

河北·科睿尼尔 **服务** 世界



科睿尼尔



科睿尼尔机械装备有限公司
Keruneil Machinery Equipment Co., Ltd



智能高速冷墩成形机
INTELLIGENT HIGH SPEED COLD HEADING FORMING MACHINE

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企业简介 ENTERPRISE BRIEF INTRODUCTION

河北科睿尼尔机械装备有限公司是河北鼎润制造智能装备旗下的子公司，公司坐落在风景秀丽的历史文化，古代冶铸之乡——邯郸武安市。本公司成立于2020年，经过几年的不懈努力，弄精蓄锐，蓄势待发！本公司占地320余亩，总投资5.4亿元，厂房建筑面积10万平米，科研及行政办公楼10000平米，是一家集研发、生产、销售及售后为一体的科技型机械设备制造企业。现拥有工程技术人员数十名。长期以来企业在生产技术方面积累了丰富的实践经验，工艺先进，产品系列齐全，生产设备完善，企业产品质量稳定，严格做到整机出厂合格率100%，深受国内广大用户一致好评。目前本公司现有员工200多人，分别于造机、品保、研发、业务，以及管理等五大部门，各部门之间彼此分工合作。本着精益求精的企业原则及客户至上的理念。为客户提供各项最完善的服务，努力进取，不断追求创新，公司将立足“以质量求生存，以信誉求发展的宗旨”。

主导产品：冷压机。（多工位异形件自动冷压成型机、标准件自动冷压成型机）、三模三冲、四模四冲、五模五冲、六模六冲等多工位冷压零件成型机，还为用户配备搓丝机、攻牙机等高效自动化的辅助设备，广泛应用于航空，船舶，汽车，摩托车，电动车、机械基础件行业的各种紧固件，非标异形件的生产，同时可以根据用户的特殊要求生产非标的成型机，并且提供专业化的服务。科睿尼尔冷压机产品全面引入日本、台湾当代先进机型设计风格，配备世界一流的电气、气动、轴承及电器控制系统，运行可靠，经久耐用。同时引进行业高端的技术工程师和资深团队，集设计、研发、精密的零件加工到精湛的装配技术为一体，本设备以精度高，噪音低，效率高，机械占地面积小的特点，得到行业的认可及新老客户的一致好评！科睿尼尔企业的服务遍布世界各地：瑞典、土耳其、希腊、印度、俄罗斯、蒙古、泰国、越南、巴基斯坦等发达国家和发展中国家。科睿尼尔机械自创立以来秉承着“质量至上，顾客为本”的原则，为您所拥有的科睿尼尔机器提供及时的、专业的、终身的售后服务。

科睿尼尔期待着与您携手合作，一起携手共创美好未来！

Hebei Kruenil Machinery Co., Ltd. is a subsidiary of Hebei Dingrun manufacturing intelligent equipment. The company is located in Wuan city, Handan, a beautiful historical and cultural town and ancient smelting town. The company was founded in 2020. After several years of unremitting efforts, we are energetic and ready to go! The company covers an area of more than 320 mu, with a total investment of 540 million yuan, a plant construction area of 100000 square meters and a scientific research and administrative office building of 10000 square meters. It is a scientific and technical mechanical equipment manufacturing enterprise integrating R & D, production, sales and after-sales. Now it has dozens of engineering and technical personnel. For a long time, the enterprise has accumulated rich practical experience in production technology, advanced technology, complete product series, perfect production equipment and stable product quality. The factory pass rate of the whole machine is strictly 100%, which is highly praised by the majority of domestic users. At present, the company has more than 200 employees in five departments: manufacturing, quality assurance, R & D, business and management. All departments divide their work and cooperate with each other. In line with the enterprise principle of excellence and the concept of customer first. Provide customers with the most perfect services, strive to forge ahead and constantly pursue innovation. The company will be based on the purpose of "survival by quality and development by reputation".

Leading products: cold heading machine, (multi station automatic cold heading forming machine for special-shaped parts, automatic cold heading bolt forming machine for standard parts), Three die three punch, four die four punch, five die five punch, six die six punching, multi station cold extrusion parts molding machine, and also provide users with high efficiency automatic auxiliary equipment such as wire twisting machine, tapping machine, etc. It is widely used in various fasteners such as aviation, ships, automobiles, motorcycles, electric vehicles, machinery foundation parts, non-standard special-shaped parts, and can produce non-standard molding machines according to the special requirements of users. And provide professional services. Corenil brand cold heading machine products fully introduce the design style of contemporary advanced models in Japan and Taiwan, and are equipped with world-class electrical, pneumatic, bearing and electrical control systems, which are reliable and durable. At the same time, it introduces high-end and technical engineers and senior teams in the industry, integrating design, R & D, precision parts processing and exquisite assembly technology. This equipment has the characteristics of high precision, low noise, high efficiency and small mechanical floor area which has been recognized by the industry and unanimously praised by new and old customers! Kruenil's services are all over the world: Sweden, Turkey, Greece, India, Russia, Mongolia, Thailand, Vietnam, Pakistan and other developed and developing countries. Since its establishment, Kruenil machinery has been adhering to the principle of "quality first and integrity-based", providing timely, professional and lifelong after-sales service for your Kruenil machinery.

