

GRM

GRA

C型單曲軸沖床
C-Frame Single Crank Power Presses

行程可調/手動、自動
Variable Slide Stroke

80. 110. 160. 200 ton



GRM/GRA

C型單曲軸沖床

C-Frame Single Crank Power Presses

行程可調

Variable Slide Stroke

高精密度加工的實現
 低噪音的實現
 便利性操作的實現
 模高變化小，動態中心偏差小
 模具壽命大幅提升
 沖壓之變形量小
 下料剪斷噪音小
 簡單明瞭之操作面板，
 操作設定容易
 行程長度可調整
 高扭距濕式離合制車器
 高精度六面導路
 高剛性機身
 電子式角度控制器
 觸碰式人機操作介面

Improve Stamping Quality
 Reduce Noise & Vibration
 Increase Operability
 Improve Comfort & Safety In Pressworking
 Reduce Variation of Die Height
 Prolong Toolings' Life
 Increase Permissible Off-center Load
 Reduce Noise & Vibration
 Easy to Adapt Various Press Automations
 High Performance Wet Type Clutch/Brake
 with Auto-forced Air Cooling
 Extra Long 6-Point Centered Gibs
 Super Rigid Steel Frame
 Multi-Function Press Control
 Variable Slide Stroke

手動調整行程長

Manual Slide Stroke Adjustment

自動調整行程長

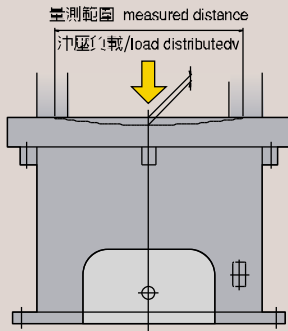
Automatic Slide Stroke Adjustment

規格/SPECIFICATIONS

規格內容 / MODEL		型式 / TYPE	GRM-80	GRA-80	GRM-110	GRA-110	GRM-160	GRA-160	GRM-200	GRA-200
能力 / Capacity		Ton	80		110		160		200	
能力發生點 / Rated tonnage point		mm	5		5		6		6	
行程長 / Stroke length		mm	20~120		20~140		20~160		20~180	
行程數 / Strokes per minute	定速 / Fixed	SPM	60		50		45		35	
	變速 / Variable		40~75		30~65		25~50		20~45	
最大模高 / Die height (S.D.A.U.)		mm	350~400		370~430		440~510		450~530	
滑塊調整量 / Slide adjustment		mm	80		90		100		110	
台盤面積 / Bolster area (LR x FB)		mm	1000 x 600		1150 x 680		1250 x 760		1400 x 820	
滑塊面積 / Slide area (LR x FB)		mm	560 x 460		650 x 520		700 x 580		850 x 650	
主電動機 / Main motor	定速 / Fixed	Hp x p	7.5 x 4	7.5 x 4	10 x 4	10 x 4	15 x 4	15 x 4	20 x 4	20 x 4
	變速 / Variable		VS 10 x 4	—	VS 15 x 4	—	VS 15 x 4	—	VS 20 x 4	—
滑塊調整馬達 Slide adjusting motor		Kw x p	0.4 x 4		0.4 x 4		0.75 x 4		0.75 x 4	
模墊 / Die Cushion	能力 / Capacity	ton	6.3		8		10		14	
	面積 / Pad area	mm	410 x 260		500 x 300		540 x 350		640 x 470	
	行程長 / Stroke	mm	70		80		80		100	
	寬度 / Width L.R.	mm	1120		1240		1360		1520	
機械尺寸 / Machine dimension	深度 / Depth F.B.	mm	2170		2277		2680		2909.8	
	高度 / Height H	mm	3000		3270		3645		4085	

最小機身變形/Minimize Frame Deflection

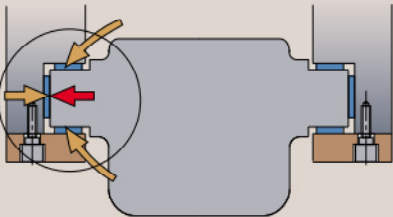
The diagram illustrates a testing machine frame with a central vertical column and a base. A horizontal beam is positioned above the column. A yellow arrow points downwards from the beam, indicating the direction of the load. A red line with arrows at both ends is shown above the beam, labeled 'measured distance' and 'load distributed'. The frame is shown in a cross-section view, with a central vertical line indicating the axis of symmetry. The base of the frame is shown with a circular feature, likely a pivot or a mounting point. The diagram is labeled '圖 10-1-1' in the top left corner.



