

F2

Series



Warm Hot Forging Presses

溫熱間鍛造沖床



700 ~ 3000. ton

F2 Series

Warm Hot Forging Presses
溫熱間鍛造沖床



高剛性
High rigidity

高精度
high precision



規格 SPECIFICATIONS

規格 內容 SPECIFICATIONS		型式 MODEL	F2-700	F2-1000		F2-1600		F2-2000	F2-2500	F2-3000	
1	最大加壓能力 Capacity	TONS	700	1000		1600		2000	2500	3000	
2	能力發生點 Rating Tonnage point	mm	4	4	5	5	6	5	5	7	
3	行程長 Stroke Length	mm	200	220	250	300		300	320	360	
4	行程數 Strokes Per Minute	連續 Continuous	SPM	100		85		80	75	70	70
		斷續 Intermittent	CPM	15		15		15	18	18	15
5	最大模高 Die Height	mm	680	760	1000	800	1055	840	890	960	
6	滑塊調整量 Slide Adjustment	mm	10	10		10		10	10	10	
7	滑塊面積 Slide plate area (LRxFB)	mm	720x800	820x850	1000x1200	980x980	1030x1350	1030x1060	1100x1150	1350x1170	
8	工作能量 Working energy	kg-m	4600	6500	8000	1300		16000	20000	25000	
9	台盤面積 Bolster Area (LRxFB)	mm	900x900	1000x1000	1200x1200	1250x1200	1350x1350	1250x1300	1250x1400	1500x1450	
10	台盤厚度 Bolster thickness	mm	115	130	140	160		180	210	260	
11	滑塊頂料能力(Slide) Slide Knockout Capacity	TONS	4	7		10		10	20	25	
12	滑塊頂料行程 Slide Knockout Stroke Length	mm	30	30		40		40	50	50	
13	台床頂料能力 Bed Knockout Capacity	TONS	20	20	30	30		30	50	60	
14	台床頂料行程 Bed Knockout Stroke Length	mm	50	50	100	60	100	60	60	60	
15	主電動機 Main Motor	定速 Fixed	HPxP	100x10	125x10	100x6	150x10	125x6	175x10	215x10	250x10
		變速 Variable	HPxp	125x8	150x8	125x8	175x8	150x8	—	—	—

1. 高剛性、高精度的構造

機身由鑄鋼及厚鋼板熔接，熔接構造其主要構件均經合理計算，分析分配構成，再由強力補強桿預力固鎖。高剛性機身構造，對製品精度的穩定構具、模座壽命之提升，有絕對貢獻。

2. 超強偏心荷重能力

本機採用雙驅動連桿設計方式，較連桿方式對偏心荷重承載能力大幅提升；同時，滑塊採強力箱型鑄鋼結構，加長型導路、導板使用高耐磨性材料組成，使本系列各機種偏心荷重能力在各工程範圍內可達到80% - 100%全負載。

3. 安全、快速反應的卡模解脫裝置

本機卡模解脫完全由電氣控制，操作簡便又快速，對模具提供安全、保護良好對策。

4. 耐久性、可靠度良好的操作

- (1) 滑塊導路採用硬質合鋼及高耐磨性之合鋼組成，可避免因溫升、集中負荷關係所產生高磨損。
- (2) 離合剎車採用嵌入式來令塊方式，並加大面積降低面壓，提升使用次數，同時來令塊維修更換容易。

5. 優良的操作性與維護性

- (1) 電動油壓式滑塊調整(可選擇自動、手動調整)可事先設定模高值，自動調整、補正及停止。
- (2) 可選擇性配備人機介面，連續監視系統(OK Monitor)，異常、故障因素可清楚顯示。
- (3) 採用強制循環潤滑方式，潤滑油可回收循環。

1. High rigidity, high precision structure

Structure frame is made of casting steel welded with thick steel plate. Major components of structure frame are designed based on detailed stress analysis and are locked tightly by strong tie rod. High rigidity of structure frame has significant contribution to the promotion of product precision stability and the life of die and die set.

2. Ultra strong eccentric loading capability

Design with twin con-rod drive has made the range of allowable eccentric loading much wider than conventional machines. In addition, the series products with slide structure made of box-type strong casting steel and with the lengthened guide gibs and guide plate made of high abrasive-resistance material can take eccentric load up to 80% - 100% of full load.

