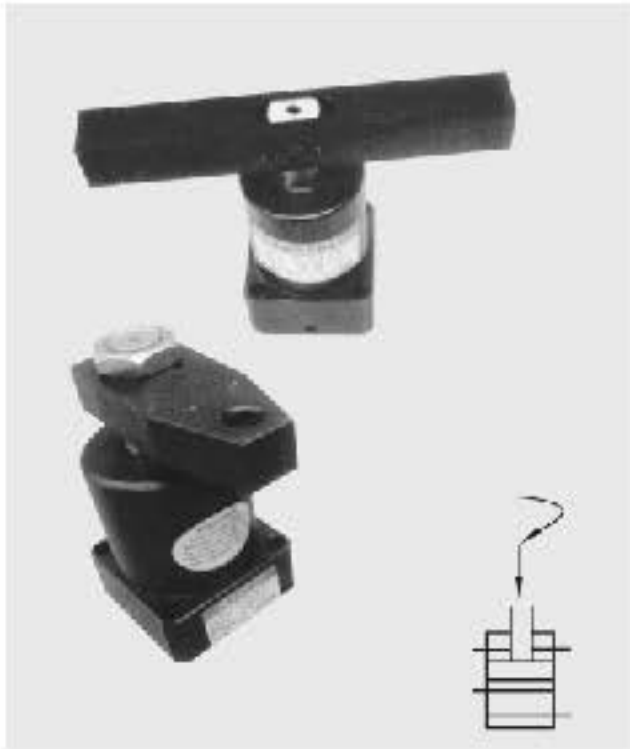


GHS油压转角缸

产品简介

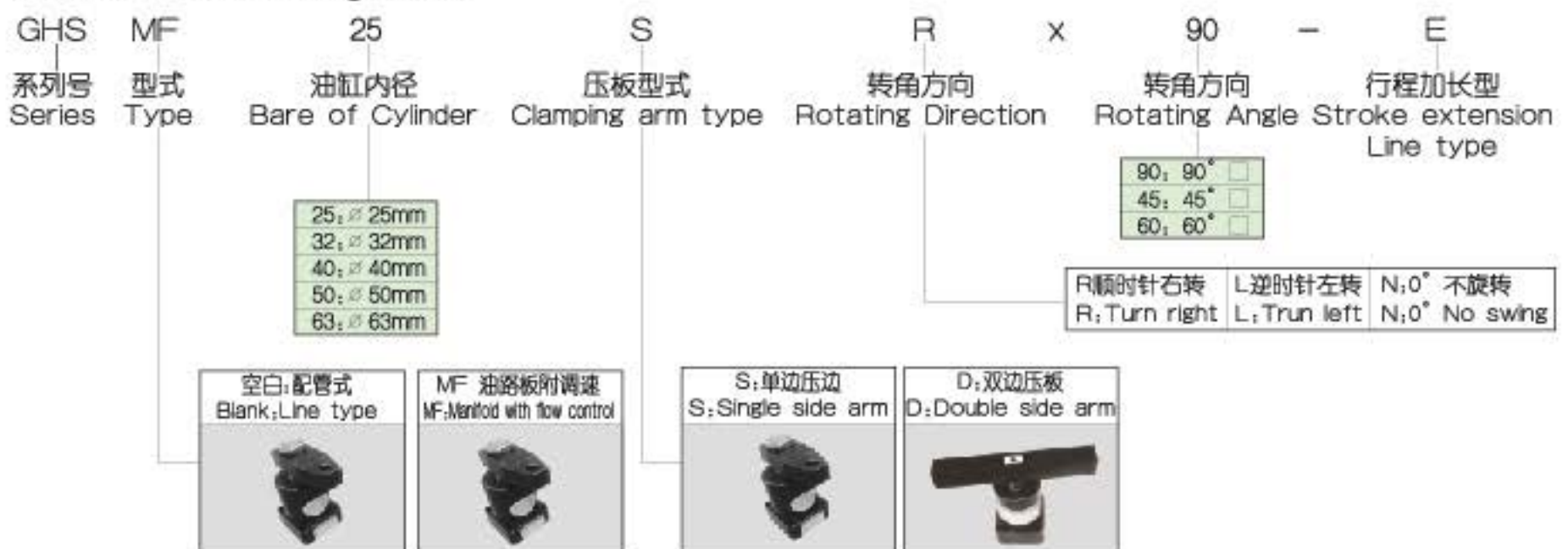
- ◆本产品适用于量产零件之专用机及MC治具，提高生产效率最佳帮手。
- ◆主要功能为油压缸作动时，活塞下压行程中压板会旋转到设计的角度，再沿着直线继续下压直到压板夹紧工件。
- ◆建议使用油压转角缸，请加装流量控制阀，避免速度过快，以及转角行程中，请勿夹持工件。
- ◆缸体材质采用机械构造用碳素钢，内壁特殊加工处理，表面光滑，使用寿命长。
- ◆压板需增加长度时，请勿大于原长度之1.5倍。
- ◆The product is ideal for mass production on a special purpose machine and jig in machining center. It will greatly upgrade production efficiency.
- ◆When the hydraulic cylinder actuate, and the piston moves downward, the clamping arm will swing to a rated angle. Then it lowers until the workpiece is clamped securely.
- ◆To avoid too fast motion, a flow control valve is suggested to connect to the hydraulic swing clamp cylinder. Do not clamp workpiece while the clamp is swinging to avoid damaging the cylinder barrel and internal parts.
- ◆The cylinder body is manufactured from structural carbon steel. Inside surface is specially treated for maximum smoothness and long service life.
- ◆When increasing length of clamping arm is required, be sure not to exceed 1.5 times of the original length.



