

wodda®  
沃达重工



Friendly note: due to technical upgrading, the company reserves the right to change the product appearance and parameters on the sample

**山东沃达重工机床有限公司**

SHANDONG WODA HEAVY MACHINERY CO., LTD.

## 关于我们 ABOUT US

Shandong Woda Heavy Machinery Co., Ltd. is a company focusing on the research and development, production and service of large and medium-sized forging machine tools, with an annual output value of nearly 200 million yuan and a plant area of more than 30000 square meters. Its main products include open press, semi closed and closed press, JH21 punch and supporting equipment of stamping production line (uncoiler, leveling machine, automatic feeder, manipulator), etc. Its customers cover more than 300 cities in China and Central Asia, Europe, Africa South America and other overseas regions

Shandong Woda heavy Machinery has a professional research and development team, has won a number of national patents, has passed the EU CE certification and the ISO9001 international quality management system certification, and has been rated as a national "high-tech enterprise", "Shandong science and technology small and medium-sized enterprise", "Zaozhuang high-end intelligent forging machine technology innovation center"

Shandong Woda heavymachinery has always focused on the corporate vision of "intelligent manufacturing in China, serving the world", with the mission of "promoting the craftsman spirit, adhering to independent innovation, and building a high-quality brand", adhering to the value of "loving practical work, achieving customers, people-oriented, and advancing with the times", constantly learning advanced technology and experience at home and abroad, strengthening cooperation with universities and scientific research institutes, and providing reliable products and professional technical solutions, Continue to create greater value for customers, provide all-round services for automobile manufacturing, sheet metal processing, animal husbandry, mining, metallurgy, environmental protection, transportation, power generation and other industries, and make modern industrial production safer, more efficient and more environmentally friendly.

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■ 荣誉资质 HONOR OF QUALIFICATION



■ 合作客户展示 SHOW CUSTOMERS





## 产品特性 PRODUCT CHARACTERISTICS

The fuselage is made of high-quality steel plate, which is designed according to high precision and high strength. After welding, the stress is removed, and the accuracy is stable and the performance is reliable.

The machine has reasonable structure design and complete configuration, which is convenient for automatic production and supporting assembly line production.

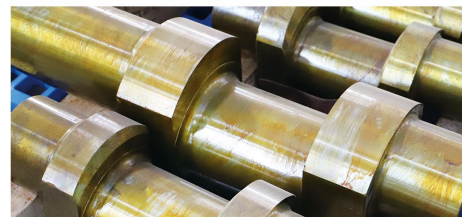
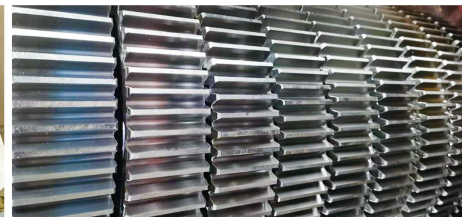
In order to ensure the relative stability of the machine operation, a pneumatic balancer device is used. High performance combined clutch / brake is adopted, which is stable, safe and reliable.

The mold adjustment accuracy is as high as 0.1mm, which is safe, convenient and reliable.

Safety double solenoid valve and hydraulic overload protection device are adopted to ensure production and operation safety.

Crankshaft, gear, connecting rod and other components, after hard oxidation and grinding, have extremely high comprehensive mechanical properties and wear resistance.

## 精密配件 PRECISION PARTS



## 高标准制造 HIGH STANDARD MANUFACTURING

CAE dynamic simulation optimization design integrating advanced technology / function structure of Europe, America and Japan

High performance Controllers / electrical appliances, hydraulic / pneumatic components and other high-end configurations of international brands.

The high rigidity fuselage is made of high-quality steel profiling welding or integral casting tempering / vibration stress treatment.

International dynamic pressure equipment technical grade machine index / manufacturing process test. The main parts are processed by high standard process of hard chromium plating / nitriding / grinding.

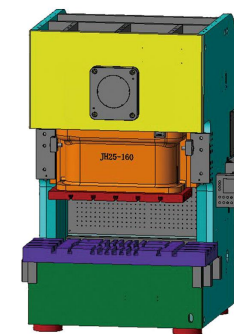
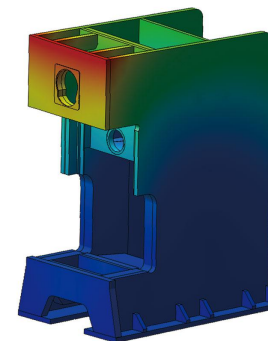
## 设备执行标准

GB/T 23280-2009	《开式压力机 精度》
GB/T5226.1-2002	《工业机械电气设备通用技术条件》
GB5226.1-2002	《机械安全 机械电气设备第一部分通用技术条件》

■ WDA series open single point precision punch



I 有限元分析 FINITE ELEMENT ANALYSIS



I 配置 CONFIGURATION

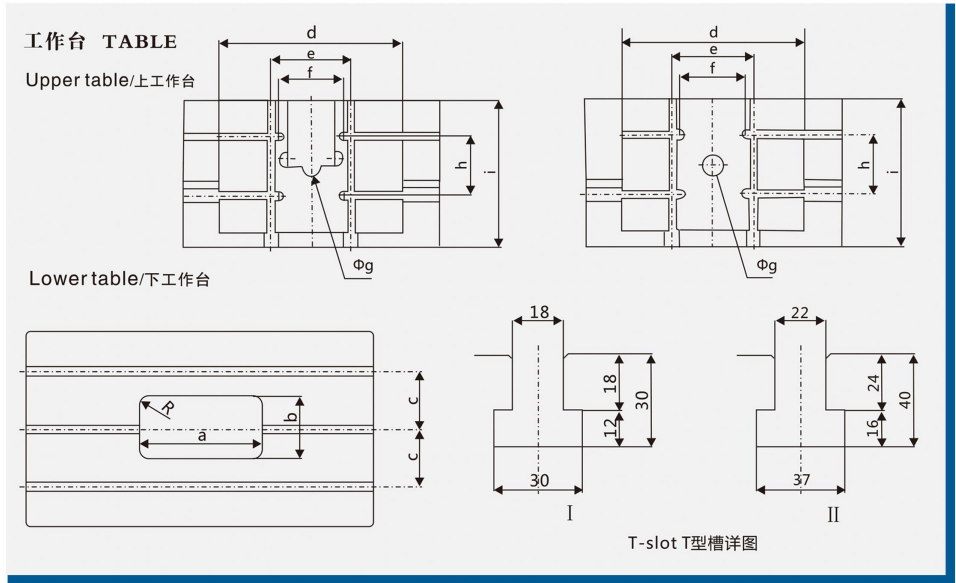
标准配置 STANDARD UNIT

油压式过载保护装置	Hydraulic over-load protector
手动式滑块调整装置 (WDA60及60以下)	Manual slider adjustment device (WDA60 below 60)
电动式滑块调整装置 (WDA60以上)	Automatic slide adjust device (WDA60 or more)
主电机 (可调速)	Main motor (adjustable)
机械式模高指示器 (WDA60及60以下)	Die height indicator (WDA60 below 60)
电动式模高指示器 (WDA60以上)	Automatic die height indicator (WDA60 or more)
滑块及模具平衡装置	Balance device
电子凸轮	Electronic cam
曲轴角度指示器	Crank angle indicator
计数器	Electrical stroke counter
空气源接头	Air source receptacle
二度落保护装置	Against over-run safety device
喷风装置	Air ejector
电源插座	Power supply
手动黄油润滑装置 (WDA60及以下)	Manual grease lubrication device (WDA60 below 60)
电动黄油润滑装置 (WDA60以上)	Electrical grease lubrication device (WDA60 or more)

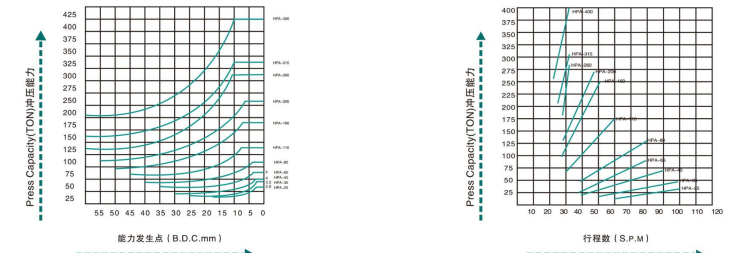
选购项目 OPTIONAL

电动式黄油润滑装置 (WDA60及以下)	Electrical grease lubrication device (WDA60 below 60)
气压模垫装置	Pneumatic die cushion device
脚踏开关	Foot switch
快速换模装置 (举模器、夹模器或移模臂) (Die lifter, clamp and die arm sepjes)	Fast mdd change device
滑块上部打料装置	Slider knock-out device
误送检测装置	Misfeed detection consent
防震脚	Anti-vibration pad
光电保护装置	Photo-electric safety device
送料机 (空气、机械及NC各类)	Feeder
料架	Uncoiler
机械手	Robot hand
模具照明装置	Die room light
触摸屏 (预断、预裁、总计数)	Touch pad (prest,total,counter)

规格	Specification	单位	WDA-25			WDA-35			WDA-45		WDA-60		WDA-80		WDA-110		WDA-160		WDA-200		WDA-260		WDA-315		WDA-400		
型式	Model		V	H	S	V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H
吨数	Capacity	ton	25			35			45		60		80		110		160		200		260		315		400		
冲力发生位置	Rated tonnage point	mm	3.2	1.6	3.2	3.2	1.6	3.2	1.6	4	2	4	2	6	3	6	3	6	3	7	3.5	8	4	8	4		
每分钟行程数	定速	Speed changing	s.p.m	60-140	130-200	60-120	40-120	110-180	40-100	110-150	35-90	80-120	35-80	80-120	30-60	60-90	20-50	40-70	20-50	50-70	20-40	40-50	20-40	30-50	20-40	30-50	
	变速	Stable speed	s.p.m	110			110			85		75		65		65		50		35		35		30		30	
行程	Stroke	mm	70	30	80	70	40	80	50	120	60	150	70	180	80	200	90	200	100	250	150	250	150	250	150		
最大闭合工作高度	Die height	mm	195	215	190	220	235	250	265	310	340	340	380	360	410	460	510	460	510	500	550	500	550	550	550	600	
滑块调整量	Slide adjustment	mm	50			50			55		60		75		80		80		100		110		120		120		
上工作台尺寸	一型	Slide area	300×230×50			360×250×50			400×300×60		500×360×70		560×420×70		650×470×80		700×550×90		850×630×90		950×700×100		950×700×100		1350×800×100		
	二型	Slide area	470×230×50			520×250×50			560×300×60		700×360×70		770×420×70		910×470×80		910×500×80		1130×630×90		1250×700×100		1250×750×100				
下工作台尺寸	Bolster area	mm	680×300×70			800×400×70			850×440×80		900×500×80		1000×550×90		1150×600×110		1250×800×140		1400×820×160		1500×840×180		1600×860×190		1650×900×200		
模柄孔	Shank hole	mm	38.1			φ38.1			φ38.1		φ50		φ50		φ50		φ65		φ65		φ65		φ65		φ65		
主电动机	Main motor	kw.p	3.7×4			3.7×4			5.5×4		5.5×4		7.5×4		11×4		15×4		18.5×4		22×4		30×4		37×4		
滑块调整机构	Slide adjust device	HP	手动 Manual operation												电动 electrical driving												
使用空气压力	Air pressure	kg/cm <sup>2</sup>	6			6			6		6		6		6		6		6		6		6		6		
冲床精度	Presses precision		GB/JIS 1class 一级																								
冲床(长×宽×高)	Presses dimension	mm	1280×850×2200			1380×900×2400			1600×950×2500		1600×1000×2800		1800×1180×2800		1900×1300×3200		2300×1400×3800		2615×1690×4075		2780×1850×4470		2910×1950×4500		3180×2150×5025		
冲床重量	Presses weight	Ton	2.1			3			3.8		5.6		6.5		9.6		16		23		32		35		40		
模垫能力	Die cushion capacity	Ton	-			2.3			2.3		3.6		3.6		6.3		10		14		14		14		14		
模垫行程长	Stroke	mm	-			50			50		70		70		80		80		100		100		100		100		
模垫有效面积	Die cushion effective area	mm <sup>2</sup>	-			300×230			300×230		350×300		450×310		500×350		650×420		710×480		710×480		710×480		710×480		



