



Zhanyu 展宇®

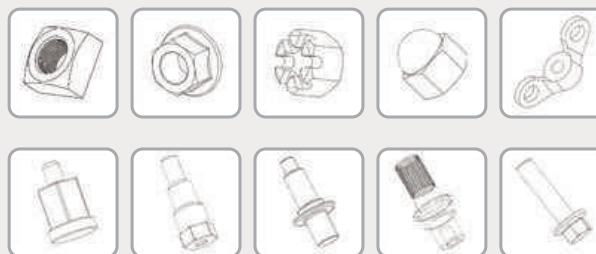
COLD FORMER

COLD FORMER

创新锻造，品质卓越，引领机械未来
INNOVATIVE FORGING, EXCELLENT QUALITY, LEADING
THE FUTURE OF MACHINERY

10B-17B 19B-27B 33B-60B

多工位螺母/螺栓/零件成型机



Product gallery 2024

温州博宇机械有限公司
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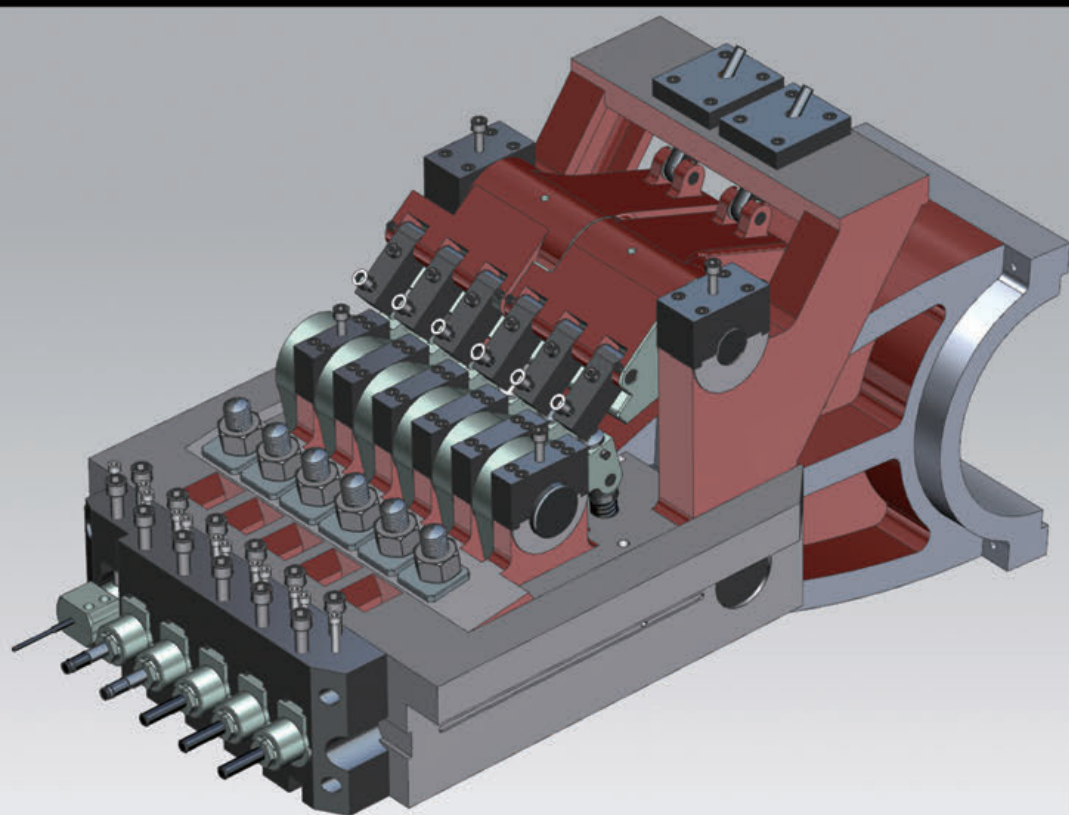
BOYU Cold Former

阳模设计的优越特性

滑块阳模设计实现冲头与工件同步满足加工各类异型件产品。
The design and implementation of the punch and workpiece slide mold meet processing all kinds of special items.

结构紧凑且设有“防破坏”保险机构。
It has a compact structure and has a "anti - damage" insurance agency.

螺母机机构装配便捷，顶出力强，便于调节。
The mechanism of nut machine is easy to assemble, with strong jacking force and easy adjustment.



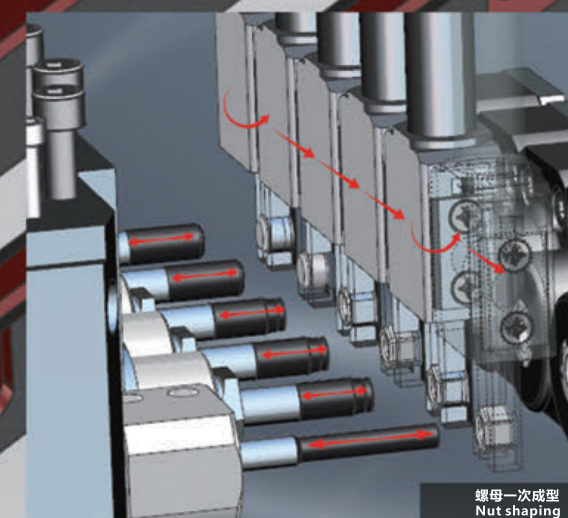
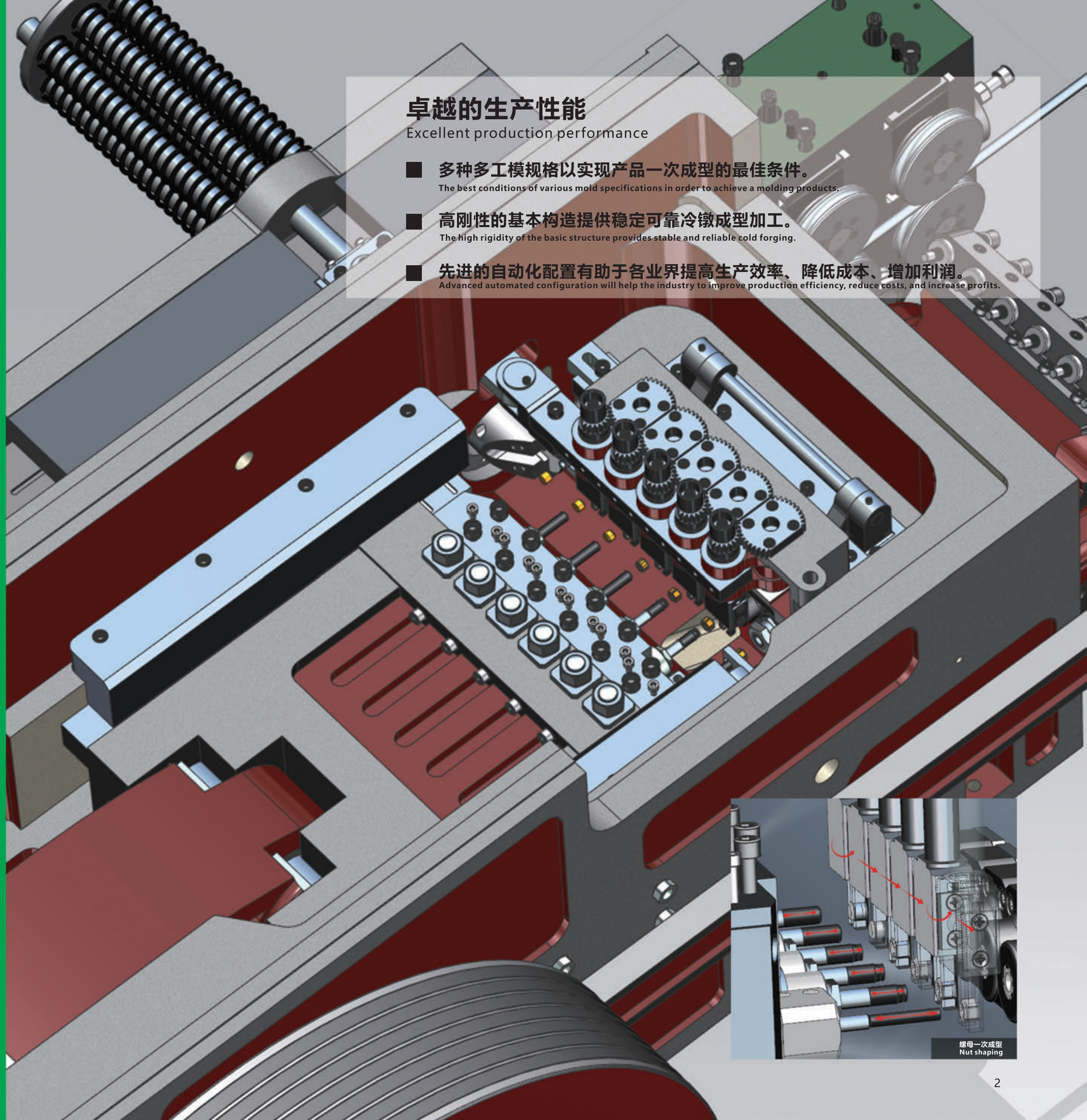
多工位螺母冷镦机是金属冷挤压成型机械中的一种高效率、全自动的专
业化机械设备，其本身优越冷镦机成型工艺和先进加工特性使得它能广泛应
用于国民经济各个领域，如：紧固件、五金件及异型非标件的加工生产。

Multi station nut cold heading machine is a kind of high efficiency and automatic specialty in
metal cold extrusion forming machineryChemical machinery and equipment, its own superior
cold heading machine forming technology and advanced processing characteristics make it can
be widely usedIt is used in various fields of national economy, such as fastener, hardware and
special-shaped non-standard parts.

卓越的生产性能

Excellent production performance

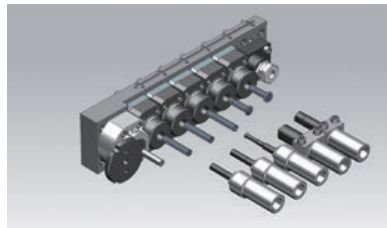
- 多种多工模规格以实现产品一次成型的最佳条件。
The best conditions of various mold specifications in order to achieve a molding products.
- 高刚性的基本构造提供稳定可靠冷镦成型加工。
The high rigidity of the basic structure provides stable and reliable cold forging.
- 先进的自动化配置有助于各业界提高生产效率、降低成本、增加利润。
Advanced automated configuration will help the industry to improve production efficiency, reduce costs, and increase profits.



螺母一次成型
Nut shaping

丰富的螺母冷镦机产品能够满足各种零件的需要

Abundant nut cold heading machine products can meet the needs of various parts



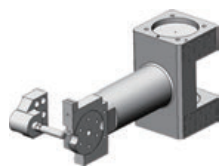
选装
Optional

单速、双速或伺服电机。
Single speed, double speed or servo motor.

选装
Optional

挡料装置，提高进料精度。

The feeding device improves the feeding precision.



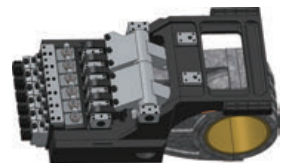
选装
Optional

变频器，在一定范围内无级调速。

Inverter, stepless speed regulation in a certain range.

