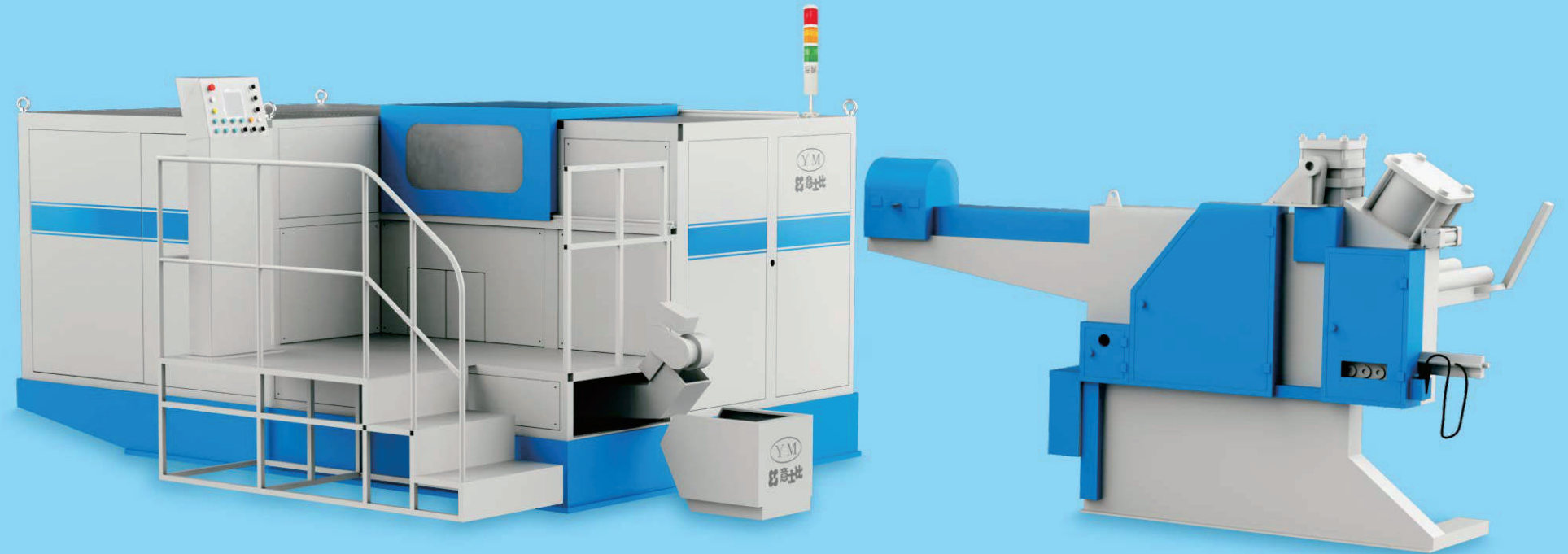




CE ISO 9001:2016

意铭意士比机械设备（苏州）有限公司
Yiming Yishibi Machinery Equipment (Suzhou) Co., Ltd.



Multi-Station Cold Heading Forming Machine Multi-Station Parts Forming Machine Multi-Station Riveting Machine Series

多工位冷镦成型机、多工位零件成型机、多工位铆钉机系列

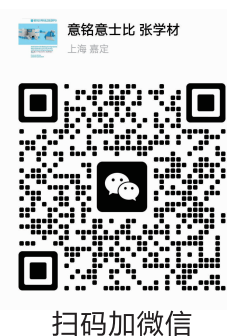
**Focus on solving
customer's problems!**

专注于解决客户问题！

CE ISO 9001:2016

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COMPANY PROFILE

公司简介

意铭意士比机械设备(苏州)有限公司,坐落于美丽富饶的太仓市,2004年在上海嘉定投产,2016年迁至苏州太仓,东与崇明岛隔江相望,南与上海宝山区、嘉定区接壤,是长三角经济体重点示范区,地理条件优越,交通四通八达,临近诸多高速。

公司创始人张学材先生原为意大利意士比机械(上海分公司)技术总监,在铆钉机、冷镦成型机行业深耕多年,对各种机型研发和设计有丰富的经验。继承了意大利意士比机械一系列优点,并在其基础上不断革新。

公司已通过 ISO9001: 2016 质量管理体系认证和 CE 安全认证,并已取得多项发明专利。公司拥有优秀的研发和制造团队,精益求精用心制造出每一台冷镦成型设备,与国内外多家知名企业均有合作。

公司配有先进品管控制,检测工艺等流程,专业生产各种型号铆钉机和【二模二冲】、【三模三冲】、【四模四冲】、【五模五冲】、【六模六冲】、【七模七冲】等多工位全自动高速螺栓冷镦机以及温镦机,(专注航空航天,军工产品,以钛合金,高镍合金为主)均符合国际标准,创新的技术人才,先进的产品加工设备,让每一台设备都有质量保证。精度高、稳定性强、生产速度快、结构合理、性价比高,广泛应用于汽配企业、军工企业、航空航天企业等领域。

公司秉承“以质量求生存,以服务求发展”,在品质稳定的前提下不断创新,完善售后服务,免去客户后顾之忧,公司愿携手海内外新老客户精诚合作,共创美好未来。

Yiming Yishibi Machinery Equipment (Suzhou) Co., Ltd.is located in the beautiful and rich Taicang City, in 2004 in Shanghai Jiading put into production, 2016 moved to Suzhou Taicang, east and Chongming Island across the river, south and Shanghai Baoshan District, Jiading District border, is the Yangtze River Delta economy key demonstration zone, geographical conditions are superior, transportation in all directions, close to many highways.

The founder of the company, Mr. Zhang Xuecai, was originally the technical director of Italian Yisby Machinery (Shanghai Branch). He has been deeply involved in the riveting machine and cold heading machine industry for many years, and has rich experience in the research and development and design of various models. Inherited a series of advantages of Italian Yisbi machinery, and continued to innovate on its basis.

The company has passed ISO9001:2016 quality management system certification and CE safety certification, and has obtained a number of invention patents. The company has an excellent R&D and manufacturing team, strives for perfection and manufactures every cold heading forming equipment, and cooperates with many well-known enterprises at home and abroad.

The company is equipped with advanced quality control, testing technology and other processes, specializing in the production of various types of riveting machines and [two-die two-punch], [three-die three-punch], [four-die four-punch], [five-die five-punch], [Six-die six-punch][seven-die seven-punch] and other multi-station automatic high-speed bolt cold heading machines and warm heading machines (focusing on aerospace, military products, mainly titanium alloys and high nickel alloys) are in line with international standards, innovative technical talents, advanced advanced product processing equipment, so that each piece of equipment has quality assurance. High precision, strong stability, fast production speed, reasonable structure, high cost performance, widely used in auto parts enterprises, military enterprises, aerospace enterprises and other fields.

Adhering to the principle of "survive by quality, develop by service", the company will continue to innovate under the premise of stable quality, improve after-sales service, and avoid customers' worries. The company is willing to cooperate sincerely with new and old customers at home and abroad to create a better future.



Multi-Station Cold Heading Forming Machine

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公司价值观

客户观——以客户需求为导向，培育新客户，打造忠实客户。

服务观——服务只有起点，满意没有终点。

发展观——适应市场、持续创新、科学发展、追求卓越。

团队观——乐观向上，永不放弃，自我激励，达成目标。

Company values

Customer concept - oriented by customer needs, cultivate new customers and create loyal customers.

Service concept - service only has a starting point, satisfaction has no end.

Development concept - adapting to the market, continuous innovation, scientific development, and pursuit of excellence.

Team concept - optimistic, never give up, self-motivation, achieve goals.

