

# 2-DIE 2-BLOW COLD HEADER

# CDH

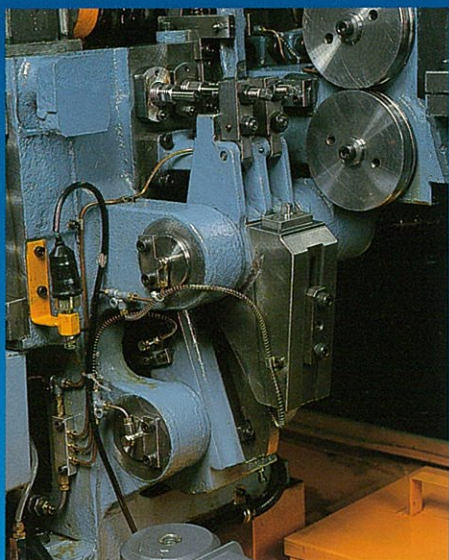


春日機械  
CHUN ZU

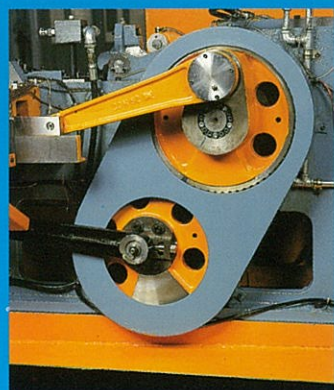




# CDH 2-DIE 2-BLOW COLD HEADER



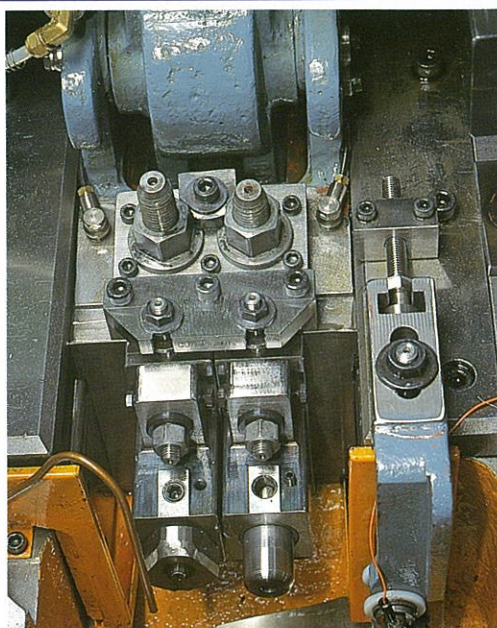
See 9



See 17

## Main Feature of CDH-52:

1. Close type cut-off knife is adapted to assure square and clean cut-off surface.
2. cut-off die is able to be adjusted forward and backward to assure cut-off clearance and cut-off quality.
3. compared with 1 die-2 blow header, 2 die-2 blow header has one more die which is good for products with square shoulder.
4. speed is faster than 1 die-2 blow headers.
5. The two punches are fixed on parallel and independent positions to allow easy adjusting.
6. Forging load is evenly shared by the two dies hence die life has improved.
7. Time for adjusting punch up-n-down motion and kick-out on 1 die-2 blow headers has been eliminated
8. pressure gripper mechanism is adapted to obtain stronger gripping function and precise transfer clearance so that transfer at high speed is possible.
9. K.O. mechanism has been greatly simplified for easy adjusting and front end position of K.O. pin always remains at the same position.
10. Close type cut-off mechanism patent pending. Roller has been alligned with cut-off rod to obtain the most sufficient and stable cut-off function.
11. Safety brake system has been adapted for quick stop.
12. Over arm mechanism is adapted to the main slide. Tool alloy steel material has taken for main slide liner to assure stable and accurate motion for long period.

