

# ASC 空壓轉角缸



## Air Swing Clamp Cylinder

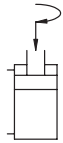
• Bore:  $\phi 25$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>

### 產品簡介

- 本產品適用於量產零件之專用機及MC治具，提高生產效率最佳幫手。
- 主要功能為空壓缸作動時，活塞下壓行程中壓板會旋轉到設計的角度，再沿著直線繼續下壓直到壓板夾緊工件。
- 建議使用空壓轉角缸，A,B入氣口請加裝流量控制閥，避免速度過快，以及轉角行程中，請勿夾持工件，導致損壞缸體及內部零件。
- 壓板需增加長度時，請勿大於原長之1.5倍。
- 缸體材質採用鋁合金，表面硬膜處理，內壁表面光滑，使用壽命長。

### Product Introduction

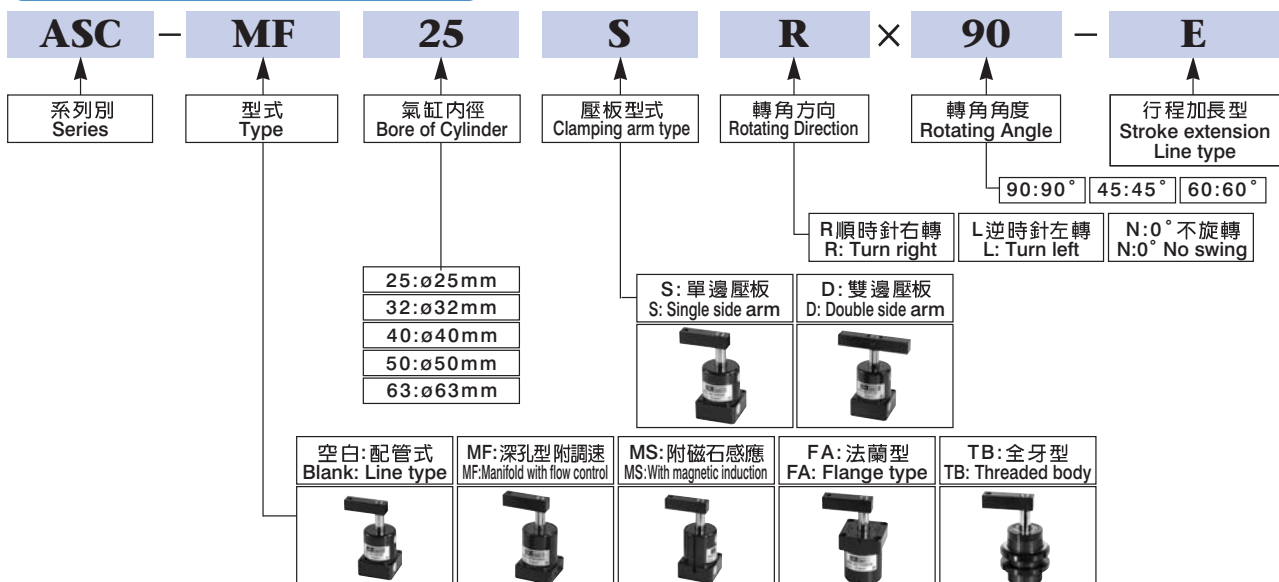
- The product is ideal for mass production on a special purpose machine and jig on machining center. It will greatly upgrade production efficiency.
- When the air cylinder actuate, and the piston moves downward, the clamping arm will swing to a rated angle! Then it lowers until the workpiece is clamped securely.
- To avoid too fast motion a flow control valve is suggested to connect to the air inlet ports (A, B) on the swing clamp cylinder. Do not clamp workpiece while the clamp is swinging to avoid damaging on the cylinder barrel and internal parts.
- When increasing length of clamping arm is required, be sure do not exceed 1.5 times of the original length.
- The cylinder body is manufactured from aluminum alloy. Surface is hard membrane treated for maximum smoothness on inside surface and long service life.



