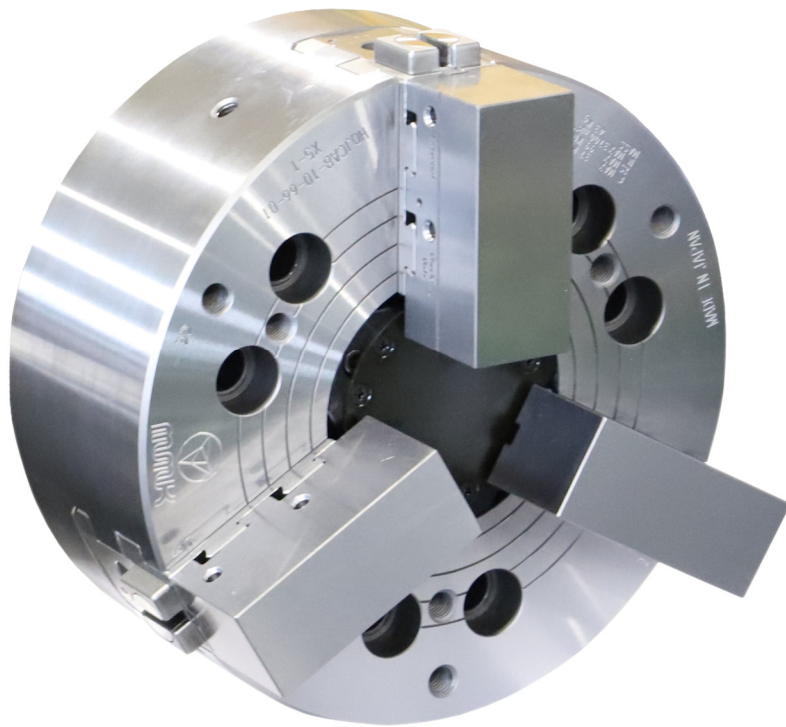


HQJC

Quick Jaw Change Chuck

自動段取替え

Automatic set-up exchange



松本機械工業株式会社

MATSUMOTO MACHINE CO., LTD.

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M10094J-10



特長

Features



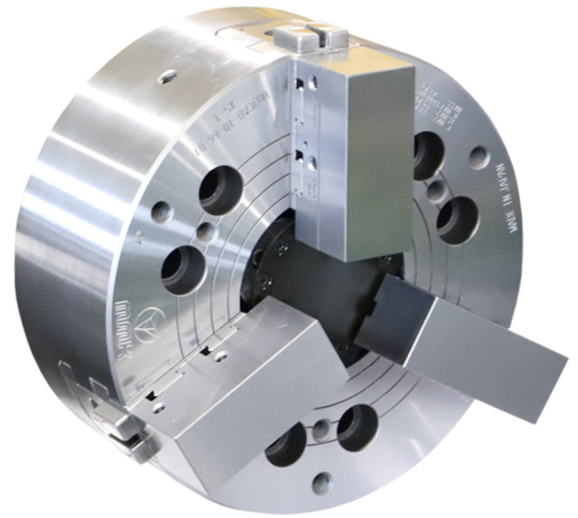
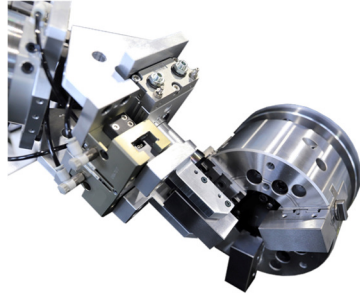
★変種変量生産の自動化

Automation of variable-volume production

従来のQJC(クイックジョーチェンジチャック)を
弊社開発ロボットハンドにより、

爪の自動交換を実現!!

Conventional QJC(Quick Jaw Change Chuck)
Developed by our company Realized
automatic exchange of jaw by robot hand!!



POINT 1

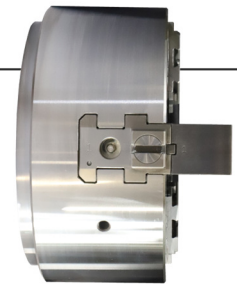
ダブルスライドで高剛性・高精度

High rigidity and precision with double slides

mmk オリジナルHeタイプ汎用チャックを応用しています。マスター
ジョーがダブルスライドのため高剛性で安全性が高い構造です。

クサビとピンによる位置決めで爪交換繰り返し精度 $\leq 10\mu\text{m}$

MMK original He-type general-purpose chuck is applied. High rigidity and safety
structure due to master jaws with double slides. Jaw exchange repeatability
 $\leq 10\mu\text{m}$ by positioning with wedge and pin.