特性资料/Specification

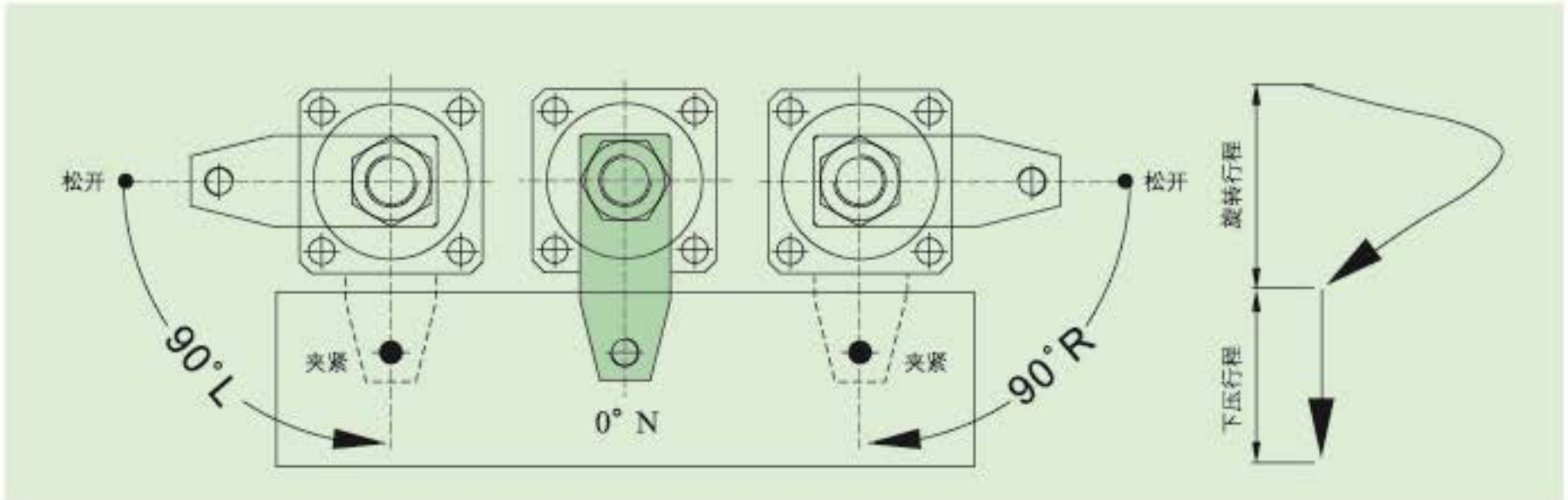
油缸内径 Bore of cylinder(mm)	∅25	∅32	∅40	∅50	∅63
活塞杆径 Bore of piston(mm)	∅18	∅20	∅22	∅28	∅35
转角行程 Swing stroke(mm)	9	11	11	13	11
压紧行程标准/加长 Clamping stroke(mm) std/incr	13	15/30	15/30	17/34	17/34
受压面积吸入/推出 Pressure area pull/push(cm ²)	2.37/4.91	4.9/8.04	8.63/12.57	13.47/19.63	21.54/31.17
理论夹持力 Theoretical clamping(30kg/cm ²)	71	147	259	404	647
使用流体 Fluid	已滤清之标准液压油 Filtered oil				
最大耐压力 Max pressure(kg/cm ²)	100kg/cm ²				
使用压力范围 Range of pressure(kg/cm ²)	10-70kg/cm ²				
转角方向 Rotating direction	左转L或右转R Turn right L or turn left R				
转角角度 Rotating angle	标准角度 Standard angle 90°(±2°)订做角度 order angle 0°, 45°(±2°) 60°(±2°)				
作动方式 Acting type	复动式 Double acting				

