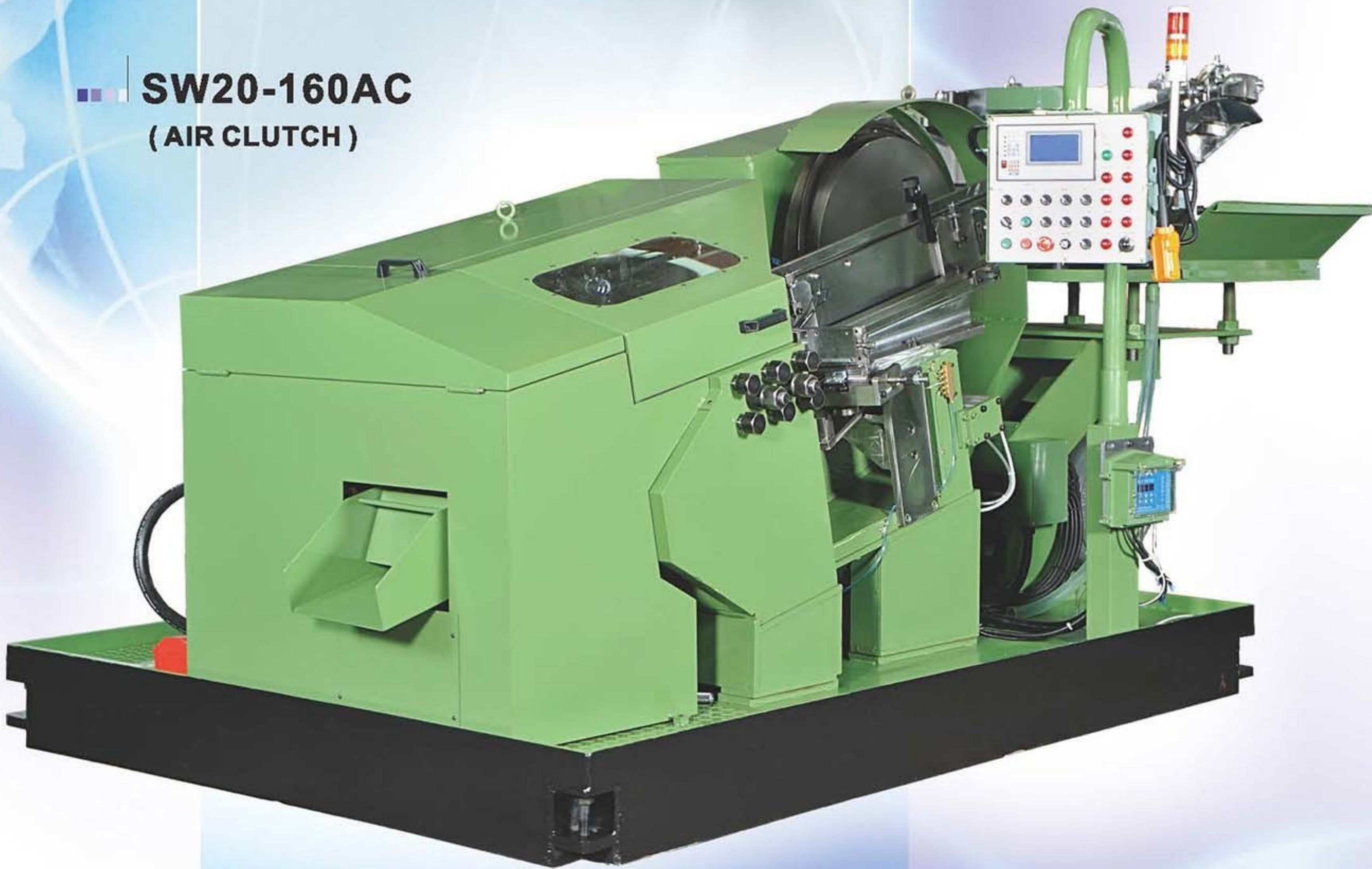




# TOP STABILITY

MACHINE INDUSTRY CO.,LTD

SW20-160AC  
(AIR CLUTCH)



