



KW1

Cold & Semi-hot forging Knuckle presses

厚板冷溫間肘節板鍛沖床

300. 400. 500. 650. 800. 1000 ton



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台灣精品 2015
TAIWAN EXCELLENCE

3C產品(具引伸、大面積之加工件，如手提電腦外殼)五金類。

Ideal for producing metal covers, stamping and drawing for 3C products (ex. laptop case and hardware).

厚板之沖壓、彎曲、引伸成型加工，汽機車零件之厚板零件下料，如齒盤沖壓。

Good for thick steel plate stamping, bending, and drawing in motor vehicle component, (ex. gear stamping).

加大寬度的床面設計，適合搭配週邊送料裝置以達自動化生產。

Large bed dimensions combined with an integrated feed system are well-suited for automotive production.

兼具冷間及溫間鍛造製程之優點，配合連續加工設備，更有利於厚板加工與板材引伸之順送工程，提供更高附加價值之產品。

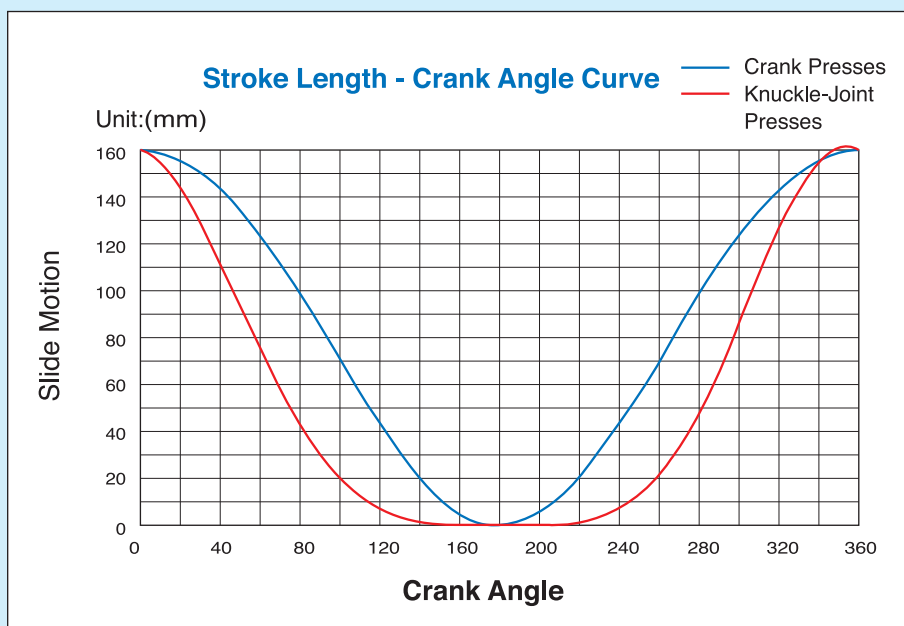
複合式濕式離合剎車器，在長時間使用下無需更換來令片，且無粉塵產生及低噪音特性，有助於提升工作環境品質。

Chin Fong's cold and semi-hot forging press, especially when coupled with feeder and transfer equipment, is effective and efficient in forging and drawing thick sheet material.

Wet clutch delivers high torque and performance at relatively low air pressure. Friction linings run in an enclosed oil bath, providing a very long lived clutch and brake with efficient heat dissipation, low vibration, minimal noise, reduced lining wear, and lower air consumption, even at high single-stroke rates of production.

主規格 Specifications

機型			KW1-300	KW1-400	KW1-500	KW1-650	KW1-800	KW1-1000
最大加壓能力 Capacity	Tons		300	400	500	650	800	1000
能力發生點 Rated Tonnage Point	mm		8	8	8	8	8	8
行程長 Stroke Length	mm		120	120	150	150	250	200(250)
行程數 Stroke Per Minute	SPM		20~40(20~45)	20~40(20~45)	20~40	20~40	20~35	20~40(20~35)
滑塊調整量 Slide Adjustment	mm		15	15	15	15	15	15
最大模高 Die Height	mm		450	450	450	450	650	650
台盤面積 Bolster Area (LR×FB)	mm		1100×950	1100×950	1250×1000	1500×1000	1500×1000	1600×1000
台盤厚度 Bolster Thickness	mm		180	180	220	220	250	250
滑塊面積 Slide Area (LR×FB)	mm		1100×850	1100×850	1250×1000	1500×1000	1500×1000	1600×1000
工作面高度 Working Height	mm		900	900	1185	1265	1300	564
側面開口 Side Opening	mm		600×570	600×570	600×570	600×570	600×770	600×770
最大上模重 Max. Upper Die Weight	kg		1000	1000	1500	1750	1750	1750
主電動機 Main Motor	HP×P		30×4	40×4	50×4	60×4	75×4	100×4



