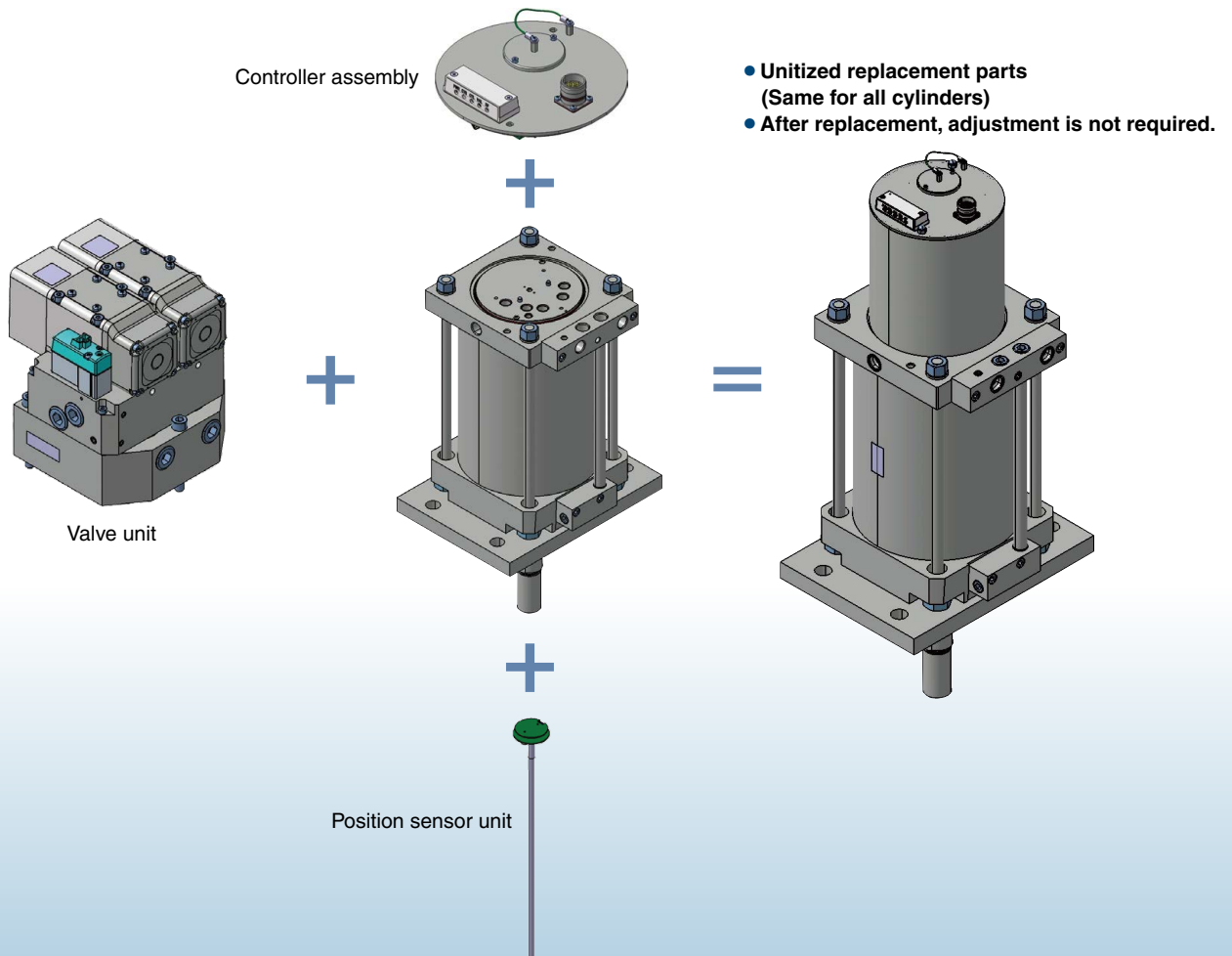
Capable of air cylinder multipoint positioning and control

With a built-in position sensor, the servo valve can be used to control the flow rate on both the head side and the rod side of the cylinder, and it can also be used to position the cylinder.

Cylinder with an integrated servo valve and controller



Easier maintenance due to unitization **p. 9**

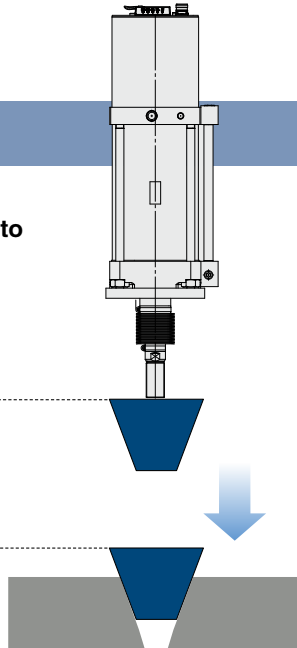


Easy initial setting

Input an I/O signal to move the rod forward, and set the rod stop position to 20 mA (or 4 mA).

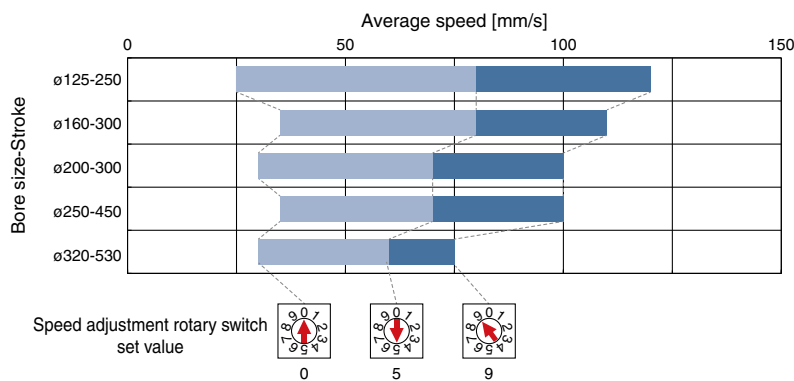
Rod retraction end: 4 mA (or 20 mA)

Rod stop position: Set to 20 mA (or 4 mA)



Speed adjustment function

Capable of 10-level speed setting

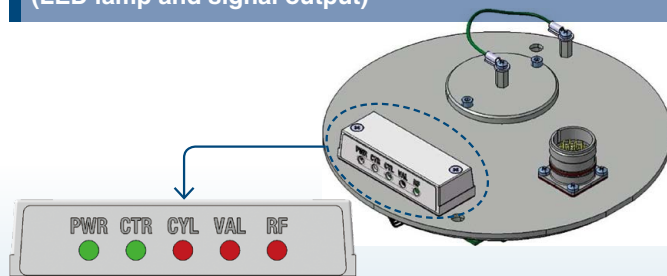


Measuring conditions | Supply pressure: 0.55 Mpa, Mounting: Vertical downward, Load: no-load, Operating direction: Upward

- * The average speed value is the stroke divided by the "full stroke time." The "full stroke time" refers to the time from when the target position operation signal is input until the piston stops.
- * The average speed adjustment range of each cylinder size varies according to the operating conditions.
- * The data above provide a guide for selection but is not guaranteed.

Built-in self-diagnosis function

(LED lamp and signal output)

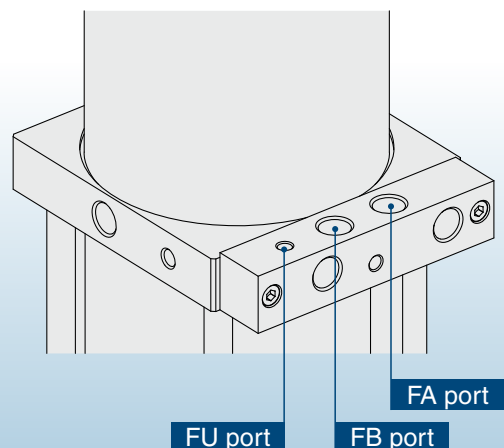


- LED display
- It is possible to output digital signals.

