

CATALOGUE

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Electro permanent magnetic milling chuck is the best magnetic clamping tool at present, which use electro pulse to “open and close”. It is very safe and reliable when workpiece is attracted by magnetic chuck in process. After attract workpiece by magnetism, the magnetic chuck holds the magnetism permanently. “Open and close” time is less than 1 second, electric pulse consume few energy, the magnetic chuck won’t be thermal deformation. it is widely used to clamp workpiece when it is machined by milling machine and CNC.

FEATURES AND ADVANTAGES

- 1 Once clamping is available to process five sides, workpieces are allowed to be larger than the working platform.
- 2 Save 50%-90% piece handing time, improve the working efficiency of labour and machine tool, lower labour work intensity.
- 3 Not required to change machine tool or production line, as the workpiece is stressed evenly, workpiece won’t transform, no shaking in process. Extend working life of cutting tools.
- 4 The magnetic chuck is applicable to clamp various components under heavy or high-speed milling in horizontal and vertical type, is also applicable to curving, irregular, difficult clamping, batch and particular workpieces. It is applicable to rough and finish machining.

- 5 Constant clamping force, not require electricity when it is in clamp status, no radiation of magnetic line, no heating phenomenon.

BASIC PARAMETERS

Model: DYZ Series
Voltage: 3Ph 380V 50Hz or Customized
Holding force: 16kg/cm²;
Holding force of square pole: 400 kg(50*50mm) 680 kg(70*70mm)
parallelism: 0.002mm/100mm
Output Max Current: 50A
(De)magnetizing Time: 0.1~1.0s
Size of Controller: 235*185*85mm
Controller Mode: details in inspection sheet
Square Poles and numbers: details in inspection sheet
Overall size: details in inspection sheet

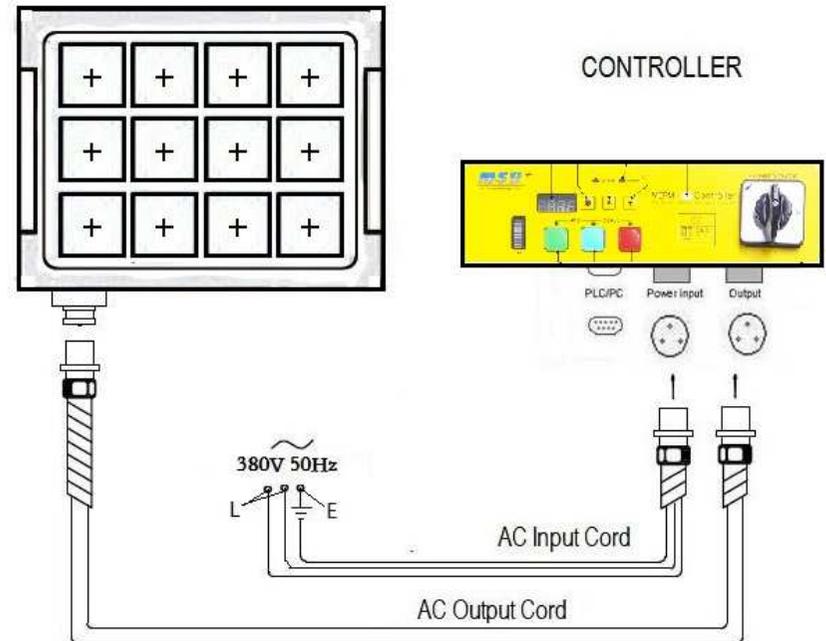
CHUCK CONNECTION

1 Preparing before Assembling

Open packing box, take out the controller and magnetic chuck, remove the packed film, clean slushing oil, the chuck is ready for mounting. Place the chuck in the suitable position of the machine

tool platform, use the clamping block(accessory) to fix it. Check the parallelism of chuck surface to the machine tool. Make it correspond to the machining requirement. Please make the connection of chuck, controller and power supply as follow picture shows.

