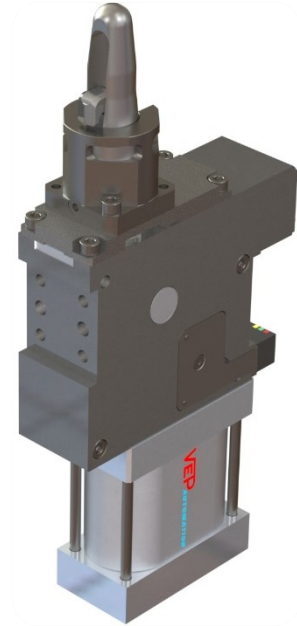


定位和夹紧单元 (钩销缸) DCA63CV

Locking and holes centring device (Sub level) DCA63CV

主要特点:

- 定位销可浮动
- 最大容差 3 mm
- 钢制侧体
- 定制钩子，定位销和盖板
- 2 个安装面 (正面 和背面)
- 气缸缸径 63 mm
带 4 个气源接口 G1/4"
- 电感式传感器: 3 个 LED, 接口 M12x1
- 滑动防焊溅保护罩



Main characteristics:

- Backlash free centering of the part
- Variable clamping position until to 3 mm
- Steel flanks
- Customized hooks, locator pins 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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订货举例

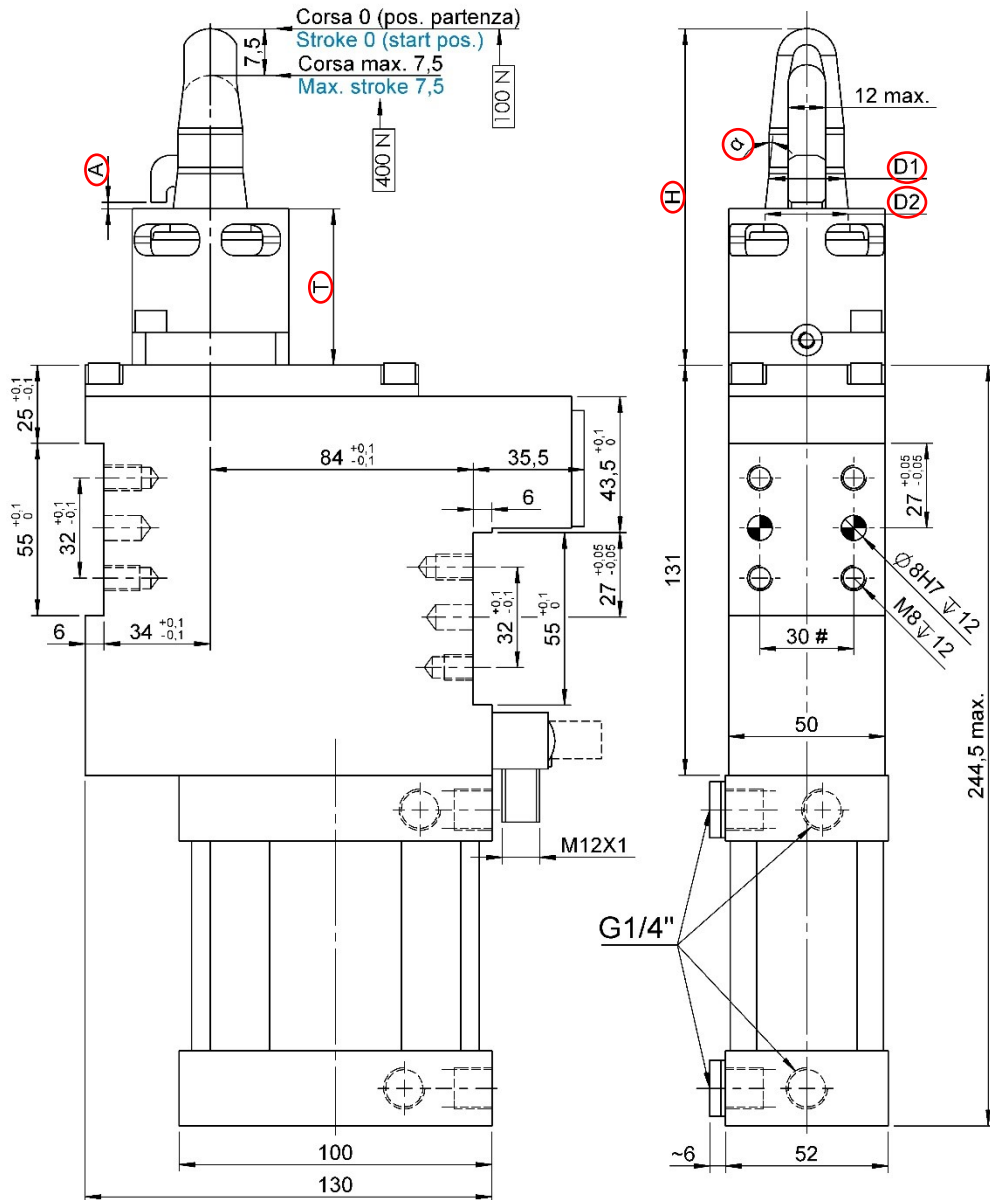
Ordering example.



