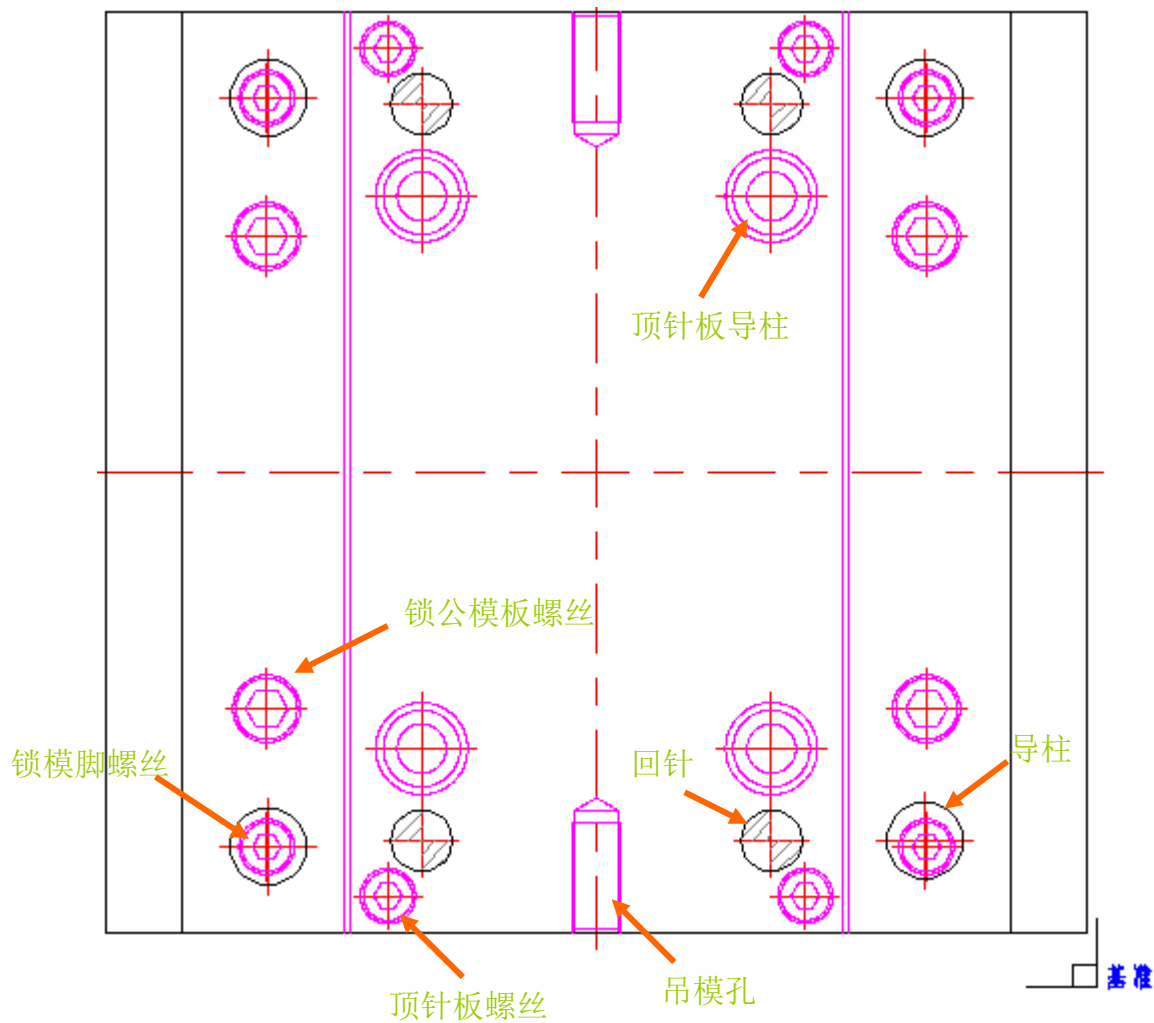
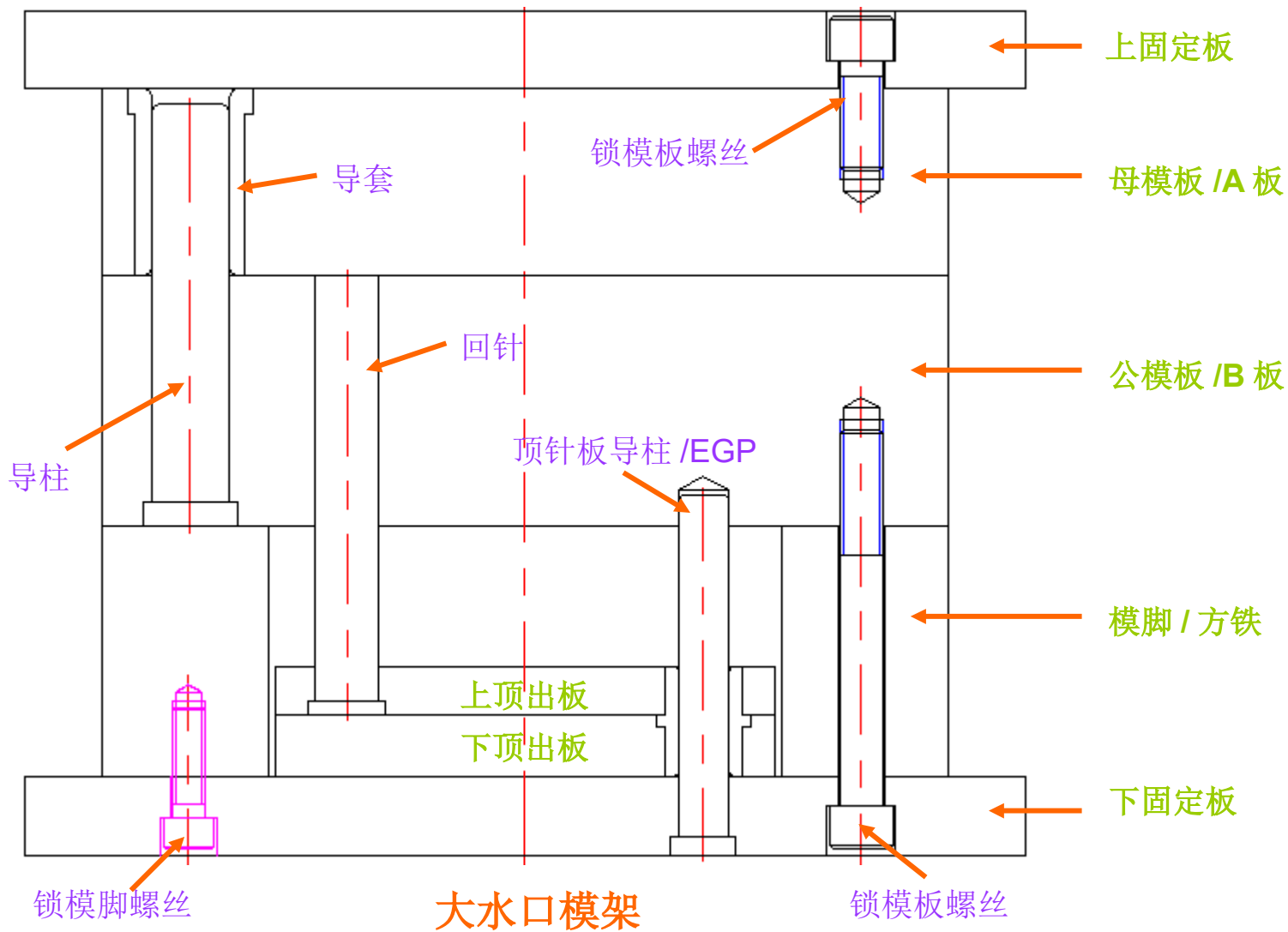


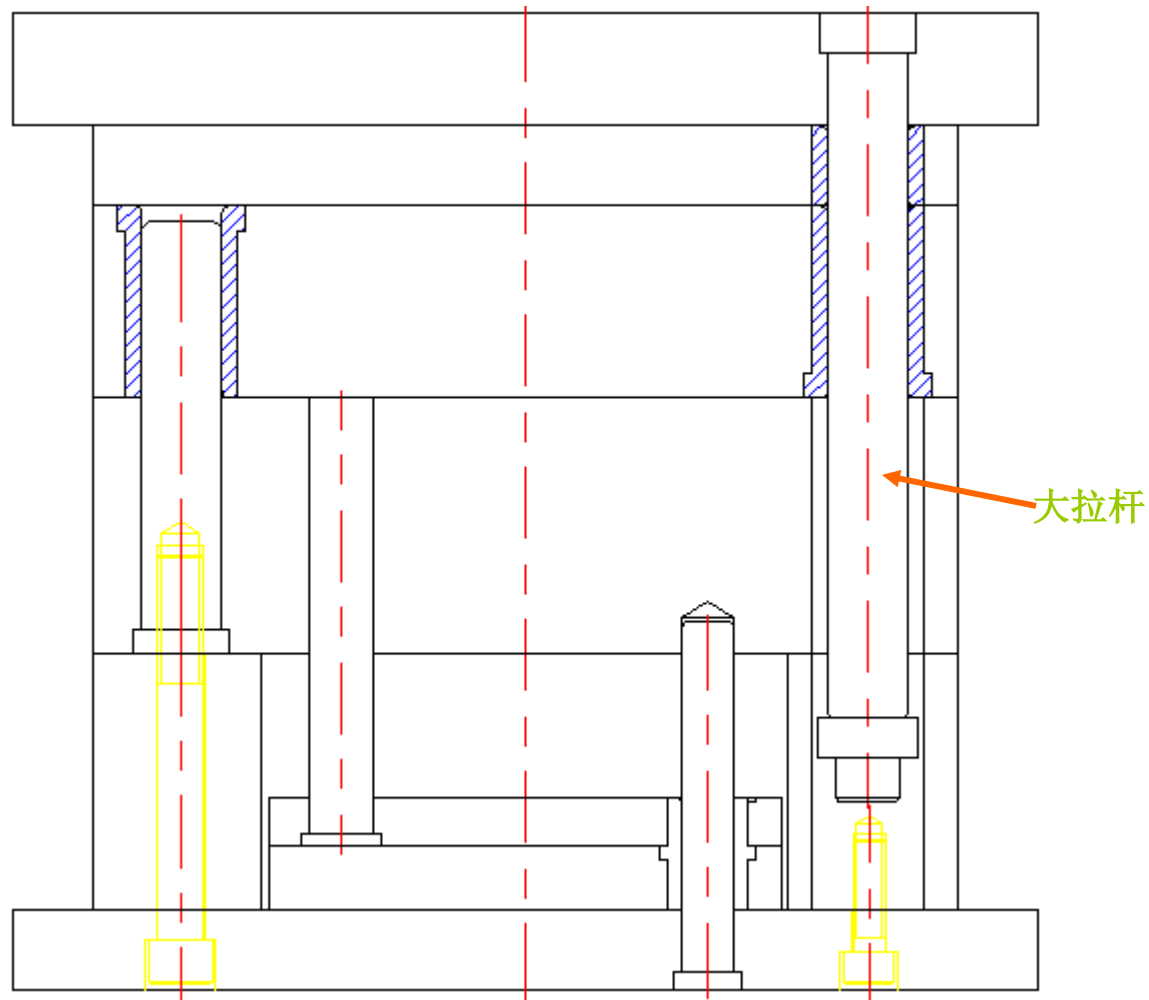
# 模架(一)



