

# Control Valve

Model BZL

Model BZT

Model BZX

Model JZG

Model BZS



## Directly-Attached Speed Control Valve, Air Bleed Valve, G-Thread Plug and Sequence Valve

### • Directly Attached to Clamps

Control Valves :

Speed control valve, air bleed valve, G-thread plug and sequence valve attached directly into Kosmek hydraulic clamp G-thread piping option.



Speed Control Valve

Model BZL  
Model BZT



Air Bleed Valve

Model BZX



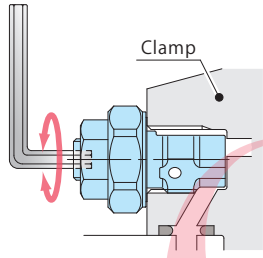
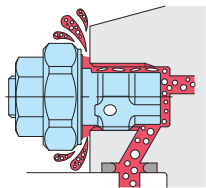
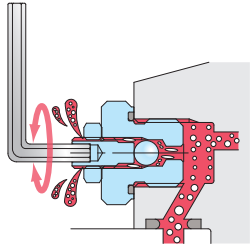
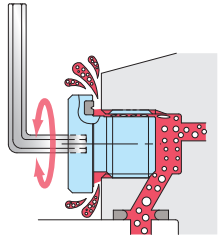
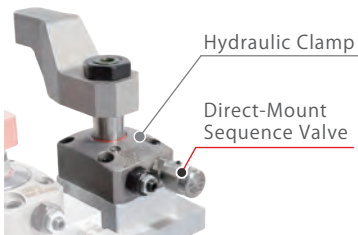
G Thread Plug

Model JZG



Direct-Mount Sequence Valve

Model BZS

	Operating Pressure Range	Action Description
<b>Speed Control Valve</b> (For Low Pressure)  Model <b>BZL</b> → P.949	7MPa or less	Adjust the flow rate with a wrench. Able to adjust the clamping speed individually. 
<b>Speed Control Valve</b> (For High Pressure)  Model <b>BZT</b> → P.953	35MPa or less	Air bleeding in the circuit is possible by loosening the speed control valve. 
<b>Air Bleed Valve</b>  Model <b>BZX</b> → P.955	35MPa or less	Air bleeding in the circuit is possible by wrench. 
<b>G Thread Plug</b>  Model <b>JZG</b> → P.957	35MPa or less	Air bleeding in the circuit is possible by loosening the G thread plug. 
<b>Direct-Mount Sequence Valve</b>  Model <b>BZS</b> → P.959	7MPa or less	Sequence Valve directly attaches to KOSMEK hydraulic clamp's G-thread piping option. Controls the operating sequence of each actuator. 

## High-Power Series

## Pneumatic Series

## Hydraulic Series

## Valve / Coupler Hydraulic Unit

## Manual Operation Accessories

## Cautions / Others

## Hole Clamp

SFA  
SFC

## Swing Clamp

LHA  
LHC  
LHS  
LHW  
LG/LT  
TLA-2  
TLB-2  
TLA-1

## Link Clamp

LKA  
LKC  
LKW  
LJ/LM  
TMA-2  
TMA-1

## Work Support

LD  
LC  
TNC  
TC

## Air Sensing Lift Cylinder

LLW

## Linear Cylinder / Compact Cylinder

LL  
LLR  
LLU  
DP  
DR  
DS  
DT

## Block Cylinder

DBA/DBC

## Centering Vise

FVA  
FVD  
FVC

## Control Valve

BZL  
BZT  
BZX/JZG  
BZS

## Pallet Clamp

VS/VT

## Expansion Locating Pin

VFL/VFM  
VFJ/VFK

## Pull Stud Clamp

FP  
FQ

## Customized Spring Cylinder

DWA/DWB

## Model No. Indication (Speed Control Valve for High Pressure)

**BZT 0 10 1 - A**

10
1
A

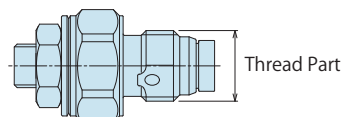
1
2
3



### 1 G Thread Size

**10** : Thread Part G1/8A Thread

**20** : Thread Part G1/4A Thread



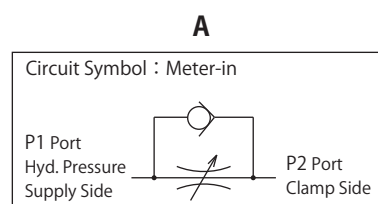
### 2 Design No.