LED display	
PWR	Power supply status
CTR	Controller status
CYL	Cylinder position sensor error
VAL	Valve error
RF	Rod friction error

Fail-safe ports

If the air servo cylinder air or power supply is cut, air from the emergency tank can be supplied via the FA/FB port in order to allow for the manual operation of the air cylinder rod.



Air Servo Cylinder

Produced upon receipt of order

IN-777



∅125, ∅160, ∅200, ∅250, ∅320

How to Order

IN-777-**160**TF-**300**F**J**-**H**L

Bore size

125	125 mm
160	160 mm
200	200 mm
250	250 mm
320	320 mm

Port thread type

TF	G
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Stroke [mm]

125	250
160	200, 300
200	200, 300
250	350, 450
320	200, 350, 530*1

*1 The models specified above are classified as Class-2 Pressure Vessels, as stipulated in the order for enforcement of the Industrial Safety and Health Act, and they are therefore not for use within Japan.

Mounting

F	With rod flange
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Auto-start function

Nil	None
S	With

LED alarm display

L	With LED alarm display
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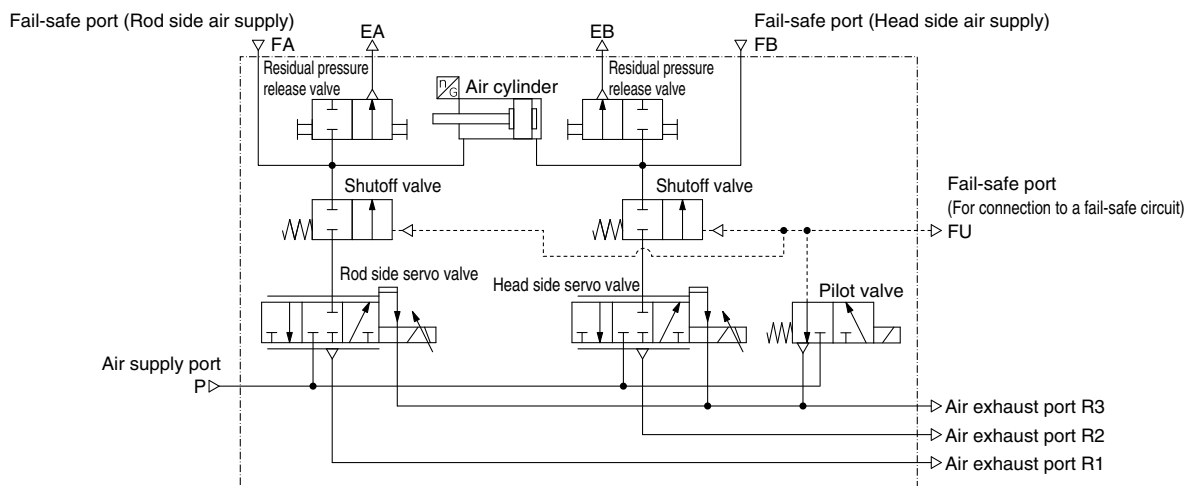
Communication protocol

H	4-20 mA/HART communication
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Rod boot

Symbol	Material	Ambient temperature
J	Silicone rubber	-20°C to 60°C (No freezing)
A	Nylon tarpaulin	-10°C to 60°C (No freezing)
Nil	None	-20°C to 60°C (No freezing)

Pneumatic Circuit



Specifications

Electrical Specifications

Power supply	Supply voltage: 24 VDC ±10%
Control system	Closed loop
Position sensor	Absolute
Analog input signal	4 to 20 mA DC
Analog input impedance	Approx. 250 Ω
Analog output signal	4 to 20 mA DC
Analog output impedance	500 Ω
Voltage between terminals	12 VDC (Equivalent to 600 Ω input resistance at 20 mA DC)
Switch input signal	4 inputs, Connect to +24 VDC ±10% Current consumption: 10 mA or less
Switch output signal	5 outputs, n-type MOSFET open source output Max. load current: 100 mA
Communication protocol	HART communication

Functional Specifications

- JOG operation
- No signal operation
- Self-diagnosis function (Allows for controller, valve, and position sensor error output when an abnormality is present)
- Fail-safe operation
- Calibration (Automatic/Manual)
- Emergency stop
- Residual pressure release valve mounted
- Target position operation
- Speed adjustment (10-level)

Specifications

Mechanical Specifications

Action	Double acting, Single rod
Fluid	Air
Compressed air filtration	0.3 μm or less
Proof pressure	1.2 MPa
Operating pressure range	0.55 to 0.8 MPa
Positioning repeatability	±0.5 mm or less
Average speed	Refer to Table 1 .
Ambient temperature	Silicone rubber material with or without rod boot: -20°C to 60°C (No freezing) Nylon tarpaulin with rod boot: -10°C to 60°C (No freezing)
Fluid temperature	-20°C to 60°C (No freezing)
Operating humidity	35 to 85% (No condensation)
Enclosure	IP67
Standards	CE, UKCA, RoHS
Weight	Refer to Table 2 .
Lubrication	Non-lube
Mounting orientation	Vertical downward/Vertical upward
Vibration resistance	Total amplitude or acceleration: 1.5 mm or 3 G
	Vibration frequency: 5 to 100 Hz
	Vibration applying direction: 3 directions (X, Y, and Z)
	Sweep time/cycle: 12 min/10 cycles
Impact resistance	Acceleration: 15 G
	Pulse applying time/waveform: 11 ms/Sine wave
	Pulse applying direction: 3 times in each direction (X, Y, and Z axes)
Allowable lateral load	Refer to Table 3 .
Theoretical output/Work load	Refer to Table 4 .
Power supply connector (body)	M23 19-pin connector (Male): Refer to Table 5 .

Table 1 Average speed [mm/s]

Bore size [mm]	Stroke [mm]	Speed adjustment rotary switch set value		
125	250	25	80	120
	200	35	70	95
160	300	35	80	110
	200	30	60	85
200	300	30	70	100
	350	35	70	95
250	450	35	70	100
	200	30	55	70
320	350	30	60	75
	530	30	60	75

- * The average speed value is the stroke divided by the "full stroke time." The "full stroke time" refers to the time from when the target position operation signal is input until the piston stops.
- * The average speed adjustment range of each cylinder size varies according to the operating conditions.
- * The data above shows values for the following measurement conditions. (Supply pressure: 0.55 MPa, Mounting: Vertical downward, Load: No load, and Operating direction: Upward)

Table 2 Weight

Bore size [mm]	Stroke [mm]	Weight [kg]
125	250	24
	200	37
160	300	43
	200	53
200	300	61
	350	86
250	450	97
	200	100
320	350	129
	530	163

Table 3 Allowable Lateral Load

Bore size [mm]	Allowable lateral load [N]
125	70
160	90
200	140
250	160
320	230

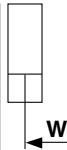


Table 4 Theoretical Output/Max. Work Load

Bore size [mm]	Operating direction	Theoretical output [N]		Max. work load [kg]*1
		Operating pressure [MPa]		
125	IN	6,400	9,200	160
	OUT	6,800	9,900	
160	IN	10,400	15,100	240
	OUT	11,100	16,100	
200	IN	16,600	24,200	240
	OUT	17,300	25,200	
250	IN	26,000	37,700	300
	OUT	27,000	39,300	
320	IN	42,700	62,100	300
	OUT	44,300	64,400	

