



副爪式快速回转油气压夹头 产品说明书

Specification of pneumatic chuck



东莞市德锐精密机械有限公司

Dongguan Derui Precision Machinery Co., Ltd.

台湾制造

Made in Taiwan

地址：东莞市寮步镇良边石大路 136 号

Addr: No. 136 Liangbian Shida Road, Liaobu Town, Dongguan City

Web: www.dr-precision.com

Tel: 0769-81103466

Fax: 0769-81103455

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产品包装内容

Product Packaging Content

1、夹头本体 1 颗

Chuck Ontology 1 piece

2、副爪安装螺丝 3 颗

Installation Screw 3 pieces

3、气压接头 2 颗

Pneumatic Connector 2 pieces

4、固定螺丝杆 1 根

Fixed Screws 1 piece

5、说明书 1 本

specification 1 pc

选购配件:

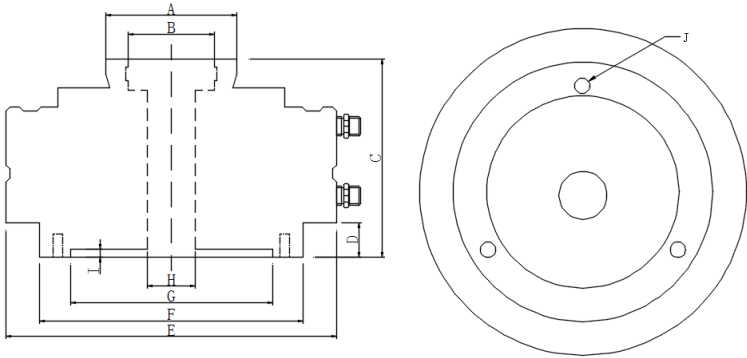
- 1、副爪
- 2、气动手动/脚踏开关
- 3、黄油枪

Optional Accessories:

- 1、Vice Claws
- 2、Pneumatic or Manual/Foot Switch
- 3、Grease Gun

外观尺寸

Appearance Size

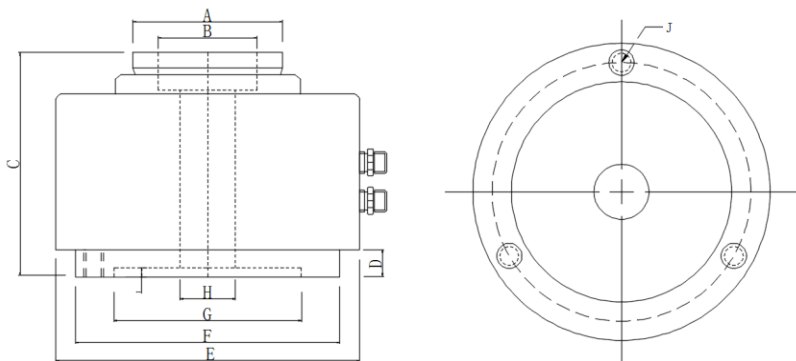


气压回转夹头

型号 (Model)	GA-25	GA-40	GA-70
A	68mm	94mm	136mm
B	25 型副爪	40 型副爪	70 型副爪
C	102mm	127mm	141mm
D	18mm	18mm	22mm
E	170mm	212mm	212mm
F	135mm	192mm	192mm
G	100mm	155mm	155mm
H	25mm	45mm	68MM
I	4	5	5
J	PCD ϕ 115	PCD ϕ 172	PCD ϕ 172
安装螺丝 (Screw)	3H-M8	3H-M10	3H-M10
最高转速 (P.P.M)	1800RPM	1600RPM	1400RPM
工作气压 (O.P.)	7kg/cm ²	7kg/cm ²	2-9kg/c m ²
夹持力 Grapping Forec	2500KGS	4100KGS	5197KGF@16kg/c m ²

