专业打造一流品质
Professional build first-class quality

宁波深蓝宇机械科技有限公司
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专业打造一流品质
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- 冲床专用快速换模系统
- 射出机压铸机快速换模系统

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公司简介/INTRODUCTION

YXMC
懿行·机械

深蓝宇公司成立于2003年，主要生产自动化、省力化的各式快速换模系统。如冲床快速换模系统、射出机及压铸机快速换模系统，印刷电路板冲孔油压脱料系统，及各种自动化夹具快速换模系统。

在产品品质及功能方面已深受使用客户认同，在稳定成长的同时,深蓝宇仍不断秉持着我们的经营理念(品质荣誉、服务回馈、创新发展)研究开发符合客户需求的产品，以期能提供完整的产品给客户。

SHEN LAN YU PRECISION DARK BLUE CO.,LTD

SHEN LAN YU Was established in 2003,We specialize in the manufacture of labor saving press automation equipment for mechanical presses.

Our Quick Die Change Systems work in conjunction with various mold clamping systems for automatic punching presses, injection molding machines, die cast machines,PCB fine piercing,and die clamping systems.Quality and functionality are the hallmarks of our products,earning our press machine accessories wide acclaim throughout the industry.SHEN LAN YU is a leader in the development of new press automation equipment as we offer products on a consistent basis;and we are proud of our 12 year history of meeting and exceeding customer requirements.we offer our press automation equipment to any test.

Taken line machinery

懿行QDCS的商业效益
Benefits of YI XING QDCS

懿行QDCS提供给各式冲床模具多样性的快速换模专用元件，此系统的使用，不仅降低了冲床的间制时间，并且大大的促进了产量的提升，使得生产管理更为合理化。
the YI XING QDCS not only reduces perss downtime due to die changes,but also greatiy improves productivity and streamlines management.

直接效应 Direct Benefits

- 减少换模时间 Reduced die change time
- 多种少量的生产 Diverse products in small lots
- 减少存货 Reduced inventory
- 产量与品质改善 Improved productivity and quality
- 降低劳力成本 Reduced labor costs

间接效应 Indirect Benefits

- 模具标准化 Die standardization
- 冲床标准化 Press standardization
- 增加操作安全 Increased safety
- 达成快速产销 Prompt delivery
- 改善工作环境 Improved shop conditions & environment

以上各种效益大大增进了企业竞争能力
Efficiency and Competitiveness

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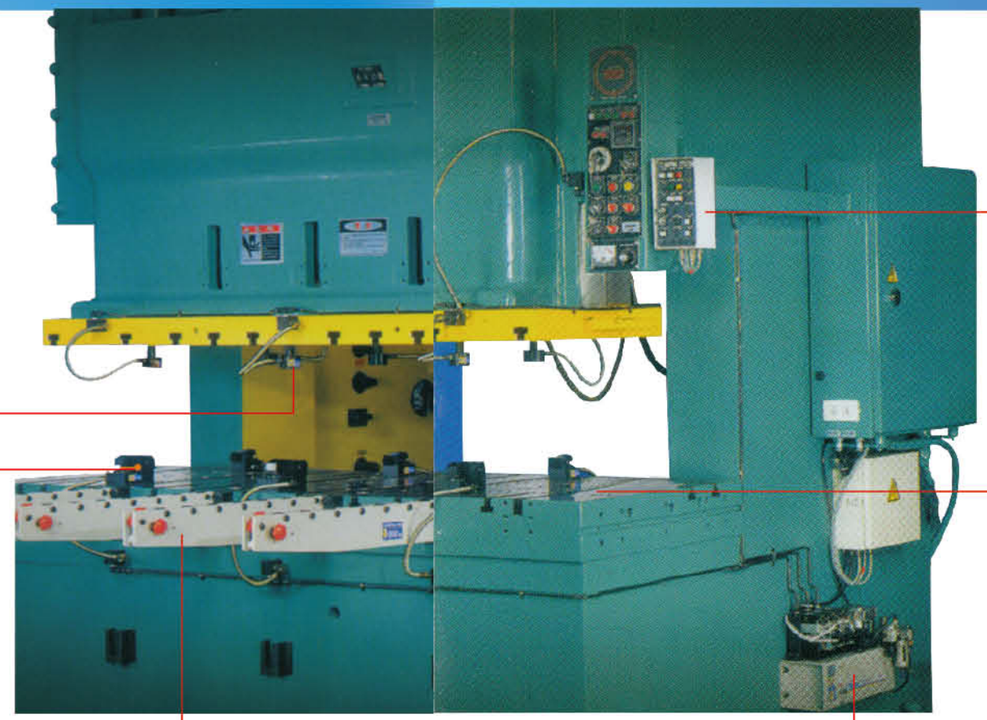
快速换模系统元件组成
QDCS Unit Introduction



操作箱/Control Panel

夹模器 /Die Clamp Series

可分TX,TY两型详述于14、15页。
TX型夹模器(直拉式)
TY型夹模器(压板式)

For details,refer to pages14and15
TX Die Clamp
TY Die Clamp

移模臂 /Die Arm Series

共有RC RD RE RF四种型式,详述于第21—25页。
RC型移模臂
RE /RF型移模臂

For details refer to pages 21—25.
RC /RD/ RE/ RF Bolster Extension Series

气动泵组合 /Power Unit

以气动方式作动，出力为油压，详见8—13页。
气动泵组合(1回路/2回路/3回路/4回路)

For details,refer to pages 8—13
power Unit Selection of system components
(1Circuit/2Circuit/3Circuit/4Circuit)

举模器 /Die Lifter Series

计有DL、DU、DB四种，详见第16—20页。
DL型举模器（油压式）
DB型举模器（滚珠式）
DR/DU型举模器（弹簧式）

For details,refer to pages 16—20.
DL Die Lifter
DB Die Lifter
DR,DU Die Lifter

Taken line machinery

组件选用基准
Selection of System Components

懿行QDCS提供了最大适用性与多样性产品，以独特的系列化设计理念，求取与冲床模具的最佳搭配，您所需求的最佳系统元件组合，可参照下列说明：

The YI XING QDCS provides maximum flexidility to accommodate diversification in presses and dies with its unique serialized design concept of componebts and equipment. For the system configuration best suited to your needs refer to the following chart:

①标准油压回路规划 Standard Hydraulic Circuit

回路数 NO.of Circuits	回路形式 Circuits Code	回路分配适用情形	System Configuration
1	C	回路使用于夹持上模	One circuit for clamping the upper die
		回路使用于夹持下模	One circuit for clamping the lower die
		回路使用于同时夹持上下模	One circuit for simultaneousiy clamping the upper and lower dies
	D	回路使用于举模器	One circuit for the lifter
2	2C	一个回路使用于夹持上模，且另一个回路使用于下模	One circuit for upper die One circuit for lower die
	CD	一个回路使用于同时夹持上模，且另一个回路使用于举模器	One circuit for simultaneousiy clamping the upper and lower dies One circuit for the lifter
3	2CD	一个回路使用于夹持上模，且另一个回路使用于下模，且第三个回路使用于举模器	Two circuit for clamping the upper and lower dies One circuit for the lifter
4	3CD	二个回路使用于夹持上模交叉方式，另一个回路使用于夹持下模，且第四个回路使用于举模器	Two circuit for clamping the upper die One circuit for clamping the lower die One circuit for the lifter

● 以上表根据回路数与回路的阀型，规划回路的分配使用情形，其中回路型式C为常开阀，D为常闭阀。
the above list is planned according to the number o f ci rcut and value plan to the necessity of the usage.
In between the circuit type"C"means ON at all time and "D"means OFF at all time

②选择夹模器 Selection of Clamps

■ 基本型式之选定
Basic Clamp Selection

模具边沿有"U"沟设计，采用TX型
模具边沿无"U"沟设计，采用TY型
Select TX Clamp when die U-slots provided
Select TY Clamp when die U-slots not provided

■ 夹模器数量
Determine the Number of Clamps Requied

根据模具的大小与冲床出力的顿数来决定
Determine the number of Clamps according to the dimensions and configuration of the dies and the T-slot arrangement on the press

■ 夹模器夹持力的计算
Determine the Clamping Force(Mode)

(夹模器总夹持力)=(冲床冲压能力20%)
(Clamping Force)=(20%press Tonnage)

■ 上下模所需夹持力的分配
Distrbution of Upper and Lower Clamping Force

(上模夹持力):(下模夹持力)=3:2
(Clamping the Upper Die):(Clamping The Lower Die)=3:2

(单一夹模器夹持力)=(上模或下模夹持力)÷夹模器数量
(Single Die Clamping Force)=(Upper or Lower Die Clamping Force)÷Clamps Number

若依据使用螺栓之规格推算夹持力，如下表：
If determine and calculate the clamping force by using the size of cap screw,pls use the list below.

螺栓规格 Screw Bolt	M16	M18	M20	M24	M30	M38
夹持力(tf) Clamping Force	3	4	6	10	15	20

上列夹模器夹持力与其数量应依据实际作业需要修正，并且供夹模之模具边沿厚度需要标准化，以利配合夹模器的使用。

The above list for the clamping force and quantities of the die clamper should be used according to the actual operation.the thickness of the mould base (bottom plate for die clamper to clamp) should be standardized

Taken line machinery

组件选用基准
Selection of System Components

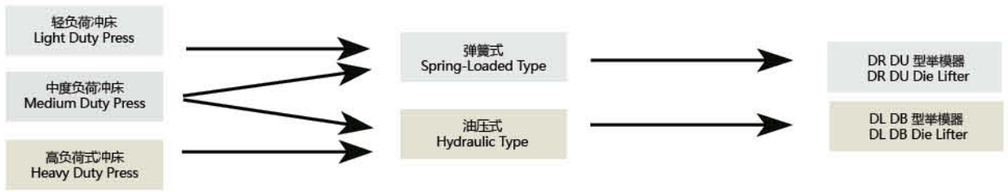
③选择举模器 Selection of Die Lifters 性能规格详载于第(16-20)页

■ 弹簧式或油压式的选定

依据冲床吨位选择DL型（油压式）或DR型（弹簧式）此外并需将模具重量与所需举模器之长度一并考量

Select Spring-loaded or Hydraulic Die Lifter

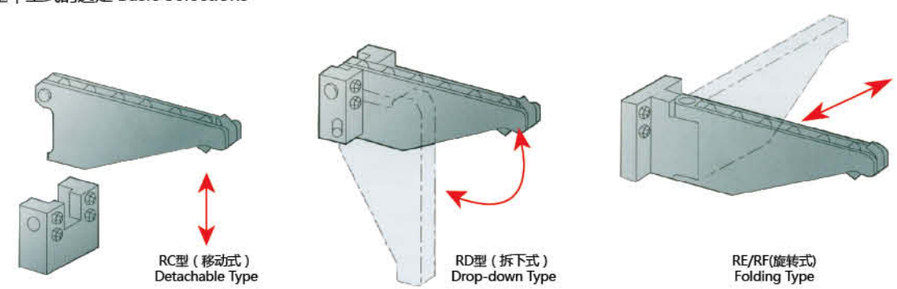
Select Spring-loaded(DR DU)or hydraulic(DL) according to the press tonnage,die weight,and the die positioning accuracy required.