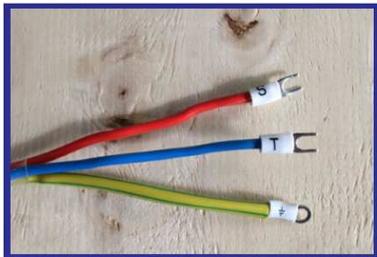
ELECTRO PERMANENT MAGNETIC CHUCK



2 Fix the chuck

	<p>Take out clamping block, insert the clamping block to the groove of chuck, then screw up tightly, the chuck is fixed.</p>
	<p>Except upper method, it is also available to fix the chuck by mounting hole. Insert the T block into T groove of machine platform, use hex screw to tighten it.</p>

3 Connect to power supply

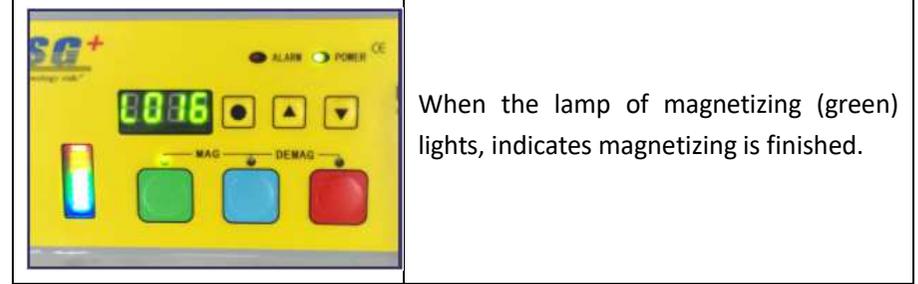
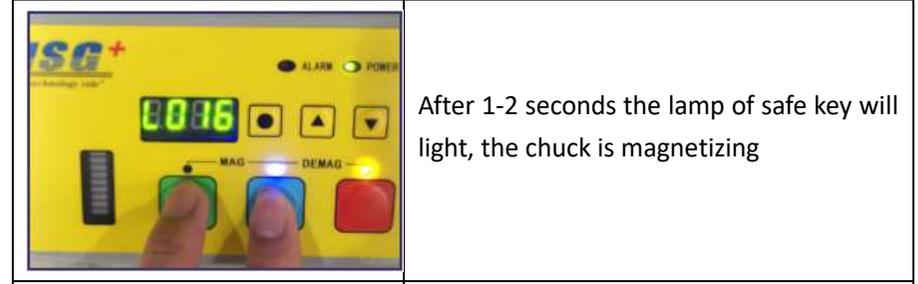
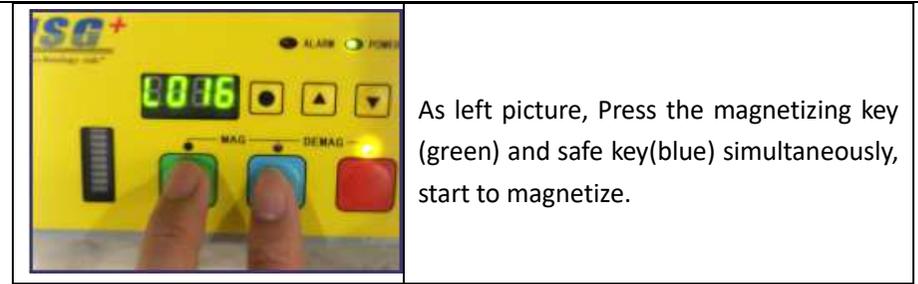
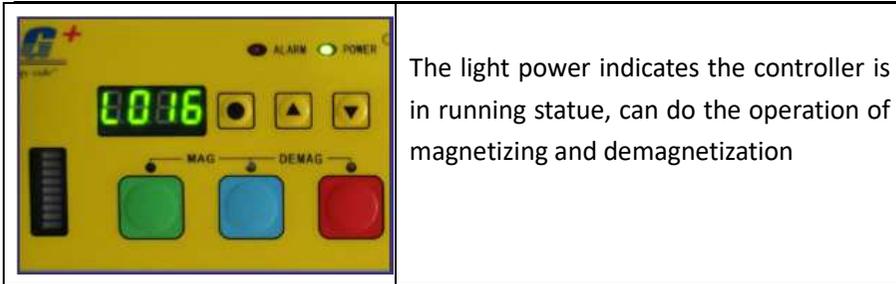
	<p>The power of the controller is 3 phase 380V, 2 wires power supply, the red and blue wires are live line, the yellow line is earth line.</p>
	<p>The red and blue wire connect with the live line of power supply. The yellow line must be connect with earth line of power supply, <u>the earth line are not allow to connect with live line, or the controller will be damaged.</u></p>