Kruenil Machinery is looking forward to working with you to create a better future together!




目前本公司现有员工200多人,分别于造机、品保、研发、业务,以及管理等五大部门,各部门之间彼此分工合作。本着精益求精的企业原则及客户至上的理念。为客户提供各项最完善的服务,努力进取,公司将立足“以质量求生存,以信誉求发展的宗旨”。期待着与新老客户精诚合作,共创美好的未来。

公司拥有完善的质量保证体系。从2006年开始在公司贯彻ISO9001质量标准,总经理为公司质量第一责任人,技术质量总监主管质量工作。公司设有质量处,负责公司正常质量工作。根据本厂的情况分别对不同产品设置不同质量标准,公司质量处负责对产品入库检验,及负责每月对生产过程的质量监督检查。公司严格执行《产品质量责任制》,对影响产品质量的主要环节设计、制造、采购、售后服务制订质量责任制,并直接与经济效益挂钩。《产品质量责任制》的贯彻执行,保证了公司质量保证体系有效运行。严格产品质量检验制度,严把产品出厂的质量关。公司设有销售服务中心作为公司质保体系的组成部分,负责产品的售后服务。对用户反馈信息做出及时处理,对用户提出的要求,及时做出反应,对产品技术改进任务及时组织人员解决。完善的质量保证体系,保证了公司产品的质量水平不断提高,以其优良的性能和可靠的质量一直受到用户的赞誉。

ABOUT US

At present, the company has more than 200 employees in five departments: manufacturing, quality assurance, R & D, business and management. All departments divide their work and cooperate with each other. In line with the enterprise principle of excellence and the concept of customer first. Provide customers with the most perfect services, strive to forge ahead and constantly pursue innovation. The company will be based on the purpose of "survival by quality and development by reputation". Looking forward to sincere cooperation with new and old customers to create a better future.

The company has a perfect quality assurance system. In 2006, he was the quality director and the quality manager of the company. The company has a quality department, which is responsible for the normal quality work of the company. Different quality standards are set for different products according to the situation of the factory. The quality department of the company is responsible for the warehousing inspection of products and the monthly quality supervision and inspection of the production process. The company strictly implements the product quality responsibility system, and formulates a quality responsibility system for the main links affecting product quality, such as design, manufacturing, procurement and after-sales service, which is directly linked to economic benefits. The implementation of the product quality responsibility system ensures the effective operation of the company's quality assurance system. Strict product quality inspection system and strict quality control of products leaving the factory. The company has a sales service center as an integral part of the company's quality assurance system, which is responsible for the after-sales service of products. Timely handle the feedback information from users, respond to the requirements put forward by users, and organize personnel to solve the product technology improvement task in time. The perfect quality assurance system ensures the continuous improvement of the quality level of the company's products. It has been praised by users for its excellent performance and reliable quality.

 **KREVERE** 科睿尼尔



科睿尼尔机械装备有限公司本着精益求精的企业原则及客户至上的理念,为客户提供各项最完善的服务,并致力于开拓国际市场。产品远销孟加拉国、智利、俄罗斯、土耳其、韩国、乌克兰、巴西、圭亚那等多个国家和地区,深得广泛赞誉和信赖。

SALES NETWORK

Krevere Machinery Co., Ltd in the business principle of excellence and customer oriented philosophy, to provide customers with the most comprehensive services, and is committed to explore the international market, the products are exported to Bangladesh, Chile, Russia, Turkey, South Korea, Ukraine, Brazil, Guyana and other countries and regions, won widespread praise and trust.



科睿尼尔 追求卓越

Koranil pursues excellence

「追求一流的技术；创造一流的产品；提供一流的服务；培养一流的人才」
Pursue the first-grade technology, create the first-class product, provide the best service, cultivate the top talents





“工欲善其事，必先利其器”

先进的检测加工设备和先进的机械设
备生产工艺，培训出专业的设备操作队伍，
高度应用现代化科技力量，使技术操作变
得更加高效，成功制造出令客户满意的冷
锻机系列产品。



“GOOD TOOLS ARE PREREQUISITE TO THE SUCCESSFUL EXECUTION OF A JOB”

Advanced testing mechanical machining equipment and advanced technologies for making the mechanical processing equipment, in addition to which there has been trained up a professional machinery operating contingent, making a full use of the modernized sci-tech force, thanks to which the technical operation became more efficient and customer satisfied cold forging machines.





用途和特点：

1. 镶嵌式无油自润滑轴承，提高联轴轴的寿命和耐磨性，降低能耗。
2. 电路系统为变频器加PLC，不但可无极变速，还可以自动检出机器工作中的故障状态停机。
3. 采用空压气动离合器，启动电流小，刹车平稳，除点动方式外每次停车滑块均能停至后死点，提供最大操作空间。
4. 设计和开发封闭防护罩，大幅减少热油气雾对工作环境的污染。
5. 机器设置油路的压力保护装置，保证机器运行时各部件的充分润滑，设置气路压力保护装置，保护机器过载现象，提高模具使用寿命。
6. 在确保机器方便调试的同时，多处设置安全保护门，强调操作人员的规范操作，确保人员的安全。

Use and characteristic

1. Non-oil self-lubricating bearings are qualified to improve the application life and abrasion resistance of the coupling shaft, as well as reduce energy consumption.
2. Circuitry for the converter plus PLC, not only continuously variable transmission, the machine can work in automatic detection of the fault condition shutdown.
3. Using pneumatic air clutch to start the current, brake smoothly, except to move the slider or the outside could stop time to stop after the death, to provide maximum room for maneuver.
4. In order to decrease the pollution of hot-oil gas spray to the working environment, closed guard is designed and developed.
5. The machine set pressure oil line protection devices to ensure that all parts of the machine running the full lubrication. Set air way pressure protection device, overload protection of the machine, improve mold life.
6. Make sure the machine can be tested in convenience, then, for the security of the staff, building safety protection door and teaching the operators to carry out standard operation are also of great importance.