**1** : Revision Number

### 3 Control Method

**A** : Meter-in

※ Meter-out option is not available for BZT.



## Specifications

Model No.		BZT0101-A	BZT0201-A
Max. Operating Pressure	MPa	35	
Min. Operating Pressure	MPa	10	
Control Method		Meter-in	
G Thread Size		G1/8A	G1/4A
Cracking Pressure	MPa	0.04	
Max. Passage Area	mm <sup>2</sup>	2.6	5.0
Usable Fluid		General Hydraulic Oil Equivalent to ISO-VG-32	
Operating Temperature	°C	0 ~ 70	
Tightening Torque for Main Body	N·m	10	25
Weight	g	12	26

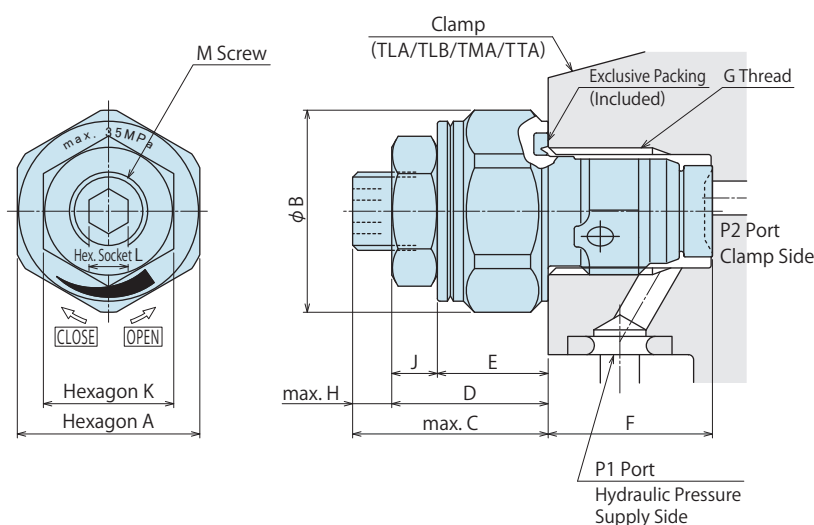
- Notes :
1. It must be mounted with recommended torque. Because of the structure of the metal seal, if mounting torque is insufficient, the flow control valve may not be able to adjust the flow rate.
  2. Do not attach a used BZT to other clamps.  
Flow control will not be made because the bottom depth difference of G thread makes metal seal insufficient.

## Applicable Products

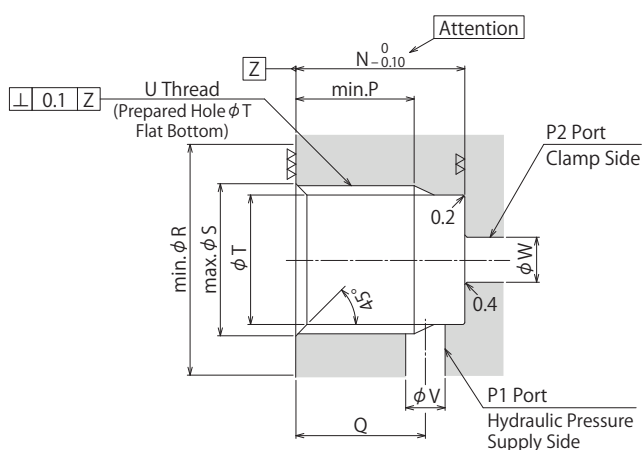
Model	TLA-2 (Double Action) Swing Clamp	TLB-2 (Double Action) Swing Clamp	TLA-1 (Single Action) Swing Clamp	TMA-2 (Double Action) Link Clamp	TMA-1 (Single Action) Link Clamp	TTA (Double Action) Linear Cylinder	TC (Single Action) Work Support
<b>BZT0101-A</b>	TLA0801-2C□□	TLB0801-2C□□	TLA0802-1C□	TMA0250-2C□	TMA0250-1C□	TTA0360-C□□	TC0553-C□
	TLA1001-2C□□	TLB1001-2C□□	TLA1002-1C□	TMA0400-2C□	TMA0400-1C□	TTA0400-C□□	TC0653-C□
	TLA1601-2C□□	TLB1601-2C□□	TLA1602-1C□	TMA0600-2C□	TMA0600-1C□	TTA0480-C□□	TC0753-C□
				TMA1000-2C□	TMA1000-1C□	TTA0550-C□□	
<b>BZT0201-A</b>	TLA2001-2C□□	TLB2001-2C□□	TLA2002-1C□	TMA1600-2C□	TMA1600-1C□	TTA0650-C□□	
	TLA2501-2C□□	TLB2501-2C□□	TLA2502-1C□	TMA2500-2C□	TMA2500-1C□		
	TLA4001-2C□□	TLB4001-2C□□	TLA4002-1C□	TMA3200-2C□	TMA3200-1C□		

