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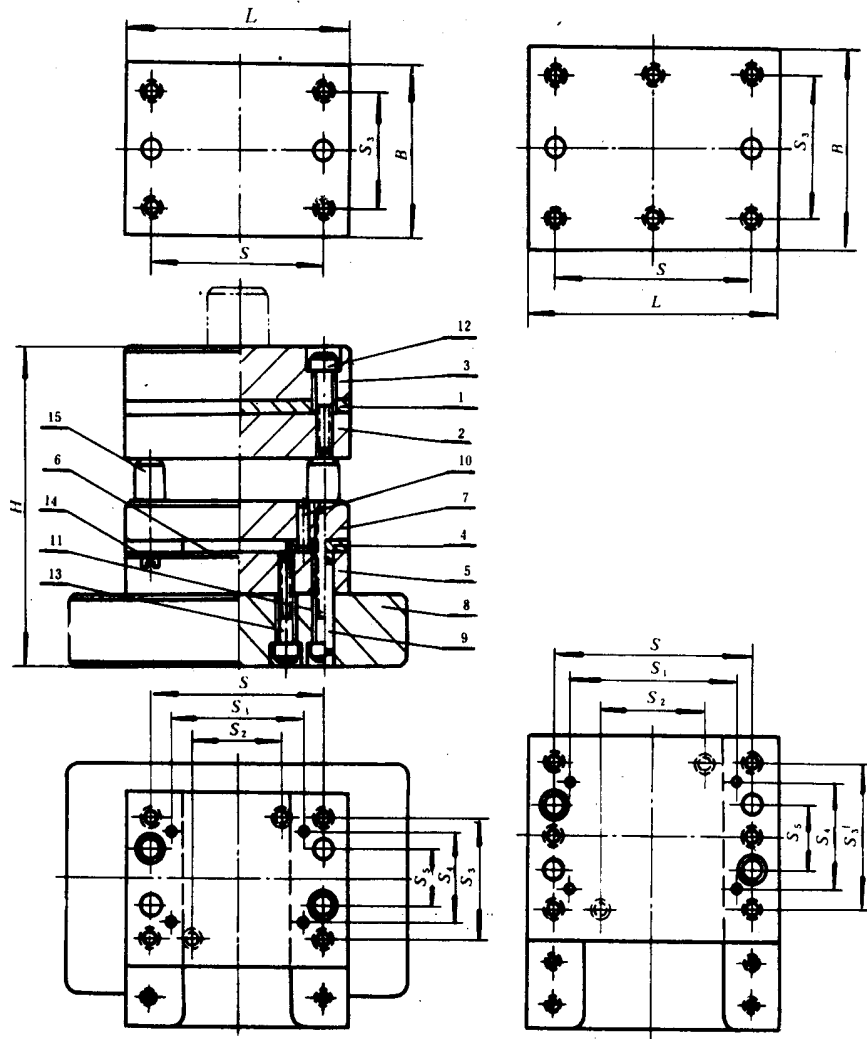
中华人民共和国国家标准

UDC 621.961.02

冷冲模导板模典型组合
纵向送料典型组合

GB 2874.1-81

Typical assembly with guide stripper for cold press dies
Typical assembly for longitudinal feeding



标记示例:

凹模周界 $L = 100 \text{ mm}$ 、 $B = 80 \text{ mm}$ 、闭合高度 H 为 $123 \sim 127 \text{ mm}$ 的纵向送料典型组合:
典型组合 $100 \times 80 \times 123 \sim 127$ GB 2874.1-81

