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交叉杆斜顶

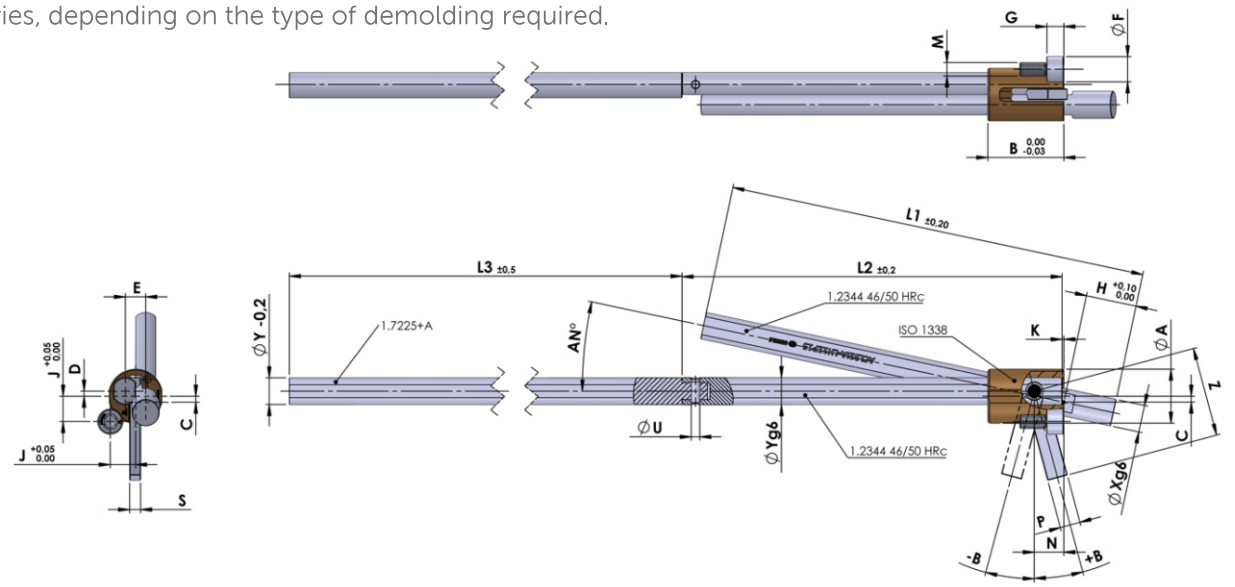
ANGULAR CROSS-BAR LIFTER



ACL

这种机制使交叉杆斜顶能够通过一个轴的垂直运动来拖动另一个导向轴。在特定角度下，通过横杆连接。
This mechanism makes it possible to drag another guided axis by means of a vertical movement of one axis. at a given angle, connected by means of a crossbar.

横杆可根据需要调整角度从而使斜向轴能够沿不同轨迹运动，以满足各种脱模需求。
This crossbar can be positioned at different angles as required, This allows the angled axis to be moved along different trajectories, depending on the type of demolding required.



型号 MODEL	行程 STROKE	通用尺寸 | GENERAL DIMENSIONS | (mm)																					
		ØA	AN°	B	C	D	E	ØF	G	H	J	K	L1	L2	L3	M	N	P	S	T	V	ØX	ØY	Z
ACL1606-LH/RH	<50/100>		6°																					
ACL1608-LH/RH	<50/100>		8°																					
ACL1610-LH/RH	<50/100>	16	10°	25	1,8	1	6,2	6	8	14	7,4	0,5	160	152	200	M4	12,5	6,5	4,1	3	3,1	8	8	30,5
ACL1612-LH-RH	<50/100>		12°																					
ACL16XX-LH/RH	<50/100>		X°																					
ACL2208-LH/RH	<50/150>		8°																					
ACL2212-LH/RH	<50/150>		12°																					
ACL2216-LH/RH	<50/150>	22	16°	30	2,1	2	8,5	8	10	20	9,8	0,5	240	222,5	300	M5	14,5	9,6	6	4	4,5	12	10	50
ACL2220-LH/RH	<50/150>		20°																					
ACL22XX-LH/RH	<50/150>		X°																					
ACL3208-LH/RH	<100/150>		8°																					
ACL3212-LH/RH	<100/150>		12°																					
ACL3216-LH/RH	<100/150>	32	16°	45	3,5	3	12	15	10	30	15	1	248	225	300	M8	17,5	12	6,5	5	6	16	16	63
ACL3220-LH/RH	<100/150>		20°																					
ACL32XX-LH/RH	<100/150>		X°																					
ACL4208-LH/RH	<100/175>		8°																					
ACL4212-LH/RH	<100/175>		12°																					
ACL4216-LH/RH	<100/175>	42	16°	60	5,5	4	16	18	13	40	19	2	280	261,5	300	M10	23,5	14	8	6	8	20	20	76
ACL4220-LH/RH	<100/175>		20°																					
ACL42XX-LH/RH	<100/175>		X°																					

选型示例 SELECTION EXAMPLE:

我们需要型号ACL32的交叉杆斜顶倾斜10°来脱模产品一侧25mm的倒扣。我们的顶出行程是125mm，但参数表显示我们需要采用100mm的顶出行程。在顶出参数表中在10°轴我们需要查找对应的数值，当该数值乘以1.25倍安全系数后，仍超出我们25mm的倒扣量，此时需要同时校核最小基角参数值。这种情况下就可以选ACL32LH1210P或者ACLC32RH1210P型号。

We need an ACL32 to remove a 25mm undercut on one side of a part that is tilted at a 10° positive angle. We have an ejection stroke of 125mm, but the table shows a stroke of 100mm that we need to use. In the ejection table, on the 10° positive axis, we look for the value that, when multiplied by 1.25, exceeds the 25mm undercut we have, while considering the value of the minimum base angle. In this case, it indicates either an ACL32LH1210P or an ACL32RH1210P.

基角:6°, 8°, 10°和12°
Base angles: 6°, 8°, 10° and 12°

角度B° ANGLE B°		100mm脱模参数对照表 DEMOLDING VALUES FOR 100mm STROKE							
POSITIVE +B°	NEGATIVE -B°	BASE 6°		BASE 8°		BASE 10°		BASE 12°	
0°		10,51		14,05		17,63		21,25	
1°	-1°	10,53	10,49	14,09	14,02	17,69	17,58	21,34	21,18
2°	-2°	10,56	10,48	14,13	13,99	17,75	17,54	21,43	21,00
3°	-3°	10,58	10,47	14,18	13,97	17,82	17,50	21,53	20,95
4°	-4°	10,61	10,46	14,23	13,95	17,90	17,46	21,63	20,91
5°	-5°	10,65	10,45	14,28	13,94	17,98	17,43	21,74	20,87
6°	-6°	10,69	10,45	14,34	13,93	18,06	17,41	21,86	20,84
7°	-7°	10,73	10,45	14,41	13,92	18,16	17,39	21,99	20,82
8°	-8°	10,77	10,46	14,48	13,92	18,26	17,38	22,13	20,80
9°	-9°	10,82	10,47	14,55	13,92	18,37	17,37	22,27	20,80
10°	-10°	10,87	10,48	14,63	13,93	18,48	17,36	22,42	20,79
12°	-12°	10,93	10,49	14,72	13,94	18,60	17,37	22,59	20,80
13°	-13°	11,06	10,53	14,91	13,97	18,86	17,39	22,94	20,82
14°	-14°	11,12	10,56	15,01	13,99	19,01	17,41	23,13	20,84
15°	-15°	11,20	10,58	15,12	14,02	19,16	17,43	23,34	20,87
17°	-17°	11,27	10,61	15,23	14,05	19,32	17,46	23,55	20,91
18°	-18°	11,44	10,69	15,48	14,13	19,67	17,54	24,01	21,00
19°	-19°	11,53	10,73	15,62	14,18	19,85	17,58	24,26	21,05
20°	-20°	11,63	10,77	15,76	14,23	20,05	17,63	24,52	21,11
21°	-21°	11,73	10,82	15,91	14,28	20,26	17,69	24,79	21,18
22°	-22°	11,84	10,87	16,07	14,34	20,48	17,75	25,08	21,26
23°	-23°	11,95	10,93	16,24	14,41	20,71	17,82	25,38	21,34
24°	-24°	12,07	10,99	16,41	14,48	20,95	17,90	25,70	21,43
25°	-25°	12,19	11,06	16,59	14,55	21,20	17,98	26,03	21,53
26°	-26°	12,33	11,12	16,79	14,63	21,46	18,06	26,39	21,63
27°	-27°	12,46	11,20	16,99	14,72	21,74	18,16	26,75	21,74
28°	-28°	12,61	11,27	17,20	14,81	22,04	18,26	27,14	21,86
29°	-29°	12,76	11,36	17,43	14,91	22,34	18,37	27,55	21,99
30°	-30°	12,92	11,44	17,66	15,01	22,67	18,48	27,98	22,13
31°	-31°	13,09	11,53	17,91	15,12	23,01	18,60	28,43	22,27
32°	-32°	13,26	11,63	18,17	15,23	23,37	18,73	28,90	22,42
33°	-33°	13,45	11,73	18,44	15,36	23,74	18,86	29,40	22,59
34°	-34°	13,65	11,84	18,73	15,48	24,14	19,01	29,93	22,76
35°	-35°	13,85	11,95	19,03	15,62	24,56	19,16	30,49	22,94
36°	-36°	14,07	12,07	19,35	15,76	25,00	19,32	31,07	23,13
37°	-37°	14,29	12,19	19,68	15,91	25,46	19,49	31,69	23,34
38°	-38°	14,53	12,33	20,03	16,07	25,95	19,67	32,35	23,55
39°	-39°	14,78	12,46	20,41	16,24	26,47	19,85	33,04	23,77
40°	-40°	15,05	12,61	20,80	16,41	27,01	20,05	33,77	24,01

标准角度范围:40°至60° 特殊角度可按需定制。
Possible angles from +40° to -60°
Especial angles upon request.