3. Safe and fast-response die stick release device

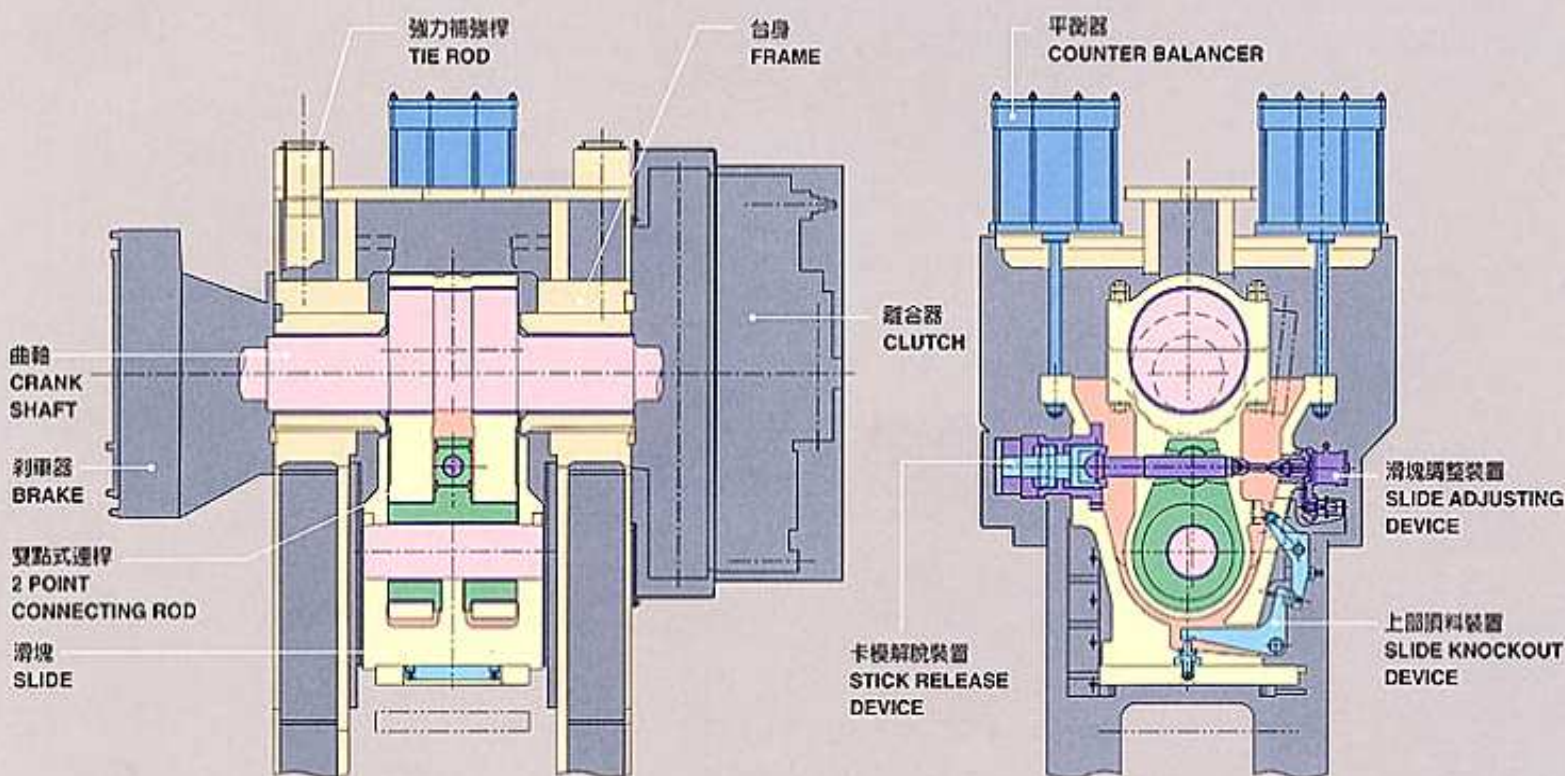
The electrically controlled die stick release device with simple, easy and fast operation provides secure and reliable protection for dies.

4. Durable and reliable operability

- (1) Slide gibs made of alloy steel and high abrasive-resistance bronze liner can withstand high abrasion due to temperature increase and concentrated loading.
- (2) Clutch/Brake is designed with insert-type lining for easy maintenance and replacement and also designed with larger disk area to reduce pressure to increase lining life.

5. Excellence in operability and maintainability

- (1) Electric-hydraulic type, position-adjustable slide (optional for manual or automatic operation): Die height, automatic adjustment, compensation, and stop mode are pre-settable.
- (2) Optional man-machine interface and OK monitor to display abnormal conditions, and the cause of malfunction.
- (3) The lubrication adopts forced circulating system permitting recovery and reuse of the oil.