### 特性資料 Specifications

氣缸內徑	Bore of cylinder	mm	$\phi 25$	$\phi 32$	$\phi 40$	$\phi 50$	$\phi 63$
活塞桿徑	Piston rod diameter	mm	$\phi 14$	$\phi 16$	$\phi 16$	$\phi 20$	$\phi 20$
轉角行程	Swing stroke	mm	9	11	11	13	13
垂直行程 標準/加長	Clamping stroke std/extension	mm	13	15 / 30	15 / 30	17 / 34	17 / 34
受壓面積 拉入/推出	Pressure area pull/push	cm <sup>2</sup>	3.37 / 4.91	6.03 / 8.04	10.56 / 12.57	16.49 / 19.63	28.03 / 31.17
理論夾持力	Theoretical clamping force	6kg/cm <sup>2</sup>	20	36	63	99	168
使用流體	Fluid	已濾清之壓縮空氣 Filtered air					
最大操作壓力	Max operation pressure	10Kg/cm <sup>2</sup>					
操作壓力範圍	Operation pressure range	1-7Kg/cm <sup>2</sup>					
轉角方向	Rotating direction	順時針右轉R或逆時針左轉L Turn right R or turn left L					
轉角角度	Rotating angle	標準角度90 選擇角度0°, 45°, 60° Standard angle 90°, Optional angle 0°, 45°, 60°					
作動方式	Acting type	複動式 Double acting					

### 訂購標示法 Ordering Code



# ASC 空壓轉角缸

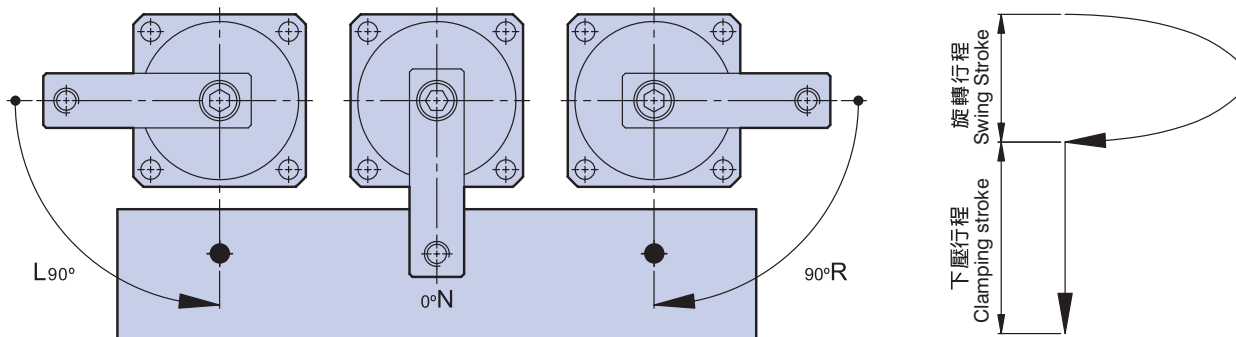


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• Bore:  $\phi 25$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>

