

YIHUA
—义华模具—



专业精密模具制造商
Professional Precision Mould Manufacturer

任丘市义华精密模具有限公司
RENQIU YIHUA PRECISION MOULD CO.,LTD



义华模具

企业文化

ENTERPRISE CULTURE

义华使命 Mission

与员工共同成长，与客户共同进步，与社会共同发展

Grow up with employee together, Progressing with
clients together, Developing with the society together

义华目标 Target

成为拉丝模具制造领域最有竞争力的标杆企业

To become a top enterprise in the filed of making wire
drawing die with best competitive ability

义华远景 Prospect

成为一家受人尊敬、具有持续成长能力的健康企业

To Become a successful and healthy enterprise which is respected
and with great protential for continuous development

义华精神 Spirit

诚信、创新、敬业、和谐、感恩

Honesty, Innovation, Dedication, Harmony, Gratefulness

企业简介 COMPANY PROFILES >>>

任丘市义华精密模具有限公司是专业从事开发、研制生产钻石、钨钢模具的现代化企业，我司引进先进的生产设备瑞士夏米尔慢走丝、日本沙迪克镜面电火花、台湾精密磨床、数控车床、奥地利超声波研磨机、激光打孔机、挪威Conoptica孔径测量仪、尼康MM400显微镜、瑞士TESA精密量具等，先进的生产设备和领先的制造技术，使我公司在模具制造方面处于领先地位，使之能够满足客户提出的各种要求，多年来我司以雄厚技术的实力，优良的售前、售后服务及良好的信誉赢得了国内外客户的广泛好评。

我公司产品主要分为三大类：

一、钻石模具：包括天然钻石拉丝模具、单晶拉丝模具、进口聚晶拉丝模具、国产聚晶（PCD）拉丝模具、高晶、CD钻石拉丝、拉管模具、聚晶绞线模具、电缆紧压模具;进口聚晶（钻石）正方、扁方、六角、半圆等异形拉丝模具（眼模）、可广泛适用于金、银、铜、铁、铝、不锈钢等金属线材、管材的拉伸缩径及改形。

二、钨钢模具：包括钨钢拉丝模具、拉管模具、螺旋模具、钢丝绳模具、涂粉模具、绞线模具、异型模具、拉伸模具、粉末冶金模具、冷镦成型模、螺丝模具、六角冲光模具、标准件模具、钨钢冲针、冲头等精密钨钢模具。可广泛应用于钢丝绳、钢绞线、电线电缆、电磁线、切割钢线、金属管材、紧固件、标准件、冶金、机械、钢铁、五金电子、建筑等多领域、多行业。

三、精密配件：硬质合金钻套、钨钢钻模、钨钢轴套、钻石高压喷嘴、钻石扇形喷嘴、硬质合金喷嘴、钨钢微孔模具等。

义华模具始终坚持“质量第一、信誉至上”的企业宗旨，把客户的需求和满意作为企业活动的核心，以“高效务实、团结创新、精益求精”的管理理念，强化“质量是企业生命”的质量方针，实践“以人为本，诚信守诺，反应迅速”的服务理念，创造优秀的企业文化，树立良好的企业形象，更好地服务于广大客户！

Renqiu Yihua Precision Mould Co., LTD. Is a professional engaged in the development, the development and production of diamond and tungsten carbide mould of a modern enterprise, our company introduced advanced production equipment Swiss summer mill good-bye silk thread cutting machine, Japanese sodick mirror EDM, Taiwan precision grinding machine, CNC lathe, Austria ultrasonic lapping machine, laser drilling machine, Norway Conoptica diameter measuring instrument, nikon MM400 microscope, Switzerland TESA palisade precision measuring tool, etc., the advanced production equipment and advanced manufacturing technology, make our company a leading position in the mold manufacturing to meet kinds of customers demand, Over the years, our company has won wide praise from customers domestic and abroad with strong technical strength, excellent pre-sales and after-sales service and good reputation.

Our products are mainly divided into three Types:

1. Diamond Dies: including natural diamond dies, single crystal dies, imported polycrystalline dies, domestic polycrystalline (PCD) dies, high crystal, CD diamond dies, tube/pipe drawing dies, polycrystalline stranded dies and cable pressing dies; Imported polycrystalline (diamond) square, flat square, hexagonal, semi-circular and other special-shaped drawing dies (eye dies), can be widely used in gold, silver, copper, iron, aluminum, stainless steel and other metal wire, pipe stretch and short diameter and shape modification.

2. Tungsten Carbide Dies: including tungsten wire drawing dies, drawing tube dies, screw mould, steel wire rope dies, powder coating mould, twisted wire mould, special-shaped mould, drawing mould, powder metallurgy mould, cold upsetting forming mould, screw mould, hexagonal finishing mould, standard parts mould, tungsten carbide punching needle, punch and other precision tungsten steel mould. It can be widely used in wire rope, wire rope, wire cable, electromagnetic wire, cutting steel wire, metal pipe material, fasteners, standard parts, metallurgy, machinery, steel, hardware electronics, construction and other fields and industries.

3. Precision Accessories: tungsten carbide drill sleeve, tungsten steel drilling die, tungsten carbide axle sleeve, diamond high-pressure nozzle, diamond fan nozzle, tungsten carbide nozzle, tungsten carbide micro-hole mould, etc.

YiHua Mould Company always adhere to the ““quality first, reputation first”” corporate purposes, the customer's needs and satisfaction as the core of business activity, in order to ““pragmatic, unity, innovation, strives for perfection”” the management idea, strengthen the quality guideline of ““quality is the enterprise life””, the practice of ““people-oriented, insist integrity , quick”” service concept, to create excellent corporate culture, establish a good corporate image, to better serve the masses of customers”

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product classification

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生产设备 PRODUCTION EQUIPMENT >>>



慢走丝 Walking wire



精密线切割 Precision wire cutting



PG光曲磨 PG optical curve grinding



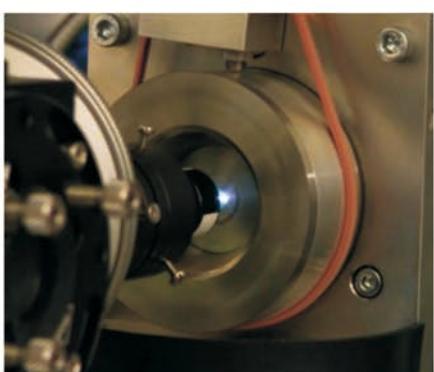
精密磨床 precision grinder



电火花 EDM electric spark



EDM电火花 electric spark



全自动钻石模具激光打孔机
Automatic Diamond Die Laser Drilling System



进口全自动模具研磨机
Automatic Diamond Die Grinding Machine



进口全自动模具研磨机
Automatic Diamond Die Grinding Machine



超声波研磨机 Ultrasonic grinding machine



全自动定径研磨机 Automatic sizing mill

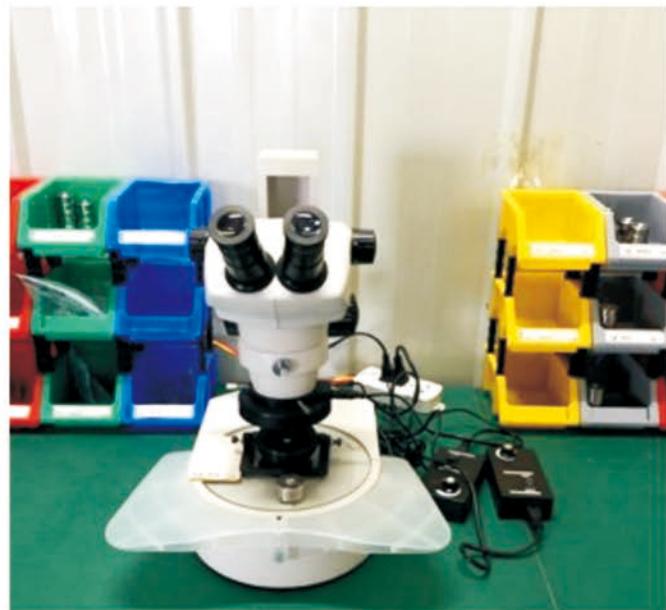


自动角度研磨机 Automatic angle grinding machine

检测设备 INSPECTION EQUIPMENT >>>



光学显微镜
Optical Microscope



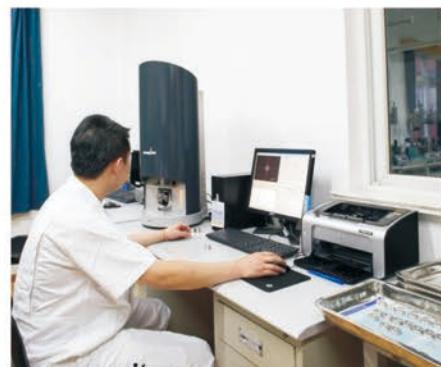
电子显微镜
electron microscope



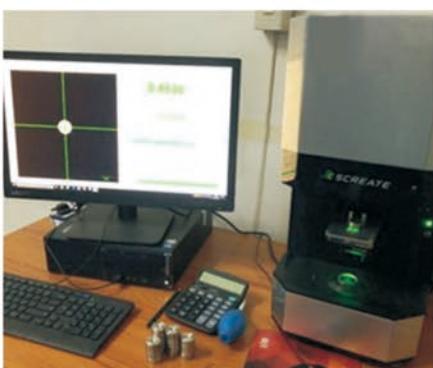
光学投影仪
optical projector



2.5 次元测量仪
2.5D admeasuring apparatus



挪威Conoptica孔径测量仪
Norway Conoptica diameter measuring instrument



孔径检测仪
Aperture detector



数字纳米线径检测仪
digital nanometer test



非接触激光外径测试仪
Non-Contact Laser Outside Diameter Tester

钻石拉丝、拉管模具 >> DIAMOND WIRE/PIPE DRAWING DIE

产品简介 Product Brief

聚晶拉丝、拉管模具选用优质的模芯制造，具有质地均匀，耐磨性强，光洁度高，精密度高、使用寿命长等优点，在长时间拉丝过程中可保证线材的表面光洁度和准确度，模具内径生产范围0.03-32mm。

Polycrystalline wire / tube drawing die are made in high quality diamond, which has the advantages of uniform texture, strong abrasion resistance, high finish, high precision and long work life, etc., and can guarantee the surface smoothness and accuracy of wire material during the long drawing process. Dies inner diameter production range is 0.03mm-32mm.

模芯材料主要分为以下几类 Diamond materials are mainly divided into the following types:

进口聚晶模芯：选用美国GE康派克斯（ Compax ）、日本住友（ Sumidia ）、英国戴比尔斯（ De Beers ）。

国产聚晶模芯：四方达CD材料、新亚CD材料、西波尔CXD、沃尔克高晶模芯。

天然钻石缩写为ND,是在地壳里高温高压环境下天然形成，是目前已知材料中最硬的物质。

单晶钻石缩写为AD、SD、SSCD、SMCD、MCD，是一种在受控条件下人造合成的钻石、高纯度、无杂质及高稳定性、这些质量特性也使得材料具有极高的硬度和稳定的耐磨性。

Imported polycrystalline diamond: America GE Compax, Japan sumidia, UK De Beers.

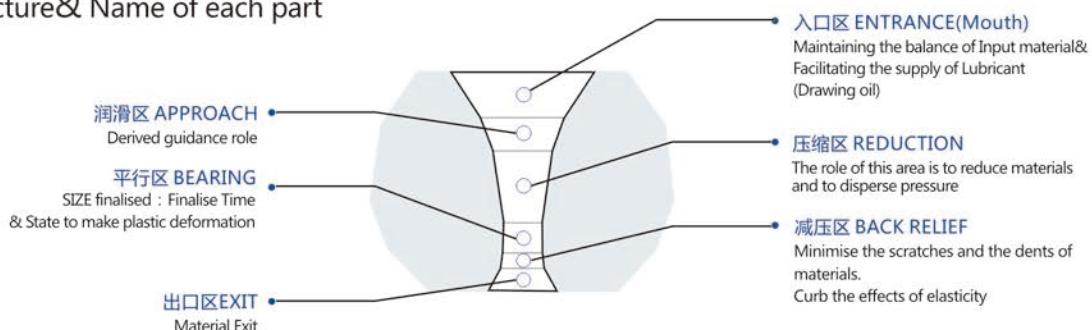
Domestic polycrystalline diamond: Sifangda CD materials, Xinya CD materials, Supower CXD, volcker high crystal cores.

Natural diamond, abbreviated ND, is naturally formed in the high temperature and high pressure environment of the earth's crust, and is the hardest substance known to date.

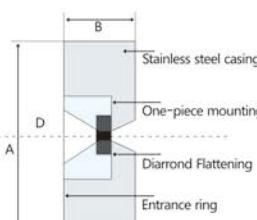
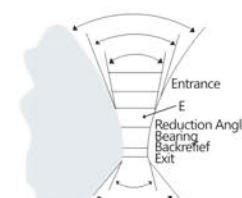
Single crystal diamond, abbreviated AD, SD, SSCD, SMCD, MCD, is a synthetic diamond made under controlled conditions with high purity, impurity, and high stability. These quality characteristics also enable the material to have high hardness and stable abrasion resistance.

模具内部结构图

Dies structure& Name of each part



模具设计参考条件 Design condition of Dies

01 SIZE of initial wire 进线尺寸	02 REDUCTION Angle control 压缩角度			
03 Performance decision of Drawing machine (Speed,etc) 设备性能	04 Property of Drawing oil 润滑性能	(REMARK) A:25±0.1mm B : 8~12±0.2mm C : +0 , 0.001~3mm D : 16~18° (Copper)		

参数信息：Data Info

线材材质 Wire	硬线 Hard Wire			软线 Soft Wire	
名称 Profile Name	不锈钢 Stainless Steel	铜包钢 Copper-clad Steel	钨、钼 Tungsten、Molybdenum	铜线 Copper Wire	铝线 Aluminium Wire
入口区 Entrance Area	70°	70°	70°	80°	80°
润滑区 Lubrication Area	30°	30°	30°	35°	35°
压缩区 Compression Area	14°±2°	14°±2°	12°±2°	16°±2°	18°±2°
平行区 Parallel Area	0.4D~0.8D	0.4D~0.8D	0.4D~0.8D	0.2D~0.5D	0.2D~0.5D
减压区 Decompress Area	25°±5°	25°±5°	25°±5°	25°±5°	25°±5°
出口区 Exit Area	50°	50°	50°	60°	60°

产品图片：PRODUCT PICTURE



聚晶拉丝、拉管模具



进口聚晶拉丝模具

单晶钻石拉丝模具

天然钻石拉丝模具

钻石拉丝、拉管模具 >>> DIAMOND WIRE/PIPE DRAWING DIE

参数信息：Data Info

聚晶拉丝模具材料规格表-四方达&新亚 Sifangda & Xinya Polycrystalline Diamond Blank Size Form								
	ADDMA	可供粒度 Blank Designation Grain Size(um)					模坯尺寸 Blank Size(mm)	最大推荐孔径 Maximum recom Die Size(mm)
		1um	3um	5um	10um	25um		
无支撑环坯 Self Supported Blank	D6		210	210	210	210	2.5x1.0	0.5
	D12		315	315	315	315	3.2x1.5	1.0
	D15		525	525	525	525	5.2x2.5	1.5
	D18		535	535	535	535	5.2x3.5	2.0
钨钢支撑环坯 Tungsten Carbide Supported Blanks	D12			415	415	415	4.2x1.5	1.0
	D15		423	423	423	423	4.2x2.3	1.5
	D18		429	429	429	429	4.0x2.9	2.0
	D21		638SP	638SP	638SP	638SP	6.8x3.8	3.1
	D24		653SP	653SP	653SP	653SP	6.8x5.3	4.4
	D27				945C	12855PX	12.9x8.7	5.8
	D30				950C	1212SPX	12.9x12.0	7.6
	D30						15.2x12.1	9.0

聚晶拉丝模具材料规格表-住友金刚石 WD Sumidia WD/Semicrystal Blank Size Form								
	ADDMA	可供粒度 Blank Designation Grain Size(um)					模坯尺寸 Blank Size(mm)	最大推荐孔径 Maximum recom Die Size(mm)
		1um	3um	5um	12um	25um		
无支撑环坯 Self Supported Blank	D6	805F		905M	905C	905E	2.5x1.0	0.5
	D12	810F		810M	810C	810E	3.2x1.5	1.0
	D15	815F		815M	815C	815E	5.2x2.5	1.5
	D18	820F		820M	820C	820E	5.2x3.5	2.0
钨钢支撑环坯 Tungsten Carbide Supported Blanks	D12	820F	910S	910M	910C	910E	1.5x1.5	0.8
	D15	915F	915S	915M	915C	915E	4.0x2.3	1.8
	D18	920F	920S	920M	920C	920E	4.0x2.9	2.3
	D21		925S	925M	925C	925E	7.0x4.0	3.5
	D24		930S	930M	930C	930E	7.0x5.3	4.6
	D24			940M	940C	940E	9.0x7.5	5.2
	D27			945M	945C	945E	13.0x9.0	5.8
	D30			950M	950C	950E	13.0x12.0	7.6