- Notes :
1. It is not recommended to use BZT for TC040□ / TC048□ / TL□040□ / TL□060□, since they have small cylinder capacity and it is difficult to adjust the speed.
  2. In case of controlling TMA / TLA, both lock side and release side should be meter-in circuit.  
If meter-out circuit is used, abnormal high pressure is created, which causes oil leakage and damage.

## External Dimensions



## Machining Dimensions of Mounting Area



Model No.	BZT0101-A	BZT0201-A
A	14	18
B	15.5	20
C	15	16
D	12	13
E	8.5	9.5
F	(12.6)	(16.1)
G	G1/8	G1/4
H	3	3
J	3.5	3.5
K	10	10
L	3	3
M (Nominal×Pitch)	M6×0.75	M6×0.75
N	12.5	16
P	8.5	11
Q	9.5	12
R	16	20.5
S	10	13.5
T	8.7	11.5
U	G1/8	G1/4
V	2.5 ~ 3.5	3.5 ~ 4.5
W	2.5 ~ 5	3.5 ~ 7

### Notes :

1. Since the  $\nabla\nabla\nabla$  area is sealing part, be careful not to damage it.
2. Since the  $\nabla\nabla$  area is the metal sealing part of BZL, be careful not to damage it. (Especially when deburring)
3. No cutting chips or burr should be at the tolerance part of machining hole.
4. As shown in the drawing, P1 port is used as the hydraulic supply side and P2 port as the clamp side.

## Notes

1. Please read "Notes on Hydraulic Cylinder Speed Control Unit" for proper hydraulic circuit design.  
Improper circuit design may lead to malfunctions and damages. (Refer to P.1356)
2. It is dangerous to release the air under high pressure. It must be done under lower pressure.  
(For reference : the minimum operating range of the product within the circuit.)
3. When the cylinder capacity is small, the speed of flow may not be controlled properly. (Recommended Cylinder Capacity : 3cm<sup>3</sup> or more)

