

ADH 东海裕祥

折弯机模具



ADH 东海裕祥

中国马鞍山市博望区新市工业区

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CONTACT US

公司简介

ADH 公司成立于2002年, 位于安徽省马鞍山市, 距南京禄口机场仅30公里。我们拥有占地2,000,000平方米的现代化生产基地, 专业制造折弯机、液压剪板机、激光切割机(包括自动化生产单元)、数控转塔冲床、智能柔性折弯中心以及钣金自动化设备。作为一家以研发和创新为核心的领先高新技术制造企业, 我们拥有多项专利和行业认证。

2002

成立时间

6000 +

年产量

120 +

研发人员

100 +

出口国家



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使命

我们致力于研发, 提升产品和服务质量, 打造全球知名的钣金制造机械中心。



愿景

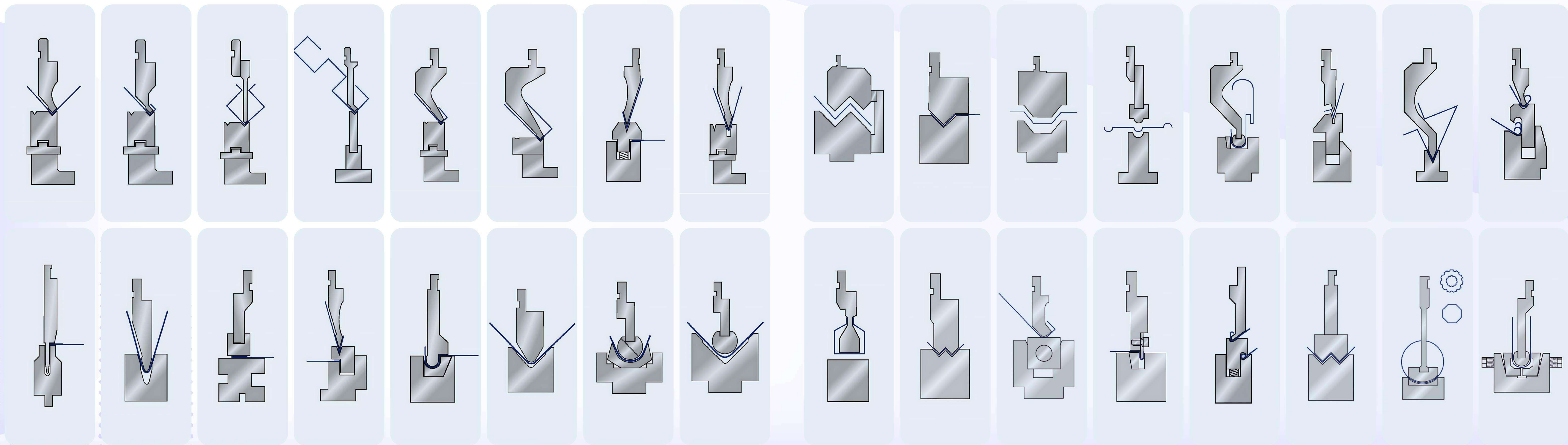
我们的目标是成为备受尊敬的钣金配套服务提供商, 赢得客户的信任和员工的自豪。



价值观

创新、精益制造、诚信、共赢。

折弯机模具



AMADA 折弯机冲头

PUNCH

LS18
26°

A	R	H	T/M
35°	0.8	67.06	50

LS11
35°
45°

A	R	H	T/M
35°	0.8	67.06	50
45°	1	65.05	70

LS20
60°

A	R	H	T/M
60°	0.8	75	70
60°	2	73.8	70

LS10.21
30°

A	R	H	T/M
30°	0.6	140.06	100
30°	3	140.01	100

LS13
35°
60°

A	R	H	T/M
35°	5	65.01	100
60°	6	64.98	100

LS10.53
45°

A	R	H	T/M
45°	6	100	100

LS12
35°

A	R	H	T/M
35°	0.5	90.06	70
35°	0.8	90.05	70
35°	1.5	90.01	70

LS10.52
30°

A	R	H	T/M
30°	0.5	135	50
30°	0.5	135	50

LS10.86
30°

A	R	H	T/M
30°	0.6	140.06	40

LS10.93
60°

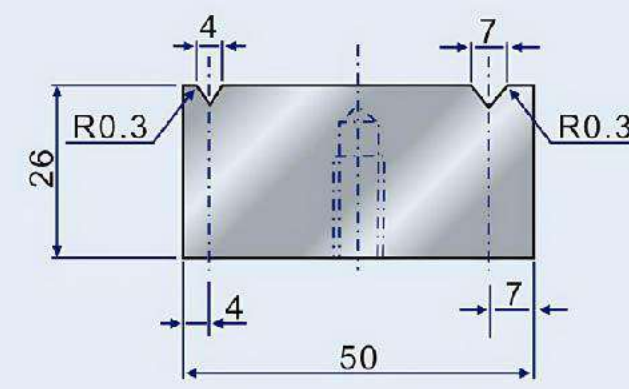
A	R	H	T/M
60°	8	200	150

L=835mm

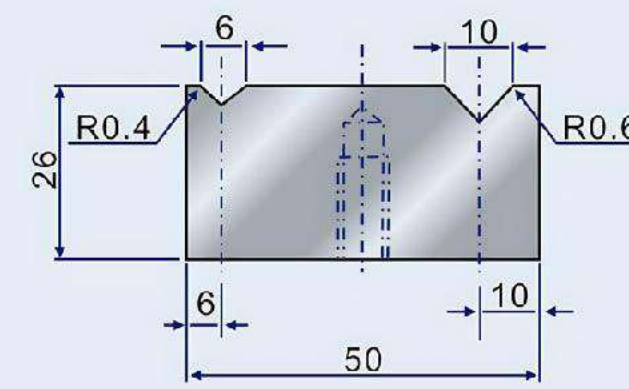
AMADA 折弯机下模

PUNCH

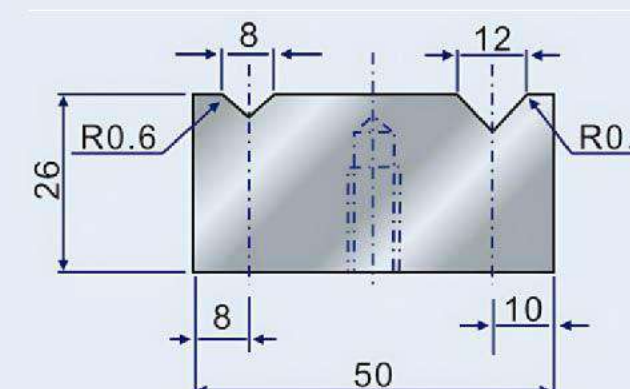
YS101 88° 90°



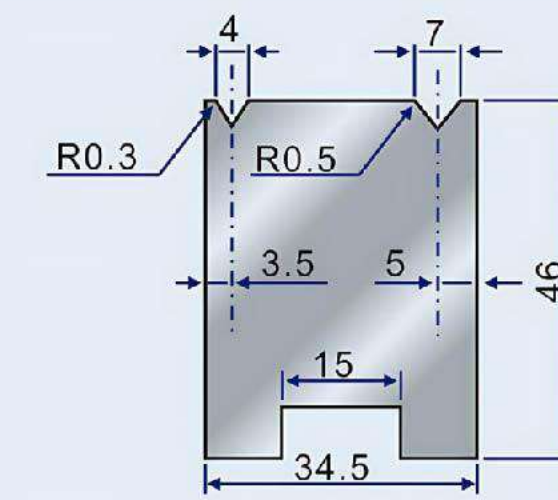
YS123 88° 90°



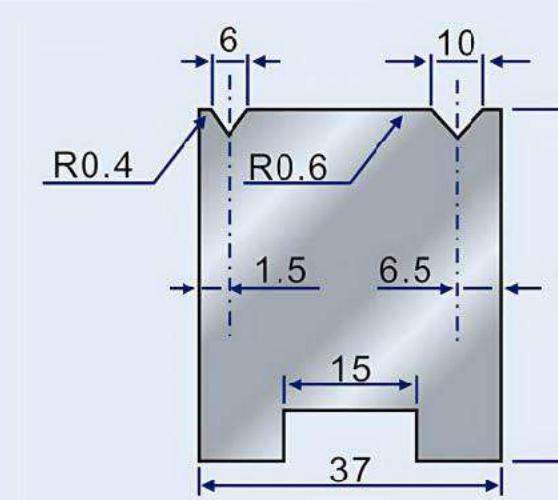
YS124 88° 90°



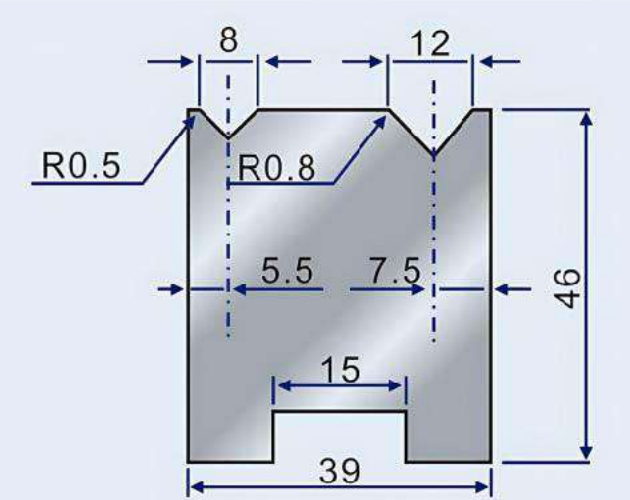
YS501 88° 90°



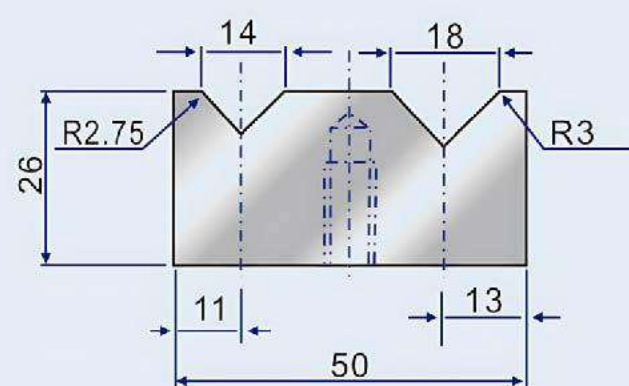
YS502 88° 90°



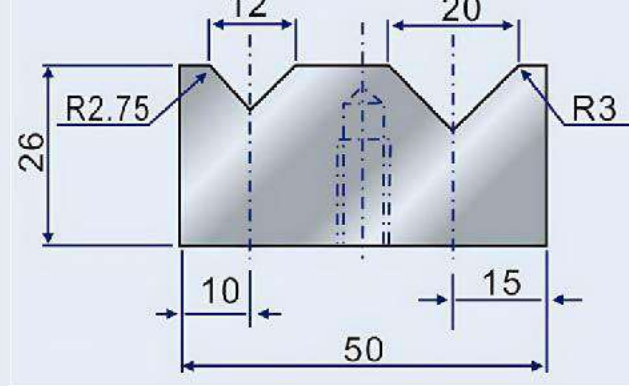
YS503 88° 90°



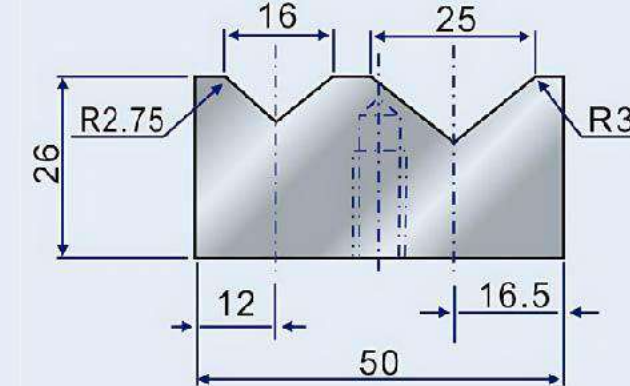
YS125 88° 90°



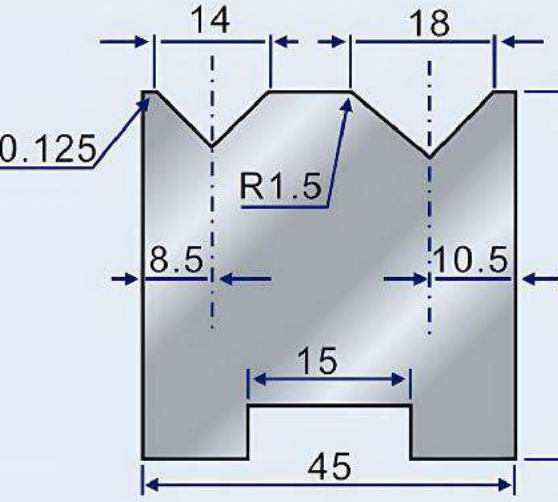
YS126 88° 90°



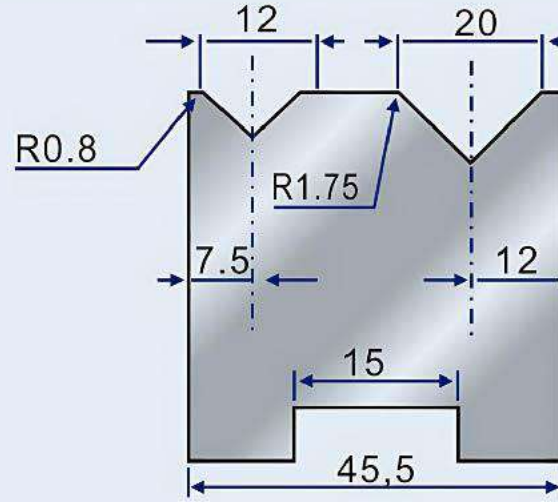
YS127 88° 90°



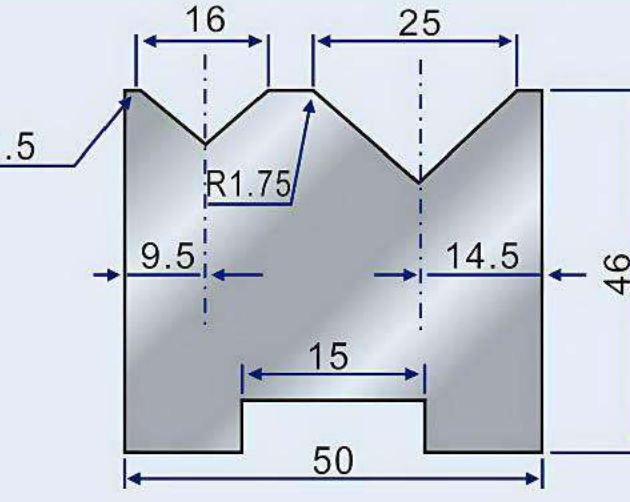
YS504 88° 90°



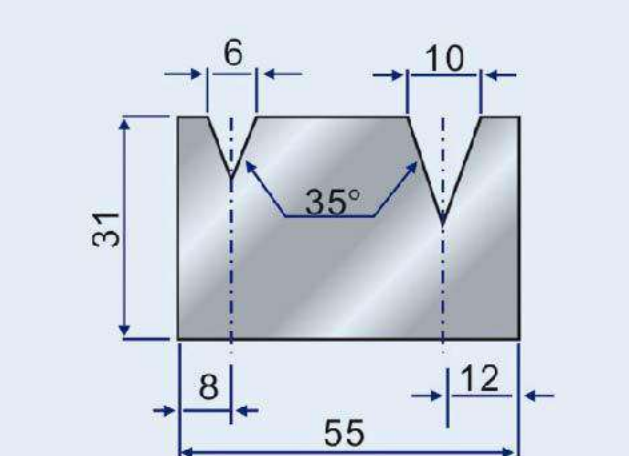
YS505 88° 90°



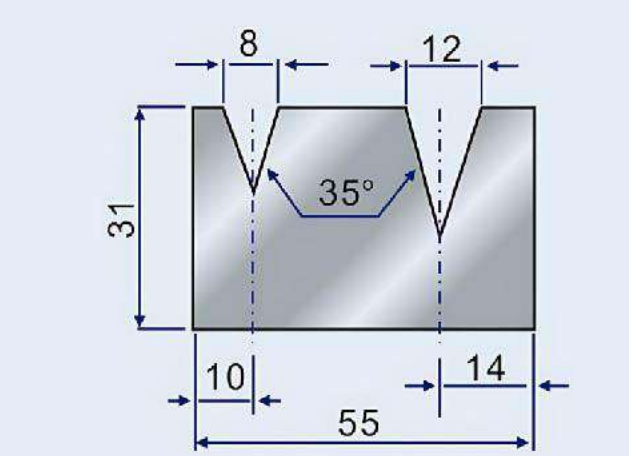
YS506 88° 90°



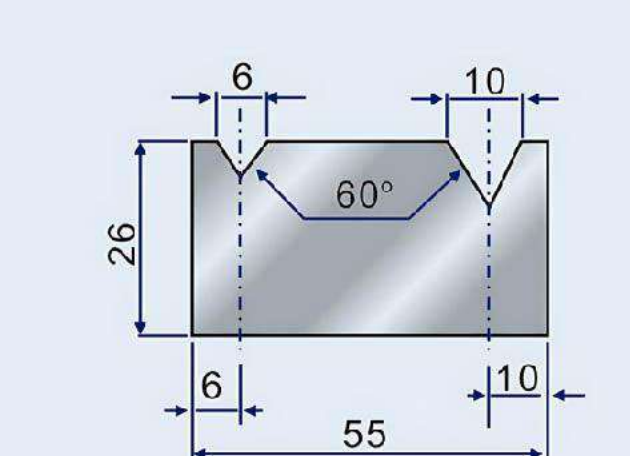
YS20.12 35°



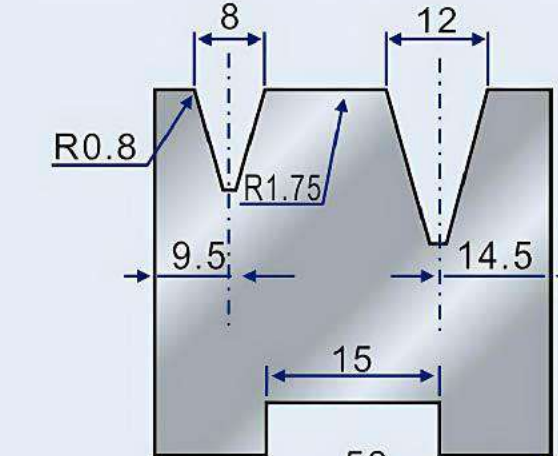
YS20.13 35°



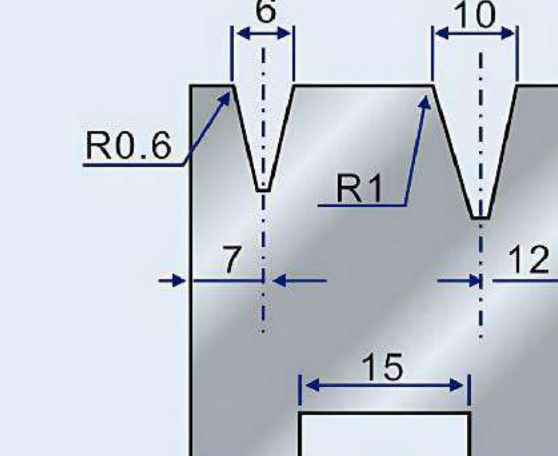
YS20.12 60°



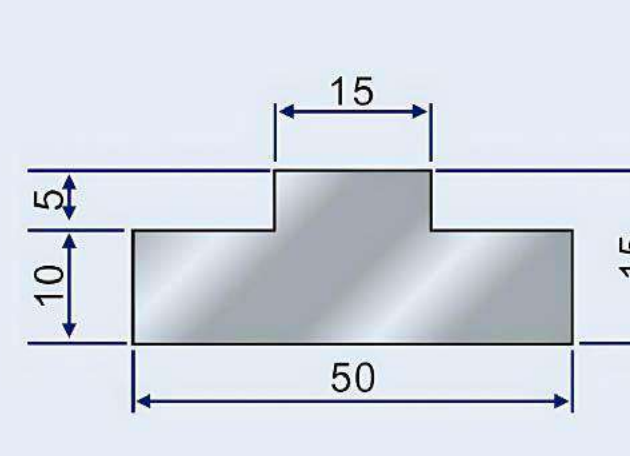
YS507 30°



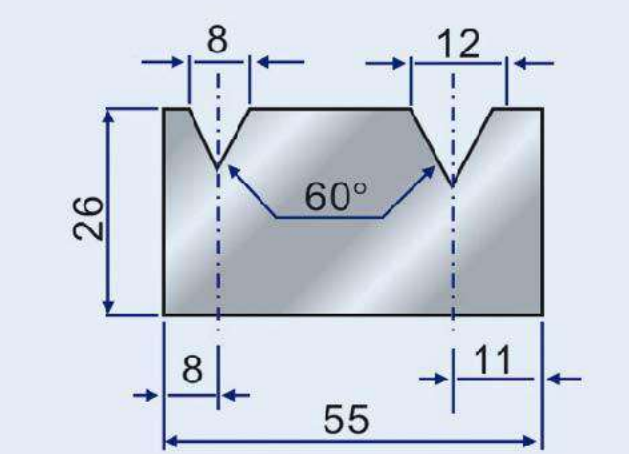
YS508 30°



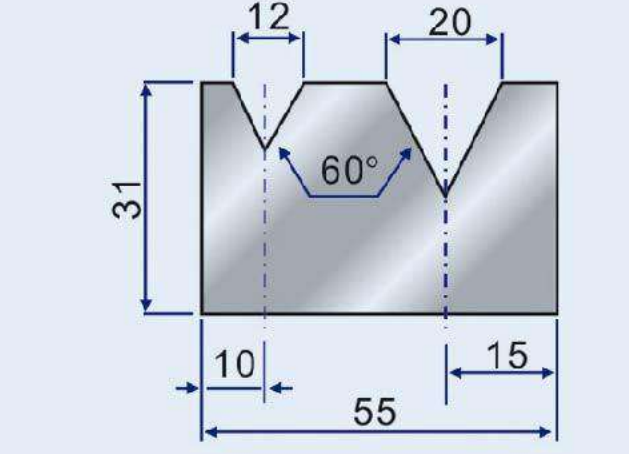
YS40.15



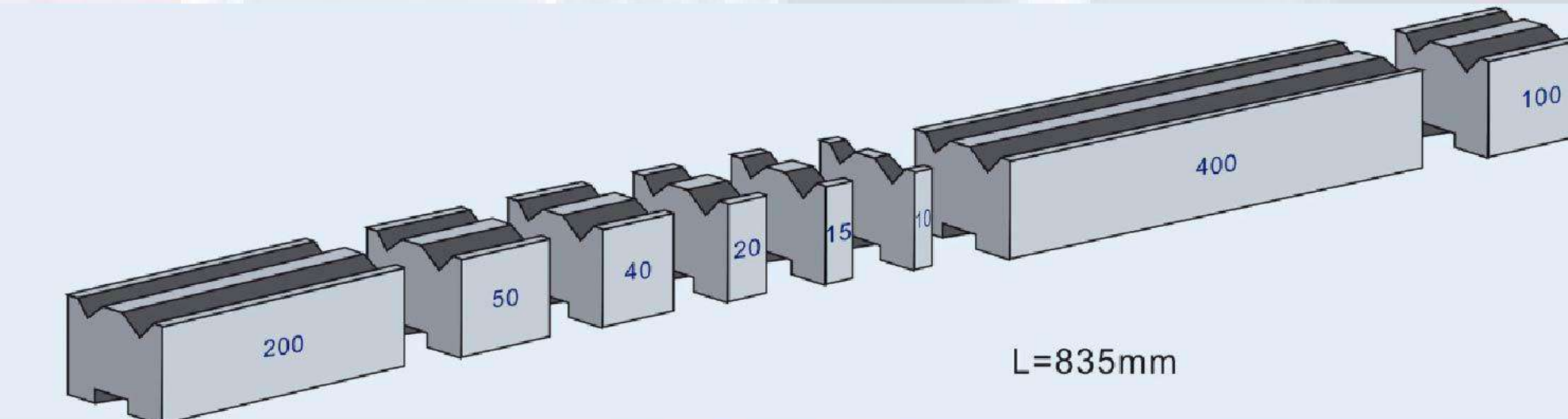
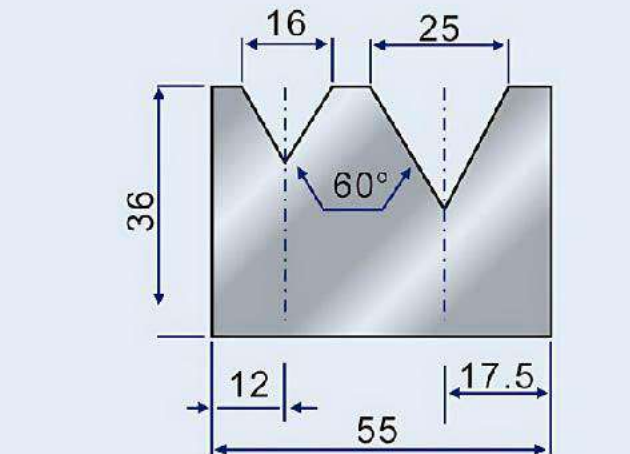
YS20.13 60°