基角:14°,16°,18°和20°
Base angles: 14°, 16°, 18° and 20°

角度B° ANGLE B°		100mm脱模参数对照表 DEMOLDING VALUES FOR 100mm STROKE							
POSITIVE +B°	NEGATIVE -B°	BASE 14°		BASE 16°		BASE 18°		BASE 20°	
0°		24,93		28,67		32,49		36,39	
1°	**1°**	25,05	**24,83**	28,82	**28,54**	32,68	**32,31**	36,64	**36,17**
2°	**2°**	25,17	**24,73**	28,98	**28,67**	32,88	**32,15**	36,89	**35,96**
3°	**3°**	25,30	**24,64**	29,15	**28,55**	33,10	**31,99**	37,16	**35,76**
4°	**4°**	25,44	**24,57**	29,33	**28,44**	33,33	**31,85**	37,44	**35,58**
5°	**5°**	25,59	**24,49**	29,52	**28,34**	33,57	**31,71**	37,74	**35,41**
6°	**6°**	25,74	**24,43**	29,73	**28,25**	33,83	**31,59**	38,05	**35,25**
7°	**7°**	25,91	**24,37**	29,94	**28,17**	34,10	**31,48**	38,39	**35,10**
8°	**8°**	26,09	**24,33**	30,17	**28,10**	34,38	**31,38**	38,74	**34,97**
9°	**9°**	26,28	**24,28**	30,41	**28,03**	34,68	**31,29**	39,11	**34,84**
10°	**10°**	26,48	**24,25**	30,67	**27,98**	35,00	**31,21**	39,49	**34,73**
12°	**12°**	26,69	**24,23**	30,94	**27,93**	35,33	**31,13**	39,90	**34,63**
13°	**13°**	27,15	**24,20**	31,52	**27,86**	36,05	**31,02**	40,78	**34,46**
14°	**14°**	27,40	**24,19**	31,83	**27,84**	36,44	**30,98**	41,26	**34,39**
15°	**15°**	27,66	**24,20**	32,16	**27,83**	36,85	**30,94**	41,75	**34,33**
17°	**17°**	27,93	**24,21**	32,50	**27,82**	37,27	**30,92**	42,28	**34,29**
18°	**18°**	28,53	**24,25**	33,25	**27,84**	38,20	**30,90**	43,40	**34,22**
19°	**19°**	28,85	**24,28**	33,65	**27,86**	38,69	**30,91**	44,01	**34,21**
20°	**20°**	29,18	**24,33**	34,07	**27,89**	39,21	**30,92**	44,65	**34,20**
21°	**21°**	29,53	**24,37**	34,51	**27,93**	39,76	**30,94**	45,32	**34,21**
22°	**22°**	29,90	**24,43**	34,98	**27,98**	40,34	**30,98**	46,02	**34,22**
23°	**23°**	30,29	**24,49**	35,47	**28,03**	40,95	**31,02**	46,77	**34,25**
24°	**24°**	30,70	**24,57**	35,98	**28,10**	41,58	**31,07**	47,55	**34,29**
25°	**25°**	31,13	**24,64**	36,52	**28,17**	42,25	**31,13**	48,37	**34,33**
26°	**26°**	31,58	**24,73**	37,09	**28,25**	42,96	**31,21**	49,24	**34,39**
27°	**27°**	32,05	**24,83**	37,69	**28,34**	43,70	**31,29**	50,15	**34,46**
28°	**28°**	32,55	**24,93**	38,32	**28,44**	44,48	**31,38**	51,11	**34,54**
29°	**29°**	33,08	**25,05**	38,98	**28,55**	45,31	**31,48**	52,13	**34,63**
30°	**30°**	33,63	**25,17**	39,68	**28,67**	46,18	**31,59**	53,21	**34,73**
31°	**31°**	34,21	**25,30**	40,42	**28,80**	47,10	**31,71**	54,35	**34,84**
32°	**32°**	34,83	**25,44**	41,19	**28,94**	48,07	**31,85**	55,55	**34,97**
33°	**33°**	35,47	**25,59**	42,01	**29,09**	49,10	**31,99**	56,83	**35,10**
34°	**34°**	36,15	**25,74**	42,88	**29,25**	50,19	**32,15**	58,19	**35,25**
35°	**35°**	36,88	**25,91**	43,80	**29,43**	51,35	**32,31**	59,63	**35,41**
36°	**36°**	37,64	**26,09**	44,77	**29,61**	52,57	**32,49**	61,16	**35,58**
37°	**37°**	38,44	**26,28**	45,80	**29,80**	53,88	**32,68**	62,80	**35,76**
38°	**38°**	39,29	**26,48**	46,89	**30,01**	55,26	**32,88**	64,54	**35,96**
39°	**39°**	40,20	**26,69**	48,06	**30,23**	56,74	**33,10**	66,41	**36,17**
40°	**40°**	41,16	**26,92**	49,29	**30,46**	58,31	**33,33**	68,40	**36,40**

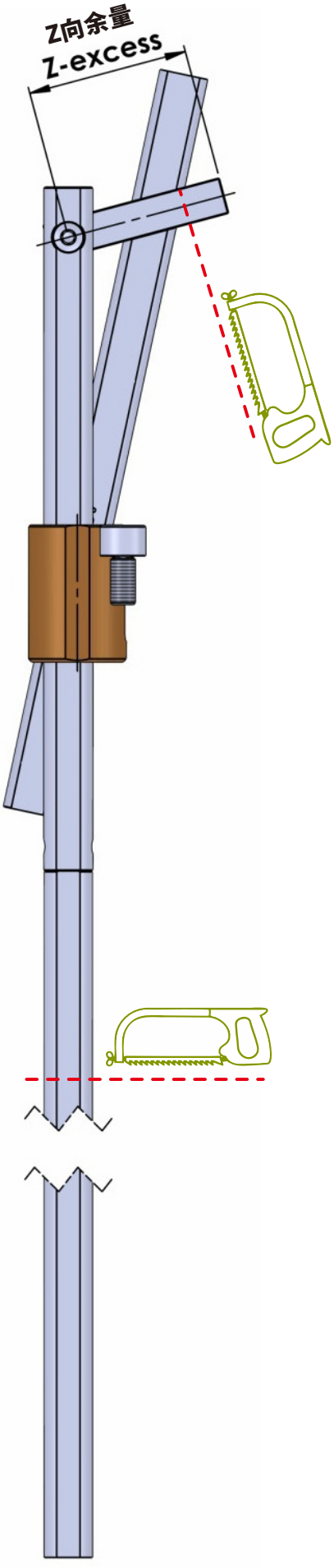
标准角度范围:40°至60° 特殊角度可按需定制。
Possible angles from +40° to -60° Especial angles upon request.

这些表格显示了基于成型零件脱模角度的脱模方向效果,假设顶出行程为 100 毫米。它应用于向上(正向)和向下(负向)的脱模方向。对于不同的顶出行程,需应用相应的校正系数。

These tables show the demolding achieved in the direction based on the exit angle of the part being molded, considering an ejection stroke of 100 millimeters. It applies to both upward (positive) and downward (negative) demolding directions. For different ejection strokes, the corresponding correction factor must be applied.

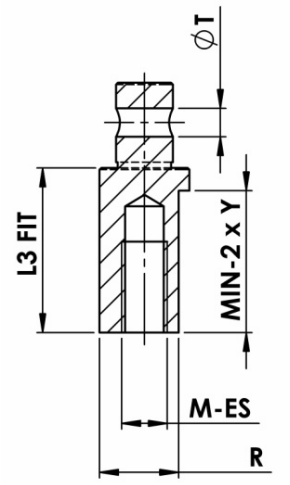
示例 Example:

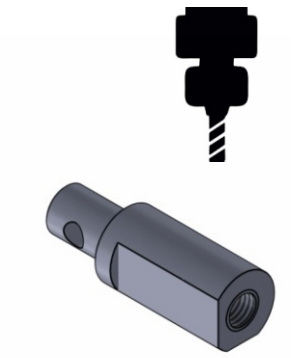
- 50mm顶出行程:将表格值乘0.5。 For a 50mm ejection stroke, multiply the table value by 0,5.
- 150mm顶出行程:将表格值乘1.5。For a 150mm ejection stroke, multiply the table value by 1,5.



在顶出行程结束时调整横杆长度
Adjust crossbar length at end of ejection stroke.

