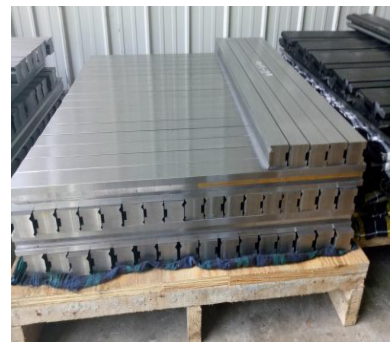
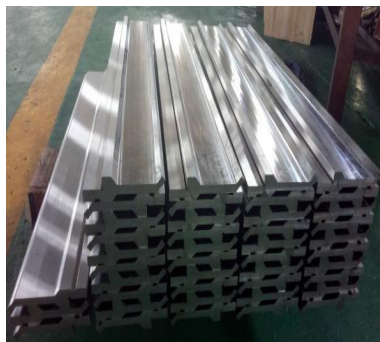
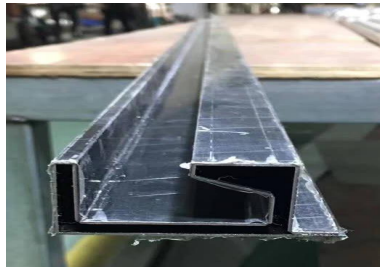


旭祥制模

Xu Xiang's Moulding

折弯成型与剪切的技术

Bending Forming and Cutting Technology



Specializing in manufacturing bending dies

安徽旭祥数控刃模具制造有限公司

Anhui xuxiang blade mould manufacturing co., ltd

企业简介: Company profile

安徽旭祥数控刀模具制造有限公司是一家专业生产和研发折弯机模具现代企业，公司位于钢城马鞍山市博望区博望镇东城工业园区内，距离南京禄口机场仅 18 公里，314 省道贯穿工业园区，交通便利。

公司经过多年的发展，公司已经从传统的加工工艺转向先进的 CAD/CAM 计算机辅助设计与制造，并且引进数控机床的使用，使公司生产研发的模具达到高精度、高效率、高稳定性。公司长期与国内外多家公司简建立长期合作关系，产品受到了广大客户的一致好评。

目前公司拥有雄厚的技术力量、先进的设备、完善的质检体系和独具特色现代化的工业管理。并且一直以“严谨、求实、创新”的敬业精神拓展自己。公司本着“质量为本、诚信第一”的生产、经营理念和一整套行之有效的服务体系，使客户真正的享受到我们的诚信可靠。

发展与成功的经验告诉我们，诚信是我们交流的基石。我们以“诚信是金”的理念结交各界朋友，信奉商道即人道

公司建立了完善的销售服务体系，在全国各大中城市设立了销售公司或办事处，形成了“被覆九州”的广阔辐射面，产品遍布二十多个省市自治区及海外。

多年来，本公司凭借雄厚的实力、良好的信誉及严格的质量管理和优质的售后服务，受到了广大新老客户的一致好评。。

我们是一个讲求奉献的集体；员工奉献才智，企业奉献社会，同时也离不开社会各界人士的鼎力支持，在企业发展步入现代化之际，我们愿与社会各界携手同进，共谋发展，以高品质的产品、系统而专业的服务共铸辉煌的明天。

Anhui xuxiang numerical control blade mould manufacturing co., ltd is a modern enterprise specializing in the production and development of bending machine moulds. the company is located in dongcheng industrial park, bowang town, bowang district, Maanshan city, steel city, only 18km from Nanjing lukou airport and 314 provincial roads run through the industrial park with convenient transportation.

After years of development, the company has shifted from traditional processing technology to advanced CAD / CAM computer-aided design and manufacturing, and introduced the use of numerical control machine tools to enable the company to produce and develop molds with high precision, high efficiency and high stability. The company has established long-term cooperative relations with many domestic and foreign companies, and its products have been well received by customers.

At present, the company has strong technical force, advanced equipment, perfect quality inspection system and unique modern industrial management. And has been expanding itself with the dedication spirit of "preciseness, realism and innovation". The company adheres to the production and management philosophy of "quality first, honesty first" and a set of effective service system, so that customers can truly enjoy our honesty and reliability.

The experience of development and success tells us that honesty is the cornerstone of our communication. We make friends from all walks of life with the concept of "honesty is gold" and believe in business as humanity.

The company has established a perfect sales service system, set up sales companies or offices in large and medium-sized cities across the country, and formed a broad "covered Kyushu" with products spread over more than 20 provinces, municipalities, autonomous regions and overseas.

Over the years, the company has been praised by many new and old customers for its strong strength, good reputation, strict quality management and high-quality after-sales service.

We are a dedicated collective; Employees contribute their talents and enterprises contribute to the society. At the same time, they cannot do without the full support of people from all walks of life. We are willing to work hand in hand with all walks of life and seek common development to create a brilliant future with high-quality products and systematic and professional services.

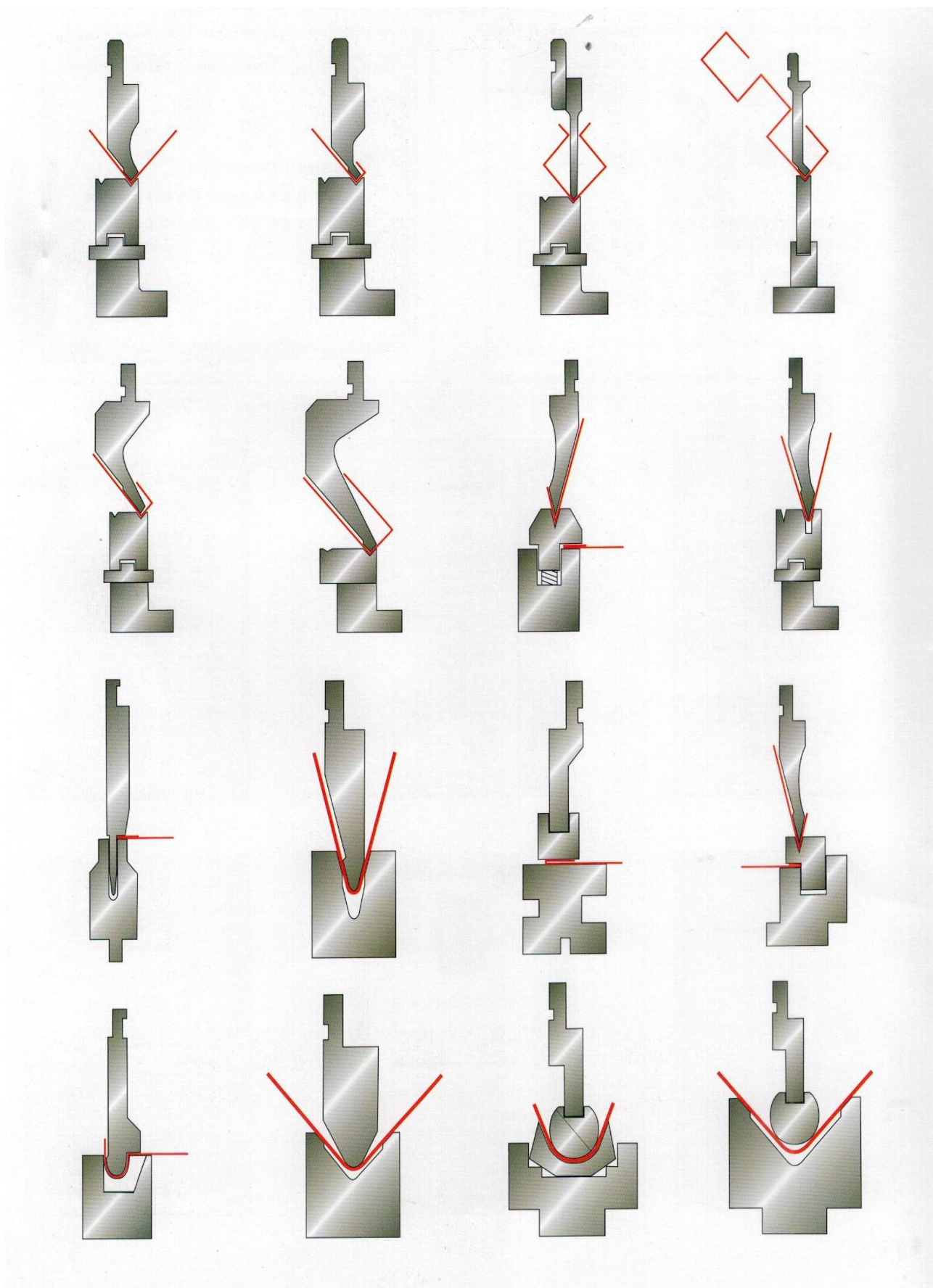
精良的设备和专业化的制造

Perfect equipment and professional manufacture

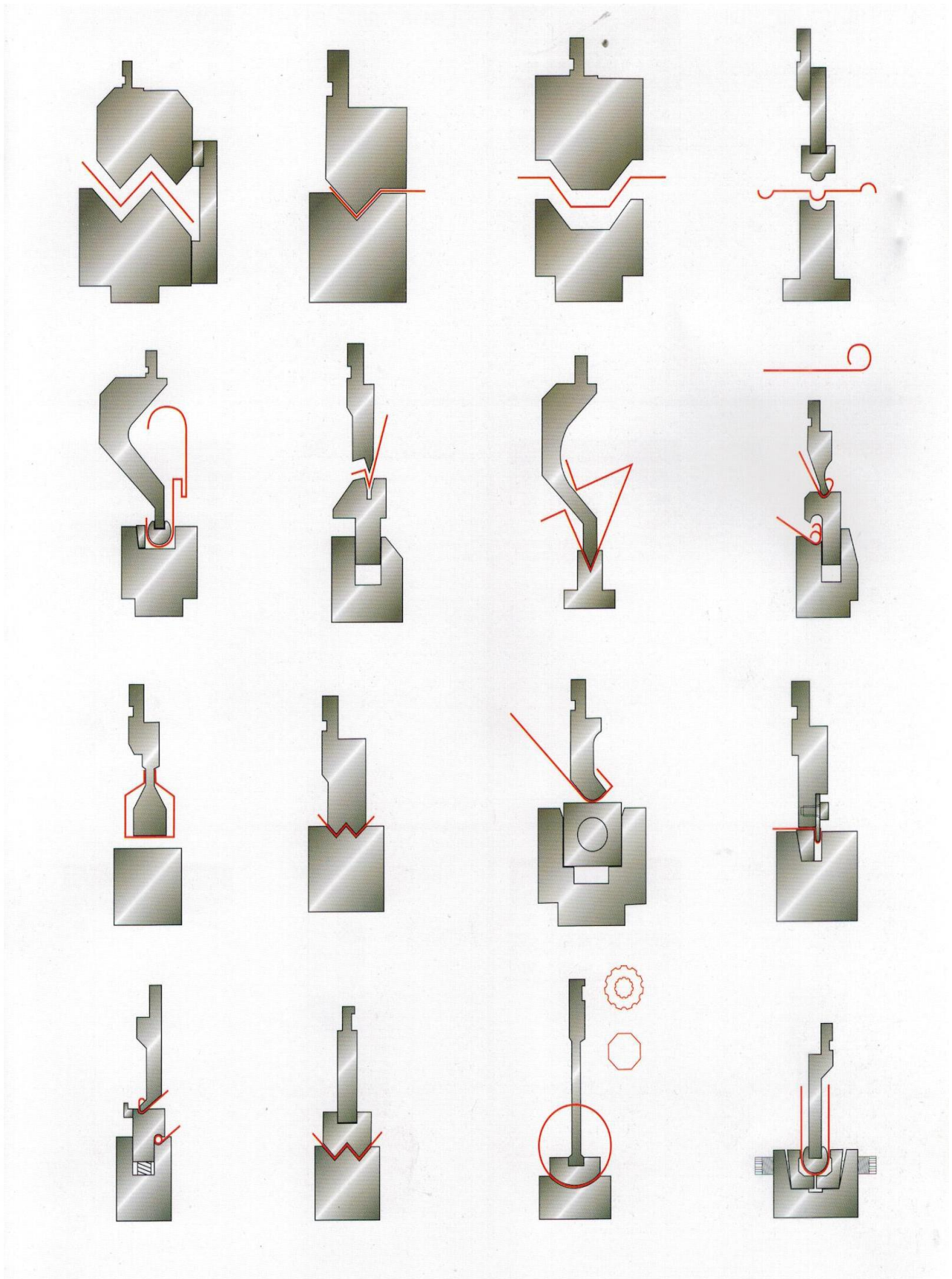
“工欲善其事，必先利其器”，企业一流的生产设备，严密的生产组织管理体系将各生产资源进行优化配置，使我们高端的生产设备物尽其事，使我们的产品品质更加完善……