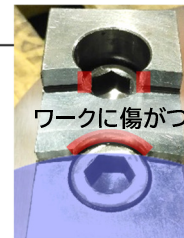
POINT 2

ボルト穴無し

Without bolt holes

HQJCの爪はボルトで固定しません。ボルト穴が無いことで
短時間で爪交換が可能です。また、R成形加工が容易で、
エッジが立たないためワークが傷つくリスクを低減します。

HQJC jaws are not bolted in place. The absence of bolt holes makes it
possible to exchange the jaws in a short time. R-forming process is also easy,
The risk of damaging the workpiece is reduced because no edges are formed.



従来の爪
Existing Jaw



QJC爪
QJC Jaw

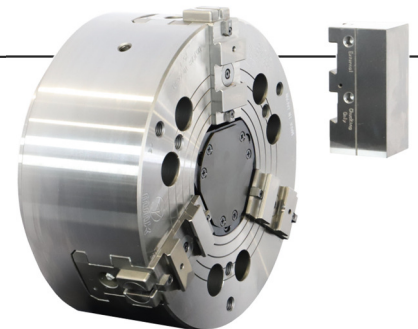
POINT 3

切粉が入りにくい

Chips are difficult to get into

HQJCはトップジョー交換方式です。そのため切粉が入りにくく、爪
交換繰り返し精度に影響がありません。加工不良を防ぎます。

HQJC is a top jaw exchange system. This prevents chips from entering the jaws
and The jaw exchange repeatability is not affected. This prevents machining
defects.



POINT 4

ロボットハンドで爪交換

Robotic hand for jaw exchange

ロボットハンドで爪自動交換を行います。

(マニュアル交換も可能)

段取り替えを含む変種変量生産の自動化に貢献します。

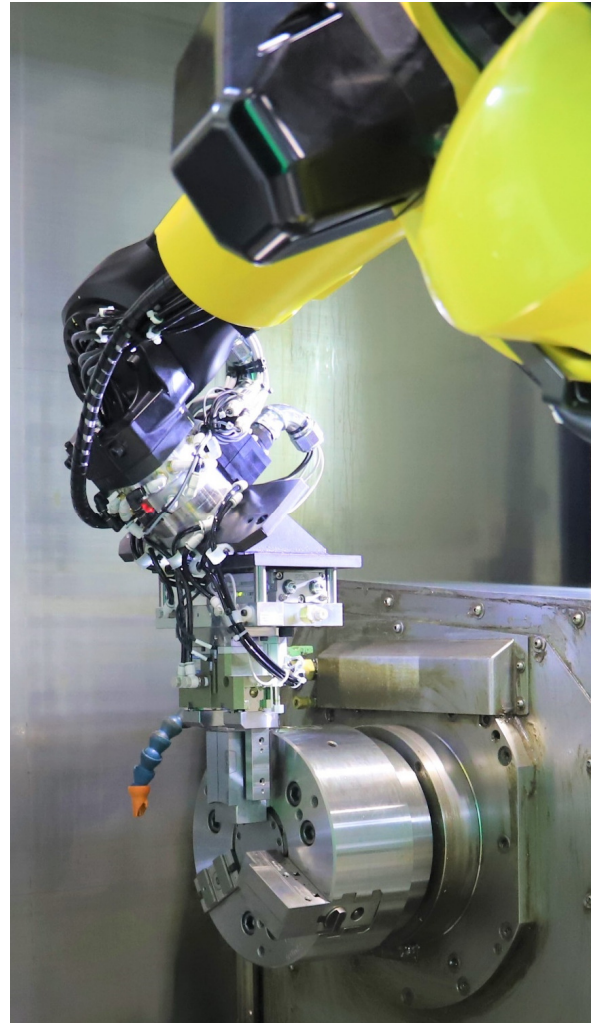
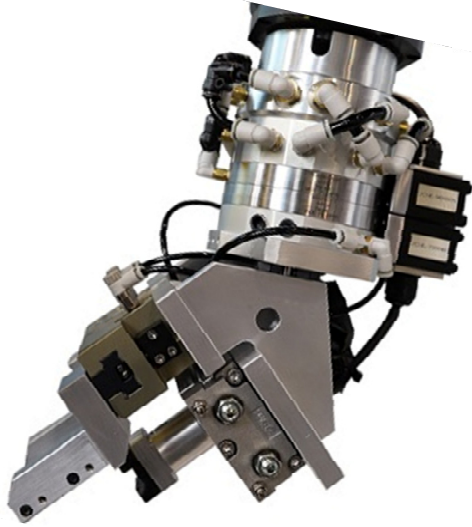
Automatic jaw exchange by robot hand.(Manual jaw exchange is also possible).