选用参考基准	Selection Criteria
举模器长度	Die Lifter
举模能力	Lift Capacity
最大承载重量	Maximum Die Lifter Load Weight
U槽尺寸	U-slot Size
配管配件	Accessories

④选择移模臂 Selection of Bolster Extensions

■ 基本型式的选定 Basic Selections



选用基准	Selection Criteria
模具尺寸	Die Dimensions
移模臂最大承载重量	Maximum Bolster Extension Load Weight
型式	Type

Taken line machinery

气动泵组合选用
Power Unit-Selection of System Components

形式表示法/Selection of Systrm Components

FP 6308U — 1 — C

FP 63 08U
- 增压杆面积 Surface area of pressure increased rod
- 活塞面积 Surface area of pressure — ϕ63 / ϕ100

C:夹模器/Die Clamp
D:举模器/Die Lifter

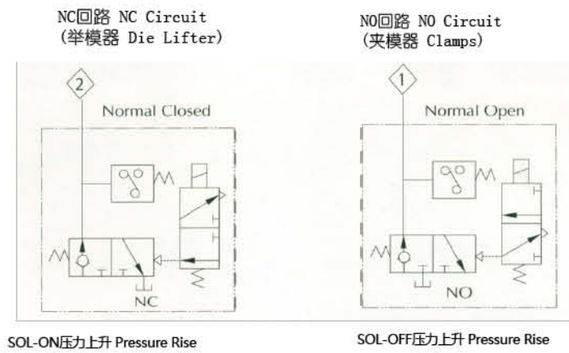
回路数 No.of Circuits	回路形式 Circuit Code	回路分配使用情况	System Configuration
1	C	回路使用于夹持上模	One circuit clamping the upper die
		回路使用于夹持下模	One circuit clamping the lower die
		回路使用于同时夹持上下模	One circuit for simultaneously ciamping the upper and lower dies
	D	回路使用于举模器	One circuit for the lifter
2	2C	一个回路使用于夹持上模，且另一个回路使用于下模	One circuit for upper die One circuit for lower die
	CD	一个回路使用于夹持下模，且另一个回路使用于举模器	One circuit for simultaneously clamping the upper and lower dies One circuit for the lifter
3	2CD	一个回路使用于夹持上模，另一个回路使用于下模，且第三个回路使用于举模器	Two circuit for clamping the upper and lower dies One circuit for the lifter
4	3CD	二个回路使用于夹持上模交叉方式，另一个回路使用于夹持下模，且第四个回路使用于举模器	Two circuits for clamping the upper die One circuit for clamping the lower die One circuit for the lifter

电压 Voltage:DC 24V，110V，220V

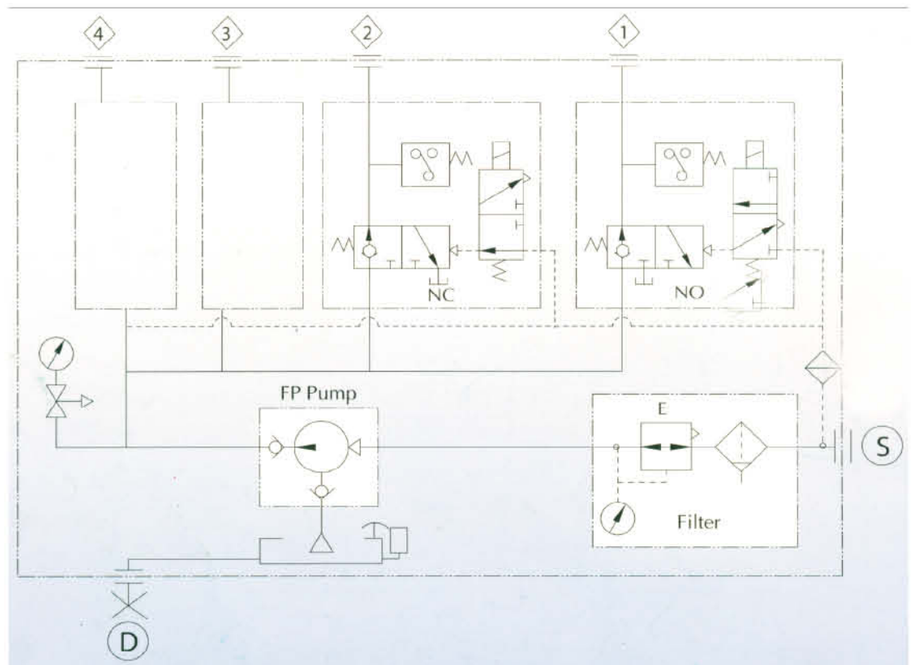
Taken line machinery

气动泵组合选用
Power Unit-Selection of System Components

油压系统回路图/Hydraulic Schematics(Typical)



回路图例 (Combined Circuit Example)



Taken line machinery

气动泵组合选用
Power Unit-Selection of System Components

FP 6308U-1-C

FP 6308U-2-2C

FP 6308U-3-2CD

FP 6308U-4-3CD

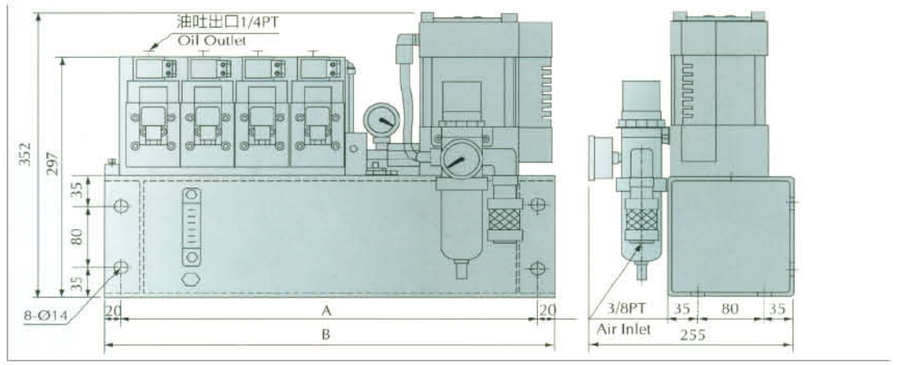
FP63	空气压力5kg/cm²时出力 AT 5kg/cm² Air Pressure	增压比 Pressure Ratio
06	420(kg/cm²)	1:84
07	300(kg/cm²)	1:60
08	250(kg/cm²)	1:50
09	200(kg/cm²)	1:40
10	150(kg/cm²)	1:30
12	100(kg/cm²)	1:20
14	80(kg/cm²)	1:16
16	50(kg/cm²)	1:10
20	40(kg/cm²)	1:8
24	26(kg/cm²)	1:5

FP 1014U-4-3CD

Taken line machinery

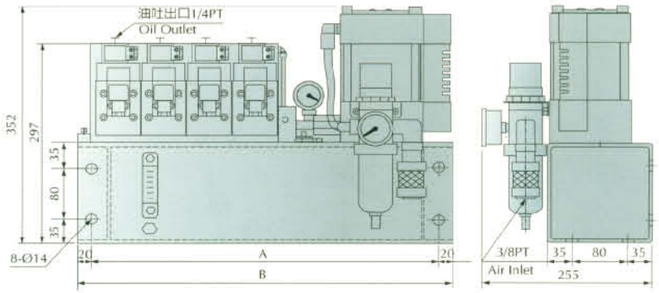
气动泵组合 外型尺寸
Hydraulic Power Units-Specifications

型号/Model:FP63 Pump



型号 Model	回路数 Total Circuits	A	B	邮箱全容量(L) Reservoir Capacity	可用容量(L) Available Lubricant	重油Weight (kg)	使用油 Lubricant
FP63□□U	1	353	393	6	4.7	23	一般液压作重油 IOS VG32-VG68 Standard hydraulic oil
FP63□□U	2	353	393	6	4.7	27	
FP63□□U	3	423	463	7.5	5.9	35	
FP63□□U	4	493	533	9	7.1	43	

型号/Model:FP100 Pump

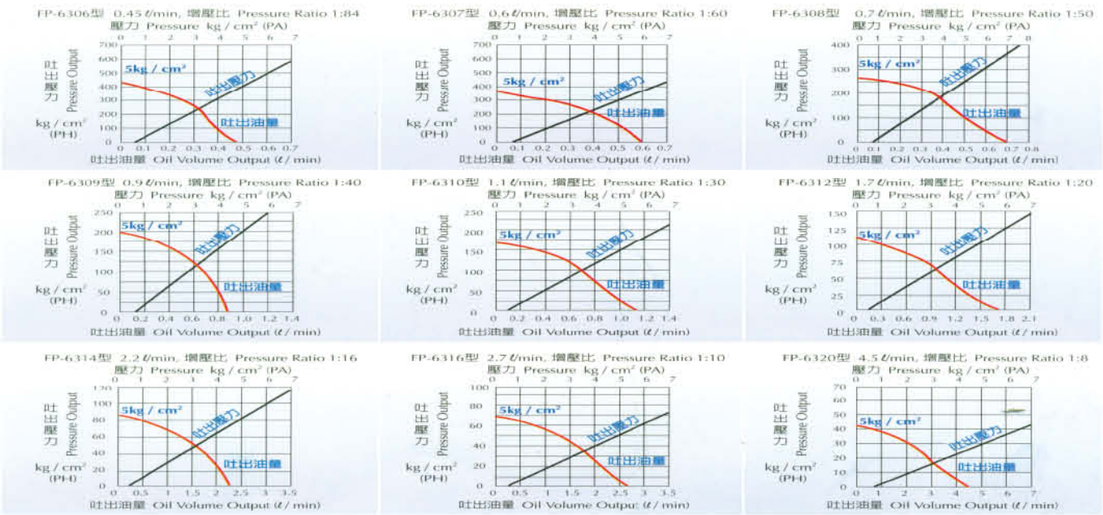


型号 Model	回路数 Total Circuits	A	B	油箱全容量(L) Reservoir Capacity	可用容量(L) available Lubricant	重量Weight (kg)	使用油 Lubricant
FP10□□U	1	353	393	6	3.8	30	一般液压作动油 ISO VG32-VG68 Standard hydraulic oil
FP10□□U	2	353	393	6	3.8	34	
FP10□□U	3	423	463	7.5	4.8	42	
FP10□□U	4	493	533	9	5.8	50	

Taken line machinery

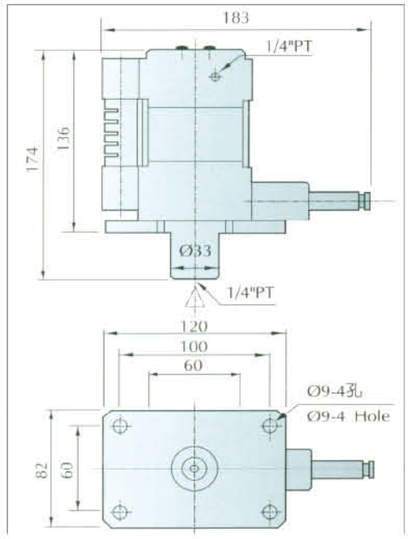
气动泵组合选用
Power Unit-Selection of System Components

L=公升



FP63规格特性Specifications

驱动流体Drive Fluid	空气 Air
空气使用压力范围Air pressure	2~6kg/cm²(2-6bar)
使用温度范围Operating Temperature	-5°~60°C
使用油 Lubricant	一般液压做重油IOS VG32-VG68 Standard hydraulic oil
单一重油 Weight	4kg



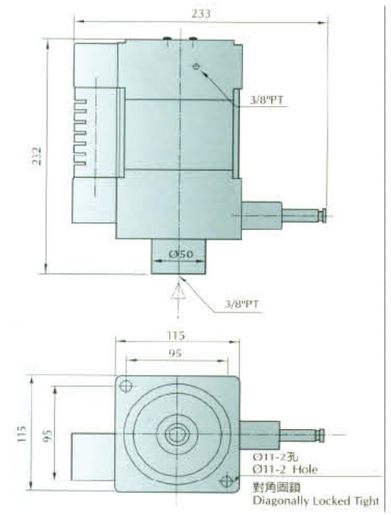
本表为压力、流量特性表提供参考
Pressure :Flow characteristics tables provided below for your reference.
(一) 空气消耗量为MAX=0.35Nm/min
Air consumption MAX=0.35Nm/min
(二) 须大流量请指示说明。
Please refer to instructions for large flow
(三) 为品质不断改良，使用前烦请电话查询确认。
Specifications are subject to change, please phone to confirm values