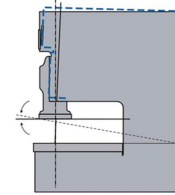
CRAPH能力曲线图



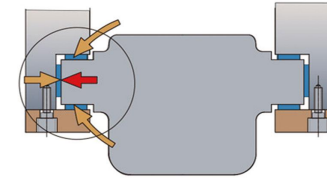
规格	WDA-25	WDA-35	WDA-45	WDA-60	WDA-80	WDA-110	WDA-160	WDA-260	WDA-260	WDA-315	WDA-400
A	240	280	300	320	360	400	440	480	520	520	520
B	120	140	150	160	180	200	220	240	260	260	260
C	90	120	120	150	150	160	220	280	290	290	290
D	80	100	120	160	180	220	220	300	300	300	300
E	/	/	/	220	300	300	300	420	420	420	420
F	150	160	210	220	220	220	175	200	200	200	200
G	38.1	38.1	38.1	50	50	50	65	65	65	65	65
a	18	18	18	22	22	22	22	22	22	22	22
b	30	30	30	37	37	37	37	37	37	37	37
c	18	18	18	24	24	24	24	24	24	24	24
d	12	12	12	16	16	16	16	16	16	16	16



High rigidity fuselage



High precision hexahedral guide rail



## 1 SPECIFICATION

Specifications	Unit	WDA-25			WDA-35		WDA-45		WDA-60	
		V	H	S	V	H	V	H	V	H
form										
tonnage	Ton	25			35		45		60	
Capability occurrence point	mm	3.2	1.6	3.2	3.2	1.6	3.2	1.6	4	2
Travel speed per minute	Constant speed	s.p.m			85		75		65	
	variable speed	s.p.m			60-140	130-200	60-120	40-120	110-180	40-100
trip	mm	70	30	80	70	40	80	50	120	60
Slide Adjustment	mm	50			55		60		75	
Maximum closing height	mm	195	215	195	220	235	250	265	310	340
Upper table size	mm	300×230×50			360×250×50		400×300×70		500×360×70	
Lower table size	mm	680×300×70			800×400×65		850×440×80		900×500×80	
Die shank hole	mm	Φ38.1			Φ38.1		Φ38.1		Φ50	
Main motor	KW.P	3.7×4			3.7×4		5.5×4		5.5×4	
Slider adjustment		手动调整带显示器 Manual adjustment (with digital display)								
air pressure	kg/cm <sup>2</sup>	6			6		6		6	

## 1 配置 CONFIGURATION

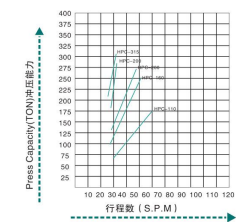
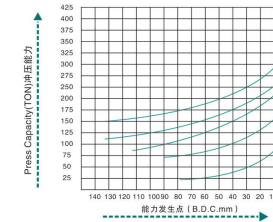
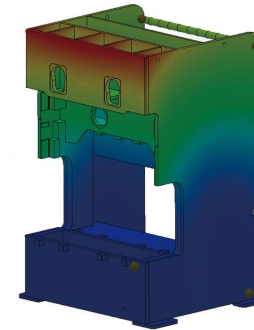
标准配置	STANDARD UNIT
变频器	计数器
触摸屏	空气源接头
预载计数器	二度落保护装置
预断计数器	电源插座
电子凸轮	维护工具及工具箱
油压式过载保护装置	使用说明书
手动式滑块调整装置	
电动式滑块调整装置	
机械式模高指示器	
电动式模高指示器	
滑块及磨具平衡装置	
曲轴角度指示器	

选购项目	OPTIONAL
电动式黄油润滑装置	
气压模垫装置	
脚踏开关	
快速换模装置 (举模器、夹模器或移模臂)	
滑块上部打料装置	
模具照明装置	
防震脚	
光电保护装置	
送料机 (空气、机械及 NC 各类)	
料架	
矫平机	
机械手	

WDA-80		WDA-110		WDA-160		WDA-200		WDA-260		WDA-300		WDA-400	
V	H	V	H	V	H	V	H	V	H	V	H	V	V
80		110		160		200		260		300		400	
4	2	6	3	6	3	6	3	7	3.5	8			10
65		50		35		35		30		30		30	
35-80	80-120	30-60	60-90	20-50	40-70	20-50	50-70	20-40	40-50	20-40			20-40
150	70	180	80	200	90	200	100	250	150	250			250
80		80		100		110		120		120		120	
340	380	360	410	460	510	460	510	500	550	500			550
560×420×70		650×470×80		700×550×90		850×630×90		950×700×100		1250×750×100		1350×800×100	
1000×550×90		1150×600×110		1250×800×140		1400×820×160		1500×840×180		1600×860×190		1650×900×200	
Φ50		Φ50		Φ65		Φ65		Φ65		Φ65		Φ65	
7.5×4		11×4		15×4		18.5×4		22×4		30×4		37×4	
电动调整具有限定和显示功能 Electric adjustment has the function of limitation and display													
6		6		6		6		6		6		6	6



有限元分析 FINITE ELEMENT ANALYSIS



CRAPH能力曲线图

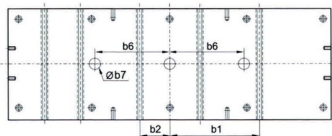
配置 CONFIGURATION

标准配置	STANDARD UNIT	选购项目	OPTIONAL
干式离合刹车器	High performance dry clutch & brake	模垫装置	Die cushion
标准操作系统	电子式曲轴角度指示器 Electronic crank angle led display	光电安全装置	Safety light curtain
Standard operating system of shuangying	电子式运转速度指示器 Electronic speed led display	滑块上部顶料装置	Slide knock-out device
运转模式选择	/切/寸动/安全-行程/连续/	主马达逆转装置	Main motor reversing circuit
operation Mode Selection	Off/inching/safety one stroke/continuous	脚踏开关	Foot switch
油压过负荷保护装置	Hydraulic overload protector	安全挡块及安全插销	Safety die block with plug
变频调速	Frequency conversion	附检知双联电磁阀	Dual solenoid valve with
度落保护装置	Overrun detector	误送检知装置	Inverter
T型双手按钮操作台	Portable 2-hand push	飞轮刹车装置	Misfeed detector
双联电磁阀	Dual solenoid valve	防震机械脚	Flywheel brake
电动滑块调整装置	Automatic slide adjust device	快速换模装置	Quick mold replace mechanism
数字式模高指示器(单位0.1mm)	Digital die height indicator (unit 0.1mm)	上夹模器	Quick die change system
电动黄油润滑装置	Automatic lubrication system	下夹模器	Upper die clamber
累计计数器6位数	Total counter, 6 digits	举模器	Die lifter
预调计数器6位数	Preset counter, 6 digits	移模臂	Dile arm
保养计数器6位数	Maintenance counter, 6 digits	自动送料装置	Automatic feed equipment
寿命计数器6位数	Life counter, 6 digits	三合一NC矫直送料机	NC straightener feed c/w uncoiler (3 in)
电子式旋转凸轮开关预备6连	Electronic rotary cam switch(6 spare channel)	NC滚轮送料机	NC roller feeder
喷风装置1/2"一路	Air ejector 1/2one channel	二合一料架兼矫直机	straightener c/w uncoiler(2 in 1)
空气源接头1/2"二回路	Air source receptacle 1/2 two channe	矫直机(整平机)	Staightene
误送检知插座	Missfeed detection circuit		
电源插座	Power Receptacle		