聚晶拉丝模具材料规格表-美国GE.Compax Polycrystalline Diamond Blank Size Form-USA GE.Compax								
	ADDMA	可供粒度 Blank Designation Grain Size(um)					模坯尺寸 Blank Size(mm)	最大推荐孔径 Maximum recom Die Size(mm)
		3um	5um	12um	25um	50um		
无支撑环坯 Self Supported Blank	D6		5010TS				2.5x1.0	0.5
	D12		5015TS				3.2x1.5	1.0
	D15		5025TS				5.2x2.5	1.5
	D18		5035TS				5.2x3.5	2.0
钨钢支撑环坯 Tungsten Carbide Supported Blanks	D12		5235				1.5x1.5	0.8
	D15			5823	5223	5430	4.0x2.3	1.8
	D18	5829			5229	5435	4.0x2.9	2.3
	D21			5840	5240	5530	7.0x4.0	3.5
	D24			5853	5253	5535	7.0x5.3	4.6
	D24				5225	5725	9.0x7.5	5.2
	D27				5208	5730	13.0x9.0	5.8
	D30				5211	5735	13.0x12.0	7.6

产品图片：PRODUCT PICTURE



进口聚晶拉管模具



聚晶拉丝模具



聚晶绞线、紧压模具

应用领域：Application Fields

电线电缆、铜丝、铝丝、铜包钢丝、铜包铝丝、钢丝绳、低碳钢线、高碳钢线、不锈钢线、镍线、铬线、钼线、钨线、铜包钢线、切割线、钢帘线、焊丝、钢管、铝管、不锈钢管等。

Wire and cable, copper wire, aluminum wire, copper clad steel wire, copper clad aluminum wire, steel wire rope, low carbon steel wire, high carbon steel wire, stainless steel wire, nickel wire, chromium wire, molybdenum wire, tungsten wire, copper clad steel wire, cutting wire, steel curtain wire, welding wire, copper pipe, aluminum pipe, stainless steel pipe, etc.



生产现场



铜丝



铜管



黄铜线



钢丝



铝电缆



钢丝



铜管

聚晶异形拉丝模具 >>> POLYCRYSTAL SHAPED WIRE DRAWING DIE

产品简介 Product Brief

聚晶异形拉丝模具选用优质的模芯制造，具有质地均匀，耐磨性强，光洁度高，精密度高、使用寿命长等优点，在长时间拉丝过程中可保证线材的表面光洁度和准确度。可生产正方、扁方、三角、六角、八角、半圆、椭圆、扇形、Z型、瓦型等各种聚晶异形拉丝模具。

正方线眼最小做到 0.18×0.18 mm，扁方线眼最小做到 0.08×0.20 mm，半圆线眼最小做到 0.20×0.40 mm，三角线眼最小做到 0.25×0.25 mm，尖角可达到 0.01 mm，公差控制在 ± 0.001 mm左右。还可根据客户要求订做其他规格形状。

Polycrystalline shaped drawing Dies is made of high quality die core, which has the advantages of uniform texture, strong abrasion resistance, high finish, high precision and long work life, etc., and can guarantee the surface smoothness and accuracy of wire material during long drawing. Can produce square, flat square, triangle, hexagon, octagonal, semicircle, ellipse, fan, Z, tile, etc.

The minimum hole size of the square dies is 0.18×0.18 mm, The minimum hole size of flat dies is 0.08×0.20 mm, The minimum size of the semi-circular dies is 0.20×0.40 mm, The minimum size of the triangle dies is 0.25×0.25 mm. The sharp Angle can control in 0.01 mm, and the tolerance is about 0.001 mm. Other specifications and shapes can also be customized according to customer requirements.

模芯材料主要分为以下几类：

Diamond materials are mainly divided into the following types:

进口聚晶模芯：选用美国GE康派克斯（Compax）、日本住友（Sumidia）、英国戴比尔斯（De Beers）。

国产聚晶模芯：四方达CD材料、新亚CD材料、西波尔CXD。

Imported polycrystalline diamond: America GE Compax, Japan sumidia, UK De Beers.

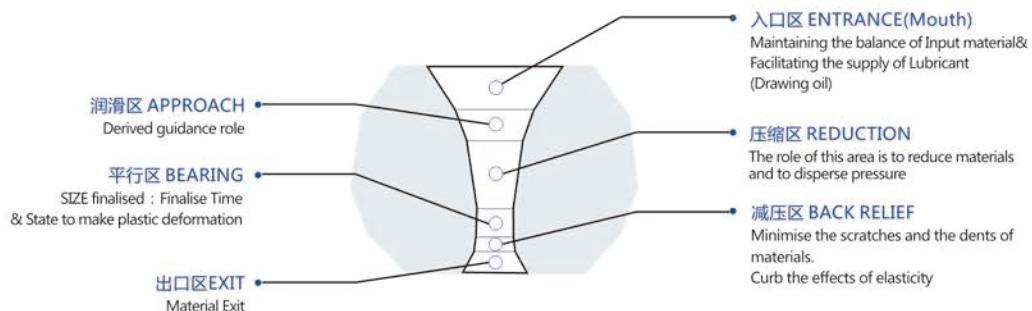
Domestic polycrystalline diamond: Sifangda CD materials, Xinya CD materials, Supower CXD.

参数信息 : Data Info

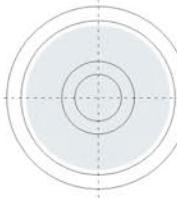
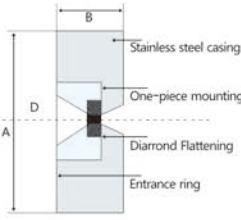
线材材质 Wire	硬线 Hard Wire			软线 Soft Wire	
名称 Profile Name	不锈钢 Stainless Steel	铜包钢 Copper-clad Steel	钨、钼 Tungsten、Molybdenum	铜线 Copper Wire	铝线 Aluminium Wire
入口区 Entrance Area	70°	70°	70°	80°	80°
润滑区 Lubrication Area	30°	30°	30°	35°	35°
压缩区 Compression Area	$14^\circ \pm 2^\circ$	$14^\circ \pm 2^\circ$	$12^\circ \pm 2^\circ$	$16^\circ \pm 2^\circ$	$18^\circ \pm 2^\circ$
平行区 Parallel Area	0.4D~0.8D	0.4D~0.8D	0.4D~0.8D	0.2D~0.5D	0.2D~0.5D
减压区 Decompress Area	$25^\circ \pm 5^\circ$	$25^\circ \pm 5^\circ$	$25^\circ \pm 5^\circ$	$25^\circ \pm 5^\circ$	$25^\circ \pm 5^\circ$
出口区 Exit Area	50°	50°	50°	60°	60°



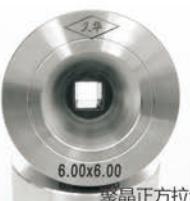
模具内部结构图 Dies structure& Name of each part



模具设计参考条件 Design condition of Dies

01 SIZE of initial wire 进线尺寸	02 REDUCTION Angle control 压缩角度			
03 Performance decision of Drawing machine (Speed,etc) 设备性能	04 Property of Drawing oil 润滑性能	{ REMARK } A:25±0.1mm B : 8~12±0.2mm C : +0 , 0.001~3mm D : 16~18° (Copper)		

产品图片: PRODUCT PICTURE



聚晶正方拉丝模具

聚晶花齿模具



聚晶异形拉丝模具



聚晶异形拉丝模具

应用领域: Application Fields

电线电缆、电磁线、铜丝、铝丝、铜包钢丝、铜包铝丝、钢丝绳、低碳钢线、高碳钢线、不锈钢线、镍线、铬线、钼线、钨线、铜包钢线、切割线、钢帘线、焊丝、钢管、铝管、不锈钢管等。

Wire and cable, electromagnetic wire, copper wire, aluminum wire, copper clad steel wire, copper clad aluminum wire, steel wire rope, low carbon steel wire, high carbon steel wire, stainless steel wire, nickel wire, chromium wire, molybdenum wire, tungsten wire, copper clad steel wire, cutting wire, steel curtain wire, welding wire, copper pipe, aluminum pipe, stainless steel pipe, etc.