Taken line machinery

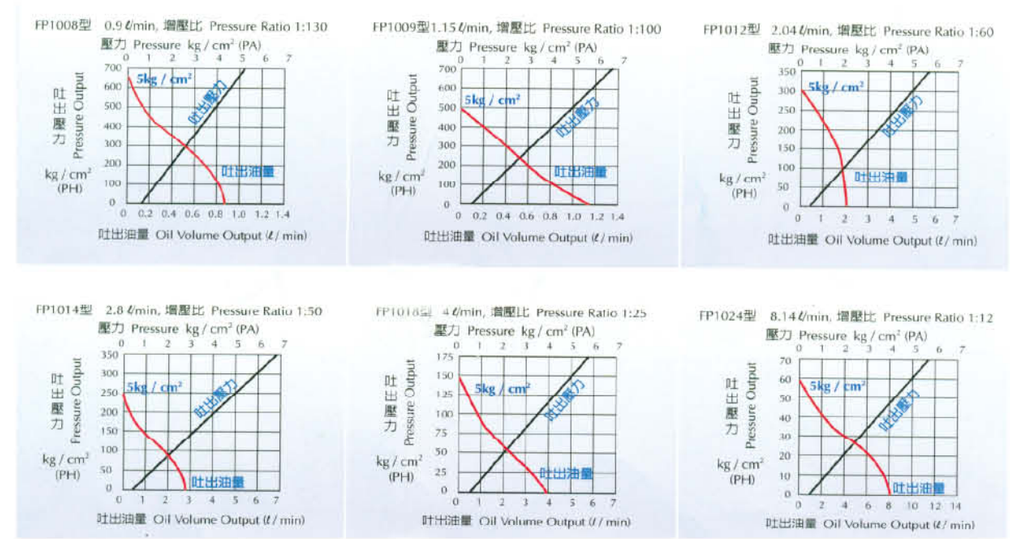
气动泵组合选用
Power Unit-Selection of System Components

FP100规格特性Specifications

驱动流体Drive Fluid	空气 Air
空气使用压力范围Air pressure	2~6kg/cm²(2-6bar)
使用温度范围Operating Temperature	-5°~60°C
使用油 Lubricant	一般液压做重油IOS VG32-VG68 Standard hydraulic oil
单一重油 Weight	11kg



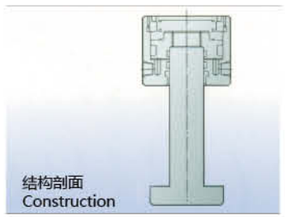
本表为压力、流量特性表提供参考
Pressure : Flow characteristics tables provided below for your reference.
(四) 空气消耗量为MAX=0.8
Air consumption
(五) 须大流量请指示说明。
Please refer to instructions for large flow
(六) 为品质不断改良，使用前烦请电话查询确认。
Specifications are subject to change, please phone to confirm values

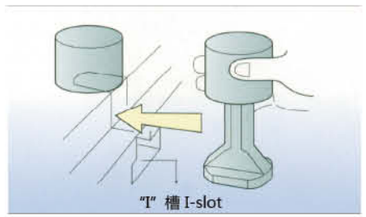


Taken line machinery

快速换模系统------TX型夹模器
QDCS—TX Die Clamp

此型夹模器有节省空间的好处，但模沿须有“U”型沟供其夹持，其底部被制成适合在台盘“T”型槽滑动。
This compact space saving, piston type clamp requires U-slots on the die shoe.The clamp leg is machined to fit the bolster The automatic slide model makes remote control possible.



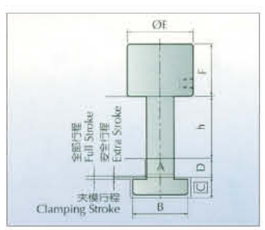


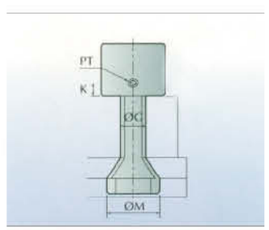
特性规格 Specifications

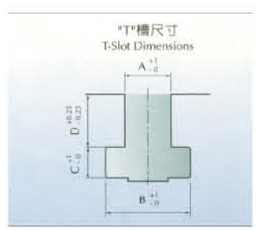
型号 Model	Unit	TX-1	TX-2	TX-4	TX-6	TX-10	TX-16	TX-25
夹持力（于油 250kg/）tons Clamping Force(at 250cm²)	tons	1	2	4	6.3	10	16	25
全部行程（X） Full Stroke	mm	5	8	8	8	8	8	8
夹模行程（Y）Clamping Stroke	mm	3	4	3	3	3	3	3
安全行程（Z）Extra Stroke	mm	2	4	5	5	5	5	5
夹模器容量（全行程）Cylinder Capacity at Full Stroke	cc.	2.7	6.5	13	21	32	54	84

（注）：安全行程为全部行程与夹模行程之差值，为特别安全预留量。
Extra Stroke is the difference value between full stroke and clamping stroke with the extra space for safe operation.

外型尺寸Dimensions







型号 Model	E	F	G	M	K	MIN.C	PT	A	B	C	D	选用泵浦 Power Unit Models
TX-1	38	37.5	14	35	11	8	1/8	22	37	16	24	FP6308U-□-□
TX-2	53	52.5	18	38	12	8	1/8	22	37	16	24	
TX-4	68	61.5	25	59	15	10	1/4	22	37	16	24	
TX-6	78	68	30	59	16	14	1/4	28	48	20	28	
TX-10	98	71	40	79	16	17	1/4	28	48	20	28	FP1014U-□-□
TX-16	127	78.5	50	88	16	17	1/4	28	48	23	28	
TX-25	148	100	60	98	15	23	1/4	36	56	25	28	

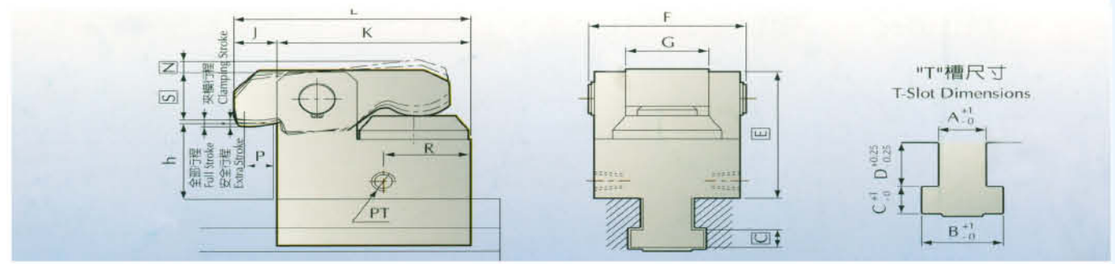
·模厚建议：25、30、35、40、45、50、55、60mm
·注：模沿厚度（h）及T槽（A.B.C.D.）尺寸如为既有（特殊）尺寸，请于订购时确认之。
Before purchase, please verify mold edge thickness (h) and T Slot(A.B.C.D.) as standard or special dimensions.

Taken line machinery

快速换模系统------TY型夹模器
QDCS—TY Die Clamp

此型夹模器以杠杆原理作用，夹持模沿，并不需“U”型沟，因此有更多宽广的适用范围。
Because this lever-type clamp does not require a U-cut on the die shoe, it may be used in a wide range of applications. The base of the clamp is machine to fit the T-slot on the bolster. The flange-mount model clamp may be bolted onto the bolster. The automatic slider model makes remote control possible.

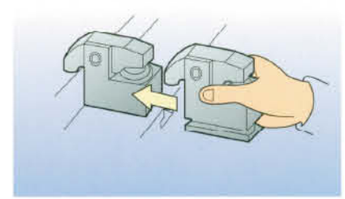
外型尺寸Dimensions

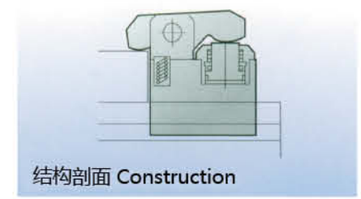


型号 Model	MIN.E	F	G	J	K	L	MAX.N	P	R	MIN.S	PT	MIN.C	A	B	C	D	选用泵浦 Power Unit
TY-1	49.5	46	20	15	58	73	10	10	19	16.5	1/8	7	22	37	16	24	FP6308U-□-□
TY-2	59	65	28	22	85	107	10	12.5	48	27	1/8	9.5	22	37	16	24	
TY-4	85	87	40	30	120	150	10	16	58	33	1/4	12	22	37	16	24	
TY-6	94	97	44	34.5	133	167.5	11	20	68	40	1/4	14	28	48	20	28	
TY-10	105	110	50	30	165	195	11	20	82	53	1/4	16.5	28	48	20	28	FP1014U-□-□
TY-16	120	130	60	35	200	235	12	20	96	67	1/4	19	28	48	23	28	
TY-25	133	152	73	35	240	275	13	20	110	81	1/4	22	36	56	25	28	

·模厚建议：25、30、35、40、45、50、55、60mm
·注：模沿厚度（h）及T槽（A.B.C.D.）尺寸如为既有（特殊）尺寸，请于订购是确认之。
Before purchase, please verify mold edge thickness (h) and T Slot(A.B.C.D.) as standard or special dimensions.

TY型夹模器





型号Model	Unit	TX-1	TX-2	TX-4	TX-6	TX-10	TX-16	TX-25
夹持力（与油 250□/）tons Clamping Force(at 250kgf/cm²)	tons	1	2	4	6.3	10	16	25
全部行程（X） Full Strok	mm	6	7	7	8	8	8	8
夹模行程（Y）Clamping Stroke	mm	3	2	3	3	3	3	3
安全行程（Z）Extra Stroke	mm	3	5	4	5	5	5	5
夹模器容量（全行程）Cylinder Capacity at Full Stroke	cc.	2	6.5	13.2	22.3	37	61	93

（注）：安全行程为全部行程与夹模行程之差值，为特别安全裕留量。
Extra Stroke is the difference value between full stroke and clamping stroke with the extra space for safe operation.

Taken line machinery

快速换模系统----DR型弹簧式举模器
QDCS-DR Die Lifter

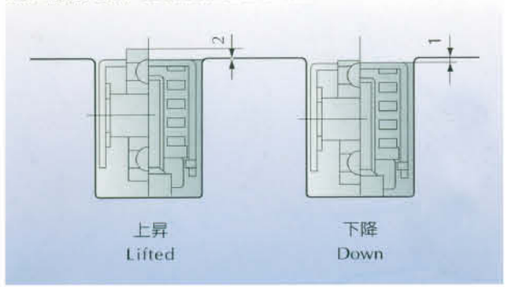
DR型弹簧式举模器

DR L - 28 - 300

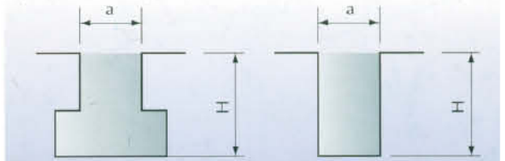
- 长度 Length: 200mm / 300mm
- 宽度 Width: 22mm / 28mm
- 形式 Model: L 滚轮 ROLL / B 滚珠 BALL

超过一顿的模具不适用 Die exceeding 1T is not applicable

DR型結構與動作 Construction and Action



T/U槽尺寸 T-slot / U-slot Dimensions



型号 Model	A	H
DR22	22	33-43
DR28	28	45-58

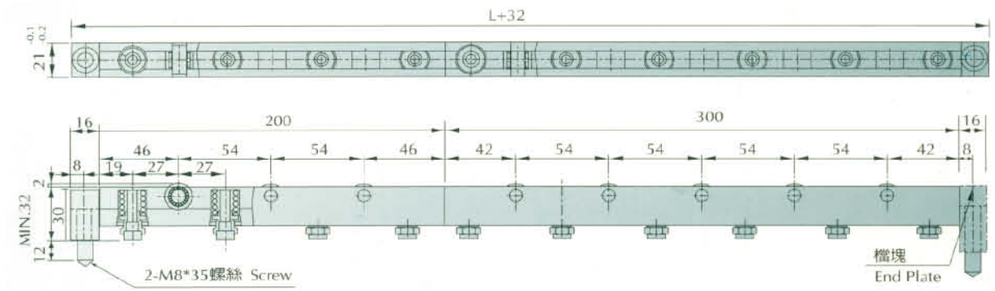
DR型基本尺寸特性 Specifications

基本型式 Specifications	宽度 Width(mm)	长度 Length(mm)	弹簧数量 Springs(pcs)	单一弹簧举模力 Lift Force(kgf)
DRL-22-200/DRB-22-200	22	200	4	37.5
DRL-22-300/DRB-22-300	22	300	6	37.5
DRL-28-200/DRB-28-200	28	200	4	75
DRL-28-300/DRB-28-300	28	300	6	75

