

SELECTION OF SYSTEM COMPONENTS 選用規範

THE CHOICE OF THE AIR DRIVEN HYDRAULIC PUMP UNIT 氣動油壓泵浦單元之選定

NUMBER OF CIRCUIT 迴路數	CHOICE STANDARD 使用規範	CONTROL MODEL 控制型式
1	Single. For the operation of the die clamp on the upper or lower die. 單一供上模或下模夾具	NO
1	The operations of the upper and lower die clamps use the same circuit. 上下模夾具使用同一迴路	NO
1	Single. For the operation of the die lifter. 單一供舉模滑軌	NC
2	Separated circuit operation for upper and lower die clamps. 上下模夾具各自迴路分開	NO
2	The same circuit operation for upper and lower die clamps. 上下模夾具使用同一迴路 One circuit is for the operation of the die lifter. 一迴路供舉模滑軌	NO NC
3	Separated circuit operation for upper and lower die clamps. 上下模夾具各自迴路分開 One circuit is for the operation of the die lifter. 一迴路供舉模滑軌	NO NC

Please refer to Page 4 for the details. 詳述請參閱P4

THE CHOICE OF THE DIE CLAMP 夾具之選用

The model for choice
選用型式

The template has the U cuts → Model CA
模板有U形溝 → CA型

The template has no U cuts → Model CB
模板無U形溝 → CB型

Please refer to Pages 5-6 for the details.
詳述請參閱P5-P6

CHOICE STANDARD
選用依據

- Total clamping force which the machine needs (ΣF) = machine capacity (tons) x 15-20%
- The ratio of total clamping force is as follows:
upper die ($\Sigma F1$) = ΣF x 60%
lower die ($\Sigma F2$) = ΣF x 40%
- Each die clamping force (F) = $\frac{\Sigma F1(2)}{n}$ (tons)
(according to the die clamp number(n) for each upper and lower die.)

- 機台所需總夾力(ΣF) = 機台能力 (噸數) x 15-20%
- 總夾力(ΣF)分配比率:
上模夾力($\Sigma F1$) = ΣF x 60%
下模夾力($\Sigma F2$) = ΣF x 40%
- 每只夾具力(F): 依上下模各使用夾具數(n)求得
 $F = \frac{\Sigma F1(2)}{n}$ (噸)

BOLT SIZE	M16	M18	M20	M24	M30	M38
Clamping force(ton)	1-3	2-4	4-6	6-10	8-15	15-20

THE CHOICE OF THE DIE LIFTER 舉模滑軌之選用

The model for choice
選用型式

DB / DL / DS / DLS

Please refer to Pages 7-8 for the details.
詳述請參閱P7-P8

CHOICE STANDARD
選用依據

- The weight of dies and the need of application → Model of die lifter.
- The size of the plate → the length of the die lifter
- The size of the T or U slot for installing the die lifter.

- 模具重量及使用需要 → 滑軌型式
- 台盤尺寸 → 滑軌長度
- 裝設滑軌之T、U形槽尺寸

THE CHOICE OF THE DIE ARM 移模支臂之選定

The model for choice
選用型式

RC / RD / RE / RF / RS

Please refer to Pages 9-12 for the details.
詳述請參閱P9-P12

CHOICE STANDARD
選用依據

- The size of the die → the length of the arm
- The weight of the die → the maximum capacity of the arm
- The method of storage → the model of the arm

- 模具尺寸 → 支臂長度
- 模具重量 → 支臂最大荷重
- 收存方式 → 支臂型式