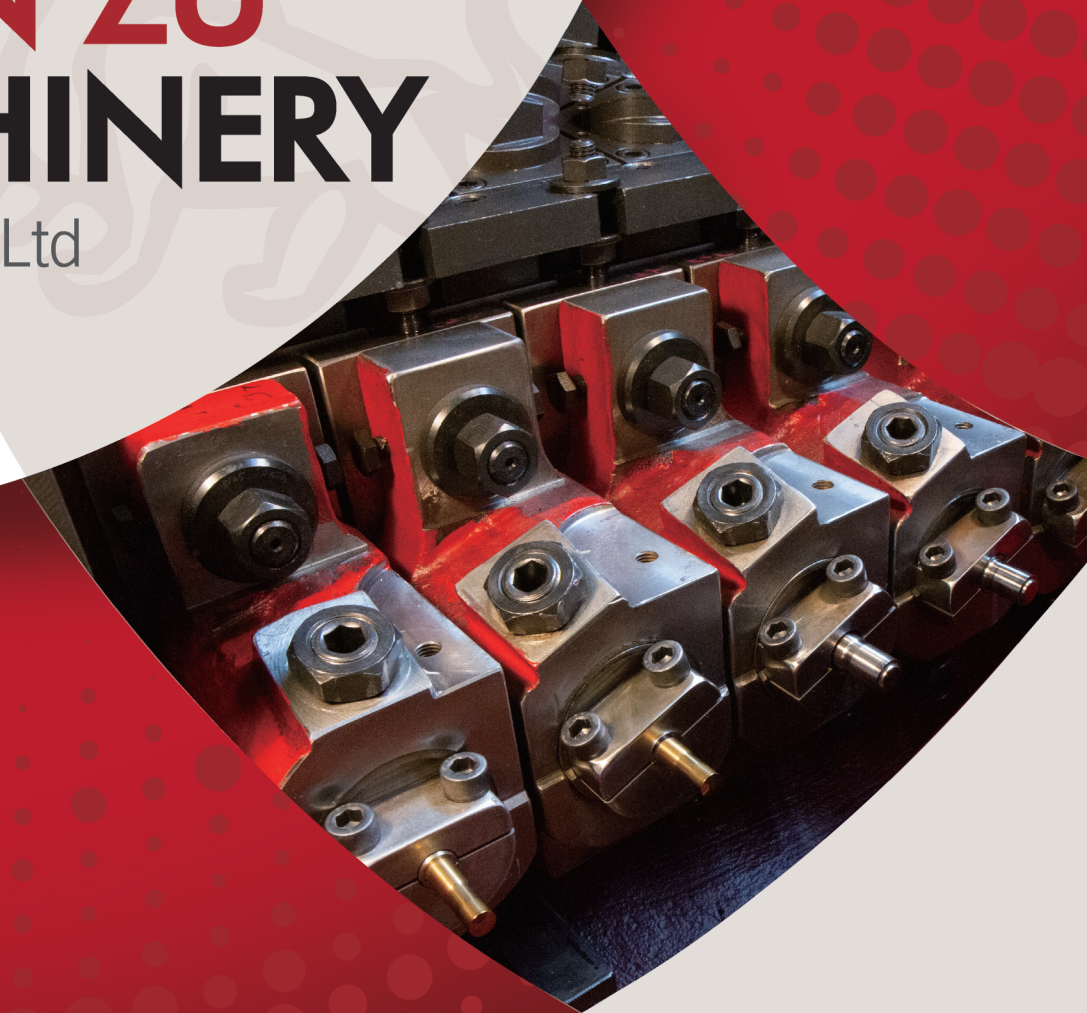


ISO-9001

# CHUN ZU MACHINERY

Industry Co., Ltd



## Taiwan Headquarters

CHUN ZU



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春日機械  
CHUNZU

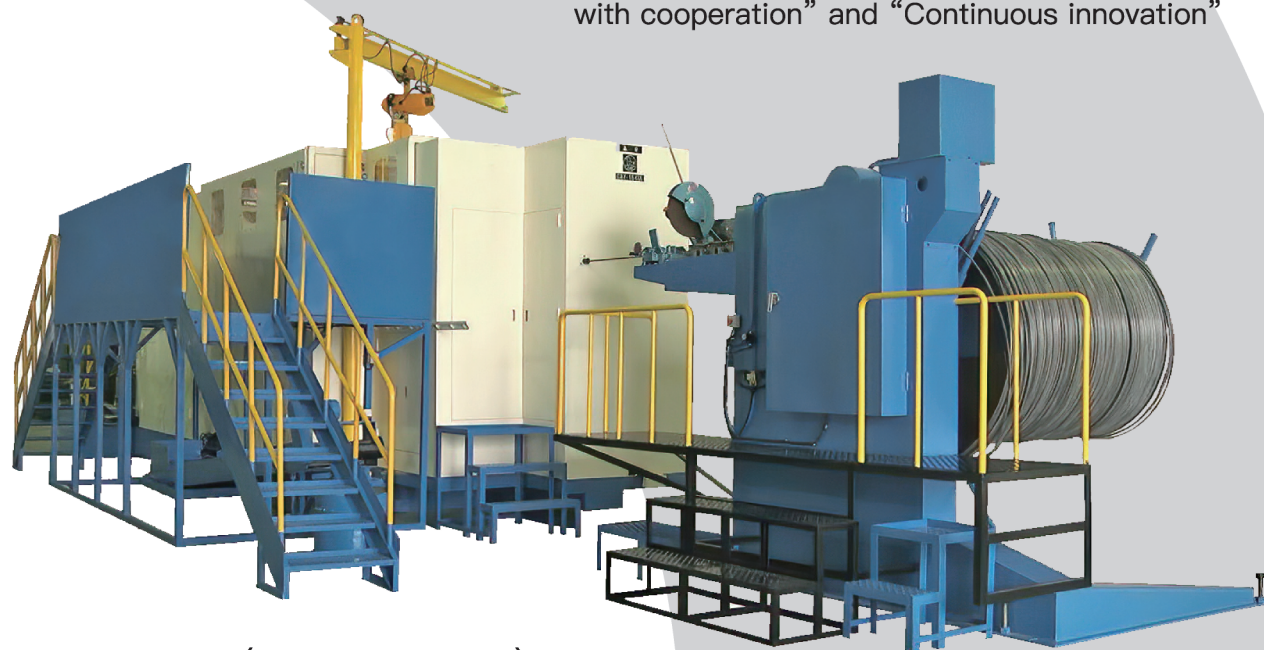


# PRODUCT

Established in 1973, Chun Zu is known worldwide for the "Lion" trademark.

Chun Zu products includes: parts formers, bolt and nut formers, thread rollers and headers. We also produce an extensive line of thread rolling and heading dies.