折弯模具示意图 Press Brake Mold

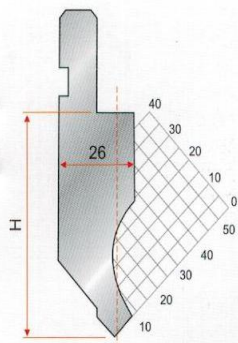


折弯模具示意图 Press Brake Mold



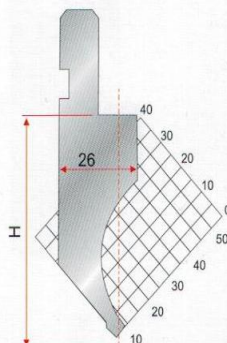
LS10.10 90° 88°

A	R	H	T/M
90°	0.8	66.66	100
88°	0.8	66.66	100
88°	3	66.56	100
90°	0.25	66.62	100
88°	0.25	66.62	100



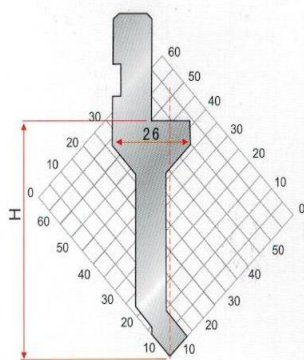
LS116 90° 88°

A	R	H	T/M
90°	0.6	66.42	35
88°	0.6	66.42	35
90°	0.25	66.38	35
88°	0.25	66.38	35



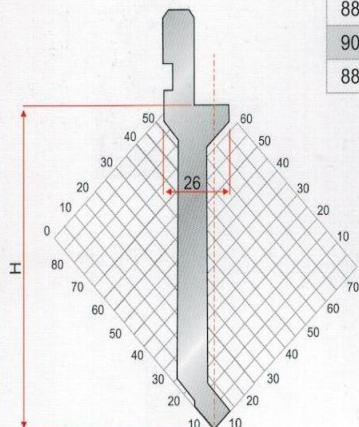
LS200 90° 88°

A	R	H	T/M
90°	0.2	69.66	50
88°	0.2	69.66	50



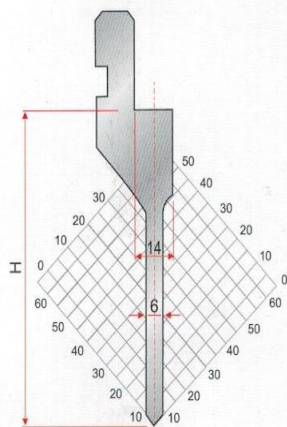
LS202 90° 88°

A	R	H	T/M
90°	0.6	99.42	50
88°	0.6	99.42	50
90°	0.25	99.42	50
88°	0.25	99.42	50



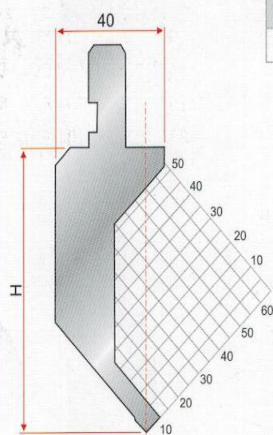
LS109 90° 88°

A	R	H	T/M
90°	0.6	94.42	50
88°	0.6	94.42	50
90°	0.25	94.38	50
88°	0.25	94.38	50



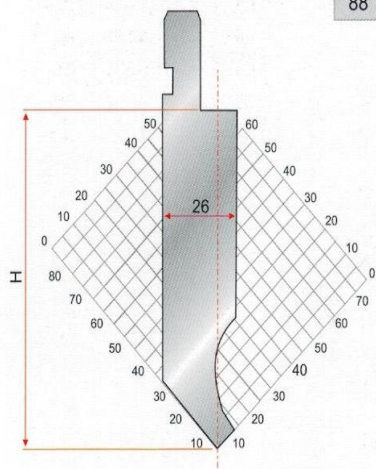
LS16 90° 88°

A	R	H	T/M
90°	0.6	84.20	20
88°	0.6	84.20	20



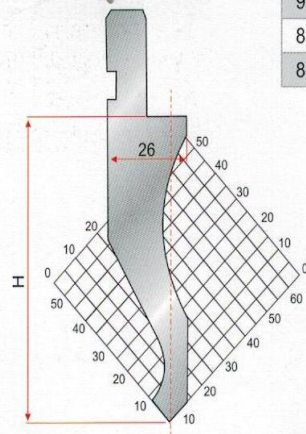
LS118 88°

A	R	H	T/M
88°	0.8	104.66	100



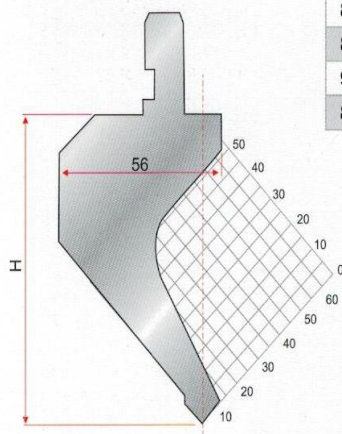
LS20 90° 88°

A	R	H	T/M
90°	0.8	86.06	100
88°	0.8	86.06	100
88°	3	84.86	100



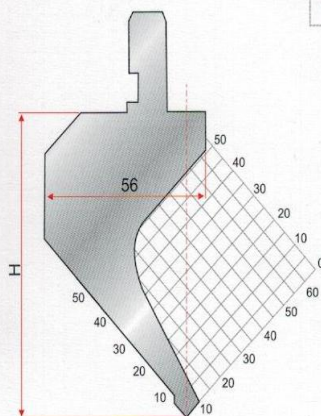
LS10.14 90° 88°

A	R	H	T/M
90°	0.8	89.66	60
88°	0.8	89.66	60
88°	3	88.56	60
90°	0.25	89.62	60
88°	0.25	89.62	60



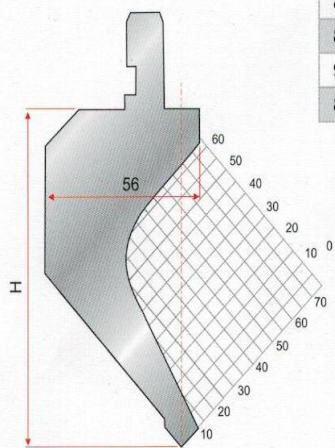
LS10.146 90° 88°

A	R	H	T/M
90°	0.25	89.88	50
88°	0.8	89.66	50



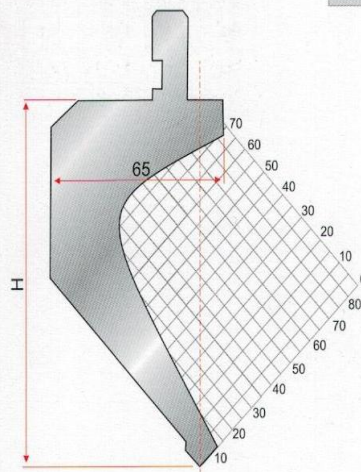
LS10.15 90° 88°

A	R	H	T/M
90°	0.8	104.66	50
88°	0.8	104.66	50
88°	3	103.51	50
90°	0.25	104.61	50
88°	0.25	104.61	50



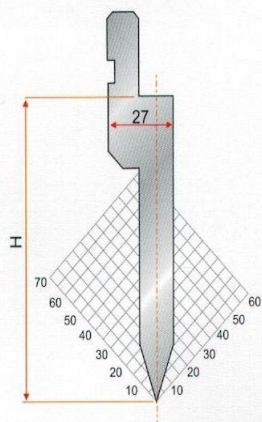
LS10.047 88°

A	R	H	T/M
88°	0.8	119.66	50



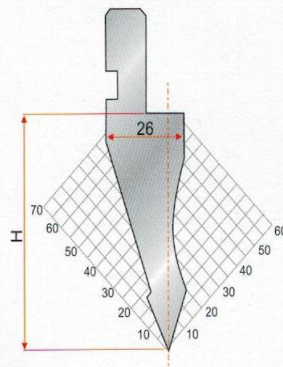
LS18 26°

A	R	H	T/M
26°	0.8	117.06	50



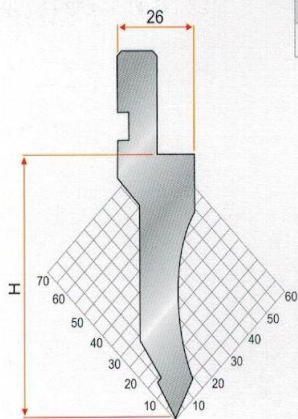
LS11 35° 45°

A	R	H	T/M
35°	0.8	67.06	50
45°	1	65.05	70



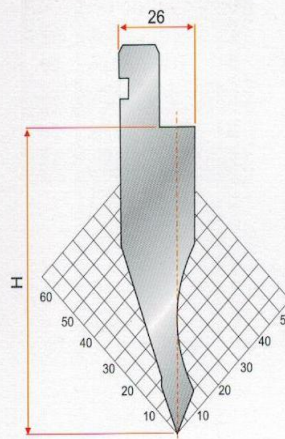
LS20 60°

A	R	H	T/M
60°	0.8	75	70
60°	2	73.8	70



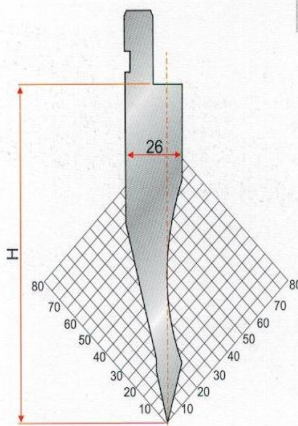
LS12 35°

A	R	H	T/M
35°	0.5	90.06	70
35°	0.8	90.05	70
35°	1.5	90.01	70



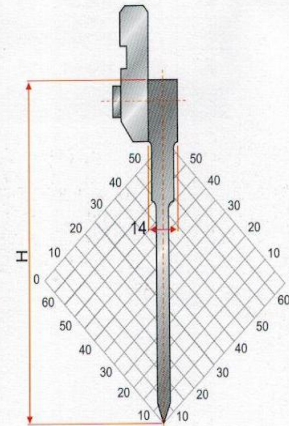
LS10.52 30°

A	R	H	T/M
30°	0.5	135	50
30°	0.5	105	50



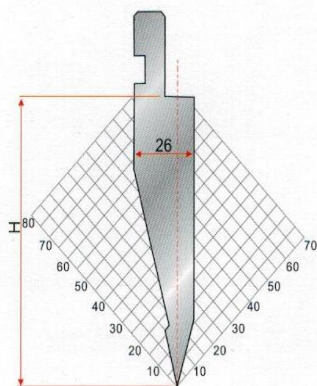
LS10.86 30°

A	R	H	T/M
30°	0.6	140.06	40



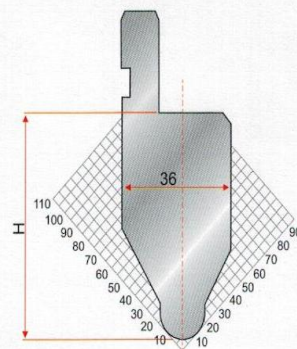
LS10.210 30°

A	R	H	T/M
30°	0.6	104.06	100
30°	3	104.01	100



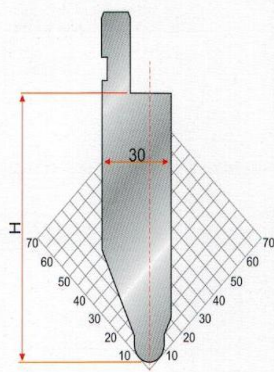
LS13 35° 60°

A	R	H	T/M
35°	5	65.01	100
60°	6	64.98	100



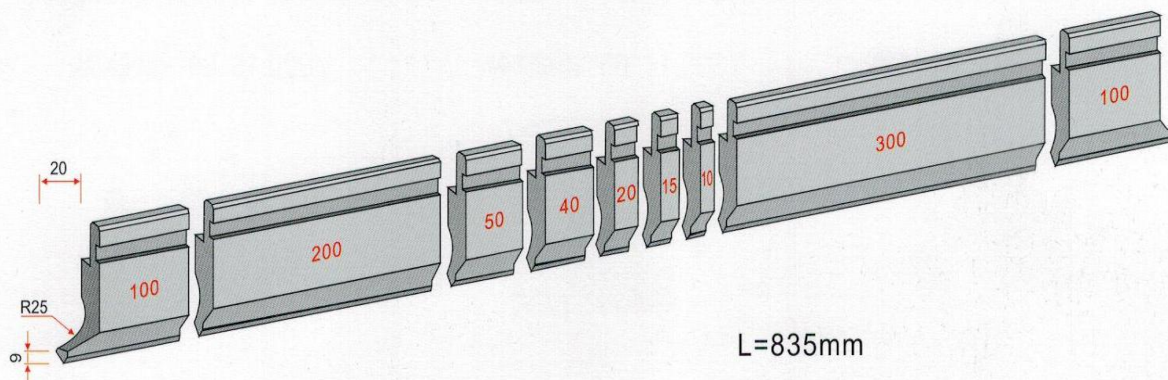
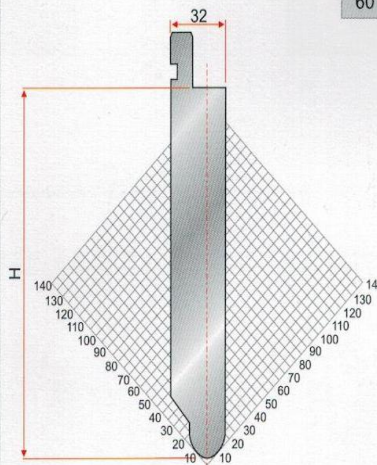
LS10.53 45°

A	R	H	T/M
45°	6	100	100



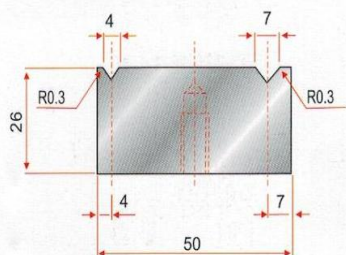
LS10.93 60°

A	R	H	T/M
60°	8	200	150

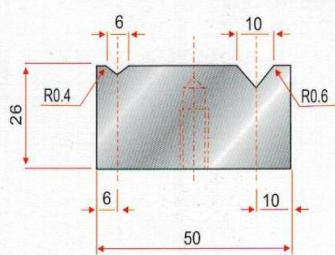


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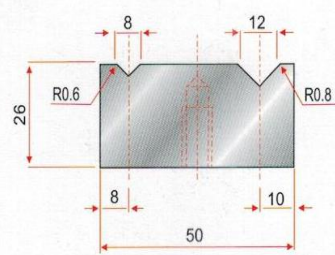
YS121 88° 90° 100T/M