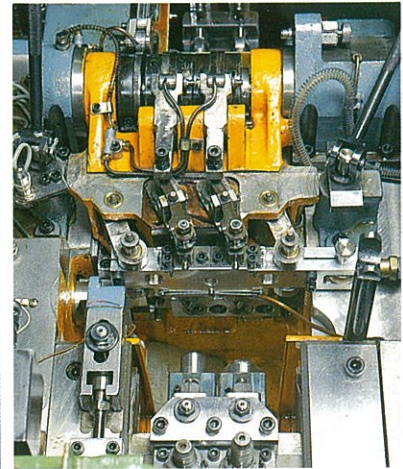


See 5,6,7,12

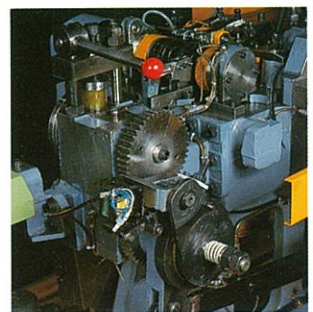


13. Majority of machine parts, especially machine frame and main slide, have been annealed so that inner stress has been removed to maintain accuracy at all time.
14. All cams have been designed and ground by the help of CAD/CAM so that functions of the cams are smooth and accurate.
15. Forward inching and backward inching is adapted for easy adjustment of die and punch.
16. Auto checker will check out all under functions:
  - 1) out-put speed
  - 2) main motor overload
  - 3) short feeding
  - 4) material end
  - 5) counter setting number
  - 6) lubrication oil pressure too low
  - 7) air pressure too low
  - 8) brake mechanism can function with both automatic and manual modes by a selectine switch. when set on automatic mode, power to motor cut and machine stops. when set on manual mode. brake will not function.

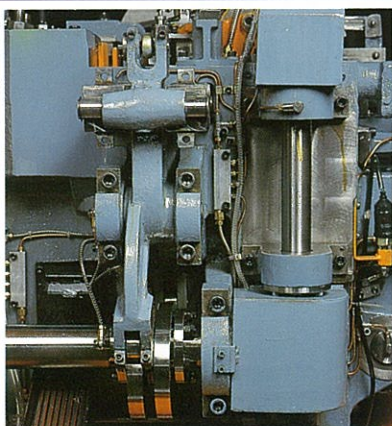
During operation, when any of the above listed functions happens, the machine will stop and pilot light will be on to the operator to check and eliminate problem for running.
17. Feeding length can be adjusted by eccentric plate underneath cut-off eccentric rod.
18. Ratchet wheel is adapted for feeding mechanism. Ratchet pawl can lift up during return motion to avoid unnecessary warn-out.



