



HSF產品特性

- ◆此系列產品結構緊湊,設計合理,使用壽命長,在2-7MPa工作條件下性能穩定。
- ◆根據不同厚薄工件,可調節活塞杆伸出彈簧強弱。
- ◆活塞杆伸出接觸力小,0.4~0.8KG範圍內,適用於各種類型工件。
- ◆本產品支撐力大,在切削過程中能徹底消除機械負載及工件震動。
- ◆安裝尺寸與目前市面銷售產品相容,可互換。

HSF Product features

- ◆This series of products with compact structure,reasonable design, long service life,in 2-7MPa working conditions stable performance.
- ◆According to the different thickness of workpiece,which can adjust the piston rod out spring strength.
- ◆Piston rod out of contact force is small,0.4-0.8KG range,suitable for all kinds of workpiece.
- ◆This product support,in the cutting process can eliminate mechanical load and working vibration.
- ◆Installation size and at present on market sales products compatible,interchangeable.

產品簡介

- A型: 夾縮支撐,在初始位置時,支撐頭在內部彈簧的作用下處於最上端,工作時依靠工件在下放時的重力下壓支撐頭使之同步向下,在工件穩妥的放在治具上時就停止下行,支撐頭也停止下行,加油壓後支撐缸鎖死給工件提供支撐并停止運行。
- B型: 上行支撐,在初始位置時,支撐頭位于最下端,工件放好後,給支撐缸加油壓使支撐頭上行,至碰到工件時支撐頭立刻停止上行并繼續加壓至鎖死,這樣支撐頭就在當前位置給工件提供支撐并且停止。

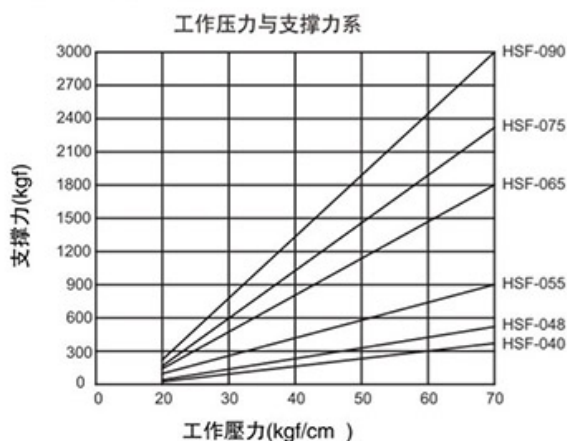
Introduction of product

- ◆Type A: Knocking-out with a spring, the spring is used to control a clamping force when the knocking-out rod (piston rod) extends to a highest knocking-out position and clamps the workpiece
- ◆Type B: Knocking-out with oil pressure, it is operated by means of oil pressure and is knocked out when being filled with oil and clamp the workpiece.

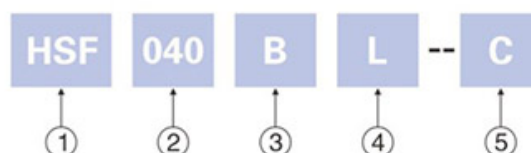
特性資料 Specification

類型Type	HSF-040AL HSF-040BL	HSF-048AL HSF-048BL	HSF-055AL HSF-055BL	HSF-065AL HSF-065BL	HSF-075AL HSF-075BL	HSF-090AL HSF-090BL
使用壓力範圍Range of pressure(kg/cm ²)	20 ~ 70kg/cm ²					
行程 Stroke(mm)	8	10	12	14	16	20
活塞杆徑Bore of piston(mm)	Φ15	Φ16	Φ20	Φ22	Φ25	Φ30
支撐力(kgf)/工作壓力(kgf/cm ²) Support(kgf)/Pressure of work(kgf/cm ²)	320/70	480/70	900/70	1800/70	2300/70	3000/70
作動方式Acting type	單動式 Single acting					

