

240FS前卡配220JZ后卡卡爪夹持范围示意图
240FS Front chuck + 220JZ rear chuck jaws clamping instruction

序号 Item	类型 Type	截面形状	前后标准卡爪许用尺寸范围 Standard jaws processing range	前卡标准双滚轮卡爪 Standard double roller jaws 窄卡爪滚轮长度Narrow roller length: 115mm 宽卡爪滚轮长度Wide roller length: 245mm	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: 36mm	后卡标准矩形管卡爪 Rear chuck rectangular jaws 卡爪长度Jaw length: 150mm	后卡选配槽钢工字钢卡爪(Optional) 短卡爪长度High jaw length: 36mm 长卡爪长度Low jaw length: 210mm	后卡档位更换 Rear chuck stroke change	
1	圆管 Round tube		min~max D (mm) : 10~230 ★: phi10~phi230	 夹持圆管 Round tube phi10~phi230mm	 内夹Inner Clamp: 一档Slot 1: 10-95mm 二档Slot 2: 50-135mm 外撑Outer push: 一档Slot 1: 95-180mm 二档Slot 2: 135-230mm	 一档 Slot 1: 36-110mm 二档 Slot 2: 65-150mm	/		
2	方管 Square tube		min~max a (mm) : 10~230 min~max b (mm) : 10~230 ★: □10x10~□230x230	 夹持方管边长: Square tube 10-230mm	 内夹Inner Clamp: 一档Slot 1: 10-95mm 二档Slot 2: 50-135mm 外撑Outer push: 一档Slot 1: 95-180mm 二档Slot 2: 135-230mm	 一档 Slot 1: 36-110mm 二档 Slot 2: 65-150mm	/		
3	矩形管 Rectangular tube		min~max a (mm) : 10~230 min~max b (mm) : 10~230 ★: □10x10~□230x230	 夹持矩形管边长: Rectangular tube 10-230mm	 内夹Inner Clamp: 一档Slot 1: 10-95mm 二档Slot 2: 50-135mm 外撑Outer push: 一档Slot 1: 95-180mm 二档Slot 2: 135-230mm	 一档 Slot 1: 36-110mm 二档 Slot 2: 65-150mm	小卡爪仅装在一档 大卡爪仅装在一档 Small jaw only on slot 1, big jaw only on slot 1; 短边 Short side: 36-110mm 长边 Long side: 100-200mm		
4	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, 戴内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.						
5	工字钢 I beam		min a (mm) : 10 max b (mm) : 200 ★: 10-20#	 夹持工字钢: I beam 10-20#	/	 一档 Slot 1: 5-10# 二档 Slot 2: 8-14#	 小卡爪仅装在一档 大卡爪仅装在一档 Small jaw only on slot 1, big jaw only on slot 1; 10-20#		
6	槽钢 U beam		min a (mm) : 10 max b (mm) : 200 ★: 5-20#	 夹持槽钢: U beam 5-20#	/	 一档 Slot 1: 5-10# 二档 Slot 2: 8-14#	 小卡爪仅装在一档 大卡爪仅装在一档 Small jaw only on slot 1, big jaw only on slot 1; 10-20#		
7	等边角钢 Equal angle steel		min~max a (mm) : 10~110 ★: 2-11#	 夹持等边角钢: Equal angle steel 边长Length: 10-110mm	/	 一档 Slot 1: 36-110mm 二档 Slot 2: 65-140mm	/		
8	不等边角钢 Unequal angle steel		min~max a (mm) : 10~110 min~max b (mm) : 10~240 ★: 2.5/1.6-18/11#	 夹持不等边角钢: Unequal ange steel 短边长 Short side: 10-110mm 长边长 Long side: 10-240mm	/	 一档 Slot 1: 36-110mm 二档 Slot 2: 65-140mm	/		

备注Remark:

- 1、此为标准卡盘, 成套承重在260KG, 夹持壁厚要求≥1mm Standard chuck load capacity is 260KG, 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 Tube range: GB/T3094-2000, ,GB/T706-2008, GB/T17395-2008;
- 3、超出以上规格的型材或非标准截面的型材能否加工请与戴内珂技术人员确认Please contact Dairuike in terms of non-standard or over-sized profiles.