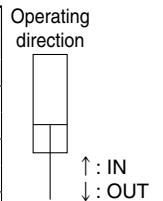
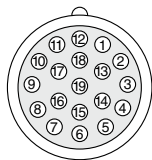


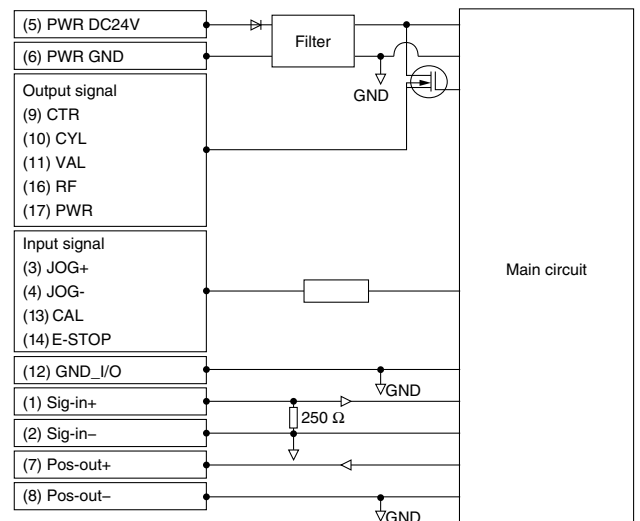
Table 5 Connector Pin Numbers (Body Side)

Pin no.	Signal name	IN/OUT	Description
1	Sig-in+	IN	Analog signal (4-20 mA(+)), HART communication signal input
2	Sig-in-	IN	Analog signal (4-20 mA(-)), HART communication signal input
3	JOG+	IN	JOG operation signal input (Moves to the rod side)
4	JOG-	IN	JOG operation signal input (Moves to the head side)
5	PWR DC24V		Power supply +24 VDC
6	PWR GND		Power supply GND
7	Pos-out+	OUT	Analog position signal (+) output
8	Pos-out-	OUT	Analog position signal (-) output
9	CTR	OUT	Controller signal output
10	CYL	OUT	Position sensor error signal output
11	VAL	OUT	Valve error signal output
12	GND_I/O		Signal GND
13	CAL	IN	Calibration signal input
14	E-STOP	IN	Emergency stop signal input*1
15	—	—	—
16	RF	OUT	Rod friction error signal output
17	PWR	OUT	Power supply error signal output
18	—	—	—
19	—	—	—



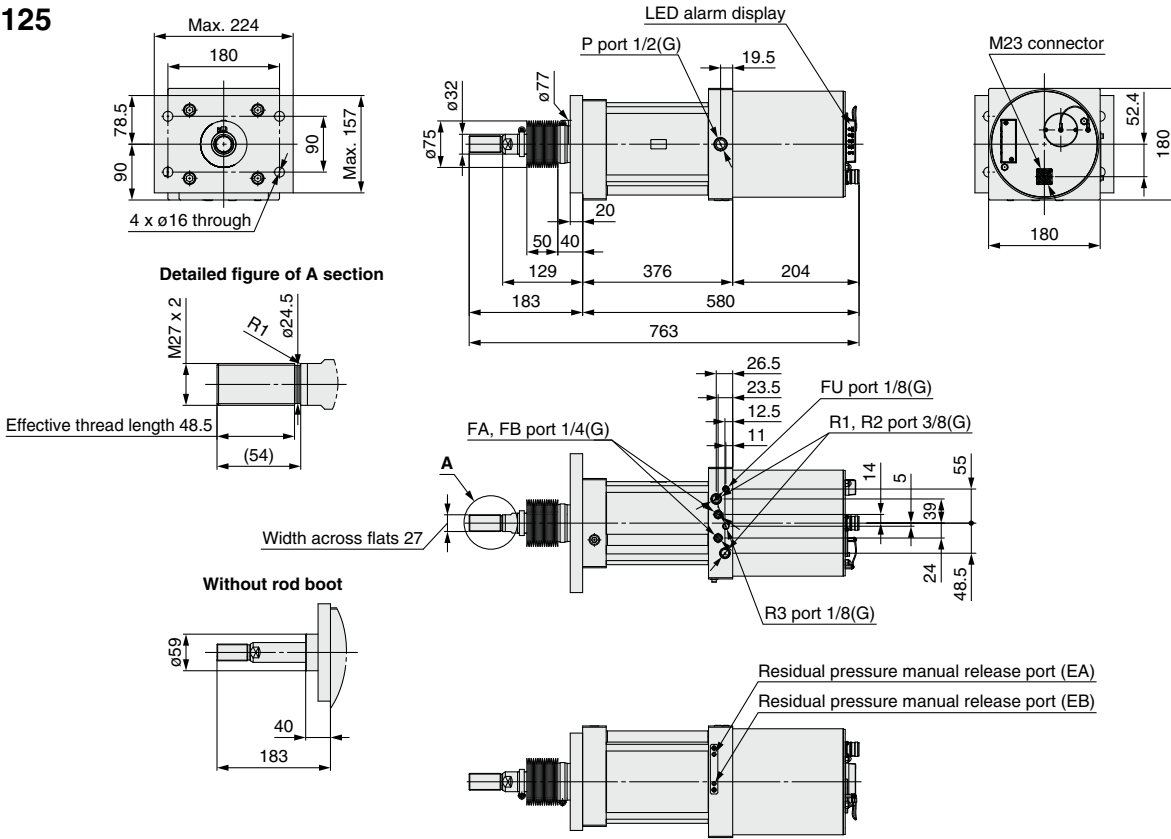
*1 When the signal is OFF, an emergency stop occurs. —: Cannot be connected