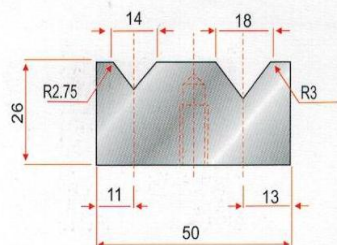
YS123 88° 90° 100T/M



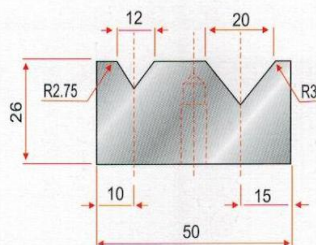
YS124 88° 90° 100T/M



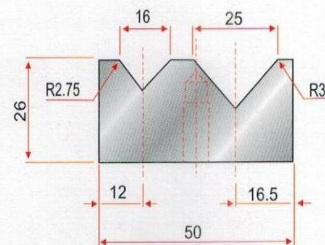
YS125 88° 90° 100T/M



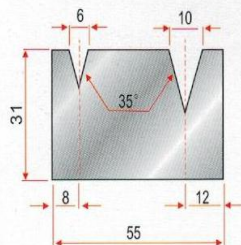
YS126 88° 90° 100T/M



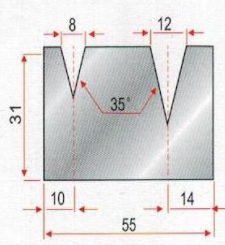
YS127 88° 90° 100T/M



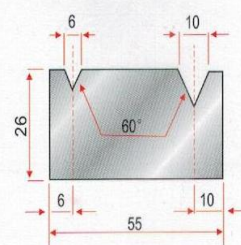
YS20.12 35° 100T/M



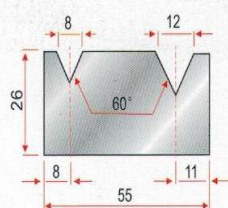
YS20.13 35° 100T/M



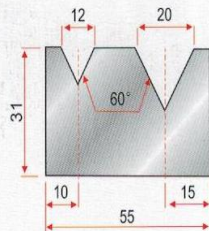
YS20.12 60° 100T/M



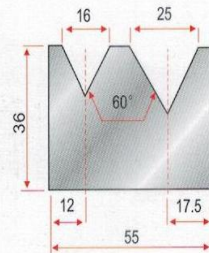
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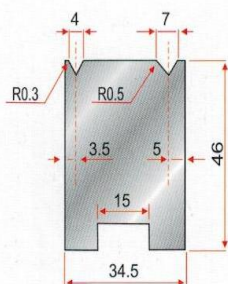
YS20.14 60° 100T/M



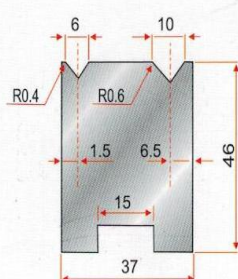
YS20.15 60° 100T/M



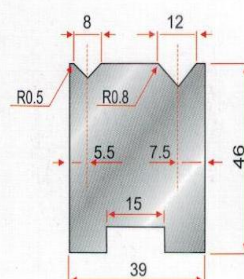
YS501 88° 90° 100T/M



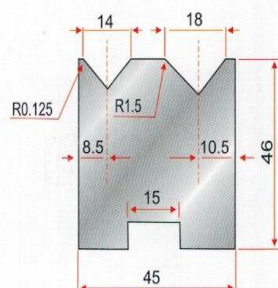
YS502 88° 90° 100T/M



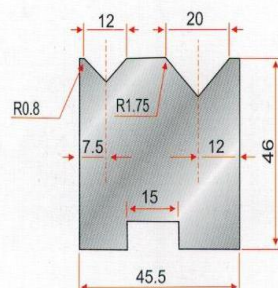
YS503 88° 90° 100T/M



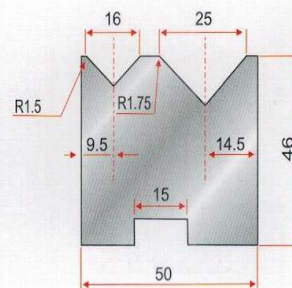
YS504 88° 90° 100T/M



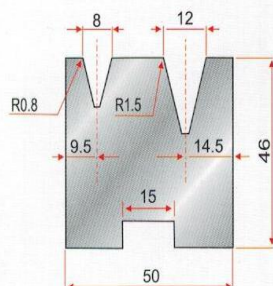
YS505 88° 90° 100T/M



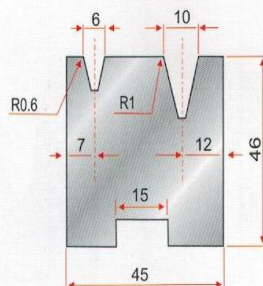
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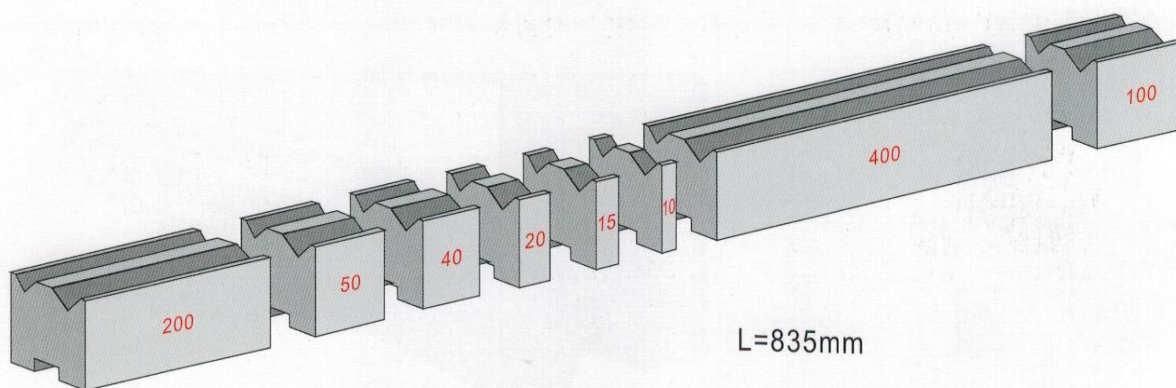
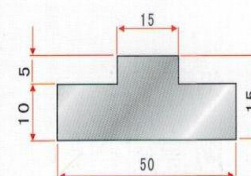
YS507 30° 40T/M



YS508 30° 40T/M

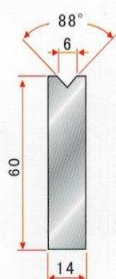


YS40.15

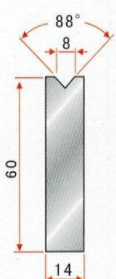


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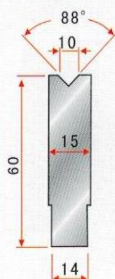
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95T/M



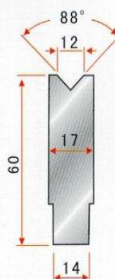
YS71 88° 90°
95T/M



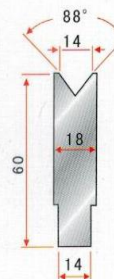
YS72 88° 90°
95T/M



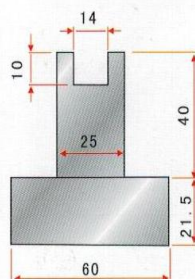
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95T/M



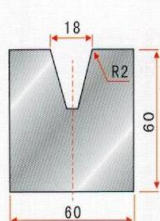
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95T/M



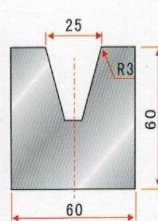
YS40.14



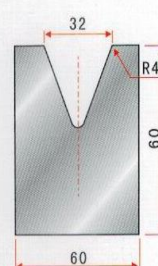
YS20.86 30° 100T/M



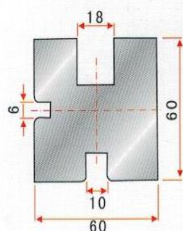
YS20.87 30° 100T/M



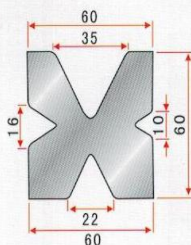
YS20.88 45° 100T/M



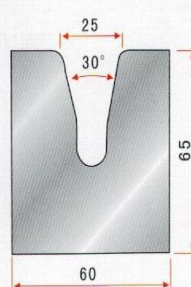
YS208



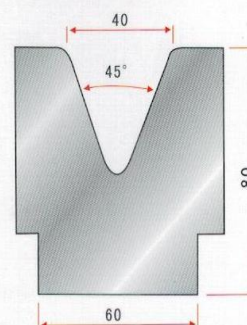
YS209



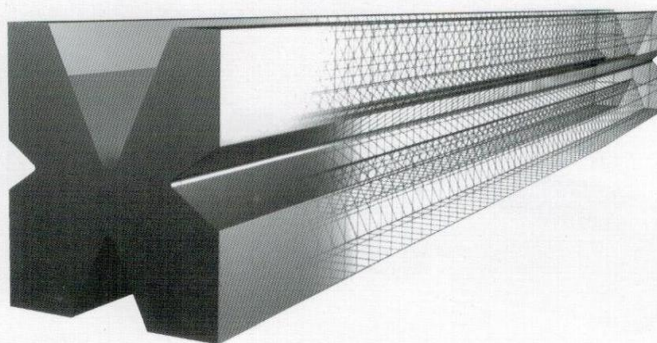
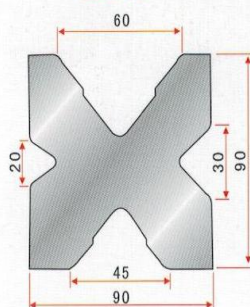
YS341



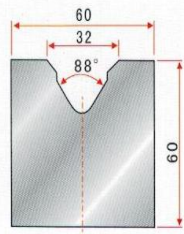
YS343



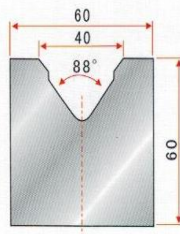
YS210



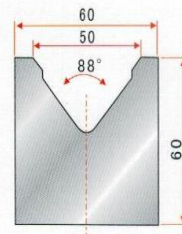
YS20.11/32 100T/M



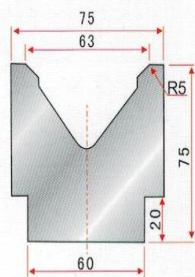
YS20.11/40 100T/M



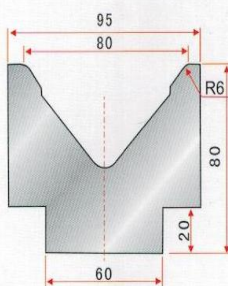
YS20.11/50 100T/M



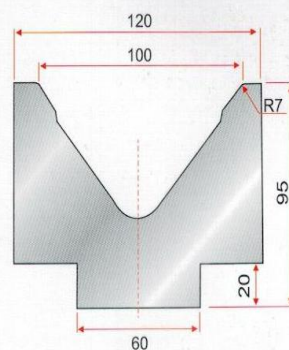
YS20.11/63 100T/M



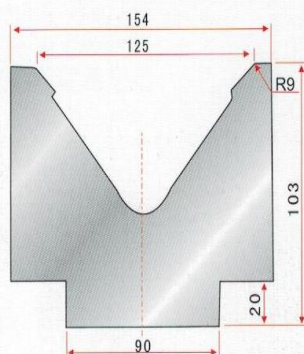
YS20.11/80 100T/M



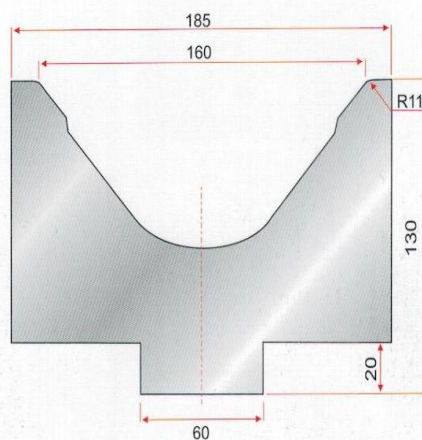
YS20.11/100 100T/M



YS20.11/125 100T/M

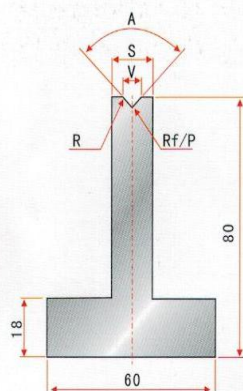


YS20.11/160 100T/M



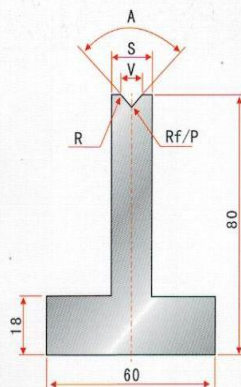
YS010

V	A	R	S	Rf/P	T/M
6	90°	0.4	14	0.5	100
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	60
6	45°	0.4	14	0.5	50
6	30°	0.6	14	1.0	35



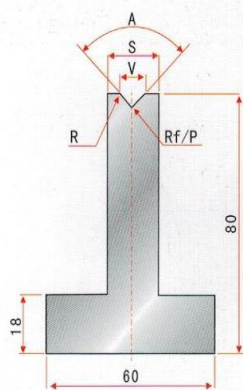
YS011

V	A	R	S	Rf/P	T/M
8	90°	0.5	14	0.5	100
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.8	18	0.5	50
8	30°	0.8	18	2.0	35