气动手动夹钳：夹料力根据产品材料性质可以调整。短寸时，第一组夹钳自动不夹取。最后一把夹钳把成品放入内部输送带，由内部输送带传输出来，以确保成品零件完整性。

Swing pneumatic clamp: the clamping force can be adjusted according to the property of the material. In the short-inch, the first set of clamp is automatically unclamped. The last set of clamp will put the finished product into the internal conveyor belt to ensure the integrity of the finished parts.



前、后退出机构由数字化伺服电机控制，可作远程调试设定，产品调试方便，成品制造精度高。

P, K, O, and K, O, structure is controlled by a digital servo motor, and can be set for remote debugging. It's convenient for debug and it can ensure the finished products with manufacturing of high precision.



离合器：气压式离合器与气压式刹车，以避免设备调试过程中启动电流重复产生，方便停车、倒车，极大提高模具调试效率。

Clutch: Equipped with pneumatic clutch and pneumatic brake to avoid the starting current generating repeatedly, convenient for parking and reversing and improve the efficiency of mold debugging in the process of installation.



气动手动夹料，可快速调整夹料中心度，操作简便、稳定，可任意更改翻转式夹料机构（选择配备）。

Pneumatic clamp, it can be adjusted centrally quickly, used simply and stably, and you can free to change the clamp with evaginable (option).



高配置、易调整的集中式空压系统。

With high-grade configuration, easy for adjustment and centralized compressed air system.

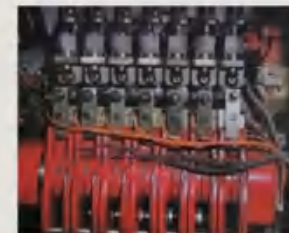
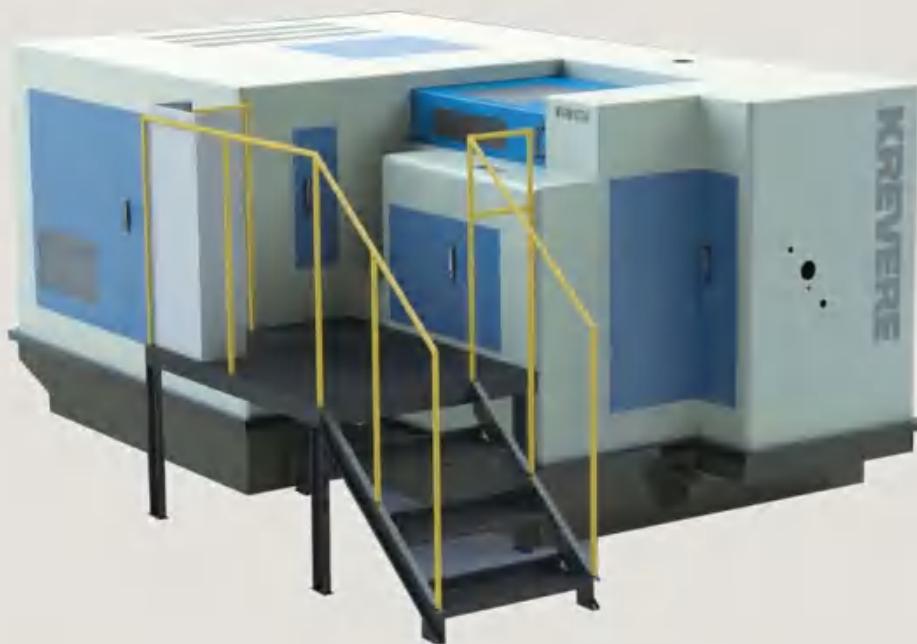


精确的切料机构，切料受力于主轴中心。

A powerful cut-off mechanism is directly driven by the crank shaft.

科睿尼尔冷墩机是一种生产效率高，生产范围较大，适应于变形复杂，集锻造、挤压、切边于一体的成型机。我们从不忽视任何一个细微环节，立志取得每个零件的加工精度。工艺流程都在我们有效的生产控制范围内。无限制提高用户的附加价值是我们永恒追求的目标，公司一直致力于为用户提供高效益、高品质、性价比最优的机械设备，帮助用户不断提高生产效率、降低成本，最终增强用户的市场竞争能力。快速、细致周全的售前售后服务，是我们不断满足并超越客户需求的有效保障，用户的需求就是我们的需求。

Corenil cold heading machine is a molding machine with high production efficiency and large production range, which is suitable for complex deformation and integrates upsetting, extrusion and edge cutting. We never ignore any subtle link and are determined to achieve that the machining accuracy and process flow of each part are within our effective production control range. Unlimited improvement of users' added value is our eternal goal. The company has been committed to providing users with high-efficiency, high-quality and cost-effective mechanical equipment, helping users continuously improve production efficiency, reduce costs, and finally enhance users' market competitiveness. Fast, meticulous and comprehensive pre-sales and after-sales service is a powerful guarantee for us to continuously meet and overload the needs of customers, all for the sake of users.