生产现场



黄铜扁线



异形黄铜棒



异形铜管



紫铜扁线



电磁线



六角扳手



不锈钢异形线材

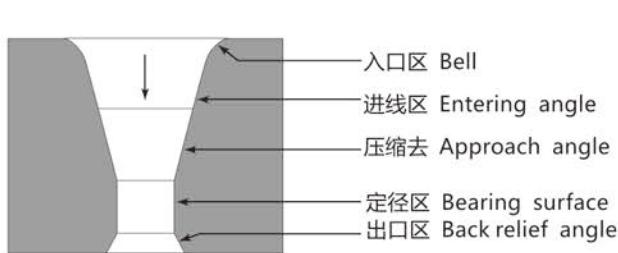
钨钢拉丝、拉管模具 >> TUNGSTEN CARBIDE WIRE/DRAWING DIES

产品简介 Product Brief

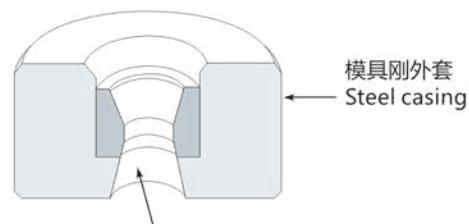
钨钢拉丝模具选用台湾春保森拉天时、株洲钻石牌、九江金鹭硬质合金材料制作，具有韧性好、耐磨性强，光洁度高，精度高、使用寿命长等优点，广泛应用于有色金属和黑色金属的拉制，我司可以根据线材、管材种类和进线尺寸设计合理的压缩区角度和定径区长度，这样可以减少拉拔力和摩擦力，使模具磨损均匀、变形稳定，增加使用寿命，模具内径生产范围0.25-700mm。

Tungsten carbide wire drawing die choose Taiwan CB-CERATIZIT, zhuzhou diamond, Jiujiang Jinlu useful carbide materials, has good toughness, wear resistance, high degree of finish, high precision, long life and other advantages, is widely used in non-ferrous metal and black metal drawing, we can according to the wire, pipe type and into the line size design reasonable compression area Angle and sizing area length, so that we can reduce the drawing force and friction force, make the dies wear uniform, deformation stability, increase the service life, dies inner diameter production range of 0.25-700 - mm.

参数信息 : Data Info



钨钢拉丝模具结构
Die for Round Drawing



钨钢模芯镶嵌
Tungsten-carbide insert (nib)



钨钢拉丝模具



硬质合金拉丝模具



钨钢拔棒模具

参数信息 : Data Info

YHMJ-1钨钢圆形拉丝模具规格对照表 (单位mm) Tungsten Carbide Wire Drawing Die Size Form				
编号 No	内孔尺寸 Core Diameter	模芯尺寸 Carbide Size	外套尺寸 Case Size	公差 Tolerance
YG-0860	0.3-1.0	8x6	25x11	±0.003
YG-1310	0.3-2.5	13x10	30x16	±0.003
YG-1614	0.5-3.0	16x14	40x27	±0.005
YG-1815	1.2-5.0	18x15	40x27	±0.005
YG-2017	2.3-6.0	20x17	40x28	±0.005
YG-2218	2.5-6.0	22x18	45x30	±0.005
YG-2518	2.3-7.0	25x18	50x30	±0.005
YG-2820	7.01-9.0	28x20	60x35	±0.005
YG-3021	9.01-10.0	30x21	60x35	±0.005
YG-3522	10.01-13.0	35x22	70x35	±0.005
YG-4025	13.01-16.0	40x25	80x42	±0.005
YG-4525	16.01-20.0	45x24	90x42	±0.005
YG-5028	20.01-25.0	50x28	100x50	±0.005
YG-5530	25.01-27.0	55x30	110x53	±0.005
YG-6035	27.01-30.0	60x35	120x60	±0.005

可根据客户要求订做模具规格尺寸 The Size Can Be Designed By Customer

产品图片 : PRODUCT PICTURE



钢绞线拉丝模具

钨钢拉丝、拉管模具 >>> TUNGSTEN CARBIDE WIRE/DRAWING DIES

参数信息 : Data Info

序号 No	牌号 Equivalent grade	ISO Grade	含钨量 WC%	含钴量 Co %	硬度 Hardness(HRA±0.5)	密度 Density	抗弯强度 TRS/Mps/Min	特性与适用范围 Characteristics and Application
1	YG3	K01	97	3	91.5	15.2	1500	适用于低应力状态下，直径小于6毫米的钢丝、有色金属和合金线材或材料。 It is suitable for steel wire, non-ferrous metal and alloy wire rod or material with a diameter of less than 6 mm under the condition of low stress.
2	YG3X	K01	97	3	92.5	15.2	1450	硬度高，耐磨性好，冲击小，冲击小。适用于细钢丝、有色金属线材。 High hardness, good wear resistance, low impact and low impact. It is suitable for fine steel wire, non-ferrous metal and alloy wire .
3	YG6	K10	94	6	90.5	14.95	2600	用于有色金属的粗加工。 used for rough machining of non-ferrous metals.
4	YG6X	K15	94	6	91.5	14.85	2700	细粒尺寸，适用于有色金属精加工和木工切削加工。 The fine grain size,suitable for processing of non ferrous metal finishing and woodworking cutting tooling
5	YG6A	K10	94	6	92	14.95	2450	适用于拉丝模和木工刀具。 suitable for wire drawing die and woodworking cutting tools
6	YG8	K30	92	8	89.5	14.7	2700	适用于拉丝模、拉丝模 suitable for wire drawing die,drawing die
7	YG11	K40	89	11	88.5	14.45	2900	适用于佩戴零件和采矿工具 suitable for wearing parts and mining tools
8	YG15	G30	86.5	13.5	87	14.0	2280	强度最佳，耐磨性低，适用于冲击回转凿岩机和重岩钻机、岩石坚硬岩层。 The strength is the best, the wear resistance is low, it is suitable for impact rotary rock drill and heavy rock drill, rock hard rock layer.
9	GK05		96	4	92	15	2720	耐磨性好，硬度高。适用于钢绳、高碳钢、有色金属的干拉和CVD基体。 Good wear resistance and high hardness.Suitable for dry drawing and CVD matrix of steel cord, high carbon steel and nonferrous metals.
10	GK05A		96	4	92.5	14.8	2450	耐磨性好，强度高。适合钢绳。 Good wear resistance, high strength.Suitable for steel cord.
11	GK30H		94	6	89	14.7	2400	耐磨性好硬度较高适用于棒材、管材、大尺寸型材的冷拔 Good abrasion resistance and hardness are suitable for cold drawing of bar, pipe and large size profile
12	GU10		97	3	93	14.8	2700	硬度高，耐磨性好。适用于高碳钢、焊丝、高碳钢的干拔 High hardness and good wear resistance.Suitable for dry drawing of high carbon steel, welding wire, high carbon steel
13	GU20		95	5	91.5	14.3	3500	硬度高，耐磨性好。适用于高碳钢、焊丝、有色金属的干拔。 High hardness and good wear resistance.Suitable for dry drawing of high carbon steel, welding wire and non-ferrous metal.

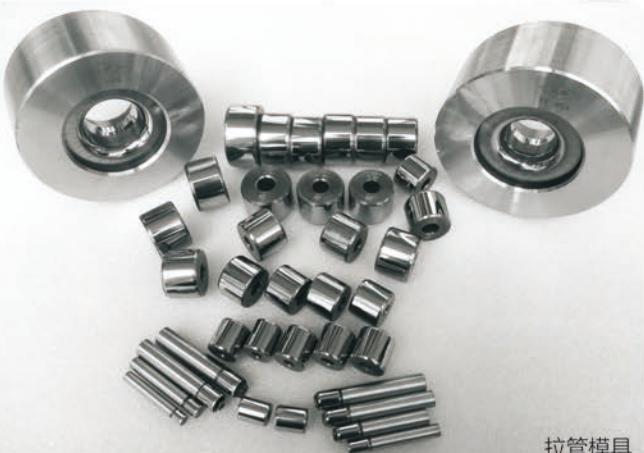
产品图片：PRODUCT PICTURE



钨钢拉管模具



硬质合金拉管模具



拉管模具

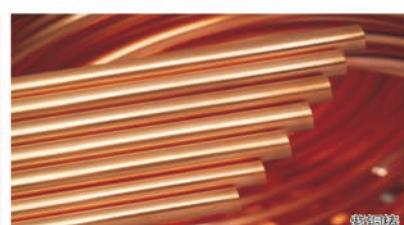
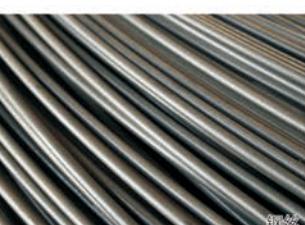


拉管内模、芯头

应用领域：Application Fields

钢丝绳、钢绞线、低碳钢线、高碳钢线、不锈钢线、切割线、钢帘线、焊丝、铜丝、铝丝、铁管、钢管、铝管、不锈钢管等。

Steel wire rope, twisted wire, low carbon steel wire, high carbon steel wire, stainless steel wire, cutting wire, steel curtain wire, welding wire, copper wire, aluminum wire, iron pipe, copper pipe, aluminum pipe, stainless steel pipe, etc.