公司的客户群

贵州航空紧固件有限公司

贵州航锐航空精密零部件制造有限公司

贵州航太精密制造有限公司

航天精工（天津）制造有限公司

苏州新凯紧固系统有限公司

欧拜欧(昆山)汽车紧固件有限公司

山东高强紧固件有限公司

浙江云端汽车部件有限公司

卓越紧固系统（上海）有限公司

联钢精密科技(中国)有限公司

安字汽车紧固件(启东)有限公司

江苏宝特汽车部件有限公司

江苏一标金属科技有限公司

无锡市三星铆钉厂

巴拉乐五金制造(宁波)有限公司

四川新原机械制造有限公司

内德史罗夫紧固件（昆山）有限公司

辉门裕罗（青岛）火花塞有限公司

售前服务

- 1、根据客户产品、产量实际情况，推荐选择所需要合适的产品型号。
- 2、公司派技术人员到现场规划场地、进行技术商务交流、设计最佳方案。

售中服务

- 1、根据客户的意见与要求完善设计，在指定的工作日内完成生产制作。
- 2、产品预验收，根据客户提出的要求，完善设备细节。

售后服务

- 1、现场对操作人员进行实际操作培训。
- 2、派技术人员定期巡检设备，对设备质量跟踪服务。

pre-sale service

1. According to the actual situation of customer products and output, it is recommended to select the appropriate product model.
2. The company sends technical personnel to the site to plan the site, conduct technical and business exchanges, and design the best solution.

In-sale service

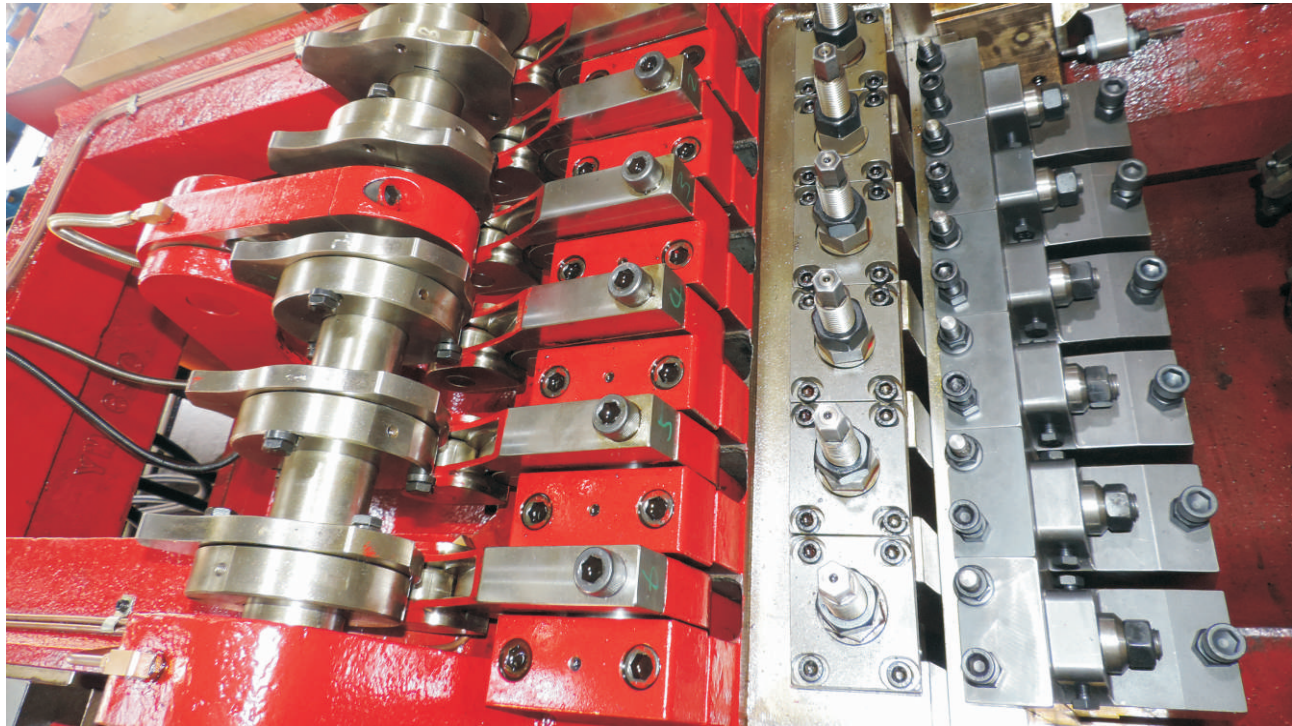
1. Improve the design according to the opinions and requirements of customers, and complete the production within the designated working days.
2. Pre-acceptance of products, perfect equipment details according to the requirements of customers.

After-sales service

1. On-site training for operators.
2. Send technicians to inspect the equipment regularly and track the quality of the equipment.

公司服务

COMPANY SERVICES

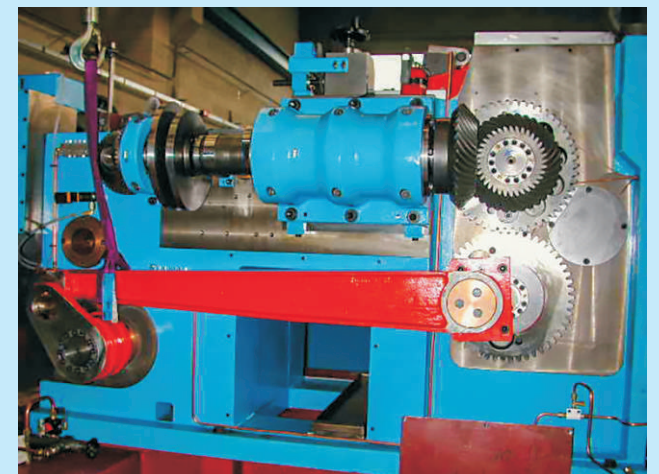
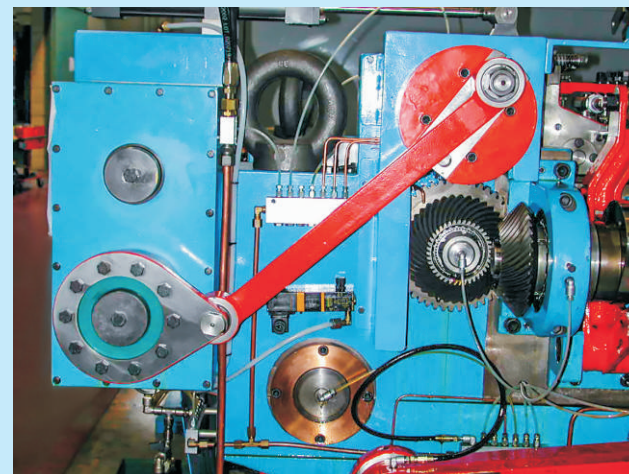


主要特点

- 1、采用意大利进口空压式离合器，法国进口多频变频器，可精准控制机器寸动、点动、连动。停止运转时主滑台自动停止在最后位置，最大化留出调试空间，使调机更方便。
- 2、气动式旋转夹钳机构设计，可任意调节夹钳夹料的力度，让机器高速、稳定生产。首工位夹钳附有短料监控装置，出现短料时夹钳自动张开，夹料停止并三色灯警示。
- 3、送线轮、压线轮均由电控气缸控制，随时调节送线轮、压线轮的压力，回程时自动分离，配有单向轴承、线性送料等，防止棘轮反转退料，送料均衡稳定。
- 4、侧轴凸轮式剪料设计，可使剪料速度快、剪刀力度大，采用圆周式剪刀剪出材料横断面平整光滑。
- 5、数字化后捅出机构可实现各个工位拍料长度独立调节，最后一工位可加装切边凸轮实现切边工能。主模下方可加装模前挡料装置，生产多台阶较短产品时更加稳定。
- 6、凸轮式阳模顶出控制设计，各个阳模顶出长度可独立调节，调节简便快捷，精度更高。
- 7、机身、主滑台、连接臂等关键部件采用高强度高韧性材质制成，并采用先进铸件锻造工艺，精密的检测制程控制，确保机器高速稳定生产。
- 8、轴承均使用日本NSK，瑞典SKF，德国INA等进口品牌。曲轴、凸轮使用高强度耐磨合金材质，并经过调质、氮化、热处理等工艺处理。保证机器的精度和使用年限。
- 9、电控系统配有法国进口多频变频器，生产过程中可实现无级变速，PLC数控检测系统自动监测机器实时工作状态，出现异常时通过三色灯提示。
- 10、机器操作系统由自主研发，配有德国西门子显示操控面板，操作简便快捷。