Contributes to automation of variable-type, variable-volume production, including set-up exchanges.

● ロボットハンド Robot hand



弊社開発のロボットハンドが爪とワークの自動交換を行います
Our robot hand automatic exchange of the jaw and the workpiece



(ex) 8 inch chuck

爪交換
Jaw exchange

約1分[※]

About 1 minutes

ワーク交換
Workpiece exchange

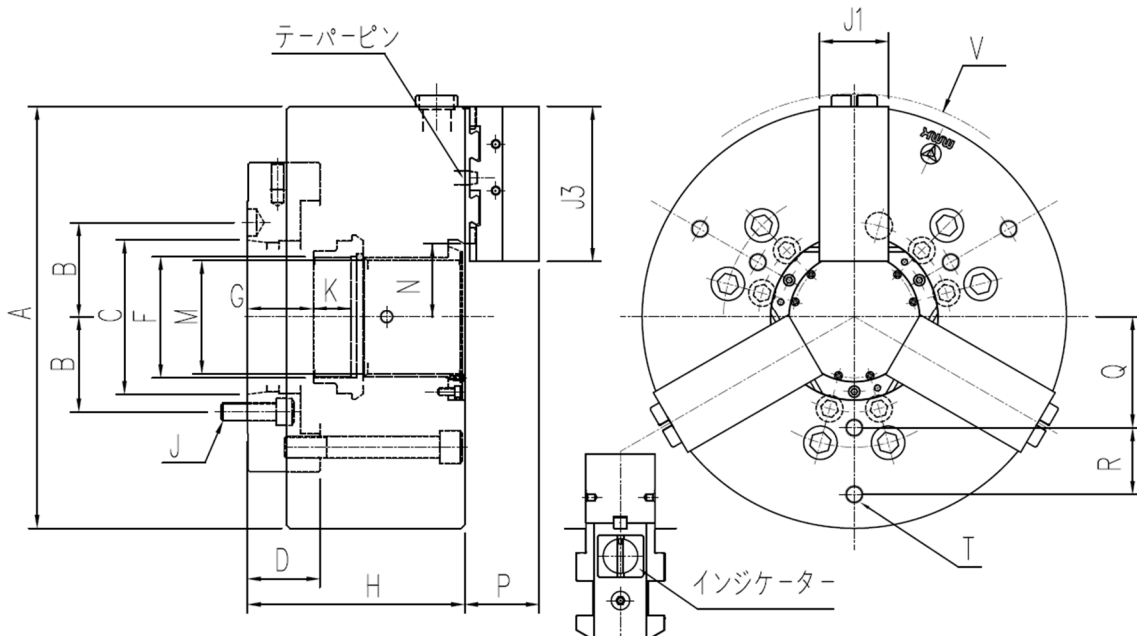
約15秒[※]