钨钢异形拉丝模具 >>> TUNGSTEN CARBIDE SHAPED WIRE DRAWING DIES

产品简介 Product Brief

钨钢异形拉丝模具选用台湾春保森拉天时、株洲钻石牌、九江金鹭硬质合金材料制作，具有韧性好、耐磨性强，光洁度高，精密度高、使用寿命长等优点，广泛应用于有色金属和黑色金属的拉制，我司可以根据线材、管材种类和进线尺寸设计合理的压缩区角度和定径区长度，这样可以减少拉拔力和摩擦力，使模具变形稳定，增加使用寿命。

Tungsten carbide wire drawing dies choose Taiwan CB-CERATIZIT, zhuzhou diamond, Jiujiang Jinlu carbide materials, has good toughness, wear resistance, high degree of finish, high precision, long life and other advantages, is widely used in non-ferrous metal and black metal drawing, we can according to the wire, pipe type and into the line size design reasonable compression area Angle and sizing area length, so that we can reduce the drawing force and friction force, make the mould deformation stability, increase the work life.

参数信息 : Data Info

春保森拉天时硬质合金材质特性表

材质	Wc	Co	粒度	比重	硬度	抗折力	冲击强度
	(±0.5%)	(±0.5%)	(um)	(g/cm ²)	(HRA)	(Kgf/mm ²)	(Kgf-m/cm ²)
KG05	95.5	4.5	0.8-2	15.05	92.5	280	0.20
KG1	94.5	5.5	1-2	15.00	92.0	300	0.26
KG2	93.5	6.5	2-3	14.90	90.5	320	0.28
KG3	91	9.0	2-3	14.61	89.3	340	0.52
KG4	88	12.0	1-2	14.30	89.3	360	0.55
KG5	88	12.0	2-3	14.31	88.3	340	0.58
KG6	86	14.0	2-3	14.12	87.3	320	0.65
KG7	85	15.0	1	13.95	89.5	350	0.70
WF03	95	5.0	≤0.6	14.80	94.0	250	0.20
UF03	94	6.0	≤0.6	14.65	94.5	360	0.20
K100	94	6.0	0.8-1	14.85	92.2	360	0.23
WF05	93	7.0	≤0.6	14.65	93.5	380	0.20
WF08	92	8.0	≤0.6	14.50	94.0	380	0.28



进口钨钢六角模具



钨钢扁线拉丝模



钨钢异形模具

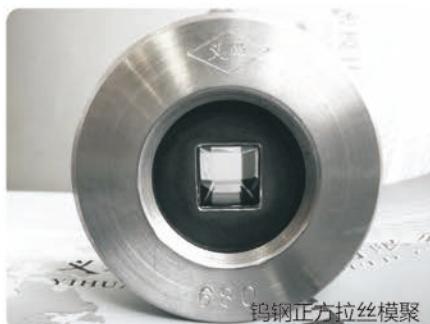


钨钢异形拉丝模具

产品图片：PRODUCT PICTURE



进口钨钢正方模具



钨钢正方拉丝模聚



钨钢异形拉丝模具



钨钢异形拉管模具

应用领域：Application Fields

异形钢材铜排、铝排、电磁线、电线电缆、电车线、不锈钢异形线、六角扳手、钢丝绳、电子线材等行业，适用于拉制正方、扁方、三角、六角、八角、半圆、椭圆、扇形、Z型、瓦型等各种异型金属线材、管材。

Special-shaped steel, copper, aluminum, electromagnetic wire, electric wire and cable, trolley wire, stainless steel special-shaped wire, hexagon wrench, steel wire rope, electronic wire material and other industries, suitable for drawing square, flat square, triangle, hexagon, octagonal, semi-circle, ellipse, fan, Z type, tile type, etc.



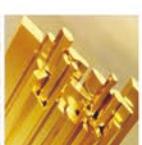
异形钢材



异形钢材



异形黄铜棒



异形黄铜棒



CT电车线



铜排



异形铜材



异形不锈钢管

钢丝绳模具 >>> STEEL WIRE ROPE DIES

产品简介 Product Brief

我司根据钢丝绳的生产工序和使用要求，专门针对于钢丝绳、钢绞线PC螺旋钢棒行业生产的拉丝模具，具有韧性好、耐磨性强，光洁度高，精密度高、使用寿命长等优点，我司可以根据线材进线尺寸设计合理的压缩区角度和定径区长度，这样可以减少拉拔力和摩擦系数，使模具磨损均匀、变形稳定，模具外套选用模具钢热处理冷压镶嵌工艺，这样增强模芯的保护力、提升了模具的抗拉强度，增加使用寿命，可根据客户要求生产Z型、瓦型、扇形等各种异形拉丝模具。

According to the requirements of the steel wire rope production processes and the use of our company, specializing in steel wire, steel strand, PC spiral steel bar in industry production of wire drawing die, has good toughness, wear resistance, high degree of finish, high precision, long life and other advantages, our company can design according to the wire into the line size reasonable compression area Angle and sizing area length, so that we can reduce the drawing force and friction coefficient, the mould wear uniform and stable deformation, dies coat adopts cold pressing mosaic technology of mould steel heat treatment, so as to enhance the core protection and enhance the tensile strength of the mould increase the service life, can according to customer request production of Z type, w type, fan and other special-shaped wire drawing die.

模具材料主要分为以下几类：

Diamond materials are mainly divided into the following two types:

进口聚晶模具：选用美国GE康派克斯（ Compax ）、日本住友（ Sumidia ）、英国戴比尔斯（ De Beers ）。

国产聚晶模具：四方达CD材料、新亚CD材料、西波尔CXD、沃尔克高晶模芯。

钨钢拉丝模具：选用台湾春保森拉天时、株洲钻石牌硬质合金、九江金鹭钨钢材料制作。

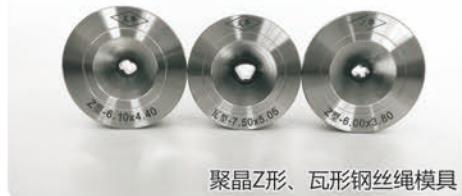
Imported polycrystalline Material: America GE Compax, Japan sumidia, UK De Beers.

Domestic polycrystalline Material : Sifangda CD materials, Xinya CD materials, Supower CXD

Tungsten Carbide Material: Taiwan CB-CERATIZIT, zhuzhou diamond, Jiujiang Jinlu



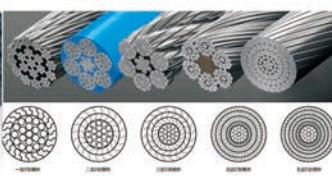
产品图片： PRODUCT PICTURE



应用领域： Application Fields

光面钢丝绳、镀锌钢丝绳、不锈钢钢丝绳、密封钢丝绳、电梯用钢丝绳、航空用钢丝绳、钻深井设备用钢丝绳、架空索道及缆车用钢丝绳、起重用钢丝绳、预应力混凝土用钢绞线、渔业用钢丝绳、矿井提升用钢丝绳、钢绞线、PC钢棒、预应力螺旋钢丝、螺旋肋钢、轮胎用钢帘线、胶带用钢丝绳等。

Smooth steel wire, galvanized steel wire rope, stainless steel wire rope, seal, elevator wire rope, wire rope, wire rope drilling deep well equipment with cable, aerial ropeway and cable car with prestressed concrete with steel strand, the reuse of wire rope, wire rope, fishing wire rope, wire rope for mine use, steel wire, PC steel rod, prestressed spiral steel wire, spiral rib steel, tire wire rope with cord, tape, etc.



纳米金刚石涂层模具 >> NANO-DIAMOND COATING DIES

产品简介 Product Brief

纳米金刚石涂层模具：是以硬质合金（WC-Co）为衬底，采用化学气相沉积法（CVD）在模具的内孔表面生长一层金刚石薄膜，并对金刚石涂层进行精密研磨抛光后得到全新模具，产品具有硬质合金模具的韧性，又有天然金刚石的硬度及耐磨性，内孔光亮、摩擦系数低，使用寿命长等优点。模具内径生产范围0.9-50mm。

Nano diamond coating dies: based on tungsten carbide (WC - Co) as the substrate, by using chemical vapor deposition (CVD) in the dies of the inner hole surface a layer of diamond film growth, and precision grinding and polishing of diamond coating after get the new dies, product has cemented carbide dies toughness, and hardness and wear resistance of natural diamond, inner hole light, low friction coefficient, long life and other advantages. The mold inner diameter production range is 0.9-50mm.