油压回转夹头

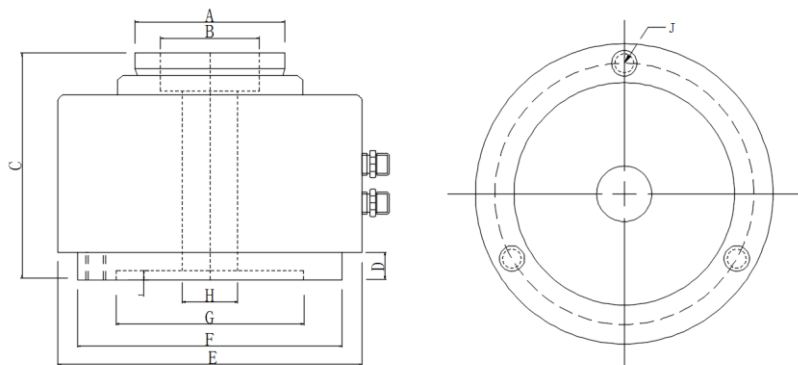
Hydraulic rotary chuck



型号 (Model)	GH-25	GH-40	GH-50	GH-70	GH-90	GH-120	GH-150
A	68mm	94mm	106mm	136mm	136mm	168mm	207mm
B	25 型副爪	40 型副爪	50 型副爪	70 型副爪	90 型副爪	120 型副爪	150 型副爪
C	104.5mm	126.5mm	129.5 mm	142mm	155mm	164mm	197mm
D	18mm	20mm	20mm	22mm	20mm	20mm	30mm
E	148mm	192mm	192mm	227mm	247mm	275mm	325
F	135mm	192mm	192mm	192mm	232mm	235mm	325
G	100mm	155mm	155mm	155mm	190mm	190mm	230mm
H	25mm	45mm	42mm	68MM	88mm	118mm	148mm
I	4	5	5	5	6	6	6
J	PCDØ115	PCDØ172	PCDØ172	PCDØ172	PCDØ210	PCDØ210	PCDØ260
安装螺丝 (Screw)	3H-M8	3H-M10	3H-M10	3H-M10	3H-M12	3H-M12	3H-M12
最高转速 (P.P.M)	1800RPM	1600RPM	1600RPM	1400RPM	1100RPM	900RPM	600RPM
工作气压 (O.P.)	10-20kg/c m ²	10-20kg/c m ²	10-20kg/c m ²	10-20kg/c m ²	10-15kg/c m ²	10-15kg/c m ²	10-15kg/c m ²
夹持力 Grapping Forec	2058KGF@ 16kg/c m ²	4032KGF@ 16kg/c m ²	4032KGF@1 6kg/c m ²	5197KGF@1 6kg/c m ²	5913KGF@1 6kg/c m ²	6148KGF@1 6kg/c m ²	7200KGF16 kg/c m ²

大行程快速油气压夹头

Large stroke high speed pneumatic and hydraulic chuck



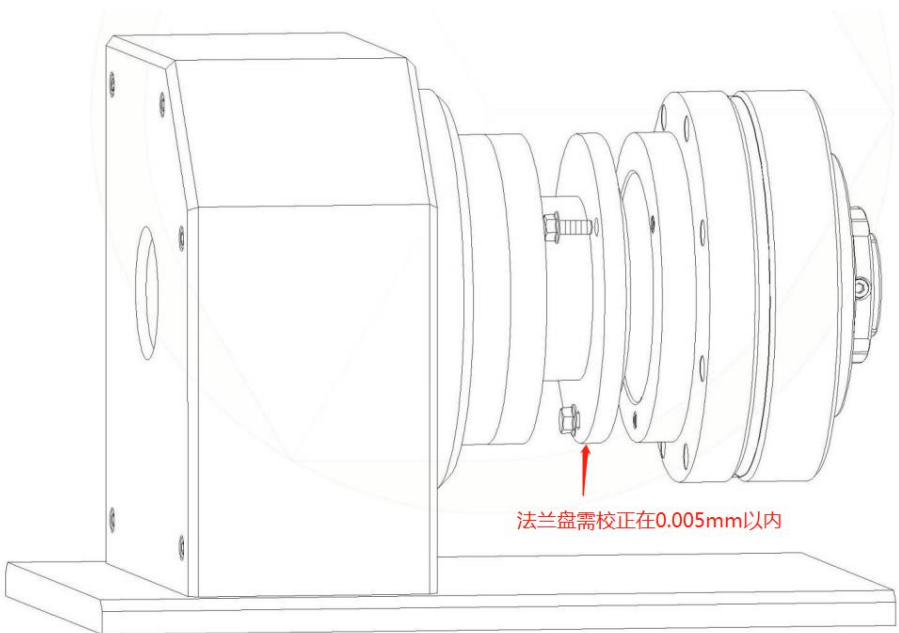
型号 (Model)	GXL-25	GXL-40	GXL-50	GXL-70	GXL-90	GXL-120	GXL-150
A	68mm	94mm	106mm	136mm	136mm	168mm	207mm
B	25 型副爪	40 型副爪	50 型副爪	70 型副爪	90 型副爪	120 型副爪	150 型副爪
C	105mm	130mm	133 mm	145mm	155mm	164mm	200mm
D	18mm	20mm	20mm	22mm	20mm	20mm	30mm
E	170mm	212mm	192mm	227mm	247mm	275mm	325
F	135mm	192mm	192mm	192mm	232mm	235mm	325
G	100mm	155mm	155mm	155mm	190mm	190mm	230mm
H	25mm	45mm	42mm	68MM	88mm	118mm	148mm
I	4	5	5	5	6	6	6
J	PCDØ115	PCDØ172	PCDØ172	PCDØ172	PCDØ210	PCDØ210	PCDØ260
安装螺丝 (Screw)	3H-M8	3H-M10	3H-M10	3H-M10	3H-M12	3H-M12	3H-M12
最高转速 (P.P.M)	1800RPM	1600RPM	1600RPM	1400RPM	1100RPM	900RPM	600RPM
工作气压 (O.P.)	10-20kg/c m ²	10-20kg/c m ²	10-20kg/c m ²	10-20kg/c m ²	10-15kg/c m ²	10-15kg/c m ²	10-15kg/c m ²
夹持力 Grapping Forec	2058KGF@ 16kg/c m ²	4032KGF@ 16kg/c m ²	4032KGF@1 6kg/c m ²	5197KGF@1 6kg/c m ²	5913KGF@1 6kg/c m ²	6148KGF@1 6kg/c m ²	7200KGF16 kg/c m ²

