

**HLYS** series

**盆体专用深拉伸液压机**  
Special deep drawing hydraulic press for basin



# HLYS<sup>series</sup> 盆体专用深拉伸液压机

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## 适用范围 Scope Of Application



本机为盆体专用深拉伸液压机，主要适用于家电，厨房用品，汽车零部件等金属薄板件的深拉伸，浅拉伸，冲压，翻边，整形等工艺，特别适用于不锈钢盆体的拉伸成型等工艺。

This machine is a special deep drawing hydraulic press for the bowls, which is mainly used for the deep drawing, shallow drawing, stamping, flanging, shaping and other processes of metal sheet parts such as home appliances, kitchen supplies, auto parts, especially for the drawing and forming process of stainless steel sinks.





## 本系列机器结构

Structure of machines

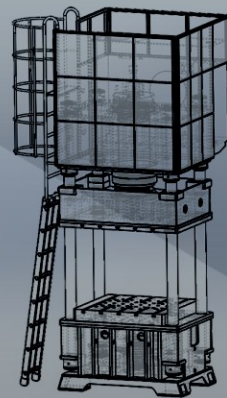


### HLYZS 为三梁四柱锁紧封闭式结构

HLYZS is a three-beam and multi-column locking enclosed structure

结构紧凑，性价比高。油箱位于机顶后方。滑块采用四柱导向，上下运动。机架采用钢板焊接，整个机架刚性坚固。配合自动化生产，迎合现代化的生产需求。

with compact structure and high cost performance. The oil tank is located behind the top of fuselage. Each slider is guided by four columns and moves up and down. The frame is welded by steel plate, the whole frame is rigid and strong. Cooperate with manipulators to realize fully automated production and meet modern production requirements.

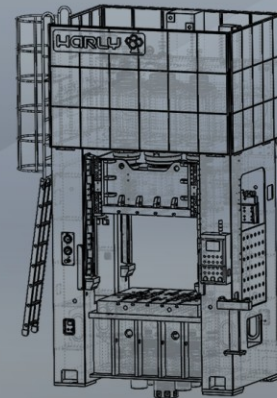


### HLYNS 为整体封闭框架式结构

HLYNS is an integral closed frame structure,

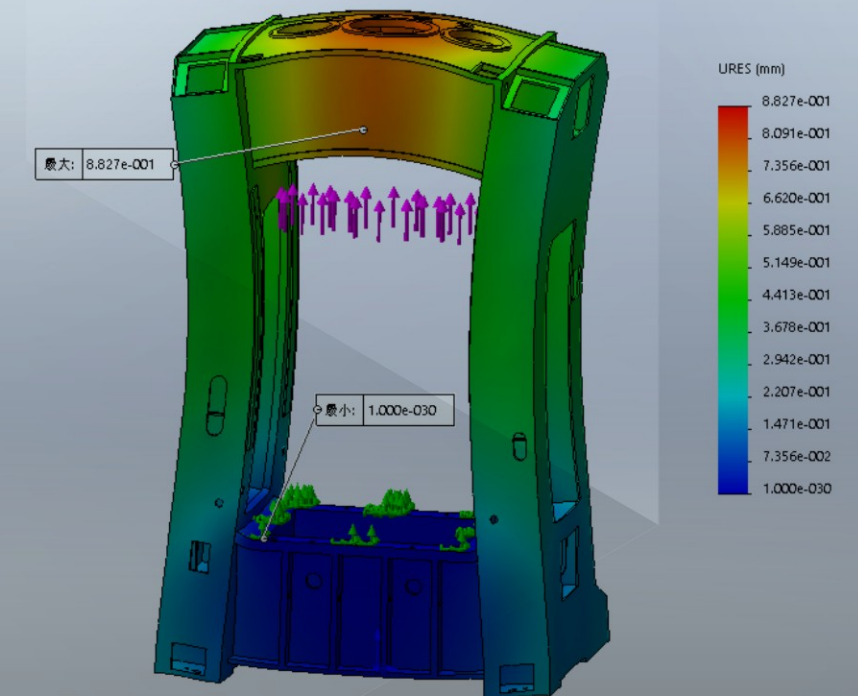
机架采用榫卯连接箱体结构，焊接后，经热处理消除床身内应力，机身整体高刚性。滑块采用四角八面导轨导向，导向精度可调并调节方便，导轨材料采用高力黄铜，动、静导轨板之间形成摩擦副，设备高精度。

The frame adopts mortise and tenon joint box structure, after welding, heat treatment to eliminate the internal stress of the bed, and the overall high rigidity of the fuselage. The slide block is guided by four-corner eight-sided guide rail, the guiding accuracy is adjustable and easy to adjust, the guide rail material is made of high-force brass, friction pairs are formed between the moving and static guide rails, and the equipment is high precision.



