

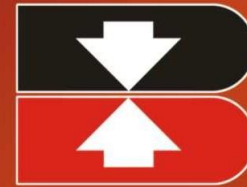
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BAIXIE  
FORGING HAMMER

BAIXIE  
FORGING HAMMER

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BAIXIE  
FORGING HAMMER

**BAIXIE**

百协锻锤

BAIXIE  
FORGING HAMMER

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# 百炼成钢 协力奋进

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始终以客户为导向  
始终以强劲产品研发及持续的技术创新  
不断开拓锻造科技新领域  
在千锤百炼中精益求精

深入细节 成就卓越

Insisting on customer-orientation  
Powerful production R & D and continuous technical innovation  
Exploiting the new forging technical field continuously  
Keeping on improving  
Paying attention to details and pursuing excellence



## 关于百协

ABOUT BAIXIE

中国程控锻锤制造基地——海安县百协锻锤有限公司，坐落在中国最具活力的长三角北翼江苏海安经济开发区，是中国唯一专业生产程控模锻锤的厂家，是一家集科研、生产、销售为一体的江苏省高新技术企业，南通市产学研示范企业。公司汇聚多年从事锻锤研究、产品开发高级工程师、硕士研究生及有志于发展我国锻造工业的工程技术人员，并与国内著名的锻压加工研究机构、高等院校建立了广泛的合作关系，在金属成形设备及工艺方面积累了丰富的知识和经验，并取得丰硕的成果。

百协公司核心产品、国家级重点新产品——程控全液压模锻锤，充分发挥传统锻锤灵活自如、成形速度快的优势，综合运用了电子、液压等现代控制、传动技术，是具有高效、节能、环保、高精度、高可靠特点的新型数控锻造设备。该产品为国内首创，达到国际同类产品先进水平。

百协程控锻锤已成功应用于汽车、摩托车、工程机械、液压管件、五金工具、手术器械、不锈钢餐具及航空航天工业，是高精度异型零件如连杆、曲轴、摇臂、转向节、拨叉、连接板、不锈钢刀叉、手术器械理想的现代化锻造成形设备，是自动化精密锻造生产线的核心设备。

百协公司可为用户提供现代化的锻造设备和自动化锻造生产线。

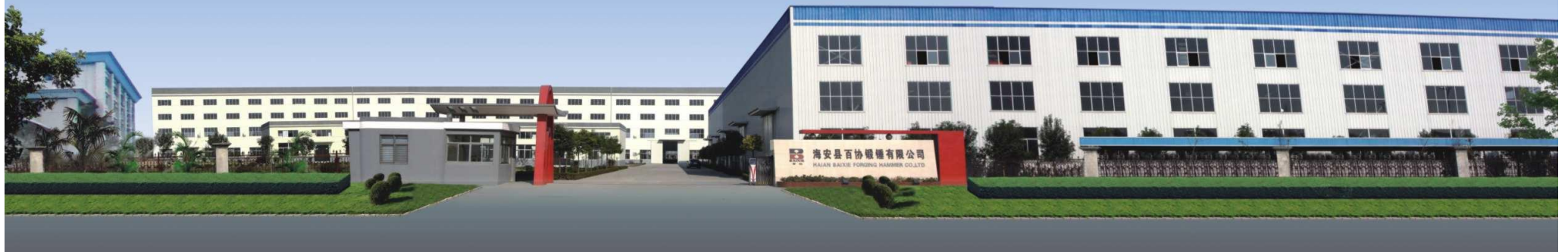
## 百协锻锤 BAIXIE

PLC forging hammer manufacturer base in China, Haian Baixie Forging Hammer Co., Ltd., located in Jiangsu Haian Economy & Development Zone in the north of Yangtze River Delta is the only professional manufacturer of PLC die forging hammer in China, Jiangsu High & New Technology Enterprise with research, development, manufacture and sale and Nantong Industry-academy-research Demonstrative Company. We collect senior engineers, post graduates and professional engineers to work together with China famous metalforming institutes and universities and have obtained much achievement.

Our core product, National Key & New Product, PLC fully-hydraulic die forging hammer takes the advantages of flexibility and fast forming of traditional forging hammer and is equipped with modern electronic and hydraulic control and transfer technology to become the modern advanced CNC forging equipment with the feature of high efficiency, energy saving, environmental protection and high accuracy. This forging hammer is the pioneer in China with the same advanced technology in the world.

