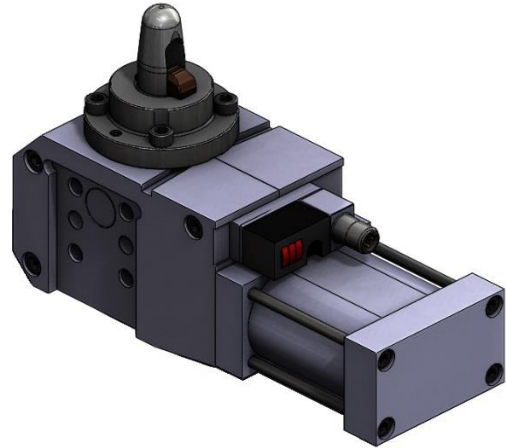


定位和夹紧单元 (钩销缸) DCA50Z.1

Locking and holes centering device (Sub level) DCA50Z.1

主要特点:

- 铝制壳体
- 水平安置
- 定制钩子和定位销
(销径 \varnothing 最小 18mm 最大 30mm, 最大高度为销径的 4 倍)
台阶面厚度按客户图纸定制
- 3 个安装面 (侧面和底部)
- 补偿公差 $\pm 0,20$ mm
- 水平气缸缸径 50mm 带
4 个 G1/4" 气源接口
- 可分离电感式传感器 (M12x1 连接)
- 防尘防焊溅保护罩



Main characteristics:

- Aluminum body
- Horizontal shape
- Customized hooks, locator pins
(\varnothing min. 18mm \div \varnothing max. 30mm, max height 4 times the \varnothing of the pin) and thickness plate
- $\pm 0,20$ mm tolerance compensation
- 3 mounting areas (lateral and bottom)
- Flat pneumatic cylinder bore 50mm with 4 feeding ports G1/4"
- Separable Inductive sensor (connection M12x1)



[PDF](#)



[3D Step](#)



[Index](#)

索引.

Index.

页码 Page	描述 Description	
1	主要特点 Main characteristics	
2	订货举例 Ordering example	
3 - 5	尺寸页码 Dimensional page	DCA50Z.1A...
		DCA50Z.1B...
		DCA50Z.1D...
6	表面处理工艺 Treatments description	
7	电感式传感器示意图/ 气路图 Diagram for inductive proximity switch / Pneumatic plan	
8	备件 Spare parts	
9	产品编号参考 Drawing reference number 备注 / Notes	

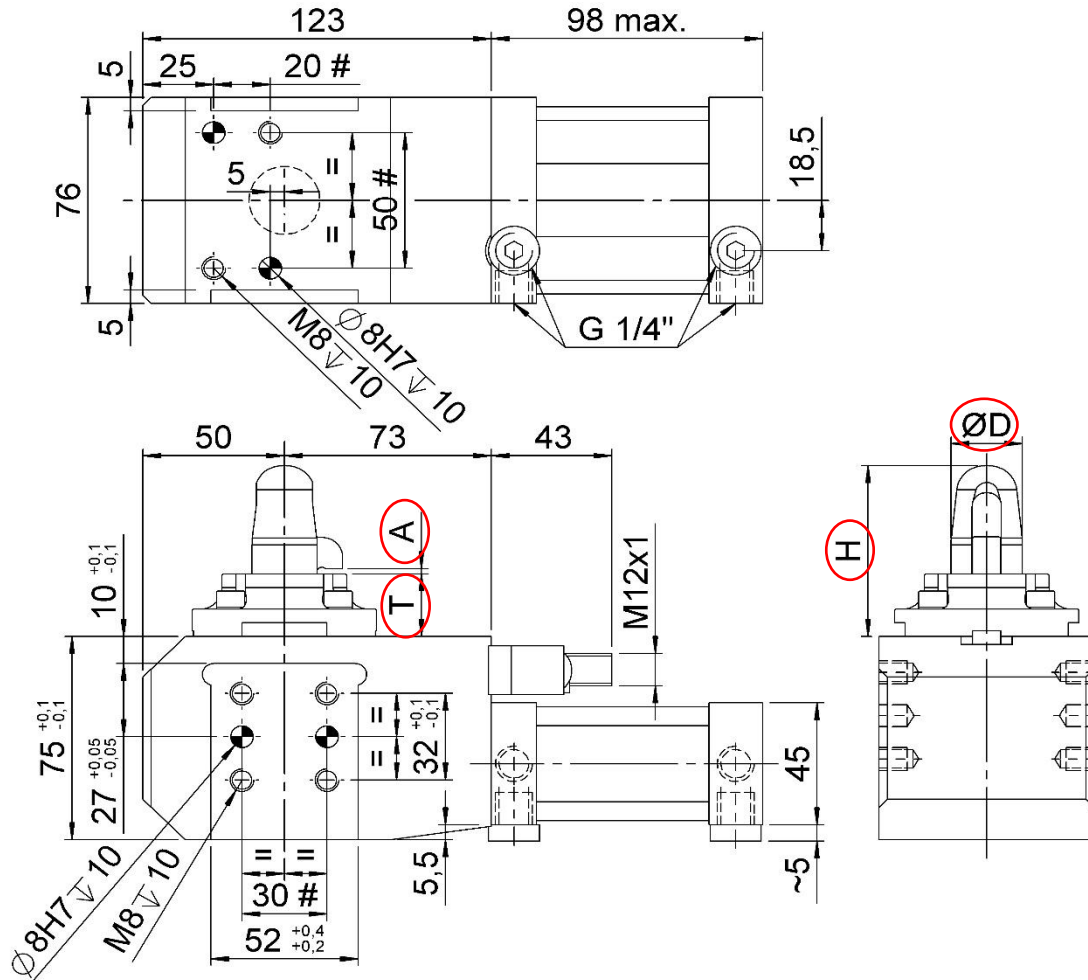
订货举例.

