

夾緊臂的安裝、拆卸

1. 旋轉式夾緊器採用帶導向槽的凸輪機械進行旋轉。如果向活塞杆上施加過大的扭矩，將會損壞夾緊器。安裝或拆卸夾緊臂時，

為了防止夾轉扭矩作用在活塞杆上，請按照下列要領進行作業。

2. 請務必按規定的扭矩緊固鎖緊螺母，緊固扭矩不充分時，使用時夾緊臂有可能滑落。

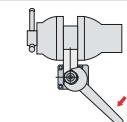
Mounting & dismounting of clamp arm

1. Swing clamp may be damaged if excessive torque is applied, since structure is intended for swinging using cam mechanism with lead grooves. Follow instructions below to prevent excessive torque from being applied on piston rod when mounting or dismounting clamp arm.

2. Be sure to tighten locknut with recommended tightening torque.

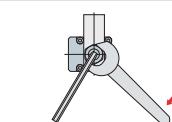
If the tightening torque is insufficient, clamp arm may slip during operation.

夾緊臂的安裝/Mounting of clamp arm



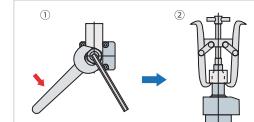
用臺虎鉗固定夾緊臂，將夾緊器主體和夾緊臂對準規定的方向後，用扳手緊固螺母。

Fix the clamp arm in a vice, then set the clamp body and clamp arm at the correct orientation, and tighten locknut with a wrench.



夾緊器主體被夾具等固定時，如上圖所示，將夾緊臂按規定方向旋裝後，用扳手卡住活塞杆前端的六角孔以防活塞杆旋轉，然後用扳手鬆緊螺母。

夾緊臂的拆卸/Dismounting of clamp arm



①用扳手卡住活塞杆前端的六角孔以固定活塞杆，然後用扳手鬆動螺母。

②拆下螺母後，用扳手等拉出夾緊臂。

4. Insert hex wrench to hex socket at tip section of piston rod to ensure that piston rod is held in place, then loosen locknut with wrench.

5. After dismounting the locknut, pull out clamp arm using gear puller.

夾緊器、工作支撐器的安裝

安裝夾緊器、工作支撐器時，請使用彈度分類為12.9的螺絲，並參考下列安裝螺絲的推剪緊固扭矩，務必按規定的扭矩緊固。

Clamp and work supports have been developed for the purpose of clamping workpiece for machine tools. Do not use them for other purposes.

Always protect them with a cover to ensure sliding surfaces are not exposed to weld slag when using them as jig for welding.

使用注意事項

1. 夾緊器、工作支撐器是以夾緊機床相關工件為目的而開發的，請勿用于其它用途。

2. 用于焊接夾具時，為了避免滑動部接觸到火花，請務必使用罩蓋等進行保護。

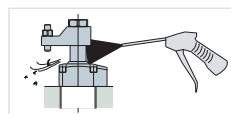
3. 為確保順暢動作，請通過噴空氣等方式定期清潔滑動部及法蘭盤表面。

Caution for hydraulic piping

1. Metal shavings may occur with hydraulic component caused by foreign substances such as metal chips and dust that are introduced into the circuit. Refer to "Piping Hydraulic System Equipment-Practical Notes" provided with the product for mounting and hydraulic piping of the product.

2. After performing hydraulic piping, always be sure to bleed air out in the hydraulic circuit. Insufficient bleeding can lead to malfunction.

3. When using multiple clamps, operating speeds and timings vary due to variance in pipe resistance and internal resistance of clamps. Adjust operating speeds and timings using flow control valve.



產品簡介

曲柄型二滑塊同步油缸,滑塊行程長。

折衷表面均經硬化及精密研磨，並直接潤滑。

高夾持精度,防塵效果佳。

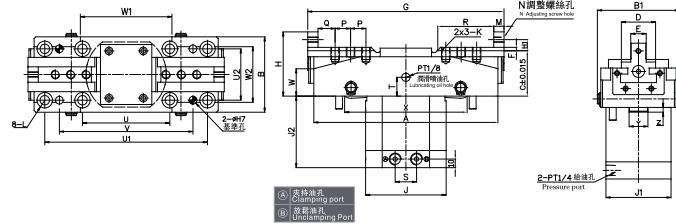


Introduction of product

Crank type two slide block synchronous oil cylinder, the length of the slide block.

All the surfaces are hardened and precision grinding, and are lubricated directly.

High clamping precision, dust effect is particularly good.



特性資料 Specification

單位 (Unit) : mm

型號/Model	HCP-20	HCP-30A	HCP-30	HCP-50
受壓面積(推出)Pressure area push(cm ²)	28.27	28.27	28.27	38.48
滑塊行程Slider stroke(mm)	20	30	30	50
最大夾持力Max clamping(kgf)	1653	1806	1806	2071
使用潤滑液Fluid	已達成之標準液度Filtered oil			
使用溫度範圍Range of temperature(°C)	-10~70(°C)			
使用壓力Max pressure(kg/cm ²)	10~35kg/cm ²			

外形尺寸表 Dimension table

單位 (Unit) : mm

SIZE MODEL	A	B	B1	C	D	E(h6)	F	G		H	H1	J	J1	J2	K	L
								Max	min							
HCP-20	215					18		249	229						83.5	
HCP-30A	250	88	96	53	40		4	295	265	75	13	94	76			M10x1.5
HCP-30	280							327	297						96	M10
HCP-50	300	110	115	65	50	28	5	369	319	90	15	105	—	120		M12x1.75