# 模架(二)



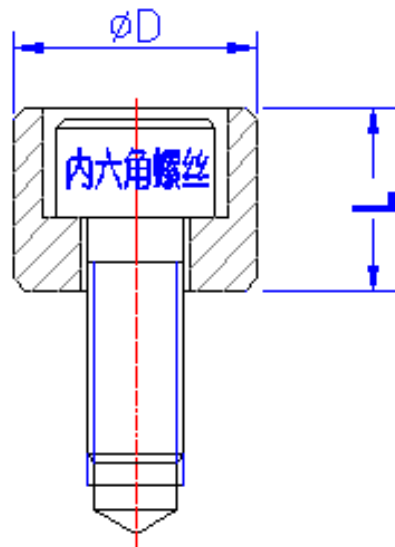
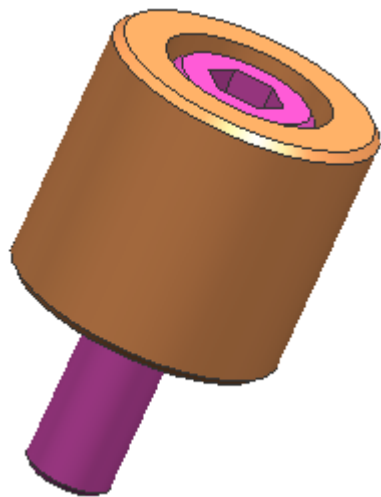
# 模架(三)



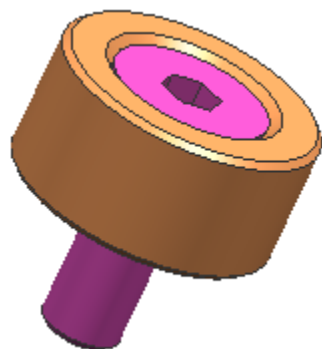
细水口模架



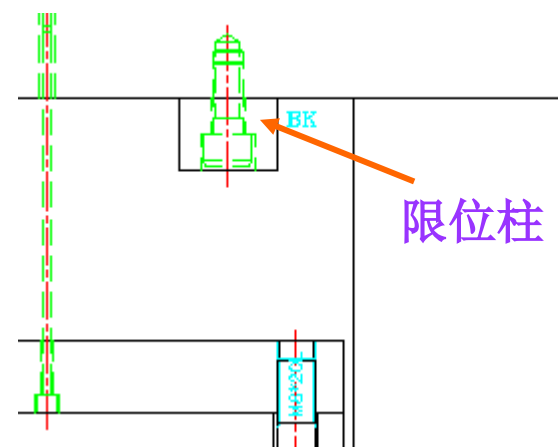
# 限位柱



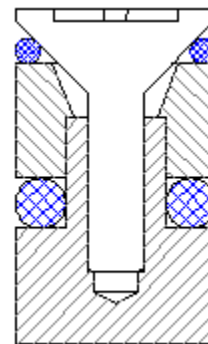
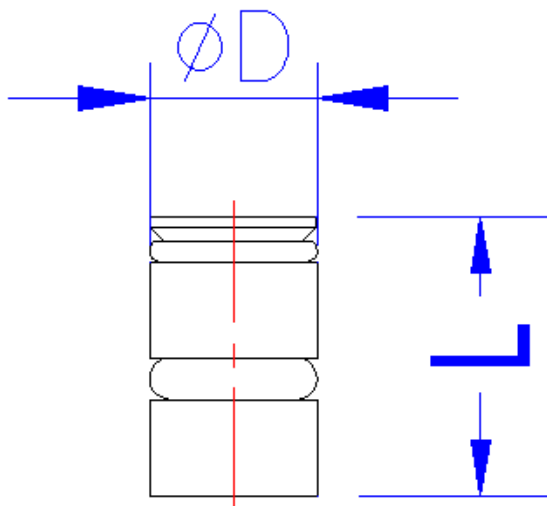
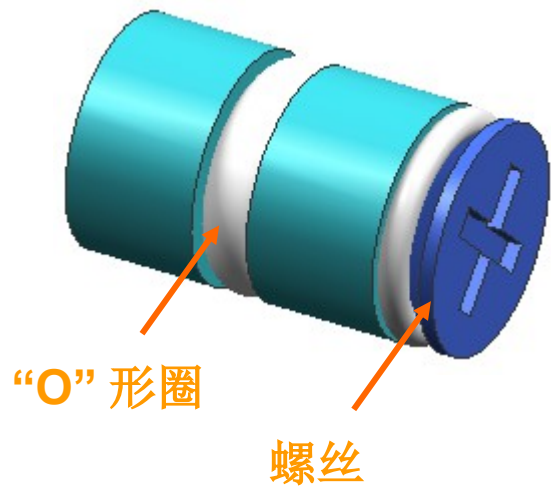
<b>D</b>	20	25	.....
<b>L</b>	根据需要调整		



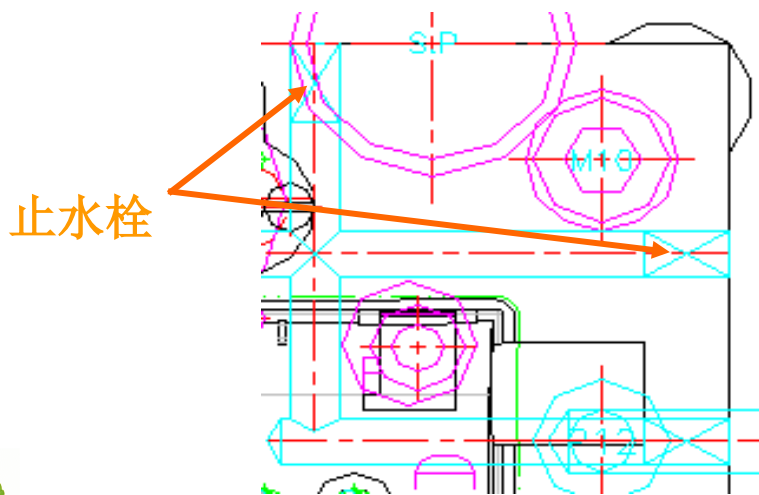
说明：用于限制模具顶出行程，常用 S50C/S45C 钢材。如右图



# 止水栓



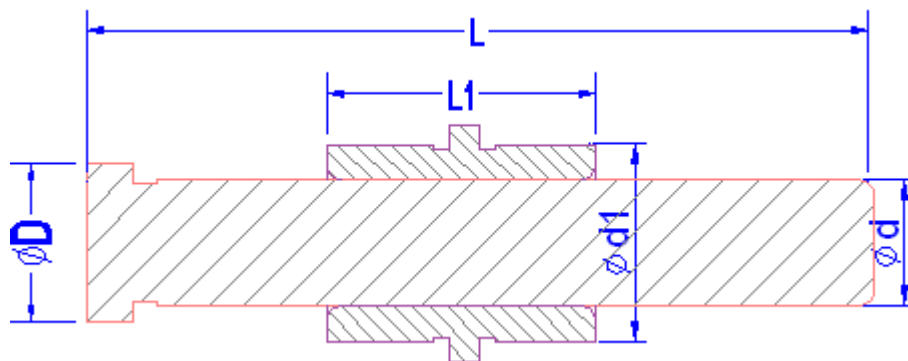
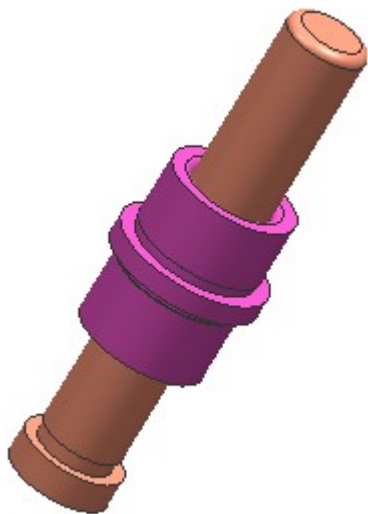
<b>D</b>	6	8	10	...
<b>L</b>	10	10	10	...



