

### Mag Vise 磁力夾具系統 Magnetic Workholding



Practical cases and simulation application of MagVise Clamping System

客戶應用照片與加工模擬圖片

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擁有40餘個國家的代理商及經銷商。除上 萬向磁性表座系列、鑽頭&端銑刀研磨機系/列···等產品,為最專業磁性系統工具研製企業。

儀辰企業一直以『創新、誠實、責任』為經營理念,積極投入產品研發,誠懇實在面對客戶所需,並秉持著企業永續經營的責任,由內而外時刻改善,自我不斷提升品質控管及改革能力,站在客戶的角度檢視產品,盡心服務以符合客戶真正需求。

Established in 1988, Earth-Chain Enterprise Co., Ltd. is a professional manufacturer of magnetic tools. The MagVise Magnetic Workholding 'Electro-Permanent Magnetic Chuck EEPM Series', Permanent Lifting Magnets ELM Series, and New Dovetail Microinching Equipment was awarded 'Good Design Product Mark' by the Industrial Development Bureau, Ministry of Economic Affairs and the 18th Taiwan Excellence Award, the "Electro-Permanent Magnetic Chuck Connection Type EEPM-C Series" was awarded the 19th Taiwan SMEs Innovation Award and the 21st Taiwan Excellence Award, and the MagVise MagneticWorkholding 'Permanent Magnetic Clamping Block ECB Series' was awarded the 16th Taiwan Excellence Award. With ISO 9001 and CE Certification as well as over 30 patents, Earth-Chain's private label 'E.C.E' is sold worldwide across five continents. Besides above mentioned products, there are also Lifting Magnet Series,



Universal Arm Magnetic Stand Series, Drill Grinder & End Mill Re-Sharpener Series...etc. Earth-Chain is a professional magnetic system tool manufacturer with agents and distributors from over 40 countries.

Innovation, honesty, and responsibility are our business philosophies that we are truthfully fulfilling. By innovatively devoting our efforts in product developments, honestly responding to our customers, and r esponsibly engaging in sustainable operations and managements, we always strive to improve our working processes, enhance our quality control and improvement ability, and develop products that constantly exceed customers expectations. Not only do we aim to achieve the objective- making the Power that works. The leading brand in the field of magnetic vise clamping systems, but we also set a high expectation for ourselves to create glories in the machining and metalworking industry.











EEPM 系列/Series

- 1. 永久磁盤電控式結構設計;1~3 秒鐘充、退磁,使用 時不須持續供電,無溫升,可長時間使用,不會因溫 度升高導致工件變形影響精度。
- 2. 夾持面積能平均涵蓋完整加工範圍,可同時加工多件 工作物,改善加工流程時間。
- 1. 1-6 seconds control for power ON & OFF. No power supply to keep the magnetic chuck ON, it could be used for long time and never get temperatures to affect the accuracy of workpieces.
- Clamping area covers all machining areas it can be machining multi-workpieces and shorten machining time

#### Electro-Permanent Magnetic Chuck

#### 永磁式電控磁盤-連結型

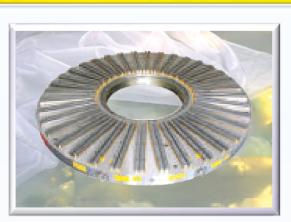


EEPM-C 系列/Series

- 1. 可依工件之大小自由組合磁力工作台之數量、位置及 問題。
- 2. 加工時刀具暢行無阻,達到鑽孔、攻牙、銑溝槽、一次完成五面成形加工等功能求。
- 1. Free to set up position, numbers and distance of EEPM-C Series according to the size of workpiece.
- 2. With induction block can be increased to more functions on workholding. Un-obstructed movement of cutters during machining. Can do 5- sides machining, drilling, tapping, grooving and forming can be done all in one cycle. This greatly enhances work efficiency, and reduces repeated positioning tolerances to achieve best machining accuracy.

#### Electro-Permanent Magnetic Chuck

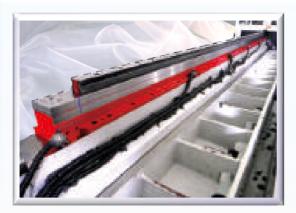
#### 永磁式電控磁盤



EEPM-CIR 系列/Series

- 1. 圓形放射狀磁極設計,適合圓形及任何形狀之工件夾 持加工。
- 2. 工件夾持加工無障礙,可自由加工工件之任何五面, 真正發揮五面加工之功能。
- Round type and radiate magnetic poles, suitable for clamping round type and any form of workpiece machining.
- 2. Un-obstructed movement of cutters during machining, the really functions of 5 side machining on workholding.

#### **Electro-Permanent Magnetic Chuck**



EEPML 系列/Series

- 1. 適用於精密線軌或長條型工件銑床、鑽孔、研磨等精 密加工使用。
- 永久磁盤電控式結構設計:1~3秒鐘充、退磁,使用時不須持續供電,無溫升、可長時間使用,不會因溫度升高導致工件變形影響精度。
- Used on Linear Guideway high precision or high accuracyoblong shape workpiece drilling, grinding machining...etc.
- 2. 1-3 seconds control for power ON & OFF. No power supply to keep the magnetic chuck ON, it could be used for long time and never get temperatures to affect the accuracy of workpieces.

#### **Electro-Permanent Magnetic Chuck**

永磁式電控磁盤



EEPM-PIM 系列/Series

- 1. 塑膠射出成型機快速換模系統
- 2. 大幅縮短70%換模時間,提升機台稼動率,適合多品種少批量、縮短交期及提升生產SOP產能。
- 3. 可提升20%容模率,不用壓板治具,發揮機台最大容模尺寸。
- Quick Mold Change Systems for Plastic Injection
   Machine
- Reduce 70% mold setting time significantly, increase machine shifts, shorten lead times and increase production capacity.
- 3. Increase 20% clamping area, without fixture plate enhancing the performance of the mold.