### 机身强度及变形量分析

Automation and Intelligent Devices



## 本系列机器的优势

### Advantages of machines

#### 高平衡、低能耗

High Balance, Low Energy Consumption

采用多缸制取代常规单缸结构，受力情况从点向面扩散，对偏负载拉伸起到高平衡效果。通过拉伸特性，电脑计算出浮动拉伸压力比值，通过差动原理把液压垫的力增压利用，达到节能的效果（通过科学技术成果鉴定，具有国际先进水平）。  
专利号：ZL201120484951.2

The multi-cylinder system is used to replace the conventional single-cylinder structure, and the force is diffused from point to plane, which has a high balance effect on the partial load tension. According to the hydraulic tensile characteristics, the computer calculates the ratio of floating tensile pressure, and uses the force of the hydraulic pad through the differential principle to achieve the effect of energy saving (through the identification of scientific and technological achievements, with the international advanced level). Patent No: ZL201120484951.2

#### 强悍的液压垫

Strong hydraulic cushion

对于屈服点高，硬度高，冷作硬化效应显著的材料（如：不锈钢）拉伸时需要较大的压边力。本设备液压垫力布局大于主缸力的1/2以上，所以非常适合此类材料的深拉伸。液压垫也可以由多个缸组成，受力均匀，对异型产品拉伸效果非常显著。

For materials with high yield point, high hardness and significant cold work hardening effect (such as stainless steel), a larger blank holder force is required when stretching. The hydraulic cushion force layout of this equipment is greater than 1/2 of the main cylinder force, so it is very suitable for deep drawing of such materials. The hydraulic cushion can also be composed of multiple cylinders, the force is uniform, and the tensile effect of special-shaped products is very significant.

#### 出色的速度、位置和压力控制性能

Excellent speed, position and pressure control performance

采用电液伺服控制，实现闭环控制回路。特定条件下，拉伸速度在5-28mm/s内任意设置。不同的产品及材料，调整不同的拉伸速度，增加拉伸的柔性效果。自主研发的定压，定位精度运算系统（专利号：2019SR020725），使设备定压及定位达到非常高的精度。

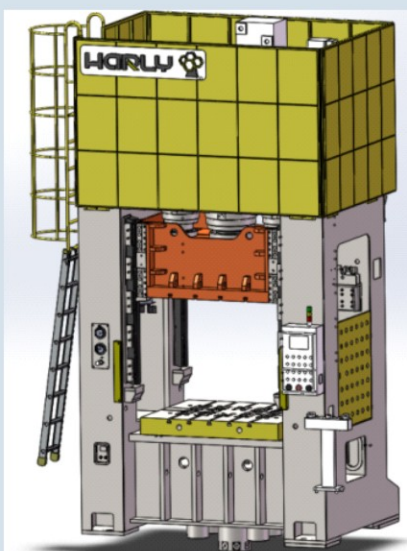
Electro-hydraulic servo control is adopted to realize the closed loop control. Under certain conditions, the drawing speed can adjust in 5-28mm/s. For different products and materials, different drawing speed can be adjusted to increase the flexibility of drawing. We are independently developed the constant pressure and positioning precision operation system (Patent No. 2019SR020725), So that the equipment constant pressure and positioning achieve very high accuracy.



## 本系列机器的优势 Advantages of machines

### 有效的降低异形及深拉伸产品的报废率

Effectively reduce the scrap rate of special-shaped and deep-drawn products.