**说明：** 止水栓常应用于水路末端防止水泄露，一般采用简易画法即可。如左图。

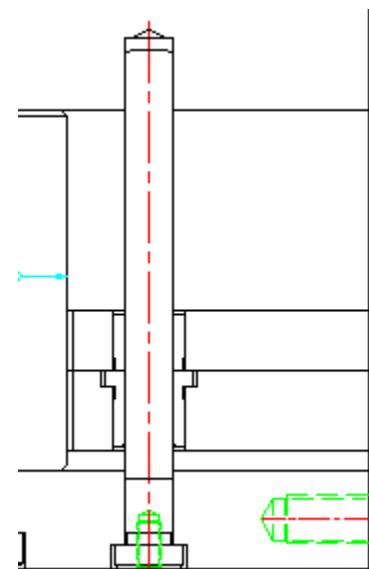


# 顶针板导柱



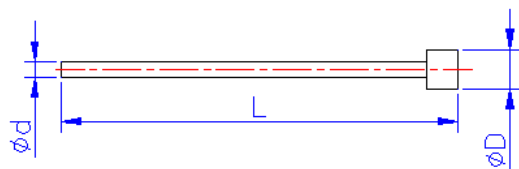
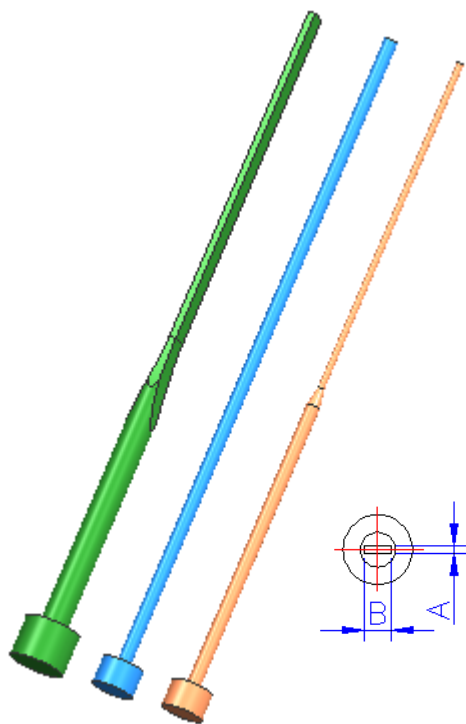
<b>d</b>	10	12	16	20	25	30
<b>D</b>	规格品					
<b>L</b>	下固定板高 + 模脚高 + d					

说明：用于顶针板精确导向。如图



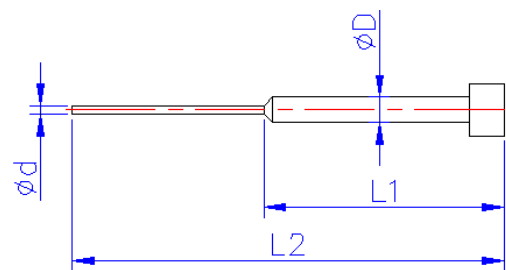


# 顶 针



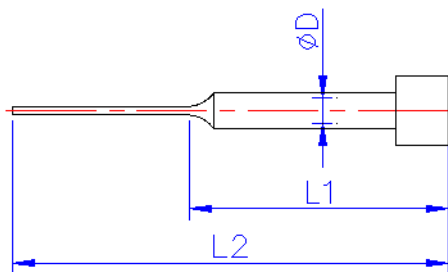
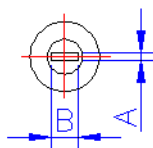
圆顶针

<b>d</b>	2	2.5	3	.....
<b>L</b>	50mm 为一长度规格			



有托顶针 / 双节顶针

<b>d</b>	0.5	0.8	1	1.5
<b>L1</b>	不小于 50mm			
<b>L2</b>	根据实际需要长度			



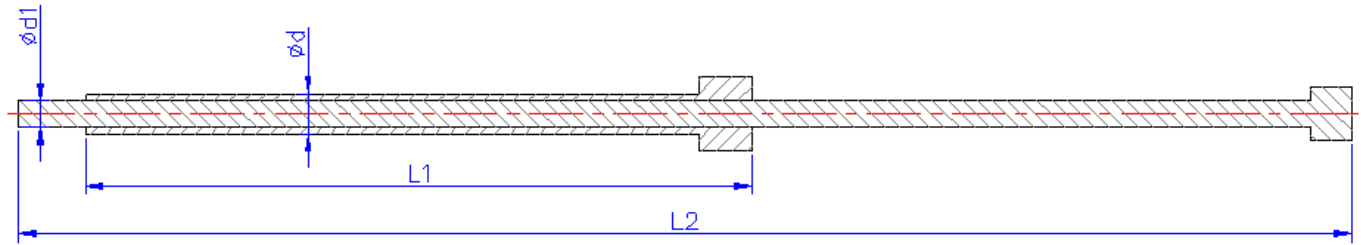
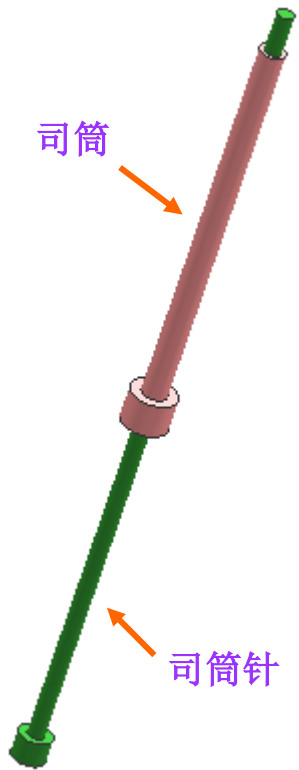
扁顶针

<b>A</b>	0.8	1	1.5	.....
<b>B</b>	根据强度和实际需要取值			
<b>L1</b>	不小于 50mm			
<b>L2</b>	根据实际需要长度			
<b>D</b>	能使 A B 都在直径内最小的整数			

**说明：顶针用于顶出塑胶产品**



# 司筒、司筒针

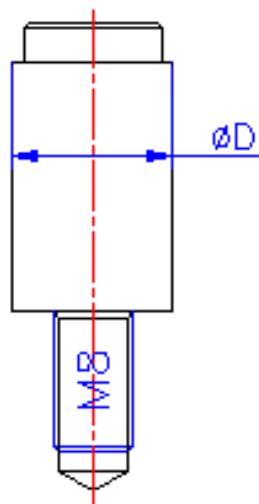
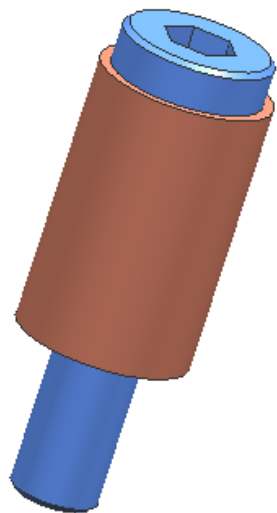


<b>d</b>	参照圆顶针规格
<b>d1</b>	参照圆顶针规格
<b>L1</b>	参照顶针规格
<b>L2</b>	参照顶针规格

说明：司筒属于顶针的另一种形式，司筒针则是一个固定不动的镶件两者相互配合，一静一动。

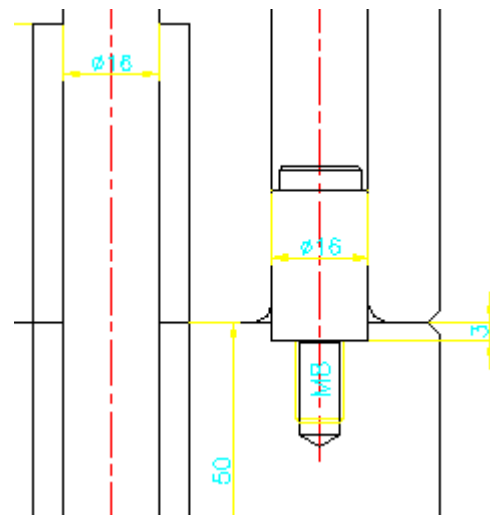


# 塑胶开闭器

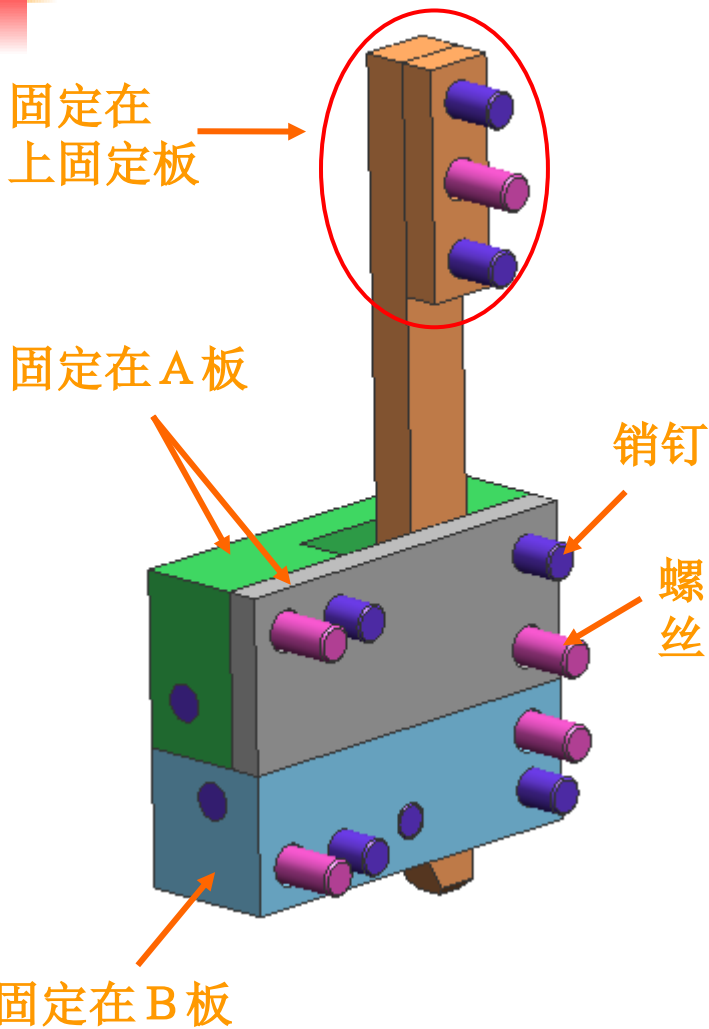


<b>D</b>	10	13	16	20
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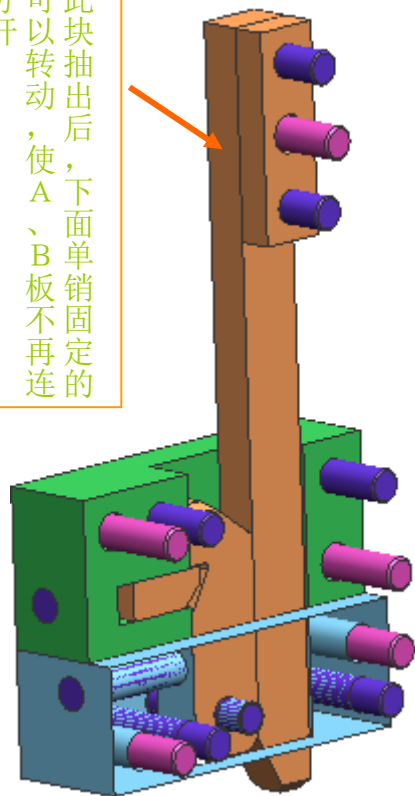
说明：开闭器常用于板与板之间的连接，如右图