#### Permanent Magnetic Clamping Block

#### 永磁式磁力工作台



ECB 系列/Series

- 1. 快速夾持工件,可做5面切削加工,鑽孔、攻牙、銑 溝槽一次完成,節省加工並提高工作效率,大幅降低 加工成本。
- 2. 可依工件之大小自由組合磁力工作台之數量、位置及 間距。
- The all new model Magnetic Clamping Block ECB Series are a new sense of clamping way for metal working on CNC Machining Center and Milling Machine in quick clamp workpieces.
- 2. Free to set up position, numbers and distance of ECB Series according to the size of workpiece.

### Application Example for Accessories Series 永磁式電控磁盤 EEPM 系列 特別附件應用圖片

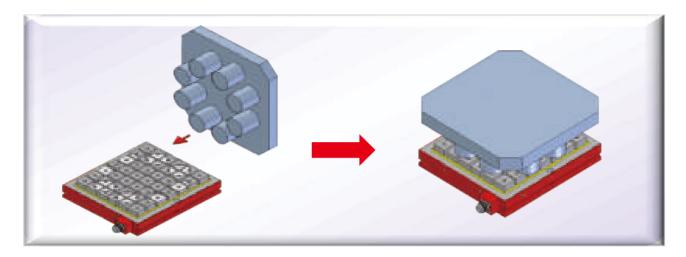
induction Block 1 導磁軟爪應用	Induction Sub Plate		
Spring Block 彈簣軟爪應用			
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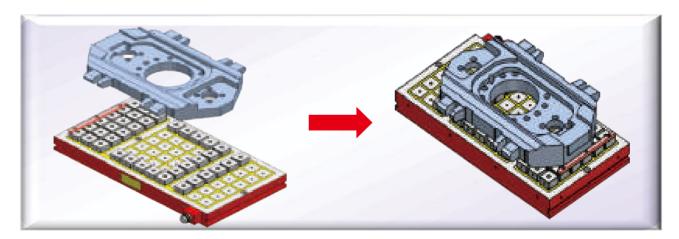


### **EEPM-IB**



當工件形狀特殊無法於磁盤上吸附加工時,可於導磁軟爪上針對工件外型銑挖凹槽,便可達到吸附工件加工,大幅縮短工件裝置時間。

Induction Blocks can be used for the clamping and processing of round shaped objects and irregular shaped objects. Cut/mill the induction blocks accordant with the shapes of the objects for machining different shapes of workpiece. Not only does it achieve fast positioning, but also server as a stopping plate.

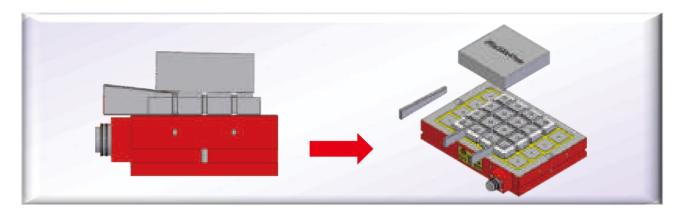


當工件內徑進行加工動作時,可應用導磁軟爪墊高工件,而內徑加工範圍則無需安裝軟爪 ,可避免加工時沾上鐵屑,達到平面與內徑一次完成加工需求。

Induction Blocks for inside diameter machining, using IB series to jack up the objects. inside diameter of the objects without IB servers to prevent the chips attaching onto objects. One process to make surface and inside diameter machining.



### **EEPM-IB**



高碳材質因含碳量較高,當工件加工完後,可能導致工件無法立即卸下。此時處理方法如上圖:加工完後,取二支已加工斜度之鋁棒,置於工件下並往內敲,就可輕易取下工件。

Since the carbon content amount is high for high-carbon materials, the object might be unable to be instantly released after machining cycle is completed due to residual magnetism. After the machining and demagnetize the EEPM chuck, place two processed slant aluminum rods underneath the object and strike the rods inwards to easily remove the object.



安裝頂針軟爪,將退磁後仍不易取下磁化之高碳鋼工件,藉由軟爪內PIN頂出力量,可輕易分離安全卸料。

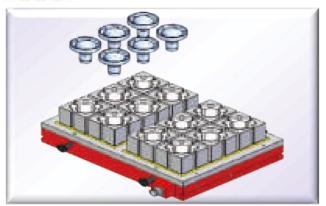
The high-carbon steel parts are difficult to remove after the magnetization using induction block with raise pin structure can easily remove the workpiece.

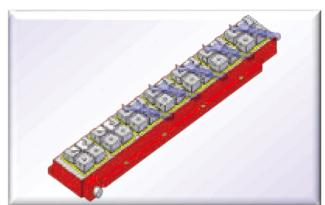


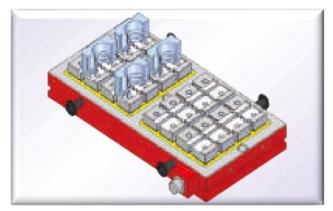
# EEPM-IB

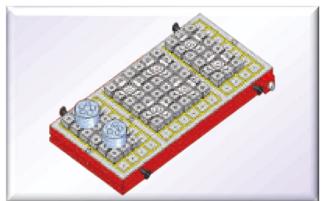


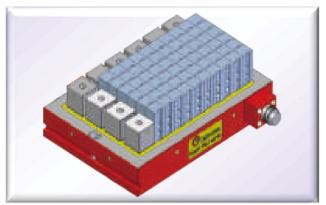
特別附件 任意搭配組合 靈活運用 Option Accessories Flexible Use, Increased More Functions

