

HEADING MACHINE

CH



春日機械
CHUN ZU

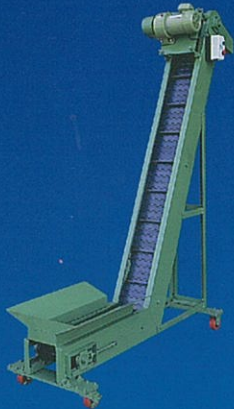


ISO 9001

CH HEADING MACHINE

Optional Attachments:

"L" type conveyor
to threader

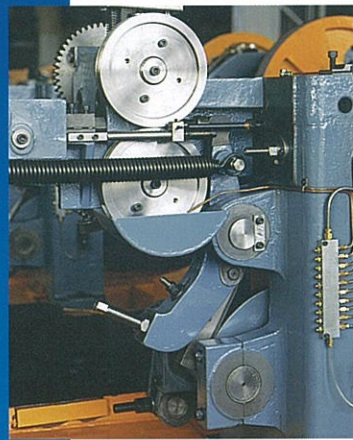


Centrifugal oil
separator



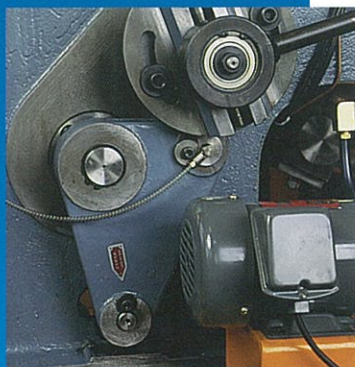
OTHER FEATURES OF CH:

1. With longest history, big numbers of production, and so many times of improvement, our experience will assure you of less trouble and high efficiency of our headers.
2. Starting from CH-3 to CH-30L, the series has many models for you to choose according to the diameters and lengths of screw products. This series is especially efficient for mass production.
3. The compact mechanical construction design with counter balance weight cast on the two flywheels bring a better dynamic balance.
4. The big diameter and wide surface of crank shaft will assure you of almost zero defect in lubrication for longer life of operation.
5. A logical and sound machine design will offer to you headers of noise level under 90 dB.
6. A positive knock-out provision has been made on the first and second punches to eliminate the possibility of parts sticking onto these punches during the operation.
7. An in-process automatic checking device can be incorporated in these headers. With this advantage one operator could run 10 machines or more.

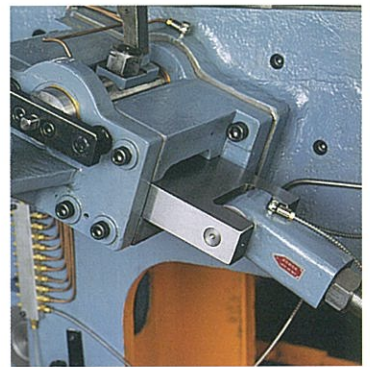


Less noise in knock-out mechanism:

An adjustable plate that is attached to the knock-out arm will always follow the knock-out cam, so that the knock-out will start slowly before accelerating. Push out rod beyond the die is held to a guided slide so that the knock-out motion from the lever will be actuated in line with the rod.



Safety pins are settled at knock-out and cut-off mechanisms so to prevent any damage to the major parts.