We adhere to the goal of "Customer Satisfaction" by the efforts of all our staffs with the concept of "Dedication with cooperation" and "Continuous innovation"



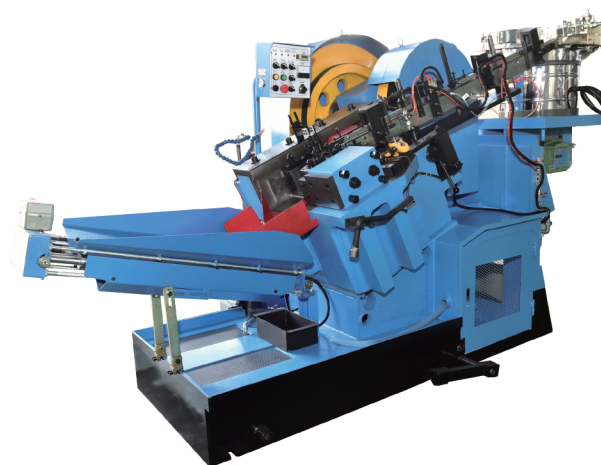
Large models (M16 and larger)

Small and medium models  
(below M12)



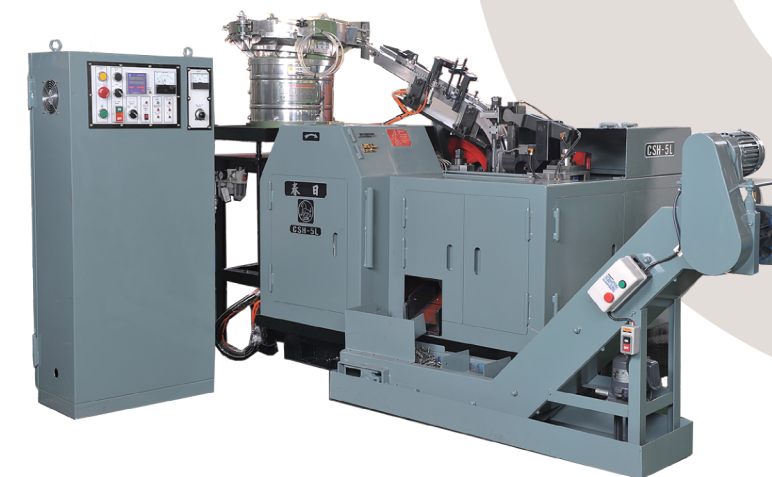
**Multi-station  
bolt / nut / part cold formers**