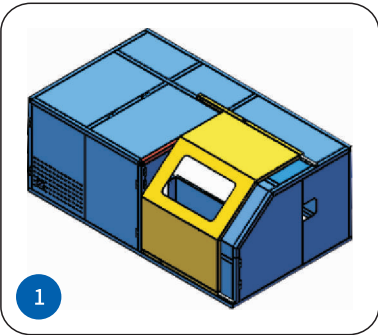
Salient Features

1. Adopt air-pressure clutch imported from Italy and multi-frequency inverter imported from France, which can precisely control inching, inching and linkage of the machine. When stopping operation, the main sliding platform automatically stops at the last position to maximize the debugging space and make the adjustment more convenient.
2. Pneumatic rotary clamping mechanism is designed, which can adjust the clamping force arbitrarily, so that the machine can produce stably and at high speed. The first position clamp is equipped with short material monitoring device. When short material occurs, the clamp opens automatically and the clamp stops and the trichrome light warns.
3. The feeding and pressing pulleys are all controlled by electronic cylinder. The pressure of feeding and pressing pulleys can be adjusted at any time. They are separated automatically when returning. They are equipped with one-way bearings, linear feeding, etc. To prevent ratchet from reversing and feeding equally and stably.
4. The side-shaft cam-type shearing design can make the shearing speed fast and the shearing force great. The material cross section is smooth and smooth when the circumferential scissors are used.
5. The digitized post-levering mechanism can realize independent adjustment of recording length at each station, and the trimming cam can be installed at the last station to realize the trimming work. The front material retaining device can be installed under the main die, which is more stable in the production of short multi-step products.
6. Cam type male mold ejection control design, the ejection length of each male mold can be adjusted independently, and the adjustment is simple and fast, with higher accuracy.
7. The body, main sliding table, connecting arm and other key components are made of high-strength and high-toughness materials, and advanced casting forging technology and precise inspection process control are adopted to ensure high-speed and stable production of the machine.
8. The bearings are imported from NSK of Japan, SKF of Sweden and INA of Germany. The crankshaft and cam are made of high-strength wear-resistant alloy, and are subject to process treatment such as quenching and tempering, nitriding and heat treatment. Ensure the accuracy and service life of the machine.
9. The electric control system is equipped with multi-frequency inverter imported from France. Stepless variable speed can be realized in the production process. The PLC CNC detection system automatically monitors the real-time working state of the machine and prompts it by trichrome lamp in case of abnormality.
10. The machine operating system is independently developed and equipped with Siemens display control panel, which is easy and fast to operate.



整机三维模拟图示例

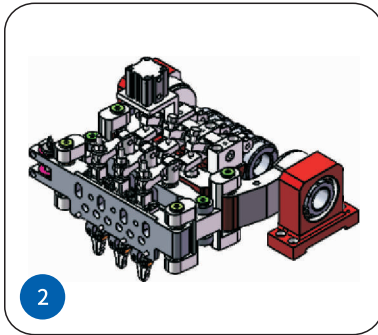
Whole machine 3D analogue image for demonstration



保护罩
Protective cover

设计合理、占地面积小、节省空间、机器调试方便。采用内置隔音棉的保护外罩，有效减小机器在生产过程产生的噪音。

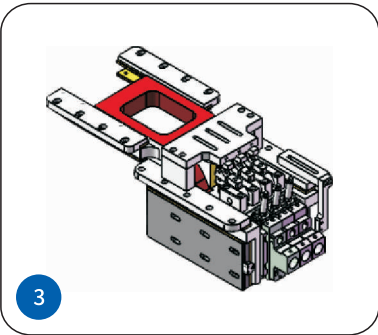
Reasonable design, small footprint, space saving and convenient machine debugging. The protective cover with built-in sound insulation cotton is adopted to effectively reduce the noise generated by the machine during the production process.



夹钳模组
Clamp module

采用自主研发夹钳结构，该夹钳机构通过凸轮控制夹爪张开闭合，工作时夹钳平移和翻转可同时进行，精度高，稳定强，调节方便。

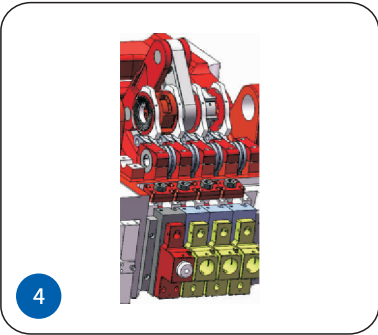
Adopt self-developed clamp structure. The clamp mechanism controls the opening and closing of the clamping jaws through cams. The translation and flipping of the clamps can be carried out at the same time during operation, with high precision, strong stability and convenient adjustment.



主滑块、阳模顶出模组
Main slide, male die ejection module

主滑块采用“工”型结构，可增加主滑块运行时水平及上下支撑行程，确保主滑块稳定运行进而保证产品的精度。曲轴与机台和滑块与机台均通过耐磨的合金铜瓦或铜板连接，承载力大，使用寿命长。曲轴与主滑块独立供油，保证设备运行时润滑充分。

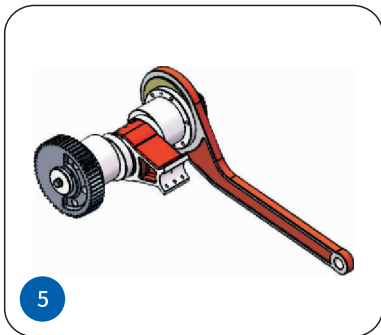
The main slider adopts the "I" type structure, which can increase the running level and upper and lower support stroke of the main slider, ensure the stable operation of the main slider and ensure the product accuracy. The crankshaft is connected with the machine tool and slider and the machine tool by wear-resistant alloy copper shingle or copper plate, which has large bearing capacity and long service life. The crankshaft is supplied with oil independently from the main slider to ensure adequate lubrication during operation of the equipment.



阳模顶出模组
Positive mould ejection module

阳模顶出凸轮与凸轮轴承紧密对接，无缝隙，无噪音，每一模顶出行程均可独立调节，顶出行程与滑块移动保持步调一致，设计有三段固定行程，也可灵活调节，精度高，稳定性强，调试简洁。

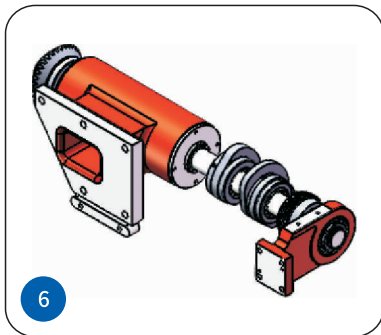
The male module ejection cam and the cam bearing are closely butted, seamless and noiseless. The ejection travel of each module can be independently adjusted. The ejection travel keeps pace with the movement of slider. There are three fixed strokes in design, which can also be adjusted flexibly with high precision, strong stability and simple debugging.



曲轴模组
Crankshaft module

采用二级齿轮传动系统，传动扭矩大，传动效率更高，配备气动离合器和制动器，减少电机功耗，保证生产安全。

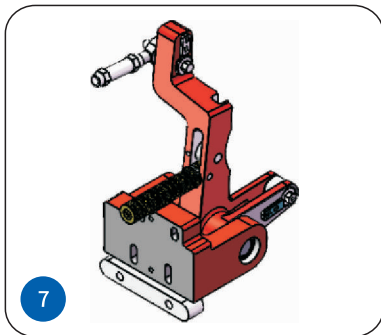
Secondary gear drive system is used with high transmission torque and high transmission efficiency. Pneumatic clutch and brake are equipped to reduce power consumption of motor and ensure production safety.



