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## 公司简介/ Company profile

江苏天联机床有限公司坐落于锻压行业领先地位——江苏南通白蒲前进开发区，始建于2006年，是一家专业致力于钣金冲压设备的研制和销售的综合性公司，公司始终坚持以振兴民族工业为己任，以服务客户为宗旨，吸收世界先进技术和工艺，结合中国实际需求，制造出结构合理、品质优良的锻压设备。

公司作为专业的钣金冲压设备制造商，始终秉持一个目标：不断了解客户的真实需求，运用先进的技术，采用合理的工艺，选用可靠的配件，为客户制造高效、稳定的产品。我们所研制的产品涵盖了入门级到自动化的系列钣金加工机械、软件和零配件，以便满足广大客户的通用化或个性化需求。公司始终秉持实施精细化管理，关注细节，注重品质，严格执行ISO9001质量管理体系，规范企业内部管理流程。在追求产品品质卓越的同时，努力提高服务质量，令用户放心、使用户满意。公司已经向客户证明：一直致力于与每一个客户建立长期良好的合作伙伴关系。

Jiangsu Tianlian Machine Co., Ltd. is located in Jiangsu, Nantong forging industry leading area BaiPu forward Development Zone, founded in 2006, is a professional committed to the metal forging equipment development and sales of Integrated Company, the company has always been to revitalize national industry responsibility, to customer service for the purpose of absorbing the world advanced technology, combined with the China actual needs and experience, reasonable structure, excellent quality of the manufacture of forging equipment.

The company is a professional manufacturer of metal forging equipment, always adhere to one goal: to continue to understand the real needs of customers, the use of advanced technology, reasonable process, selection of reliable manufacturing parts, high efficient and stable products to customers. The products we have developed range from the entry-level to the automatic series of sheet metal processing machines, software and accessories, so as to meet the needs of the customers in general or in a personalized way.

The company always adhere to the implementation of fine management, attention to detail, focus on quality, strict implementation of ISO9001 quality management system, standardize enterprise internal management processes, in the pursuit of product quality excellence and strive to improve the quality of service, so that users trust, customer satisfaction.

The company has demonstrated to the customer that it has always been committed to building long-term, good partnerships with each and every customer.

## 江苏天联机床有限公司

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# JIANGSU TIANLIAN MACHINE TOOL



## ● 液压机

Y32、Y27、Y28、Y41、Y61系列  
HYDRAULIC MACHINE

## ● 伺服液压机

CNC SERVO HYDRAULIC PRESS

## 江苏天联机床有限公司

Jiangsu Tianlian Machine Tool Co., Ltd.

## Y32系列四柱液压机

Y32 series four column hydraulic press



## Y32系列四柱液压机

Y32 series four column hydraulic press



### 性能特点:

- 计算机优化结构设计, 三梁四柱式结构, 简单、经济、实用。
- 液压控制采用插装阀集成系统, 动作可靠, 使用寿命长, 液压冲击小, 减少了连接管路与泄露点。
- 独立的电气控制系统, 工作可靠, 动作直观, 维修方便。
- 采用按钮集中控制, 具有调整、手动和半自动三种操作方式。
- 通过操作面板选择, 可实现定程、定压两种成型工艺, 并具有保压延时等功能。
- 滑块的工作压力、空载快速下行和慢速工进的行程范围均可根据工艺需要进行调整。

### Performance characteristics:

- The computer optimized structural design, three beam four column structure, is simple, economical and practical.
- The hydraulic control adopts the integrated system of cartridge valves. The operation is reliable, the service life is long, the hydraulic shock is small, and the connection pipe and the dew-point are reduced.
- Independent electrical control system, reliable operation, intuitive operation, convenient maintenance.
- It adopts button centralized control, which has three modes of operation: adjustment, manual and semi-automatic.
- Through the operation panel selection, it can realize two kinds of forming processes of fixed range and constant pressure, and have the functions of holding pressure and delaying time.
- The working pressure of the slider, the no-load fast down and the range of the slow speed shift can be adjusted according to the process requirements.

本系列液压机为一般用途液压机, 又称为万能液压机, 适用于金属材料的拉伸、弯曲、翻边、冷挤、冲裁等工艺, 还适用于校正、压制、粉末制品、磨料制品压制成型以及塑料制品、绝缘材料的压制成型。

This series of hydraulic machine for general purpose hydraulic machine, also known as the universal hydraulic machine, applicable to metal materials tensile, bending, flanging, cold extrusion, stamping and other craft, also suitable for calibration, pressing, powder products, abrasive products pressing and plastic products, insulation materials pressing molding.

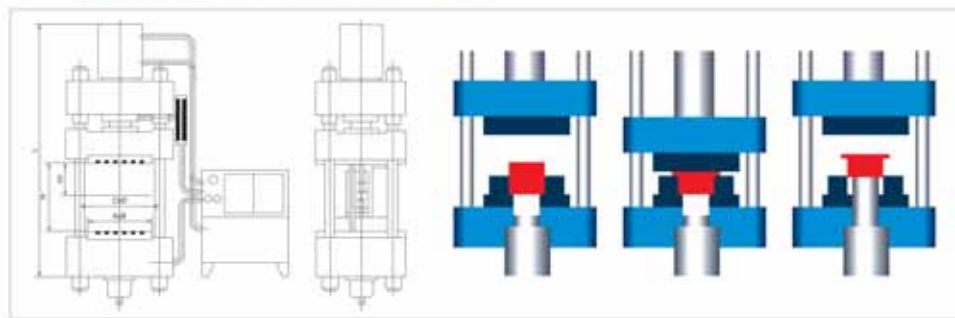
### 选配附件:

- 冲裁缓冲装置
- 换模用浮动导轨和滚动托架
- 模具快速夹紧机构
- 光幕安全保护装置
- 打料装置
- 油加热或冷却装置
- 位移传感器、触摸屏装置
- 电加热管控制系统
- 移动工作台
- PLC
- 抽芯缸多路控制
- 滑块锁紧机构

### Optional accessories:

- Blanking buffer
- Floating guide rail and rolling bracket for die change
- Quick clamping mechanism for die
- Light curtain protection device
- Clamping device
- Oil heating or cooling device
- Displacement transmitting and heating industrial display screen device
- Electric heating tube control system
- Moving table
- PLC
- Multiple control of core pulling cylinder
- Slider locking mechanism

### 结构及运作示意图 Structure and operation schematic diagram



### Y32系列四柱液压机数据参数

Y32 Technical parameters of series four column hydraulic press data parameters

参数名称 Parameter		单位 Unit	Y32-63	Y32-100	Y32-200	Y32-315C	Y32-315	Y32-500	Y32-630	Y32-800	Y32-1000	Y32-1250	Y32-1600	Y32-2000
公称力 Rated force		KN	630	1000	2000	3150	3150	5000	6300	8000	10000	12500	16000	20000
顶出力 Knock out force		KN	190	190	280	400	400	1000	1000	1000	1600	1600	2000	3200
回程力 Return force		KN	120	165	240	600	600	900	850	1000	1300	1600	2000	3200
滑块行程 Ram stroke		mm	500	600	700	800	800	900	900	900	1000	1200	1200	1300
顶出行程 Knock out stroke		mm	200	200	200	300	300	350	350	350	400	400	400	500
开口高度 Opening height		mm	800	800	1120	1250	1250	1500	1500	1800	1800	1800	1800	1800
滑块行程速度 Ram speed	空程 Life Stroke	mm/s	100	120	120	100	90	100	100	120	110	120	120	130
	工作 Work	mm/s	8-16	7-15	5-12	5-12	5-12	7-15	5-12	5-12	5-12	5-12	4-9	4-9
	回程 Back Stroke	mm/s	85	90	95	70	70	80	85	95	85	85	95	85
顶出速度 Ejecting Speed	上行 Upward	mm/s	55	75	80	55	55	75	75	75	75	75	70	60
	退回 Back	mm/s	90	95	95	90	90	95	95	105	90	105	95	90
工作台尺寸 Baker Surface Size	左右 L-R	mm	580	690	1000	1260	900	1400	1600	2200	2500	2500	2800	3200
	前后 F-R	mm	500	630	940	1160	900	1400	1600	1600	1800	1800	2000	2200
机器外形尺寸 Overall Dimension	左右 L-R	mm	2500	2500	2650	3500	3150	3900	4510	4800	5100	5400	5600	4500
	前后 F-B	mm	1430	1430	1350	1500	1500	2150	2250	2400	2400	2500	2600	3200
	地面以上 Above Ground	mm	3220	3250	3800	4640	4500	5200	5400	5700	6000	6100	6200	7200
电机功率 Motor power		KW	5.5	7.5	15	22	22	2X22	2X22	2X30	2X45	2X45	3X37	3X45

由于产品在不断的改进中, 如出现样本技术参数与产品实际数据有不一致处, 应遵照双方的技术协议参数, 不再另行通知。  
Description and specification given in this catalogue are subject to modification without notice.



卧式四柱液压机 Horizontal four column hydraulic press



下顶式四柱液压机 Lower top four column hydraulic press

### Y27系列四柱式单动薄板冲压液压机

Y27 series four column single action sheet tension (press) hydraulic press



#### 性能特点:

- 计算机优化结构设计, 四柱式结构, 简单、经济、实用; 框架式结构, 四角八面导轨, 导向精度高, 抗偏载能力强, 精度保持性好, 并采用集中润滑。
- 液压控制采用插装阀集成系统, 动作可靠, 使用寿命长, 液压冲击小, 减少了连接管路与泄露点, 液压集成系统采用独立控制单元。
- 独立的电气控制系统, 工作可靠, 动作直观, 维修方便。
- 采用按钮集中控制, 具有调整、手动和平自动三种操作方式。
- 通过操作面板选择, 可实现定程、定压两种成型工艺, 并具有保压延时等功能。
- 滑块的工作压力, 空载快速下行和慢速工进的行程范围均可根据工艺需要进行调整。

#### Performance characteristics:

- Computer optimized structural design, four column structure, simple, economical and practical, frame type structure, four angle and eight sides guide rail, high steering accuracy, strong anti deviation capacity, good precision retention; and centralized lubrication.
- The hydraulic control adopts the integrated system of cartridge valves. The operation is reliable, the service life is long, the hydraulic shock is small, the connection pipe and the dew point are reduced, and the hydraulic integration system adopts the independent control unit.
- Independent electrical control system, reliable operation, intuitive operation, convenient maintenance.
- It adopts button centralized control, which has three modes of operation: adjustment, manual and semi-automatic.
- Through the operation panel selection, it can realize two kinds of forming processes of fixed range and constant pressure, and have the functions of holding pressure and delaying time.
- The working pressure of the slider, the no-load fast down and the range of the slow speed shift can be adjusted according to the process requirements.

#### 适用领域:

适用于一般零件和较精密零件的拉伸、弯曲、成型、翻边等各种压制工艺, 还可用于切边、冲裁落料, 主要适用以下领域:  
汽车零部件: 车身覆盖件、制动片、油箱、底盘、桥壳、保险杠。  
家用电器: 洗衣机零件、电饭锅零件、电视机电零件、冰箱零件等。  
厨房用具: 洗洁槽、器具、不锈钢用具等其他各种容器。

#### Applicable field

The utility model is suitable for various pressing processes, such as stretching, bending, forming, flanging, etc. of general parts and precision parts, and can also be used for trimming, blanking and blanking, and is mainly applicable to the following fields:  
Auto parts: body panels, brake pads, oil pans, chassis, axle housing, bumper.  
Household appliances: washing machine parts, rice cooker parts, TV parts, refrigerator parts, etc.  
Kitchen utensils: sink, kettle, stainless steel utensils and other containers.

#### 选配附件:

- 冲裁缓冲装置 • 模具保护装置 • 冲裁缓冲装置 • 滑块锁紧机构
- 位移传感器装置 • 打料装置 • 位移传感器装置 • 移动式推广模块油压机
- 油加热或冷却装置 • 数控、伺服系统 • 油加热或冷却装置 • 微动时模装置

#### Optional accessories:

- Blanking buffer
- Displacement sensing device
- Oil heating or cooling device
- Die protection device
- Charging device
- Numerical control and servo system
- Sliding locking mechanism
- Floating guide for changing die of mobile workbench plant
- Micro punch die set

## Y27K系列框架式单动薄板冲压液压机

Y27K series four column single action sheet tension (press) hydraulic press



### 产品选型优势:

- 精准: 采用数控电脑系统, 电子尺, 配以高精度导向, 有效保证冲件高精度。
- 高效: 采用 ATOS 电液比例控制技术 & 关键进口元器件, 确保压机高速、高压, 运行平稳冲击小。人机智能界面可储存 70 套模具成型参数, 大大降低调整时间及冲压试件废品率。
- 节能: 采用真空充液快速增压技术, 在主缸或底缸 (液压垫) 顶出过程中利用内置快速泄缸启动运行, 速度可在一定范围内任意调整, 而大腔在真空负压状态下自动吸入油箱内大气压强下的数倍于泵流量的油液, 因而在空程快速运行过程中, 油泵电机是很少做功的, 只是在慢速加压时才输出最大功率, 所以在一个工作周期中有效节能 30% ~ 50%。
- 环保: 采用进口密封件, 确保油缸零泄露; 天联缓冲减振机理, 确保机身低噪音。
- 省力: 采用高频响数字缓冲器, 缓冲力常态为零, 冲裁断裂瞬间到最大值, 该过程由电脑动态跟踪反馈控制, 确保主缸最大压力在冲裁缓冲过程中不被抵消掉, 因而冲裁过程中可有效省力 30% 以上。
- 安全: 人机工程设计, 配置安全光幕保护。
- 便捷: 整机工业设计, 并做有限元分析, 结构紧凑, 便于柔性生产线转运安装。(该 Y27K 系列采用最新的技术和理念, 将人机界面、PLC 和比例技术相结合, 性价比高)

