

## ▼ 組件選用基準

### SELECTION OF SYSTEM COMPONENTS

SUNZUANT Q.D.C.S.提供了最大適用性與多樣性產品，以獨特化的系列化設計理念，求取與沖床模具的最佳搭配，您所需求的最佳系統元件組合，可參照下列說明：

The SUNZUANT QDCS provides maximum flexibility to accommodate diversification in presses and dies with its unique serialized design concept of components and equipment. For the system configuration best suited to your needs. Refer to the following:

#### ◎ 標準油壓回路規劃 / Standard Hydraulic Circuits 【性能規格詳閱P6~11 For details, refer to pages 6~11】

回路數 Number of Circuit	回路型式 Circuits Code	回路分配使用情形	System Configuration
1	C	<ul style="list-style-type: none"> <li>→ 回路使用於夾持上模</li> <li>→ 回路使用於夾持下模</li> <li>→ 回路使用於同時夾持上下模</li> </ul>	<ul style="list-style-type: none"> <li>One circuit for clamping the upper die.</li> <li>One circuit for clamping the lower die.</li> <li>One circuit for simultaneously clamping the upper and lower dies.</li> </ul>
	D	→ 回路使用於舉模器	One circuit for the LIFTER.
2	2C	→ 一個回路使用於夾持上模且另一個回路使用於下模	One circuit for upper die. One circuit for lower die.
	CD	→ 一個回路使用於同時夾持上下模且另一個回路使用於舉模器	One circuit for simultaneously clamping the upper and lower dies. One circuit for the LIFTER.
3	2CD	→ 一個回路使用於夾持上模且另一個回路使用於下模且第三個回路使用於舉模器	One circuit for clamping the upper die. One circuit for the lower die. One circuit for the LIFTER.
4	3CD	→ 二回路使用於夾持上模交叉方式另一個回路使用於夾持下模且第四個回路使用於舉模器	Two circuits for clamping the upper die in a criss-cross manner. Another one circuit is for clamping the lower die. The 4th circuit is for the LIFTER.

※ 以上表根據回路數與回路的閥型，規劃回路的分配使用情形，其中回路型式C為常開閥，D為常閉閥。  
The above list is planned according to the number of circuit and valve plan to the necessity of the usage. In between the circuit type "C" means ON at all time and "D" means OFF at all time

#### ◎ 選擇夾模器 / Selection of Clamps 【性能規格詳閱P12,13 For details, refer to pages 12&13】

##### » 基本型式之選定

模具邊沿有“U”溝設計 採用TX型  
 模具邊沿無“U”溝設計 採用TY型  
 Selection the basic types of clamps  
 The die is provided with U-cuts -TX Clamp  
 The die is not provided with U-cuts -TY Clamp

##### » 夾模器數量

根據模具的大小與沖床出力的噸數來決定  
 Determining the number of clamps required  
 Determine the number of clamps according to the dimensions and configuration of the dies and the T-slot arrangement on the press.

##### » 夾模器夾持力的計算

(夾模器總夾持力) = (沖床沖壓能力20%)  
 上下模所需夾持力的分配  
 (上模夾持力) : (下模夾持力) = 3 : 2  
 (單一夾模器夾持力) =  
 (上模或下模夾持力) ÷ 夾模器數量  
 若依所使用螺栓之規格推算夾持力，如下表

##### Determine the clamping force(model)

Determine the clamping force (force of a clamp × the number) to 20% or more of the press tonnage for each of the upper and lower dies.  
 (clamping the upper die) : (clamping the lower die) = 3:2  
 (single die clamping force) = (upper or lower dies clamping force) ÷ Clamps number

螺栓規格Screw Bolt	M16	M18	M20	M24	M30	M38
夾持力(tf)Clamping Force	4	4	6	10	16	20



※ 上列夾模器夾持力與其數量應依實際作業需要修正，並且供夾模之模具邊沿厚度需標準化，以利配合夾模器之使用  
 The above list for the clamping force and quantities of the die clamper should be used according to the actual operation. The thickness of the mould base (bottom plate for die clamper to clamp) should be standardized.

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### SELECTION OF SYSTEM COMPONENTS

#### ◎ 選擇舉模器 / Selection of Lifting Rollers

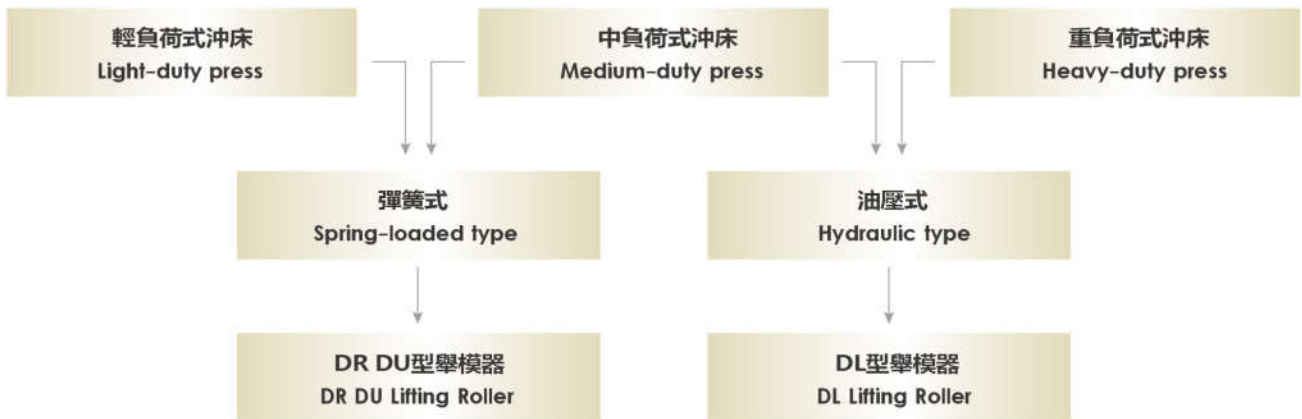
【性能規格詳閱P14~18 For details, refer to pages 14~18】