About 15 seconds

※ワークやチャックサイズ、ロボットで異なります

※Depends on workpiece, chuck size, robot

● HQJC型パワーチャック 外観図 Power chuck for HQJC Drawing



仕様 Specification



モデル名 Model name		HQJCA5-6-35B	HQJCA6-8-46	HQJCA8-10-66	HQJCA8-12-67	HQJCA11-15-103	HQJCA15-18-165B	
径の呼び Nominal dia.	in.	6	8	10	12	15	18	
最高回転数 Maximum speed	min ⁻¹	4,600	4,100	3,400	2,500	1,800	1,500	
爪ストローク Jaw stroke	mm	φ 4.7	φ 6.4	φ 8.0	φ 8.0	φ 9.5	φ 9.5	
シフターストローク Sifter stroke	mm	15	20	25	25	30	30	
最大把握力 Max. clamping force	KN	46.3	82.3	98.8	114.7	147	147	
許容シリンダー推力 Max. draw bar pull	KN	17.2	28.1	32.1	42.9	51.9	51.9	
重量 weight	kgf	14	25	43	75	137	223	
把握径 Chucking Dia	Max.	mm	φ 151.2	φ 189	φ 228.6	φ 274.5	φ 342.9	φ 411.3
	Min.	mm	φ 42	φ 52	φ 59.6	φ 65	φ 101	φ 177

寸法 Size

モデル名 Model name		HQJCA5-6-35B	HQJCA6-8-46	HQJCA8-10-66	HQJCA8-12-67-01	HQJCA11-15-103	HQJCA15-18-165B	
A	mm	φ 168	φ 210	φ 254	φ 305	φ 381	φ 457	
B	mm	52.4	66.7	85.7	85.7	117.5	165.1	
C		A2-#5	A2-#6	A2-#8	A2-#8	A2-#11	A2-#15	
D	mm	22	17.5	25	30	35	65	
F		M52×P1.5	M60×P1.5	M85×P2.0	M100×P2.0	M130×P2.0	M175×P3.0	
G	Max.	mm	17	18.5	18	33	25	50
	Min.	mm	2	-1.5	-7	8	-5	20
H	mm	92	104	123	140	165	220	
J		6-M10	6-M12	6-M16	6-M16	6-M20	6-M22	
K		17	24	30	24.5	40	40	
M		φ 35	φ 46	φ 66	φ 67	φ 103	φ 165	
N	Max.	mm	29.5	35	44.8	48.5	66.5	104.5
	Min.	mm	27.15	31.8	40.8	44.5	61.75	99.75
P	mm	32	42	52	54	67	67	
Q	mm	45	60	80	85	100	120	
R	mm	25	25	30	45	60	75	
T		6-M8深12	6-M8深15	6-M12深20	6-M16深30	6-M16深25	6-M16深20	
V		φ 184	φ 230	φ 270	φ 325	φ 404	φ 479	
J1		27	34	40	50	62	62	
J3		63	79	96	120	140	140	