### Performance characteristics:

- Accurate: the use of CNC computer systems, electronic ruler, with high-precision orientation, effectively ensure high precision stamping parts.
- High efficiency: adopt ATOS electro-hydraulic proportional control technology and imported components of Guan Jian to ensure high speed, high pressure, smooth operation and small impact. The man-machine interface can store 70 sets of mold forming parameters, greatly reduce the adjustment time and the reject rate of the stamping parts.
- Energy saving: the vacuum liquid filling fast charging technology, in the master cylinder or the bottom cylinder (hydraulic cushion) ejection process by using the built-in quick cylinder starting operation, speed can be adjusted within a certain range, and the oil cavity in the vacuum state of automatic suction tank under atmospheric pressure several times to pump flow therefore, in the process of rapid air during operation, the pump motor is rarely work, only in the press when the maximum power output. Therefore, in a working cycle, effective energy saving 30% - 50%.
- Environmental protection: imported seals are used to ensure the zero leakage of the oil tank.
- The mechanism of combined cushioning and vibration reduction ensures that the body is low noise.
- Energy saving: by high frequency digital buffer, the buffer capacity of the norm is zero, the maximum blanking rupture moment, this process by computer dynamic negative feedback control, to ensure that the master cylinder maximum pressure will not be offset in the buffer blanking process, thus the blanking process can be effective saving more than 30%.
- Safety: ergonomic design, configuration of safety protection.
- Convenient: complete industrial design, and do finite element analysis, compact structure, easy to flexible production line transshipment installation. (the Y27K series incorporates the latest technologies and concepts that combine human-machine interface, PLC and proportional technology to achieve high performance price ratio)

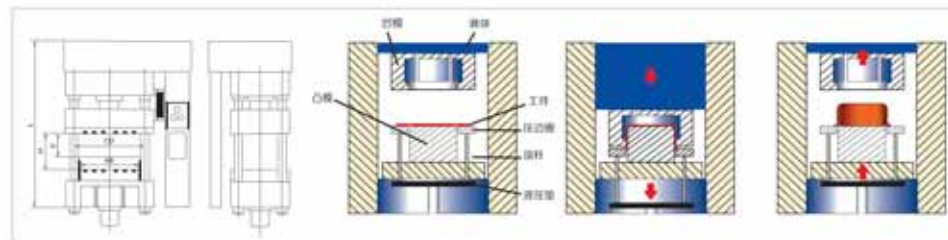
## Y27 系列单动薄板冲压液压机技术参数

Y27 Technical parameters of series single action sheet stamping press

参数名称 Parameter	单位 Unit	200	315	400	400A	500	500A	630	630A	800	800A	1000	1250	1600	2000	
公称力 Rated force	KN	2000	3150	4000	4000	5000	5000	6300	6300	8000	8000	10000	12500	16000	20000	
回程力 Return force	KN	480	600	500	570	900	1000	900	900	1000	1000	1350	2000	2700	2700	
滑块行程 Ram stroke	mm	700	800	800	800	900	1000	900	1200	1000	1300	1000	1300	1500	1600	
开口高度 Opening high	mm	1120	1200	1200	1200	1400	1400	1500	1600	1800	1800	1800	1800	2000	2000	
液压垫公称力 Cushion force	KN	400	630	1000	1000	2000	2000	2000	2000	2500	2500	4000	4000	5000	5000	
液压垫行程 Cushion stroke	mm	250	300	300	300	350	350	350	400	400	400	400	400	500	500	
滑块速度 Ejecting Speed	空程 Lidle Stroke	mm/s	100	120	180	180	150	170	150	160	150	200	160	150	120	130
	工作 Work	mm/s	6-10	6-10	9-20	9-20	10-22	10-22	8-19	8-19	8-18	8-18	8-19	7-15	6-13	7-15
	回程 Back Stroke	mm/s	60	60	160	130	120	130	130	130	140	140	140	90	70	110
液压垫速度 Cushion speed	上行 Upward	mm/s	60	60	60	60	55	55	45	60	45	45	45	39	45	
	退回 Back	mm/s	120	120	160	160	140	170	95	120	95	90	90	95	80	90
工作台面 有效尺寸 Table size	左右 L-R	mm	1000	1260	1750	2000	2200	3000	2500	3500	2200	3500	2500	3500	4000	4600
	前后 F-B	mm	900	1120	1250	1500	1600	2000	1800	2000	1600	2000	1800	2000	2600	2600
液压垫尺寸 Cushion size	左右 L-R	mm	600	650	1200	1420	1570	2320	1920	2800	1570	2800	2020	2800	3220	3820
	前后 F-B	mm	600	650	800	1120	1120	1420	1270	1420	1120	1420	1270	1420	2020	2020
外形尺寸 Over all dimensions	左右 L-R	mm	3280	3900	4250	4500	4700	5600	5100	4700	4900	4000	5500	5600	6200	
	前后 F-B	mm	1400	1800	2750	3000	3100	3500	3400	3600	3300	3700	3500	3800	4000	4200
	地面以上 Above Ground	mm	3900	5200	5350	5600	5800	6200	6200	7200	6700	6800	7300	8000	8000	8600
主电机功率 Motor power	KW	15	22	44	44	60	60	74	74	90	90	110	110	165	225	

