



**Hinweis:**

Bitte beachten Sie, dass beim Volleinbau des NSE3 138-V1 der Luftanschluss bodenseitig zugefuehrt wird.

**Entlueftung des Kolben:**

Bei der Betaetigung des NSE3 138-V1 muss eine Entlueftung des Kolbenraums gewaehrleistet werden. Es gibt 3 Moeglichkeiten den Kolbenraum des NSE3 138-V1 zu entlueften:  
 ① Durch die Verwendung der Turbo- Funktion  
 ② Durch Anschließen des Turbo- Anschlusses (ohne diesen jedoch zu verwenden)  
 ③ Durch Entfernen des bodenseitigen Gewindestifts an der Unterseite des NSE3 138-V1

Um die Entlueftung des Kolbenraums zu gewaehrleisten, ist ein Anschluss ohne Sperrfunktion zu verwenden.

**Entlueftung Spannschieberhub:**

④ Um beim Spannhub der Spannschieber des NSE3 138-V1 ein Luftpolster zu verhindern, ist zusaetzlich die Entlueftungsbohrung Ø5 mm zu integrieren.

**Entlueftung Einbau:**

⑤ Um beim Einbau der NSE3 138-V1 ein Luftpolster zu verhindern, ist zusaetzlich eine Entlueftungsbohrung Ø5 mm zu integrieren.

**Verwendung von mehreren Modulen:**

Bei der Verwendung von mehreren NSE3 138-V1 muss beim Stichmaß eine Toleranz von ± 0.015 mm gewaehrleistet werden.  
 ⑥ Alle Module muessen hoehengleich ≤ 0.03 mm sein.

**Abdichtung:**

⑦ Nut fuer O-Ring DIN 3771 Ø140x2 Id.Nr.: 9937935 (O-Ring ist nicht im Lieferumfang enthalten)

**Remark:**

Please note, that the air connection of the full intgrated NSE3 138-V1 is only possible from the bottom side.

**Vent of the piston chamber:**

During the actuation of the NSE3 138-V1, the piston chamber need to be vent. There are 3 options to vent the piston chamber of the NSE3 138-V1:  
 ① By using the turbo- function itself  
 ② By connecting the turbo- connection (without using it)  
 ③ By removing the set screw from the bottom side of the NSE3 138-V1

To maintain the vent of the piston chamber, you have to use a connector without lock function.

**Clamping slide stroke vent:**

④ To prevent a air buffer because of the clamping stroke, please add an additional vent bore Ø5 mm.

**Assembly vent:**

⑤ To prevent a air buffer during the assembling, please add an additional vent bore Ø5 mm.

**Using of several moduls:**

By using several NSE3 138-V1 the pitch tolerance ± 0.015 mm need to be maintained.  
 ⑥ All modules height matched to each other within ≤ 0.03 mm.

**Sealing:**

⑦ Groove for O-ring DIN 3771 Ø140x2 Id.No.: 9937935 (O-Ring is not included)

Anzahl der Module Quantity of moduls	mind. Schlauch-Nennweite minimum hose diameter
1	4 mm
2, 3, 4	6 mm
ab 5	8 mm