侧轴模组
Side Shaft Module

先进的侧轴设计可同时给夹子机构和剪料机构提供动力，小型设备均采用凸轮剪料，比传统S板剪料速度快、剪力大、剪切更平整等优势。

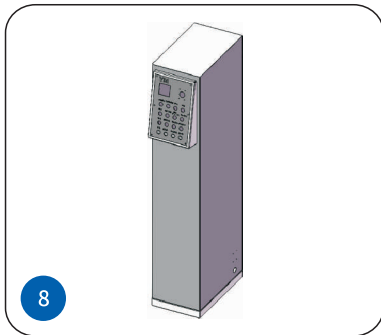
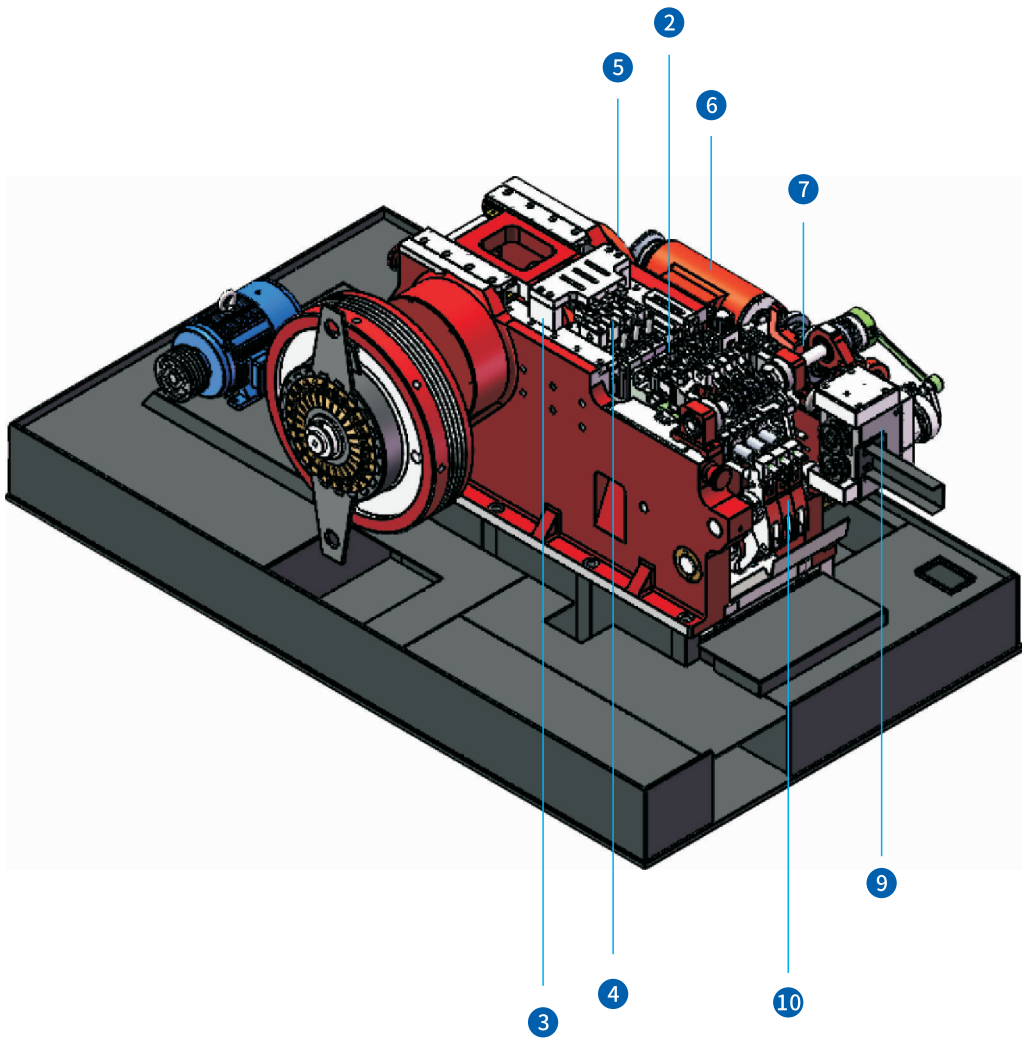
Advanced side-shaft design provides power for both clip mechanism and cutting mechanism. Cam shearing is used for small-scale equipment, which has advantages over traditional S-plate such as fast shearing speed, large shearing force and smoother shearing.



凸轮移送夹子模组
Cam transfer clip module

通过共轭凸轮控制夹钳往复运动，侧轴弹簧使凸轮与摆臂轴承紧密接触，控制夹子往复行程平稳，夹料更稳定。凸轮材料选用20CrMoTi，并采用渗碳工艺处理，经久耐用。

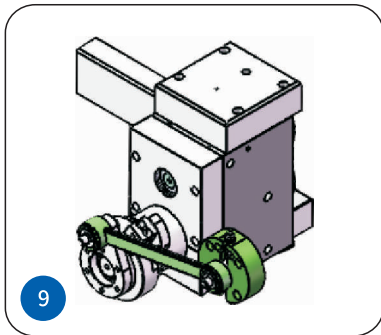
Through the conjugate cam control clamp reciprocating movement, the side shaft spring makes the cam close contact with the swing arm bearing, so as to control the clamp reciprocating travel smoothly and clamp material more stable. Cam material is 20CrMoTi and carburized for durability.



电控机构
Electronic control mechanism

电器元件、变频器均采用德国西门子和法国施耐德国际品牌，电控系统采用意士比自主开发的操作系统，反应灵敏、操作简单便捷。

Electrical components and frequency converters are under the brand of Siemens Germany and Schneider France. Electronic control system uses the operating system independently developed by Espresso, which is sensitive, simple and convenient to operate.



送线模组
Line feeding module

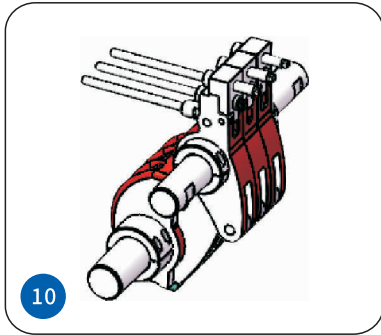
通过传动凸轮带动摆臂运动，达到送料目的，传动凸轮通过伺服动力系统控制，具有送料动作快，送料精度高，结构稳定性高等优点。

The drive cam drives the swing arm to achieve the purpose of feeding. The drive cam is controlled by servo power system, which has the advantages of fast feeding action, high feeding accuracy and high structural stability.

母模顶出
Master die ejection

各工位拍料行程均可独立调节，最后工位附有调节凸轮，控制切边动作，配有压力检测装置，灵活调节切边压力和平整度。

The recording stroke of each station can be independently adjusted. At last, the station is equipped with adjusting cam to control trimming action and pressure detection device to adjust trimming pressure and smoothness flexibly.

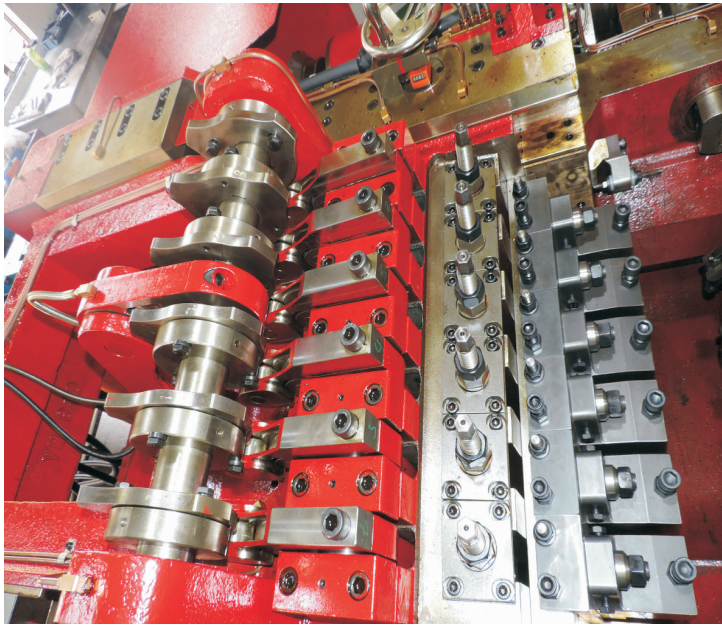
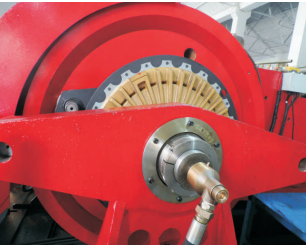


整机设备局部分解图

Local decomposition diagram of complete equipment

主滑块连接后翼燕尾式设计，主滑块运行中冲模与主模始终保持同心，确保生产精度高、运行稳定。主滑块与两翼上、下、侧三面均采用超耐磨镶嵌自润式铜板。保证机器高精度，延长使用寿命，且各冲模均可实现反打功能。

The main slider is connected with the rear wing dovetail design. During the operation of the main slider, the punching die and the main die are always concentric to ensure high production accuracy and stable operation. The main slider and the upper, lower and side surfaces of the two wings are made of super wear-resistant inlaid self-lubricating copper plates. Ensure the high precision of the machine, prolong the service life, and all the punching dies can realize the reverse striking function.