### High-Power Series

### Pneumatic Series

### Hydraulic Series

### Valve / Coupler Hydraulic Unit

### Manual Operation Accessories

### Cautions / Others

#### Hole Clamp

SFA  
SFC

#### Swing Clamp

LHA  
LHC  
LHS  
LHW  
LG/LT  
TLA-2  
TLB-2  
TLA-1

#### Link Clamp

LKA  
LKC  
LKW  
LJ/LM  
TMA-2  
TMA-1

#### Work Support

LD  
LC  
TNC  
TC

#### Air Sensing Lift Cylinder

LLW

#### Linear Cylinder / Compact Cylinder

LL  
LLR  
LLU  
DP  
DR  
DS  
DT

#### Block Cylinder

DBA/DBC

#### Centering Vise

FVA  
FVD  
FVC

#### Control Valve

BZL  
**BZT**  
BZX/JZG  
BZS

#### Pallet Clamp

VS/VT

#### Expansion Locating Pin

VFL/VFM  
VFJ/VFK

#### Pull Stud Clamp

FP  
FQ

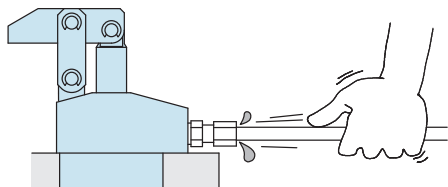
#### Customized Spring Cylinder

DWA/DWB

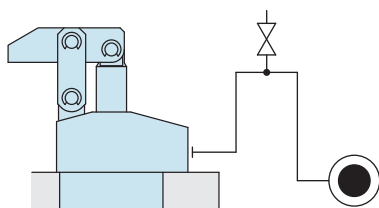
## Cautions

### ● Installation Notes (For Hydraulic Series)

- 1) Check the Usable Fluid
  - Please use the appropriate fluid by referring to the Hydraulic Fluid List.
- 2) Procedure before Piping
  - The pipeline, piping connector and fixture circuits should be cleaned by thorough flushing.
  - The dust and cutting chips in the circuit may lead to fluid leakage and malfunction.
  - There is no filter provided with Kosmek's product except for a part of valves which prevents foreign materials and contaminants from getting into the circuit.
- 3) Applying Sealing Tape
  - Wrap with tape 1 to 2 times following the screw direction.
  - Pieces of the sealing tape can lead to oil leakage and malfunction.
  - Please implement piping construction in a clear environment to prevent anything getting in products.
- 4) Air Bleeding of the Hydraulic Circuit
  - If the hydraulic circuit has excessive air, the action time may become very long. If air enters the circuit after connecting the hydraulic port or under the condition of no air in the oil tank, please perform the following steps.
    - ① Reduce hydraulic pressure to less than 2MPa.
    - ② Loosen the cap nut of pipe fitting closest to the clamp by one full turn.
    - ③ Shake the pipeline to loosen the outlet of pipe fitting.  
Hydraulic fluid mixed with air comes out.



- ④ Tighten the cap nut after bleeding.
- ⑤ It is more effective to release air at the highest point inside the circuit or at the end of the circuit.  
(Set an air bleeding valve at the highest point inside the circuit.)



### 5) Checking Looseness and Retightening

- At the beginning of the machine installation, the bolt and nut may be tightened lightly. Check the looseness and re-tighten as required.

### ● Hydraulic Fluid List

ISO Viscosity Grade ISO-VG-32		
Maker	Anti-Wear Hydraulic Oil	Multi-Purpose Hydraulic Oil
Showa Shell Sekiyu	Tellus S2 M 32	Morlina S2 B 32
Idemitsu Kosan	Daphne Hydraulic Fluid 32	Daphne Super Multi Oil 32
JX Nippon Oil & Energy	Super Hyrando 32	Super Mulpus DX 32
Cosmo Oil	Cosmo Hydro AW32	Cosmo New Mighty Super 32
ExxonMobil	Mobil DTE 24	Mobil DTE 24 Light
Matsumura Oil	Hydol AW-32	
Castrol	Hyspin AWS 32	

Note : Please contact manufacturers when customers require products in the list above.

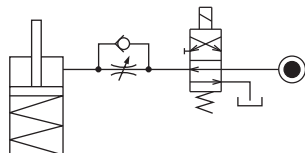
## ● Notes on Hydraulic Cylinder Speed Control Unit



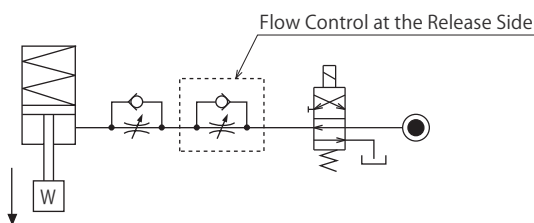
Please pay attention to the cautions below. Design the hydraulic circuit for controlling the action speed of hydraulic cylinder. Improper circuit design may lead to malfunctions and damages. Please review the circuit design in advance.

### ● Flow Control Circuit for Single Acting Cylinder

For spring return single acting cylinders, restricting flow during release can extremely slow down or disrupt release action. The preferred method is to control the flow during the lock action using a valve that has free-flow in the release direction. It is also preferred to provide a flow control valve at each actuator.