后退出机构各工位可独立调整，且最后一个工位，可以通过调整凸轮位置或更换凸轮，实现切边动作。配有压力检测安全销。

Each station of K, O structure can be adjusted independently, and the last station can realize the action of trimming by adjusting the cam position or changing another cam. It is equipped with a safety pin to check up the pressure.

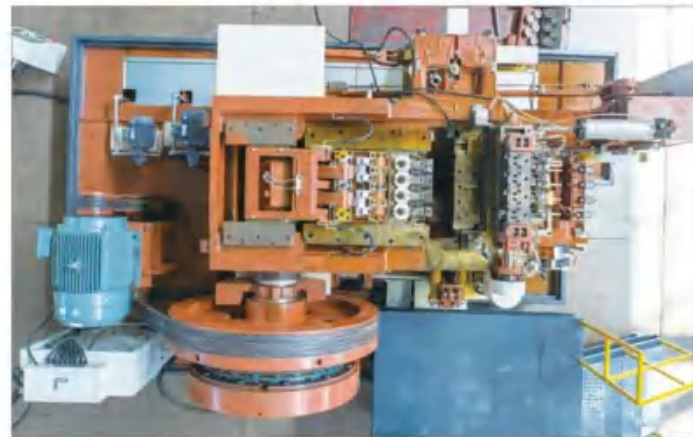


高精度主滑块连接后翼设计，使主滑块行进更稳定准确。使用QT600材质更耐磨更耐热，内衬套用ZQsn10-1加厚铜套保障精度和延长使用寿命。

The high-precision main slider is connected with the rear wing design to make the main slider travel more stable and accurate. The QT600 material is more wear-resistant and heat-resistant. The inner bushing is thickened with ZQsn10-1 copper sleeve to ensure accuracy and prolong service life.



大型三坐标测量设备，确保每台出厂机器的零部件精度。
Large CMM equipment ensures the accuracy of parts of each factory machine.



螺栓冷镦机前视图
Plan view of bolt former
Advanced automatic product line and excellent procedures make our products superior. Our technical people's participating in manufacturing and supervising makes sure our products' stability and reliability. We adopt advanced computer auxiliary system gathered design, manufacture and analyzing to makes use all parts and procedures operate harmony. Advanced checking equipment, self-contained inspecting procedures and strict quality criterion to achieve the goal that all products have no fault.



采用气缸控制棘爪机构，插齿会自动抬起，消除噪声；电器采用电磁阀送料气缸间歇送料功能，实现了更大规格产品的生产，拓宽了机器生产的规格。

By cylinder control pawl mechanism shaper will lift automatically, eliminating the noise; Electric electromagnetic valve cylinder feeding intermittently send Material functions, to achieve greater product specifications Production, broaden the machine production specifications.



立式全自动校直机，使线材进出自动化。采用卧式线架，便于线材安装，送料时会自动松开线材，保护线材表面的拉伤。

Straightening machine make the material get in and out automatically. A horizontal line planes, easy cable installation. When will self-feed loosen the wire move to protect the surface of the wire stain.



整机油管实现单管对点独立供油，确保在高速运转下实现油膜均匀，油压均衡。

The whole point of the tubing to achieve a single tube of oil independence, to ensure uniform film, hydraulic equilibrium at high speeds, production specifications.

SERIES 3-DIE 3-BLOW BOLT FORMER(三模三冲螺丝成型机)

单位:mm

规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF
机型 MODEL	10B3S	10B3SL	13B3S	13B3SL	13B3SXL	17B3S	17B3SL	17B3SXL	17B3SUL	19B3S	19B3SL	19B3SXL	19B3SUL
模数 FORGING STATION	3												
最大切断直径 MAX CUT-OFF DIA	9			11			13			17			
最大切断长度 MAX CUT-OUT LENGTH	70	105	105	130	180	105	180	230	350	140	185	240	400
后托顶出长度 MAX KICK-OUT LENGTH	60	90	90	120	175	90	175	225	325	120	180	225	325
前托顶出长度 MAX P. K. O LENGTH	13	20	17	23	30	20	30	36	60	26	30	35	60
切槽 CUT-OFF QUILL (DXL)	28x46	28x46	35x56	35x56	38x79	40x66	40x80	40x80	40x80	46x80	46x80	60x100	65x100
母模 MAIN DIE HOLE (DXL)	50x65	50x105	60x105	60x135	70x185	70x95	80x185	80x240	80x330	93x135	93x190	93x240	93x350
母模中心距 DIES PITCH	60			87			93			114			
公模冲 PUNCH HOLE (DXL)	40x80	40x110	45x110	45x110	45x130	50x102	50x130	50x190	50x200	60x120	60x170	60x200	60x250
主滑板行程 RAM STROKE	120	150	150	182	250	160	250	360	460	200	270	360	500
压接力 (ton) FORGING POWER	28	30	50	50	55	70	70	80	80	90	90	100	100
尺寸 SIZE	1/4 (m6)			5/16 (m8)			3/8 (m10)			1/2 (m12)			
产品 PRODUCTIONS	最大长度 MAX LENGTH												
	50	75	75	100	150	75	150	200	300	100	150	200	300
	最短长度 MIN LENGTH												
	12	16	14	20	30	16	30	50	100	20	40	50	100
	每分种最大产能 MAX OUT-PUT (pcs/minute)												
	300	240	240	210	180	210	175	110	80	170	125	100	80
	主马达 (HP) MAIN MOTOR												
	10	15	20	20	30	20	30	40	40	40	50	50	50
	机械重量 (ton) APPROX WT												
	6.5	7.5	10	11	13.5	12.5	17	21	26.5	20	23	27	33



