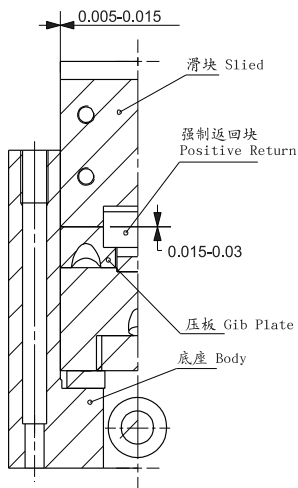
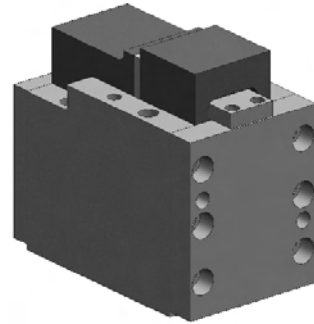


## KRCL 概要

属小型反向斜楔，其最大特点是驱动块与工作滑块的运动方向相反。  
适用于将模具的冲压方向平行转换为相反的运动方向。

## KRCL Features

KRCL is a small type reverse cam, its most important feature is the driver and the slide movement in the opposite direction.  
Applied parallel to the direction of press into the opposite direction of motion.



## 滑块结构和强制拉回块结构

见 KRCL 滑块图的文件

完全盒式导向的滑动方式，滑块和底座的单边间隙0.005~0.015mm。  
另外压板和滑块强制拉回块的间隙0.01~0.03mm。

## The Slide Structure and the Positive Return Structure.

See KRCL slide picture

Complete box-oriented sliding mode, the slide and the body of the unilateral clearance 0.005 ~ 0.015mm.

The gib plate and the Positive Return clearance 0.01 ~ 0.03mm.

## KRCL的结构、拆卸和装配

见 KRCL 结构图的文件

### 拆卸方法

取下16，取出2。  
取下17，顺滑动方向取出4。  
卸下7，其余均可取出。

### 装配方法

按与拆卸相反的顺序装配。  
确认滑动部分有无附着物，装配之前请涂抹润滑脂。  
因为滑块和底座之间有间隙要求，所以先确认刻印的件号后再组装。  
拆卸后组装不要忘记紧固螺栓。

## KRCL's Structure, Disassembly and Assembly.

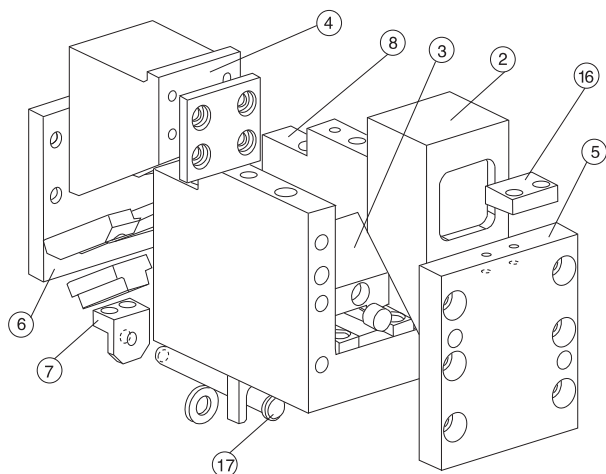
See KRCL assembly picture

### Demolition Methods

Remove the 16, remove the 2.  
Remove the 17, along the direction of sliding out 4.  
Remove the 7, the rest can be removed.