工艺与技术: Process and Technology

有针对性的前处理工艺：使涂层与基体紧密结合

底层微米级金刚石涂层：极佳的耐磨性

表层纳米级金刚石涂层：优秀的表面光洁度和低摩擦系数

计算机模拟优化孔型设计：使线材受力均匀

Targeted pretreatment process: to make the coating and substrate close together

Bottom micron diamond coating: excellent wear resistance

Surface nano-coating: excellent surface finish and low friction coefficient

Computer simulation optimization pore design: to make the wire uniform force

纳米金刚石涂层模具优点：Advantages of nano diamond coating die:

1、使用寿命长：拉铜铝丝、低碳钢丝、中碳钢丝、电缆绞线、焊丝、模具使用寿命是硬质合金模具的20-30倍以上，电缆绞线是硬质合金的50倍以上。

2、尺寸控制精度高，线材尺寸稳定，可长期保持尺寸的一致性。

3、模具内孔光亮、自润滑性好、表面摩擦系数小，生产的线材表面光洁度高，不粘料，成品线材品质好，同时可以降低设备设备损耗。

4、节约原材料，生产的金属丝长度比传统模具生产的长1%-2%。

5、免修模式，免维护，减少停机检测、换模的次数、大幅提高生产效率，单位时间产量明显增加，节约大量人工成本。

6、适用于无酸洗拉拔工艺，环保，节能。

Long service life: the service life of copper wire, aluminum wire, low carbon steel wire, medium carbon steel wire, cable capstan wire, welding wire and mould is 20-30 times higher than that of hard alloy mould, and the cable capstan wire is more than 50 times of hard alloy.

High precision in size control, stable dimension of wire, and consistent dimension for a long time.

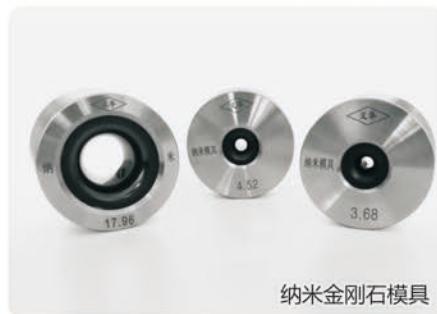
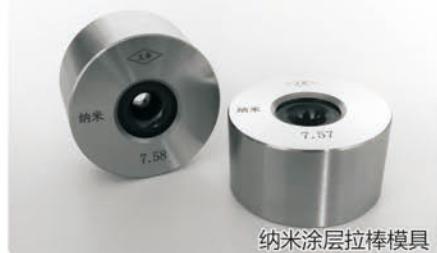
The inner hole of the mould is bright, the self-lubricating property is good, the surface friction coefficient is small, the surface of the wire material produced is smooth, non-sticky, the finished wire material is of good quality, and the loss of equipment and equipment can be reduced at the same time.

Save raw materials, and the length of wire produced is 1-2% longer than that produced by traditional mould.

No-repair mode, no maintenance, reduce the number of downtime detection and mold change, greatly improve the production efficiency, significantly increase the output per unit time, and save a lot of labor costs.

Suitable for pickling and drawing process without acid, environmental protection and energy saving.

产品图片: PRODUCT PICTURE



应用领域: Application Fields

铜丝、铝丝、电线电缆、不锈钢焊丝、中、低碳钢焊丝、不锈钢线、低碳钢线、钢管、铝管、不锈钢管等。

Copper wire, aluminum wire, wire and cable, stainless steel wire, medium and low carbon steel wire, stainless steel wire, low carbon steel wire, copper tube, aluminum tube, stainless steel pipe, etc.



电缆模具 CABLE DIES >>>

产品简介 Product Brief

我司根据电线、电缆的生产工序和使用要求，专门针对于电线电缆行业生产全套电缆模具、包括：铜丝、铝丝圆形拉丝模具、瓦型、扇形、Z型等异形导体模具、纳米金刚石涂层模具、电缆紧压模具、扇形绞线模具、瓦形绞线模具、电缆挤出模具、成缆模具等。

Our company according to the production process of wire and cable and use requirements, specifically for wire and cable industry production of the cable set, including: copper wire, aluminum wire round wire drawing dies, tile type, fan-shaped, Z shaped dies, nano coating dies, cable conductor press dies, the fan wire dies, tile shape of the winding dies, cable extrusion dies, cabling, etc.

模具材料主要分为以下几类：

Diamond materials are mainly divided into the following two types:

进口聚晶模具：选用美国GE康派克斯（Compax）、日本住友（Sumidia）、英国戴比尔斯（De Beers）。

国产聚晶模具：四方达CD材料、新亚CD材料、西波尔CXD、沃尔克高晶模芯。

纳米金刚石涂层模具：是以硬质合金（WC-Co）为衬底，采用化学气相沉积法（CVD）在模具的内孔表面生长一层金刚石，并对金刚石涂层进行精密研磨抛光后得到全新模具，模具具有硬质合金模具的韧性，又有天然金刚石的硬度及耐磨性，内孔光亮、摩擦系数低，使用寿命长等优点。

钨钢模具：选用台湾春保森拉天时钨钢、株洲钻石牌硬质合金、九江金鹭钨钢材料制作。

Imported polycrystalline diamond : America GE Compax, Japan sumidia, UK De Beers.

Domestic polycrystalline diamond: Sifangda CD materials, Xinya CD materials, Supower CXD, volcker high crystal.

Nano-coating dies: based on tungsten carbide (WC-Co) as the substrate, by using chemical vapor deposition (CVD) growth in the dies of the inner hole surface a layer of diamond and diamond coating on precision grinding and polishing after get the new dies, nano coating dies toughness, and hardness and wear resistance of natural diamond, inner hole light, low friction coefficient, long life and other advantages.

Tungsten Carbide Material:Taiwan CB-CERATIZIT, zhuzhou diamond, Jiujiang Jinlu



电缆拉丝模具

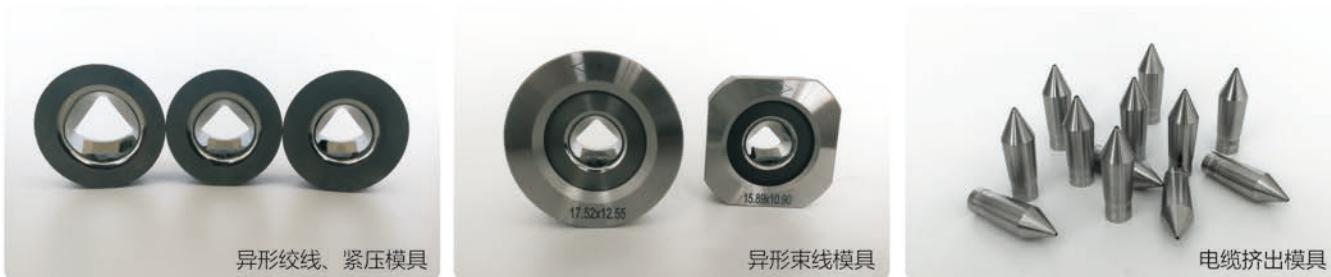
瓦形、Z形导体拉丝模具

纳米涂层、钨钢、聚晶绞线模具

产品图片：PRODUCT PICTURE



纳米涂层、钨钢拉丝模



应用领域：Application Fields

低压电缆、高压电缆、交联线电缆、铠装电缆、铝合金电缆、架空电缆、控制电缆等电线电缆。

Low voltage cable, high voltage cable, sheath cable, armored cable, aluminum cable, overhead cable, control cable, etc.



螺丝模具 >> PUNCH SCREW DIES

产品简介 Product Brief



螺丝模具主要包括主模、预冲模、头冲模、成型模具、切料模具、切刀、螺母模具、六瓣组合模具、多工位模具、六角冲光模具、六角切边模、模壳、顶针等；选用台湾春保、株洲钻石、自贡长城耐冲击硬质合金材料制作，具有高抗击韧性及抗疲劳强度、不易崩缺，不易断裂，耐磨性强、不易磨损，精密度高、稳定性强、使用寿命长等特点。

The screw dies mainly include : predie, head die, forming die, cutting die, cutting tool, nut die, six-disc combination die, multi-position die, hexagon blanking die, hexagon trimming die, die shell and thimble, etc. Made of Taiwan Chunbao, Zhuzhou diamond and Zigong Great Wall shock resistant hard alloy materials, it has high resistance toughness, fatigue strength, not easy to break, not easy to break, wear resistance, high precision, stability and long work life.