4 Swift Contactor

	<p>Before connect to swift contactor, please clean the dust inside by air gun, then check there is water, oil or foreign objects in it.</p>
	<p>Make the groove of controller (the part is circled by red) upward, then insert to the swift contactor.</p>
	<p>When the contactor contacts with the joint of chuck, rotate in right, clip into the joint and tighten it, when listen to the sound of "ka", the connection is complete.</p>

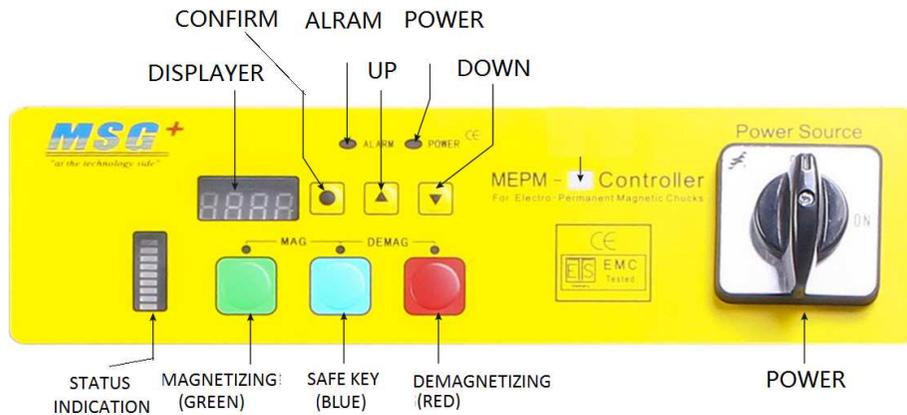
5 Start switch

	<p>After connect with power supply, rotate the switch in the controller from 0 to 1, open the power.</p>
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OPERATION INSTRUCTION

1 Operation Panel



2 Magnetizing

When operate the controller, if the signal lamp twinkle and the controller is no response, it indicates that it is the abnormal operation. At the time, close the controller, start it again, it will be normal,

3 Demagnetizing

	<p>As left picture, Press the demagnetizing key (red) & safe key (blue) simultaneously, start to demagnetize.</p>
	<p>After 1-2 seconds the lamp of safe key will light, the chuck is demagnetizing</p>
	<p>When the lamp of demagnetizing (red) lights, indicates demagnetizing is finished.</p>

Open the power for several seconds, when the displayer shows L016, it allows to adjust, press ▼ to reduce the level, press ▲ to increase the level, the digital in displayer will change according to the time of pressing, when it shows L001 the strength is the minimum.

If want to change the default strength, after adjust to the level which is need, press ● for seconds, finish the setting, close and open again, the default value is changed

MATTERS NEED ATTENTION

- 1 Do not drill in the chuck surface directly, if it is required please contact with our company.
- 2 The connector must be clean and dried. Every time before use it, please use air gun to remove the scrap iron, water or other impurity. Or it may cause short out.
- 3 Cover and lock the connector quickly after machining.

4 Adjust The Strength Of Holding Force

The default strength of the chuck is level 16(maximum), generally it is not need to adjust it, if some special requirements need to adjust it, can do it as follow instructions.

Packing list

No.	Name	Quantity	Remark
1	Electro Permanent magnetic chuck	1 set	
2	Power Cord	1 pc	
3	Clamping Plate, Screw	4 sets	
4	Instruction manual	1 pc	

Inspector:

Date:

INSPECTION SHEET

Product No.: _____ Model: _____
Product Date: _____

The product is executes standard Q/JBDP-4k-2016, passed inspection, approve to deliver

Inspector:

Quality Controller:

Date:

Date: