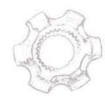


Gear broaching



伺服上拉式立式内拉床

Servo up-broaching type vertical internal broaching machine LG57AS Series

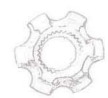
LG57AS 系列



- 伺服驱动
· Servo drive
- 上拉式作业，地面式安装
· Pull-up operation, ground installation
- 系列产品多种多样，适宜自动化连线
· Series products are various and suitable for automatic connection



项目 ITEM	单位 UNIT	LG5710AS-1200	LG5720AS-1600	LG5730AS-2000
额定拉削力 Rated broaching force	kN	100	200	300
最大行程 Max.stroke	mm	1,200	1,600	2,000
拉削速度 Broaching speed	m/min	1 ~ 7.5	1 ~ 6	1 ~ 6
返程速度 Return speed	m/min	1 ~ 10	1 ~ 8	1 ~ 12
适用拉刀长度 Applicable broach length	mm	750 ~ 1,300	1,100 ~ 1,700	1,300 ~ 2,100
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ160 三工位Φ120	单工位Φ180 三工位Φ150	单工位Φ200 三工位Φ150
机床总功率 Total power	kW	19	28	45
机床外形 Machine tool shape	m	3.5×4.2×4.2	3.8×4.0×5.5	3.8×4.0×6.1
机床净重 Net weight	t	9	12	14



液压上拉式立式内拉床

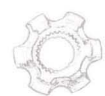
Hydraulic pull-up type vertical internal broaching machine LG57RS Series

LG57RS 系列



- 液压驱动
· Hydraulic drive
- 上拉式作业，地面安装
· Pull-up operation, ground installation

项目 ITEM	单位 UNIT	LG5710RS-1200	LG5720RS-1600	LG5730RS-1600
额定拉削力 Rated broaching force	kN	100	200	300
最大行程 Max.stroke	mm	1,200	1,600	1,600
拉削速度 Broaching speed	m/min	1 ~ 7	1 ~ 7	1 ~ 7
返程速度 Return speed	m/min	1 ~ 14	1 ~ 14	1 ~ 14
适用拉刀长度 Applicable broach length	mm	800 ~ 1,300	1,100 ~ 1,700	1,100 ~ 1,700
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ160 三工位Φ120	单工位Φ180 三工位Φ150	单工位Φ200 三工位Φ150
机床总功率 Total power	kW	22	33	36
机床外形 Machine tool shape	m	4x5.5x4	4x4.8x4.9	4x5.6x5.1
机床净重 Net weight	t	9	12	14



双缸双立柱上拉式立式内拉床

Double-cylinder double-column pull-up type vertical internal broaching machine LG557FA Series

LG557FA 系列



- 单床身结构
· Single bed structure
- 双油缸驱动，满足大切削力需求
· Double cylinder drive, meet the demand of large cutting force
- 机械臂实现独立换刀，操作便捷
· The mechanical arm realizes independent tool change, which is convenient to operate.



双缸双床身上拉式立式内拉床

Double-cylinder double-bed pull-up type vertical internal broaching machine LG557MH Series

LG557MH 系列

- 双床身结构，双油缸驱动
· Double bed structure, driven by double cylinders
- 适合加工精度高的各种较大内花键、内齿轮以及各种形状的内孔
· Suitable for machining various large internal splines, internal gears and internal holes of various shapes with high precision



项目 ITEM	单位 UNIT	LG55740FA-2000	LG55760FA-2000
额定拉削力 Rated broaching force	kN	400	600
最大行程 Max.stroke	mm	2,000	2,000
拉削速度 Broaching speed	m/min	1 ~ 7	1 ~ 6
返程速度 Return speed	m/min	2 ~ 15	2 ~ 12
适用拉刀长度 Applicable broach length	mm	1,100~ 2,100	1,100 ~ 2,100
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ240 三工位Φ160	单工位Φ240 三工位Φ160
机床总功率 Total power	kW	70	79
机床外形 Machine tool shape	m	4.6x5.8x7.1	4.6x5.8x7.2
机床净重 Net weight	t	28	31

项目 ITEM	单位 UNIT	LG55740MH-2000	LG55760MH-2000
额定拉削力 Rated broaching force	kN	400	600
最大行程 Max.stroke	mm	2000	2000
拉削速度 Broaching speed	m/min	1~7	1~6
返程速度 Return speed	m/min	2~15	2~12
适用拉刀长度 Applicable broach length	mm	1300 ~ 2100	1300 ~ 2100
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ240	单工位Φ280
机床总功率 Total power	kW	68	76
机床外形 Machine tool shape	m	5.5x6.5x6	5.5x7x6
机床净重 Net weight	t	24	27

Gear broaching

CHR 畅尔



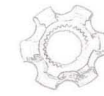
液压下拉式立式内拉床

Hydraulic pull-down type vertical internal broaching machine

LG51SH 系列

LG51SH Series

- 地坑安装或站架操作
Pit installation or stand operation
- 适用工件范围广，加工精度高，生产节拍快
Wide range of applicable workpieces, high machining accuracy and fast production tempo
- 拉刀全程护送，防止拉刀摆动，提高拉削精度
Broach is escorted in the whole process to prevent broach from swinging and improve broaching accuracy



液压双缸下拉式立式内拉床

Hydraulic double-cylinder pull-down type vertical internal broaching machine LG55KH Series

LG55KH 系列

- 液压双缸驱动，满足特大吨位工件加工
Hydraulic double-cylinder drive, meeting the processing of extra-large tonnage workpieces
- 拉刀全程护送，防止拉刀摆动，提高拉削精度
Broach is escorted in the whole process to prevent broach from swinging and improve broaching accuracy
- 受力与拉削中心同面，拉削稳定
The stress is in the same plane as the broaching center, and broaching is stable