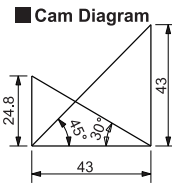
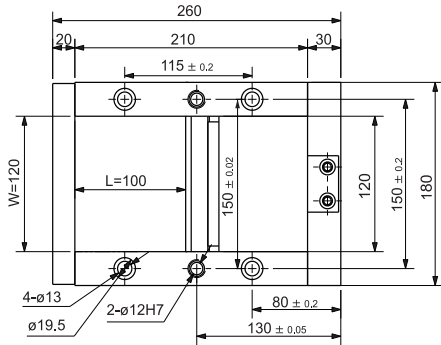
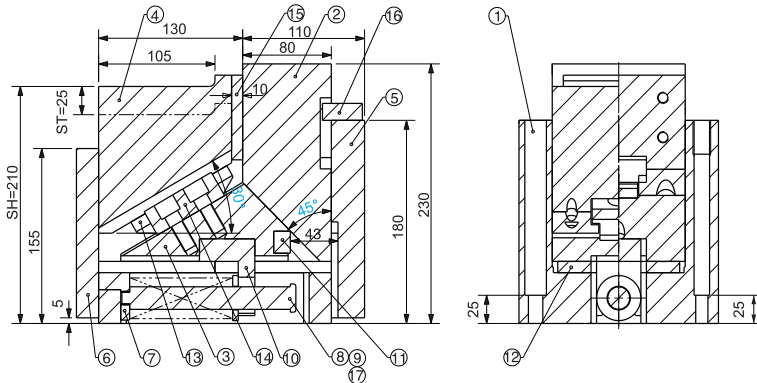
### Assembly Method

Reverse order by assembly and disassembly  
Confirm whether the sliding part of the attachments, please apply grease before assembly.  
Because the gap between the slide and the body requirements, we first identified the parts number engraved after assembly.  
Do not forget that after the demolition of fastening bolt assembly.





## KRCL120-25



### 零部件表

Table of Components

代号 No.	名称 Description	数量 Qty	材料和备注 Material and Remark
①	底座 Body	1	HT300
②	驱动块 Driver	1	HT300
③	滑块 A Slider A	1	HT300
④	滑块 B Slider B	1	HT300
⑤	挡板 A End Plate A	1	20Cr
⑥	挡板 B End Plate B	1	20Cr
⑦	导杆安装板 Fixed plate	1	45
⑧	导杆 Spring Guide Pin	1	45
⑨	弹簧垫片 Spring Washer	1	45
⑩	弹簧挡块 Spring Block	1	45
⑪	缓冲器 Return Cushion stop	1	聚氨酯
⑫	导板 Wear Plate	4	铜合金+石墨
⑬	导板 Wear Plate	2	铜合金+石墨
⑭	刚性返回器 Positive Return Follower	1	20Cr
⑮	导板 Wear Plate	1	铜合金+石墨
⑯	压板 Upper Plate	1	45
⑰	弹簧 Coil Spring	1	TL50-125

工作行程 Working Stroke	弹簧力 Return Spring	
	初压 Initial	终压 Final
25	463	3311

KRCL 120

普通型代码 Normal Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (L)	工作面宽度 Working Face Width (W)	重量 Weight (kg)
KRCL120-25	210	100	120	63



Order **Catalog No.**  
KRCL120-25

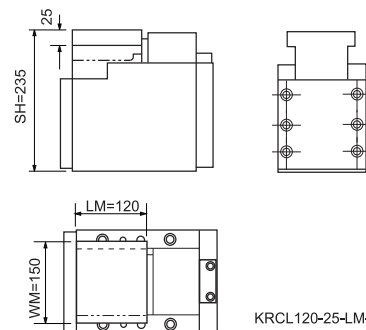
拓宽型代码 Overhang Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (LM)	工作面宽度 Working Face Width (WM)	重量 Weight (kg)
KRCL120-25-LM-WM	235	120	150	66

说明：工作面拓展能达到的最大值，LM=120，WM=150，增量为10mm。  
Note: The maximum working surface is extended forward LM=120mm, WM=150mm(at increments of 10mm).