# 扣机



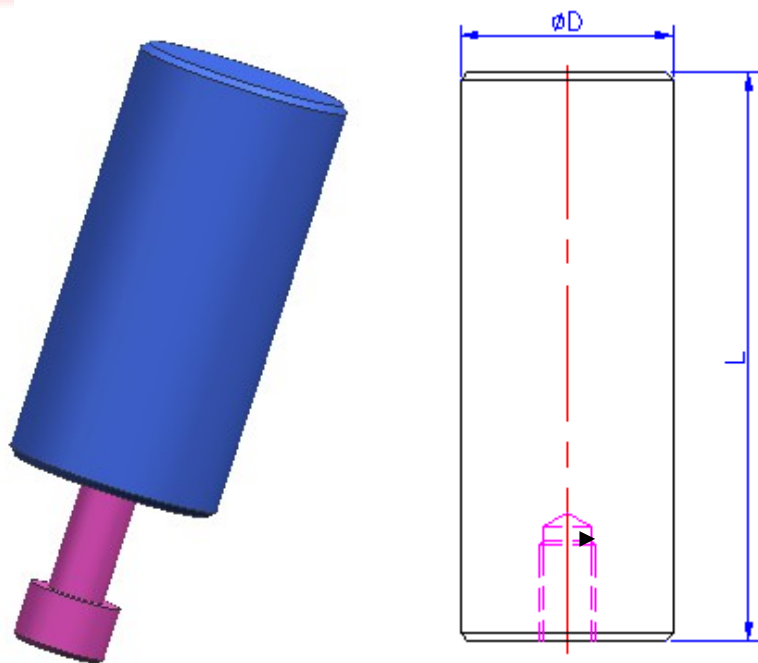
此块抽出后，下面单销固定的  
勾块可以转动，使 A、B 板不再连  
接而分开。



说明：扣机常用在需多次开模的模  
具中，并保证开模的先后顺序不错乱，  
达到塑胶产品顺利脱模的效果。在实际  
运用时可根据需要调整长度及固定的位  
置。



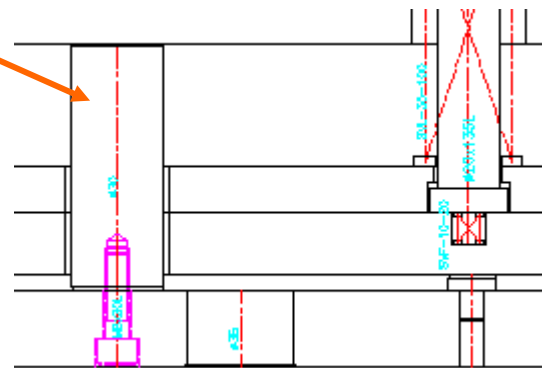
# 支撑柱



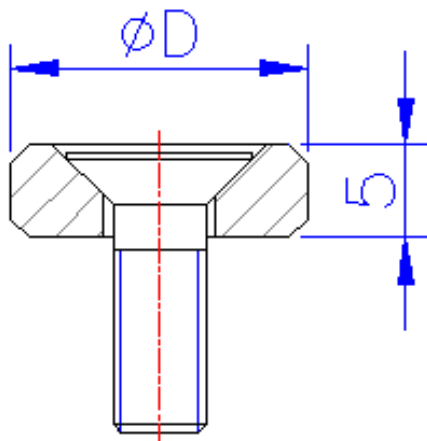
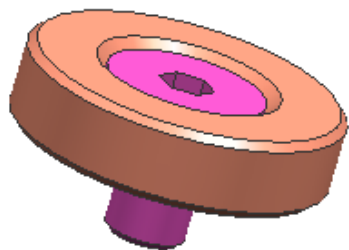
<b>D</b>	20	25	30	.....
<b>L</b>	与模具方铁实际高度同高			

说明：支撑柱又叫撑头用来辅助方铁来支撑模具，使模具难以因注塑压力过大而变形，保证模具寿命。如右图

支撑柱

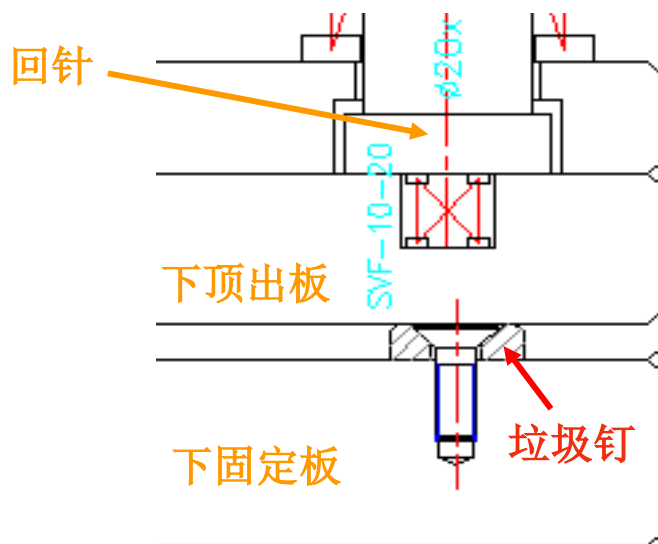


# 垃圾钉

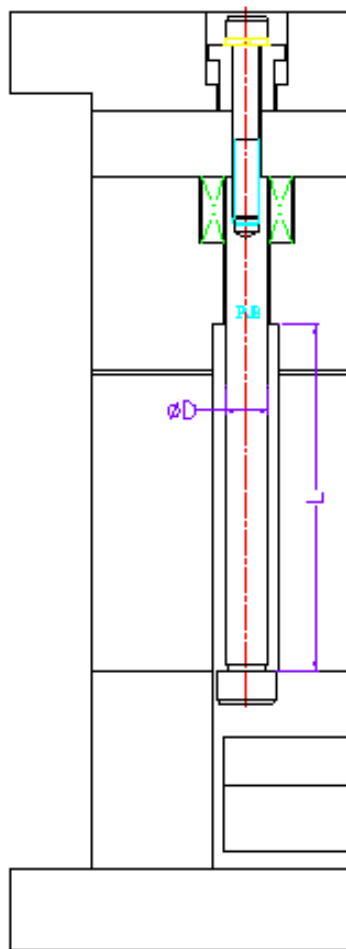
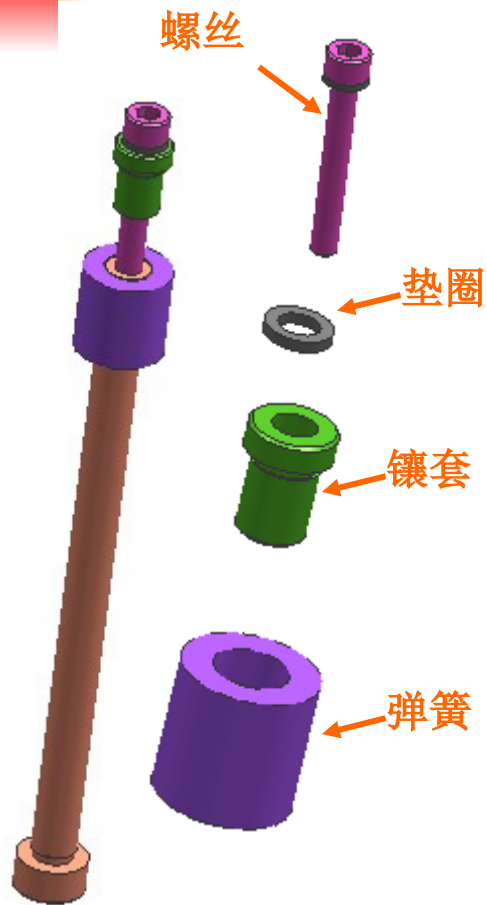


<b>D</b>	16	20	.....
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**说明：**垃圾钉位于下顶出板与下固定板之间，为了防止模具生产时垃圾掉在下顶出板下而引起的模具不平稳，放在回针下面也有抗模具变形作用。如右图



# 小 拉 杆

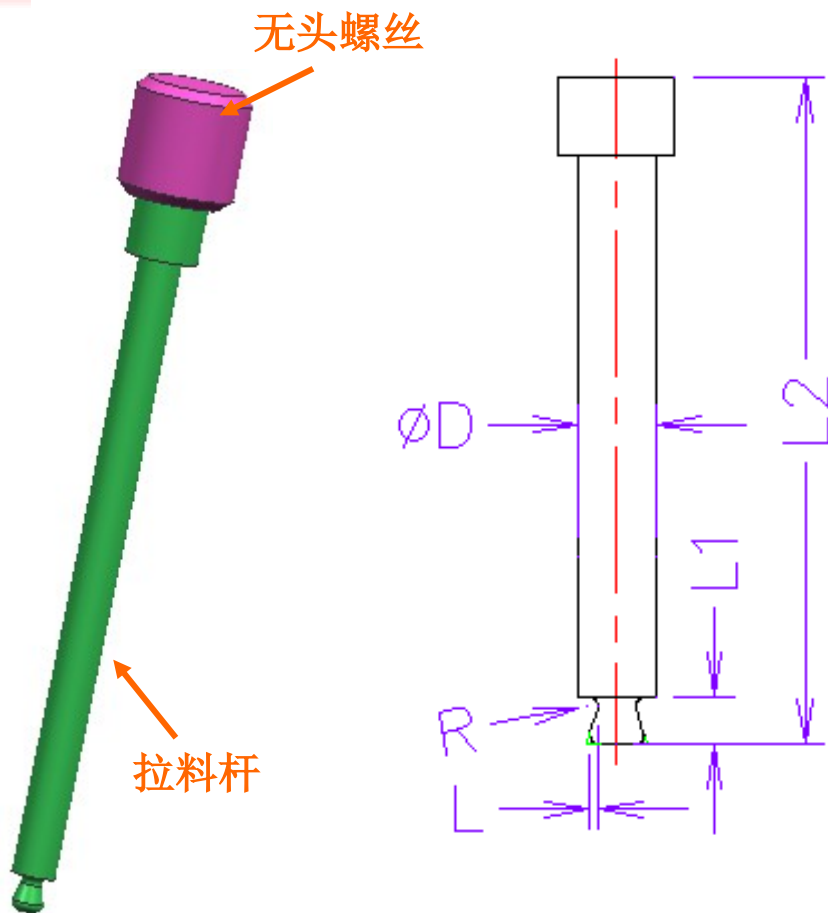


<b>D</b>	10	13	16	.....
<b>L</b>	$\geq$ 水口料长度 20mm			

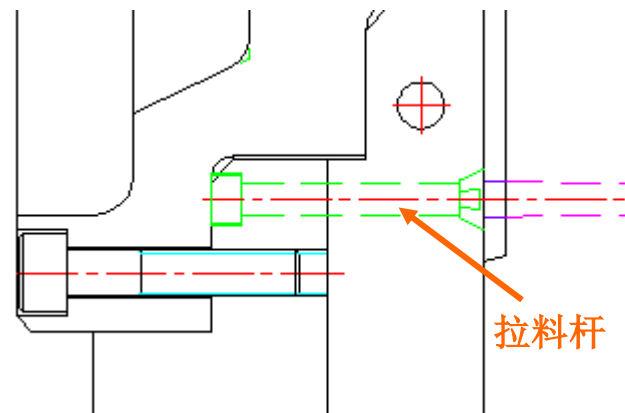
**说明：**小拉杆一般用于三板模，由多个零件装配而成为了实现多次开模而设计的一种机构，形式多样化。常用形式如左图。