DCA63CV...

钩销缸, D. 63, 3mm 容差, 定位销可浮动

Sub-Level, D. 63, 3mm compensation, backlash free centering



ØD1 min.	19 mm
ØD2 max.	32 mm
α min.	6°
H max.	6 volte ØD1 6 times ØD1
T min.	50mm
A:	钣金板厚度(容差 +3mm) Metal sheet thickness (variable up to +3mm)

定位销行程 Stroke pin [mm]	推力 Thrust force [N]
0,0	100
2,5	200
5,0	300
7,5 (max.)	400

#公差: 定位销孔 ±0.02, 螺纹孔 ±0.1

#Tolerances: dowel holes ±0.02, screw holes ±0.1

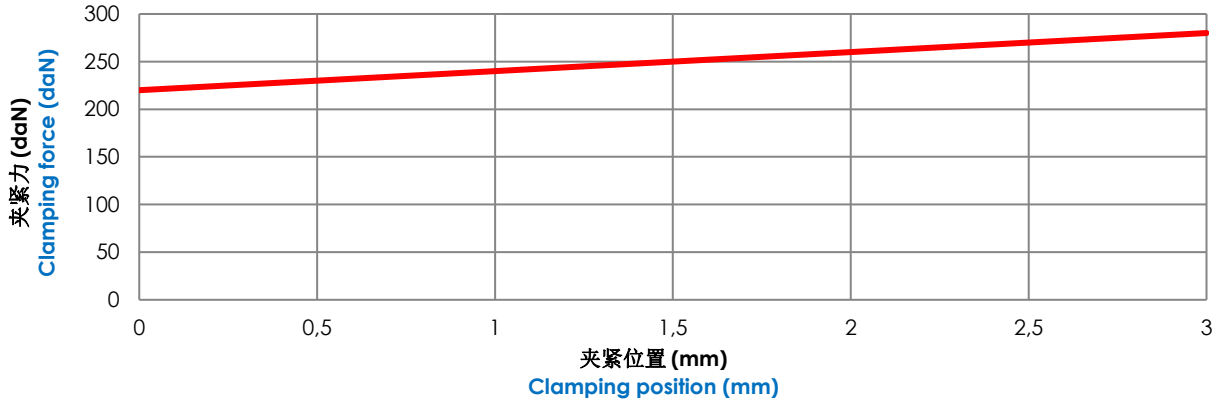
类型 Type	缸径 Cylinder bore	夹紧力 Clamping force	重量 Weight	工作气压 Working pressure	保持力 Holding moment
	[mm]	[daN]	[Kg]	[bar]	[daN]
DCA63CV...	63	220 (A) – 280 (A+3)	~ 7,5	5 – 8	330

图表

Diagram.

夹紧力曲线图

Force diagram



电感式传感器示意图

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

Diagram for Inductive proximity switch

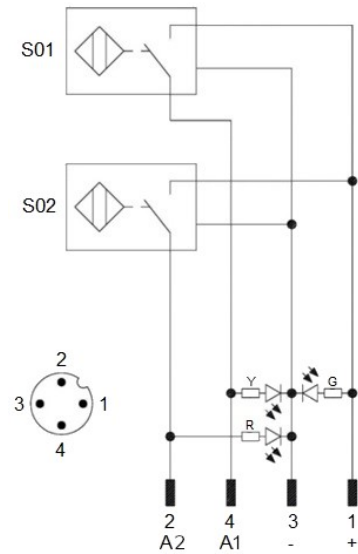
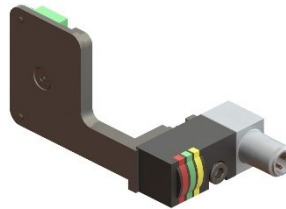
(cod. 06862/R/C with red LED, 06862/W/C with white LED).

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;
- 耗电电流: < 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

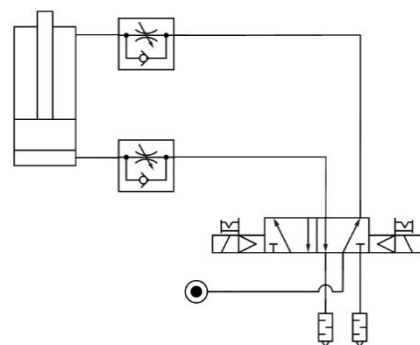
Y = 黄色 LED / yellow LED
G = 绿色 LED / green LED
R = 红色 LED / red LED

1 = 棕色系 / 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	~ 0,7



表面处理工艺描述.

Treatments description.