产品安装

Setup

夹头与设备连接结盘调整至对应位置，将夹头安装上螺丝固定。

Adjust the chuck to the corresponding position when connecting the chuck to the device. Fixed the chuck with screw



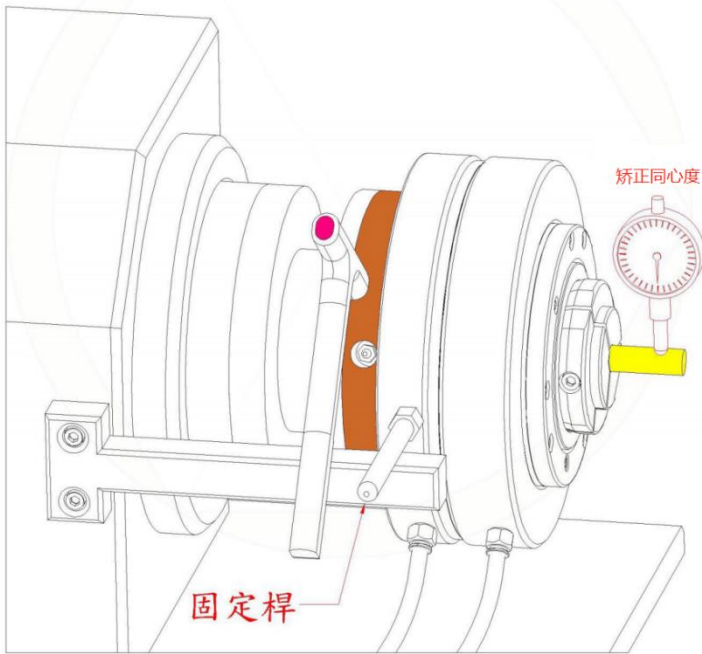
⊙ 螺絲鎖進夾頭的長度不可超過17mm

产品安装

Setup

夹持验棒校正夹头并依机台设固定杆完成安装。

Using inspection rod to adjust chuck and according to the device to set a fixed rod to finish the installation.



- ▶ 固定杆安装（M10 X P1.0）位置在下方气嘴的两侧。
- ▶ 可依外观尺寸 F 制作验棒，不需安装副爪直接夹持验棒校正夹头

Fixed rod should be install on both side of the air tap.

According to the appearance size to make the inspection rod, and no need to install a vice clam, using inspection rod to adjust the chuck.

注意事项

Notice

- ▶ 夹头安装螺丝锁入长度为 17mm，过长会使夹头卡死无法动作。
- ▶ 最大使用气压：10kg/cm²
- ▶ 夹头校正精度与最终夹持精度成正比。
- ▶ 夹头无防水结构，避免切削液飞溅夹头。
- ▶ 夹头需施打黄油，依使用转速、轴承状况调整打油频率。

