



## 双伺服数控立式内拉床

LG57MS 系列

Double servo CNC vertical internal broaching machine



- 双电机同步伺服驱动，满足大吨位拉削  
· Double-motor synchronous servo drive, meeting the needs of large-tonnage broaching
- 双床身对向布局，拉削在中间，受力与拉削中心在同一平面上  
· Double lathe beds are arranged in opposite directions, broaching is in the middle, and the stress is on the same plane as the broaching center.

项目 ITEM	单位 UNIT	LG5720MS-1600	LG5740MS-2000	LG5760MS-2000
额定拉削力 Rated broaching force	kN	200	400	600
最大行程 Max.stroke	mm	1,600	2,000	2,000
提刀行程 Lifting stroke	mm	1,000	1,300	1,600
拉削速度 Broaching speed	m/min	1 ~ 6	1 ~ 6	1 ~ 6
返程速度 Return speed	m/min	1 ~ 10	1 ~ 10	1 ~ 10
适用拉刀长度 Applicable broach length	mm	950 ~ 1700	1250 ~ 2000	1250 ~ 2000
最大工件外径 Max. workpiece outer diameter	mm	Φ240(单工位)	Φ300(单工位)	Φ300(单工位) Φ250(双工位) Φ130(三工位)
主电机功率 Main motor power	kW	15x2	37x2	37x2
机床总功率 Total power	kW	39	80	88
机床外形 Machine tool shape	m	4.6x4.6x5.5	3.0x4.9x5.5	4.3x6.0x7.1
机床净重 Net weight	t	15	24	35

# Gear broaching

CHR 畅尔



伺服上拉式立式内拉床

Servo up-drawing type vertical internal broaching machine

LG57AS 系列



- 伺服驱动  
· Servo drive
- 上拉式作业，地面式安装  
· Pull-up operation, ground installation
- 系列产品多种多样，适宜自动化连线  
· Series products are various and suitable for automatic connection



项目 ITEM	单位 UNIT	LG5710AS-1200	LG5720AS-1600	LG5730AS-2000
额定拉削力 Rated broaching force	kN	100	200	300
最大行程 Max.stroke	mm	1,200	1,600	2,000
提刀行程 Lifting stroke	mm	1,000	1,000	1,000
拉削速度 Broaching speed	m/min	1 ~ 7	1 ~ 7	1 ~ 7
返程速度 Return speed	m/min	1 ~ 10	1 ~ 10	1 ~ 10
适用拉刀长度 Applicable broach length	mm	750 ~ 1,300	1,100 ~ 1,700	1,300 ~ 2,100
最大工件外径 Max. workpiece outer diameter	mm	Φ200 (单工位) Φ150 (双工位)	Φ240 (单工位) Φ200 (双工位) Φ160 (三工位)	Φ260 (单工位)
主电机功率 Main motor power	kW	15	22	37
机床总功率 Total power	kW	21	26	45
机床外形 Machine tool shape	m	3.6×4.6×4	3.8×5×5.5	5×5.5×6.1
机床净重 Net weight	t	9.2	12	20

# Gear broaching

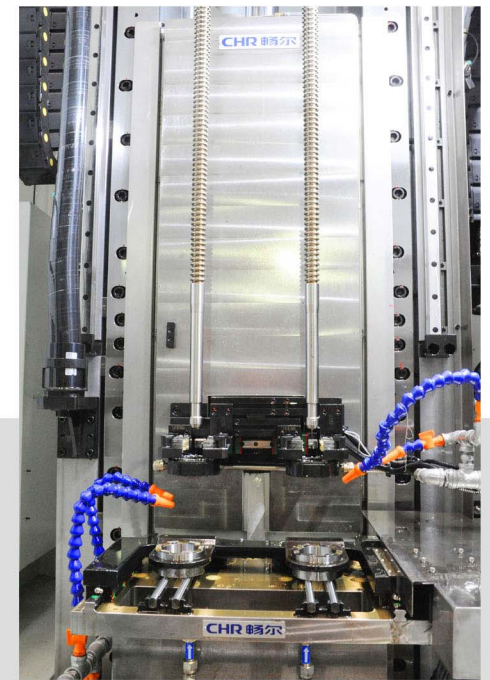
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液压上拉式立式内拉床