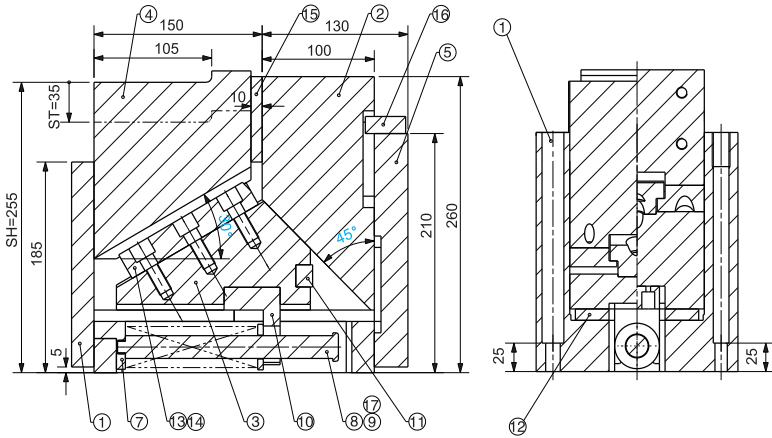


Option **Catalog No.** - LM - WM  
KRCL120-25 - LM - WM

拓展后滑块工作面“LM”和“WM”的最大值  
Tooling Overhang "LM"and"WM"Max.

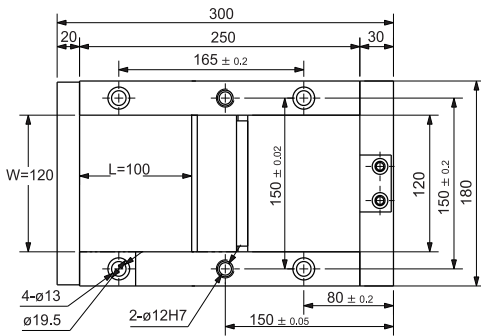


# KRCL120-35

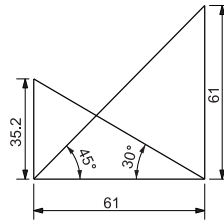


## 零部件表 Table of Components

代号 No.	名称 Description	数量 Qty	材料和备注 Material and Remark
①	底座 Body	1	HT300
②	驱动块 Driver	1	HT300
③	滑块 A Slider A	1	HT300
④	滑块 B Slider B	1	HT300
⑤	挡板 A End Plate A	1	20Cr
⑥	挡板 B End Plate B	1	20Cr
⑦	导杆安装板 Fixed plate	1	45
⑧	导杆 Spring Guide Pin	1	45
⑨	弹簧垫片 Spring Washer	1	45
⑩	弹簧挡块 Spring Block	1	45
⑪	缓冲器 Return Cushion stop	1	聚氨酯
⑫	导板 Wear Plate	4	铜合金+石墨
⑬	导板 Wear Plate	2	铜合金+石墨
⑭	刚性返回器 Positive Return Follower	1	20Cr
⑮	导板 Wear Plate	1	铜合金+石墨
⑯	压板 Upper Plate	1	45
⑰	弹簧 Coil Spring	1	TL50-175



### Cam Diagram



工作行程 Working Stroke	弹簧力 Return Spring	
	初压 Initial	终压 Final
35	425	3311

普通型代码 Normal Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (L)	工作面宽度 Working Face Width (W)	重量 Weight (kg)
KRCL120-35	255	100	120	75



Order **Catalog No.**  
KRCL120-35

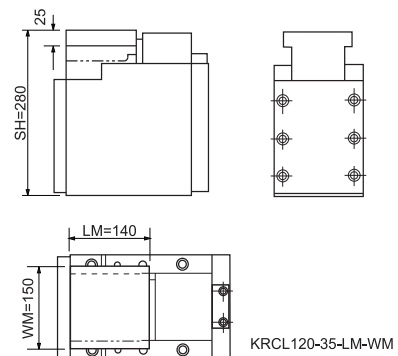
拓宽型代码 Overhang Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (LM)	工作面宽度 Working Face Width (WM)	重量 Weight (kg)
KRCL120-35-LM-WM	280	140	150	78

说明：工作面拓展能达到的最大值，LM=140，WM=150，增量为10mm。  
Note: The maximum working surface is extended forward LM=140mm, WM=150mm(at increments of 10mm).