CBF / CBP / CNF / CNP series



**Thread rolling machines**

CPR series



**Second operation open die  
heading machines**

CSH series



**Bushing cut-off heading machines**

CNH series



**1-Die 2-Blow  
heading machines**

CH series



**2-Die 2-Blow heading  
machines**

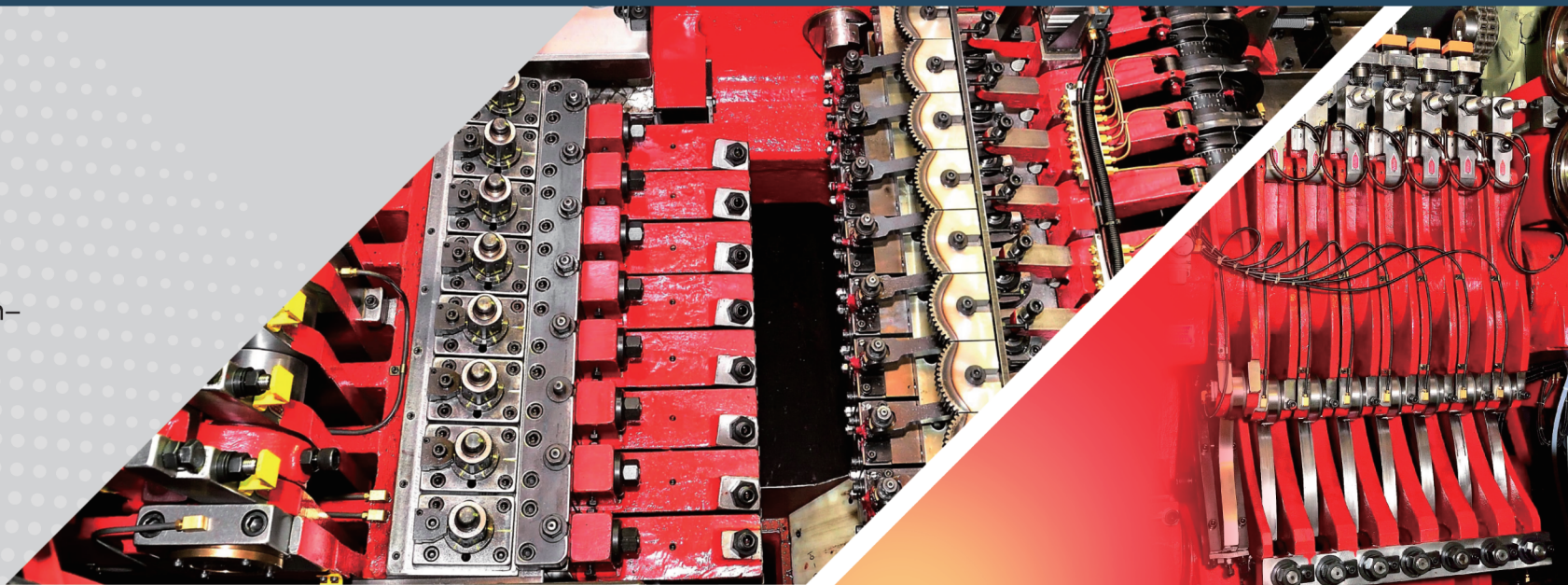
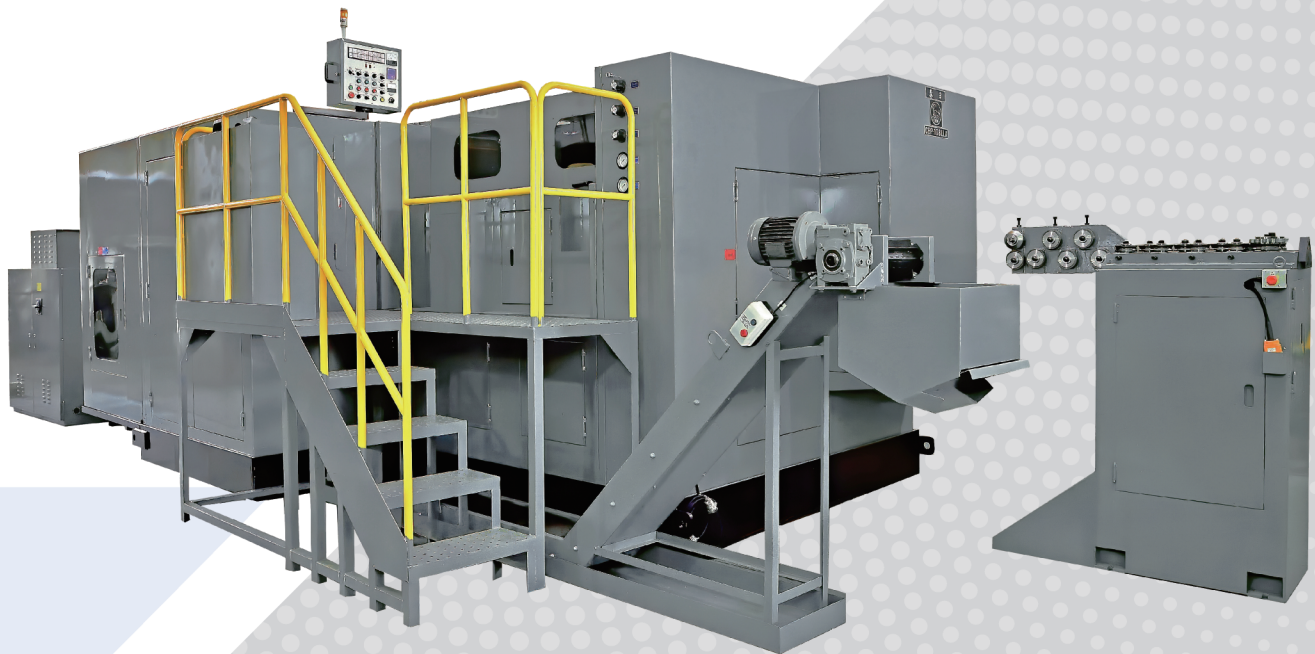
CDH series



