RoHS

Type fixed to die set
ZGUA (Unit)
ZGUA—R (Rail)
ZGUA—L (Rail)

L	a1	a2
60		45
80	10	65
100		75

15°

4—φ7

2—M6   2—φ7

C2

5   Y±0.1

R≦0.8

X±0.25

① ②

M S50C
H 55HRC〜
part: Induction-hardened

RoHS

Type fixed to die plate
ZGUB (Unit)
ZGUB—R (Rail)
ZGUB—L (Rail)

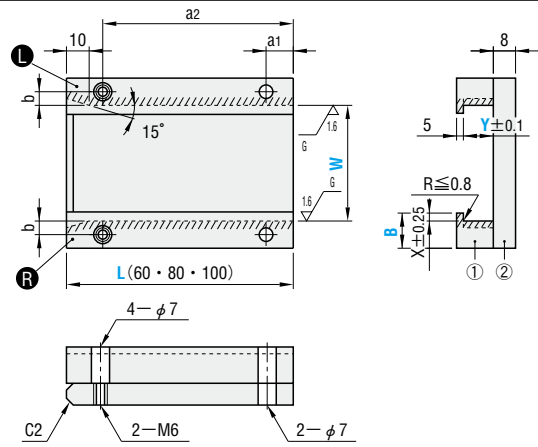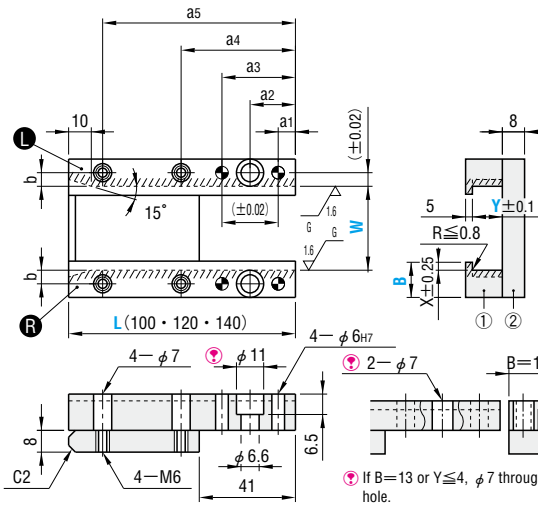| L	a1	a2	a3	a4	a5
100					85
120	8	20	32	50	105
140					115

15°   (±0.02)   (±0.02)

5   Y±0.1

R≦0.8

X±0.25

① ②

L (100・120・140)

4—φ6H7

4—φ7   φ11   2—φ7   B=13

4—M6   φ6.6   6.5

C2   41

If B=13 or Y≦4, φ7 through hole.

M S50C
H 55HRC〜
part: Induction-hardened

■Unit

Catalog No.		L	Y 1mm increments	W 0.1mm increments	b	X
Type	B					
ZGUA	13	60	1〜30	10〜160	5	3
	16	80			7	3
	20	100			8	5
ZGUB	13	100	1〜30	10〜160	5	3
	16	120			7	3
	20	140			8	5

■Rail

Catalog No.		L	Y 1mm increments	b	X
Type	B				
ZGUA—R ZGUA—L	13	60	1〜30	5	3
	16	80		7	3
	20	100		8	5
ZGUB—R ZGUB—L	13	100	1〜30	5	3
	16	120		7	3
	20	140		8	5

Order

Catalog No.	—	L	—	Y	—	W
ZGUA 13	—	100	—	22	—	53.2
ZGUB—R20	—	140	—	15		

Days to Ship Quotation

Price Quotation

B	Base unit price 1〜9 sets					
	ZGUA			ZGUB		
	L60	L80	L100	L100	L120	L140
13			Quotation			
16						
20						

B	Base unit price 1〜9 pieces					
	ZGUA—R・ZGUA—L			ZGUB—R・ZGUB—L		
	L60	L80	L100	L100	L120	L140
13			Quotation			
16						
20						

■**Features**

L   max30   R   Rail ①

Material   Plate ②
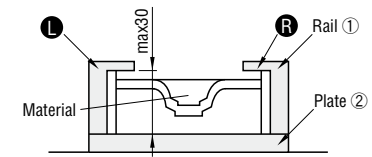
● Because lifting up to 30 mm is possible, can be used for bending, drawing, and other machining.
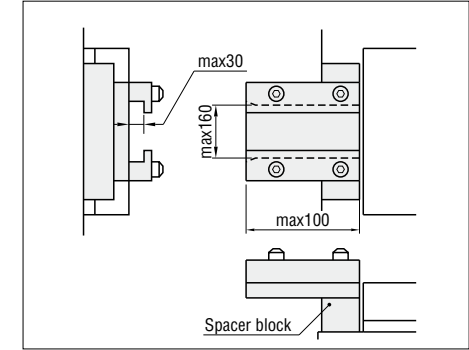● When using to match the material width, the rails can also be ordered on their own.

ex Example

1 **Selecting the unit structure:** Select the unit type according to the die structure, production volume, regrinding frequency, and other factors.

Type fixed to die set

max30   max160   max100

Spacer block

● Fastened by bolts to the die set. (Place a spacer block immediately in front of the die plate.)
● Does not interfere with the layout inside the die.

Type fixed to die plate

max30   max160   max100
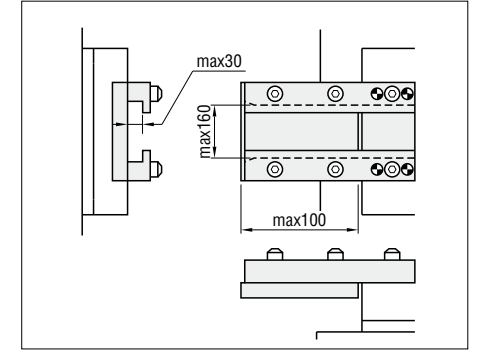
● Fastened to the die plate by bolts or dowel pins.
● Requires a relief in the layout inside the die. (The use of a spacer block can prevent interference with parts inside the die.)
● Features excellent reproducibility at reassembly.

2 **dimension selection:** Decide this dimension based on the width of the material used, lift height, and installation conditions.
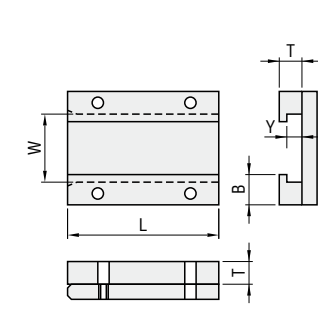
① Determine the W dimension (material guide width).
  Material width＋Material width tolerance＋α (installation accuracy error)
② Determine the Y dimension (groove height).
  Lift height＋Material thickness＋α
③ Determine the T dimension (material guide plate height)
  Determine based on the groove height in ②. However, T＝Y＋5
④ Determine the L dimension (length of material guide plate).
  Determine the L dimension based on the distance between the feeder and die plate, material width and sheet thickness.
  ● Determine the full length dimension (L) based on the full length for a type fixed to the die set, and on the length projecting from the die plate for a type fixed to the die plate.
⑤ Determine the B dimension (width of material guide plate).
  Determine the B dimension with consideration for factors such as the overall balance of the die plate and die, and interference with the sub-guide. Verify that the positions for bolt or dowel pin installation are available.

●**Blank for fixing inside the die** (Material guide plate) **Catalog No.** SBM (Equivalent to HPM2T)・SBA (SKS93) ☞P.875

●This is a blank for the material guide plate blank inside the die.
●The material can be selected according to the conditions.