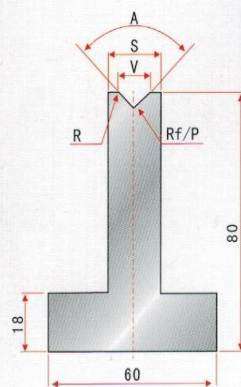
YS012

V	A	R	S	Rf/P	T/M
10	90°	0.6	18	0.5	100
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.5	60
10	45°	1.0	18	0.7	50
10	30°	1.0	24	2.0	50



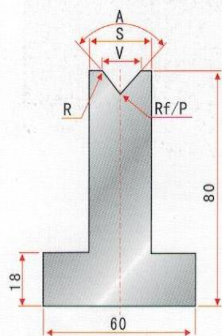
YS013

V	A	R	S	Rf/P	T/M
12	90°	0.8	18	0.5	100
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40



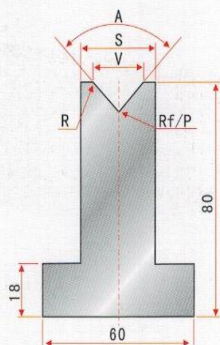
YS014

V	A	R	S	Rf/P	T/M
16	90°	1	24	0.5	100
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	45



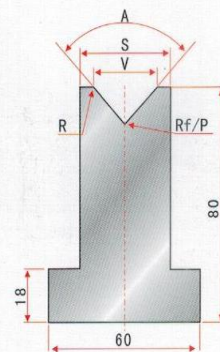
YS015

V	A	R	S	Rf/P	T/M
20	88°	3	30	0.5	100
20	60°	3	30	0.7	60
20	45°	2.5	30	1.0	50
20	30°	2.5	35	5.0	50

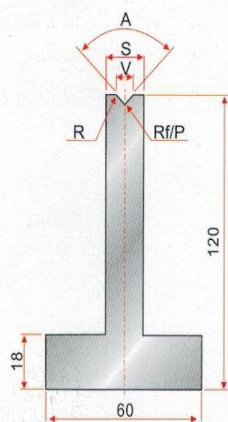


YS016

V	A	R	S	Rf/P	T/M
25	88°	3	35	0.5	100
25	60°	3	35	1.0	60
25	45°	3	35	1.0	50
25	30°	3	40	5.0	50

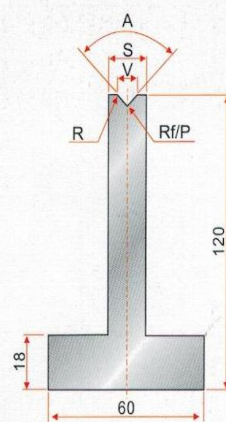


YS017



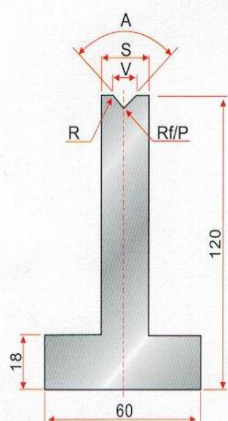
V	A	R	S	Rf/P	T/M
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	60
6	45°	0.6	14	0.5	50
6	30°	0.6	14	1.0	35

YS018



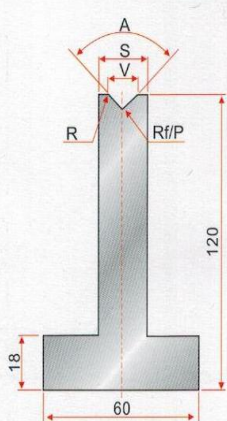
V	A	R	S	Rf/P	T/M
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.8	18	0.5	50
8	30°	0.8	18	2.0	35

YS019



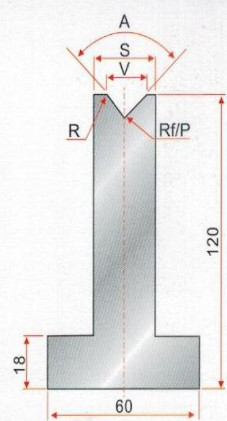
V	A	R	S	Rf/P	T/M
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.5	60
10	45°	1.0	18	0.7	50
10	30°	1.0	24	2.0	50

YS020

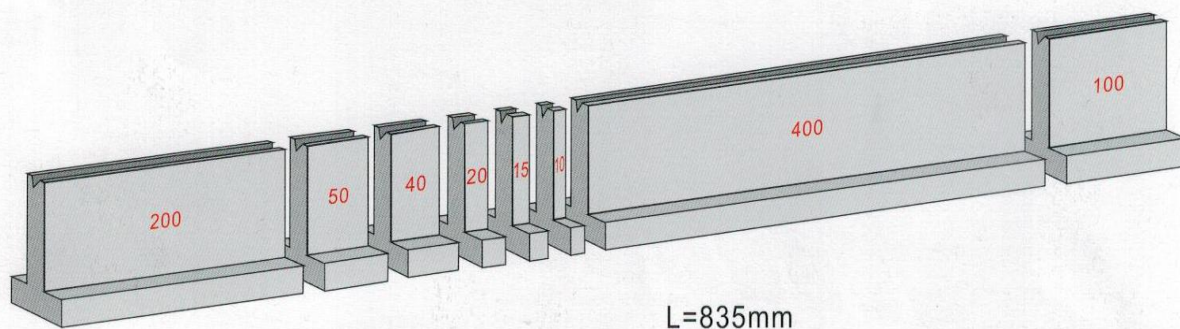


V	A	R	S	Rf/P	T/M
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40

YS021

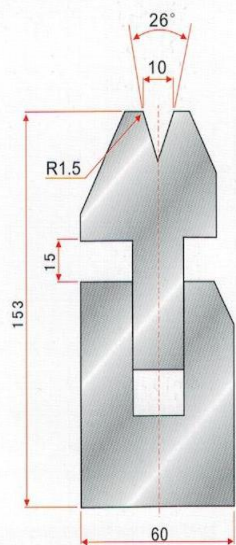


V	A	R	S	Rf/P	T/M
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	45

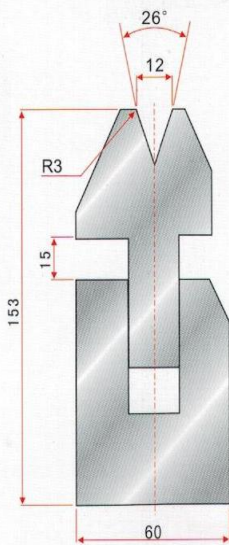


L=835mm

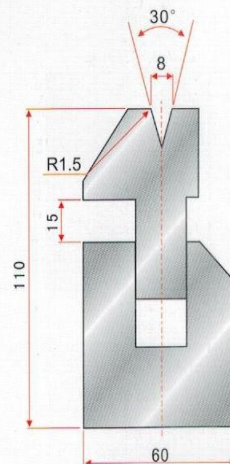
PSS31 26° 100T/M



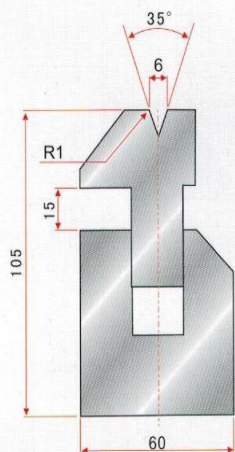
PSS32 26° 100T/M



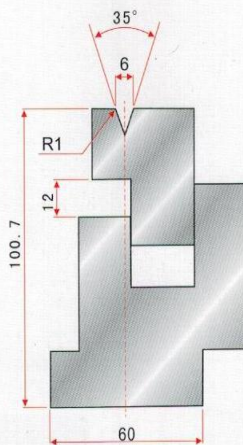
PSS33 30° 80T/M



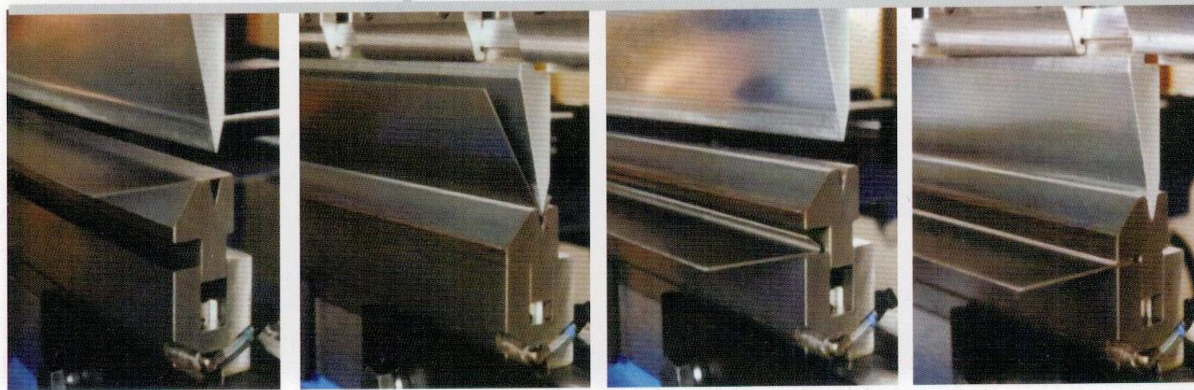
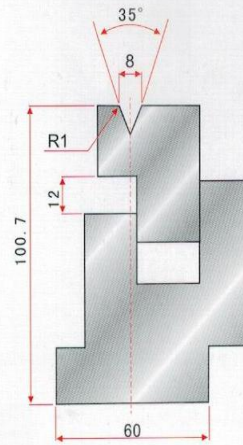
PSS34 35° 80T/M



PSS35 35° 60T/M

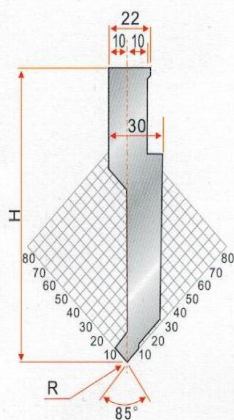


PSS36 35° 60T/M



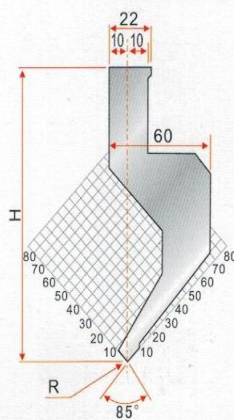
L2S 85°

A	R	H	T/M
85°	1	155	130



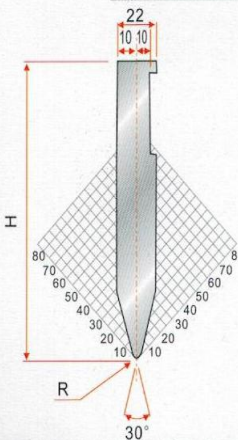
L4S 85°

A	R	H	T/M
85°	0.8	155.05	90
85°	1.5	155.03	90



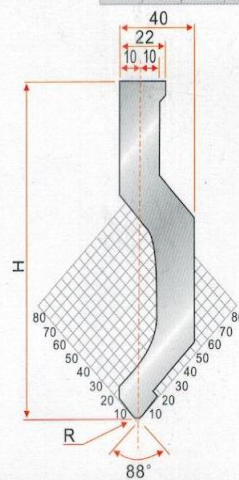
L6S 30°

A	R	H	T/M
30°	1	155.04	160
30°	3	155.01	160



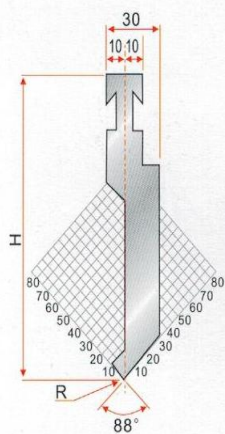
L8S 88°

A	R	H	T/M
88°	1	155	80



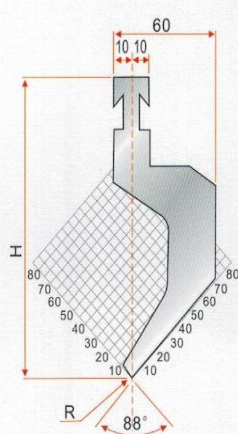
L2R 88°

A	R	H	T/M
88°	1	155	100



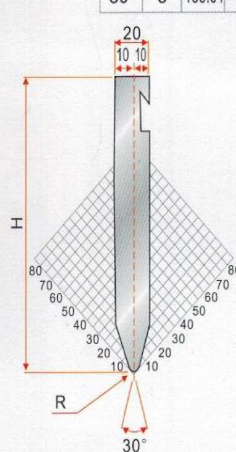
L4R 88°

A	R	H	T/M
88°	1.5	155	80



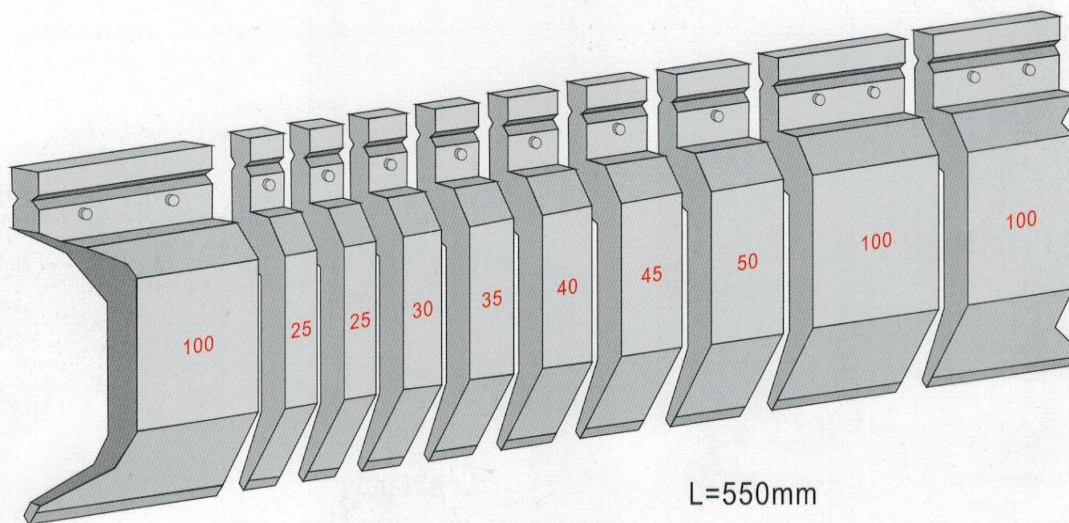
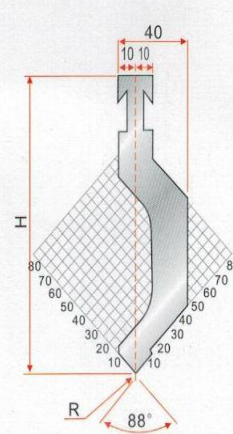
L7R 30°