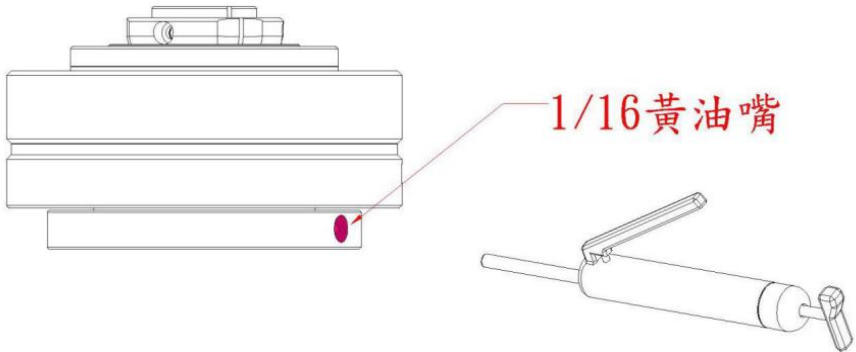
Length of the screw is 17mm

Max operation pressure is 10kg/cm²

The correction accuracy of the chuck is proportional to the final clamping accuracy

Avoiding the cutting fluid enter into the chuck directly.

Using butter to protect the chuck, according to the speed and bearing situation to decide how often the butter is used



- ▶ 请严格遵守下列使用之压力、转速及再润滑时限关系表：

Please pay more attention to below using notice

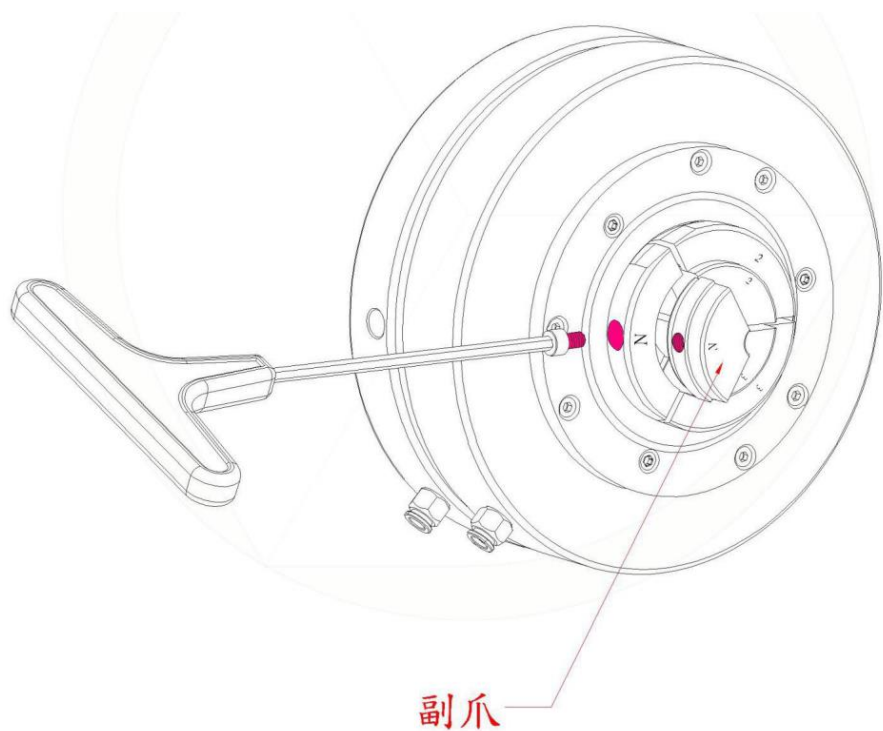
转速 Speed	使用压力 Apply Pressure	再润滑时限 Intervals
0~500RPM	25kg/cm ² 以下 (below)	200 小时 (Hour)
500~1000RPM	20kg/cm ² 以下 (below)	90 小时 (Hour)
1000~1500RPM	16kg/cm ² 以下 (below)	40 小时 (Hour)
1500RPM 以上 (Over)	12kg/cm ² 以下 (below)	16 小时 (Hour)

副爪安装

Vice Claw Installed

副爪依相同编号安装上筒夹，如图示完成安装或拆卸。

Put the same vice clam number to correct collet to finish the installation.



副爪订购

Vice Claws order

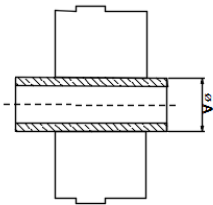
1、请先告知副爪规格如 C-70,C-40,C-25。

1、 Inform The Specification Of Jaw First,E.G.,C-70,C-40,C-25.

