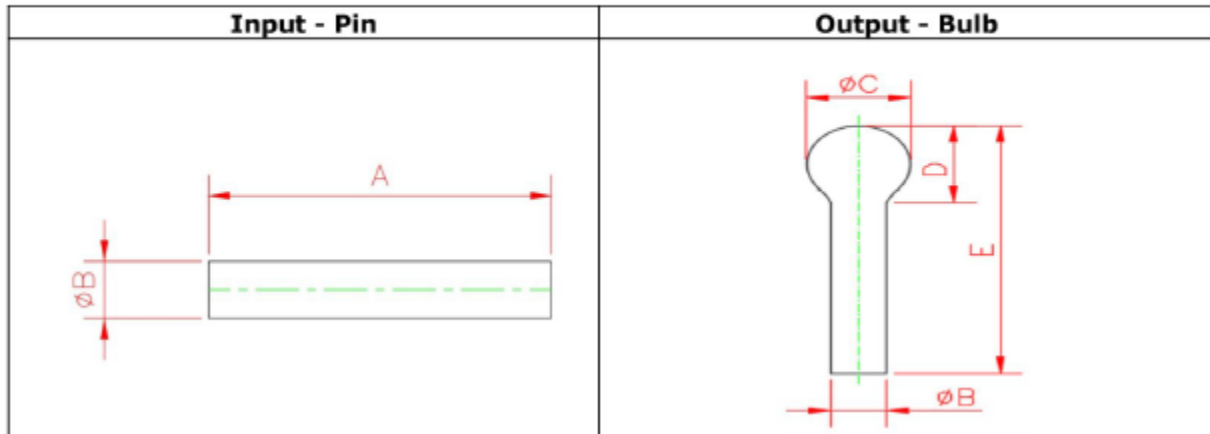


Pre-Quotation information required for Up setter

Component Details:



	Minimum (mm)	Maximum (mm)		Minimum (mm)	Maximum mm)
A	400	720	B	11,5	13,5
B	11,5	13,5	C	30	55
			D	30	55
			E	190	500
Material	DIN-41Cr4, DIN-X45CrSi9-3, DIN-X53CrMnNiN21-9				
Single Head/Twin Head	Twin head				
Cycle time	30s - 45s				
Loading of parts-Auto/Manual	Manual Auto				
Unloading of Bulb from Up setter to Press-Auto/manual	Manual Auto				

Quantity Details

Annual Expected Qty	300 000
Rate of production (Parts/hr.)	50 - 65

3) Machine structure

The machine consists of machine bed, hydraulic system, heating system, electrical control system, coolant system and auto loading & unloading system;

1. Upset host

Fuselage steel plate welding structure, working face through large-scale machine tools to ensure the accuracy of the machine assembly. The fuselage is equipped with anvil system part, clamping system part, upsetting system part, etc.

① Anvil system consist of anvil cylinder, guide block mechanism, anvil electrode, anvil seat and alloy conductive block; guide block installed on two pieces round guide column, the column through heat treatment to ensure the strength and service life; anvil cylinder push the guide block to ensure the force balance in processing; Anvil electrode adapts T2 copper and installed on the guide block, another side is connected with transformer; anvil seat and alloy

conductive block connected with anvil electrode. Alloy conductive block is wearing parts

② Clamping system consist of clamping cylinder, clamping electrode and jaw conductive block

③ Add anti-bending support

④ Upsetting cylinder push guide block mechanism movement. Upsetting cylinder adapt double oil circuit, reduce the return time and improve the working efficiency

2. Hydraulic system

① Medium pressure oil circuit, supply oil by vane pump, the hydraulic valve is mounted on the integrated oil block. Hydraulic valve adapts oil research series hydraulic parts;

② Proportional pressure regulator control pressure.

3. Electrical & Pneumatic System

① Using Mitsubishi PLC, Control module, touch screen and replacement encoder

Setting Parameter

Setting forging forward multiple distance

Setting transformer multiple heating voltage

Display the real time position of forging cylinder

② Low-voltage electric is Schneider

③ Upsetting cylinder stroke is controlled by encoder

④ Operate function: Adjustment, semi-Auto, Auto, you can choose by operator

4. Heat System

① 2 sets 50 KVA single phase transformer to heat, low voltage and heavy current;

② Adapt SCR voltage regulator, stepless regulation of primary voltage of transformer

③ With infrared detection device

5. Cooling system

① Cooling for anvil electrode, clamping electrode, hydraulic oil.

② Water pressure: 3-3.5 Bar

6. Auto loading & unloading system

The machine is equipped with auto loading and unloading system, save the labor.

4) Positioning method

Auxiliary support

5) Cycle time

Φ12.0-13.0 mm as standard, 15s-20s/piece (it's up to the shape of products);

Main Parameter

S/C	Name	Specification	Unit	Remark
1	Max. Hydraulic working pressure	16	Mpa	
2	Max forging force	120	KN	
3	Max. Stroke of forging cylinder	500	Mm	
4	Max. Stroke of anvil cylinder	200	Mm	
5	Max. Stroke of clamping cylinder	50	Mm	
6	Rod diameter	10-13	Mm	
7	Rod length	700	Mm	
	Power	50	KVA	2 sets

	Heat	Primary voltage	380	V	
		Frequency	50	Hz	
	Oil pump	Specification	YB1-40		
		Pressure	10	Mpa	
		Flow	40	MI/r	
	Motor	Power	7.5	KW	
		Speed	960	R/min	

Main configuration

#	Name	Specification	Brand
1	PLC		Mitsubishi
2	Hydraulic system		
3	Touch screen	GS-2107-WTBD	Mitsubishi
4	Low-voltage electrical appliances		Schneider
5	Pneumatic Components		AirTAC
6	proportionate valve		YUKEN
7	Voltage	3-phase 380V	