

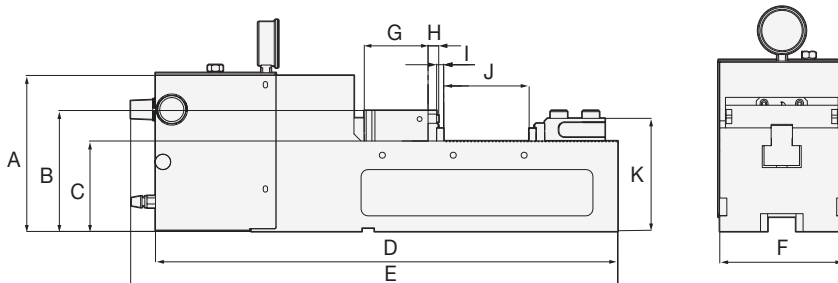
STAMPING UNIT

Model: ASC-153



The stamping jaws section is replaceable, depending on preferred tooth profile.

We supply specialized jaws for the ASC series and also accept orders for custom jaw designs.



SPECIFICATIONS (Material: Material: FCD 60 ductile Iron. Hardness: HRC 50)

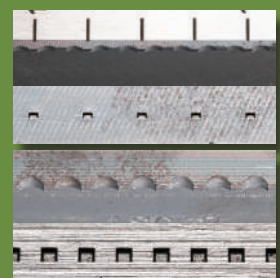
Unit: mm

Model	A	B	C	D	E	F	G	H	I
ASC-153	220	170	127	652	690	175	90	15	10

Model	J	K	Stamping Force	Safety Range	Weight(kg)
ASC-153	120	160	0-24000 kg	10 mm	117



Specialized stamping jaws



Custom-jaws tooth profile samples

SIMPLE, QUICK & ACCURATE

ASC-153 Stamping Unit can easily shape tooth profile on the workpiece, which allows precise positioning between the workpiece and the vise.

1 The body of the Stamping Unit is made of **Ductile Iron FCD 70** with patented **PNEUMATIC SYSTEM**. Required tooth profile is pre-stamped onto the workpiece with high pressure, so that the workpiece will be stably clamped by the corresponding tooth profile on five-axis vise.

2 The stamping force is between **0~24 tons**, which is suitable for stamping tooth profile on both soft and hard materials. The black knob is **pressure regulator**, used to set pneumatic force according to processing conditions.

3 The serrated jaws of stamping unit are made of **Tool Steel**, heat-treated to achieve hardness above **HRC55** and marked with scales to facilitate accurate positioning. It is recommended that the hardness of workpiece should not exceed HRC35.

4 The effective stamping stroke of the moveable jaw is **10mm**: during the initialization phase, please adjust the jaw spacing according to the width of the workpiece and make sure to reserve **3~5mm** as a margin for smooth loading/unloading. Meanwhile, please refer to the scale on the jaws to set the datum point.

5 Pre-stamping is beneficial to both hard and soft workpieces. The former can effectively reduce wear and tear caused by workpiece on the serrated jaws; the latter can avoid workpiece deformation caused by excessive pressure for stable clamping.

6 By engaging the teeth profile of both the workpiece and the vise, clamping accuracy can be fully guaranteed; therefore, it is ideal for multi-part processing and automatic processing.

7 Customized serrated jaws of the stamping unit are acceptable.

Simple setting, Quick pre-stamping, which can greatly improve the reliability of five-axis processing.