# 拉料杆



D	3	4	5	6	.....
L	0.4 左右				
L1	2.5~5				
L2	根据实际板厚确定				
R	0.3~0.5				

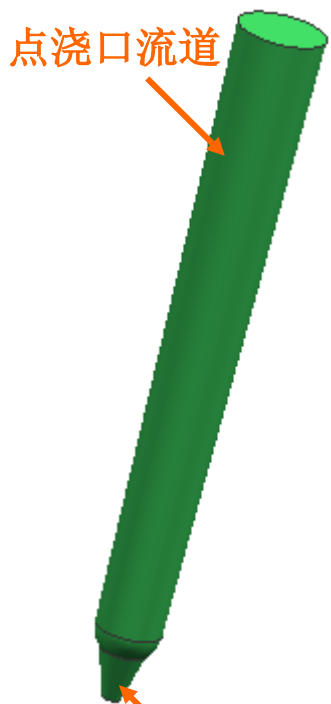


说明：拉料杆常用于三板模中，利用 L 距离的倒扣勾住流道料，开模后使流道料脱离产品。如图

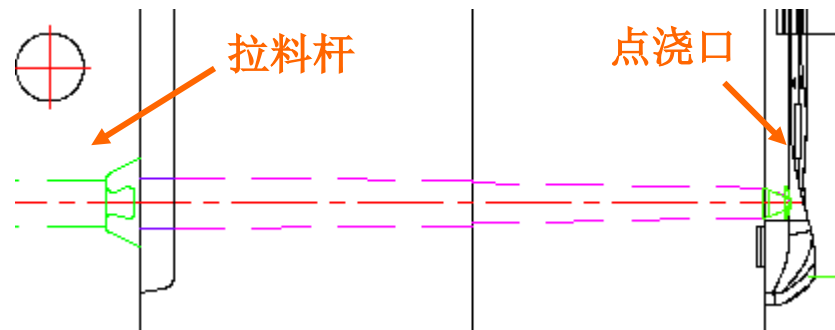
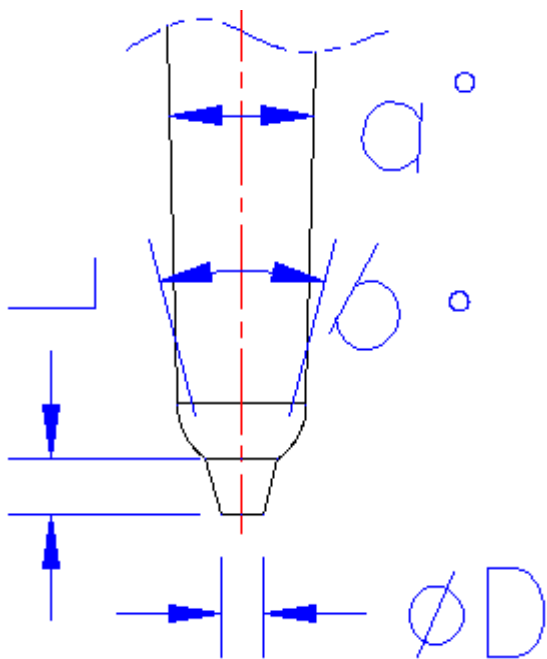


# 点 浇 口

点浇口流道



点浇口

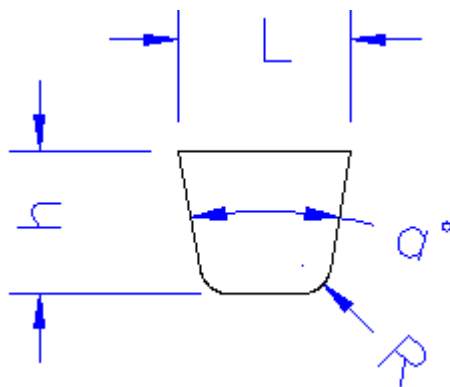
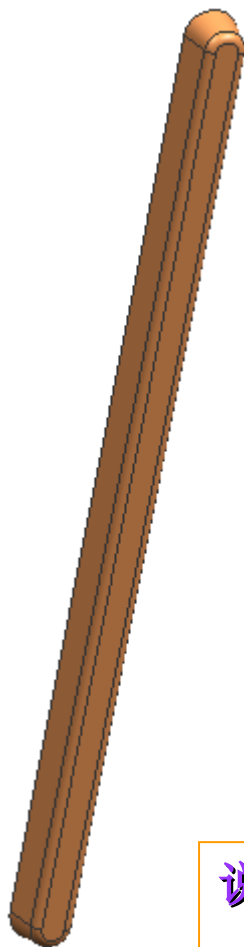


$D=0.5\sim 2$   
 $a=3\sim 10$   
 $b=20\sim 60$   
 $L=0.5\sim 2$

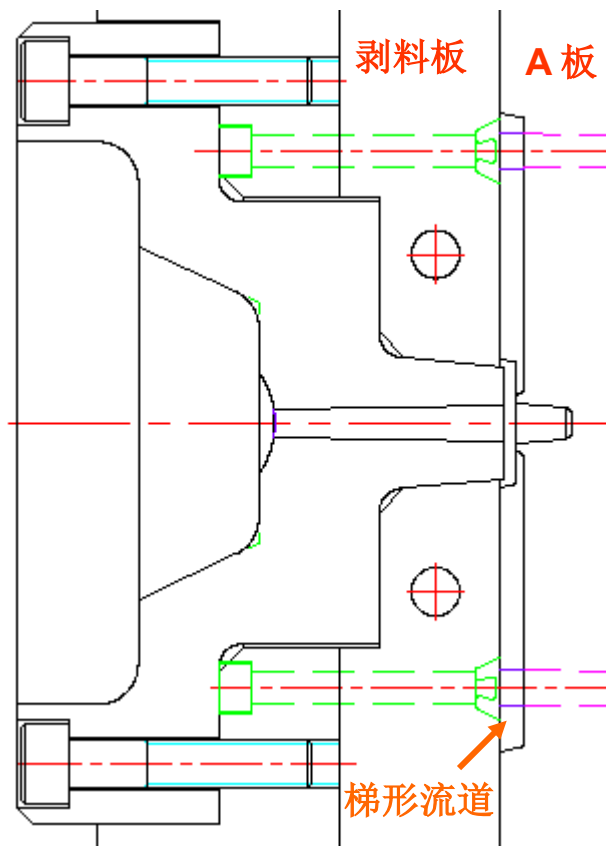
说明：点浇口常用于三板模，以针点方式进浇，有利于产品外观和自动脱水口料，一般一个点相对应一个拉料杆。如上图



# 梯形流道



**L=3~10**  
**h=3~8**  
**a=10~30**  
**R=0.5~3**

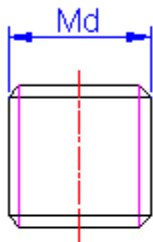


说明：梯形流道常用于三板模，此流道开在剥料板下的A板处，流动性次于圆形流道。

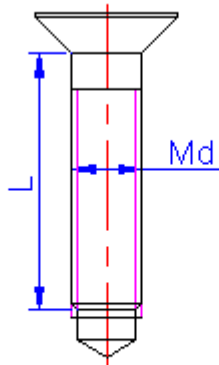


# 螺 丝

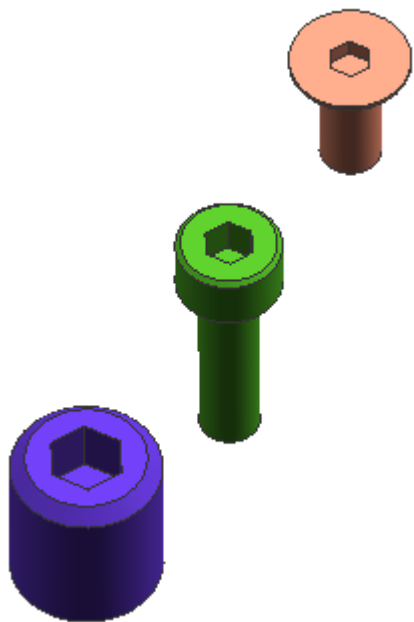
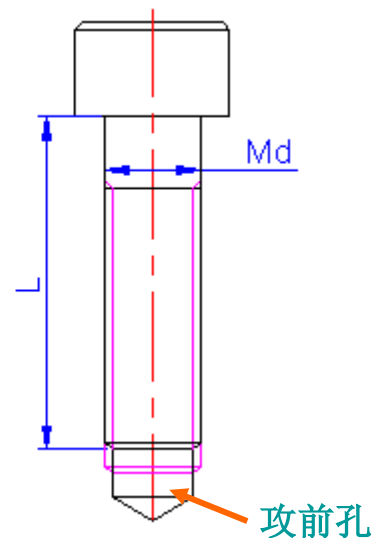
无头螺丝



