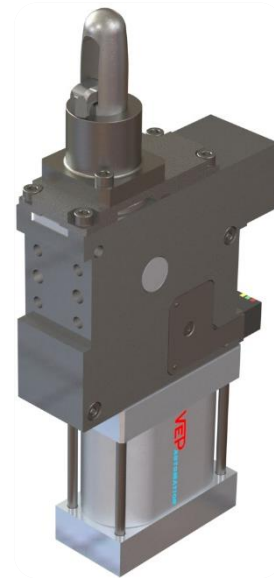


## 锁紧和定位单元 (钩销缸) DCA63V.2-V6

### Locking and holes centring device (Sub-level) DCA63V.2-V6

#### 主要特点:

- 钢制壳体
- 关闭位置可调至 3 mm  
可选最大至 6mm (“DCA63V6...”)
- 根据客户设计定制钩子，定位销  
(直径最小 20 mm，最大 40 mm，高度最大为直径的 5 倍)和支撑销
- 2 种安装方式(正面和背面)
- 扁平气缸缸径 63 mm  
带 4 个接头 G1/4”
- 感应限位开关: 3 个 LED, 接口 M12x1
- 滑动防焊溅保护罩



#### Main characteristics:

- Steel flanks
- Variable clamping position until to 3 mm  
Until to 6 mm optional (“DCA63V6...”)
- Customized hooks, locator pins  
(min. Ø20 mm – max. Ø40 mm max. height 5 times  
the ø of the pin) and top plates
- 2 mounting areas (front and rear)
- Flat pneumatic cylinder bore 63 mm  
with 4 feeding ports G1/4”
- Inductive proximity switch: 3 LEDs, connection M12x1
- Flowing weld splashes protection



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[3D Step](#)



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5	表面处理 Treatments description	
6	备件/ 图纸代号 Spare parts / Drawing reference number	
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## 订货举例.

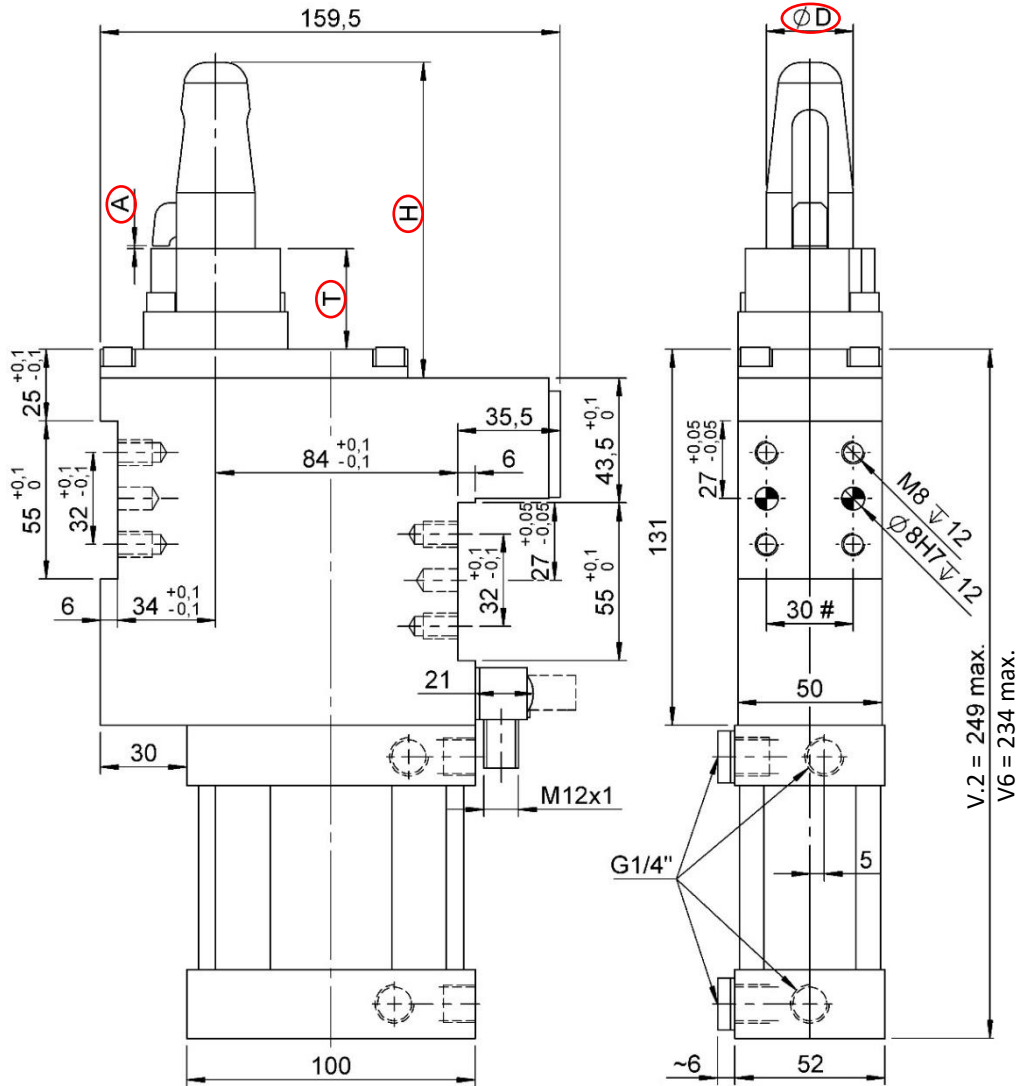
### Ordering example.

