

產品簡介

- 此型式油壓缸適用於夾持工件取放空間保持靜空,方便工件取放高壓夾持。
- 油壓缸夾持動作為下壓式,含有旋轉行程(請勿夾持工件)以及垂直下壓行程。
- 本產品使用德制油封及進口零件,缸體內壁經特殊加工處理表面光滑,確保使用性能及壽命。
- 最大充油速度請參考特性資料,請勿使用過大充油速度,以免回轉過快,如有回轉發不確定,請安裝流量控制閥,降低充油速度。
- 壓板長度使用壓力請參考P152所示,請勿任意超長使用。



Introduction of product

- The series of swing clamp cylinder is ideal for workpiece clamping which requires a sufficient space for convenient workpiece loading and unloading and high pressure clamping.
- It provides swing motion (do not clamp workpiece) and portocol hold down motion.
- The swing clamp cylinder employs Germany oil seal and imported parts. The inside surface of cylinder barrel is specially treated, featuring maximum smoothness, high performance and long service life.
- For maximum oil feeding speed, refer to specifications. Do not exceed oil feeding speed to avoid too high swing speed. In case improper swing speed occurs, it is suggested to equip with an additional oil flow control valve to reduce oil feeding speed.
- Refer to the dimensional drawing for proper swing arm length and operation pressure. Do not extend the swing arm is desired.

特性資料 Specifications

油缸內徑	Bore of cylinder	mm	Φ25	Φ40	Φ50	Φ63
活塞杆徑	Piston rod diameter	mm	Φ20	Φ32	Φ40	Φ50
轉角行程	Swing stroke	mm	7	8	11	12
垂直行程	Clamping stroke	mm	11	14	15	15
最大充油速度	Max oil filling speed	cc/s	3.2	10	18.4	27.7
下壓需求	Downward clamping oil required	cc	3.2	10	18.4	27.7
回復需求	Return oil required	cc	8.8	27.7	51	74.8
轉角方向	Rotating direction	順時針右轉R或逆時針左轉L Turn right R or turn left L				
轉角角度	Rotating angle	標準角度90° Standard angle 90°				
最小操作壓力	Min operation pressure	40kg/cm ²				

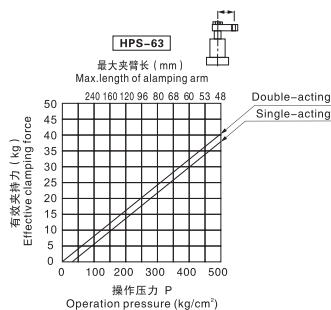
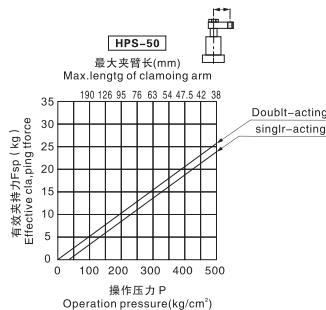
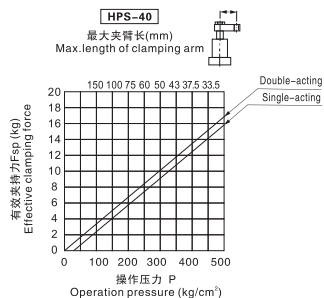
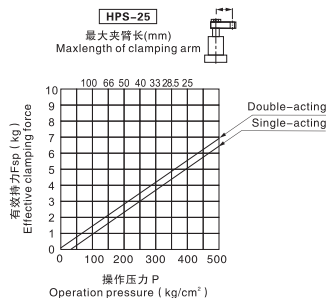
訂購標示法 Ordering Code

HPS-25 S A R x 90

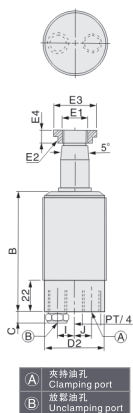
① ② ③ ④ ⑤ ⑥

1	系列別 Series	HPS
2	油缸內徑 Bore of cylinder	Φ25, Φ40, Φ50, Φ63
3	動作方式 Acting type	單動 S: Single-acting 復動 D: Double-acting
4	安裝型式 Mounting type	全牙型 A: Threaded type 底座型 B: 配管型 Line type Flange C: 油路板型 Manifold type
5	轉角方向 Rotating direction	順時針右轉R或逆時針左轉L Turn right R or turn left L
6	轉角角度 Rotating angle	標準角度 90° Standard angle 90°