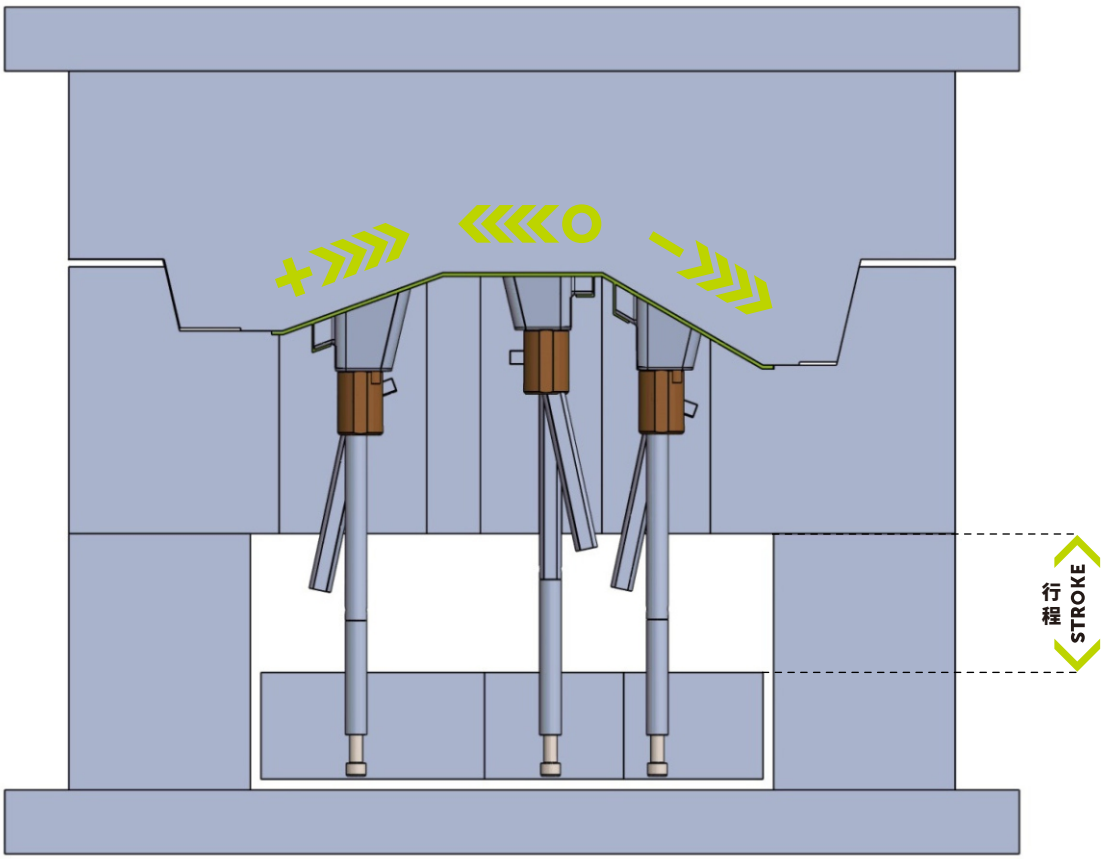
型号 MODEL	Y	R-0,05	M-ES
ACL16	7.9	7.15	M4
ACL22	**9.9**	**9.15**	**M6**
ACL32	15.8	13.9	M8
ACL42	**19.8**	**17.9**	**M10**
ACL52	24.8	22.9	M12

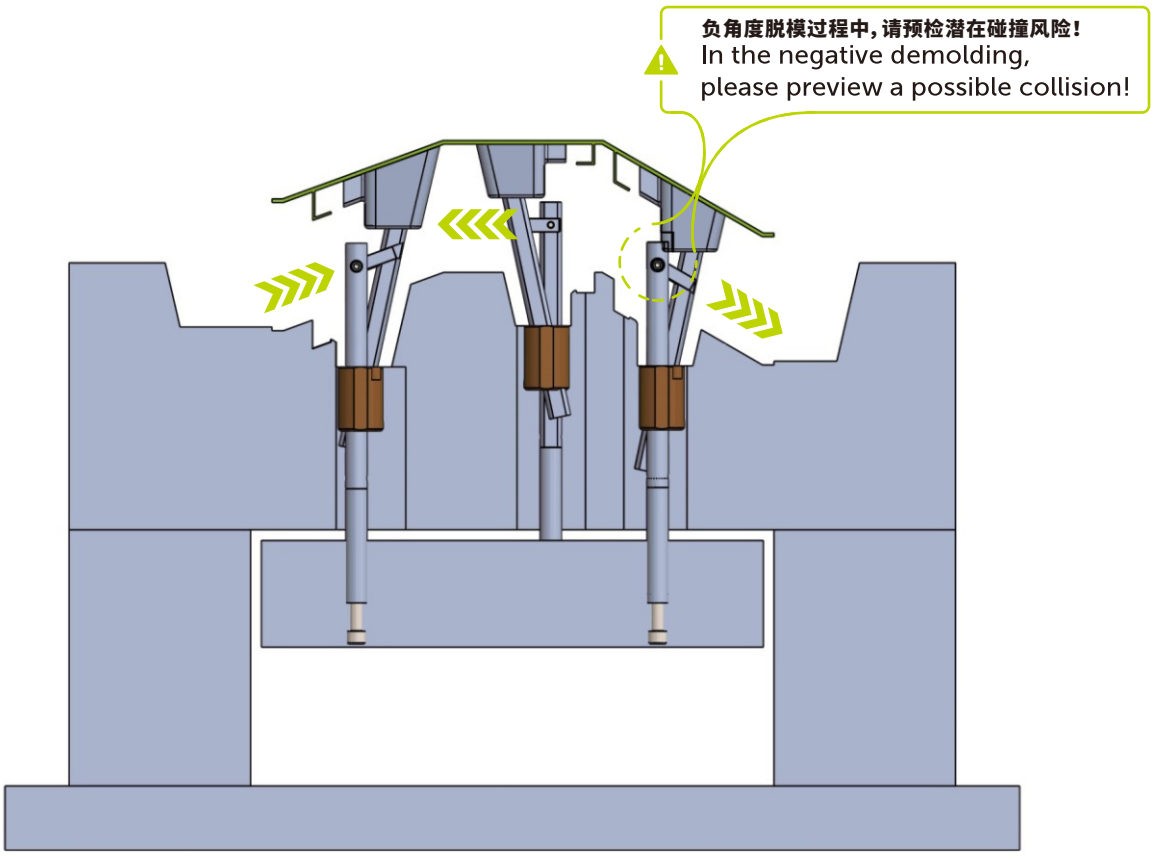


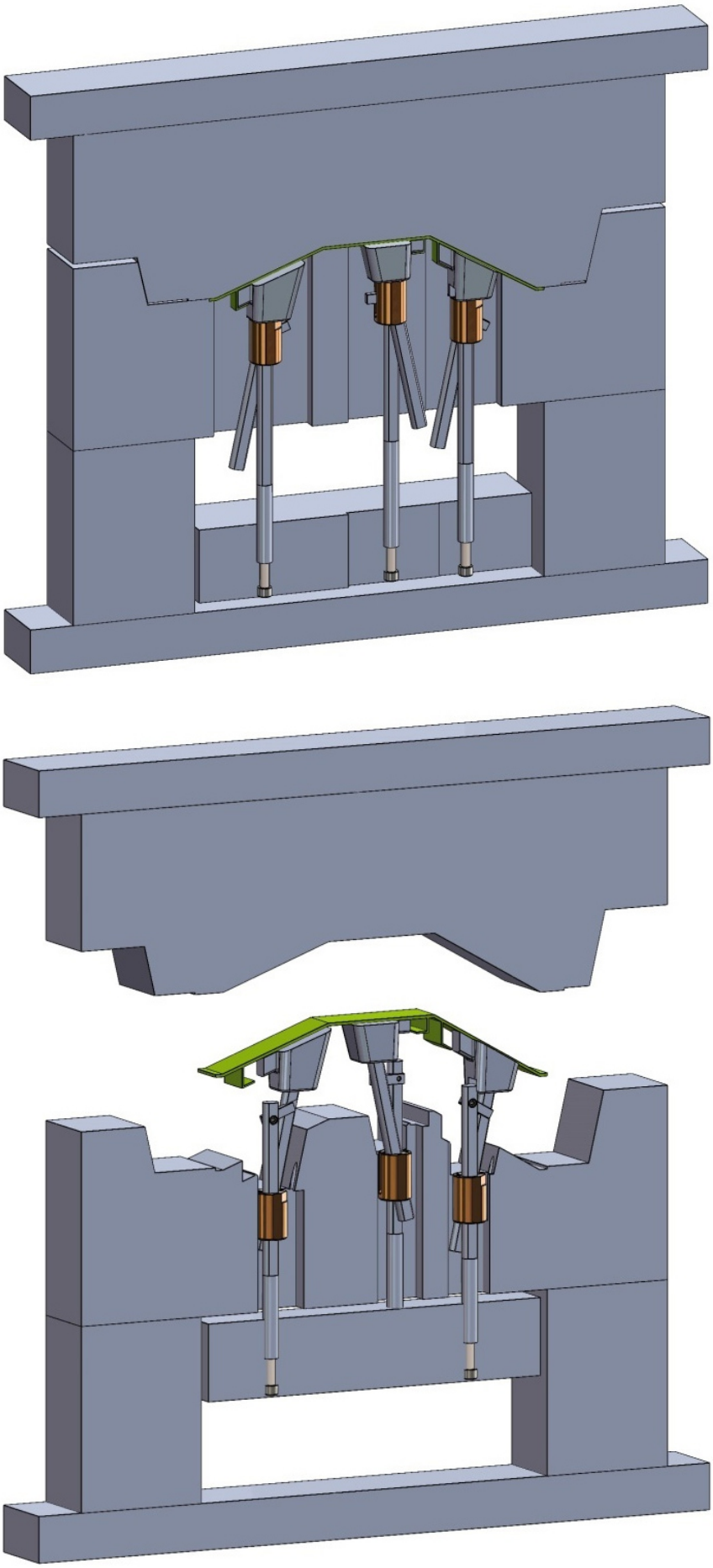


定位面
Make keying surface

M-ES 推荐使用螺纹孔
M-ES is the recommended threaded hole.