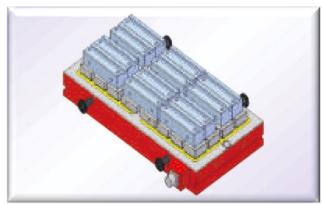


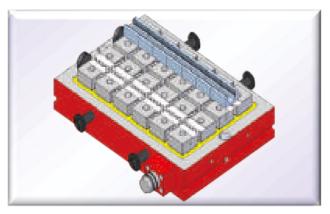


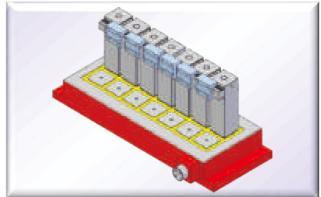










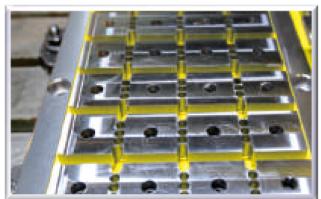


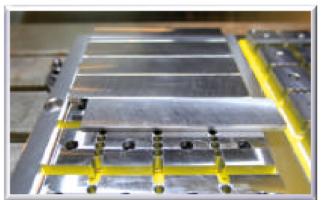


# EEPM-IB



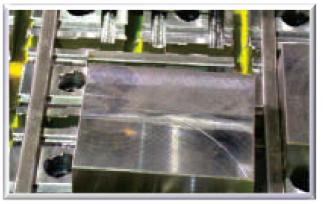
















### 彈簧軟爪應用實例 Spring Block

# **EEPM-SP**



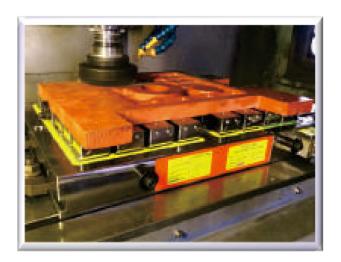
特別附件 任意搭配組合 靈活運用 Option Accessories Flexible Use, Increased More Functions



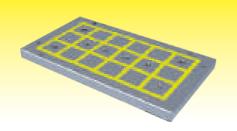












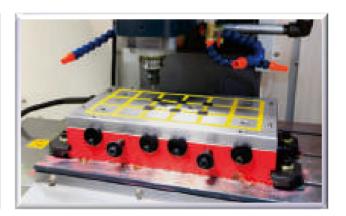
### 導磁面板應用實例 Induction Sub Plate

# **EEPM-ISP**

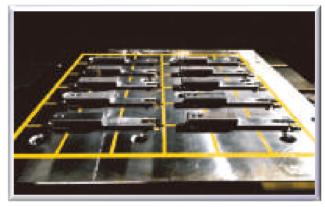


特別附件 任意搭配組合 靈活運用 Option Accessories Flexible Use, Increased More Functions







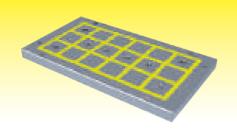












### 導磁面板應用模擬範例 Induction Sub Plate

# **EEPM-ISP**





# 薄小型工件加工應用實例 EEPM Thin and Small Workpiece Machining



EEPM-A / EEPM-B 系列 薄小工件加工應用

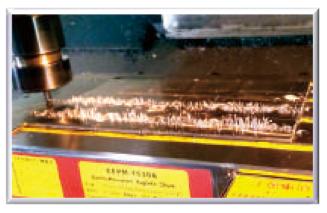


EEPM-A / EEPM-B Series
Thin & Small Workpiece Applications





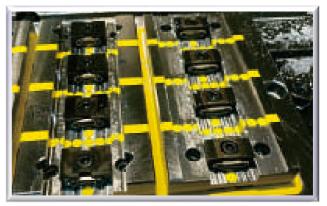














### 小型工件加工應用實例 Small Workpiece Machining

### **EEPM**



EEPM-A / EEPM-B 系列 薄小工件加工應用



EEPM-A / EEPM-B Series
Thin & Small Workpiece Applications





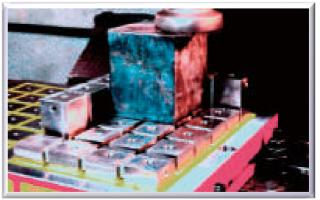














### 中型工件加工應用實例 Medium Workpiece Machining

### **EEPM**



EEPM-D / EEPM-E 系列 中大型工件加工應用



EEEPM-D / EEPM-E Series

Medium & Large Workpiece Applications



















# 中、大型工件加工應用實例 EEPM Medium and Large Workpiece Machining



EEPM-D / EEPM-E 系列 中大型工件加工應用



EEEPM-D / EEPM-E Series

Medium & Large Workpiece Applications



















## 大型工件加工應用實例 Large Workpiece Thin Machining

## **EEPM**



EEPM-D / EEPM-E 系列 中大型工件加工應用



EEEPM-D / EEPM-E Series

Medium & Large Workpiece Applications





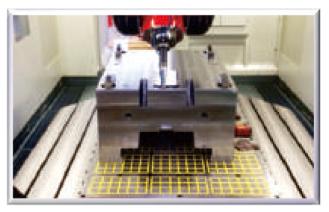














### 量產工件加工應用實例 Multi-workpiece Machining

## **EEPM**



應用實例影片 Practical Case



















### 永磁式電控磁盤-連結型 應用實例 Application Examples of EEPM-C

# EEPM-C



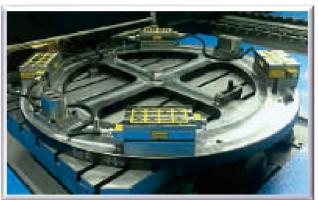
EEPM-C / ECB 系列 龍門大型工件加工應用 (自由組合磁力夾具之數量、位置及間距)



EEPM-C / ECB Series

Double Column Application
(Free to set up position, numbers and distance)



















### 立式車床研磨 Vertical Lathe (Grinding)

# EEPM-CIR



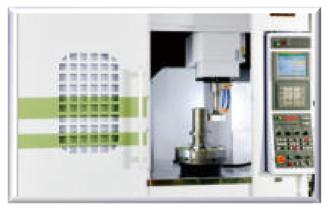
EEPM-CIR 系列 圓形工件加工應用



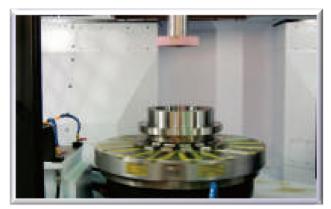
EEPM-CIR Series
Round Workpiece Applications