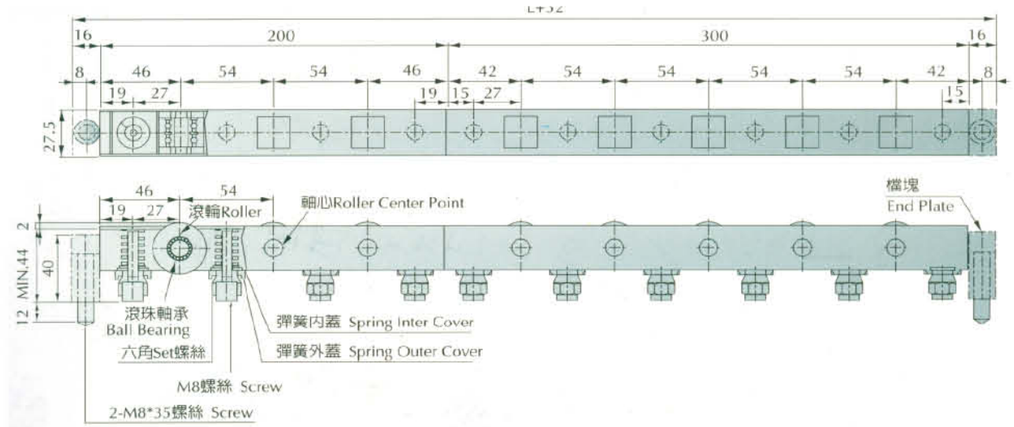
Taken line machinery

快速换模系统----DR型/DU型弹簧式举模器
QDCS-DR/DU Die Lifter

DR-22Dimensions



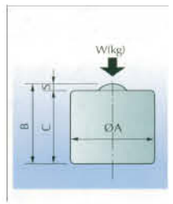
DR-28Dimensions



单一举模器最大举模力 (kgf) Maximum Lift Force Force per Line (kgf)

规格 (Model) \ 长度(mm) / 最大举模力 (kg)	200	300	400	500	600	700	800	900	1000	1100	1200	1300	1400	1500	1600	1700	1800	1900	2000
DR22	150	225	300	375	450	525	600	675	750	825	900	975	1050	1125	1200	1275	1350	1425	1500
DR28	300	450	600	750	900	1050	1200	1350	1500	1650	1800	1950	2100	2250	2400	2550	2700	2850	3000

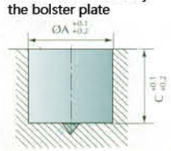
DU滚珠弹簧式举模器



特性规格 Specifications

	DU100	DU200
A	$38^{+0}_{-0.05}$	$45^{+0}_{-0.05}$
B	38	45
D	$35^{+0}_{-0.05}$	$42^{+0}_{-0.05}$
S	3	3
W	100kgf	200kgf

台盘加工尺寸
Dimension for modify the bolster plate



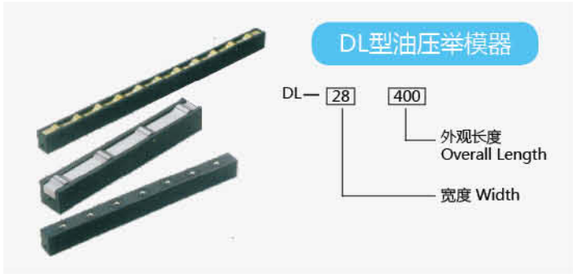
Taken line machinery

快速换模系统——DL型油压式举模器（滚轮型）
QDCS-DR/DU Die Lifter (Roller Type)

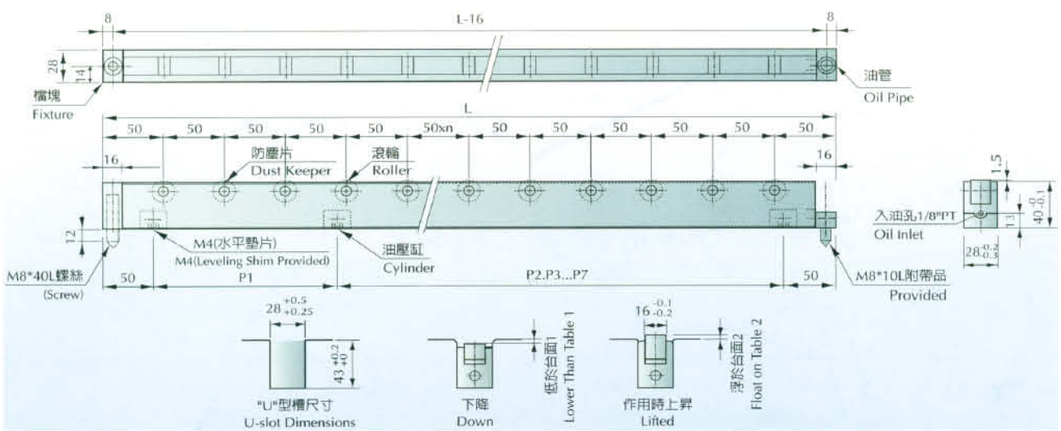
DL型油压式举模器，以油压方式举模，有强力举模能力，适合模具重量变化差异大时使用。
The hydraulic DL DIE LIFRER withstands heavy loads and abuse. The scrap guard / scrapers keep the roller surfaces free from scrap. The rollers are arrayed in closer pitches to prevent damage to the bottom of heavy dies. The height of the roller can be adjusted by removing some of the built-in shims of different thicknesses.

规格特性 Specifications

基本形式 Basic Model	Unit	DL 28	DL 50
单一缸体举模力 Lifting Force Per cylinder	tons	0.5	1.1
工作油压 Working Hydraulic Pressure	kgf/cm²	250	250
总上升行程 Total Stroke	mm	3	3
单一缸体容油量 One Cylinder Capacity	cc.	0.6	1.4



DL-28 Dimensions



型号 Model	总长度（mm）Overall	滚轮数 Roller Qty	载模能力（kgf）Die Load Capacity	油压缸（kg）Lift Cylinder		油压缸距离（mm）Lift Cylinder Pitch						
				丁数（pcs）	举模力(kgf) Lift Force	P1	P2	P3	P4	P5	P6	P7
DL-28-400	400	7	560	2	1000	300						
DL-28-500	500	9	720	3	1500	90	310					
DL-28-600	600	11	880	4	2000	100	340	60				
DL-28-700	700	13	1040	4	2000	150	350	100				
DL-28-800	800	15	1200	5	2500	95	95	390	120			
DL-28-900	900	17	1360	5	2500	110	110	410	170			
DL-28-1000	1000	19	1520	6	3000	130	130	420	110	110		
DL-28-1100	1100	21	1680	6	3000	150	150	460	120	120		
DL-28-1200	1200	23	1840	7	3500	100	100	150	200	200	300	
DL-28-1300	1300	25	2000	7	3500	150	150	300	300	150	150	
DL-28-1400	1400	27	2160	8	4000	100	100	150	150	200	250	350
DL-28-1500	1500	29	2320	8	4000	100	100	150	150	200	350	350

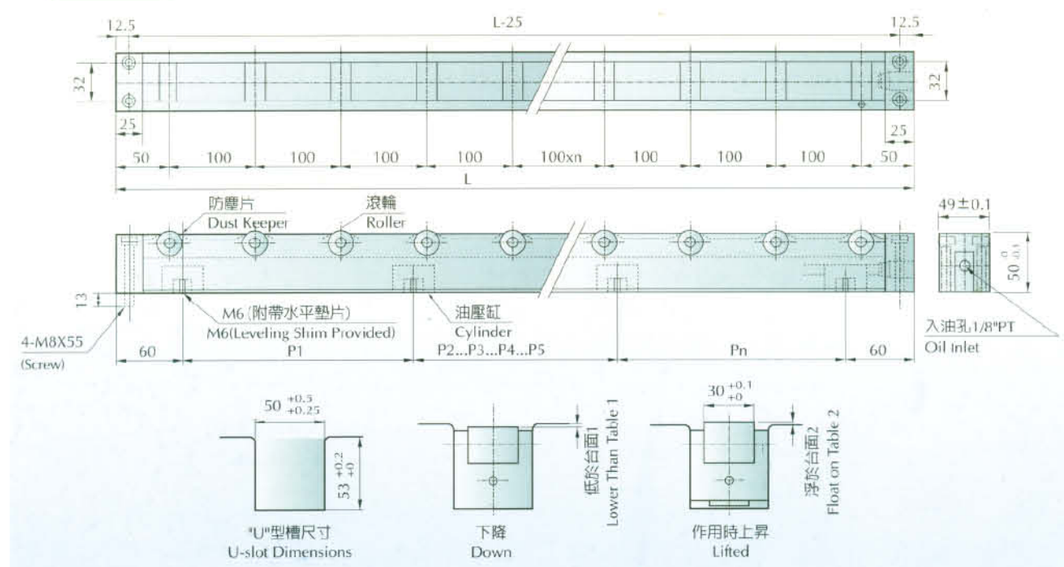
• 1000L以上建议用DL-50

Taken line machinery

速换模系统----DL型油压式举模器（滚轮型）
QDCS-DR/DU Die Lifter (Roller Type)

DL型油压式举模器，以油压方式举模，有强力举模能力，适合模具重量变化差异大时使用。
The hydraulic DL DIE LIFRER withstands heavy loads and abuse. The scrap guard / scrapers keep the roller surfaces free from scrap. The rollers are arrayed in closer pitches to prevent damage to the bottom of heavy dies. The height of the roller can be adjusted by removing some of the built-in shims of different thicknesses.

DL-50



型号 Model	总长度（mm）Overall	滚轮数 Roller Qty	载模能力（kgf）Die Load Capacity	油压缸（kg）Lift Cylinder		油压缸距离（mm）Lift Cylinder Pitch						
				丁数（pcs）	举模力(kgf) Lift Force	P1	P2	P3	P4	P5	P6	P7
DL-50-400	400	4	800	2	2200	280						
DL-50-500	500	5	1000	3	3300	90	290					
DL-50-600	600	6	1200	4	4400	90	330	60				
DL-50-700	700	7	1400	4	4400	140	340	100				
DL-50-800	800	8	1600	4	4400	170	390	120				
DL-50-900	900	9	1800	4	4400	210	400	170				
DL-50-1000	1000	10	2000	5	5500	125	125	410	220			
DL-50-1100	1100	11	2200	5	5500	150	150	400	280			
DL-50-1200	1200	12	2400	5	5500	150	150	400	380			
DL-50-1300	1300	13	2600	6	6600	150	150	200	400	280		
DL-50-1400	1400	14	2800	6	6600	150	150	200	400	380		
DL-50-1500	1500	15	3000	7	7700	150	150	200	300	300	280	
DL-50-1600	1600	16	3200	7	7700	100	150	250	400	300	280	
DL-50-1700	1700	17	3400	8	8800	100	100	150	250	300	300	380
DL-50-1800	1800	18	3600	8	8800	100	100	150	250	300	300	480

• 注：订购时，如有下料孔请附台盘图。
For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom

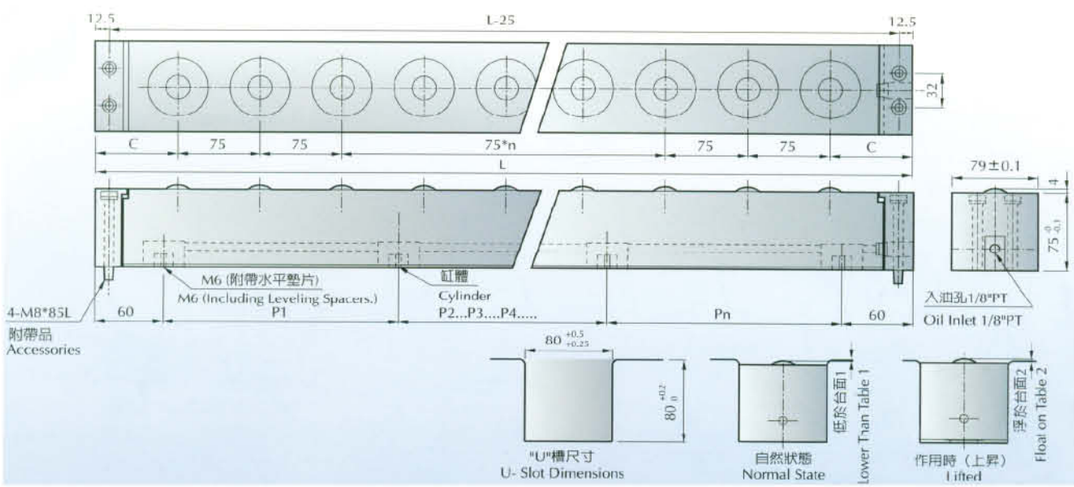
Taken line machinery

快速换模系统——DB型油压式举模器（滚珠型）
QDCS-DB Die Lifter (Ball Type)

DB-80适用于模具重量1500kg以下 （DB-80 for Dies 1500kg or More）

DB型油压式举模器，利用万向滚珠的方式，适合前后左右移动模具时使用。
The hydraulic DB Die Lifter employs universal bearings for superior forward and reverse, left and right motion of molds in and out of press machines.