Allgemeintoleranzen DIN ISO 2768-mH		Tolerierung ISO 8015		Gewindetoleranzen DIN ISO 965-1	
Grenzabmasse fuer Laengenmasse DIN ISO 2768 T1 mittel	0.5 -6	0.125	0.2	0.1	0.05
	6 -30	0.2	0.3	0.1	0.05
	30 -120	0.3	0.4	0.1	0.05
	120 -400	0.4	0.5	0.1	0.05
	400 -1000	0.5	0.6	0.1	0.05
	1000 -2000	0.6	0.8	0.1	0.05
	±0.1	0.8	1.2	0.1	0.05
	±0.2	1.2	1.6	0.1	0.05
	±0.3	1.6	2.0	0.1	0.05
	±0.5	2.0	2.5	0.1	0.05
	±0.8	2.5	3.2	0.1	0.05
	±1.2	3.2	4.0	0.1	0.05
	±1.6	4.0	5.0	0.1	0.05
	±2.0	5.0	6.3	0.1	0.05
	±2.5	6.3	8.0	0.1	0.05
	±3.2	8.0	10.0	0.1	0.05
	±4.0	10.0	12.5	0.1	0.05
	±5.0	12.5	16.0	0.1	0.05
	±6.3	16.0	20.0	0.1	0.05
	±8.0	20.0	25.0	0.1	0.05
	±10.0	25.0	31.5	0.1	0.05
	±12.5	31.5	40.0	0.1	0.05
	±16.0	40.0	50.0	0.1	0.05
	±20.0	50.0	63.0	0.1	0.05
	±25.0	63.0	80.0	0.1	0.05
	±31.5	80.0	100.0	0.1	0.05
	±40.0	100.0	125.0	0.1	0.05
	±50.0	125.0	160.0	0.1	0.05
	±63.0	160.0	200.0	0.1	0.05
	±80.0	200.0	250.0	0.1	0.05
	±100.0	250.0	315.0	0.1	0.05
	±125.0	315.0	400.0	0.1	0.05
	±160.0	400.0	500.0	0.1	0.05
	±200.0	500.0	630.0	0.1	0.05
	±250.0	630.0	800.0	0.1	0.05
	±315.0	800.0	1000.0	0.1	0.05
	±400.0	1000.0	1250.0	0.1	0.05
	±500.0	1250.0	1600.0	0.1	0.05
	±630.0	1600.0	2000.0	0.1	0.05
	±800.0	2000.0	2500.0	0.1	0.05
	±1000.0	2500.0	3150.0	0.1	0.05
	±1250.0	3150.0	4000.0	0.1	0.05
	±1600.0	4000.0	5000.0	0.1	0.05
	±2000.0	5000.0	6300.0	0.1	0.05
	±2500.0	6300.0	8000.0	0.1	0.05
	±3150.0	8000.0	10000.0	0.1	0.05
	±4000.0	10000.0	12500.0	0.1	0.05
	±5000.0	12500.0	16000.0	0.1	0.05
	±6300.0	16000.0	20000.0	0.1	0.05
	±8000.0	20000.0	25000.0	0.1	0.05
	±10000.0	25000.0	31500.0	0.1	0.05
	±12500.0	31500.0	40000.0	0.1	0.05
	±16000.0	40000.0	50000.0	0.1	0.05
	±20000.0	50000.0	63000.0	0.1	0.05
	±25000.0	63000.0	80000.0	0.1	0.05
	±31500.0	80000.0	100000.0	0.1	0.05
	±40000.0	100000.0	125000.0	0.1	0.05
	±50000.0	125000.0	160000.0	0.1	0.05
	±63000.0	160000.0	200000.0	0.1	0.05
	±80000.0	200000.0	250000.0	0.1	0.05
	±100000.0	250000.0	315000.0	0.1	0.05
	±125000.0	315000.0	400000.0	0.1	0.05
	±160000.0	400000.0	500000.0	0.1	0.05
	±200000.0	500000.0	630000.0	0.1	0.05
	±250000.0	630000.0	800000.0	0.1	0.05
	±315000.0	800000.0	1000000.0	0.1	0.05
	±400000.0	1000000.0	1250000.0	0.1	0.05
	±500000.0	1250000.0	1600000.0	0.1	0.05
	±630000.0	1600000.0	2000000.0	0.1	0.05
	±800000.0	2000000.0	2500000.0	0.1	0.05
	±1000000.0	2500000.0	3150000.0	0.1	0.05
	±1250000.0	3150000.0	4000000.0	0.1	0.05
	±1600000.0	4000000.0	5000000.0	0.1	0.05
	±2000000.0	5000000.0	6300000.0	0.1	0.05
	±2500000.0	6300000.0	8000000.0	0.1	0.05
	±3150000.0	8000000.0	10000000.0	0.1	0.05
	±4000000.0	10000000.0	12500000.0	0.1	0.05