+
0
-
行程 STROKE

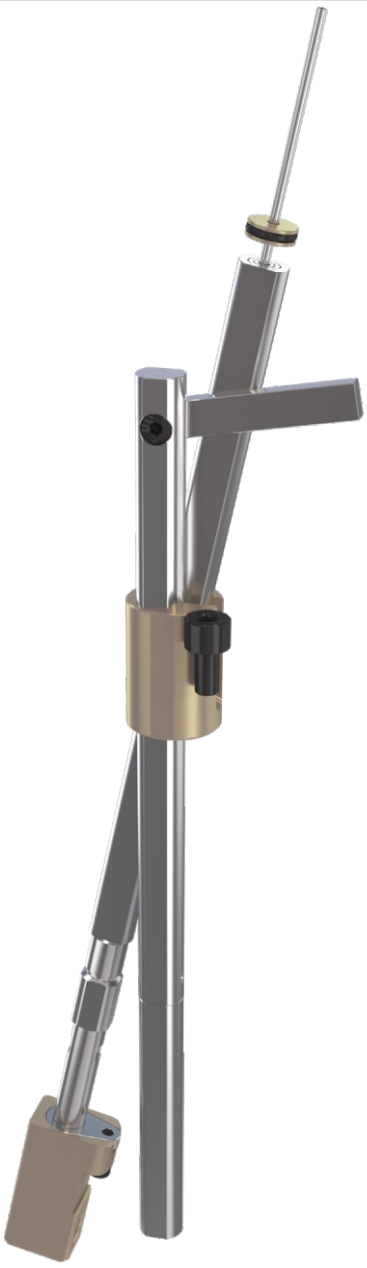

负角度脱模过程中，请预检潜在碰撞风险！
In the negative demolding,
please preview a possible collision!



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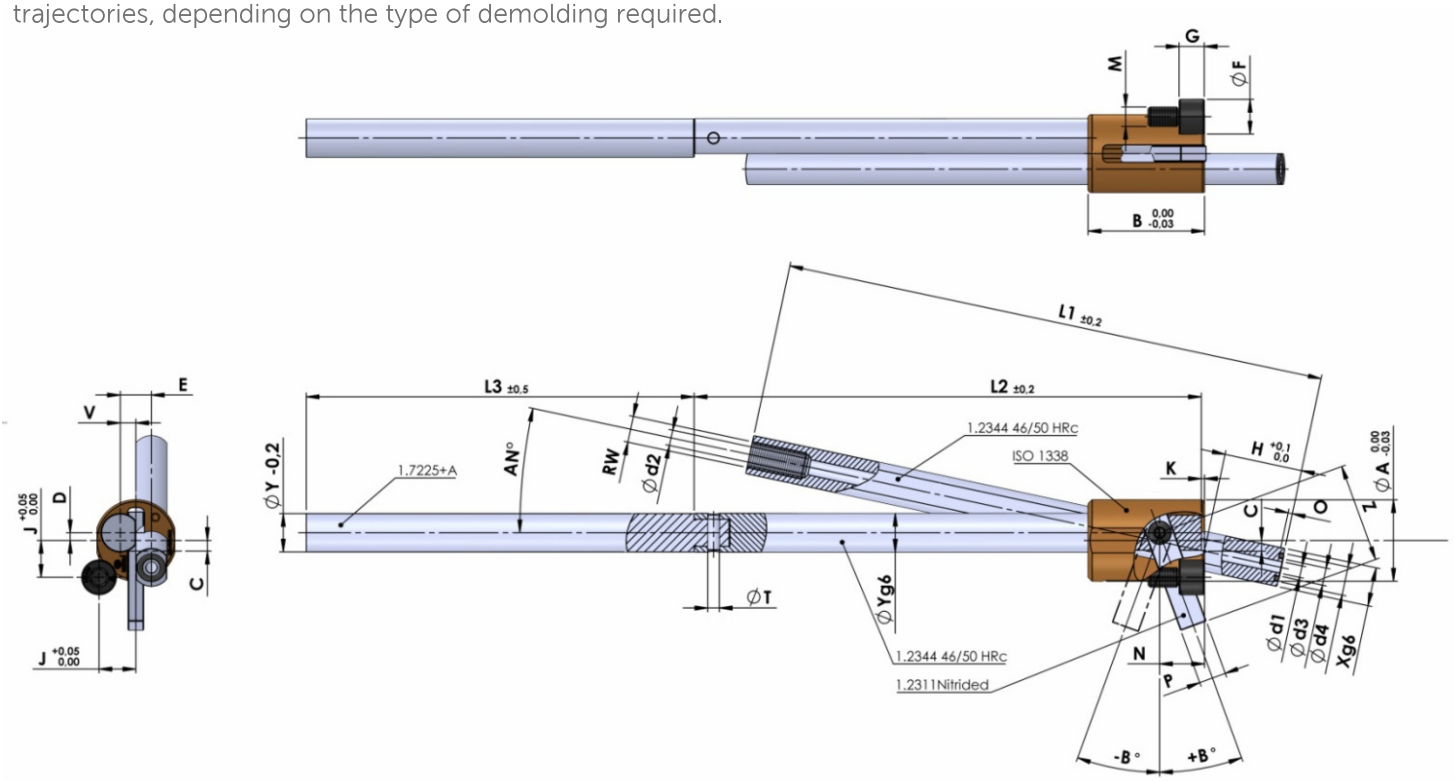
交叉式斜顶冷却系统

ANGULAR CROSS-BAR LIFTER COOLING



ACLC

这种机制使交叉杆斜顶能够通过一个轴的垂直运动来拖动另一个导向轴。在特定角度下，通过横杆连接。
This mechanism makes it possible to drag another guided axis by means of a vertical movement of one axis. at a given angle, connected by means of a crossbar.
横杆可根据需要调整角度从而使斜向轴能够沿不同轨迹运动，以满足各种脱模需求。
This crossbar can be positioned at different angles as required, This allows the angled axis to be moved along different trajectories, depending on the type of demolding required.



型号 MODEL	行程 STROKE	通用尺寸 | GENERAL DIMENSIONS | (mm)																												
		ØA	AN°	B	C	D	Ød1	Ød2	Ød3	Ød4	E	ØF	G	H	J	K	L1	L2	L3	M	N	O	P	RW	S	T	V	ØX	ØY	Z
ACLC3208-LH/RH	<100/150>		8°																											
ACLC3212-LH/RH	<100/150>		12°																											
ACLC3216-LH/RH	<100/150>	32	16°	45	3,5	3	4	7	6	10,8	12	15	10	30	15	1	248	225	300	M8	17,5	1,7	12	1/8"	6,5	5	6	16	16	63
ACLC3220-LH-RH	<100/150>		20°																											
ACLC32XX-LH/RH	<100/150>		X°																											
ACLC4208-LH/RH	<100/175>		8°																											
ACLC4212-LH/RH	<100/175>		12°																											
ACLC4216-LH/RH	<100/175>	42	16°	60	5,5	4	6	8	9	14,8	16	18	13	40	19	2	280	261,5	300	M10	23,5	2,2	14	1/4"	8	6	8	20	20	76
ACLC4220-LH-RH	<100/175>		20°																											
ACLC42XX-LH/RH	<100/175>		X°																											

选型示例 SELECTION EXAMPLE:

我们需要型号ACL32的交叉杆斜顶倾斜10°来脱模产品一侧25mm的倒扣。我们的顶出行程是125mm，但参数表显示我们需要采用100mm的顶出行程。在顶出参数表中在10°轴我们需要查找对应的数值，当该数值乘以1.25倍安全系数后，仍超出我们25mm的倒扣量，此时需要同时校核最小基角参数值。这种情况下就可以选ACL32LH1210P或者ACLC32RH1210P型号。
We need an ACL32 to remove a 25mm undercut on one side of a part that is tilted at a 10° positive angle. We have an ejection stroke of 125mm, but the table shows a stroke of 100mm that we need to use. In the ejection table, on the 10° positive axis, we look for the value that, when multiplied by 1.25, exceeds the 25mm undercut we have, while considering the value of the minimum base angle. In this case, it indicates either an ACLC32LH1210P or an ACLC32RH1210P.

参考型号XX或者特殊系列，可提供6°, 8°, 10°, 12°, 14°, 16°, 18°和20°的基板倾斜角，能够适配不同顶出行程需求，包括更大的 A=Ø52，轴Ø25的型号。
Models named XX, or special, may have bases with angles of 6, 8, 10, 12, 14, 16, 18 and 20 degrees of inclination, adapted to specific ejection strokes, as well as a larger model with A=Ø52 and Ø25 axes.