参数信息 : Data Info

春保森拉天时冷镦模具材料性能及用途介绍
Properties and Uses Of CB-CERATIZIT Cold Upsetting Die Materials

材质名称 Material	Co(±0.5%)	粒度(um)	比重 (g/cm ³)	硬度(HRA)	抗折力(kgf/mm ²)	用途 Appliaction
KG5	12	2-3	14.31	88.3	340	高韧性冷锻模 High toughness cold forging die
KG6	14	2-3	14.12	87.3	320	高韧性冷锻模 High toughness cold forging die
ST6	15	3-6	13.8	86	270	孔径Ø 2.1以下不锈钢螺丝模 Aperture Ø 2.1 the following mode of stainless steel screws
ST7	20	2-6	13.4	85.3	270	孔径Ø 2.1以下不锈钢螺丝模 Aperture Ø 2.1 the following mode of stainless steel screws
EA65	18	2-6	13.75	85	300	孔径Ø 20螺丝模 Aperture Ø 20 screw mold
EA90	24	2-6	13.22	82.8	270	孔径Ø 20-Ø 50螺丝模 Aperture Ø 20-50 Ø screw mold
VA80	20	3-6	13.58	84	280	高耐冲击锻造模 High impact forging die
VA90	22	6-9	13.39	82.5	240	高耐冲击锻造模 High impact forging die
VA95	25	6-9	13.12	81.5	20	高耐冲击锻造模 High impact forging die

产品图片：PRODUCT PICTURE



应用领域：Application Fields

用于生产高强度螺栓、螺母、汽车螺栓、膨胀螺丝、内六角螺丝、外六角螺丝等。

Used for producing high strength bolts, nuts, bolts, expansion screws, hexagon screws, hexagon screws, etc.



螺丝



T型螺丝



螺母



不锈钢螺丝



不锈钢螺丝



膨胀螺丝

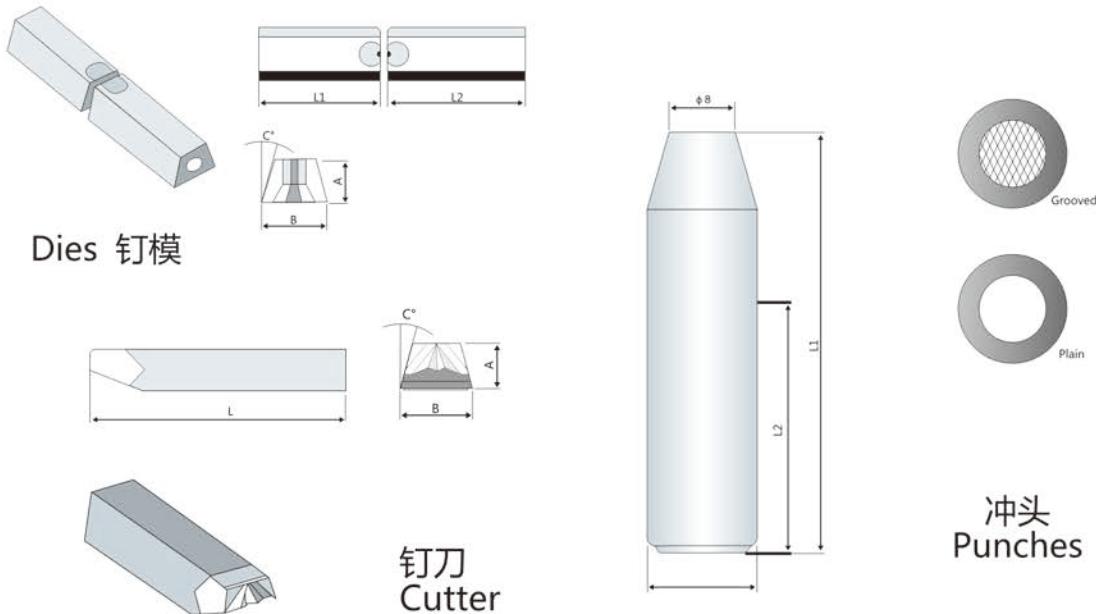
制钉模具 NAIL DIES >>>

产品简介 Product Brief

制钉模具主要包括钉模、钉刀、冲头，可根据要求生产711、712、713、714、715、716等全套制钉模具，模具材料选用台湾春保、株洲钻石牌、自贡长城耐冲击硬质合金材料制作，具有高抗击韧性及抗疲劳强度、不易崩缺，不易断裂，耐磨性强、不易磨损，精度高、稳定性强、使用寿命长等特点。

Nail dies including :mold, screw knife, punch, can according to the requirements can produce 711, 712, 713, 714, 715, 716, such, as full bearing pin dies, dies material selection of Taiwan's spring zhuzhou diamond, zigong Great Wall impact resistance carbide materials, with high combat toughness and fatigue resistance, not easy to collapse, not easy to break, resistance to wear, not easy to wear and high precision, strong stability, long work life, etc.

参数信息 : Data Info



产品图片：PRODUCT PICTURE



钉刀



钉刀



瓦楞钉螺旋模具



螺旋钉模具

应用领域：Application Fields

圆钉、水泥钉、射钉、普通铁钉、瓦楞钉、螺纹钉、麻花钉、干壁钉、油毡钉、地板钉、鞋钉等。

Round nail, cement nail, shot nail, ordinary iron nail, corrugated nail, screw nail, hemp nail, dry wall nail, felt nail, floor nail, shoe nail, etc.



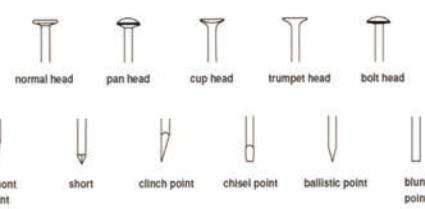
普通钉



水泥钉



钢钉



钢钉



麻花钉



瓦楞钉



钨钢拉伸模具 >>>

TUNGSTEN CARBIDE STRETCH DIES

产品简介 Product Brief

钨钢拉伸模选用台湾春保、株洲钻石牌超耐磨硬质合金材料精加工制作，使产品具有硬度高、耐磨性强、韧性好、内孔光洁度高、拉伸的产品表面光亮、摩擦系数低、使用寿命长等特点，广泛应用于铜、铁、铝、不锈钢等各种金属产品的拉伸成型。

拉伸就是用冲压，拉环或金属模的工艺把板型金属材料变形为圆柱体或者盒子形状的零件。深拉通常在双动压机的防皱压板上进行，防皱压板可以有效防止凸起的边缘在被拉进钢模时起皱。

拉伸技术在生产过程中应用非常广泛。拉深应用于很多行业。例如，可以用在汽车行业中生产汽车零件；还可以用来制造家用产品，例如不锈钢餐具。

Tungsten carbide tensile mould choose Taiwan Chunbao, Zhuzhou diamond super wear-resistant tungsten carbide material finishing production, make the products with high hardness and wear resistance, good toughness, high inner hole finish, stretching products surface brightness, low coefficient of friction, long life and other characteristics, widely used in copper, iron, aluminum, stainless steel and other metal products stretch forming.

Stretching is the process of forming sheet metal material into cylinder or box shape by stamping, drawing ring or metal mould. Deep drawing is usually carried out on the anti-wrinkle press of the double-acting press, which can effectively prevent the raised edge from wrinkling when being pulled into the steel mould.

Deep drawing technology is widely used in the production process. Deep drawing is used in many industries. For example, it can be used in the automobile industry to produce automobile parts. It can also be used to make household products, such as stainless steel tableware.