SERIES 3-DIE 3-BLOW BOLT FORMER(三模三冲螺丝成型机)

单位:mm

规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	
机型 MODEL	24B3S	24B3SL	24B3SXL	24B3SUL	30B3S	33B3S	36B3S	41B3S	45B3S					
模数 FORGING STATION	3													
最大切断直径 MAX CUT-OFF DIA	20				25		28		31		36		40	
最大切断长度 MAX CUT-OUT LENGTH	185	270	320	400	270	300	320	400	450					
后托顶出长度 MAX KICK-OUT LENGTH	185	230	280	335	230	260	290	340	390					
前托顶出长度 MAX P. K. O LENGTH	33	36	50	60	35	45	60	60	70					
切槽 CUT-OFF QUILL (DXL)	60x100	60x120	60x120	60x120	75x120	84x130	90x140	110x140	115x140					
母模 MAIN DIE HOLE (DXL)	100x195	100x240	100x294	100x360	125x240	140x280	160x294	178x385	195x420					
母模中心距 DIES PITCH	87		126		138		156		174		195		210	
公模冲 PUNCH HOLE (DXL)	75x160	75x200	75x232	75x232	90x197	96x210	105x232	120x250	135x280					
主滑板行程 RAM STROKE	280	360	420	500	360	400	440	500	580					
压接力 (ton) FORGING POWER	160	160	175	175	220	260	320	450	600					
尺寸 SIZE	5/8 (m16)				3/4 (m20)		7/8 (m22)		1 (m24)		1-1/8 (m27)		1-3/4 (m30)	
产品 PRODUCTIONS	最大长度 MAX LENGTH													
	150	200	250	300	200	225	250	300	355					
	最短长度 MIN LENGTH													
	25	50	60	100	40	50	60	80	100					
	每分种最大产能 MAX OUT-PUT (pcs/minute)													
	120	100	75	65	90	75	60	50	50-50					
	主马达 (HP) MAIN MOTOR													
	75	75	100	100	100	125	125	150	175					
	机械重量 (ton) APPROX WT													
	39	44	48	54	57	75	92	124	160					



备注 / REMARKS:
 1. 本图例所示之规格仅供参考, 实际生产时请以设计图为准。
 THE FIGURE SHOWN IN BRACKET SHOWS THE MAX LENGTH OF THE PRODUCT ALLOWED FOR ROTATIONAL TURNING.
 2. 实际生产时, 产能会根据产品的不同而有所差异。
 PRODUCTION CAPACITY DEPENDS ON APPLICABLE PRODUCTS MATERIAL STRENGTH OF THE DIE.
 3. 本图例所示之规格仅供参考, 实际生产时请以设计图为准。
 WE RESERVE THE RIGHT TO CHANGE THE DESIGN OR PRODUCTION WITHOUT NOTICE BEING GIVEN TO OUR CUSTOMERS.

SERIES 4-DIE 4-BLOW BOLT FORMER(四模四冲螺丝成型机)