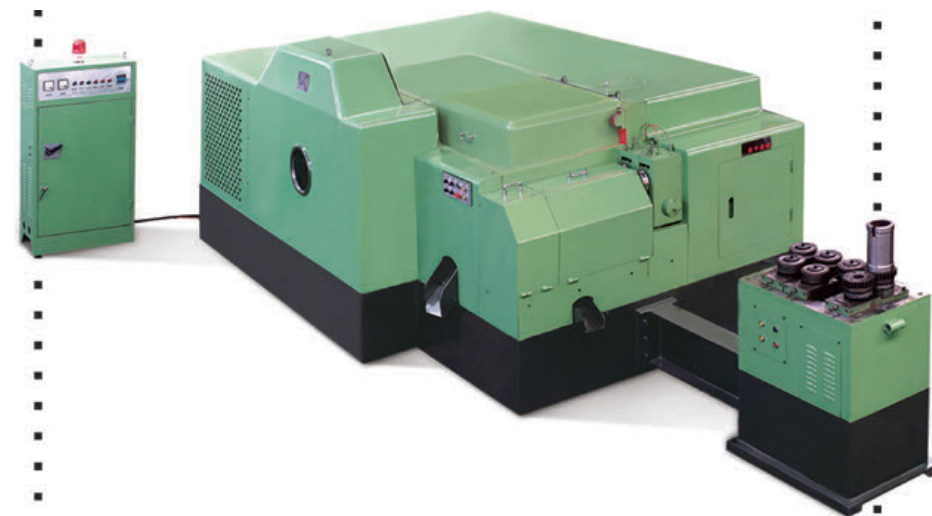
选择
Choice

MT式滑块



11B-17B多工位螺母冷镦机

11B-17B Multi station Nut Cold Heading Machine

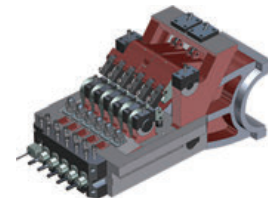


19B-60B多工位螺母冷镦机

19B-60B Multi station Nut Cold Heading Machine

选择
Choice

阳模PKO



选择
Choice

轴承式标准式

Bearing standard type

曲轴和冲击连杆采用全球最好的SKF轴承配合，适合加工普通产品，标准螺母。

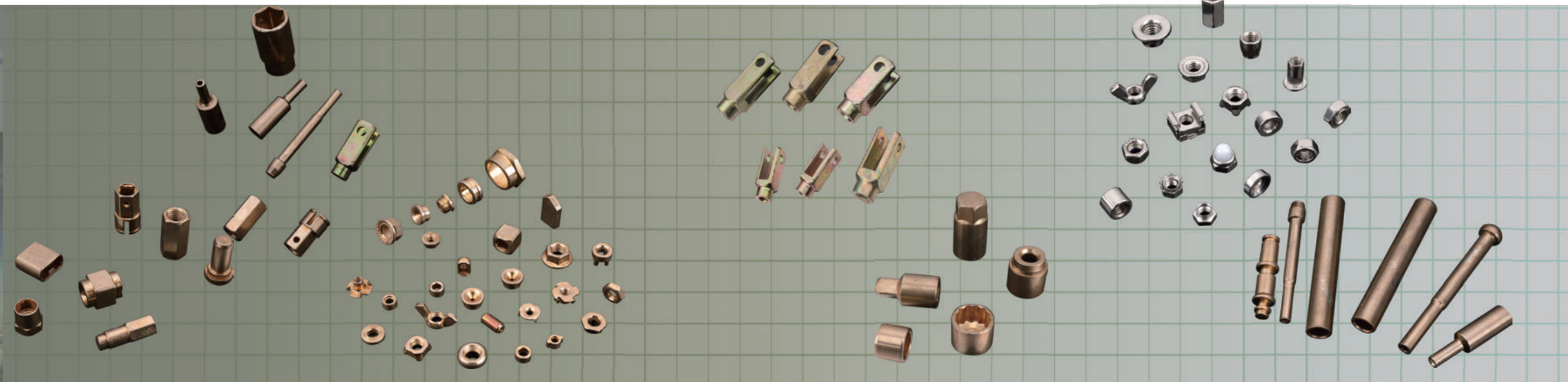
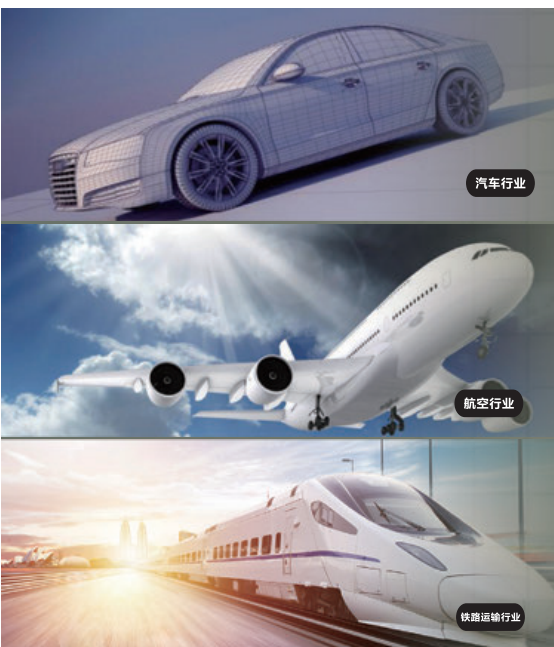
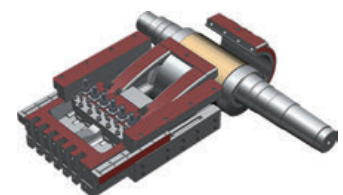


选择
Choice

铜套加长式

Lengthening of copper sleeve

铜瓦加长式曲轴与冲击连杆采用合金铜瓦配合，冲击承力大，使用寿命长，维修成本低。

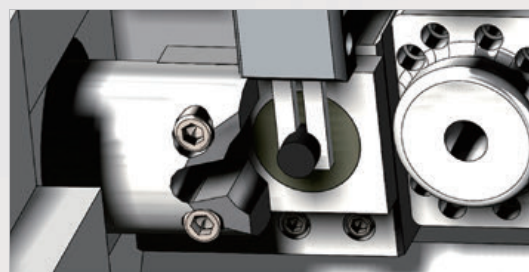
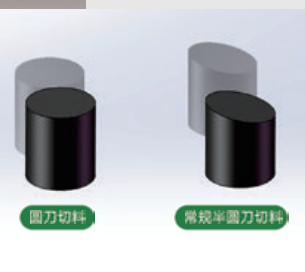
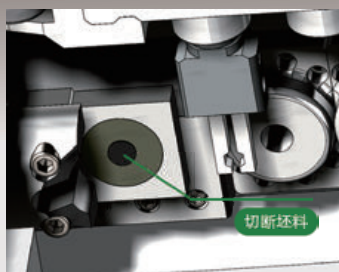


双曲线机构的高强度、高精度的零件成型机能够高效满足各种中、高碳钢的零部件冷锻成型

The high-strength and high-precision part forming machine with hyperbolic mechanism can efficiently meet the cold forging requirements of various medium and high carbon steel parts

圆切刀和独立钳架夹料机构

Circular cutting blade and independent clamp frame clamping mechanism

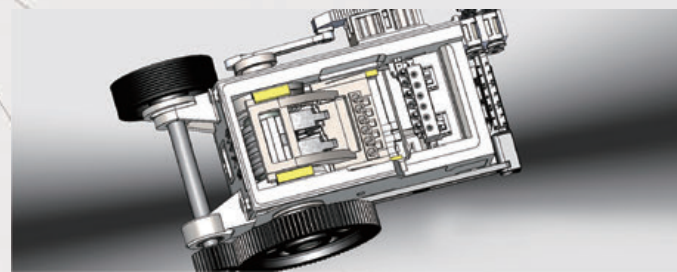


切料采用整圆切割设计，线材切断时平行度得到控制使得线材断面更加平整，大幅提高材料合格率。
The cutting material adopts a round cutting design, and the parallelism is controlled during wire cutting, making the wire section smoother and significantly improving the material qualification rate.

独立的钳架驱动结构配合圆刀切完料以后，后顶棒把料推入夹钳，并运转入下一工位。
After the independent clamp drive structure is combined with the circular knife to cut the material, the rear top rod pushes the material into the clamp and transports it to the next workstation.

机身增加背轴配备主、副飞轮

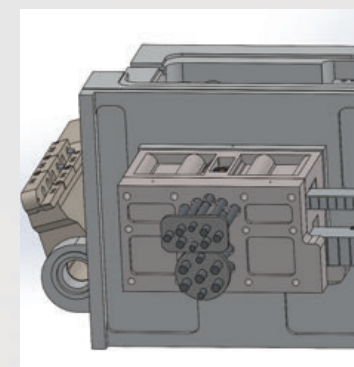
The body is equipped with a back axis and primary and secondary flywheels



采用大模数齿轮刚性传动设计，传动稳定性和传动效率大幅提升，齿轮传递扭矩，比传统皮带损失更小。
Adopting a large modulus gear rigid transmission design, the transmission stability and efficiency are greatly improved, and the gear transmits torque with less loss than traditional belts.

双曲线凸轮机构，搭配一体式剪刀箱

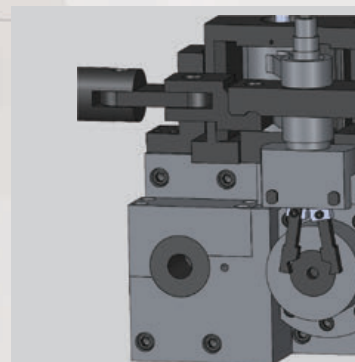
Hyperbolic cam mechanism, paired with an integrated scissor box



剪切机构采用双S板驱动设计，一体式剪刀箱，一块S板驱动剪切刀杆进行往复切料运动，一块S板驱动钳架拉杆进行往复夹料运动，搭配圆刀使用相得益彰。
The cutting mechanism adopts a dual S-plate drive design, with an integrated scissor box. One S-plate drives the cutting rod to perform reciprocating cutting motion, while the other S-plate drives the clamp rod to perform reciprocating clamping motion. When used in conjunction with a circular knife, it complements each other.

机械张钳结构

Mechanical tensioning clamp structure



钳架体升级为机械张钳结构，可根据产品自由伸缩，满足各种异型零件的夹持。
The clamp body has been upgraded to a mechanical tensioning clamp structure, which can freely expand and contract according to the product, meeting the clamping needs of various irregular parts.

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滑块加长型尾翼，机身结构加强

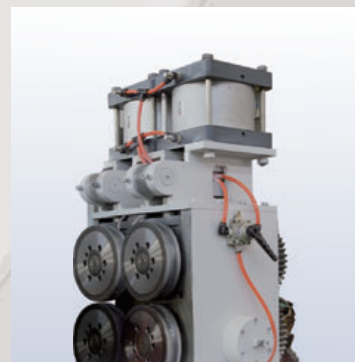
Extended tail wing with slider, reinforced fuselage structure



滑块加长型尾翼设计，合模精度可以得到有效提升，延长模具寿命，节省模具成本，滑块侧板采用高碳合金钢整体淬火处理，比传统侧板更加坚硬、耐磨、寿命长。机身通过壁厚的增加、材质的改良和结构的优化，新设计的机体综合机械性能大幅提升。
The extended tail wing design of the slider can effectively improve the precision of mold closing, prolong the life of the mold, and save mold costs. The side plate of the slider is made of high carbon alloy steel, which is quenched as a whole, making it harder, more wear-resistant, and has a longer lifespan than traditional side plates. The overall mechanical performance of the newly designed fuselage has been greatly improved by increasing wall thickness, improving materials, and optimizing the structure.