| 凹模周界 | | L | 80 | 100 | 100 | 100 | 125 | (140) | 125 |
|--------|---------------------|----------------|---------------|-----------------|------------------|----------------|-----------------|----------------|----------------|
| 凸模 | | B | 63 | 50 | 55 | 80 | 80 | 60 | 100 |
| 闭合高度 H | | 长度 | 50 | 111 | 123 | 127 | 116 | 132 | 136 |
| 孔距尺寸 | | 最 小 | 60 | 80 | 78 | 101 | 116 | 101 | 101 |
| | | 最 大 | 47 | 65 | 60 | 83 | 98 | 83 | 83 |
| | | S ₁ | 32 | 50 | 42 | 65 | 80 | 65 | 65 |
| | | S ₂ | 45 | 29 | 42 | 58 | 42 | 58 | 58 |
| | | S ₃ | 21 | 21 | 26 | 26 | 26 | 40 | 40 |
| | | S ₄ | | | | | | | |
| | | S ₅ | | | | | | | |
| 1 | 垫板 GB 2858.3-81 | 1 | 80 × 63 × 6 | 100 × 63 × 6 | 100 × 80 × 6 | 125 × 80 × 6 | (140) × 80 × 6 | 125 × 100 × 6 | 125 × 100 × 6 |
| 2 | 固定板 GB 2858.2-81 | 1 | 80 × 63 × 16 | 100 × 63 × 16 | 100 × 80 × 16 | 125 × 80 × 16 | (140) × 80 × 16 | 125 × 100 × 18 | 125 × 100 × 18 |
| 3 | 上模座 GB 2858.2-81 | 1 | 80 × 63 × 18 | 100 × 63 × 18 | 100 × 80 × 20 | 125 × 80 × 20 | (140) × 80 × 20 | 125 × 100 × 20 | 125 × 100 × 20 |
| 4 | 导料板 GB 2865.5-81 | 2 | 83 × B × 8 | | 100 × B × 8 | | | 140 × B × 8 | |
| 5 | 凹模 GB 2858.1-81 | 1 | 80 × 63 × 12 | 100 × 63 × 12 | 100 × 80 × 12 | 125 × 80 × 12 | (140) × 80 × 12 | 125 × 100 × 20 | 125 × 100 × 20 |
| 6 | 承料板 GB 2865.6-81 | 1 | 80 × 20 × 2 | 100 × 20 × 2 | 100 × 20 × 2 | 125 × 20 × 2 | (140) × 20 × 2 | 125 × 40 × 2 | 125 × 40 × 2 |
| 7 | 导板 GB 2858.2-81 | 1 | 80 × 63 × 16 | 100 × 63 × 16 | 100 × 80 × 16 | 125 × 80 × 16 | (140) × 80 × 16 | 125 × 100 × 18 | 125 × 100 × 18 |
| 8 | 下模座 GB 2857.4-81 | 1 | 125 × 80 × 25 | (140) × 80 × 25 | (140) × 100 × 30 | 160 × 100 × 30 | 200 × 100 × 30 | 160 × 125 × 30 | 160 × 125 × 30 |
| 9 | 圆柱销 GB 119-76 | 6 | 6 × 30 | | 8 × 30 | | 8 × 35 | | |
| 10 | 圆柱销 GB 119-76 | 4 | | 3 × 12 | | | 4 × 20 | | |
| 11 | 螺钉 GB 70-76 | 4 | M6 × 50 | | M8 × 50 | | M8 × 60 | | |
| 12 | 螺钉 GB 70-76 | 4 | M6 × 30 | | M8 × 30 | | | | |
| 13 | 螺钉 GB 70-76 | 2 | M6 × 30 | | M8 × 30 | | M8 × 35 | | |
| 14 | 螺钉 GB 65-76 | 2 | | | M5 × 8 | | | M6 × 10 | |
| 15 | 限位柱 GB 2869.2-81 | 4 | | | | | | | |
| | | 2 | 12 × 15 | | 12 × 20 | | 16 × 20 | | |