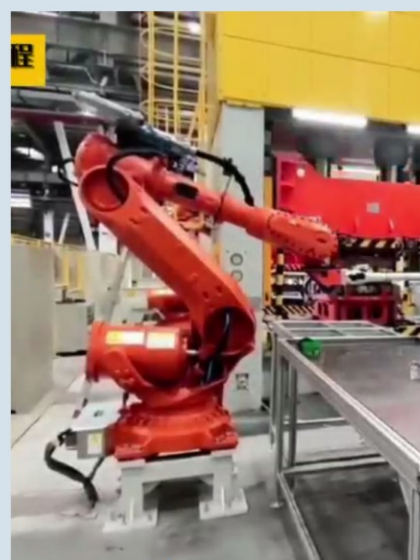


颠覆原有的液压机液压垫浮动拉伸的工艺。在本设备上增加模具润滑系统 (专利号:201220177040Y) 有效的增加材料的流动性, 同时也可以进行油拉伸, 让你感觉到高难度的拉伸产品变的没有难度。产品外形品质大大提高。

Subversion of the original hydraulic cushion floating drawing process. Add the mold lubrication system (patent No. : 201220177040Y) to the equipment to effectively increase the material liquidity, and at the same time, it can also carry out oil drawing, you can feel that the high difficulty of drawing products become no difficulty. The appearance quality of products is greatly improved.

### 自动化及智能化装置

Automation and Intelligent Devices

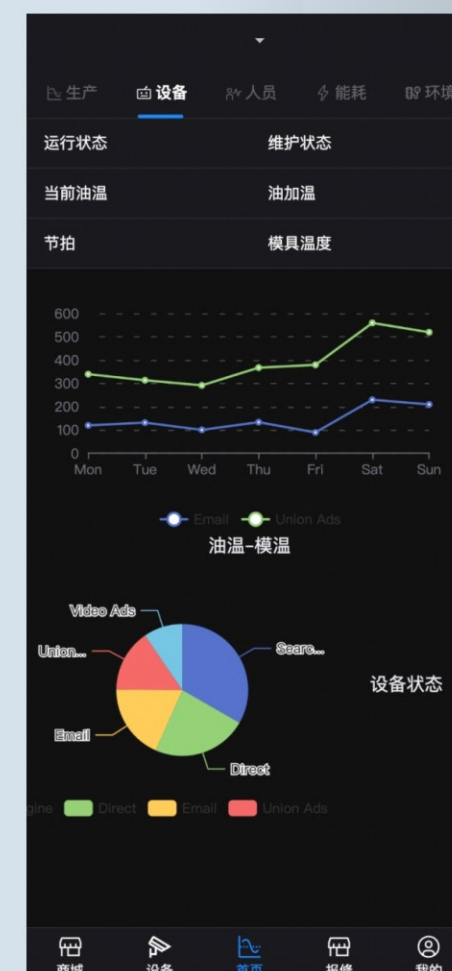


自动化上选配机械手及上料装置,搭配自定义步进程序, 实现设备全自动生产。智能上设备选配扫描枪, 模具识别装置, 搭配生产信息化管理系统, 实现智能化信息化生产。同时设备配备了图构点检, 智能维护等功能, 保证生产的可靠性。

Automatic selection of robot and feeding device, with freely defined stepping logic system software, to achieve automatic production of equipment. Intelligent equipment is equipped with scanning gun, mold identification device and production information management system to realize intelligent information production. At the same time, the equipment is equipped with mapping point inspection, intelligent maintenance and other functions to ensure the reliability of production.

### 具备了先进的智能服务

Advanced intelligent service



让客户无忧是我们一直奋斗的目标, 设备的故障我们必须第一时间知道。手机扫描屏幕上的“智能服务”二维码, 我们的设备服务平台就告诉你设备出现了什么问题, 接下来的事, 请放心交给我们。

Let customer reassurance is our goal, we must know the failure of the machine in the first time. Scan the "intelligent service" QR code on the screen, our machine service platform will show what is the problem, then the next thing, please rest assured to us.