送料箱气缸压料机构

Feeding box cylinder pressing mechanism

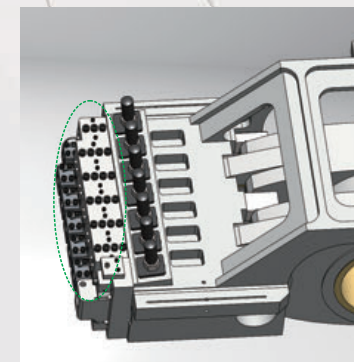


送料箱采用气缸压料系统，调试压线轮时候更加省力，便捷。压力可调，防止压力过大导致线材压扁。
The feeding box adopts a cylinder pressing system, which is more labor-saving and convenient when debugging the pressing wheel. Adjustable pressure to prevent excessive pressure from flattening the wire.

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新型冲棒供油系统

New type of fuel supply system for punching rods



滑块、冲模座内部设计油路，油嘴跟随滑块让冲棒不间断供油。
The internal oil circuit of the slider and die seat is designed, and the oil nozzle follows the slider to continuously supply oil to the punching rod.

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其锻造力、主飞轮扭矩在传统冷锻机的基础上提高了30%-40%

Its forging force and main flywheel torque have been increased by 30% -40% on the basis of traditional cold forging machines

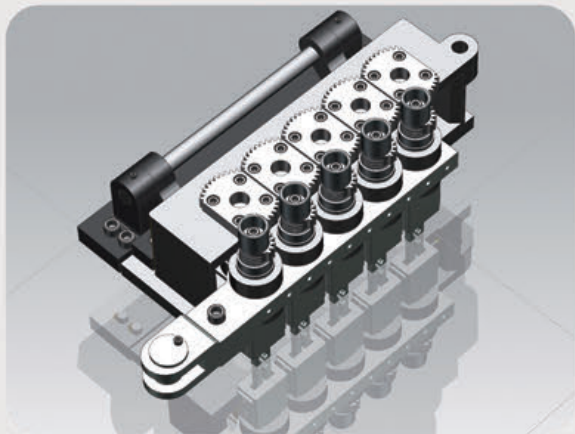


27B-60B多工位零件成型机

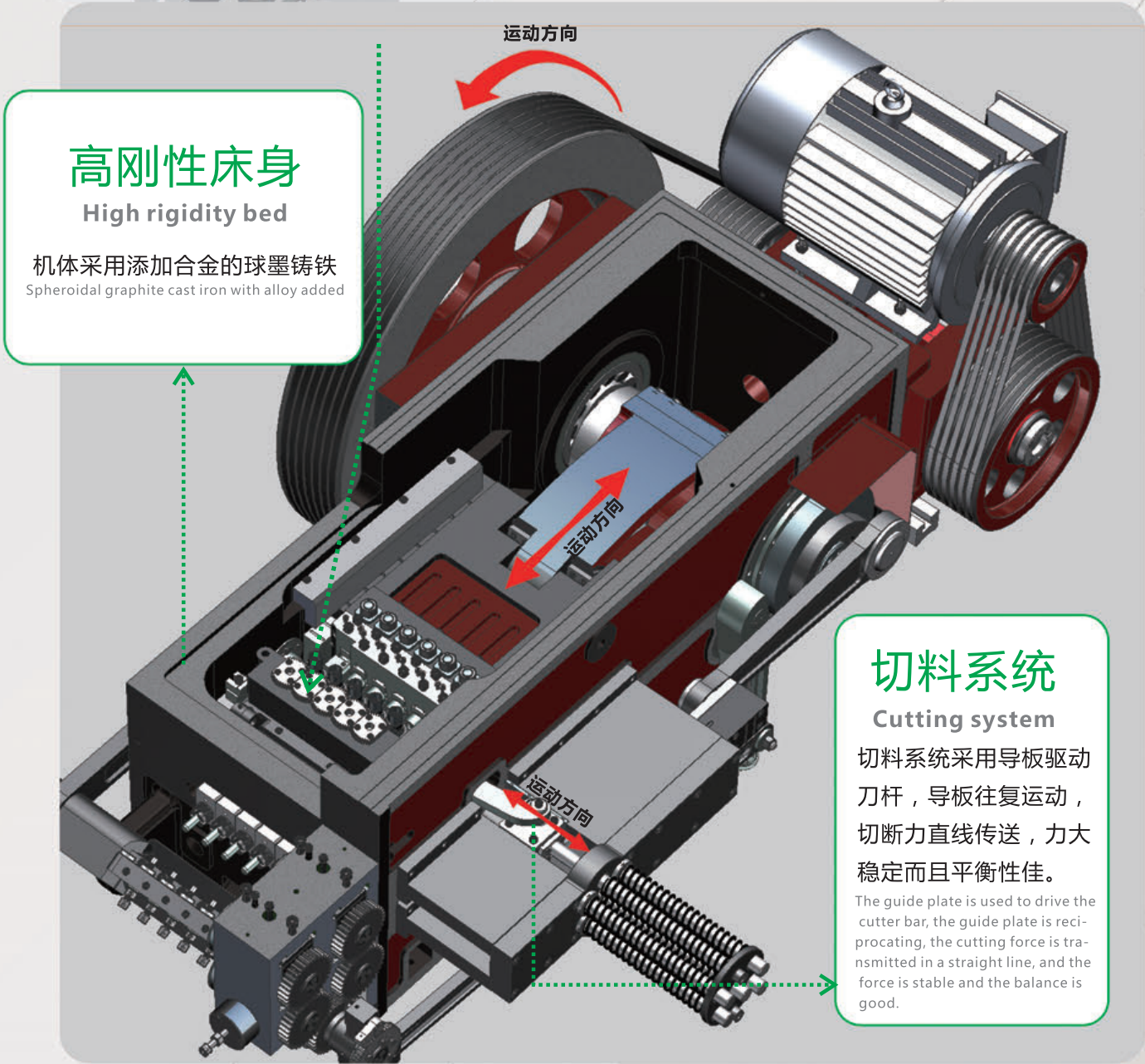
27B-60B Multi Station Part Forming Machine

优质的设计理念，铸就高精度、高效能、高寿命，低损耗

High quality design concept, casting high precision, high efficiency, high life, low loss.



钳架系统可以进行90、180度翻转，更利于成型工艺的安排。
The clamp frame system can be turned over 90 and 180 degrees, which is more conducive to the arrangement of molding process.



高刚性床身

High rigidity bed

机体采用添加合金的球墨铸铁
Spheroidal graphite cast iron with alloy added

切料系统

Cutting system

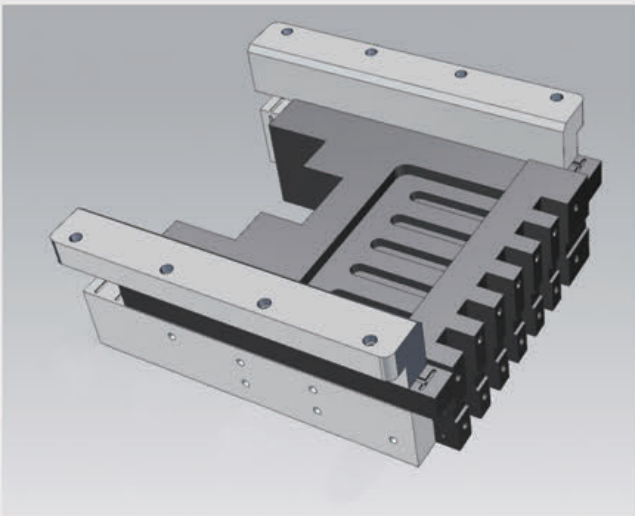
切料系统采用导板驱动刀杆，导板往复运动，切断力直线传送，力大稳定而且平衡性佳。

The guide plate is used to drive the cutter bar, the guide plate is reciprocating, the cutting force is transmitted in a straight line, and the force is stable and the balance is good.

主滑块 Main slider

滑块T型设计，运行更加平稳，更有利于加工精密高，形状复杂的产品。

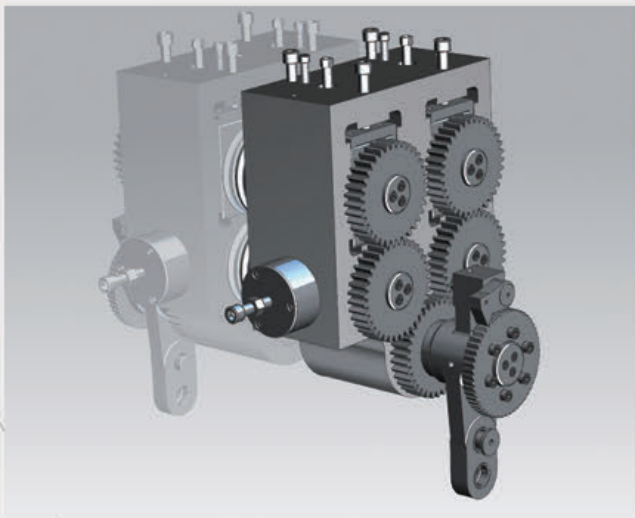
The T-shaped design of the slider ensures smoother operation and is more conducive to processing products with high precision and complex shapes.



送料部件 Feed part

棘轮机构，协调有序，齿轮经特殊处理，传动精度高，耐磨性强、寿命高。

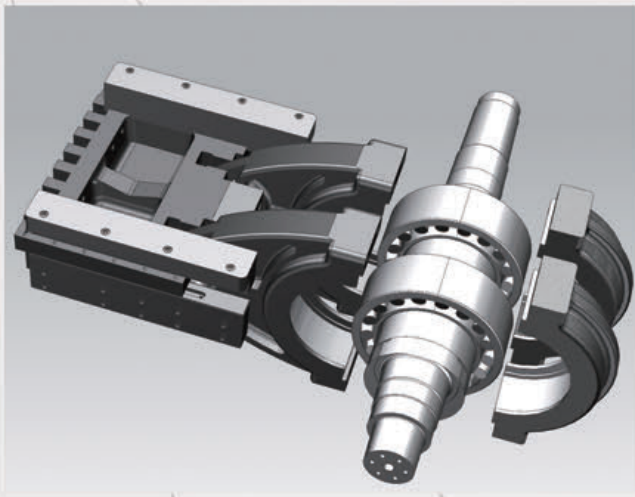
Ratcheting mechanism, coordinated and orderly, gear through special treatment, high transmission precision, strong wear resistance, high life.



轴承式 Bearing type

高品质的轴承，较低摩擦阻力、充足的润滑，设备运转高速灵活，产品精度稳定持久。

High quality bearings, low friction resistance, sufficient lubrication, high speed and flexible equipment operation, stable and durable products.