零件号、名称及标准编号

续表

| 凹模周界 | | L | (140) | 160 | (140) | 160 | 200 | 160 | 160 | (140) |
|--------|---------------------|----------------|------------------|----------------|------------------|----------------|----------------|------------------|------------------|------------------|
| 凸模 | | B | 100 | 147 | 156 | 134 | 102 | 90 | 76 | 58 |
| 闭合高度 H | | 长 | 60 | 132 | 136 | 116 | 98 | 80 | 76 | 58 |
| 孔距尺寸 | | 度 | 132 | 136 | 116 | 98 | 80 | 76 | 58 | 40 |
| | | 最 | 132 | 136 | 116 | 98 | 80 | 76 | 58 | 40 |
| | | 小 | 132 | 136 | 116 | 98 | 80 | 76 | 58 | 40 |
| | | 大 | 136 | 136 | 116 | 98 | 80 | 76 | 58 | 40 |
| | | S | 116 | 134 | 102 | 90 | 76 | 58 | 40 | 66 |
| | | S ₁ | 98 | 102 | 90 | 76 | 58 | 40 | 66 | 66 |
| | | S ₂ | 80 | 90 | 76 | 58 | 40 | 66 | 66 | 66 |
| | | S ₃ | 76 | 80 | 70 | 55 | 40 | 66 | 66 | 66 |
| | | S ₄ | 58 | 77 | 55 | 40 | 66 | 66 | 66 | 66 |
| | | S ₅ | 40 | 55 | 40 | 66 | 66 | 66 | 66 | 66 |
| 1 | 垫板 GB 2858.3-81 | 1 | (140) × 100 × 6 | 160 × 100 × 6 | (140) × 125 × 6 | 160 × 125 × 6 | 200 × 125 × 6 | 160 × (140) × 6 | 160 × (140) × 6 | 160 × (140) × 6 |
| 2 | 固定板 GB 2858.2-81 | 1 | (140) × 100 × 18 | 160 × 100 × 18 | (140) × 125 × 18 | 160 × 125 × 18 | 200 × 125 × 18 | 160 × (140) × 22 | 160 × (140) × 22 | 160 × (140) × 22 |
| 3 | 上模座 GB 2858.2-81 | 1 | (140) × 100 × 20 | 160 × 100 × 20 | (140) × 125 × 25 | 160 × 125 × 25 | 200 × 125 × 25 | 160 × (140) × 25 | 160 × (140) × 25 | 160 × (140) × 25 |
| 4 | 导料板 GB 2865.5-81 | 2 | 140 × B × 8 | 165 × B × 8 | 165 × B × 8 | 165 × B × 8 | 165 × B × 8 | 200 × B × 10 | 200 × B × 10 | 200 × B × 10 |
| 5 | 凹模 GB 2858.1-81 | 1 | (140) × 100 × 20 | 160 × 100 × 20 | (140) × 125 × 25 | 160 × 125 × 25 | 200 × 125 × 25 | 160 × (140) × 22 | 160 × (140) × 22 | 160 × (140) × 22 |
| 6 | 承料板 GB 2865.6-81 | 1 | 140 × 40 × 3 | 160 × 40 × 3 | 140 × 40 × 3 | 160 × 40 × 3 | 200 × 40 × 3 | 160 × 60 × 3 | 160 × 60 × 3 | 160 × 60 × 3 |
| 7 | 导板 GB 2858.2-81 | 1 | (140) × 100 × 18 | 160 × 100 × 18 | (140) × 125 × 18 | 160 × 125 × 18 | 200 × 125 × 18 | 160 × (140) × 22 | 160 × (140) × 22 | 160 × (140) × 22 |
| 8 | 下模座 GB 2857.4-81 | 1 | 200 × 125 × 30 | 250 × 125 × 35 | 200 × 160 × 35 | 250 × 160 × 35 | 250 × 160 × 35 | 250 × 200 × 35 | 250 × 200 × 35 | 250 × 200 × 35 |
| 9 | 圆柱销 GB 119-76 | 6 | 8 × 35 | 10 × 35 | 10 × 35 | 10 × 35 | 10 × 45 | 10 × 45 | 10 × 45 | 10 × 45 |
| 10 | 圆柱销 GB 119-76 | 4 | 4 × 20 | 4 × 20 | 4 × 20 | 4 × 20 | 4 × 25 | 4 × 25 | 4 × 25 | 4 × 25 |
| 11 | 螺钉 GB 70-76 | 4 | M8 × 60 | M10 × 60 | M10 × 60 | M10 × 60 | M10 × 75 | M10 × 75 | M10 × 75 | M10 × 75 |
| 12 | 螺钉 GB 70-76 | 4 | M8 × 30 | M10 × 35 | M10 × 35 | M10 × 35 | M10 × 40 | M10 × 40 | M10 × 40 | M10 × 40 |
| 13 | 螺钉 GB 70-76 | 2 | M8 × 35 | M10 × 35 | M10 × 35 | M10 × 35 | M10 × 45 | M10 × 45 | M10 × 45 | M10 × 45 |
| 14 | 螺钉 GB 65-76 | 2 | M6 × 10 | M6 × 10 | M6 × 10 | M6 × 10 | M6 × 10 | M6 × 10 | M6 × 10 | M6 × 10 |
| 15 | 限位柱 GB 2869.2-81 | 2 | 16 × 20 | 20 × 25 | 20 × 25 | 20 × 25 | 25 × 20 | 25 × 20 | 25 × 20 | 25 × 20 |