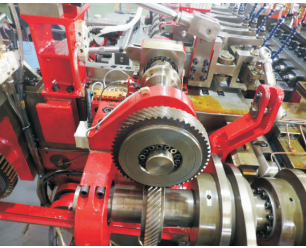


进口空压式离合器传动机构，精准控制飞轮轴与飞轮瞬间分离或闭合。使机器正常运转时不会紧急制动，对马达和电控造成损坏。

The imported air pressure clutch transmission mechanism accurately controls the instantaneous separation or closure of the flywheel shaft and the flywheel. So that the machine will not be subject to emergency braking during normal operation, causing damage to the motor and electric control.

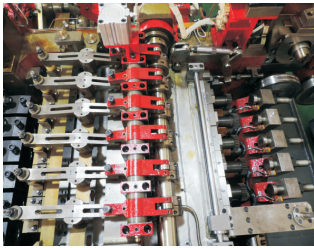
分体独立调节式阳模顶出设计，顶出长度由凸轮控制，可实现高精度微调。

Split independent adjustment male mold ejection design, ejection length is controlled by cam, which can realize high-precision fine adjustment.



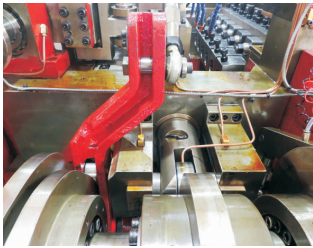
侧轴凸轮式夹钳机构，夹钳反应速度快，稳定性强。

Side shaft cam clamp mechanism, the clamp response speed is fast and the stability is strong.



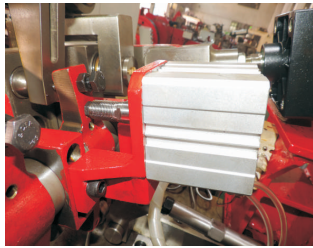
摆臂式气动夹钳，夹力可调、可旋转，出现短料时，首组夹钳自动张开不夹料。

Swing arm type pneumatic clamp, the clamping force is adjustable and can be rotated. When there is a short material, the first group of clamps will automatically open and not clamp the material.



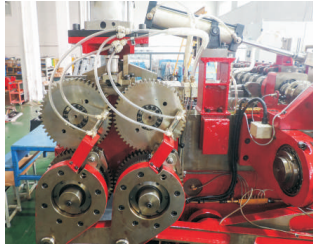
侧轴凸轮式剪刀机构，剪料速度快，剪断面平整。

Side shaft cam scissor mechanism, fast cutting speed and smooth cutting surface.



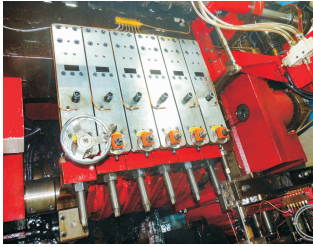
首组夹钳控制气缸。

The first set of clamps controls the cylinders.



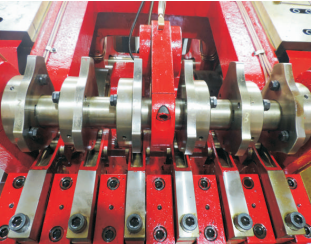
棘轮送线机构，内部设有多个单向轴承，并和棘爪配合，防止退料，确保送线稳定。

The ratchet wire feeding mechanism has multiple one-way bearings inside, and cooperates with the pawl to prevent the material from returning and ensure the stable wire feeding.



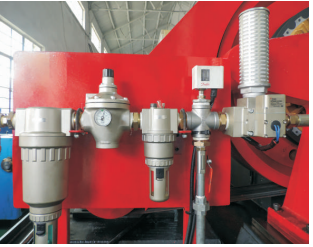
手摇式数字化后捅出调节机构，每一工位可实现独立调节。

After the hand-crank digitization, the adjustment mechanism is poked out, and each station can be independently adjusted.



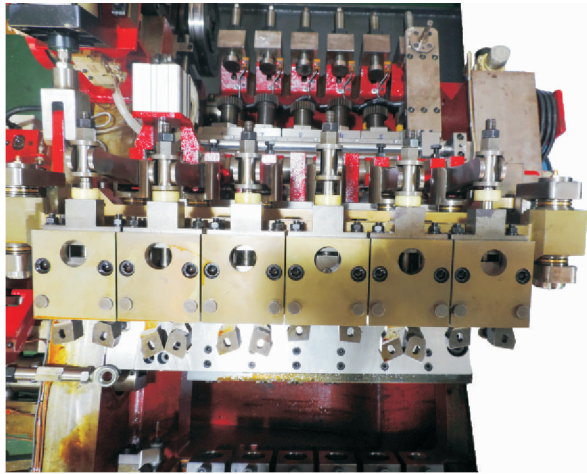
凸轮式阳模顶出机构，每一冲模顶出长度均可独立调节。

Cam-type male die ejection mechanism, the ejection length of each die can be adjusted independently.



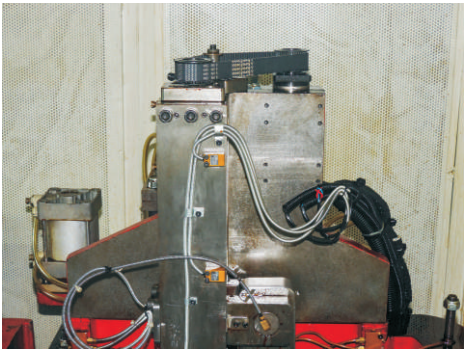
日本进口集中式空压调节系统，经久耐用。

The centralized air pressure regulation system imported from Japan is durable.



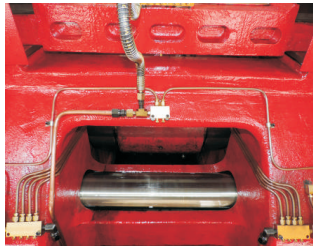
高精度复合式气动夹钳机构，夹料又快又稳，并可实现反转夹料。

High precision compound pneumatic clamp mechanism, fast and stable clamping, and can realize reverse clamping.



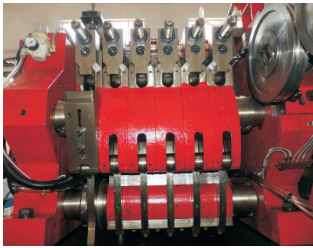
水平线性送料系统，可精准控制每次送料长度，增加夹具与线材之间的受力面积，防止线材被夹伤。

The horizontal linear feeding system can precisely control the length of each feeding, increase the force area between the clamp and the wire, and prevent the wire from being pinched.



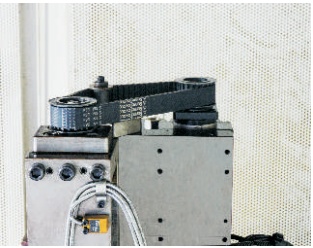
二级动力传动机构，缴锻力更大，动力输出更稳定。

The secondary power transmission mechanism, the upsetting force is larger, and the power output is more stable.



后捅出调节机构，各工位均可独立调节，最后一工位可更换或修改凸轮实现切边功能。

After the adjustment mechanism is poked out, each station can be adjusted independently, and the cam can be replaced or modified in the last station to realize the trimming function.