高精度六面導路 / Box Type Six-Point Gib

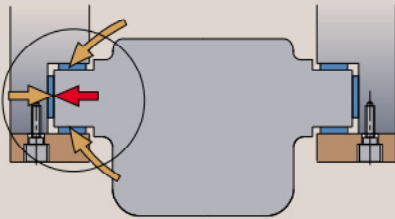
- 超長導路精度高
- 側向力台身直接吸收，導路精度穩定性極佳。

One-piece, full-length, box type gibs assure actuated slide guiding. Force is delivered vertically, minimizing lateral thrust and, consequently, reducing off-center loading and friction in the gibs.



The diagram illustrates a Box Type Six-Point Gib system. It shows a cross-section of a machine bed (grey) and a slide (light blue). Six gibs are used for vertical guidance: two on the left side and four on the right side. A red arrow indicates the direction of lateral force being absorbed by the gibs. Yellow arrows show the vertical force being applied to the slide. The gibs are connected to the bed and slide via a series of links and pins, ensuring precise vertical movement.

- One-piece, full-length, box type gibs assure actuated slide guiding. Force is delivered vertically, minimizing lateral thrust and, consequently, reducing off-center loading and friction in the gibs.



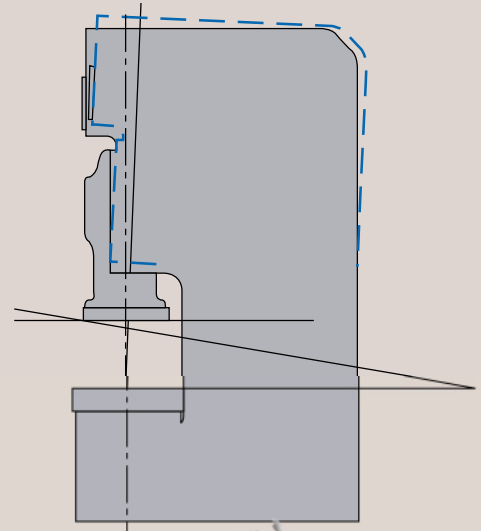
超高剛性台身 / Super Rigid Steel Frame

結構剛性最佳化
沖壓製品精度大幅提升
模具壽命有效延長

The diagram illustrates a cross-section of a heavy-duty steel frame. It features a thick, solid base plate supported by a robust vertical column. A horizontal beam is mounted on top of the column, and a vertical rod or plunger extends from the beam down to the base. The entire structure is enclosed within a rectangular frame, with dashed lines indicating the internal components and the overall dimensions. The design emphasizes structural rigidity and stability.

The Chin Fong GRM Series is designed to resist deflection, and provide accurate pressings and longer die life, even at full tonnage loads. The heavy, one-piece welded steel frame is fully stress relieved and designed to provide a stable base for the GRM Series presses.

結構剛性最佳化
沖壓製品精度大幅提升
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高感度過負荷保護裝置 / Highly Responsive

Hydraulic Overload Protector (H.O.L.P.)