标准式规格参数(轴承式)							
Standard specification parameter							
型号 Model	11B	11B18L	12B20L	14B20L	17B25L	19B6S	
模数 (mm) Forging station	6s	6s	6s	6s	6s	6s	
最大切断直径 (mm) Cutdffdia	11	11	12	14	17	19	
切断长度 (mm) Cut-off length	3.3~12	3.3~20	3.3~22	5~20	6~25	10~18	
最大后冲顶出长度 (mm) Kick-Out Length	12	18	20	20	25	20	
母模中心距离 (mm) Center Distance	50	50	50	60	70	80	
最大锻压力 (Ton) Forgingpower	65	65	75	90	120	200	
主马达(KW) Main motor	15	15	15	22	22	30	
油用量 (每桶约200L) 8号或者10号冷镦油	800L	800L	800L	1000L	1200L	1600L	
机械重量 (Ton) machinery wieght	4.5T	4.5T	6T	8.5T	11.5T	16T	
尺寸 (M) size	长(L)	2.5	2.5	2.8	3	3.6	3.8
	宽(W)	1.65	1.65	1.65	2.1	2.2	2.4
	高(H)	1.25	1.25	1.3	1.35	1.6	1.8

加长式规格参数(铜瓦式)							
Elongated specification parameter							
型号 Model	11B20LT	11B40LT	11B50LT	11B60LT	12B20LT	14B40LT	
模数 (mm) Forging station	6s/7s	6s/7s/8s	6s/7s	6s	6s	6s/7s/8s	
最大切断直径 (mm) Cutdffdia	11	11	11	11	12	14	
切断长度 (mm) Cut-off length	3.3~22	6~40	8.5~54	8.5~60	3.3~22	10.2~42	
最大后冲顶出长度 (mm) Kick-Out Length	20	40	50	50	20	40	
母模中心距离 (mm) Center Distance	50	50	50	50	50	60	
最大锻压力 (Ton) Forgingpower	65	65	65	65	65	120	
主马达(KW) Main motor	15	15	15	15	15	22	
油用量 (每桶约200L) 8号或者10号冷镦油	800L	800L	800L	800L	800L	1000L	
机械重量 (Ton) machinery wieght	4.5T/5T	5.5T/6T/6.5T	5.8T/6.3T	6.1T	6T	9.5T/10.5T/11.5T	
尺寸 (M) size	长(L)	2.5	2.8	2.87	2.87	2.5	3.3/3.4/3.5
	宽(W)	1.65	1.65/1.66/1.7	1.65/1.67	1.65	1.65	2/2.1/2.2
	高(H)	1.25	1.3	1.3	1.3	1.3	1.7

如有要求：可进行定制

As required: customizable

本公司随时进行研究改进工作，因此保留随时更改设计、规格尺寸和机械结构的权利，本数据仅供参考。

The company is at any time to carry out research and improvement, and therefore reserves the right to change the design, specification, size and mechanical structure at any time. This data is for reference only.

加长式规格参数(铜瓦式)							
Elongated specification parameter							
型号 Model		14B60LT	14B80LT	17B25LT	17B40LT	19B6ST(18L)	19B40LT
模数 (mm) Forging station		6s/7s/8s	6s/7s	6s/7s	6s/7s/8s	6s	6s/7s
最大切断直径 (mm) Cutdffdia		14	14	17	17	19	19
切断长度 (mm) Cut-off length		11.6~63	23~85	6~25	8~41.5	7~20	10~42
最大后冲顶出长度 (mm) Kick-Out Length		60	80	25	40	18	40
母模中心距离 (mm) Center Distance		60	60	70	70	80	80
最大锻压力 (Ton) Forgingpower		120	120	140	200	200	200
主马达(KW) Main motor		22	22/30	22/30	30/30/45	30	37
油用量 (每桶约200L) 8号或者10号冷镦油		1000L	1000L	1200L	1200L	1600L	1600L
机械重量 (Ton) machinery wieght		10T/11.5T/13T	11.5T/12.5T	11.5T/13T	12T/13T/14T	16T	16.5T/17.5T
尺寸 (M) size	长(L)	3.4/3.8/4.15	3.9/4.3	3.5	3.7	3.8	3.8
	宽(W)	2/2.2/2.3	2.1/2.2	2.1/2.2	2.1/2.2/2.3	2.3	2.3/2.4
	高(H)	1.7	2	1.8	1.8	1.9	1.9
型号 Model		19B60LT	19B80LT	19B100LT	22B30LT	24B30LT	24B40LT
模数 (mm) Forging station		6s/7s/8s/9s	6s/7s/9s	7s	6s	6s	6s/7s
最大切断直径 (mm) Cutdffdia		19	19	19	22	24	24
切断长度 (mm) Cut-off length		14.2~62	28~84	34~100	12~33	14~32	16~40
最大后冲顶出长度 (mm) Kick-Out Length		60	80	100	30	30	40
母模中心距离 (mm) Center Distance		80	80	80	90	100	100
最大锻压力 (Ton) Forgingpower		260	260	260	270	280	280
主马达(KW) Main motor		445/45/55/75	45/55/75	75	45	45	55
油用量 (每桶约200L) 8号或者10号冷镦油		1600L	1600L	1600L	2000L	2600L	2600L
机械重量 (Ton) machinery wieght		19T/21T/22T/23T	19.5T/21T/24T	22T	22T	26T	26.5T/28T
尺寸 (M) size	长(L)	4.7	4.7/4.9/4.9	5	4.4	4.8	4.8/5.1
	宽(W)	2.3/2.4/2.5/2.7	2.3/2.4/2.7	2.4	2.4	2.8	2.8/2.9
	高(H)	2.1	2.1	2.2	2.1	2.2	2.2

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加长式规格参数(铜瓦式)							
Elongated specification parameter							
型号 Model		24B60LT	24B80LT	27BT	27B60LT	27B90LT	30B6T
模数 (mm) Forging station		6s/7s/8s/9s	6s/7s/9s	6s/7s	6s/7s/8s/9s	6s/7s	6s/7s
最大切断直径 (mm) Cutdffdia		24	24	27	27	27	21~35
切断长度 (mm) Cut-off length		25~68	30~85	14.7~32	26~68	30~93	35
最大后冲顶出长度 (mm) Kick-Out Length		60	80	30	60	90	35
母模中心距离 (mm) Center Distance		100	100	110	110	110	120
最大锻压力 (Ton) Forgingpower		300	300	300	300	330	330
主马达(KW) Main motor		75/75/90/90	75/90/90	75	75/90/110/132	90	110
油用量 (每桶约200L) 8号或者10号冷墩油		2600L	2600L	3200L	3200L	3200L	3800L
机械重量 (Ton) machinery wieght		32T/35T/37T/38T	35T/36.5T/38T	36.5T/38.5T	38T/40T/43T/46T	40T/43T	45T/48T
尺寸 (M) size	长(L)	5.4/5.4/5.5/5.6	5.6	5	5.5	5.5/5.8	5.7
	宽(W)	2.8/2.9/3.1/3.3	2.7/2.9/3.3	2.8/2.9	2.8/3.1/3.2	2.9/3	3.4/3.5
	高(H)	2.2	2.2	2.4	2.2/2.3/2.4	2.3/2.4	2.3
型号 Model		33B50LT	33B100LT	36B50LT	41B60LT	41B80LT	41B120LT
模数 (mm) Forging station		6s/7s	6s/7s/9s	6s/7s	6s	6s	7s
最大切断直径 (mm) Cutdffdia		33	33	36	41	41	41
切断长度 (mm) Cut-off length		12~54	34~102	15~52	15~68	20~83	42~120
最大后冲顶出长度 (mm) Kick-Out Length		50	100	50	60	80	120
母模中心距离 (mm) Center Distance		140	140	150	165	165	165
最大锻压力 (Ton) Forgingpower		330	350	600	600	600	600
主马达(KW) Main motor		132/160	200/200/220	200	200	220	220
油用量 (每桶约200L) 8号或者10号冷墩油		4800L	4800L	5200L	5600L	5600L	5600L
机械重量 (Ton) machinery wieght		53T/57T	75T/80T/87T	79T/84T	87T	90T	95T
尺寸 (M) size	长(L)	5.7/5.8	6.7	6.35	6.6	6.8	7.3
	宽(W)	3.6/3.8	3.9/4.1/4.5	3.5/3.6	3.7	3.7	3.9
	高(H)	2.6	2.8/2.9/3.1	2.7	2.8	2.8	2.8

如有要求：可进行定制

As required: customizable

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零件成型机(铜瓦式) Part forming machine					
型号 Model		30B6ST35L	33B6ST40L	33B6ST100L	36B7ST80L
切料模中心距(mm) Center Distance		70	80	80	80
最大切断直径 (mm) Cutdffdia		30	33	33	36
切断长度 (mm) Cut-off length		14~35	16~42	32~101	20~83
最大后冲顶出长度 (mm) Kick-Out Length		35	40	100	80
母模中心距离 (mm) Center Distance		120	140	140	150
最大锻压力 (Ton) Forgingpower		500	500	500	650
伺服马达(KW) Main motor		90	110	132	132
机械重量 (Ton) machinery wieght		45T	55T	78T	84T
尺寸 (M) size	长(L)	5.8	6	6.5	7
	宽(W)	3	3.3	3.3	3.5
	高(H)	2.4	2.7	2.9	3
型号 Model		41B6ST50L	50B6ST60L	50B7ST100L	58B6ST80L
切料模中心距(mm) Center Distance		90	95	95	95
最大切断直径 (mm) Cutdffdia		41	50	50	50
切断长度 (mm) Cut-off length		18~50	15~63	35~101	20~80
最大后冲顶出长度 (mm) Kick-Out Length		50	60	100	80
母模中心距离 (mm) Center Distance		165	200	200	240
最大锻压力 (Ton) Forgingpower		800	950	950	1050
伺服马达(KW) Main motor		160	200	200	150
机械重量 (Ton) machinery wieght		95T	120T	140T	140T
尺寸 (M) size	长(L)	6.2	6.6	8.5	9
	宽(W)	3.9	4.3	4.5	5
	高(H)	3.1	3.1	3.1	3.2

如有要求：可进行定制

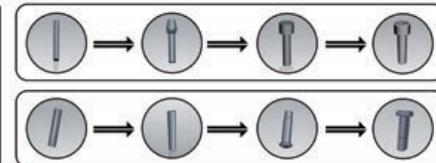
As required: customizable

本公司随时进行研究改进工作，因此保留随时更改设计、规格尺寸和机械结构的权利，本数据仅供参考。
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丰富的螺栓冷镦机系列产品能够满足各种超长零件的需要

The rich series of bolt cold heading machine products can meet the needs of various ultra long parts