Ordering example.

DCA50Z.1	A	-	I	-	00000	-	STD
<p>产品类型和气缸缸径: Type and cylinder bore:</p> <p>DCA50Z.1 锁紧和定位单元 缸径 50 mm locking and holes centering device with pneumatic cylinder bore 50 mm</p> 			<p>产品特殊编号: Drawing reference number: 根据客户要求定制的钩子，定位销和台阶面厚度的 VEP 产品编号。 VEP code with client references to build the hook, the locator pin and the thickness plates.</p> 				
<p>钩子位置: Hook position: A: 钩子朝向气缸(标准位置) Hook facing towards pneumatic cylinder</p>  <p>B: 钩子在 A 位置旋转 180° hook rotated 180° compared to A</p>  <p>D: 双钩 double hook</p> 			<p>定位销类型: Type of locator pin:</p> <p>XXX: 无定位销 without locator pin</p> <p>NT3: 带渗氮表面处理定位销 locator pin with NT3 treatment</p> <p>STD: 标准渗碳定位销 standard locator pin</p> <p>WCC: 带碳化钨表面处理的标准定位销 standard locator pin with WC/C treatment</p> <p>DLC: 带类金刚石碳表面处理的定位销 locator pin with DLC treatment</p> <p>更多信息，请参考第 4 页 For more information see page 4</p>				
			<p>电感式接近开关: Proximity switch:</p> <p>X: 无接近开关 without proximity switch</p> <p>I: 带电感式接近开关 proximity switch</p> 				

DCA50Z.1A-I-00000-XXX

钩销缸, D. 50, 水平安置
Sub-Level, D. 50, horizontal shape



夹紧范围

不正确的工作范围($\pm 0,2$) 可能会导致钩子变形。

Clamping zone:

A not correct working range ($\pm 0,2$), could causing a hook deformation

- ØD:** 销径最小 18 mm ÷ 最大 30 mm
Ø min 18 mm ÷ Ø max 30 mm
- H:** 最大高度是 销径的 4 倍(D)
4 times the Ø of the pin (D)
- T:** 支撑高度
support height
- A:** 请标明钣金板厚度
indicate the thickness of the sheet