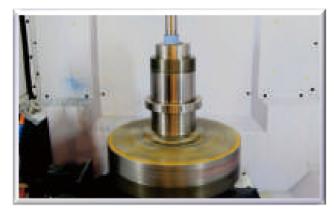


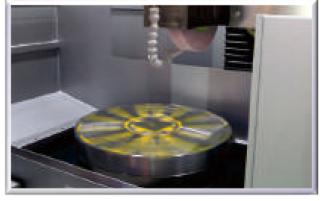














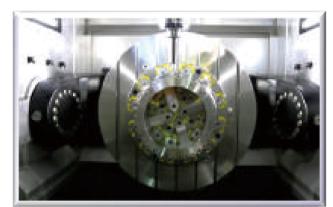
# 立式車床 & 五軸加工 **EEPM-CIR**<u>Vertical Lathe & CNC 5 Axis Machining</u>



EEPM-CIR 系列 圓形工件加工應用



EEPM-CIR Series
Round Workpiece Applications

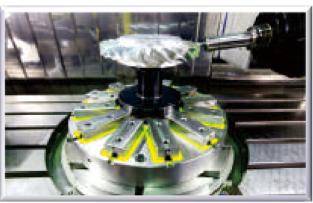


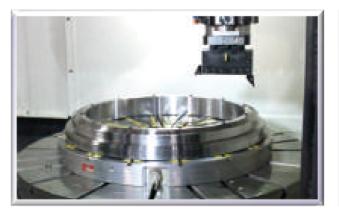
















### 臥式車銑、研磨 Horizontal Lathe (Grinding)

# **EEPM-CIR**



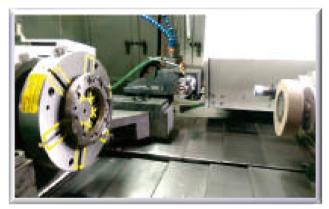
EEPM-CIR 系列 圓形工件加工應用



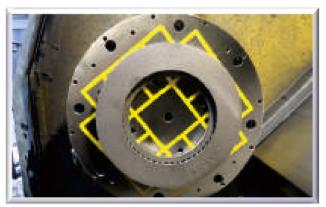
EEPM-CIR Series
Round Workpiece Applications



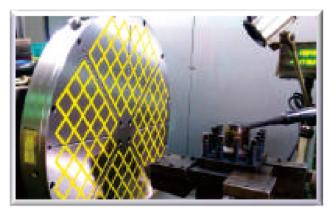








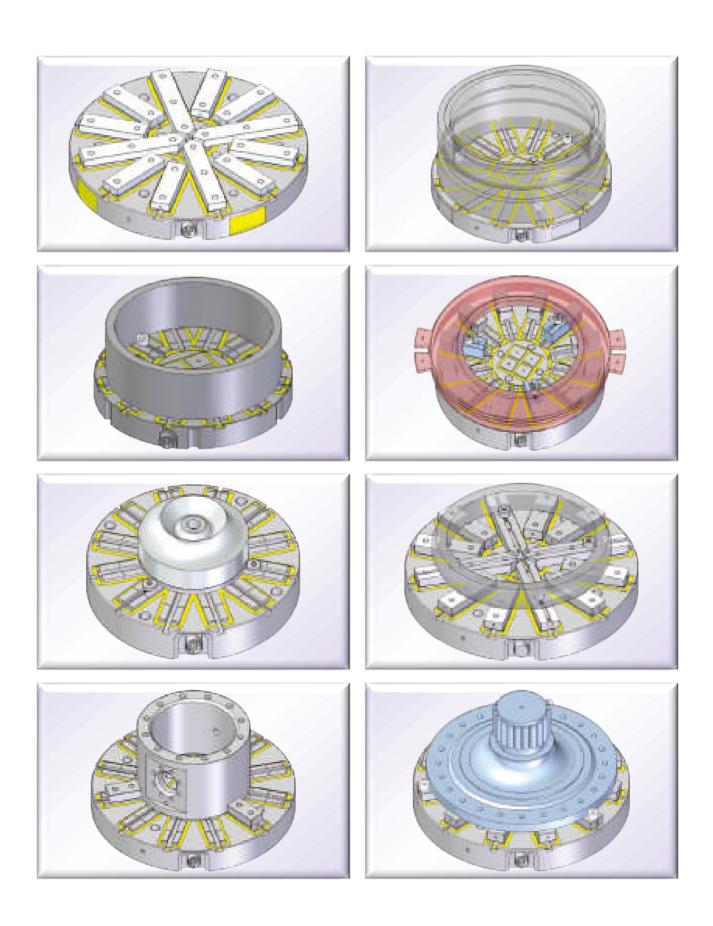






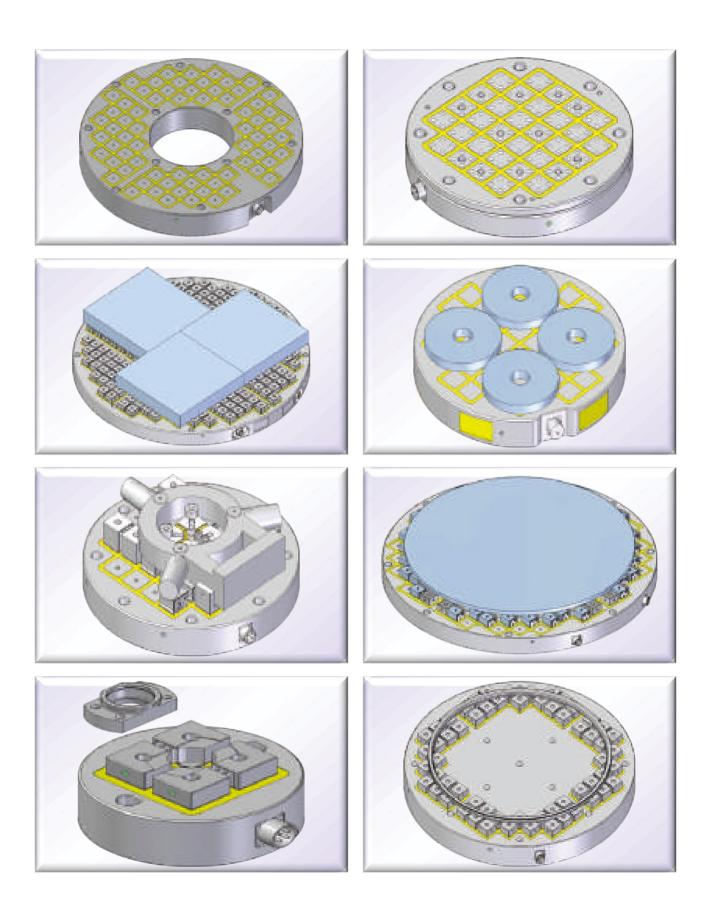


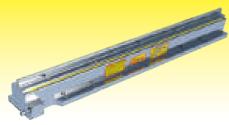
# 立式車床 & 五軸加工模擬範例 **EEPM-CIR** Vertical Lathe & CNC 5 Axis Machining (simulation)