YS20.14 60°

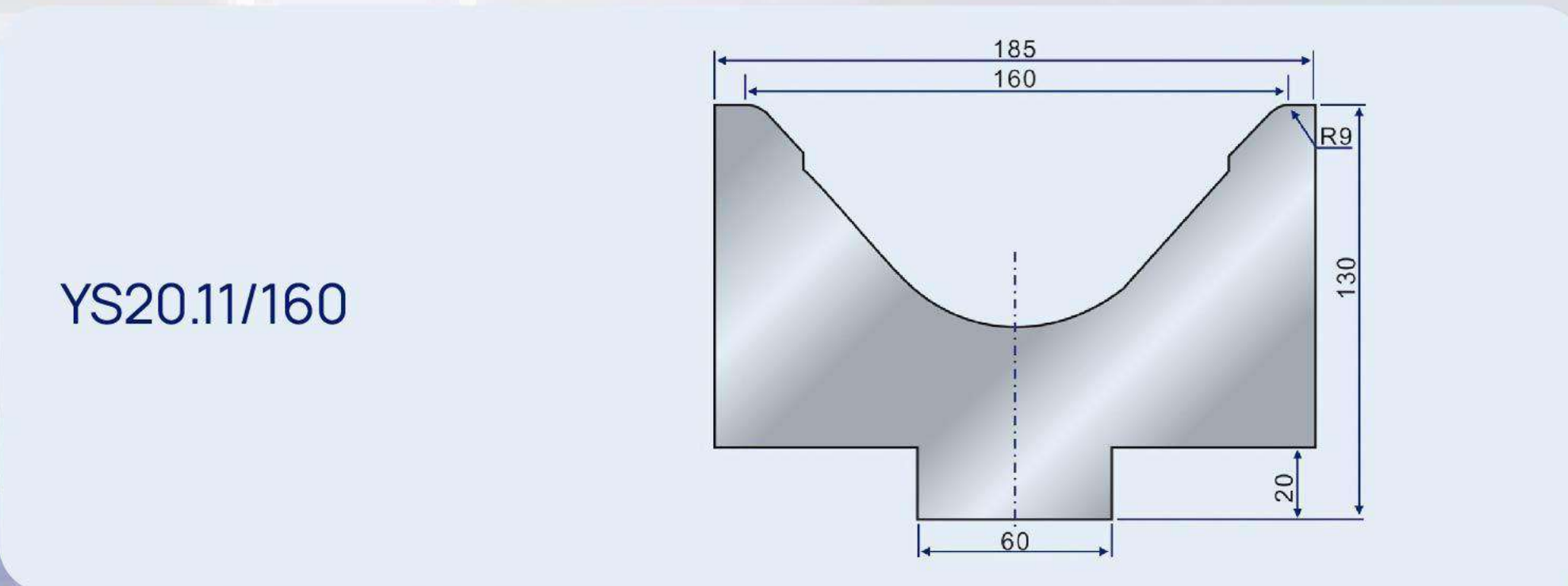
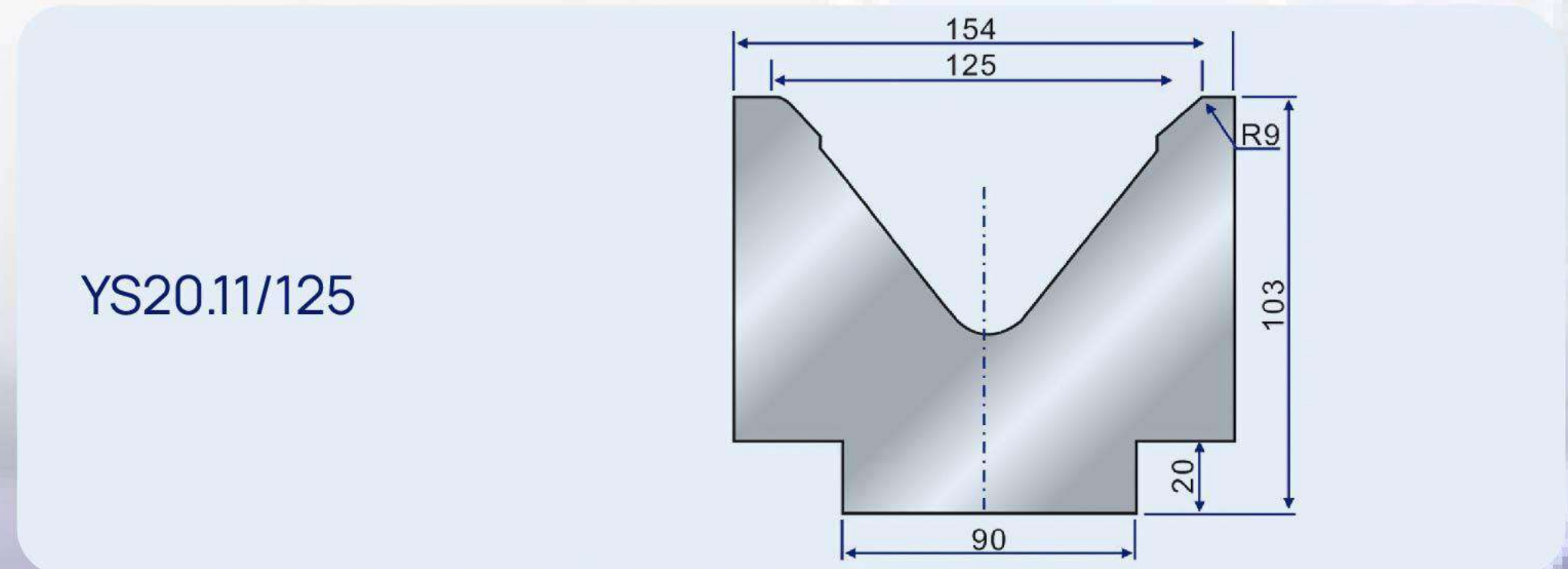
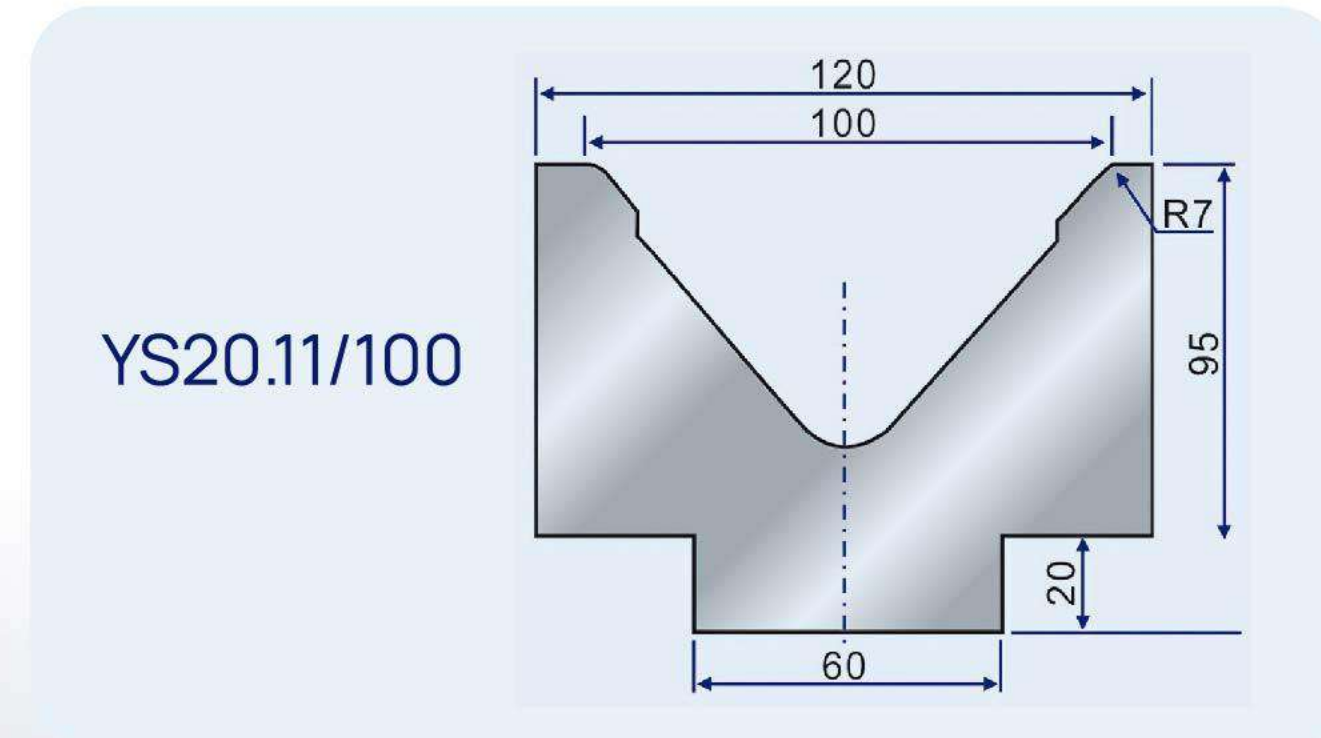
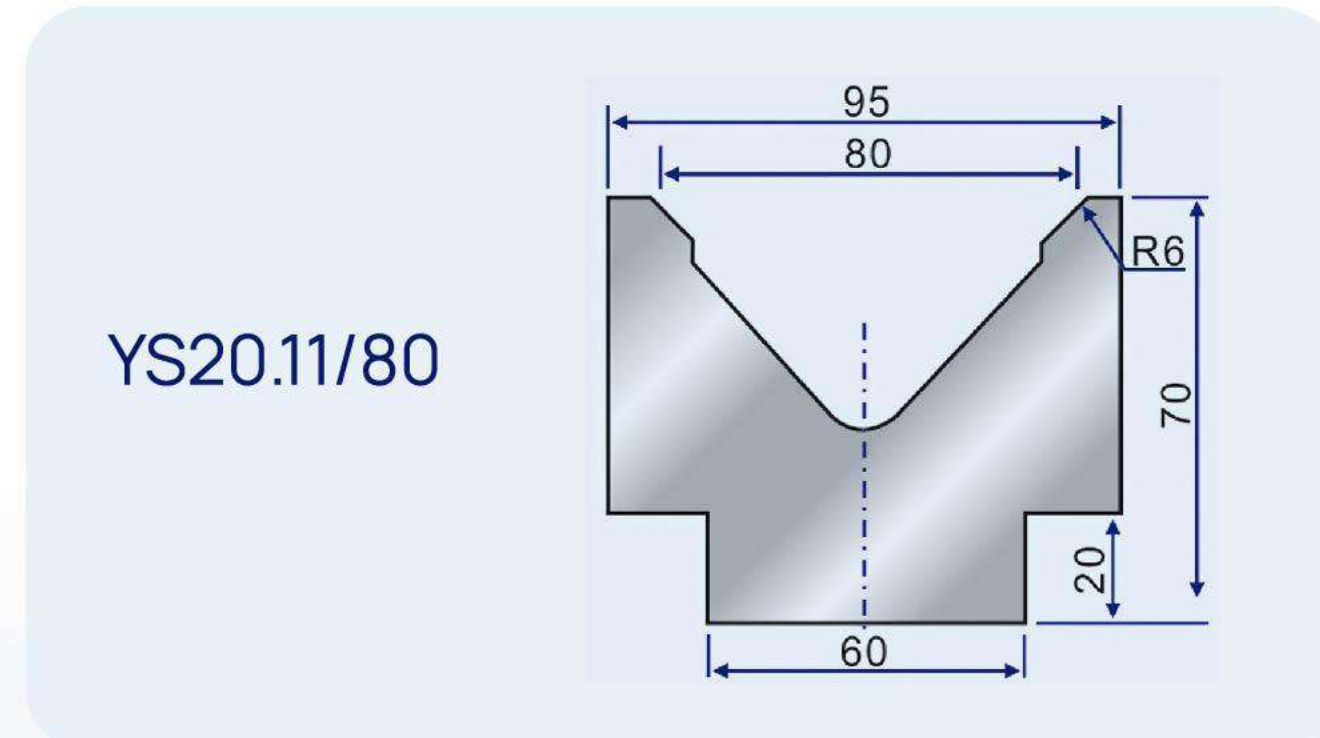
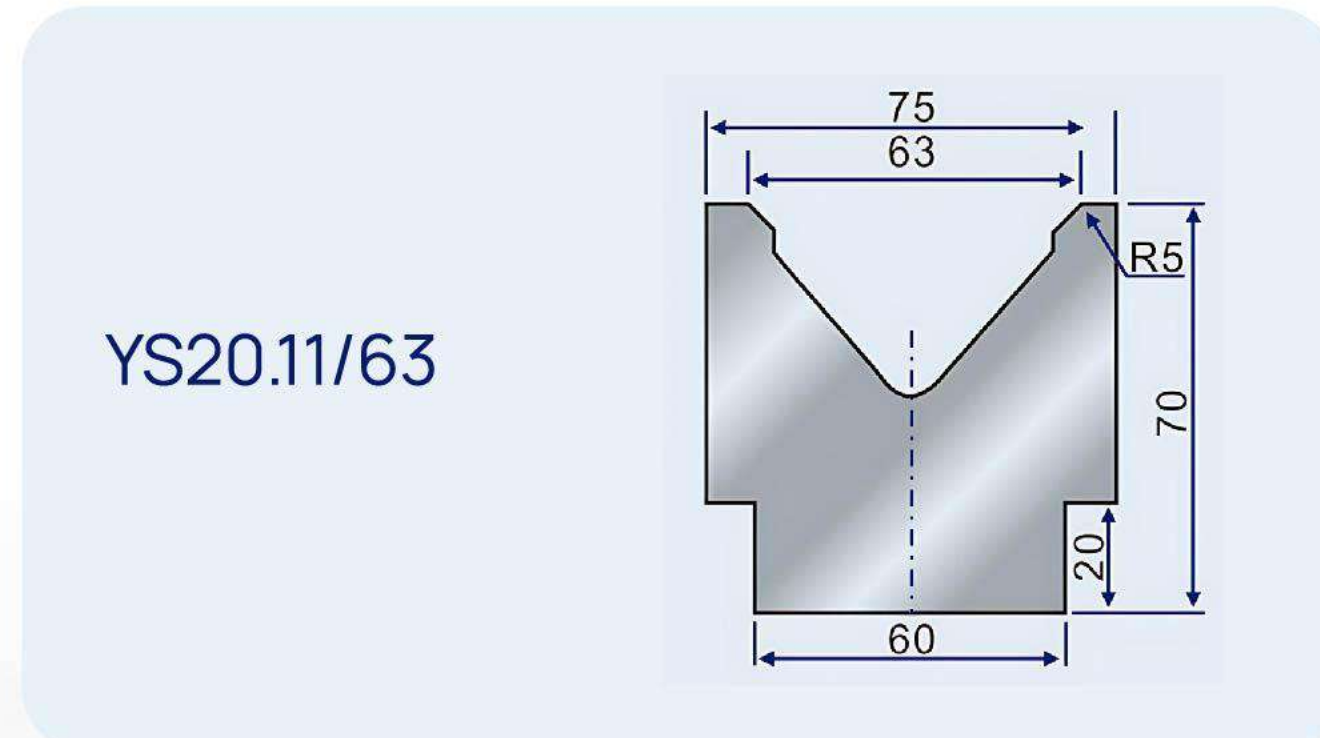
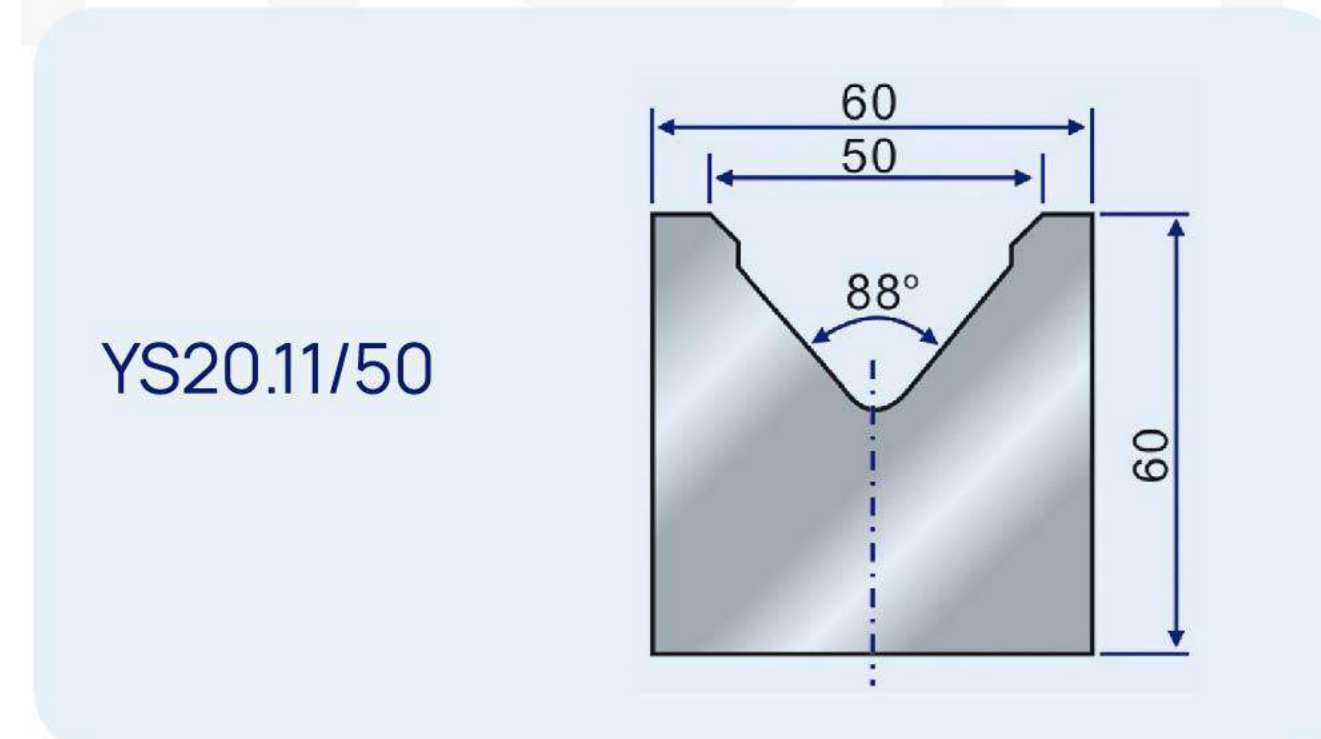
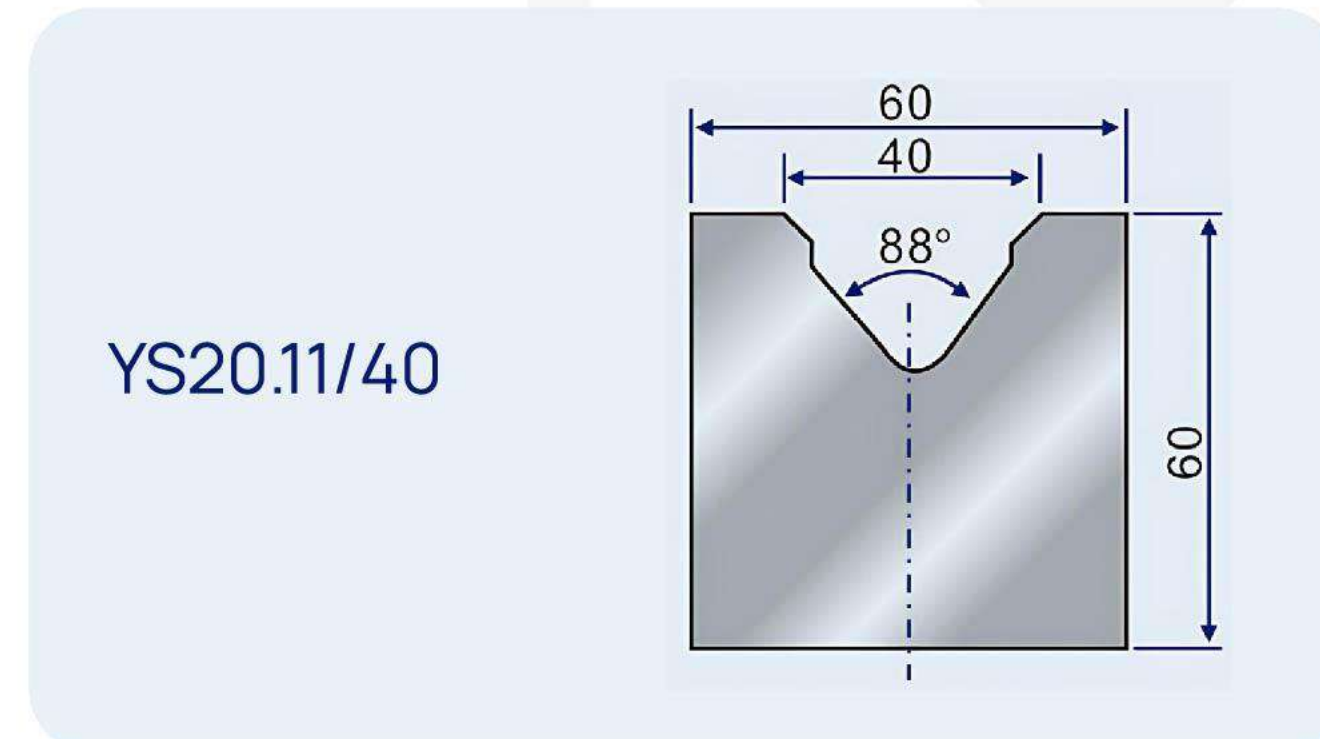
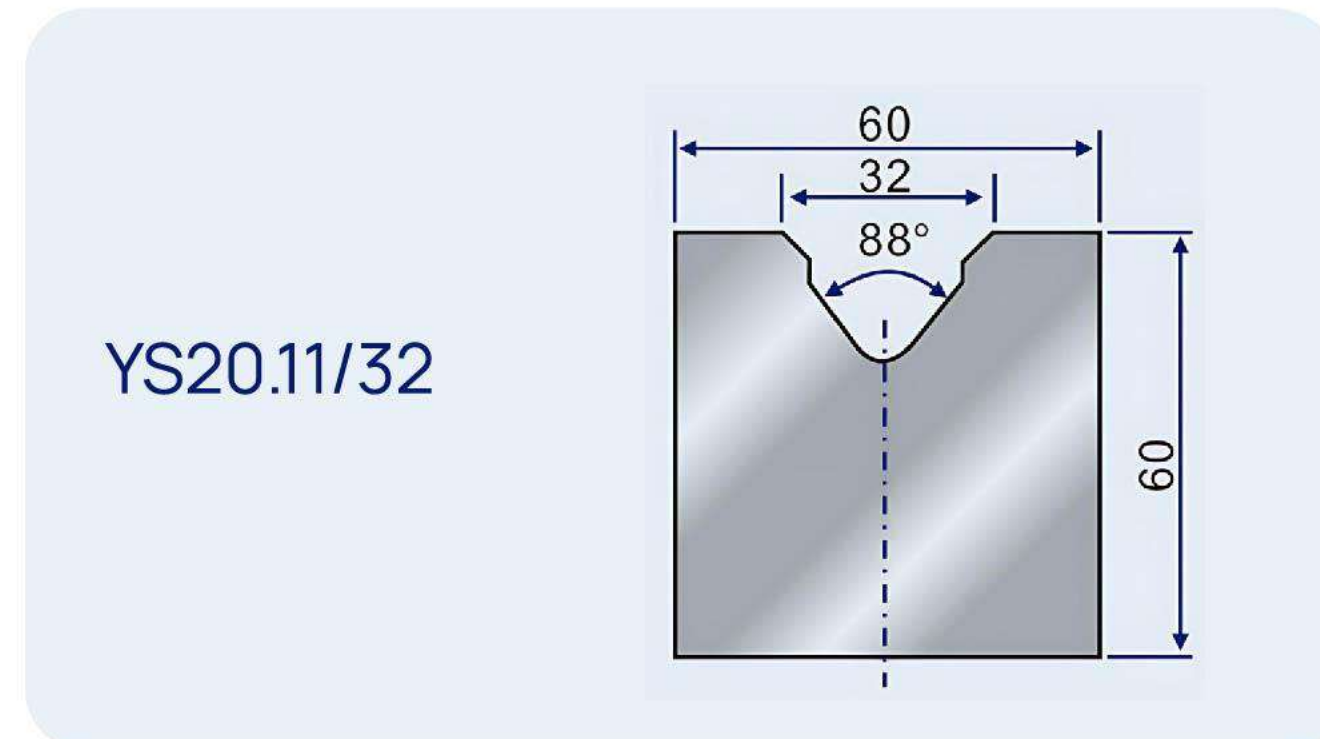
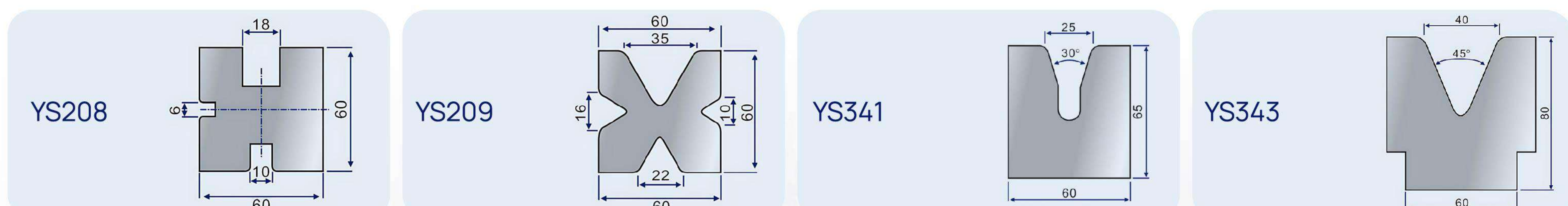
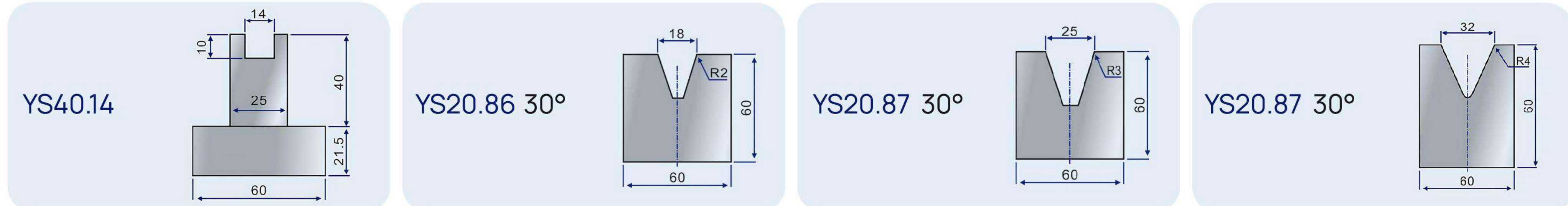
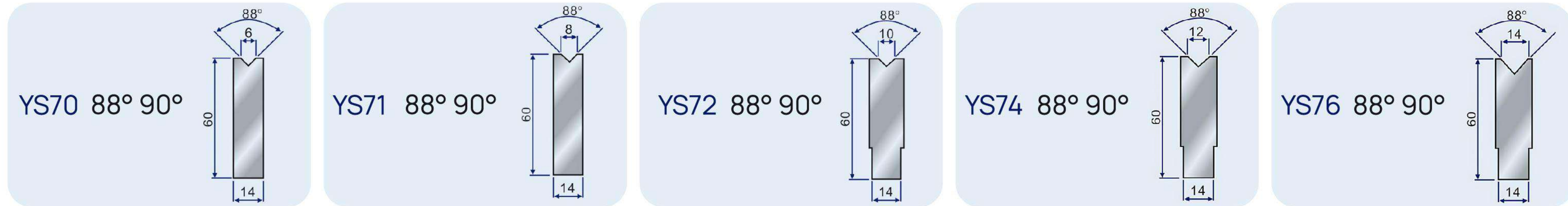


YS20.15 60°



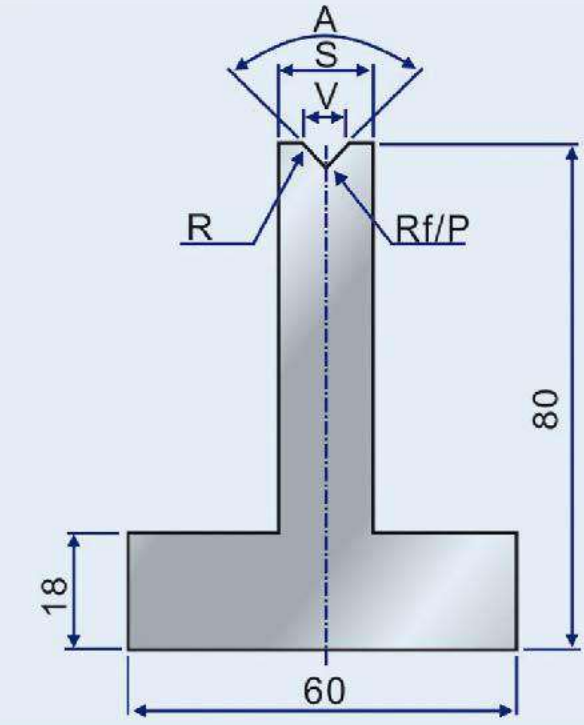
AMADA 折弯机下模

PUNCH



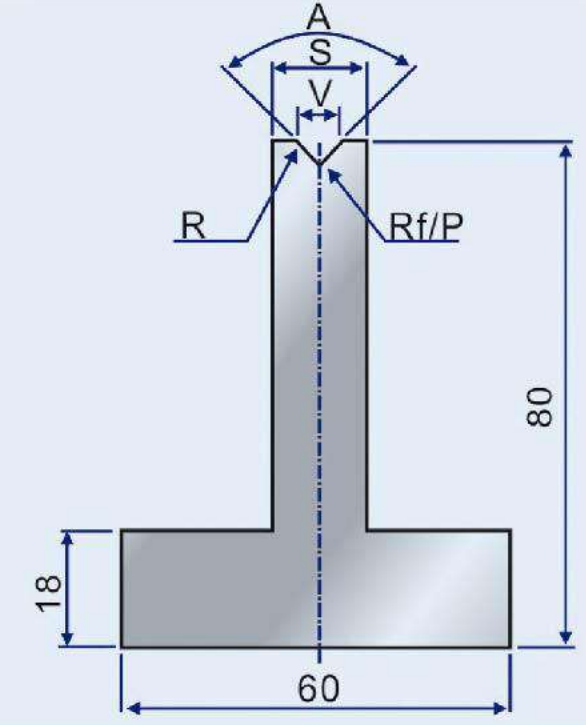
AMADA 折弯机下模

PUNCH



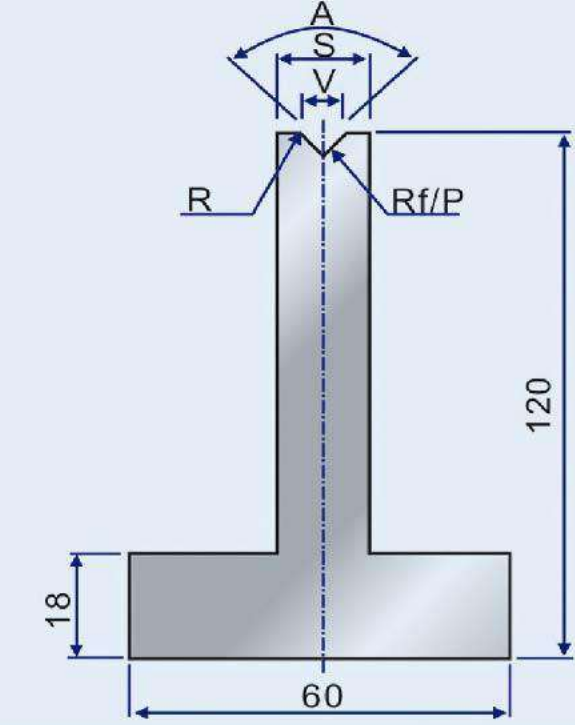
YS010

V	A	R	S	Rf/P	T/M
6	90°	0.4	14	0.5	100
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	100
6	45°	0.4	14	0.5	100
6	30°	0.4	14	1.0	100



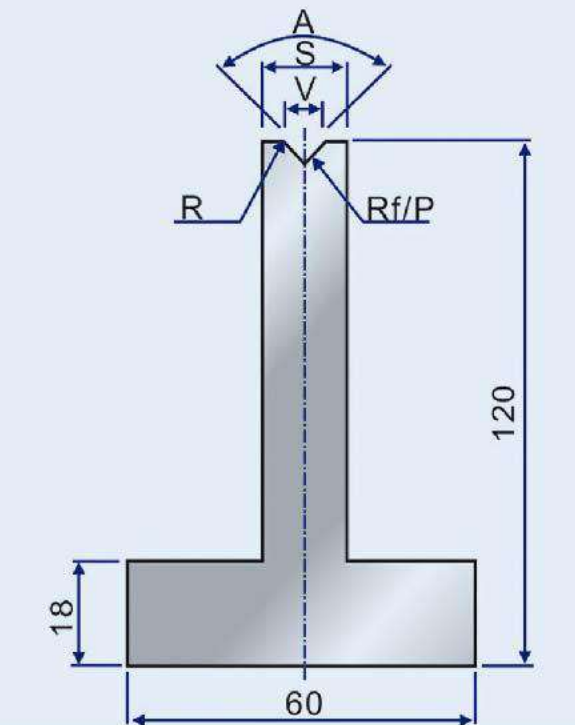
YS011

V	A	R	S	Rf/P	T/M
8	90°	0.5	14	0.5	100
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.5	14	0.5	50
8	30°	0.5	14	2.0	35



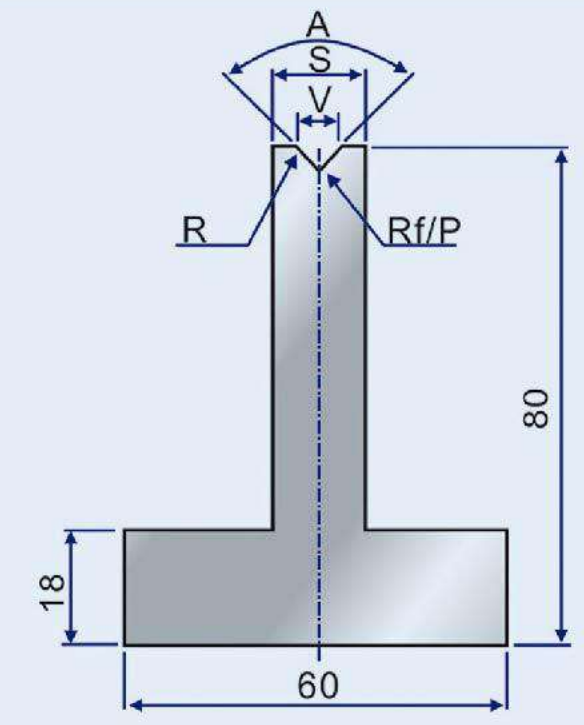
YS017

V	A	R	S	Rf/P	T/M
6	88°	0.4	14	0.5	100
6	60°	0.4	14	0.5	60
6	45°	0.6	14	0.5	50
6	30°	0.6	14	1.0	35



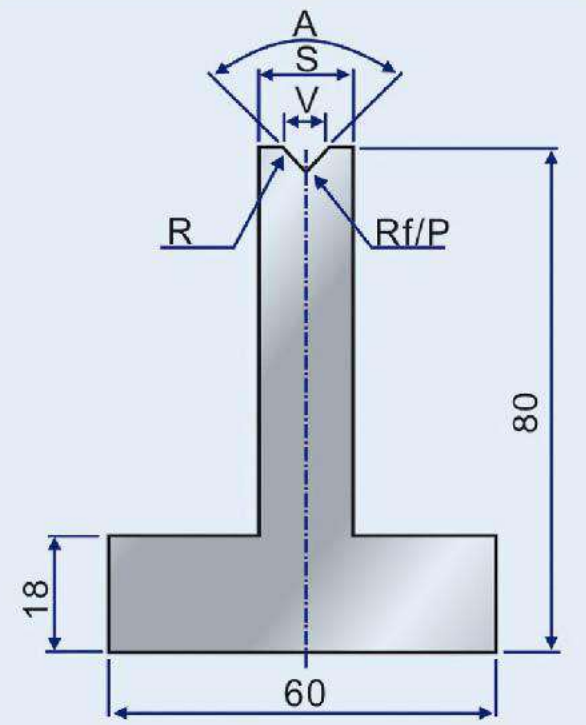
YS018

V	A	R	S	Rf/P	T/M
8	88°	0.5	14	0.5	100
8	60°	0.5	14	0.7	60
8	45°	0.8	18	0.5	50
8	30°	0.8	18	2.0	35



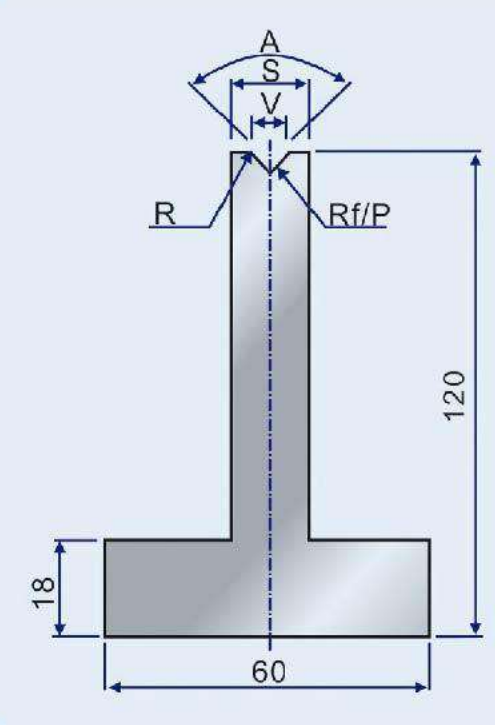
YS012

V	A	R	S	Rf/P	T/M
10	90°	0.6	18	0.5	100
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.7	60
10	45°	1.0	18	0.5	50
10	30°	1.0	24	2.0	50



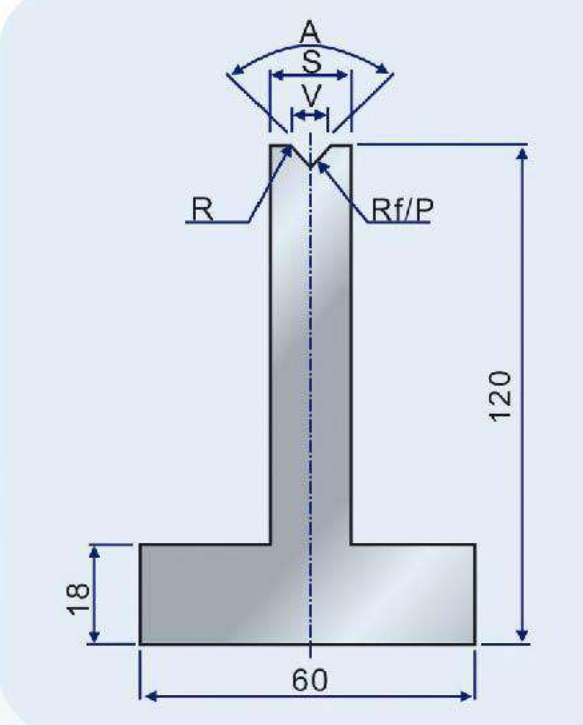
YS013

V	A	R	S	Rf/P	T/M
12	90°	0.8	18	0.5	100
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40



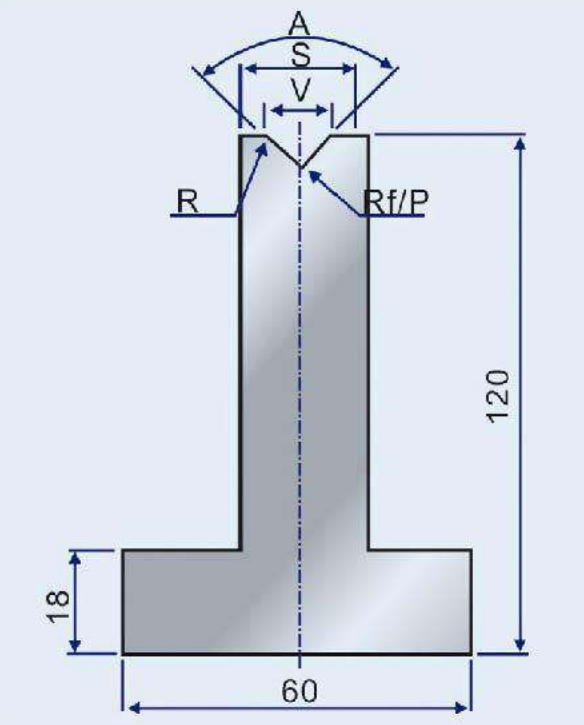
YS019

V	A	R	S	Rf/P	T/M
10	88°	0.6	18	0.5	100
10	60°	0.6	18	0.5	60
10	45°	1.0	18	0.7	60
10	30°	1.0	24	2.0	50



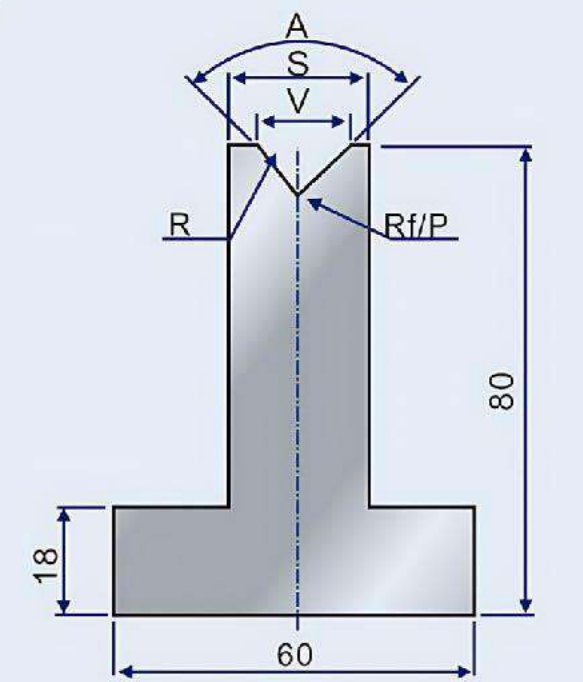
YS020

V	A	R	S	Rf/P	T/M
12	88°	2.75	18	0.5	100
12	60°	0.8	18	0.5	60
12	45°	1.5	24	0.7	50
12	30°	1.5	24	2.0	40



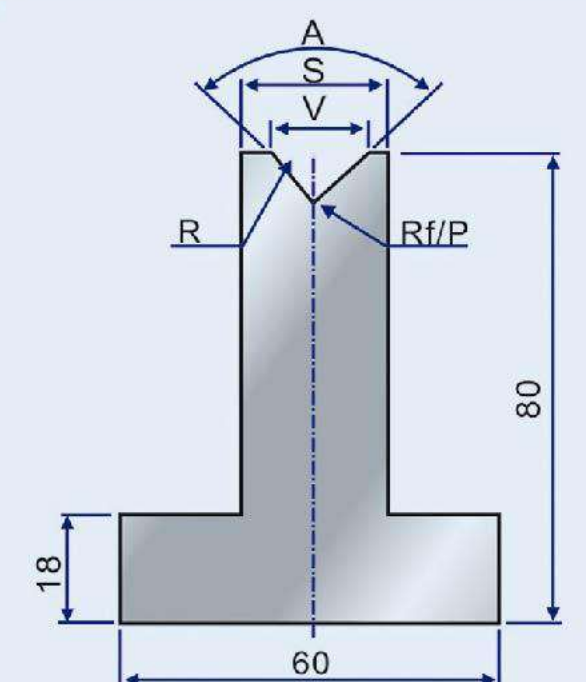
YS021

V	A	R	S	Rf/P	T/M
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	45



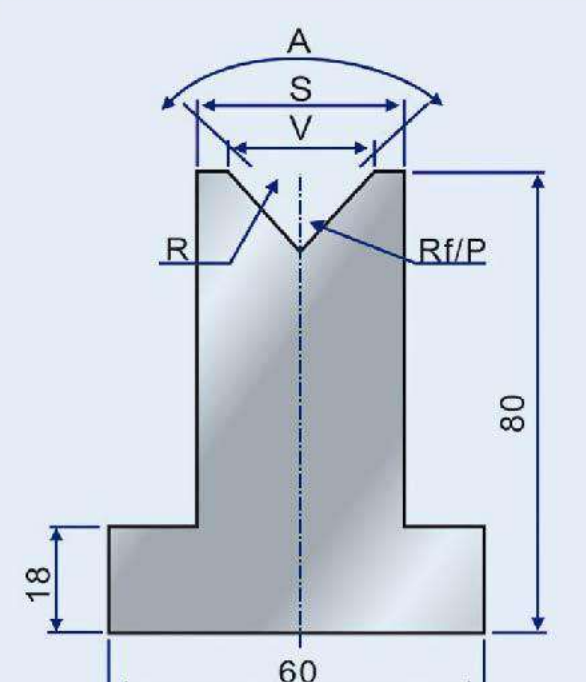
YS014

V	A	R	S	Rf/P	T/M
16	90°	1	24	0.5	100
16	88°	2.75	24	0.5	100
16	60°	3	24	0.7	60
16	45°	2	24	1.0	50
16	30°	2	30	5.0	40



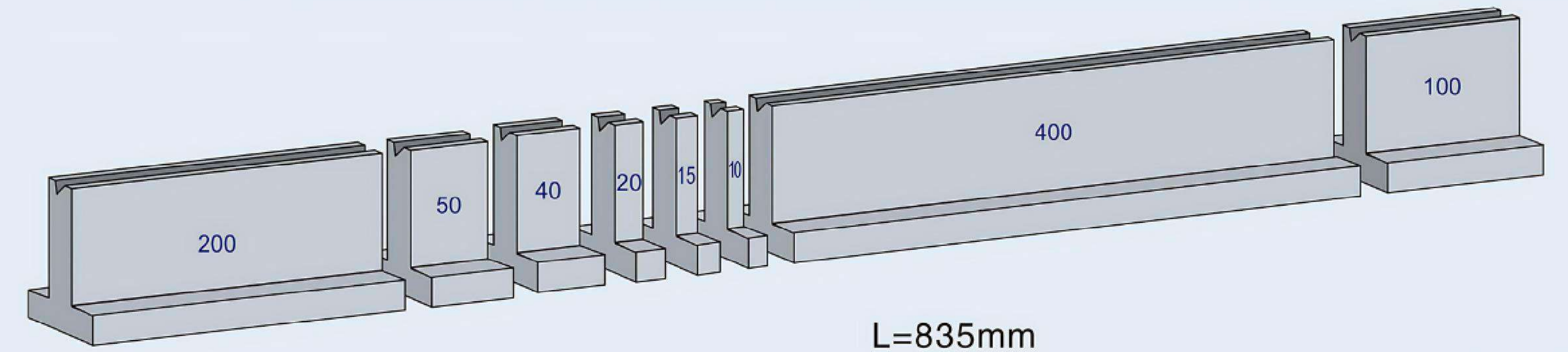
YS015

V	A	R	S	Rf/P	T/M
20	90°	3	30	0.5	100
20	88°	3	30	0.7	60
20	60°	2.5	30	1.0	50
20	45°	2.5	35	5.0	50



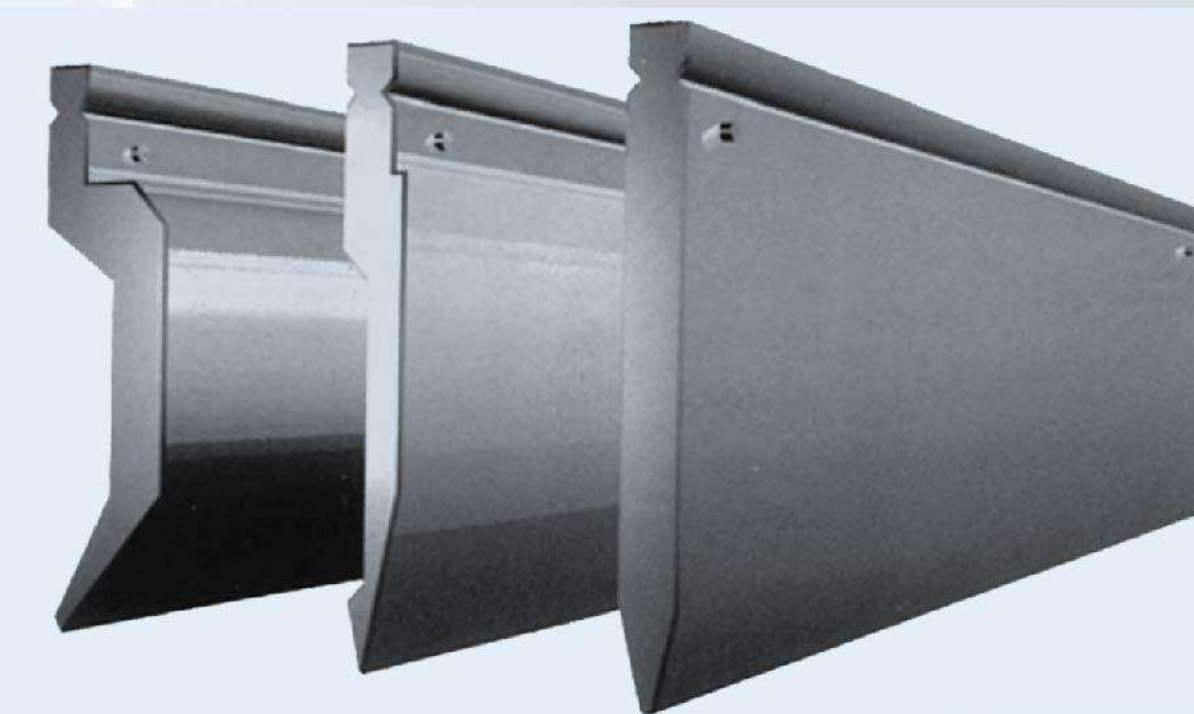
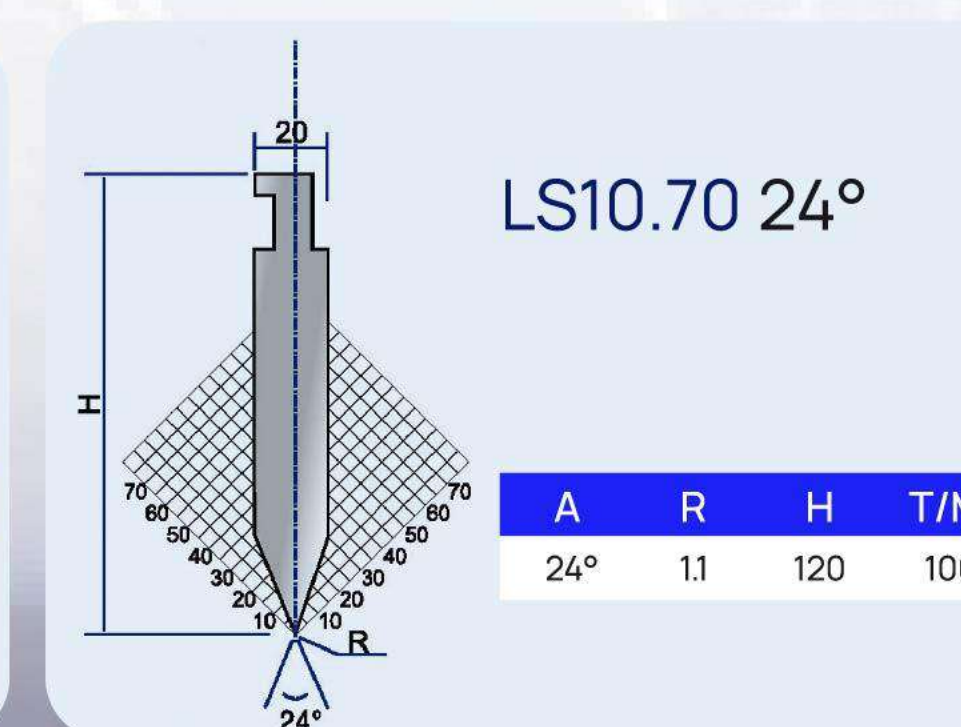
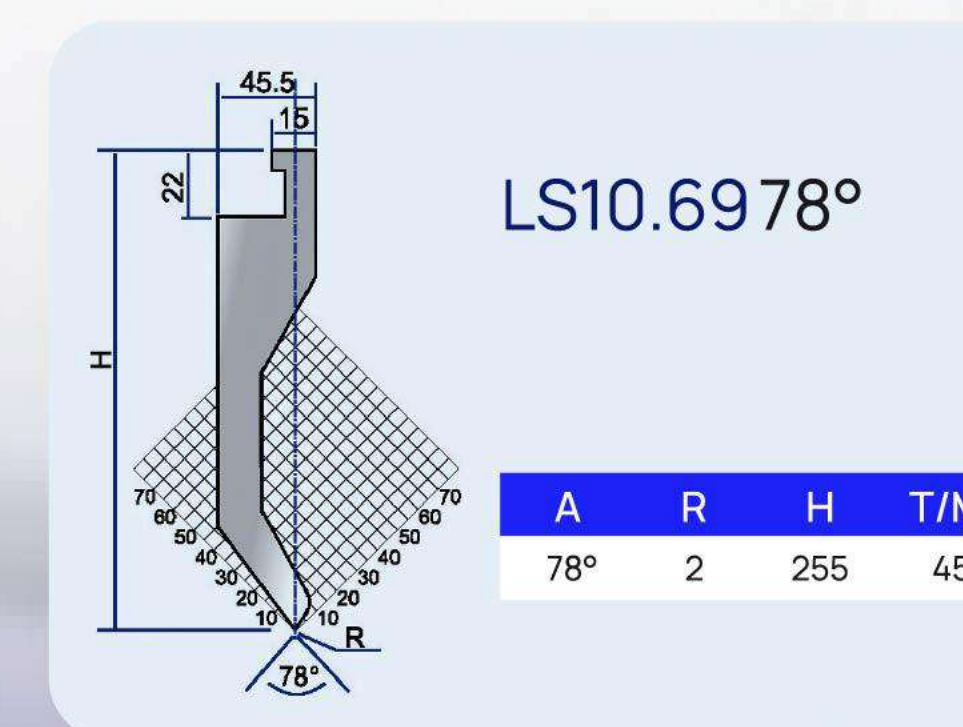
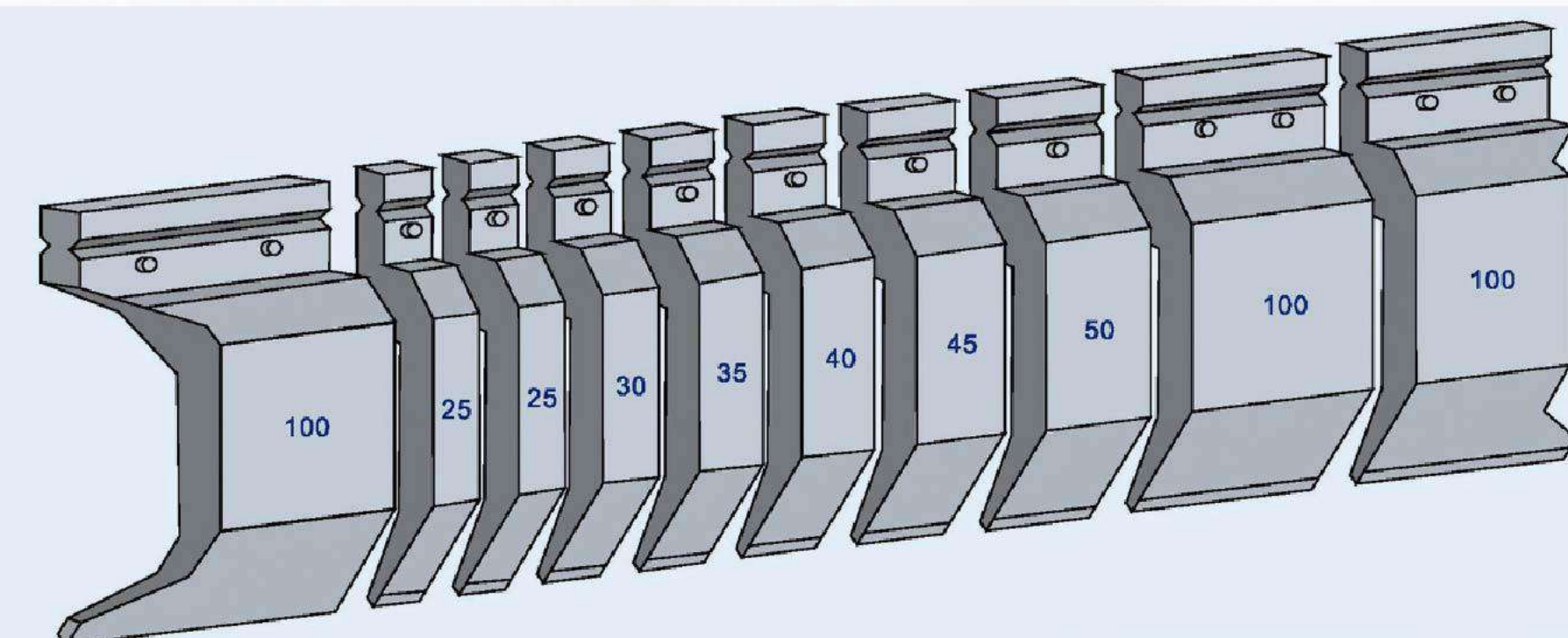
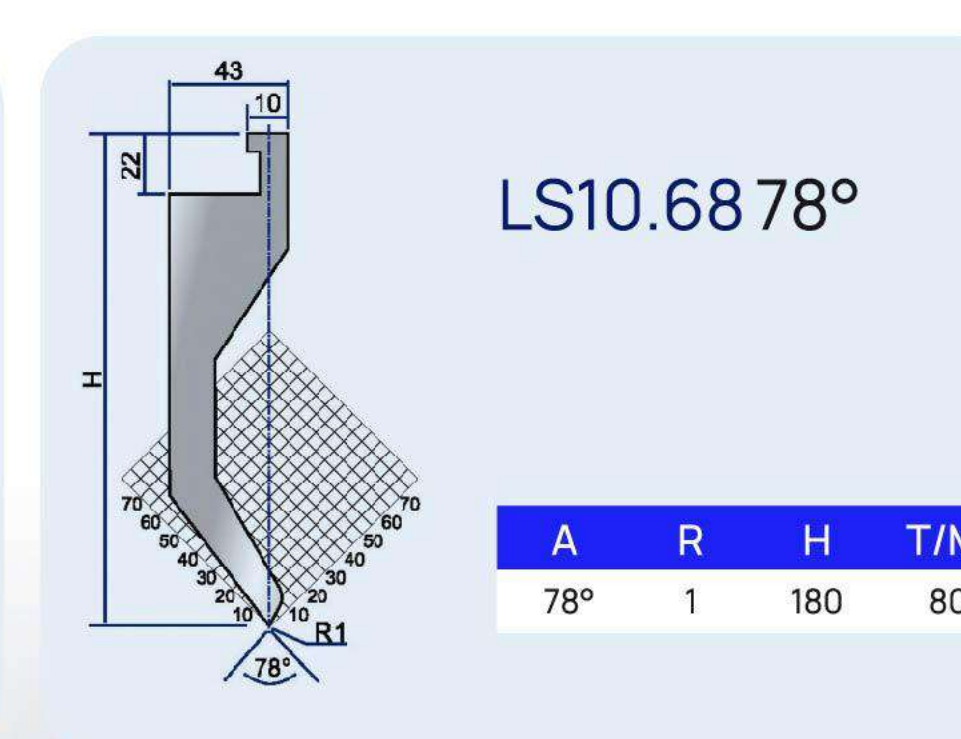
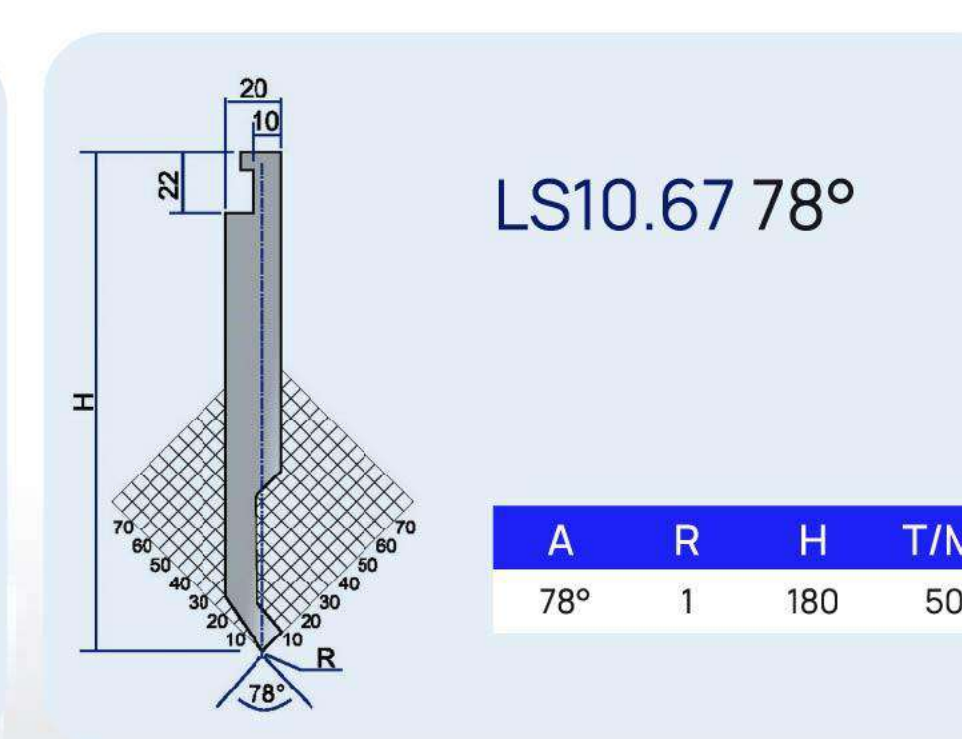
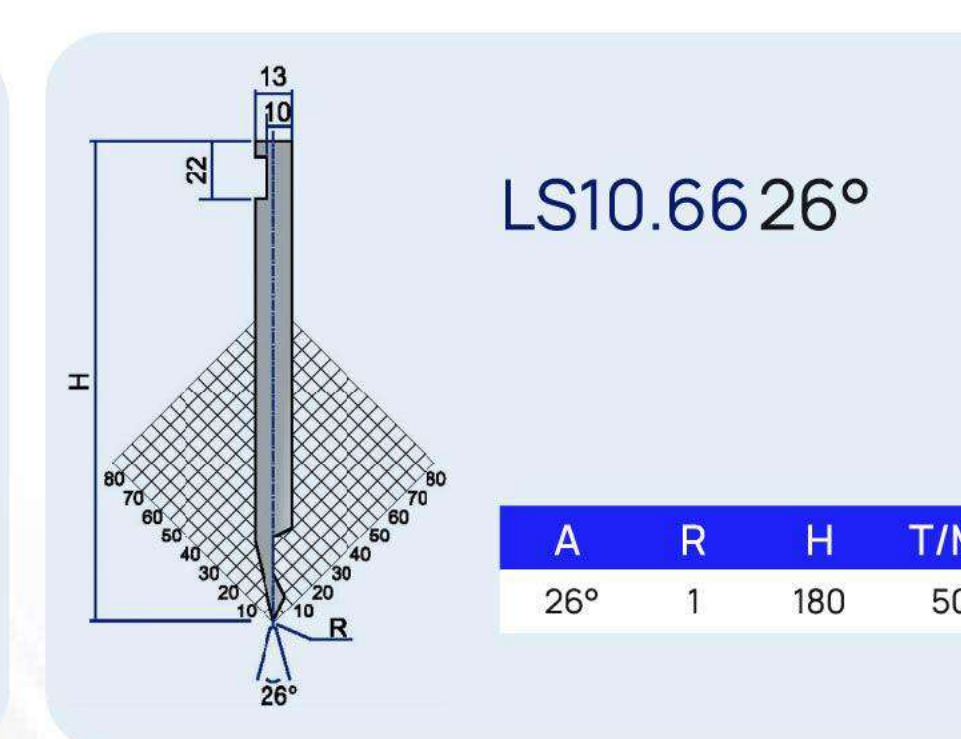
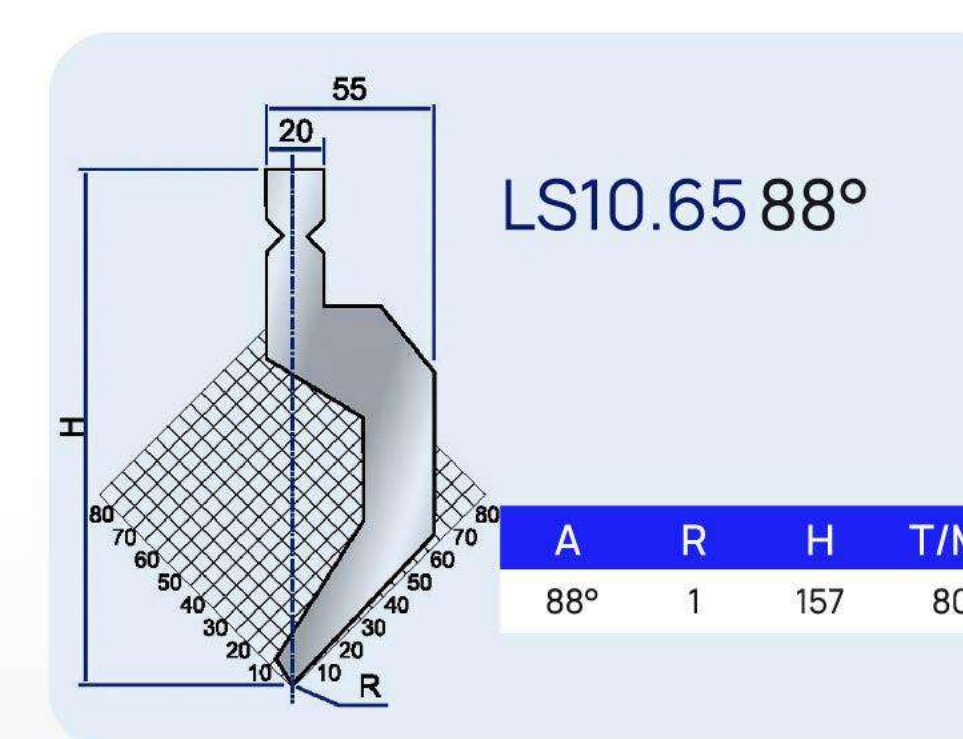
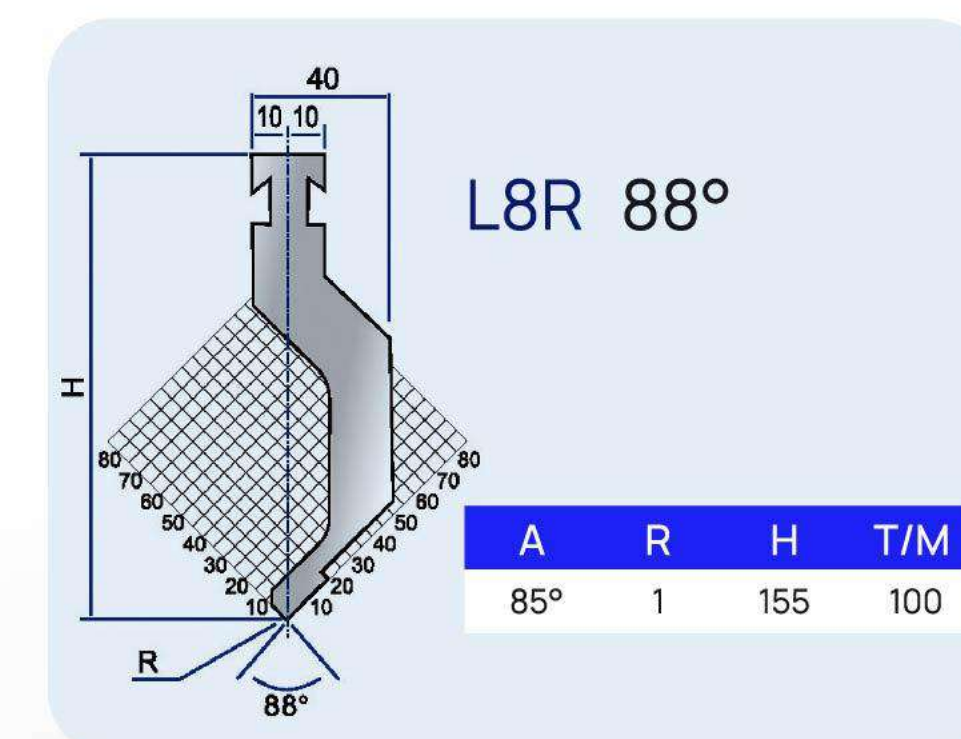
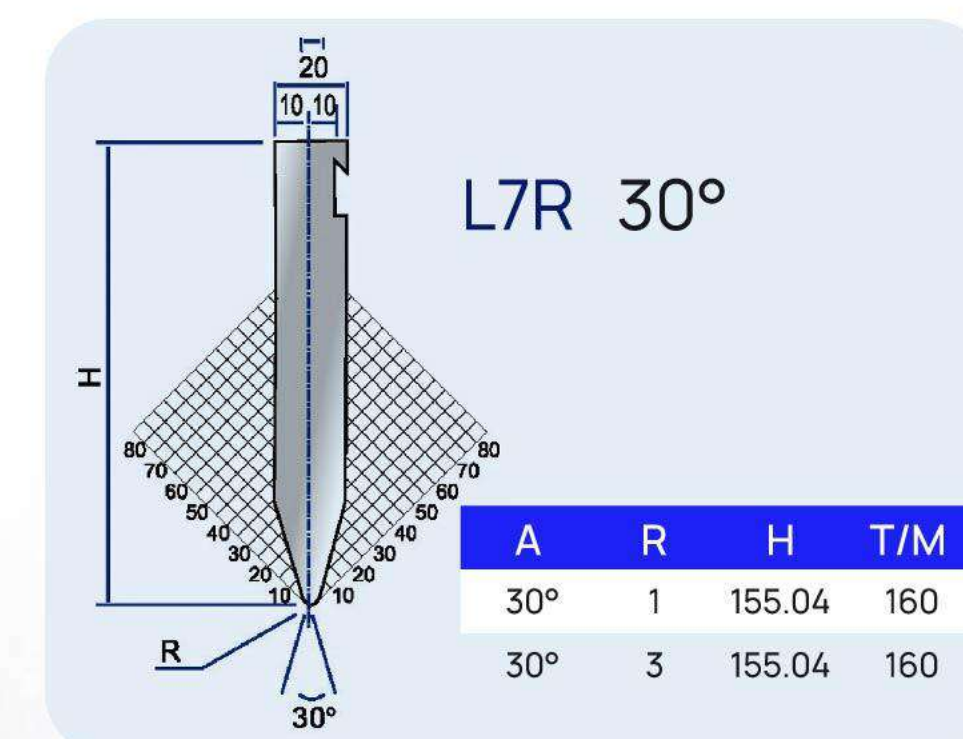
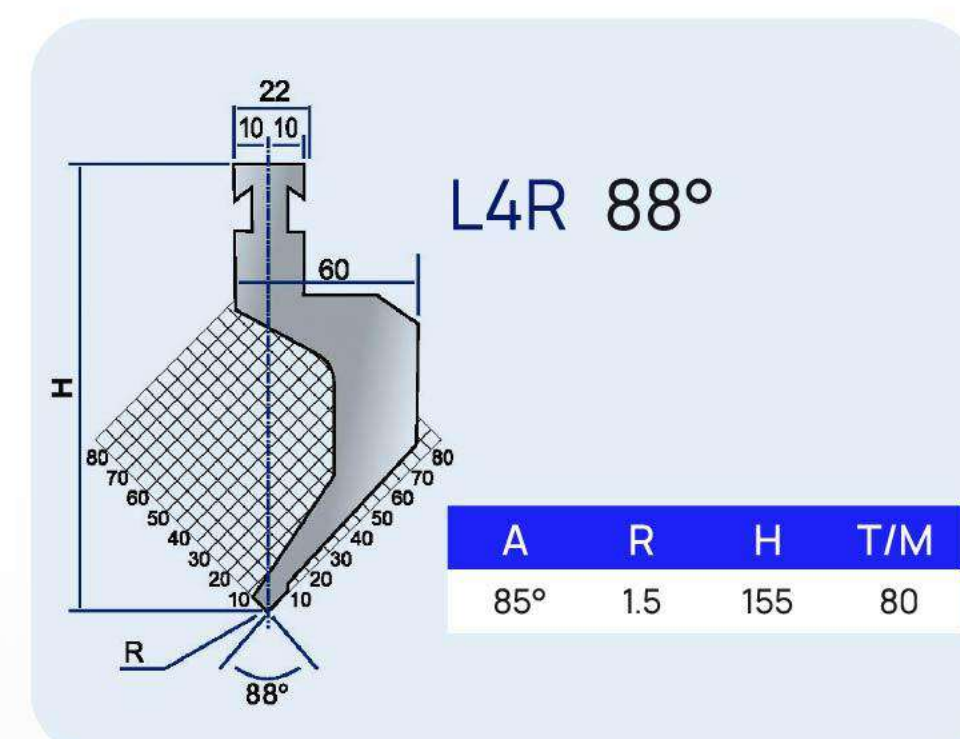
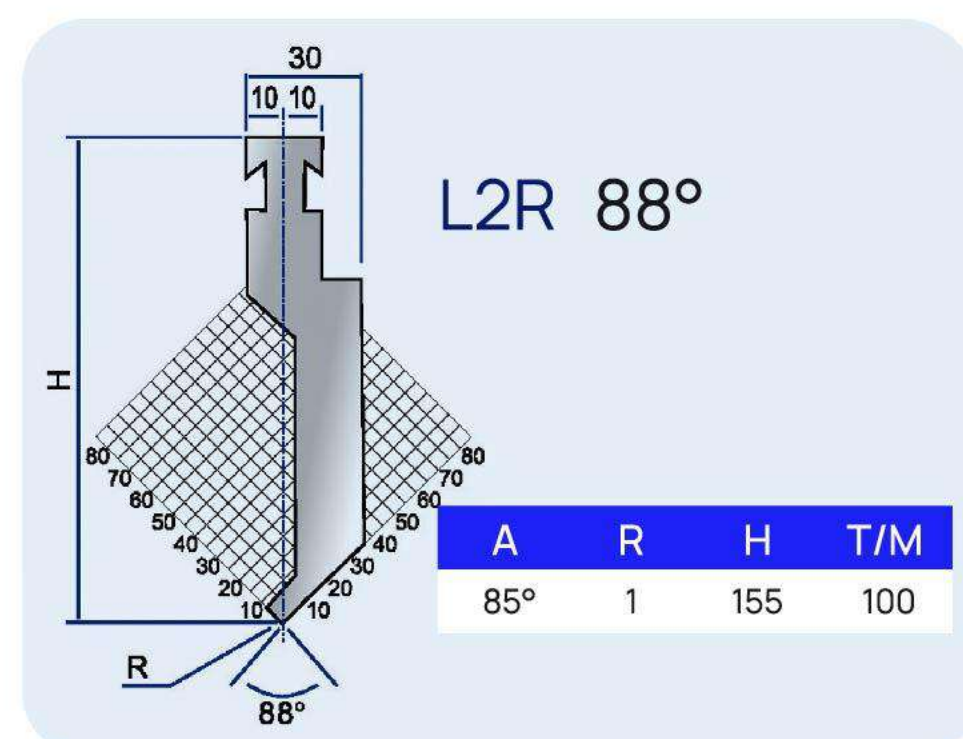
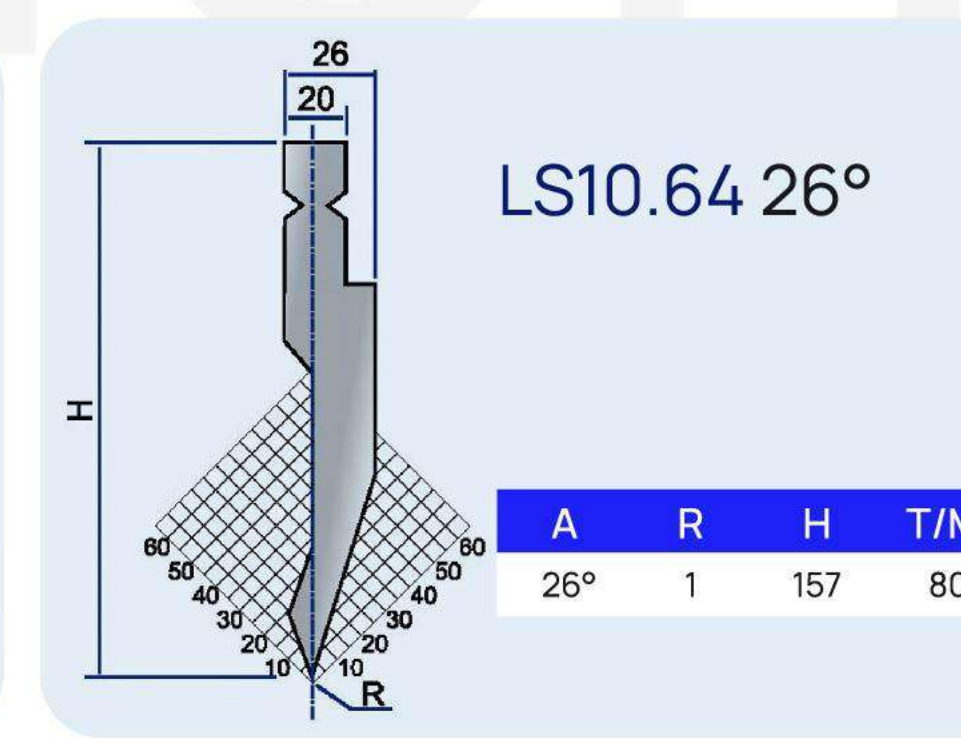
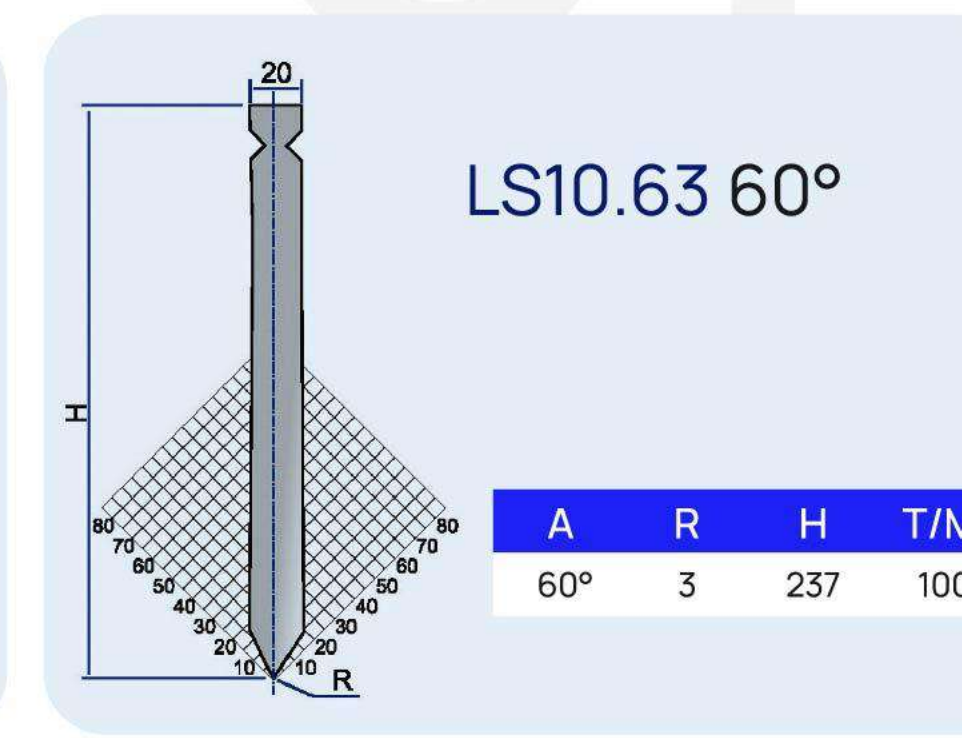
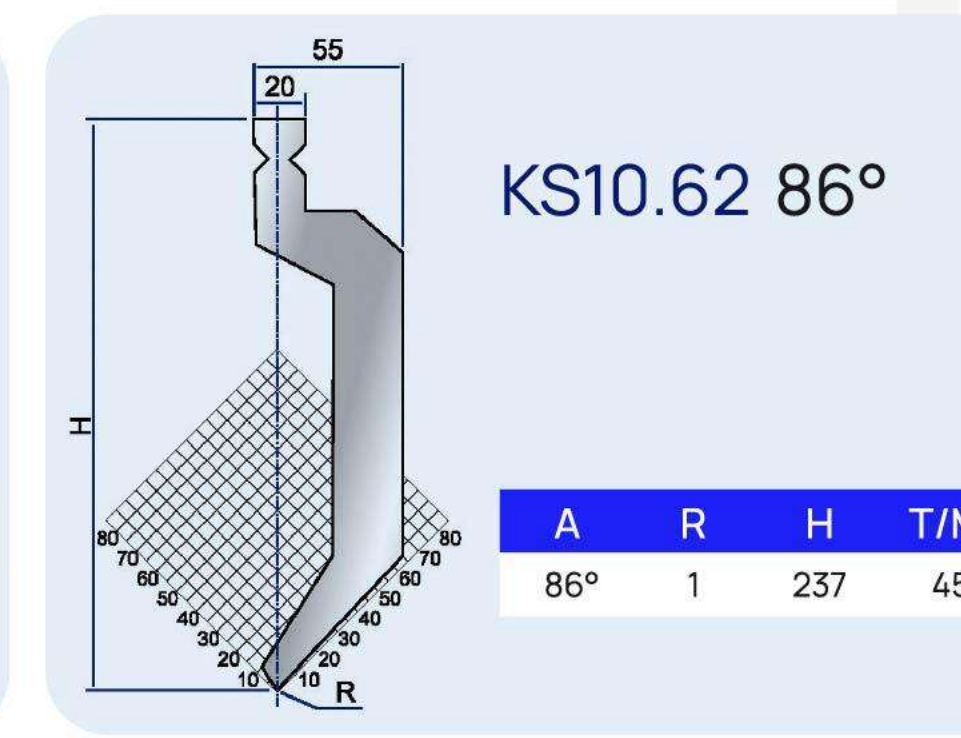
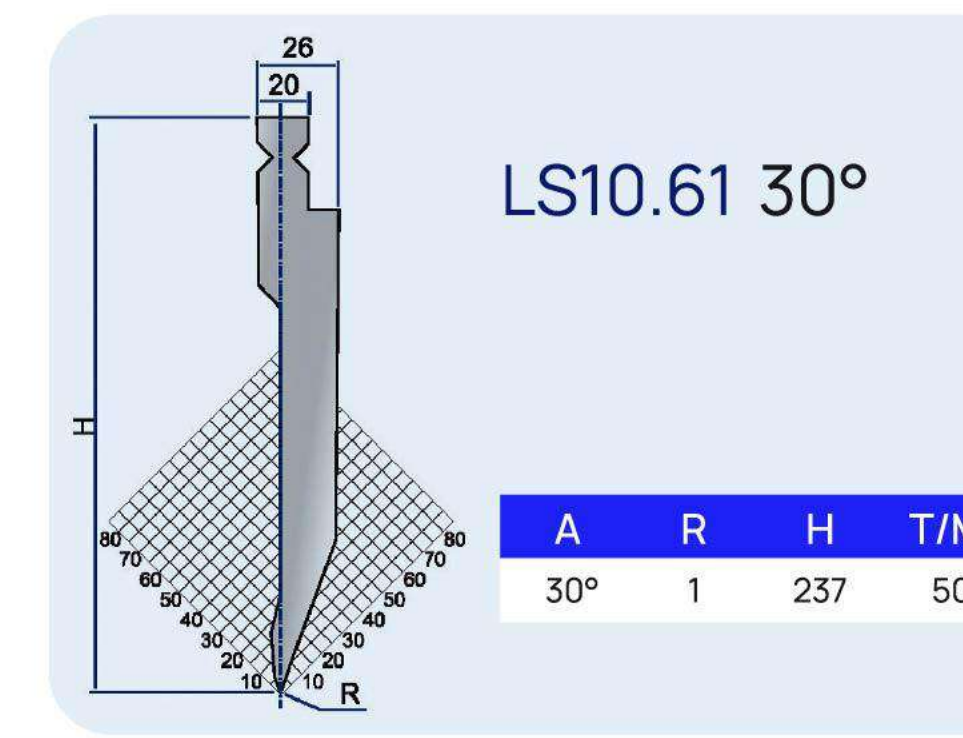
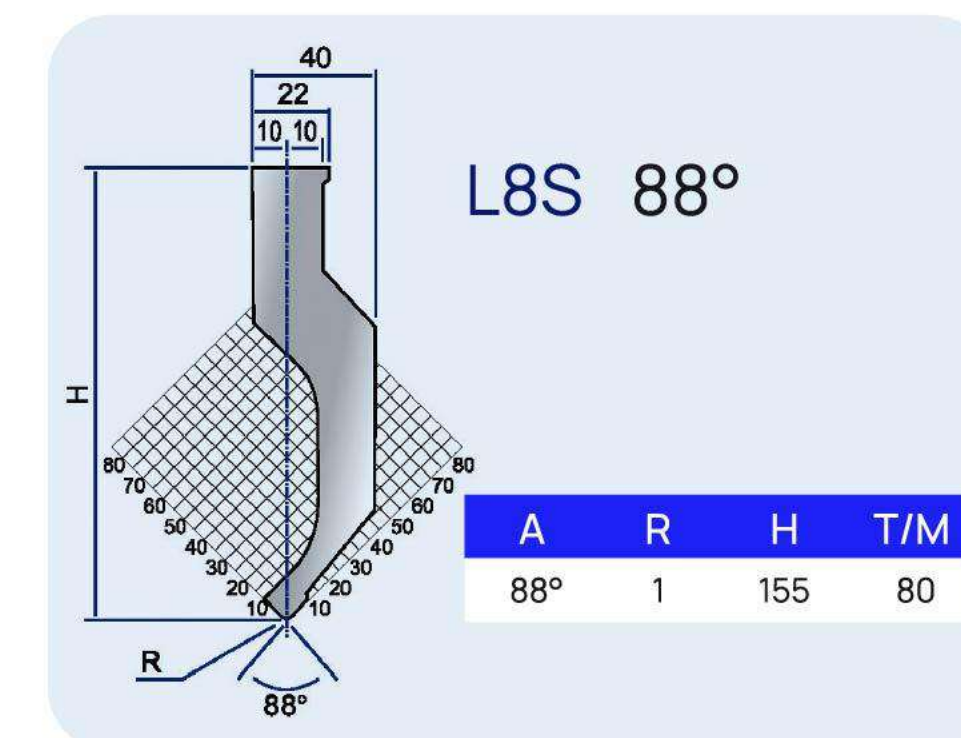
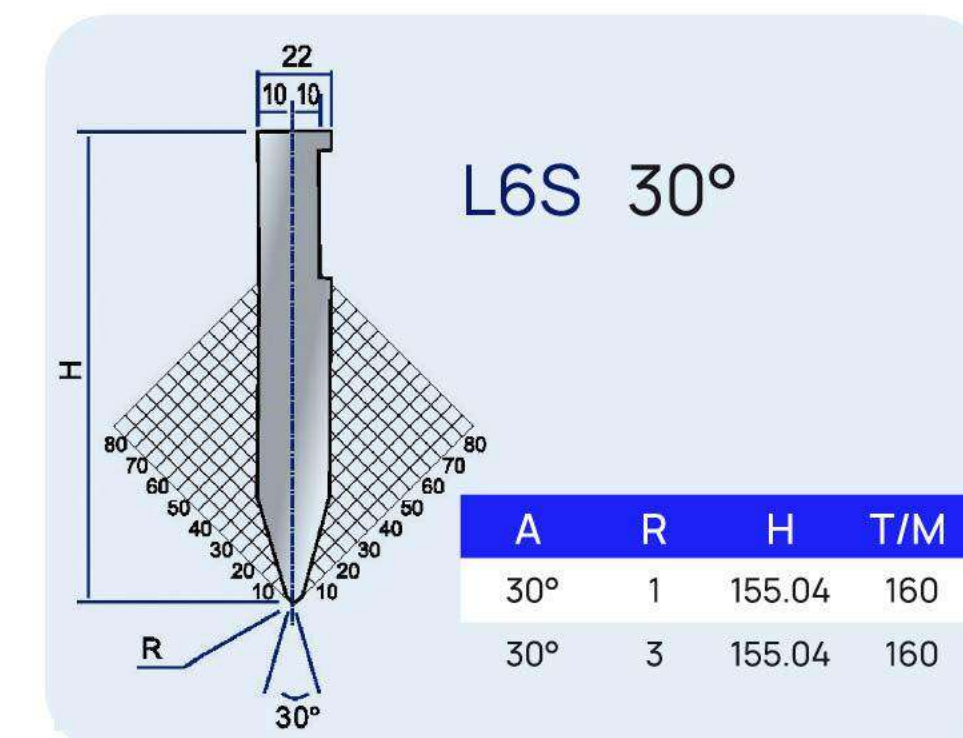
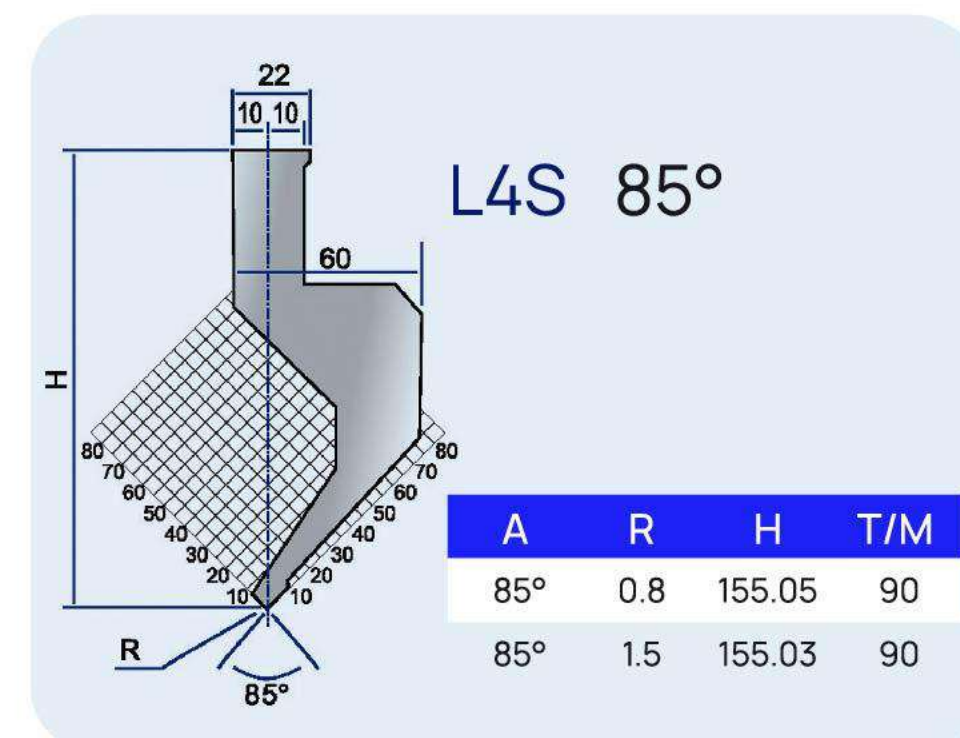
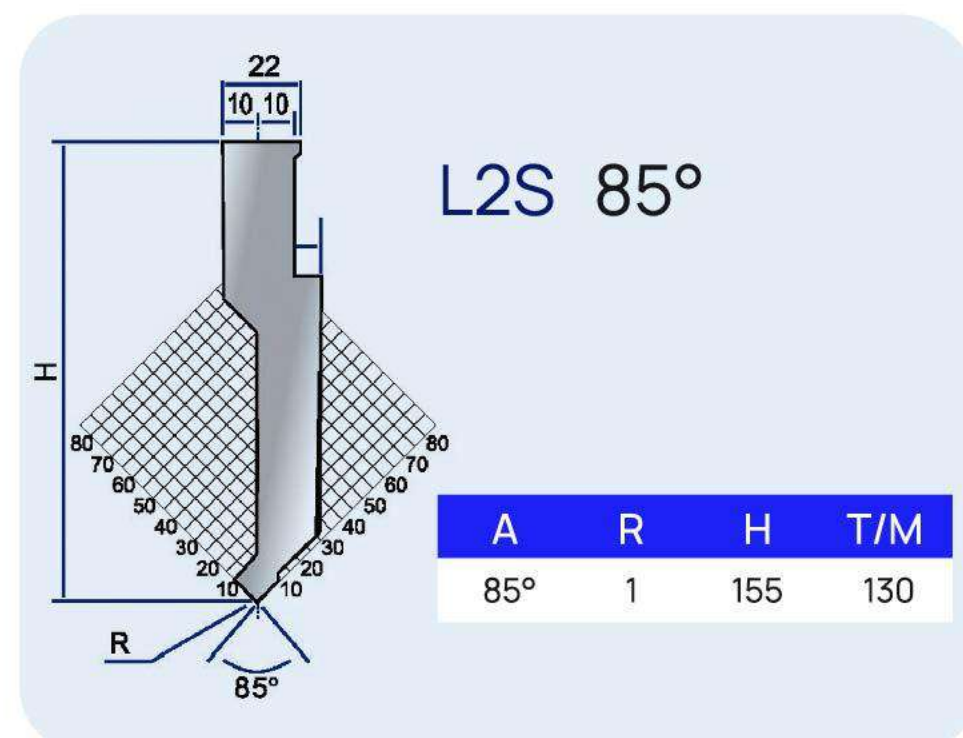
YS016