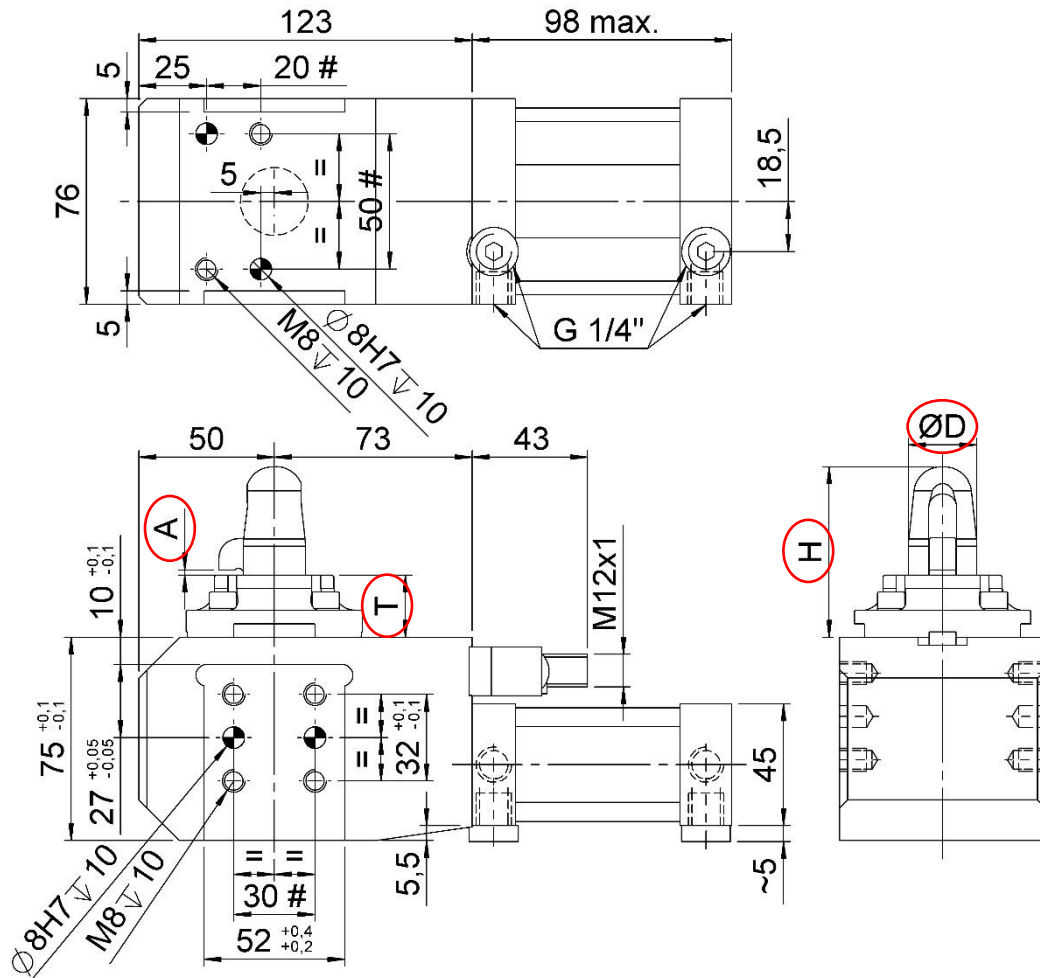
:定位销孔 $\pm 0,02$, 螺纹孔 $\pm 0,1$

Tolerances: dowel holes $\pm 0,02$, screw holes $\pm 0,1$

类型 Type	缸径 Cylinder bore	最大夹紧力(5 bar) Max. clamping force (5bar)	重量 Weight	最大工作气压 Max. working pressure	保持力 Holding force
	[mm]	[daN]	[Kg]	[bar]	[daN]
DCA50Z.1A...	50	200	~ 3	6	330

DCA50Z.1B-I-00000-XXX

钩销缸, D. 50, 水平安置
Sub-Level, D. 50, horizontal shape



夹紧范围：

不正确的工作范围(±0,2) 可能会导致钩子变形。

Clamping zone:

