

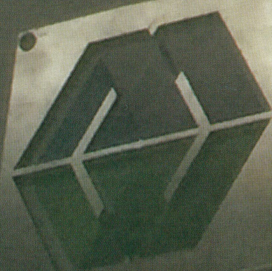


ALLOY WHEEL MACHINING PROFESSION

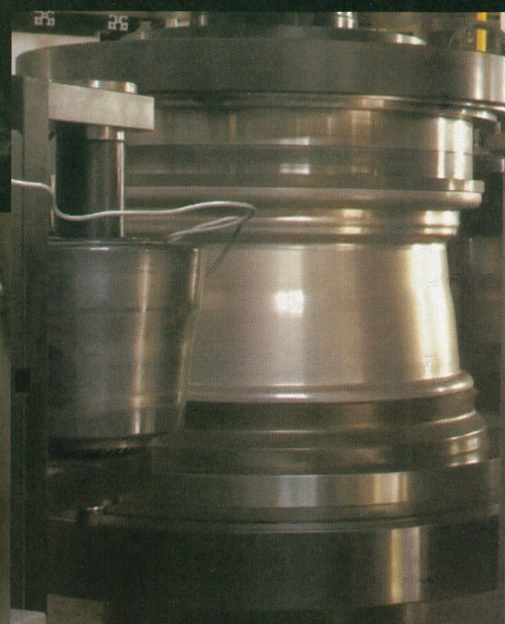
the
W MACHINE

輥鍛技術 更省錢 更方便 更有效

EMRF 1000 輥鍛機 Booth No. 1330



ALLOY WHEEL MACHINING PROFESSION
the
W MACHINE



RFTTM
ROLLING FORCE TECHNOLOGY

Application on Alloy Wheel

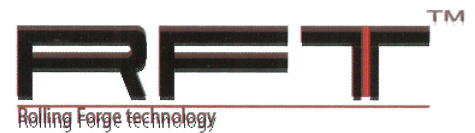
長揚機械股份有限公司

powered



**Everrising Machinery and Automation Co.
Evershine Alloy Wheel Co.**

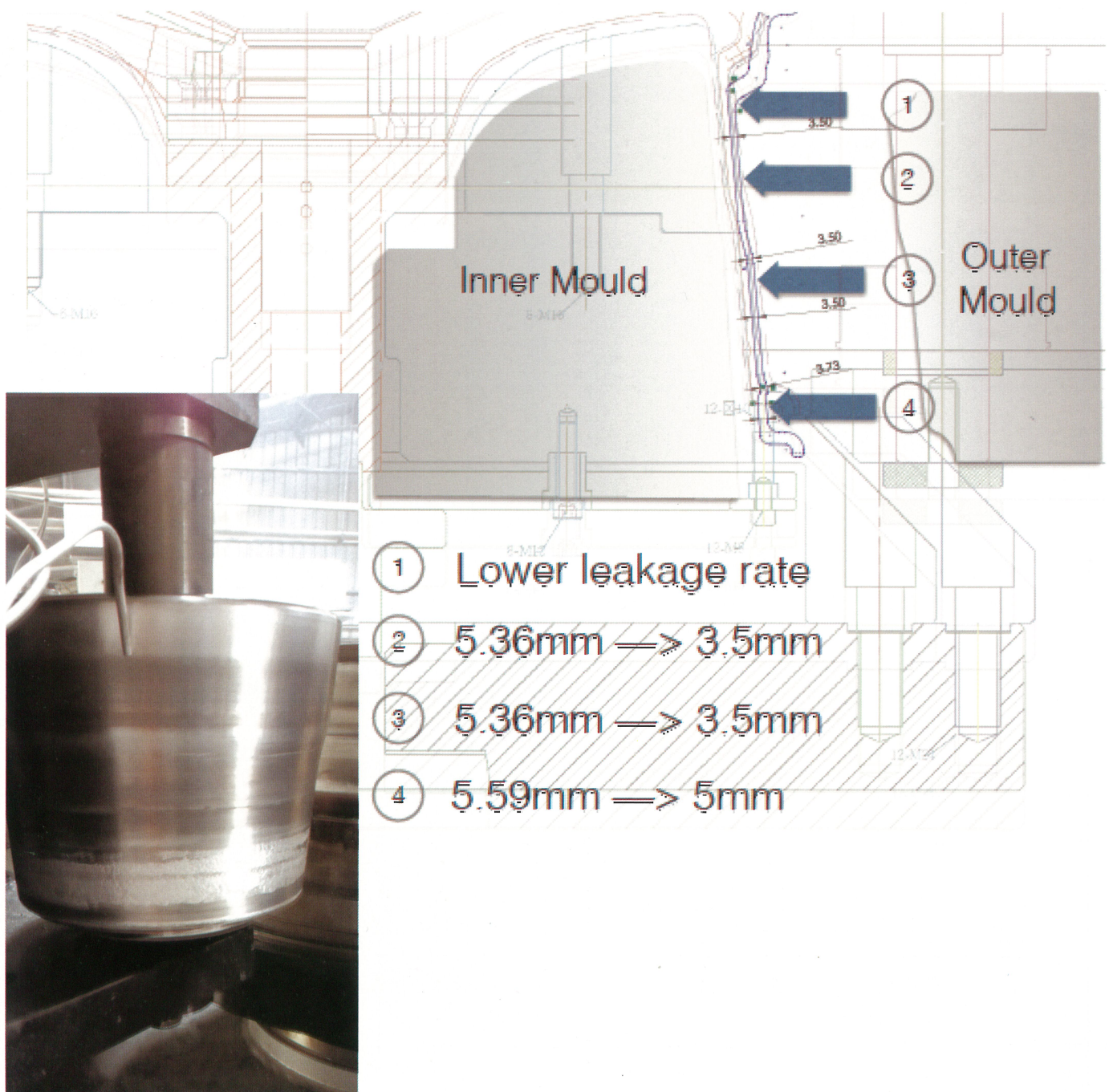
RFT Process Design