线性送料伺服马达，可确保每次送料精确。

The linear feeding motor ensures accurate feeding every time.



自主研发操作软件，配有德国进口触摸式操作面板，操控更简便。

Independent research and development of operating software, equipped with German imported touch operation panel, easier to control.

K/KD系列

K/Kd series

二模二冲、三模三冲工位高速螺栓冷镦成型机、铆钉机

2-mode 2-punch, 3-mode 3-punch station high-speed bolt cold heading forming machine, riveting machine



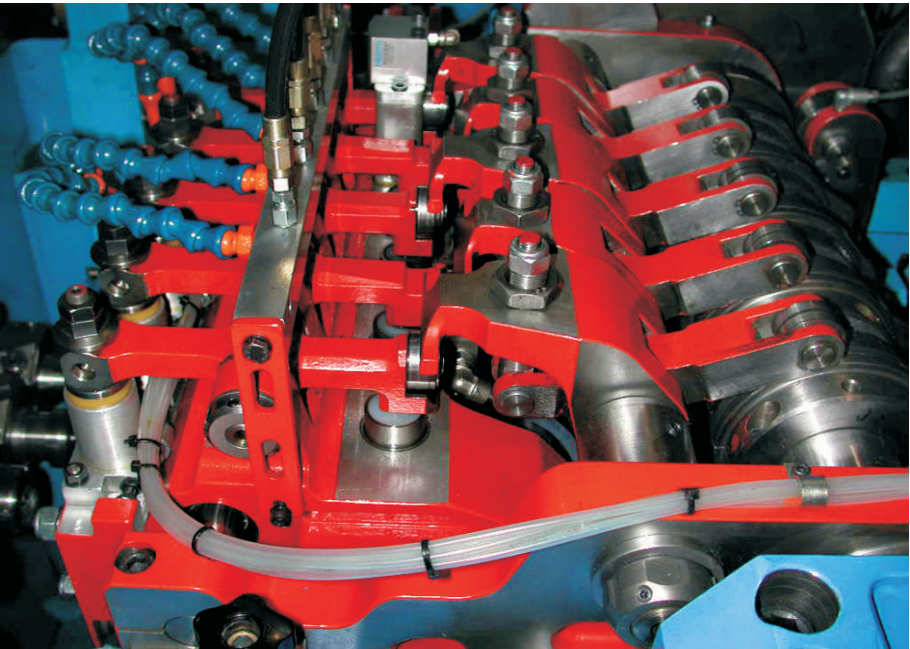
备注:

- 1、产品的生产速度取决于产品的形状、尺寸和材料。
- 2、表中所列最大材料切断直径和可制产品尺寸按中碳合金钢计算。

REMARKS:

- 1、Output rate is subject to the shape, size and material of tho product.
- 2、The Max.cut-off die and the product size shown below are calculated on the base of modium carbon alloy steel.

主要技术参数 Main technical parameters



型号 Model	单位 Unit	KD-203	KD-205	KD-206	K-304	KD-304	KD-306	KD-308	KD-310
工位数 Forging station	No.	2	2	2	3	3	3	3	3
锻造力 Forging force	Kgf	12000	22000	28000	22000	24000	28000	45000	90000
最大剪断直径 Max.cut-off dia	mm	Ø3	Ø6	Ø8	Ø5	Ø5	Ø8	Ø10	Ø12
最大剪断长度 Max.cut-off length	mm	35	70	80	45	85	90	100	140
生产速度 Production speed	pcs/ min	280	260	260	220	260	260	220	210
母模顶出行程 Master die ejection stroke	mm	40	65	80	40	70	85	90	130
冲模顶出行程 Punch die ejection stroke	mm	10	15	15	20	20	25	30	40
主滑台行程 Main sliding table stroke	mm	80	110	120	100	110	120	130	160
母模外形尺寸 Overall dims. Of mian die	mm	Ø35*35	Ø35*60	Ø50*90	Ø35*60	Ø46*60	Ø50*90	Ø50*100	Ø60*130
冲模外形尺寸 Overall dims. Of punch die	mm	Ø22*40	Ø31*80	Ø38*85	Ø31*70	Ø31*70	Ø38*80	Ø40*100	Ø45*125
剪模外形尺寸 Overall dims. Of cut of die	mm	Ø18*22	Ø18*25	Ø28*35	Ø18*25	Ø18*39	Ø28*45	Ø28*40	Ø40*60
模具间距 Die pitch	mm	50	55	55	55	55	55	60	80
可制螺丝直径 Applicable bolt dia	mm	1-3	2-5	3-6	2-4	2-4	2-5	3-8	4-10
可制螺丝头下长度 Shank lenght of blank	mm	10-28	10-65	10-80	10-40	10-65	10-65	10-85	10-115
最大法兰直径 Max flange dia	mm	Ø8	Ø10.5	Ø17	Ø9.5	Ø9.5	Ø17	Ø17	Ø19
主机马达 Main engine motor	KW	3.75	5.5	18.5	5.5	5.5	18.5	22	30
机器重量 Machine weight	Kgs	2200	3600	7200	3000	3200	6500	14500	18000
机器外形尺寸 Machine dimension	mm	1500*1200*1000	2600*1200*1150	2750*1200*1150	2600*1500*1400	2600*1500*1400	2750*1500*1500	3500*1850*2000	3630*2150*2280

本公司保留修改以上参数的权利，如有更改恕不另行通知。

The company reserves the right to modify the above parameters without prior notice.



KD/K系列

Kd/k series

四模四冲工位高速螺栓冷镦成型机、铆钉机

4-mode 4-punch station high-speed bolt cold heading forming machine, riveting machine

备注:

1、产品的生产速度取决于产品的形状、尺寸和材料。

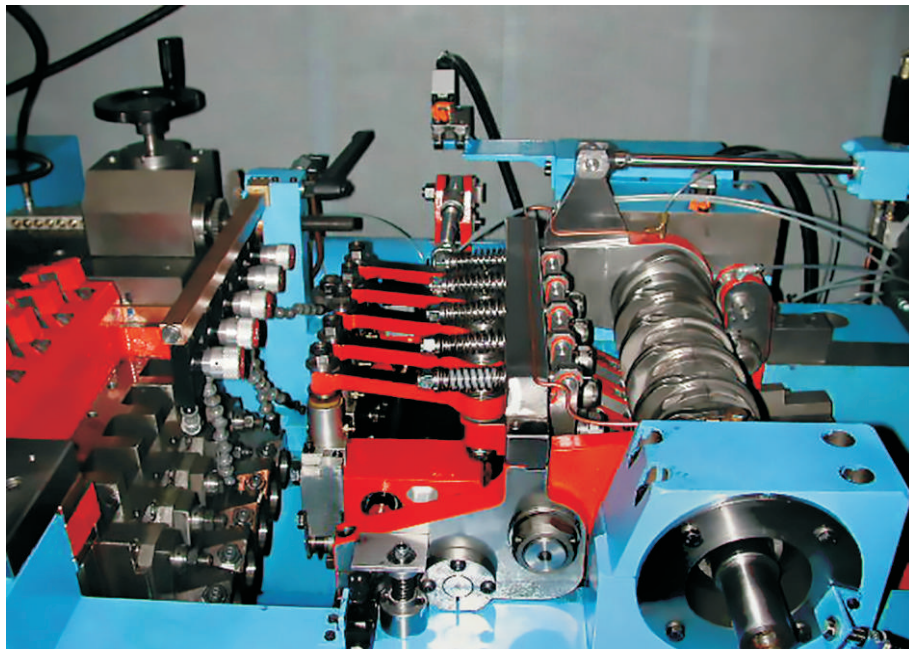
2、表中所列最大材料切断直径和可制产品尺寸按中碳合金钢计算。

REMARKS:

1、Output rate is subject to the shape, size and material of tho product.

2、The Max.cut-off die and the product size shown below are calculated on the base of modium carbon alloy steel.

