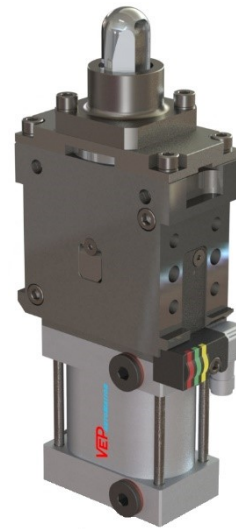


## 锁紧和定位单元（钩销缸） DCA50R.1

### Locking and holes centring device (Sub level) DCA50R.1

#### 主要特点:

- 铁制外壳
- 紧凑型设计
- 客户定制钩子，定位销和台阶面高度  
(定位销直径从  $\varnothing$  18mm -  $\varnothing$  40mm,定位销最大高度是直径的 4 倍)
- $\pm 0,15$  mm 公差补偿
- 2 个安装面 (前面和后面)
- 50mm 扁平气缸带 6 个 G1/4"接口
- 电感式接近开关: 3 个 LED 灯, M12x1 接口
- 带防焊渣防飞溅活动板



#### Main characteristics:

- Steel flanks
- Compact design
- Customized hooks, locator pins  
( $\varnothing$  min. 18mm  $\div$   $\varnothing$  max. 40mm, max height 4 times the  $\varnothing$  of the pin) and thickness plate
- $\pm 0,15$  mm tolerance compensation
- 2 mounting areas (front and rear)
- Flat pneumatic cylinder bore 50mm with 6 feeding ports G1/4"
- Inductive proximity switch: 3 LEDs, connection M12x1
- Flowing weld splashes protection



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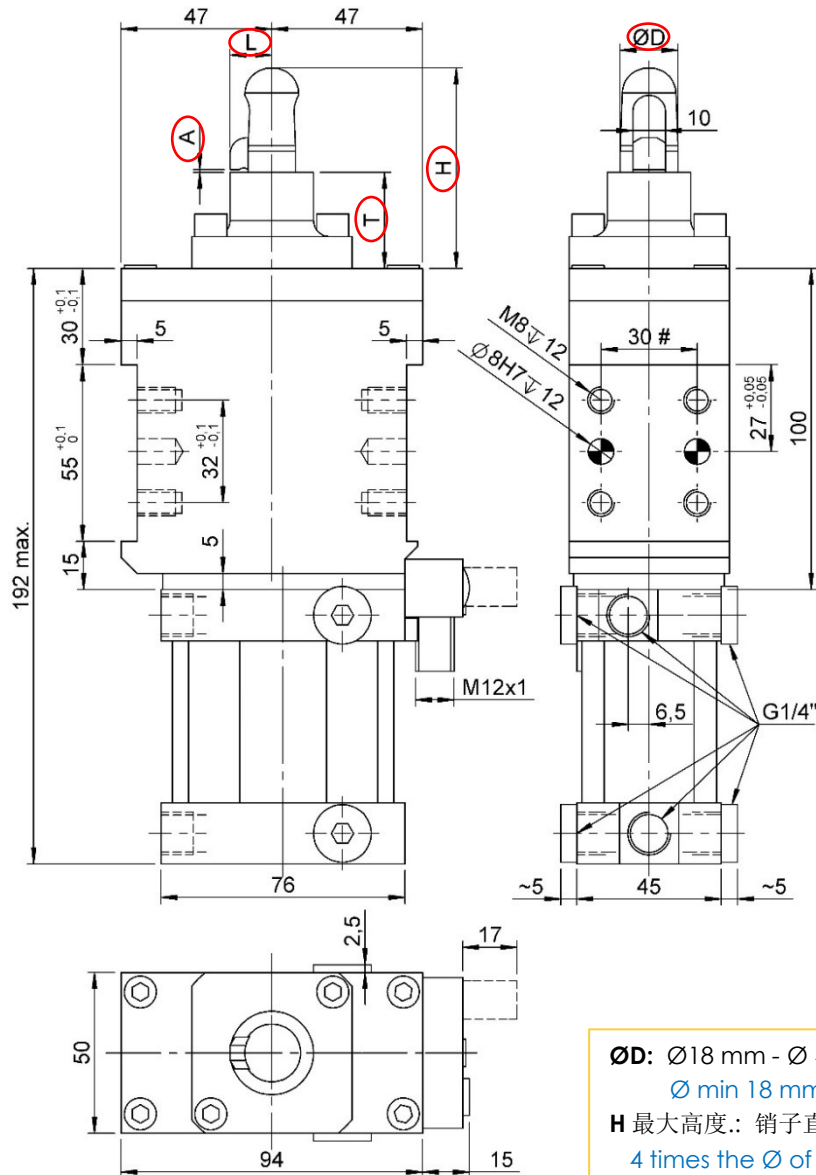
## 订货举例.