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### 结构及运作示意图 Structure and operation schematic diagram



## Y28 系列双动薄板拉伸液压机

Y28 series double acting plate stretching hydraulic press



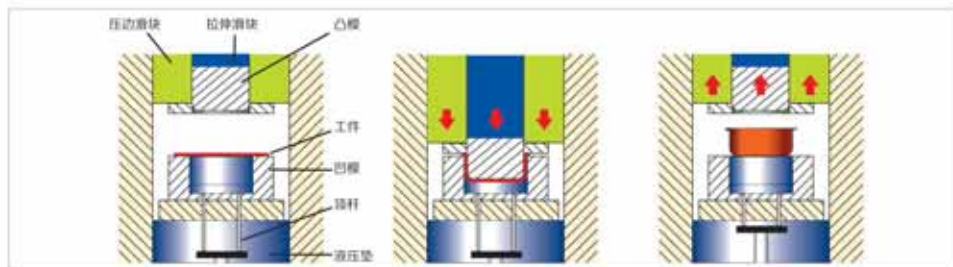
### 性能特点:

- 本系列液压机完全适用于金属薄板制品的拉伸成型工艺，并可完成翻边、弯曲等动作。
- 本系列液压机机身结构有四梁四柱式(Y28型)与框架双滑块式(Y28K型)两种，两只滑块可分别单独动作，亦可合并一起动作，使机器不仅适用于薄板制品的拉伸成型工艺，还满足其他产品的压制成型要求。
- 机器具有独立的液压与电气控制系统，采用按钮集中控制，可实现定压和定程两种工艺，具有调整、手动及半自动三种操作方式，其压力和行程可在规定范围内进行调整。

### Performance characteristics:

- This series of hydraulic press is fully applicable to the stretching forming process of sheet metal products, and can complete the flanging, bending and other operations.
- This series of press machine has four four beam (Y28 type) and the framework of double block type (Y28K type) two, two blocks can be separately or together with action, action, make the machine stretch forming process is not only suitable for sheet products, but also to meet the requirements of other compression molding products.
- The machine with independent hydraulic and electric control system, centralized control buttons, can realize the constant pressure and constant process of two kinds of process, with adjustment of free types of manual and semi-automatic mode of operation, the pressure and stroke can be adjusted within a predetermined range.

### 运作示意图 Operation schematic diagram



## Y28 系列双动薄板拉伸液压机技术参数

Y28 Technical parameters of series double action plate stretch hydraulic press

参数名称 Parameter	单位 Unit	100/160	160/250	200/315	400/630	500/800	630/1000	1000/1500	
公称力 Rated force	KN	1600	2500	3150	6300	8000	10000	15000	
拉伸滑块拉伸力 Drawing force	KN	1000	1600	2000	4000	5000	6300	10000	
压边滑块压边力 Blank holder force	KN	125X4	225X4	285X4	630X4	800X4	1000X4	1500X4	
顶出缸顶出力 Ejection force	KN	200	300	400	630	1000	1250	2000	
拉伸滑块回程力 Return force for drawing	KN	165	210	240	500	900	850	1000	
压边滑块回程力 Blank holding slide return	KN	200X4	41X4	60X4	134X4	150X4	240X4	300X4	
液体最大工作压力 Max pressure of liquid	Mpa	25	25	25	25	25	25	25	
压边滑块中心孔尺寸 Central hole size of blank	mm	φ350	φ450	φ550	800X800	1400X800	1600X1000	2000X1000	
拉伸滑块最大开口高度 Max opening height of	mm	900	1100	1250	1500	1600	1800	2000	
压边滑块最大开口高度 Max opening height of blank	mm	650	800	900	1050	1100	1250	1400	
拉伸滑块最大行程 Max stroke of drawing slide	mm	500	560	710	800	800	900	1000	
压边滑块最大行程 Max stroke of blank holding slide	mm	500	560	710	800	800	900	1000	
顶缸行程 Ejection cylinder slide	mm	200	200	250	350	350	400	400	
拉伸滑块有效尺寸 Effective size of	左右 L-R	mm	800	1120	1200	1600	2200	2500	3000
	前后 F-B	mm	800	1000	1200	1600	1600	1800	1800
压边滑块有效尺寸 Effective size of blank	左右 L-R	mm	800	1120	1200	1600	2200	2500	3000
	前后 F-B	mm	800	1000	1200	1600	1600	1800	2000
	空程下行 Upstroke	mm/s	80	100	120	120	130	150	160
拉伸滑块速度 Drawing slide speed	工作 Pressing	mm/s	8-20	8-20	8-20	5-12	7-15	7-15	6-11
	回程 Return	mm/s	120	140	150	85	80	105	130
	空程下行 Upstroke	mm/s	70	80	90	100	110	130	130
压边滑块速度 Blank holding slide speed	工作 Pressing	mm/s	16-40	15-35	15-35	8-20	9-23	9-23	8-15
	回程 Return	mm/s	170	170	135	90	120	95	100
	工作台面有效尺寸 Table size	左右 L-R	mm	800	1120	1200	1600	2200	2500
机器外形尺寸 Over all dimensions of the machine	前后 F-B	mm	800	1000	1200	1600	1600	1800	2500
	左右 L-R	mm	2700	3200	3600	4100	4800	5300	6000
	地面上高度 Height above floor	mm	1400	1500	1700	1800	2000	2200	2500
主电机功率 Total motor power	kw	5.5+5.5	7.5+7.5+3	15+7.5+4	15+15+4	22+22+7.5	30+30+7.5	150	