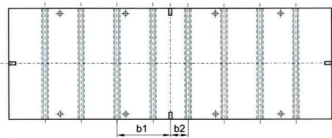


规格	Specification	单位	WDC-110		WDC-160		WDC-200		WDC-250		WDC-315	
型式	Model		V	H	V	H	V	H	V	H	V	H
吨数	Capacity	Tom	110		160		200		250		315	
冲压发生位置	Rated tonnage point	mm	5	3	6	3	6	3	7	3.5	7	3.5
每分钟行程数	Stable speed	s.p.m	35-65	50-100	30-55	40-85	25-45	35-70	20-35	30-60	20-35	30-50
行程	Stroke	mm	180	110	200	130	250	150	280	170	300	170
最大闭合工作高度	Die height	mm	400	435	450	485	500	550	550	605	550	615
滑块调整量	Slide adjustment	mm	100		100		120		120		120	
下工作台尺寸	Bolster area	mm	1800 × 650 × 130		2000 × 760 × 150		2400 × 840 × 170		2700 × 900 × 170		2750 × 900 × 190	
上工作台尺寸	Slide area	mm	1400 × 500 × 70		1600 × 550 × 70		1850 × 650 × 95		2100 × 700 × 95		2100 × 700 × 95	
主马达	Main motor	kw × p	11 × 4		15 × 4		18.5 × 4		22 × 4		30 × 4	
使用空气压力	Air pressure	kg/cm <sup>2</sup>	6		6		6		6		6	
冲床精度	Presses precision		GB/JIS 1 class 一级									
冲床(长 × 宽 × 高)	Presses dimension	mm	1745 × 2000 × 3059		1940 × 2200 × 3709		2235 × 2620 × 3849		2545 × 3000 × 4304		2545 × 3010 × 4689	
冲床重量	Capacity	ton	14.2		20		27.5		45.5		48	
模垫顶板面积	Die cushion work part dimension	mm <sup>2</sup>	350 × 235 × 2组		410 × 260 × 2组		540 × 350 × 2组		640 × 470 × 2组		640 × 470 × 2组	

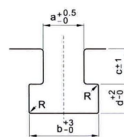
上下工作台  
slide bolster



上工作台

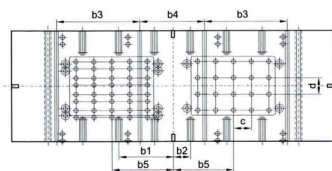


图形一



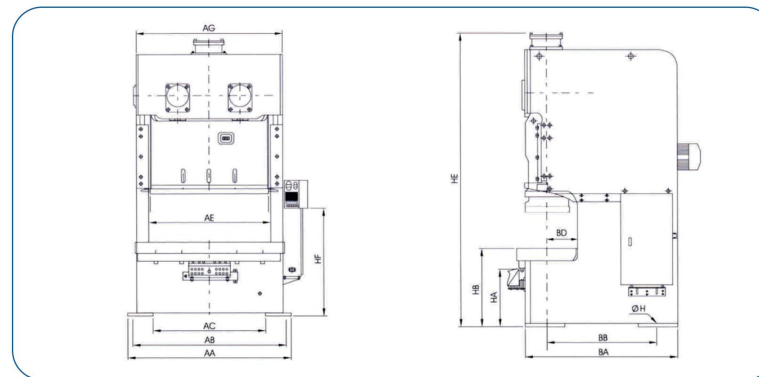
T-slot T型槽详图

MODEL	A	B
a	22	28
b	37	48
c	24	28
d	16	20
R	1	1



图形二 (含举模器, 用 "U" 型槽)  
Include The Lifting, Use the U-Slot

外形尺寸  
DIMENSIONS



规格 Specification	WDC-110		WDC-160		WDC-200		WDC-250		WDC-315	
型式 Model	V	H	V	H	V	H	V	H	V	H
AA	2000		2200		2620		3000		3010	
AB	1900		2080		2460		2800		2810	
AC	1360		1520		1820		2200		2210	
AE	1510		1660		1990		2220		2230	
AG	1780		1980		2320		2590		2600	
BA	1745		1940		2235		2545		2545	
BB	1295		1380		1885		2145		2145	
BD	330		385		425		455		455	
HA	(630)		(730)		(790)		(820)		(820)	
HB	830		990		1070		1100		1120	
HE	3059		3709		3849		4304		4689	
HF	1240		1440		1570		1587		1587	
ΦH	Φ35		Φ47		Φ54		Φ54		Φ54	

规格参数  
Specification

规格 Specification	WDC-110	WDC-160	WDC-200	WDC-250	WDC-315	
T型槽型号	A	A	B	B	B	
T型槽条数(上/下)	4/6	6/8	6/8	6/8	6/8	
b1	375	375	375	450	450	
b2	125	125	125	150	150	
b3	320	520	710	680	680	
b4	430	520	520	540	540	
b5	255	415	455	510	510	
b6	320	350	375	450	450	
Φb7	Φ50	Φ50	Φ50	Φ50	Φ50	
图形二	模垫销孔数目 × 孔径	30 × Φ20 <sup>+0.5</sup> <sub>-0.1</sub>	48 × Φ20 <sup>+0.5</sup> <sub>-0.1</sub>	48 × Φ28 <sup>+0.5</sup> <sub>-0.1</sub>	70 × Φ28 <sup>+0.5</sup> <sub>-0.1</sub>	70 × Φ28 <sup>+0.5</sup> <sub>-0.1</sub>
	销孔距离c × d	75 × 100	75 × 75	100 × 100	100 × 100	100 × 100