A not correct working range (±0,2), could causing a hook deformation

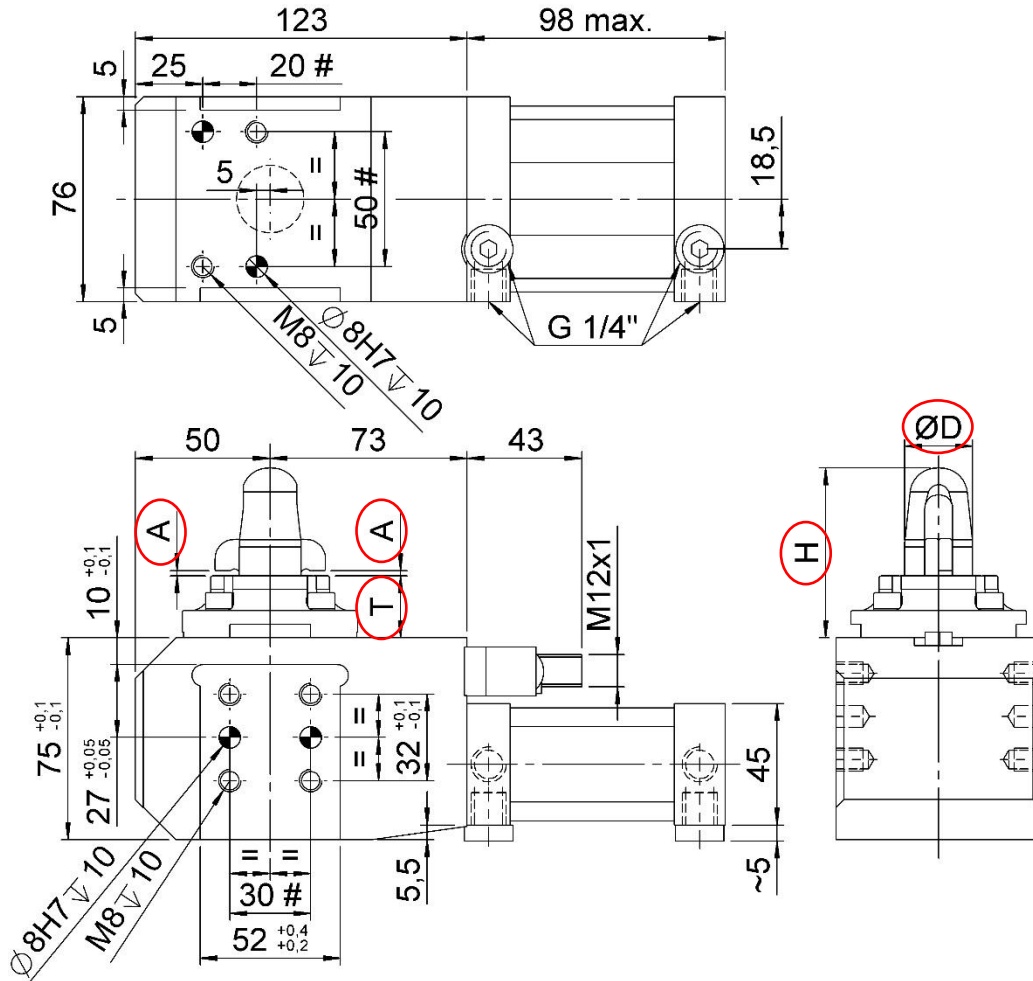
- ØD:** 销径最小 18 mm ÷ 最大 30 mm
Ø min 18 mm ÷ Ø max 30 mm
- H:** 最大高度是 销径的 4 倍(D)
4 times the Ø of the pin (D)
- T:** 支撑高度
support height
- A:** 请标明钣金板厚度
indicate the thickness of the sheet

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	最大夹紧力(5 bar) Max. clamping force (5bar)	重量 Weight	最大工作气压 Max. working pressure	保持力 Holding force
	[mm]	[daN]	[Kg]	[bar]	[daN]
DCA50Z.1B...	50	200	~ 3	6	330

DCA50Z.1D-I-00000-XXX

钩销缸, D. 50, 水平安置
Sub-Level, D. 50, horizontal shape



夹紧范围：

不正确的工作范围(±0,2) 可能会导致钩子变形。

Clamping zone:

A not correct working range (±0,2), could causing a hook deformation

- ØD: 销径最小 18 mm ÷ 最大 30 mm
Ø min 18 mm ÷ Ø max 30 mm
- H: 最大高度是 销径的 4 倍(D)
4 times the Ø of the pin (D)
- T: 支撑高度
support height
- A: 请标明钣金板厚度
indicate the thickness of the sheet

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	最大夹紧力(5 bar) Max. clamping force (5bar)	重量 Weight	最大工作气压 Max. working pressure	保持力 Holding force
	[mm]	[daN]	[Kg]	[bar]	[daN]
DCA50Z.1D...	50	200	~ 3	6	330

表面处理工艺描述

Treatments description.

NT3 (渗氮)

NT3表面渗氮处理工艺硬度可达 HV1> 600 (~ >55HRC)，深度达0.3 毫米，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)

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 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**渗氮 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

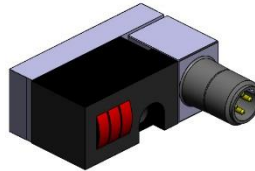
For more information, contact the technical department of VEP Automation.