V	A	R	S	Rf/P	T/M
25	88°	3	35	0.5	100
25	60°	3	35	1.7	60
25	45°	3	35	1.0	50
25	30°	3	40	5.0	50



欧式折弯机冲头

PUNCH



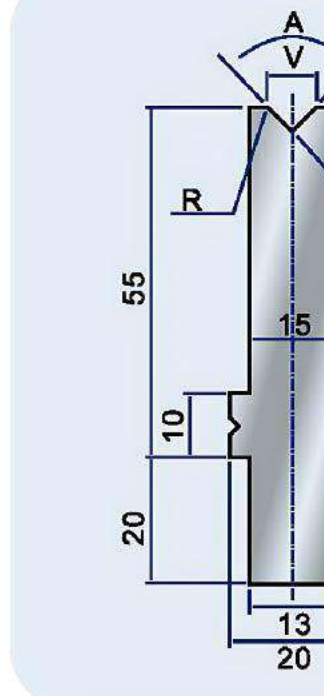
欧式折弯机冲头

PUNCH



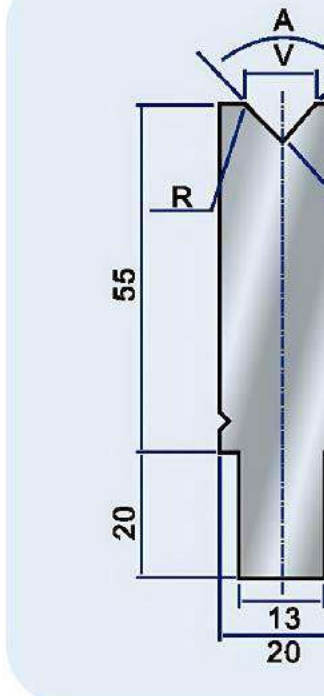
YM6 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
6	90°	0.4	55	20	15	0.5	100
6	88°	0.8	55	20	15	0.5	100
6	30°	0.6	55	20	15	2.0	35



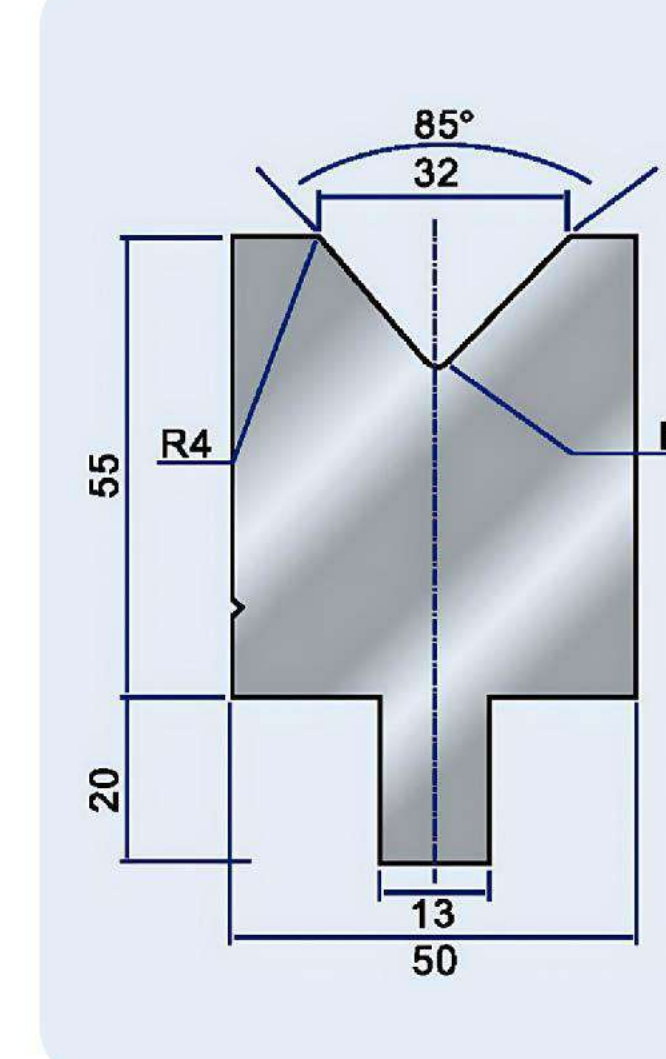
YM8 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
6	90°	0.5	55	20	15	0.5	100
6	88°	1.0	55	20	15	0.5	100
6	30°	0.8	55	20	15	2.0	35



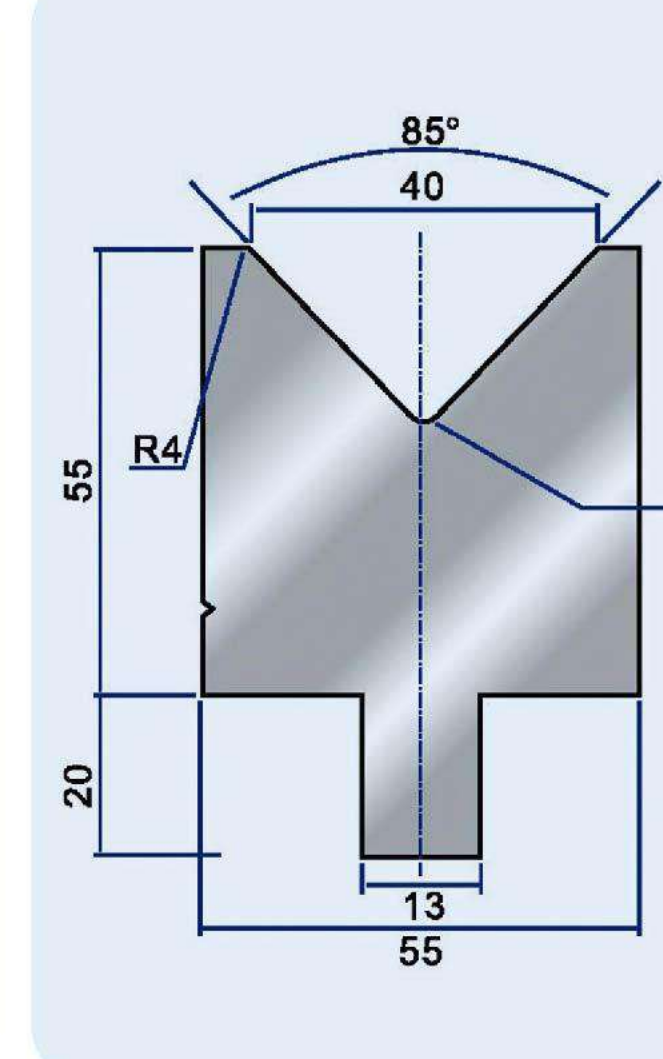
YM10 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
10	90°	1.0	55	20	20	0.5	100
10	88°	1.0	55	20	20	0.5	100
10	30°	1.0	55	20	15	2.0	50



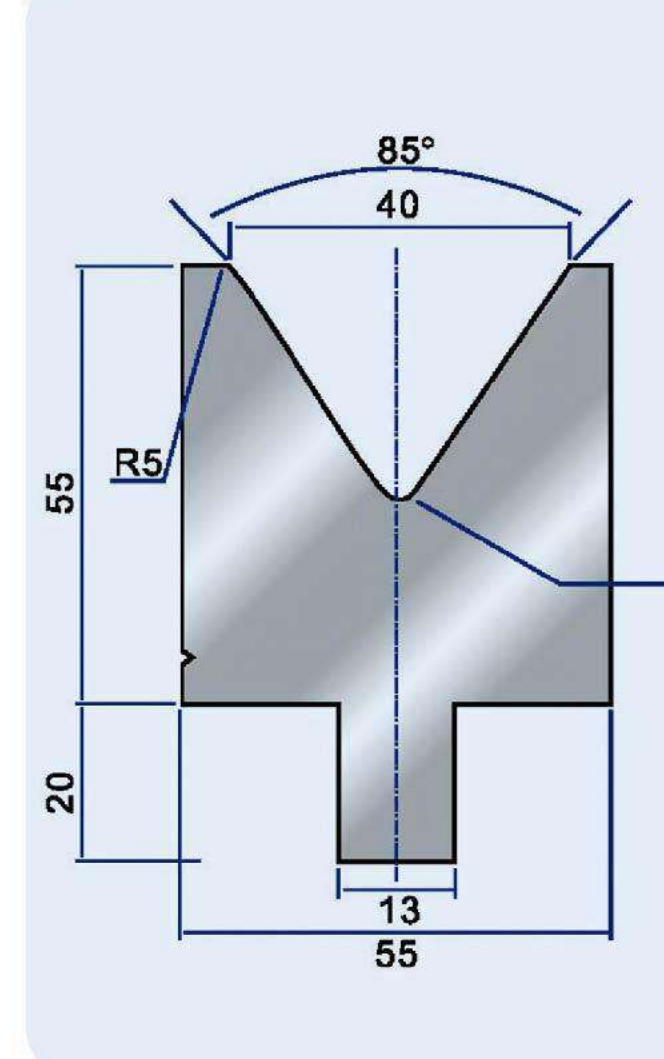
YM32 85°

V	A	R	S	Rf/P	T/M
32	85°	4.0	50	3.0	100



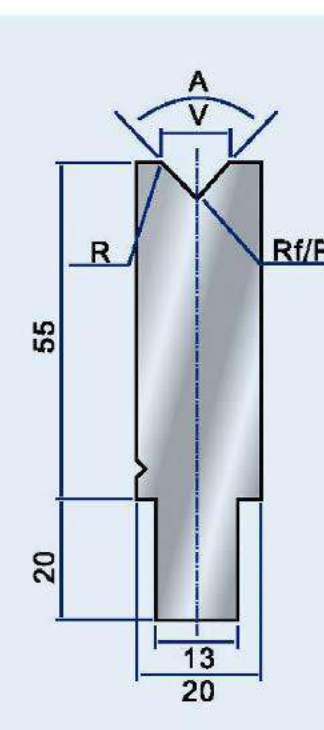
YM40 85°

V	A	R	S	Rf/P	T/M
40	85°	4.0	55	4.0	100



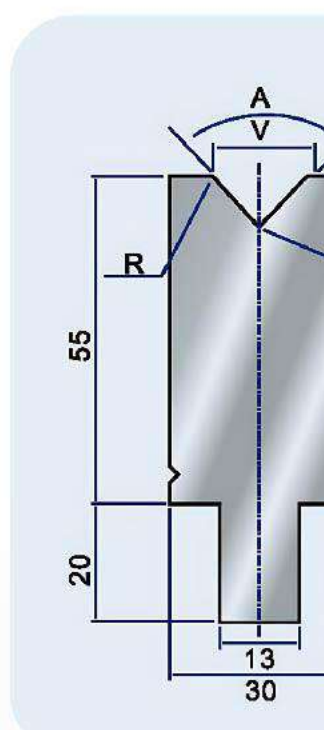
YM32 60°

V	A	R	S	Rf/P	T/M
40	60°	5.0	55	5.0	100



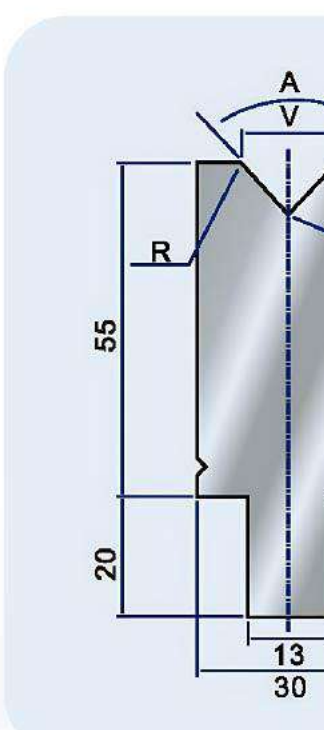
YM12 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
12	90°	1.5	55	20	15	0.5	100
12	88°	1.5	55	20	15	0.5	100
12	30°	1.5	55	20	15	2.0	40



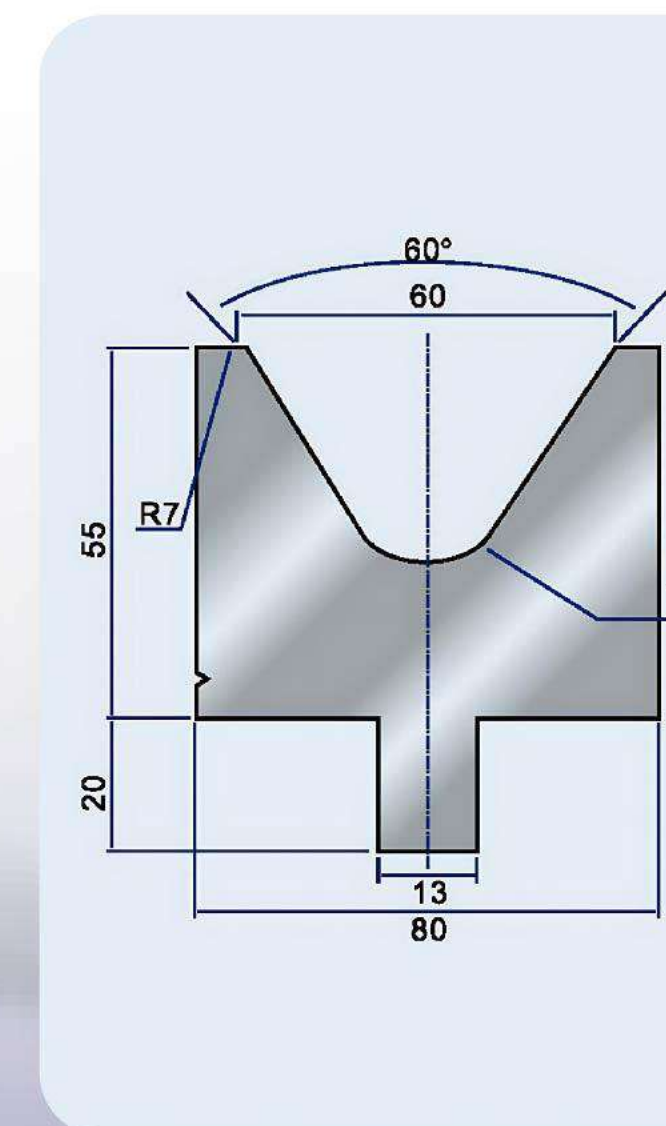
YM16 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
16	90°	2.0	55	30	30	0.5	100
16	88°	2.0	55	30	30	0.5	100
16	30°	2.0	55	30	30	2.0	45



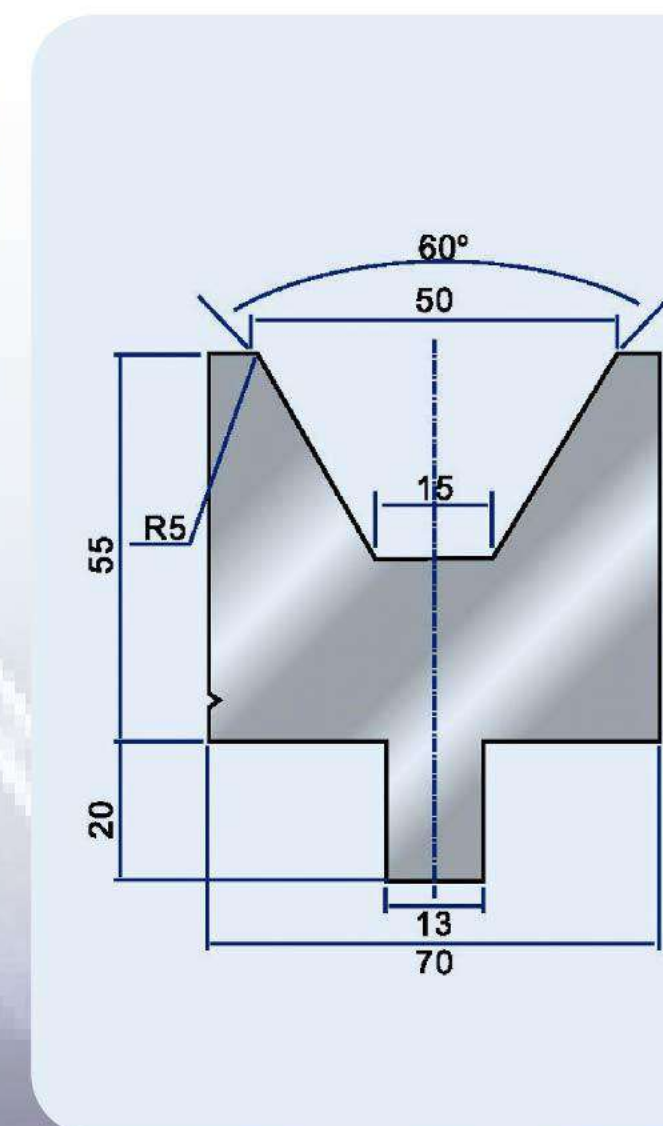
YM20 90° 88° 30°

V	A	R	H	T	S	Rf/P	T/M
16	90°	2.0	55	30	30	0.5	100
16	88°	2.0	55	30	30	0.5	100
16	30°	2.0	55	30	30	2.0	45



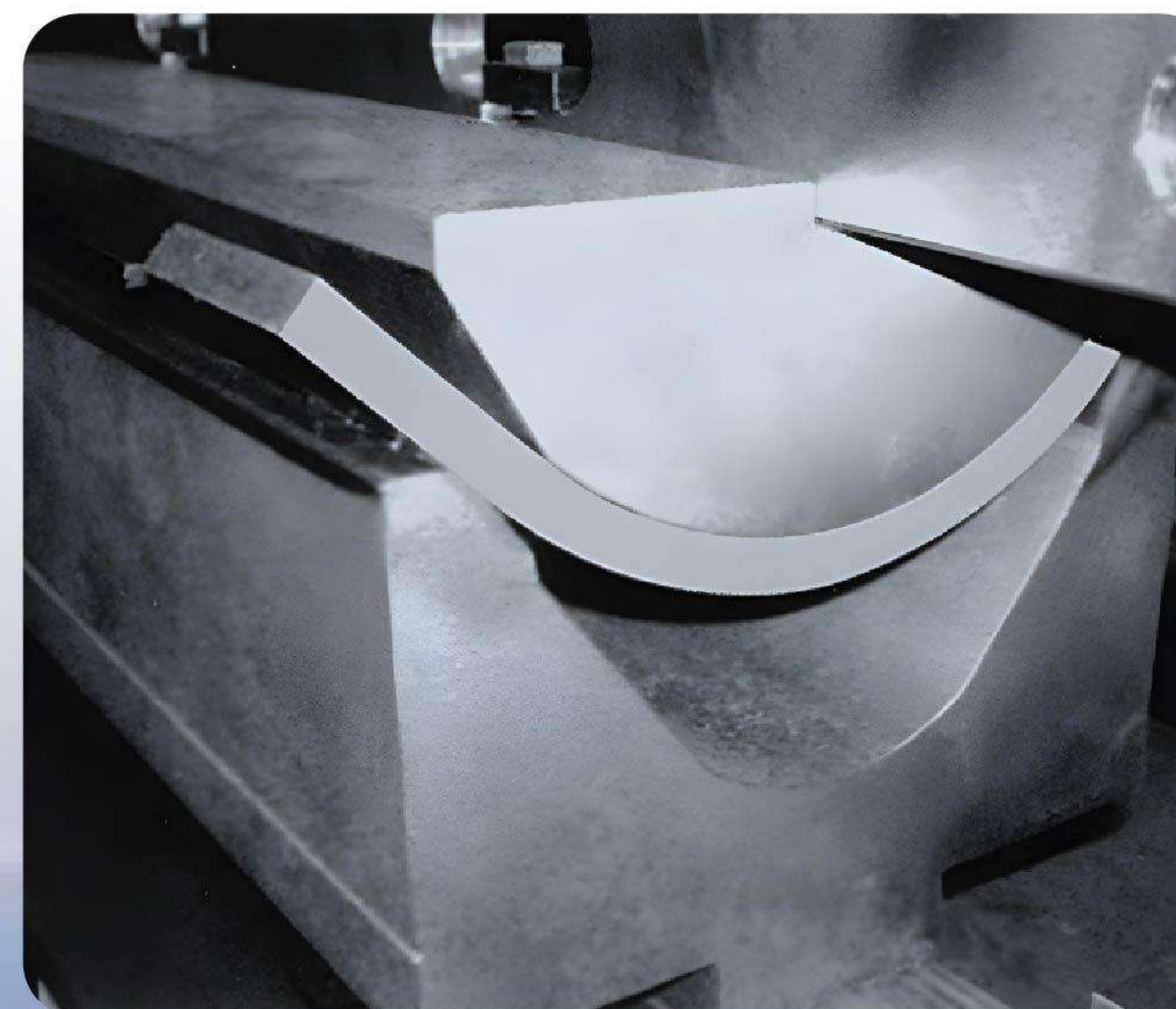
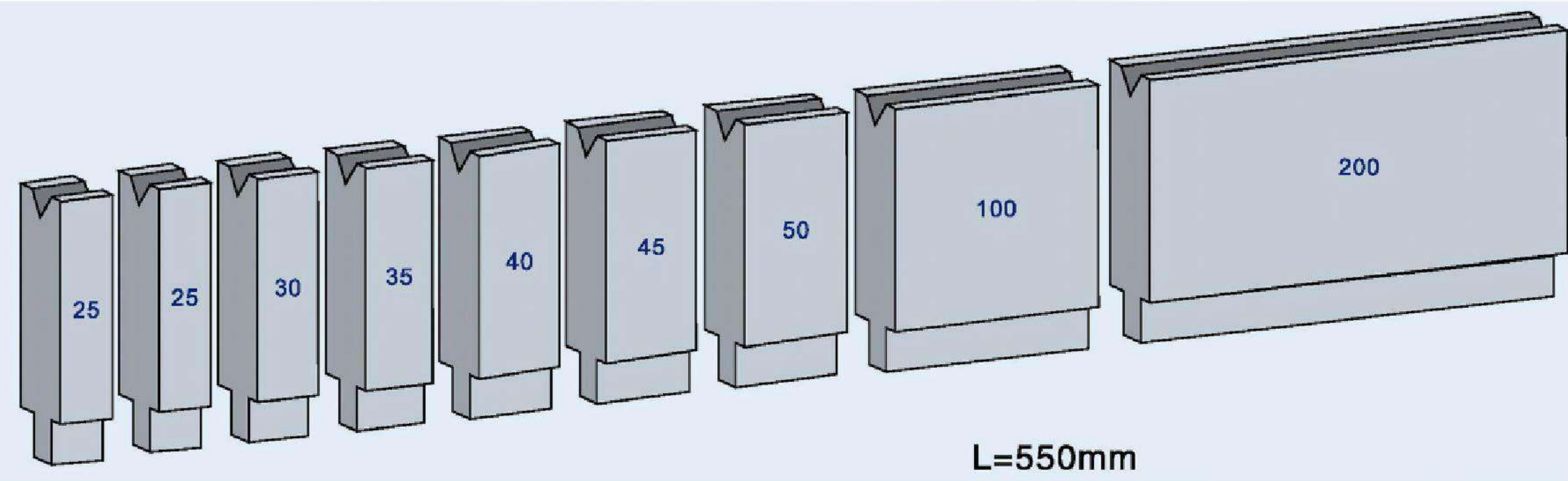
YM60 60°