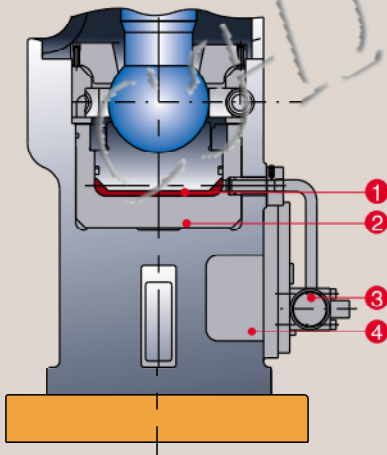
快速反應過載
瞬間油壓洩載

1. 過負荷保護裝置
2. 油壓緩衝缸
3. 油壓缸活塞
4. 油箱

1. Piston
2. Hydraulic Overload Protector Cylinder
3. H. O. L. P.
4. Oil Tank

Chin Fong's fast response H.O.L.P. will relieve the pressure of a tonnage overload in milliseconds, causing the press to stop simultaneously. Press and toolings can therefore be protected effectively. Hydraulic pressure of the system can be rebuilt by pushing reset button. Press, then, resume normal operation when inching the slide up to TDC position.

快速反應過載
瞬間油壓洩載



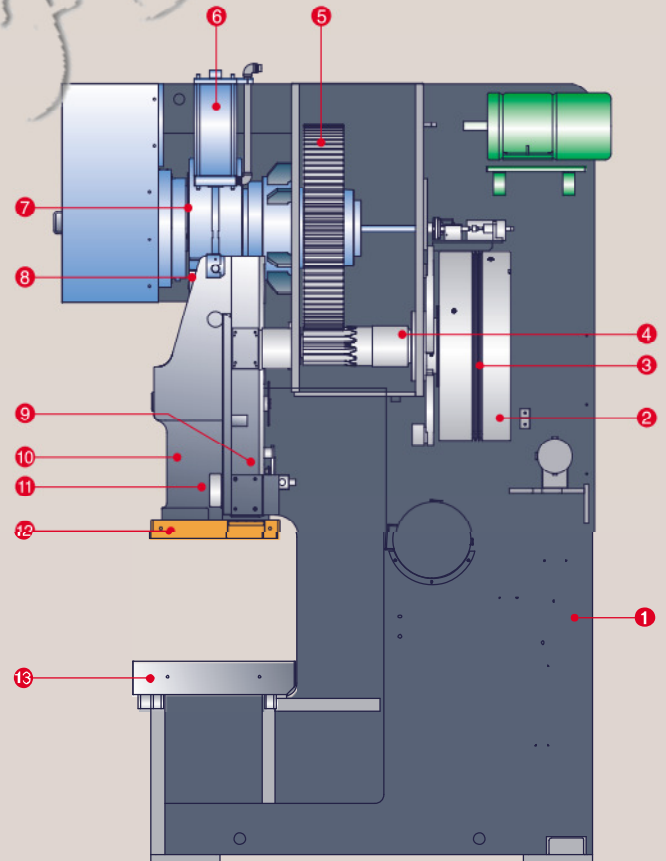
- | | |
|-----------|--|
| 1.過負荷保護裝置 | 1. Piston |
| 2.油壓緩衝缸 | 2. Hydraulic Overload Protector Cylinder |
| 3.油壓缸活塞 | 3. H. O. L. P. |
| 4.油箱 | 4. Oil Tank |

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GRM / GRA

1. 机身 2. 飛輪 3. 濕式離合制車器 4. 傳動軸 5. 大齒輪 6. 平衡器 7. 曲軸
8. 鋸牙 9. 過負荷油室 10. 滑塊 11. 頂料裝置 12. 滑塊板 (可拆卸式) 13. 台盤