产品成型

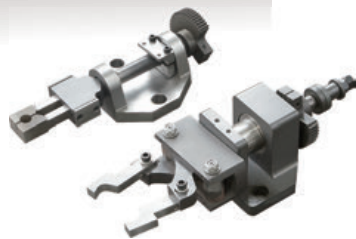


螺丝成型过程图
Screw forming process diagram

选装
Optional

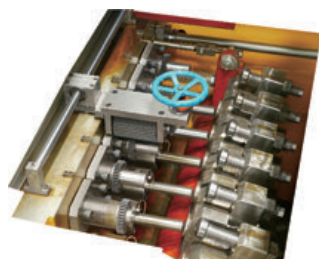
翻转式夹钳

翻转式大张开夹钳



选装
Optional

手摇数字化牙纹管
调整装置



10B-19B多工位螺栓冷镦机

10B-19B Multi Station Bolt Cold Heading Machine



24B-50B多工位螺栓冷镦机

24B-50B Multi Station Bolt Cold Heading Machine

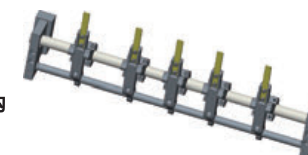
选装
Optional

电动式数字化送料装置



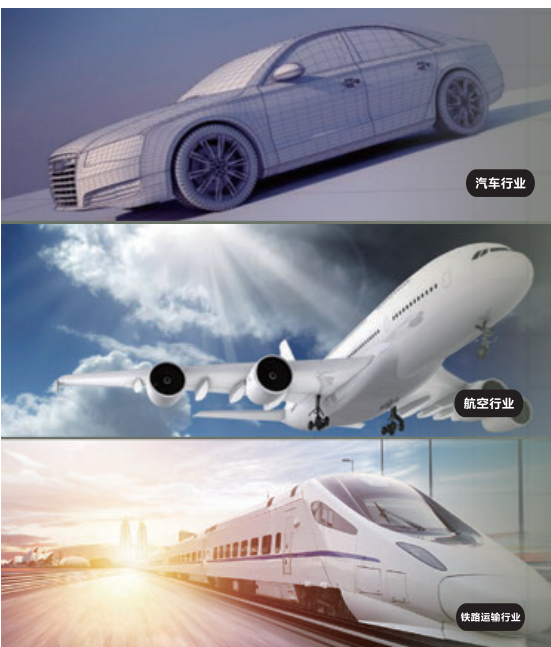
选装
Optional

模前挡料机构



选装
Optional

手摇式数字化挡料装置



汽车行业

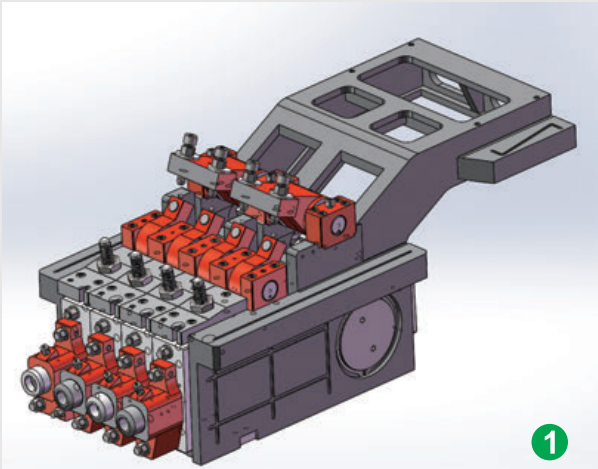
航空行业

铁路运输行业



螺栓机内部结构图示例：

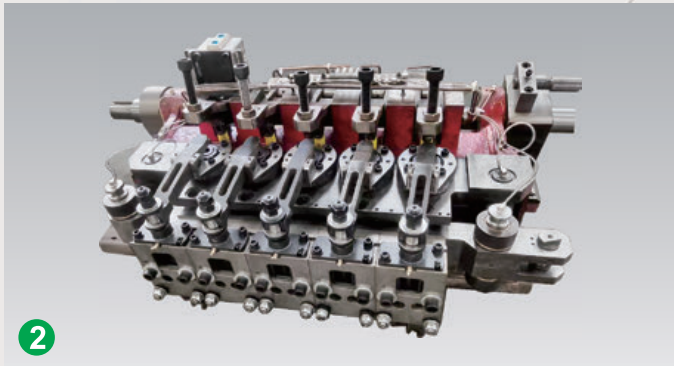
主滑块部分 Main slider section



滑块高稳定性，高精度的“马腿式”滑块，可上下左右调节。主滑块连接后翼的巧妙设计，底部都采用超耐磨的铸锡铜板，自动供油，保证机器滑块的长期运作精度。

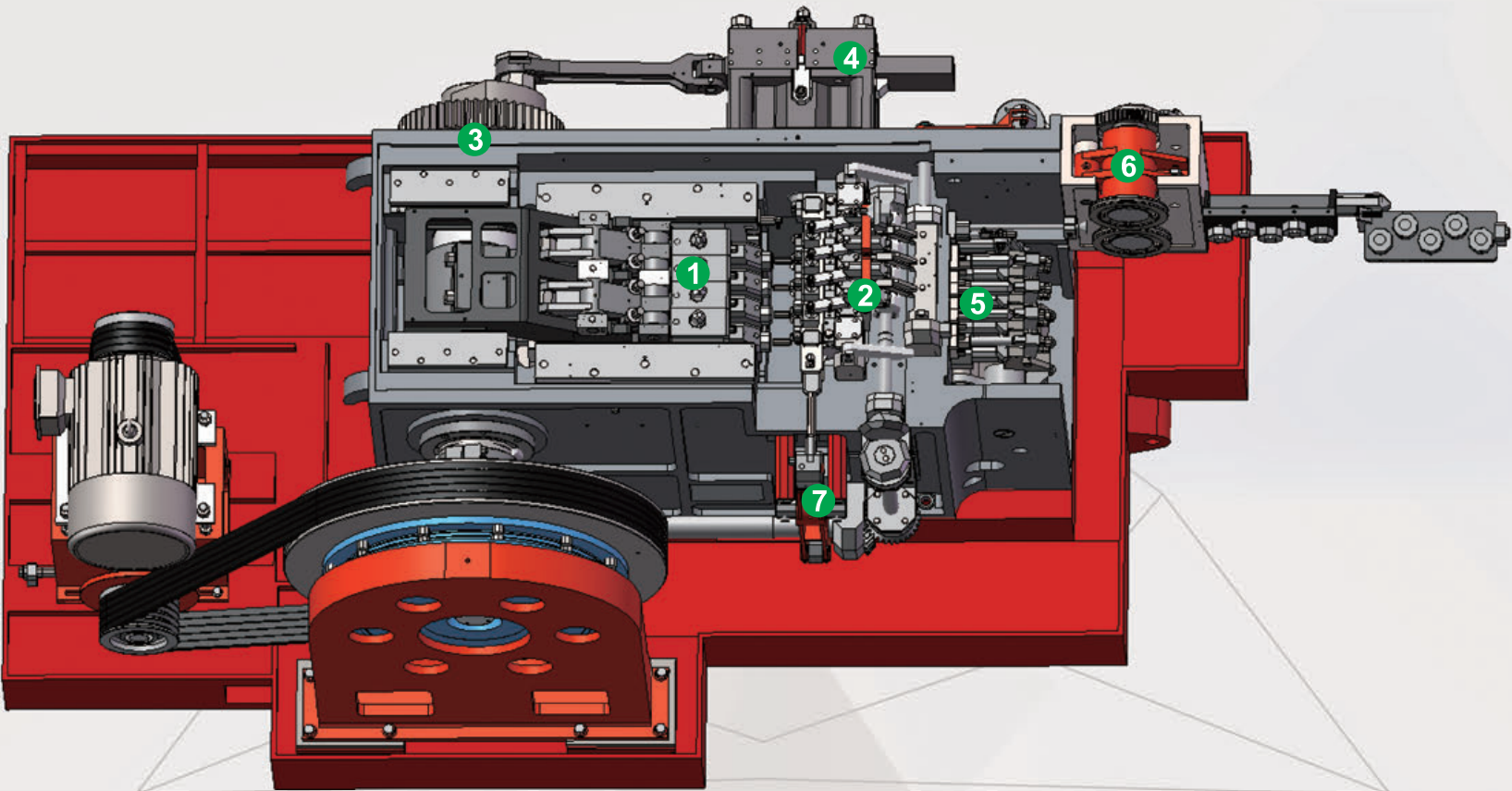
The slider has high stability and is a high-precision "horse legged" slider that can be adjusted up, down, left, and right. The clever design of connecting the main slider to the rear wing, with ultra wear-resistant cast tin copper plates at the bottom, automatically supplying oil to ensure the long-term operation accuracy of the machine slider.

夹仔台部件 Clamping table parts

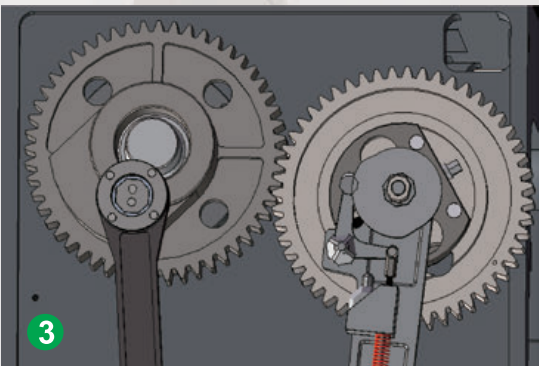


高精度多功能的夹仔台，可选择弹簧式夹仔台或气动式夹仔台，实现零件的平移或翻转。

High precision and multi-functional clamping table, spring type clamping table or pneumatic clamping table can be selected to realize translation or turnover of parts.



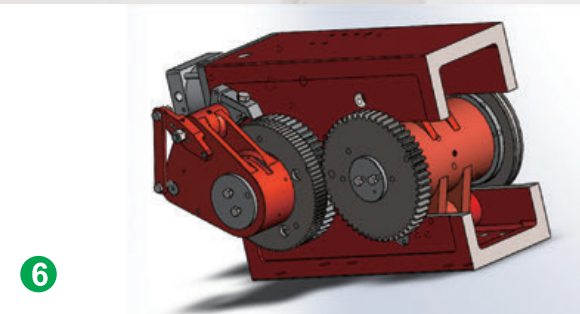
齿轮机构 Gear mechanism



送料大齿轮和切刀齿轮高精度的加工，齿面通过热处理后，采用进口的磨齿机磨齿，使得切刀机构和送料机构完美的契合。

High precision machining of feeding gear and cutter gear. After heat treatment, the imported grinding gear is used. The machine grinds the teeth to make the cutter mechanism and feeding mechanism complete. The fit of beauty.

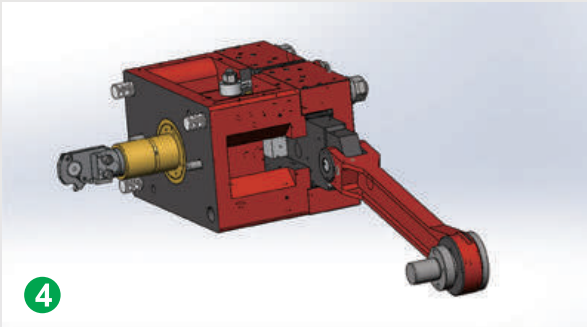
送料部分 Feeding part



采用进口设备加工齿轮，保证齿轮精度，提高进料的精度。

Using imported equipment to process gears, Ensure gear accuracy and improve feed accuracy.

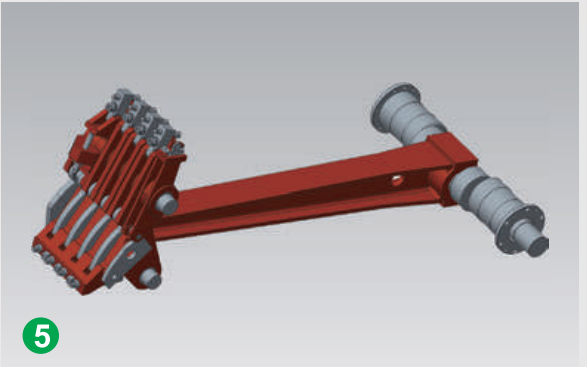
剪切部分 Shear section



切料部份为滑块连杆驱动，曲轴传递连贯的剪切力，使剪短面整齐平整。

The cutting part is driven by slider and connecting rod and transmitted by crankshaft. Continuous shear force makes the short surface neat and smooth.

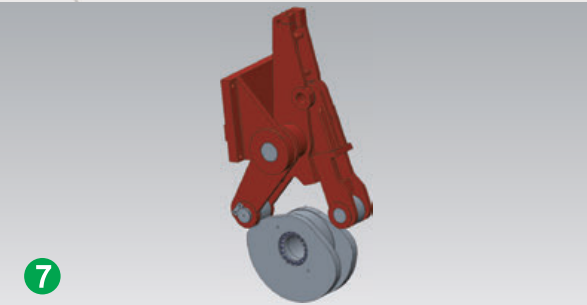
后托部分 Posterior part



后托部分各工位的顶料长度可通过凸轮单独调整，也可更换凸轮实现切边。

The ejector length of each station of the back support part can be convex. The wheel can be adjusted separately and the cam can be replaced to realize trimming.