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対象: 本社工場

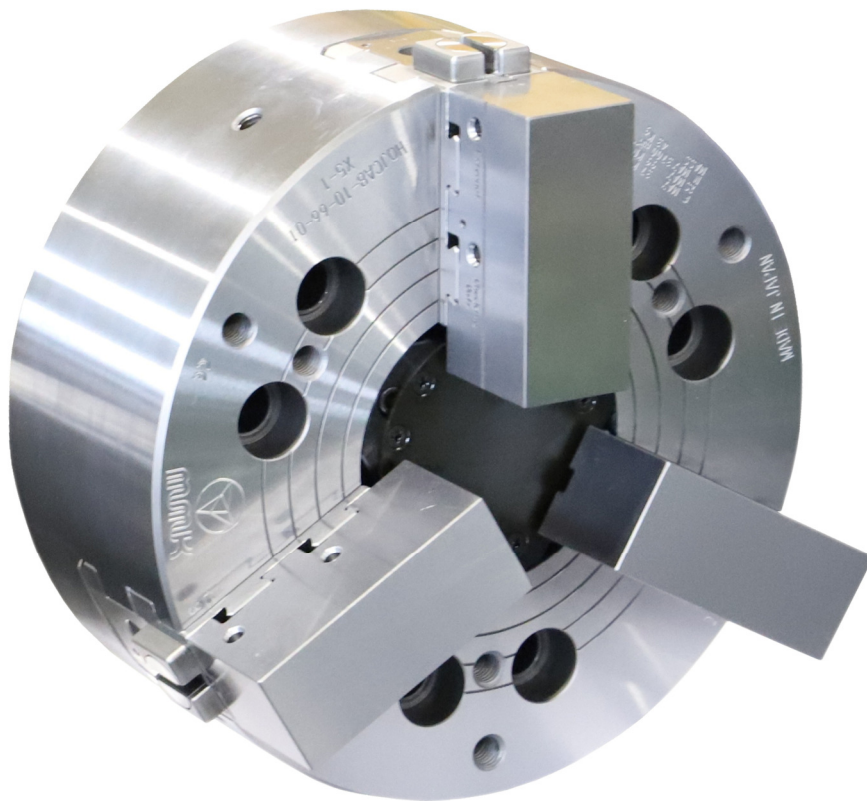
対象: 本社工場・東京・名古屋営業所

Chuck · J-13 · 2405 · 500 · Printed in Japan

HQJC

Quick Jaw Change Chuck

Automatic set-up change



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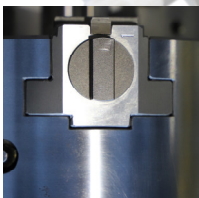
● FEATURES



Revolutionize Precision: **mmk**'s HQJC Chuck – Unleashing the Power of Automation with Seamless, Unmanned Jaw Changes!

POINT 1 HIGH RIGIDITY AND PRECISION WITH DOUBLE SLIDES

We have implemented our now signature double-slide technology. H-shaped master jaws ensure better surface pressure distribution during rotation resulting in high rigidity and precision with exchange repeatability $\leq 10\mu\text{m}$.



Old model



New model

POINT 2 NO BOLTS – NO HASSLE

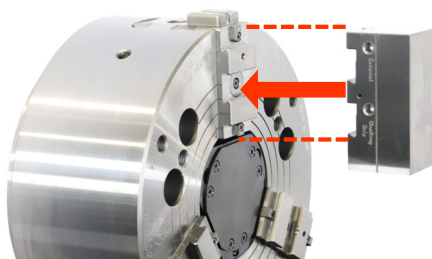
Forming of standard jaws (with bolt holes) often results in sharp edges that can damage the workpiece.



In contrast, HQJC jaws are not bolted in place, which means the absence of sharp bolt-hole edges and allows for instant jaw changing.



POINT 3 SWarf SHALL NOT PASS!



HQJC is a top jaw-changing system. This prevents swarf from entering the chuck resulting in better jaw change repeatability and reduced processing defects.