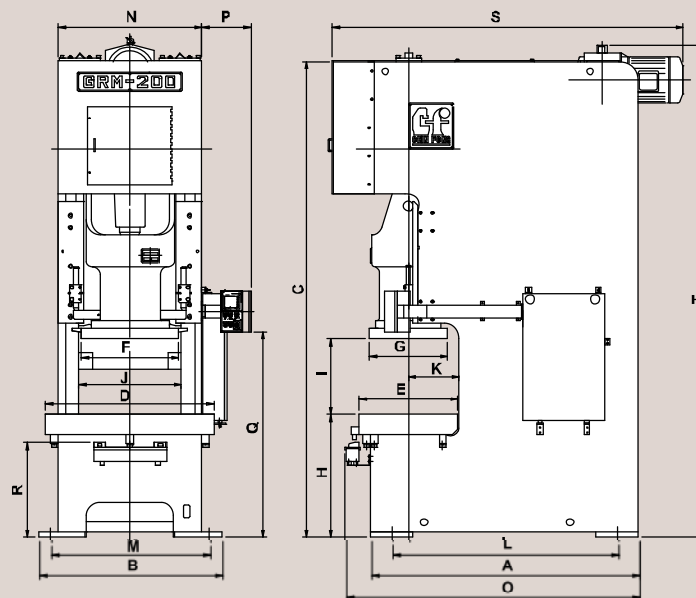
1. Press Frame 2. Flywheel 3. Wet Clutch & Brake 4. Pinion Drive Shaft
5. Main Gear 6. Counter Balancer 7. Crankshaft 8. Adjusting Screw
9. Hydraulic Overload Protector 10. Slide 11. Slide Knockout
12. Slide Plate (Detachable) 13. Bolster



1. 台身 2. 飛輪 3. 濕式離合剎車器 4. 傳動軸 5. 大齒輪 6. 平衡器 7. 曲軸
8. 鋸牙 9. 過負荷油室 10. 滑塊 11. 頂料裝置 12. 滑塊板 (可拆卸式) 13. 台盤
1. Press Frame 2. Flywheel 3. Wet Clutch & Brake 4. Pinion Drive Shaft
5. Main Gear 6. Counter Balancer 7. Crankshaft 8. Adjusting Screw
9. Hydraulic Overload Protector 10. Slide 11. Slide Knockout
12. Slide Plate (Detachable) 13. Bolster

外觀尺寸/
OUTLINE DIMENSIONS

GRM / GRA



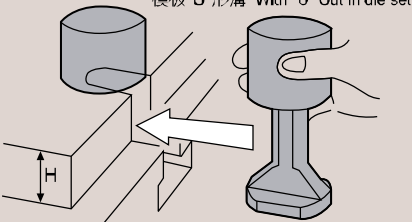
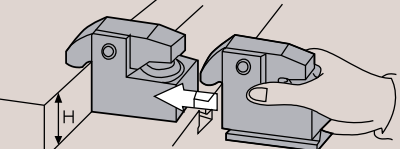
單位/Unit: mm

機種/MODEL	GRM-80	GRA-80	GRM-110	GRA-110	GRM-160	GRA-160	GRM-200	GRA-200
A	1565		1770		2000		2225	
B	1120		1240		1360		1520	
C	2960		3120		3580		3950	
D	1000		1150		1250		1400	
E	600		680		760		820	
F	560		650		700		850	
G	460		520		580		650	
H	830		835		915		1020	
I	400		430		600		630	
J	598		680		750		850	
K	310		350		390		420	
L	1305		1530		1700		1875	
M	930		1050		1270		1320	
N	830		950		1075		1195	
O	1773		1978		2208		2433	
P	405		405		405		405	
Q	1340		1385		1645		1705	
R	663		650		695		785	
S	2170	2015	2277	2110	2680	2470	2910	2680
T	3000		3270		3645		4085	

(以下型式、規格及數量之選配，僅供參考)

(For reference only. Select the items below properly as needed.)

便利的快速換模系統/Quick Die Change System (Q. D. C. S.)