移钳部分 Mobile forceps section



采用共轭凸轮夹钳传动机构，钳架往复运动更加平稳，高速运转更加稳定。

Adopting a conjugate cam clamp transmission mechanism, the reciprocating motion of the clamp frame is more stable, and the high-speed operation is more stable.

规格 Specification 机型 Model	63SL	83S	83SL	83SXL	83SUL	103S	103SL	103SXL	103SUL	133SL	133SXL	133SUL
	10B3SL	13B3S	13B3SL	13B3SXL	13B3SUL	17B3S	17B3SL	17B3SXL	17B3SUL	19B3SL	19B3SXL	19B3SUL
模数(mm) Forging Station	3	3	3	3	3	3	3	3	3	3	3	3
可制螺丝直径(mm) Normal Bolt Size	3~6	5~8	5~8	5~8	5~8	6~10	6~10	6~10	6~10	8~12.7	8~12.7	8~12.7
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	12~80	12~75	12~90	30~150	40~200	16~110	30~160	50~210	80~310	40~160	50~210	80~310
最大切断直径 Cut-Off Dia.Max.(mm)	8	11	11	11	11	13	13	13	13	16	16	16
最大切断长度 Cut-Off Length Max.(mm)	105	105	120	180	240	135	180	230	350	185	240	400
后托顶出长度 Kick-Out Length Max.(mm)	90	85	100	175	215	115	175	225	325	180	225	325
前托顶出长度 P.K.O. Length Max.(mm)	20	22	22	30	35	25	30	36	60	30	35	60
切模 Cut-Off Quill(D×L)(mm)	28×46	35×56	35×56	38×79	38×79	40×66	40×80	40×80	40×80	46×80	55×100	55×100
母模 Main Die Hole(D×L)(mm)	50×110	60×105	60×130	70×185	70×240	75×135	75×185	75×240	75×330	93×190	93×240	93×350
母模中心距离 DIES PITCH (mm)	60	87	87	87	87	93	93	93	93	114	114	114
公模束 PUNCH HOLE(D×L) (mm)	40×110	45×110	45×110	45×130	45×175	50×110	50×130	50×190	50×200	60×170	60×200	60×250
主滑板行程 RAM STROKE (mm)	150	150	160	250	350	190	250	360	460	270	360	500
压造力 Forging Power (mm)	40	65	65	70	70	90	85	90	90	130	130	140
每分钟最大产能 Max Output(pcs/minute)	210	170	170	150	140	150	130	100	80	125	100	80
主马达 Main Motor (KW)	15	18.5	18.5	22	22	22	30	30	30	37	37	37
LENGTH (mm)	3500	4000	4200	4500	5500	4300	5400	5500	6500	6000	6500	7500
WIDTH (mm)	1900	2200	2200	2300	2300	2600	2600	2600	2600	2800	2800	2870
HEIGHT (mm)	1700	2000	2000	2200	2400	2000	2300	2300	2400	2200	2300	2700
机械重量 Approx.Wt. (ton)	8.5	11	12	14	17	15	18	21	27	26	29	34

材料使用35# 钢以上及不锈钢，生产规格降一级。本公司随时进行研究改进的工作，因此保有随时更改设计，规格尺寸及机械结构之权利，本目录之规格仅供参考。

TMaterials used 35# steel Or above or stainless steel,the production specification falls to lower-level. No responsibility is taken for this data,which may be altered as improveements in manufacture dictate.

如有要求：可进行定制

As required: customizable

规格 Specification 机型 Model	163S	163SL	163SXL	163SUL	203S	203SUL	253L	253SL	303S	363S
	24B3S	24B3SL	24B3SXL	24B3SUL	30B3S	30B3SUL	36B3S	36B3SL	41B3S	45B3S
模数(mm) Forging Station	3	3	3	3	3	3	3	3	3	3
可制螺丝直径(mm) Normal Bolt Size	10~16	10~16	10~16	10~16	12~20	12~20	16~25.4	16~25.4	20~30	27~33
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	30~150	40~200	60~250	100~300	40~200	100~305	60~250	100~300	100~300	100~300
最大切断直径 Cut-Off Dia.Max.(mm)	22	22	22	22	25	25	30	30	34	36
最大切断长度 Cut-Off Length Max.(mm)	185	270	320	400	270	400	320	370	400	400
后托顶出长度 Kick-Out Length Max.(mm)	185	230	280	335	230	335	290	340	340	340
前托顶出长度 P.K.O. Length Max.(mm)	33	36	50	60	35	60	60	60	60	60
切模 Cut-Off Quill(D×L)(mm)	60×100	60×120	60×120	60×120	75×120	75×120	90×140	90×140	110×140	115×140
母模 Main Die Hole(D×L)(mm)	100×195	100×240	100×294	100×360	125×240	125×360	160×294	160×370	178×385	195×385
母模中心距离 DIES PITCH (mm)	126	126	126	126	138	138	174	174	195	210
公模束 PUNCH HOLE(D×L) (mm)	75×160	75×200	75×232	75×232	90×190	90×240	105×232	105×235	120×250	135×250
主滑板行程 RAM STROKE (mm)	280	360	420	500	360	500	440	500	500	500
压造力 Forging Power (mm)	200	200	215	215	265	270	380	390	520	600
每分钟最大产能 Max Output(pcs/minute)	120	100	75	65	90	60	60	55	45	40-45
主马达 Main Motor (KW)	55	55	75	75	75	90	110	110	132	160
LENGTH (mm)	7500	8500	9000	10000	8000	8600	9500	10000	11000	12000
WIDTH (mm)	3000	3000	3000	3000	3200	3200	3500	3500	4000	4200
HEIGHT (mm)	2600	2600	2800	2900	2900	3100	3000	3300	3300	3600
机械重量 Approx.Wt. (ton)	39	46	48	55	58	80	98	118	135	170

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规格 Specification 机型 Model	64SL	64SLL	84S	84SL	84SXL	84SUL	104S	104SL	104SXL	104SUL	134SL	134SXL	134SUL
	10B4SL	10B4SLL	13B4S	13B4SL	13B4SXL	13B4SUL	17B4S	17B4SL	17B4SXL	17B4SUL	19B4SL	19B4SXL	19B4SUL
模数(mm) Forging Station	4	4	4	4	4	4	4	4	4	4	4	4	4
可制螺丝直径(mm) Normal Bolt Size	3~6	3~6	5~8	5~8	5~8	5~8	6~10	6~10	6~10	6~10	8~12.7	8~12.7	8~12.7
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	12~80	15~105	15~75	15~90	30~150	40~200	15~110	30~160	40~210	90~310	35~160	40~210	90~310
最大切断直径 Cut-Off Dia.Max.(mm)	8	8	11	11	11	11	13	13	13	13	16	16	16
最大切断长度 Cut-Off Length Max.(mm)	105	130	105	120	180	240	135	180	230	350	185	240	400
后托顶出长度 Kick-Out Length Max.(mm)	90	110	90	100	175	215	115	175	225	325	180	225	325
前托顶出长度 P.K.O. Length Max.(mm)	20	25	22	22	30	35	30	30	36	60	30	35	60
切模 Cut-Off Quill(D×L)(mm)	28×46	28×46	35×56	35×56	38×79	38×79	40×66	40×80	40×80	40×80	46×80	60×100	60×100
母模 Main Die Hole(D×L)(mm)	50×105	50×130	60×105	60×130	70×185	70×240	75×135	75×185	75×240	75×330	93×190	93×240	93×350
母模中心距离 DIES PITCH (mm)	60	60	87	87	87	87	93	93	93	93	114	114	114
公模束 PUNCH HOLE(D×L) (mm)	40×110	40×110	45×110	45×110	45×130	45×175	50×110	50×130	50×190	50×200	60×170	60×200	60×350
主滑板行程 RAM STROKE (mm)	150	180	150	160	250	350	190	250	360	460	270	360	500
压造力 Forging Power (mm)	40	45	70	70	70	70	90	85	90	90	120	130	130
每分钟最大产能 Max Output(pcs/minute)	220	200	160	160	160	140	140	130	110	80	120	100	80
主马达 Main Motor (KW)	15	15	22	22	22	22	30	30	30	37	37	37	37
LENGTH (mm)	3500	4000	4000	4200	4500	5500	4300	5400	5500	6500	6000	6500	7500
WIDTH (mm)	1960	2000	2287	2287	2387	2387	2693	2693	2693	2693	2914	2914	2984
HEIGHT (mm)	1700	1900	2000	2000	2200	2400	2000	2300	2300	2400	2200	2300	2700
机械重量 Approx.Wt. (ton)	10	12	12	13.5	16	20	17	20	25	30	28	33	39

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如有要求：可进行定制

As required: customizable

规格 Specification 机型 Model	164S	164SL	164SUL	204S	204SL	204SUL	204SULL	254L	254SL	254SXL	304S	364S
	24B4S	24B4SL	24B4SUL	30B4S	30B4SL	30B4SUL	30B4SULL	36B4S	36B4SL	36B4SXL	41B4S	45B4S
模数(mm) Forging Station	4	4	4	4	4	4	4	4	4	4	4	4
可制螺丝直径(mm) Normal Bolt Size	10~16	10~16	10~16	12~20	12~20	12~20	12~20	16~25.4	16~25.4	16~25.4	20~30	27~33
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	30~160	40~210	100~310	40~200	60~250	100~305	100~360	60~250	100~300	100~380	100~300	100~300
最大切断直径 Cut-Off Dia.Max.(mm)	22	22	22	26	26	26	26	30	30	30	35	37
最大切断长度 Cut-Off Length Max.(mm)	185	270	400	270	320	400	445	320	370	460	400	400
后托顶出长度 Kick-Out Length Max.(mm)	185	230	335	230	285	335	370	290	340	410	340	340
前托顶出长度 P.K.O. Length Max.(mm)	33	36	60	35	60	60	70	60	60	60	60	60
切模 Cut-Off Quill(D×L)(mm)	60×100	60×120	60×120	75×120	75×120	75×120	75×120	90×140	90×140	90×140	110×140	115×140
母模 Main Die Hole(D×L)(mm)	100×195	100×240	100×360	125×240	125×294	125×360	125×420	160×294	160×370	160×450	160×385	195×385
母模中心距离 DIES PITCH (mm)	126	126	126	138	138	138	138	174	174	174	195	210
公模束 PUNCH HOLE(D×L) (mm)	75×160	75×200	75×232	90×190	90×232	90×240	90×290	105×232	105×235	106×270	120×250	135×250
主滑板行程 RAM STROKE (mm)	280	360	500	360	430	500	580	440	500	600	500	500
压造力 Forging Power (mm)	200	200	215	265	285	300	320	380	420	450	520	600
每分钟最大产能 Max Output(pcs/minute)	100	100	65	90	65	60	55	60	55	45-50	45	40-45
主马达 Main Motor (KW)	55	55	75	75	75	90	90	90	110	110	132	160
LENGTH (mm)	7500	8500	10000	8000	8300	8600	8800	9500	10000	10600	11000	12000
WIDTH (mm)	3126	3126	3126	3338	3400	3400	3400	3700	3700	3900	4195	4410
HEIGHT (mm)	2600	2600	2900	2900	3000	3100	3200	3000	3300	2900	3300	3600
机械重量 Approx.Wt. (ton)	45	51	62	65	76	87	82	108	128	160	152	195