DB-80



型号 Model	总长度（mm）Overall	滚轮数 Roller Qty	载模能力 Die Load Capacity	油压缸（kg）Lift Cylinder		油压缸距离（mm）Lift Cylinder Pitch															边距 Margin
				丁数（pcs）	举模力(kgf) Lift Force	P1	P2	P3	P4	P5	P6	P7	P8	P9	P10	P11	P12	P13	P14	P15	C
DL-80-400	400	4	800	3	4400	80	120	80													87.5
DL-80-500	500	6	1200	3	4400	90	200	90													62.5
DL-80-600	600	7	1400	4	6600	80	80	160	80	80											75
DL-80-700	700	9	1800	4	6600	90	90	220	90	90											87.5
DL-80-800	800	10	2000	6	8800	80	80	80	200	80	80	80									62.5
DL-80-900	900	11	2200	6	8800	90	90	90	240	90	90	90									75
DL-80-1000	1000	13	2600	6	11000	80	80	80	80	240	80	80	80	80							87.5
DL-80-1100	1100	14	2800	8	11000	90	90	90	150	260	90	90	90	90							62.5
DL-80-1200	1200	15	3000	8	11000	100	100	100	100	280	100	100	100	100							75
DL-80-1300	1300	16	3400	8	13200	90	90	90	90	90	280	90	90	90	90	90					87.5
DL-80-1400	1400	18	3600	10	13200	100	100	100	100	100	280	100	100	100	100	100					62.5
DL-80-1500	1500	19	3800	10	15400	90	90	90	90	90	90	300	90	90	90	90	90	90			75
DL-80-160	1600	20	4200	10	15400	100	100	100	100	100	100	280	100	100	100	100	100	100			87.5
DL-80-1700	1700	22	4400	12	17600	90	90	90	90	90	90	90	320	90	90	90	90	90	90	90	62.5

•注：订购时，如有下料孔请附台盘图。
For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom

Taken line machinery

快速换模系统——RC/RD/RE/RF型移模臂
QDCS-RC/RD/RE/RF Bolster Extension Series

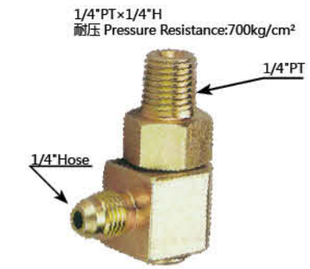
当您使用起重机或叉车升降机做模具更换时，包括RC（移动式）、RD（折下式）与RE/RF（旋转式）系列，可供选用移模臂使用，可以使模具的移到冲床台盘确定位置。
Bolster extensions makes it easy to move dies to an accessible area with arcane or forklift truck for convenient die changes. designs are available: Detachable RC series, drop-down RD series(alternate model), and folding RE/RF series.

	空气压力(5kg/cm²) At Air 5kg/cm²	增压比 Pressure Ratio
06	420(kg/cm²)	1:84
07	300(kg/cm²)	1:60
08	250(kg/cm²)	1:50
09	200(kg/cm²)	1:40
10	150(kg/cm²)	1:30
12	100(kg/cm²)	1:20
14	80(kg/cm²)	1:16
16	50(kg/cm²)	1:10
20	40(kg/cm²)	1:8
24	26(kg/cm²)	1:5

外形图于12-13
Model on 12-13

气动泵单体 Air Pump

AV气控阀 Air Control Valve



过转接头 Rotary Unit

RC Serier RC系列

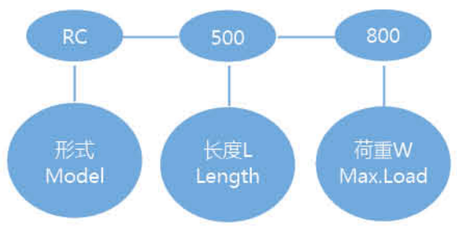
RD Serier RD系列

RC Serier RE/RF系列

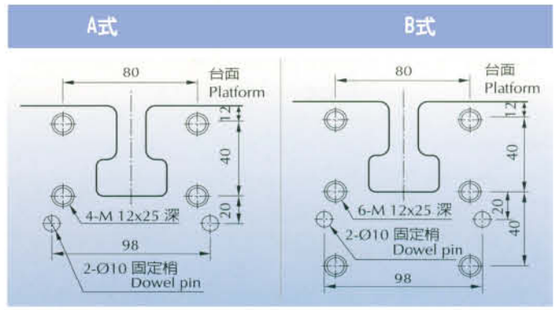
Taken line machinery

快速换模系统—RC型移模臂（轻、中负荷）
QDCS-RC Bolster Extension Series(Light Duty、Medium Duty)

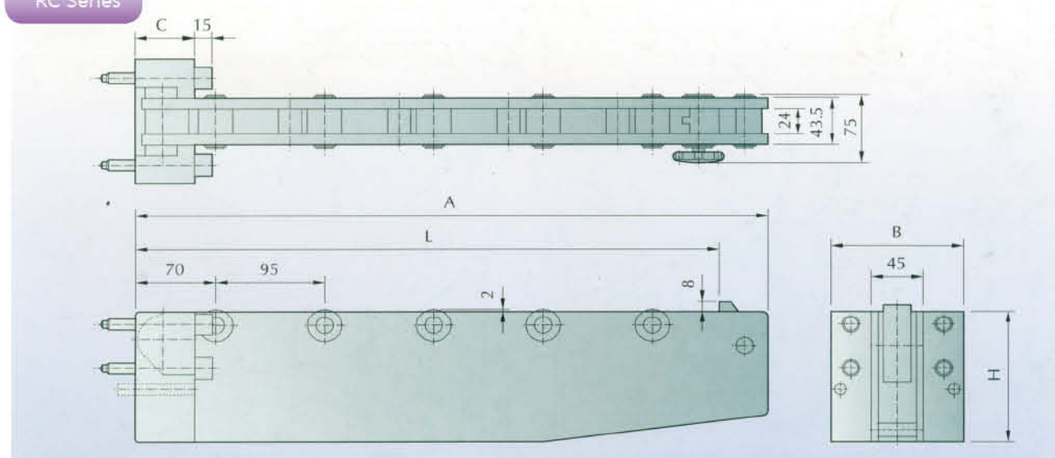
型式表示法 Model/Length/Max.Load



安装钻孔尺寸 Mounting Hole Dimensions



RC Series

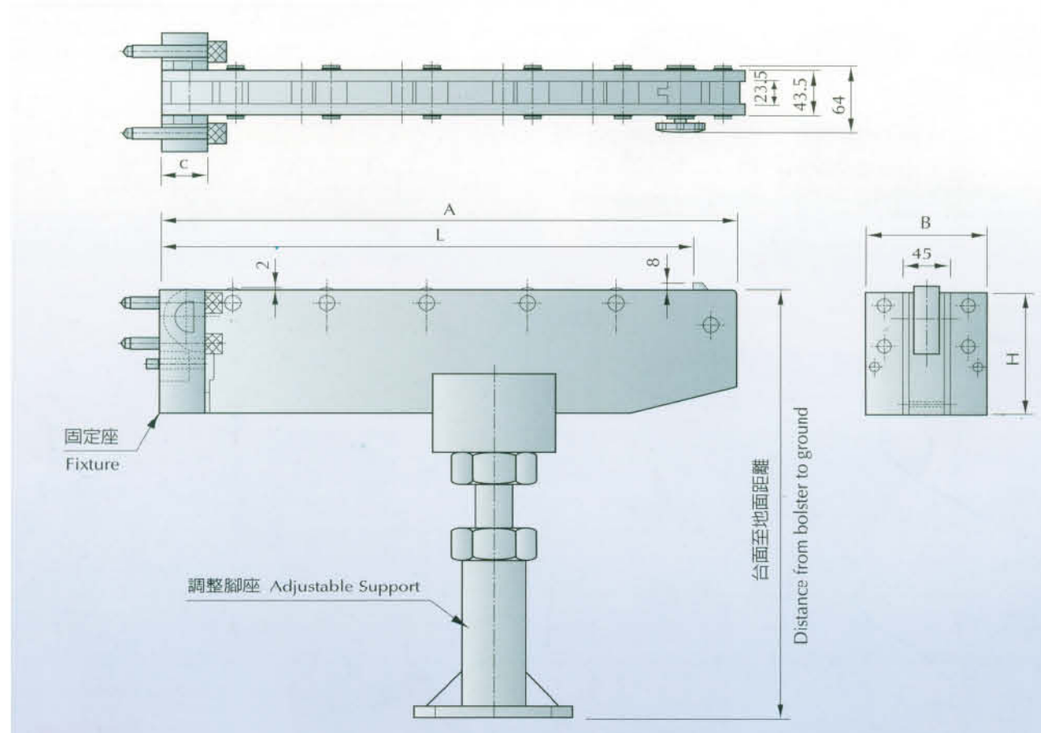


型号 Model	模具引出长 Die Travel(L)	最大荷重 Max.Load(kg)	全长 Overall Length(A)	固定座 Fixture			个/支 Rollers	安装尺寸 Installed Dimensions	固定座形式 Fixture Model
				B	C	H			
RC-500-800	500	800	550	115	46	120	5	A式	RC-120
RC-500-1250	500	1250	550			160			RC-160
RC-500-1600	500	1600	550						
RC-700-600	700	600	750		50	200		B式	RC-200
RC-700-1000	700	1000	750		46	120	7	A式	RC-120
RC-800-800	800	800	850			160			RC-160
RC-800-1600	800	1600	850			160	8		
RC-800-2000	800	2000	850		50	200		B式	RC-200
RC-900-900	900	900	950			240			RC-240
RC-1000-1600	1000	1600	1050			200	10		RC-200

Taken line machinery

快速换模系统——RC型移模臂(重负荷)
QDCS-RC Bolster Extension Series (Heavy Duty)

RC型(移动式) Detachable RC Series



型号 Model	模具引出长 Die Travel(L)	最大荷重 Max.Load (kg)	全长 Overall Length(A)	固定座Fixture			个/支 Rollers	安装尺寸 Installed Dimensions	固定座型式 Fixture Model
				B	C	H			
RC-1200-2500	1200	2500	1250	115	45	120	14	A式	RC-120
RC-1300-2500	1300	2500	1350				15		
RC-1400-2500	1400	2500	1450				17		
RC-1500-2500	1500	2500	1550				18		
RC-1600-2500	1600	2500	1650				19		
RC-1700-2500	1700	2500	1750				20		

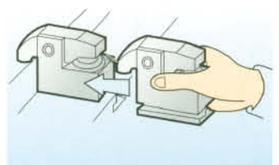
- (L)尺寸超出1000mm须加调整脚座。Requires adjustable support if die travels over 1000mm. 附脚座.These models come standard with adjustable support
- 规格外请确认。Contact us for other specifications

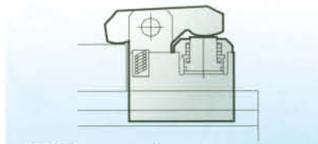
Taken line machinery

TY型夹模器/TY TYPE DIE CLAMP

此型夹模器以杠杆原理作用，夹持模沿，并不需要“U”沟因此有更宽广的使用范围。
Because this lever-type clamp does not require a U-cut on the die shoe, it may be used in a wide range of applications. The base of the clamp is machine to fit the T-slot on the bolster. The flange-mount model clamp may be bolted onto the bolster. The automatic slider model makes remote control possible.