A	R	H	T/M
30°	1	155.04	160
30°	3	155.01	160



L8R 88°

A	R	H	T/M
88°	1	155	100

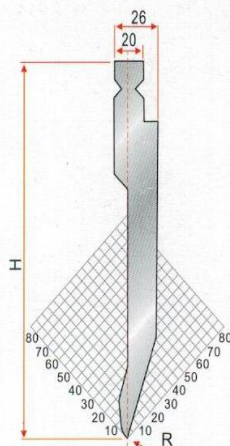


L=550mm

LS10.61

30°

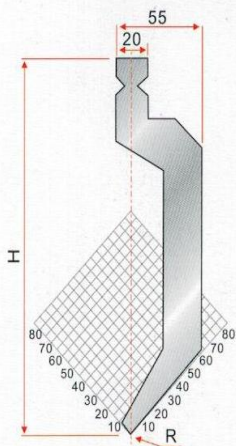
A	R	H	T/M
30°	1	237	50



LS10.62

86°

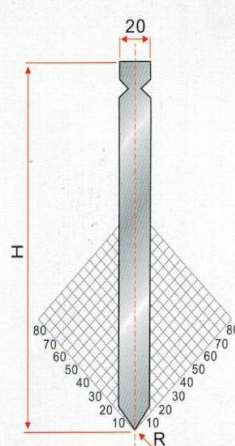
A	R	H	T/M
86°	1	237	40



LS10.63

60°

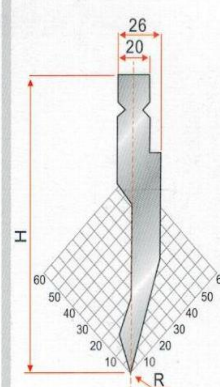
A	R	H	T/M
60°	3	237	100



LS10.64

26°

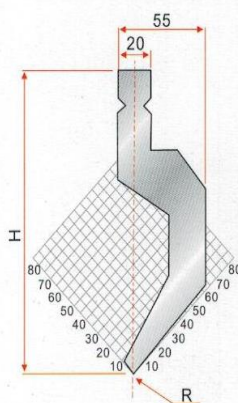
A	R	H	T/M
26°	1	157	80



LS10.65

88°

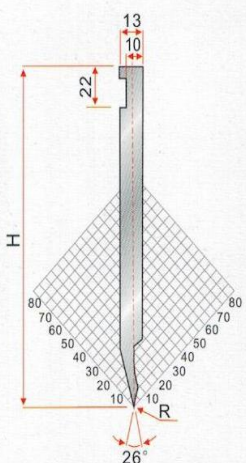
A	R	H	T/M
88°	1	157	80



LS10.66

26°

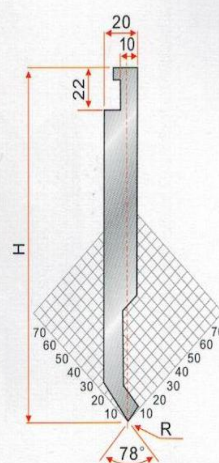
A	R	H	T/M
26°	1	180	50



LS10.67

78°

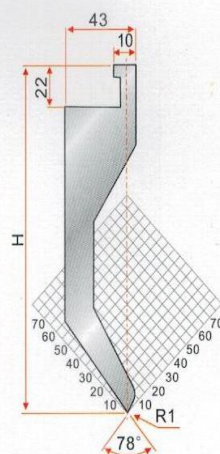
A	R	H	T/M
78°	1	180	50



LS10.68

78°

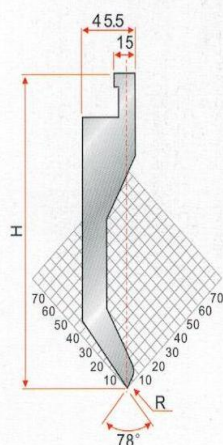
A	R	H	T/M
78°	1	180	80



LS10.69

78°

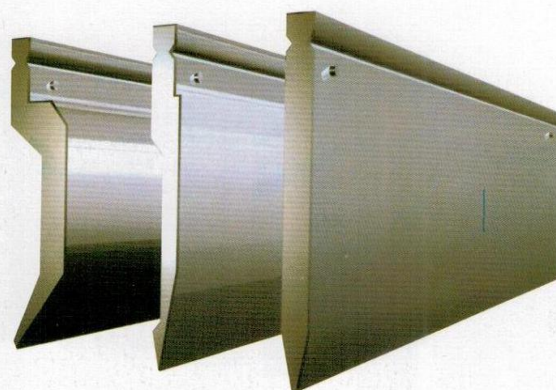
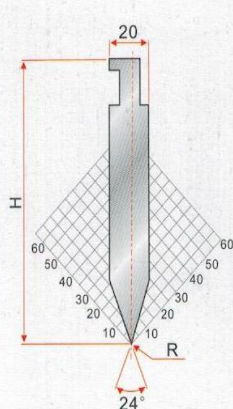
A	R	H	T/M
78°	2	255	45



LS10.70

24°

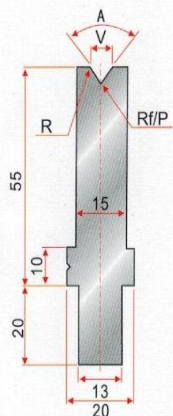
A	R	H	T/M
24°	1.1	120	100



YM6

90° 88° 30°

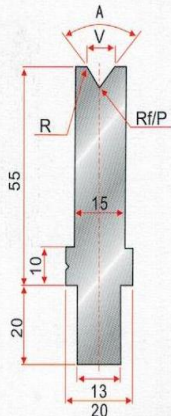
V	A	R	H	T	S	Rf/P	T/M
6	90°	0.4	55	20	15	0.5	100
6	88°	0.8	55	20	15	0.5	100
6	30°	0.6	55	20	15	1.0	35



YM8

90° 88° 30°

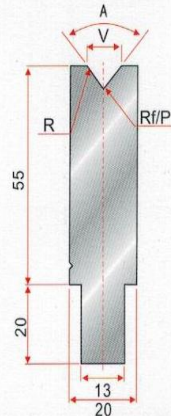
V	A	R	H	T	S	Rf/P	T/M
8	90°	0.5	55	20	15	0.5	100
8	88°	1.0	55	20	15	0.5	100
8	30°	0.8	55	20	15	2.0	35



YM10

90° 88° 30°

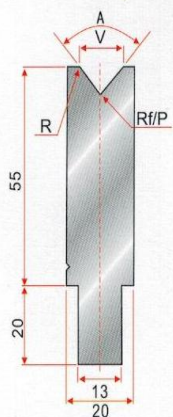
V	A	R	H	T	S	Rf/P	T/M
10	90°	1.0	55	20	20	0.5	100
10	88°	1.0	55	20	20	0.5	100
10	30°	1.0	55	20	15	2.0	50



YM12

90° 88° 30°

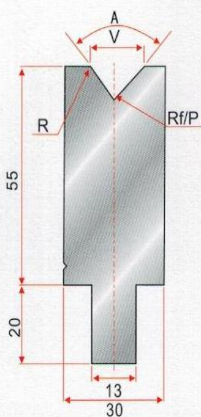
V	A	R	H	T	S	Rf/P	T/M
12	90°	1.5	55	20	15	0.5	100
12	88°	1.5	55	20	15	0.5	100
12	30°	1.5	55	20	15	2.0	40



YM16

90° 88° 30°

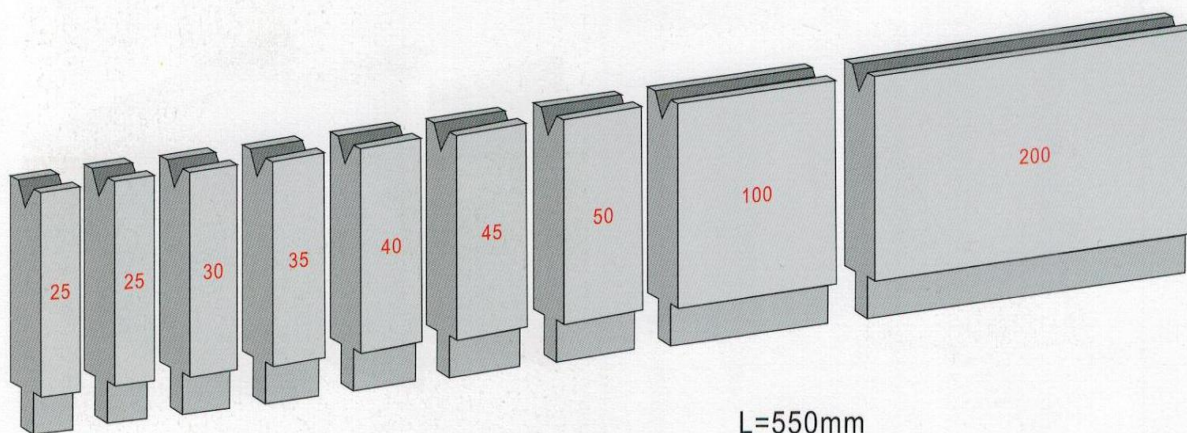
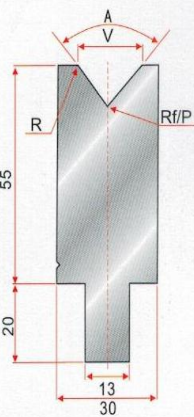
V	A	R	H	T	S	Rf/P	T/M
16	90°	2.0	55	30	30	0.5	100
16	88°	2.0	55	30	30	0.5	100
16	30°	2.0	55	30	30	5.0	45



YM20

88° 30°

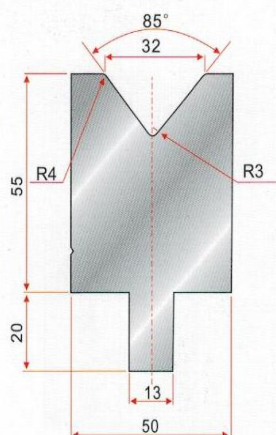
V	A	R	H	T	S	Rf/P	T/M
20	88°	2.0	55	30	30	0.5	100
20	30°	2.5	55	35	35	5.0	50