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如有要求：可进行定制

As required: customizable

规格 Specification 机型 Model	65SL	65SLL	85S	85SXL	105S	105SL	105SXL	135SL	135SXL	135SLL	135SUL
	10B5SL	10B5SLL	13B5S	13B5SXL	17B5S	17B5SL	17B5SXL	19B5SL	19B5SXL	19B5SLL	19B5SUL
模数(mm) Forging Station	5	5	5	5	5	5	5	5	5	5	5
可制螺丝直径(mm) Normal Bolt Size	3~6	3~6	5~8	5~8	6~10	6~10	6~10	8~12.7	8~12.7	8~12.7	8~12.7
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	10~80	15~105	12~90	30~155	15~110	30~160	40~210	35~160	40~210	50~250	80~310
最大切断直径 Cut-Off Dia.Max.(mm)	8	8	11	11	15	15	15	16	16	16	16
最大切断长度 Cut-Off Length Max.(mm)	105	130	120	180	135	180	230	185	240	310	400
后托顶出长度 Kick-Out Length Max.(mm)	90	110	100	175	115	175	225	180	225	280	325
前托顶出长度 P.K.O. Length Max.(mm)	20	22	25	30	30	30	36	30	35	60	60
切模 Cut-Off Quill(D×L)(mm)	28×46	28×46	35×56	38×79	40×66	40×80	40×80	55×80	55×100	55×100	55×100
母模 Main Die Hole(D×L)(mm)	50×110	50×130	60×130	70×185	75×135	75×185	75×240	93×190	93×240	93×294	93×350
母模中心距离 DIES PITCH (mm)	60	60	87	87	93	93	93	114	114	114	114
公模束 PUNCH HOLE(D×L) (mm)	40×110	40×110	45×110	45×130	50×110	50×130	50×190	60×170	60×200	60×232	60×250
主滑板行程 RAM STROKE (mm)	150	180	160	250	190	250	360	270	360	420	500
压造力 Forging Power (mm)	50	50	90	90	105	105	110	150	160	160	165
每分钟最大产能 Max Output(pcs/minute)	180	170	140	140	130	130	100	100	90	80	70
主马达 Main Motor (KW)	15	15	22	22	30	30	37	45	45	45	45
LENGTH (mm)	3500	4000	4000	4500	4300	5400	5500	6000	6500	7000	7500
WIDTH (mm)	2020	2060	2374	2474	2786	2786	2786	3142	3142	3142	3098
HEIGHT (mm)	1700	1900	2000	2200	2000	2300	2300	2200	2300	2500	2700
机械重量 Approx.Wt. (ton)	12	14	17	21	20	25	30	32	38	41	45

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As required: customizable

规格 Specification 机型 Model	165S	165SL	165SXL	165SUL	205S	205SL	205SUL	255L	255SL	305SL	365L
	24B5S	24B5SL	24B5SXL	24B5SUL	30B5S	30B5SL	30B5SUL	36B5S	36B5SL	41B5SL	45B5SL
模数(mm) Forging Station	5	5	5	5	5	5	5	5	5	5	5
可制螺丝直径(mm) Normal Bolt Size	10~16	10~16	10~16	10~16	12~20	12~20	12~20	16~25.4	16~25.4	24~30	27~33
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	30~160	40~200	40~250	80~300	40~200	50~250	80~305	60~250	80~300	80~300	80~300
最大切断直径 Cut-Off Dia.Max.(mm)	23	23	23	23	30	30	30	32	32	36	38
最大切断长度 Cut-Off Length Max.(mm)	185	270	320	400	270	320	400	320	370	380	380
后托顶出长度 Kick-Out Length Max.(mm)	185	230	280	335	230	285	335	290	340	340	340
前托顶出长度 P.K.O. Length Max.(mm)	33	36	60	60	35	60	60	60	60	60	60
切模 Cut-Off Quill(D×L)(mm)	60×100	60×120	60×120	60×120	75×120	75×120	75×120	90×140	90×140	115×140	120×140
母模 Main Die Hole(D×L)(mm)	108×195	108×240	108×294	108×360	125×240	125×294	125×360	160×294	160×370	178×385	195×385
母模中心距离 DIES PITCH (mm)	126	126	126	126	138	138	138	174	174	195	210
公模束 PUNCH HOLE(D×L) (mm)	75×160	75×200	75×232	75×232	90×190	90×232	90×240	105×232	105×232	120×250	135×250
主滑板行程 RAM STROKE (mm)	280	360	420	500	360	430	500	440	500	500	500
压造力 Forging Power (mm)	230	230	250	250	320	340	360	440	480	600	680
每分钟最大产能 Max Output(pcs/minute)	100	75	65	60	70	60	55	55	50	45	40-45
主马达 Main Motor (KW)	55	55	75	75	75	75	90	90	110	132	160
LENGTH (mm)	7500	8500	9000	10000	8000	8300	8600	9500	10600	11000	12000
WIDTH (mm)	3252	3252	3252	3252	3476	3538	3538	3848	4074	4390	4620
HEIGHT (mm)	2600	2600	2800	2900	2900	3000	3100	3000	2900	3300	3600
机械重量 Approx.Wt. (ton)	53	58	63	69	75	87	97	130	146	170	210

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As required: customizable

规格 Specification 机型 Model	66SL	66SLL	86S	86SL	86SXL	106S	106SL	106SXL	136SL	136SXL	136SUL
	10B6SL	10B6SLL	13B6S	13B6SL	13B6SXL	17B6S	17B6SL	17B6SXL	19B6SL	19B6SXL	19B6SUL
模数(mm) Forging Station	6	6	6	6	6	6	6	6	6	6	6
可制螺丝直径(mm) Normal Bolt Size	3~6	3~6	5~8	5~8	5~8	6~10	6~10	6~10	8~12.7	8~12.7	8~12.7
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	10~80	15~100	12~90	12~100	30~155	15~110	30~160	40~210	35~160	40~210	80~310
最大切断直径 Cut-Off Dia.Max.(mm)	10	10	13	13	13	16	16	16	18	18	18
最大切断长度 Cut-Off Length Max.(mm)	105	130	120	130	180	135	180	230	185	240	400
后托顶出长度 Kick-Out Length Max.(mm)	90	110	100	120	175	115	175	225	180	225	325
前托顶出长度 P.K.O. Length Max.(mm)	20	20	25	30	30	30	35	45	40	50	60
切模 Cut-Off Quill(D×L)(mm)	32×46	32×46	40×56	40×56	40×79	45×66	45×80	45×80	55×80	55×100	55×100
母模 Main Die Hole(D×L)(mm)	50×110	50×130	60×130	70×135	70×185	75×135	75×185	75×240	93×190	93×240	93×350
母模中心距离 DIES PITCH (mm)	60	60	87	87	87	93	93	93	114	114	114
公模束 PUNCH HOLE(D×L) (mm)	40×110	40×110	45×110	45×110	45×130	50×110	50×130	50×190	60×170	60×200	60×250
主滑板行程 RAM STROKE (mm)	150	180	160	182	250	190	250	360	270	360	500
压造力 Forging Power (mm)	55	55	100	100	100	130	130	140	170	180	180
每分钟最大产能 Max Output(pcs/minute)	150	140	120	120	100	100	100	90	90	80	70
主马达 Main Motor (KW)	15	18.5	22	22	30	30	30	37	45	45	55
LENGTH (mm)	3500	4000	4200	4500	5500	4300	5400	5500	6000	6500	7500
WIDTH (mm)	2080	2120	2461	2461	2561	2879	2879	2879	3142	3142	3212
HEIGHT (mm)	1700	1900	2000	2200	2400	2000	2300	2300	2200	2300	2700
机械重量 Approx.Wt. (ton)	15	17	20	23	26	23	27	32	35	41	50

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规格 Specification 机型 Model	166S	166SL	166SXL	166SUL	206S	206SL	206SUL	256L	256SL	306S	366S
	24B6S	24B6SL	24B6SXL	24B6SUL	30B6S	30B6SL	30B6SUL	36B6S	36B6SL	41B6S	45B6S
模数(mm) Forging Station	6	6	6	6	6	6	6	6	6	6	6
可制螺丝直径(mm) Normal Bolt Size	10~16	10~16	10~16	10~16	12~20	12~20	12~20	16~25.4	16~25.4	24~30	27~33
可制螺丝头下长度(mm) Shank Length Of Bolt Blanks	30~160	40~200	50~250	80~300	40~200	50~250	80~305	60~250	80~300	80~300	80~300
最大切断直径 Cut-Off Dia.Max.(mm)	25	25	25	25	30	30	30	34	34	38	41
最大切断长度 Cut-Off Length Max.(mm)	185	270	320	400	270	320	400	320	370	380	380
后托顶出长度 Kick-Out Length Max.(mm)	185	230	280	335	230	285	335	290	340	340	340
前托顶出长度 P.K.O. Length Max.(mm)	40	40	60	60	50	60	60	60	60	60	60
切模 Cut-Off Quill(D×L)(mm)	75×100	75×120	75×120	75×120	85×120	85×120	85×120	109×140	109×140	115×140	129×140
母模 Main Die Hole(D×L)(mm)	108×195	108×240	108×294	108×360	125×240	125×294	125×360	160×294	160×370	178×385	195×385
母模中心距离 DIES PITCH (mm)	126	126	126	126	138	138	138	174	174	195	210
公模束 PUNCH HOLE(D×L) (mm)	75×160	75×200	75×232	75×232	90×190	90×232	90×240	105×232	105×232	120×250	135×250
主滑板行程 RAM STROKE (mm)	280	360	420	500	360	430	500	440	500	500	500
压造力 Forging Power (mm)	260	260	280	280	390	390	400	520	520	750	900
每分钟最大产能 Max Output(pcs/minute)	80	65	55	50	60	50	45	45	45	45	45
主马达 Main Motor (KW)	75	75	90	90	90	90	110	110	132	160	200
LENGTH (mm)	7500	8500	9000	10000	8000	8300	8600	9500	10000	11000	12000
WIDTH (mm)	3378	3378	3378	3378	3614	3676	3676	4022	3848	4585	4830
HEIGHT (mm)	2600	2600	2800	2900	2900	3000	3100	3000	3300	3300	3600
机械重量 Approx.Wt. (ton)	58	65	70	76	80	90	105	142	158	185	225