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## Y41 系列单柱液压机

Y41 series single column hydraulic press



### 性能特点:

- 本系列为单柱校正压装液压机,用途十分广泛。适用于轴类零件和型材的校正、轴套件的压装,板件的弯曲、压印、拉伸以及塑料、粉末制品的压制等工艺。
- 本机采用计算机优化结构设计,C型单臂式机身结构,整机采用钢板焊接,并经炉回火处理,韧性好,结构简单,操作方便。
- 液压控制系统采用二通插装阀集成系统,动作可靠,使用寿命长。液压冲击小,并减少连接管路泄露点。
- 独立的电气控制系统,工作可靠,动作直观,维修方便,采用按钮集中控制,具有调整、手动、半自动(半自动可分为定程和定压两种工艺)三种操作方式。
- 滑块的工作压力、空载快速下行和慢速工进的行程范围均可根据工艺需要调整。

### 可选配:

- 校正工作台、光电保护、冷却装置、PLC、悬臂吊装置。

### Performance characteristics.

- This series is a hydraulic machine, it is widely used, suitable for shaft parts and profile correction, shaft sleeve pressing, plate bending, stamping, stretching and pressing of plastic and powder products process.
- This machine adopts the computer optimized structure design, C type single arm type frame structure, the whole machine uses the steel plate welding, and after the hearth tempering processing, the steel quality is good, the structure is simple, the operation is convenient.
- The hydraulic control system adopts the two-way cartridge valve integrated system, which has reliable operation, long service life, little hydraulic shock, and less connection pipe leakage point.
- Independent electrical control system, reliable, intuitive operation, convenient maintenance, centralized control buttons, adjustment, manual and semi-automatic (semi-automatic which can be divided into two kinds of process and constant pressure process) three kinds of mode of operation.
- The working pressure of the slider, the no-load fast down and the range of the slow speed still can be adjusted according to the process requirements.

### Optional.

- calibration bench, photoelectric protection, cooling device, PLC, cantilever hanging device.

## Y41 系列单柱液压机技术参数

Y41 Technical parameters of series single column hydraulic press:

参数名称 Parameter	单位 Unit	Y41-25	Y41-40	Y41-63	Y41-100	Y41-160	Y41-200	Y41-315	Y41-400	Y41-500	Y41-800	Y41-1000
公称力 Rated force	KN	250	400	630	1000	1600	2000	3150	4000	5000	8000	10000
液体最大工作压力 Max pressure of liquid	MPa	12.5	25	25	25	25	25	25	25	25	25	25
滑块行程 Ram stroke	mm	400	400	500	500	500	600	800	800	900	900	1250
喉深 Throat depth	mm	320	320	320	350	360	360	1300	1300	1300	1500	1800
开口高度 Daylight	mm	600	600	800	900	900	900	1500	1500	1500	1800	3200
滑块速度 Ram speed	空程下行 Idle stroke	mm/s	60	50	60	80	60	70	80	80	80	100
	工作 Pressing	mm/s	10-15	10-15	10-15	8-14	8-15	8-15	8-15	6-12	7-15	8-14
	回程 Return	mm/s	120	110	120	70	120	120	80	70	80	70
工作台面积 有效尺寸 Table size	左右 L-R	mm	510	600	710	700	800	900	2000	2500	2500	2800
	前后 F-B	mm	500	500	600	600	630	700	2000	1250	1400	2000
工作台距地面高度 Operation Height	mm	700	650	750	700	700	800	500	500	500	600	500
主电机功率 Motor power	Kw	3	5.5	5.5	11	15	15	30	30	37	60	90
外形尺寸 Over all dimensions	左右 L-R	mm	860	950	1100	1100	1200	1300	2000	2500	2500	3000
	前后 F-B	mm	1500	1550	1550	1600	1700	1750	4500	4200	4750	5700
	地面上高度 Height above floor	mm	2950	3150	3350	3500	3650	3750	5000	5200	5750	7000