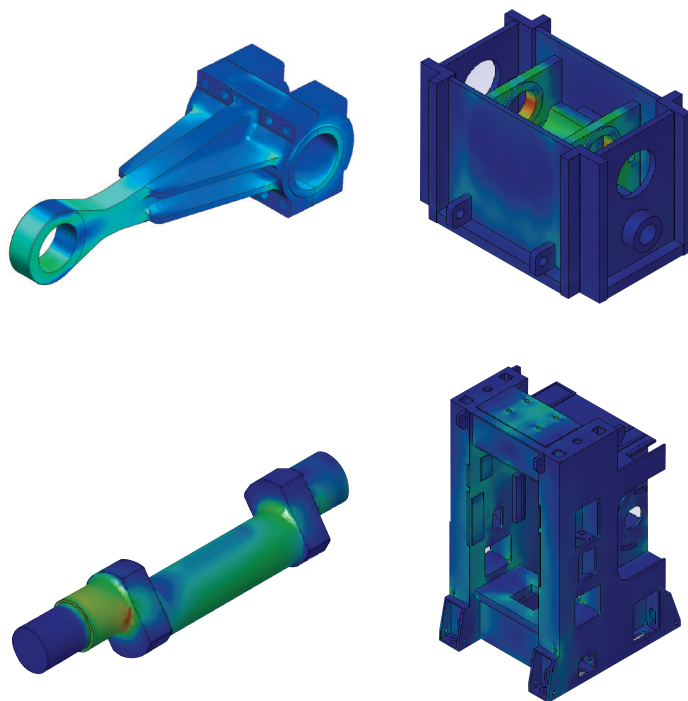
肘節式 連桿機構，下死點停留時間長，利於延長塑性成型時間，減少材料在成形加工時的回彈角。加工域速度低，特別適用於製品引伸、壓印、下料…等沖壓工程。

Knuckle-joint drive system creates a unique slide motion curve which extends the time for forming and also prevents “spring-back” of material. The slide motion creates low slide velocity through the work, allowing the material to flow and set better.

高剛性 台身設計，變形率小，可有效降低沖壓時產生的台身變形量。

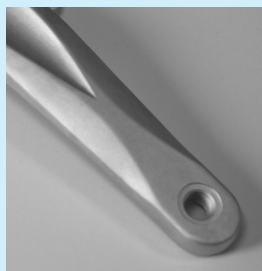
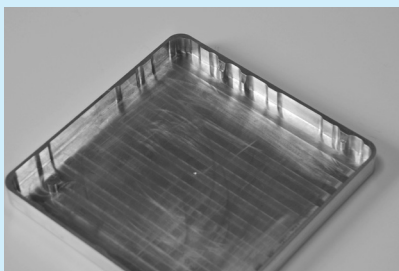
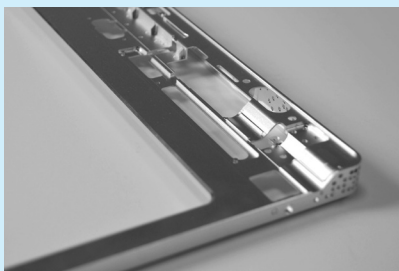
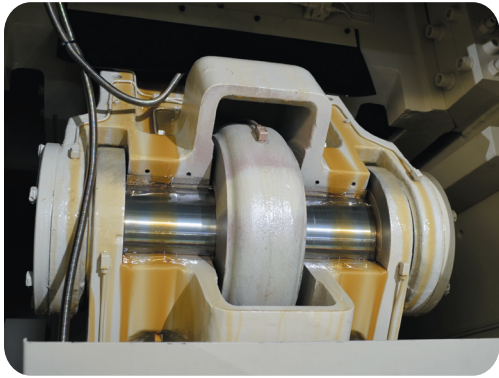
針對重要零組件進行FEM有限元素分析，如台身、曲軸、連桿、滑塊…等，可更精確的掌握每個重要部位的受力條件及變形，有助於實現最佳化設計。

