

2012

年制造我国第一台 400KJ 数控液压对击锤  
In 2012, the first set 400KJ CNC hydraulic counterblow hammer is finished.

2011

年制造我国第一台 125KJ U 型机身数控全液压锻锤  
In 2011, the first set 125KJ CNC fully hydraulic die forging hammer with U shape hammer body is finished.

2010

年完成我国第一台 320KJ 蒸汽锻锤数控化改造  
In 2010, the first set 320KJ steam forging hammer CNC innovation was developed in China.

2009

年完成我国第一台 250KJ 蒸汽锻锤数控化改造  
In 2009, the first set 250KJ steam forging hammer CNC innovation was developed in China.

2008

年完成我国第一台 125KJ 蒸汽锻锤数控化改造  
In 2008, the first set 125KJ steam forging hammer CNC innovation was developed in China.

2006

研制出我国第一台 100KJ 机身微动数控液压对击锤  
In 2006, the first set 100KJ CNC hydraulic counterblow hammer with micro-motion of the machine body was developed in China.

2004

年完成我国第一台 80KJ 蒸汽锻锤数控化改造  
In 2004, the first set 80KJ steam die forging hammer CNC innovation was developed in China.

2002

年完成我国第一台具有国际同类产品先进水平的全液压锻锤  
In 2002, the first set CNC fully hydraulic die forging hammer with the international advanced level of similar products was developed in China.

江苏百协精锻机床有限公司

(原海安县百协锻锤有限公司)

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百协机床



BAIXIE



# 关于百协

## ABOUT BAIXIE

中国数控锻锤制造基地——江苏百协锻锤机床有限公司（原海安县百协锻锤有限公司），坐落在中国最具活力的长三角北翼江苏海安经济开发区，位于中国东部交通大动脉沈海高速海安出口处，是中国唯一专业生产数控锻锤的厂家，是一家集科研、生产、销售为一体的江苏省高新技术企业，南通市产学研示范企业。

百协公司具有制造中国最大规格 1000KJ 数控锻锤的综合实力，拥有 TK6916、T6920D 等重量型数控落地锻锤加工设备，拥有起重单件 120 吨能力的大型产品总装车间。公司通过 ISO9001 质量管理体系认证和 CE 认证，并获得数控锻锤出口许可证。

百协公司已成为：

- 中国最专业的数控锻锤制造商；
- 中国最早的数控锻锤制造商；
- 中国门类齐全的数控锻锤制造商；
- 国产最大规格的数控锻锤制造商；
- 国内出口量最大的数控锻锤制造商；
- 国内市场占有量最大的数控锻锤制造商。

数控锻锤是百协公司的主导产品。最新推出的 400KJ 数控全液压对击锤，是国内首创、国际领先，是借鉴了国内外大吨位锻锤先进技术最新设计，通过独特的液压联动对击系统、先进的液压动力驱动系统及人机对话的程序打击控制系统，实现锻锤的高效、节能、环保、高精度、高可靠运行，与同类锻锤设备相比具有显著的性能价格优势。

百协数控锻锤已成功应用于汽车、摩托车、工程机械、液压管件、五金工具、手术器械、不锈钢餐具及航空航天工业，是高精度异型零件如连杆、曲轴、摇臂、转向节、拨叉、连接板、不锈钢刀叉、手术器械理想的现代化锻造成形设备，是自动化精密锻造生产线的核心设备。百协公司全体员工将以“百炼成钢，协力奋进，锻造精品，锤炼人生”的企业精神，始终致力于精密锻造设备及工艺的开发与应用研究，以其先进的技术装备、不断创新的锻锤理论与实践成果昂首屹立于世界先进锻造装备工业之林！

百协锻锤  
BAIXIE

CNC forging hammer manufacturing base in China, Jiangsu Baixie Precision Forging Machinery Co., Ltd. (formerly Hainan Baixie Forging Hammer Co., Ltd.), locating in Jiangsu Hainan Economy & Development Zone in the north of Yangtze River Delta, situating in the Hainan Exit of Yanhai Highway, is the only professional manufacturer of CNC die forging hammer in China, Jiangsu High & New Technology Enterprise with R&D, manufacture and sales and Nantong Industry-academy-research Demonstrative Company.