L=550mm

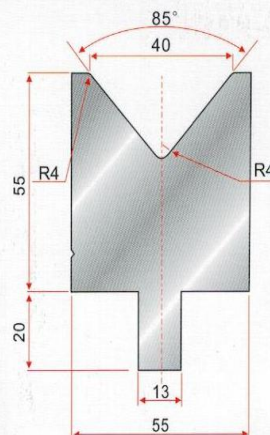
YM32 85°

V	A	R	S	Rf/P	T/M
32	85°	4.0	50	3.0	100



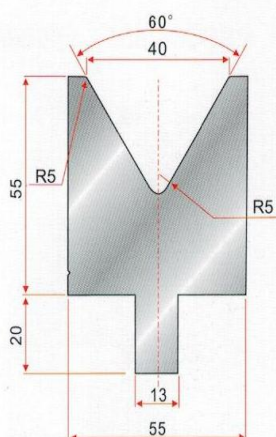
YM40 85°

V	A	R	S	Rf/P	T/M
40	85°	4.0	55	4.0	100



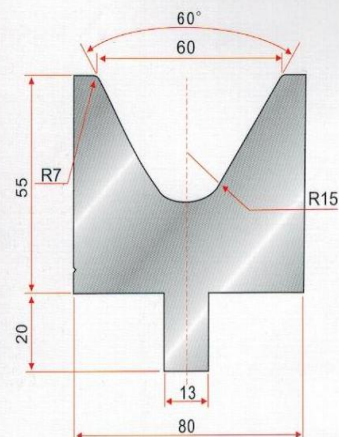
YM40 60°

V	A	R	S	Rf/P	T/M
40	60°	5.0	55	5.0	100



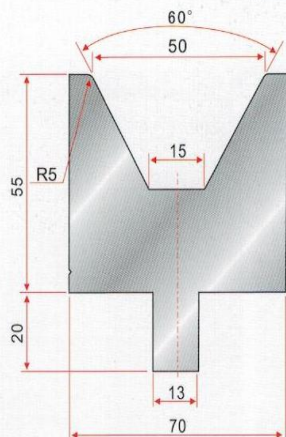
YM60 60°

V	A	R	S	Rf/P	T/M
60	60°	7.0	80	15	100

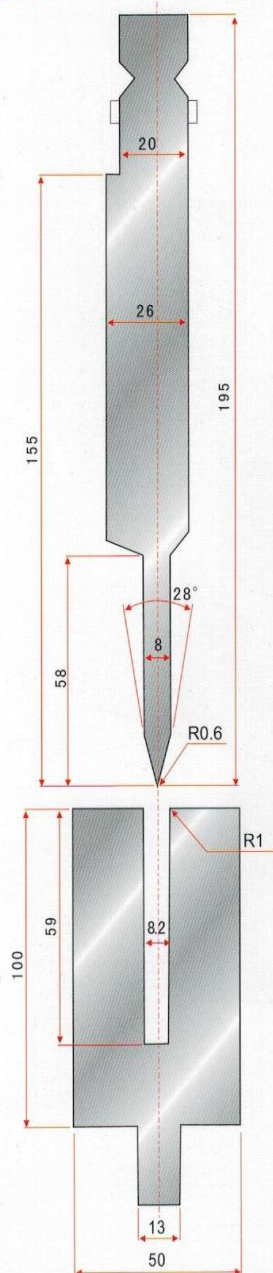


YM50 60°

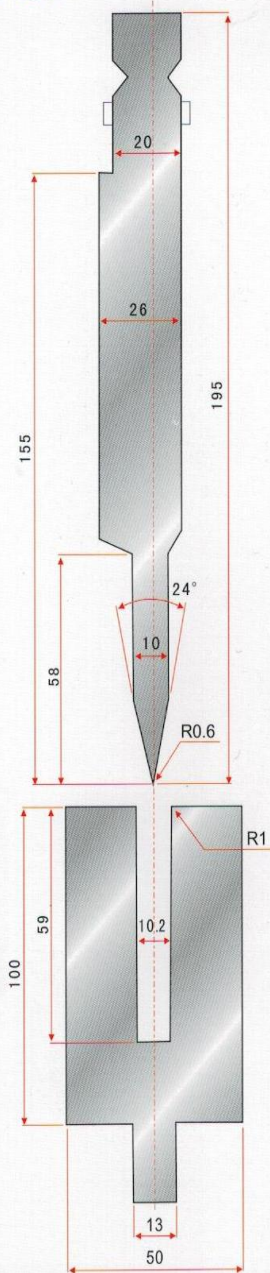
V	A	R	S	Rf/P	T/M
50	60°	5.0	70	15	100



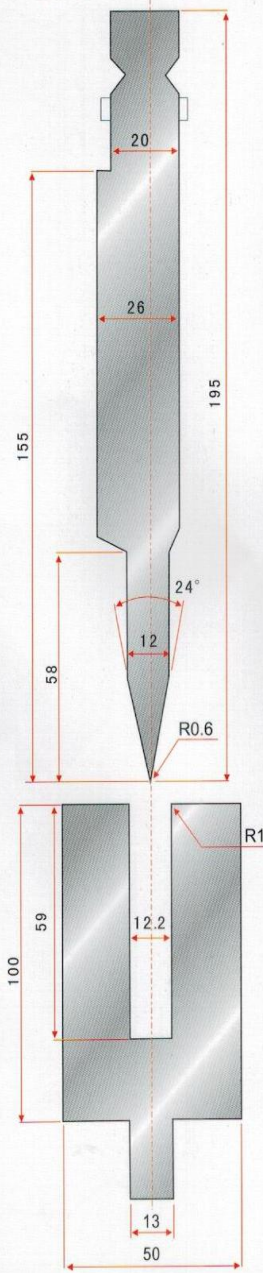
PSS41 28° 80T/M



PSS42 24° 80T/M



PSS43 24° 80T/M

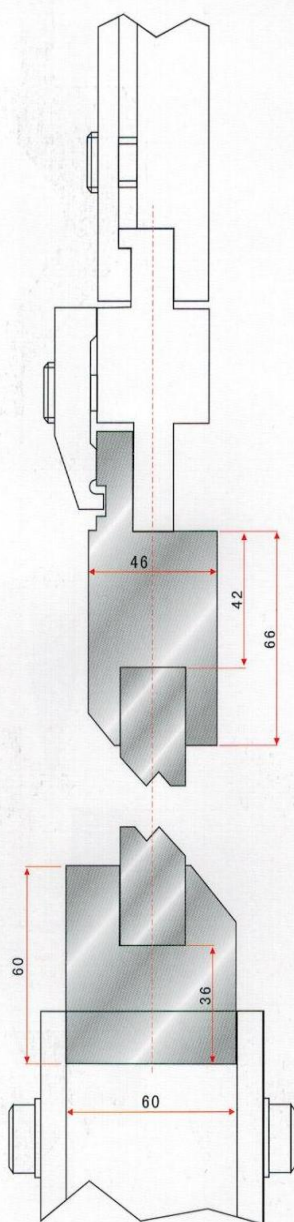


S mm	A mm	Ton/M	2×S	Ton/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	2	40
1.25	3.5	17	2.5	50
1.5	4.6	22	3	63
2	5.5	30	4	80
2.5	6.5	55	5	90
3	8	70	6	100

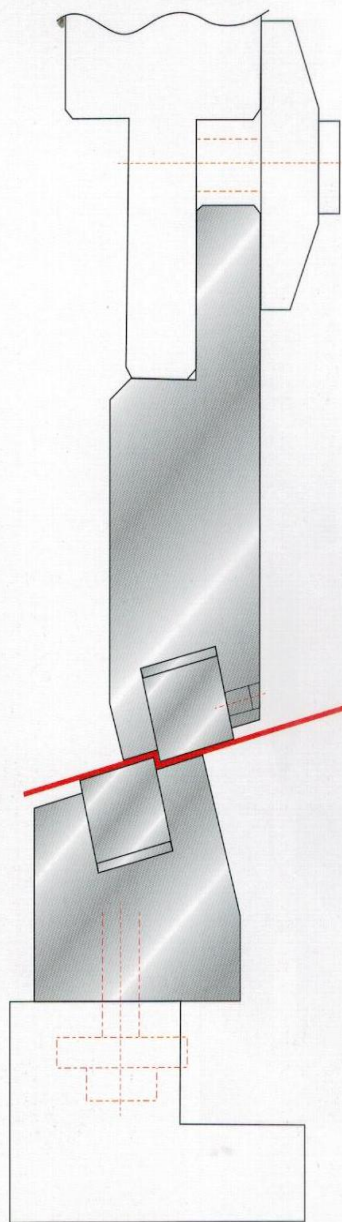
S mm	A mm	Ton/M	2×S	Ton/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	26	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

段差式模具 *Segmented Mold*

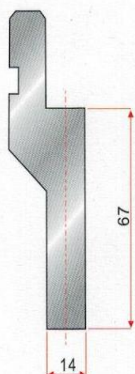
DC01



DC02



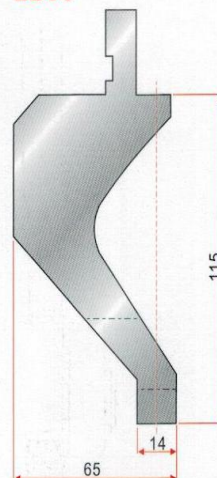
LB01



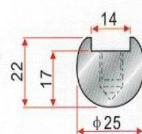
LB02



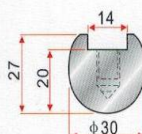
LB03



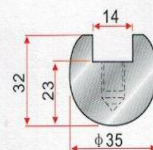
LT R12.5



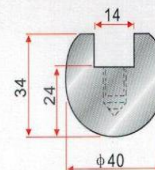
LT R15



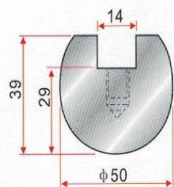
LT R17.5



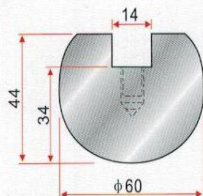
LT R20



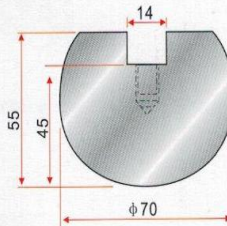
LT R25



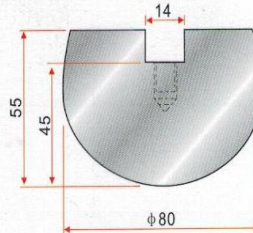
LT R30



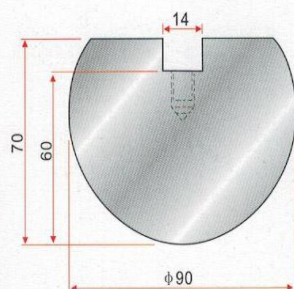
LT R35



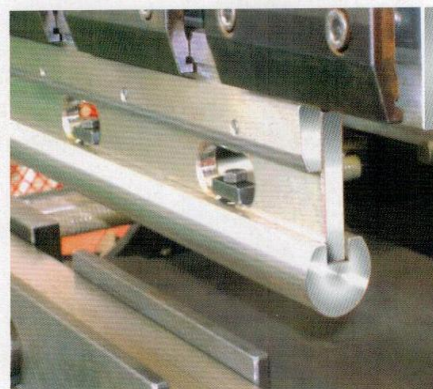
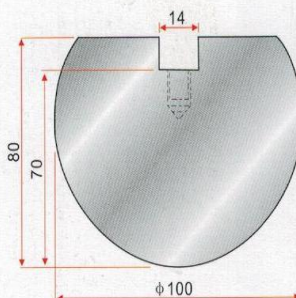
LT R40