Accelerated clamping speed by excessive hydraulic flow to the cylinder may sustain damage. In this case add flow control to regulate flow. (Please add flow control to release flow if the lever weight is put on at the time of release action when using swing clamps.)



### ● Flow Control Circuit for Double Acting Cylinder

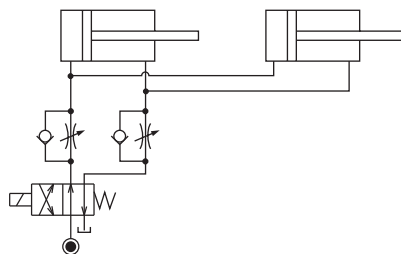
Flow control circuit for double acting cylinder should have meter-out circuits for both the lock and release sides. Meter-in control can have adverse effect by presence of air in the system.

However, in the case of controlling LKE, TMA, TLA, both lock side and release side should be meter-in circuit.

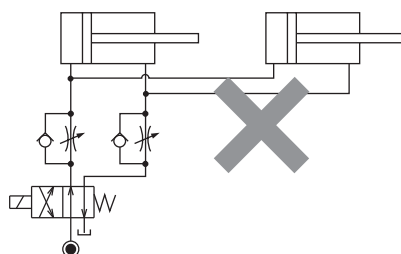
Refer to P.75 for speed adjustment of LKE.

For TMA and TLA, if meter-out circuit is used, abnormal high pressure is created, which causes oil leakage and damage.

【Meter-out Circuit】(Except LKE/TMA/TLA)

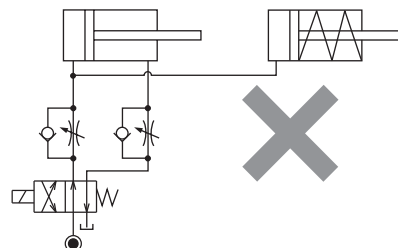


【Meter-in Circuit】(LKE/TMA/TLA must be controlled with meter-in.)



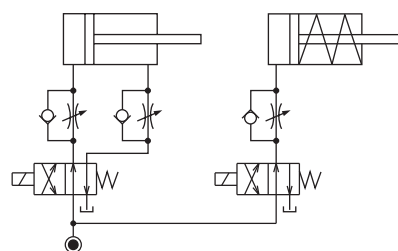
In the case of meter-out circuit, the hydraulic circuit should be designed with the following points.

- ① Single acting components should not be used in the same flow control circuit as the double acting components. The release action of the single acting cylinders may become erratic or very slow.

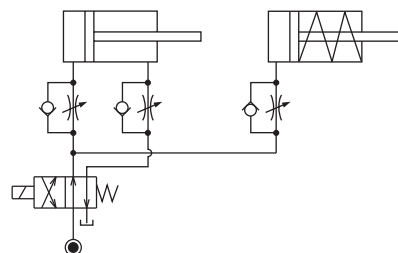


Refer to the following circuit when both the single acting cylinder and double acting cylinder are used together.

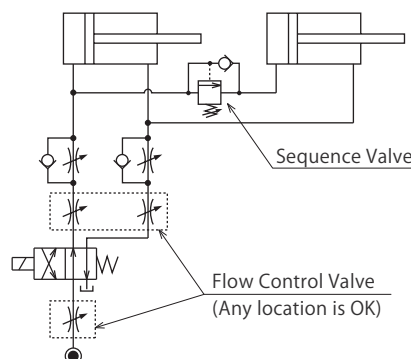
- Separate the control circuit.



- Reduce the influence of double acting cylinder control unit. However, due to the back pressure in tank line, single action cylinder is activated after double action cylinder works.



- ② In the case of meter-out circuit, the inner circuit pressure may increase during the cylinder action because of the fluid supply. The increase of the inner circuit pressure can be prevented by reducing the supplied fluid beforehand via the flow control valve. Especially when using sequence valve or pressure switches for clamping detection. If the back pressure is more than the set pressure then the system will not work as it is designed to.