Baixie's PLC forging hammers have been widely applied in automobile, motorcycle, hydraulic tube, hardware, surgical instruments, stainless steel tableware and spaceflight industry. They are the ideal equipment to produce complicated parts, such as connecting rods, crankshaft, rockers, knuckle, fork, stainless steel knives and forks and surgical instruments, the key equipment of precise forging line.

Baixie can supply modern forging equipment and automatic forging line to the user.





## 百协文化

CULTUER OF BAIXIE

**企业宗旨：** 赶超世界先进技术，开拓锻造工业未来

**企业精神：** 百炼成钢，协力奋进，锻造精品，锤炼人生

**发展目标：** 依靠科技，不断创新，谋求发展，争创一流

**企业理念：** 创“百协”品牌，做行业龙头

**质量方针：** 顾客为本，诚信服务；持续创新，追求卓越

**服务方针：** 服务第一、产品第一

**COMPANY PURPOSE:**

Overtaking worldwide advanced technology to exploit forging future

**COMPANY SPIRIT:**

Work in collaboration, apply in speciality, update in reality, and improve in time

**COMPANY TARGET:**

Rely on technology, continue to innovate and develop, try to become the leader

**COMPANY PHILOSOPHY:**

Create the brand of “Baixie” and stride forward in the front of forging industry

**QUALITY POLICY:**

Customer oriented, sincere service, continuous innovation, pursuit excellence

**COMPANY SERVICE:**

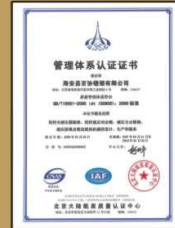
High quality and excellent service





# 百协荣誉

## GLORY OF BAIXIE



辉煌历程 印证实力  
Splendid Course of Development, demonstrate Company Strength





## 持续创新 追求卓越

CONTINUOUS INNOVATION  
& EXCELLENCE PURSUIT

**2008** 年完成我国第一台125kJ蒸汽锻锤数控化改造

In 2008, the first set 125kJ steam forging hammer CNC innovation was developed in China.

**2006** 研制出我国第一台100kJ机身微动程控液压对击锤

In 2006, the first set 100kJ PLC hydraulic counterblow hammer with micro-motion of the machine body was developed in China.

**2004** 年完成我国第一台80kJ蒸汽模锻锤数控化改造

In 2004, the first set 80kJ steam die forging hammer CNC innovation was developed in China.

**2002** 研制出我国第一台具有国际同类产品先进水平的程控全液压模锻锤

In 2002, the first set PLC fully-hydraulic die forging hammer with the international advanced level of similar products was developed in China.

**1988** 研制出我国第一台消振液压模锻锤

In 1988, the first set vibration-free hydraulic die forging hammer was developed.

**1974** 研制出我国第一台63kJ机身微动液压对击锤

In 1974, the first set 63kJ hydraulic counterblow hammer with micro-motion of the machine body was developed in China.



## 百协品牌 领航锻造



BAIXIE BRAND, THE  
PIONEER IN FORGING



汽车摇臂模锻生产线  
automobile rocker die forging line



工具自动化生产线  
tool automatic forging line



五金锻造生产线  
hardware forging line

中国**最专业**的程控锻锤制造商  
中国**最早**的程控锻锤制造商  
中国**门类最齐全**的程控锻锤制造商  
中国**最大**的程控锻锤制造商  
中国**唯一**出口程控锻锤制造商  
国内市场**占有量最大**的程控锻锤制造商

the most professional manufacturer of PLC forging hammers in China;  
the earliest manufacturer of PLC forging hammers in China;  
the most complete manufacturer of PLC forging hammers in China;  
the greatest manufacturer of PLC forging hammers in China;  
the only exporter & manufacturer of PLC forging hammers in China;  
the largest market occupation of PLC forging hammers in China.