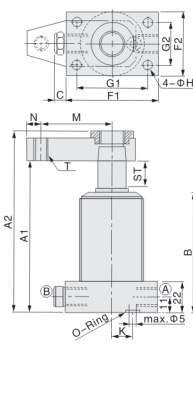
有效夾持力FSP與使用壓力P對照圖



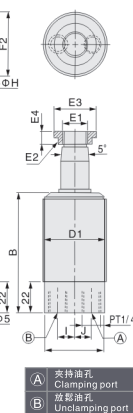
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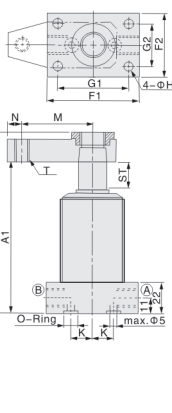
Flange Type



Tgreaded Type



Flange Type



外形尺寸表 Dimension table

UNIT:mm

ITEM	MODEL	HPS-25	HPS-40	HPS-50	HPS-63
ST:Swing/Clamping		18:7/11	22:8/14	26:11/15	27:12/15
A1		105.5	119.5	138	142
A2		126.5	147.5	172	182
B		84.5	94.5	110	119.5
C		8	8	8	8
D1	M45X1.5	M60X1.5	M80x2.0	M90x2.0	
D2	Φ43	Φ58	Φ77	Φ88	
E1	M18X15	M28X1.5	M35X1.5	M45X1.5	
E2	Φ23.5	Φ33.5	Φ45.5	Φ55.5	
E3	30	40	55	68	
E4	9	10	11	12	
F1	65	85	100	115	
F2	45	63	80	90	
G1	50	65	80	90	
G2	30	44	60	68	
H	Φ6.5	Φ8.5	Φ13.5	Φ16	
I	12	12.5	19	25.5	
J	12	19.5	26.5	34	
K	15	28	31	37.5	
O-Ring	P7	P7	P9	P9	
M	50	75	95	120	
N	10	15	15	18	
T	M10X1.5	M16X2	M16X2	M20X2.5	

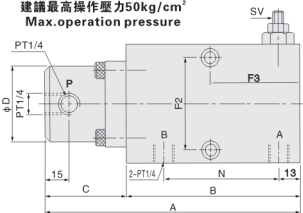
產品簡介

- ◆本產品機構內附油壓順序閥，預壓式特性操作時可將作動缸充滿油，達到預先設定之壓力，順序閥動作，即可獲得倍數增壓。
- ◆適用於油壓專用機，MC油路具壓回路中。部份油壓缸需高壓操作之場合，僅需一抵電磁閥或安裝於管路中，即可操作HB增壓器，可將低油壓自動轉換成高油壓，獲得高壓夾持。

Introduction of product

- ◆A hydraulic sequential valve is attached to this booster, when operating, it oils cylinder and makes it be at the dual pressure and let the sequential valve act, and then it will have multiple boosting pressure.
- ◆It's fit for hydraulic special purpose machine and MC clamp in low pressure circuit. It needs a solenoid valve installed in the circuit, and then it will be able to operate HB super-charger. The super-charger may be converted automatically from low oil-pressure into high oil-pressure and obtain a high pressure clamping

建議最高操作壓力50kg/cm²
Max.operation pressure



外形尺寸表 Dimension table 單位 (Unit) :mm

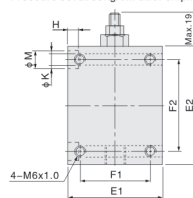
MODEL	HB-9×6	HB-8×22	HB-5×35	HB-3.8×45
增壓倍數 Multiple boost	9	8	5	3.8
高壓輸出量 High pressure output	6cc	22cc	35cc	45cc
A	157		210	
B	107		139	
C	50		71	
φD	φ46		φ58	
E1	58		82	
E2	72		100	
F1	43		62	
F2	56		80	
F3	55		70	
H	7		9	
φK	φ7		φ9	
φM	φ11		φ14	
N	71		96	



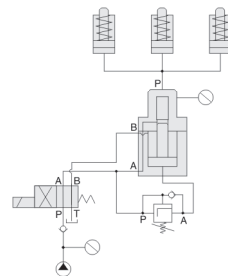
SV油壓順序閥調整參考
Adjustment reference for sv sequence valve

M6 長度L	M6 Length L	mm	7	6	5	4	3	2	1
啟動壓力	Start Pressure	kg/cm ²	20	25	30	35	40	45	50

出廠設定壓力30kg/cm²
Pressure set at 30kg/cm² before shipment



回路圖 Circuit diagram



A:進油, B:回油, P:出油