订购标示法/Ordering Code

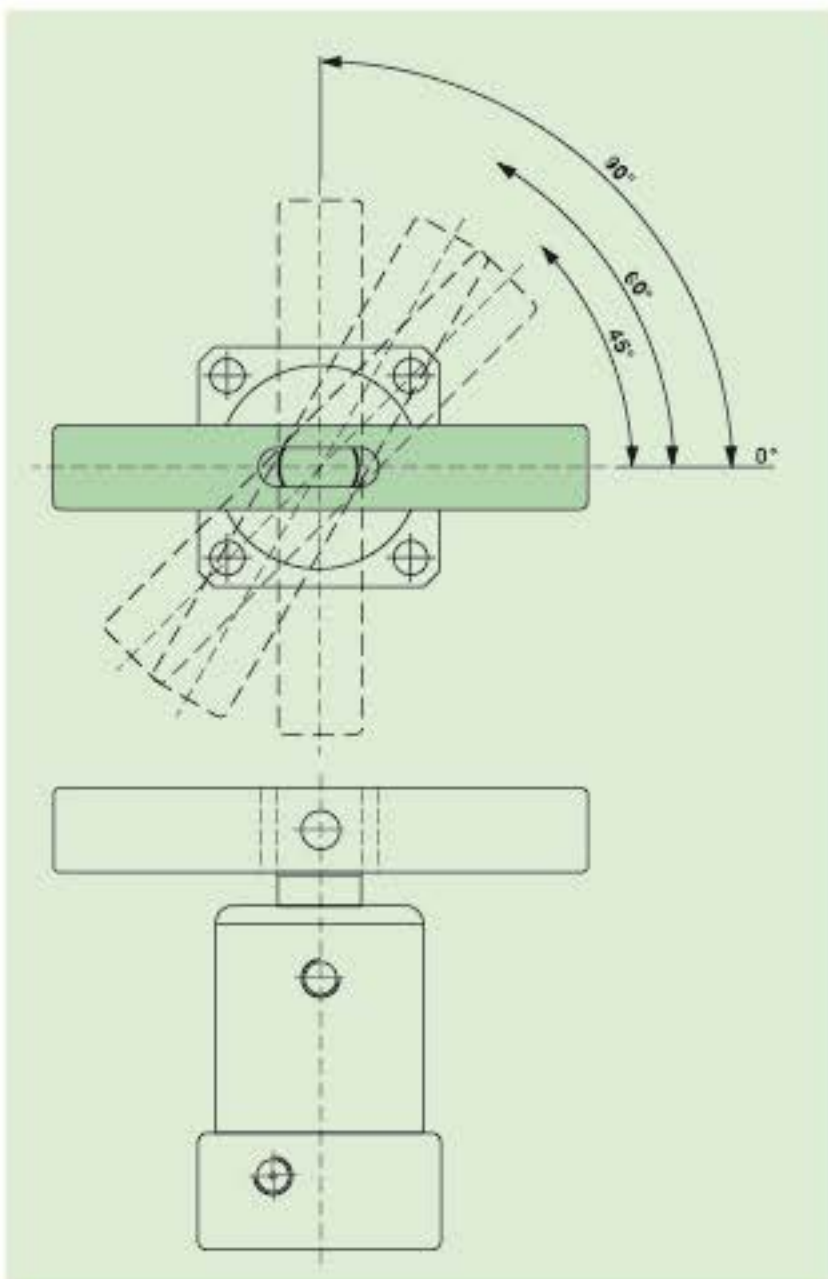


单边压板旋转示意图
Single Side Swing Clamp

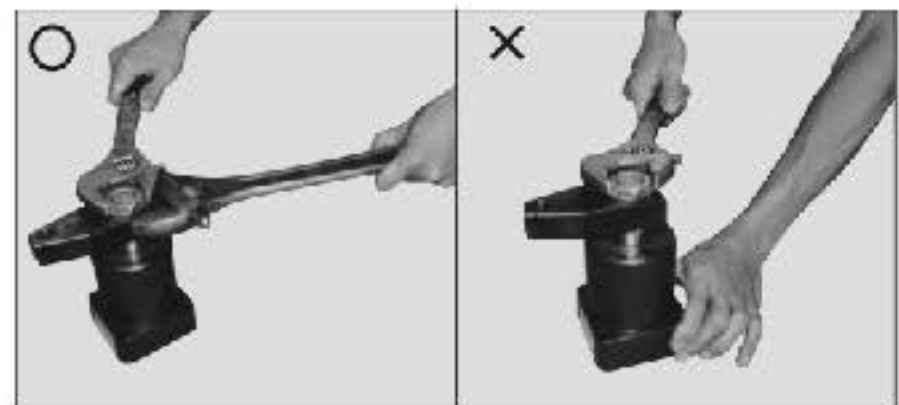
注: 转角方向是指下压时转角方向



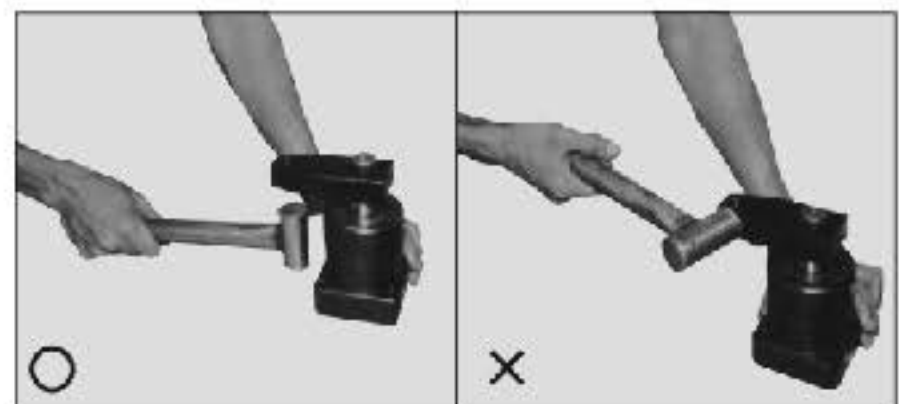
双边压板旋转示意图
Double Side Swing Clamp



压板锁紧操作方式
Clamping Arm Mounting Methods



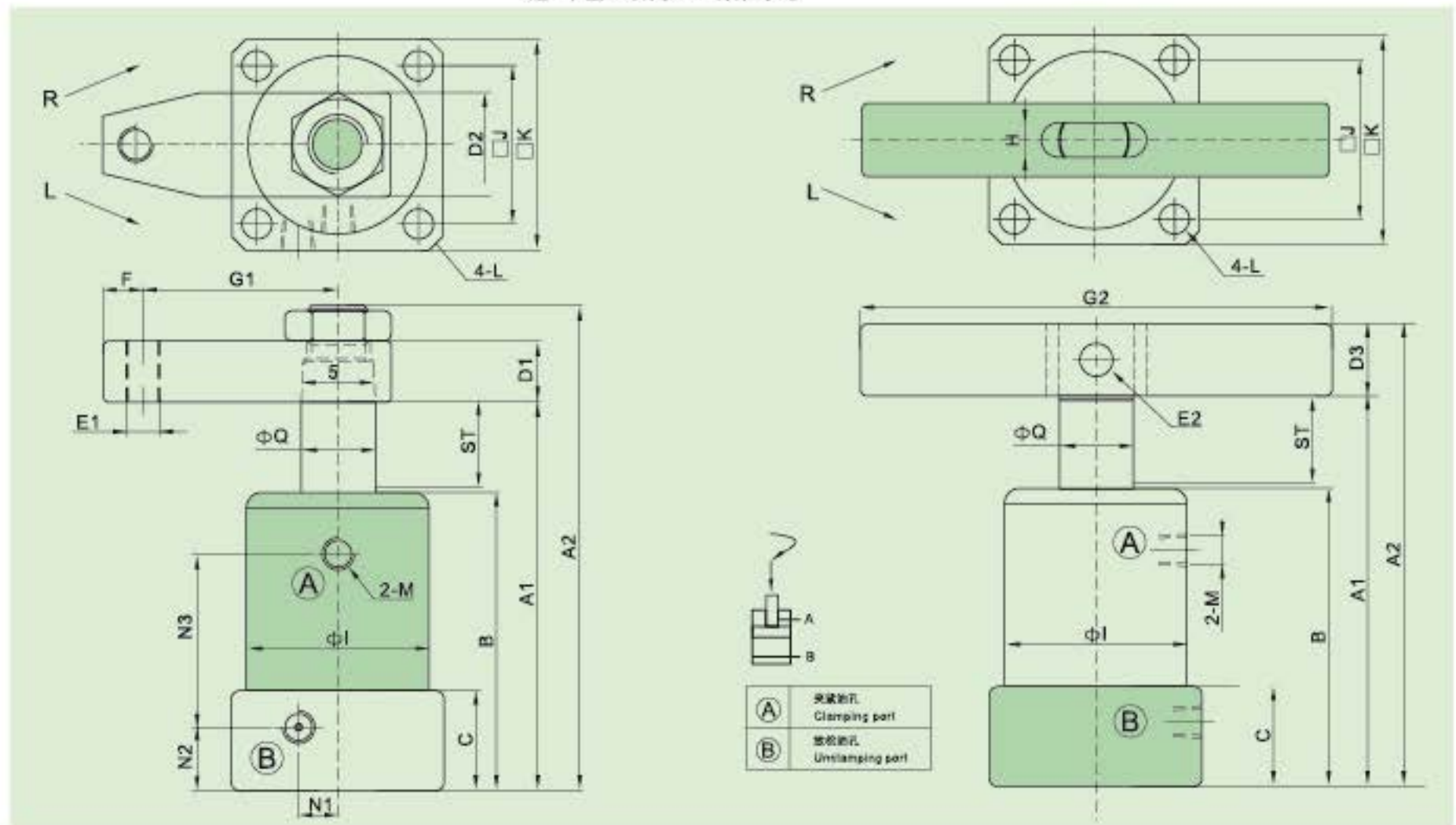
压板拆卸操作方式
Clamping Arm Removing Methods



单边压板旋转示意图
Single Side Swing Clamp

双边压板旋转示意图
Double Side Swing Clamp

注: 下图为转角90° 放松状态



外形尺寸表/Dimension table

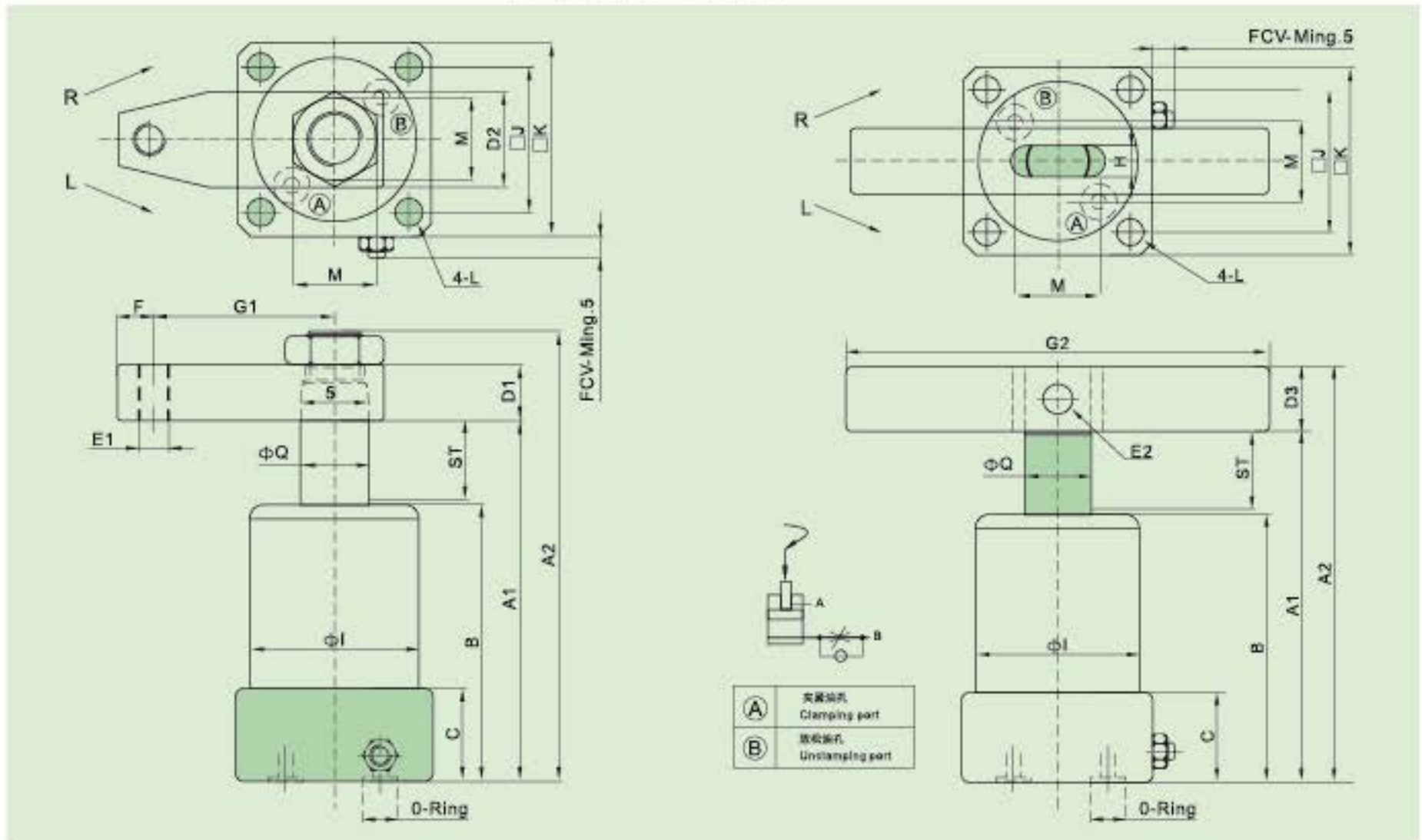
单位(Unit):mm