CTK-80程控锻锤生产线  
CTK-80 PLC forging hammer producing line



程控对击锤生产线  
PLC counterblow forging hammer producing line



五条出口模锻件生产线  
five die forging lines for exported forgings



连杆锻造生产线  
connecting rods forging lines



法兰锻造生产线 (125KJ)  
flange forging line (125KJ)



顾客为本 诚信服务

CUSTOMER ORIENTED &  
SINCERE SERVICE





精雕细琢 完美品质

EXQUISITE WORKMANSHIP  
& PERFECT QUALITY





# 现代科技 彰显魅力

## MODERN TECHNOLOGY & CHARM DISPLAY

### CHK 系列程控全液压模锻锤

Series CHK PLC Fully-Hydraulic Die Forging Hammer



#### 技术特征

- 全液压动力驱动
- 可编程打击控制，数字化输入
- 整体U形铸钢砧座床身
- 放射形宽导轨结构
- 弹性细锤杆
- 人机界面，故障自动诊断，全中文显示
- 液压顶出装置、液压阻尼隔振器，可根据客户要求随机提供

#### 优点

- 高效、节能、安全、可靠
- 坚固、耐用、刚性好、精度高
- 打击能量、打击步序可任意设定
- 回程速度快、不闷模
- 操作简单、灵活

#### 适应性

- 多品种小批量生产
- 异形零件的精密锻造
- 多模膛锻造及闭式模锻造
- 粉末锻造、合金钢及有色金属锻造

#### Technical Feature

- Fully hydraulic driving
- Programmable striking control and digital inputting
- U-shape integrated cast steel hammer frame
- Actinoid wide guide rails construct
- Elastic thin hammer rod
- Man-machine interface and automatically displaying malfunction
- Hydraulic knockout system and shock absorbers supplied according to the customer's requirement

#### Advantage

- High efficiency, energy saving, reliability and safety
- Firmness, durability, good rigidity and high accuracy
- Striking energy and striking sequence set optionally
- Return quickly without closing the die
- Easy and flexible operation

#### Application

- The small batch products
- Precision forge of complex components
- Forge with several mold cavities and closed die forging
- Powder forging, alloy steel forging and non-ferrous metal forging

#### 技术参数 Tech. Parameter

规格 Spec.	CHK	16	25	31.5	50	63	80	100	125
打击能量 Striking energy	kJ	16	25	31.5	50	63	80	100	125
锤头质量 Ram weight	kg	1100	1700	2300	3000	4200	5400	6800	8500
打击频率 Striking frequency	min <sup>-1</sup>	90	90	80	80	75	70	70	70
电机功率 Motor power	kW	30	55	55	2 × 55	2 × 55	2 × 90	2 × 90	2 × 110
机器质量 Machine weight	t	24	38	50	78	98	116	150	180



# 现代科技 彰显魅力

## MODERN TECHNOLOGY & CHARM DISPLAY

### CTK 系列程控全液压模锻锤（换头）

Series CTK Fully-hydraulic Die Forging Hammer (hammer ram changed)



#### 基本结构

- 全液压动力系统高度集成，无需泵房、地面液压站
- 可编程打击控制，数字化输入
- 长锤头结构，可提高工作精度
- 打击能量、打击步序可任意设定，无富余能量的打击，可降低打击噪音、提高模具寿命
- 人机界面，故障自动诊断，全中文显示

#### 性能特点

- 高效、节能
- 稳定的锻件质量
- 较低的运行费用
- 广泛的适用性
- 较低的投资成本
- 简单的维护与操作

#### Basic construct

- High integrated fully hydraulic driving system without pump chamber and hydraulic station on the ground
- Programmable striking control and digital inputting
- Long hammer tup enhancing working accuracy
- Striking energy and striking sequence set optionally without surplus striking energy avoiding noise and increasing the die life
- Man-machine interface, automatically diagnosing the malfunction

#### Performance and Feature

- High efficiency and energy saving
- Consistent quality of forging
- Lower run cost
- Wide application
- Lower investment cost
- Easy maintenance and operation

#### 技术参数 Tech. Parameter

规格 Spec.	CTK	25	50	75	125	250	400
打击能量 Striking energy	kJ	25	50	75	125	250	400
锤头质量 Ram weight	kg	2100	3000	5000	8500	12500	22500
打击行程 Striking stroke	mm	720	800	850	950	1050	1150
打击频率 Striking frequency	min <sup>-1</sup>	90	80	80	60	50	40
电机功率 Motor power	kW	55	2 × 55	2 × 90	4 × 55	4 × 90	4 × 110



现代科技 彰显魅力

MODERN TECHNOLOGY &  
CHARM DISPLAY

## 机身微动程控液压对击锤

PLC Hydraulic Counterblow Hammer with hammer  
body micro-motion



### 基本配置

- 柱塞缸密封为进口件
- 配有自动润滑系统
- 配有油温、压力数字显示在线检测器（德国）
- 配有日本三菱公司电子控制系统
- 配有日本三菱公司中文人机界面
- 配有旁路循环冷却、过滤系统
- 所用主油泵为斜轴式柱塞泵
- 配有42个故障检测点（液压、电器），其中36个为自动检测点
- 铸钢机架