DCA63	V.2	-	I	-	00000	-	STD
<p><b>产品型号和气缸缸径:</b> <b>Type and cylinder bore:</b></p> <p><b>DCA63</b> 锁紧和定位装置 气缸缸径 63 mm; locking and holes centering device with pneumatic cylinder bore 63 mm</p> 		<p><b>限位开关:</b> <b>Proximity switch:</b></p>  <p><b>X:</b> 无限位开关 without proximity switch</p> <p><b>I:</b> P+F 感应限位开关带红色 LED proximity switch P+F with red LED</p> <p><b>W:</b> P+F 感应限位开关带白色 LED (保时捷规格) proximity switch P+F with white LED (Porsche normative)</p>					
<p><b>型号:</b> <b>Type:</b></p> <p><b>V.2:</b> 夹紧补偿公差 clamping compensation</p> <p>请注意: 夹紧位置可调至 3 mm <b>NOTE:</b> <a href="#">variable clamping position up to 3 mm</a></p> <p><b>V6:</b> 夹紧补偿公差 clamping compensation</p> <p>请注意.: 夹紧位置可调至 6 mm <b>NOTE:</b> <a href="#">variable clamping position up to 6 mm</a></p>		<p><b>定制产品编号:</b> 为客户定制产品钩子, 定位销, 支撑销厚度而提供的 VEP 编号</p> <p><b>Drawing reference number:</b> VEP code with client references to build the hook, the locator pin and the thickness plates.</p> 					
		<p><b>定位销种类:</b> <b>Type of locator pin:</b></p> <p><b>XXX:</b> 无定位销 without locator pin</p> <p><b>NT3:</b> 带 NT3 级渗氮处理定位销 locator pin with NT3 treatment</p> <p><b>STD:</b> 带标准处理定位销 standard locator pin</p> <p><b>WCC:</b> 带碳化钨涂层定位销 standard locator pin with WC/C treatment</p> <p><b>DLC:</b> 带类金刚石碳涂层定位销 locator pin with DLC treatment</p> <p>更多的信息请参考第 5 页 <a href="#">For more information see page 5</a></p>					

DCA63V...-I-00000-XXX

钩销缸 D. 63, 夹紧补偿公差 3mm 或 6mm

Sub-Level, D. 63, 3mm or 6mm clamping compensation



$\varnothing D$ : 最小  $\varnothing 20 \text{ mm}$  ÷ 最大  $\varnothing 40 \text{ mm}$ .  
 $\varnothing_{\text{min.}} 20 \text{ mm} \div \varnothing_{\text{max.}} 40 \text{ mm}$ .  
 H: 最大高度是销径的 5 倍  $\text{max. } n.5 \times \varnothing D$   
 T: 支撑销高度 *support height*  
 A: 夹紧厚度 (V.2 可调整至 +3 mm)  
 (V6 可调整至 +6 mm)  
*clamping thickness (V.2 variable until to +3 mm)*  
*(V6 variable until to +6 mm)*