# PRODUCT

## Multi-station bolt / nut / part cold formers

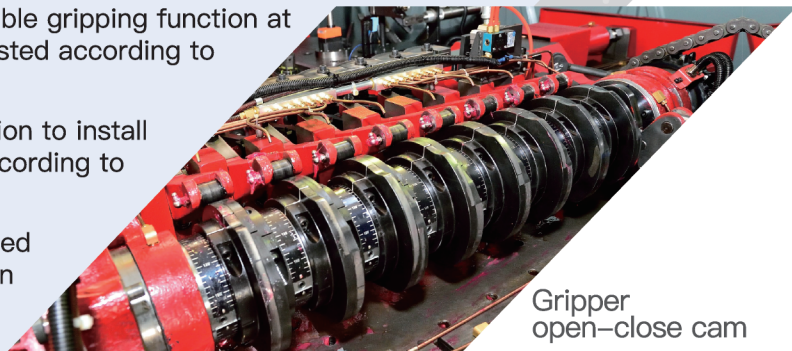
Chun Zu is a Taiwan leader in advanced cold forming machinery, process technology, and customer support products and services. We offer a full range equipment, to meet the global marketplace needs.



Forging technology

Independent K.O. mechanism

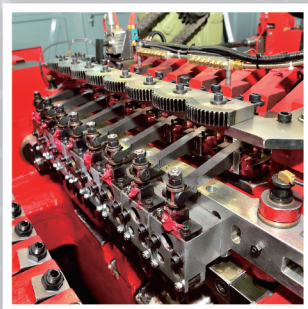
- ✱ The pneumatic clutch brake system has been designed to actuate as “Inching”, “Single stroke” and “Continuous running”. The main ram always stop at rear position while operating either “Single stroke” or “Continuous running” cycle. (Except CDH model)
- ✱ The machine is made of gray cast iron, like frame and main slider are stress relief after casting to avoid deformation and keeps its precision, and have better rigidity and extremely low elongation to provide the machine stability.
- ✱ The main slider is secured by “Overarm” design, the hardened alloy steel plates fixed to it will maintain its precision and stability.
- ✱ Pneumatic gripper mechanism is adapted to obtain stable gripping function at high speed production. The gripping force can be adjusted according to each kind of product.
- ✱ CBP/CNP models adopt separate design for each station to install bolt type, nut type or combo type cassette grippers according to product requirements.
- ✱ The CBF/CBP/CNP series (M10 and above) are equipped with a dual lubrication system. The crankshaft and main slider have an independent lubrication system.
- ✱ The counterweight of the mechanism design contributes to machine’s great stability.
- ✱ An inverter is installed on AC motor to allow variable speed during testing and production.
- ✱ CBF/CBP/CNP series are equipped with coolant supply pipe that automatically rises.



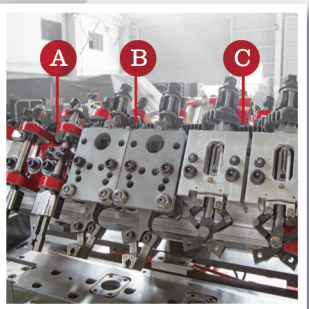
Gripper  
open-close cam



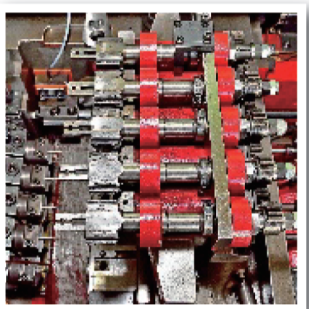
Operation panel



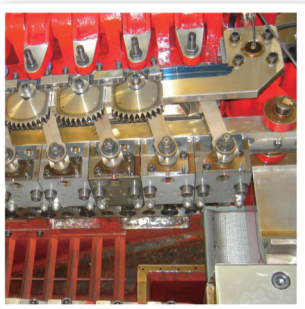
Cassette transfer system



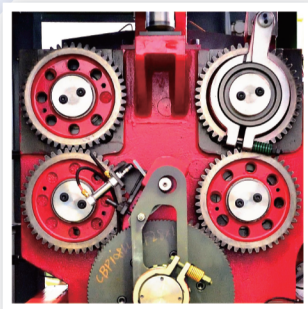
Cassette transfer system  
A: universal transfer cassette  
B: straight transfer cassette  
C: combo type transfer cassette



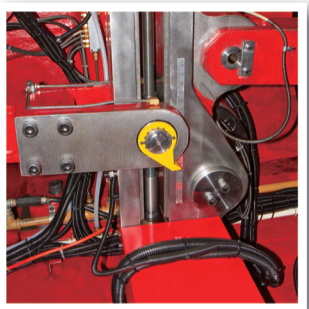
Integrated transfer  
system (CNF series)



Finished product  
anti-collision system  
(with extra finger to avoid parts  
damaged)



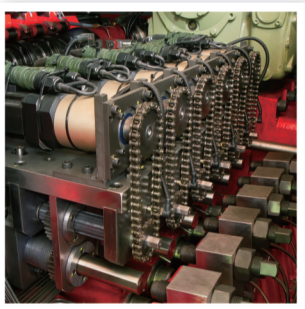
Feeding mechanism



Feeding length adjustment  
(by servo motor)



K.O. length adjustment  
(by hand wheel)



K.O. length adjustment  
(by servo motor)



Transmission gear

✱ Please contact our sales staff for the details of each mechanism and specifications.