### 性能特点

- 锥阀式控制、高度集成的液压系统，基本无泄露，高效、节能
- 多项安全措施、周到的在线检测、简洁的系统设计，确保安全、可靠
- 具有一般、程控两种能量控制方式，可任意变换、设定，操作简单
- 所用液压件90%为标准易购件，原理结构简单，生产运行费用低
- 较低的投资成本

### Basic disposition

- Imported sealed parts used in the plunger case
- Automatic lubricating system
- On-line digital display detector of oil temperature and pressure (Germany)
- Electronic control system of Mitsubishi
- Man-machine conversation screen of Mitsubishi
- Bypass circular cooling and filter system
- Main oil pumps: angle-type plunger pumps
- 42 malfunction check points (hydraulic, electronic) with 36 automatic check points.
- Casting steel hammer framework

### Performance and Feature

- High integrated hydraulic system with tapered valve control, no leakage, high efficiency and energy saving
- Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability
- Normal PLC energy control ways can be adjusted and set optionally and easily
- 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost
- Lower investing cost

### 技术参数 Tech. Parameter

规格 Spec.	CDK	40	63	100
打击能量 Striking energy	kJ	40	63	100
锤头质量 Ram weight	kg	2200	3100	4500
打击行程 Striking stroke	mm	500	600	640
打击频率 Striking frequency	min <sup>-1</sup>	60	60	60
电机功率 Motor power	kW	75	2 × 55	2 × 75

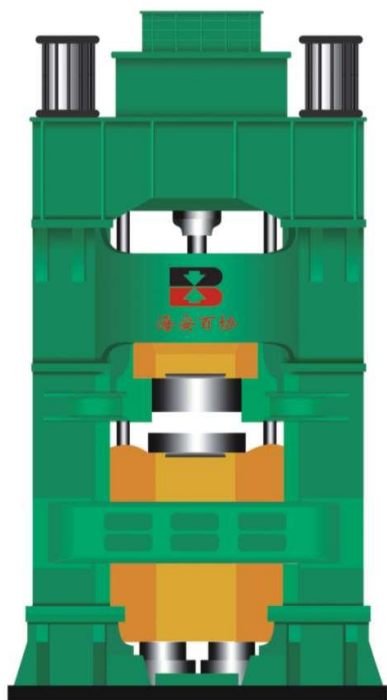


## 现代科技 彰显魅力

### MODERN TECHNOLOGY & CHARM DISPLAY

## 程控液压对击锤

### PLC Hydraulic Counterblow Hammer



#### 基本配置

- 锤杆、活塞所用密封件均为进口件
- 配有自动润滑系统
- 配有油温、压力数字显示在线检测器（德国）
- 配有日本三菱公司电子控制系统
- 配有日本三菱公司中文人机界面
- 配有旁路循环冷却、过滤系统
- 所用主油泵为斜轴式柱塞泵
- 配有42个故障检测点（液压、电器），其中36个为自动检测点
- 钢板焊接机架

#### 性能特点

- 双阀式控制、高度集成的液压力头，真正实现无管化连接，基本无泄露，高效、节能
- 多项安全措施、周到的在线检测、简洁的系统设计，确保安全、可靠
- 具有一般、程控两种能量控制方式，可任意变换、设定，操作简单
- 所用液压件90%为标准易购件，原理结构简单，生产运行费用低

#### Basic disposition

- Imported sealed parts used in the hammer rod and piston
- Automatic lubricating system
- On-line digital display detector of oil temperature and pressure (Germany)
- Electronic control system of Mitsubishi
- Man-machine conversation screen of Mitsubishi
- Bypass circular cooling and filter system
- Main oil pumps: angle-type plunger pumps
- 42 malfunction check points (hydraulic, electronic) with 36 automatic check points.
- Welding hammer framework

#### Performance and Feature

- High integrated hydraulic power unit with double valve control realize no pipes connecting to ensure no leakage, high efficiency and energy saving
- Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability
- Normal PLC energy control ways can be adjusted and set optionally and easily
- 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost

#### 技术参数 Tech. Parameter

规格 Spec.	CDKA	160	250	320	400
打击能量 Striking energy	kJ	160	250	320	400
上锤头质量 Ram weight(up)	kg	8400	13000	16000	22000
下锤头质量 Ram weight(down)	kg	42000	62000	76000	92000
打击行程 Striking stroke	mm	535	550	565	580
下锤头打击行程 Striking stroke(down ram)	mm	135	145	145	150
打击频率 Striking frequency	min <sup>-1</sup>	50	45	40	40
主电机功率 Main motor power	kW	220	360	400	440

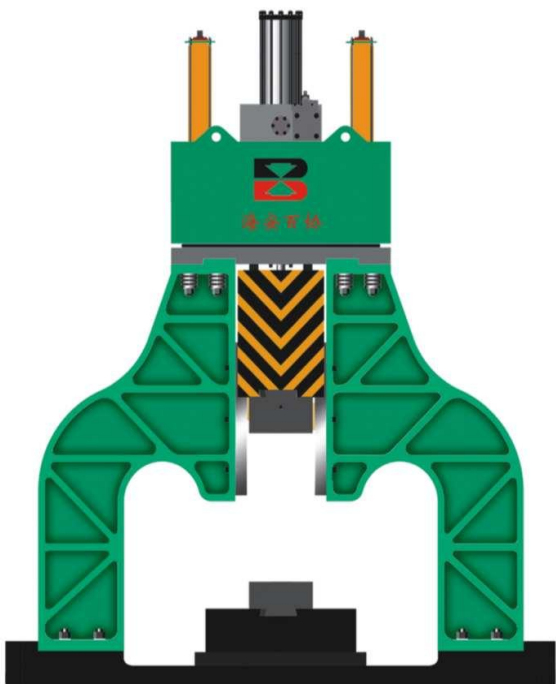


现代科技 彰显魅力

MODERN TECHNOLOGY &  
CHARM DISPLAY

## CTY 系列液压自由锻锤

Series CTY Hydraulic Free Forging Hammer



### 基本配置

- 锤杆、活塞所用密封件均为进口件
- 配有自动润滑系统
- 配有油温、压力数字显示在线检测器（德国）
- 配有日本三菱公司电子控制系统
- 配有日本三菱公司中文人机界面
- 配有旁路循环冷却、过滤系统
- 所用主油泵为斜轴式柱塞泵
- 配有42个故障检测点（液压、电器），其中36个为自动检测点
- 铸钢机架，铸钢砧座

### 性能特点

- 锥阀式控制、高度集成的液压动力头，真正实现无管化连接，基本无泄漏，高效、节能
- 多项安全措施、周到的在线检测、简洁的系统设计，确保安全、可靠
- 具有手动、程控两种能量控制方式，可任意变换、设定，操作简单
- 所用液压件90%为标准易购件，原理结构简单，生产运行费用低

### Basic disposition

- Imported sealed parts used in the hammer rod and piston
- Automatic lubricating system
- On-line digital display detector of oil temperature and pressure (Germany)
- Electronic control system of Mitsubishi
- Man-machine conversation screen of Mitsubishi
- Bypass circular cooling and filter system
- Main oil pumps: angle-type plunger pumps
- 42 malfunction check points (hydraulic, electronic) with 36 automatic check points.
- Casting steel hammer framework and anvil insert

### Performance and Feature

- High integrated hydraulic power unit with tapered valve control realize no pipes connecting to ensure no leakage, high efficiency and energy saving
- Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability
- Manual and PLC energy control ways can be adjusted and set optionally and easily
- 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost

### 技术参数 Tech. Parameter

规格 Spec.	CTY	35	70	120	180
打击能量 Striking energy	kJ	35	70	120	180
锤头质量 Ram weight	kg	2100	3000	5400	7000
打击行程 Striking stroke	mm	940	1125	1350	1450
打击频率 Striking frequency	min <sup>-1</sup>	80	68	60	60
电机功率 Motor power	kW	2 × 30	3 × 45	3 × 75	4 × 75



## 竭诚服务 誉满天下

### WHOLEHEARTED SERVICE AND FAME THROUGHOUT THE WORLD

**2008年6月**，世界著名的工具制造商德国Wiha公司从百协购买两台CHK-25程控全液压模锻锤，并于7月份安装、投产使用。半年时间内海安百协出口的程控全液压模锻锤已达到4台。

**2008年5月**，百协公司的CHK-25程控全液压模锻锤出口至叙利亚Industrial Solution公司。

**至2008年4月**，以百协程控全液压模锻锤为核心设备的美利龙餐厨具（苏州）有限公司（美国独资企业）两条自动化精密锻造生产线，已经安全、正常运行三年以上，这两条自动化生产线由一人操作，包含加热、轧制、模锻及机器人等自动化设备，除百协锻锤外，其它均为进口设备。