NT3 (表面渗碳)

NT3表面渗碳处理工艺可以达到 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 (标准定位销)

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。对缺口具有良好的抗御性。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 sp² (石墨) 和碳 SP³ (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 sp² (graphite) and Carbon SP³ (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		电感式传感器 P+F带红色 LED Inductive proximity switch P+F with red LED	06862/R/C
		电感式传感器 P+F 带白色 LED Inductive proximity switch P+F with white LED	06862/W/C
密封圈组件 Seals kit		63 mm气缸缸体密封组件 Seal components for pneumatic cylinder bore 63 mm	SCR-CIL63V.2
钩子 Hook		钩子 + 滑动防飞溅保护罩 Hook + flowing weld splashes protection	HK-00000 *
定位销 Locator pin		定位销 Locator pin	LP-CV/00000XXX **
缸体 Cylinder liner		铝制气缸缸体 Cylinder liner	CL-00000 *
支撑台阶面 Top plate		支撑台阶面 Reaction dowel	RD- CV/00000 *
弹簧 Spring		补偿弹簧 仅用于 DCA63V.2 Compensation spring for DCA63V.2	09481/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-"09876" 为钩子备件

CL-"09876" 为铝制缸体备件

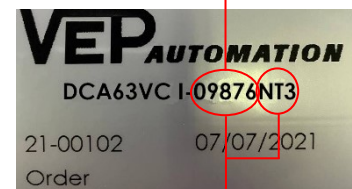
RD-CV/"09876" 为支撑台阶面备件

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

Example: HK-"09876" for spare hook

CL-"09876" for spare cylinder liner

RD-CV/"09876" for spare reaction dowel

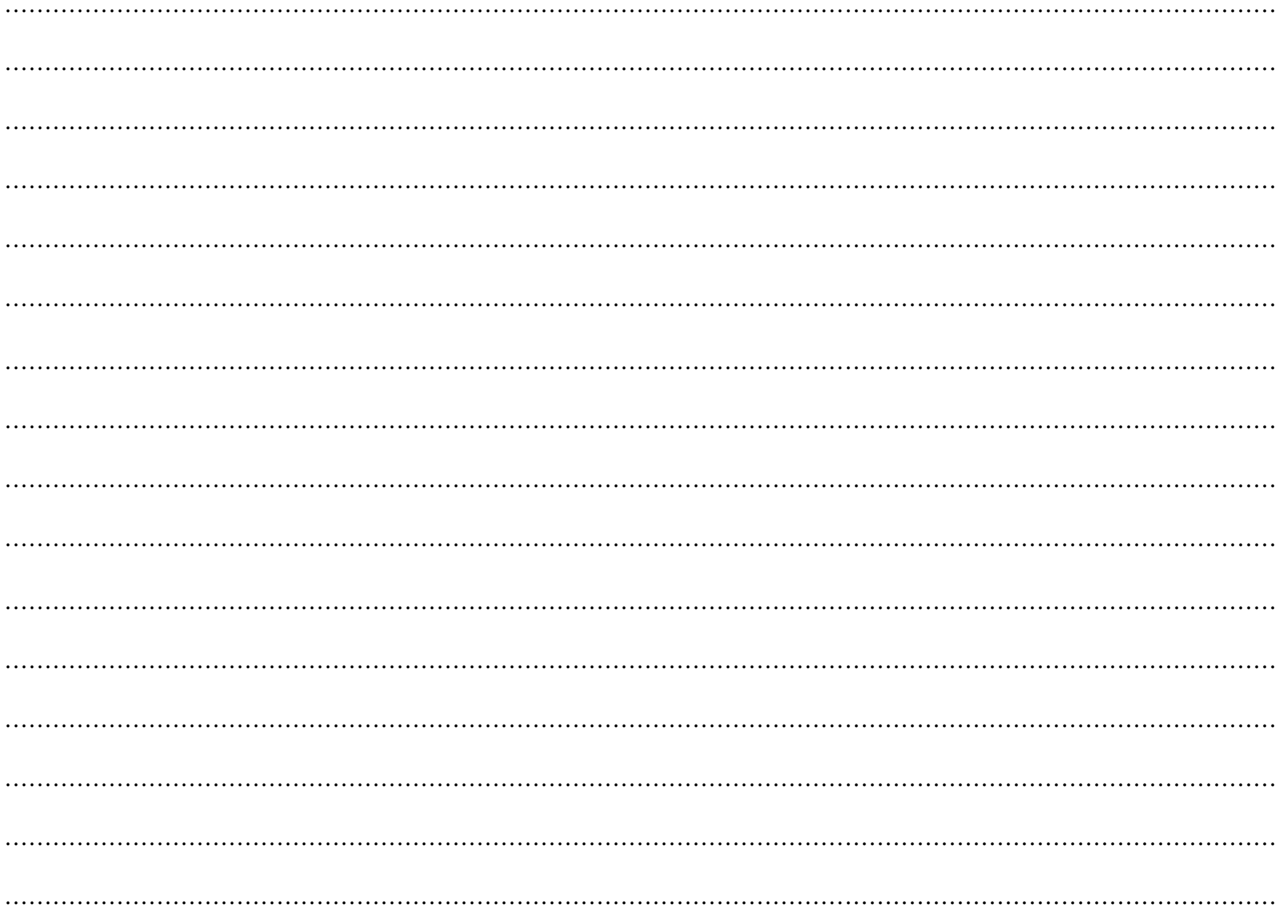


** 00000XXX = 在产品完整代码中描述的参考编号 + 定位销表面处理工艺

举例: LP-CV/"09876NT3" 为经 NT3 渗氮处理定位销

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

Example: LP-/CV"09876NT3" for nitrided locator pin



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