基角:6°,8°,10°和12°
Base angles: 6°, 8°, 10° and 12°

角度B° ANGLE B°		100mm脱模参数对照表 DEMOLDING VALUES FOR 100mm STROKE							
POSITIVE +B°	NEGATIVE -B°	BASE 6°		BASE 8°		BASE 10°		BASE 12°	
0°		10,51		14,05		17,63		21,25	
1°	-1°	10,53	10,49	14,09	14,02	17,69	17,58	21,34	21,18
2°	-2°	10,56	10,48	14,13	13,99	17,75	17,54	21,43	21,00
3°	-3°	10,58	10,47	14,18	13,97	17,82	17,50	21,53	20,95
4°	-4°	10,61	10,46	14,23	13,95	17,90	17,46	21,63	20,91
5°	-5°	10,65	10,45	14,28	13,94	17,98	17,43	21,74	20,87
6°	-6°	10,69	10,45	14,34	13,93	18,06	17,41	21,86	20,84
7°	-7°	10,73	10,45	14,41	13,92	18,16	17,39	21,99	20,82
8°	-8°	10,77	10,46	14,48	13,92	18,26	17,38	22,13	20,80
9°	-9°	10,82	10,47	14,55	13,92	18,37	17,37	22,27	20,80
10°	-10°	10,87	10,48	14,63	13,93	18,48	17,36	22,42	20,79
12°	-12°	10,93	10,49	14,72	13,94	18,60	17,37	22,59	20,80
13°	-13°	11,06	10,53	14,91	13,97	18,86	17,39	22,94	20,82
14°	-14°	11,12	10,56	15,01	13,99	19,01	17,41	23,13	20,84
15°	-15°	11,20	10,58	15,12	14,02	19,16	17,43	23,34	20,87
17°	-17°	11,27	10,61	15,23	14,05	19,32	17,46	23,55	20,91
18°	-18°	11,44	10,69	15,48	14,13	19,67	17,54	24,01	21,00
19°	-19°	11,53	10,73	15,62	14,18	19,85	17,58	24,26	21,05
20°	-20°	11,63	10,77	15,76	14,23	20,05	17,63	24,52	21,11
21°	-21°	11,73	10,82	15,91	14,28	20,26	17,69	24,79	21,18
22°	-22°	11,84	10,87	16,07	14,34	20,48	17,75	25,08	21,26
23°	-23°	11,95	10,93	16,24	14,41	20,71	17,82	25,38	21,34
24°	-24°	12,07	10,99	16,41	14,48	20,95	17,90	25,70	21,43
25°	-25°	12,19	11,06	16,59	14,55	21,20	17,98	26,03	21,53
26°	-26°	12,33	11,12	16,79	14,63	21,46	18,06	26,39	21,63
27°	-27°	12,46	11,20	16,99	14,72	21,74	18,16	26,75	21,74
28°	-28°	12,61	11,27	17,20	14,81	22,04	18,26	27,14	21,86
29°	-29°	12,76	11,36	17,43	14,91	22,34	18,37	27,55	21,99
30°	-30°	12,92	11,44	17,66	15,01	22,67	18,48	27,98	22,13
31°	-31°	13,09	11,53	17,91	15,12	23,01	18,60	28,43	22,27
32°	-32°	13,26	11,63	18,17	15,23	23,37	18,73	28,90	22,42
33°	-33°	13,45	11,73	18,44	15,36	23,74	18,86	29,40	22,59
34°	-34°	13,65	11,84	18,73	15,48	24,14	19,01	29,93	22,76
35°	-35°	13,85	11,95	19,03	15,62	24,56	19,16	30,49	22,94
36°	-36°	14,07	12,07	19,35	15,76	25,00	19,32	31,07	23,13
37°	-37°	14,29	12,19	19,68	15,91	25,46	19,49	31,69	23,34
38°	-38°	14,53	12,33	20,03	16,07	25,95	19,67	32,35	23,55
39°	-39°	14,78	12,46	20,41	16,24	26,47	19,85	33,04	23,77
40°	-40°	15,05	12,61	20,80	16,41	27,01	20,05	33,77	24,01

标准角度范围:40°至60° 特殊角度可按需定制。
Possible angles from +40° to -60°
Especial angles upon request.

基角:14°,16°,18°和20°
Base angles: 14°, 16°, 18° and 20°

角度B° ANGLE B°		100mm脱模参数对照表 DEMOLDING VALUES FOR 100mm STROKE							
POSITIVE +B°	NEGATIVE -B°	BASE 14°		BASE 16°		BASE 18°		BASE 20°	
0°		24,93		28,67		32,49		36,39	
1°	**1°**	25,05	**24,83**	28,82	**28,54**	32,68	**32,31**	36,64	**36,17**
2°	**2°**	25,17	**24,73**	28,98	**28,67**	32,88	**32,15**	36,89	**35,96**
3°	**3°**	25,30	**24,64**	29,15	**28,55**	33,10	**31,99**	37,16	**35,76**
4°	**4°**	25,44	**24,57**	29,33	**28,44**	33,33	**31,85**	37,44	**35,58**
5°	**5°**	25,59	**24,49**	29,52	**28,34**	33,57	**31,71**	37,74	**35,41**
6°	**6°**	25,74	**24,43**	29,73	**28,25**	33,83	**31,59**	38,05	**35,25**
7°	**7°**	25,91	**24,37**	29,94	**28,17**	34,10	**31,48**	38,39	**35,10**
8°	**8°**	26,09	**24,33**	30,17	**28,10**	34,38	**31,38**	38,74	**34,97**
9°	**9°**	26,28	**24,28**	30,41	**28,03**	34,68	**31,29**	39,11	**34,84**
10°	**10°**	26,48	**24,25**	30,67	**27,98**	35,00	**31,21**	39,49	**34,73**
12°	**12°**	26,69	**24,23**	30,94	**27,93**	35,33	**31,13**	39,90	**34,63**
13°	**13°**	27,15	**24,20**	31,52	**27,86**	36,05	**31,02**	40,78	**34,46**
14°	**14°**	27,40	**24,19**	31,83	**27,84**	36,44	**30,98**	41,26	**34,39**
15°	**15°**	27,66	**24,20**	32,16	**27,83**	36,85	**30,94**	41,75	**34,33**
17°	**17°**	27,93	**24,21**	32,50	**27,82**	37,27	**30,92**	42,28	**34,29**
18°	**18°**	28,53	**24,25**	33,25	**27,84**	38,20	**30,90**	43,40	**34,22**
19°	**19°**	28,85	**24,28**	33,65	**27,86**	38,69	**30,91**	44,01	**34,21**
20°	**20°**	29,18	**24,33**	34,07	**27,89**	39,21	**30,92**	44,65	**34,20**
21°	**21°**	29,53	**24,37**	34,51	**27,93**	39,76	**30,94**	45,32	**34,21**
22°	**22°**	29,90	**24,43**	34,98	**27,98**	40,34	**30,98**	46,02	**34,22**
23°	**23°**	30,29	**24,49**	35,47	**28,03**	40,95	**31,02**	46,77	**34,25**
24°	**24°**	30,70	**24,57**	35,98	**28,10**	41,58	**31,07**	47,55	**34,29**
25°	**25°**	31,13	**24,64**	36,52	**28,17**	42,25	**31,13**	48,37	**34,33**
26°	**26°**	31,58	**24,73**	37,09	**28,25**	42,96	**31,21**	49,24	**34,39**
27°	**27°**	32,05	**24,83**	37,69	**28,34**	43,70	**31,29**	50,15	**34,46**
28°	**28°**	32,55	**24,93**	38,32	**28,44**	44,48	**31,38**	51,11	**34,54**
29°	**29°**	33,08	**25,05**	38,98	**28,55**	45,31	**31,48**	52,13	**34,63**
30°	**30°**	33,63	**25,17**	39,68	**28,67**	46,18	**31,59**	53,21	**34,73**
31°	**31°**	34,21	**25,30**	40,42	**28,80**	47,10	**31,71**	54,35	**34,84**
32°	**32°**	34,83	**25,44**	41,19	**28,94**	48,07	**31,85**	55,55	**34,97**
33°	**33°**	35,47	**25,59**	42,01	**29,09**	49,10	**31,99**	56,83	**35,10**
34°	**34°**	36,15	**25,74**	42,88	**29,25**	50,19	**32,15**	58,19	**35,25**
35°	**35°**	36,88	**25,91**	43,80	**29,43**	51,35	**32,31**	59,63	**35,41**
36°	**36°**	37,64	**26,09**	44,77	**29,61**	52,57	**32,49**	61,16	**35,58**
37°	**37°**	38,44	**26,28**	45,80	**29,80**	53,88	**32,68**	62,80	**35,76**
38°	**38°**	39,29	**26,48**	46,89	**30,01**	55,26	**32,88**	64,54	**35,96**
39°	**39°**	40,20	**26,69**	48,06	**30,23**	56,74	**33,10**	66,41	**36,17**
40°	**40°**	41,16	**26,92**	49,29	**30,46**	58,31	**33,33**	68,40	**36,40**

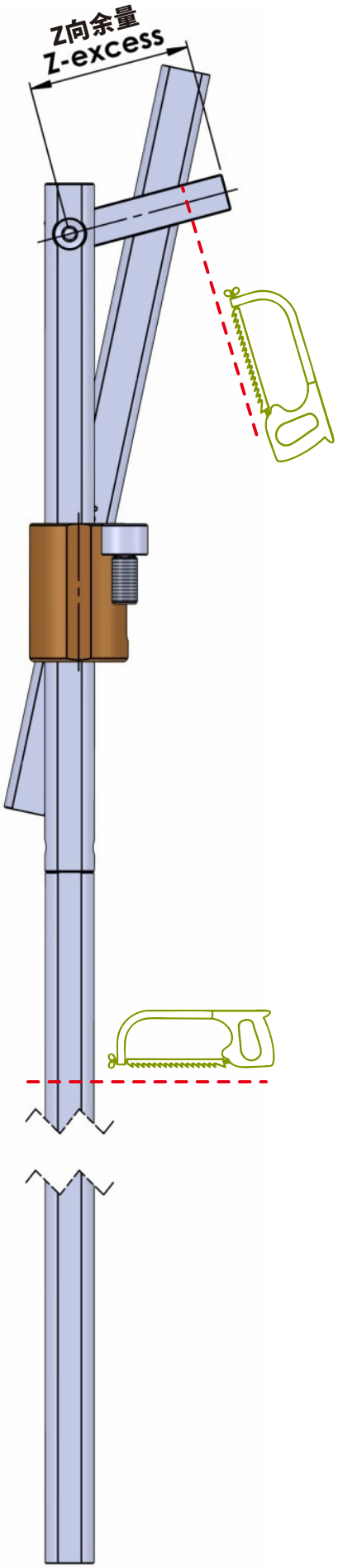
标准角度范围:40°至60° 特殊角度可按需定制。
Possible angles from +40° to -60° Especial angles upon request.