### FORMING MACHINES

ITEM \ MACHINES	CBF series	CBP series	CNF series	CNP series	CDH series
	BOLT FORMERS	BOLT PARTS FORMERS	NUT FORMERS	NUT PARTS FORMERS	2-DIE 2-BLOW HEADING MACHINES
NO. OF FORGING STATION	3-4	5-8	5	5-7	2
MAX.FORGING LOAD (Ton)	430	730	400	1000	200
CUT-OFF DIAMETER (mm)	Ø2-Ø30	Ø2-Ø41	Ø5-Ø32	Ø5-Ø48	Ø2-Ø20
CUT-OFF LENGTH (mm)	10-500	10-450	3-40	20-180	11-230
INTEGRATED TRANSFER SYSTEM	●		●		●
CASSETTE TRANSFER SYSTEM (UNIVERSAL/STRAIGHT/COMBO)		●		●	
TRIMMING MECHANISM	●	●			
PNEUMATIC CLUTCH	●	●	●	●	

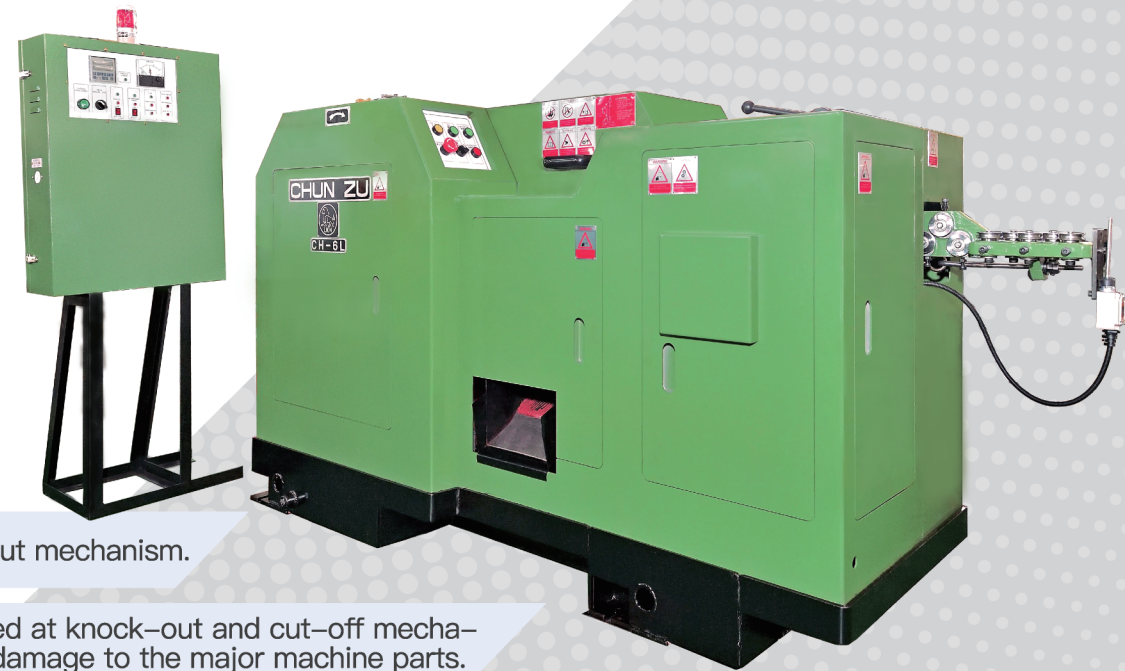
✱Modifications are subject to change without notice.



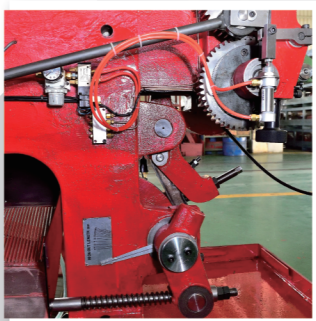
# PRODUCT

## CH series 1-Die 2-Blow heading machines

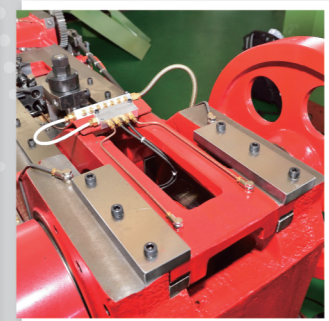
CH series can produce varied head type screws, like pan head, flat head, socket head, bugle head, truss head...etc. The products are with high concentricity.



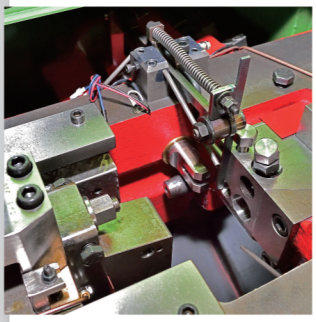
- ✱ Less noise in knock-out mechanism.
- ✱ Safety pins are installed at knock-out and cut-off mechanisms to prevent any damage to the major machine parts.
- ✱ Up and down punch sliding mechanism.
- ✱ Easy knock-out adjusting mechanism.



Feeding mechanism and knock-out mechanism



The main slider with "OVERARM" design to secure the stability and high precision of machine.