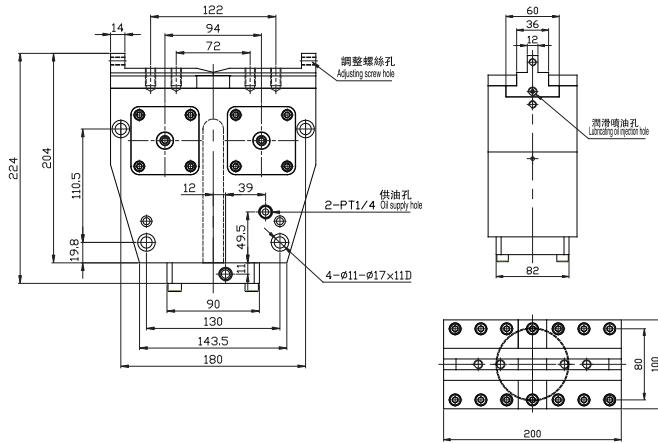
SIZE MODEL	M	N	P	Q	R	S	T	U	U1	U2	V	W	W1	W2	X	Y	Z
HCP-20	12		18	20	66									32	110	150	4
		m6x1						25	22	102	180	60	156		65	156	6
HCP-30A	14		20	24													
HCP-30																	
HCP-50	16	M12x1.25	21	28		30	32	105	230	85	195				80	180	30

产品简介

曲柄型二滑块同步油缸，滑块行程长；
折动面均经硬化及精密研磨，并直接润滑；
高夹持精度，防尘效果佳；
可调行程。

Introduction of product

Crane type two slide block synchronous oil cylinder, the length of the slide block; All the surfaces are hardened and precision grinding, and are lubricated directly; High clamping precision, dust effect is particularly good; Adjustable stroke.



特性资料 Specification

型号Model	HCP-30-S
受压面積(推出)Pressure area push(cm ²)	28.27
滑块行程Slider stroke(mm)	30
最大夹持力Max clamping(kgf)	1806
使用流體Fluid	已濾清之標準液壓Filtered oil
使用溫度範圍Range of temoerature(°C)	-10~70(°C)
使用壓力Max preguare(kg/cm ²)	10~35kg/cm ²

产品简介

- ◆符合GB/T15622-2995
- ◆采用高密封性的密封圈，避免了油缸的泄漏，且使用壽命長。
- ◆活塞杆采用45鋼，活塞杆表面鍍硬鉻，結構堅固耐用。
- ◆安裝方式有SD, FA, FB, LB, TC, CA, CB, CBP, CAB, 供設計者依據需求選擇。
- ◆任何特殊油缸皆可訂做，歡迎來電諮詢。



Introduction of product

- ◆Standard:GB/T15622-2995
- ◆Use high-quality seal to avoid leakage and have long service life.
- ◆The rod cover and rear cover make from No45 Steel, and the piston is chromeplate, With the compact structure, more durable.
- ◆There are several mounting types, SD, FA, FB, LB, TC, CA, CB, CBP, and CAB, The designer could choose it according to the demand.
- ◆Any other special cylinder could order, welcome to contact with us.

特性資料 Specification

油壓缸內徑 bore sizes of cylinder(mm)	Φ30	Φ40	Φ50	Φ63	Φ80	Φ100	Φ125
使用流體 Fluid	以濾清之標準液壓油filtered oil						
缸管材質 material of cylinder barrel	碳鋼管 carbon steel STKM-13C/白鐵管 stainless tubes SUS 304/AL tube A6063TDS-T5						
使用壓力範圍 the range of pressure(MPa)	0.3~7.0MPa(3~70kg/cm ²)						
使用溫度範圍 the range of temperature(°C)	-10~+60(°C)						
使用速度範圍 the speed(mm/sec)	8~300(mm/sec)						
標準活塞長度 (PM) length of standard piston	30	30	30	30	35	50	50
訂制行程(子)1501~2500mm活塞長度 (PM), piston length when the stroke is between 1501~2500mm	60	60	60	60	70	100	100
訂制行程(子)2501~4000mm活塞長度 (PM), piston length when the stroke is between 2501~4000mm	120	120	120	120	140	150	150

訂購標示法 Ordering code

MOB	Z	-	63	/	25	*	100	LB	+	Y
形式 TYPE	缸內徑	缸外徑	缸內徑	行程	缸內徑	缸外徑	缸內徑	行程	缸內徑	轉心固定型式
MOB 同步型	Ø30	Ø40	Ø50	Ø63	Ø25	Ø30	Ø40	Ø100	Ø100	ACCESORY
MOB 電動型	Ø40	Ø50	Ø60	Ø80	Ø20	Ø30	Ø40	Ø125	Ø125	Y (標準)
	Ø50	Ø60	Ø70	Ø100	Ø25	Ø35	Ø50	Ø150	Ø150	YP (YPIN)
	Ø60	Ø70	Ø80	Ø125	Ø30	Ø40	Ø50	Ø200	Ø200	KG (KANG)
	Ø70	Ø80	Ø90	Ø150	Ø35	Ø45	Ø60	Ø250	Ø250	PHS (PHS)
	Ø80	Ø90	Ø100	Ø180	Ø40	Ø50	Ø70	Ø300	Ø300	T (T型)
	Ø100	Ø125	Ø150	Ø200	Ø50	Ø60	Ø80	Ø400	Ø400	LB (LB)
										H (H型)
										A (A型)
標記號 不規範型	標記號									
Z	Z	Z	Z	Z	Z	Z	Z	Z	Z	Z
規範號										
本系列適用 Ø40~Ø100										