#公差: 定位销  $\pm 0.02$ , 螺纹孔  $\pm 0.1$

#Tolerances: dowel holes  $\pm 0.02$ , screw holes  $\pm 0.1$

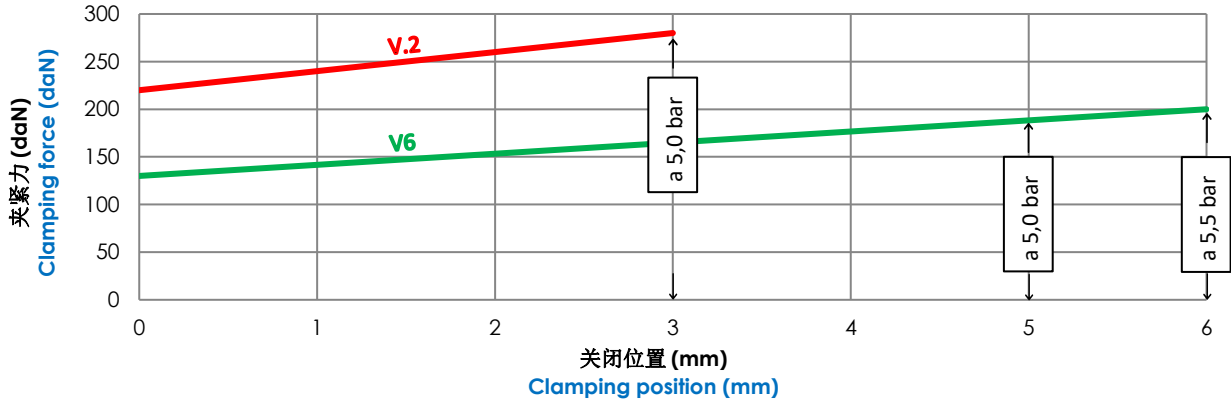
型号 Type	缸径 Cylinder bore	夹紧力 Clamping force	重量 Weight	工作气压 Working pressure	保持力 Holding moment
	[ mm ]	[ daN ]	[ Kg ]	[ bar ]	[ daN ]
DCA63V.2...	63	220 (A) – 280 (A+3)	~ 7	5 – 8	330
DCA63V6...	63	130 (A) – 190 (A+5) 130 (A) – 200 (A+6)	~ 7 ~ 7	5 – 8 5,5 – 8	230

图表.

## Diagram.

力度表

### Force diagram



### 感应限位开关电路图

(代码 06862/R/C 带红色 LED, 代码 06862/W/C 带白色 LED).

### Diagram for Inductive proximity switch

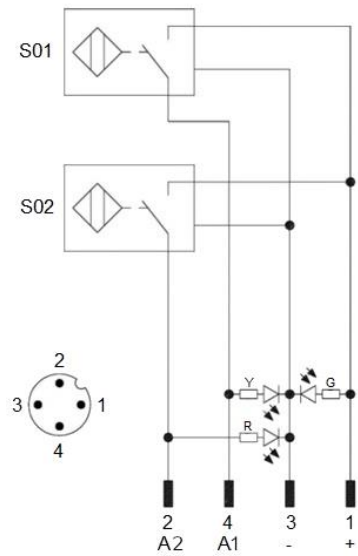
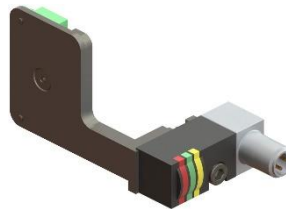
(cod. 06862/R/C with red LED, 06862/W/C with white LED).

技术参数(P+F):

- 输出类型: PNP;
- 输入电压: 10-30 VDC;
- 最大换向电流: 200 mA;
- 耗电量: < 25 mA;
- 电压差: < 2 V
- 工作温度: -25° / 70° C.

Technical data (P+F):

- Output type: PNP;
- Feeding voltage: 10-30 VDC;
- Max. commutating current: 200 mA;
- Power supply: < 25 mA;
- Voltage drop: < 2 V;
- Temperature range: -25° / 70° C.



S01 = 打开信号  
S01 = opening signal  
S02 = 关闭信号  
S02 = closing signal

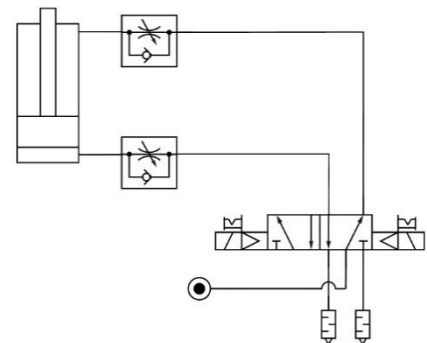
Y = 黄色 LED / yellow LED  
G = 绿色 LED / green LED  
R = 红色 LED / red LED

1 = 棕色线 / brown wire  
2 = 黑色线 / black wire  
3 = 蓝色线 / blue wire  
4 = 白色线 / white wire

### 气路图

### Pneumatic diagram.

工作气压 Working pressure	耗气量 (5 bar) Air consumption (5 bar)
[ bar ]	[ l ]
5 - 8	~ 1,4



## 表面处理工艺.

### Treatments description.

#### NT3 (表面渗氮)

NT3表面渗氮处理工艺可以达到 HV1> 600 (~ >55HRC)的硬度和0.3 毫米的深度，然后逐渐衰减，使材料恢复到自然硬度 (HV~280)。NT3 表面处理通常用于直径较小的定位销。外观是灰色。

#### NT3 (Nitriding)

Nitriding NT3 treatment has an hardness HV1> 600 (~ >55HRC) up to a depth of 0.3mm, then it collapses leaving the material to its natural hardness (HV~280). NT3 treatment is often recommended for small sizes locating pins. Its color is grey