Forming area



Forming area

HEADING MACHINES			
ITEM \ MACHINES	CH	CNH	CSH
DIE	1-DIE 2-BLOW HEADING MACHINES	BUSHING CUT-OFF HEADING MACHINES	SECOND OPERATION HEADING MACHINES
BLOW	2		
MAX.FORGING LOAD (Ton)	400	25	50
RAW MATERIAL FORM	COIL WIRE	COIL WIRE	SLUG or SEMI-FINISHED PRODUCTS
CH、CNH：CUT-OFF DIAMETER (mm) CSH：BLANK DIAMETER (mm)	Ø0.8-Ø32	Ø3-Ø6.35	Ø3-Ø10
CH、CNH：MAX. CUT-OFF LENGTH(mm) CSH：BLANK LENGTH (EXCLUDE HEAD) (mm)	5-417	89	25-380
CH、CNH：SHANK LENGTH OF BLANK(mm) CSH：MAX. BLANK LENGTH OUT OF DIE(mm)	3-305	8-64	0-80
GRIPPER TYPE	SPRING TYPE	PNEUMATIC TYPE	SPRING TYPE
PKO MECHANISM	GENERAL TYPE PKO SYNCHRONOUS TYPE PKO (OPTION)	SYNCHRONOUS TYPE PKO	NOT AVAILABLE
OTHERS	-	-	OPEN DIE MECHANISM

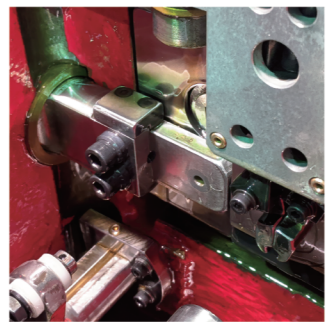
✱ Please contact our sales staff for the details of each mechanism and specifications.

## CNH BUSHING CUT-OFF HEADING MACHINES

The CNH series is 1-Die 2-Blow heading machine. It is an advanced forming machines, suitable to produce simple products with higher precision.



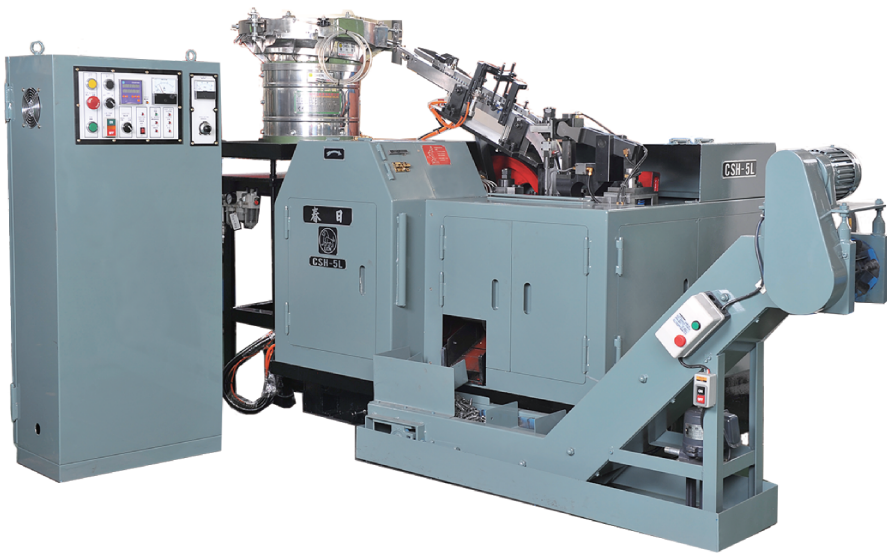
- ✱ Bushing cut-off mechanism: the cutting surface is more flat and is suitable to produce higher precision products
- ✱ Synchronous PKO mechanism / Pneumatic transfer/ New design Knock-out mechanism



Bushing cut-off mechanism

## CSH SECOND OPERATION HEADING MACHINES

The CSH series is 1-Die 2-Blow open die Reheader. It is designed based on our heading machine. It can save production cost by reducing materials and eliminate other secondary operations.



- ✱ The slugs or semi-products are fed using a vibrator feeder to forge the head or neck.
- ✱ Easy adjustable mechanisms can be adjusted according to different products.
- ✱ These adjusting mechanisms are similar to the CH model, which can shorten the operator training time.