Baixie has capacity to manufacture China largest 1000 KJ CNC forging hammer, with heavy CNC pit boring & milling equipment such as TK6916, T6920D and so on, and spacious assembly workshop with craning capacity of 120 tons. Baixie has passed ISO9001 Quality Management System Certificate, TÜV Rheinland CE certificate and Export License for CNC forging hammer.

Baixie has been:

- the most professional manufacturer of CNC forging hammers in China;
- the earliest manufacturer of CNC forging hammers in China;
- the most complete manufacturer of CNC forging hammers in China;
- the greatest manufacturer of CNC forging hammers in China;
- the only exporter & manufacturer of CNC forging hammers in China;
- the largest market occupation of CNC forging hammers in China.

CNC forging hammer is the main product of Baixie. Its new 400 KJ CNC counterblow hammer is first in China and advanced in the world. It adopts the advanced technology of the large forging hammer at home and abroad, special hydraulic coupled counterblow system, advanced hydraulic driving system and person-machine program control system ensure its high effect, energy save, environmental protection, best precision and high reliability, which has the advantages of quality and price compared with other similar products.

Baixie's CNC forging hammers have been widely applied in automobile, motorcycle, engine machine, hydraulic tube, hardware, surgical instruments, stainless steel tubeware and spaceflight industry. They are the ideal equipment to produce complicated parts, such as connecting rods, bend axes, rockers, steering knuckle, fork, tie plate, stainless steel knives and forks and surgical instruments, the key equipment of precise forging line.

All the staffs in Baixie will assist on our spirit "Work in collaboration, Apply in specially, Update in reality, Improve in time". Baixie will concentrate on development and research on precision forging equipment, stand firmly in the field of the world advanced forging equipment industry with high technology machine,



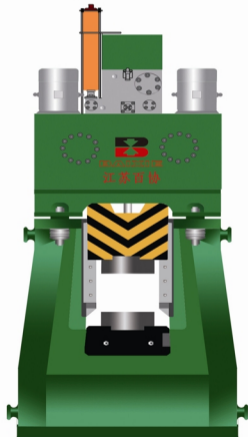


# 现代科技 彰显魅力

## MODERN TECHNOLOGY & CHARM DISPLAY

### CHK 系列数控全液压模锻锤

Series CHK CNC Fully-Hydraulic Die Forging Hammer



#### 技术特征

- 全液压驱动系统，避免油气互窜；
- 高精集成液压控制系统，智能精准控制安装在阀上，实现无管连接，提高了液压系统的效率，更有利于设备维护；
- 液压系统能在工况下进行升降速度动作，操作更安全；
- 先导阀及主阀采用锥阀结构，响应速度快，密封性好，不产生内泄漏；
- 刀架的夹点采用重密封结构，避免了液压油的外溢；
- 特别设计液压油缸及锤杆导向结构，能避免偏心偏摆，有利于延长使用寿命；
- 整体造型线条流畅，外观设计美观，锤头导向精度高保持性好；
- 三重输入式与缸定位，从而使得锤头不受力；
- 触摸屏人机界面，故障自动诊断和报警，方便了设备的操作和维护；
- 打击能量的数字化精确控制，避免了打击过程中能量浪费的现象。

#### 优点

- 高效、节能、安全、可靠、环保；
- 坚固、耐用、密封好、精度高；
- 回程速度快，不回程；
- 操作简单、灵活；
- 可配套自动化生产线；
- 适应性强。

#### 适应性

- 多品种小批量生产；
- 异形零件精密锻造；
- 多模锻制造及封闭式锻造；
- 粉末锻造、合金钢及有色金属锻造。

#### 技术参数 Technical parameters

规格 SPEC.	CHK	16	25	31.5	50	63	80	100	125
打击能量 Striking energy	kJ	16	25	31.5	50	63	80	100	125
锤头质量 Ram weight	kg	1100	1750	2250	3400	4200	5400	6800	8400
打击频率 Striking frequency	min <sup>-1</sup>	100	90	90	90	80	80	75	70
电机功率 Motor power	kW	30	55	55	2X55	2X55	2X90	2X110	
机器质量 Machine weight	T	26	41	51	85	100	125	150	195