**2008年3月**，常州精铸锻有限公司购买的百协CTK-125程控全液压模锻锤安装投产。

**2008年2月**，河北明达铸锻有限公司第三次订购百协CHK-31.5KJ程控全液压模锻锤。

**2008年2月**，百协程控全液压模锻锤落户俄罗斯Nobosibirsk Tools Plant，并投产使用，且得到俄方用户的非常满意评价。

**2008年元月**，马来西亚（昆山）正大新成锻造有限公司从百协购买CHK-25程控全液压模锻锤，用于汽车连杆的锻造成形。

**2007年9月**，瑞安南方锻件有限公司再次从百协订购2台CHK-31.5程控全液压模锻锤，该公司在此前已从百协公司购买过同型号的程控全液压模锻锤。

**2007年5月25、26日**百协锻锤有限公司成功召开CHK-50程控全液压模锻锤和CDK-100程控液压对击锤的科技成果鉴定会及技术交流会。中国锻压协会原秘书长蔡楠、华中理工大学何永标教授、上海交大王以华教授、原东风锻造有限公司总经理赵一平高工出席会议并给予高度评价。

**2007年3月**河北欧亚锻铸有限公司第五次订购百协CHK型程控全液压模锻锤。该公司曾分别于2003、2004、2005、2006年先后购买了四台百协CHK型程控全液压模锻锤。

**1. In June 2008**, Wiha company(Germany), a world-famous toolmaker, purchased two sets CHK-25 PLC Fully Hydraulic Die Forging Hammer, which will be installed and in use in July. Four sets Baixie's PLC Fully Hydraulic Die Forging Hammers have been exported in half one year.

**2. In May 2008**, Baixie's CHK-25 PLC Fully Hydraulic Die Forging Hammer was exported to Industrial Solution, a company in Syria.

**3. Until April 2008**, two automatic precision forging lines in Mei Li Long Houseware(Suzhou) Co.,Ltd.(invested solely by America) have been running safely and regularly for three years, whose core equipments are Baixie's PLC Fully Hydraulic Die Forging Hammers. These two lines are operated by one worker, and all the equipments are imported except Baixie's forging hammers.

**4. In March 2008**, Baixie's CHK-125 PLC Fully Hydraulic Die Forging Hammer bought by Changzhou Jingling Foundry&Forging Co.,Ltd. was installed and in use.

**5. In February 2008**, Hebei Mingda Casting&Forging Co.,Ltd. ordered Baixie's CHK-31.5 PLC Fully Hydraulic Die Forging Hammer for the third time.

**6. In February 2008**, Baixie's PLC Fully Hydraulic Die Forging Hammer installed in Nobosibirsk Tools Plant(a company in Russia) and was in use, which was appraised highly by Russian user.

**7. In January 2008**, CHK-25 PLC Fully Hydraulic Die Forging Hammer bought by Malaysia Chaitai-xincheng Precision Forging (Kunshan)Co.,Ltd. from Baixie was used to forge and form the connecting rods of automobile.

**8. In September 2007**, Ruian Nanfang Forging Co.,Ltd. ordered two CHK-31.5PLC Fully Hydraulic Die Forging Hammers once again in Baixie. This company has bought PLC Fully Hydraulic Die Forging Hammer of the same type before.

**9. On May 25 & 26 2007**, CHK-50 PLC Fully Hydraulic Die Forging Hammer and CDK-100 PLC Hydraulic Counterblow Hammer achievement appraising and technology exchanging meeting was held by Haian Baixie Forging Hammer Co.,Ltd. Caiyong, former general secretary of Confederation of Chinese Metalforming Industry, Heyongbiao, professor of Huazhong University of Science and Technology, Wangyihua, professor of Shanghai Jiao Tong University and Zhaoyiping, former senior engineer of Dongfeng Motor Forging Co.,Ltd. attended the meeting and highly appraised it.

**10. In March 2007**, Hebei Ouya Forging&Casting Co.,Ltd. ordered CHK PLC Fully Hydraulic Die Forging Hammer from Baixie for the fifth time. It has bought four sets successively from 2003 to 2006.

## 百协锻锤 锻造精品



### BAIXIE FORGING HAMMER & FORGE REFINE PRODUCT



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