High rigidity design lowers the deformation/deflection rate of less than FEM (Finite Element Method) is used in product design to provide quality and accuracy in all key components (ex. frame, crank, link, slide, etc.), and to ensure the integrity of the final product.

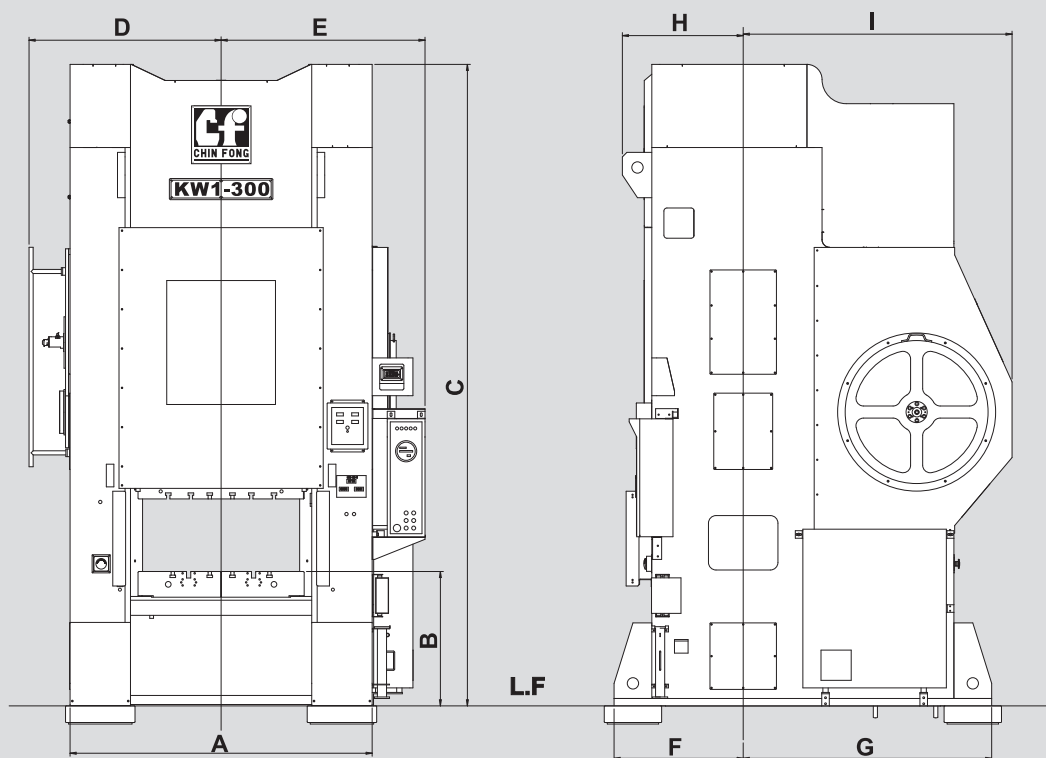


KW1-系列沖床可以進行鈹金的沖壓製程 (下料、引伸、彎曲及局部成形製程) 及冷間鍛造製程 (壓扁 / 鍛粗製程、擠伸、引縮、壓印成形製程) 複合工法，達到板材的近淨成型沖鍛複合加工。

KW1 series combine press forging (ex. Blanking, drawing, bending and partial forming) and cold forging (ex. upsetting, extrusion, ironing and coining) in order to achieve fine blanking, near-net-shaping and press forging for sheet material.