#### Technical feature

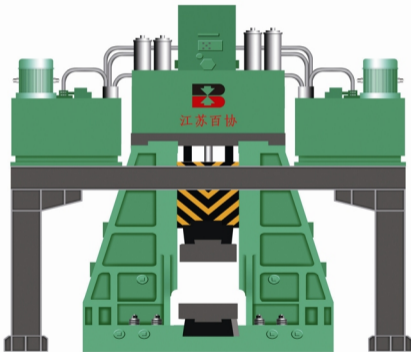
- Fully hydraulic driving system, avoiding oil and steam air crossing;
- High integrated hydraulic control system and accumulator fixed directly on main valve block without any pipe connecting, improving hydraulic system efficiency and easy to maintenance;
- Slow up and down in the case of releasing hydraulic system pressure, safer to operate;
- Taper priority valves and main valves structure, to get high response speed, good sealing performance and no internal leakage;
- Advanced high and low pressure double sealing structure, avoiding oil leakage;
- Special reparable oil cylinder and piston rods guiding structures, suitable for off-center forging and extending piston rod life;
- One piece casting U frame and radial wide guide rails, to get stable and high ram accuracy;
- Initial guide rails allocation in three side, get no stress to guide rails screw;
- Touch screen man-machine interface and automatic malfunction diagnosis and alarm, easy for machine operation and maintenance;
- Digitized and exacted controlling striking energy, avoiding surplus energy harm during striking.

#### Advantages

- High efficiency, energy saving, safety, reliability and environmental protection;
- Firmness, durability, good rigidity and high accuracy;
- Return quickly, unclonced die;
- Easy and flexible operation;
- Be equipped with automatic forging line;
- Wide application.

#### Application

- Parts with small batch but many kinds;
- Precision forging of irregular and complex parts;
- Forge with several mold cavities and closed forging;
- Powder forgings, alloy steel forgings and non-ferrous metal forgings.



## 基本结构

- 全液压动力系统高度集成，无需泵房、地面液压站；
- 可编程打击控制，数字化输入；
- 长锤头结构，可提高工作精度；
- 打击能量、打击步序可任意设定，无多余能量的打击，可降低打击噪音，提高模具寿命；
- 人机界面，故障自动诊断，中英文显示。

## Basic construct

- High integrated fully hydraulic driving system, no need of pump chamber and hydraulic station;
- Programmable striking control and digital inputting;
- Long hammer top enhancing working accuracy;
- Striking energy and striking sequence set optionally without surplus striking energy avoiding noise and increasing the die life
- Man-machine interface and automatically malfunction diagnosis, Chinese and English display.

## 性能特点

- 高效、节能；
- 稳定的锻件质量；
- 较低的运行费用；
- 广泛的适用性；
- 较低的投资成本；
- 简单的维护与操作。

## Performance and features

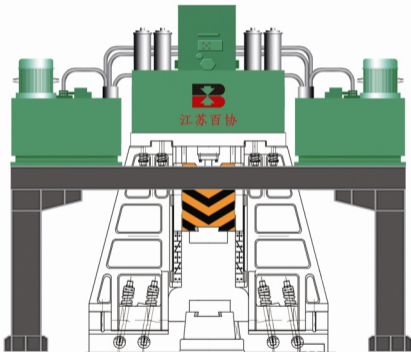
- High efficient, energy saving;
- Consistent quality of forging;
- Lower run cost;
- Wide application;
- Lower investment cost;
- Easy maintenance and operation.

## 技术参数 Technical parameters

规格 SPEC	CTKA	160	200	250	320	400
打击能量 Striking energy	kJ	160	200	250	320	400
锤头质量 Ram weight	kg	9000	10000	11500	13000	17000
打击行程 Striking stroke	mm	1000	1050	1100	1200	1300
打击频率 Striking frequency	min <sup>-1</sup>	60	55	50	45	45
电机功率 Motor power	kW	4x75	4x90	4x90	4x100	6x110

## CTK 系列数控全液压模锻锤(换头)

Series CTK CNC Fully-Hydraulic Die Forging Hammer  
(Hydraulic drive conversion)



### 基本结构

- 全液压动力系统高度集成，无需泵房、地面液压站；
- 可编程打击控制，数字化输入；
- 长锤头结构，可提高工作精度；
- 打击能量、打击步序可任意设定，无多余能量的打击，可降低打击噪音，提高模具寿命；
- 人机界面，故障自动诊断，中英文显示。

### Basic construct

- High integrated fully hydraulic driving system, no need of pump chamber and hydraulic station;
- Programmable striking control and digital inputting;
- Long hammer top enhancing working accuracy;
- Striking energy and striking sequence set optionally without surplus striking energy avoiding noise and increasing the die life
- Man-machine interface and automatically malfunction diagnosis, Chinese and English display.