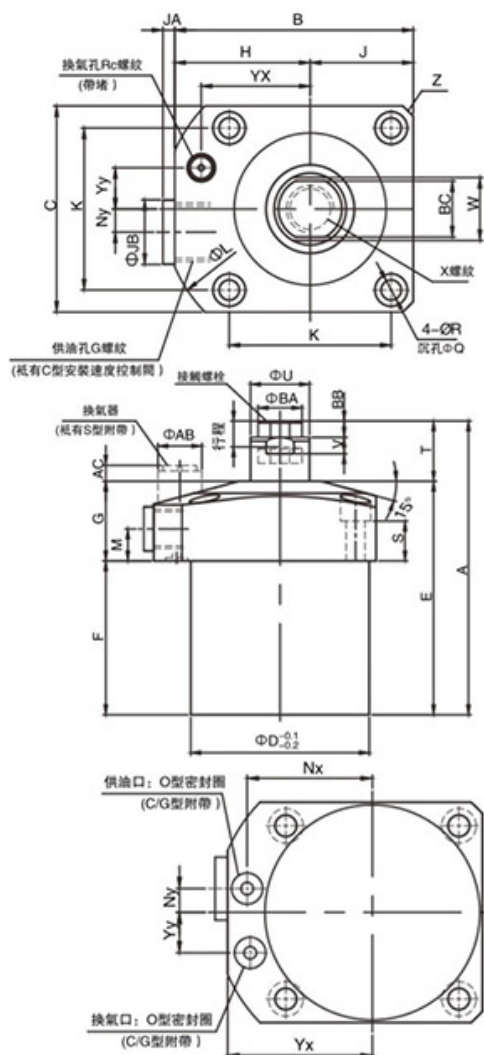
特性曲綫圖 HSF-★*L



訂購標示法 Ordering Code

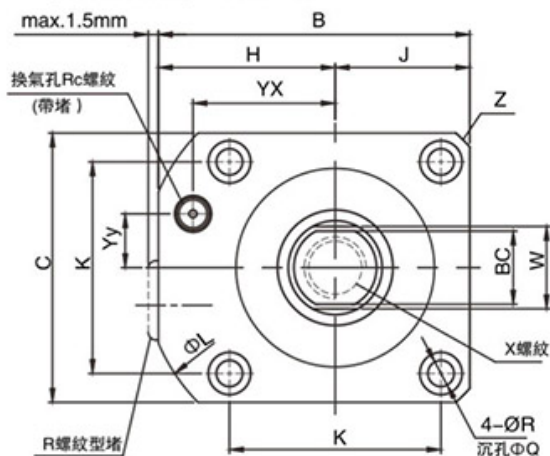


①	系列號 Series
②	本體外徑尺寸
③	A: 彈簧頂出型 A:Spring extended piston B: 油壓頂出型 B:Hydraulic extended piston
④	L: 低壓
⑤	C: 板式 (配有G螺紋堵, 帶排氣功能) G: 板式 (配有R螺紋堵) S: 配管式 (Rc螺紋)