外觀尺寸



單位: mm

機種	KW1-300	KW1-400	KW1-500	KW1-650	KW1-800	KW1-1000
A	2000	2100	2200	2545	2725	3125
B	900	900	1185	1265	1300	1424
C	4245	4245	5342	5555	6050	6740
D	1275	1275	1375	1550	1640	1805
E	1350	1400	1450	1622	1715	2100
F	855	890	930	950	1050	1250
G	1645	1730	2020	2150	2390	3260
H	800	800	825	832	882	982
I	1780	1810	2095	2350	2420	2995

標準附屬配件

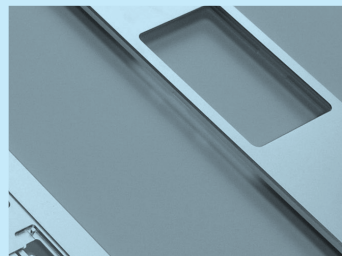
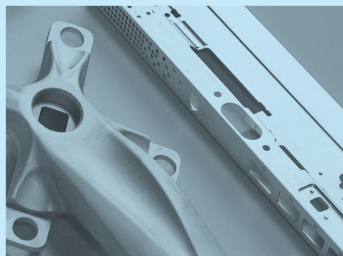
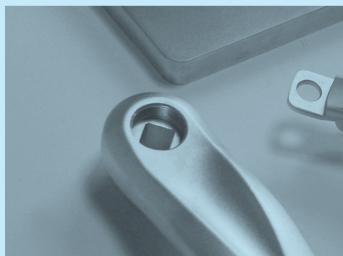
Standard Functions / Accessories

- 濕式離合剎車器
- 滑塊及模具平衡裝置
- 電動滑塊調整裝置 (附油壓鎖定)
- 二度落保護裝置
- 荷重檢測 (安全) 裝置
- 循環集中潤滑給油裝置
- 數字式模高指示器 (單位 : 0.1mm)
- 誤送檢知金屬插座
- T型操作台
- 安全梯
- 空氣吹料接頭 (3/8")
- 空氣源接頭 (3/8")
- PLC可程式控制器
 - 電子式凸輪開關 預備6連
 - 電子式角度指示器 / 行程數指示器
 - 電子式預調計數器 / 行程計數器 (6位數)
- 變頻器及主馬達逆轉裝置
- Wet Type Clutch & Brake
- Slide and Die Balance Device
- Motorized Slide Adjustment (Locking Device)
- Overrun Detector
- Load Monitor Device
- Centralized Re-circulation Lubrication Device
- Die Height Indicator (Unit : 0.1mm)
- Misfeed Detection Receptacle
- Portable 2-hand Pushbutton T-stand
- Safety Ladder
- Air Ejector (3/8")
- Air Source Receptacle (3/8")
- PLC Controller
 - Electronic Rotary Cam Switch (6 spare channels)
 - Electronic Crank Angle Display / Stroke No. Indicator
 - Electronic Preset Counter / Stroke counter (6 digits)
- Inverter & Main Motor Reversing Circuit Device

特殊附屬配件

Optional Functions / Accessories

- 飛輪剎車裝置
- 光電安全裝置
- 滑塊上部頂料裝置
- 電子式旋轉凸輪開關 (預備16連)
- 腳踏開關 (附切結書)
- 模具照明燈
- 後安全防護門
- 電源插座110V / 220V單相
(電源客戶自備)
- 防震裝置
- 基礎螺絲 & 基礎板
- 迴轉式操作盤
- 附檢知雙連電磁閥
- 快速換模裝置 (Q.D.C.S.)
- 自動送料裝置
- 沖床控制器MPC系列
- 上下部油壓模墊 (精密下料模具)
- Flywheel Brake Device
- Photoelectric Safety Device
- Upper Slide Knockout Device
- Electronic Rotary Cam Switch (16 spare channel)
- Foot Switch
- Die Area Light
- Rear Safety Guard
- Power Receptacle (Single phase, 110V / 220V
power source wiring by user)
- Anti-Vibration Press Mounts
- Foundation Anchor Bolts & Plates
- Swivel Type Operation Panel
- Dual-coiled Solenoid Valve with Detector
- Quick Die Change System
- Auto Feeding System
- Control System MPC Series
- Hydraulic Die Cushion for Upper & Lower Stampin
Die (Fine Blanking)



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