### 性能特点

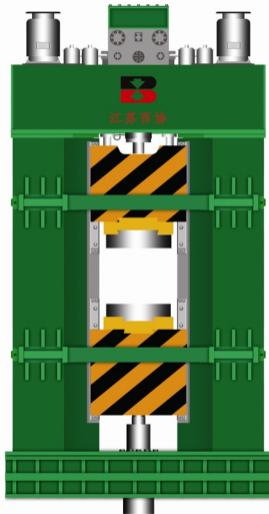
- 高效、节能；
- 稳定的锻件质量；
- 较低的运行费用；
- 广泛的适用性；
- 较低的投资成本；
- 简单的维护与操作。

### Performance and features

- High efficient, energy saving;
- Consistent quality of forging;
- Lower run cost;
- Wide application;
- Lower investment cost;
- Easy maintenance and operation.

### 技术参数 Technical parameters

规格 SPEC	CTK	25	50	75	125	250	320	400
打击能量 Striking energy	kJ	25	50	75	125	250	320	400
锤头质量 Ram weight	kg	1750	3400	5100	8000	11500	13000	17000
打击行程 Striking stroke	mm	720	850	900	1000	1100	1200	1300
打击频率 Striking frequency	min <sup>-1</sup>	90	80	70	60	50	45	45
电机功率 Motor power	kW	55	2x55	2x90	4x55	4x90	4x110	6x110



## 基本配置

- ▶ 锤杆、活塞所用密封件均为进口件；
- ▶ 配有自动润滑系统；
- ▶ 配有油温、压力数字显示在线检测器（德国）；
- ▶ 配有德国西门子电子控制系统；
- ▶ 配有德国西门子人机界面；
- ▶ 配有旁路循环冷却、过滤系统；
- ▶ 所用主油泵为斜轴式柱塞泵；
- ▶ 配有42个故障检测点（液压、电气），其中36个为自动检测点；
- ▶ 铆钉焊接结构；
- ▶ 等质量锤头通过液压联动实现等行程单空对击。

## 性能特点

- ▶ 高度集成的动力头采用数控全液压驱动原理，真正实现无管化连接，基本无泄露，高效、节能；
- ▶ 多重安全措施，周到的在线检测，简洁的系统设计，确保安全、可靠；
- ▶ 具有一般、数控两种能量控制方式，可任意变换、设定，操作简单；
- ▶ 所用液压缸90%为标准元件件，原理结构简单，生产运行费用低。

## 技术参数 Technical parameters

规格 SPEC	CDKA	160	200	250	320	400
打击能量 Striking energy	kJ	160	200	250	320	400
上锤头质量 Ram weight (up)	kg	18000	23000	29000	35000	48000
下锤头质量 Ram weight (down)	kg	20000	25000	32000	39000	52000
上锤头打击行程 Striking stroke (up ram)	mm	630	700	700	700	700
下锤头打击行程 Striking stroke (down ram)	mm	630	700	700	700	700
打击频率 Striking frequency	min <sup>-1</sup>	50	50	45	45	40
主电机功率 Main motor power	kW	220	264	360	440	528

## Basic disposition

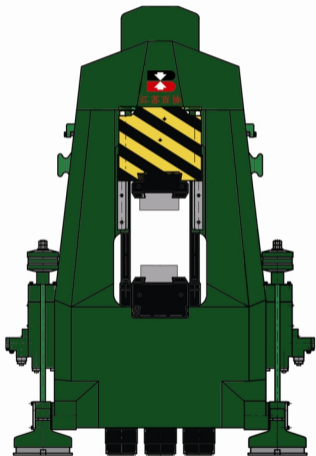
- ▶ Imported sealed parts used in the hammer rod and piston;
- ▶ Automatic lubricating system;
- ▶ On-line digital display detector of oil temperature and pressure (Germany);
- ▶ Electronic control system of SIEMENS;
- ▶ Man-machine conversation screen of SIEMENS;
- ▶ Bypass circular cooling and filter system;
- ▶ Main oil pumps: angle-type plunger pumps;
- ▶ 42 malfunction check points (hydraulic, electronic) with 36 automatic check points;
- ▶ Welding hammer framework;
- ▶ The counterblow hammer's rams which have the equal weight strike each other with equal striking stroke by the hydraulic driving.