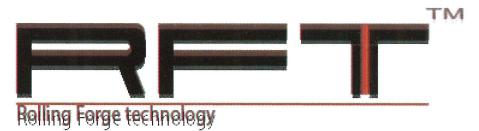
什麼是軋鍛技術

Using rolling forged process to increase

the strength of rim 運用軋壓鍛造方式增加輪圈強度



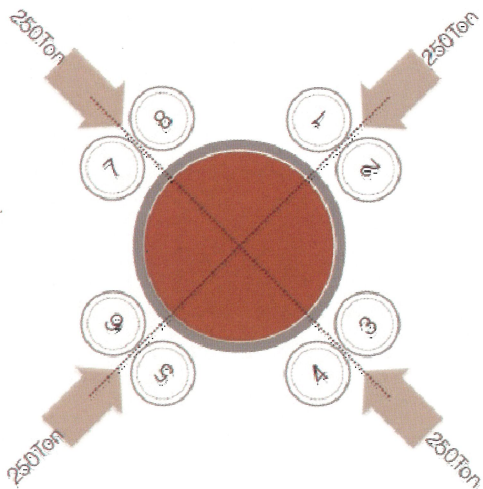
The Performance of RFT



RFT 成效

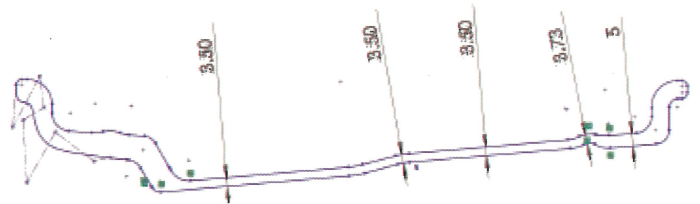
EACH 250 TONS FORCE

每軸最大力量 250 噸



Lower Leakage Rate

低洩氣率



19" Wheels

Weight Saving

8.11 kg → 6.79 kg

1.32 kg ↓

19' 輪圈重量

16.3 % ↓

減少 16.3%厚度縮減



19" Wheels

Thickness of Rim

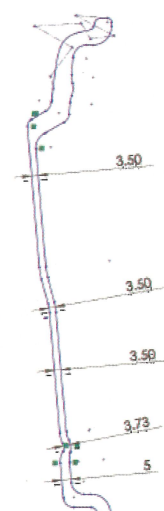
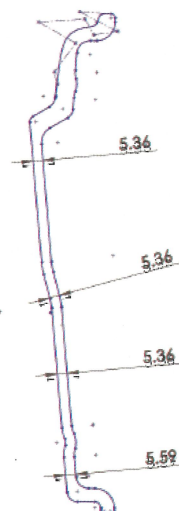
厚度縮減 34.7%