本表格展示了基于倒扣脱模角度实现的脱模方向效果,以100mm顶出行程为基准。.适用于正向(向上)和负面(向下)两种脱模方向。对于不同的顶出行程,需应用相应的校正系数。

These tables show the demolding achieved in the direction based on the exit angle of the part being molded, considering an ejection stroke of 100 millimeters. It applies to both upward (positive) and downward (negative) demolding directions. For different ejection strokes, the corresponding correction factor must be applied.

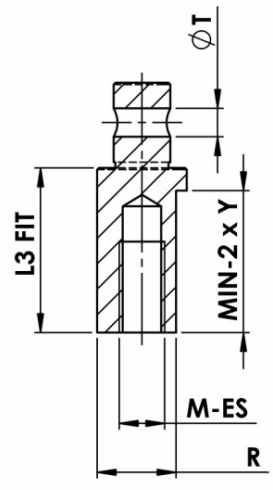
示例 Example:

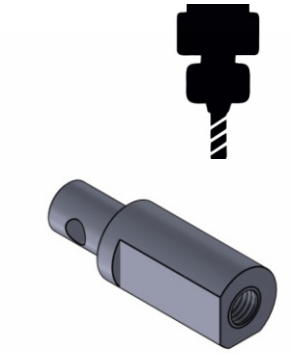
- 50mm顶出行程:将表格值乘0.5。 For a 50mm ejection stroke, multiply the table value by 0,5.
- 150mm顶出行程:将表格值乘1.5。For a 150mm ejection stroke, multiply the table value by 1,5.



在顶出行程结束时调整横杆长度
Adjust cam length at end of ejection stroke.

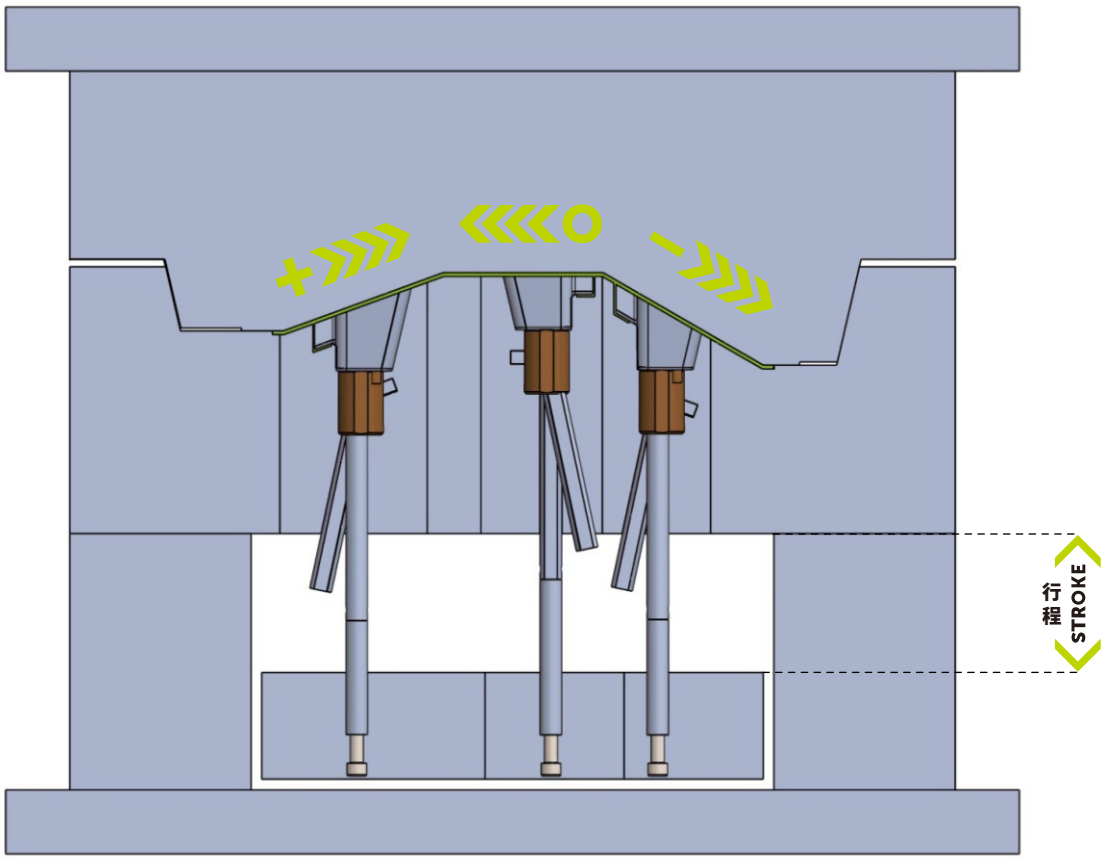
型号 MODEL	Y	R-0,05	M-ES
ACL32	15.8	13.9	M8
ACL42	**19.8**	**17.9**	**M10**

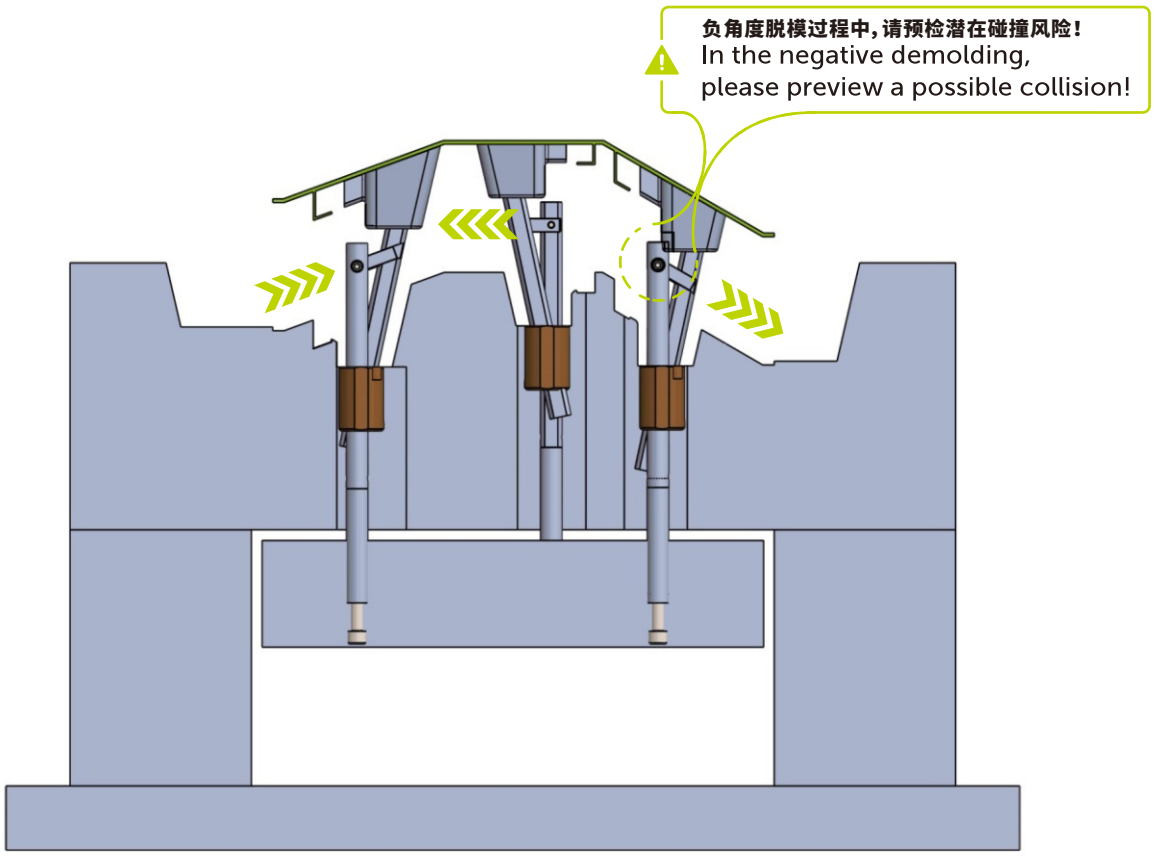


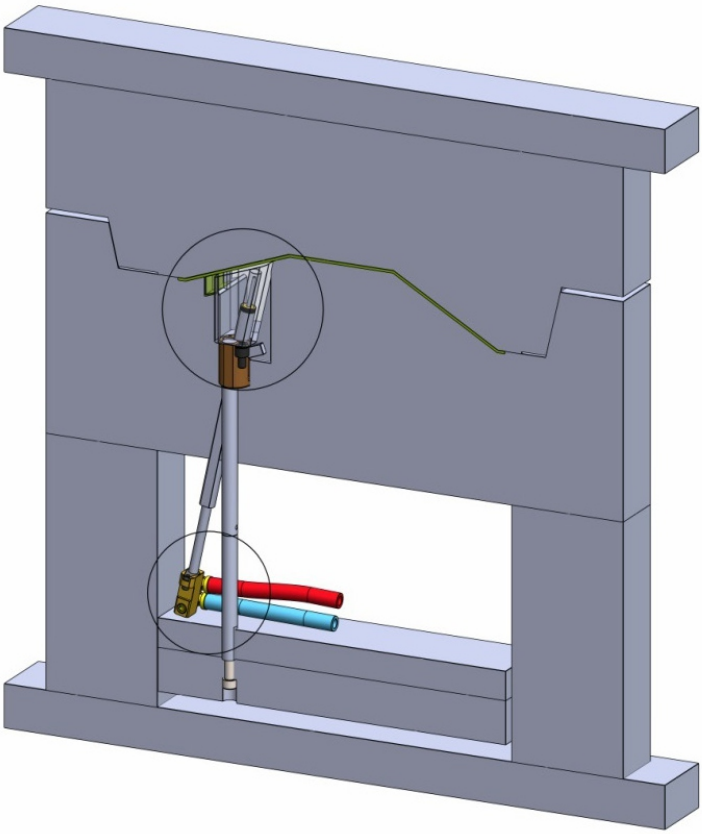


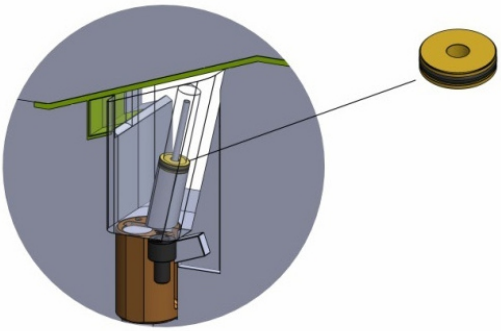
定位面
Make keying surface

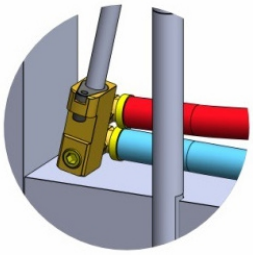
M-ES 推荐使用螺纹孔
M-ES recommended screw threaded drill.