单位:mm

规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF																																																	
机型 MODEL	10B4S	10B4SL	13B4S	13B4SL	13B4SL	13B4SL	17B4S	17B4SL	17B4SL	17B4SL	19B4S	19B4SL	19B4SL	19B4SL																																																	
模数 FORGING STATION	4																																																														
最大切断直径 MAX CUT-OFF DIA	9			11				13				17																																																			
最大切断长度 MAX CUT-OUT LENGTH	70	105	105	130	180	220	135	180	230	350	140	185	240	400																																																	
后托顶出长度 MAX KICK-OUT LENGTH	60	90	90	120	175	215	115	175	225	325	120	180	225	325																																																	
前托顶出长度 MAX P. K. O. LENGTH	13	20	20	23	30	34	20	30	36	60	26	30	35	60																																																	
切槽 CUT-OFF QUILL (DXL)	28x46	28x46	28x46	35x56	38x79	38x79	40x66	40x80	40x80	40x80	46x80	46x80	60x100	65x100																																																	
母模 MAIN DIE HOLE (DXL)	50x65	50x105	50x105	60x130	70x185	70x240	70x135	80x185	80x240	80x330	93x135	93x190	93x240	93x350																																																	
母模中心距 DIES PITCH	60			87				93				114																																																			
公模架 PUNCH HOLE (DXL)	40x80	40x110	40x110	45x110	45x130	45x175	50x111	50x130	50x190	50x200	60x120	60x170	60x200	60x250																																																	
主滑板行程 RAM STROKE	120	150	150	182	250	350	180	250	360	460	200	270	360	500																																																	
压接力 (ton) FORGING POWER	40	40	65	65	70	70	85	85	90	90	120	120	130	130																																																	
尺寸 SIZE	1/4 (m6)			5/16 (m8)				3/8 (m10)				1/2 (m12)																																																			
产品 PRODUCTIONS	<table border="1"> <tr> <td>最大长度 MAXLENGTH</td> <td>50</td> <td>75</td> <td>75</td> <td>100</td> <td>150</td> <td>200</td> <td>100</td> <td>150</td> <td>200</td> <td>300</td> <td>100</td> <td>150</td> <td>200</td> <td>300</td> </tr> <tr> <td>最短长度 MIN LENGTH</td> <td colspan="2">HEX 外六角螺丝</td> <td>12</td> <td>16</td> <td>16</td> <td>20</td> <td>30</td> <td>40</td> <td>16</td> <td>30</td> <td>50</td> <td>100</td> <td>20</td> <td>40</td> <td>50</td> <td>100</td> </tr> <tr> <td></td> <td colspan="2">SOCKET 强力螺丝</td> <td>16</td> <td>20</td> <td>20</td> <td>25</td> <td>40</td> <td>40</td> <td>20</td> <td>40</td> <td>50</td> <td>100</td> <td>25</td> <td>40</td> <td>50</td> <td>100</td> </tr> </table>														最大长度 MAXLENGTH	50	75	75	100	150	200	100	150	200	300	100	150	200	300	最短长度 MIN LENGTH	HEX 外六角螺丝		12	16	16	20	30	40	16	30	50	100	20	40	50	100		SOCKET 强力螺丝		16	20	20	25	40	40	20	40	50	100	25	40	50	100
最大长度 MAXLENGTH	50	75	75	100	150	200	100	150	200	300	100	150	200	300																																																	
最短长度 MIN LENGTH	HEX 外六角螺丝		12	16	16	20	30	40	16	30	50	100	20	40	50	100																																															
	SOCKET 强力螺丝		16	20	20	25	40	40	20	40	50	100	25	40	50	100																																															
每分钟最大产能 MAX OUT-PUT (pcs/minute)	300	240	240	200	180	140	200	175	110	80	170	125	100	80																																																	
主马达 (HP) MAIN MOTOR	15	15	20	30	30	30	30	40	40	40	50	50	50	50																																																	
机械重量 (ton) APPROX WT	8	10	12	13.5	15.5	19.5	16	19	24	29	23	27	32	39																																																	



SERIES 4-DIE 4-BLOW BOLT FORMER(四模四冲螺丝成型机)

单位:mm

规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF																																														
机型 MODEL	24B4S	24B4SL	24B4SL	24B4SL	30B4S	30B4SL	30B4SL	33B4S	36B4SS	36B4S	36B4SL	36B4SL	41B4S	45B4S																																															
模数 FORGING STATION	4																																																												
最大切断直径 MAX CUT-OFF DIA	20				25			28			31			36		40																																													
最大切断长度 MAX CUT-OUT LENGTH	185	270	320	400	270	320	400	300	220	320	370	400	400	450																																															
后托顶出长度 MAX KICK-OUT LENGTH	185	230	280	335	230	285	335	260	185	290	340	410	340	390																																															
前托顶出长度 MAX P. K. O. LENGTH	33	36	56	60	35	60	60	45	30	60	60	60	60	70																																															
切槽 CUT-OFF QUILL (DXL)	60x100	60x120			75x120			84x130			90x140			110x140		115x140																																													
母模 MAIN DIE HOLE (DXL)	100x195	100x240	100x294	100x360	125x240	125x294	125x360	145x280	160x210	160x294	160x370	160x450	178x385	195x420																																															
母模中心距 DIES PITCH	126				138			156			174			195		210																																													
公模架 PUNCH HOLE (DXL)	75x160	75x200	75x232	75x232	90x190	90x232	90x240	90x210	105x180	105x232	105x235	106x270	120x250	135x280																																															
主滑板行程 RAM STROKE	280	360	420	500	360	430	500	400	300	440	500	600	500	580																																															
压接力 (ton) FORGING POWER	200	200	215	215	265	285	300	320	360	380	420	450	520	635																																															
尺寸 SIZE	5/8 (m16)				3/4 (m20)			7/8 (m22)			1 (m24)			1-1/8 (m27) 1-3/4 (m30)																																															
产品 PRODUCTIONS	<table border="1"> <tr> <td>最大长度 MAXLENGTH</td> <td>150</td> <td>200</td> <td>250</td> <td>300</td> <td>200</td> <td>250</td> <td>305</td> <td>225</td> <td>150</td> <td>250</td> <td>300</td> <td>380</td> <td>300</td> <td>355</td> </tr> <tr> <td>最短长度 MIN LENGTH</td> <td colspan="2">HEX 外六角螺丝</td> <td>25</td> <td>50</td> <td>60</td> <td>100</td> <td>40</td> <td>60</td> <td>100</td> <td>50</td> <td>40</td> <td>60</td> <td>100</td> <td>100</td> <td>100</td> </tr> <tr> <td></td> <td colspan="2">SOCKET 强力螺丝</td> <td>35</td> <td>50</td> <td>60</td> <td>100</td> <td>40</td> <td>60</td> <td>100</td> <td>60</td> <td>50</td> <td>60</td> <td>100</td> <td>100</td> <td>100</td> </tr> </table>														最大长度 MAXLENGTH	150	200	250	300	200	250	305	225	150	250	300	380	300	355	最短长度 MIN LENGTH	HEX 外六角螺丝		25	50	60	100	40	60	100	50	40	60	100	100	100		SOCKET 强力螺丝		35	50	60	100	40	60	100	60	50	60	100	100	100
最大长度 MAXLENGTH	150	200	250	300	200	250	305	225	150	250	300	380	300	355																																															
最短长度 MIN LENGTH	HEX 外六角螺丝		25	50	60	100	40	60	100	50	40	60	100	100	100																																														
	SOCKET 强力螺丝		35	50	60	100	40	60	100	60	50	60	100	100	100																																														
每分钟最大产能 MAX OUT-PUT (pcs/minute)	120	100	75	65	90	65	60	80	80	60	55	45-50	45	40-45																																															
主马达 (HP) MAIN MOTOR	75	75	100	100	100	125	125	125	125	125	150	150	175	200																																															
机械重量 (ton) APPROX WT	45	51	56	62	65	76	87	85	86	108	128	160	152	195																																															



