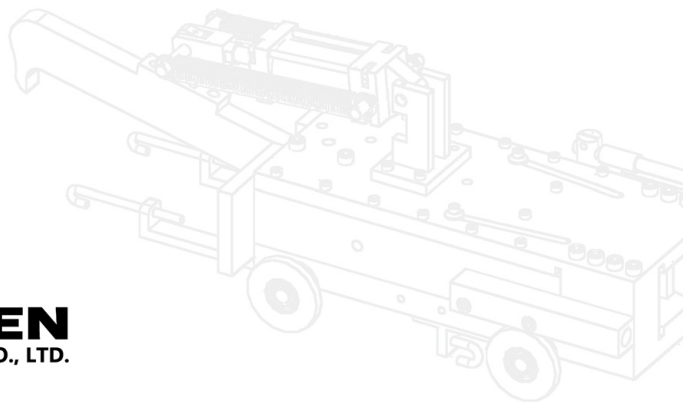
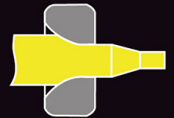


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# Automatic Cold Drawing Machine



**HOREN**  
INDUSTRIAL CO., LTD.

**Automatic Cold Drawing Machine**

- Straightening Machine
- Cold Drawing Machine
- Metal Swaging Machine

**自動金屬伸拉機**

- 矯直機
- 金屬伸拉機
- 金屬束頭機

## Automatic Cold Drawing Machine

# Main Features

- ✓ Fully automated loading and unloading workflow for efficiency
- ✓ PLC control system for easy operation
- ✓ Processes equilateral workpieces with hydraulic push pointer

The Automatic Cold Drawing machine is a chain-type machine which has equipped with a loading machine, feeding machine, hydraulic push pointer, and discharging arms. The HS model series is designed to streamline the cold drawing process by using a hydraulically powered extrusion unit (also known as the push pointer) to clamp the workpiece and push it directly against the drawing die. The drawn materials are then carried using unloading arms to designated collection racks next to the drawbench.

From loading to unloading, this entire process is controlled using a PLC control system, making it very efficient and ideal for automatic bar-to-bar drawing. The head-press mechanism replaces the swaging process that is normally required during traditional cold drawing. Moreover, the fully automated process reduces the need for costly manpower and helps streamline the precision drawing process. The automation from this HS model series is suitable for the drawing of round, hexagonal, and square metal bars.

## 自動金屬冷伸拉機

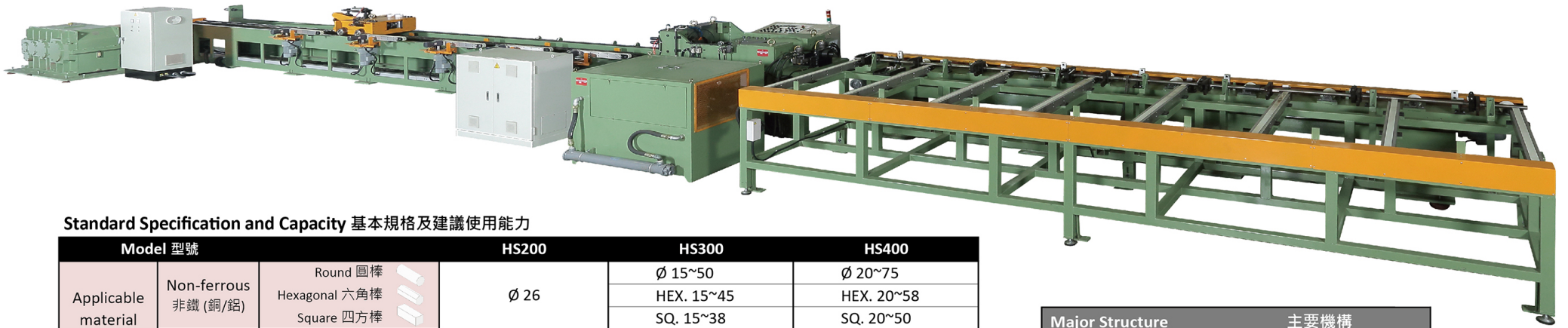
# 3大優點

- ✓ 全自動加工流程提高生產效率
- ✓ PLC控制系統操作簡便，提升人力資源運用
- ✓ 搭配油壓擠頭機，適合於各種異形棒材及等邊材料

HS型鏈條式冷伸拉機在基本款上配有置料機、送料機、油壓擠頭機座及下料臂裝置。主要設計是將材料以自動化方式送入擠頭機座，再藉由機座所產生的液壓力量將金屬棒材推擠進伸拉模具，並透過數控方式使夾車自動感應，進行夾取及拉拔作業。完畢後收料模式則是利用旋轉手臂機組，將材料轉送入定位收料架。

機台運作全程均採用PLC程式控制，優於傳統手動式冷伸拉機，油壓擠頭機座可取代束頭作業，將材料直接送

入伸拉段進行加工。該款機型的設計適用於圓形、六角形及四方形等等邊棒材，在自動模式的操作下，除了可有效提升人力資源的運用及簡化生產流程，手動模式仍可針對異形材料進行加工，其適用性對於棒材加工來說相當多元。