电感式接近开关示意图 (cod. 3/433/C).

Diagram for Inductive proximity switch (cod. 3/433/C).

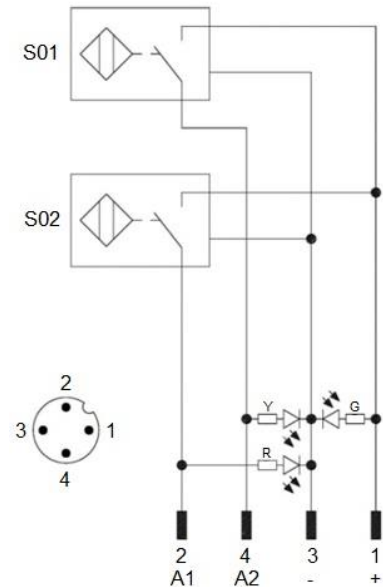
技术参数 (P+F):

- 输出类型: PNP;
- 输入电压: 10-30 VDC;
- 最大换向电流: 200 mA;
- 消耗电流: < 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.



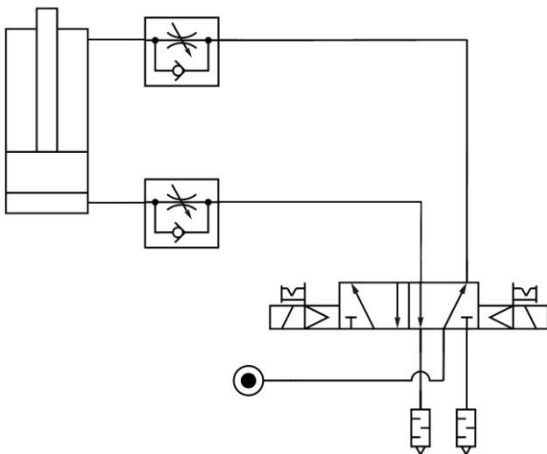
S01 = 打开信号
S01 = opening signal
S02 = 关闭信号
S02 = closing signal

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 plant.



cilindro pneumatico pneumatic cylinder	pos. chiusura closed pos.						
	pos. apertura open pos.						
segnale pos. apertura open pos. signal	1						
	0						
segnale pos. chiusura closed pos. signal	1						
	0						

工作气压 Working pressure	耗气量(5 bar) Air consumption (5 bar)
[bar]	[l]
4 - 6	0,7

备件.

Spare parts.

配套元件 # Kit	图片 Picture	描述 Description	代号 Article
密封套装 Seals kit		缸径 50 mm 的气缸密封组件 Seal components for pneumatic cylinder bore 50 mm	SCR-DCA50Z
接近开关 Proximity switch		完整电感式接近开关 Inductive proximity switch complete	3/433/C
功率放大器 Power amplifier		功率放大器带红色 LED Power amplifier red LED	3/413
传感器卫星件 Sensor's satellite		传感器卫星件 Sensor's satellite	4/417
钩子 Hook		钩子 + 滑动防焊溅保护罩 Hook + flowing weld splashes protection	HK-00000 *
定位销 Locator pin		定位销 Locator pin	LP-00000XXX **
支撑销 Top plate		支撑销 Reaction dowel	RD-00000 *
缸体 Cylinder liner		完整铝制气缸缸体 Complete pneumatic cylinder	CL-00000 *

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 - "08665"** 为钩子备件

CL - "08665" 为铝制缸体备件

RD - "08665" 为挡片备件

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

Example: **HK-"08665"** for spare hook

CL-"08665" for spare cylinder liner

RD-"08665" for spare reaction dowel

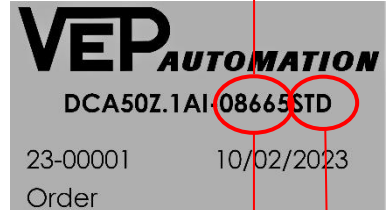
** **00000XXX** = 在产品完整代码中描述的参考编号 + 定位销表面处理工艺 .

举例: **LP - "08665STD"** 为 STD 标准渗碳抛光定位销

** **00000XXX** = reference number describe in the complete code of the

device + type of the treatment present on the locator pin.

Example: **LP - "08665STD"** for locator pin with STD treatment



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