夹模器 DIE CLAMP





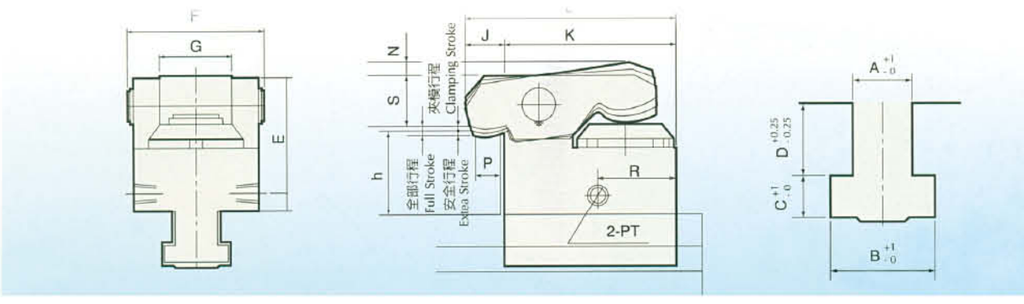
结构剖面 Construction

特性规格 Specifications

型号Model	TY2	TY4	TY6	TY10	TY16	TY25
夹持力（与油压 250kg/）tons Clamping Force(at 250)	2	4	6.3	10	16	25
全部行程（X）mm Full Stroke mm	7	7	8	8	8	8
夹模行程（Y）mm Clamping Stroke mm	2	3	4	3	3	3
安全行程（Z）mm Extra Stroke mm	5	4	4	5	5	5
夹模器缸体容量 Cylinder Capacity at full Stroke	6.5	13.2	22.3	37	61	93

（注）：安全行程为全部行程与夹模行程之差值，为特别安全预留量。
Extra Stroke is the difference value between full stroke and clamping stroke with the extra space for safe operation.

外型尺寸/ OUTLINE DIMENSIONS

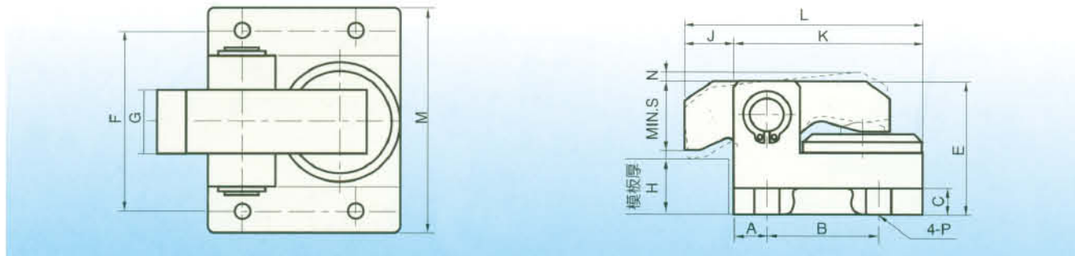


型号 Model	MIN.E	F	G	J	K	L	MAX.N	P	R	MIN.S	PT	MIN.S	型号 Model	A	B	C	D	选用泵浦 Power units model
TY2	59	65	28	22	85	107	10	12.5	48	27	1/8	9.5	TY-2	22	37	16	24	FP6308U-□-□
TY4	85	87	40	30	120	150	10	16	58	33	1/4	12	TY-4	22	37	16	24	
TY6	94	97	44	34.5	133	167.5	11	20	68	40	1/4	14	TY-6	28	48	20	28	
TY10	105	110	50	30	165	195	11	20	82	53	1/4	16.5	TY-10	28	48	20	28	FP1014U-□-□
TY16	120	125	60	35	200	235	12	20	96	67	1/4	19	TY-16	28	48	23	28	
TY25	133	155	73	35	240	275	13	20	110	81	1/4	22	TY-25	36	56	25	28	

注：模沿厚度（h）及T槽（A.B.C.D.）尺寸如为既有（特殊）尺寸，请于订购时确认之。
Before purchase, please verify mold edge thickness (h) and T Slot(A.B.C.D.) as standard or special domensions.

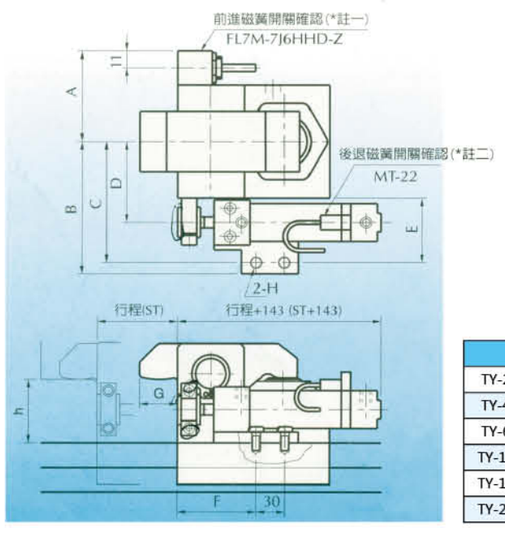
TY-B型夹模器型号/TY-B TYPE DIE CLAMP MODELS

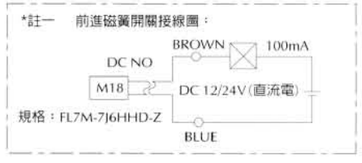
外型尺寸Outline Dimensions

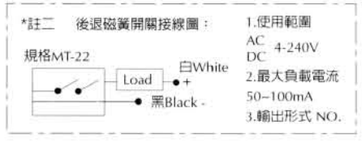


型号 Model	A	B	C	MIN.E	F	G	M	J	K	L	N	MIN.S	P
TY-2B	15	50	12	59	80	28	100	22	85	107	10	27	M10×25L螺丝 Screw
TY-4B	15	72	18	85	110	40	135	30	120	150	10	33	M12×40L螺丝 Screw
TY-6B	28.5	76	25	94	120	44	150	34.5	133	167.5	11	40	M16×50L螺丝 Screw

TY-C型夹模器型号/TY-C TYPE DIE CLAMP MODELS





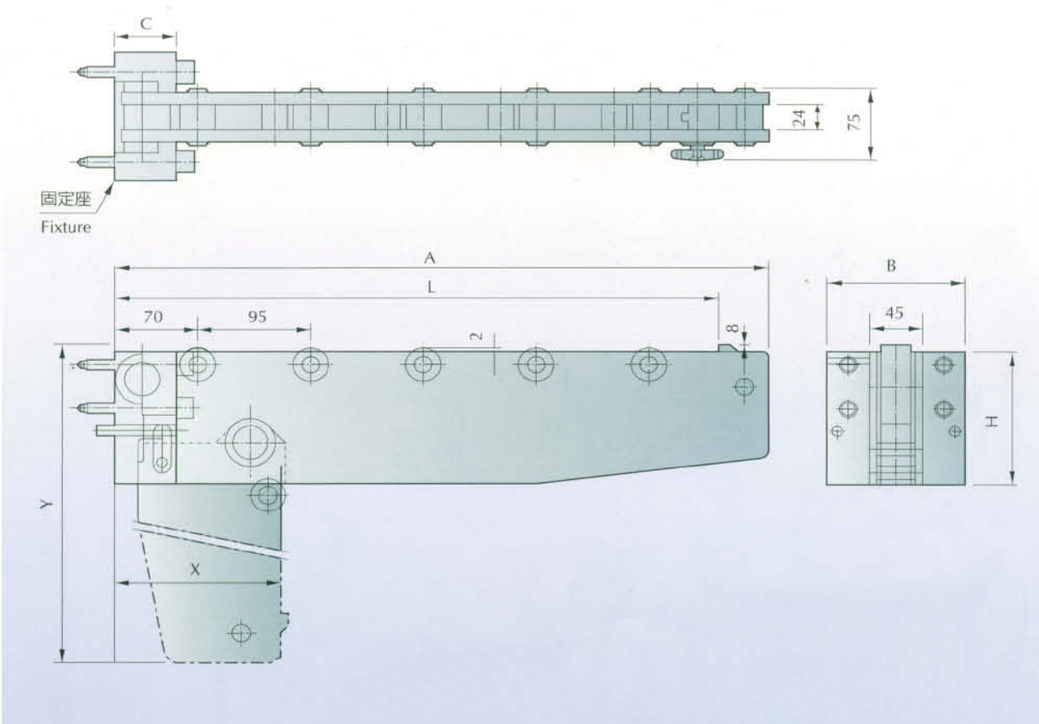


	A	B	C	D	E	F	G	H（：台盘攻牙深度）	气缸规格
TY-2C	51	93	86	54	57	82	22	M10×25L:8.6×25深	MIB32*行程
TY-4C	62	104	97	65	57	82	30	M10×25L:10.3×25深	MIB32*行程
TY-6C	67	127	115	75	70	85	30	M10×25L:10.3×25深	MIB40*行程
TY-10C	77	132	120	80	70	85	30	M10×25L:10.3×25深	MIB40*行程
TY-16C	82	142	130	90	70	85	35	M10×25L:10.3×25深	MIB40*行程
TY-25C	94.5	154.5	142.5	102.5	70	85	35	M10×25L:10.3×25深	MIB40*行程

Taken line machinery

快速换模系统----RD型移模臂
QDCS-RD Bolster Extension Series

RD型（折下式）Drop-Down RD Series

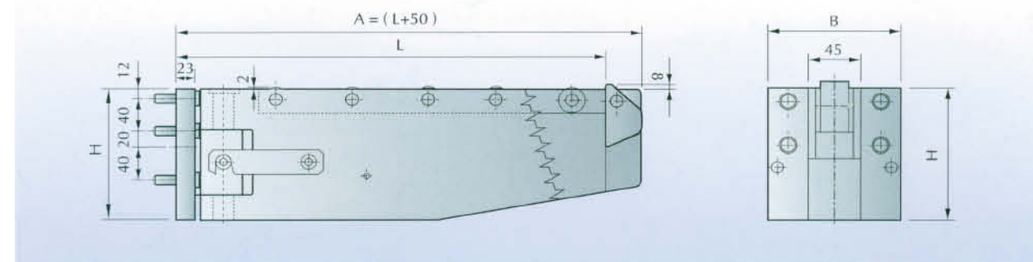


型号 Model	模具引出长 Die Travel(L)	最大荷重 Max.Load	全长 Overall Length(A)	固定座 Fixture			个/支 Rollers	安装尺寸 Installed Dimensions	折下时尺寸 Drop-Down	
				B	C	H			X	Y
RD-500-800	500	800	550	115	52	120	5	A式	140	620
RD-500-1250	500	1250	550			160			180	660
RD-500-1600	500	1600	550			200		B式	220	700
RD-700-600	700	600	750			120	7	A式	140	820
RD-700-1000	700	1000	750			120			180	860
RD-800-800	800	800	850			160	8		180	960
RD-800-1600	800	1600	850			200		B式	220	1000
RDF-800-2000	800	2000	850			240			260	1040
RD-900-900	900	900	950			200	9		220	1100
RD-1000-1600	1000	1600	1050				10			1200