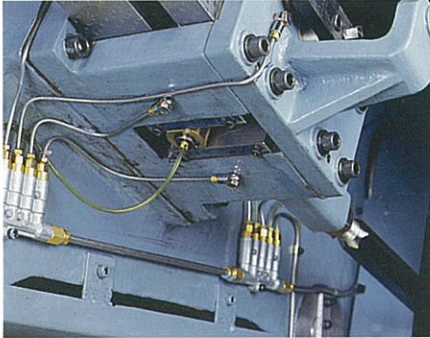




ISO 9001

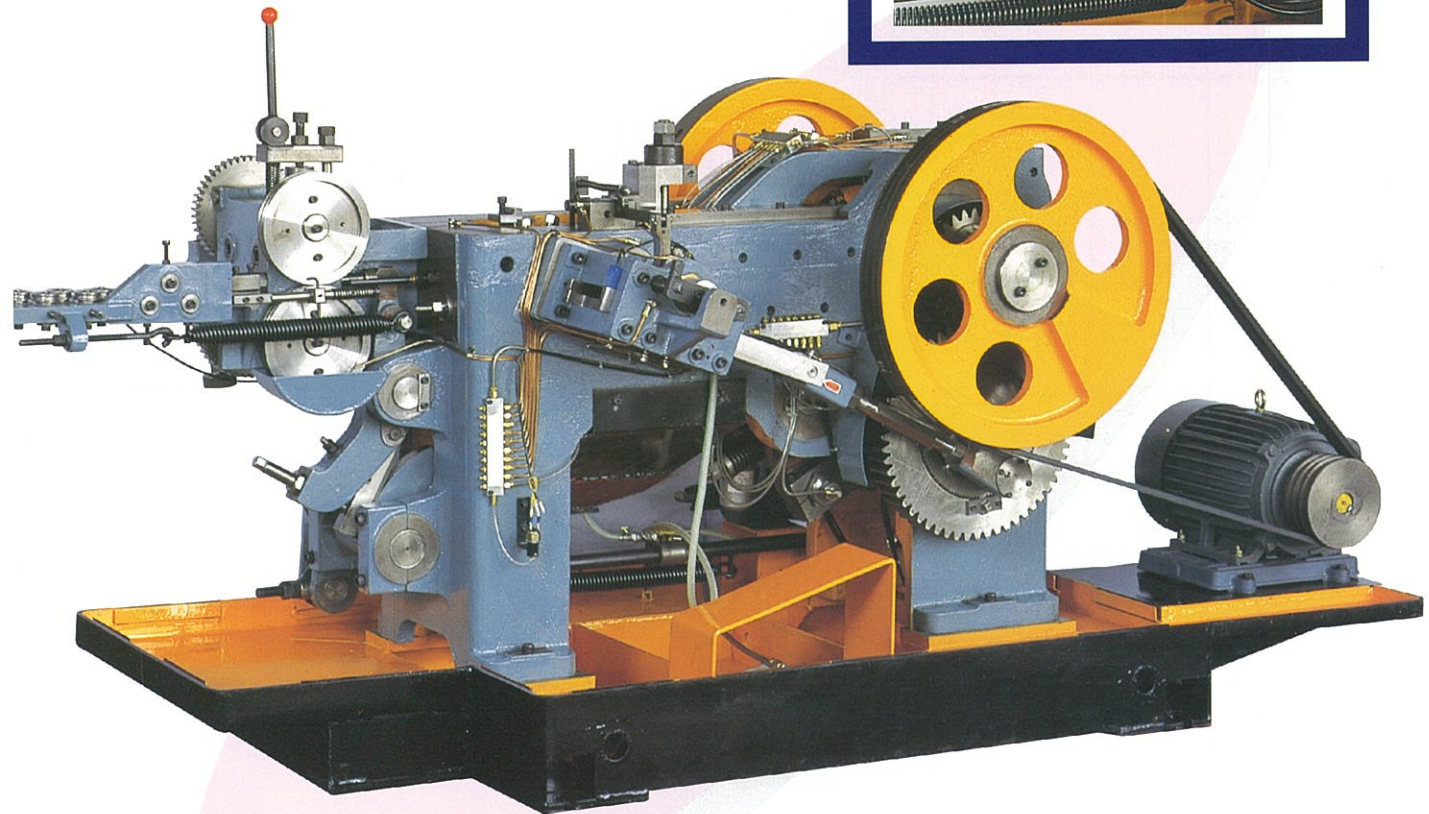
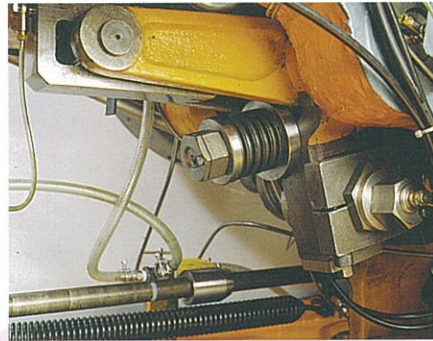
▼ **Rigid cut-off mechanism:**

The cut-off roller is supported on both sides to gain maximum rigidity and stable cut-off.
(R.O.C. Patent : New design No.23060.)
(U.S.A. Patent pending.)



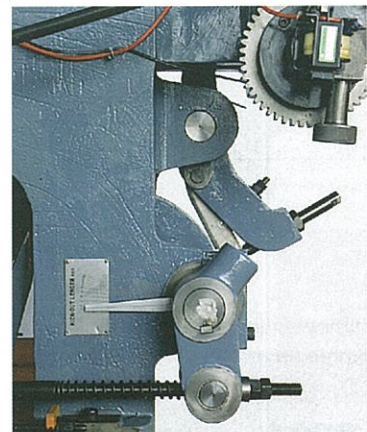
Such useful up and down mechanism:

The simple rational design of the shock absorbing device for punch slide up and down motion not only provide quick adjustment but simple maintenance.