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## Y61 系列挤压成型液压机

Y61 Series extrusion forming hydraulic press



### 性能特点:

- 计算机优化结构设计, 四柱式结构简单、经济、实用; 三梁四柱结构, 短行程的上梁和主缸(侧缸)合为一体, 使工作台面可以尽量小, 立柱与滑块采用耐磨树脂、航空复合衬套 SF2 导向, 配合间隙小, 导向长, 增加机器的抗偏载能力, 活塞杆和立柱表面镀铬、镀硬铬, 耐磨性好。
- 计算机优化结构设计, 整体框架式结构, 工作台面小, 机身强度高, 具有很好经济实用性, 机身导向方式采用四角八面导轨导向, 导向精度高, 精度保持性强, 特别适用于轴类零件、齿形类零件的精密挤压成型。
- 液压控制系统采用插装式集成系统, 动作可靠, 使用寿命长, 液压冲击小, 减少了连接管路与泄漏点。
- 采用 PLC 控制的电气系统, 结构紧凑, 工作灵敏可靠, 柔性好;
- 具有调整、双手单次循环等操作方式。
- 通过操作面板选择, 可实现定程、定压两种成型工艺。
- 采用进口液压元件及电器元件, 经久耐用, 保证机器运行稳定。

### 适用范围:

- 主要适用金属材料的冷锻、温锻及挤压成型, 以及压印、浅拉伸、落料等用途。
- 如汽车、摩托车、自行车配件、手机外壳、LED 散热器、表壳、五金工具、钟表、电子电器、眼镜、首饰、工艺品等。

### Performance characteristics:

- Computer optimized structure design, four column type structure is simple, economical and practical; three beam four column structure, short stroke beam and the master cylinder (cylinder) as a whole, the work table can be as small as possible, the column and the block with a wear-resistant resin, aviation composite bushing SF2 oriented, with small gap, guide long, increase resistance the partial load capacity of the machine, the piston rod and the column surface of the high, hard chromium plating, wear resistance.
- Computer optimized structure design, framed structure, small work table, the body of high strength, good economy and practicality; body oriented way with four horns and eight sides of guide rail, high guiding precision, accuracy remains strong. The utility model is especially suitable for the precise extrusion forming of the shaft parts and the tooth shaped parts.
- Hydraulic control system uses plug-in integrated system, reliable operation, long service life, low hydraulic impact, reducing the connection pipe and leakage point.
- The electric system controlled by PLC has the advantages of compact structure, sensitive and reliable operation and good flexibility.
- With adjustment, hands, single cycle and other modes of operation.
- Through the operation panel selection, it can realize two kinds of forming processes of fixed range and constant pressure.
- Adopt imported hydraulic components and electrical components, durable, ensure the stable operation of the machine.

### Scope of application:

- Mainly applicable to cold forging of metal materials, warm forging and extrusion forming, and stamping, Asakura Hebs, blanking and other purposes.
- Such as automobile, motorcycle, bicycle fittings, mobile phone shell, LED radiator, watch-case, hardware tool, watch and clock, electronic appliance, glasses, jewelry, handicraft, etc.

## Y61 系列挤压成型液压机产品展示

Y61 series extrusion forming hydraulic press product display



## Y61 系列挤压成型液压机技术参数

Y61 Series of extrusion forming hydraulic press technical parameters

参数名称 Parameter	单位 Unit	Y61-200	Y61-315	Y61-500	Y61-800	Y61-1000	Y61-1500	Y61-2000	
公称压力 Nominal pressure	KN	2000	3150	5000	8000	10000	15000	20000	
液压系统最大工作压力 Maximum operating pressure of hydraulic system	Mpa	25	25	25.5	25	26	25	25	
主缸回程力 Return force of main cylinder	KN	200	200	300	450	500	1650	2100	
主缸最大行程 Maximum stroke of master cylinder	mm	200	250	250	300	300	300	350	
活动横梁到工作台最大距离 Maximum distance from moving beam to worktable	mm	700	800	800	800	900	1000	1100	
主缸快速下降速度 Quick down speed of master cylinder	mm/s	150	150	180	180	180	160	150	
主缸加压下降速度 Main cylinder pressure drop speed	mm/s	5-10	5-12	5-12	7-13	5-10	5-9	5-8	
主缸快速回程速度 Quick return speed of master cylinder	mm/s	55-90	55-90	70-115	70-115	90-105	90-105	90-105	
送料缸公称压力 Nominal pressure of return cylinder	KN	300	300	300	30	600	600	600	
送料缸最大行程 Maximum stroke of return cylinder	MM	200	200	200	220	250	250	250	
工作台有效面积 Effective area of table	左右 L-R	mm	600	700	800	950	900	1200	1300
	前后 F-B	mm	600	700	800	950	1000	1200	1300
电机功率 Motor power	KW	7.5X2	11X2	15X2	18.5X2	22X2	37X2	45X2	