■ WDD series semi closed single point precision punch



规格参数 SPECIFICATION

规格	Specification	单位	WDD-80	WDD-110	WDD-160	WDD-200	WDD-260	WDD-315	WDD-400
型式	Model		V H	V H	V H	V H	V H	V H	V H
顺数	Capacity	Ton	80	110	160	200	260	315	400
冲力发生位置	Rated Tonnage point	mm	4 2	6 3	6 3	6 3	7 3.5	8 4	8 4
行程	Stroke	mm	150 70	180 80	200 90	200 100	250 150	250 150	250 150
最大闭合工作高度	Die Height	mm	340 380	360 410	460 510	460 510	500 550	450 550	550 600
每分钟行程数	Stroke per Minute	s.p.m	35-80 80-125	30-60 60-90	20-50 40-70	20-50 50-70	20-40 40-50	20-40 30-50	20-40 30-50
滑块调整量	Slide Adjustment	mm	80	80	100	110	120	120	120
上工作台尺寸	Slide Area	mm	560 x 420 x 70	650 x 470 x 80	700 x 550 x 90	800 x 630 x 90	900 x 700 x 100	1200 x 750 x 100	1300 x 800 x 100
下工作台尺寸	Boister Area	mm	760 x 550 x 90	900 x 600 x 110	980 x 880 x 140	1140 x 820 x 160	1280 x 840 x 180	1330 x 880 x 190	1400 x 900 x 200
主电动机	Main Motor	kw x p	7.5 x 4	11 x 4	15 x 4	18.5 x 4	22 x 4	30 x 4	37 x 4
滑块调整机构	Slide Adjust Device	HP	电动 electrical driving						
使用空气压力	Air Pressure	kg/cm <sup>2</sup>	6	6	6	6	6	6	6
冲床(长 x 宽 x 高)	Presses Dimension	mm	1890 x 1300 x 3000	1965 x 1400 x 3200	1965 x 1400 x 3200	1965 x 1400 x 3200	1965 x 1400 x 3200	1965 x 1400 x 3200	2400 x 3200 x 4600
冲床重量	Presses Weight	Ton	7.8	10.5	17.8	25.3	30	35	40
冲床精度	Presses Precision		GB/JIS 1class 一级						
模垫能力	Die Cushion Capacity	Ton	3.6	6.3	10	14	14	14	14
模垫行程长	Stroke	mm	70	80	80	100	100	100	100
模垫有效面积	Die cushion effective area	mm <sup>2</sup>	450 x 310	500 x 350	650 x 420	700 x 480	700 x 480	700 x 480	700 x 480

配置 CONFIGURATION

标准配置	STANDARD UNIT
液压式过载保护装置	Hydraulic over-load protector
电动式滑块调整装置	Automatic slide adjust device
电动式模高指示器	Automatic die height indicator
滑块及模具平衡装置	Balance device
变频调速	Frequency conversion
电子凸轮	Electronic cam
曲轴角度指示器	Crank angle indicator
计数器	Electrical stroke counter
空气源接头	Air source receptacle
二度落保护装置	Against over-run safety device
电动式黄油润滑装置	Electrical automatic lubrication system
电源插座	Power supply

选购项目	OPTIONAL
气压模式装置	Pneumatic die cushion device
预裁计数器	Preset counter
预断计数器	Preset counter
脚踏开关	Foot switch
快速换模装置	Quick die change device
(举模器、夹模器或移模臂) (Die lifter, clamp and die arm sepjes)	
滑块上部打料装置	Slide knock-out device
误送检测装置	Misfeed detection consent
防震脚	Anti-vibration press mount
光电保护装置	Photo-electronic safety device
送料机(空气、机械及NC各类)	Feeder
料架	Uncoiler
矫平机	Leveler
机械手	Mechanism hand
模具照明装置	Die room light
左(右)侧送料装置	Left(right) feeding device

## ■ WDJ series closed single point precision punch



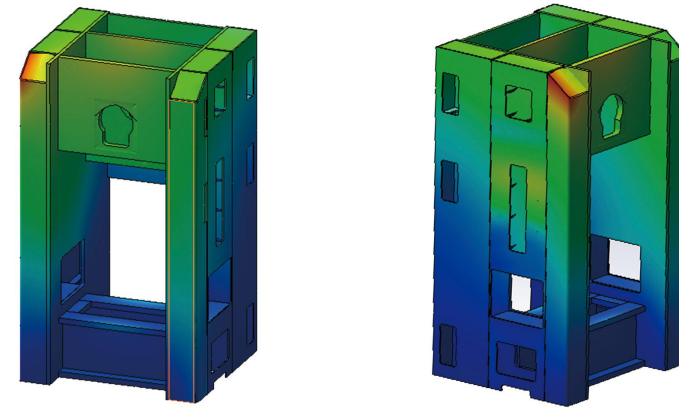
标准配置		STANDARD UNIT	
油压式过载保护装置	Hydraulic overload protection device		
电动式滑块调整装置	Electric slide adjusting device		
电动式模高指示器	Electric die height indicator		
滑块及模具平衡装置	Slide and the die balance device		
电子凸轮	Electronic cam		
曲轴角度指示器	Crank angle indicator		
计数器	Counter		
空气源接头	Air source adapter		
二度落保护装置	Two degree drop protection device		
空气吹料装置	The air blowing device		
维护工具及工具箱	Maintenance tool and tool box		
机械式防震脚	Mechanical Shockproof foot		
误送料检知装置	Fault detection device		
主马达逆转装置	The main motor reversing device		
变频调速	Frequency conversion		

进口集油式消音器	Imported oil-collecting silencer
触摸屏控制装置	Touch screen control device
电动式黄油润滑装置	Electric butter lubrication device

### 选购项目

模垫装置	Die cushion device
快速换模装置	Quick die change device
(举模器、夹模器或移模器)	(for the mold, mold clamp mold or shift)
滑块上部打料装置	The slider a knockout device
模具照明装置	Die lighting device
自动送料装置	The automatic feeding device
(送料机、料架、矫正机)	(feeder, feeder, leveling machine)
预调、预裁计数器	Pre, pre cut counter
脚踏开关	foot switch
观点保护装置	