1.86 mm ↓

34.7 % ↓

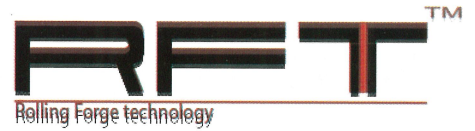
Standard Rim (m/m)

RFT Rim (m/m)



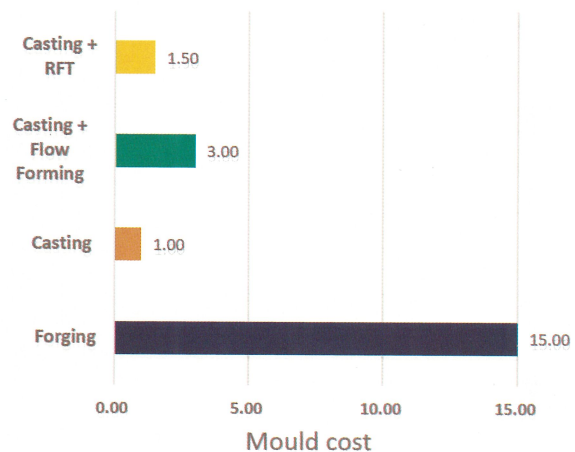
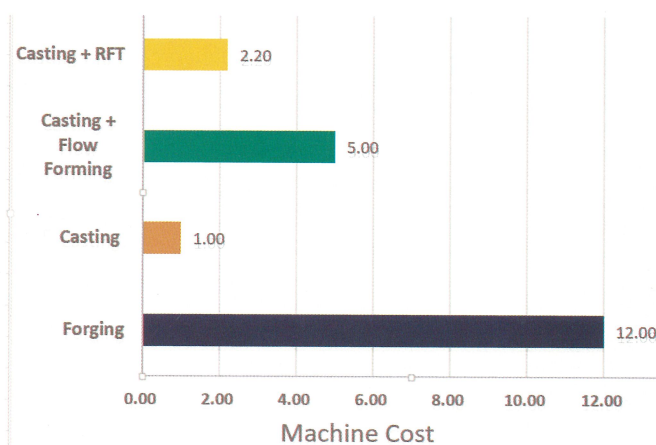
RFT Cost Analysis

RFT 成本分析



RFT 機械價格只有
FLOW FORMING
價格的一半不到

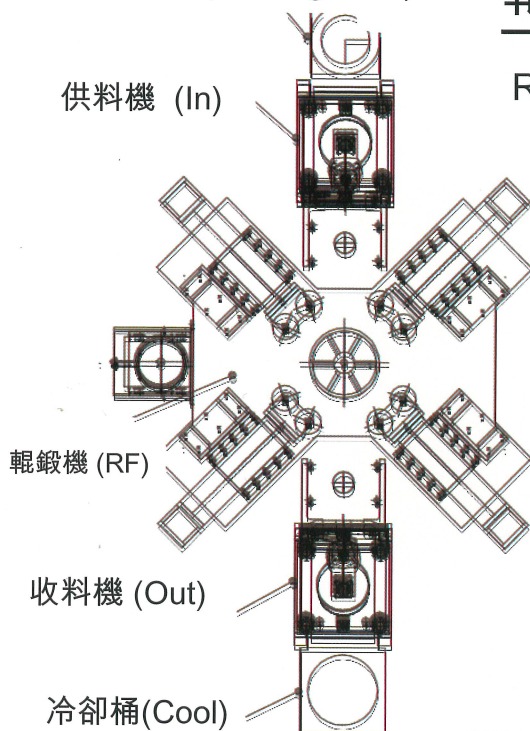
RFT 模具費用只有
Flow Forming 的一半



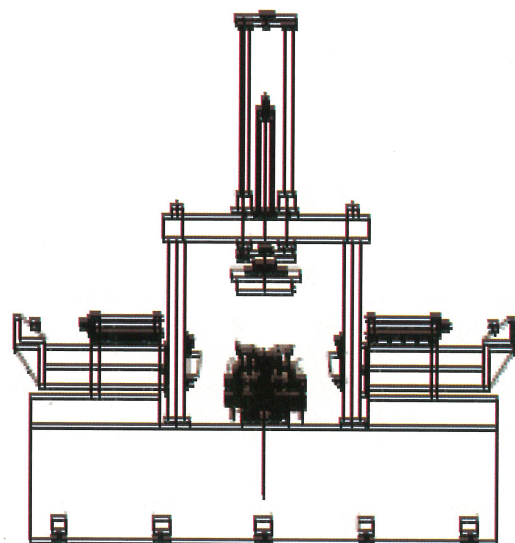
升降加熱台(Heating table)