	±5000000.0	12500000.0	16000000.0	0.1	0.05
	±6300000.0	16000000.0	20000000.0	0.1	0.05
	±8000000.0	20000000.0	25000000.0	0.1	0.05
	±10000000.0	25000000.0	31500000.0	0.1	0.05
	±12500000.0	31500000.0	40000000.0	0.1	0.05
	±16000000.0	40000000.0	50000000.0	0.1	0.05
	±20000000.0	50000000.0	63000000.0	0.1	0.05
	±25000000.0	63000000.0	80000000.0	0.1	0.05
	±31500000.0	80000000.0	100000000.0	0.1	0.05
	±40000000.0	100000000.0	125000000.0	0.1	0.05
	±50000000.0	125000000.0	160000000.0	0.1	0.05
	±63000000.0	160000000.0	200000000.0	0.1	0.05
	±80000000.0	200000000.0	250000000.0	0.1	0.05
	±100000000.0	250000000.0	315000000.0	0.1	0.05
	±125000000.0	315000000.0	400000000.0	0.1	0.05
	±160000000.0	400000000.0	500000000.0	0.1	0.05
	±200000000.0	500000000.0	630000000.0	0.1	0.05
	±250000000.0	630000000.0	800000000.0	0.1	0.05
	±315000000.0	800000000.0	1000000000.0	0.1	0.05
	±400000000.0	1000000000.0	1250000000.0	0.1	0.05
	±500000000.0	1250000000.0	1600000000.0	0.1	0.05
	±630000000.0	1600000000.0	2000000000.0	0.1	0.05
	±800000000.0	2000000000.0	2500000000.0	0.1	0.05
	±1000000000.0	2500000000.0	3150000000.0	0.1	0.05
	±1250000000.0	3150000000.0	4000000000.0	0.1	0.05
	±1600000000.0	4000000000.0	5000000000.0	0.1	0.05
	±2000000000.0	5000000000.0	6300000000.0	0.1	0.05
	±2500000000.0	6300000000.0	8000000000.0	0.1	0.05
	±3150000000.0	8000000000.0	10000000000.0	0.1	0.05
	±4000000000.0	10000000000.0	12500000000.0	0.1	0.05
	±5000000000.0	12500000000.0	16000000000.0	0.1	0.05
	±6300000000.0	16000000000.0	20000000000.0	0.1	0.05
	±8000000000.0	20000000000.0	25000000000.0	0.1	0.05
	±10000000000.0	25000000000.0	31500000000.0	0.1	0.05
	±12500000000.0	31500000000.0	40000000000.0	0.1	0.05
	±16000000000.0	40000000000.0	50000000000.0	0.1	0.05
	±20000000000.0	50000000000.0	63000000000.0	0.1	0.05
	±25000000000.0	63000000000.0	80000000000.0	0.1	0.05
	±31500000000.0	80000000000.0	100000000000.0	0.1	0.05
	±40000000000.0	100000000000.0	125000000000.0	0.1	0.05
	±50000000000.0	125000000000.0	160000000000.0	0.1	0.05
	±63000000000.0	160000000000.0	200000000000.0	0.1	0.05
	±80000000000.0	200000000000.0	250000000000.0	0.1	0.05
	±100000000000.0	250000000000.0	315000000000.0	0.1	0.05
	±125000000000.0	315000000000.0	400000000000.0	0.1	0.05
	±160000000000.0	400000000000.0	500000000000.0	0.1	0.05
	±200000000000.0	500000000000.0	630000000000.0	0.1	0.05
	±250000000000.0	630000000000.0	800000000000.0	0.1	0.05
	±315000000000.0	800000000000.0	1000000000000.0	0.1	0.05
	±400000000000.0	1000000000000.0	1250000000000.0	0.1	0.05
	±500000000000.0	1250000000000.0	1600000000000.0	0.1	0.05