### Ordering example.

DCA50R.1	-	I	-	00000	-	STD
<p><b>Modello ed alesaggio cilindro:</b> 产品类型和气缸缸径:</p> <p><b>DCA50R</b> 50mm 钩销夹紧定位气缸 locking and holes centering device with pneumatic cylinder bore 50 mm</p> 				<p><b>产品特殊代码:</b> VEP 公司根据客户提供的信息，定制钩子、定位销和台阶面高度.</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>接近开关:</b> <b>Proximity switch:</b></p> <p><b>X:</b>不带接近开关 without proximity switch</p> <p><b>I:</b>带接近开关 proximity switch</p> 				<p><b>定位销类型:</b> <b>Type of locator pin:</b></p> <p><b>XXX:</b> 不带定位销 without locator pin</p> <p><b>NT3:</b> NT3 表面处理工艺定位销 locator pin with NT3 treatment</p> <p><b>STD:</b> 标准定位销 (表面抛光+渗碳处理) standard locator pin</p> <p><b>WCC:</b> 标准定位销带碳化钨表面处理工艺 standard locator pin with WC/C treatment</p> <p><b>DLC:</b> 定位销带类金刚石涂层表面处理工艺 locator pin with DLC treatment</p> <p>详细信息请参考第 4 页 For more information see page 4</p>		

DCA50R.1-I-00000-XXX

钩销缸, D. 50 缸径, 紧凑型设计  
Sub-Level, D. 50, compact design



ØD: Ø18 mm - Ø 40 mm  
Ø min 18 mm ÷ Ø max 40 mm  
H 最大高度.: 销子直径的 4 倍  
4 times the Ø of the pin (D)  
L 最大宽度.: 销子直径的 0.75 倍  
0.75 times the Ø of the pin (D)  
T: altezza tassello  
support height  
A: 钣金件厚度  
indicate the thickness of the sheet

**夹紧范围:**

如果工作范围不正确(±0,15), 可能会导致钩子变形.

**Clamping zone:**

A not correct working range (±0,15), could causing a hook deformation

#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	气缸缸径 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	空气耗气量 Air consumption (5 bar)
	[ mm ]	[ daN ]	[ Kg ]	[ bar ]	[ daN ]	[ l ]
DCA50R.1...	50	250	~ 3,4	6	380	0,5

## 表面处理工艺描述.

### Treatments description.

#### NT3 (表面渗氮)

NT3表面渗氮处理工艺可以达到HV1>1600(~>55HRC)的硬度和0.3mm的深度, 然后就逐渐衰减到他的自然硬度(HV~280). NT3表面处理工艺经常用于直径较小的定位销。它的颜色是灰色。

#### 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)

表面渗碳加抛光处理工艺, 硬度可以达到58-62HRC, 渗碳深度0.5mm, 然后硬度逐渐衰减。对缺口有良好的抵御性。因为表面抛光, 颜色是黑色。

#### 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处理工艺是基本STD标准定位销的基础上, 增加了碳化钨表面涂层。WCC表面处理工艺硬度可以达到(1000 ÷ 1500 HV 0.05), 厚度为0.003mm.

WCC涂层 (wc/c) 由碳化钨和非晶碳组成。它具有优异的耐磨性和较低的摩擦系数。它是减少刮伤或其他粘附现象的理想方法。它的颜色是煤灰色。

#### 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 (类金刚石涂层)

DLC类金刚石涂层表面处理工艺是基于标准定位销基础上增加了类金刚石涂层。DLC涂层拥有较高的硬度(1500 ÷ 2500 HV 0.05), 涂层厚度为0.003mm.DLC处理工艺由SP2碳(石墨)和SP3碳(金刚石)组成。它具有很高的耐磨性和很低的摩擦系数。它是减少或消除磨损、刮伤和粘附现象的理想选择。它的颜色是闪亮的黑色

#### 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> 20mm 优先选择 **STD/WCC/DLC**  
For locator pins with diameter > 20 mm is preferred to use the type **STD/WCC/DLC**
- 定位销直径 ≤ 20mm 组件的功能只能通过选择 NT3 来保证  
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.