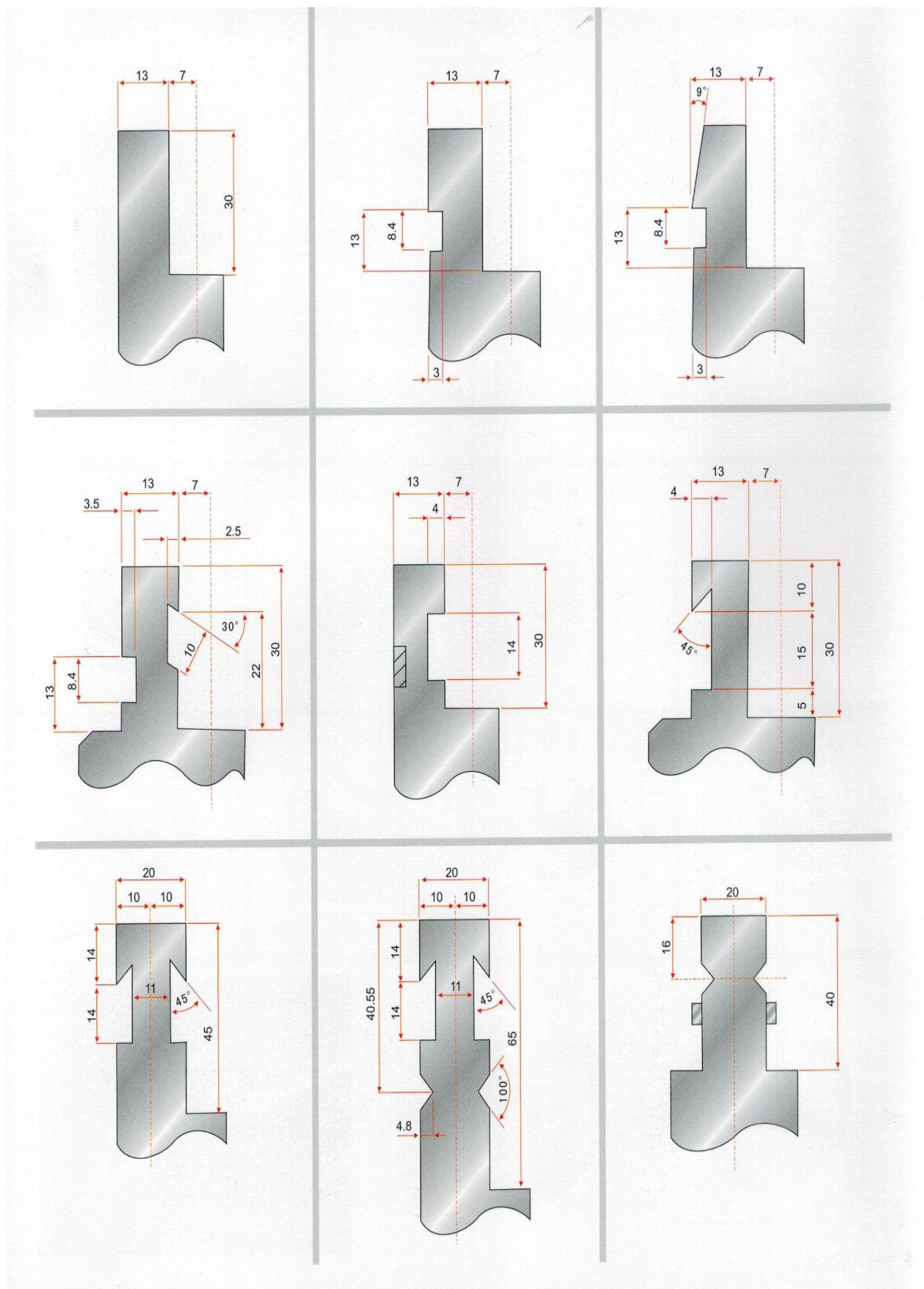


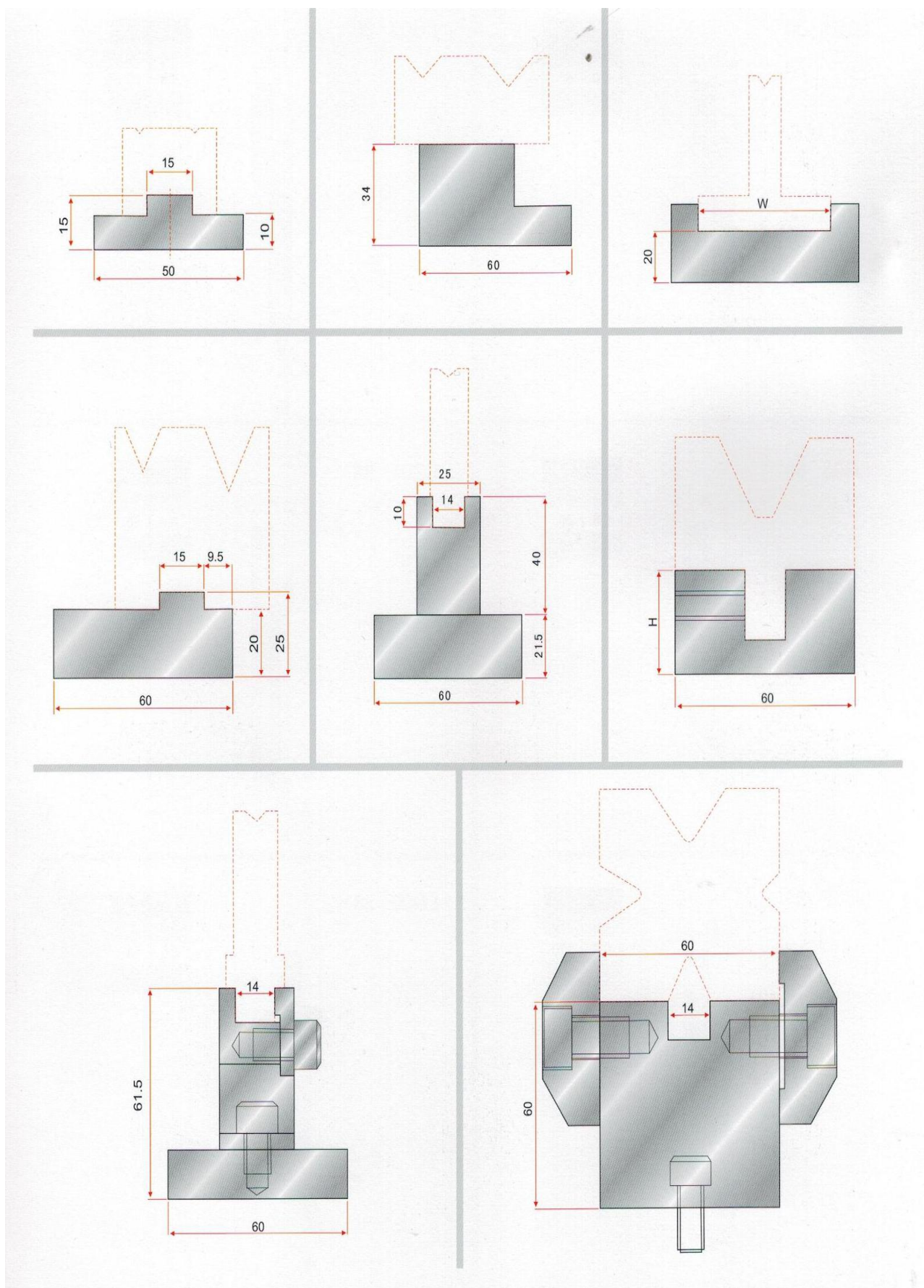
LT R45



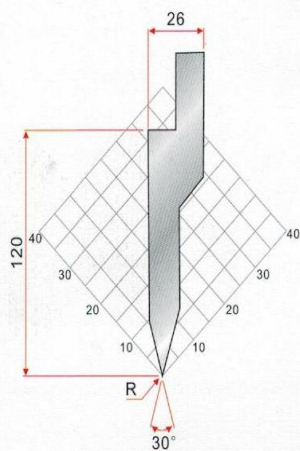
LT R50



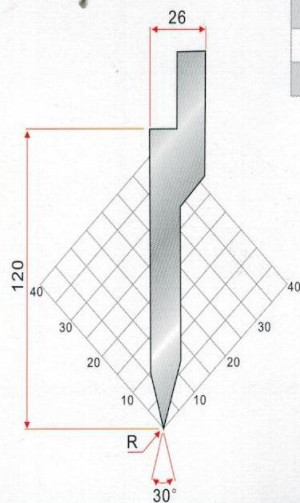




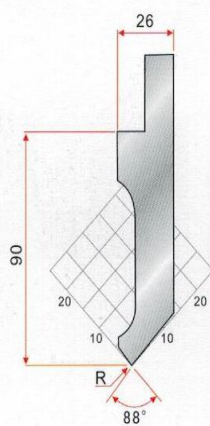
LG01 30°



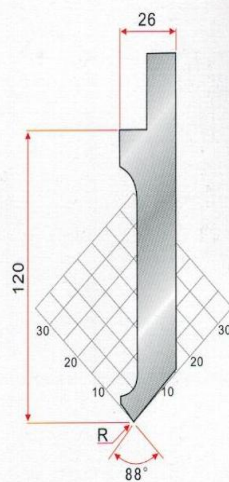
LG02 30°



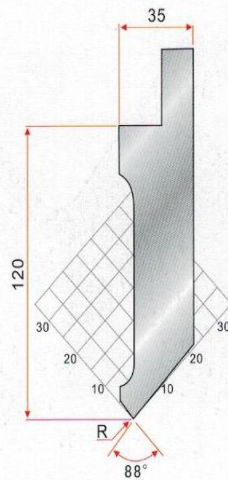
LG03 88°



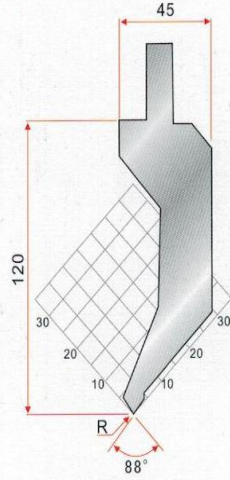
LG04 88°



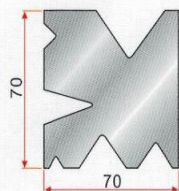
LG05 88°



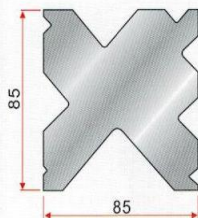
LG06 88°



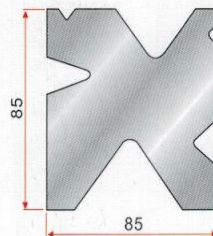
YG01



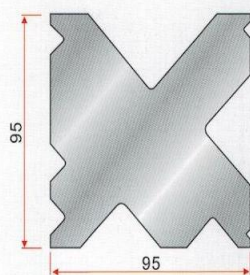
YG02



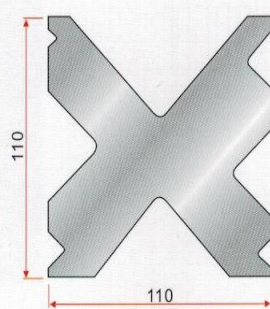
YG03



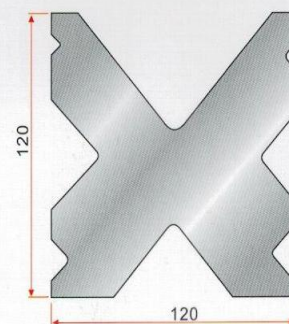
YG04



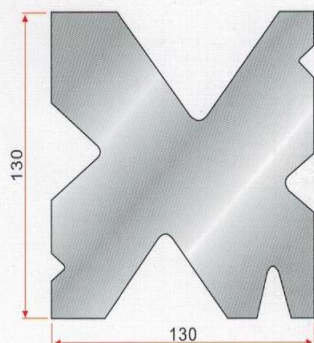
YG05



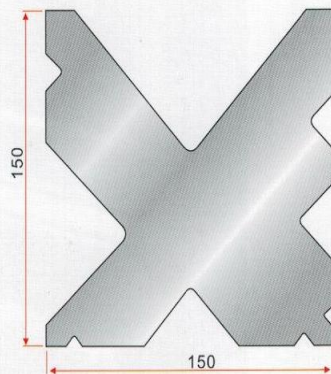
YG06



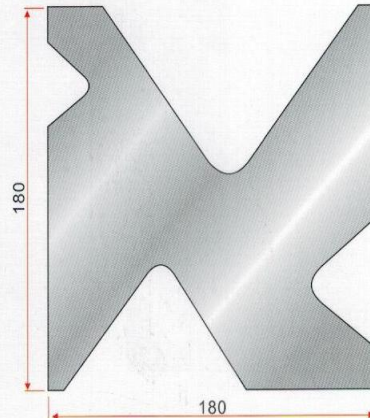
YG07



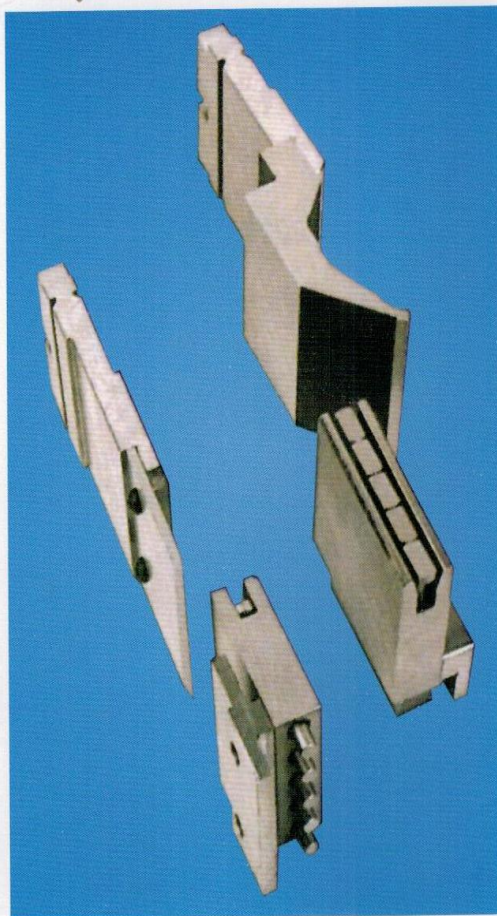
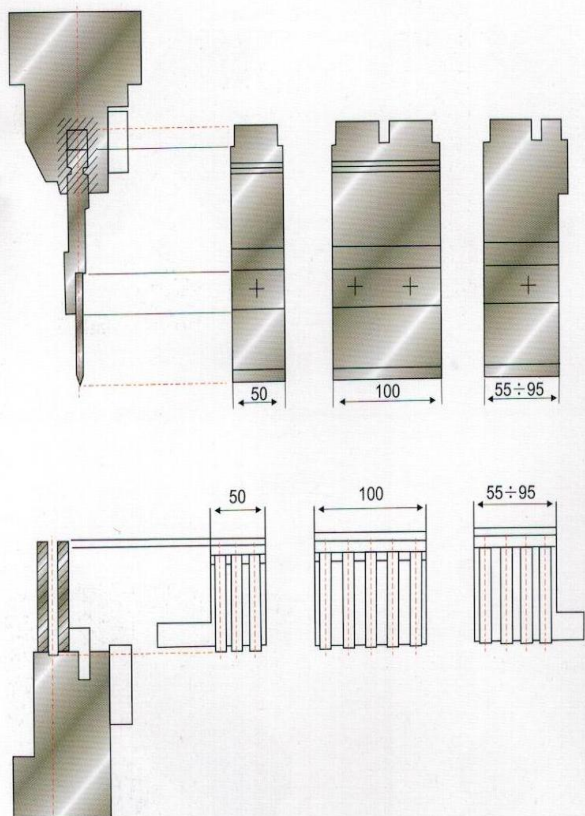
YG08



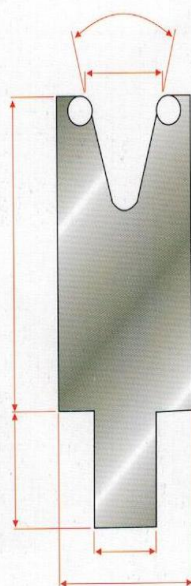
YG09



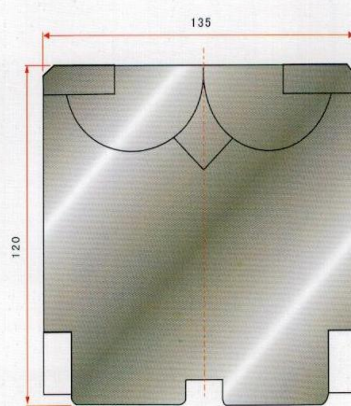
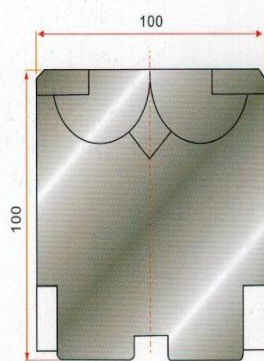
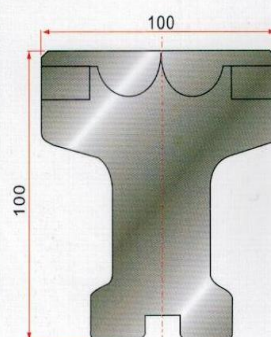
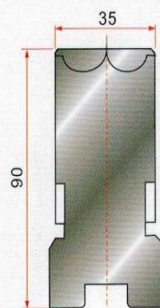
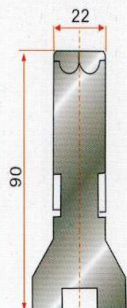
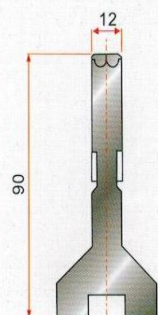
三点式模具 Three point mold



