

120圆孔卡盘配120B/JZ后卡 (卡爪夹持范围示意图)  
120A Front chuck + 120B/JZ rear chuck jaws clamping instruction

序号 Item	类型 Type	截面形状 Sectional shape	前后标准卡爪许用尺寸范围 Standard jaws processing range	前卡标准双滚轮偏心轴卡爪 Standard double roller jaws	后卡标准内夹外撑卡爪 Rear chuck inner clamp/outer push jaws 卡爪内夹宽度Jaw length: 84mm 夹持20mm以下管材需将夹片拆下 Clamping of tubes up to 20 mm requires the removal of the clamping plate.	后卡档位更换 Rear chuck stroke change
1	圆管 Round tube		min~ max D (mm) : 10~120 ★: φ10-φ120	 夹持圆管 Clamp Round tube φ10-φ120	 内夹Inner Clamp: 一档Slot 1: 10-45mm 二档Slot 2: 40-80mm  Outer push: 一档Slot 1: 45-85mm 二档Slot 2: 80-120mm	
2	矩形管 Rectangular tube		min~ max a (mm) : 10~80 ★: □10*10-□80*80	 夹持矩形管边长 Clamp Rectangular tube □10*10-□80*80	 内夹Inner Clamp: 一档Slot 1: 10-45mm 二档Slot 2: 40-80mm  Outer push: 一档Slot 1: 45-85mm 二档Slot 2: 80-120mm	
3	椭圆管 平椭圆形管 Oval tube		椭圆管因管材的特殊性, 请发送具体尺寸图纸, 戴芮珂根据具体尺寸设计相应卡爪 For better clamping effect, please provide detailed drawing then we can design the jaws accordingly.			
4	工字钢 I beam		min a (mm) : 10 max b (mm) : 80 ★max: 8#	 夹持工字钢: Clamp I beam 5-8#	 二档Slot 2: 内夹Inner Clamp 5-8#	
5	槽钢 U beam		min a (mm) : 10 max b (mm) : 80 ★max: 8#	 夹持槽钢: Clamp U beam 5-8#	 二档Slot 2: 内夹Inner Clamp 5-8#	
6	等边角钢 Equal angle steel		min~max a (mm) : 10~80 ★max: 8#	 夹持等边角钢: Clamp Equal angle steel 边长Length: 10-80mm	 一档 Slot 1: 内夹Inner Clamp 10-45mm 二档Slot 2: 内夹Inner Clamp 40-80mm	
7	不等边角钢 Unequal angle steel		min~max a (mm) : 10~50 min~max b (mm) : 80~80 ★max: 8/5#	 夹持不等边角钢: Clamp Unequal angle steel 短边长 Short side: 10-50mm 长边长 Long side: 10-80mm	 一档 Slot 1: 内夹Inner Clamp 10-45mm 二档Slot 2: 内夹Inner Clamp 40-80mm	

备注Remark:

- 1、此为标准卡盘, 成套承重在80KG, 夹持壁厚要求≥1mm; Standard chuck load capacity is 80KG, tube thickness should be ≥1mm;
- 2、选择标准: GB/T3094-2000冷拔异型钢管, GB/T706-2008热轧型钢, GB/T17395-2008无缝钢管; GB/T17395-2008无缝钢管 Tube range: GB/T3094-2000, GB/T706-2008, GB/T17395-2008;
- 3、超出以上规格的材质或非标准截面的型材能否加工请与戴芮珂技术人员确认。Please contact Dairuike in terms of non-standard or over-sized profiles.