## 有限元分析 FINITE ELEMENT ANALYSIS



## 规格参数 SPECIFICATION

规格	Specification	单位	WDJ-110		WDJ-160		WDJ-200		WDJ-250		WDJ-300		WDJ-400		WDJ-500		WDJ-630	
型式	Type		V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H
吨数	Tonnes	KN	110		110		200		250		300		400		500		500	
能力发生位置	Ability location	mm	6	3	6.5	4	7	4	7	4	9	7	9	7	13	7	13	7
行程	stroke	mm	180	40	200	80	250	40	250	40	300	250	300	250	350	300	350	300
每分钟行程数	Number of trips per minute	s.p.m	20-45	80-180	20-40	60-100	20-40	60-130	20-40	50-110	20-35	10-25	20-30	20-35	10-25	15-30	10-25	15-30
最大闭合工作高度	Maximum closed working height	mm	450	290	500	310	550	350	550	380	650	550	550	700	700	650	700	650
最大上模重量	Maximum die weight	kg	800		800		1200	1000	800		1500		1000	1500	1500		1500	
滑块调整量	Slider adjustment	mm	100		100	100	150	100	150	100	150	120	150	120	150		150	
上工作台尺寸	Upper studio size	mm	700x600		900x700		1200x650		1200x800		1000x900		1100x1000		1200x1000		1400x1200	
下工作台尺寸	Lower studio size	mm	700x700		1000x700		1300x820		1300x900		1100x1000		1200x1100		1200x1100		1400x1200	
冲床重量	Moving bed weight	tons	14		19		21		34		35		40		63		80	
冲床精度	Moving bed accuracy		GB/JIS1级															
台身厚度	Chamber thickness	mm	140		150		160		180		200		200		220		240	
侧向开口	Lateral opening	FBxH	400x400	400x400	780x430	780x430	780x600	780x600	780x600	780x600	400x500	900x600	900x600	450x600	500x650		500x650	
工作台离地距离	Studio distance from the ground	mm	900		900		950		950		950		950		1000		1000	
主电动机	Main motor	kw.p	11x4		15x4		18.5x4		30x4		30x4		45x4		55x4		75x4	
滑块调整马达	Slider adjustment motor	kw.p	0.75x4		0.75x4		0.75x4		1.5x4		1.5x4		2.2x4		2.2x4		2.2x4	
台身结构	Airframe mechanism		一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式
			One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame



## 规格参数 SPECIFICATION

规格	Specification	单位	WDP-110		WDP-160		WDP-200		WDP-250		WDP-300		WDP-400		WDP-500		WDP-630	
			V	H	V	H	V	H	V	H	V	H	V	H	V	H	V	H
型式	Type																	
吨数	Tonnes	KN	110		110		200		250		300		400		500		500	
能力发生位置	Ability location	mm	6	3	6.5	4	7	4	7	4	9	7	9	7	13	7	13	7
行程	stroke	mm	180	40	200	80	250	40	250	40	300	250	300	250	350	300	350	300
每分钟行程数	Number of trips per minute	s.p.m	20-45	80-180	20-40	60-100	20-40	60-130	20-40	50-110	20-35	10-25	20-30	20-35	10-25	15-30	10-25	15-30
最大闭合工作高度	Maximum closed working height	mm	450	290	500	310	550	350	550	380	650	550	550	700	700	650	700	650
最大上模重量	Maximum die weight	kg	800		800		1200		1000		800		1500		1000		1500	
滑块调整量	Slider adjustment	mm	100	100	100	100	150	100	150	100	150	120	150	150	150	150	150	150
上工作台尺寸	Upper studio size	mm	700x600		900x700		1200x650		1200x800		1000x900		1100x1000		1200x1100		1400x1200	
下工作台尺寸	Lower studio size	mm	700x700		1000x700		1300x820		1300x900		1100x1000		1200x1100		1200x1100		1400x1200	
冲床重量	Moving bed weight	tons	14		19		21		34		35		40		63		80	
冲床精度	Moving bed accuracy		GB/JIS1级															
台盘厚度	Chamber thickness	mm	140		150		160		180		200		200		220		240	
侧向开口	Lateral opening	FBxH	400x400	400x400	780x430	780x430	780x600	780x600	780x600	780x600	780x600	400x500	900x600	900x600	450x600	500x650	500x650	500x650
工作台离地距离	Studio distance from the ground	mm	900		900		950		950		950		950		1000		1000	
主电动机	Main motor	kw.p	11x4		15x4		18.5x4		30x4		30x4		45x4		55x4		75x4	
滑块调整马达	Slider adjustment motor	kw.p	0.75x4		0.75x4		0.75x4		1.5x4		1.5x4		2.2x4		2.2x4		2.2x4	
台身结构	Airframe mechanism		一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式	一体式
			One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame	One-piece frame

## 配置 CONFIGURATION

标准配置	STANDARD UNIT
油压式过载保护装置	Hydraulic overload protection device
电动式滑块调整装置	Electric slide adjusting device
电动式模高指示器	Electric die height indicator
滑块及模具平衡装置	Slide and the die balance device
电子凸轮	Electronic cam
曲轴角度指示器	Crank angle indicator
计数器	Counter
空气源接头	Air source adapter
二度落保护装置	Two degree drop protection device
空气吹料装置	The air blowing device
维护工具及工具箱	Maintenance tool and tool box
机械式防震脚	Mechanical Shockproof foot
误送料知装置	Fault detection device
主马达逆转装置	The main motor reversing device
变频调速	Frequency conversion

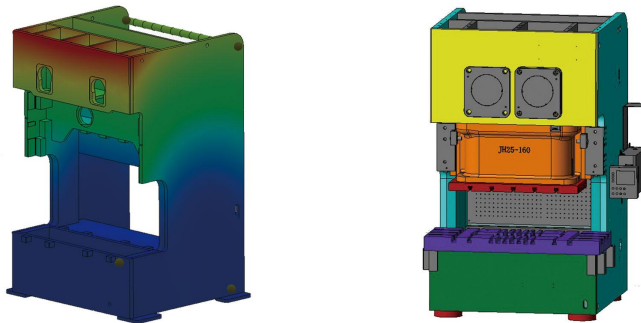
进口集油式消音器	Imported oil-collecting silencer
触摸屏控制装置	Touch screen control device
电动式黄油润滑装置	Electric butter lubrication device