Wiring Diagram

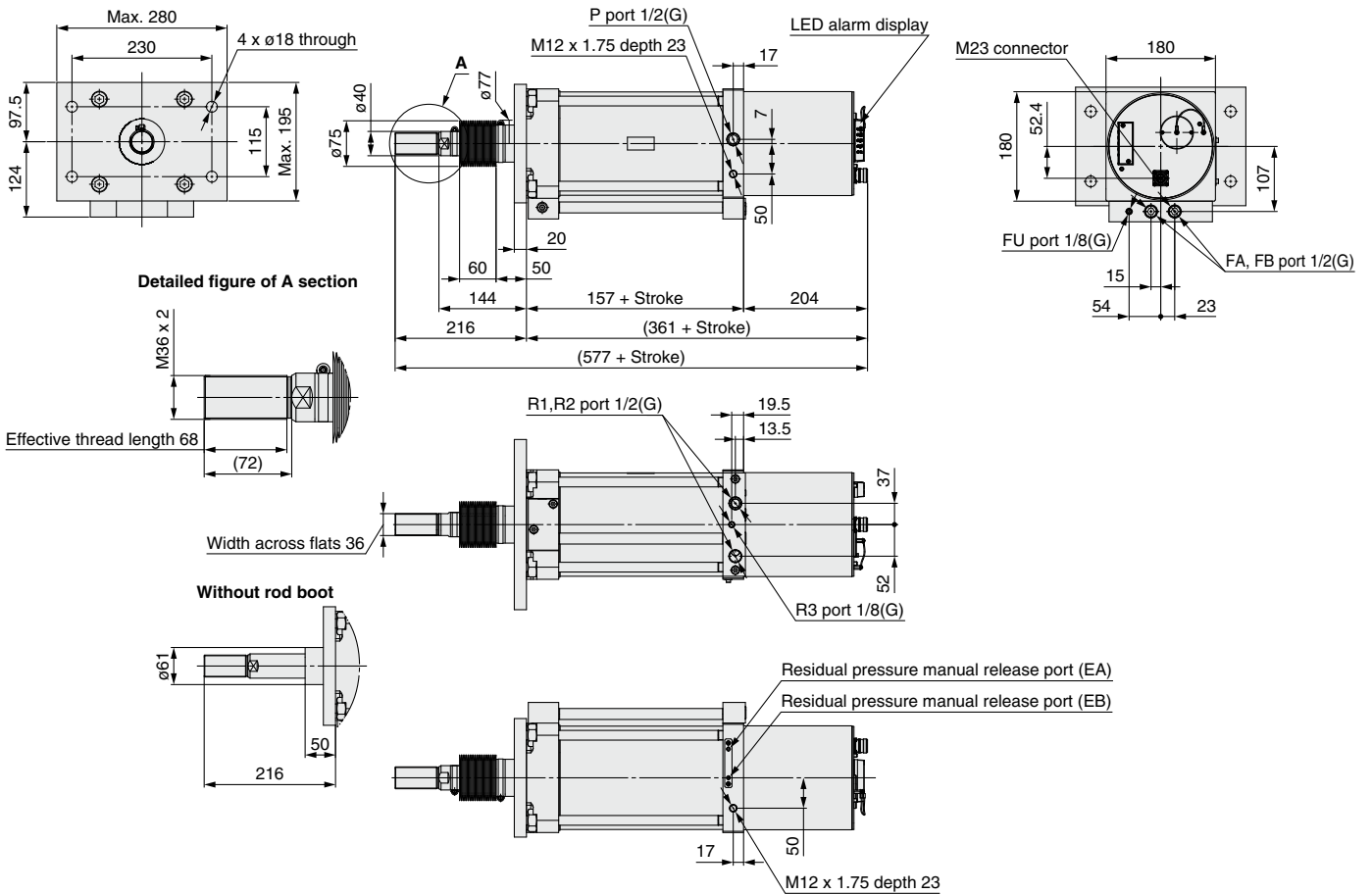


Dimensions

ø125

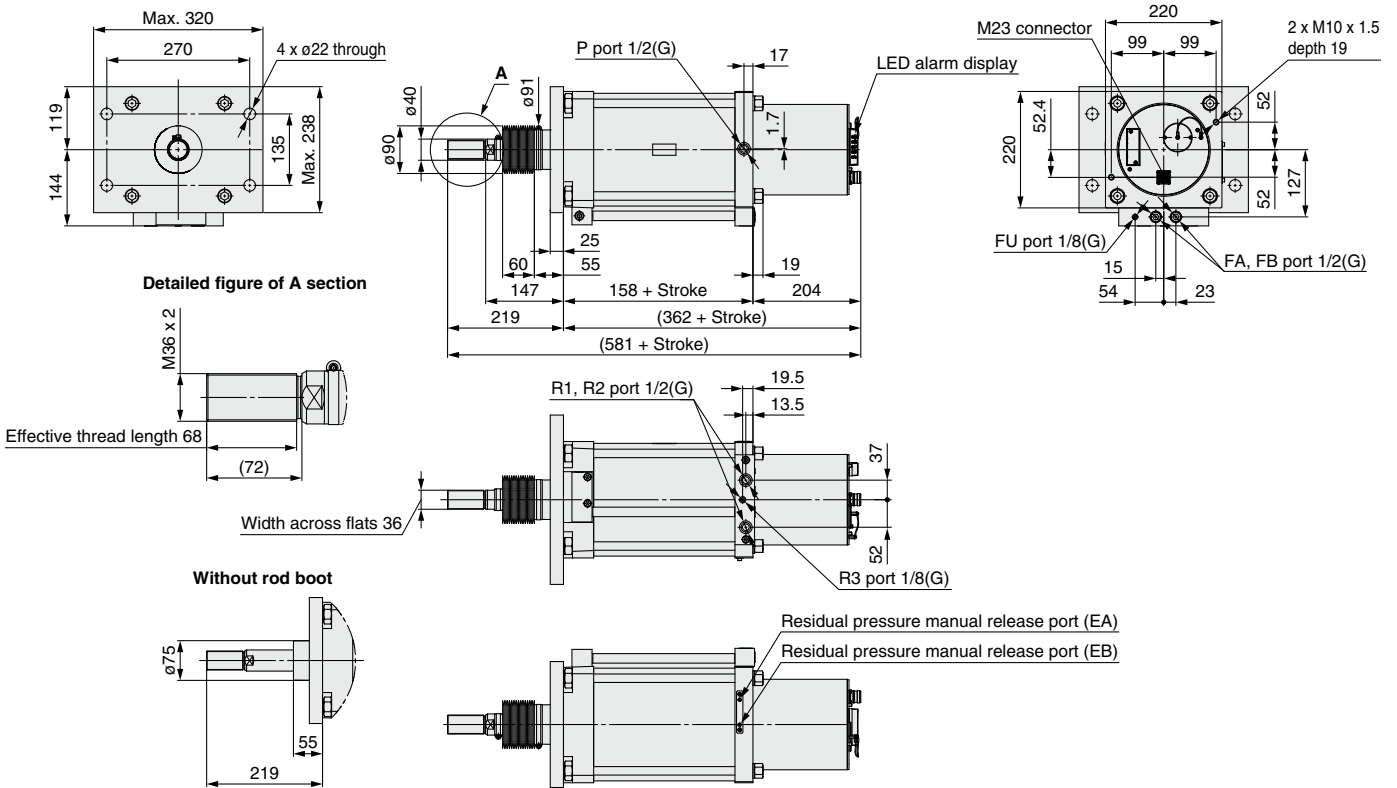


ø160

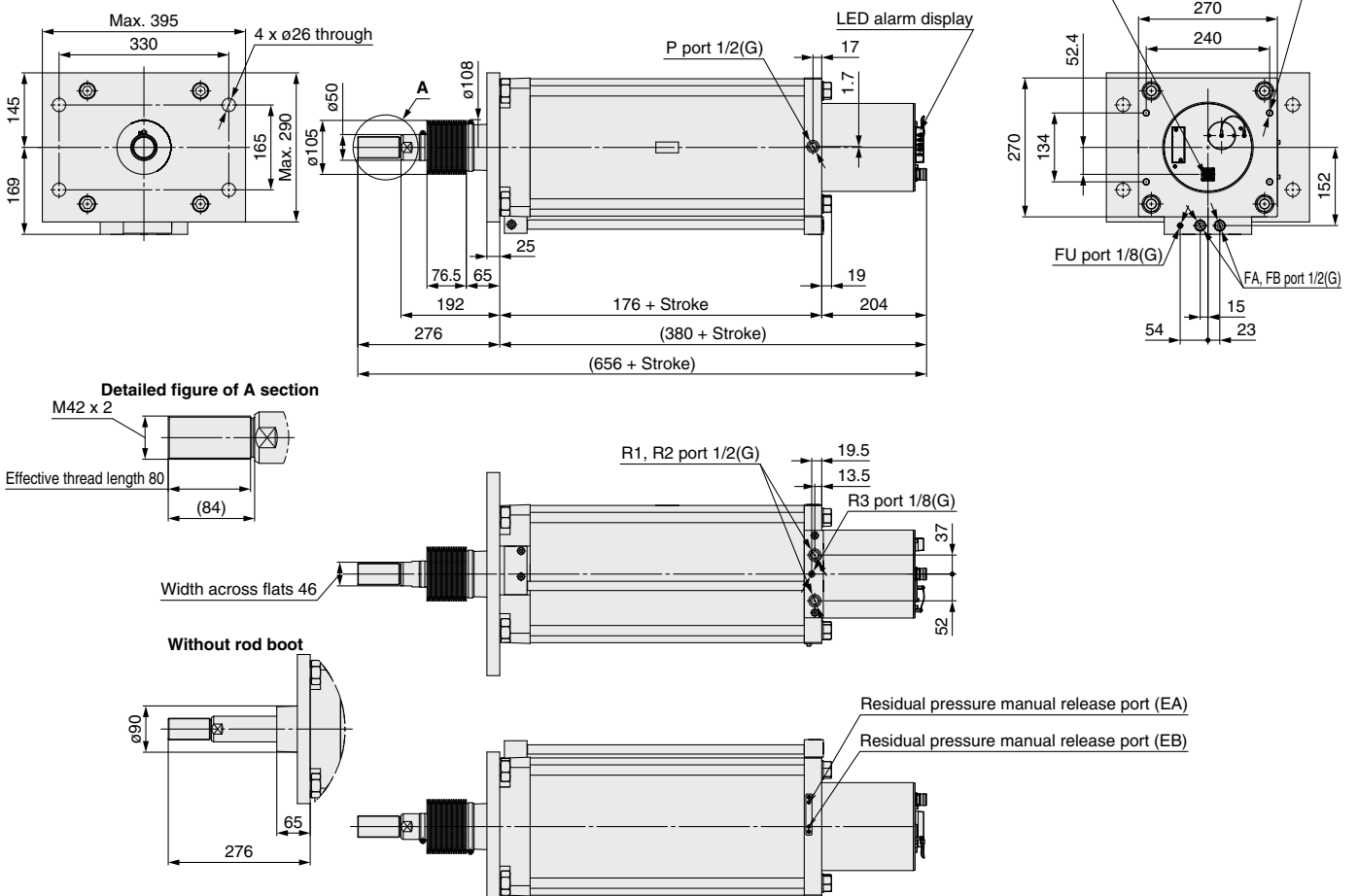


Dimensions

ø200

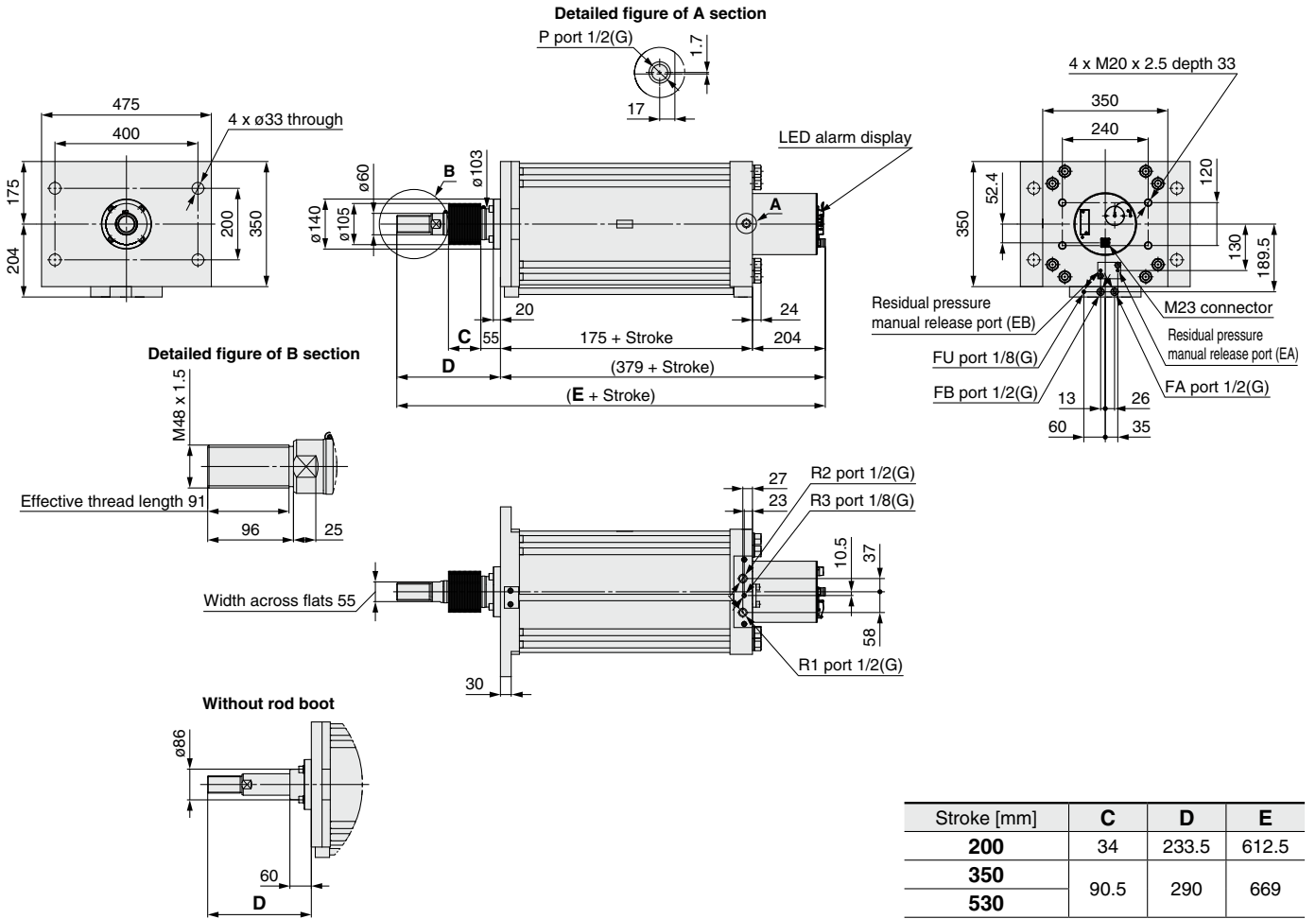


ø250



Dimensions

ø320



Working Principle/Construction

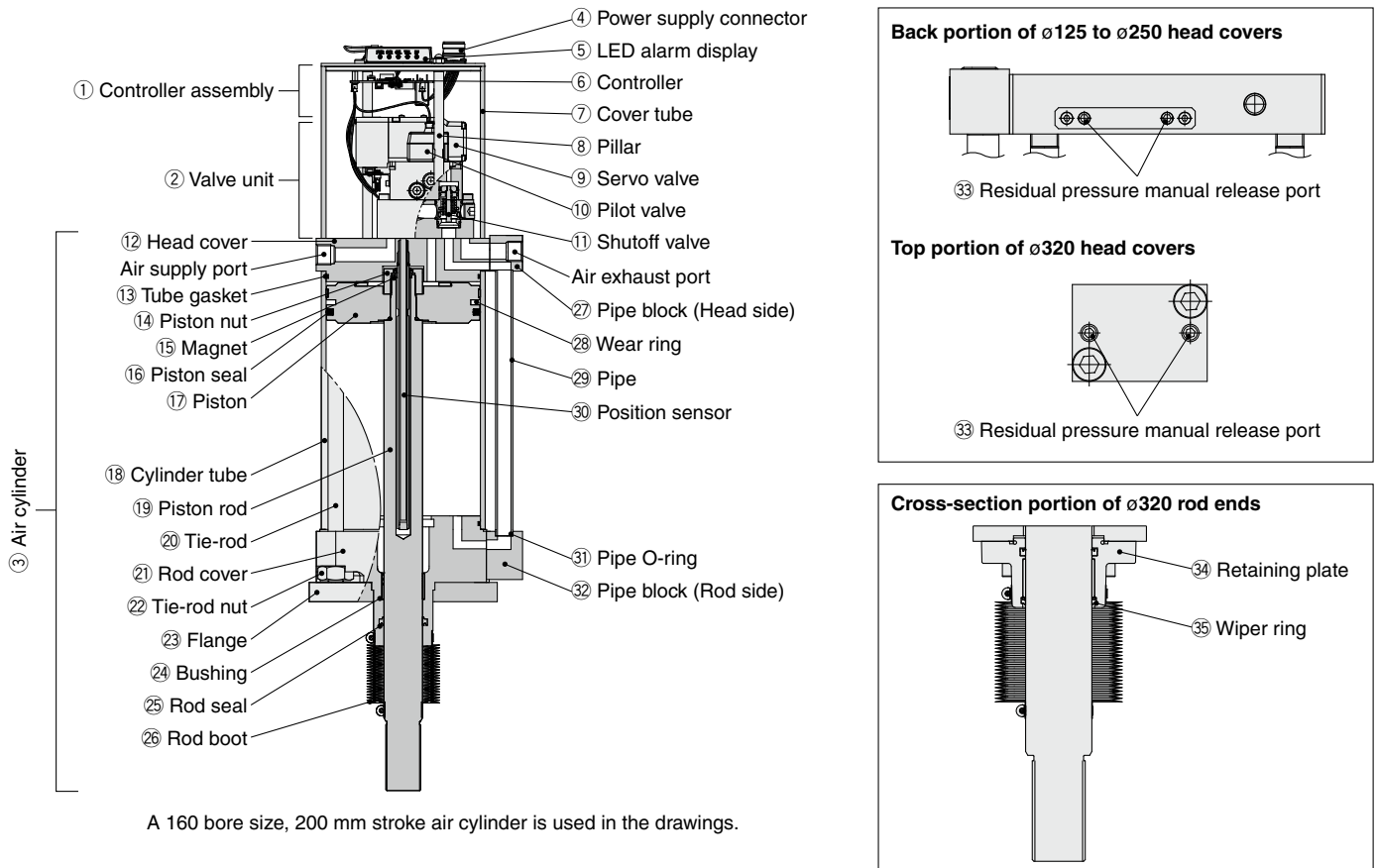
The ③ position sensor built in to the ③ air cylinder outputs the current position of the ⑱ piston rod to the ⑥ controller.

Next, the ⑥ controller outputs a command signal to the 2 ⑨ servo valves according to the target position signal sent from the host controller.

Then, according to the command signal sent from the ⑥ controller, the ⑨ servo valves control the ③ air cylinder air supply or exhaust to move the piston rod forwards or backwards, or to stop it at the target position.

The opening and closing of the ⑪ shutoff valve is controlled by the ⑩ pilot valve connected to the ⑥ controller.

Two air-operated ⑪ shutoff valves (head side and rod side) are mounted along the air passage between the ⑨ servo valves and the ③ air cylinder. During an emergency stop (air or power supply cutoff, emergency stop signal input, etc.), the 2 ⑪ shutoff valves will close and ③ air cylinder operation will be stopped.



A 160 bore size, 200 mm stroke air cylinder is used in the drawings.

Component Parts