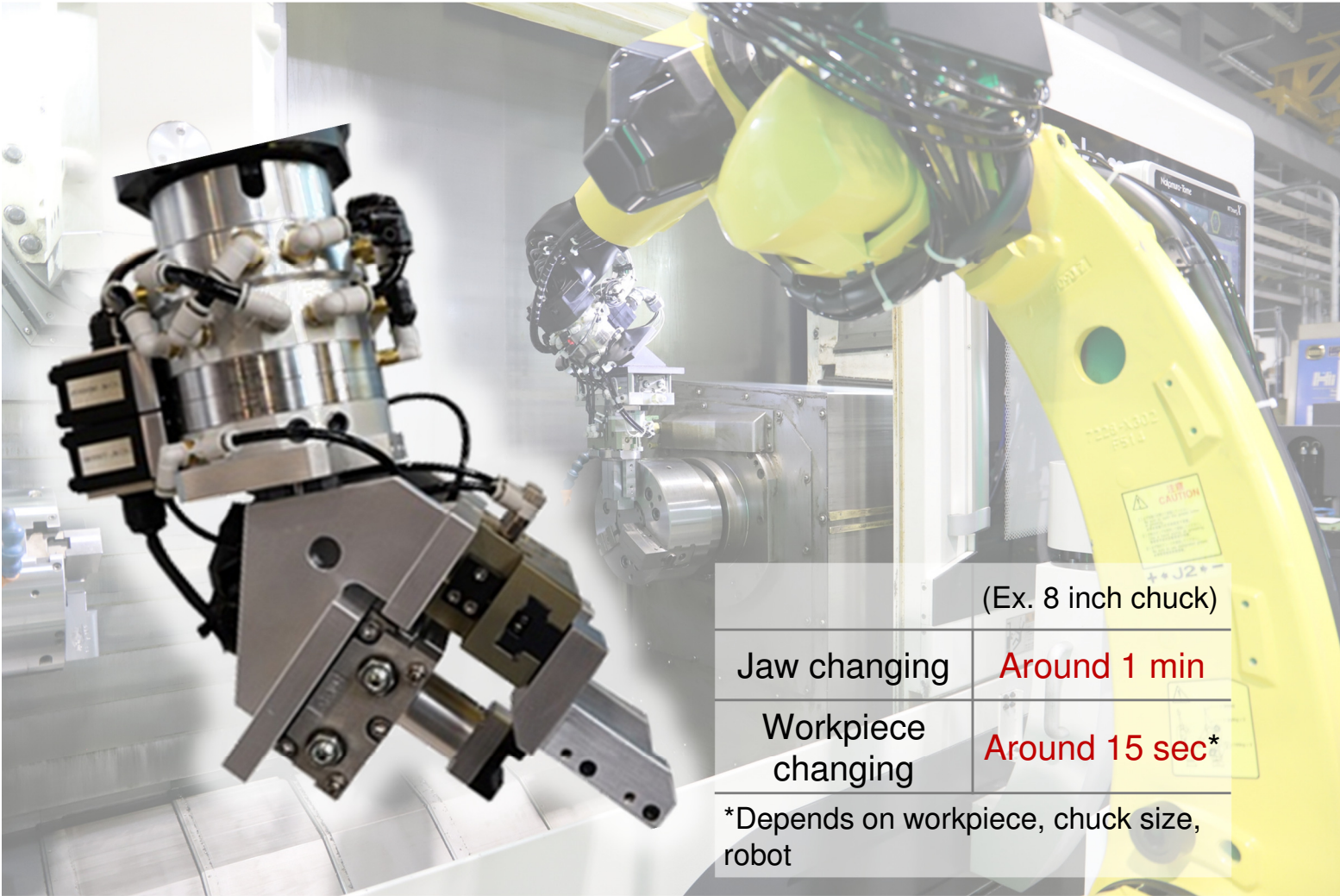
POINT 4 CHANGE THE JAWS WITH ROBOT HAND

The quick and smooth jaw-changing system of HQJC chuck allows for switching between manual and robotic jaw-changing. Used in tandem with our Smart Terrace AIO system it makes automation of mixed model production and continuous 24-hour operation possible.

ROBOT HAND



The unique robot hand developed by MMK performs automatic changing of jaws and workpieces.