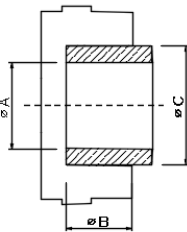
2、指定副爪形状及尺寸，如下：

2、 Specify Jaw's Type And Size, as below:

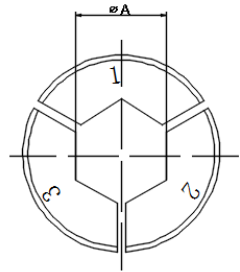
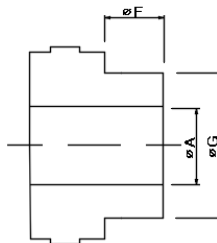
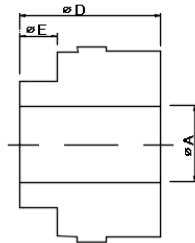
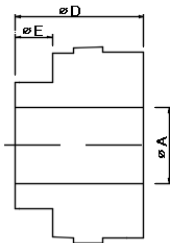
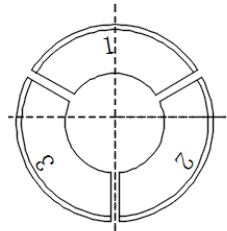
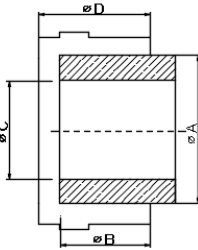
A-通孔型
Vent type



B-双层型
Double-Ply Type



C-加长型
Longer type



D-后加长型
Rear Longer Type

E-前后加长型
Front-Rear Longer Type

F-留才型
Bushing Type

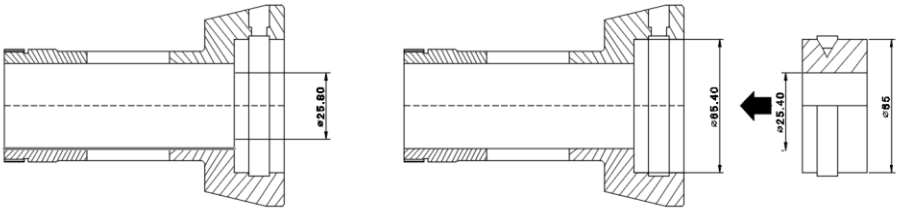
副爪订购

Vice Claws order

3、所有夹持部位 $\varnothing A$ 之尺寸，请以工作实际外径尺寸，例如：A-通孔型的工件 25.40mm，不要指示成 25.80mm，因本公司夹头筒夹已经预留加大 0.4mm 了。

3、Inform Real Working O.D. Size

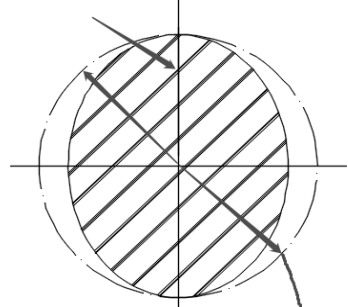
Of All Clamping Part $\varnothing A$. IT,S Not Necessary To Add The Bushing Type Working Piece Is 25.40mm,Not 25.80mm,Because Spring Collet Is Prior Enlarged 0.4mm By Jau Chyan.



4、工件公差很大时，请告诉我们最大处尺寸。

Please inform us if there is a big difference of the tolerance, and let us know the max size of your work-piece

工件/WORKING PIECE



最大尺寸
/MAX.O.D.

副爪自行车制方法

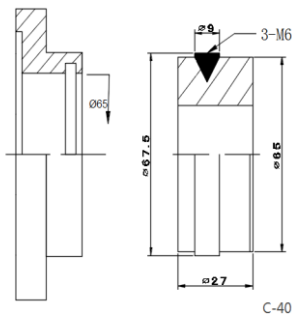
Method Of Jaw Machining

1、本公司可以提供车制副爪专用模具，及半成品副爪（生爪）给顾客自行车制副爪；副爪模具安装精度如同夹头一样，其精度必须在 0.01mm 以内

2、副爪模具直接装在车床上来车制或用三爪接头夹接。

3、模具内径车制时以工件实际外径尺寸为准。例如：C-40 型其外径为 $\phi 65$ 整。如果要研磨，则自行决定预留研磨量。

4、副爪材质为 YK-30 高碳素工具钢，经水淬处理，温度为 800°C ；经油淬处理时，温度为 830°C ，回火温度为 180°C ，时间 1 小时，及硬度约为 HRC60°，也可以用氧气焊在夹持局部加热至 820°C 时，投入水里处理即可。热处理后可以再装回模具研磨，即告完成。



1、 we can provide the mold and semi-finished vice clam, customer can make vice clam by themselves, the accuracy must be within 0.01mm.