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## Y34KS 伺服液压机

Y34KS Servo hydraulic press



### 性能特点:

- 全新一代伺服液压机,采用伺服电机-泵系统代替传统液压电气系统。
- 节能环保:伺服控制系统凭借软件的软处理实现平滑快速动作,减小震动;工作按需供油,节能效果显著,也降低了因油液溢流而产生的油温、噪音小,节省电能 30-60%,节约液压油 50%,平均降低噪音 10dB 以上。
- 安全精密:每台机器均安装红外线安全光栅,有效保护操作人员,采用伺服闭环控制系统,通过对速度、压力、位移的精确控制,实现高精度压制,伺服智能控制,确保机器重复定位精度可达  $\pm 0.05\text{mm}$ ,压力误差  $\pm 1\%$ 。
- 故障率低:伺服智能专利控制系统,不但不无功,油温不易升高,且油路系统内无负压,较大降低了故障,延长液压元件的使用寿命,电器设有故障自动报警及一键复位功能,整机按不同功能模式,设计成模块结构,拆装简便,一般故障可直接通过触摸屏查看,维修简单。
- 稳定高效:智能化控制,可操作性高:采用 PLC+伺服系统+触摸屏+电子尺的控制方式,速度、压力、位移可通过触摸屏数字化输入,根据模具及生产工艺的不同实现实时数字调节,耐震及抗侧压力强,整机稳定,精密耐用,适用于落料、成型、挤压等多种工艺用途。
- 全系列液压机都可以采用伺服电机-泵系统。

### Performance characteristics:

- Performance characteristics: a new generation of servo hydraulic machine, servo motor pump system instead of the traditional hydraulic and electrical systems.
- Energy saving: servo control system with soft processing software to achieve smooth steady and rapid action to reduce vibration; work according to the needs of oil supply, significant energy saving effect, but also reduce the oil temperature, oil overflow caused by the noise, saving electric energy saving hydraulic oil 30-60%, 50%, the average noise reduction over 10db.
- Safety precision: each machine are installed infrared safety protection grating, the operator effectively, adopt servo closed-loop control system, controlled by precise control of speed, pressure, displacement, high precision servo press, intelligent control, to ensure the machine repeat positioning accuracy of 0.05mm, the pressure error is  $\pm 1\%$ .
- Low failure rate: intelligent servo control system of patent, do not work hard, the oil temperature is not easy to rise, and no negative pressure oil system, greatly reduce the failure, getting the service life of hydraulic components, electrical appliances equipped with automatic fault alarm and a reset function. The whole machine is designed as a modular structure according to different function modes and is easy to assemble and disassemble. The general faults can be directly viewed by the touch screen, and the maintenance is simple.
- Stable and efficient, intelligent control, high maneuverability Adopt PLC+ servo system + touch screen + electronic ruler control mode, speed, pressure and displacement through the touch screen digital input, according to the mold and production process of different real-time digital control. Seismic and lateral pressure, the stability, precision and durable, suitable for blanking, forming, extrusion and other technology applications.
- A full range of hydraulic machines can be servo motor pump system.

## Y34KS 系列伺服液压机技术参数

Y34KS Technical parameters of Servo hydraulic press

参数名称 Parameter	单位 Unit	200	315	400	500	630	
公称力 Rated force	kN	2000	3150	4000	5000	6300	
回程力 Knock out force	kN	240	305	350	580	650	
顶出力 Return force	min-1	400	630	630	1000	1000	
滑块行程 Ram stroke	mm	500	600	600	700	700	
顶出行程 Knock out stroke	mm	150	200	200	250	250	
开口高度 Opening high	kw	850	1000	1000	1150	1150	
滑块速度 Ram speed	空程 Idle Stroke	kg	250	220	250	200	180
	工作 Work	mm	20	13	10	15	13
	回程 Back Stroke	mm/s	160	130	120	130	120
顶缸速度 Ejecting Speed	上行 Upward	mm/s	100	65	65	75	75
	退回 Back	mm/s	170	160	160	130	130
工作台尺寸 Buster Surface Size	左右 L/R	mm	1000	1260	1250	1400	1600
	前后 F/B	mm	940	1160	1250	1400	1600
机器外形尺寸 Overall Dimension	左右 L/R	mm	2000	3000	3450	3800	4100
	前后 F/B	mm	1800	2200	2300	2400	2500
	地面以上 Above Ground	mm	4500	5000	5200	5500	5800
电机功率 Motor power	kw	21.4	21.4	21.4	21.4×2	21.4×2	
机器总重量 Total machine weight	kg	8000	12000	16000	23500	28000	

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### 结构及运作示意图 Structure and operation schematic diagram