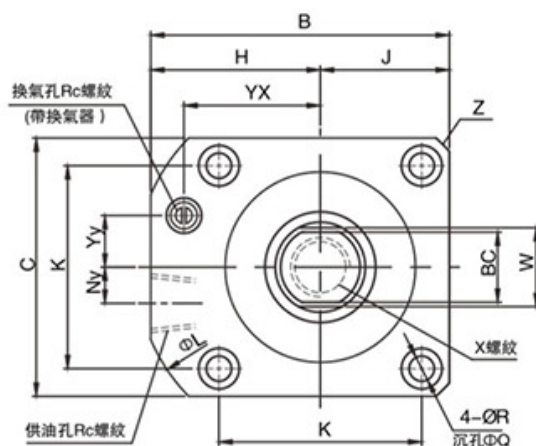


HSF-AL

※本圖所示為***AL- G



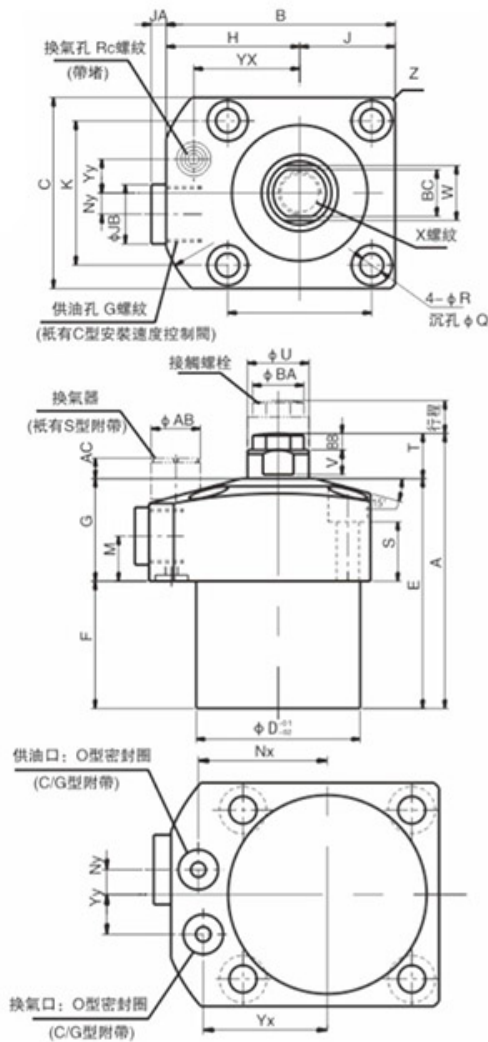
※本圖所示為***AL- S



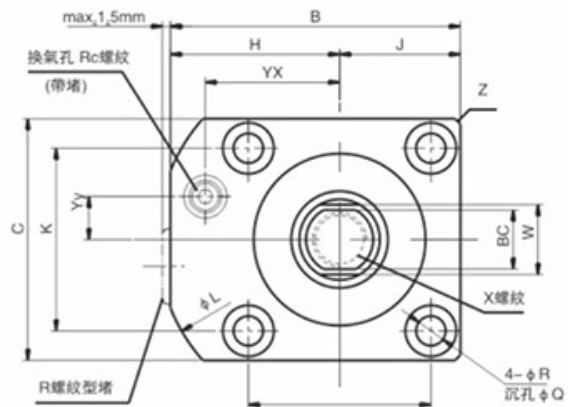
外形尺寸表 Dimension table

ITEM	MODEL	HSF-040AL	HSF-048AL	HSF-055AL	HSF-065AL	HSF-075AL	HSF-090AL
A		75	85	97	115	142	169
B		54	61	69	81	92	107
C		45	51	60	70	80	95
D		40	48	55	65	75	90
E		56	64	70	85	107	128
F		31	39	45	56	72	88
G		25	25	25	29	35	40
H		31.5	35.5	39	46	52	59.5
J		22.5	25.5	30	35	40	47.5
K		34	40	47	55	63	75
L		68	73	80	94	106	126
M		11	11	11	11	13	13
Nx		26	30	33.5	39.5	45	52.5
Ny		5	0	0	0	0	0
P		3	3	3	5	5	5
Q		9.5	9.5	11	11	14	17.5
R		5.5	5.5	6.8	6.8	9	11
S		14.5	13.5	11.5	14.5	17	18
T		19	21	27	30	35	41
U		15	16	20	22	25	30
V		6	6	8	9	9	10.5
W		13	13	17	19	22	24
X(公稱直徑x深度)		M10x11	M10x11	M12x13	M12x13	M16x20	M16x20
Yx		25	28	31	37	42.5	50
Yy		8	11	13	14	15	15
Z		c1	C3	R40	R47	R53	R63
AB		12	12	12	12	12	12
AC		5	4	3.5	2	1.5	0
BA		12.5	12.5	16.5	16.5	21.5	21.5
BB		4	4	6	6	9	9
BC		11	11	14	14	19	19
CA		M5x0.8	M5x0.8	M6	M6	M8	M10
JA		3.5	3.5	3.5	3.5	4.5	4.5
JB		14	14	14	14	19	19
行程		8	10	12	14	16	20
供油孔	-C型	G1/8	G1/8	G1/8	G1/8	G1/4	G1/4
	-S型	Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/4	Rc1/4
	-G型	Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/4	Rc1/4
R螺紋堵頭		P5	P5	P5	P7	P7	P7
口型密封圈 (-C/-G型)		Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/8
換氣孔		Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/8	Rc1/8

