

Anyang Forging Press Machinery Industry Co., Ltd

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 **Large type hot forging hydraulic press**



Applications:

Large type hot forging hydraulic press is the forging equipment which can be forged different types of open die forging process. It is the widespread usage in forging industry. According to different requirements of the market, our company researches and designs the 800T, 1600T, 2000T, 2500T, 3150T, 5000T etc series forging hydraulic press.

Features:

The hydraulic press adopts the three cross beam four columns structure, and the top and lower cross beam, four columns and lock nut consist of the closing framework born the full load. There is one set fast exchange die device set in movable cross beam so that it is convenient for hoisting the workpiece. The top die is connected with the exchange die device, and it is easy to change the die and save the time. The bi-directional horizontal movement worktable is connected with the lower cross beam. The movable cross beam is driven by plunger type main cylinder, lift cylinder and guided by the columns and moves between the top and lower cross beam.

The working cylinder of hydraulic press consists of three hydraulic cylinders. It can realize the upgrade automatically during the working. When upsetting the forgings, the first pressure is not enough, the pressure should be risen to second pressure. It is not still enough, and it will be risen to the maximum pressure 25Mpa. Before it has the pressure in middle cylinder, now three cylinders have the pressure simultaneously.

This machine is transmitted the energy through the hydraulic oil, and it can be come true the large force in systematical structure, there is large stroke, moreover, it can be gotten the rated maximum pressure wherever the position of stroke. It can come true the pressure maintaining for a long time so that it can be gotten the overload protection easily. It is better than forging hammers comparing to the symmetrical blow. So it can be manufactured the symmetrical internal and external structure forgepieces.

The Indication of hydraulic system adopts stroke indication and pressure indication, so the fixed stroke pressing and fixed pressure pressing. The former adopts the encoder and the latter adopts the pressure relay, so it can be met the working requirements.

The hydraulic system is controlled by the second grade inserted valve,so the machine has uniformity of operation and no shock,and there is multilevel overload protection,oil temperature alarm,oil level alarm protection etc auto protection device.The electric system is controlled by the PLC so that ensures the safety of machine and operators.

To compress the working cylinder with the prefill valve of large flow volume,it is connected with the reserve tank.It can come true the quick oil extension and quick oil return when lifting.It's saved the forging change over time and enhance the forging efficiency.

The cooling system is set in this machine,and it can be controlled the oil temperature and ensured the normal operation.

Detail Parameters of Large Size Hot Forging Press:

Item	Unit	800T	1600T	2000T	2500T	3150T	4000T	5000T
Rated force	MN	8	16	20	25	31.5	40	50
Working pressure	Mpa	25	25	25	25	25	25	25
clear opening	mm	2300	2600	3000	3400	4000	4700	5200
Max stroke	mm	1000	1400	1600	1600	1900	2200	2600
Column center distance	mm	2200×1100	2600×1400	2800×1500	3200×1600	3500×1800	4000×2000	4500×2200
Return speed	mm/s	300	250	250	250	200	200	200
Working speed	mm/s	45	45	45	45	45	45	45
Idle stroke speed	mm/s	300	300	250	250	200	200	200
Fast forge number	min-1	45	45	45	45	35	35	35
Oil cylinder diameter	mm	∅ 640	∅ 740 2-∅ 360	∅ 740, 2-∅ 480	∅ 900, 2-∅ 460	3-∅ 730	∅ 900, 2-∅ 840	3-∅ 920
Column diameter	mm	∅ 260	∅ 340	∅ 360	∅ 420	∅ 480	∅ 550	∅ 600
Working table size	mm	2500×1400	3500×1600	4000×1600	4000×2000	5000×2200	5500×2200	5500×2800
Working table max stroke	mm	800	1500	1500	200	2500	3500	3500
Working table speed	mm/s	200	150	150	150	150	100	100
Allowed max excentricity	mm	80	120	120	120	150	150	150
Forge steel ingot drawing out	T	5	15	20	35	45	50	58
Forge steel ingot upsetting	T	2.5	8	14	17	20	24	28
Motor power	KW	330	990	1100	1320	1650	2090	2420
Total weight	T	90	280	410	540	660	980	1200

Pictures of large size hot forging press