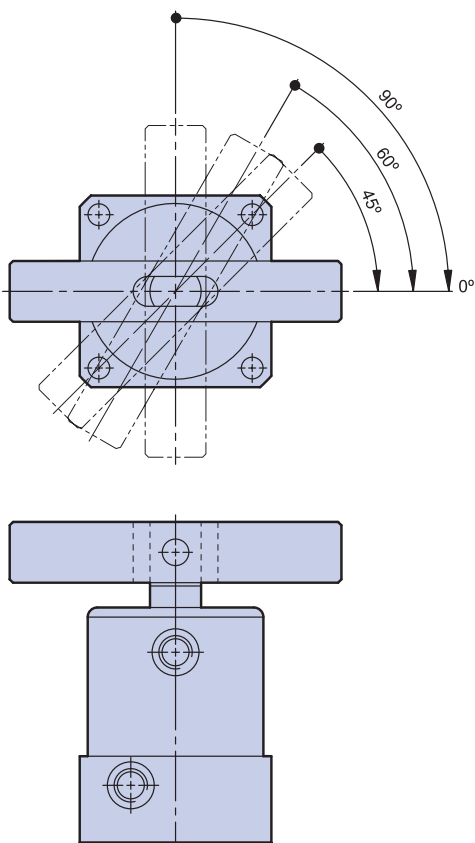
### 單邊壓板旋轉示意圖

#### Single Side Swing Clamp



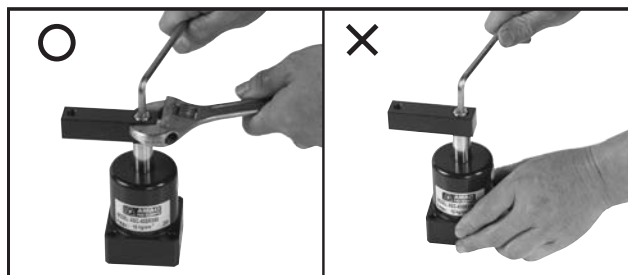
### 雙邊壓板旋轉示意圖

#### Double Side Swing Clamp



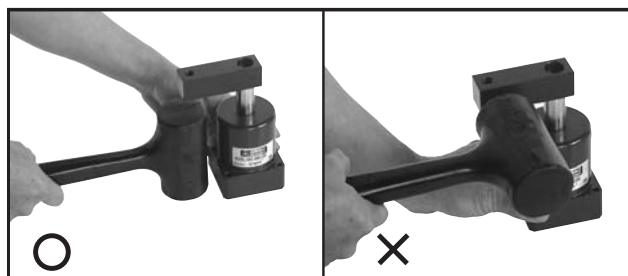
### 壓板鎖緊操作方式

#### Clamping Arm Mounting Methods



### 壓板拆卸操作方式

#### Clamping Arm Removing Methods

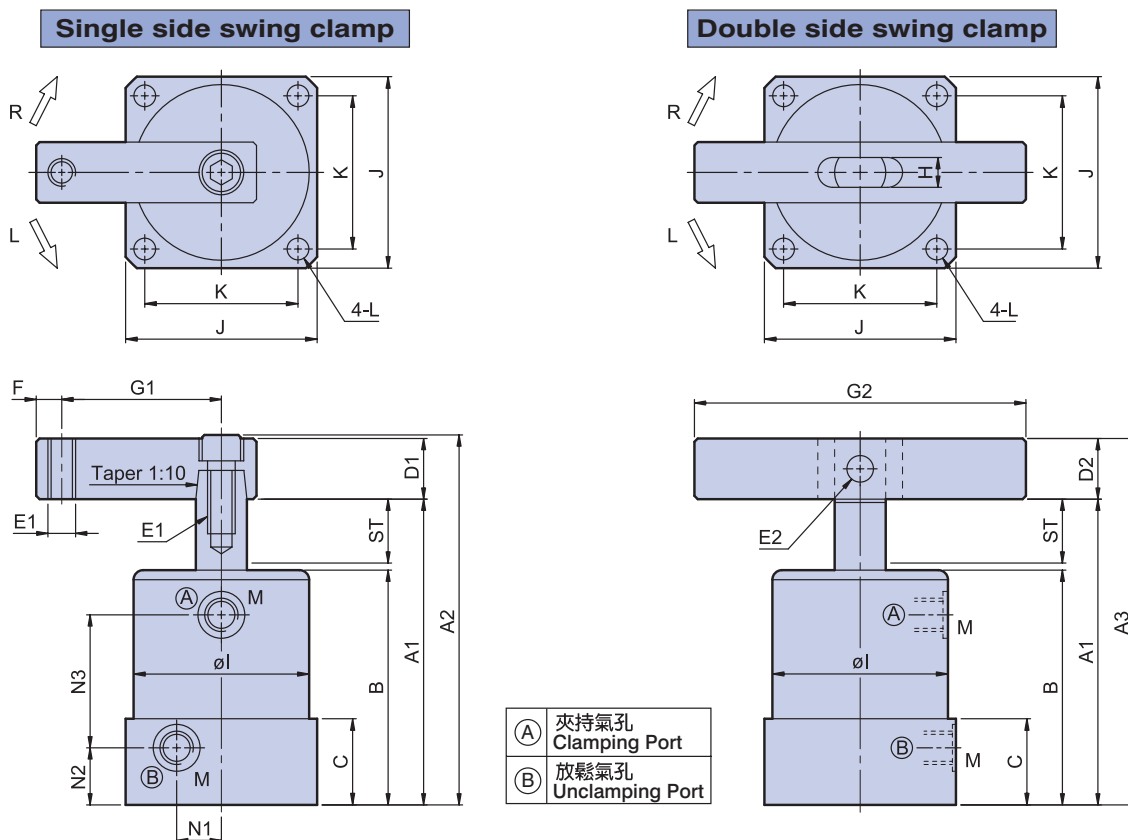


# ASC 空壓轉角缸 Line type



## Air Swing Clamp Cylinder

• Bore:  $\phi 25$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>



### Dimensional table

UNIT:mm

ITEM \ MODEL	ASC-25	ASC-32		ASC-40		ASC-50		ASC-63	
ST:Swing/Clamping	22:9/13	26:11/15	41:11/30	26:11/15	41:11/30	30:13/17	47:13/34	30:13/17	47:13/34
A1	89	108	138	108	138	124	158	124	158
A2	(105.9)	(128)	(158)	(128)	(158)	(150.4)	(184.4)	(150.4)	(184.4)
A3	—	127	157	127	157	146.2	180.2	146.2	180.2
B	65	78	93	78	93	90	107	90	107
C	23	28		28		31		31	
D1	□15.9	□19		□19		□25.4		□25.4	
D2	—	□19		□19		□22.2		□22.2	
E1	M6 x 1.0	M8 x 1.25		M8 x 1.25		M10 x 1.5		M10 x 1.5	
E2	—	ø8		ø8		ø8		ø8	
F	6	8		8		10		10	
G1	35	50		55		60		70	
G2	—	140		140		160		160	
H	—	9		9		10		10	
øI	ø35	ø46		ø55		ø65		ø78	
J	38	50		60		70		83	
K	30	40		48		57		67	
L	ø4.6	ø5.6		ø6.8		ø6.8		ø9	
M	M5 x 0.8	G1/8		G1/8		G1/8		G1/8	
N1	8	11.5		14		17		20	
N2	16.5	19		19		21		21	
N3	39.5	45	60	45	60	54	71	54	71