##### » 彈簧式或油壓式之選定

依據沖床噸位選擇 DL 型（油壓式）或 DR 型（彈簧式），此外並需將模具重量與所需舉模器之長度一並考量

##### Selection spring-loaded or hydraulic type

Selection spring-loaded (DR DU) or hydraulic (DL) roller according to the press tonnage, die weight, and the die positioning accuracy required.



##### ▽ 選用參考基準

- 舉模器長度
- 最大承載重量
- 配管配件
- 舉模能力
- U槽尺寸

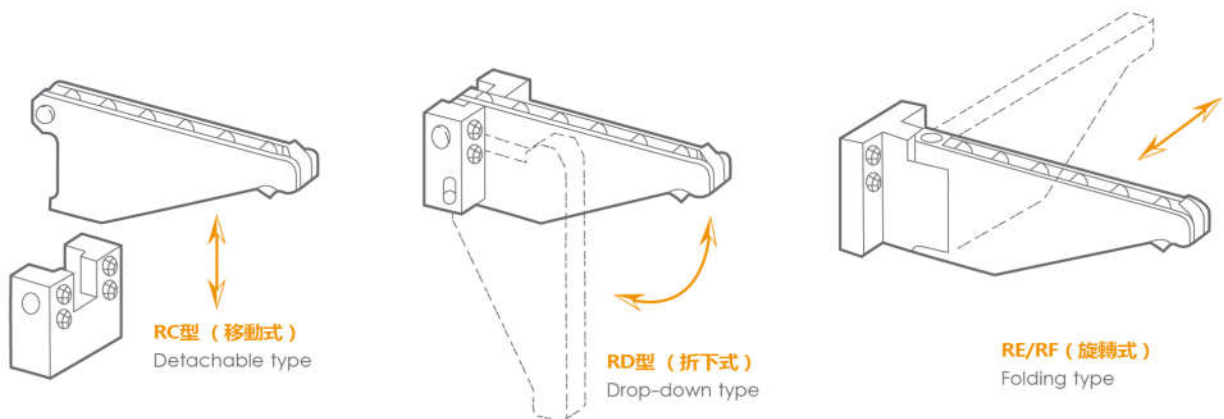
##### Selection criteria

- Roller length
- Maximum roller load weight
- Accessories
- Lift capacity
- U-cuts size

#### ◎ 選擇移模臂 / Selection of Bolster Extensions

【性能規格詳閱P19~22 For details, refer to pages 19~22】

##### » 基本型式之選定 Select the basic type



##### ▽ 選用參考基準

- 模具尺寸
- 移模臂最大承載重量
- 型式

##### Selection criteria

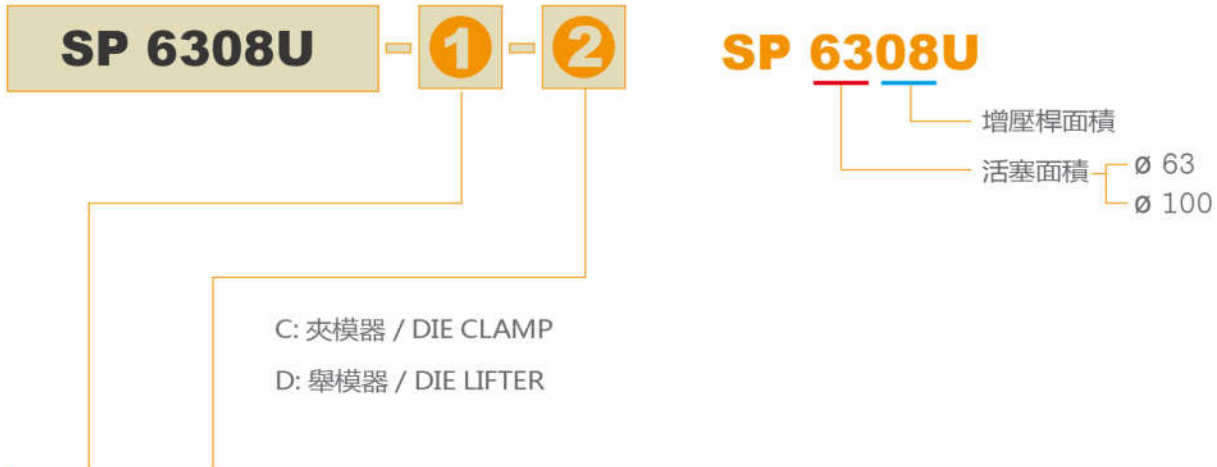
- Die dimensions
- Maximum roller load weight
- Type



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#### ◎ 形式表示法 / Hydraulic Schematics



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