# 立式車床 & 五軸加工模擬範例 **EEPM-CIR** Vertical Lathe & CNC 5 Axis Machining (simulation)





### 精密線軌研磨 Linear Guideway high precision

## **EEPML**



EEPML 系列 精密線軌或長條型工件加工使用



EEPML Series Linear Guideway / Strip-Shaped Workpiece





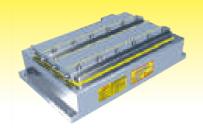










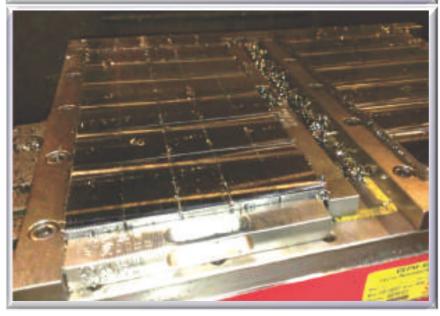


### 滑塊加工應用實例 Slide Block Machining

# **EEPM**

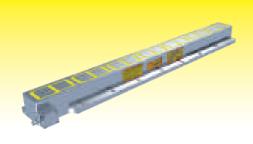
















# 塑膠射出成型機快速換模系統 EEPM-PIM Quick Mold Change Systems for Plastic Injection Machine



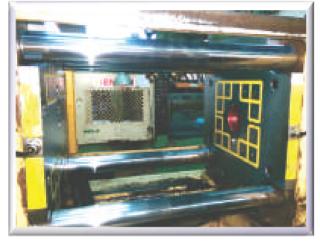
EEPM-PIM 系列 塑膠射出成型快速換模系統



EEPM-PIM Series

Quick Mold Change Systems for

Plastic Injection Machine



120T 橡塑膠射出機



Plastic Injection Machine



150T 橡塑膠射出機



Plastic Injection Machine



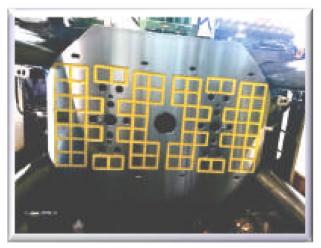
550T 橡塑膠射出機



Plastic Injection Machine



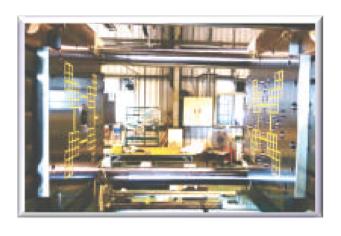
# 塑膠射出成型機快速換模系統 EEPM-PIM Quick Mold Change Systems for Plastic Injection Machine



750T 橡塑膠射出機



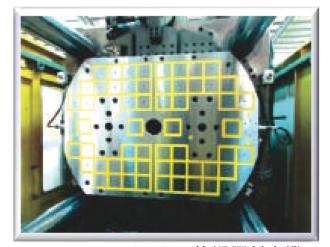
Plastic Injection Machine



750T 橡塑膠射出機



Plastic Injection Machine



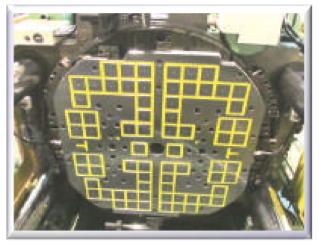
950T 橡塑膠射出機



Plastic Injection Machine



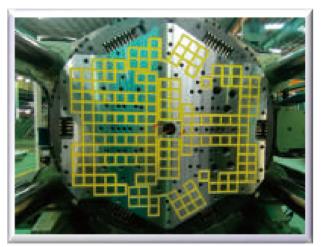
# 塑膠射出成型機快速換模系統 EEPM-PIM Quick Mold Change Systems for Plastic Injection Machine



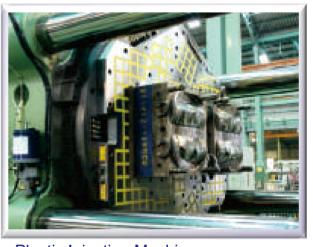
1200T 橡塑膠射出機



Plastic Injection Machine



1600T 橡塑膠射出機



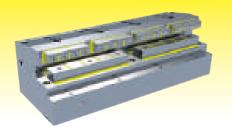
Plastic Injection Machine



1800T 橡塑膠射出機



Plastic Injection Machine

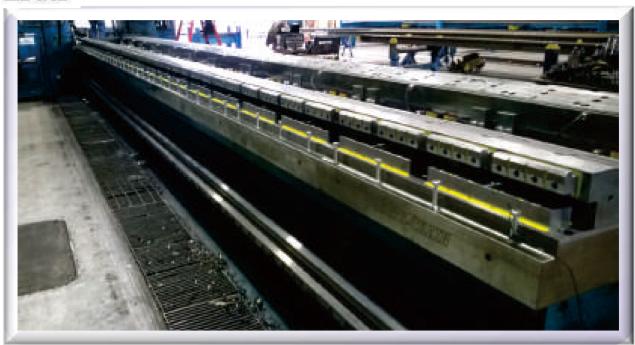


### 鐵軌加工應用實例 Railway Machining

# **EEPM-RW**



應用實例影片 Practical Case













### 臥式加工應用實例 Horizontal Machining

## EEPM-V



EEPM-V / EEPM-IT 系列 臥式側面加工應用



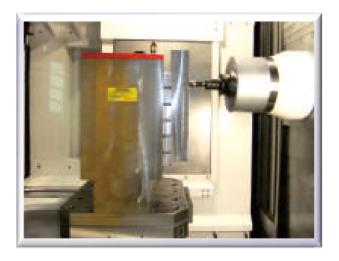
EEPM-V / EEPM-IT Series Horizontal Applications