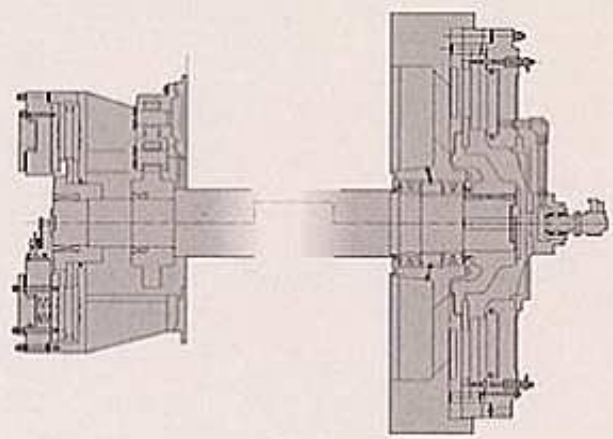


滑塊傳動連桿採用大直徑、兩點支撐，承受高偏心負荷。並採用專利之滑塊調整機構及頂料機構。
(專利號碼：新型137530號)

Connecting rod of slide is designed with larger diameter and with two-point Support to take high eccentric loading. Patented slide adjusting mechanism and material knock-out mechanism are adopted.
(Patent No:137530 New Type)

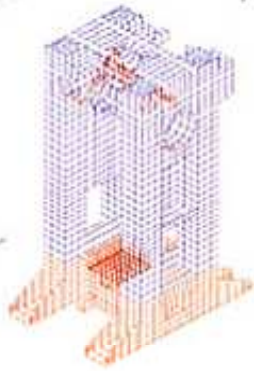
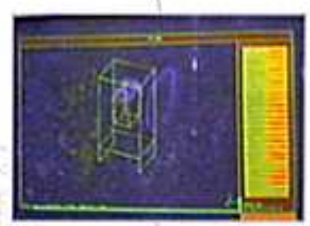
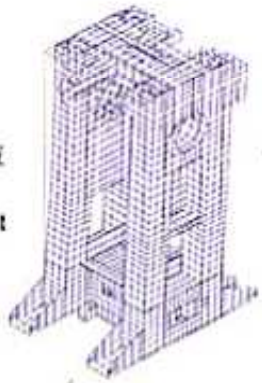
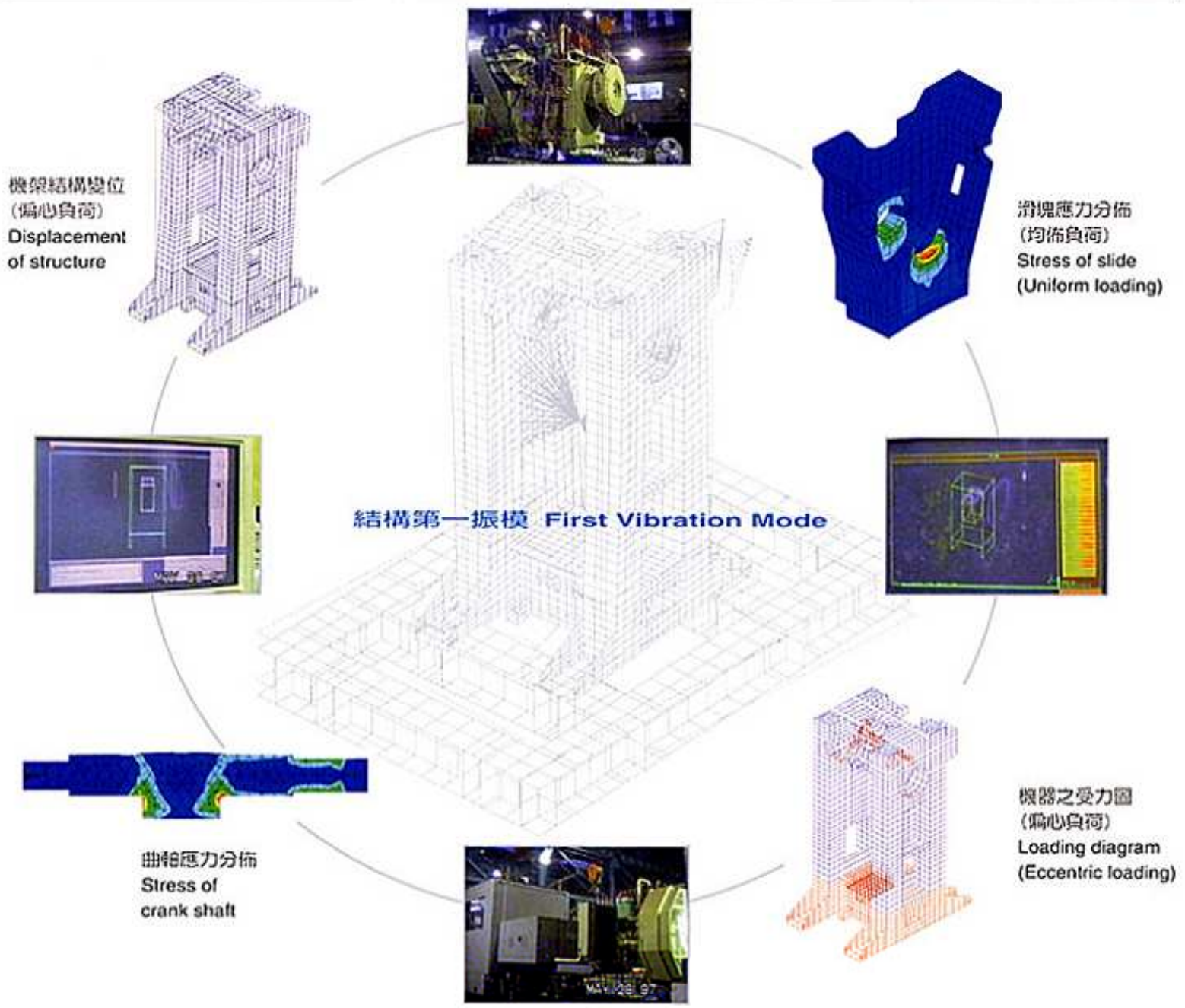
高傳動扭矩離合器 & 剎車器