平头螺丝



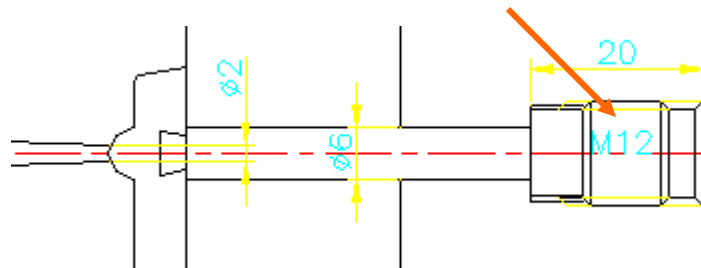
内六角螺丝



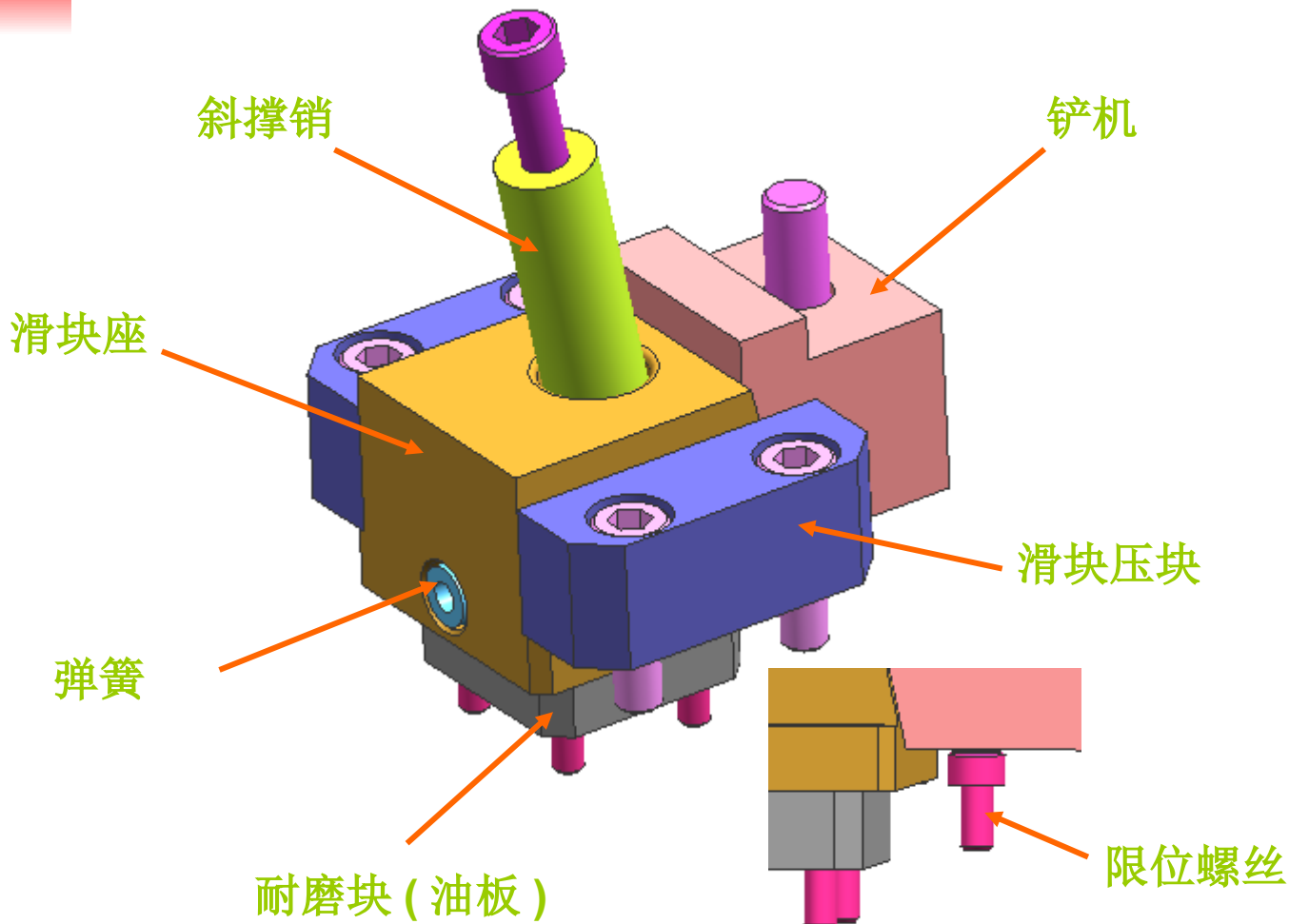
**M**, 螺丝代号  
**D**, 螺丝最大直径  
**L**, 螺紋有效长度

说明：模具中常用螺丝为这三种，在模具中起到固定和连接的作用。

无头螺丝



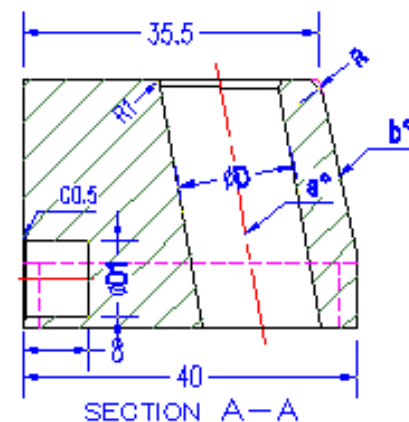
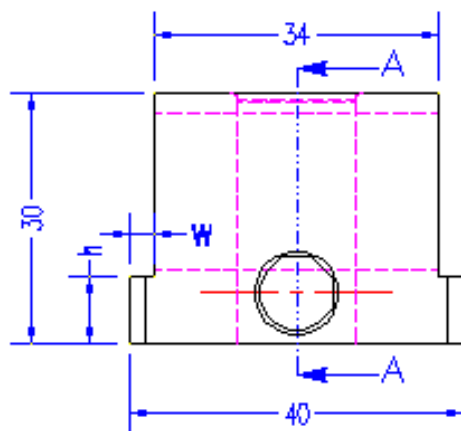
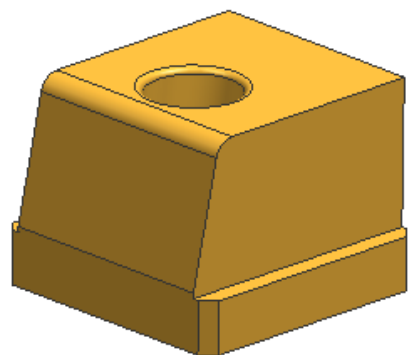
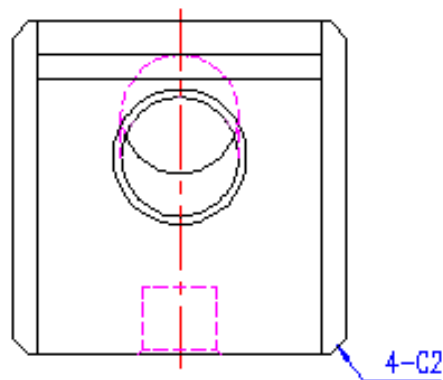
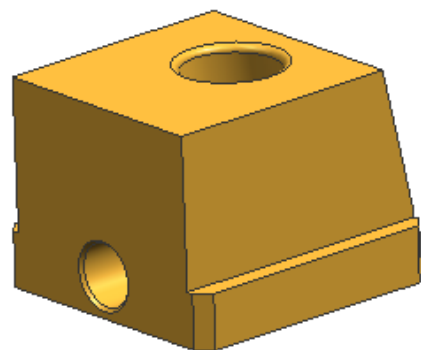
# 滑 块



说明：滑块又叫行位，常用于产品侧抽向抽芯，抽芯部分与滑块座连接。是常见的一种模具机构。



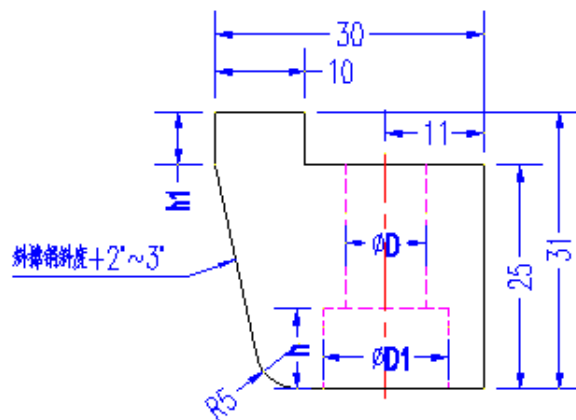
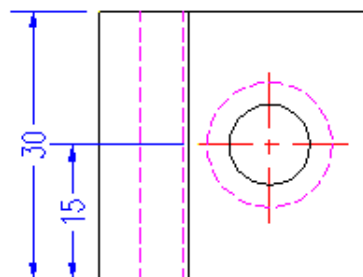
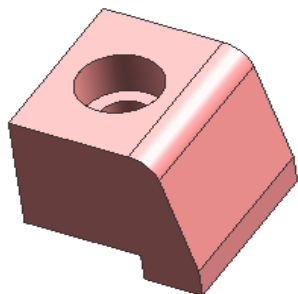
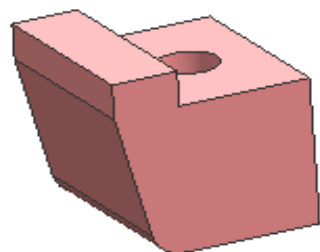
# 滑块座



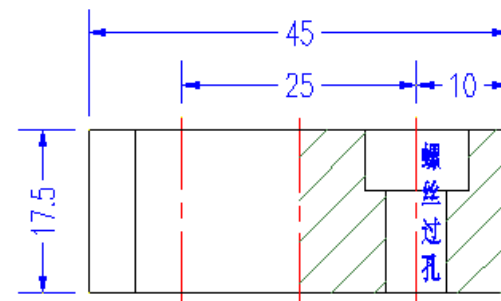
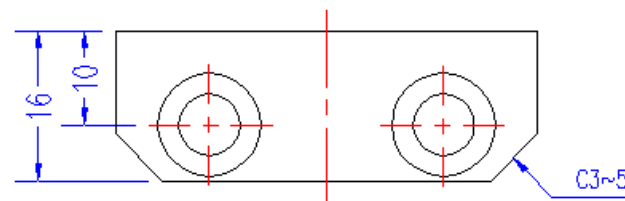
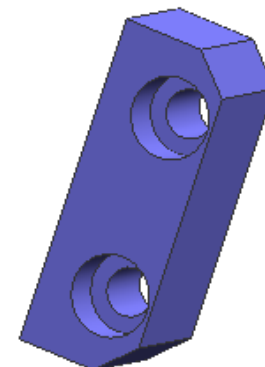
**$W=3\sim 5$**        **$h=5\sim 8$**        **$a\leq 24$**        **$b=a+2\sim 3$**   
 **$D = \text{斜撑斜直径} + 1\sim 2$**        **$D1 = \text{弹簧直径} + 1$**



