

# LF1

## Compound - Link Sheet Metal Forging Press

連桿式板鍛沖床



200. 300. 400. 500. 650 ton

# LF1

# Compound - Link Sheet Metal Forming

## 連桿式板鍛沖床

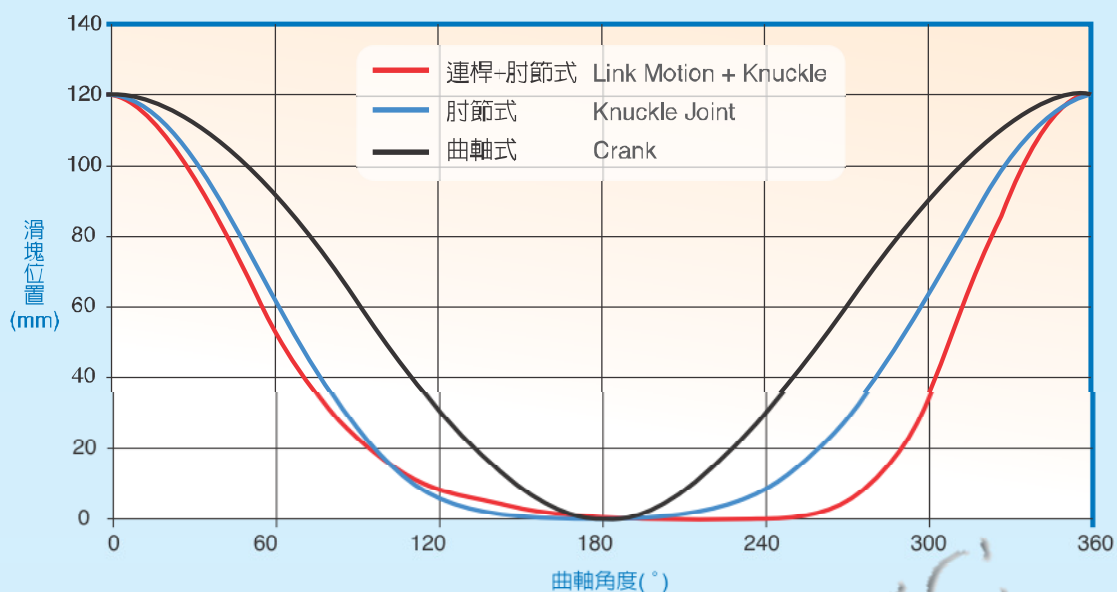


- 機身剛性高、變形量小。  
Super rigid, low-deflection steel frame.
- 連桿加肘節傳動機構，具有獨特的沖壓加工成形曲線。  
Link-motion drive combined with knuckle-joint transmission system creates a unique slide motion curve.
- 能進行薄板材之冷間鍛造、引伸加工、精密下料加工、近淨成型(淨成型)加工及板材沖鍛複合成型加工。  
Available for sheet materials in Cold Forging, drawing Fine Blanking, Near-Net-Shaping(Net shape) and Press Forging.
- 可滿足輕合金(鎂、鋁)、不銹鋼及高張力鋼板等小型薄板沖鍛成型的需求。  
Suitable for press forging of light compound materials such as magnesium, aluminum, or sheet steel, and high-tension steels.
- 適用於3C產品(如MP3、PDA、高階手機等)金屬外殼之沖壓成型。  
Ideal to produce the metal covers stamping for 3C products(ex. MP3, PDA, High-end cell phones).
- 適用於刀具類、五金類、汽機車與自行車零件等之精密下料。  
Adaptable to Fine Blanking for knives, hard wares and auto parts.

## 規格 Main Specifications

機型		LF1-200	LF1-300	LF1-400	LF1-500	LF1-650
最大加壓能力 Capacity	TONS	200	300	400	500	650
能力發生點 Pating Tonnage Point	mm	4.8	8			
行程長 Stroke Length	mm	120	150			
行程數 Strokes Pre Minute	spm	25 ~ 45	20 ~ 40			
最大模高 Die Height	mm	450				
台盤面積×厚度 (L-R × F-R × T) Bolster Area	mm	1300 x 970 x 160		1300 x 1000 x 190		
滑塊面積 (L-R × F-B) Slide Area	mm	1300 x 970		1300 x 1000		
滑塊調整量 Slide Adjustment	mm	50	80			
側面開口(L-R × H) Side Opening	mm	420 x 400	450 x 450		465 x 450	
工作面高度 Working Height	mm	890	900	950	1,000	
最大上模重量 Maximum Upper Die Weight	kg	1,000	1,500			
主電動機 Main Motor	HP × P	25HP x 4P	30HP x 4P	40HP x 4P	50HP x 4P	60HP x 4P
滑塊調整馬達 Slide Adjusting Motor	HP × P	2HP x 4P				