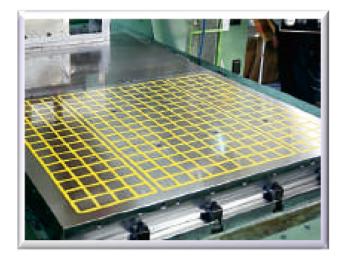


### 齒條加工應用實例 Rack Machining

### **EEPM**



應用實例影片 Practical Case















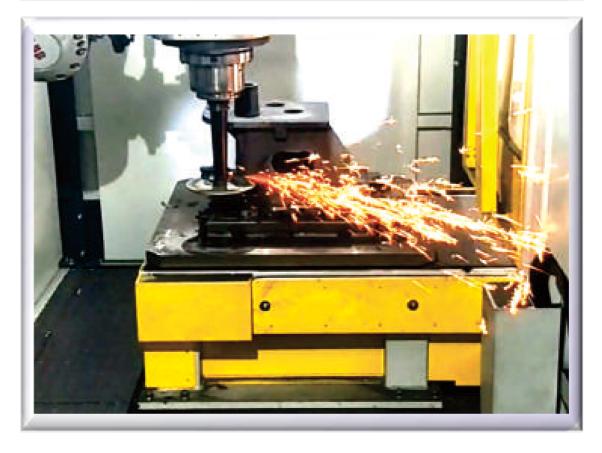
### 機械手臂加工鑄件應用實例 Machining Casting by Robotic Arm

## **EEPM**



應用實例影片 Practical Case







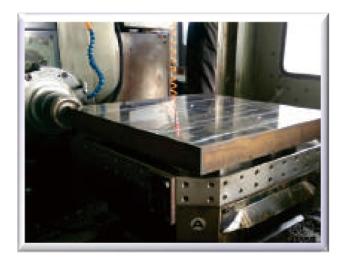
# 交換台加工 **EEPM**<u>Exchange Machining (Pallet Changer)</u>



應用實例影片 Practical Case

















### 壓鑄機應用實例 Stamping Machine

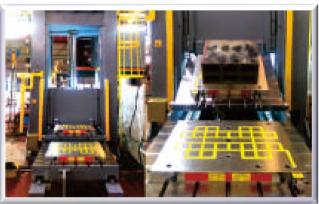


應用實例影片 Practical Case

















### 油壓裁切機應用實例 Die Cutting Machine

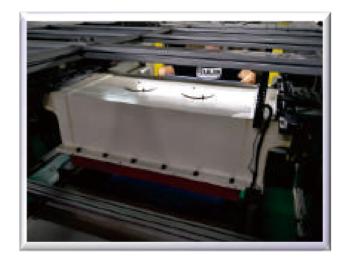
## **EEPM**

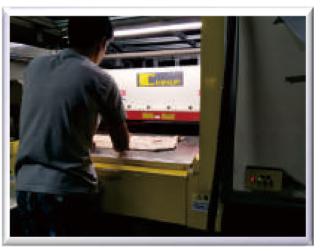


應用實例影片 Practical Case















#### 虎鉗加工應用實例 Clamp Vise for Machining

#### **EEPM**

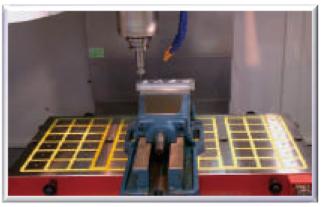


應用實例影片 Practical Case









#### 實例:

客戶在購買EEPM系列產品時,都會考慮將機台台面一邊放置磁盤一邊放置虎鉗,以便加工非導磁工件或小型工件時交替使用,其實客戶可將機台台面放滿磁盤,需用到虎鉗時,直接放置於磁盤上吸磁後就可進行加工。

#### 優點:

機台台面全面磁盤時,如需使用虎鉗時直接吸附於磁盤上,反而無需固定螺絲時間;且台面全面磁盤應用,讓工件不論大、小變化時,皆能自由夾持,達到加工空間全面使用。

#### **EXAMPLE:**

Deploy all machine table with EEPM chucks, put tradional vise on the chucks for nonmagnetic objects, Vise could be magnetised by EEPM chucks directly. Not need time to set up the vises by screws to reduce setting time. All machine table is paved with EEPM chucks for all dimension/shapes objects, use the chucks flexibly.



# 非導磁工件加工應用實例 Non-magnetic Workpiece Machining EEPM

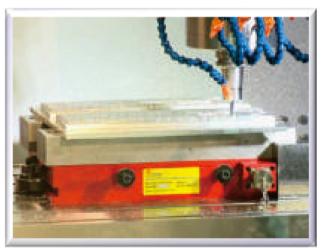


應用實例影片 Practical Case









#### 實例:

在非導磁工件下方鎖上鐵材,再置於EEPM系列磁盤上進行吸磁動作後,便可進 行加工動作。

#### 優點:

無虎鉗夾持時刀具行進干涉困擾,無壓板耗時夾持麻煩;使用EEPM系列磁盤便 可達到非導磁工件也能五面加工之功能,改善以往非導磁工件耗時費力傳統夾 持方式。

#### **EXAMPLE:**

Fix a iron plate in the bottom of non-magnetic workpiece. The iron plate could be magnetized by EEPM chucks to do non-magnetic workpiece machining. Easy to set up, easy to do 5 sides machining.