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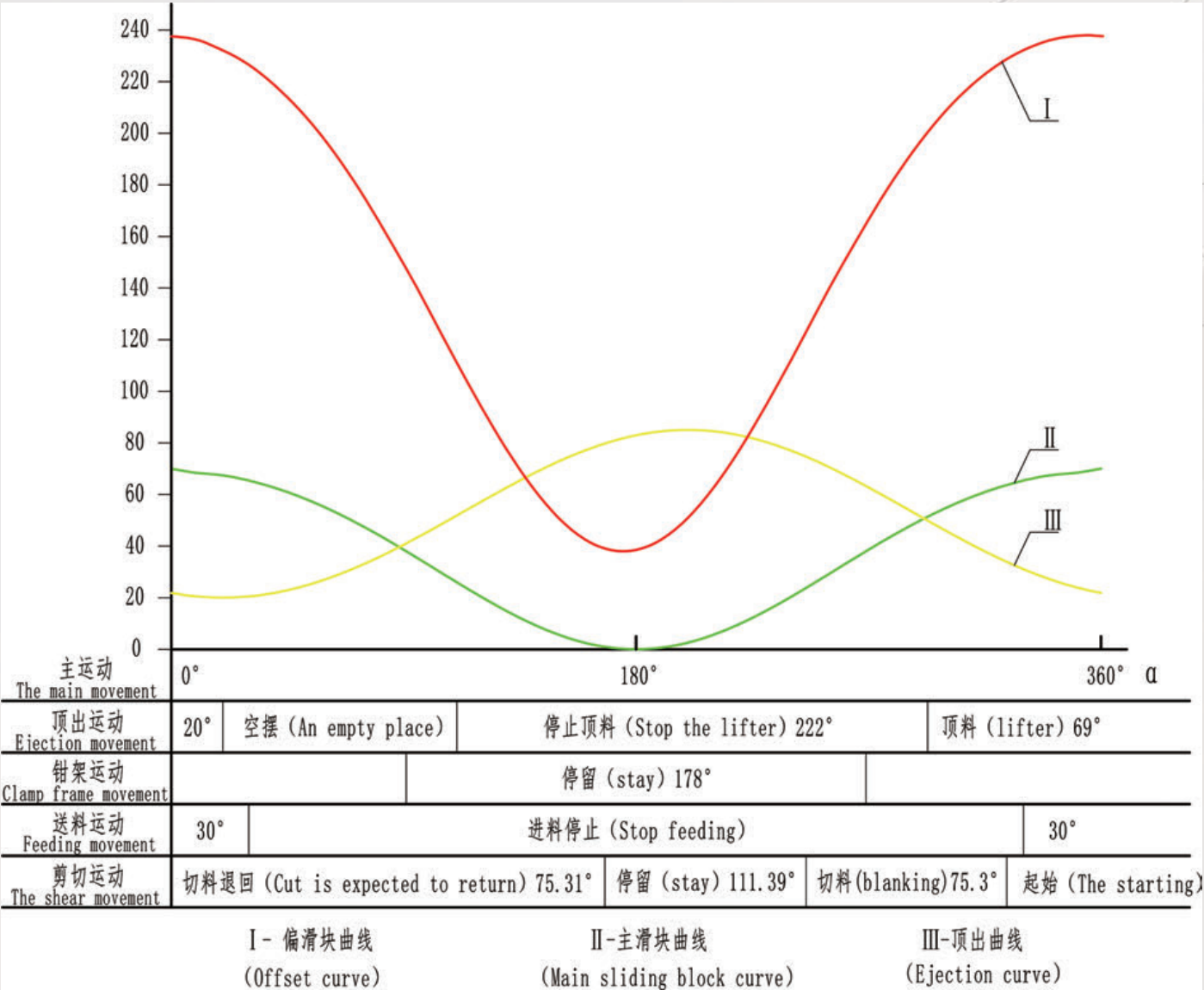
如有要求：可进行定制

As required: customizable

最佳的运动循环
Optimal movement cycle

最经济的时间比例协调
The most economical time scale coordination

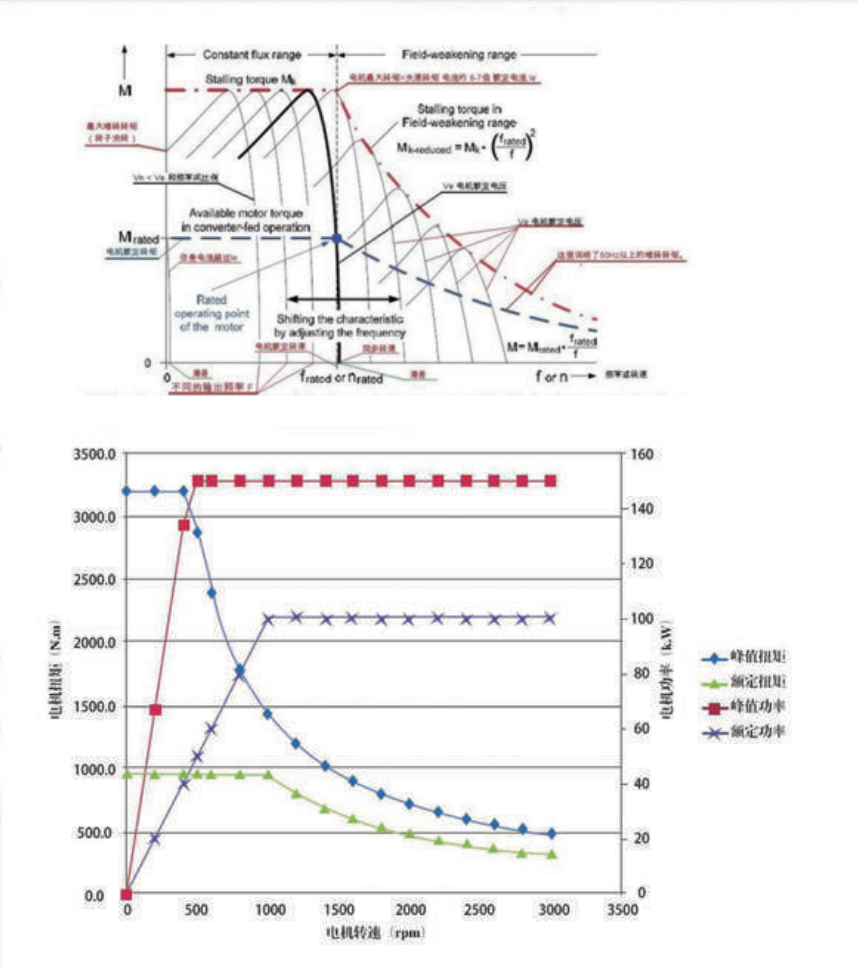
安全、平稳、高效能
Safety, stability, efficiency



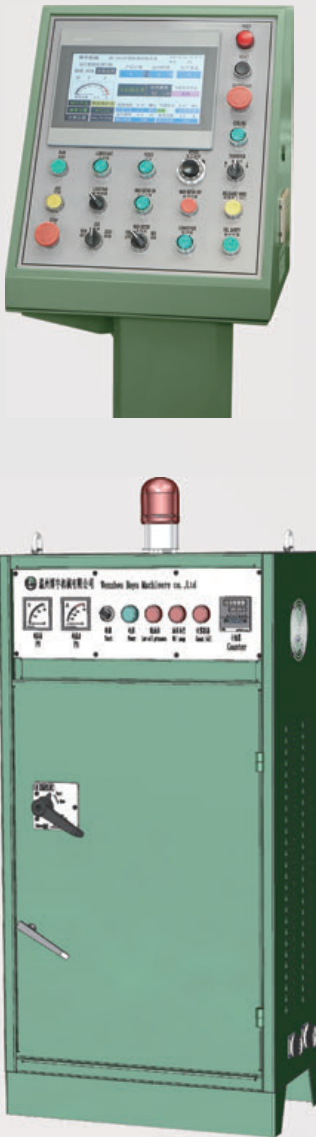
冷锻机运行/曲线图
Cold forging machine running / curve diagram

配电系统的先进特性

The advanced characteristics of the distribution system



- 安全保护----机器故障自动停止
Safety protection - automatic stop of machine failure
- 故障检测----机器异常操作自动报警
Fault detection - automatic alarm for machine abnormal operation
- 温度检测----时刻监视轴承与曲轴工作温度
Temperature detection - time monitoring of working temperature of bearing and crankshaft
- 油压检测----时刻监测油压情况，低油压报警
Oil pressure detection - time monitoring of oil pressure, low oil pressure alarm
- 计数----对作业数量进行统计
Counter - count the number of jobs
- 提高精度---实现了位置，速度和力矩的闭环控制，克服寸进问题
Improve the accuracy - the closed loop control of position, speed and torque can be realized to overcome the inching problem
- 适应性----抗过载能力强，能瞬间负载波动
Adaptability - strong resistance to overload and instantaneous load fluctuation



企业简介

Brief Introduction

温州博宇机械有限公司位于温州空港新区，拥有两个生产加工基地，现有四万平方的标准厂房，从是金属冷镦成形机集研发、生产、销售于一体的国家高新技术企业。公司主要产品为全自动金属冷镦成形螺母、螺栓机；多工位冷镦成形螺母、螺栓机等系列产品，产品销往国内及海外等国家和地区，广泛应用于汽车、摩托车、铁路运输、工程机械、航空航天、能源、家电等企业。同时受到了广大客户的好评，并在同行业中领先之一。公司已通过了ISO9001、ISO45001、ISO14001等管理体系认证，同时获得了浙江制造品字标认证及国际互认证书。公司拥有发明、实用新型专利80多项。公司先后荣获：国家高新技术企业、浙江省专精特新中小企业、省级企业技术研发中心、浙江省高成长科技型中小企业、浙江省科技型中小企业、温州市科技（创新）型企业、温州市信用管理示范企业等荣誉。公司坚持“以技术为先导、以质量求生存、以诚信待客户”为宗旨，欢迎国内外客户光临惠顾携手合作、共赢未来。

Wenzhou Boyu Machinery Co., Ltd. is located in Wenzhou Airport New Area, with two production and processing bases and a standard factory of 40000 square meters. It is a national high-tech enterprise that integrates research and development, production, and sales of metal cold heading forming machines. The company's main products are fully automatic metal cold heading forming nuts and bolt machines; A series of products such as multi station cold forging nuts and bolt machines are sold to domestic and overseas countries and regions, and are widely used in enterprises such as automobiles, motorcycles, railway transportation, engineering machinery, aerospace, energy, and home appliances. At the same time, it has received praise from a large number of customers and is one of the leaders in the same industry. The company has passed management system certifications such as ISO9001, ISO45001, and ISO14001, and has also obtained Zhejiang Manufacturing Product Label Certification and International Mutual Recognition Certificate. The company has over 80 invention and utility model patents. The company has successively won honors such as National High tech Enterprise, Zhejiang Province Specialized, Refined, Special and New Small and Medium sized Enterprise, Provincial Enterprise Technology Research and Development Center, Zhejiang Province High Growth Science and Technology Small and Medium sized Enterprise, Zhejiang Province Science and Technology Small and Medium sized Enterprise, Wenzhou City Science and Technology (Innovation) Enterprise, Wenzhou City Credit Management Model Enterprise, etc. The company adheres to the principle of "technology as the guide, quality for survival, and integrity for customers", and welcomes domestic and foreign customers to visit and cooperate with us for a win-win future.



车间展示 Workshop display



工欲善其器，必先利其器 Advanced equipment

从零部件的车、铣、刨、磨、镗、热处理等机械加工，再到机械组装，我们拥有一整套生产流水线以及数百台先进的加工设备，如日本马扎克加工中心、大隈加工中心、韩国斗山加工中心，海天龙门铣、加工中心等更有先进的监测加工设备以及专业的设计操作团队和严格的生产管理体系。

From mechanical processing such as turning, milling, planing, grinding, boring, and heat treatment of components, to mechanical assembly, we have a complete set of production lines and hundreds of advanced processing equipment, such as the Mazak machining center in Japan, Okuma machining center, Doosan machining center in South Korea, Haitian Longmen milling, machining center, etc. More advanced monitoring and processing equipment, professional design and operation team, and strict production management system.

企业荣誉 Corporate honors



博宇的自信与骄傲来自客户的好评，来自广大用户和社会的支持，来自业界同仁的信任。翻出平日的荣誉证书，博宇人坚信：已有的荣誉与骄傲应让其在我们手中延续，将有的荣誉与骄傲，还会从我们手中创造……

Boyu's confidence and pride come from customer praise, support from users and society, and trust from colleagues in the industry. Looking up their usual certificates of honor, Boyu people firmly believe that the existing honors and pride should be allowed to continue in our hands, and the honors and pride that will be present will be created from our hands