## 獨特的沖壓加工成形曲線 Unique Press Slide Motion Curve



連桿加肘節式之機構運動曲線具有延長成形時間的效果，沖壓成形時加工於下死點停留很長的時間(曲軸角度180度~240度)，因此此獨特的滑塊運動曲線，適合用於形狀複雜的板材鍛造成型加工。

Link-Motion with Knuckle Joint transmission structure creates a unique slide motion curve which is able to extend the time for forming from 180° - 240° crank angle. This slide motion is ideal for complex sheet metal forging.

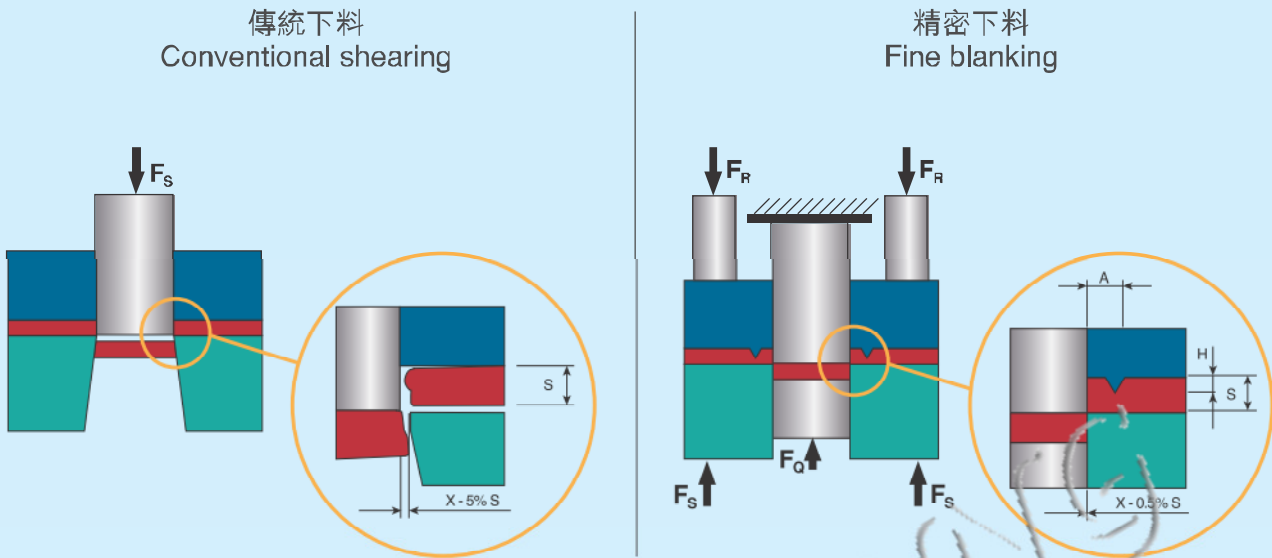
可滿足輕合金(鎂、鋁)、不銹鋼及高張力鋼板等薄板沖鍛成型的需求  
Available for light compound materials (magnesium, aluminum), sheet steel and high-tension steels





## 何謂精密下料 (Fine Blanking)?

傳統下料與精密下料技術的主要差異  
The Differences between Conventional Shearing and Fine Blanking



能進行薄板材之精密下料、近淨成型 (淨成型) 及板材沖鍛複合成型加工  
Fine Blanking, Near-Net-Shaping and Press Forging for sheet material