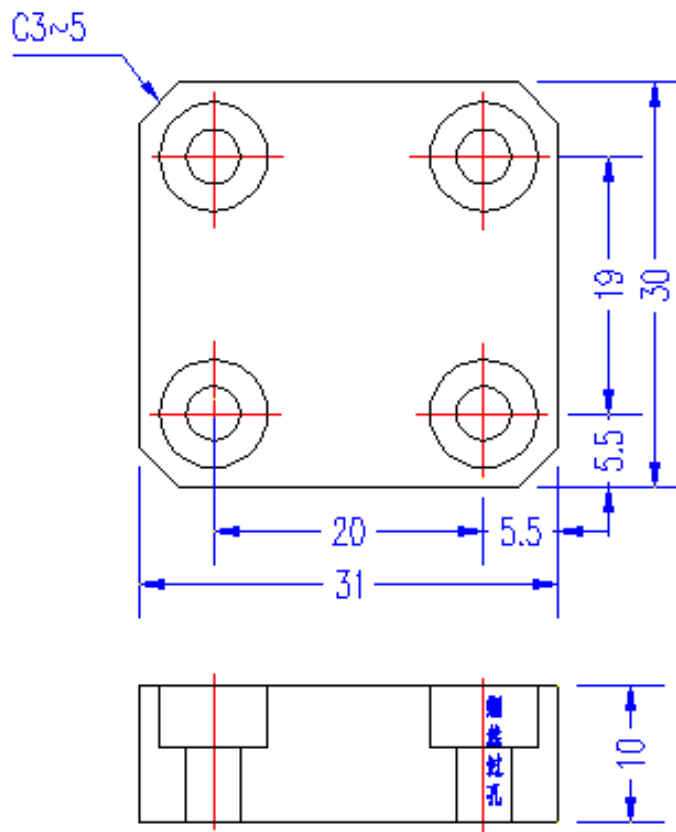
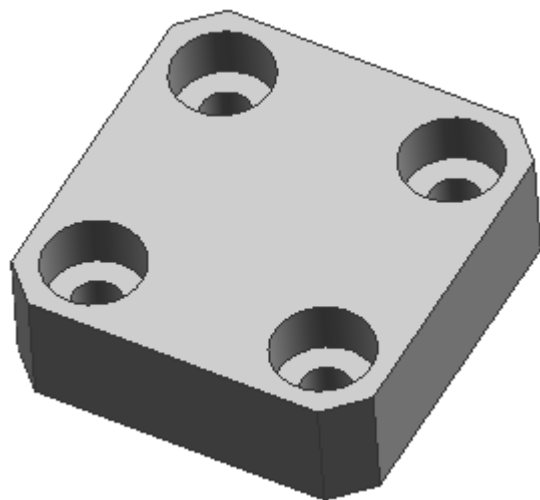
# 铲机、压块



$h1=5\sim 15$   
 $h=$  螺丝杯头高 +1  
 $D=$  螺丝直接 +1  
 $D1=$  螺丝杯头直径 +1~2



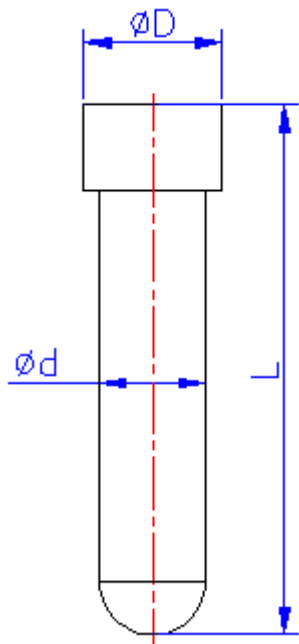
# 耐磨块



说明：耐磨块的大小根据滑块座底下大小确定。

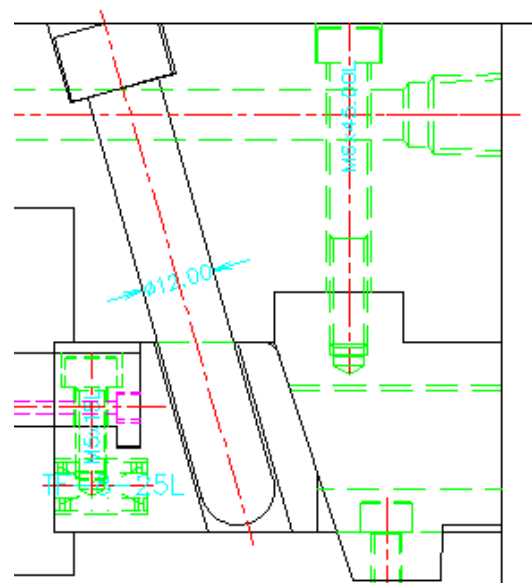


# 斜撑销



<b>d</b>	10						
<b>D</b>	13						
<b>L</b>	根据实际需要自由选择长短						

说明：斜撑销常应用于滑块中，如右图

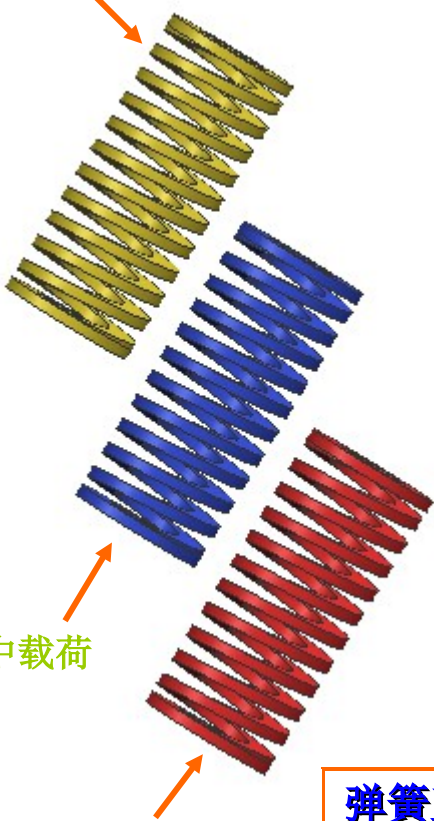


其它形式

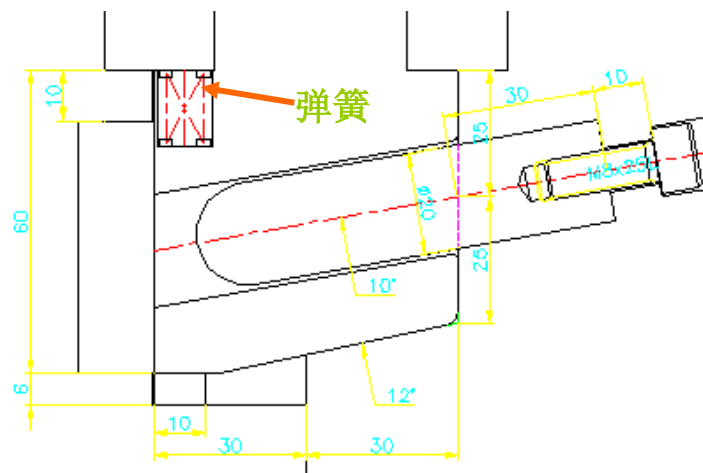
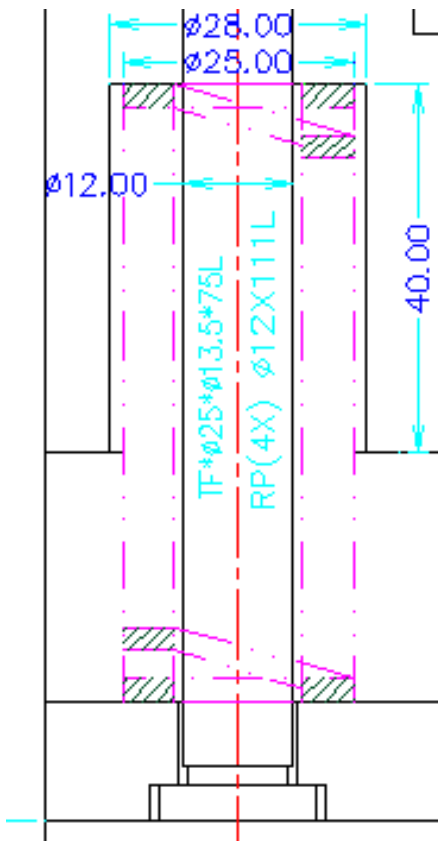


# 弹 簧

轻小载荷



中载荷

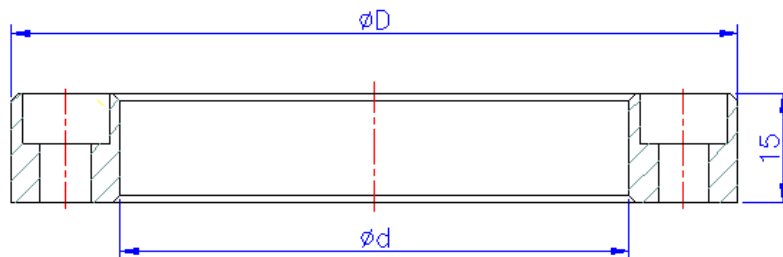
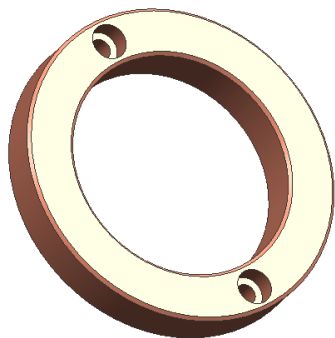


**说明：**弹簧是模具中常见的一种零件，主要应用于回针，滑块，斜顶，小拉杆，前模顶出等场合。

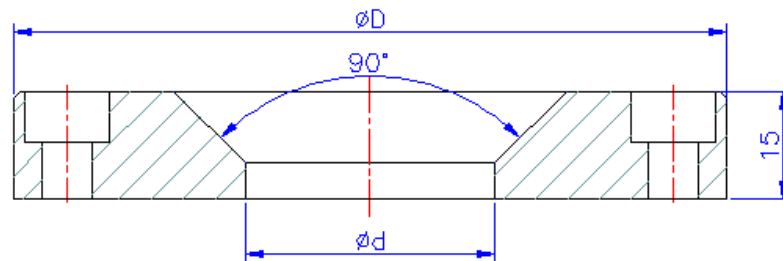
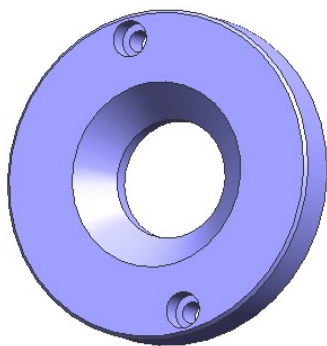
弹簧直径	8	10	12	15	20	25	30	.....
弹簧长度	长度根据实际需要而定，一般以 5 为增量单位							



# 定位环



<b>D</b>	100	120	.....
<b>d</b>	70	90	.....