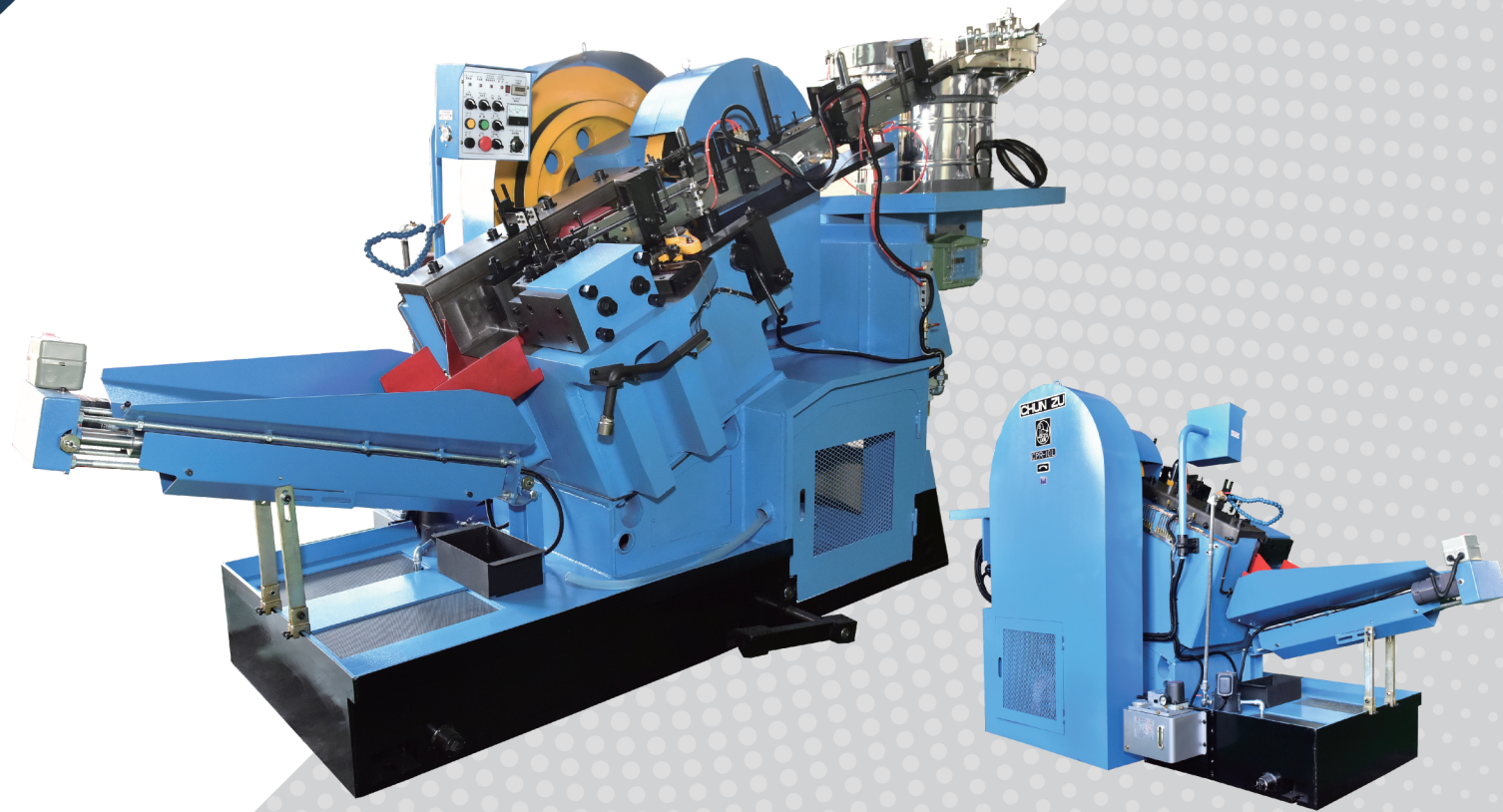
✱ Please contact our sales staff for the details of each mechanism and specifications.



# PRODUCT

## CPR THREAD ROLLING MACHINES

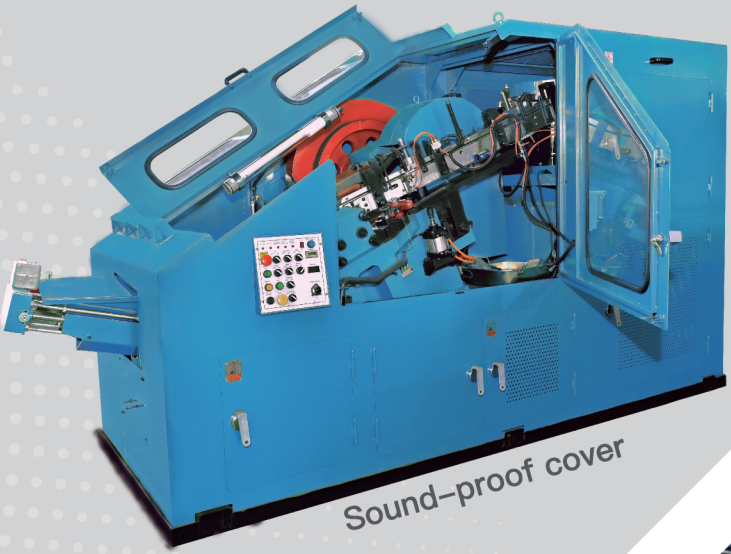
CPR series is high speed and stability with various equipment options.