#### STD (标准)

STD标准表面渗碳加抛光处理工艺，硬度达58÷62 HRC，深度达0.5mm，然后逐渐减小。对缺口具良好的抗御性。因为抛光，表面呈黑色。

#### STD (Standard Option)

Standard carburizing treatment + burnishing has an hardness of 58÷62 HRC up to a depth of 0.5mm, then it decreases progressively. Good resistance to nicking problems. Its color is black due to the burnishing

#### WCC (WC/C 碳化钨表面涂层)

WCC处理工艺 是在STD 渗碳处理基础上添加碳化物涂层。WCC 处理硬度可达 (1000 ÷ 1500 HV 0.05)，厚度达 0,003 毫米。

WCC 涂层 (WC/C) 由钨和非晶碳组成。它具有优异的耐磨性和较低的摩擦系数。它是减少癫痫发作或其他粘连现象的理想选择。外观是煤灰色。

#### WCC (WC/C Tungsten Carbide)

The surface coating based on tungsten carbide WCC is in addition to STD cementation treatment described above. The WCC treatment has high hardness characteristics (1000 ÷ 1500 HV 0.05) and a thickness of 0,003mm.

The WCC coating (WC/C) is composed of tungsten carbide and amorphous carbon. It has an excellent wear resistance and a reduced friction coefficient. It is ideal for reducing seizures or other adhesive phenomena. Its color is anthracite.

#### DLC (类金刚石碳涂层)

DLC类金刚石碳涂层 是在STD 渗碳处理基础上添加类金刚石涂层。DLC 处理具超高硬度(1500 ÷ 2500 HV 0.05)，厚度达0,003mm。

DLC 涂层由碳 sp<sup>2</sup> (石墨) 和碳 SP<sup>3</sup> (金刚石) 组成。它具有较高耐磨性和较低的摩擦系数。它是减少或消除磨损，刮伤及粘附现象的理想选择。外观是亮黑色。

#### DLC (Diamond Like Carbon)

The surface coating carbon based DLC is in addition to STD cementation treatment described above. The DLC treatment has very high hardness characteristics (1500 ÷ 2500 HV 0.05) and a thickness of 0,003mm.

The DLC coating consists of carbon sp<sup>2</sup> (graphite) and Carbon SP<sup>3</sup> (diamond). It has very high wear resistance and a very low friction coefficient. It is ideal for minimizing or eliminating problems of abrasions and seizures and adhesive phenomena. Its color is shiny black.

- 定位销直径大于 > 20mm 优先选择 **STD/WCC/DLC处理**  
For locator pins with diameter > 20 mm is preferred to use the type **STD/WCC/DLC**
- 定位销直径小于 ≤ 20mm 只能选用 **NT3** 处理以保证组件的正常功能  
For locator pins with diameter ≤ 20mm the functionality of the component is only guaranteed by choosing the type **NT3**

更多信息，请联系 VEP 自动化公司技术部门。

For more information, contact the technical department of VEP Automation.

备件.

## Spare parts.

配套元件 # Kit	图片 Picture	描述 Description		代号 Article
限位开关 Proximity switch		电感式限位开关 P+F 带红色 LED Inductive proximity switch P+F with red LED		06862/R/C
		电感式限位开关 P+F 带白色 LED Inductive proximity switch P+F with white LED		06862/W/C
密封圈组件 Seals kit		缸径 63 mm 的气动密封组件 Seal components for pneumatic cylinder bore 63 mm		SCR-CIL63V.2
钩子 Hook		钩子 + 滑动防焊溅保护盖 Hook + flowing weld splashes protection		HK-00000 *
定位销 Locator pin		定位销 Locator pin		LP-00000XXX **
缸筒 Cylinder liner		铝制缸筒 Cylinder liner		CL-00000 *
支撑销 Top plate		支撑销 Reaction dowel		RD-00000 *
弹簧 Spring		补偿弹簧	DCA63V.2	09481/C
		Compensation spring	DCA63V6	10748/C

产品参考编号.

## Drawing reference number.

\* 00000 = 在产品完整代码中描述的参考编号.

举例: HK-"07810" 为钩子备件

CL-"07810" 为铝制缸体备件

RD-"07810" 支撑销备件

\* 00000 = reference number describe in the complete code of the device.

Example: HK-"07810" for spare hook

CL-"07810" for spare cylinder liner

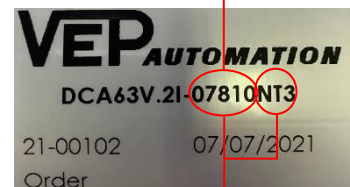
RD-"07810" for spare reaction dowel

\*\* 00000XXX = 在产品完整代码中描述的参考编号 + 定位销表面处理工艺.

举例: LP - "07810NT3" 为带 NT3 表面渗氮定位销

\*\* 00000XXX = reference number describe in the complete code of the device + type of the treatment present on the locator pin.

Example: LP - "07810NT3" for nitrided locator pin





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