

## 轉角缸選用須知 General Information

- 一、單項獎邊壓板長度客戶需自行變更時，其長度勿超過G值的1.2倍，以避免活塞杆嚴重傾斜。若設計上必須超過時。建議使用雙邊系列產品，以延長缸體壽命。雙（單）邊夾持皆需考慮壓板過長時，壓板本身之重量是否過重，使用調速閥適度慢空（油）壓流速。以避免慣性造成轉角機構損壞。另外勿以未調壓（速）之空氣源直接使用于油壓轉角缸上。
- 二、在下壓夾持時，切勿于轉角行程中即夾持工件，應于垂直行程的範圍內夾持。否則將啓重損壞缸體。
- 三、每次上下工件時，請務必用氣槍清潔活塞杆及油封上附着之鐵屑異物，以避免異物在轉角瞬間嵌入油封內造成洩漏。
- 四、氣壓缸于使用時，務必安裝三點組合及調速閥，以有效除漏、潤滑，及避免慣性撞擊導致轉角卡死，延長使用壽命。
- 五、單邊壓板因配管管路問題需變換方向時，請務必以板手固定壓板，再鬆開螺絲N，由下往上將壓板敲離轉向即可，切勿側向施力或撞擊；鎖緊時亦同，以免轉角機構不當受力，造成損壞。
- 六、理論夾持力以 $F=P \times A$ 計算而得，事實上需考慮摩擦力，單動缸另需考慮彈簧之回復力所造成之損失。一般經驗取理論值的85%（僅供參考）為其實際夾持力。
- 七、轉角方向以下壓時的方向為主，區分為左轉（L）和右轉（R），標示于缸體標籤上。
- 八、使用之動力源切勿超過額定最大使用壓力與最高流量值。

1. If users want to change the length of the single arm of a clamping cylinder, it should be noted that the length must be less than 1.2 times G value in order to avoid the serious slanting of the piston rod. If the length in design needs to be larger than the aforesaid limit value, it is better to use products having double arms in order to extend the use life of the cylinder.
2. When using double/single arms of which the lengths are very long, it is necessary to consider whether the weight of the clamping arm is too heavy or not, and to use a throttle to appropriately slow down the flow rate of the air/oil in order to avoid the damage of the swing mechanism due to the inertia of the clamping arm. Further, it should not directly apply the unadjusted air pressure to the hydraulic swing clamp cylinder.
3. Workpiece should not be clamped within a swing stroke during the downward pressing of the clamping arm, and should be clamped within the vertical stroke; otherwise, the cylinder will be seriously damaged.
4. During the loading and unloading of a workpiece, it is necessary to use an air gun to clean the piston and the seal for removing the iron slag or foreigner objects attached thereon in order to prevent the foreigner objects from entering the seal to cause oil leakage.
5. When using the pneumatic cylinder, it is necessary to use a device having F.R.L. function and a throttle in order to effectively remove the moisture, lubricate the cylinder and avoid the damage of the swing mechanism due to the inertia impact of the clamping arm in order to extend the use life of the cylinder.
6. If the direction of the single arm needs to be changed due to the problem of piping, it should use a wrench to fix the clamping arm first, and then unscrew the screw and knock the clamping arm upward to change its direction. It should not apply the lateral force to the clamping arm or laterally impact the clamping arm, which should be also noted when locking the clamping arm in order to avoid the damage of the swing mechanism due to improper force applied thereon.
7. The theoretical clamping force is derived from the formula:  $F=p \times A$ . In fact, the friction must be taken into consideration; further, it should take the loss due to the restoring force of the spring into consideration when using single-acting cylinders. In general, the actual clamping force is 85% (just for reference) of the theoretical clamping force.
8. The direction of the swing is directed to be the direction of the downward pressing of the clamping arm, including clockwise direction (Right) and counterclockwise direction (Left), which will be marked on the label on the cylinder.
9. The power source should not exceed the rated maximum pressure and the highest flow value. · F: Filters R: Regulators L: Lubricators



正確鎖壓板



正確拆壓板



不正確鎖壓板



不正確拆壓板



嚴禁直接于活塞杆處加工