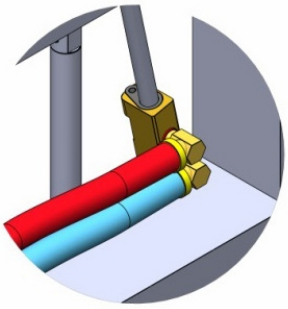

+
0
-
行程 STROKE

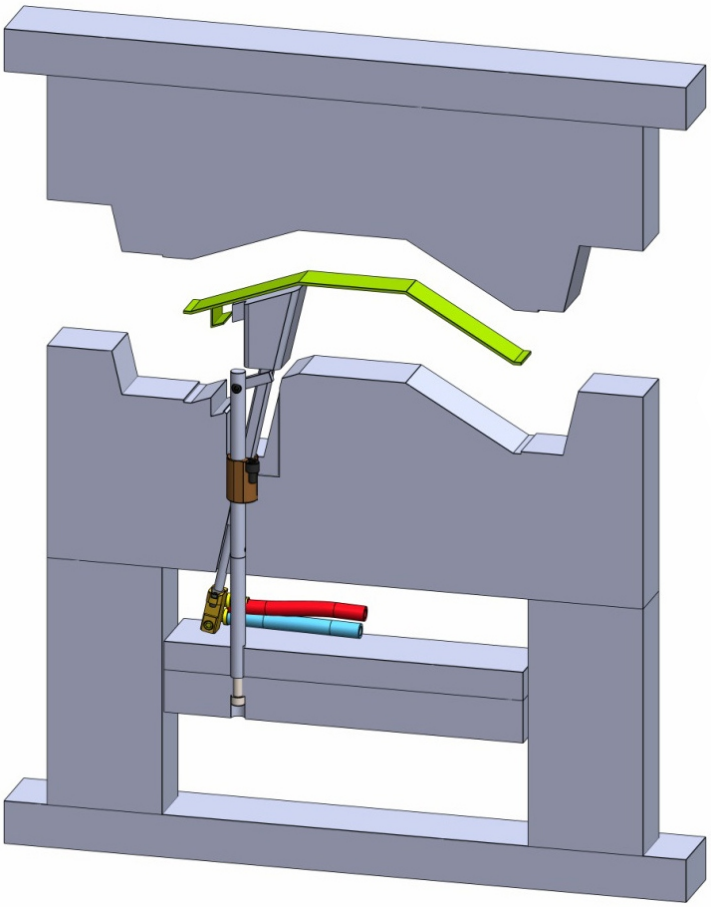

负角度脱模过程中，请预检潜在碰撞风险！
In the negative demolding,
please preview a possible collision!