## Performance and features

- ▶ High integrated power units adopts CNC fully hydraulic driving to realize no pipes connecting to ensure no leakage, high efficiency and energy saving;
- ▶ Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability;
- ▶ Normal CNC energy control ways can be adjusted and set optionally and easily;
- ▶ 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost.

## CDK 型机身微动数控液压对击锤

Series CDK CNC Hydraulic Counterblow Hammer With Body Micro-Motion



### 基本结构

- ▶ 柱塞缸密封为进口件；
- ▶ 配有自动润滑系统；
- ▶ 配有油温、压力数字显示在线检测器（德国）；
- ▶ 配有日本三菱公司电子控制系统；
- ▶ 配有日本三菱公司人机界面；
- ▶ 配有旁路循环冷却、过滤系统；
- ▶ 所用主油缸为斜轴式注射泵；
- ▶ 配有42个故障检测点（液压、电器），其中36个为自动检测点；
- ▶ 铸钢机架。

### 性能特点

- ▶ 微动式控制、高度集成的液压系统，基本无泄露，高效、节能；
- ▶ 多重安全措施、周密的在线检测、简介的系统设计，确保安全、可靠；
- ▶ 具有一批、数控两种能量控制方式，可任意变换、设定，操作简单；
- ▶ 所用液压件90%为标准易购件，原理结构简单，生产运行费用低；
- ▶ 较低的投资成本。

### 技术参数 Technical parameters

规格 SPEC	CDK	40	63	100
打击能量 Striking energy	kJ	40	63	100
锤头重量 Ram weight	kg	2200	3100	4500
打击行程 Striking stroke	mm	500	600	640
打击频率 Striking frequency	min <sup>-1</sup>	60	60	60
电机功率 Motor power	kW	75	2x55	2x75

### Basic disposition

- ▶ Imported sealed parts used in the plunger case;
- ▶ Automatic lubricating system;
- ▶ On-line digital display detector of oil temperature and pressure (Germany);
- ▶ Electronic control system of Mitsubishi;
- ▶ Man-machine conversation screen of Mitsubishi;
- ▶ Bypass circular cooling and filter system;
- ▶ Main oil pumps: angle-type plunger pumps;
- ▶ 42 malfunction check points (hydraulic, electronic) with 36 automatic check points;
- ▶ Casting steel hammer framework.

### Performance and features

- ▶ High integrated hydraulic system with tapered valve control, no leakage, high efficiency and energy saving;
- ▶ Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability;
- ▶ Normal CNC energy control ways can be adjusted and set optionally and easily;
- ▶ 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost;
- ▶ Lower investing cost.

## CZD 型系列空气单臂锤

Series CDZ Air Single Frame Hammer

### ■ 产品简介 Product Profiles

CZD空气锤和传统的1000kg、750kg空气锤一样，电机直接带动空气锤的皮带轮转动，通过后缸活塞上下运动，后缸的气体带动前缸的锤杆实现上下打击。与同打击能量的电液锤相比，具有能耗低、打击速度快、运行成本低、故障率低、占地面积小、维修方便等优点。

CZD air hammer is like traditional 1000kg and 750kg air hammer, the motor drives the belt wheel of air hammer, through the up and down motion of rear cylinder piston, the gas in rear cylinder drives up the hammer stem of the front cylinder to realize the up and down strike. Compared with the electro-hydraulic hammer of identical striking energy, it is of low energy consumption, fast striking speed, low operation cost, low failure rate, small area covered, and convenience in repair.