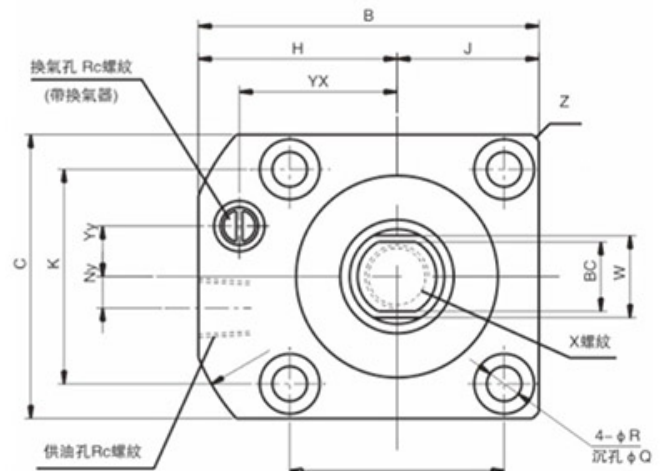
HSF-BL



※本圖所示為***BL-G



※本圖所示為***BL-S



外形尺寸表 Dimension table

ITEM	MODEL	HSF-040BL	HSF-048BL	HSF-055BL	HSF-065BL	HSF-075BL	HSF-090BL
A		67	75	85	101	126	149
B		54	61	69	81	92	107
C		45	51	60	70	80	95
D		40	48	55	65	75	90
E		56	64	70	85	107	128
F		31	39	45	56	72	88
G		25	25	25	29	35	40
H		31.5	35.5	39	46	52	59.5
J		22.5	25.5	30	35	40	47.5
K		34	40	47	55	63	75
L		68	73	80	94	106	126
M		11	11	11	11	13	13
Nx		26	30	33.5	39.5	45	52.5
Ny		5	0	0	0	0	0
P		3	3	3	5	5	5
Q		9.5	9.5	11	11	14	17.5
R		5.5	5.5	6.8	6.8	9	11
S		14.5	13.5	11.5	14.5	17	18
T		11	11	15	16	19	21
U		15	16	20	22	25	30
V		6	6	8	9	9	10.5
W		13	13	17	19	22	24
X(公稱直徑x深度)		M10×11	M10×11	M12×13	M12×13	M16×20	M16×20
Yx		25	28	31	37	42.5	50
Yy		8	11	13	14	15	15
Z		C1	C3	R40	R47	R53	R63
AB		12	12	12	12	12	12
AC		5	4	3.5	2	1.5	0
BA		12.5	12.5	16.5	16.5	21.5	21.5
BB		4	4	6	6	9	9
BC		11	11	14	14	19	19
CA		M5×0.8	M5×0.8	M6	M6	M8	M10
JA		3.5	3.5	3.5	3.5	4.5	4.5
JB		14	14	14	14	19	19
行程		8	10	12	14	16	20
供油孔	-C型	G1/8	G1/8	G1/8	G1/8	G1/4	G1/4
	-S型	RC1/8	RC1/8	RC1/8	RC1/8	RC1/4	RC1/4
	-G型	RC1/8	RC1/8	RC1/8	RC1/8	RC1/4	RC1/4
R螺紋堵頭		P5	P5	P5	P7	P7	P7
口型密封圈(-C/-G型)		P5	P5	P5	P7	P7	P7
換氣孔		RC1/8	RC1/8	RC1/8	RC1/8	RC1/8	RC1/8