軋鍛機主要部位

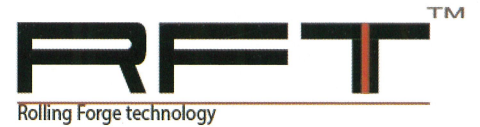
Rolling Forge Machine Layout



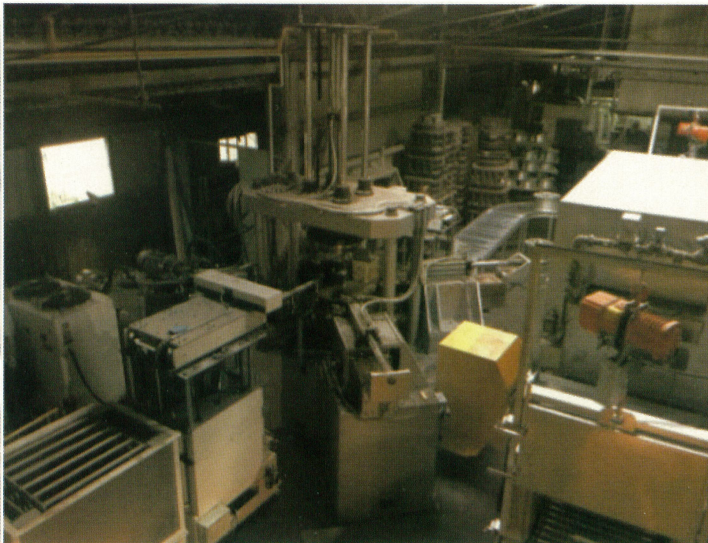
油壓單元
Hydraulic



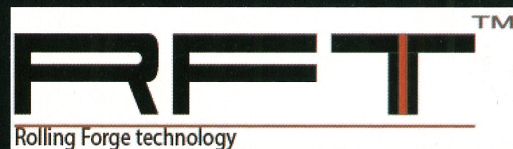
Rolling Force Machine Specification



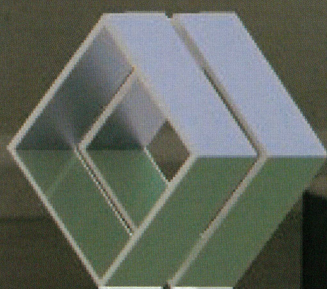
輥鍛機規格



加工能力 Capacity		主軸 Spindle	
最大旋徑 Max Swinging Dia (mm)	Ø 1000	主軸轉速 Spindle (rpm)	30 ~ 90
最大輥鍛外徑 Max Rolling Dia (mm)	Ø 610	馬達 Motor	
最大輥鍛高度 Max Rolling Height (mm)	320	主軸馬達 Spindle motor (kw)	15
工作台至上模最高距離 Max height between table and up tooling (mm)	850	油壓馬達 Oil hydraulic motor (kw)	50
行程 Travel		循環油冷卻系統馬達 Cooling system motor (kw)	7.5
邊模行程 Side tooling travel (mm)	450	一般規格	
上模行程 Up tooling travel (mm)	650	機器械長/寬 Machine layout (L*W mm)	4210×3520
脫模行程 Release tooling travel (mm)	35	機械高度 Machine height (mm)	3640~4290
邊模快速進給 Side tooling high speed (mm/min)	4500	機械占地面積 Machine area (mm)	3520×6250
邊模慢速進給 Side tooling high speed (mm/min)	5~30	機械重量 Machine weight (kg)	21000
		電力需求 Power required (kva)	80



Everrising Machinery and
Automation Corporation



alloy wheel machine profession

the

W MACHINE

長揚機械股份有限公司

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