### ■ 技术参数 Technical Parameters

项 目	单位	CZD-1750	CZD-2500	项 目		单位	CZD-1750	CZD-2500
				电 机	电 机			
落下部分质量	kg	≈1850	2500	电 机 功 率	kw	110	132	
最大打击能量	kJ	54	75					
锤头打击次数	min <sup>-1</sup>	95	72					
锤杆中心至锤身距离	mm	900	1000	锤 杆 尺 寸	mm	480	500	
						2250	2460	
工作区高度	mm	1050	1200	机 身 总 质 量	kg	36000	45000	
锻锤最大材料厚度	mm	400×400	500×500	总 质 量	kg	24000	31000	
锻锤最大材料直径	mm	φ420	φ520					

### ■ CZD2500空气锤与3T电液锤对比

	落下部分质量	最大打击能量	锤头打击次数	锤杆中心至锤身距离	电机功率
CZD2500空气锤	2500kg	75kJ	72次/分	1000mm	132kw
3T电液锤	2000kg	70kJ	50-60次/分	800mm	55kw×3=165kw

## C41 型系列空气锤

Series C41 Air Hammer

### ■ 产品简介 Product Profiles

本锤适用于锻工车间各种形状零件的自由锻造。如延伸、锻粗、冲孔、热剪、锻接、锻粗和弯曲等。使用开式垫模可以进行各种模锻。

This hammer is applicable for the free forging for parts of all the shapes at forging workshop, such as extension, upsetting, hole stamping, hot shear, forged connection, twisting and bending. All sorts of mold forging can be conducted with open cushion mold.



### ■ 技术参数 Technical Parameters

项 目	单位	C41-60	C41-85	C41-75	C41-150	C41-200	C41-250	C41-500B	C41-750B	C41-1000	C41-1500	
		落下部分质量	kg	40	65	70	190	200	250	560	750	1000
最大打击能量	kJ	0.53	0.9	1.0	2.2	4.0	5.8	13.7	19.0	26.5	54	
锤头打击次数	min <sup>-1</sup>	245	200	210	160	140	140	115	105	95	80	
锤杆中心至锤身距离	mm	235	290	300	300	395	420	550	750	800	900	
工作区高度	mm	224	270	300	370	420	450	600	670	620	800	
锻锤最大材料厚度	mm	52×52	60×60	65×65	120×130	150×150	160×160	270×270	270×270	300×300	400×400	
锻锤最大材料直径	mm	φ58	φ75	φ85	φ145	φ170	φ175	φ280	φ300	φ330	φ450	
电动机功率	kw	4	7.5	7.5	15	18.5	22	37	55	75	110	
锤 杆 尺 寸	宽	mm	1180	1380	1440	2375	2500	2660	3360	3670	4120	4500
	高	mm	690	840	800	1085	900	1150	1425	1290	1590	1900
	内 径	mm	1140	1780	1800	2150	2300	2540	3060	3170	3400	4120
机身总质量	kg	620	1900	1950	2050	2600	5000	11200	18000	20000	30000	
总质量	kg	480	1000	1000	1610	2300	5000	5720	9000	13000	16000	



## DCH 系列锻造操作机

Series CDZ Forging Operation Machine

### 产品简介 Product Profiles

锻造操作机适用于锻造和锻压行业，与各种自由锻锤及压机配合，能完成送料成形的各种工序；对减轻劳动强度、提高生产效率具有重要作用；是锻造行业不可缺少的辅助设备。

DCH系列操作机。采用电动机驱动完成钳架前后升降、倾斜、大车前后移动；液压驱动完成钳头夹持动作。

DCH系列操作机，钳架提升空间可不受限制，尤其适用于锻造大型件或常用马架时锻造工件。



Forging operation machine is applicable for forging and press industry. It cooperates with all sorts of free forging hammers and presses, can accomplish all the steps in bigot profiling. It is of important function for reduction of labor intensity and boosting production efficiency; it is indispensable auxiliary equipment in forging industry.

DCH series operation machine. It is driven by motor to accomplish the forward and backward rising, tilting of tong hold, as well as movement of chassis; and can act the pincer clutch by hydraulic driving.

For DCH series operation machine, the long hold lifting space is unlimited. It is especially suitable for making heavy forging or forging involving mandrel supporter.