选购项目	OPTIONAL
模垫装置	Die cushion device
快速换模装置	Quick die change device
(举模器、夹模器或移模器)	(for the mold, mold clamp mold or shift)
滑块上部打料装置	The slider a knockout device
模具照明装置	Die lighting device
自动送料装置	The automatic feeding device
(送料机、料架、矫正机)	(feeder, feeder, leveling machine)
预调、预载计数器	Pre, pre cut counter
脚踏开关	foot switch
观点保护装置	

## ■ WDM series closed double point precision punch



## 有限元分析 FINITE ELEMENT ANALYSIS



## 配置 CONFIGURATION

标准配置	STANDARD UNIT
标准操作系统	电子式曲轴角度指示器 Electronic crank angle led display 电子式运转速度指示器 Electronic speed led display
运转模式选择	切削/安全-行程连续 / Off/finishing/safety one stroke/continuous
油压过负荷保护装置	Hydraulic overload protector
变频调速	Frequency conversion
二度落保护装置	Overrun detector
T型双手按钮操作台	Portable 2-hand push
双联电磁阀	Dual solenoid valve
电动滑块调整装置	Automatic slide adjust device
数字式模高指示器(单位0.1mm)	Digital die height indicator (unit 0.1mm)
电动黄油润滑装置	Automatic lubrication system
累计计数器6位数	Total counter. 6 digits
预调计数器6位数	Preset counter. 6 digits
保养计数器6位数	Maintenance counter. 6 digits
寿命计数器6位数	Life counter. 6 digits
电子式旋转凸轮开关预备6连	Electronic rotary cam switch(6 spare channel)
喷风装置1/2" 一回路	Air ejector 1/2 one channel
空气源接头1/2" 二回路	cle 1/2 two channel
误送检知插座	Missfeed detection circuit

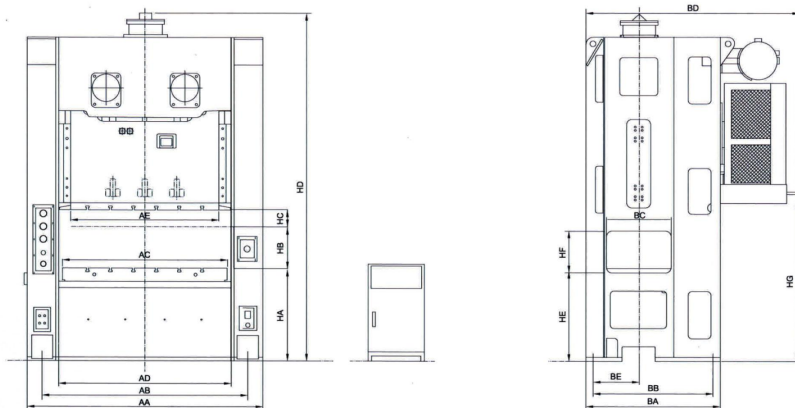
选购项目	OPTIONAL
模垫装置	Die cushion
光电安全装置	Safety light curtain
滑块上部顶料装置	Slide knock-out device
主马达逆转装置	Main motor reversing circuit
脚踏开关	Foot switch
安全挡块及安全插销	Safety die block with plug
误送检知装置	Inverter
防震机械脚	Flywheel brake
快速换模装置	Quick mold replace mechanism
上夹模器	Quick die change system
下夹模器	Upper die clammer
举模器	Die lifter
移模臂	Die arm
基础螺丝及基础板	Anchor bolts & foundation plates
自动送料装置	Automatic feed equipment
三合一NC矫直送料机	NC straightener feed c/w uncoiler(3 in 1)
NC滚轮送料机	NC roller feeder
二合一料架兼矫直机	Staightener c/ w uncoiler(2 in 1)
矫直机(整平机)	Staightene

## 规格参数 SPECIFICATION

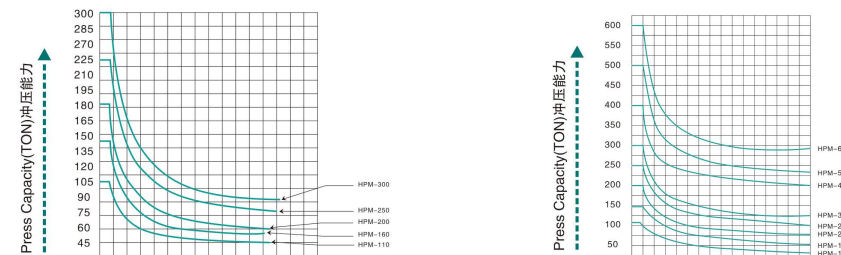
规格	Specification	单位	WDM-110		WDM-160		WDM-200		WDM-250		WDM-300		WDM-400		WDM-500		WDM-630		
型式	Model		V	H	V	H	V	H	V	H	V	H	V	V	V	V	V	V	
吨数	Capacity	Tom	110	160	200	250	300	400	500	630									
冲力发生位置	Rated Tonnage point	mm	5	3	6	3	6	3	7	3	7	3	7	7	10				
行程	Stroke	mm	180	110	180	130	250	150	280	150	300	170	300	300	300				
每分钟行程数	Stroke per Minute	s.p.m	35-65	50-100	30-55	40-85	20-50	35-70	20-40	30-60	20-35	30-50	20-40	15-25	15-25				
最大闭合工作高度	Die Height	mm	400	350	450	400	500	450	550	450	550	450	550	600	600				
滑块调整量	Slide Adjustment	mm	100	100	120	120	120	120	120	120	120	120	120	120	200				
上工作台尺寸	Slide Area	mm	1400×550	1600×650	1850×750	2400×900	2400×900	2620×1000	3200×1200	3740×1300									
下工作台尺寸	Boister Area	mm	1550×750	1800×780	2200×940	2500×1000	2500×1000	2700×1100	3400×1200	4000×1400									
侧向开口	Side opening	mm	600×350	700×450	900×600	900×600	900×600	900×600	1000×700	1000×700									
主电动机	Main Motor	kw × p	11×4	15×4	18.5×4	30×4	30×4	37×4	55×4	75×4									
使用空气压力	Air Pressure	kg/cm <sup>2</sup>	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	
冲床精度	Presses Precision		GB/JIS 1class 一级																
冲床(长×宽×高)	Presses dimension	mm	2155×2280×3180	2308×2560×3682	2523×3000×3915	2789×3600×4593	2889×3600×4728	3225×3800×5150	3655×4500×5150	3955×5100×5971									