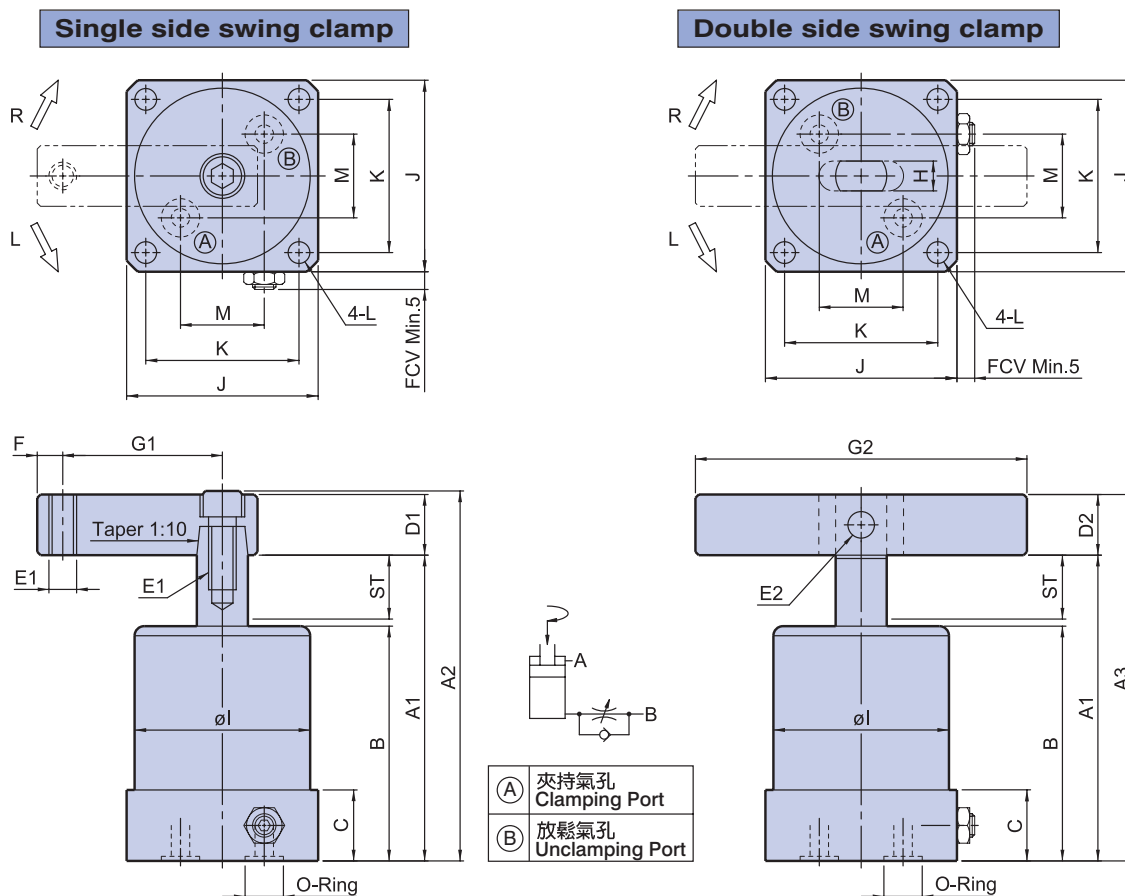
# ASC 空壓轉角缸 MF 深孔型附調速

Manifold with flow control



## Air Swing Clamp Cylinder MF

• Bore:  $\phi 32$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>



### Dimensional table

UNIT:mm

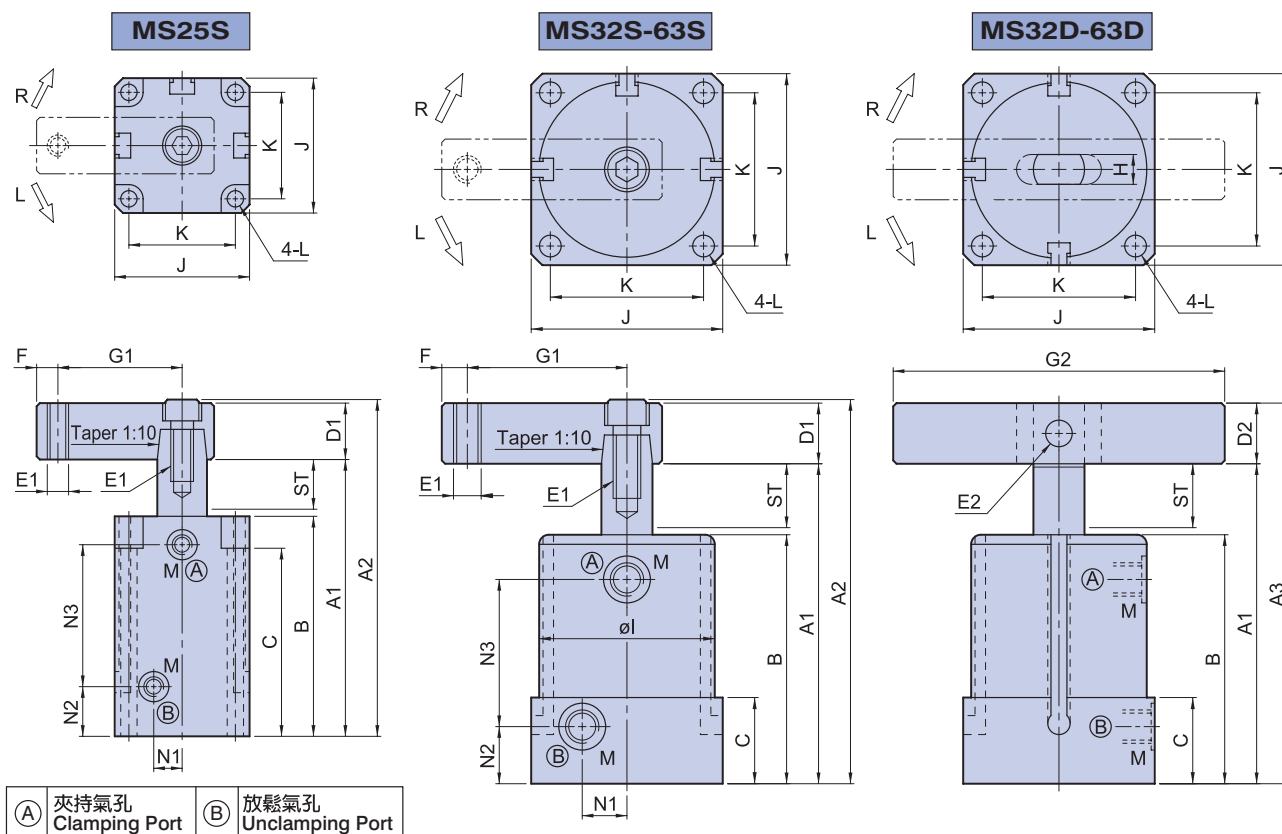
ITEM \ MODEL	ASC-MF32	ASC-MF40	ASC-MF50	ASC-MF63
ST:Swing/Clamping	26:11/15	26:11/15	30:13/17	30:13/17
A1	108	108	124	124
A2	(128)	(128)	(150.4)	(150.4)
A3	127	127	146.2	146.2
B	78	78	90	90
C	22	22	25	25
D1	□19	□19	□25.4	□25.4
D2	□19	□19	□22.2	□22.2
E1	M8 x 1.25	M8 x 1.25	M10 x 1.5	M10 x 1.5
E2	$\phi 8$	$\phi 8$	$\phi 8$	$\phi 8$
F	8	8	10	10
G1	50	55	60	70
G2	140	140	160	160
H	9	9	10	10
$\phi l$	$\phi 46$	$\phi 55$	$\phi 65$	$\phi 78$
J	50	60	70	83
K	40	48	57	67
L	$\phi 5.6$	$\phi 6.8$	$\phi 6.8$	$\phi 9$
M	19	23	28	32
O-Ring	P7	P7	P9	P9