### 技术参数 Technical Parameters

型号	起重重量	夹持材料直径		钳杆中心线到钳架高度		钳杆中心距	钳杆伸出量	钳杆长度	钳杆重量	钳杆上倾角	钳杆下倾角	钳杆总功率	钳架外形尺寸			机器总重量			
		最小	最大	最小	最大								长	宽	高				
DC30	30	90	120	600	835	1435	2000	20	1750	32	7.4	10	地置	10	89	730	3185	3055	28
DC50	50	100	150	800	935	1635	2000	20	2000	32	7.4	10	地置	10	89	730	3185	3055	32
DC100	100	200	200	1000	900	2700	3500	12	2115	17.5	5.8	10	地置	10	182	1800	4200	5800	90
DC160	160	300	280	1250	950	2750	3500	12	2250	17.5	5.2	10	地置	10	319	1100	4000	6000	110
DC200	200	400	350	1400	1000	3500	3500	12	2300	15	4.8	10	地置	10	275	1200	4500	6800	150
DC300	300	600	400	1500	1100	3100	3000	11	2800	15	4.8	10	地置	10	330	1300	4000	6400	130
DC400	400	1000	400	1600	1100	3100	4000	10	3000	13.5	4.5	10	地置	10	370	1300	5200	6800	190
DC500	500	1250	400	1700	1100	3100	4000	9	3200	13.5	4.5	10	地置	10	410	1400	5200	6800	210
DC1000	1000	2500	600	2200	1300	3800	6000	7	4500	10.5	3.3-4.1	10	地置	10-12	836	1800	4300	6800	500

## DCY系列有轨旋转式锻造操作机

Series DCY Tracked Rotary Forging Operation Machine

### 产品简介 Product Profiles

锻造操作机适用于锻造和锻压行业，与各种自由锻锤及压机配合，能完成送料成形的各种工序；对减轻劳动强度、提高生产效率具有重要作用；是锻造行业不可缺少的辅助设备。

DCY系列有轨旋转式锻造操作机，采用液压驱动完成钳架前后升降、倾斜、钳头夹持、钳头翻转和大车旋转等动作；电动机驱动完成大车前后移动。

DCY系列有轨旋转式锻造操作机能任意角度旋转，具有操作方便、动作灵活可靠，适宜配套5T以下的锻锤和小型压机。



Forging operation machine is applicable for forging and press sector, can cooperate with all sorts of free forging hammer and press, and accomplish all the steps in bigot profiling. It is of important function for reduction of labor intensity and boosting production efficiency; it is indispensable auxiliary equipment in forging industry.

DCY series tracked rotary forging operation machine accomplishes forward and backward raising of tong hold, tilting, pincer clatching, pincer flip and chassis rotation actions by hydraulic driving, the motor drives machine to complete forward and backward motion of chassis.

DCY series tracked rotary forging operation machine can rotate at any angle, is of convenient operation, flexible and reliable action, and is suitable to match with forging hammer and small press less than 5T.

### 技术参数 Technical Parameters

项 目	单 位	DCY10	DCY20	DCY30	DCY50	项 目	单 位	DCY10	DCY20	DCY30	DCY50	
载重量	KN	10	20	30	50	钳杆上倾角	°	5	6	5	14	
夹持力矩	KNm	20	40	60	100	钳杆下倾角	°	5	6	7	14	
						最小	mm	100	100	150	钳杆伸出量	mm
最大	mm	350	450	450	600	钳架回转速	Mpa	10	10	10	10	
钳杆中心线距	最小	mm	700	740	740	800	机架回转直径	mm	5050	5360	5710	7570
轨道高度	最大	mm	1100	1340	1340	1600	电动机总功率	Kw	16.5	32.5	37	66
									轨道中心距	mm	1600	1600
钳头转速	r.p.m	30	20	20	20	机器外形尺寸	宽	mm	2368	2400	2710	3000
大车前进速度	m/min	42	42	32	30	高	mm	2530	2560	2980	3280	
								水旱提升速度	m/min	5	5	5



# 百协品牌 领航锻造

## BAIXIE BRAND THE PIONEER IN FORGING



山东农具CHK31.5kJ-CHK80kJ 4条模锻线  
CHK31.5kJ-CHK80kJ rigging forging  
lines in Shandong (4 lines)



安徽转向节CHK80kJ模锻线  
CHK80 steering knuckle forging line in Anhui



苏州餐具CHK16kJ 2条自动化模锻线  
CHK16kJ tableware automatic forging  
lines in Suzhou (2 lines)



巴西五金工具CHK25kJ模锻线  
CHK25kJ hand tool forging line in Brazil



景县叉车零件CHK25kJ-CHK31.5kJ 4条模锻线  
CHK25kJ-CHK31.5kJ forklift part forging  
lines in Jingxian (4 lines)