## 电感式接近开关图表 (代码. 08157/R/C).

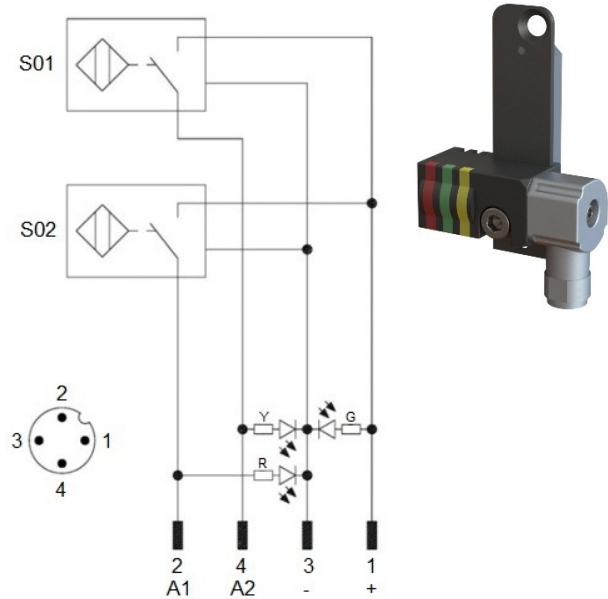
### Diagram for Inductive proximity switch (cod. 08157/R/C).

#### 技术数据 (P+F):

- 输出类型: PNP
- 供电电压: 10-30 VDC;
- 最大换向电流: 200 mA;
- 电源供应: < 25 mA;
- 电压差: < 2 V
- 温度范围: -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.



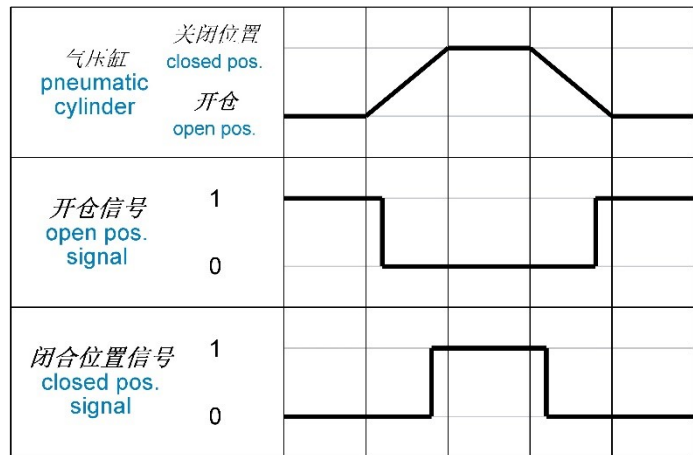
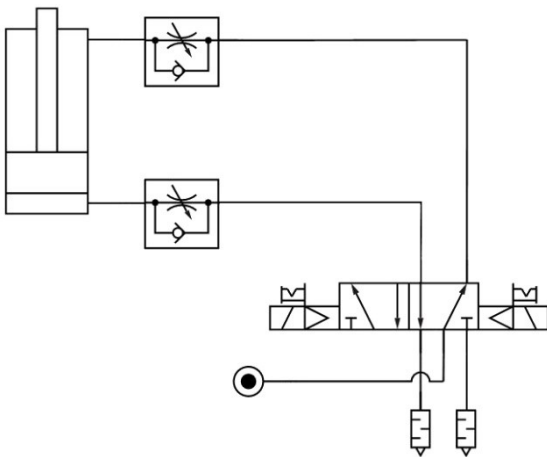
S01 = 打开信号  
S01 = opening signal  
S02 = 夹紧信号  
S02 = closing signal

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



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

备件.

## Spare parts.

# Kit	图片 Picture	描述 Description	代号 Article
密封圈组件 Seals kit		50 mm气缸缸体密封组件 Seal components for pneumatic cylinder bore 50 mm	SCR-DCA50R.1
接近开关 Proximity switch		电感式接近开关 Inductive proximity switch	08157/R/C
钩子 Hook		钩子+活动焊渣保护板 Hook + flowing weld splashes protection	HK-00000 *
定位销 Locator pin		定位销 Locator pin	LP-00000XXX **
气缸铝壳体 Cylinder liner		气缸铝壳体 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 - "10081" 为钩子备件

CL - "10081" 气缸铝壳体

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

Example: HK - "10081" for spare hook

CL - "10081" for spare cylinder liner

\*\* 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 - "10081NT3" 为NT3表面处理的定位销.

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

Example: LP - "10081NT3" for locator pin with NT3 treatment

