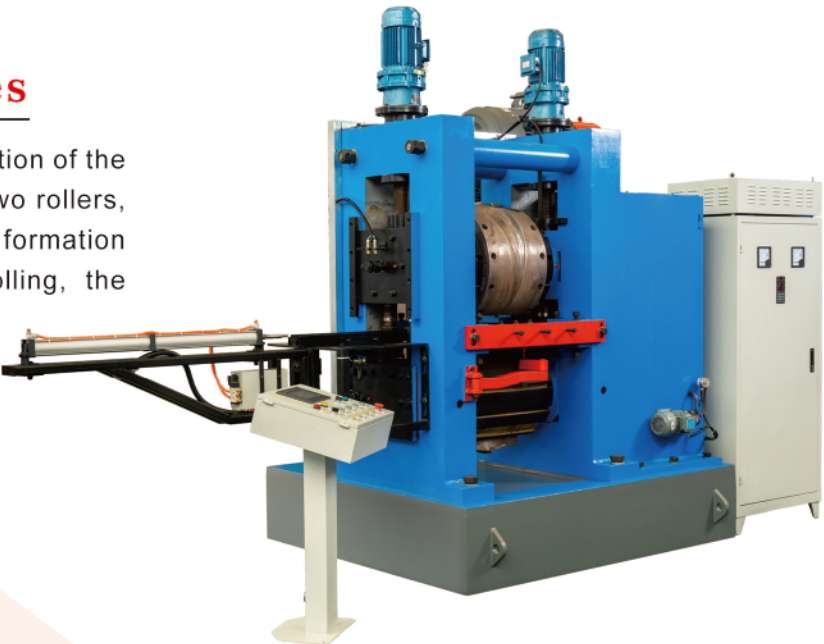


INTEGRATED CROSS WEDGE ROLLING MACHINE D46 SERIES

The integrated cross wedge rolling machine D46 series are widely used in manufacturing forgings or steel parts in automobile, machinery and other fields. The outside diameter of the roller is 320-1650mm. The maximum diameter of the billet is 35-180mm while the length of rolled part is 260-1200mm.

Mechanical Principles

Cross wedge rolling refers to the rotation of the blanks in the same direction between two rollers, deformation between the dies, and the formation of parts or preformed parts. After rolling, the metal billet gradually transforms into a tapered billet which can be further processed into various types of components using forging or cutting techniques.



Product Structure

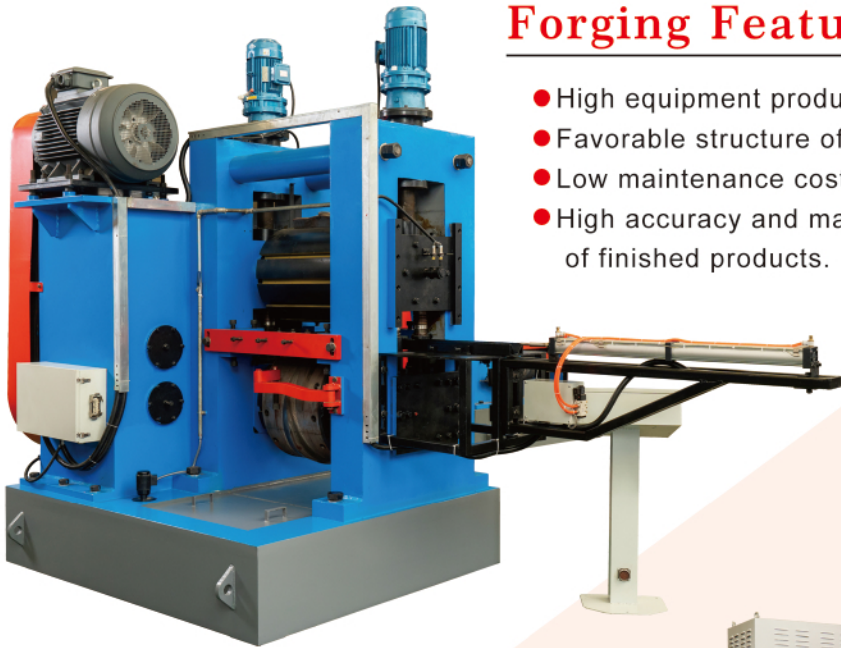
COMMODITY	DESCRIPTION	QUANTITY(SET)	Notes
Cross Wedge Rolling Machine	Main Machine	1	Non-common parts. Please contact us to get specific model for details.
	Electrical Cabinet	1	
	Operating Table	1	
	Feeder	1	

Technical Specification

	Unit	Model								
		D46-300	D46-400	D46-500	D46-630	D46-800	D46-1000	D46-1200	D46-1400	D46-1600
Outside Diameter of Die	mm	320	400	500	630	800	1000	1200	1440	1650
Diameter of Billet max.	mm	35	45	55	65	85	110	130	150	180
Length of Rolled Part	mm	260	300	400	500	600	800	950	1100	1200
Diameter of Roller	mm	240	320	400	500	640	800	1000	1200	1350
Rpm of Roller	r/min	28	25	22	12	8.5	6	4.5	3.5	2.5
Burrs(Height*Width)	mm	≤ 3 x 12	≤ 3 x 12	≤ 4 x 15	≤ 4 x 15	≤ 4 x 18	≤ 5 x 20	≤ 6 x 25	≤ 10 x 35	≤ 10 x 40
Power of Main Motor	kW	15	22	30	37	55	110	132	185	250
Primary Section Shrinkage of Rolled Piece	%	< 75	< 75	< 75	< 75	< 75	< 75	< 75	< 75	< 75
Width of Die max.	mm	≤ 400	≤ 500	≤ 500	≤ 600	≤ 900	≤ 1000	≤1200	≤1400	≤1600
Adjustment of Gap between Center of Rollers	mm	±15	±15	±25	±30	±35	±50	±55	±75	±80
Axial Adjustment of Roller	mm	±8	±10	±10	±10	±10	±10	±10	±10	±10
Adjustment of Roll Phase	°	±3	±3	±3	±3	±3	±3	±3	±3	±3
Up and Down Adjustment of Guide Plate	mm	±15	±15	±20	±20	±25	±35	±35	±35	±40
Back and Forth Adjustment of Guide Plate	mm	±15	±20	±20	±25	±30	±35	±35	±40	±40
Normal Rolling Temperature	℃	1050-1150	1050-1150	1050-1150	1050-1150	1050-1150	1050-1150	1050-1150	1050-1150	1050-1150
Coaxiality	mm	≤ 0.5	≤ 0.5	≤ 0.5	≤ 0.6	≤ 0.8	≤ 1	≤1.2	≤ 1.5	≤1.5

Forging Features

- High equipment production capacity (up to 1000 parts/hour).
- Favorable structure of material fibers.
- Low maintenance costs.
- High accuracy and maximum proximity to required dimensions of finished products.



Application

- Automotive manufacturing
- Construction industry
- Hardware tools manufacturing
- Power fittings manufacturing
- Agriculture industry
- Other-industries customized service available