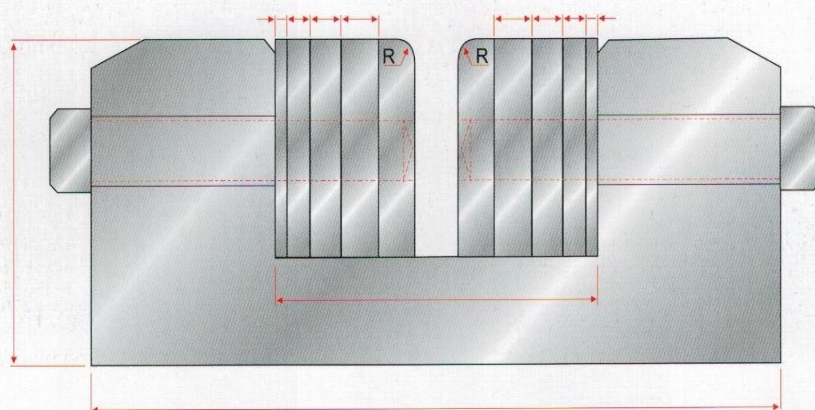
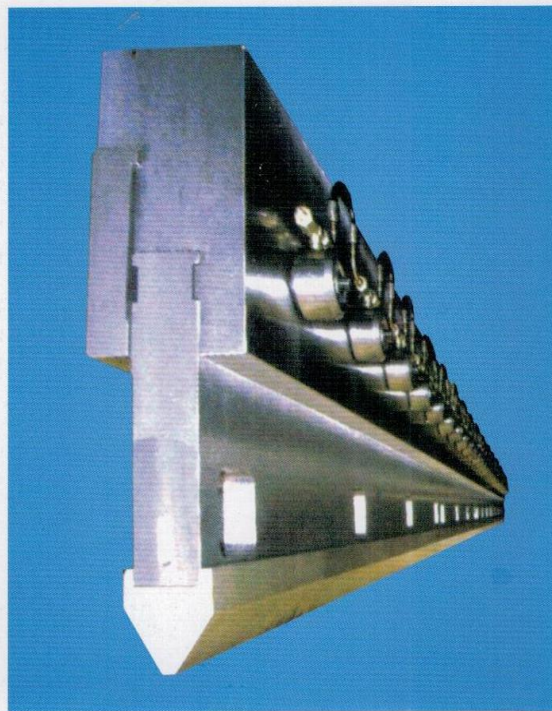
无压痕模具 Scratch resistance



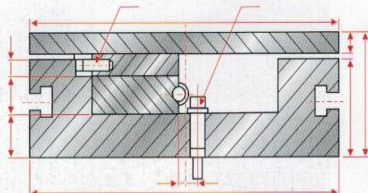
无压痕模具 Non-Streaking Mold



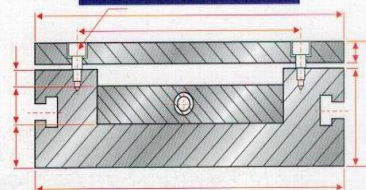
可调式槽形模具 Adjustable Groove Mold



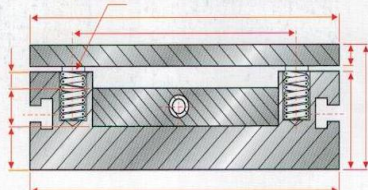
拉杆式工作台



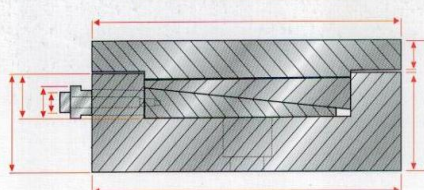
拉杆式工作台



拉杆式工作台



手动式工作台

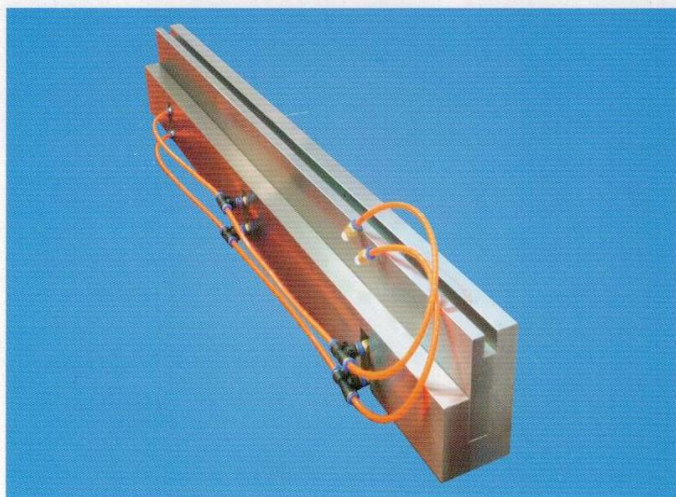




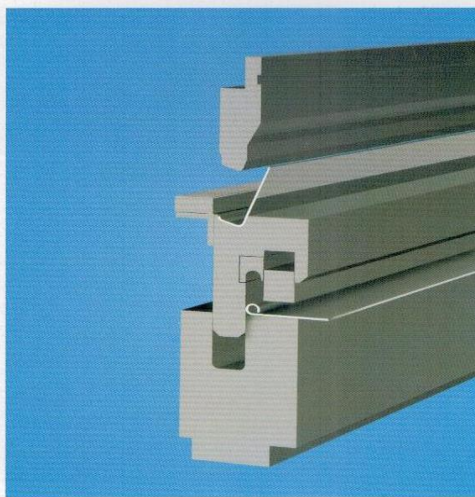
门边模具 Door Framing Mold



机箱模 Case Mold



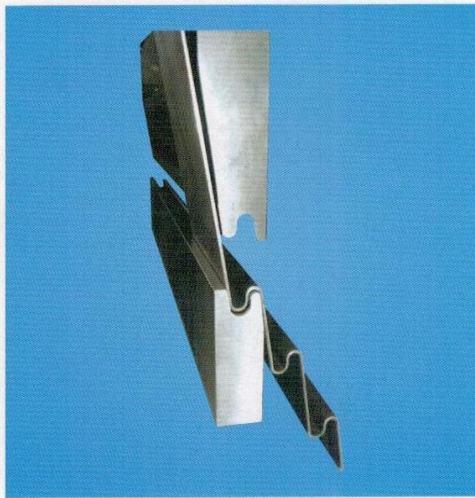
气动式压边模 Pneumatic Bending Mold



组合模具 Combination Mold

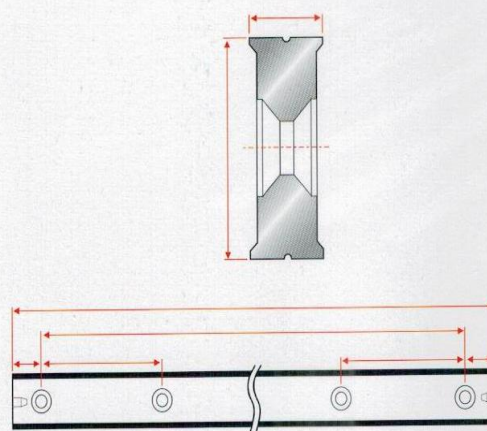
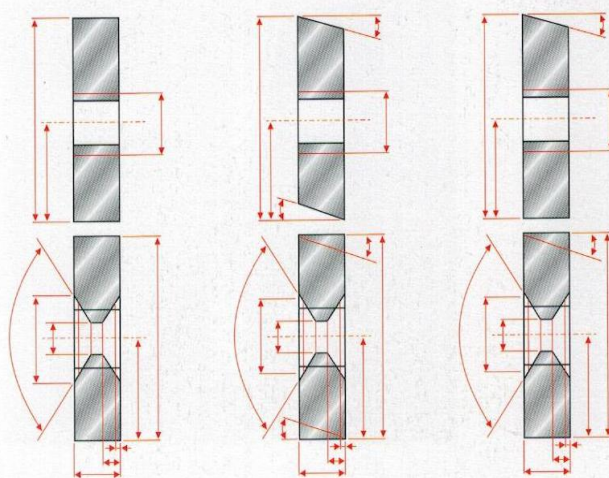
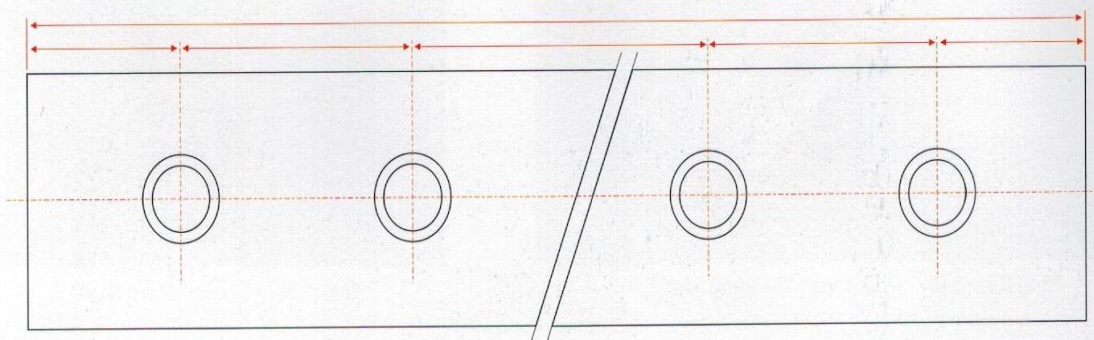
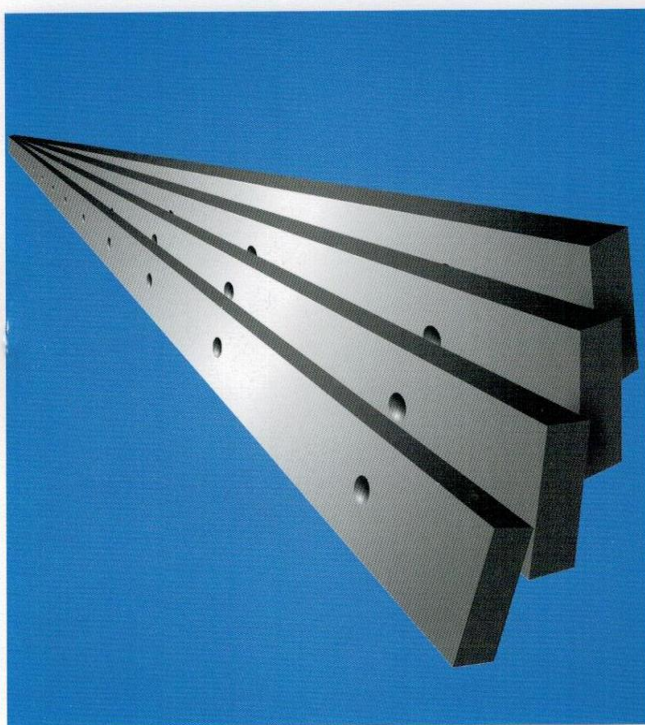


预弯模 Preflex Mold



S 模 S Type Mold

剪板机刀片 *Shearing Machine blade*



折弯压力表 *Bending char*

材料的板厚及折弯的内侧半径决定后，请参阅下表。

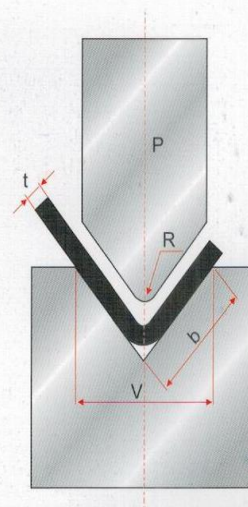
1. 由表可看出折弯材料时每米所需的压力。
2. 折弯时所使用的下模的V槽宽度 (V)。
3. 折弯后所得的最短边长度 (b)。

注：下表所示为一般板厚所对应的模具V槽宽度。

Please check the diagram after slab thickness and bending inner radius being decided.

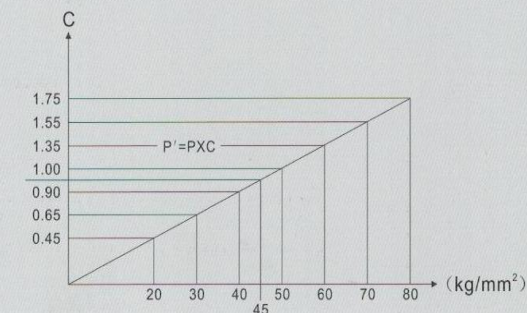
- 1.It can be seen that the pressure at every meter when bending materials;
- 2.The V-groove width(V) of bottom mold while bending;
- 3.The shortest-length(b) arising while bending.

Note: The following diagram shows the corresponding V groove width of the mold with general thickness.



T	0.5~2.6	3.0~8	9~10	12以上
V	6t	8t	10t	12t

	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V									
t	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b									
mm	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26	33	41	R									
0.5	4	3																													
0.6	6	4	4	4									t 板材料厚度 (抗拉强度=45-50kg/mm²) P 每米所需压力 (Ton/m) R 折弯内侧半径 b 最短边长度 V 下模V槽的宽度 t: Board material thickness(tensile strength=45-50kg/ mm²) P: Necessary pressure per metre(Ton/m) R: Bending inner radius b: Shortest-length V: The V-groove width of bottom mold																		
0.8		7	7	5	4																										
1.0		11	10	8	7	6																									
1.2			14	12	10	8	7	6																							
1.4				15	13	11	10	9	8																						
1.6					17	15	13	11	10	9																					
2.0						22	19	17	15	13	11																				
2.3							25	23	29	17	15	12																			
2.6								28	25	22	18	14																			
3.0									34	30	24	19	15																		
3.2										34	27	22	17	14																	
3.5											33	26	20	16	13																
4.0											43	34	27	21	17																
4.5	铝 =30kg/mm ² P=P (表) ×0.65												44	34	27	21															
5.0	不锈钢 =70kg/mm ² P=P (表) ×1.6												52	42	33	26	21														
6.0													60	48	38	30	24														
7.0															52	41	33	26													
9.0																67	54	43													
10																85	67	53	42												
12																	96	78	60	55											
16																		136	107	86											
19																			150	125	100										
22																				160	130										
25																					210	170									
30																						240									



旭祥制模

Xu Xiang's Moulding

诚信专业◎进取双赢

Honesty and Credit Profession◎ Enterprising and Win - Win

安徽旭祥数控刃模具制造有限公司

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