No.	Description	Material/Surface treatment	No.	Description	Material/Surface treatment
1	Controller assembly*1	Aluminum alloy/Anodized (Main parts)	21	Rod cover	ø160 to ø250: Aluminum die-cast/Chromated ø125 and ø320: Aluminum alloy/Anodized
2	Valve unit*1	—	22	Tie-rod nut	Stainless steel
3	Air cylinder	—	23	Flange*2	Steel/Zinc plating
4	Power supply connector	—	24	Bushing	Bearing alloy
5	LED alarm display	Aluminum alloy/Painted (Main parts)	25	Rod seal*1	Low-temperature NBR
6	Controller	—	26	Rod boot (Option)*1	Silicone rubber material (selectable) Nylon tarpaulin
7	Cover tube	Aluminum alloy/Anodized	27	Pipe block (Head side)*3	Aluminum alloy/Anodized
8	Pillar	Aluminum alloy	28	Wear ring*1	Resin
9	Servo valve*1	—	29	Pipe	Aluminum alloy/Anodized
10	Pilot valve*1	—	30	Position sensor*1	—
11	Shutoff valve	—	31	Pipe O-ring*1	Low-temperature NBR
12	Head cover	Aluminum alloy/Anodized	32	Pipe block (Rod side)*4	Aluminum alloy/Anodized
13	Tube gasket*1	Low-temperature NBR	33	Residual pressure manual release port	—
14	Piston nut	Stainless steel	34	Retaining plate	Stainless steel
15	Magnet	—	35	Wiper ring*1	Low-temperature NBR
16	Piston seal*1	Low-temperature NBR			
17	Piston	Aluminum alloy/Chromated			
18	Cylinder tube	ø125 to ø250: Aluminum alloy/Anodized ø320: Carbon steel tube/Painted			
19	Piston rod	Stainless steel/Hard chrome plating			
20	Tie-rod	Stainless steel			