V	A	R	S	Rf/P	T/M
60	60°	7.0	80	15	100



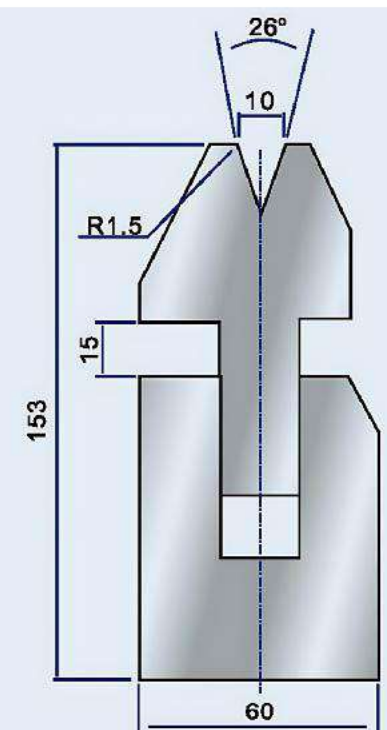
YM50 60°

V	A	R	S	Rf/P	T/M
50	60°	5.0	70	15	100

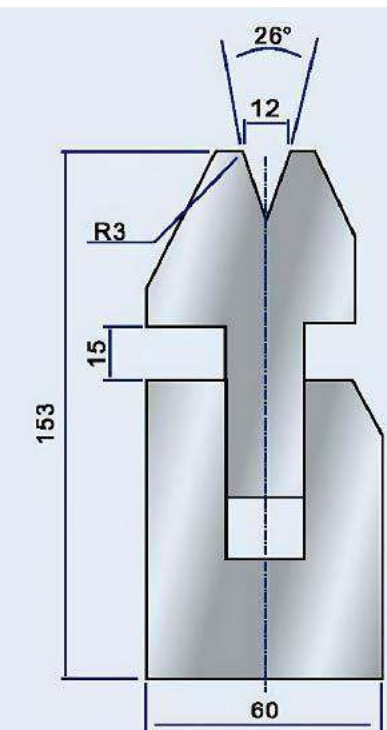


AMADA 压边模具

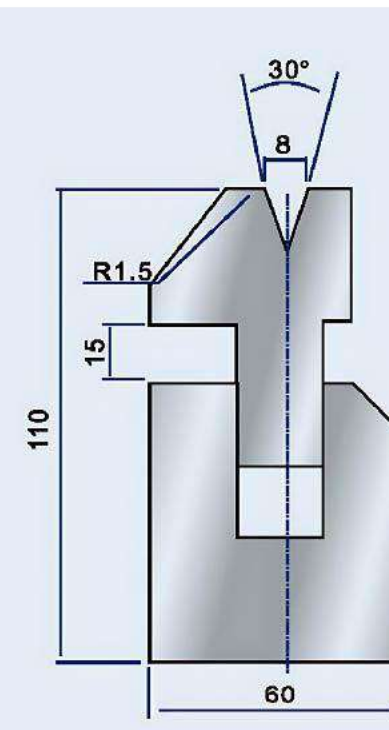
PSS31 26°



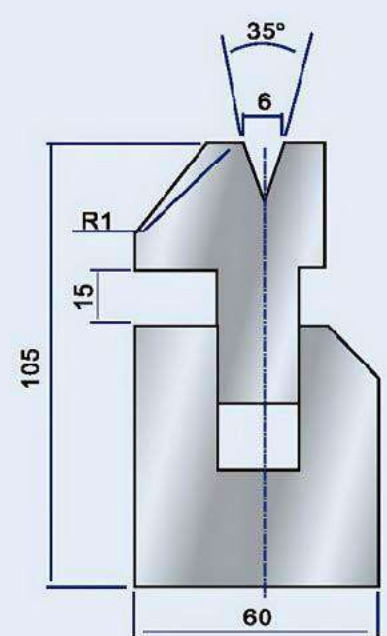
PSS32 26°



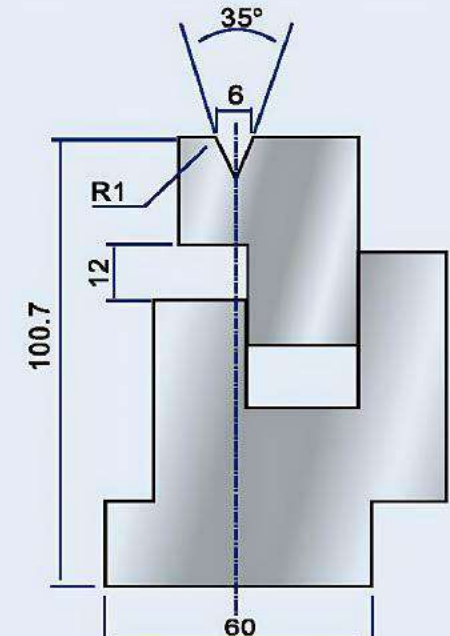
PSS32 30°



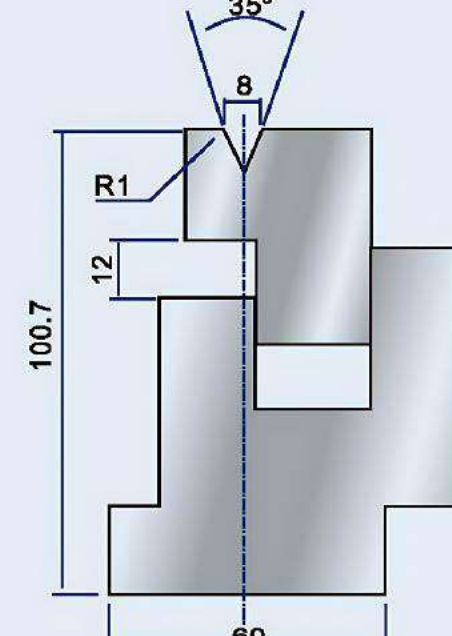
PSS33 35°



PSS35 35°

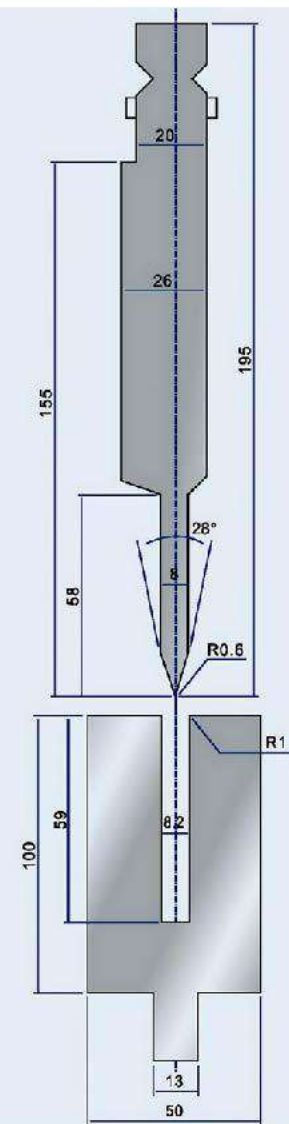


PSS32 30°

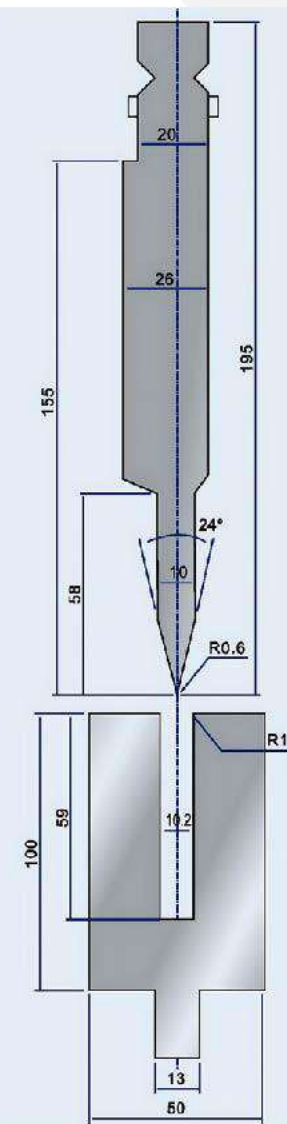


欧式压边模具

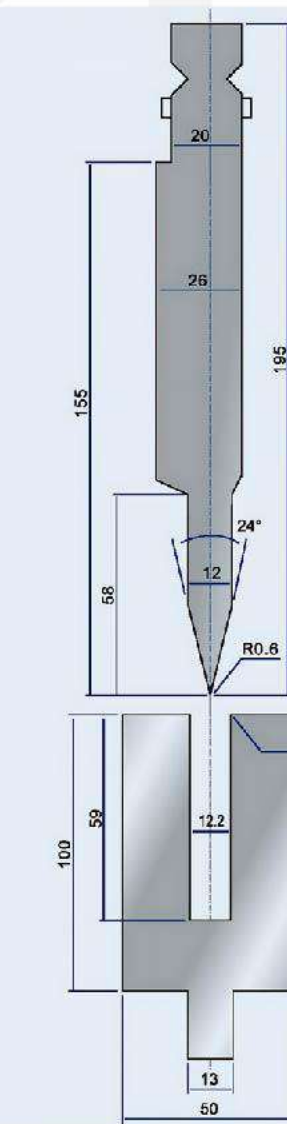
PSS41 28°



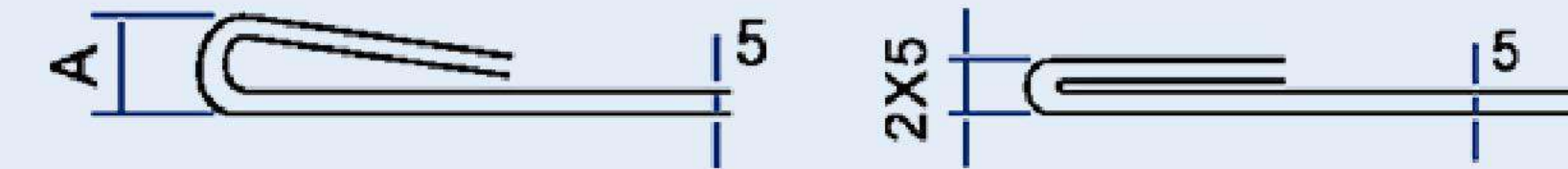
PSS42 24°



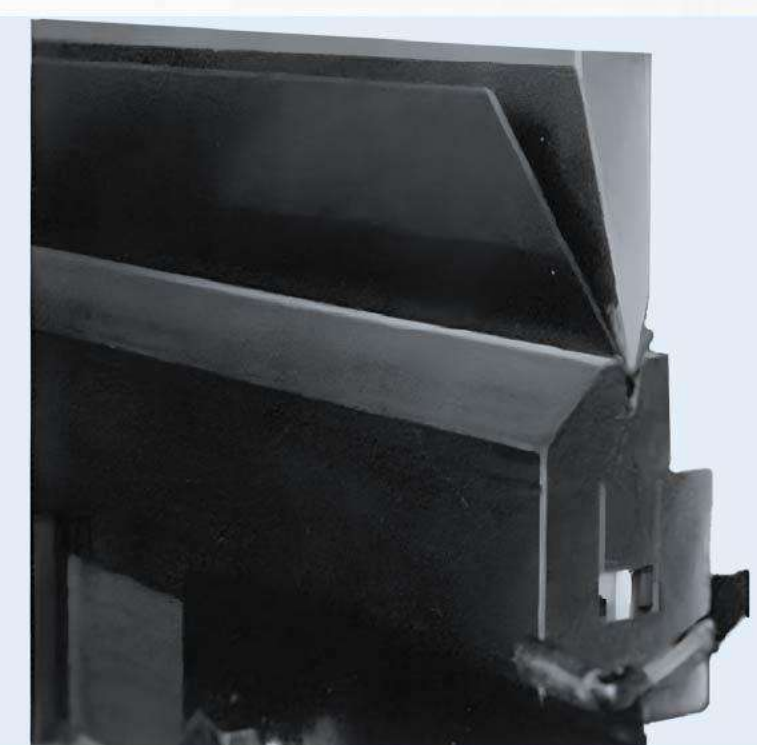
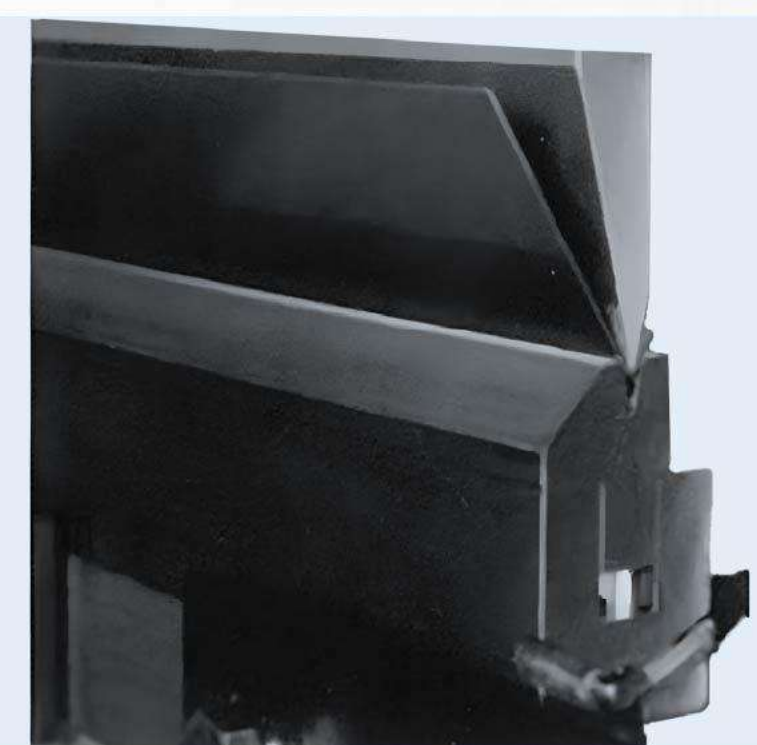
PSS43 24°



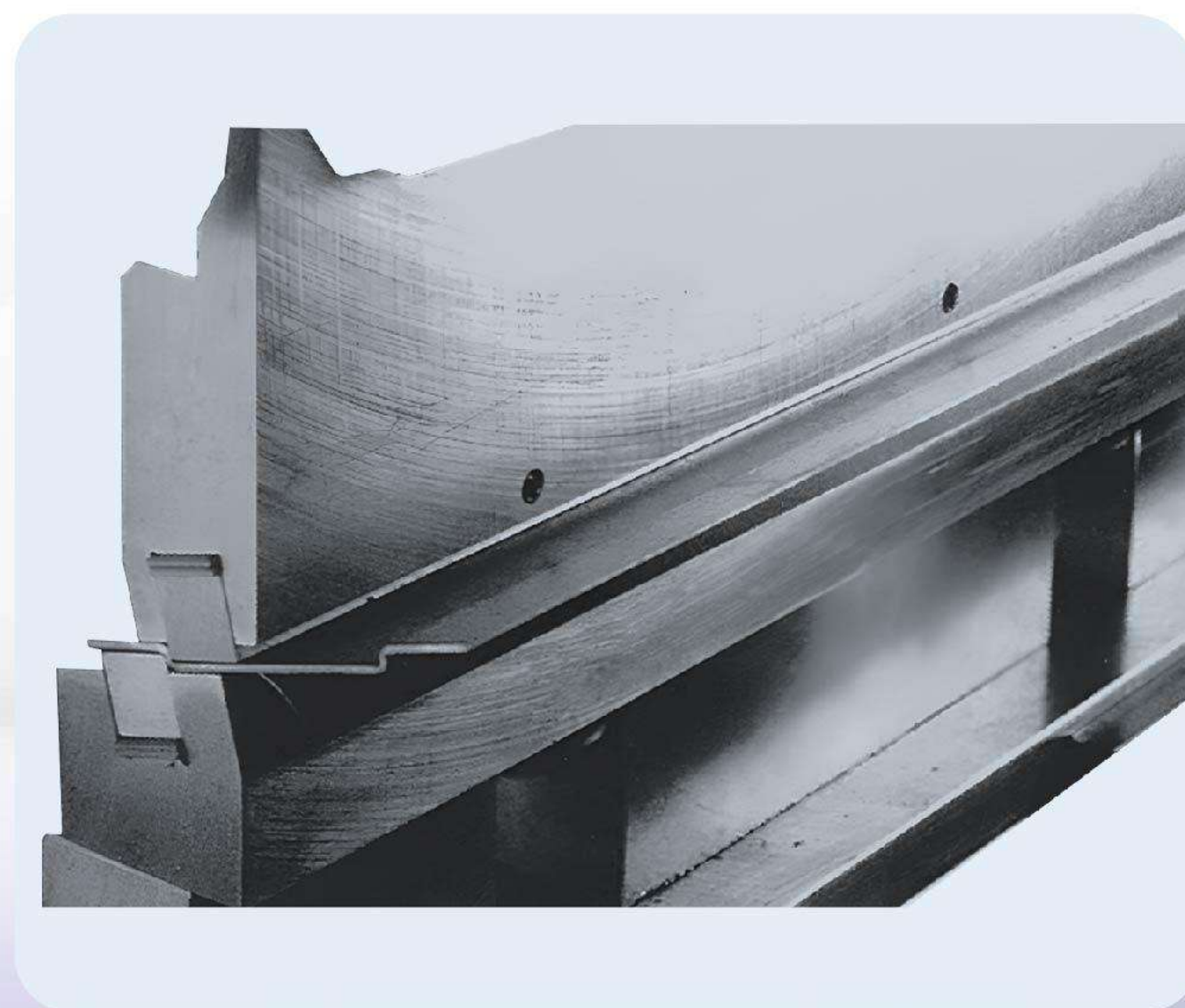
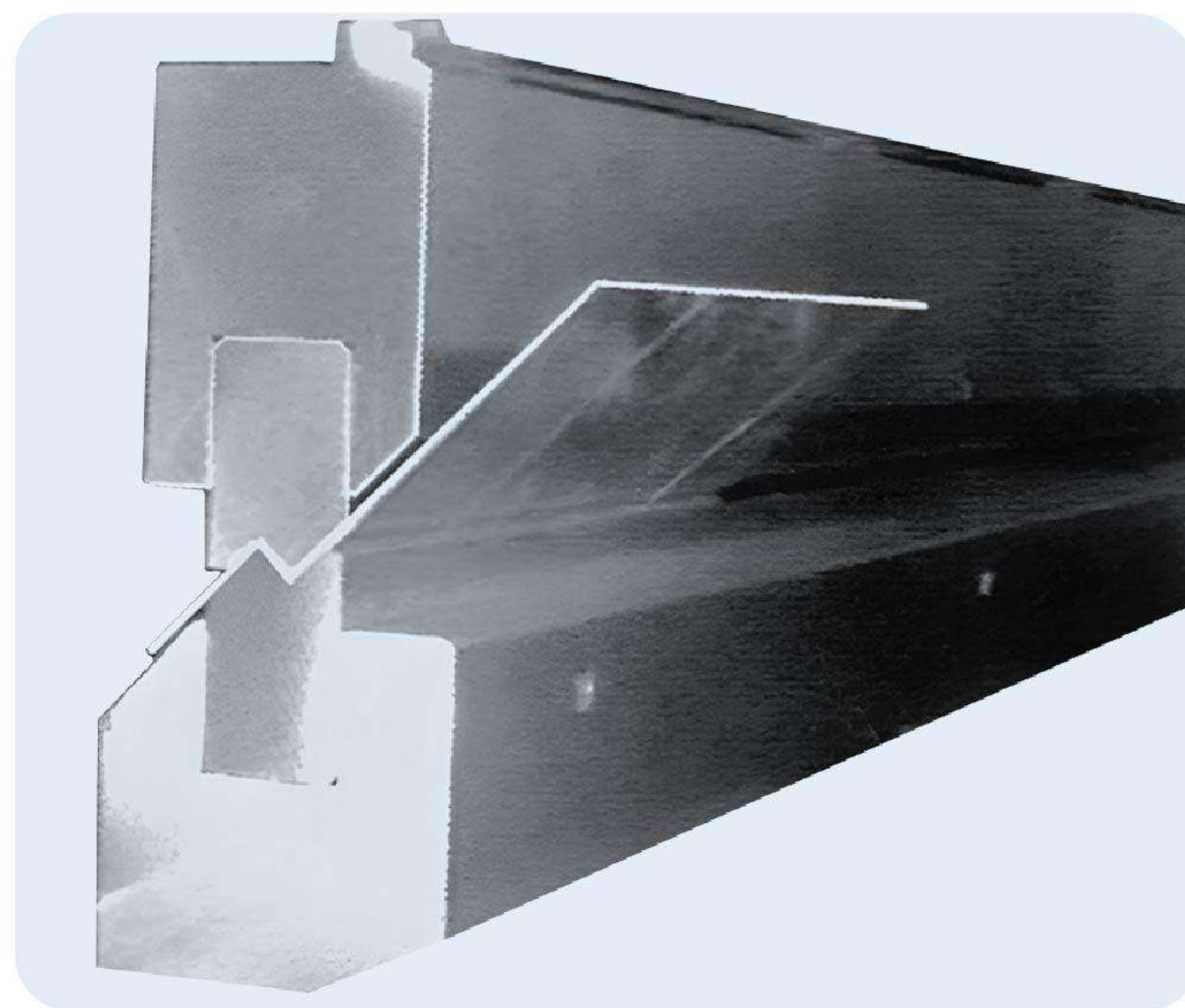
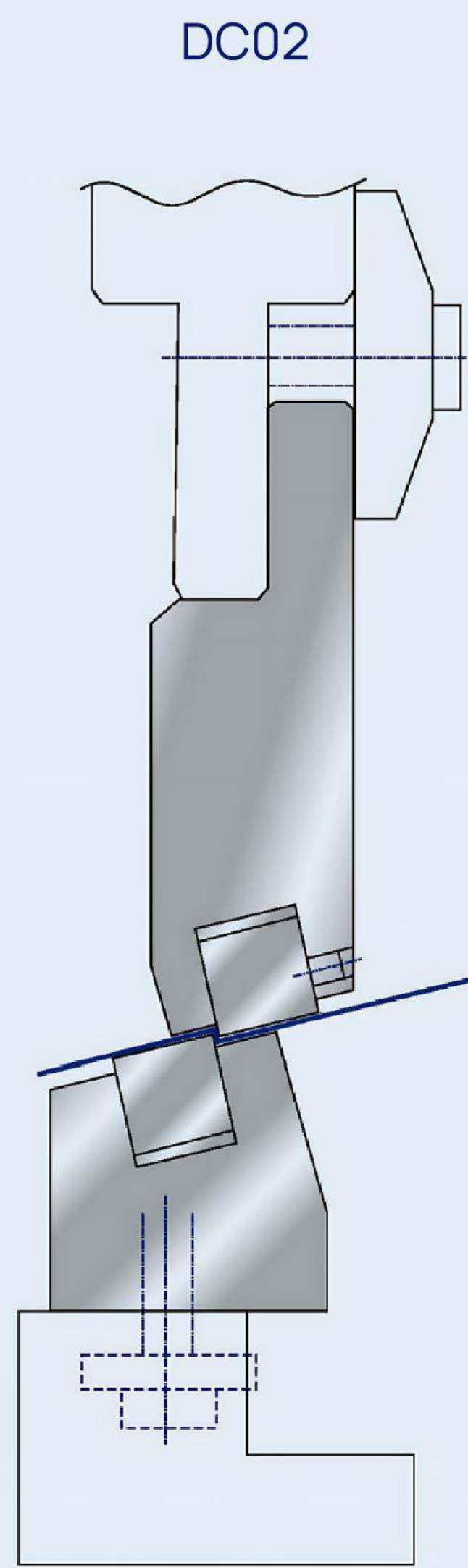
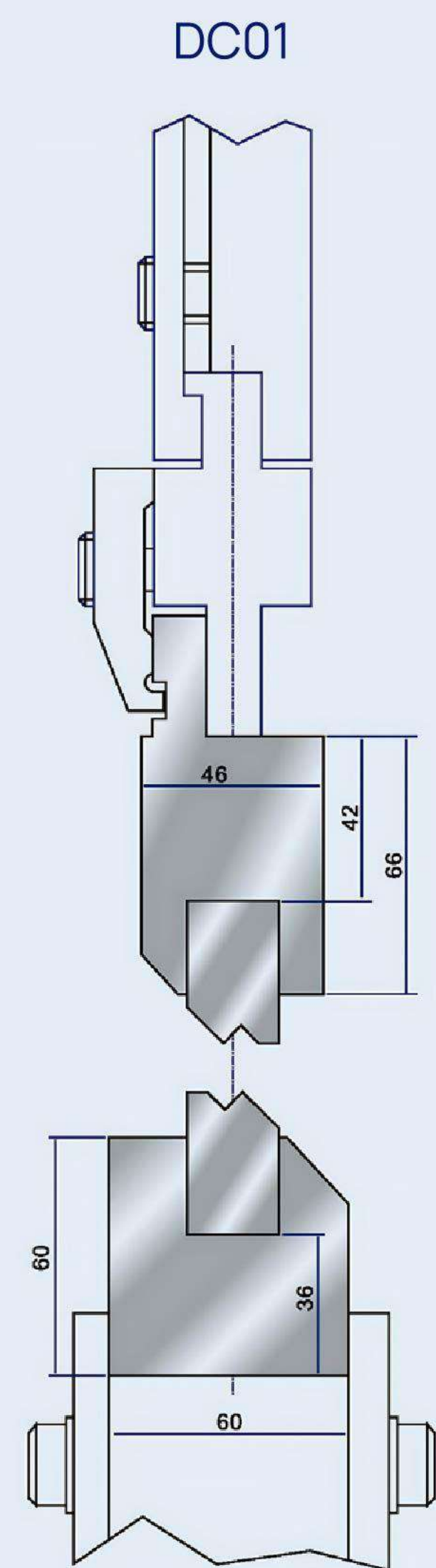
Smm	Amm	Ton/M	2XS	Ton/M
0.6	3	9	1.2	23
0.8	3	12	1.6	32
1	3.5	15	2	40
1.25	3.5	17	2.5	50
1.5	4.6	22	3	63
2	5.5	30	4	80
2.5	6.5	55	5	90
3	8	70	6	100



Smm	Amm	Ton/M	2XS	Ton/M
0.6	3	15	1.2	35
0.8	3	20	1.6	50
1	3.5	25	2	60
1.25	3.5	26	2.5	80
1.5	4.6	38	3	95
2	5.5	50	4	130

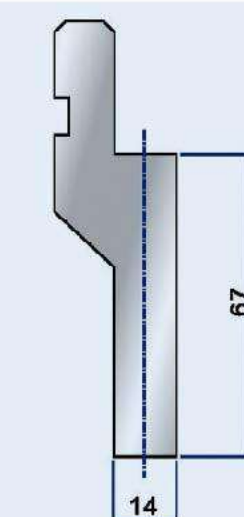


Z形阶梯成形模具

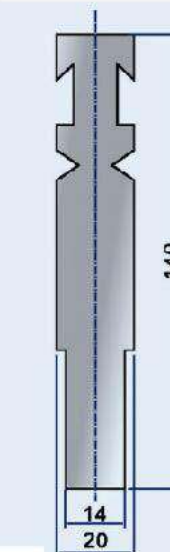


圆角成形模具

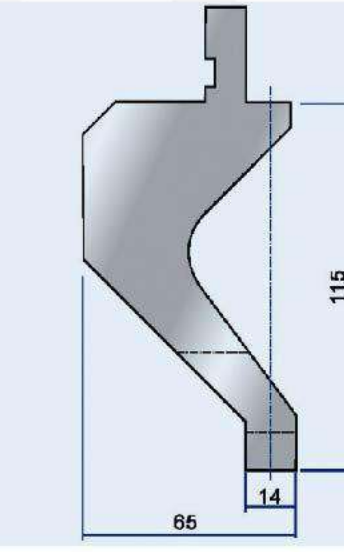
LB01



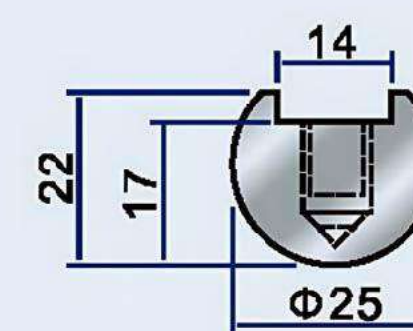
LB02



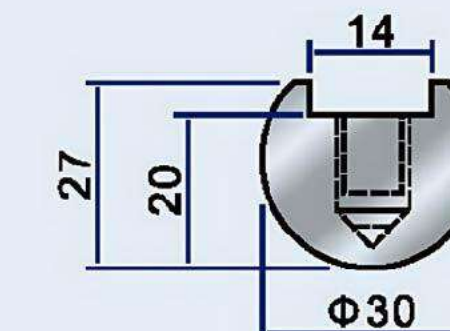
LB03



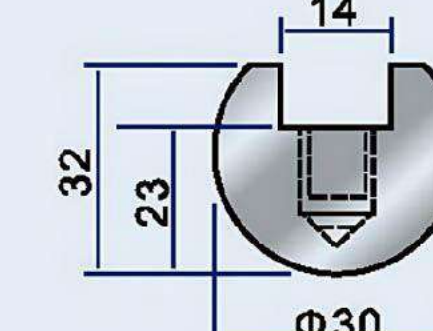
LTR12.5



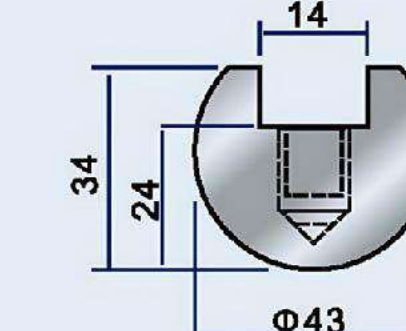
LTR15



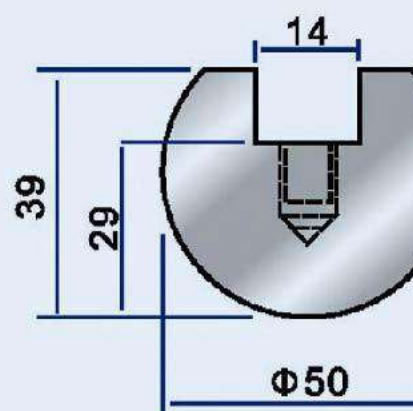
LTR17.5



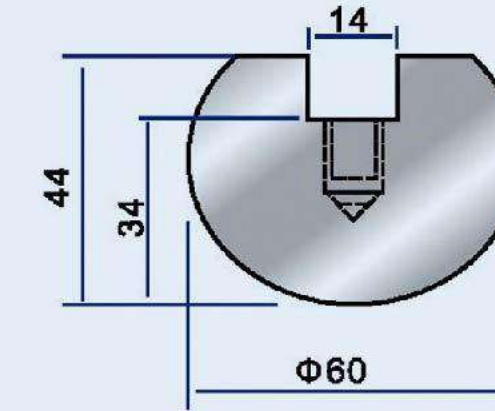
LTR20



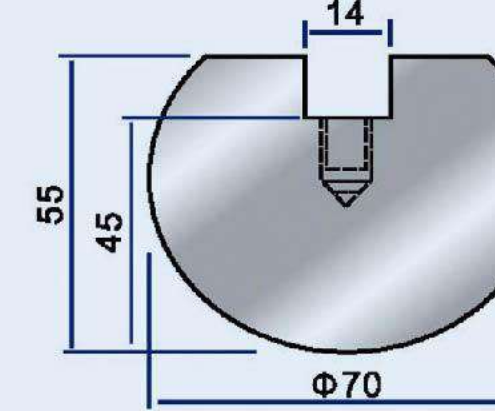
LTR25



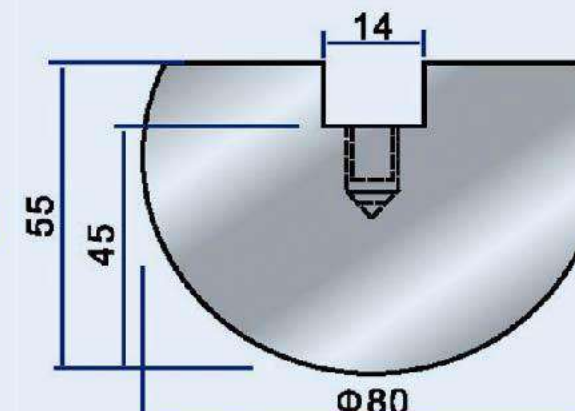
LTR30



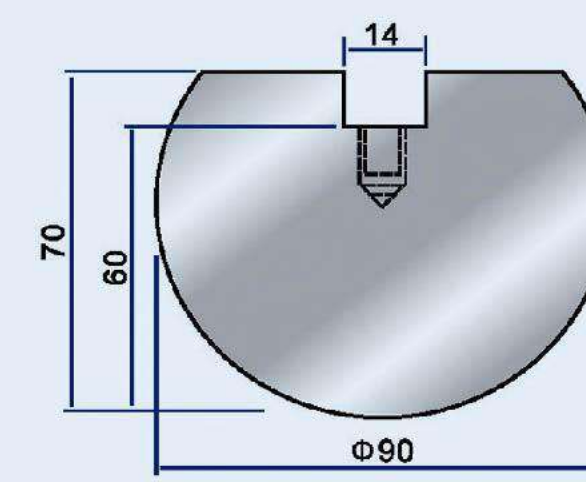
LTR35



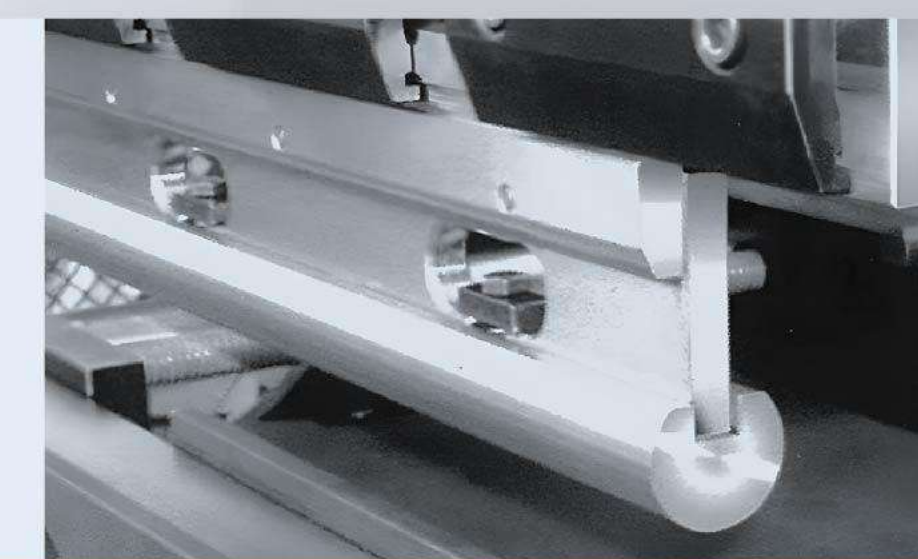
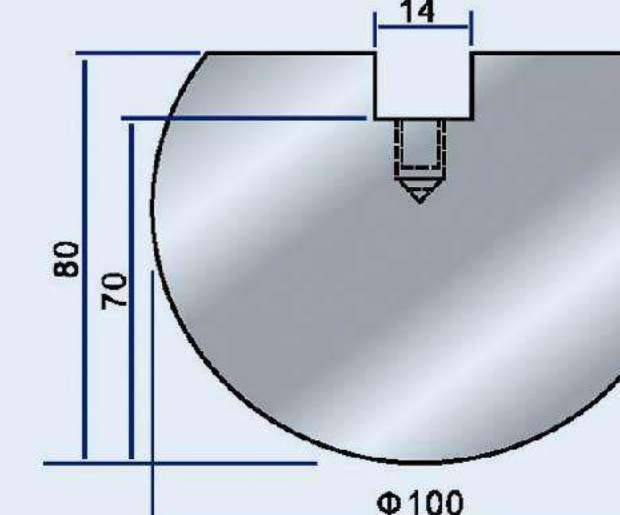
LTR40