项目 ITEM	单位 UNIT	LG5120SH-1600	LG5130SH-1600	LG5140SH-2000
额定拉削力 Rated broaching force	kN	200	300	400
最大行程 Max.stroke	mm	1,600	1,600	2,000
拉削速度(分档调速) Broaching speed(Step speed regulation)	m/min	2.5 ~ 4.5 ~ 7	3 ~ 5 ~ 8	2~4~6
返程速度 Return speed	m/min	10	20	12
适用拉刀长度 Applicable broach length	mm	1100 ~ 1700	1100 ~ 1700	1200 ~ 2100
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ350	单工位Φ350	单工位Φ350
机床总功率 Total power	kW	27	32	50
机床外形 Machine tool shape	m	3.5x5.2x5.8	4.0x5.8x6.7	4.0x6.0x8.0
机床净重 Net weight	t	15	18	20

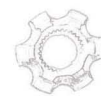
项目 ITEM	单位 UNIT	LG5560KH-2000	LG55100KH-2000
额定拉削力 Rated broaching force	kN	600	1,000
最大行程 Max.stroke	mm	2000	2,000
拉削速度 Broaching speed	m/min	1~5	1~5
返程速度 Return speed	m/min	10	10
适用拉刀长度 Applicable broach length	mm	1200 ~ 2000	1200 ~ 2000
最大工件外径 Max. workpiece outer diameter	mm	单工位Φ400 三工位Φ180	单工位Φ400
机床总功率 Total power	kW	85	91
机床外形 Machine tool shape	m	4.4x6.6x8.5	4.4x6.6x8.5
机床净重 Net weight	t	32	34



精锻齿轮拉削加工

Precision forging gear broaching

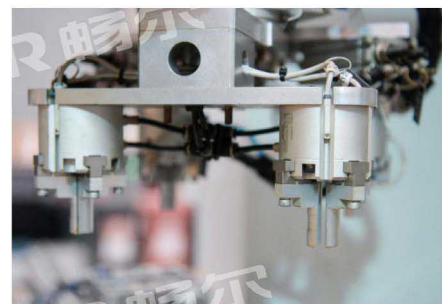
- 工件移动式内拉床
· Workpiece movable internal broaching machine
- 机械手自动上下料
· Automatic loading and unloading of manipulator



转向节叉拉削加工

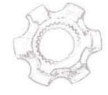
Steering knuckle fork broaching

- 工件移动式内拉床
· Workpiece movable internal broaching machine
- 伺服驱动, 自动化上下料机构
· Servo-driven, automated loading and unloading mechanism



Automation Application Examples

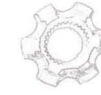
CHR 畅尔 自动化应用案例



轮毂单元自动化拉削

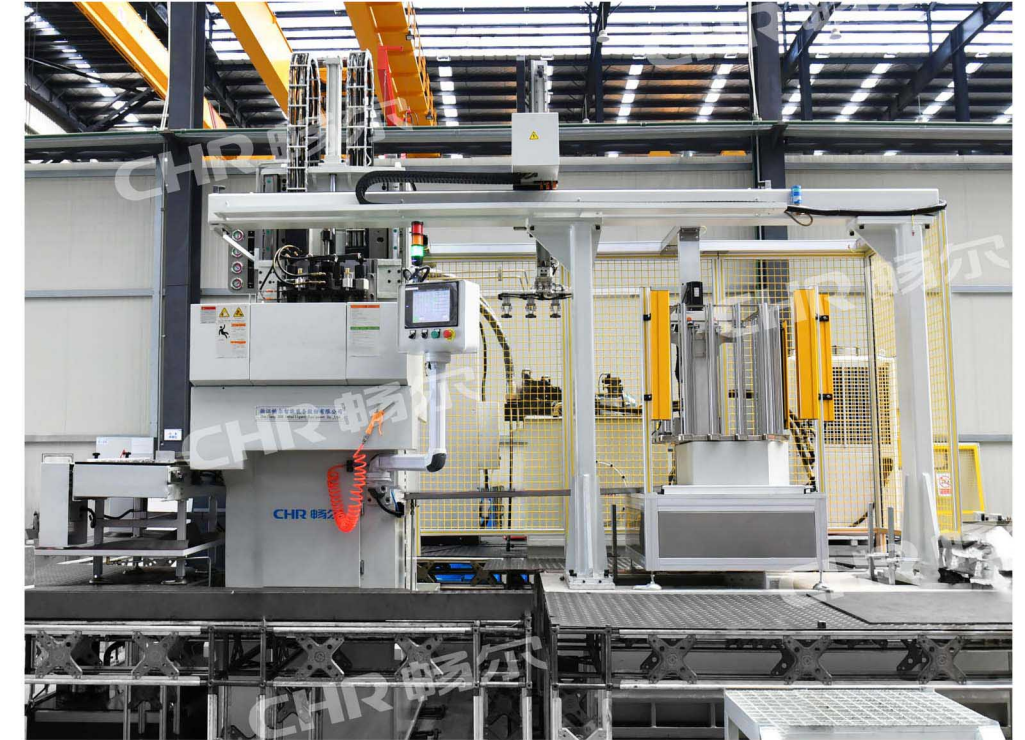
Automatic broaching of wheel hub unit

- 伺服驱动，拉削平稳
· Servo drive for smooth broaching
- 加工范围广，精度高，节拍快
· Wide processing range, high precision, fast tempo
- 装配后成套拉削
· Assembled set broaching



三销架、行星轮自动化拉削

Automatic broaching of three pin holders and planetary wheels



- 四工位自动化加工
· Four-station automated processing
- 适用于多工位小零件的拉削加工
· Suitable for multi-station broaching of small parts