#### 模組化加工應用實例 Modular Machining

#### **EEPM**

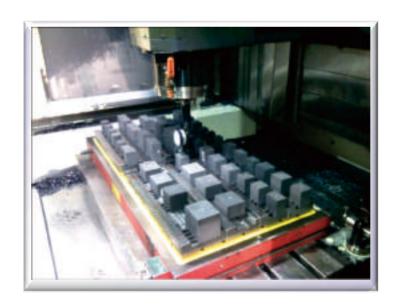


#### 實例:

- 1. 客戶先將非導磁工件固定在鐵材治具板上。
- 2. 再將鐵材治具板置於磁盤上, 吸磁後便可一次加工量產非導磁工件。

#### **EXAMPLE:**

- 1. Fix the non-magnetic workpiece on the iron material fixture.
- 2. Put the iron fixture onto the EEPM chuck. After magnetizing the chuck can do multi-piece of nonmagnetic workpiece machining at one time.



#### 優點:

當加工機在加工工件時,操作人員可同時固定下一組欲加工工件,待機台上工件加工完成,就可直接洩料再上料加工,達到人員全時應用,機台無待料全時加工。

#### Advantage:

The operator can do next batch material setting during machining period after machining the operator can feed second batch material, no time wasting during material changing. Machine works full time no waiting for material.







### 立式加工應用實例 <u>Vertical Machining</u>



EEPM-C / ECB 系列 龍門大型工件加工應用 (自由組合磁力夾具之數量、位置及間距)



EEPM-C / ECB Series
Double Column Application
(Free to set up position, numbers and distance)























