

360FS前卡配360JL后卡卡爪夹持范围示意图  
360FS Front chuck + 360JL rear chuck jaws clamping instruction

序号 Item	类型 Type	截面形状		前卡标准双滚轮卡爪 Standard double roller jaws 窄滚轮长度Narrow roller length: 142mm 宽滚轮长度Wide roller length: 370mm	后卡标准内夹外撑卡爪 Rear chuck inner clamp/outer push jaws	后卡标准矩形管卡爪 Rear chuck rectangular jaws 高卡爪长度High jaw length: 134mm 矮卡爪长度Low jaw length: 324mm	后卡一对L形小卡爪 Rear chuck small jaws pair L shape	后卡档位更换 Rear chuck stroke change
1	圆管 Round tube		min~max D (mm) : 20~360 ★: φ20-φ360	 夹持圆管直径: Round tube φ20-φ360mm	 内夹Inner Clamp: 一档Slot 1: 20-115mm 二档Slot 2: 95-190mm 三档Slot 3: 185-285mm 外撑Outer push: 一档Slot 1: 95-190mm 二档Slot 2: 165-265mm 三档Slot 3: 260-360mm	 一档 Slot 1: 45-115mm 二档 Slot 2: 95-190mm 三档Slot 3: 185-285mm	/	
2	方管 Square tube		min~max a (mm) : 20~360 ★: □20~□360	 夹持方管边长: Square tube 20-360mm	 内夹Inner Clamp: 一档Slot 1: 20-115mm 二档Slot 2: 95-190mm 三档Slot 3: 185-285mm 外撑Outer push: 一档Slot 1: 95-190mm 二档Slot 2: 165-265mm 三档Slot 3: 260-360mm	 一档 Slot 1: 45-115mm 二档 Slot 2: 95-190mm 三档Slot 3: 185-285mm	/	
3	矩形管 Rectangular tube		min~max a (mm) : 20~360 min~max b (mm) : 20~360 ★: □20x20~□360x360	 夹持矩形管边长: Rectangular tube 20-360mm	 内夹Inner Clamp: 一档Slot 1: 20-115mm 二档Slot 2: 95-190mm 三档Slot 3: 185-285mm 外撑Outer push: 一档Slot 1: 95-190mm 二档Slot 2: 165-265mm 三档Slot 3: 260-360mm	 一档 Slot 1: 45-115mm 二档 Slot 2: 95-190mm 三档Slot 3: 185-285mm	/	
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.					
5	工字钢 I beam		min a (mm) : 45 max b (mm) : 320 ★: 10-32#	 夹持工字钢: I beam 10-36#	/	 一档 Slot 1: 10# 二档 Slot 2: 12-18# 三档Slot 3: 20-28#	 小卡爪仅装在三档 大卡爪仅装在三档 Small jaw only on slot 3, big jaw only on slot 2: 24-32#	
6	槽钢 U beam		min a (mm) : 45 max b (mm) : 320 ★: 10-32#	 夹持槽钢: U beam 5-36#	/	 一档 Slot 1: 10# 二档 Slot 2: 10-18# 三档Slot 3: 20-28#	 小卡爪仅装在三档 大卡爪仅装在一档 Small jaw only on slot 3, big jaw only on slot 1: 24-32#	
7	等边角钢 Equal angle steel		min~max a (mm) : 45~130 ★: 4.5-12.5#	 夹持等边角钢: Equal angle steel 边长Length: 20-125mm	/	 一档 Slot 1: 4.5-11# 二档 Slot 2: 12.5#	/	
8	不等边角钢 Unequal angle steel		min~max a (mm) : 45-125mm min~max b (mm) : 45-200mm ★: 7/4.5-20/12.5#	 夹持不等边角钢: Unequal angle steel 短边长 Short side: 20-130mm 长边长 Long side: 20-200mm	/	 一档 Slot 1: 4.5-11# 二档 Slot 2: 8-18# 三档Slot 3: 11~20#	/	

备注Remark:

- 1、此为标准卡盘, 成套承重在1000KG, 夹持壁厚要求≥2mm Standard chuck load capacity is 1000KG, tube thickness should be ≥2mm;
- 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芮珂技术人员确认Please contact Dairuik in terms of non-standard or over-sized profiles.