主要技术参数 Main technical parameters



型号 Model	单位 Unit	KD-404	KD-405	KD-406	KD-408	KD-410	KD-413	KD-416	KD-420	KD-425
工位数 Forging station	No.	4	4	4	4	4	4	4	4	4
锻造力 Forging force	Kgf	24000	35000	55000	80000	125000	160000	245000	420000	570000
最大剪断直径 Max.cut-off dia	mm	Ø5	Ø7	Ø8	Ø10	Ø12	Ø16	Ø18	Ø23	Ø30
最大剪断长度 Max.cut-off length	mm	45	90	100	140	165	220	195	240	275
生产速度 Production speed	pcs/ min	280	260	220	220	180	120	100	95	80
母模顶出行程 Master die ejection stroke	mm	40	70	90	130	145	200	178	240	350
冲模顶出行程 Punch die ejection stroke	mm	20	20	30	40	40	60	40	46	46
主滑台行程 Main sliding table stroke	mm	100	120	130	160	195	270	260	346	346
母模外形尺寸 Overall dims. Of mian die	mm	Ø46*60	Ø50*90	Ø50*100	Ø60*130	Ø75*130	Ø86*190	Ø100*200	Ø125*240	Ø150*250
冲模外形尺寸 Overall dims. Of punch die	mm	Ø31*70	Ø38*85	Ø40*100	Ø45*115	Ø53*125	Ø60*130	Ø75*185	Ø90*215	Ø120*270
剪模外形尺寸 Overall dims. Of cut of die	mm	Ø18*39	Ø28*35	Ø28*40	Ø40*60	Ø45*60	Ø55*75	Ø60*90	Ø75*120	Ø80*130
模具间距 Die pitch	mm	50	55	60	80	94	110	120	140	160
可制螺丝直径 Applicable bolt dia	mm	2-4	2-5	3-6	4-8	6-10	8-16	10-18	12-24	14-27
可制螺丝头下长度 Shank lenght of blank	mm	10-40	10-65	10-85	10-115	10-115	20-180	20-165	20-200	20-240
最大法兰直径 Max flange dia	mm	Ø9.5	Ø16	Ø17	Ø19	Ø23	Ø28	Ø30	Ø36	Ø38
主机马达 Main engine motor	KW	5.5	18.5	22	30	37	55	75	90	132
机器重量 Machine weight	Kgs	3800	7100	8800	16500	24500	35600	54000	78000	118000
机器外形尺寸 Machine dimension	mm	2600*1800*1400	3500*2000*1800	3370*2030*1950	4260*2635*2135	4400*2500*2300	5200*2950*3050	5700*3200*3250	6300*3580*3380	7200*4300*3550

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KD/K系列

Kd/k series

五模五冲工位高速螺栓冷镦成型机、铆钉机

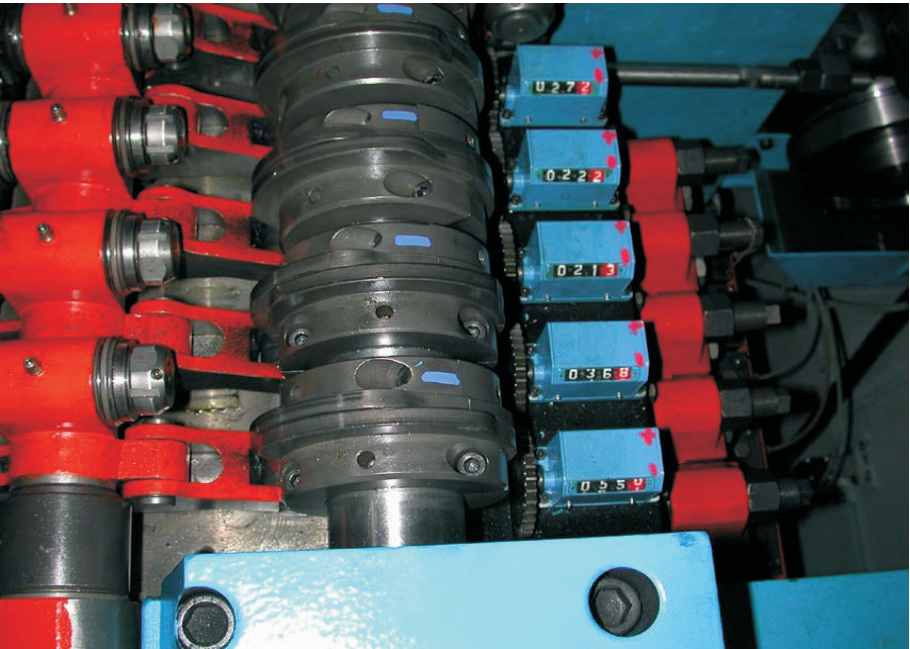
5-mode 5-punch station high-speed bolt cold heading forming machine, riveting machine

备注:

- 1、产品的生产速度取决于产品的形状、尺寸和材料。
- 2、表中所列最大材料切断直径和可制产品尺寸按中碳合金钢计算。

REMARKS:

- 1、Output rate is subject to the shape, size and material of tho product.
- 2、The Max.cut-off die and the product size shown below are calculated on the base of modium carbon alloy steel.



主要技术参数 Main technical parameters

型号 Model	单位 Unit	K-505	K-506	KD-506	KD-508	KD-510	KD-513	KD-516	KD-520	KD525
工位数 Forging station	No.	5	5	5	5	5	5	5	5	5
锻造力 Forging force	Kgf	46000	55000	55000	80500	125000	172000	295000	435000	650000
最大剪断直径 Max.cut-off dia	mm	Ø6	Ø8	Ø8	Ø10	Ø12	Ø16	Ø23	Ø26	Ø32
最大剪断长度 Max.cut-off length	mm	80	95	100	140	165	220	240	260	280
生产速度 Production speed	pcs/ min	240	200	220	200	200	120	95	80	65
母模顶出行程 Master die ejection stroke	mm	70	70	90	130	145	200	220	240	255
冲模顶出行程 Punch die ejection stroke	mm	30	30	30	40	40	60	60	65	70
主滑台行程 Main sliding table stroke	mm	120	120	130	160	195	270	285	355	370
母模外形尺寸 Overall dims. Of mian die	mm	Ø50*90	Ø50*100	Ø50*100	Ø60*130	Ø75*130	Ø86*190	Ø108*200	Ø125*240	Ø140*250
冲模外形尺寸 Overall dims. Of punch die	mm	Ø38*85	Ø38*85	Ø40*100	Ø45*115	Ø53*125	Ø70*130	Ø75*185	Ø90*215	Ø120*270
剪模外形尺寸 Overall dims. Of cut of die	mm	Ø28*35	Ø28*35	Ø28*45	Ø40*60	Ø45*60	Ø70*69	Ø75*100	Ø75*120	Ø80*130
模具间距 Die pitch	mm	55	55	60	80	94	110	129	140	160
可制螺丝直径 Applicable bolt dia	mm	2-5	3-6	3-6	4-8	6-10	8-16	10-22	12-30	14-32
可制螺丝头下长度 Shank lenght of blank	mm	10-65	10-85	10-85	10-115	10-115	20-180	20-200	20-220	20-221
最大法兰直径 Max flange dia	mm	Ø16	Ø17	Ø17	Ø19	Ø25	Ø26	Ø30	Ø36	Ø38
主机马达 Main engine motor	KW	18.5	22	22	30	37	55	75	90	115
机器重量 Machine weight	Kgs	7700	9900	9900	19500	25300	46000	66500	97200	164000
机器外形尺寸 Machine dimension	mm	3300*2100*1650	3450*2030*1750	3450*2030*1750	3630*2350*2090	4100*2500*2200	5100*4100*2750	13200*5300*2950	13650*5500*3100	14750*6500*3300