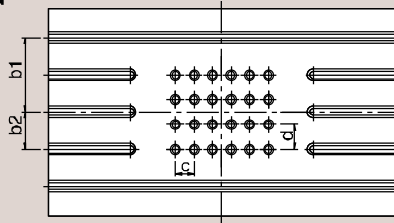
TX型夾模器 / Die Clamp TX-type		選用配置 / Option		數量 / Qty	機型 / Model	GRM-80 GRA-80	GRM-110 GRA-110	GRM-160 GRA-160	GRM-200 GRA-200
 模版"U"形溝 With "U" Gut in die set	夾模器 Die Clamp	上端 Upper	TX-2 or TY-2	夾持力2噸/個 Clamping Force 2 tons/pc					
			TX-4 or TY-4	夾持力4噸/個 Clamping Force 4 tons/pc	4	4			
			TX-6 or TY-6	夾持力6噸/個 Clamping Force 6 tons/pc			4	4	
	夾模器 Die Clamp	下端 Lower	TX-2 or TY-2	夾持力2噸/個 Clamping Force 2 tons/pc					
			TX-4 or TY-4	夾持力4噸/個 Clamping Force 4 tons/pc	4	4	4	4	
			TX-6 or TY-6	夾持力6噸/個 Clamping Force 6 tons/pc					
 模版厚: H (請確認厚度) Die plate thickness, H, to be specified	夾模器 Die Clamp	夾模器 Die Clamp	DL28-400	舉模力1.1噸/個 Pay Load 1.1 tons/pc	2				
			DL28-500	舉模力1.2噸/個 Pay Load 1.2 tons/pc			2		
			DL28-600	舉模力1.4噸/個 Pay Load 1.4 tons/pc	2	2	2	2	
			DL28-700	舉模力1.5噸/個 Pay Load 1.5 tons/pc			2		
			DL28-800	舉模力1.6噸/個 Pay Load 1.6 tons/pc	2	2		2	
夾模器 Die Arm	夾模器 Die Arm	RC-700-600	承載力600kg/個 Pay Load 600 kg/pc			2			
		RC-800-800	承載力800kg/個 Pay Load 800 kg/pc				2		
		RC-900-900	承載力900kg/個 Pay Load 900 kg/pc						
液壓動力單元 Hydraulic Power Unit FP6308U						1			

模板厚: H (請確認厚度)
Die plate thickness, H, to be specified

台盤BOLSTER

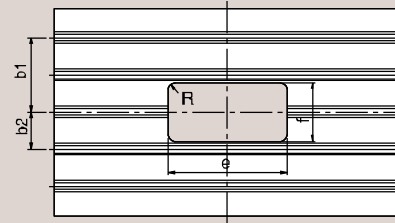
圖一

Fig. 1



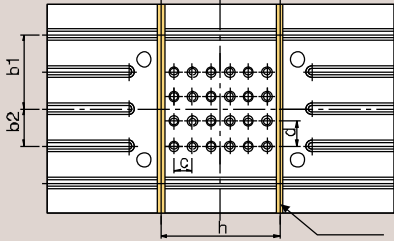
圖二

Fig. 2



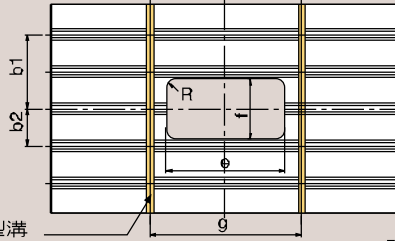
圖三

Fig. 3



圖四

Fig. 4

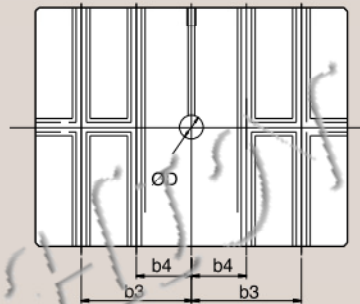


含舉模器用"U"型溝
with "U" slot for die lifter

單位/Unit: mm

機種/Model	GRM-80	GRA-80	GRM-110	GRA-110	GRM-160	GRA-160	GRM-200	GRA-200
T型槽型式/Type of T-Slot	A		B		B		B	
T型槽條數/No. of T-Slot	3		5		5		5	
模墊銷孔數目x孔徑/No. of Pin Hole x Dia.	24 x $\phi 20^{+0.5}_{+0.1}$		24 x $\phi 28^{+0.5}_{+0.1}$		24 x $\phi 28^{+0.5}_{+0.1}$		35 x $\phi 28^{+0.5}_{+0.1}$	
c x d	75 x 75		90 x 90		100 x 100		100 x 100	
b1	150		250		300		300	
b2	-		150		150		150	
e x f	360 x 180		400 x 200		440 x 220		480 x 240	
R	30		30		30		30	
g	480		480		520		560	
h	440		530		580		680	