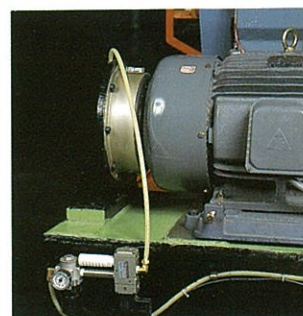
See 1,2,3,8



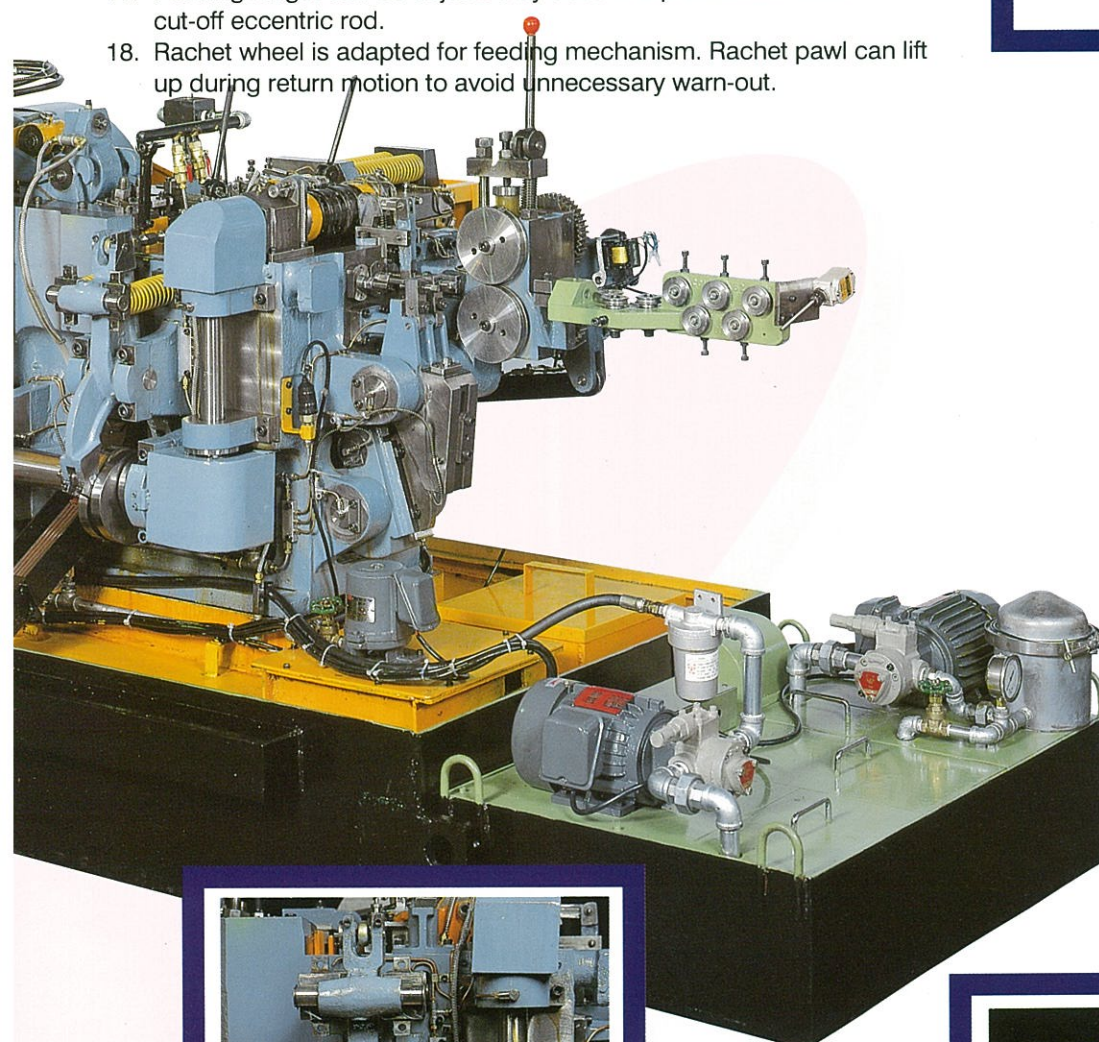
See 18 Patent Pending



See 14



See 11





# SPECIFICATION OF 2-DIE 2-BOLW HEADER



M/C TYPE		CDH-52	CDH-52L	CDH-62	CDH-82	CDH-82L	CDH-102	CDH-122	CDH-162	CDH-202
Description										
NO.OF FORGING STATION		2	2	2	2	2	2	2	2	2
FORGING LOAD	Kg	22,000	22,000	30,000	50,000	50,000	70,000	80,000	140,000	200,000
MAX.CUT-OFF DIA.	mm	φ 5	φ 5	φ 6	φ 8	φ 8	φ 10	φ 12	φ 16	φ 20
MAX.CUT-OFF LENGHT	mm	54	67	67	105	230	130	135	190	210
MAX.OUT PUT	pcs/min.	350	300	280	240	120	200	180	135	120
P.K.O.STROKE	mm	8	8	10	12	25	16	18	32	32
K.O.STROKE	mm	38	51	51	76	204	102	102	152	152
MAIN SLIDE	mm	104	122	122	190	340	210	194	280	296
MAIN MOTOR	HP	7.5	10	15	20	30	30	40	50	60
CUT-OFF DIE DIA. x LENGHT	mm	φ 38*30L	φ 38*30L	φ 30*45L	φ 53*56L	φ 35*56L	φ 45*59L	φ 63*69L	φ 64*100L	φ 75*120L
MAIN DIE DIA. x LENGHT	mm	φ 38*65L	φ 38*80L	φ 50*80L	φ 60*120L	φ 60*235L	φ 75*135L	φ 86*135L	φ 108*200L	φ 125*200L
DIE PITCH	mm	46	46	60	80	80	94	110	129	140
PUNCH DIA x LENGHT	mm	Moving φ26*70L Stationary φ31*65L	Moving φ26*70L Stationary φ31*65L	Moving φ40*90L Stationary φ40*90L	Moving φ45*100L Stationary φ45*95L	Moving φ45*145L Stationary φ45*140L	Moving φ53*115L Stationary φ53*115L	Moving φ60*130L Stationary φ60*130L	Moving φ75*185L Stationary φ75*185L	Moving φ90*215L Stationary φ90*215L
MACHINE NET WT.(APPROX)	Kg	4,150	4,700	7,000	9,500	19,500	16,000	18,000	40,000	50,000

Remarks : Modification subjected to change without any notice.

## Our Allied Products :

- Bolt Formers
- Parts Former
- Heading Machine
- Open Die Header
- Thread Rolling Machine
- Nut Formers
- Slotting Machine
- Forming Tools
- Thread Rolling Die
- Trimming Die



ISO 9001

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