备注 / REMARKS:
 1. 4冲模生产时需注意送料, 避免因送料不到位造成产品不合格。
 2. 因产品规格不同, 机器的生产能力会有所不同。
 3. 因物料不同, 产品的强度会有所不同。
 4. 因物料不同, 产品的重量会有所不同。
 5. 因物料不同, 产品的长度会有所不同。
 6. 因物料不同, 产品的直径会有所不同。
 7. 因物料不同, 产品的螺距会有所不同。
 8. 因物料不同, 产品的螺纹会有所不同。
 9. 因物料不同, 产品的表面处理会有所不同。
 10. 因物料不同, 产品的包装会有所不同。

SERIES 5-DIE 5-BLOW BOLT FORMER(五模五冲螺丝成型机)

		单位:mm												
规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	
机型 MODEL	10B55	10B55L	13B55	13B55L	13B55SL	17B55	17B55L	17B55SL	19B55	19B55L	19B55SL	19B55LL	19B55ULL	
模数 FORGING STATION	5													
最大切断直径 MAX CUT-OFF DIA	9			11			13			17				
最大切断长度 MAX CUT-OUT LENGTH	70	105	105	130	180	135	180	230	140	185	240	310	400	
后托顶出长度 MAX KICK-OUT LENGTH	60	90	90	120	175	115	175	225	120	180	225	280	325	
前托顶出长度 MAX P. K. O LENGTH	13	20	20	23	30	20	30	36	26	30	35	60	60	
切槽 CUT-OFF QUILL (DXL)	28x46	28x46	35x46	35x56	38x79	40x66	40x80	40x80	46x80	46x80	60x100	60x100	65x100	
母模 MAIN DIE HOLE (DXL)	50x65	50x105	60x105	70x135	70x185	70x135	80x185	80x240	93x135	93x190	93x240	93x294	93x350	
母模中心距 DIES PITCH	60			87			93			114				
公模架 PUNCH HOLE (DXL)	40x80	40x110	45x110	45x130	45x130	50x111	50x130	50x190	60x120	60x170	60x200	60x232	60x250	
主滑板行程 RAM STROKE	120	150	150	182	250	180	250	360	200	270	360	420	500	
压接力 (ton) FORGING POWER	45	50	80	85	90	105	105	110	145	160	170	170	175	
尺寸 SIZE	1/4 (m6)			5/16 (m8)			3/8 (m10)			1/2 (m12)				
产品 PRODUCTIONS	最大长度 MAXLENGTH													
	50	75	75	100	150	100	150	200	100	150	200	250	300	
	最小长度 MIN LENGTH													
	12	16	16	20	30	16	30	50	20	40	50	50	100	
	六角螺栓 HEX 外六角螺栓													
	16	20	20	25	40	20	40	50	25	40	50	50	100	
	六角螺母 SOCKET 强力螺母													
每分钟最大产能 MAX OUT-PUT (pcs/minute)	240	200	200	180	160	180	150	100	140	110	90	80	70	
主马达 (HP) MAIN MOTOR	15	20	30	30	40	40	40	50	50	50	75	75	75	
机械重量 (ton) APPROX WT	9.5	11.5	14	16	18.5	19	23	28	27	32	38	41	45	



SERIES 5-DIE 5-BLOW BOLT FORMER(五模五冲螺丝成型机)