# ASC 空壓轉角缸 MS附磁石感應 With magnetic induction



## Air Swing Clamp Cylinder MS

• Bore:  $\phi 25$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>



### Dimensional table

UNIT:mm

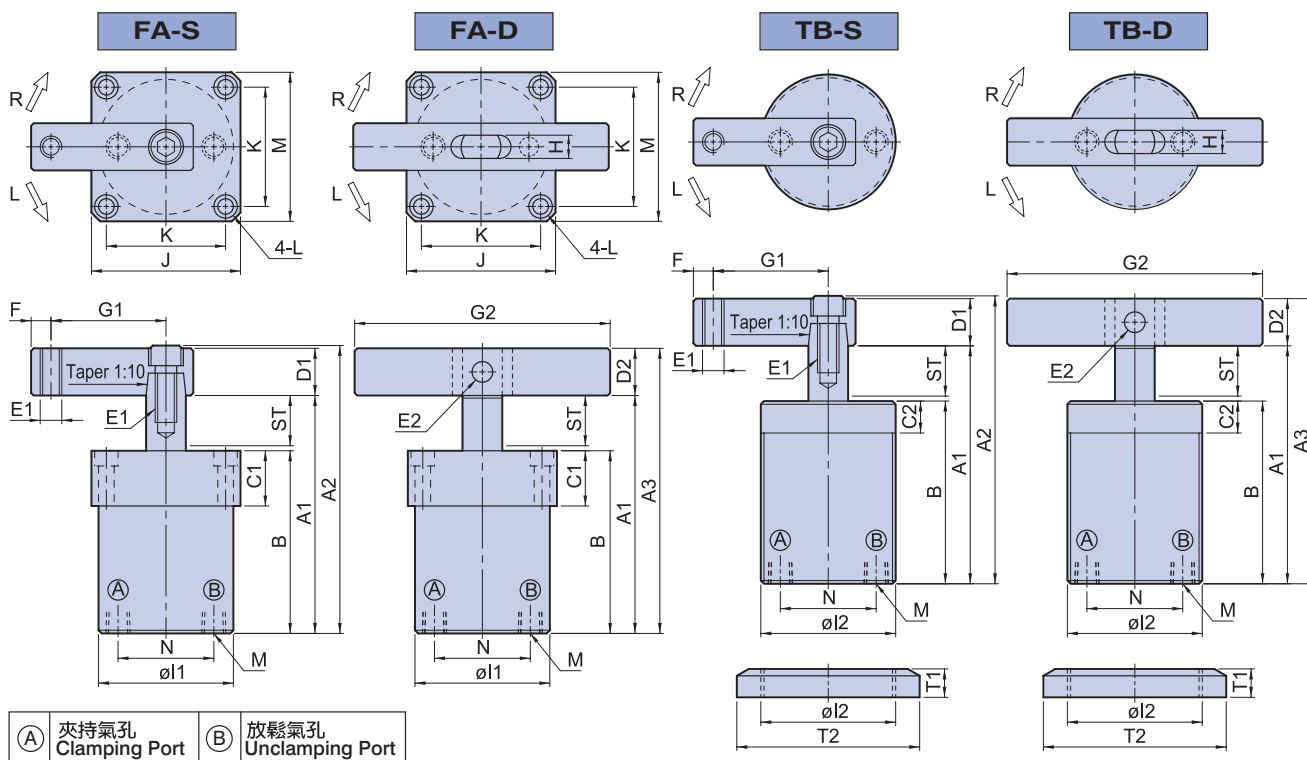
ITEM \ MODEL	ASC-MS25	ASC-MS32	ASC-MS40	ASC-MS50	ASC-MS63
ST: Swing/Clamping	22:9/13	26:11/15	26:11/15	30:13/17	30:13/17
A1	94	113	113	129	129
A2	(110.9)	(133)	(133)	(155.4)	(155.4)
A3	—	132	132	151.2	151.2
B	70	83	83	95	95
C	60	28	28	31	31
D1	□15.9	□19	□19	□25.4	□25.4
D2	—	□19	□19	□22.2	□22.2
E1	M6 x 1.0	M8 x 1.25	M8 x 1.25	M10 x 1.5	M10 x 1.5
E2	—	$\phi 8$	$\phi 8$	$\phi 8$	$\phi 8$
F	6	8	8	10	10
G1	35	50	55	60	70
G2	—	140	140	160	160
H	—	9	9	10	10
$\phi l$	$\phi 35$	$\phi 46$	$\phi 55$	$\phi 65$	$\phi 78$
J	38	50	60	70	83
K	30	40	48	57	67
L	$\phi 4.6$	$\phi 5.6$	$\phi 6.8$	$\phi 6.8$	$\phi 9$
M	M5 x 0.8	G1/8	G1/8	G1/8	G1/8
N1	8	11.5	14	17	20
N2	16.5	19	19	21	21
N3	44.5	50	50	59	59

# ASC 空壓轉角缸 FA法蘭型/TB全牙型 Flange type / Threaded body



## Air Swing Clamp Cylinder FA.TB

• Bore:  $\phi 32$ - $\phi 63$ mm • Pmax: 10kg/cm<sup>2</sup>



(A) 夾持氣孔 Clamping Port (B) 放鬆氣孔 Unclamping Port

### Dimensional table

UNIT:mm

MODEL	ASC-FA32 ASC-TB32	ASC-FA40 ASC-TB40	ASC-FA50 ASC-TB50	ASC-FA63
ITEM				
ST:Swing/Clamping	26:11/15	26:11/15	30:13/17	30:13/17
A1	108	108	124	124
A2	(128)	(128)	(150.4)	(150.4)
A3	127	127	146.2	146.2
B	78	78	90	90
C1	22	22	25	25
C2	12	12	15	—
D1	□19	□19	□25.4	□25.4
D2	□19	□19	□22.2	□22.2
E1	M8 x 1.25	M8 x 1.25	M10 x 1.5	M10 x 1.5
E2	ø8	ø8	ø8	ø8
F	8	8	10	10
G1	50	55	60	70
G2	140	140	160	160
H	9	9	10	10
ø11	ø46	ø55	ø65	ø78
ø12	M50 x 1.5	M55 x 1.5	M65 x 1.5	—
J	50	60	70	83
K	40	48	57	67
L	ø5.6-ø9 x 5.5D.	ø6.8-ø10.5 x 6.5D.	ø6.8-ø10.5 x 6.5D.	ø9-ø14 x 9D.
M	PT1/8	PT1/8	PT1/8	PT1/8
N	32	40	50	63
T1x2PCS	11	11	12	—
T2	ø70	ø75	ø85	—