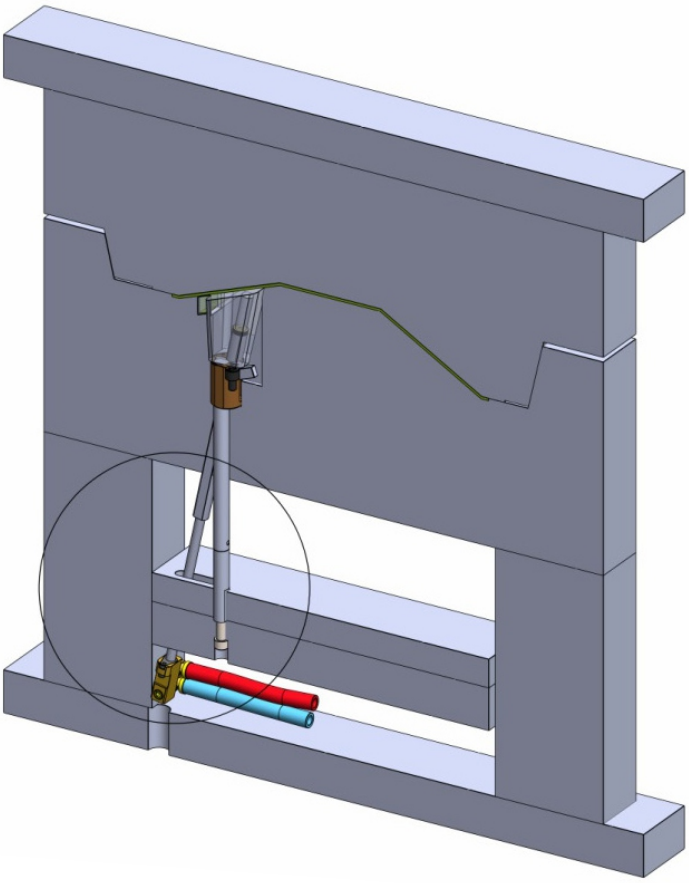


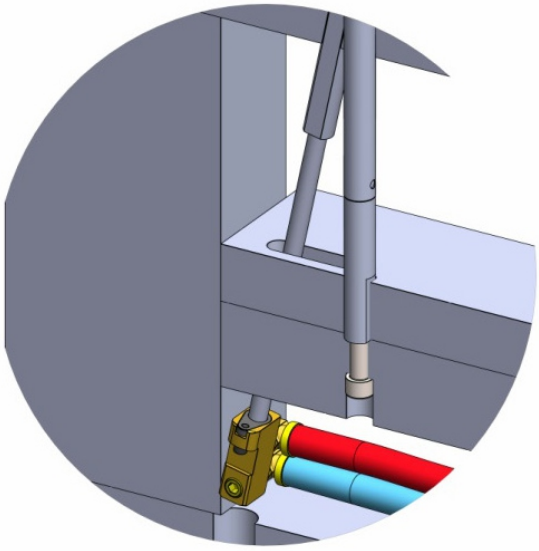


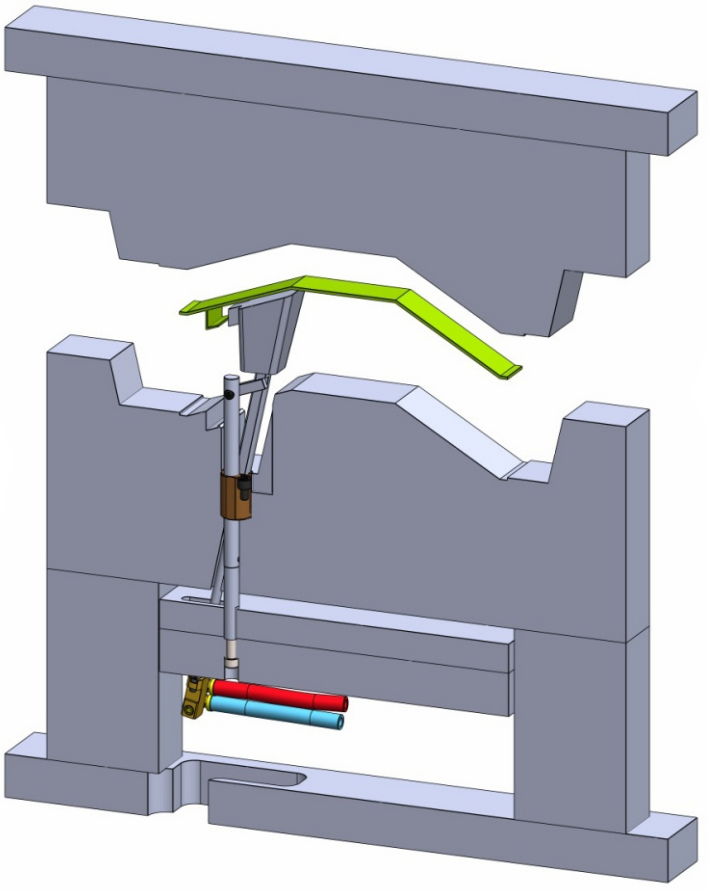












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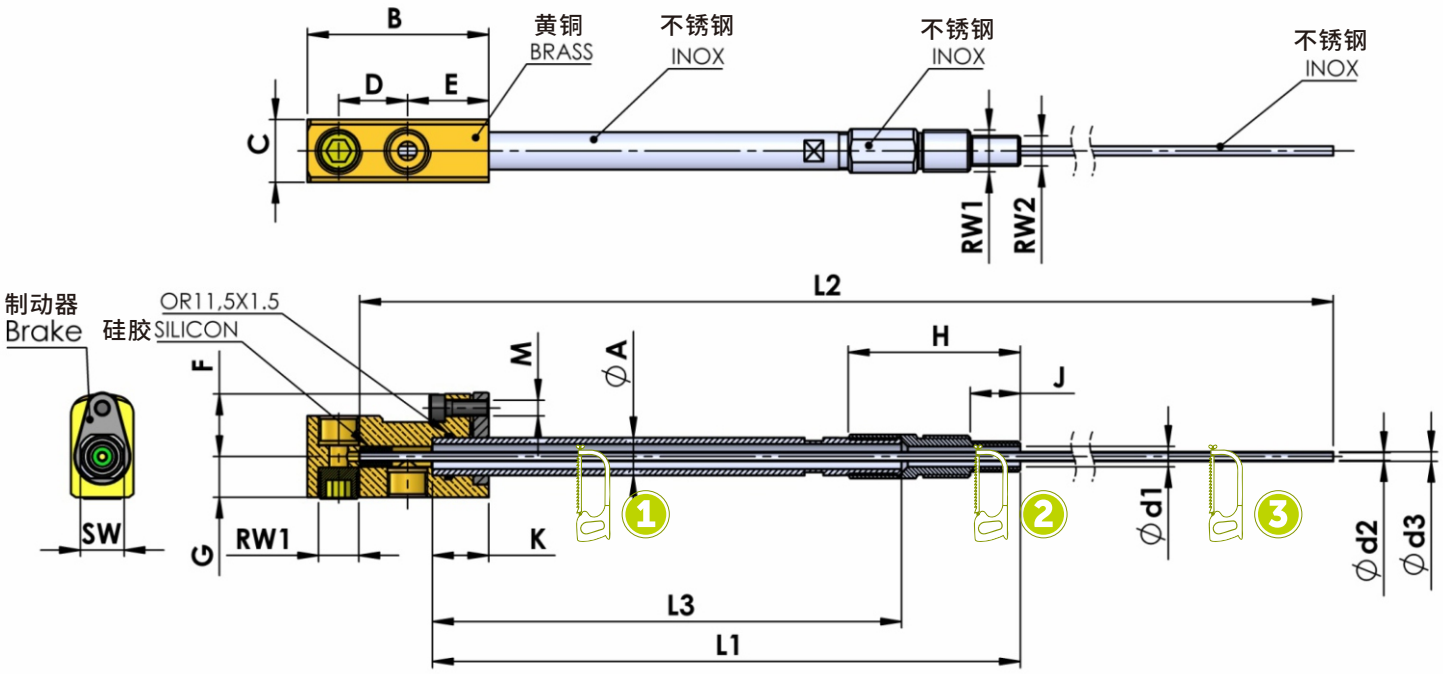
冷却水嘴系统
COOLING BUBBLER SYSTEM



CB

冷却水嘴系统
Cooling bubbler system.

该系统具备多项优势及可选配置：
This system offers several advantages and options.
冷却液通过中心内管流入，经外管排出，从而将受冷却元件的热量散发。
It allows the coolant to enter through the central inner pipe and evacuate it through the outer pipe, thus dissipating the heat from the cooled element.
支持安装标准化接头，并可灵活组合流体进出口端。
It allows the installation of standardized fittings and the combination of the fluid inlet and outlet sides.



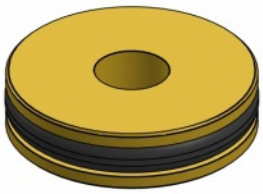
切口1，2，3的长度取决于所需尺寸及使用型号。
Cuts in lengths 1, 2, and 3 will depend on the required length and the model being used.
切口1：为了达到正确长度，切割面需打磨光滑以避免划伤内部O型圈。
For cut 1, to obtain the correct length, the cut area must be smoothed to prevent scratches on the inner O-ring.
切口2：仅ACLC42CS-L2版本需要此工序，用于加工RW1/4螺纹。
For cut 2, this is only necessary for the ACLC42CS-L2* version, which only requires the RW 1/4" thread.
切口3：用于限制冷却液的渗透深度。
For cut 3, this is to limit the depth to which the coolant must penetrate.

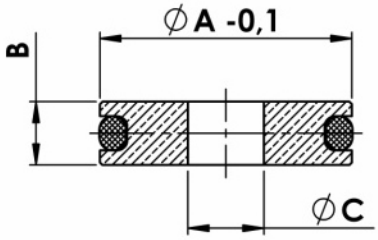
型号 MODEL	通用尺寸 | GENERAL DIMENSIONS | (mm)																				
	ACLC	ØA	B	C	D	Ød1	Ød2	Ød3	E	F	G	H	J	K	L1	L2*		M	SW	RW1	RW2
ACLC32CS-L2*	ACLC32	12	58	20	22	6,5	2,5	3	26	20	13	55	16	15	188	400	600	M5	14	1/4"	1/8"
ACLC42CS-L2*	ACLC42						3,5	4							172	400	600				

订单编号必须参考表格内+L2
The order reference must be the reference from box +L2.
示例：我们需要订购L2长度为400的ACLC42CS型号；其编号应为ACLC42CS-400
Example: We need an ACLC42CS with an L2 length of 400; its reference would be ACLC42CS-400.
其他尺寸请咨询确认。
For other measures, consult.

冷却源系统及可选配件
Cooling source system, optional accessories.

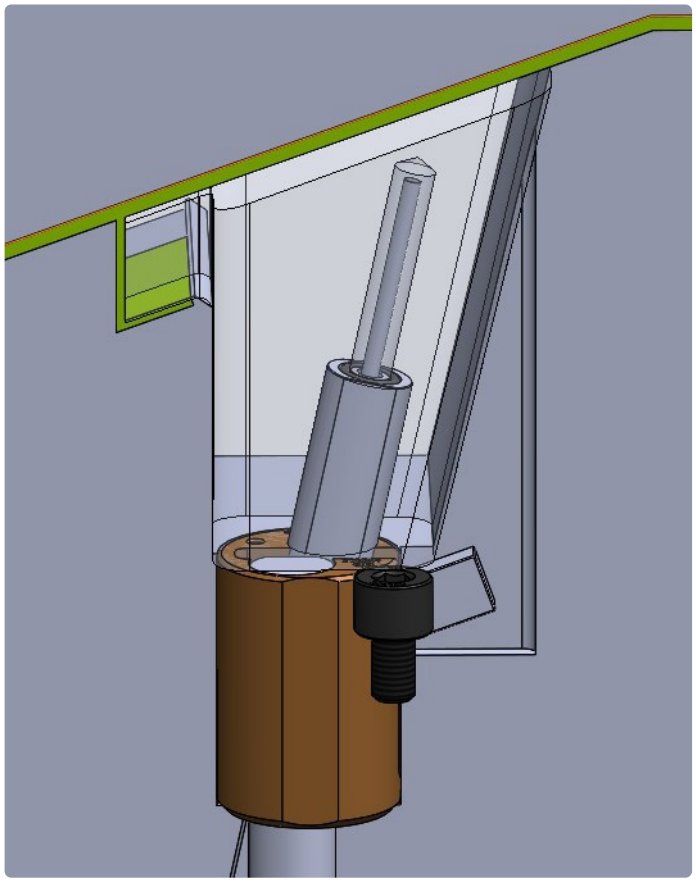
该冷却阀可以很好的扩大冷却通道的直径，从而增加模具活动镶件的冷却接触面积。
Valve, this element allows to enlarge the diameter of the cooling well, thus increasing the cooled surface in the mobile insert.



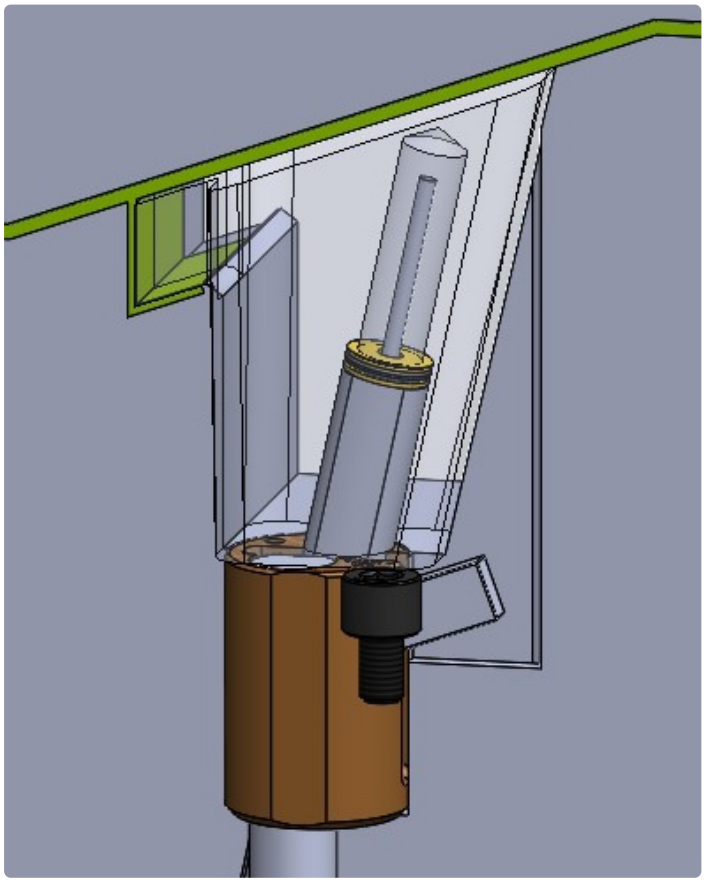


型号 MODEL	A-0,1	B	C
VA-ACL32	16	5	4
VA-ACL42	20	5	6

不带冷却阀冷却
WITHOUT VALVE



带冷却阀冷却
WITH VALVE





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