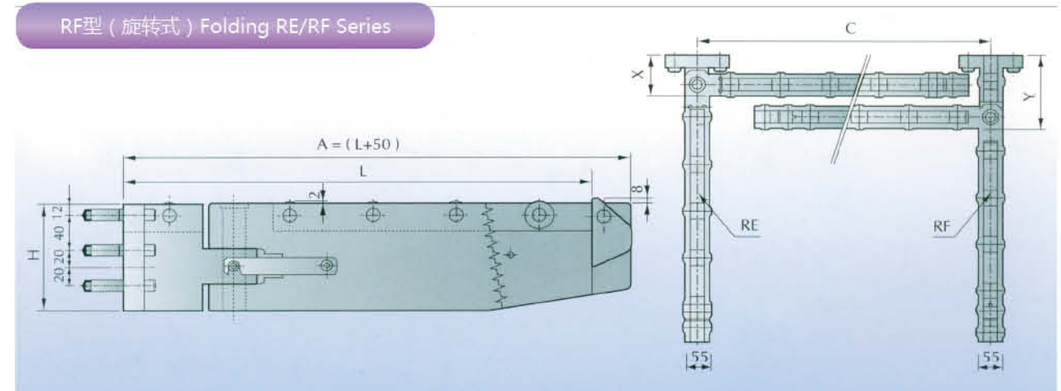
Taken line machinery

快速换模系统----RE/RF型移模臂
QDCS-RD/RF Bolster Extension Series

RD型（旋转式）Folding RE/RF Series



RF型（旋转式）Folding RE/RF Series



型号 Model	模具引出长 Die Travel(L)	最大荷重 Max.Load	全长 Overall Length(A)	固定座 Fixture			个/支 Rollers	安装尺寸 Installed Dimensions	折下时尺寸 Drop-Down	
				C	B	H			X	Y
RE.RF-500-800	500	800	550	525	115	120	5	A式	90	150
RE.RF-500-1250	500	1250	550	525		160				
RE.RF-700-600	700	600	750	725		120	7			
RE.RF-700-1600	700	1600	750	725		200	7	B式		
RE.RF-800-800	800	800	850	825		160	8	A式		
RE.RF-800-1600	800	1600	850	825		200	8	B式		
RE.RF-500-1600	500	1600	550	525		200	5			
RE.RF-900-900	900	900	950	925			9			

订购资料表 Quotation Request From

(如果您订购二台以上机床换模系统，请复印此份表格使用，并明列每台冲床资料。)
(If you require quotations for more than one press ,please copy this form one for each machine)

A 冲床部份 Press Parts	A1	新购或就有 New or Existing	☐ 新购 New ☐ 就有Existing
	A2	制造商及型号 Manufacturer and Model	制造商 Manufacturer ☐ 型号 Model ☐
	A3	冲床形式 Type of Press	☐ C Frame ☐ 直柱型Straight Side ☐ Transfer ☐ Other Specify (其它) ☐
	A4	冲压能力 Tonnage	☐ tf ☐ 美制 US ☐ 公制Metric
	A5	滑块尺寸 Slide Dimensions	(L-R) ☐ X(F-B) ☐ mm(inch)
	A6	台盘尺寸 Bolster Dimensions	(L-R) ☐ X(T-B) ☐ mm(inch)
	A7	T槽(详细测量) T-slot	☐ 有 Yes ☐ 没有 No 尺寸 Dimensions a: ☐ c: ☐ b: ☐ d: ☐
B 模具部份 Die Parts	B1	最大重量 Max.Weight	☐ kg(1bs)
	B2	最大尺寸 Max.Dimensions	(W) ☐ x(L) ☐ x(H) ☐ mm(inch)
	B3	螺栓用"U"槽 U-slot for Bolting	☐ 有 Yes ☐ 没有 No
	B4	模具边缘厚度 Die Shoe Thickness	☐ mm(inch)
	B5	模具底部 Bottom	☐ 平面 Plain ☐ 格子状 Lattice
	B6	特殊需求 Special Requirements	☐

C 换模组件部份 Die Change System Parts	C1 所需组件 Required Components	夹模器 Clamp	型式 Model ☐ X ☐ 个 Pcs	
		举模器 Die Lifter	型式 Model ☐ X ☐ 个 Pcs	
		移模臂 Bolster Extension	型式 Model ☐ X ☐ 个 Pcs	
		气动泵组合 Power Unit	型式 Model ☐ X ☐ 个 Pcs	
	C2 阀门操作 Valve Operation	☐ 手动式 Manual ☐ 电气操作式 Automatic		
		☐ 电力规格 Power Ssupply	☐ AC ☐ DC ☐ Volt ☐ Hz	

基本资料 Your Information

公司名称/COMPANY：	联络人/NAME：
地址/ADD：	
电话/TEL：	传真/FAX：

Taken line machinery

Q M C S 导入效益 & 选用指导 / Q M C S BENEFITS & SYSTEM COMPONENTS SELECT

直接效益 DIRECT BENEFITS

- 减少换模时间 Reduce Die Changing Time
- 多种少量的生产 Diverse Products in Small Batches
- 减少存货Reduced Stock Inventory
- 产量与品质改善 Improved Productivity and Quality
- 降低劳力成本 Reduced Labor Costs

间接效益 INDIRECT BENEFITS

- 间接效益 INDIRECT BENEFITS
- 间接效益 Indirect Benefits
- 模具标准化Die standardization
- 作业标准化 Operation Standardization
- 增加操作安全Increased Operation Safety
- 增加操作安全Increased Operation Safety
- 改善工厂环境Better Working Environment

▲以上各种效益大大增进了企业竞争能力！ Increased Overall

Q.M.C.S 导入效益

懿行 Q M C S提供各式射出机、压铸机模具多样性的快速换模专用元件，此系统的使用，不仅减少了间置，并且大大促进了产能的提升，使得生产管理更为合理化。

Q.M.C.S BENEFITS

YI XING Q M C S provides different injection molding and hydraulic mold casting machinery with many types of efficient quick mold changing systems which highlight time saving and enhanced productivity for more rationalized production management.

Q.M.C.S 选用指导

懿行 Q M C S为使您能依照模具尺寸，射出成形机、压铸机的规格来选定，准备有下列各种机械。请考虑工厂的布局，将来的生产计划，等标准化之后，选择最适合的方式。

Q.M.C.S SELECTION

The YI XING specifications are available for you to choose in accordance to your injection molding requirements and actual production situations Make sure of your production plans standard production procedure before choosing the product that suits you best

模板Mold Plate	换模方式Mold Change	使用之夹模方式Clamping type	条件、特征Condition Character
不能统一情形时 No Union	吊车（垂直放入） Put Vertically	移动式夹模器 Moving Clamper	必须在盘面上加T沟，或者安装T沟板 To Be With T-Slot
可以统一情形时 Union	吊车（垂直放入） Put Vertically	固定式移动式夹模器 Fixed & Moving Clamper	夹模器固定于盘面或在盘面上移动 Clamper Fixed Or Moving On Plate
	台车（水平放入） Put Horizontally	固定式夹模器 Fixed Clamper	将输送滚输（或滑轨）安装于盘面。必须有台车或模具交换台，换模时间极短，作业最简单，亦可全自动化。 Install roller or sliding rail upon the plate. Use cart or mold exchange table the shortest possible mold changing time and easy operation.

Taken line machinery

操作箱/ CONTROL BOX

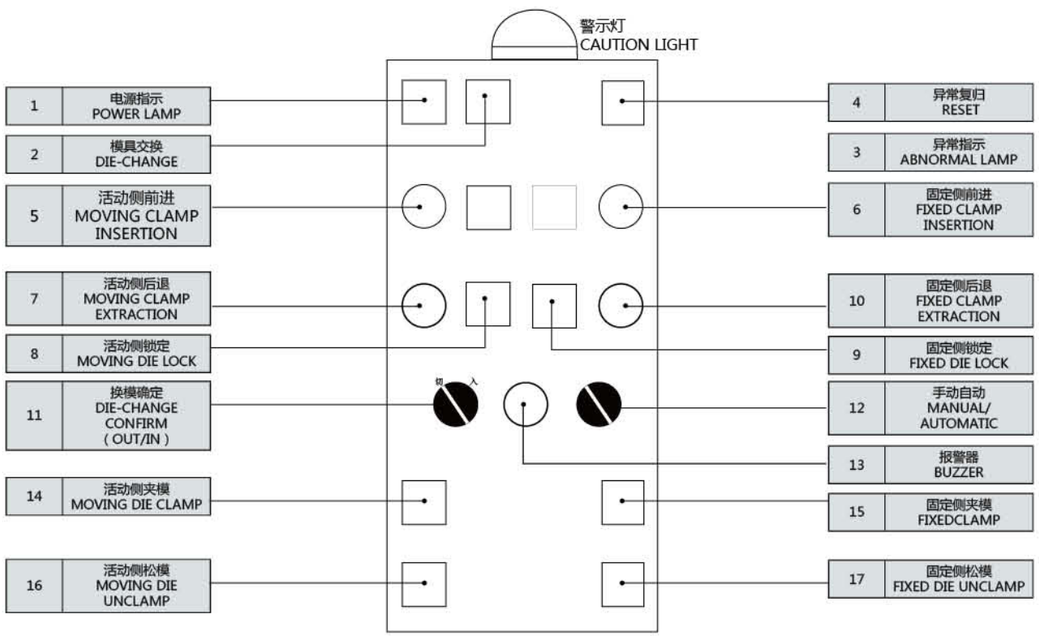
操作箱控制键说明

操作控制箱为本快速换模系统状态提示，与功能操作介面，上半部（1~10）为提示与自动操作功能，下半部（11~17）为手动操作功能按键。

THE CONTROL PANEL

The control panel offers an interface to monitor and control operations of the quick mold change system.
The upper half of the screen (lines1-10) displays automatic functions while the lower half(lines11-17)is used for operator-controlled functions.

操作箱面板 CONTROL BOX PANEL



Taken line machinery

订购资料表/QUOTATION INFORMATION FORM

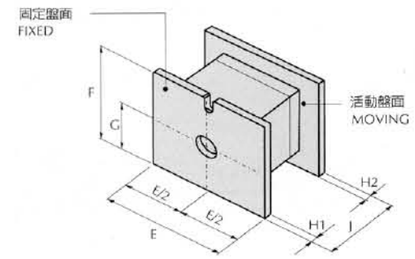
模具外型尺寸图DIE DIMENTIONS

项目 ITEM	E	F	G	J	H1	H2
尺寸 (SIZE)						

m/m

注：1.未指示公差处，以一般公差加工
2.各钻孔，攻牙孔倒角基准：
3.未指示公差处，以一般公差加工

Clamps with a dimension greater than max.h+d are also optionally available



(如果您订购二台以上射出成型器、压铸机换模系统，请明列每台射出成型机、压铸机资料)(请COPY使用)
(if you require quotation for more than one press,please copy thisform for each machine.)

A PART ABOUT PRESS 设备部分	A1 New or Existing 新购或就有	☐ New 新购	☐ Existing就有	
	A2 Manufacturer and model 制造商及型号	Manufacturer 制造商		model 型号
	A3 Tonnage 射出/压铸能力	☐ tf	☐ US美制	☐ Metric公制
	A4 Fixed dimensions固定台盘尺寸	(E)	X(F)mm	
	A5 Moving dimensions 活动台盘尺寸	(E)	X(F)mm	
	A6 T-slot T槽(详细测量)	☐ YES有 ☐ NO没有	Dimension 尺寸	A : C : B : D :

B PART ABOUT PRESS 设备部分	B1 Max.weight 最大重量	kg(1bs)		
	B2 Max.dimensions最大尺寸	(W) x(L)	x(H)	mm(inch)
	B3 U-cut for bolting螺栓用"U"槽	☐ Yes有	☐ No没有	
	B4 Die shoe thickness磨具边缘厚度	mm(inch)		
	B5 bottom磨具底部	☐ Plain平面	☐ Lattice格子状	
	B6 Special requirements 特殊需求			

FROM

公司名称/COMPANY: 联络人/ATTN：
地址/ADD:
电话/TEL: 传真/FAX：

Taken line machinery

模具垂直放入图例/ DEMONSTRATION OF PUT MOLD VERTICLLY

模具垂直放入时

一般射出成型机或压铸机模具垂直放入方式使用最多，懿行Q.M.C.S提供夹模器可移关方式换模系统，不仅减低换台的间置时间，并且崔进产能的提升，使得生产管理更为合理化，自动化。

VERTICAL TYPE

Most of the molds for injection molding and mold casting machines are fitted vertically , YI XING Q.M.C.S However adopts removable mold changing system that not only saves idle time for enhanced production efficiency but also spurs even rationalized and automated production management.