*1 Refer to page 9 for maintenance parts and seal kit accessories.

*2 The rod cover is integrated for size ø320.

*3 The head cover is integrated for size ø125.

*4 The rod cover is integrated for size ø125.

Maintenance Parts

① Controller assembly

IN-777P-HL-410AS

Communication protocol

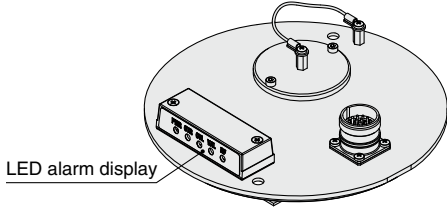
H	4-20 mA/HART communication
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Auto-start function

Nil	None
S	With

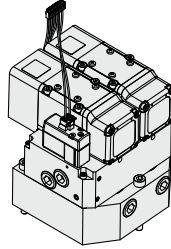
LED alarm display

L	With LED alarm display
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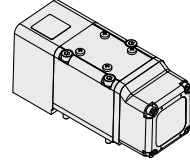
② Valve unit

IN-777P-010AS



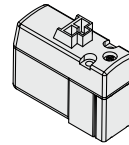
⑨ Servo valve

XT581-V-C-X001

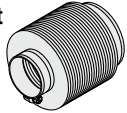


⑩ Pilot valve

V211KT-5LOZ-X48



⑫ Rod boot



Bore size [mm]	Stroke [mm]	Part number	
		Silicone rubber material	Nylon tarpaulin
125	250	C96A2G-1461V-R	C96A2G-0294Y-R
	300	C95A6G-471AQ-R	CS1-J16-300
160	200	C95B0G-472AQ-R	C95B0G-0304Y-R
	300	C95B5G-533AQ-R	C95B5G-574EQ-R
200	200	C1SC2G-1468V-R	CS1-J25-200
	350	C1SC2G-1470V-R	CS1-J25-530
250	200		
	350		
320	200		
	350		
320	350		
	530		

⑬ Position sensor unit

IN-777P-200-830AS



Cylinder stroke

200	200 mm
250	250 mm
300	300 mm
350	350 mm
450	450 mm
530	530 mm

* For the position sensor unit, the cylinder stroke is the same for all tube sizes.

