

# 锻 锤

## Forging Hammer

### ◆ 我公司设计制作的锻锤分为自由锻锤和模锻锤两种。

自由锻锤广泛应用于碳素钢和合金钢的自由锻造，有单臂式：CZ-D，拱式：CZ-G，桥式：CZ-Q三种系列。

模锻锤结构简单、成型性能好、万能性强而成为我国模锻行业中应用做多的设备。我公司与西德拉斯科公司合作生产了我国的第一台电动液压模锻锤，且在此基础上自行设计了25KJ的电动液压模锻锤。其中，为缅甸多功能柴油机厂生产的16吨蒸汽空气两用模锻锤，目前是国内最大的模锻锤。

The Forging Hammer we designed into Open Forging Hammer and Die Forging Hammer. Open Forging Hammer is widely used in open forging of Carbon and Alloy Steel, including Single Arm Open Forging Hammer: CZ-D, Arch Type Open Forging Hammer: CZ-G, Bridge Type Open Forging Hammer.

Die Forging Hammer is one of important Equipment used in forging industry for it's simple, good forming and strong universal. We've produced the first Electric-Hydraulic Die Forging Hammer in China of which was cooperated with Lasco Inc. of West Germany. And we designed 25KJ Electric-Hydraulic Die Forging Hammer by ourselves on the basis of it. Among them, 16 Ton Steam-Air die forging hammer produced for Multifunctional diesel engine plant of Burma, is the largest of China Currently.

### ◆ 典型业绩 Typical experience list

序号 item	设备名称 equipment	用户单位 user
1	2t 空气锤 air hammer	沈阳第一锻造厂 ShenYang First Forging Company
2	5t 桥式双动蒸汽空自由锻锤 bridge style steam and air free hammer	朝鲜 North Korea
3	3t 模锻锤 die forging hammer	沈飞 ShenYang Aircraft
4	16t 蒸汽空气两用模锻锤 steam-air die forging hammer	缅甸多功能柴油机厂 Burma multifunction diesel engine plant

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## ◆ 16吨蒸汽空气两用模锻锤技术规范

Technical standardization of 16 Ton Steam-Air die forging hammer

序号 Item	产品名称 Equipment	规格 Specification
1	落下部分的公称重量 (带上锻模) Nominal weight of drop part (including the forging die )	16000 kg
2	最大锤击能量 (不小于) The maximum energy of hammer(not less than)	400000 J
3	锤头最大行程 The maximum stroke of hammer head	1500 mm
4	不带燕尾榫的锻模最小闭合高度 The minimum close-height of the forging die without dovetail Joint	500 mm
5	两导轨间净距 Clear distance between two guide way	1200 mm
6	锤头前后方向长度 Forward inference and backward inference length of the hammer head	2000 mm
7	模座前后方向长度 Forward inference and backward inference length of the die holder	2100 mm
8	空气进入汽缸前的压力 Pressure of air before entering the cylinder	0.7 ~ 0.9MPa
9	空气的最高允许温度 The maximum acceptable temperature of air	150°C
10	上锻模公称重量	1500 kg
11	上锻模最大重量	4000 kg
12	砧座重量The weight of anvil	325217 kg
13	不计砧座时锻锤重量 The weight of forging hammer without anvil	94600 kg
14	机器总重 The total weight of the machine	419830 kg
15	机器轮廓尺寸 The contour dimensions of the machine	4500 x 2500 x 11604 mm

## ◆ 自由锻锤技术参数 Technical parameters

名称 Name	机器型号 type	CZ-D 3	CZ-Q 5
落下部份公称重量 kg Nominal weight of drop part		3000	5000
落下部分实际重量 kg Actual weight of drop part		3034	5040
打击能量 (不小于) kJ Against energy		105	170
最大行程 mm Maximum stroke		1200	1700
汽缸直径 mm Cylinder diameter		φ550	φ635
锤杆直径 mm Hammer rod diameter		φ300	φ200
两导轨间距离 mm Distance between two rail			750
锤杆中心至锤身距离 mm Distance Between hammer and rod center		950	
下砧面至地面距离 mm Distance from anvil to floor		750	730
两锤身间距离 mm Distance between tow hammer body			
立柱间距离 mm Distance between tow column			3900
下砧面至导轨距离 mm Distance from anvil to Guide			850
进汽 (气) 压力 Mpa Steam into power		蒸汽: 0.7~0.9 或 空气: 0.6~0.8 Steam : 0.7~0.9 or Air : 0.6~0.8	
进气管直径 mm Intake tube Diameter		φ125	5"
排气管直径 mm Exhaust Diameter		φ150	φ219
锤地面以上高度 mm High above floor		5650	7510
锤总高度 mm High of Hammer		7230	10365
安装面积 (长×宽) mm Installation area (Length×Width)		5200×2300	6270×2600
机器总重量 t Total weight		72.43	159.7

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