交换方式 MOLD CHANGE

模具水平放入图例/ DEMONSTRATION OF PUT MOLD HORIZONTALLY

模具水平放入时

模具水平放入时，可使用换模台车方式，更换模具，更具安全性，并连成成块快速换模系统之规则，使得模具之输送及储存更具自动化。

HORIZONTALLY TYPE

When molds are fitted horizontally , mold changing cart may be used for safe operation and realization of quick mold changing for entire factory with increased automation of mold delivery and storage

交换方式 MOLD CHANGE

Taken line machinery

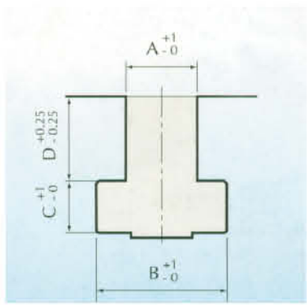
射出成形机、压铸机快速换模系统标准型式选用表/ QMCS TYPICAL SECTIONS BY INJECTION MOLDING MACHINS & MOLD CASTING MACHINES

射出成形机、压铸机快速换模系统标准型式选用表
Q.M.C.S typical sections by injection molding machines & mold casting machines

机台能力 TON	夹模器CLAMPER					气动泵组合 PUMP MODEL	建议模板厚度PLATE THICKNISS		建议T槽尺寸 T-SLOT SIZE			
	活动侧 MOVING	数量 PCS	固定侧 FIXED	数量 PCS	总夹模力 TOTAL		活动侧 MOVING	固定侧 FIXED	A	B	C	D
150	TY-2	4	TY-2	4	16TON	FP6308U-□-□C	35	35	$22^{+1.0}_{-0}$	$37^{+1.0}_{-0}$	$16^{+1.0}_{-0}$	24±0.25
250	TY-4	4	TY-4	4	32TON	FP6308U-□-□C	40	40	$28^{+1.0}_{-0}$	$48^{+1.0}_{-0}$	$20^{+1.0}_{-0}$	28±0.25
350	TY-6	4	TY-6	4	48TON							
550	TY-10	4	TY-10	4	80TON	FP1014U-□-□C						
850	TY-16	4	TY-16	4	128TON	FP1014U-□-□C	50	50	$28^{+1.0}_{-0}$	$48^{+1.0}_{-0}$	$23^{+1.0}_{-0}$	28±0.25
1000	TY-16	6	TY-16	6	192TON							
1300	TY-25	4	TY-25	4	200TON		50	50	$36^{+1.0}_{-0}$	$56^{+1.0}_{-0}$	$25^{+1.0}_{-0}$	28±0.25
1600	TY-25	6	TY-25	6	300TON							

夹模器 Die Clamp

气动泵组合 Power units



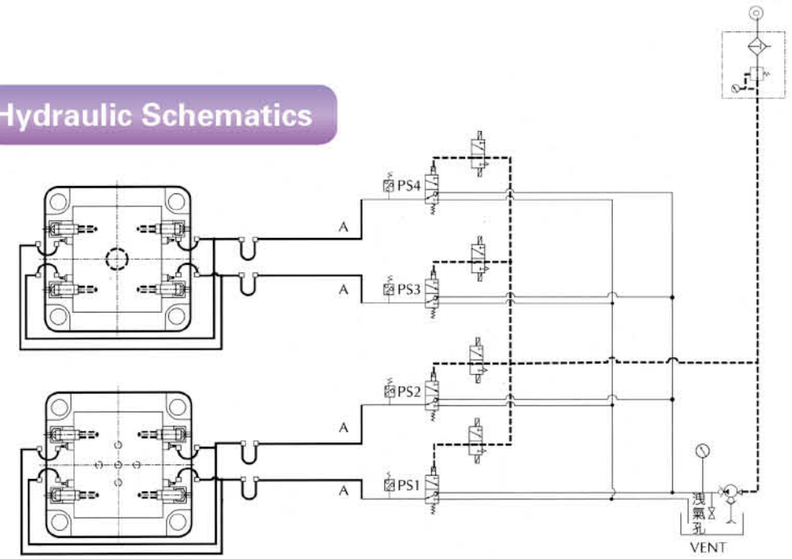
建议T槽尺寸T-SLOT SIZE

油压系统回路图/ HYDRAULIC SCHEMATICS

油压系统回路图 Hydraulic Schematics

固定盘面
Fixed Bolster Plate

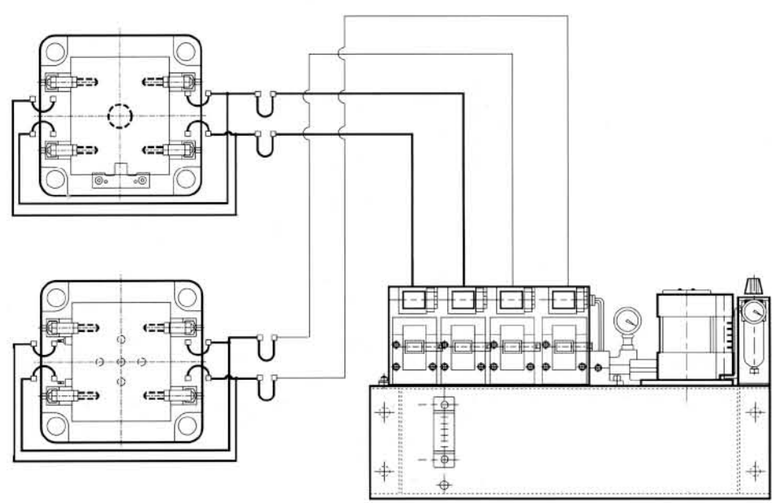
活动盘面
Moving Bolster Plate



油压系统回路图 Hydraulic Schematics

固定盘面
Fixed Bolster Plat

活动盘面
Moving Bolster Plate



Taken line machinery

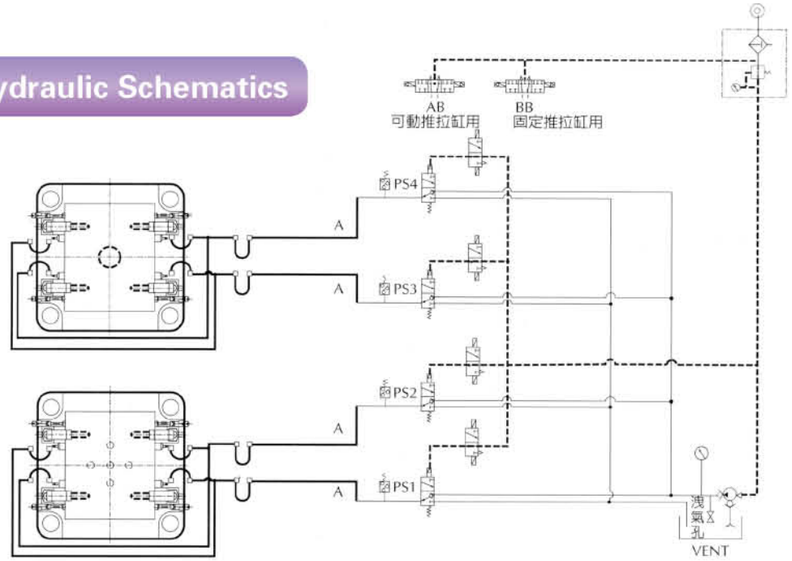
射出机/压铸机应用范例/
APPLICATION OF INJECTION & CASTING MACHINES

油压系统回路图 Hydraulic Schematics

★（附推拉缸）

固定盘面
Fixed Bolster Plate

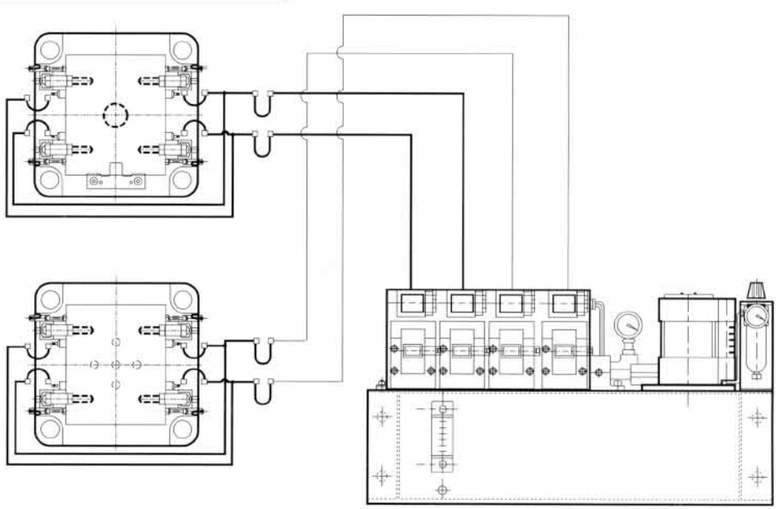
活动盘面
Moving Bolster Plate



油压系统回路图 Hydraulic Schematics

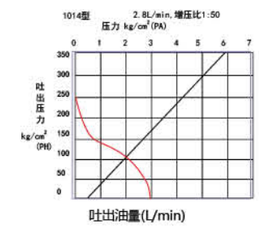
固定盘面
Fixed Bolster Plate

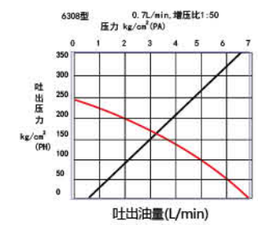
活动盘面
Moving Bolster Plate



气动泵组合外型尺寸/
AIR-DRIVING PUMP UNITS SELECTION

气动泵组合AIR DRIVING PUMP UNITS





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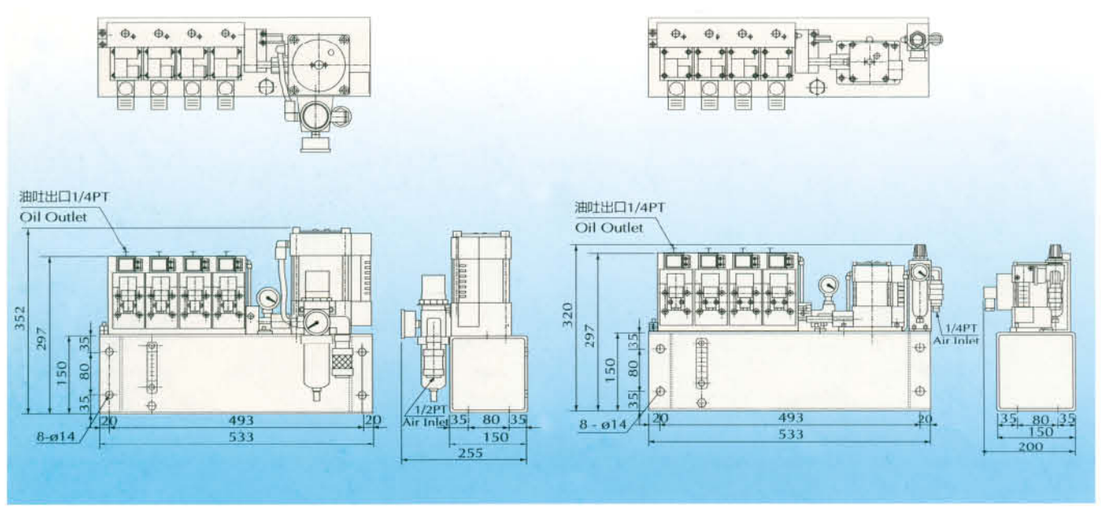

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