CONTENTS

FORWARD, vii

PREFACE, viii

1 INTRODUCTION

- 1-1: Introduction, 1
- 1-2: Historical Perspective, 2
- 1-3: Capabilities, 2
- 1-4: Size of the Industry, 8
- 1-5: Careers in Fluid Power, 9
- 1-6: How Fluid Power Works, 12
- 1-7: Summary, 15

2 BASICS OF HYDRAULICS

- 2-1: Introduction, 19
- 2-2: How Oil Transmits Power, 20
- 2-3: Work Performed by the System, 21
- 2-4: Multiplication of Force, 21
- 2-5: Power and Horsepower, 24
- 2-6: Fluid Horsepower, 26
- 2-7: Torque and Torque Horsepower, 31
- 2-8: Torque Horsepower and Fluid Horsepower Relationships, 32
- 2-9: Summary, 34

3 HYDRAULIC FLUIDS

- 3-1: Introduction, 37
- 3-2: Types of Fluids, 38
- 3-3: Fluid Applications, 40
- 3-4: Properties of Fluids, 42
- 3-5: Fluid Storage and Handling, 52
- 3-6: Filtration, 53
- 3-7: Summary, 64

4 SEALS AND PACKINGS

- 4-1: Introduction, 67
- 4-2: Static Seals, 70
- 4-3: Dynamic Seals, 76
- 4-4: Materials and Compounds, 79
- 4-5: Seal Configuration, 83
- 4-6: Elastomer Seal Testing, 91
- 4-7: Summary, 92

5 ENERGY IN HYDRAULIC SYSTEMS

- 5-1: Introduction, 95
- 5-2: Continuity Equation, 96
- 5-3: Pressure and Head, 100
- 5-4: Potential and Kinetic Energy, 103
- 5-5: Bernoulli's Equation, 106
- 5-6: Torricelli's Theorem, 110
- 5-7: Flow Through Orifices, 112 .
- 5-8: Flow in Pipes, 114
- 5-9: Reynolds Number, 115
- 5-10: Darcy-Weisbach and Hagen Poiseuille Formulas, 118
- 5-11: Equivalent Length, 124
- 5-12: Circuit Calculations, 126
- 5-13: Summary, 130
- 6 PUMPS
 - 6-1: Introduction, 133
 - 6-2: Pumping Theory, 134
 - 6-3: Pump Types, 140
 - 6-4: Pump Performance, 160
 - 6-5: Pump Selection Factors, 163
 - 6-6: Other Pump Characteristics, 164
 - 6-7: Summary, 166
- 7 VALVES
 - 7-1: Introduction, 171
 - 7-2: Pressure Control Valves, 173
 - 7-3: Flow Control Valves, 176
 - 7-4: Directional Control Valves, 183
 - 7-5: Summary, 205

8 ACTUATORS: CYLINDERS AND MOTORS

- 8-1: Introduction, 207
- 8-2: Cylinders, 208
- 8-3: Cushioning Devices, 217
- 8-4: Rotary Actuators, 227
- 8-5: Limited Rotation Actuators, 232
- 8-6: Continuous Rotation Actuators, 234
- 8-7: Electrohydraulic Pulse Motors (EHPM), 243
- 8-8: Output Performance and Testing, 245
- 8-9: Summary, 248

- 9 SYSTEMS COMPONENTS
 - 9-1: Introduction, 251
 - 9-2: Reservoirs and Heat Exchangers, 252
 - 9-3: Accumulators, 258
 - 9-4: Intensifiers, 264
 - 9-5: Conductors and Connectors, 267
 - 9-6: Instrumentation, 278
 - 9-7: Hydraulic Power Units, 282
 - 9-8: Hydrostatic Transmissions, 284
 - 9-9: Electrical Controls, 287
 - 9-10: Summary, 292
- 10 SYSTEMS DESIGN AND BASIC CIRCUITS
 - 10-1: Introduction, 295
 - 10-2: Sizing Actuators from Output Objectives, 297
 - 10-3: Constant Flow Systems, 304
 - 10-4: Constant Pressure Systems (C-P), 306
 - 10-5: Constant Horsepower Systems (C-Hp), 307
 - 10-6: Load Sensing Systems, 310
 - 10-7: Basic Circuits, 312
 - 10-8: Open Center vs. Closed Center Circuits, 322
 - 10-9: Pump Selection, 325
 - 10-10: Matching Components, 327
 - 10-11: Monitoring Performance, 328
 - 10-12: Compliance with Safety Recommendations and Standards, 330
 - 10-13: Summary, 332

11 INTRODUCTION TO PNEUMATICS

- 11-1: Introduction, 335
- 11-2: Applying Gas Laws to Pneumatic Systems, 336
- 11-3: Compressors, 342
- 11-4: Pneumatic Systems, 349
- 11-5: Valves, 354
- 11-6: Cylinders and Motors, 362
- 11-7: Air Conditioners, 364
- 11-8: Basic Circuits, 371
- 11-9: Summary, 376

12 PNEUMATIC LOGIC CONTROL

- 12-1: Introduction, 379
- 12-2: Logic Control Concepts, 380
- 12-3: Basic Air Logic Circuit Design, 385
- 12-4: Miniature Pneumatics, 386
- 12-5: Moving Part Logic and Modular Air Components, 387
- 12-6: Fluidic Control Systems, 389
- 12-7: Operating Principles, 390
- 12-8: Fluidic Devices, 394
- 12-9: Basic Fluidic Circuits, 398
- 12-10: Summary, 402

APPENDIX A

LETTER SYMBOLS AND ABBREVIATIONS, 404

APPENDIX 8

CONVERSION FACTORS, 408

APPENDIX C

APPROXIMATE VISCOSITY CONVERSIONS, 409

APPENDIX D

USA STANDARD GRAPHIC SYMBOLS FOR FLUID POWER DIAGRAMS, 411

APPENDIX E

OFFSET BEND CALCULATIONS FOR STEEL TUBING, 423

APPENDIX F

STANDARD TEST PROCEDURES, 427

INDEX, 432