德阳东汽叶片CHK80kJ-CTK125kJ 2条模锻线  
CHK80kJ-CTK125kJ vane forging lines in  
Deyang Dongfang Turbine Co.,Ltd (2 lines)



俄罗斯工具CHK25模锻线  
CHK25 hand tool forging line in Russia



景县工程机械CHK25kJ-CHK31.5kJ 3条模锻线  
CHK25kJ-CHK31.5kJ engineering machine parts  
forging lines in Jingxian (3 lines)



江苏锚链CHK16kJ-CHK125kJ 4条模锻线  
CHK16kJ-CHK125kJ anchor chain forging  
lines in Jiangsu (4 lines)



上海汽车连杆CHK31.5kJ-63kJ 2条模锻线  
CHK31.5kJ-CHK63kJ connecting rod forging  
line in Shanghai (2 lines)



台企汽车配件CHK31.5kJ-CHK100kJ 5条模锻线  
CHK31.5kJ-CHK100kJ automobile forging  
lines in Taiwan company (5 lines)



国内首台125kJ U型机身模锻线 (2011年)  
China first set 125kJ forging hammer with U-frame (in 2011)



美国史丹利工具CHK31.5kJ-CHK50kJ 2条模锻线  
CHK31.5kJ-CHK50kJ hand tool forging  
lines in Stanley (2 lines)



景县汽配、叉车配件、机械零件等CHK16kJ-CHK31.5kJ 5条模锻线  
CHK16kJ-CHK31.5kJ automobile, forklift and machinery parts forging  
lines in Jingxian (5 lines)



# 百协品牌 领航锻造

## BAIXIE BRAND THE PIONEER IN FORGING



瑞安汽配CHK25kJ-80kJ 4条模锻线  
CHK25kJ-CHK80kJ automobile parts forging  
lines in Rui'an (4 lines)



上海手术器械CHK16kJ-CHK25kJ 4条模锻线  
CHK16kJ-CHK25kJ Surgical instrument forging  
lines in Shanghai(4 lines)



台湾不锈钢法兰CHK31.5kJ-CHK100kJ 3条模锻线  
CHK31.5kJ-CHK100kJ stainless steel flanges forging  
lines in Taiwan (3 lines)



台湾拍伸直角接头CHK31.5kJ模锻线  
CHK31.5kJ angle coupling forging  
line in Taiwan Bothwell



土耳其汽配CHK31.5K模锻线  
CHK31.5 KJ automobile parts forging  
line in Turkey



山东威力工具CHK25kJ-CHK100kJ 12条模锻线  
CHK25kJ-CHK100kJ hand tools forging  
lines in Shandong Maxpower Tool Group (12 lines)



越南工具CHK31.5kJ-CHK50kJ 2条模锻线  
CHK31.5kJ-CHK50kJ hand tools forging  
lines in Vietnam (2 lines)



重庆汽车连杆50kJ模锻线  
CHK50kJ connecting rods forging line in Chongqing



山东铁路配件250kJ模锻线  
CTK250kJ railway parts forging  
line in Shandong



常州汽配CTK125kJ 2条模锻线  
CTK125kJ automobile parts forging  
lines in Changzhou



德阳东汽CTK125kJ 2条模锻线  
CTK125kJ forging lines in Deyang  
Dongfang Turbine Co. Ltd (2 lines)



南汽锻造CTK80kJ模锻线  
CTK80kJ forging lines in Nanqi Forging



青海曲轴CTK320kJ模锻线  
CTK320kJ crank shafts forging line in Qinghai



长春一汽CTK80kJ-CTK125kJ 4条模锻线  
CTK80kJ-CTK125kJ automobile forging  
lines in FAW (4 lines)

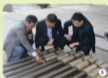


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Customers in Vietnam discussing hammer technology with Baishie engineers

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4. 德国客户来百协考察  
Germany customers visiting Baishie

5. 泰国客户来公司洽谈  
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6. 德国WHA工具公司来百协考察洽谈  
WHA Germany negotiating with Baishie

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8. 叙利亚客户来百协接受培训  
Syria customers receiving training in Baishie

9. 清华大学锻压机械专家顾永华教授在百协考察指导  
Professor Mr. Yan Yonghua in Tsinghua University, a Forging Machinery Specialist, came to Baishie to inspect and instruct.





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# 百协荣誉

## GLORY OF BAIXIE