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KD系列

Kd series

六模六冲工位高速零件成型机

6-mode 6-punch station high speed parts forming machine



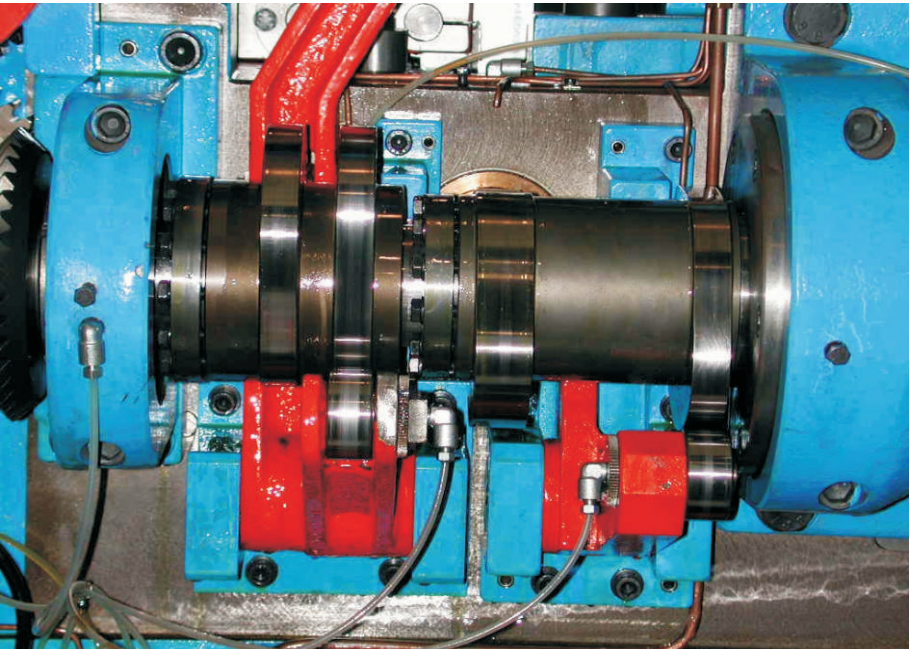
备注:

- 1、产品的生产速度取决于产品的形状、尺寸和材料。
- 2、表中所列最大材料切断直径和可制产品尺寸按中碳合金钢计算。

REMARKS:

- 1、Output rate is subject to the shape, size and material of tho product.
- 2、The Max.cut-off die and the product size shown below are calculated on the base of modium carbon alloy steel.

主要技术参数 Main technical parameters



型号 Model	单位 Unit	KD-606	KD-608	KD-610	KD-613	KD-616	KD-620	KD-625
工位数 Forging station	No.	6	6	6	6	6	6	6
锻造力 Forging force	Kgf	63800	105000	138000	185000	320000	470000	720000
最大剪断直径 Max.cut-off dia	mm	Ø8	Ø12	Ø16	Ø18	Ø26	Ø32	Ø38
最大剪断长度 Max.cut-off length	mm	100	140	145	220	240	260	320
生产速度 Production speed	pcs/ min	200	160	150	100	95	80	60
母模顶出行程 Master die ejection stroke	mm	90	130	145	200	220	255	300
冲模顶出行程 Punch die ejection stroke	mm	30	40	50	60	60	70	70
主滑台行程 Main sliding table stroke	mm	130	160	195	270	275	350	450
母模外形尺寸 Overall dims. Of mian die	mm	Ø60*100	Ø60*130	Ø75*130	Ø94*190	Ø108*220 (300)	Ø125*240 (450)	Ø148*250
冲模外形尺寸 Overall dims. Of punch die	mm	Ø45*100	Ø45*115	Ø53*125	Ø70*130	Ø75*185	Ø90*215	Ø120*270
剪模外形尺寸 Overall dims. Of cut of die	mm	Ø28*45	Ø40*60	Ø45*75	Ø75*80	Ø84*120	Ø85*120	Ø109*150
模具间距 Die pitch	mm	65	80	94	110	129	140	160
可制螺丝直径 Applicable bolt dia	mm	3-6	4-8	6-10	8-16	10-18	12-24	16-32
可制螺丝头下长度 Shank lenght of blank	mm	10-85	20-115	20-120	20-180	20-200	25-240	25-290
最大法兰直径 Max flange dia	mm	Ø17	Ø19	Ø27	Ø32	Ø42	Ø48	Ø56
主机马达 Main engine motor	KW	22	30	37	55	90	115	132
机器重量 Machine weight	Kgs	9800	24000	28500	47500	68000	125000	180000
机器外形尺寸 Machine dimension	mm	3500*2200*2200	4200*2750*2500	4530*3300*2275	6000*4100*3000	13600*6300*3150	15200*5750*3350	16500*6800*3540

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KD系列

Kd series

七模七冲工位高速零件成型机

7-mode 7-punch station high speed parts forming machine

备注:

- 1、产品的生产速度取决于产品的形状、尺寸和材料。
- 2、表中所列最大材料切断直径和可制产品尺寸按中碳合金钢计算。

REMARKS:

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主要技术参数 Main technical parameters

型号 Model	单位 Unit	KD-706	KD-708	KD-710	KD-715	KD-718	KD-722	KD-726
工位数 Forging station	No.	7	7	7	7	7	7	7
锻造力 Forging force	Kgf	70000	125000	146000	218000	320000	500000	780000
最大剪断直径 Max.cut-off dia	mm	Ø8	Ø12	Ø18	Ø20	Ø30	Ø35	Ø42
最大剪断长度 Max.cut-off length	mm	100	140	135	220	230	240	295
生产速度 Production speed	pcs/ min	200	160	120	100	100	60	60
母模顶出行程 Master die ejection stroke	mm	90	130	100	200	210	220	270
冲模顶出行程 Punch die ejection stroke	mm	30	40	50	60	60	60	70
主滑台行程 Main sliding table stroke	mm	130	160	190	270	275	346	365
母模外形尺寸 Overall dims. Of mian die	mm	Ø50*100	Ø60*130	Ø85*150	Ø100*190	Ø110*220(300)	Ø150*250(450)	Ø165*250
冲模外形尺寸 Overall dims. Of punch die	mm	Ø40*100	Ø45*115	Ø53*125	Ø75*130	Ø75*180	Ø100*245	Ø120*270
剪模外形尺寸 Overall dims. Of cut of die	mm	Ø28*45	Ø40*60	Ø65*75	Ø80*120	Ø84*120	Ø128*120	Ø139*150
模具间距 Die pitch	mm	60	80	94	110	129	165	190
可制螺丝直径 Applicable bolt dia	mm	3-6	4-8	6-10	8-20	10-24	16-30	18-32
可制螺丝头下长度 Shank lenght of blank	mm	10-85	20-115	10-90	20-180	20-190	20-200	25-240
最大法兰直径 Max flange dia	mm	Ø17	Ø19	Ø28	Ø34	Ø42	Ø48	Ø56
主机马达 Main engine motor	KW	22	30	37	55	90	110	132
机器重量 Machine weight	Kgs	14000	27000	32000	65000	78000	151000	187000
机器外形尺寸 Machine dimension	mm	3500*2200*2200	4400*2750*2500	5300*3000*2750	6000*4100*3000	14500*6500*3150	15800*6650*3250	17500*7800*3650

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应用领域

Application territory

多工位自动冷镦机是锻压机械中的一种高效率、自动化的专业机床。冷镦工艺和自动冷镦机是标准件行业用来生产各种螺栓、螺钉、铆钉、螺母的重要手段。由于冷镦设备本身的先进性和冷镦工艺的优越性，也使得它能广泛应用于国民经济各个领域，如：航空、轮船、机械、轨道交通、汽车、摩托车、自行车、缝纫机、建筑、家具及轻工、日用品等行业的紧固件及异形非标件的加工生产。

Auto Multi-station Cold Upsetting Former is a specialized machine tool with high efficiency and automation among forging machinery. Cold upsetting technique and auto cold upsetting formers are used as an important means for producing different kinds of bolts, screws, rivets and nuts in the field of fastener industry. Because of the advantage of the cold upsetting equipment itself and the superiority of cold upsetting technique, the formers also are widely used in different national economic territories for producing fasteners and abnormal non-standard parts such as aviation, steamer, machinery, rail traffic, vehicle, motorcycle, bicycle, sewing machine, construction, furniture, light industry and daily necessities, etc.