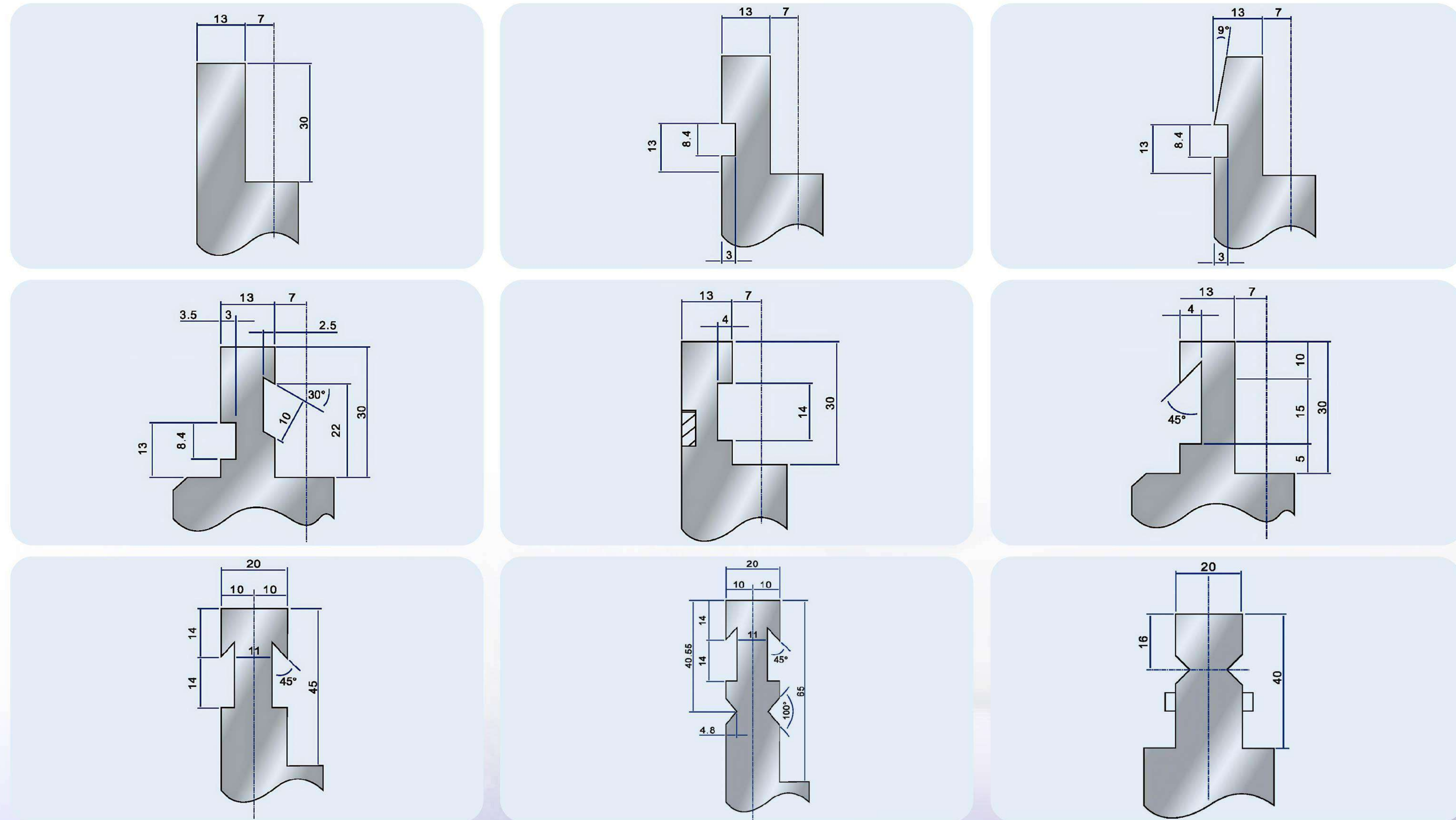
LTR45



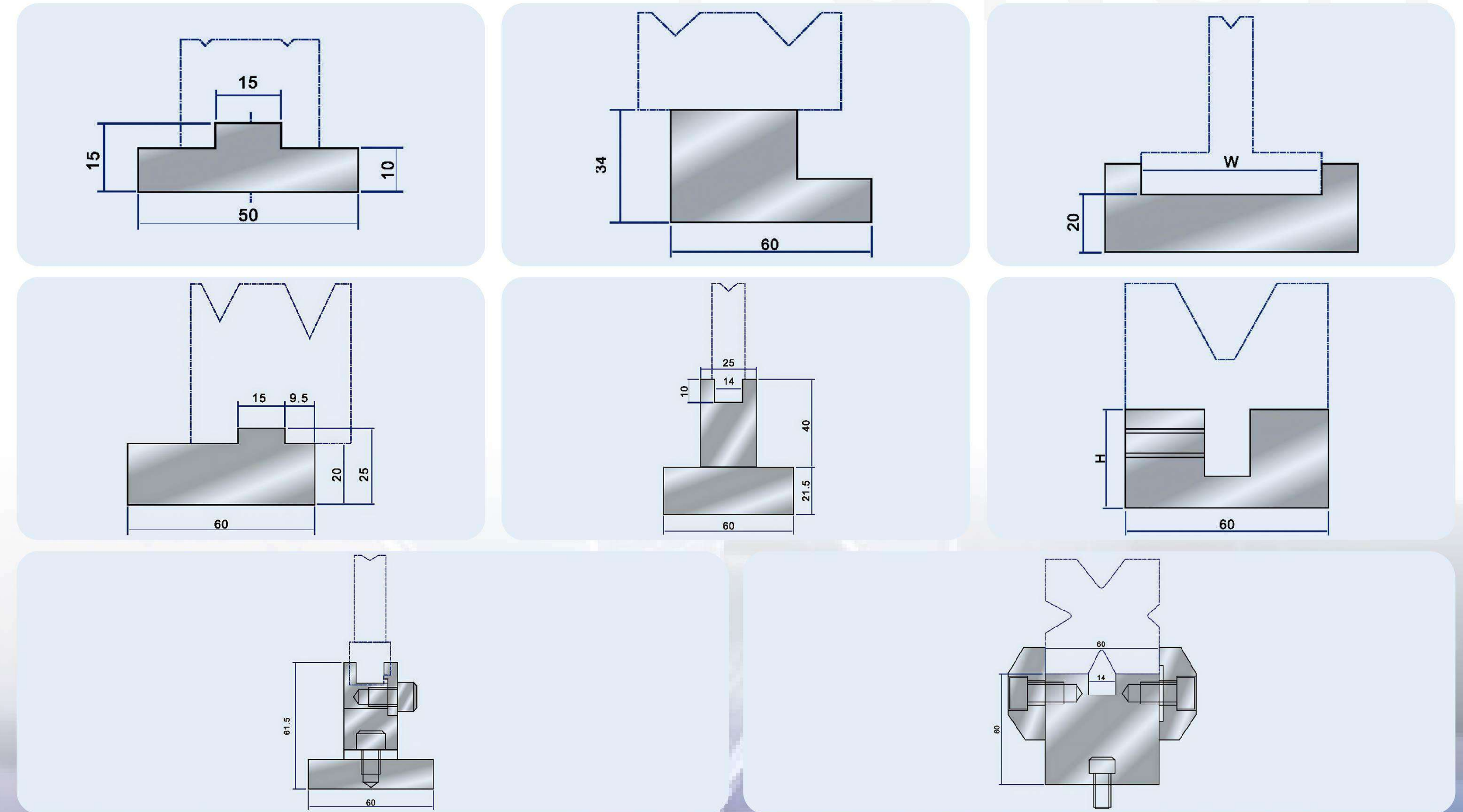
LB02



模具存放架



模具安装导轨



标准折弯机冲头

PUNCH

LG01
30°

R	T/M
0.5	60
0.8	60
1.0	60

LG02
30°

R	T/M
0.5	60
0.8	60
1.0	60

LG03
88°

R	T/M
0.5	80
0.8	80
1.0	80

LG04
88°

R	T/M
0.5	80
0.8	80
1.0	80

LG05
88°

R	T/M
0.5	120
0.8	120
1.0	120

LG06
88°

R	T/M
0.5	60
0.8	60
1.0	60

LB01

LB02

LB03

LB04

LB05

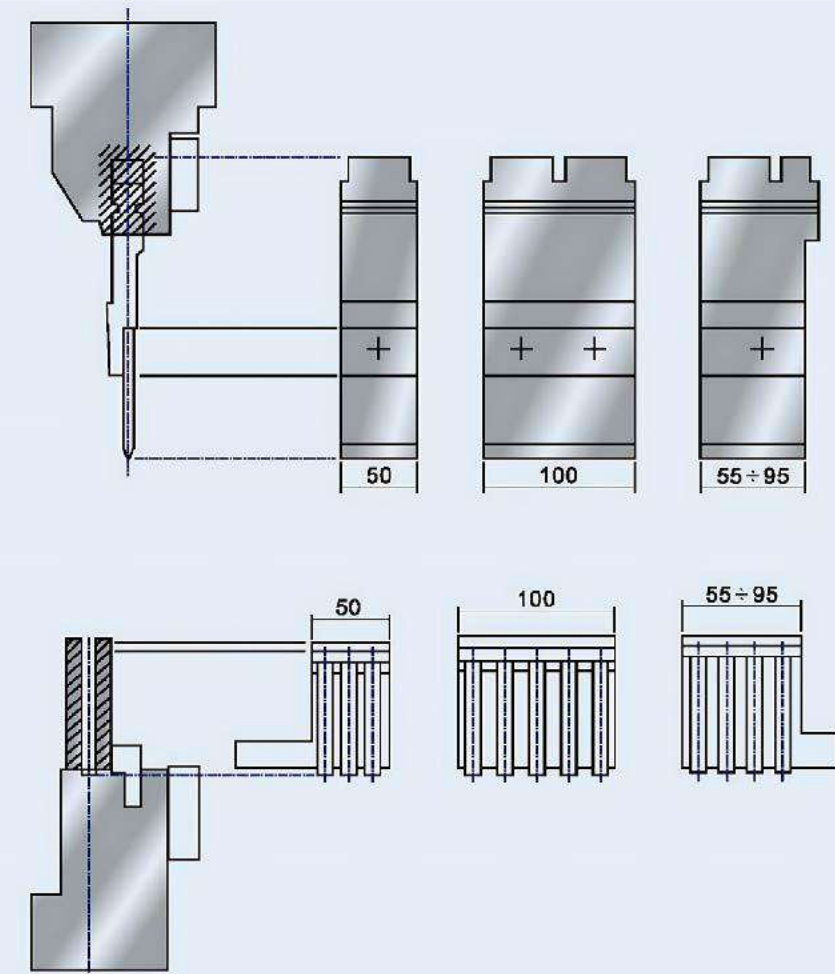
LB06

LB07

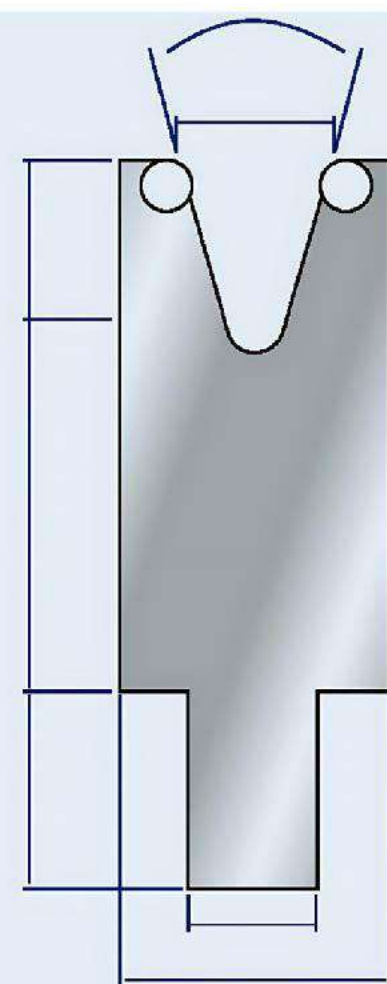
LB08

LB09

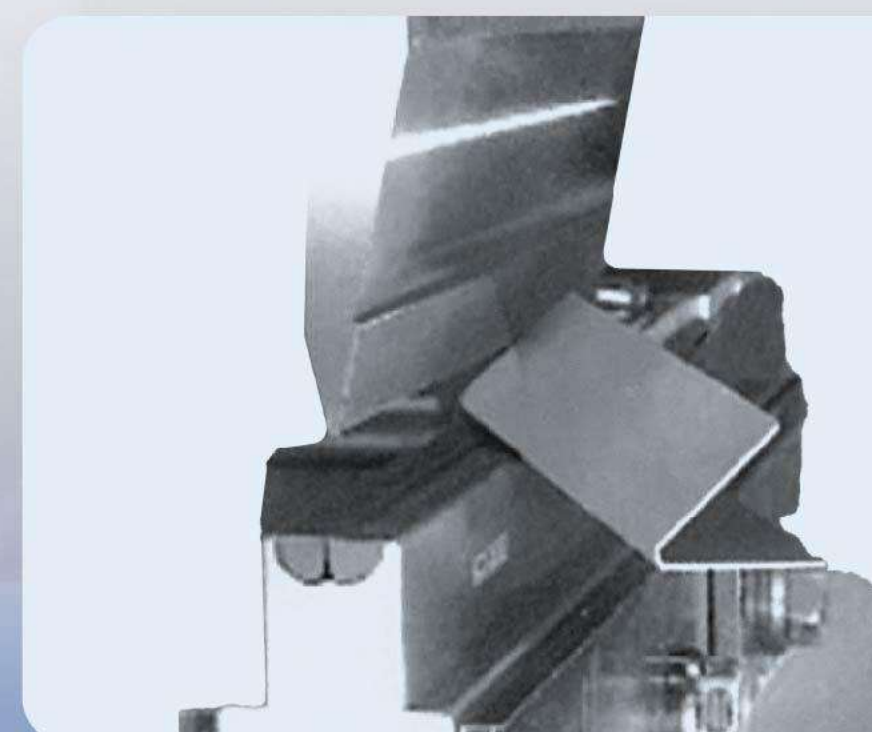
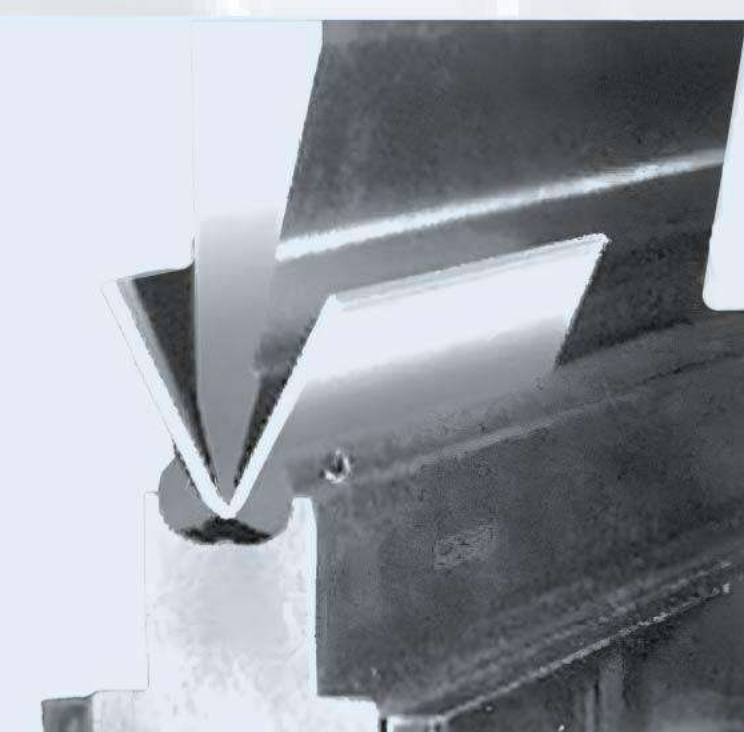
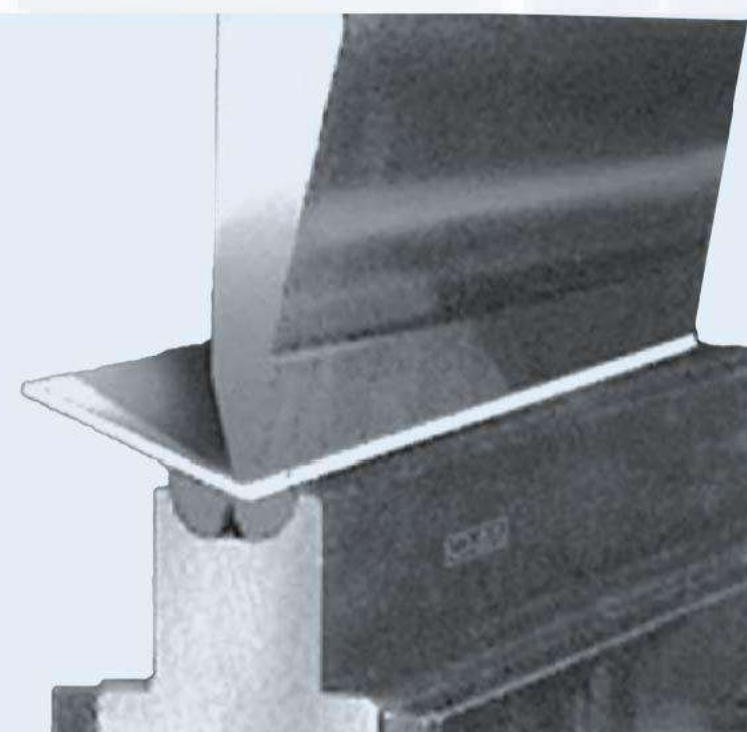
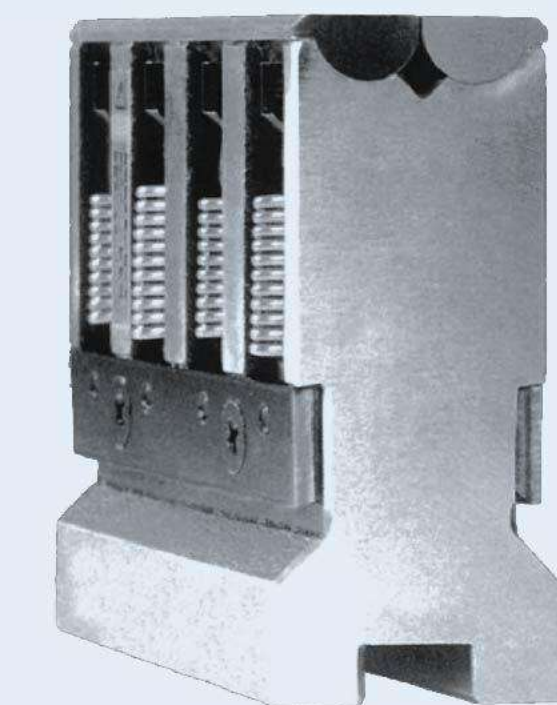
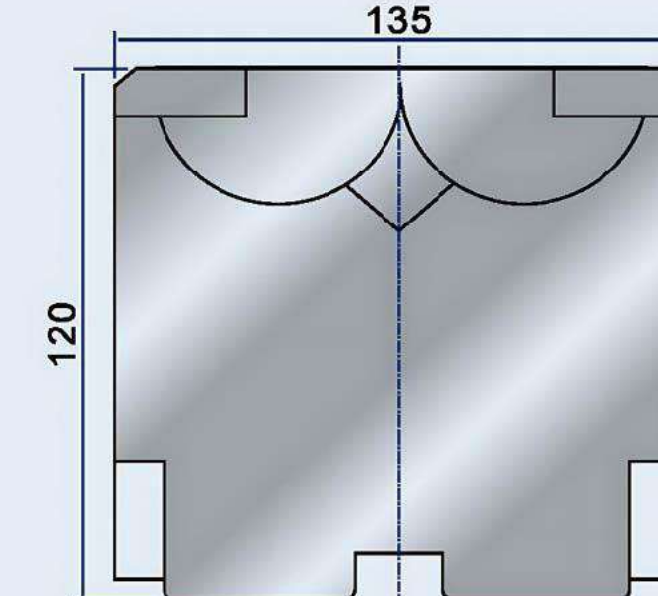
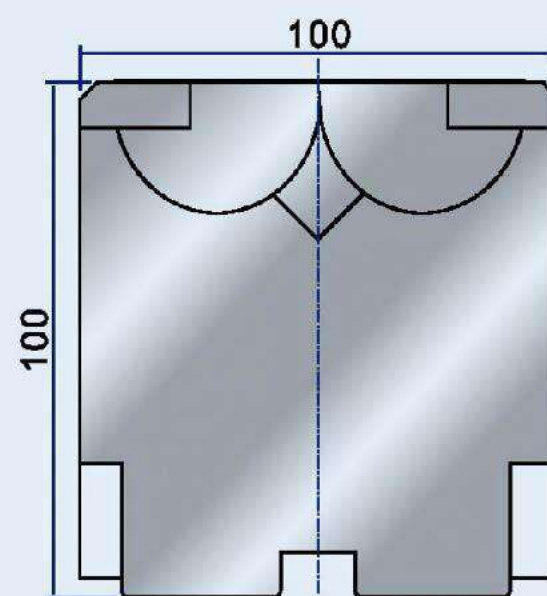
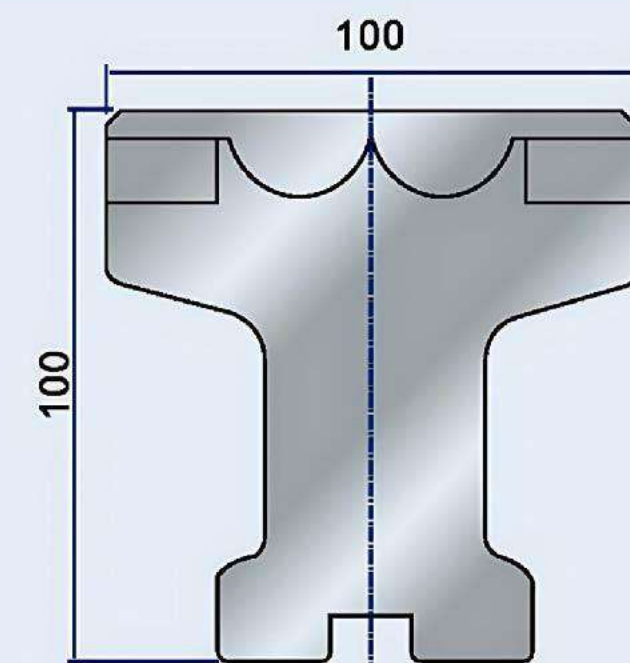
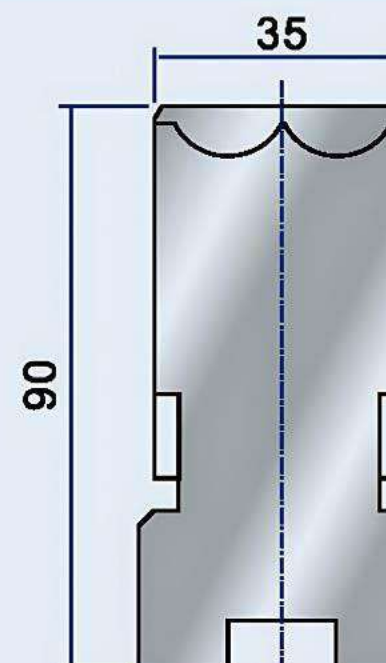
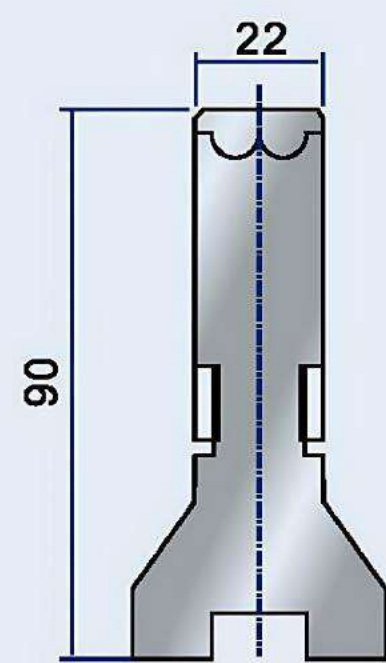
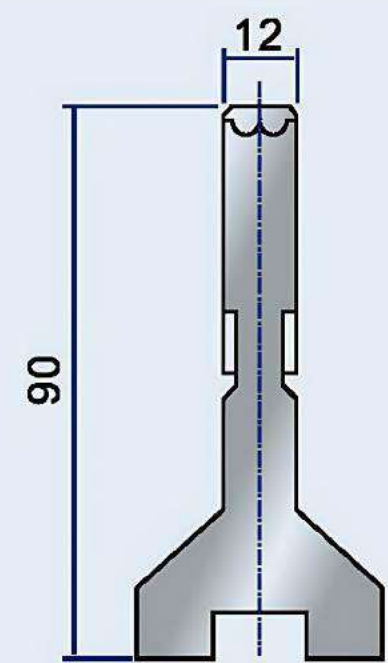
三点式模具



耐刮擦模具



标准耐磨模具

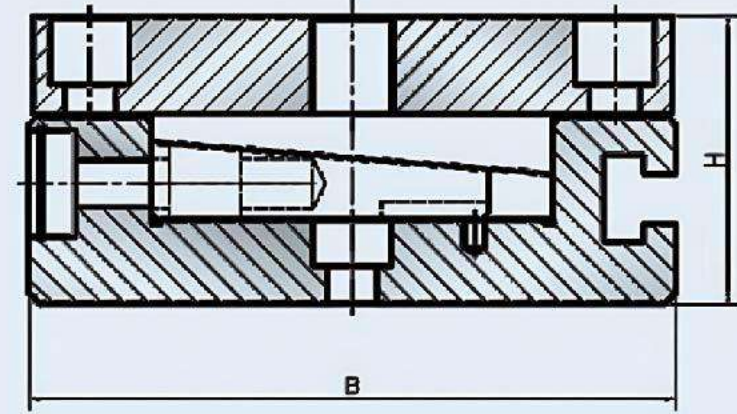


PUNCH

折弯机补偿表

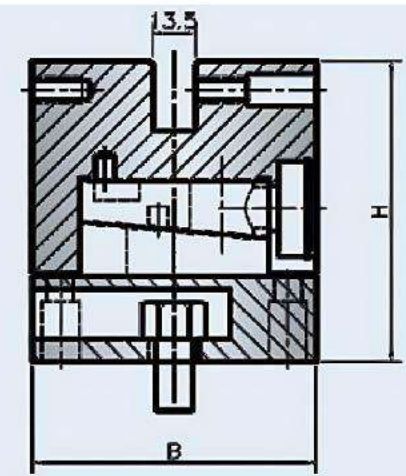
水平补偿

BGT-A1



技术规格 (毫米)				调节	产品型号
L	B	H	最大补偿值		
2500	180	80	1.0	手动	BGT-2500x180x80/A1
3200					BGT-3200x180x80/A1
4000					BGT-4000x180x80/A1
2500	200	80			BGT-2500x200x80/A1
3200					BGT-3200x200x80/A1
4000					BGT-4000x200x80/A1
2500	220	80	BGT-2500x220x80/A1		
3200			BGT-3200x220x80/A1		
4000			BGT-4000x220x80/A1		
3200	240	85	1.2	手动	BGT-3200x240x85/A1
4000					BGT-4000x240x85/A1
6000					BGT-6000x240x85/A1
3200	280	90			BGT-3200x280x90/A1
4000					BGT-4000x280x90/A1
6000					BGT-6000x280x90/A1