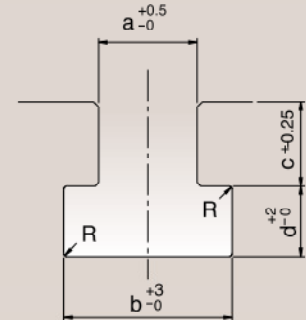
滑塊板加工圖 / SLIDE PLATE



單位/Unit: mm

機種/Model	GRM-80	GRA-80	GRM-110	GRA-110	GRM-160	GRA-160	GRM-200	GRA-200
滑塊板面積(左右x前後) / Slide Plate Area (LR x FB)	560x460		650x520		700x580		850x650	
T型槽型式/Type of T-Slot	A		B		B		B	
T型槽條數/No. of T-Slot	2		2		4		4	
模柄孔徑/Hole Dia. D	$\phi 50$		$\phi 50$		$\phi 65$		$\phi 65$	
b3	150		150		300		300	
b4	-		-		150		150	

T型槽詳細 / T-Slot Detail



單位/Unit: mm

尺寸/Dim.	型式/Type	A	B
a		22	28
b		37	48
c		24	28
d		16	20
R		1	1

標準功能/配件 Standard Functions / Accessories

- 固定式雙手按鈕操作台
- 觸碰式操作直盤
- 運轉模式選擇 / 切/寸動/安全一行程/連續
- 油壓過負荷保護裝置
- 二度落保護裝置
- 雙聯電磁閥
- 電動滑塊調整裝置
- 數字式模高指示器(單位0.1mm)
- 手動黃油潤滑裝置
- 噴風裝置3/8"一迴路
- 空氣源接頭3/8"一迴路
- 電源插座(電源客戶自備)
- (僅適用單相110V / 220V電源)
- 主馬達逆轉裝置
- 變頻器(GRA)
- Fixed Type Two-hand "RUN" Pushbutton Panel
- E-Series Control System
- Operation Mode Selection Off / Inching / Safety One Stroke / Continuous
- Hydraulic Overload Protector (H.O.L.P.)
- Overrun Detector (Brake Monitor)
- Dual-coiled Solenoid Valve
- Motorized Slide Adjusting Device (above 60-260ton)
- Digital Die Height Indicator (unit:0.1mm)
- Air Ejector, 3/8", one channel
- Air Source Receptacle, 3/8", one channel
- Life Counter
- Electronic Rotary Cam Switch (6 spare channel)
- Inverter & main motor reversing circuit
- Inverter (GRA)

選用功能/配件 Optional Functions / Accessories

- 模型裝置
- 光電安全裝置
- 滑塊上部頂料裝置
- 電動黃油潤滑裝置
- T型操作台
- 安全擋塊及安全插銷
- 自動化回落3/8"4方井
- 飛輪制動裝置
- 送料軸端
- (前端延伸式)
- 快速模具交換 (Q.D.C.)
 - 上火模器
 - 下火模器
- 舉模器
- 移模臂
- 防震機械減
- 模具照明燈
- 變頻器(GRM)
- Crankshaft Front-end Extension
- Quick Die Change System
 - Upper Die Clamps
 - Die Lifters
 - Lower Die Clamps
 - Die Arms
- Anti-vibration Press Mounts
- Die Room Light
- Inverter (GRM)
- Die Cushion
- Safety Light Curtain
- Slide Knockout Device
- Motorized Grease Pump
- Portable 2-hand Pushbutton
- T- Stand
- Safety Block with plug
- Automation Air Circuit 3/8"
- Flywheel Brake
- Power Take-off Shaft



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