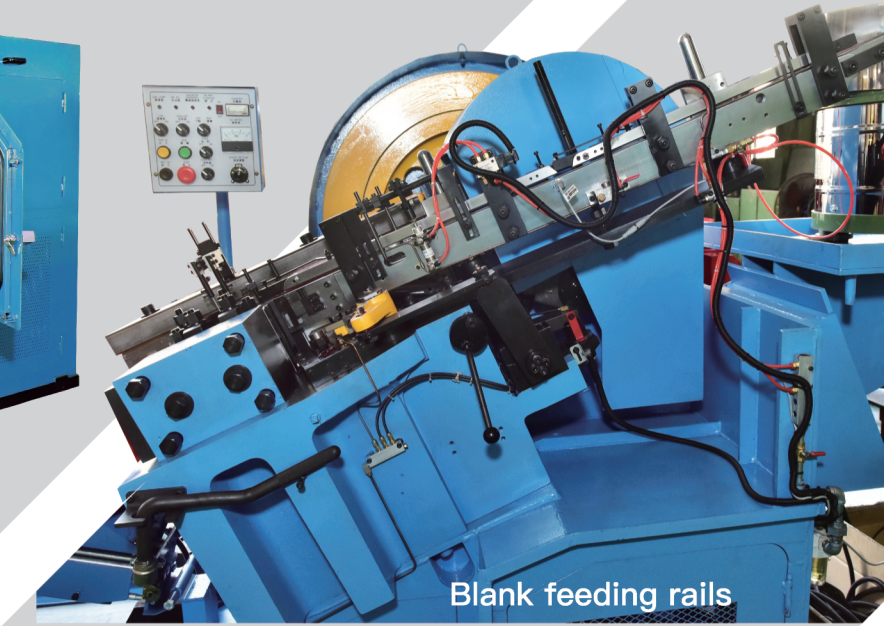
- \* A.C. motor and inverter allow variable speed adjustment during jogging and continuous running.
- \* Phosphoric bronze liners and hardened alloy steel liners are used for the sliding surface of the main slider to maintain high precision of threading and longer working life of thread dies.
- \* 3 direction (X,Y,Z) adjustment of stationary die pocket makes the alignment of height and parallelism between stationary and moving die easier.
- \* The machine is made of gray cast iron, like frame and main slider are stress relief after casting to avoid deformation and keeps its precision, and have better rigidity and extremely low elongation to provide the machine stability.
- \* This frame is designed and manufactured for high strength. The deformation of the frame is very small while rolling.



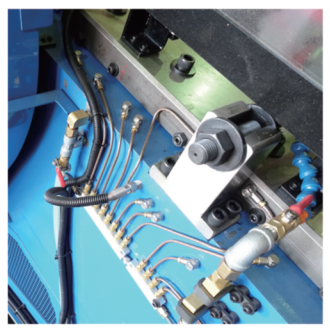
\* Each mechanism can be easily adjusting according to different products.



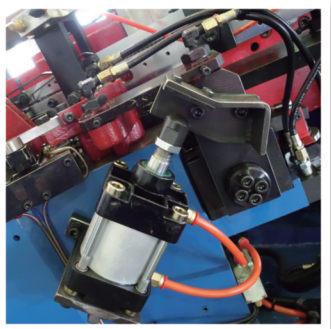
Sound-proof cover



Blank feeding rails



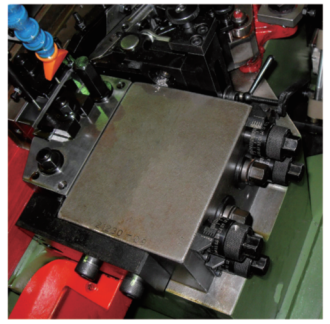
1.Lubrication system on main slider  
2.Temperature sensor on main slider



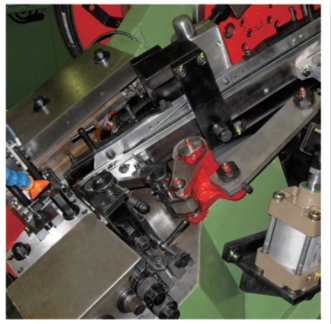
Pusher finger retractor



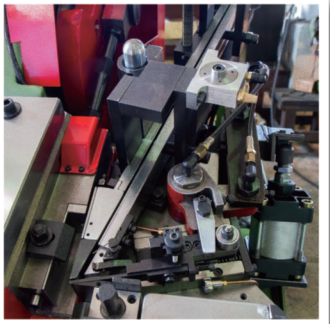
Main frame with Tie-Bar construction



Fine adjustment die pocket



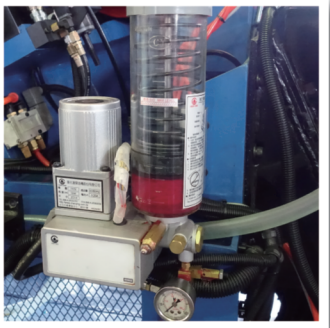
Swing type blank start system



Sliding type blank start system

Thread rolling machines	
MIN.&MAX. THREAD DIAMETER mm	2-42
MIN.&MAX. THREAD DIAMETER FOR SELF TAPPING SCREW mm (CPR3-CPR10)	#2-#14
MIN.&MAX. THREAD LENGTH mm	3-250
MIN.&MAX. SHANK LENGTH UNDER HEAD mm	3-350
MAX. THREAD ROLLING FORCE Kgf	150000

\* Please contact our sales staff for the details of each mechanism and specifications.



Auto grease device



# PRODUCT

## Hot and Cold Forming Tools



Our facilities include the finest machines for tool manufacturing. This enables us to produce standardize and precise tooling.

All phases of tooling manufacture necessary to produce tools with good finish and production life are controlled within our factory. We produce tools for all phases of fastener manufacturing. Heading and trimming dies, standard and special punches, rolling dies, knockout pins. Inserts, and cutoff tools are all within our standard manufacturing program.

Our production includes tooling made from many types of alloy steel, high speed steel, tungsten carbide, and sintered high speed steel.

## Fastener Reference