### Standard Specification and Capacity 基本規格及建議使用能力

Model 型號		HS200	HS300	HS400	
Applicable material 適用材質 (mm)	Non-ferrous 非鐵(銅/鋁)	Round 圓棒 Hexagonal 六角棒 Square 四方棒	Ø 26	Ø 15~50 HEX. 15~45 SQ. 15~38	Ø 20~75 HEX. 20~58 SQ. 20~50
	Steel / Alloy 鋼鐵 / 合金材料	Round 圓棒 Hexagonal 六角棒 Square 四方棒	Ø 16	Ø 15~40 HEX. 15~32 SQ. 15~25	Ø 20~50 HEX. 20~45 SQ. 20~38
Motor 馬力		30HP	50HP / 75HP	75HP / 100HP	
Spherical Dice Size 半弧形模具尺寸		JIS 145 / 100	JIS 215	JIS 250 / 230	
Hydraulic Push Pointer 油壓擠頭機		15HP PC28 (H40)	20HP PC60 (H70)	30HP PC100 (H110)	
Average Tensile Strength (Chain) 鏈條平均抗拉強度*		36,000 kgf / 52,000 kgf	52,000 kgf / 97,000 kgf	151,000 kgf / 183,000 kgf	
Optional Model 選配款		HS200P 300F-25RC05/3RC10T	HS300P HS300H 400F-3RC1015T/4RC1530T	HS400P HS400H 600F-6RC1530T/5RC2050T	

※Above specifications and dimensions are subject to updates according to the requirements without prior notice.

以上規格、尺寸因需求變更而有所調整設計，恕不另行通知。

\* The average tensile strength of roller chains is for reference only.

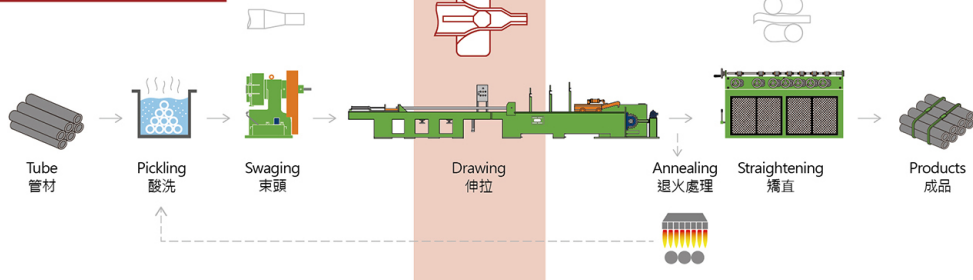
抗拉強度資訊僅供參考，實際強度會依照鏈條材質需求而定。

Major Structure	主要機構
■ PLC system	■ PLC控制系統
■ Inverter	■ 變頻器
■ Hydraulic push pointer	■ 油壓擠頭機座
■ Discharging arms	■ 下料臂機組
■ High strength roller chair	■ 高強度鏈條
■ Power drive system	■ 動力結合機組
Optional	選配項目
■ Automatic loading unit	■ 自動置料機座
■ Automatic feeding unit	■ 自動送料機組
■ Carriage on linear guideway	■ 線型滑軌式夾車
■ Human-machine Interface (HMI)	■ 人機介面

# Production Flowchart 生產流程

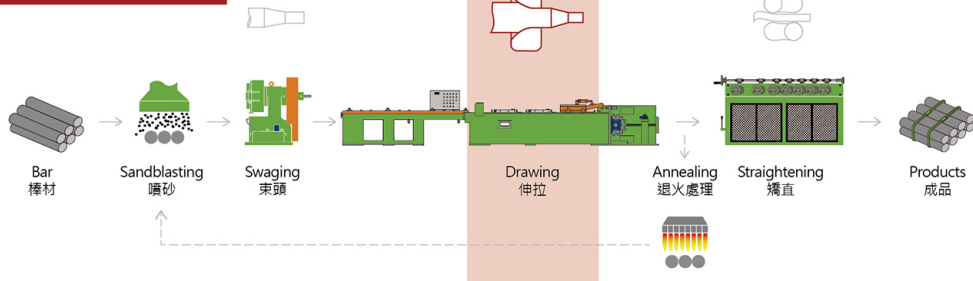
## Tube Drawing Process

### 金屬管材生產



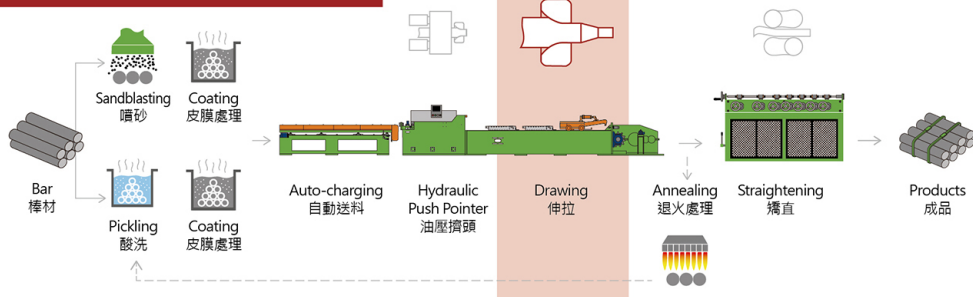
## Bar Drawing Process

### 金屬棒材生產



## Automatic Bar to Bar Drawing Process

### 自動金屬棒材生產



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