MODEL	CHS-25	CHS-32		CHS-40		CHS-50		CHS-63	
ITEM									
ST: Swing/Clamping	22:9/13	26:11/15	41:11/30	26:11/15	41:11/30	30:13/17	47:13/34	30:13/17	47:13/34
A1	104	118	148	123	153	137	171	142	176
A2	(127)	(144)	(174)	(150)	(180)	(167)	(201)	(177)	(211)
A3	123	140	170	145	175	162	196	174	208
B	76	85	100	90	105	100	117	105	122
C	27	30		30		34		34	
D1	16	18		18		20		23	
D2	27	31		31		37		48	
D3	□19	□22		□22		□25		□32	
E1	M10	M10		M10		M12		M16	
E2	∅8	∅8		∅10		∅12		∅15	
E3	M14x1.5	M16x1.5		M18x1.5		M20x1.5		M24x2	
F	10	10		10		12		15	
G1	50	55		60		65		75	
G2	140	160		160		180		200	
H	9	10		10		12		15	
I	∅46	∅50		∅54		∅66		∅80	
K	52	56		63		72		88	
J	40	44		48		57		70	
L	∅6.8	∅6.8		∅9		∅9		∅11	
M	PT1/8	PT1/8		PT1/8		PT1/4		PT1/4	
N1	8	10		12		15		17	
N2	17	19		19		21.5		22	
N3	46	52	67	57	72	63.5	80.5	68	85
Q	∅18	∅20		∅22		∅28		∅35	

单边压板旋转示意图
Single Side Swing Clamp

双边压板旋转示意图
Double Side Swing Clamp

注: 下图为转角90° 放松状态



外形尺寸表/Dimension table

单位(Unit):mm

MODEL	CHS-MF25	CHS-MF32	CHS-MF40	CHS-MF50	CHS-MF63
ITEM					
ST; Swing/Clamping	22,9/13	26,11/15 41,11/30	26,11/15 41,11/30	30,13/17 47,13/34	30,13/17 47,13/34
A1	104	118 148	123 153	137 171	142 176
A2	(127)	(144) (174)	(150) (180)	(167) (201)	(177) (211)
A3	123	140 170	145 175	162 196	174 208
B	76	85 100	90 105	100 117	105 122
C	27	25	25	30	30
D1	16	18	18	20	23
D2	27	31	31	37	48
D3	□19	□22	□22	□25	□32
E1	M10	M10	M10	M12	M16
E2	∅8	∅8	∅10	∅12	∅15
E3	M14x1.5	M16x1.5	M18x1.5	M20x1.5	M24x2
F	10	10	10	12	15
G1	50	55	60	65	75
G2	140	160	160	180	200
H	9	10	10	12	15
∅I	∅46	∅50	∅54	∅66	∅80
K	55	57	63	72	88
J	42	44	48	57	70
L	∅6.8	∅6.8	∅9	∅9	∅11
M	19	21	23	28	32
O-Ring	P7	P7	P9	P9	P9
Q	∅18	∅20	∅22	∅28	∅35