Seal kit

IN-777P-125-910AS

Bore size

125	This set includes the following: ⑬ Tube gasket (2 pcs.)
160	⑮ Piston seal (1 pc.)
200	⑲ Rod seal (1 pc.)
250	⑳ Wear ring (1 pc.)
	㉑ Pipe O-ring (2 pcs.)
320	This set includes the following: ⑬ Tube gasket (2 pcs.)
	⑮ Piston seal (1 pc.)
	⑲ Rod seal (1 pc.)
	⑳ Wear ring (1 pc.)
	㉑ Pipe O-ring (2 pcs.)
	㉒ Wiper ring (1 pc.)

* The seal kit includes a grease pack.

* The circled numbers correspond to the component numbers in the cross-section construction drawing on page 8.

Ambient temperature specifications

Silicone rubber material: -20°C to 60°C (No freezing)

Nylon tarpaulin: -10°C to 60°C (No freezing)

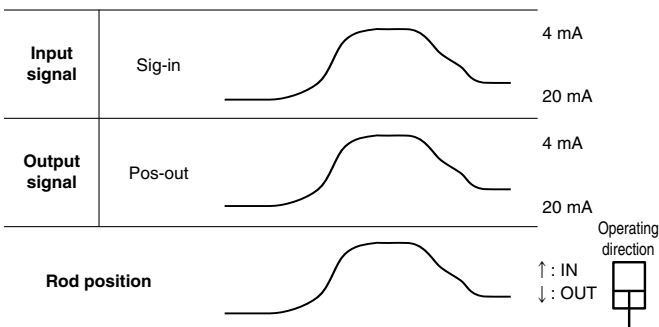
Operation Modes

■ Target position operation

The rod position is decided according to the Sig-in signal input by the external controller.

The rod position is then output as a Pos-out signal.

* Be sure to calibrate the product before use. If the set point has not yet been set, the rod will not move even during a target position operation. Refer to page 10 for calibration instructions.

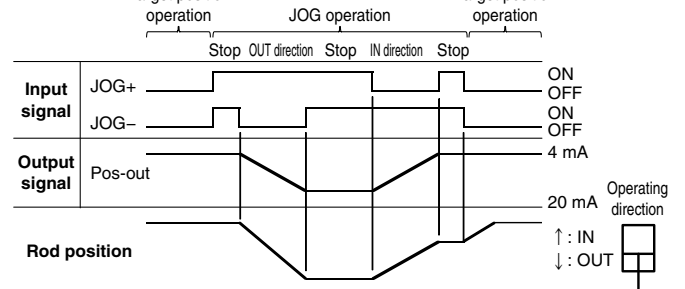


* The operating direction can be changed.

■ JOG operation

The rod moves according to the JOG signal input by the external controller.

Timing chart



		JOG+	
		OFF	ON
JOG-	OFF	Target position operation	JOG operation (Moves in the OUT direction)
	ON	JOG operation (Moves in the IN direction)	JOG operation (Stops)

* The device will move to the target position input as the Sig-in and stop when changing from JOG operation to target position operation.

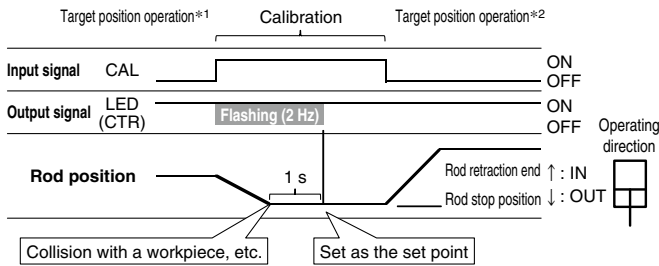
Operation Modes

■ Calibration

Set the rod position (set point) by inputting a CAL signal into the external controller and setting the Sig-in signal to 20 mA (default). When changing the operation direction, the 4 mA rod position becomes the set point. It is possible to change the operation mode from automatic to manual.

Automatic (Default)

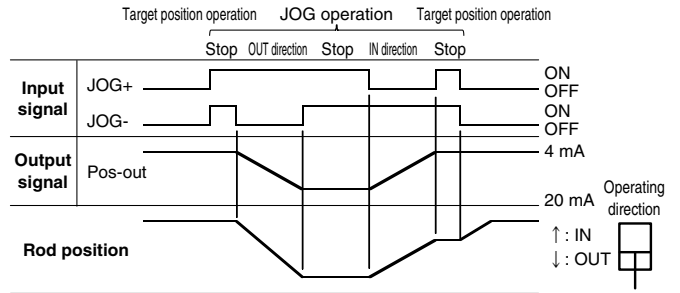
When the CAL signal is turned ON, the rod will move in the OUT direction, and the position where the rod stops for 1 s will become the set point. When the CAL signal is turned OFF, the rod will move in the IN direction, and the rod will stop at the retraction end.



- *1 If the set point has not yet been set, the rod will not move even during a target position operation.
- *2 The target position may vary slightly before and after the set point has been set, even if the Sig-in signal is the same.

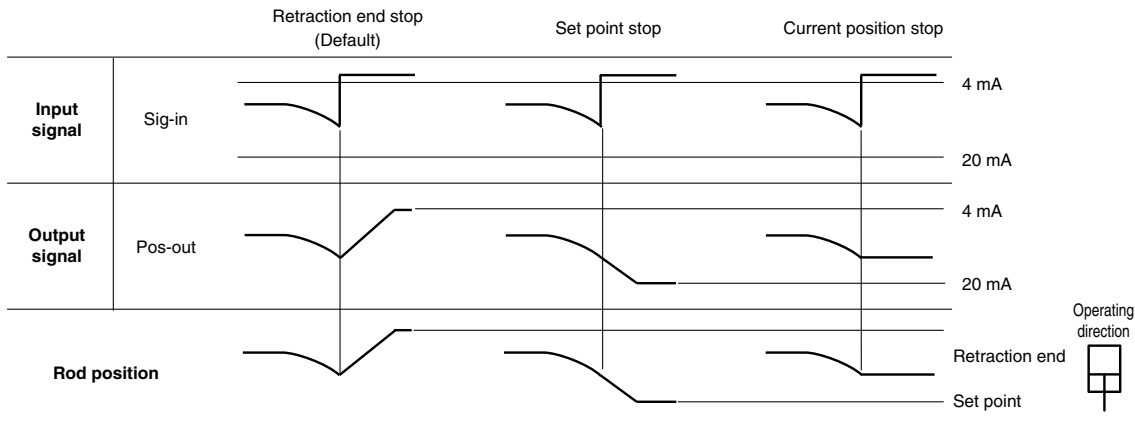
Manual

The rod will be moved by the JOG signal, and the position of the rod when the CAL signal is input will become the set point.



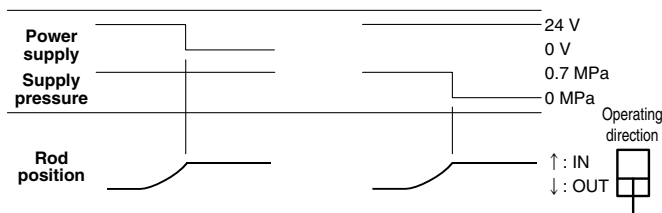
■ No signal operation

This is the operation mode used when the Sig-in signal input into the external controller is 4 mA or less. The rod will move to the predetermined position and then stop.