Convenient adjustment of knock-out mechanism:

The adjustmebt of the knock-out lever length is easily accessible by referring to the attached indicating needle and scale.



SPECIFICATION OF HEADING MACHINE



M/C TYPE Description		CH-3	CH-5S	CH-5L	CH-6S	CH-6L	CH-6LL	CH-10S	CH-10L	CH-10LL	CH-12	CH-12LL	CH-20S	CH-20L	CH-30L
CUT-OFF DIA.	mm	0.8~3	2~5	2~5	3~6.35	3~6.35	3~6.35	6~10	6~10	6~10	8~12.7	8~12.7	9.5~20	9.5~20	12~32
MAX.CUT-OFF LENGTH	mm	34	45	69	63	89	128	93	145	170	135	252	195	300	417
SHANK LENGTH OF BLANK	mm	3~22	6~25.4	6~50.8	8~38	8~64	25~102	15~51	15~102	38~153	38~100	40~203	30~150	60~254	75~305
MAIN DIE DIA	mm	φ25*34L	I φ34.5*45L O φ30*45L	I φ34.5*65L O φ30*65L	φ38*55L	φ38*75L	φ38*110L	φ65*120L	φ65*120L	φ65*168L	φ78*110L	φ88*223L	φ148*210L	φ148*285L	φ245*400L
CUT-OFF DIE DIA.	mm	φ15*20L	I φ19*30L O φ20*30L	I φ19*30L O φ20*30L	φ25*35L	φ25*35L	φ25*35L	φ32*35L	φ32*35L	φ32*35L	φ32*35L	φ35*40L	φ38*45L	φ54*65L	φ97*125L
DISTANCE OF MAIN DIE & CUT-OFF DIE	mm	24	30	30	36	36	40	55	55	55	62	72	117	117	205
#1 PUNCH DIE.	mm	φ22*45L	I φ31*62.5L O φ27*60.5L	I φ31*62.5L O φ27*60.5L	φ35*77L	φ35*77L	φ35*77L	φ40*98L	φ40*98L	φ40*98L	φ48*117L	φ58*120L	φ73*170L	φ73*170L	φ97*265L
#2 PUNCH DIE.	mm	φ18*38L	φ25*52L	φ25*52L	φ35*67.5L	φ35*67.5L	φ35*67.5L	φ40*113L	φ40*113L	φ40*113L	φ48*95L	φ58*116L	φ73*170L	φ73*170L	φ107*253L
DISTANCE OF #1 & #2 PUNCH	mm	24	30	30	41	41	41	46	46	46	52	66	85	85	127
MAIN SLIDER STROKE	mm	44	60	84	80	106	146	120	172	220	150	290	210	330	450
P.K.O. STROKE	mm	4	6.5	10	8	10	12	10	13	17	13	20			
K.O. STROKE	mm	22	26	51	38	64	102	51	102	153	100	203	150	254	305
MAIN MOTOR	HP	3	7.5	5	7.5	7.5	7.5	15	15	15	15	20	40	40	75
MAX. OUT-PUT	PCS/MIN	300	250	200	200	160	110	120	100	70	75	50	45	35	28
MACHINE WT.	Kg	650	1,300	1,400	2,300	2,500	3,000	5,800	6,000	6,500	6,100	12,000	21,000	21,000	70,000
FORGING LOAD	TONS	10	20	20	25	25	25	40	40	40	50	70	250	250	400

Remarks:

- 1 · The material of cut-off and forming shown above are for low/medium carbon steel and high tensile alloy steel(grade 10.8)
- 2 · The max speed of out-put for stainless steel and special trial should be discussed.
- 3 · Modifications subjected to change without any notice.

Our Allied Products:

- Bolt Formers
- Parts Former
- 2 die - 2 Blow Heading Machine
- Heading Machine
- Open Die Header
- Thread Rolling Machine
- Nut Formers
- Slotting Machine
- Forming Tools
- Thread Rolling Die
- Trimming Die



ISO 9001

CHUN ZU MACHINERY INDUSTRY CO., LTD.

HEAD OFFICE & FACTORY :

50. TA PAO ST. KANGSHAN, TAIWAN, R.O.C.

TEL : 886-7-6212196~8. 6214106~10

FAX : 886-7-6221718. 6217417

http : WWW.CHUNZU.COM

e-mail : chunzu@ms9.hinet.net