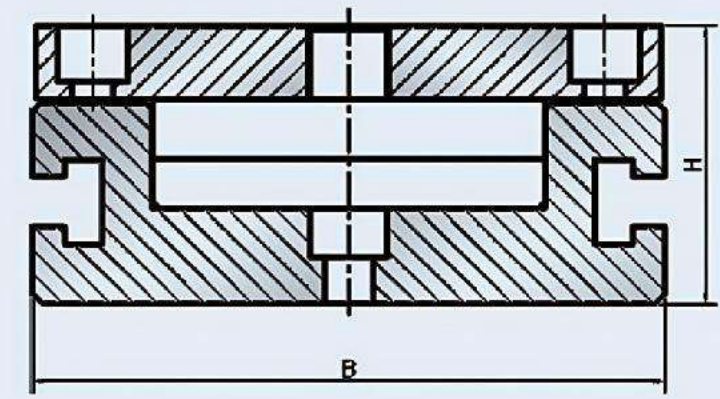
BGT-A2



技术规格 (毫米)				调节	产品型号
L	B	H	最大补偿值		
1050	95	90	1.0	手动	BGT-1050x95x90/A2
1250					BGT-1250x95x90/A2
1500					BGT-1500x95x90/A2
2050					BGT-2050x95x90/A2
2570					BGT-2570x95x90/A2
3100					BGT-3100x95x90/A2
4100					BGT-4100x95x90/A2

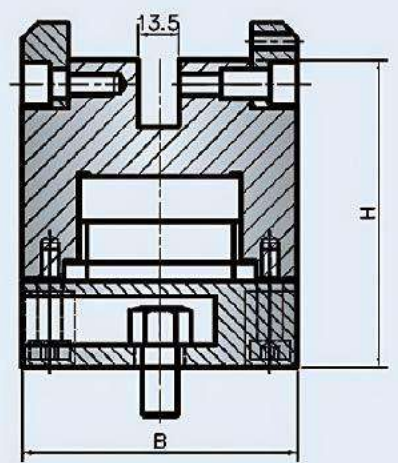
垂直补偿

BGT-B1



技术规格 (毫米)				调节	产品型号
L	B	H	最大补偿值		
2500	180	100	2.0	手动 & 电机	BGT-2500x180x100/B1
3200					BGT-3200x180x100/B1
4000					BGT-4000x180x100/B1
2500					200
3200	BGT-3200x200x100/B1				
4000	BGT-4000x200x100/B1				
2500	220	100			BGT-2500x220x100/B1
3200					BGT-3200x220x100/B1
4000			BGT-4000x220x100/B1		
3200	240	100	BGT-3200x240x100/B1		
4000			BGT-4000x240x100/B1		
6000			BGT-6000x240x100/B1		
3200	280	100	BGT-3200x280x100/B1		
4000			BGT-4000x280x100/B1		
6000			BGT-6000x280x100/B1		

BGT-B2

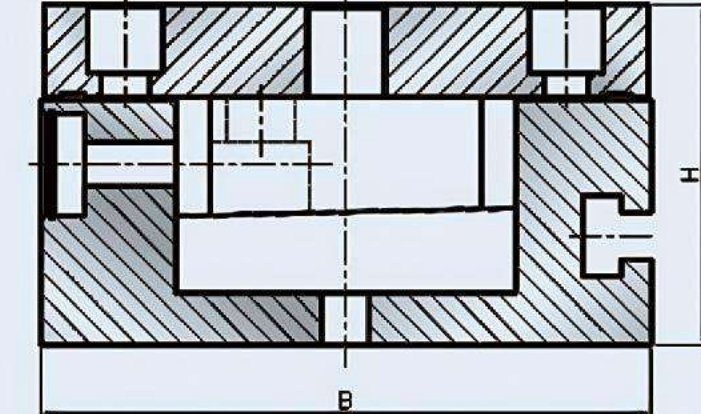


技术规格 (毫米)				调节	产品型号
L	B	H	最大补偿值		
1050	95	90	2.0	手动 & 电机	BGT-1050x95x90/B2
1250					BGT-1250x95x90/B2
1500					BGT-1500x95x90/B2
2050					BGT-2050x95x90/B2
2570					BGT-2570x95x90/B2
3100					BGT-3100x95x90/B2
4100					BGT-4100x95x90/B2

双向补偿

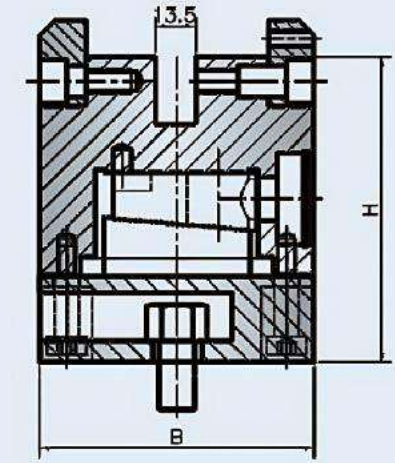
水平补偿

BGT-C1



技术规格 (毫米)			最大补偿值		调节	产品型号
L	B	H	水平	垂直		
2500	180	100	2.0	0.5	手动 + 手动 和 手动 + 电动	BGT-2500x180x100/C1
3200						BGT-3200x180x100/C1
4000						BGT-4000x180x100/C1
2500						200
3200	BGT-3200x200x100/C1					
4000	BGT-4000x200x100/C1					
2500	220	100				BGT-2500x220x100/C1
3200						BGT-3200x220x100/C1
4000			BGT-4000x220x100/C1			
3200	240	100	BGT-3200x240x100/C1			
4000			BGT-4000x240x100/C1			
6000			BGT-6000x240x100/C1			
3200	280	110	BGT-3200x280x100/C1			
4000			BGT-4000x280x100/C1			
6000			BGT-6000x280x100/C1			

BGT-C2

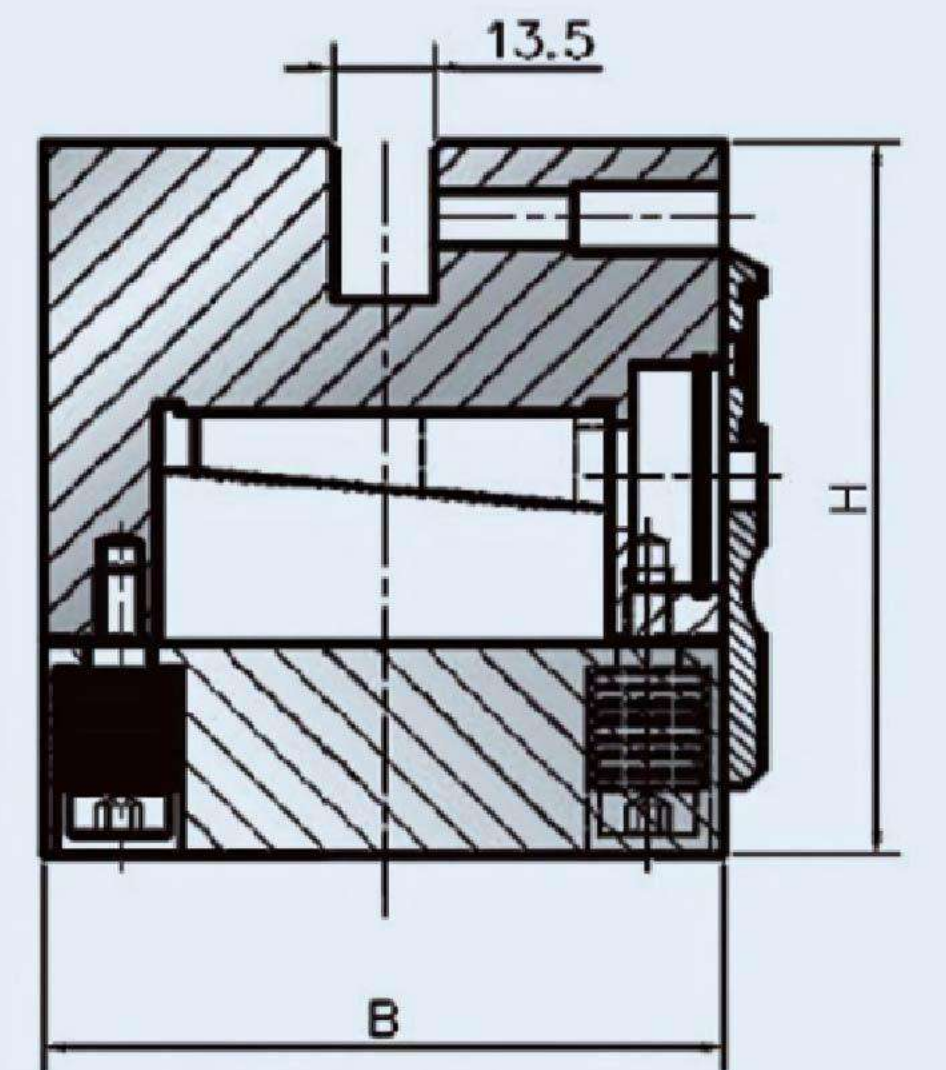


技术规格 (毫米)			最大补偿值		调节	产品型号
L	B	H	水平	垂直		
1050	95	100	2.0	0.5	手动 + 手动 和 手动 + 电动	BGT-1050x90x100/C2
2050						BGT-2050x90x100/C2
2570						BGT-2570x90x100/C2
3100						BGT-3100x90x100/C2
4100						BGT-4100x90x100/C2

高精度 双向补偿

技术规格 (毫米)			最大补偿值		调节	产品型号
L	B	H	水平	垂直		
2050	90	95	1.33	0.44	手动 + 手动 和 手动 + 电动	BGT-2050x90x95/D
2570			1.55	0.44		BGT-2570x90x95/D
3100			1.85	0.44		BGT-3100x90x95/D
4100			2.00	0.44		BGT-4100x90x95/D

BGT-D1



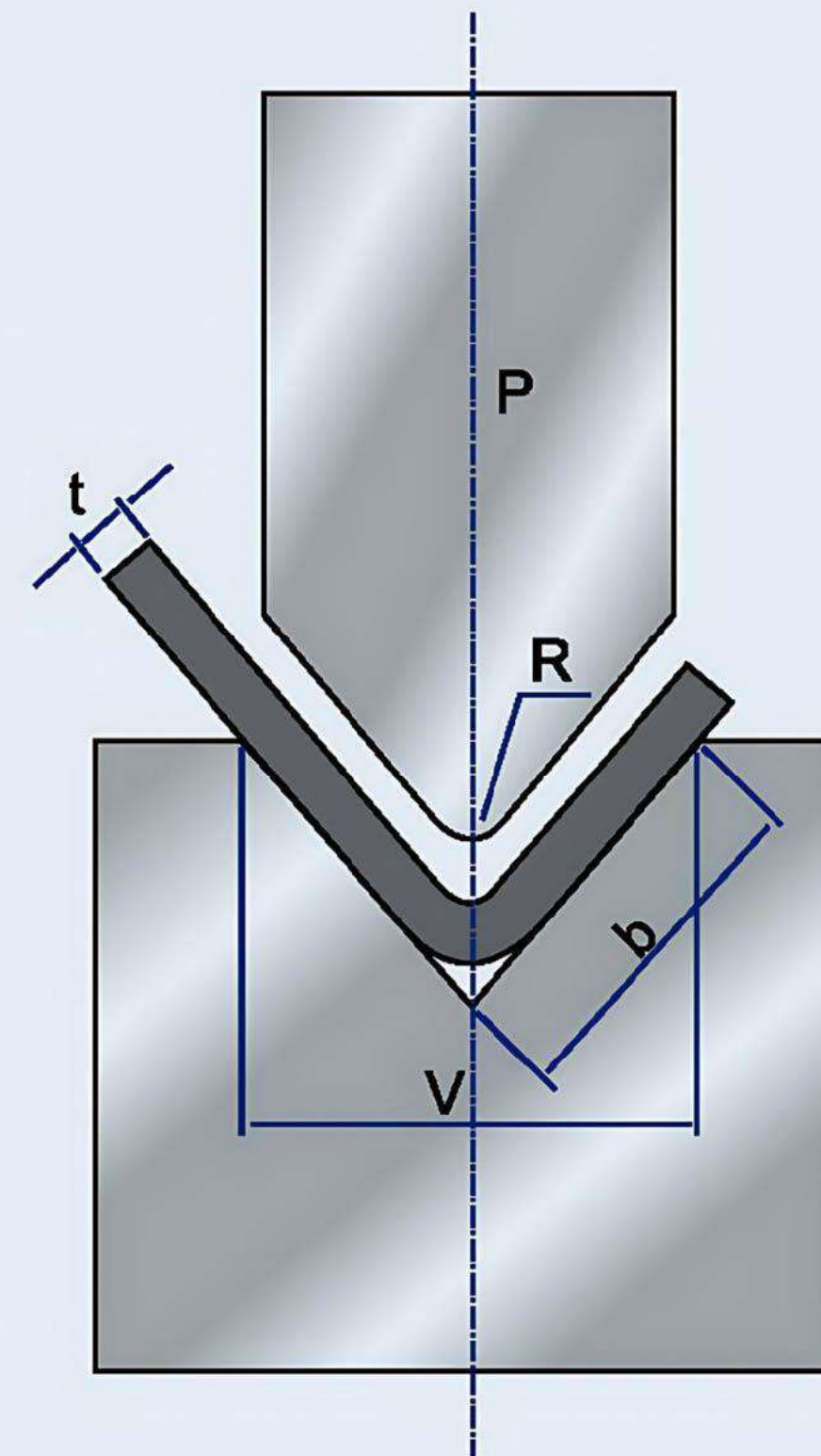
弯曲图表

在确定板材厚度和弯曲内半径后, 请查看该图表。

1. 可查看材料在弯曲时每米所需的压力;
2. 弯曲时下模的V形槽宽度 (V);
3. 弯曲过程中产生的最短边长度 (b)。

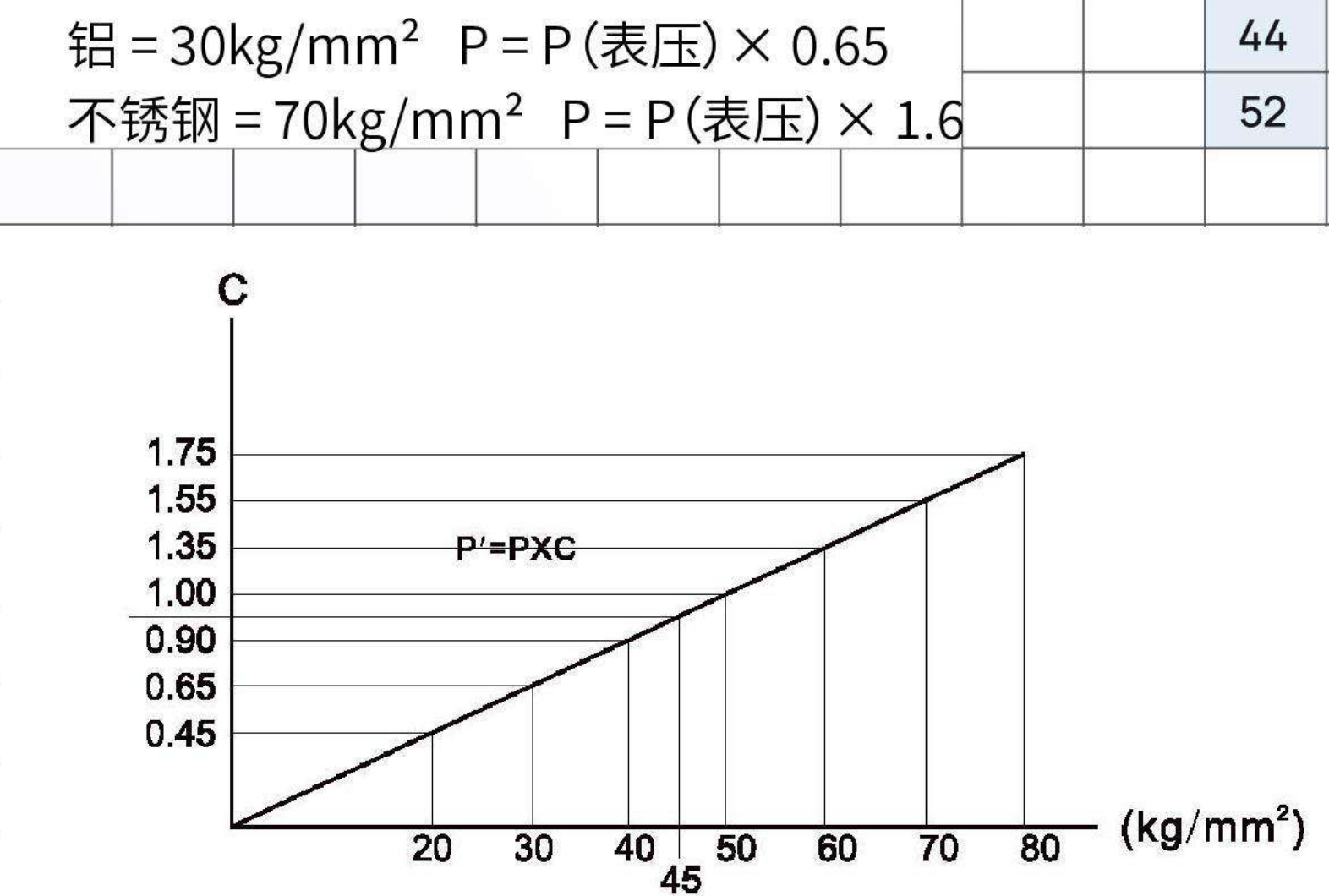
注: 下图显示了不同常规板厚所对应的模具V形槽宽度。

T	0.5~2.6	3.0~8	9~10	12 or higher
V	6t	8t	10t	12t

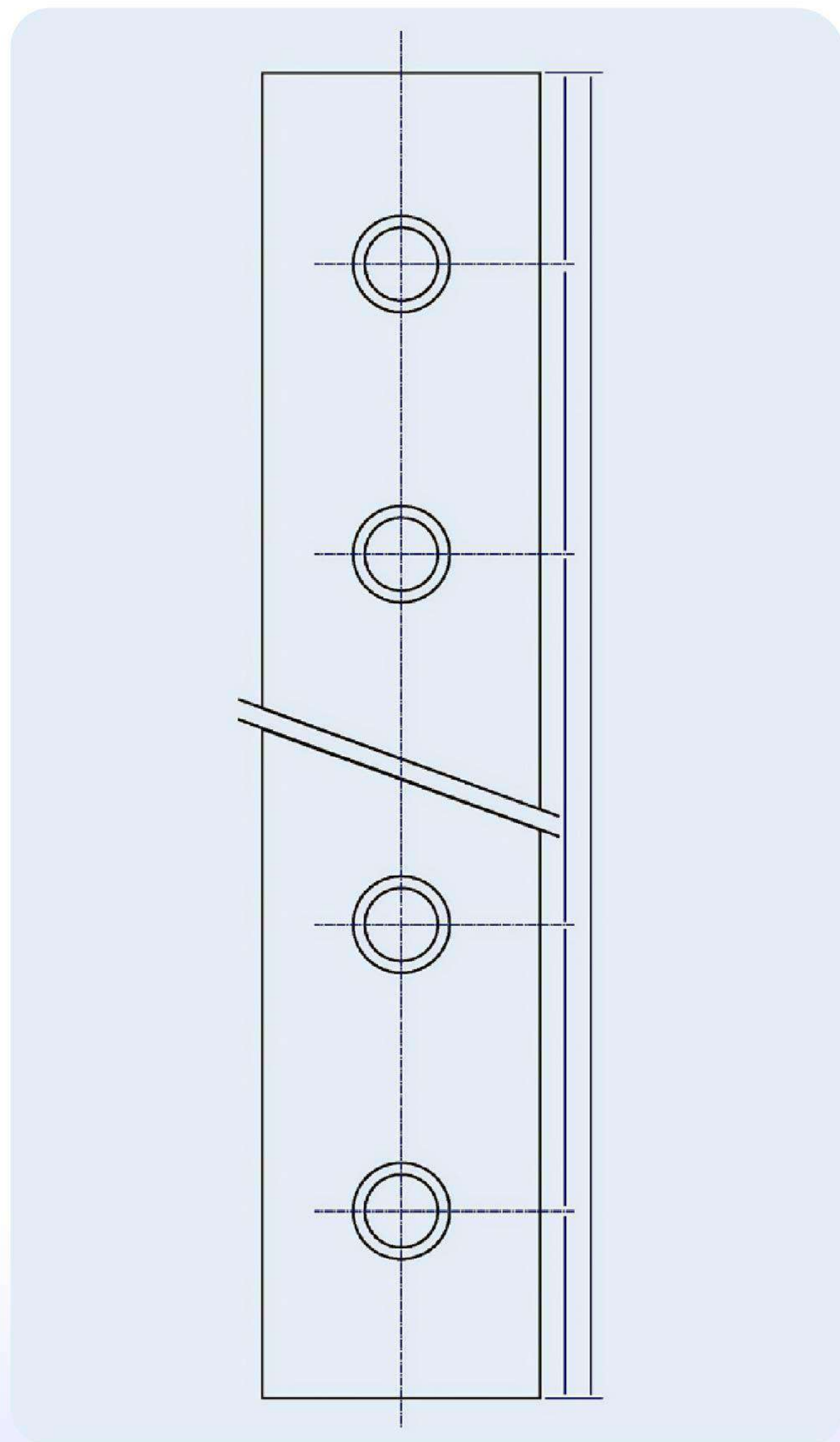
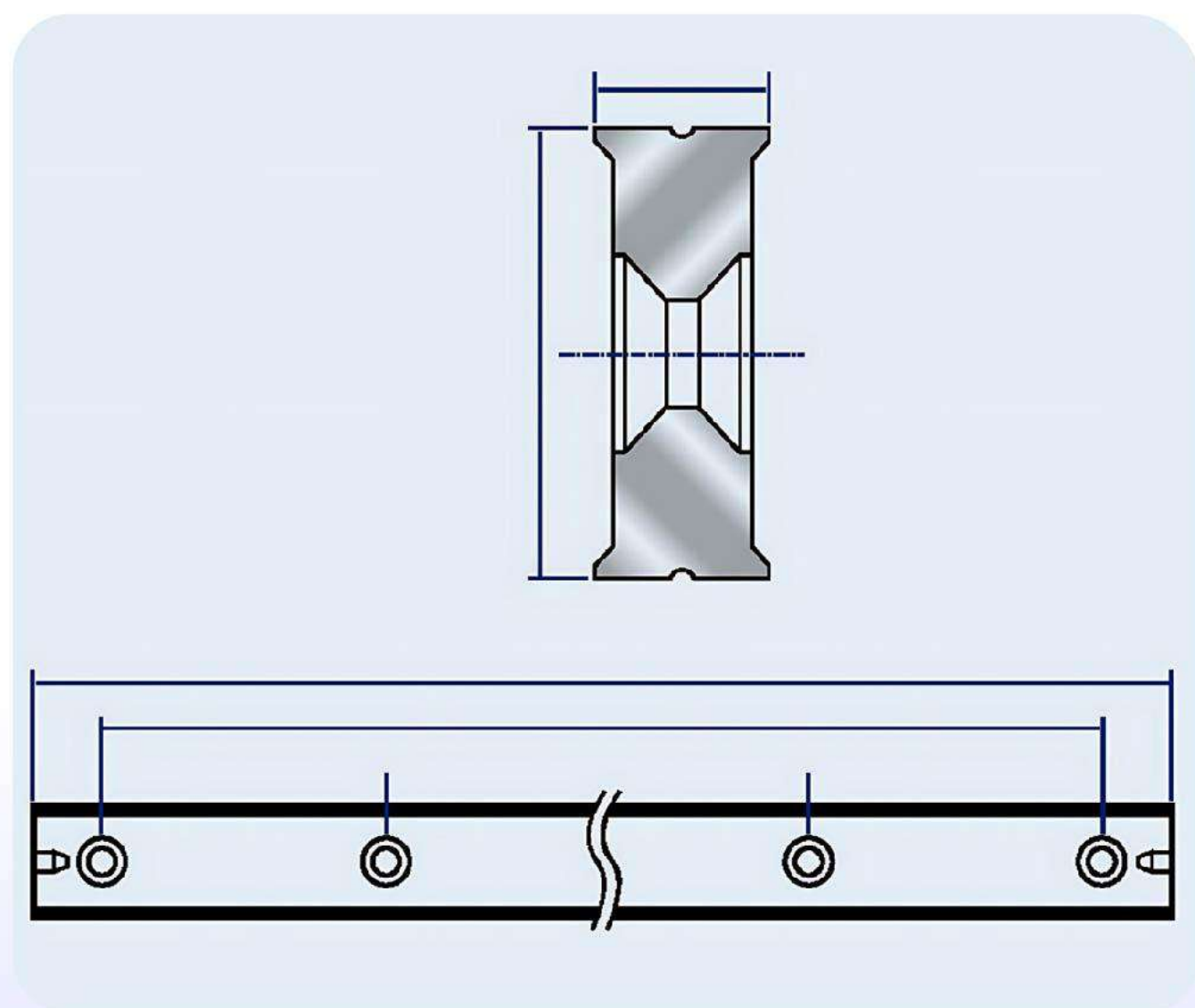
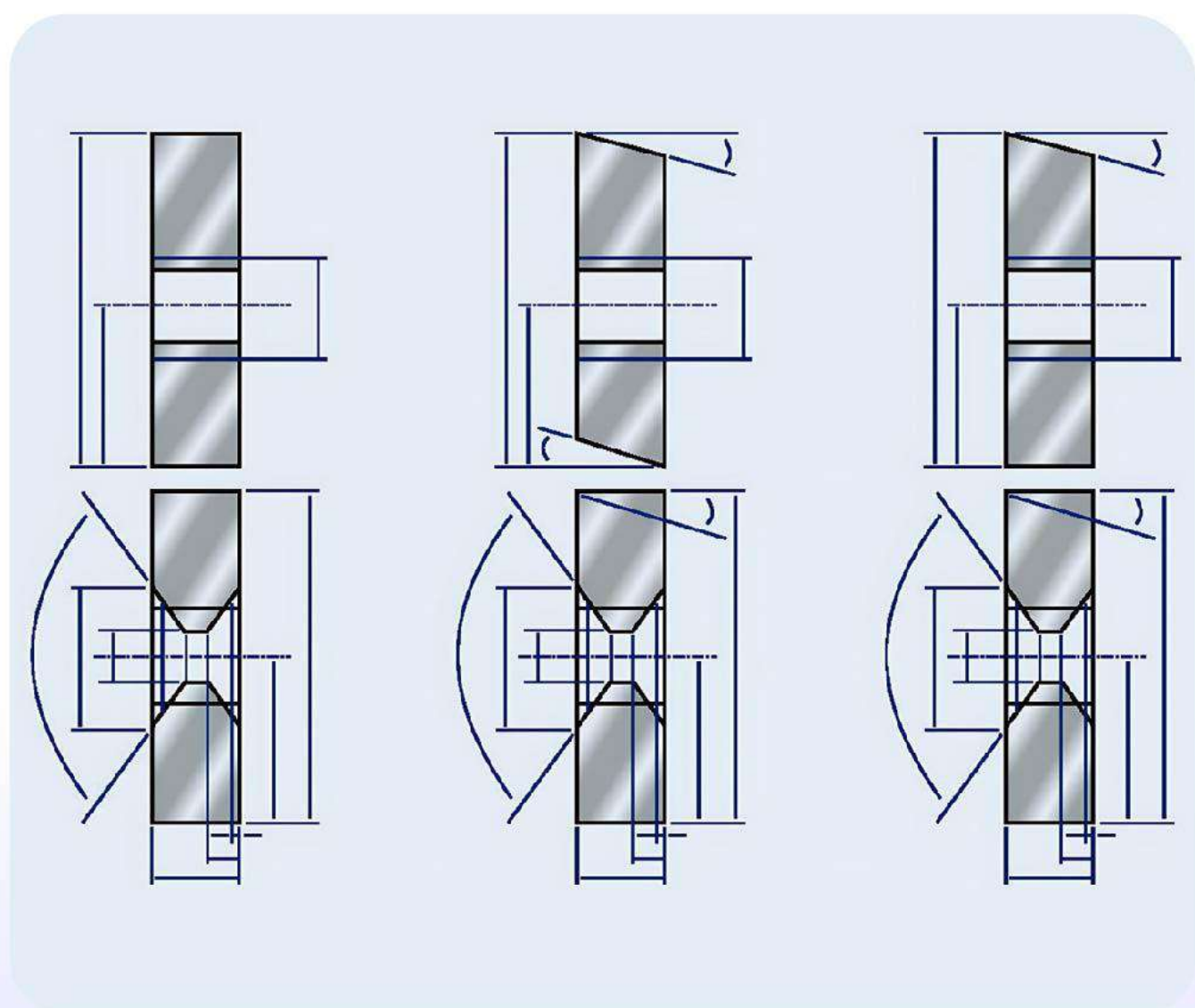


	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V
t	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b
mm	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26	33	41	R
0.5	4	2																				
0.6	6	4	4	4																		
0.8		7	7	5	4																	
1.0		11	10	8	7	6																
1.2			14	12	10	8	7	6														
1.4				15	13	11	10	9	8													
1.6					17	15	13	11	10	9												
2.0						22	19	17	15	13	11											
2.3							25	23	29	17	15	12										
2.6								28	25	22	18	14										
3.0									34	30	24	19	15									
3.2										34	27	22	17	14								
3.5											33	26	20	16	13							
4.0											43	34	27	21	17							
4.5												44	34	27	21							
5.0													52	42	33	26	21					
6.0														60	48	38	30	24				
7.0																52	41	33	26			
9.0																	67	54	43			
10																	85	67	53	42		
12																		96	78	60	55	
16																			136	107	86	
19																				150	125	100
22																					160	130
25																						210
30																						240

t: 板材厚度 (抗拉强度=45-50kg/mm²)
 P: 每米所需压力 (吨/米)
 R: 弯曲内半径
 b: 最短长度
 V: 下模V槽宽度



剪板机刀片



折弯机模具