参数信息 : Data Info

硬质合金拉伸模具材料性能及用途介绍
Properties And Usage Of Hard Alloy Tensile Mould Materials Are Introduced

牌号	密度g/cm ³	硬度HRA	抗弯强度 TRS	推荐应用领域Recommended applications
MD05	14.8	93	2800	硬度高，耐磨性好，是硬粉末压制适合的阴模材料、但只适于壁厚大，形成区形状简单的阴模。 High hardness and good abrasion resistance, it is a kind of vulva material suitable for hard powder pressing, but it is only suitable for large wall thickness and simple shape
MD10	14.5	91.5	3400	具有较高的硬度和强度，适用于硬粉末的压制成型模具。 With high hardness and strength, it is suitable for pressing and forming die of hard powder.
MD20	14.2	90	3800	具有高强度和高硬度，适合压制压力高或形状较复杂压的压制成型模具 High strength and hardness, suitable for pressing high pressure or more complex shape of pressing mold
MD30	14.6	90.5	3000	有较好的综合性，可作为一般的粉末压制成型模具 Has a good comprehensive, can be used as a general powder press molding tool
MD36	13.8	89	3600	强韧性和高耐磨可用于形状复杂或压制压力较大的粉末压制成型模具 Strong toughness and high abrasion resistance can be used in powder pressing moulds with complex shape or high pressure
MD40	14.2	88	3200	有较高的强韧性，可用于形状很复杂的模具，如齿轮模具等。 It has high toughness and can be used in complicated mould, such as gear mould.
MD45	14	86.5	3200	

产品图片：PRODUCT PICTURE



应用领域：Application Fields

拉深技术在生产过程中应用非常广泛。拉深应用于很多行业。例如，可以用在汽车行业中生产汽车零件；还可以用来制造家用产品，例如不锈钢餐具。

汽车配件、摩托车配件、机械配件、电机外壳、万向轮支架、灭火器外壳、轴承外壳、锁壳、电脑、手机配件、不锈钢餐具、化妆品外壳等。

Deep drawing technology is widely used in the production process. Deep drawing is used in many industries. For example, it can be used in the automobile industry to produce automobile parts. It can also be used to make household products, such as stainless steel tableware.

Auto parts, motorcycle parts, mechanical parts, motor housing, universal wheel support, fire extinguisher housing, bearing housing, lock housing, computer, mobile phone accessories, stainless steel tableware, cosmetic case, etc.



硬质合金配件 >>>

TUNGSTEN CARBIDE PRECISION PARTS

产品简介 Product Brief



硬质合金配件

硬质合金配件主要包括：硬质合金钻套、硬质合金轴套、涂粉模具、钨钢密封环、钨钢喷嘴、机械配件、剥壳轮、调直轮、轧辊、钨钢板材、棒材、刀具、硬质合金球阀球座、钨钢顶针、冲针等。

硬质合金配件具有耐磨性好、导热系数高、摩擦系数低、膨胀系数小、耐酸、耐碱等较稳定的化学性，自润滑性、耐腐蚀性、导热系数高、膨胀系数小等优点。

Tungsten carbide parts mainly include: tungsten carbide drilling sleeve, tungsten carbide axle sleeve, powder coating mould, tungsten carbide seal ring, tungsten carbide nozzle, mechanical parts, shell stripping wheel, straightening wheel, roll, tungsten carbide plate, bar material, cutter, tungsten carbide ball valve base, tungsten carbide thimble, punching needle, etc.

Hard tungsten carbide parts have the advantages of good wear resistance, high thermal conductivity, low friction coefficient, small expansion coefficient, acid resistance and alkali resistance, self-lubricating property, corrosion resistance, high thermal conductivity and small expansion coefficient.

应用领域：Application Fields

广泛应用于机械加工泵、压缩机、离心机、搅拌机、冶金、机械、钢铁、石油化工、建筑、汽车、五金电子等行业。

Widely used in mechanical processing pumps, compressors, centrifuges, agitators, metallurgy, machinery, steel, petrochemical, construction, automotive, hardware electronics and other industries.

产品图片：PRODUCT PICTURE



钨钢钻套



硬质合金轴套



硬质合金轴套



钨钢工件



钨钢喷嘴



钨钢涂粉模具



钨钢钻套



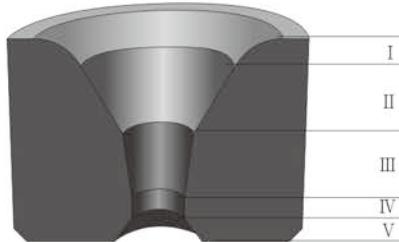
硬质合金密封环



全套引线模具

技术指南 >>>

TECHNICAL GUIDE



I : 入口区：拉拔材料从此处进入模具，一般为圆弧过渡，避免拉拔材料被模具划伤。

II : 润滑区：储存润滑剂、润滑拉拔材料，利于拉制过程的顺利进行。

III : 工作区：是金属拉拔的塑性变形区，工作区的关键尺寸为长度和角度。长度越小，被拉拔的金属对模具的工作区产生压力越大，而使拉应力显著增加，加快模具磨损，影响拉拔效果；工作区的长度随拉拔材料及其直径和润滑情况的不同而不同，其选择原则是：1) 拉制金属线材时，应比拉制硬金属线材短；2) 拉制小直径线材时，应比大直径线材短；3) 湿式润滑拉伸应比干式拉伸短。工作锥角：工作锥角越大拉拔材料的抗拉强度、硬度升高而弯曲、扭转值降低；拉制钢材时工作锥角应较小，而拉制有色金属及其合金时工作角锥则应较大。

IV : 定径区：拉伸材料通过定径区得到最终尺寸，定径区的长度因拉拔材料的硬度、截面大小和润滑情况的不同而不同。若定径区过长，在拉拔过程中会增加摩擦力，使模具温度升高，影响模具寿命，同时也会增加拉应力，拉拔时缩线率、断线率都会增高，电力消耗也增大；若定径区过短，在拉拔时工作锥发生变化时会影响拉制品尺寸；一般拉制软金属材料的较拉制硬金属材料的短，拉制大直径材料的较拉制小直径材料的短，湿式拉伸的较干式拉伸的短。

V : 出口区和出口角锥：出口区是拉拔材料离开模具最后通过的部分，它起到保护定径区不致崩裂的作用，出口区不宜过短，否则模具的出口端容易破裂；出口角是用于保证拉伸金属不致擦伤定径区的出口处而影响线材质量；在模具修整时一定要将出口区和定径区连接部分的尖棱磨去，使其成为圆弧过渡，保证线材通过时不被划伤。

Entrance zone: drawing materials enter the dies through this area. Generally it is an arc in order to avoid drawing materials scratched by the dies.

Lubrication zone: it is for lubricant storage and drawing material lubrication which is conducive to smooth drawing.

Working zone: it is a plastic deformation zone for metal drawing which key dimension is length and angle. Smaller length will make drawing metal cause more pressure to working zone. This will significantly increase the tensile stress and accelerate the wearing of the dies which will influence drawing effect. Working zone length differs in different drawing material, diameter and lubrication. The selection principle is: 1) the length should be shorter in drawing soft metal wire compared to drawing hard metal wire; 2) the length should be shorter in drawing small diameter wire compared to drawing big diameter wire; 3) the length should be shorter in wet drawing compared to dry drawing. Working zone angle: bigger angle will increase the tensile strength and the hardness of drawing material while will decrease the bending and torsion. Working zone angle should be smaller in drawing steel while it should be bigger in drawing non-ferrous metal and carbide.

Cylinder length: drawing material gets its final size through cylinder length. Cylinder length differs in different hardness, section and lubrication of the drawing material. If cylinder length is too big, it will increase the friction which heightens the die temperature and then influences the die life. It will also increase the tensile stress which causes the rising of shrinkage rate and breakage rate in drawing as well as powder consumption; if cylinder length is too short, working cone changes will affect finished size in drawing. Generally 1) cylinder length is shorter in drawing soft metal material compared to drawing hard metal material; 2) cylinder length should be shorter in drawing small diameter wire compared to drawing big diameter wire; 3) cylinder length should be shorter in wet drawing compared to dry drawing.

Outlet zone and outlet angle: outlet zone is the last part where drawing material leaves from the dies. It is to protect the cylinder length from cracking. Outlet zone should not be too short, otherwise the outlet will be easily broken; outlet angle means to ensure that drawing metal will not scratch outlet zone and influence the wire quality; during adjusting the dies the sharp part connecting outlet zone and cylinder length must be ground to be an arc in order to avoid the wire scratched when passing through the dies.



销售网络 SELLING NETWORK



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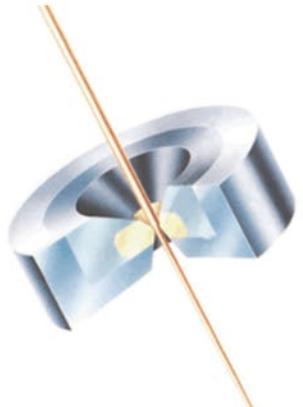
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Products Material:

ND MONO PCD CD Diamond

TC Tungsten Carbide Nano-Coating

Use Field:

- Wire manufacture
- Pipe manufacture
- Tube manufacture
- Cable manufacture
- Jewelry manufacture
- Screw/Bolt/Nut /Nail manufacture

