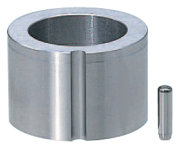
# GFSDS · GFDDS · GFDRS GFDES · GFDGS

## 沖孔下模

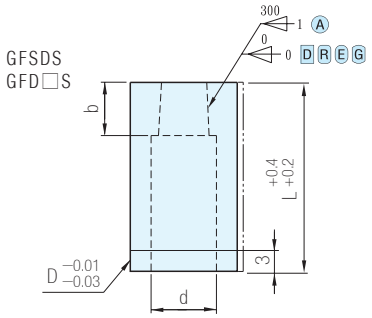
火焰淬火 · 定位銷止動型

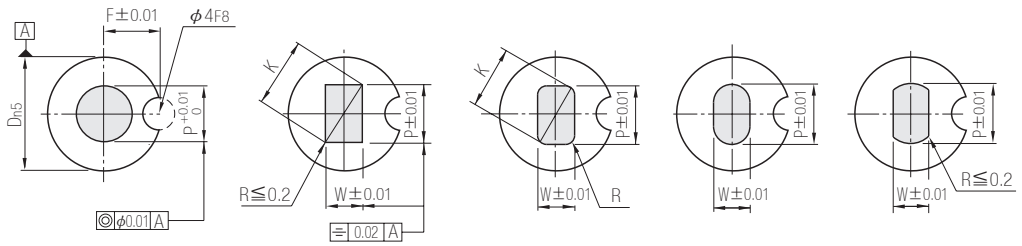
TOHATSU

RoHS



| 材質 | 硬度 | 附件 |
|---|---|---|
| SX105V | 未淬火 | NP4－15 |




Ⓐ

Ⓓ
- P≧W
- $K=\sqrt{P^2+W^2}$

Ⓡ
- P≧W
- $0.15 \leqq R < \frac{W}{2}$
- $K=\sqrt{(P-2R)^2+(W-2R)^2}+2R$

Ⓔ
- P>W

Ⓖ
- P>W

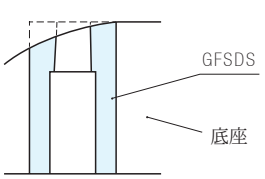
| Dn5 | | Catalog No. TYPE | | Catalog No. D | L | 指定單位0.01mm Ⓐ min. P max. | Ⓓ Ⓡ Ⓔ Ⓖ P·Kmax. | Ⓓ Ⓡ Ⓔ Ⓖ P·Wmin. | Ⓡ R | b | d | F |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20 | +0.024 +0.015 | Ⓐ | GFSDS | 20 | 25 | 6.00～12.20 | 12.20 | 3.00 | 0.15 ～ W/2 以下 只 Ⓡ | 8 | 12.6 | 10 |
| 25 | | Ⓓ | GFDDS | 25 | | 10.00～16.20 | 16.20 | | | | 16.6 | 12.5 |
| 32 | +0.028 +0.017 | Ⓡ | GFDRS | 32 | | 15.00～20.20 | 20.20 | 4.00 | | 10 | 20.6 | 16 |
| 38 | | Ⓔ | GFDES | 38 | | 19.00～26.20 | 26.20 | 5.00 | | | 26.6 | 19 |
| | | Ⓖ | GFDGS | | | | | | | | | |

### Wa. 注意

- 火焰淬火用下模
  由於下模未實施熱處理，因此追加工比較容易，適合於裝入鑄件底座後，與鑄件底座同時進行成形加工等情況，如果加工後進行火焰淬火，則會形成63~64HRC的表面硬化層，從而獲得極高的耐磨損性

  ⓘ 刃口尺寸是火焰淬火前的尺寸，根據火焰淬火的狀況不同，可能會有一些尺寸變化，請留意

### Ex. 使用例

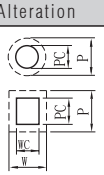
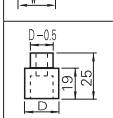


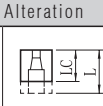
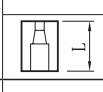

訂貨：Catalog No. – L – P – W – R(只Ⓡ)

GFDRS 20 – 25 – P10.20 – W6.00 – R2.25

交期：9 天

### 追加工

| Alteration | | Code | Ⓐ | Ⓓ Ⓡ Ⓔ Ⓖ |
|---|---|---|---|---|
| 刃口追加工 |  | PC WC | 變更刃口直徑 $\frac{P}{W} > \frac{PC}{WC} \geqq \frac{P \cdot Wmin}{2} \geqq 1.50$ 指定單位0.01mm | |
| |  | TYC | 前端台階加工<br>刃口側前端進行台階加工 | |

| Alteration | | Code | Ⓐ | Ⓓ Ⓡ Ⓔ Ⓖ |
|---|---|---|---|---|
| 全長追加工 |  | LC | 變更全長 10≦LC<L<br>指定單位0.1mm<br>(LKC併用時，指定單位可爲0.01mm)<br>ⓘ 導入部縮短(L－LC) | |
| |  | LKC | 變更全長公差 $L^{+0.4}_{+0.2} \rightarrow L^{+0.05}_{0}$ | |
| 其它 | | KC | – | 變更止逼位置<br>指定單位1° |

訂貨：Catalog No. – L(LC – P(PC) – W(WC) – R – (KC，LKC，TYC…)

GFDDS 20 – 25 – P9.00 – WC2.00 – KC90