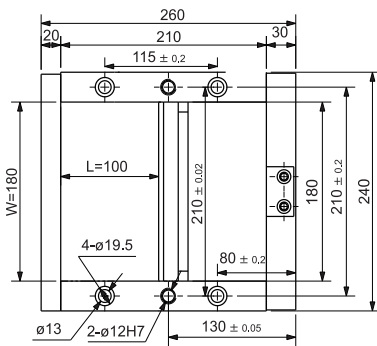
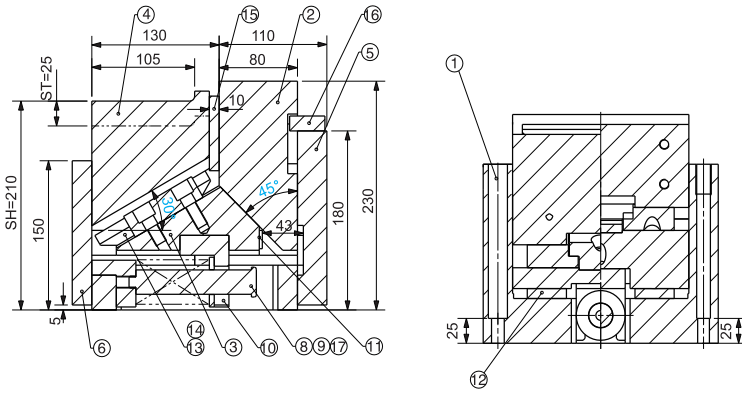


Option **Catalog No.** - **LM** - **WM**  
KRCL120-35 - LM - WM

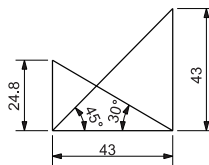
拓展后滑块工作面“LM”和“WM”的最大值  
Tooling Overhang "LM" and "WM" Max.



## KRCL180-25



Cam Diagram



工作行程 Working Stroke	弹簧力 Return Spring	
	初压 Initial	终压 Final
25	463	3311

### 零部件表 Table of Components

代号 No.	名称 Description	数量 Qty	材料和备注 Material and Remark
①	底座 Body	1	HT300
②	驱动块 Driver	1	HT300
③	滑块 A Slider A	1	HT300
④	滑块 B Slider B	1	HT300
⑤	挡板 A End Plate A	1	20Cr
⑥	挡板 B End Plate B	1	20Cr
⑦	导杆安装板 Fixed plate	1	45
⑧	导杆 Spring Guide Pin	1	45
⑨	弹簧垫片 Spring Washer	1	45
⑩	弹簧挡块 Spring Block	1	45
⑪	缓冲器 Return Cushion stop	1	聚氨酯
⑫	导板 Wear Plate	4	铜合金+石墨
⑬	导板 Wear Plate	2	铜合金+石墨
⑭	刚性返回器 Positive Return Follower	1	20Cr
⑮	导板 Wear Plate	1	铜合金+石墨
⑯	压板 Upper Plate	1	45
⑰	弹簧 Coil Spring	1	TL50-125

KRCL  
180

普通型代码 Normal Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (L)	工作面宽度 Working Face Width (W)	重量 Weight (kg)
KRCL180-25	210	100	180	90



Order **Catalog No.**  
KRCL180-25

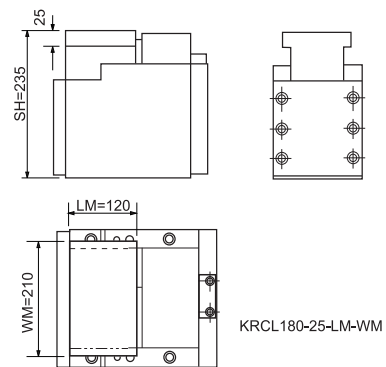
拓宽型代码 Overhang Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (LM)	工作面宽度 Working Face Width (WM)	重量 Weight (kg)
KRCL180-25-LM-WM	235	120	210	94

说明：工作面拓展能达到的最大值，LM=120，WM=210，增量为10mm。  
Note: The maximum working surface is extended forward LM=120mm, WM=210mm(at increments of 10mm).



Option **Catalog No.** - **LM** - **WM**  
KRCL180-25 - LM - WM

拓展后滑块工作面“LM”和“WM”的最大值  
Tooling Overhang "LM"and"WM"Max.

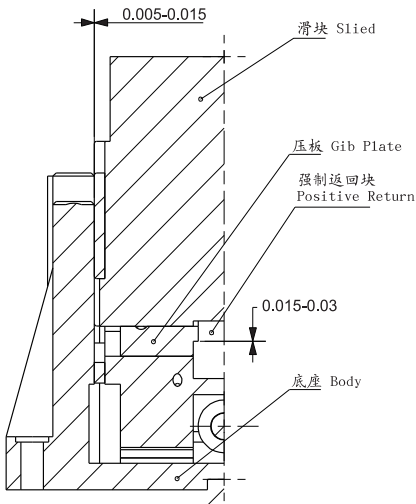
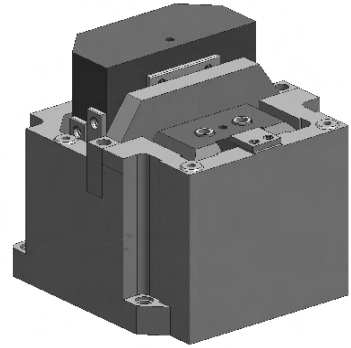


## KRCO 概要

属重型反向斜楔，其最大特点是驱动块与工作滑块的运动方向相反。  
适用于将模具的冲压方向平行转换为相反的运动方向。

## KRCO Features

KRCO is a heavy duty type reverse cam, its most important feature is the driver and the slide movement in the opposite direction.  
Applied parallel to the direction of press into the opposite direction of motion.



### 滑块结构和强制拉回块结构

见 KRCO滑块图的文件

完全盒式导向的滑动方式，滑块和底座的单边间隙0.005~0.015mm。  
另外压板和滑块强制拉回块的间隙0.01~0.03mm。

### The Slide Structure and the Positive Return Structure.

See KRCO slide picture

Complete box-oriented sliding mode, the slide and the body of the unilateral clearance 0.005 ~ 0.015mm.

The gib plate and the Positive Return clearance 0.01 ~ 0.03mm.

## KRCO的结构、拆卸和装配

见 KRCO结构图的文件

### 拆卸方法

取下15，取出3。  
取下5，顺滑动方向取出2。  
卸下19，其余均可取出。

### 装配方法

按与拆卸相反的顺序装配。  
确认滑动部分有无附着物，装配之前请涂抹润滑脂。  
因为滑块和底座之间有间隙要求，所以先确认刻印的件号后再组装。  
拆卸后组装不要忘记紧固螺栓。

## KRCO's Structure, Disassembly and Assembly.

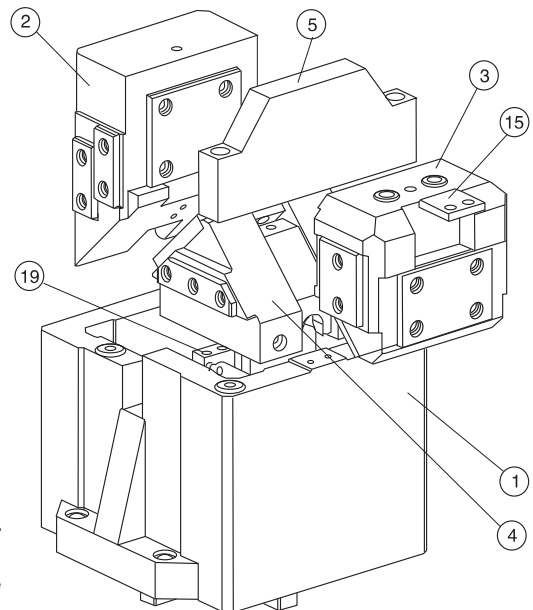
See KRCO assembly picture

### Demolition Methods

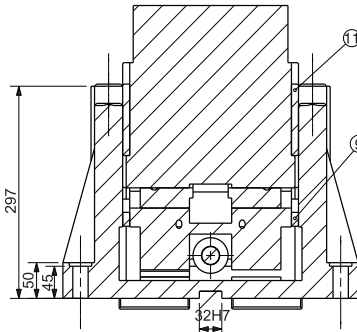
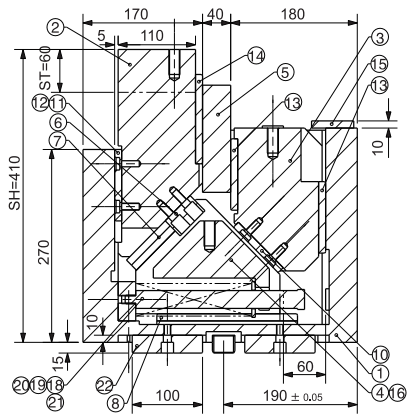
Remove the 15, remove the 3.  
Remove the 5, along the direction of sliding out 2.  
Remove the 19, the rest can be removed.

### Assembly Method

Reverse order by assembly and disassembly  
Confirm whether the sliding part of the attachments, please apply grease assembly.  
Because the gap between the slide and the body requirements, we first identified the parts number engraved after assembly.  
Do not forget that after the demolition of fastening bolt assembly.

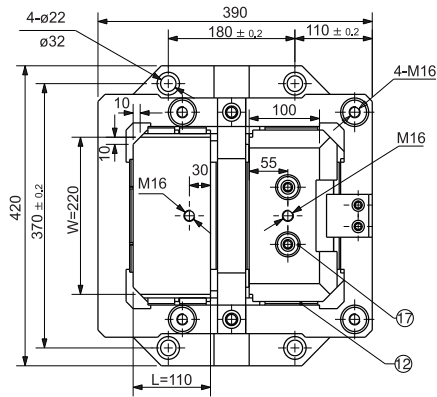


## KRCO220-60

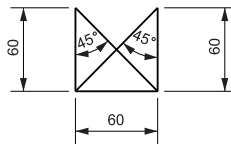


### 零部件表 Table of Components

代号 No.	名称 Description	数量 Qty	材料和备注 Material and Remark
①	底座 Body	1	QT450
②	驱动块 Driver	1	HT300
③	滑块 A Slider A	1	HT300
④	滑块 B Slider B	1	HT300
⑤	导板 Wear Plate	1	HT300
⑥	刚性返回器 Positive Return Follower	1	45
⑦	导板 Wear Plate	2	铜合金+石墨
⑧	导板 Wear Plate	1/1	铜合金+石墨
⑨	导板 Wear Plate	2	铜合金+石墨
⑩	导板 Wear Plate	1	铜合金+石墨
⑪	导板 Wear Plate	6	铜合金+石墨
⑫	导板 Wear Plate	3	铜合金+石墨
⑬	导板 Wear Plate	2	铜合金+石墨
⑭	导板 Wear Plate	1	铜合金+石墨
⑮	止动块 Stopper	1	45
⑯	缓冲器 Return Cushion stop	2	聚氨酯
⑰	缓冲器 Return Cushion stop	2	聚氨酯
⑱	弹簧 Coil Spring	1	TJL50-229
⑲	导杆安装板 Fixed plate	1	45
⑳	导杆 Spring Guide Pin	1	45
㉑	弹簧垫片 Spring Washer	1	45
㉒	定位键 Key	4	45



### Cam Diagram



工作行程 Working Stroke	弹簧力 Return Spring	
	初压 Initial	终压 Final
60	874	3496

普通型代码 Normal Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (L)	工作面宽度 Working Face Width (W)	重量 Weight (kg)
KRCO220-60	410	110	220	265



Order **Catalog No.**  
**KRCO220-60**

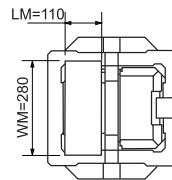
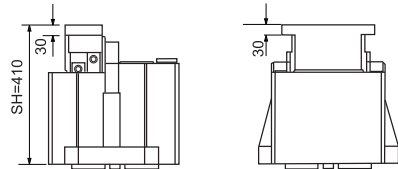
拓展型代码 Overhang Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (LM)	工作面宽度 Working Face Width (WM)	重量 Weight (kg)
KRCO220-60-LM-WM	410	110	280	270

说明：工作面拓展能达到的最大值，LM=110，WM=280，增量为10mm。  
Note: The maximum working surface is extended forward LM=110mm, WM=280mm(at increments of 10mm).



Option **Catalog No.** - **LM** - **WM**  
**KRCO220-60 - LM - WM**

拓展后滑块工作面“LM”和“WM”的最大值  
Tooling Overhang "LM" and "WM" Max.



KRCO220-60-LM-WM



# KRC0320-60

**■ 零件表  
Table of Components**

代号 No.	名称 Description	数量 Qty	材料和备注 Material and Remark
①	底座 Body	1	QT450
②	驱动块 Driver	1	HT300
③	滑块 A Slider A	1	HT300
④	滑块 B Slider B	1	HT300
⑤	导板 Wear Plate	1	HT300
⑥	刚性返回器 Positive Return Follower	1	45
⑦	导板 Wear Plate	2	铜合金+石墨
⑧	导板 Wear Plate	1/1	铜合金+石墨
⑨	导板 Wear Plate	2	铜合金+石墨
⑩	导板 Wear Plate	1	铜合金+石墨
⑪	导板 Wear Plate	6	铜合金+石墨
⑫	导板 Wear Plate	3	铜合金+石墨
⑬	导板 Wear Plate	2	铜合金+石墨
⑭	导板 Wear Plate	1	铜合金+石墨
⑮	止动块 Stopper	1	45
⑯	缓冲器 Return Cushion stop	2	聚氨酯
⑰	缓冲器 Return Cushion stop	2	聚氨酯
⑱	弹簧 Coil Spring	1	TJM50-254
⑲	导杆安装板 Fixed plate	1	45
⑳	导杆 Spring Guide Pin	1	45
㉑	弹簧垫片 Spring Washer	1	45
㉒	定位键 Key	4	45

工作行程 Working Stroke	弹簧力 Return Spring	
	初压 Initial	终压 Final
60	1312	4462

普通型代码 Normal Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (L)	工作面宽度 Working Face Width (W)	重量 Weight (kg)
KRC0320-60	410	145	320	310



Order **Catalog No.**  
**KRC0320-60**

拓宽型代码 Overhang Catalog No.	闭合高度 Shut Height (SH)	工作面长度 Working Face Width (LM)	工作面宽度 Working Face Width (WM)	重量 Weight (kg)
KRC0320-60-LM-WM	410	145	380	316

说明：工作面拓展能达到的最大值，LM=145，WM=380，增量为10mm。  
Note: The maximum working surface is extended forward LM=145mm, WM=380mm(at increments of 10mm).



Option **Catalog No.** - **LM** - **WM**  
**KRC0320-60- LM - WM**

拓展后滑块工作面“LM”和“WM”的最大值  
Tooling Overhang "LM"and"WM"Max.

SH=410

LM=145

WM=380

KRC0320-60-LM-WM