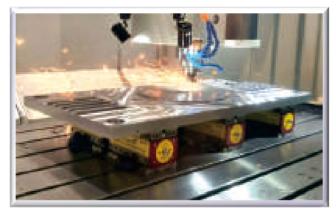
### 立式加工應用實例 Vertical Machining



應用實例影片 Practical Case





















### 立式加工應用實例 Vertical Machining





















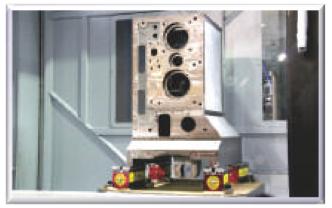
### 臥式加工應用實例 Horizontal Machining



應用實例影片 Practical Case





















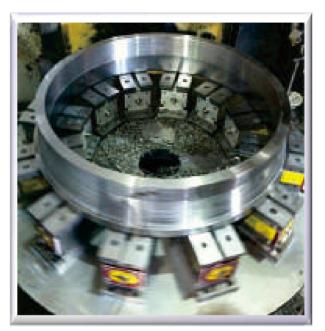


### 立式車床加工應用實例 Vertical Lathe Practical application

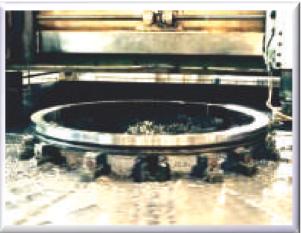


應用實例影片 Practical Case



























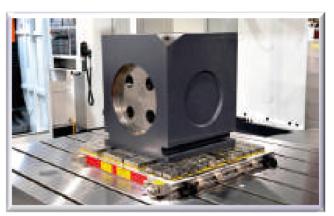


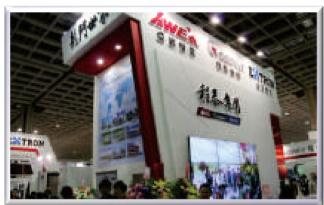
















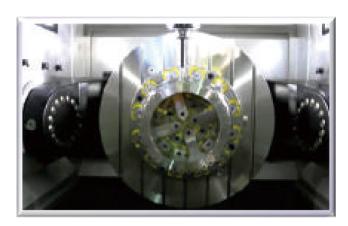










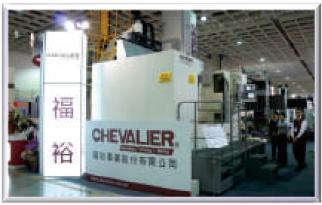












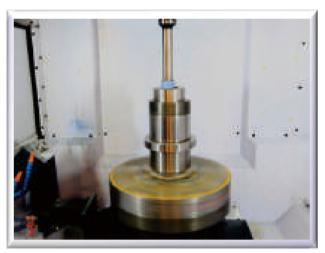


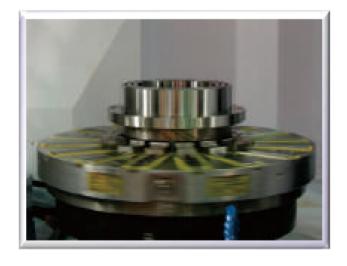


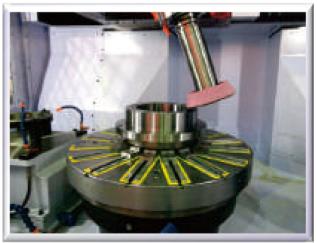
### 建瑋機械 CHIEN WEI



























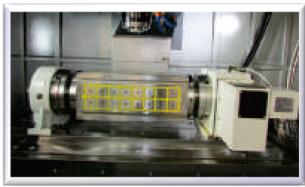
#### 德川機械 DETRON

MagVise 磁力夾具系統 Magnetic Workholding











#### 友嘉機械 FAIR FRIEND GROUP



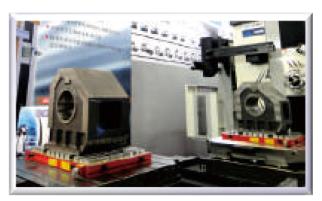


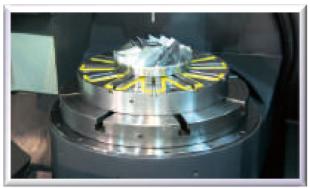


#### 遠東機械 FEMCO

#### MagVise 磁力夾具系統 Magnetic Workholding





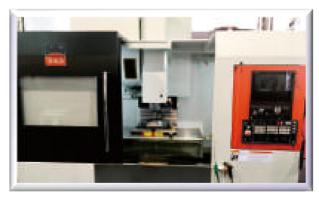






#### 龍昌機械 FIRST

MagVise 磁力夾具系統 Magnetic Workholding











#### 五星精機 FIVE STAR SEIKI

MagVise 磁力夾具系統 Magnetic Workholding







華銳機械 FOCUS SEIKI



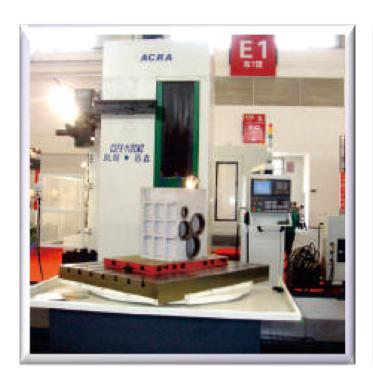








#### 凱傑機械 FREJOTH

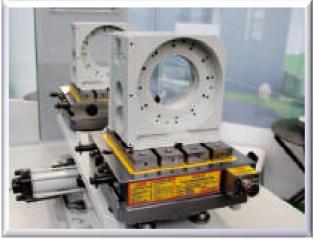






巨隆國際精機 <u>GANRO</u>







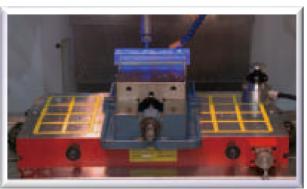
#### 巨庭機械 GEETECH

#### MagVise 磁力夾具系統 Magnetic Workholding











#### 新虎將機械 GENTIGER

MagVise 磁力夾具系統 Magnetic Workholding











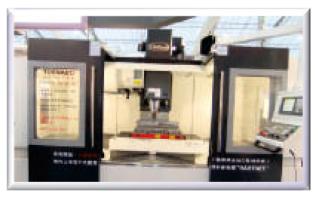






# **Hartford**

協鴻機械 HARTFORD











#### 台灣赫可機械 <u>HURCO</u>







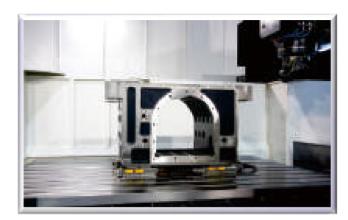






**k**ZFO

#### 高鋒機械 KAO FONG

































#### 邁鑫機械 MANFORD

MagVise 磁力夾具系統 Magnetic Workholding











#### 常準機械 MAXIMART

MagVise 磁力夾具系統 Magnetic Workholding











#### **MAZAK**







鉅業機械 MILLSTAR

MagVise 磁力夾具系統 Magnetic Workholding















#### 先捷機械 OSCAR

#### MagVise 磁力夾具系統 Magnetic Workholding





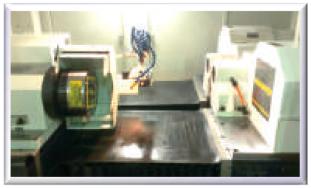




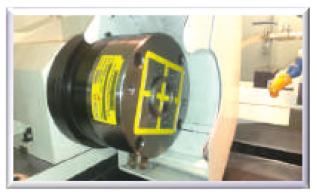
#### 大光長榮 PALMARY

MagVise 磁力夾具系統 Magnetic Workholding











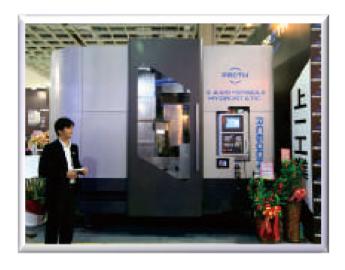
#### 寶嘉誠工業 PARKSON

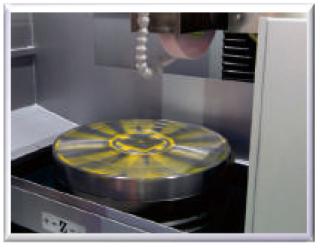






上一機械 PROTH



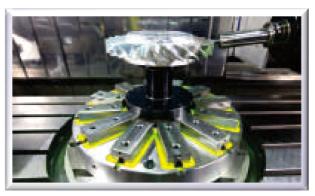




#### 百德機械 QUASER

#### MagVise 磁力夾具系統 Magnetic Workholding





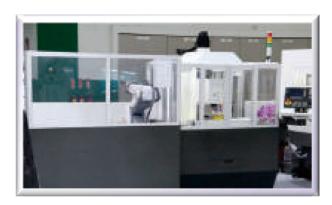






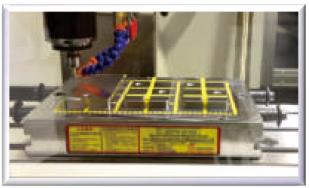
#### 榮富工業 RONG FU

MagVise 磁力夾具系統 Magnetic Workholding











#### 潭佳精密 ROTARY TABLE







#### 香福機械 ROUNDTOP





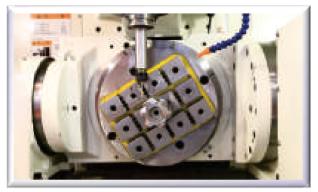




#### 台中精機機械 VICTOR TAICHUNG

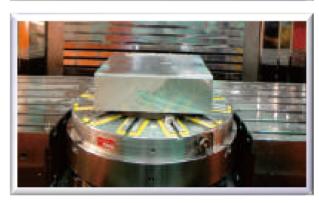














香巖進機械 VISION WIDE

MagVise 磁力夾具系統 Magnetic Workholding







#### 楊鐵機械 YANG IRON















眾程科技 ZHONGCHENG

MagVise 磁力夾具系統 Magnetic Workholding









Electro-Permanent Magnetic Chunk

永磁式磁力工作台 Permanent Magnetic Clamping Block







儀辰企業股份有限公司 EARTH-CHAIN ENTERPRISE CO., LTD.

台中市43546梧棲區港埠路一段551號 Tel: 886-4-26303737 Fax: 886-4-26303636 No. 551, Sec. 1, Gangbu Rd., Wu-Chi Dist., Taichung City, Taiwan Web-site:www.earth-chain.com E-mail:ece@earth-chain.com.tw