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HoChier, Taiwan
后生機械

CNC SPM Machine



Tube/Pipe Special Purposed Equipment

- Pipe Notching Machine
- Multi-Drilling Machine
- Pipe Expanding Machine
- Tapper Former
- Knurling/Drawing/Cutting/Bending Machine



CNC Mitering Special Purposed Machine

- Both Ends Fine Boring Machine
- Flow Drilling Machine
- CNC Tapping Center
- Special Size CNC Machining Center
- Special Function CNC Machine



Automated Production Line Solution

- Full Auto Machining Machine
- Full Auto Forming Machine
- NC/CNC Horizontal type rotary transfer machine

Tube/Pipe Special Purposed Equipment

All Kinds of Hydraulic Machines

- ▶ Professional
- ▶ Quality
- ▶ Improve Productivity
- ▶ Deduce cost

CNC SPM Fine Boring Machine

雙五道四軸銑孔機

- 1 4 spindle boring at one cycle
- 2 4 bearing hole
- 3 concentricity at same line



CNC SPM Tapping Machine

數控鑽孔攻牙機

- 1 4th-axis rotary table
- 2 Z-axis high is 750mm(Enlarge)
- 3 Special proposed tapping machine



Single End Notching Machine

切管機/沖弧口機

- 1 Apply for Cro-Moly, Alloy, stell
- 2 Notching angel adjustable 0~180 deg.



Auto-Feeding Mitering Notch Machine

管件自動送料銑弧口機

- 1 Auto feeding and discharging
- 2 With Lubricating device



HO CHIER ENTERPRICE Co., LTD

Manufacturer of Tube Processing Machine, Special-Purposed Machine
No.351, Dama Rd., Waipu Township, Taichung City 438, Taiwan
438 台中市外埔區大馬路351號

Contact information:

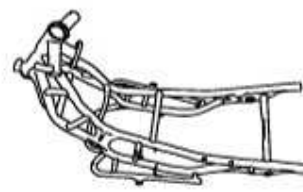
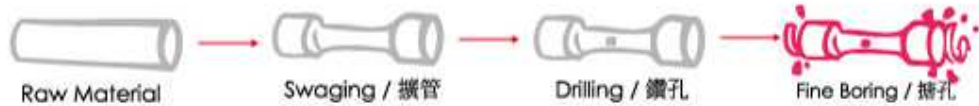
Tel: +886-4-26830612

Fax: +886-4-26830237

Http://www.hochier.com

E-mail: Sales@hochier.com

Processing



Model	FB-HDS-41A	FB-HDS-42C	FB-Tradition
Spindle Module			
Spindle	Machine center spindle	Machine center spindle	SPM traditional spindle
Spindle drive	Belt type	Direct type	Belt type
Max. rpm	3800 rpm	4000 rpm	2000 rpm
Cutter bar type	BT40	BT40	Flange type
Spindle Motor	Servo type Spindle Motor	Servo type Spindle Motor	Normal Motor
Cutter change	By UnClamping cylinder	By UnClamping cylinder	Screw type
ATC	1 cutter	2 cutters	1 cutter
Spindle cooler	NA	Yes	NA
Sliders			
Guide	Linear guide	Linear guide	Hard guide
Feeding	Servo	Servo	Servo (or Hydraulic)
Feeding Speed	Fast	Fast	Slow
Clamping			
Clamping Force	Panel number control	Panel number control	Manual adjust
Force FB vs BB	Fixed	Force can be changed automatically btw BriefBoring and FineBoring	Fixed
Electric			
Control	CNC	CNC	CNC (or PLC)
MPG	Yes	Yes	NA
Accuracy			
Spindle Roundness	< 0.003mm	< 0.003mm	0.005-0.008mm
Machine concentricity	< 0.025mm	< 0.025mm	0.05mm
Facilities			
Door	Auto	Auto	Manual
Machine weight	Around 4.5 Tons	Around 5.5 Tons	Around 2.7 Tons
Photo			

CNC ATC Double End Fine Boring Machine
數控換刀機構雙端搪孔機



- 1 中心加工機 高速主軸
- 2 夾持壓力可數值調整 自動換壓
- 3 可自動手動 打刀BT40
- 4 圖文操作介面 免編程式·易操作
- 5 增加刀片的壽命
- 6 先粗精換刀後精搪 可增加精度的穩定性
- 7 可選配增加 中間Y軸伺服工作滑台
- 8 可選配增加為6支刀刀庫



CNC ATC FINE BORING

Solve the double-end machining at the same time, special machinery for roundness and concentricity.

- CNC control
- Auto cutter change (Rough boring > Fine boring or Multi-shape)
- Cutter magazine (2pcs/6pcs)
- Machine center spindle with high speed motor

Application:

Head Tube, Swing Arm, Bottom Bracket
Guide Sleeve, Wrist Pin of Engine Piston





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CNC ATC Double End Fine Boring Machine
 數控換刀機構雙端搪孔機



01
 Shorten the working time
 縮短同時加工細加工時

02

To solve the double-end machining at the same time, special machinery for roundness and concentricity.
 解決雙端同時搪孔真圓度與同心度的專用機械

04

Boring process for bearing boring and through mandrel.
 針對軸承孔與穿心軸的搪孔製程

03
 No need to move the workpiece.
 不需移動加工件

- *To solve the problem of excessive tolerance of dimensional tolerances.
- *Machining method for resolving double-layer boring aperture.
- *Increase the insert life of fine boring.
- ① 可解決預留量過多造成尺寸公差不穩定的問題
- ② 可解決雙層搪孔孔徑的加工法
- ③ 可增加精搪刀片的壽命



The diameter of the fine hole requires allowance only <math><0.2\text{mm}</math>. If the allowance is too large, you need to rough fine boring and then fine boring again.
 精搪孔直徑尺寸只需要預留<math><0.2\text{mm}</math>。若加工預留量過多，則需要先粗搪再精搪



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