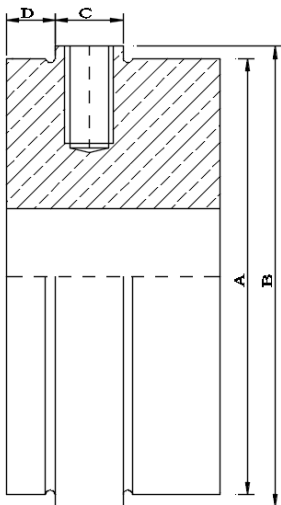
2、 Jaw Can Be Mounted Directly On The Lathe Or Clamped On Three Jaw Chuck to Machine.

3.The actual diameter of the work-piece shall prevail when the die is turned. For example: the O.D of C-40 is $\phi 65$. If you want to grind, reserve the amount of grinding at your discretion

4、 Deputy claw material for YK - 30 high carbon tool steel, through water quenching treatment, temperature is 800°C ;After oil quenching process, temperature is 830°C , tempering temperature is 180°C , for 1 hour, and hardness of about HRC60°, can also use oxygen welding when clamping locally heated to 820°C , in water treatment. After heat treatment can be put back to the mold grinding, that is completed

副爪尺寸

Vice Claws Size



型号 Item	A	B	C	D	安装螺丝 Install Screw
C-25	45mm (1.77 ")	47.5mm (1.87 ")	7mm (1.77 ")	5.0mm (1.77 ")	M5×10
C-40	65mm (2.56 ")	67.5mm (2.66 ")	9mm (0.35 ")	6.0mm (0.24 ")	M6×12
C-70	105mm (4.13 ")	107.5mm (4.23 ")	9mm (0.35 ")	6.0mm (0.24 ")	M6×12
C-120	140mm (5.51 ")	143.5mm (5.65 ")	9mm (0.35 ")	6.0mm (0.24 ")	M6×14
型号 (Item)	C-25	C-40	C-70	C-120	
适用夹头型号 (Match Chuck style)	GA-25 GH-25 GXL-25	GA-40/GH-40/GX L-40/CAF-40	GA-70/GH-70/G XL-90/CAF-70	GH-120/G XL-120	

夹头故障处理对策

How to deal with the malfunction

项目	现象	原因	对策
1	偶尔不放料 Occasionally no feeding	筒夹与润滑套斜度接触部位润滑不足 Insufficient lubrication at the oblique contact between the collet and the sleeve	请先以小铁器敲滑套，使其开启，再加油 Please knock the slip sleeve with a small iron to make it open before adding oil
2	时常不放料 Often no feeding	压力过大 Too stressed	先做前项动作，再将压力调低 Push the chuck forward first, then reduce the pressure
3	时常不放料 Often no feeding	副爪过度磨损、尺寸太大 Excessive wear out of the vice clam, and the size is too big	请更换副爪 Change the vice clam
4	时常不放料 Often no feeding	工件公差过大 The tolerance of work piece is too big	请控制前加工精度 Control the accuracy
5	时常不放料 Often no feeding	工件有沙子 Having send in the work-piece	请保持工件清洁 Cleaning the work-piece
6	时常不放料 Often no feeding	其他 other	请拆下送修 Contact after-sales service to repair it
7	漏油 oil leak	油封磨损 oil seal wear	请拆下送修 Contact after-sales service to repair it
8	运转有杂音 轴承损坏 Noise in operation, and bearing damage	压力过大，黄油不清洁，使用切削液 Too stressed, butter not clear, using cutting fluid	请拆下送修，并改进前列原因 Contact after-sales service to repair it
9	筒夹断裂 Collet fracture	压力过大，副爪过度磨损，副爪尺寸太大，时常空夹持 Excessive pressure, excessive wear of auxiliary claw, auxiliary claw size is too large, often empty clamping	请换筒夹，请并改进前列原因，防止夹持形成过大。 Change the collet, avoiding the clamping stroke too large

保修证

The warranty card

产品编号 (Product Model) : _____

购买日期 (Date) : _____

保修日期 (Warranty Period) : 一年 (One Year)

故障描述 (Problem Details) : _____

联系方式 (Tel) : _____

地址: 东莞市寮步镇良边石大路 136 号

Add: No. 136 Liangbian Shida Road, Liaobu Town, Dongguan City

注: 若夹头出现保修问题请填好信息寄回厂家

**Note: if there is any warranty problem with the chuck, please fill in above informations
and send it back to the manufacturer**