High-Power  
Series

Pneumatic Series

Hydraulic Series

Valve / Coupler  
Hydraulic Unit

Manual Operation  
Accessories

Cautions / Others

## Cautions

Installation Notes  
(For Hydraulic Series)

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## ● Cautions

### ● Notes on Handling

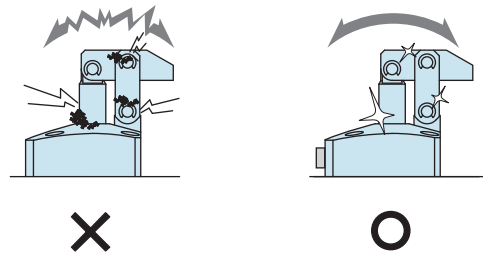
- 1) It should be operated by qualified personnel.
- The hydraulic machine and air compressor should be operated and maintained by qualified personnel.
- 2) Do not operate or remove the product unless the safety protocols are ensured.
  - ① The machine and equipment can only be inspected or prepared when it is confirmed that the safety devices are in place.
  - ② Before the product is removed, make sure that the above-mentioned safety devices are in place. Shut off the pressure and power source, and make sure no pressure exists in the air and hydraulic circuits.
  - ③ After stopping the product, do not remove until the temperature drops.
  - ④ Make sure there is no abnormality in the bolts and respective parts before restarting the machine or equipment.
- 3) Do not touch a clamp (cylinder) while it is working. Otherwise, your hands may be injured due to clinching.



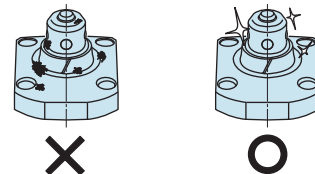
- 4) Do not disassemble or modify.
- If the equipment is taken apart or modified, the warranty will be voided even within the warranty period.

### ● Maintenance and Inspection

- 1) Removal of the Machine and Shut-off of Pressure Source
  - Before the machine is removed, make sure that safety devices and preventive devices are in place. Shut off the pressure and power source, and make sure no pressure exists in the air and hydraulic circuits.
  - Make sure there is no abnormality in the bolts and respective parts before restarting.
- 2) Regularly clean the area around the piston rod and plunger.
  - If it is used when the surface is contaminated with dirt, it may lead to packing seal damage, malfunctioning and fluid leakage.



- 3) Please clean out the reference surfaces on a regular basis (taper reference surface and seating surface) of the locating products. (VS/VT/VFL/VFM/VFJ/VFK/WVS/VWM/VWK/VX/VXE/VXF)
  - The locating products, except VX/VXE/VXF model, can remove contaminants with cleaning functions. However, hardened cutting chips, adhesive coolant and others may not be removed. Make sure there are no contaminants before installing a workpiece/pallet.
  - Continuous use with contaminant on components will lead to locating accuracy failure, malfunction and fluid leakage.



- 4) If disconnecting by couplers, air bleeding should be carried out on a regular basis to avoid air mixed in the circuit.
- 5) Regularly tighten nut, bolt, pin, cylinder, pipe line and others to ensure proper use.
- 6) Make sure the hydraulic fluid has not deteriorated.
- 7) Make sure there is a smooth action without an irregular noise.
  - Especially when it is restarted after left unused for a long period, make sure it can be operated correctly.
- 8) The products should be stored in the cool and dark place without direct sunshine or moisture.
- 9) Please contact us for overhaul and repair.

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## ● Warranty

### 1) Warranty Period

- The product warranty period is 18 months from shipment from our factory or 12 months from initial use, whichever is earlier.

### 2) Warranty Scope

- If the product is damaged or malfunctions during the warranty period due to faulty design, materials or workmanship, we will replace or repair the defective part at our expense.  
Defects or failures caused by the following are not covered.
  - ① If the stipulated maintenance and inspection are not carried out.
  - ② If the product is used while it is not suitable for use based on the operator's judgment, resulting in defect.
  - ③ If it is used or operated in an inappropriate way by the operator.  
(Including damage caused by the misconduct of the third party.)
  - ④ If the defect is caused by reasons other than our responsibility.
  - ⑤ If repair or modifications are carried out by anyone other than Kosmek, or without our approval and confirmation, it will void warranty.
  - ⑥ Other caused by natural disasters or calamities not attributable to our company.
  - ⑦ Parts or replacement expenses due to parts consumption and deterioration.  
(Such as rubber, plastic, seal material and some electric components.)