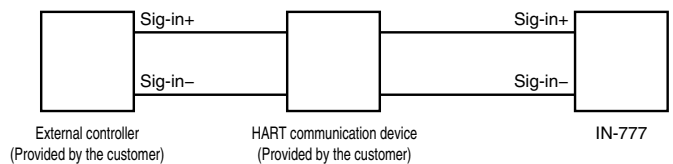
■ Emergency stop

When the air servo cylinder air or power supply is cut during use, the built-in shutoff valves will close, stopping the rod. Air from the emergency tank can be supplied via the fail-safe port (FA/FB) in order to allow for the operation of the air cylinder rod.



■ HART (Highway Addressable Remote Transducer) communication

With this communication type, a digital signal is superimposed on the 4-20 mA Sig-in signal and then transmitted. Connect a HART communication device (provided by the customer) between the Sig-in + and the Sig-in -.



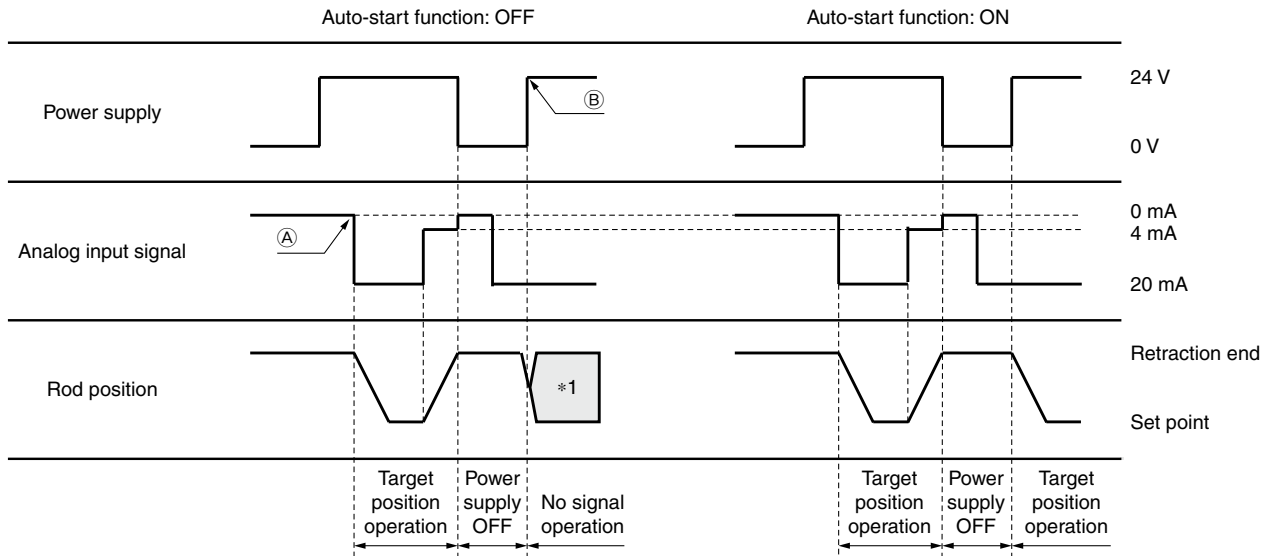
Main transmission contents	
1.	IN-777 information – confirmation and revision
2.	HART communication settings – confirmation and revision
3.	Cylinder operating conditions - setting and confirmation
4.	Calibration - execution
5.	Operating mode - setting and revision
6.	JOG operation - execution
7.	Operation status/Alarm confirmation

Operation Modes

■ Auto-start function

For the auto-start function OFF specification, to start the target position operation, input the analog input signal (A) only after turning the power supply ON. Inputting the analog input signal before the power supply has been turned ON (B) will result in a switch to no-signal operation.

For the auto-start function ON specification, the order in which the analog input signal is inputted and the power supply is turned ON does not matter; the target position operation will start once both requirements have been satisfied.



*1 For no-signal operation, stopping at the retraction end, stopping at the set point, or stopping at the current position can be selected when determining the settings.



IN-777

Air Servo Cylinder Specific Product Precautions

Be sure to read this before handling the products.

Mounting

⚠ Caution

1. **Vibration may occur due to positioning control depending on the operating environment, load, conditions, etc.**

Be sure to inspect the actual machine for sufficient strength retention in regard to the amount of cylinder vibration that occurs.

2. **Mount so that a lateral load which exceeds the allowable lateral load is not applied to the piston rod.**

If a lateral load which exceeds the allowable lateral load is applied, the positioning repeatability during the target position operation will decline, which may lead to piston rod malfunction.

In addition, if the seals, cylinder tubing, etc., come into direct contact with the metal parts of the piston, air leakage due to uneven wear or reduced service life due to accelerated wear of the bearing may result. Refer to **Table 2** on page 4 for the allowable lateral load.

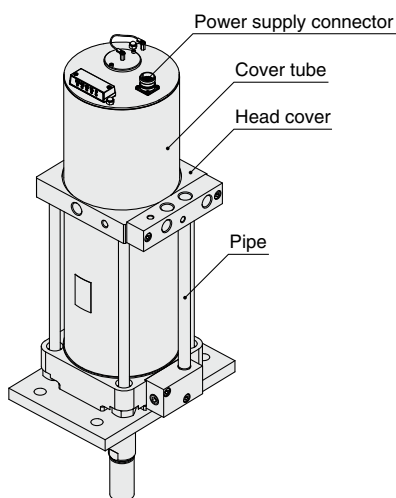
3. **When a workpiece is mounted on the piston rod end, connect them by aligning the axial center of the piston rod and that of the workpiece.**

If they are off-center, a lateral load will be generated and the phenomena mentioned in item 2 may occur.

4. **When mounting the body, be sure to avoid force being applied to the piping between the air cylinder head cover and the rod cover, cover tube, power supply connector, etc.**

Applying excessive external force to the piping may result in damage to the piping or a malfunction.

As screw holes for installing eye bolts are provided on the head covers of sizes $\phi 160$ and larger, insert the eye bolts into the screw holes and hang the product to mount it.



Operating Precautions

⚠ Caution

1. **When powering-up the product, restarting after an emergency stop, or switching the operating mode, be careful as the piston rod may suddenly extend or retract according to the settings.**

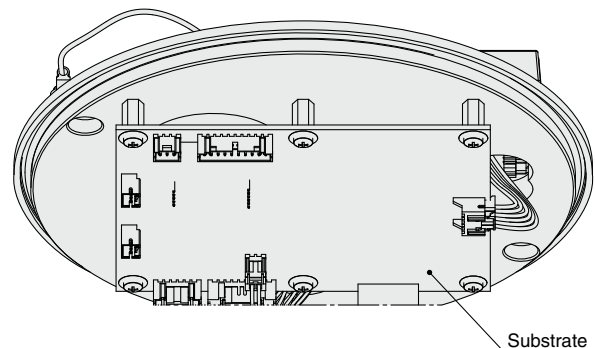
2. **Avoid use in environments where condensation is generated.**

When moving the product to a location at room temperature after operating it in low-temperature conditions, the temperature will rise suddenly and condensation will be generated. If water droplets from the generated condensation adhere to the internal substrate, an electric short-circuit may occur, resulting in a malfunction.

Maintenance

⚠ Caution

1. **When disassembling the product for controller assembly replacement, etc., be sure not to touch the substrate with your bare hands.**



⚠ Safety Instructions Be sure to read the "Handling Precautions for SMC Products" (M-E03-3) and "Operation Manual" before use.