LG57RS 系列

Hydraulic pull-up type vertical internal broaching machine LG57RS Series



- 液压驱动  
· Fluid drive
- 上拉式作业，地面安装  
· Pull-up operation, ground installation

项目 ITEM	单位 UNIT	LG5710RS-1200	LG5720RS-1600	LG5730RS-1600
额定拉削力 Rated broaching force	kN	100	200	300
最大行程 Max.stroke	mm	1,200	1,600	1,600
提刀行程 Lifting stroke	mm	1,250	1,250	1,250
拉削速度(分档调速) Broaching speed(Step speed regulation)	m/min	2.5 ~ 4.5 ~ 7	2.5 ~ 4.5 ~ 7	2.5 ~ 4.5 ~ 7
返程速度 Return speed	m/min	14	14	14
适用拉刀长度 Applicable broach length	mm	800 ~ 1,300	1,100 ~ 1,700	800 ~ 1600
最大工件外径 Max. workpiece outer diameter	mm	Φ200 (单工位 Single station) Φ160 (双工位 Duplex position) Φ110 (三工位 Three stations)	Φ300 (单工位 Single station) Φ160 (双工位 Duplex position) Φ110 (三工位 Three stations)	Φ300 (单工位 Single station) Φ160 (双工位 Duplex position) Φ110 (三工位 Three stations)
主电机功率 Main motor power	kW	15	22	30
机床总功率 Total power	kW	22	33	40
机床外形 Machine tool shape	m	4.3x4.8x4.4	5.3x3.7x4.6	6.5x4x5.1
机床净重 Net weight	t	9	15	18



## 双缸双立柱上拉式立式内拉床

Double-cylinder double-column pull-up type vertical internal broaching machine LG557FA Series

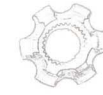
LG557FA 系列

LG557FA Series



- 单床身结构  
· Single bed structure
- 双油缸驱动，满足大切削力需求  
· Double cylinder drive, meet the demand of large cutting force
- 机械臂实现独立换刀，操作便捷  
· The mechanical arm realizes independent tool change, which is convenient to operate.

项目 ITEM	单位 UNIT	LG55740FA-2000	LG55760FA-2000
额定拉削力 Rated broaching force	kN	400	600
最大行程 Max.stroke	mm	2000	2000
提刀行程 Lifting stroke	mm	1400	1400
拉削速度（分档调速） Broaching speed(Step speed regulation)	m/min	1 ~ 7	1 ~ 6
返程速度 Return speed	m/min	2 ~ 15	2 ~ 12
适用拉刀长度 Applicable broach length	mm	1050 ~ 2100	1050 ~ 2100
最大工件外径 Max. workpiece outer diameter	mm	Φ360(单工位 Single station) Φ300(双工位 Duplex position) Φ190(三工位 Three stations)	Φ400(单工位 Single station) Φ360(双工位 Duplex position) Φ260(三工位 Three stations)
主电机功率 Main motor power	kW	45	53.5
机床总功率 Total power	kW	67	76
机床外形 Machine tool shape	m	4.6×5.8×7.1	4.8×6×7.2
机床净重 Net weight	t	35	40



## 双缸双床身上拉式立式内拉床

Double-cylinder double-bed pull-up type vertical internal broaching machine LG557MH Series

LG557MH 系列

LG557MH Series

- 双床身结构，双油缸驱动  
· Double bed structure, driven by double cylinders
- 适合加工精度高的各种较大内花键、内齿轮以及各种形状的内孔  
· Suitable for machining various large internal splines, internal gears and internal holes of various shapes with high precision



项目 ITEM	单位 UNIT	LG55740MH-2000	LG55760MH-2000
额定拉削力 Rated broaching force	kN	400	600
最大行程 Max.stroke	mm	2000	2000
提刀行程 Lifting stroke	mm	1400	1400
拉削速度（分档调速） Broaching speed(Step speed regulation)	m/min	1 ~ 7	1 ~ 6
返程速度 Return speed	m/min	2 ~ 15	2 ~ 12
适用拉刀长度 Applicable broach length	mm	1200 ~ 2000	1300 ~ 2000
最大工件外径 Max. workpiece outer diameter	mm	Φ280(单工位 Single station)	Φ300(单工位 Single station)
主电机功率 Main motor power	kW	45	54
机床总功率 Total power	kW	67	76
机床外形 Machine tool shape	m	5.3×6.5×6	5.5×7×6
机床净重 Net weight	t	24	26

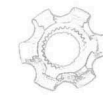
## CHR 畅尔 自动化应用案例



### 精锻齿轮拉削加工

Precision forging gear broaching

- 工件移动式内拉床  
· Workpiece movable internal broaching machine
- 机械手自动上下料  
· Automatic loading and unloading of manipulator



### 转向节叉拉削加工

Steering knuckle fork broaching

- 工件移动式内拉床  
· Workpiece movable internal broaching machine
- 伺服驱动，自动化上下料机构  
· Servo-driven, automated loading and unloading mechanism



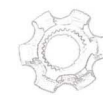
## CHR 畅尔 自动化应用案例



### 轮毂单元自动化拉削

*Automatic broaching of wheel hub unit*

- 液压驱动，拉削平稳  
*Hydraulic drive for smooth broaching*
- 加工范围广，精度高，节拍快  
*Wide processing range, high precision, fast tempo*
- 装配后成套拉削  
*Assembled set broaching*



### 三销架、行星轮自动化拉削

*Automatic broaching of three pin holders and planetary wheels*



- 四工位自动化加工  
*Four-station automated processing*
- 适用于多工位小零件的拉削加工  
*Suitable for multi-station broaching of small parts*