零件号、名称及标准编号

续表

mm

| 凹模周界 | | L | 200 | 250 | 200 | 250 | 200 | 250 | (280) |
|--------|---------------------|----------------|------------------|------------------|------------------|----------------|----------------|------------------|---------|
| 凸模 | | B | (140) | | | | 160 | | |
| 闭合高度 H | | 长 | 70 | | 75 | | | 80 | |
| 孔距尺寸 | | 度 | 158 | | 170 | | | 175 | |
| | | 最 | 164 | | 176 | | | 181 | |
| | | 小 | 170 | 220 | 162 | 220 | 220 | 240 | |
| | | 大 | 140 | 175 | 134 | 175 | 175 | 200 | |
| | | S | 110 | 130 | 106 | 140 | 140 | 160 | |
| | | S ₁ | 112 | | | | 124 | | |
| | | S ₂ | 112 | | | | 100 | | |
| | | S ₃ | 66 | | | | 70 | | |
| | | S ₄ | | | | | | | |
| | | S ₅ | | | | | | | |
| 1 | 垫板 GB 2858.3-81 | 1 | 200 × (140) × 6 | 250 × (140) × 8 | 200 × 160 × 8 | 250 × 160 × 8 | 200 × 160 × 8 | (280) × 160 × 8 | |
| 2 | 固定板 GB 2858.2-81 | 1 | 200 × (140) × 22 | 250 × (140) × 22 | 200 × 160 × 22 | 250 × 160 × 22 | 200 × 160 × 22 | (280) × 160 × 22 | |
| 3 | 上模座 GB 2858.2-81 | 1 | 200 × (140) × 25 | 250 × (140) × 25 | 200 × 160 × 25 | 250 × 160 × 25 | 200 × 160 × 25 | (280) × 160 × 25 | |
| 4 | 导料板 GB 2865.5-81 | 2 | 200 × B × 10 | | | | | 220 × B × 10 | |
| 5 | 凹模 GB 2858.1-81 | 1 | 200 × (140) × 22 | 250 × (140) × 22 | 200 × 160 × 22 | 250 × 160 × 22 | 200 × 160 × 22 | (280) × 160 × 22 | |
| 6 | 承料板 GB 2865.6-81 | 1 | 200 × 60 × 3 | 250 × 60 × 4 | 200 × 60 × 3 | 250 × 60 × 4 | 200 × 60 × 4 | 280 × 60 × 4 | |
| 7 | 导料板 GB 2858.2-81 | 1 | 200 × (140) × 22 | 250 × (140) × 22 | 200 × 160 × 22 | 250 × 160 × 22 | 200 × 160 × 22 | (280) × 160 × 22 | |
| 8 | 下模座 GB 2857.4-81 | 1 | 250 × 200 × 35 | (280) × 200 × 40 | (280) × 200 × 40 | 315 × 200 × 40 | 315 × 200 × 40 | 400 × 200 × 40 | |
| 9 | 圆柱销 GB 119-76 | 6 | 10 × 45 | | | | | 12 × 45 | |
| 10 | 圆柱销 GB 119-76 | 4 | | | | 4 × 25 | | | |
| 11 | 螺钉 GB 70-76 | 4 | | | | | | | |
| 12 | 螺钉 GB 70-76 | 6 | M10 × 75 | | | | | M12 × 80 | |
| 13 | 螺钉 GB 70-76 | 4 | M10 × 40 | | | | | | |
| 14 | 螺钉 GB 65-76 | 2 | M10 × 45 | | | | | M12 × 35 | |
| 15 | 限位柱 GB 2869.2-81 | 2 | 25 × 20 | | | | | M6 × 10 | 25 × 30 |

注: ① B 值设计时选定, 导料板厚度仅供参考。
② 括号内的尺寸尽可能不采用。

GB 2874.1-81

技术条件：按GB 2875-81的规定。