## 生产流程 Production process



► 拉伸现场 Stretching field



► 自动生产线 Automatic production process



► 模具 Mold



► 产品 Production



► 清洗机 Cleaning machine



► 退火炉 Annealing furnace



► 冲床切边 punch machine for trimming



► 冲溢水孔机 punching spillway hole



► 溢水孔 Spillway hole



► 手工抛光 Hand polishing



► 自动抛光 Automated polishing



► 底部喷涂 Sink Bottom Spray Paint



► 包装 Packing





## 参数表 Parameter list

项 目 Item	型 式 Model	公称压力 Normal pressure	顶出压边力 Cushion pressure	液压最大 工作压力 Top pressure	滑块距工作 台最大间距 Max daylight	滑块最大行程 Slider max stroke	液压垫行程 Cushion stroke	滑块速度 Slider speed			工作台面 有效尺寸 Worktable size		液压垫板 有效尺寸 Cushion size		顶针孔直径 Ejector pinhole diameter	电机功率 Motor	精 度 Precision
								快下 Fast descend	工进 Press	回程 Ascend	左右 R-L	前后 F-R	左右 R-L	前后 F-R			
单 位 unit		KN	KN	Mpa	mm	mm	mm	mm/s	mm/s	mm/s	mm	mm	mm	mm	mm	KW	Jis (CNS) 1 Lass 一级 Lever 1
HLYS-200	Z型	2000	1200	25	1100	600	250	210	6-30	200	1000	900	630	600	40	19	
	N型																
HLYS-315	Z型	3150	2000	25	1100	600	300	210	6-30	200	1380	1200	980	750	45	36	
	N型																
HLYS-400	Z型	4000	2500	25	1100	600	300	210	6-30	200	1600	1200	1050	750	45	48	
	N型																
HLYS-500	Z型	5000	3000	25	1250	750	320	210	6-30	200	1800	1400	1300	850	45	60	
	N型																
HLYS-630	Z型	6300	4000	25	1250	750	320	210	6-30	200	1800	1500	1300	1000	50	70	
	N型																
HLYS-800	Z型	8000	4500	25	1300	800	350	210	6-24	200	2200	1500	1800	1000	50	70	
	N型																
HLYS-1000	Z型	10000	5000	25	1300	800	350	210	6-24	200	2200	1500	1800	1000	55	96	
	N型																
HLYS-1250	Z型	12500	6300	25	1300	800	350	210	6-24	200	2200	1500	1800	1000	55	120	
	N型																



配置表

Configuration list

项 目 Item	配置 Configuration		基本款 Basic	选配 Selection
配件 ( Parts )				
润滑给油装置 Circulating lubricating oil feeding device	手动 Manual		O	
	电动 Electric			O
空气源及喷风接头 Air Sources &Breeze Joint				O
电源插座 Power outlet			O	
工作照明灯working Light Devices				O
滑块中缸Slider center cylinder				O
电液伺服Electro-hydraulic servo				O
液压垫分段比例调压系统 Cushion subsection proportional control system			O	
油液冷却 Cooler	水冷 Water cooler		O	
	强制 Forced cooler			O
油加热装置 Oil heating device				O
安全防护 Safety Device	光栅保护 Grating protection	前 (F)	O	
		后 (R)		O
	滑块锁装置 Slider lock device		O	
自动化装置 Automation device				O
快换模装置 Fast speed change mold device	举模器 Mold lifter			O
	举模臂 Mold lifter arm			O
	夹模器 Mold clamp			O
移动操纵装置 Movable Operation Device	脚踏 Pedal			O
	双手 Both hands		O	

项 目 Item	配 置 Configuration		基本款 Basic	选配 Selection
功能 (Function)				
冲压缓冲装置 Press buffer device				O
模温装置 Mold TEMP device	加温 Heating			O
	冷却 Cooling			O
模具识别装置 Mold recognition function				O
模具加油润滑装置 Mold oiling device				O
智能化装置 Intelligent device	人脸识别 Face identification			O
	能耗管理 Energy consumption management			O
	扫描枪接口 Scanning interface			O
	数据接口 Data interface			O
三色灯运转指示灯 Three-color operating indicator light			O	O
系统软件 System software				O
设备点检系统 Machine inspection system				O
设备诊断系统 Machine diagnostic system				O
智能服务平台系统 Intelligent service system				O
生产信息化管理系统 Production information management system				O
模具储存量系统 Mold storage system			O	
附件 Attachment			O	
地脚垫板 Anchor plate			O	
顶杆 Ejector rod			O	
维修工具 Maintenance tools			O	
使用说明书 Use Manual			O	
合格证明书 Certification			O	