		单位:mm												
规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	
机型 MODEL	24B55	24B55L	24B55SL	24B55LL	30B55	30B55L	30B55LL	33B55	36B55	36B55L	41B55	45B55		
模数 FORGING STATION	5													
最大切断直径 MAX CUT-OFF DIA	20				25				28		31		36	
最大切断长度 MAX CUT-OUT LENGTH	185	270	320	400	270	320	400	300	320	370	400	450		
后托顶出长度 MAX KICK-OUT LENGTH	185	230	280	335	230	285	335	260	290	340	340	390		
前托顶出长度 MAX P. K. O LENGTH	33	36	60	60	35	60	60	45	60	60	60	70		
切槽 CUT-OFF QUILL (DXL)	60x100	60x120	60x120	60x120	75x120		84x130		90x140		90x140		110x140	
母模 MAIN DIE HOLE (DXL)	100x195	100x240	100x294	100x360	125x240	125x294	125x360	145x280	160x294	160x370	178x385	195x420		
母模中心距 DIES PITCH	126				138				156		174		195	
公模架 PUNCH HOLE (DXL)	75x160	75x200	75x232	75x232	90x190	90x232	90x240	96x210	105x232	105x235	120x250	135x280		
主滑板行程 RAM STROKE	280	360	420	500	360	430	500	400	440	500	500	580		
压接力 (ton) FORGING POWER	230	230	250	250	320	340	360	350	440	480	630	700		
尺寸 SIZE	5/8 (m16)				3/4 (m20)				7/8 (m22)		1 (m24)		1-1/8 (m27) 1-3/4 (m30)	
产品 PRODUCTIONS	最大长度 MAXLENGTH													
	150	200	250	300	200	250	305	225	250	300	300	355		
	最小长度 MIN LENGTH													
	25	50	60	100	40	60	100	50	60	100	100	100		
	六角螺栓 HEX 外六角螺栓													
	35	50	60	100	60	60	100	60	60	100	100	100		
	六角螺母 SOCKET 强力螺母													
每分钟最大产能 MAX OUT-PUT (pcs/minute)	100	75	65	60	70	60	55	60	55	50	45	40		
主马达 (HP) MAIN MOTOR	100	100	100	100	125	125	125	125	150	150	200	200		
机械重量 (ton) APPROX WT	52	58	63	69	73	85	97	100	126	146	180	225		



备注 / REMARKS:

1. 本台规格书仅供参考, 如有需要请向本公司索取详细规格书。
2. 后托顶出行程在括号内表示为最大行程, 实际行程可根据产品不同而有所调整。
3. 本台规格书仅供参考, 如有需要请向本公司索取详细规格书。
4. 本台规格书仅供参考, 如有需要请向本公司索取详细规格书。

WE RESERVE THE RIGHT TO CHANGE THE DESIGN SPECIFICATIONS WITHOUT NOTICE BEING SET FORTH THEREIN.

SERIES 6-DIE 6-BLOW BOLT FORMER(六模六冲螺丝成型机)

单位:mm

规格 SPECIFICATION	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF	STBF
机型 MODEL	13B65	13B65XL	17B65	17B65L	19B65	19B65L	19B65XL	24B65	30B65	36B65
模数 FORGING STATION	6									
最大切断直径 MAX CUT-OFF DIA	11		13		17		25		32 34	
最大切断长度 MAX CUT-OUT LENGTH	105	180	135	135	140	185	240	200	250	320
后托顶出长度 MAX KICK-OUT LENGTH	90	175	115	115	120	180	225	175	220	290
前托顶出长度 MAX P. K. O LENGTH	20	30	20	20	30	30	35	45	45	60
切槽 CUT-OFF QUILL (DXL)	35x56	38x79	40x66	40x66	46x80	46x80	60x100	60x100	75x120	90x140
母模 MAIN DIE HOLE (DXL)	60x105	70x185	70x135	70x135	93x135	93x190	93x240	108x195	125x240	150x294
母模中心距 DIES PITCH	87		93		114		126		138 174	
公模架 PUNCH HOLE (DXL)	45x110	45x130	50x111	50x130	60x120	60x170	60x200	75x160	90x190	105x232
主滑板行程 RAM STROKE	150	250	180	250	200	270	360	280	360	440
压道力 (Ton) FORGING POWER	95	110	120	120	150	160	170	260	400	500
尺寸 SIZE	5/16 (m8)		3/8 (m10)		1/2 (m12)		5/8 (m16)		3/4 (m20) 1 (m24)	
产品 PRODUCTION	最大长度 MAX LENGTH									
	75	150	100	150	100	150	200	155	200	250
	最短长度 MIN LENGTH									
	16	30	16	30	20	40	50	40	40	50
	每分钟最大产能 MAX OUT-PUT (pcs/minute)									
	150	130	130	130	110	100	90	90	65	50
	主马达 (HP) MAIN MOTOR									
	30	40	40	40	50	50	75	100	125	150
	机械重量 (Ton) APPROX WT									
	16	22.5	22	26	29	35	42	65	85	136

NOTE / REMARKS:
1. THE KICK-OUT STROKE IN BRACKET SHOWS THE MAX. LENGTH OF THE PRODUCT ALLOWED FOR ROTATIONAL TRANSFER.
2. THE PRODUCTION CAPACITY, MAINLY DEPENDS ON APPLICABLE PRODUCTS MATERIAL TENSILE STRENGTH OF THE WORK.
3. THE DIE SETTING AND THE DIE LIFE WILL BE AFFECTED BY THE WORKING TEMPERATURE.
4. WE RESERVE THE RIGHT TO CHANGE THE DESIGN OR TECHNICAL DATA WITHOUT NOTICE BEING IN WRITING.



科睿尼尔机械装备有限公司

科学凝聚精品 睿智打造工匠

Science condenses fine products Wise craftsmen

科睿尼尔与您同行! Keruineil walks with you!



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