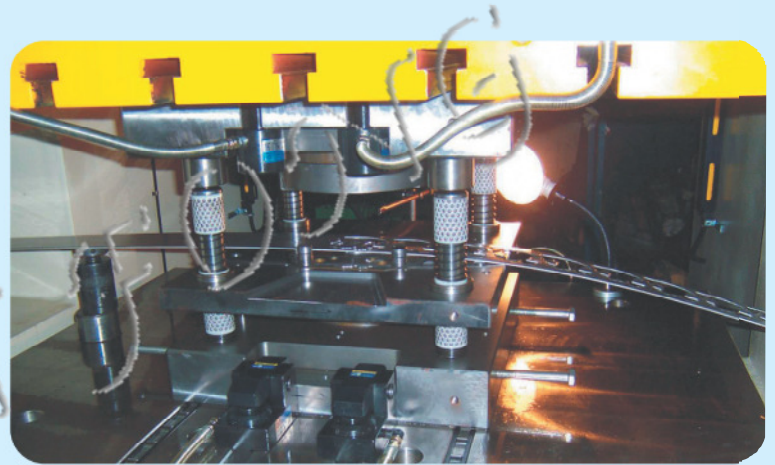


除滑塊於接近下死點之沖鍛加工區間停留時間拉長使工件有足夠時間進行精密下料、近淨成型及板材沖鍛複合成型適用外，更將滑塊作動往後遞延回升，使工件不會產生回彈(Spring Back)，讓成形性更佳，並提高製品之良率。

Extend the time at Bottom Dead Center(BDC), in order to process Fine Blanking, Near-net-shape and Press Forging, Unique Slide Motion prevents "spring back" of materials, and also creates better forming and productivity.

## 精密下料連續順送自動化沖壓生產線

- 精密下料自動化沖壓生產線組成：  
沖床 / 模具 / 上、下油壓模墊 / 料卷 / 三合一送料機(料架、矯直、送料) / 廢料回收架
- The Automatic Fine Blanking Press Line is Composed by:  
Press / Die / Upper and Lower Hydraulic Die Cushion / Material / 3 in 1 Feeding Machine(Coiler, Straightener, and Feeder) Waste Recycler
- 精密下料模具上、下油壓模墊設定：  
1. 工件沖壓時能力為135ton~145ton  
2. 上模設定壓力50ton、下模設定壓力30ton
- Setting Fine Blanking Die and Hydraulic upper and lower die cushion:  
1. Pressing Capacity 135~145ton  
2. UpperDie Cushion: 50ton, LowerDieCushion: 30ton



### 標準附屬配件

- T型操作台
- E電控
  - 電子式曲軸角度指示器
  - 電子式運轉速度指示器
  - 運轉狀態LCD監視器
- 運轉模式選擇  
切 / 寸動 / 安全-行程 / 連續
- 二度落保護裝置
- 電動滑塊調整裝置
- 數字式模高指示器 (0.1mm)
- 濕式離合剎車器
- 荷重檢測試(安全)裝置
- 滑塊導路電動黃油潤滑裝置
- 傳動系統循環集中潤滑給油裝置
- 滑塊及模具平衡裝置
- 變頻器及主馬達正逆轉裝置

### Standard Functions / Accessories

- T-Stand Operator
- E-Series Control System
  - Electronic Crank Angle Display
  - Electronic SPM Display
  - LCD type Press status monitor
- Operation Mode Selection  
Off / Inch / Safe-Program / Continuous
- Overrun Detector
- Motorized Slide Adjustment
- Digital Die Height Indicator (unit 0.1mm)
- Wet Clutch and Brake
- Load Monitor Detector
- Electrical Grease Lubrication
- Central Lubrication in Driven System
- Slide and Die Balance Device
- Inverter and Main Motor Reverse Device

## Fine Blanking with Continuous progressive Automatic Press Line

### ● 精密下料沖壓效果確認：

1. 切斷面光亮平滑無破斷面，並兼具壓印效果
2. 採用精密下料技術，切面平滑，不需再二次加工

### ● Confirm with Fine Blanking and Pressing

1. Surface is smooth without fracture and with coining feature
2. No need for secondary Processing



### 選用功能 / 配件

- 台身底部廢料槽(前方排出)
- VS馬達(非E電控使用)
- 光電安全裝置
- 防震裝置
- 基礎板及基礎螺絲
- 安全檔塊及安全插銷
- 模具照明燈
- 沖床控制器MPC系列
- 油壓上部頂料裝置(配合精密下料用)
- 油壓式模墊(配合精密下料用)
- 電源插座110V單相，電源客戶自備

### Optional Accessories

- Bottom Scrap tank (Front side)
- VS Motor (Not Applicable to E-Series Control System)
- Photo electronic safety guard
- Anti Vibration Mount
- Foundation Plate and Anchor Bolts
- Safety Block and Plug
- Die Room Light
- Control System MPC Series
- Hydraulic Slide Knock-out Device
- Hydraulic Die Cushion
- Power receptacle(Single phase,110V)





創新、服務、回饋

沖壓機械專業製造廠

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