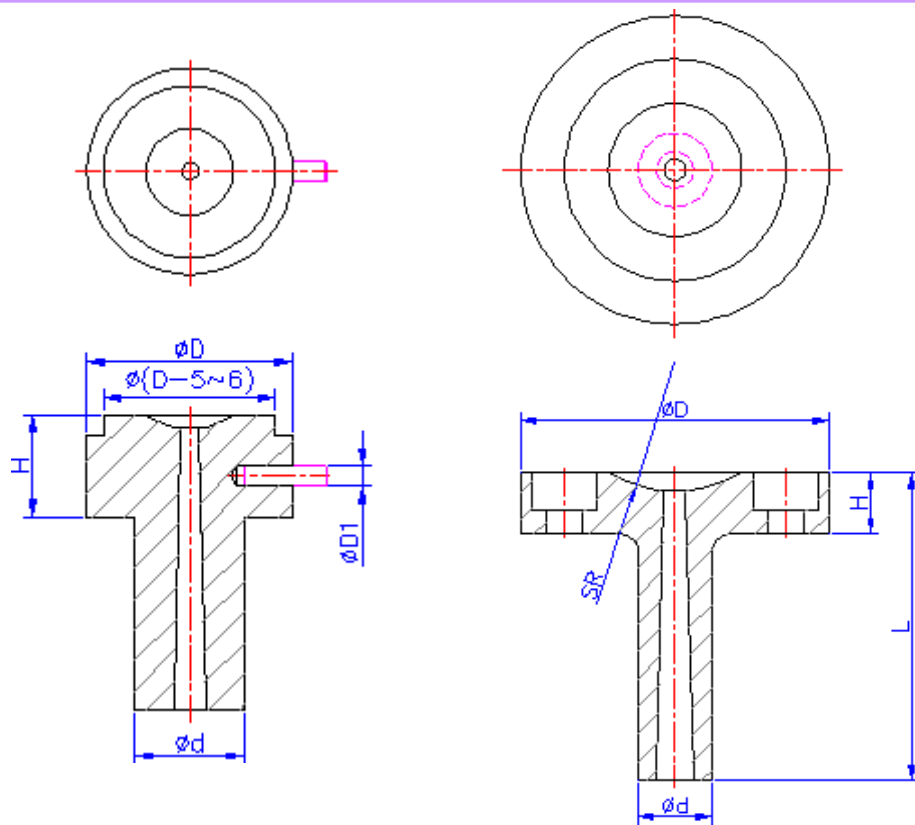
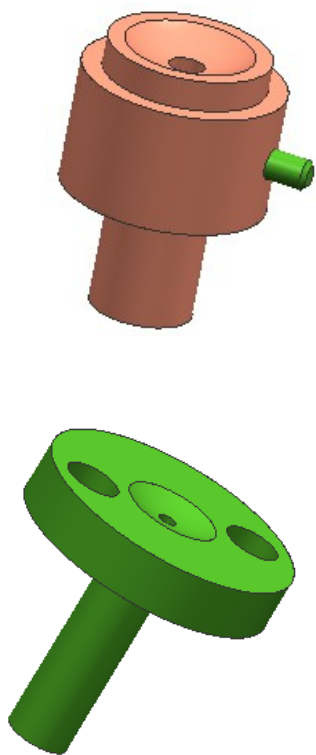


<b>D</b>	100	120	.....
<b>d</b>	35	35	.....

说明：定位环又叫定位圈，与注塑机连接，给注塑机喷嘴定位作用。



# 唧嘴

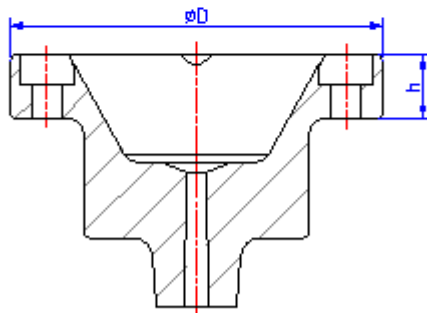
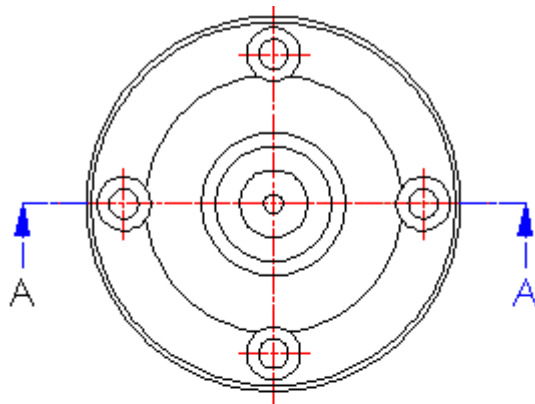
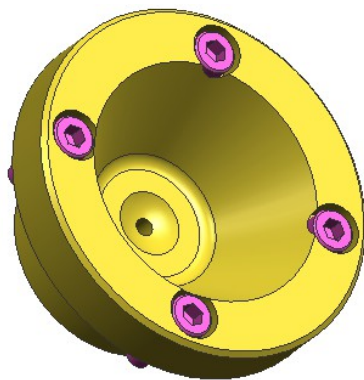


D d h: 型号不同尺寸不同，可查看相关标准件书，L可根据实际需要长度任意调整。

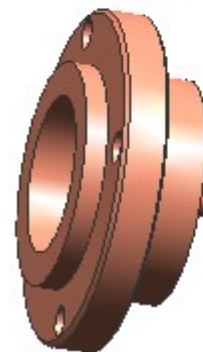
说明：注塑成型时唧嘴和注塑机喷嘴相接触，常见形式有销钉和螺丝固定二种形式，如上图。



# 延伸唧嘴



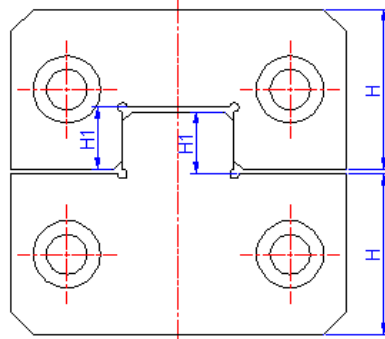
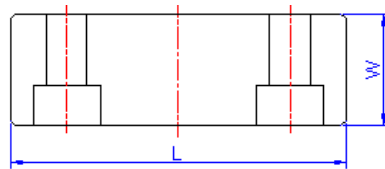
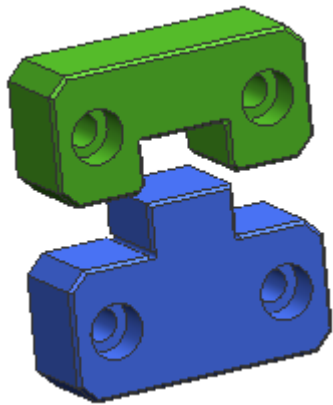
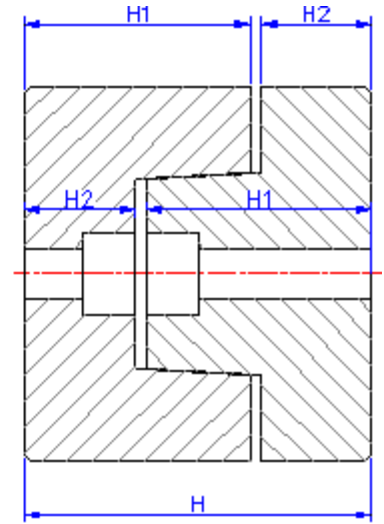
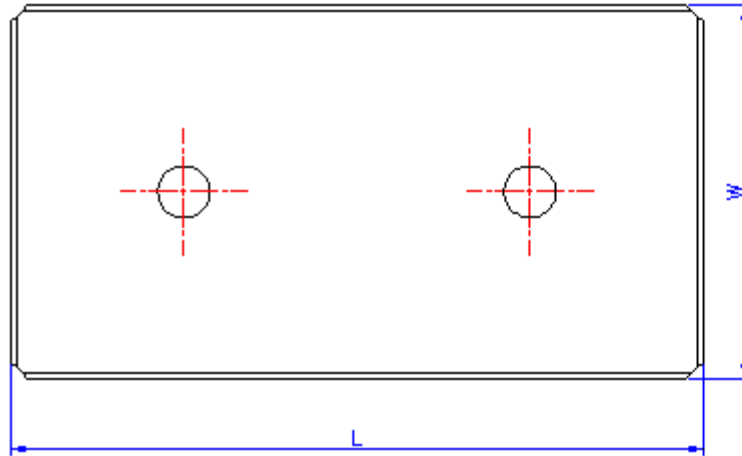
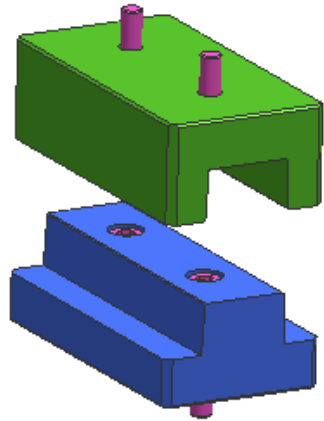
SECTION A-A



其它形式

说明：延伸唧嘴是把定位环和唧嘴二部分做成一个整体的模具零件  
其规格尺寸可参照定位环和唧嘴自行设计出所需要的规格。





**说明：**边锁 / 零度束块，是一种模具标准零件，常用于精密定位，成对使用。



顶针板导柱: **EGP** 顶针: **JP/EP** 回针: **RP** 导柱: **GB**  
弹簧: **spring** 公模仁: **core** 母模仁: **cavity** 滑块: **Side**  
浇口: **gate** 水路: **cool** 螺丝: **Screw** 支撑柱: **SP**  
垃圾钉: **STD**