High torque transmission clutch/brake



1. High performance, high efficiency clutch/brake has better brake stop angle and higher sensitivity than similar traditional presses used in normal operating conditions.
2. Low moment inertial, impact-durable, and high brake torque.
3. Clutch/brake lining made of non-asbestos material dissipates heat quickly and reduces hazard to both human body and environments.
4. Maintenance and replacement for Clutch/brake lining is easy and simple.

1. 高性能、高效率離合器&剎車器，在正常狀態下，剎車停止角度較傳統類型沖床，離合器剎車器靈敏度高。
2. 低慣性力矩，耐衝擊，高傳動剎車扭矩。
3. 使用來令塊，散熱速度快，並採用非石棉系材質，可減少對人體危害及環境污染。
4. 維修時來令塊更換簡便，容易。



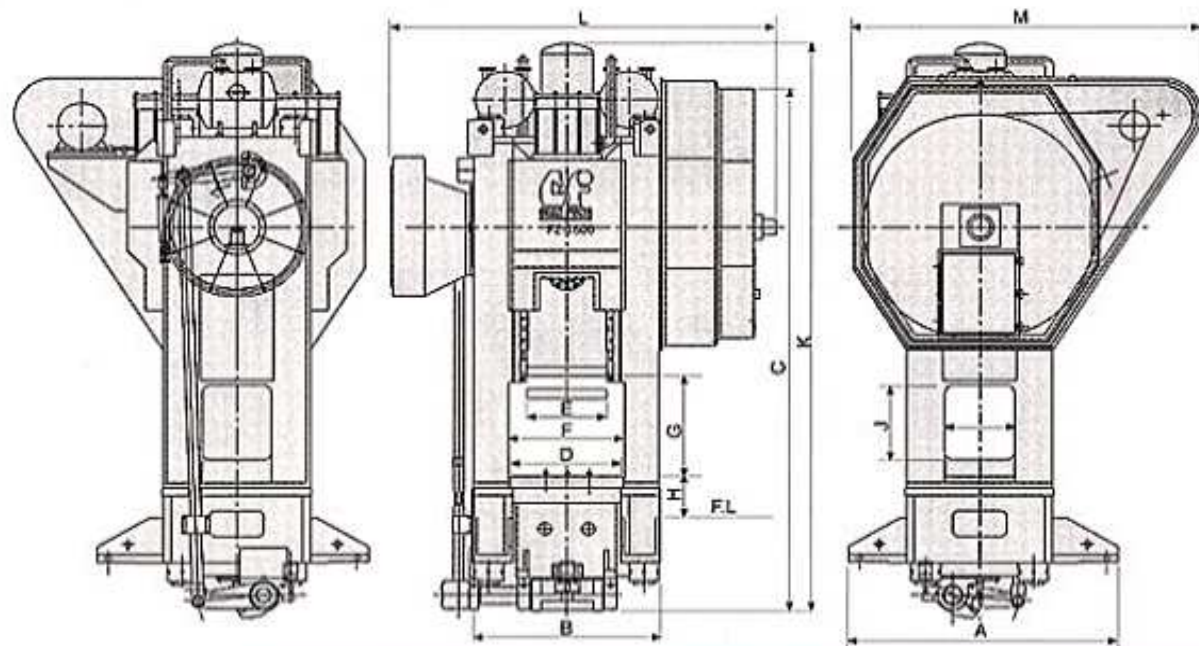
溫熱間鍛造沖床 Warm Hot Forging Presses

鍛造的名稱 Name of forgings	Connecting rod 連桿	Pin 銷	Ring gear 齒環	Con'rod cap 連桿上蓋	Taper roller bearing 滾錐軸承	Truck link 轉向連桿	Valve 凡而	Outer joint 存連接頭外環
最後的產品 Finished products								
材料的形狀 Shape of materials								
溫熱間鍛造沖床 Warm Hot Forging Presses	1	1	1	1	1	1	1	1
	2	2	2	2	2	2	2	2
	3	3	3	3	3	3	3	3
	4	4	4	4	4	4	4	4
	5	5	5	5	5	5	5	5
備註 Remarks	熱間鍛造 Hot forging	溫或熱間鍛造 Warm or Cold forging	熱間鍛造 Hot forging	熱間鍛造 Hot forging	熱間鍛造 Hot forging	熱間鍛造 Hot forging	熱間鍛造 Hot forging	溫熱鍛造 Warm forging

標準功能/配備 STANDARD FUNCTION/ ACCESSORIES 特殊功能/配備 OPTIONAL FUNCTION/ ACCESSORIES

- | | | | |
|---|--|--|---|
| <ul style="list-style-type: none"> • T型可移動式雙手操作台 • 立式操作面盤 • 電子式曲軸角度指示器 • 電子式運轉速度指示器 • 滑塊鎖鎖裝置 • 卡模解脫裝置 • 二度落檢知裝置 • 主馬達 • 油壓式滑塊調整 • 模高指示器(0.1mm) • 循環式潤滑裝置 • 手動黃油潤滑裝置 • 噴風裝置 • 空氣源接頭 • 誤送檢知迴路 • 電子式凸輪開關 • 電磁式計數器 | <ul style="list-style-type: none"> • Portable run button operation stand • Main operation Panel • Electronic Crank angle indicator • Electronic run speed indicator • Slide locking device • Stick release device • Overrun detector device • Main motor • Hydraulic motor type Slide adjusting device • Die height indicator • Recirculating oil lubrication device • Manually grease lubrication device • Air ejector • Air pipe receptacle for service tools • MisFeed detect circuit • Electronic rotary cam switch • Magnetic stroke counter | <ul style="list-style-type: none"> • VS馬達 • 變頻器 • 電動式黃油潤滑裝置 • 滑塊頂料裝置 • 底座頂料裝置 • 荷重顯示器 • 前安全柵 • 溫度檢知器 • 模具冷卻裝置 • NC三次元送料裝置 • 高週波加熱器 • 上夾模器 • 下夾模器 • 舉模器 • 移模臂 • 防震裝置 • 模具區域照明燈 • 換模台車 | <ul style="list-style-type: none"> • Variable speed motor • Invertor • Electric grease lubrication device • Slide knock-out device • Bed knock-out device • Load Monitor • Safety guard • Temperature detector • Dies Cooling device • NC Transfer unit • Induction Heater • Upper die clamper • Lower die clamper • Die lifter • Die arm • Antivibration Mount • Die room Light • Die change car |
|---|--|--|---|

外觀尺寸 OUTLINE DIMENSION



Model	A	B	C	D	E	F	G	H	I	J	K	L	M
F2-700	2500	1900	4650	900	720	1060	680	700	670	720	5450	3375	2430
F2-1000	3300	2200	7740	1000	820	1250	760	700	800	900	8460	5040	4000
F2-1600	3600	2400	7535	1250	980	1400	800	700	900	1000	8795	5250	4100
F2-2000	3830	2600	8150	1250	1030	1400	840	550	1050	1000	9320	5370	4310
F2-2500	3920	2860	8290	1250	1100	1450	890	550	1100	1000	9590	5740	4600
F2-3000	4200	3360	8480	1500	1350	1750	960	550	1150	1050	9740	5950	5000



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