规格	WDM-110		WDM-160		WDM-200		WDM-250		WDM-300		WDM-400		WDM-500		WDM-630	
MODEL	V	H	V	H	V	H	V	H	V	H	V	V	V	V	V	V
AA	2280		2590		3000		3600		3600		3800		4500		5100	
AB	1980		2240		2650		3250		3250		3450		4050		4650	
AB	1550		1800		2200		2500		2500		2700		3400		4000	
AD	1680		1880		2290		2800		2800		3000		3600		4200	
AE	1400		1600		1850		2100		2200		2620		3200		3740	
BA	1236		1450		1600		1770		1870		2100		2325		2625	
BB	1076		1290		1440		1610		1710		1940		1925		2265	
BC	600		700		900		900		900		900		1000		1100	
BD	2151		2309		2523		2799		2899		3225		3650		3955	
BE	420		490		620		670		770		770		700		820	
HA	930		1000		1000		1100		1200		1200		1250		1700	
HB	400	435	450	400	500	450	550	450	550	450	550	600	600	600	600	600
HC	180	110	180	130	250	150	280	170	300	170	300	300	300	300	300	300
HC	3180	3757	3682	4015	3915	4593	4438	4903	4729	5150	5281	5971	5971	5971	5971	5971
HE	900		950		940		1050		1150		1150		1100		1655	
HF	380		450		600		600		600		600		700		700	
HG	1583	1730	1655	1910	1810	2081	1926	2296	2131	2495	2765	3450	3450	3450	3450	3450

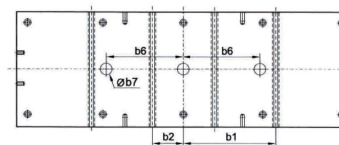
外形尺寸  
Dimensions



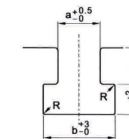
能力曲线图 Graph



上下工作台 slide bolster

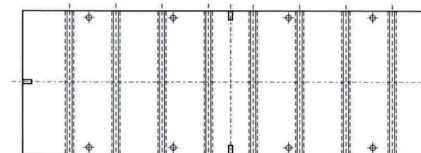


上工作台

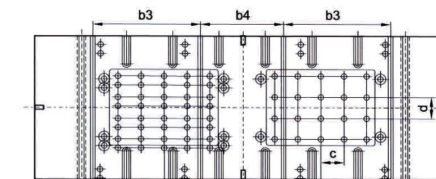


T-slot T型槽详图上工作台

MODEL	A	B
a	22	28
b	37	48
c	24	28
d	16	20
R	1	1



图形一



图形二 (含举模器, 用U型槽)

MODEL	WDM-110	WDM-160	WDM-200	WDM-250	WDM-300	WDM-400	WDM-500	WDM-630
T型槽型号	A	A	B	B	B	小台面 大台面	小台面 大台面	小台面 大台面
T型槽条数	6/6	6/8	6/8	6/8	6/8	6/8 10/10	8/8 10/10	8/8 12/12
b1	375	375	375	450	450	450	450	450
b2	125	125	125	150	150	150	150	150
b3	240	520	710	680	680	680	800	800
b4	750	520	520	540	540	540	780	780
b5	410	415	455	510	510	510	750	900
Φb7	320	350	375	450	450	730	760	1000
模垫销孔 数目×孔径	30×Φ20	48×Φ20	48×Φ28	70×Φ28	70×Φ28	70×Φ28	96×Φ28	96×Φ28
销孔距离 c×d	75×100	75×75	100×100	100×100	100×100	100×100	100×100	100×100

■ JH21 series open single point precision punch



标准附属配件 STANDARD ACCESSORY			可选附属配件 OPTIONAL ACCESSORY		
1	油压过负荷保护装置	1 式	1	手动黄油润滑装置	1 式
2	电动滑块调整装置	1 式	2	主马达逆转装置	1 式
3	电动黄油润滑装置	1 式	3	滑块上部顶料装置【滑块打料杆】	1 式
4	滑块及模具平衡装置	1 式	4	预调计数器 (6 位数)	1 组
5	电子凸轮 (PAC10) 控制器	1 组	5	保养用小时定时器	1 组
6	指针式曲轴角度指示器	1 式	6	光电安全装置	1 式
7	数字式模高指示器 (0.1mm)	1 组	7	防震装置S78-10-06	1 式
8	定速马达	1 组	8	快速换模装置(详细规格参阅附件)	1 式
9	可编程控制器 PLC	1 组	9	无桶式气压模垫装置	1 组
10	维护工具及工具箱	1 套	10	二度落保护装置	1 式
11	操作说明书及检查成绩表《中文版》	1 份	11	安全网	1 式

规格参数 SPECIFICATION

Type [Model]	25 T	45 T	63 T	80 T	125 T
nomal force	250kN	450kN	630kN	800kN	1250kN
Ability occurrence point (mm)	3	4	4	5	5
slide stroke (mm)	80	100	120	140	160
max die set height (mm)	250	270	300	320	370
Number of stroke of slider (mm)	100	80	70	60	50
Mold height adjustment (mm)	50	60	80	80	100
throat depth (mm)	210	230	300	300	370
Slider surface size (mm)	250×360	340×410	400×480	420×560	520×620
bed dimension (mm)	700 ×400	810 ×440	900 ×580	1000 ×580	1120 ×720
The main motor (mm)	3×4	5.5×6	5.5×6	7.5×4	11×4

Type [Model]	160 T	200 T	250 T	315 T	400 T
nomal force	1600kN	2000kN	2500kN	3150kN	4000kN
Ability occurrence point (mm)	6	6	8	8	10
slide stroke (mm)	180	200	200	200	200
max die set height (mm)	400	450	450	430	430
Number of stroke of slider (mm)	45	40	40	30	25
Mold height adjustment (mm)	110	110	110	120	120
throat depth (mm)	390	430	450	420	420
Slider surface size (mm)	580×700	650×880	700×930	650×850	650×850
bed dimension (mm)	1200 ×760	1400 ×840	1500 ×880	1400 ×800	1400 ×800
The main motor (mm)	15×6	18.5×6	22×6	30×6	37×6