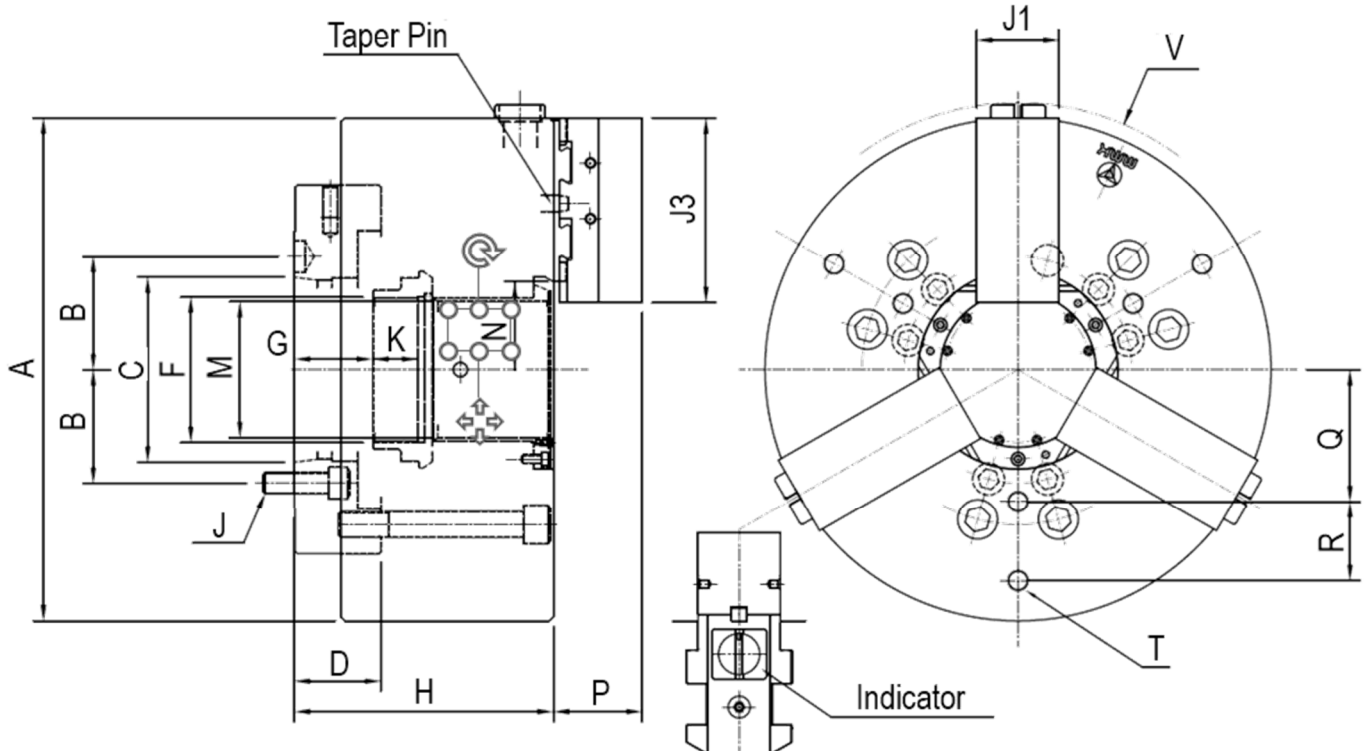


(Ex. 8 inch chuck)

Jaw changing	Around 1 min
Workpiece changing	Around 15 sec*

*Depends on workpiece, chuck size, robot

HQJC APPEARANCE DRAWING



SPECIFICATION



MODEL NAME		HQJC A5-6- 35B	HQJCA6-8- 46	HQJCA8- 10-66	HQJCA8- 12-67-01	HQJCA11- 15-103	HQJCA15-18- 165B	
Nominal dia.	in.	6	8	10	12	15	18	
Max. speed	min ⁻¹	4,600	4,100	3,400	2,500	1,800	1,500	
Jaw stroke	mm	φ4.7	φ6.4	φ8.0	φ8.0	φ9.5	φ9.5	
Sifter stroke	mm	15	20	25	25	30	30	
Max. clamping force	KN	46.3	82.3	98.8	114.7	147	147	
Max. draw bar pull	KN	17.2	28.1	32.1	42.9	51.9	51.9	
Weight	kg	14	25	43	75	137	223	
Chucking Dia	Max.	mm	φ151.2	φ189	φ228.6	φ274.5	φ342.9	φ411.3
	Min.	mm	φ42	φ52	φ59.6	φ65	φ101	φ177
Applicable cylinder		****	****	****	****	****	****	

SIZE

MODEL NAME		HQJCA5-6- 35B	HQJCA6-8- 46	HQJCA8-10- 66	HQJCA8-12- 67-01	HQJCA11-15- 103	HQJCA15-18- 165B	
A	mm	φ168	φ210	φ254	φ305	φ381	φ457	
B	mm	52.4	66.7	85.7	85.7	117.5	165.1	
C		A2-#5	A2-#6	A2-#8	A2-#8	A2-#11	A2-#15	
D	mm	22	17.5	25	30	35	65	
F		M52×P1.5	M60×P1.5	M85×P2.0	M100×P2.0	M130×P2.0	M175×P3.0	
G	Max.	mm	17	18.5	18	33	25	50
	Min.	mm	2	-1.5	-7	8	-5	20
H	mm	92	104	123	140	165	220	
J		6-M10	6-M12	6-M16	6-M16	6-M20	6-M22	
K		17	24	30	24.5	40	40	
M		φ35	φ46	φ66	φ67	φ103	φ165	
N	Max.	mm	29.5	35	44.8	48.5	66.5	104.5
	Min.	mm	27.15	31.8	40.8	44.5	61.75	99.75
P	mm	32	42	52	54	67	67	
Q	mm	45	60	80	85	100	120	
R	mm	25	25	30	45	60	75	
T		6-M8 Depth 12	6-M8 Depth 15	6-M12 Depth 20	6-M16 Depth 30	6-M16 Depth 25	6-M16 Depth 20	
V		φ184	φ230	φ270	φ325	φ404	φ479	
J1		27	34	40	50	62	62	
J3		63	79	96	120	140	140	



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