Damages excluding from direct result of a product defect shall be excluded from the warranty.



# Sales Offices

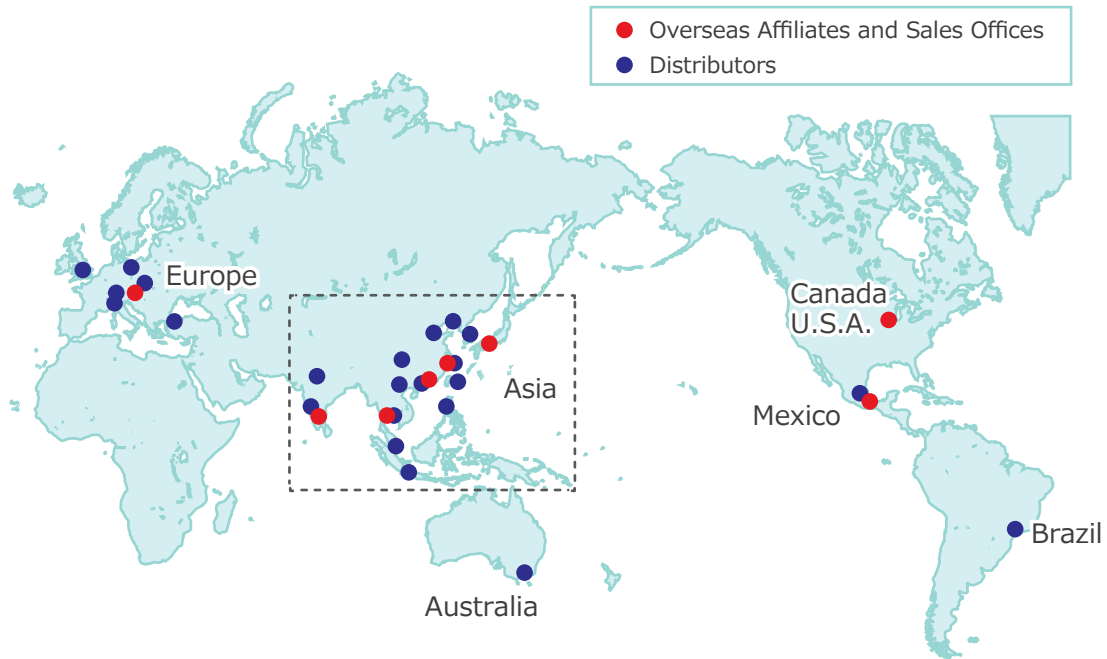
## Sales Offices across the World

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PHILIPPINES (Philippines Exclusive Distributor) G.E.T. Inc, Phil.	<b>TEL. +63-2-310-7286</b> Victoria Wave Special Economic Zone Mt. Apo Building, Brgy. 186, North Caloocan City, Metro Manila, Philippines 1427	<b>FAX. +63-2-310-7286</b>
INDONESIA (Indonesia Exclusive Distributor) PT. Yamata Machinery	<b>TEL. +62-21-29628607</b> Delta Commercial Park I, Jl. Kenari Raya B-08, Desa Jayamukti, Kec. Cikarang Pusat Kab. Bekasi 17530 Indonesia	<b>FAX. +62-21-29628608</b>

## Sales Offices in Japan

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Tokyo Sales Office	<b>TEL. 048-652-8839</b> 〒331-0815 埼玉県さいたま市北区大成町4丁目81番地	<b>FAX. 048-652-8828</b>
Nagoya Sales Office	<b>TEL. 0566-74-8778</b> 〒446-0076 愛知県安城市美園町2丁目10番地1	<b>FAX. 0566-74-8808</b>
Fukuoka Sales Office	<b>TEL. 092-433-0424</b> 〒812-0006 福岡県福岡市博多区上牟田1丁目8-10-101	<b>FAX. 092-433-0426</b>

# Global Network



Asia Detailed Map



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