上穩機械工業股份有限公司  
**TOP STABILITY MACHINE INDUSTRY CO.,LTD**

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# TOP STABILITY

## THREAD ROLLING MACHINE

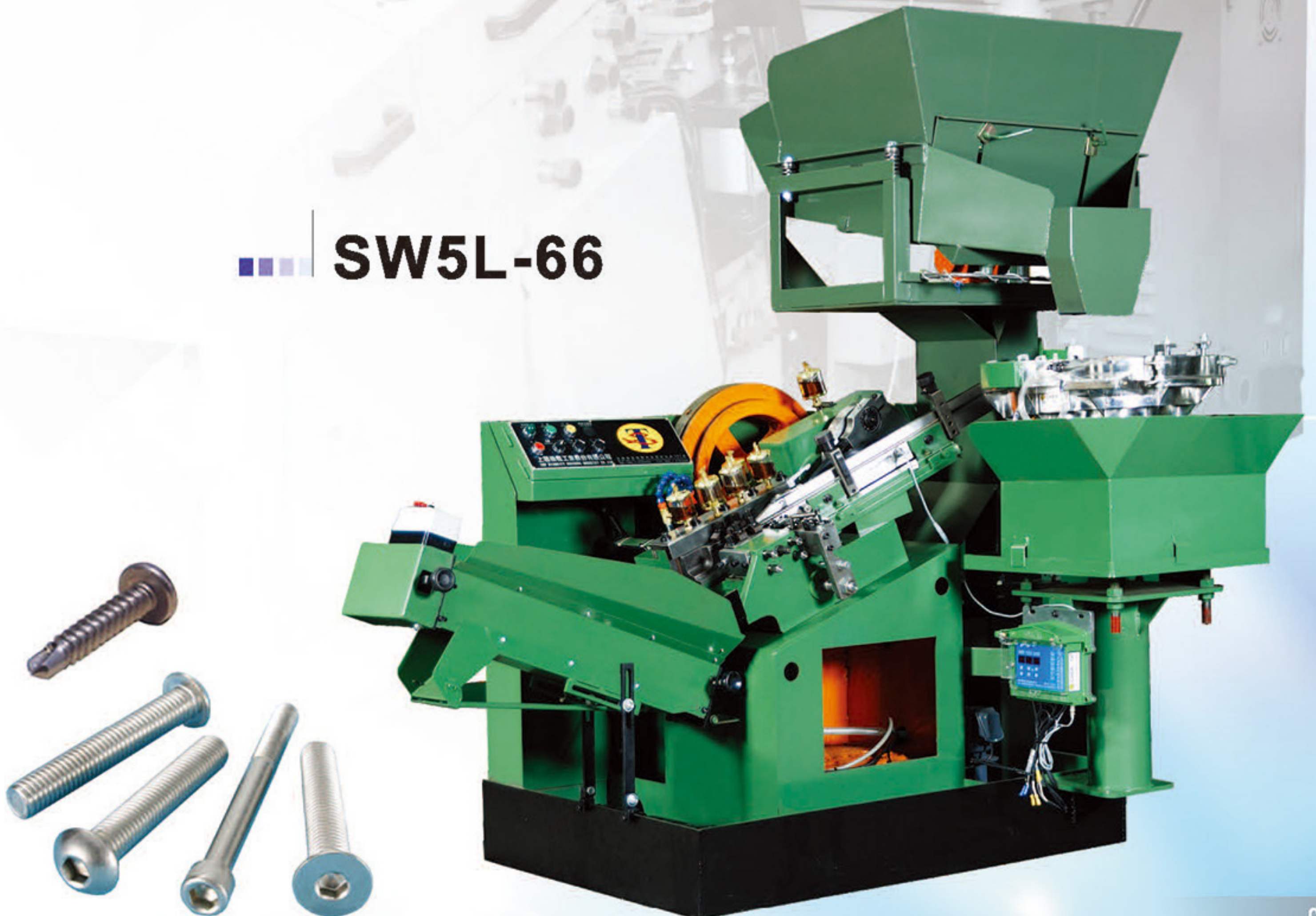
搓 牙 機



SW5S-56



SW5L-66



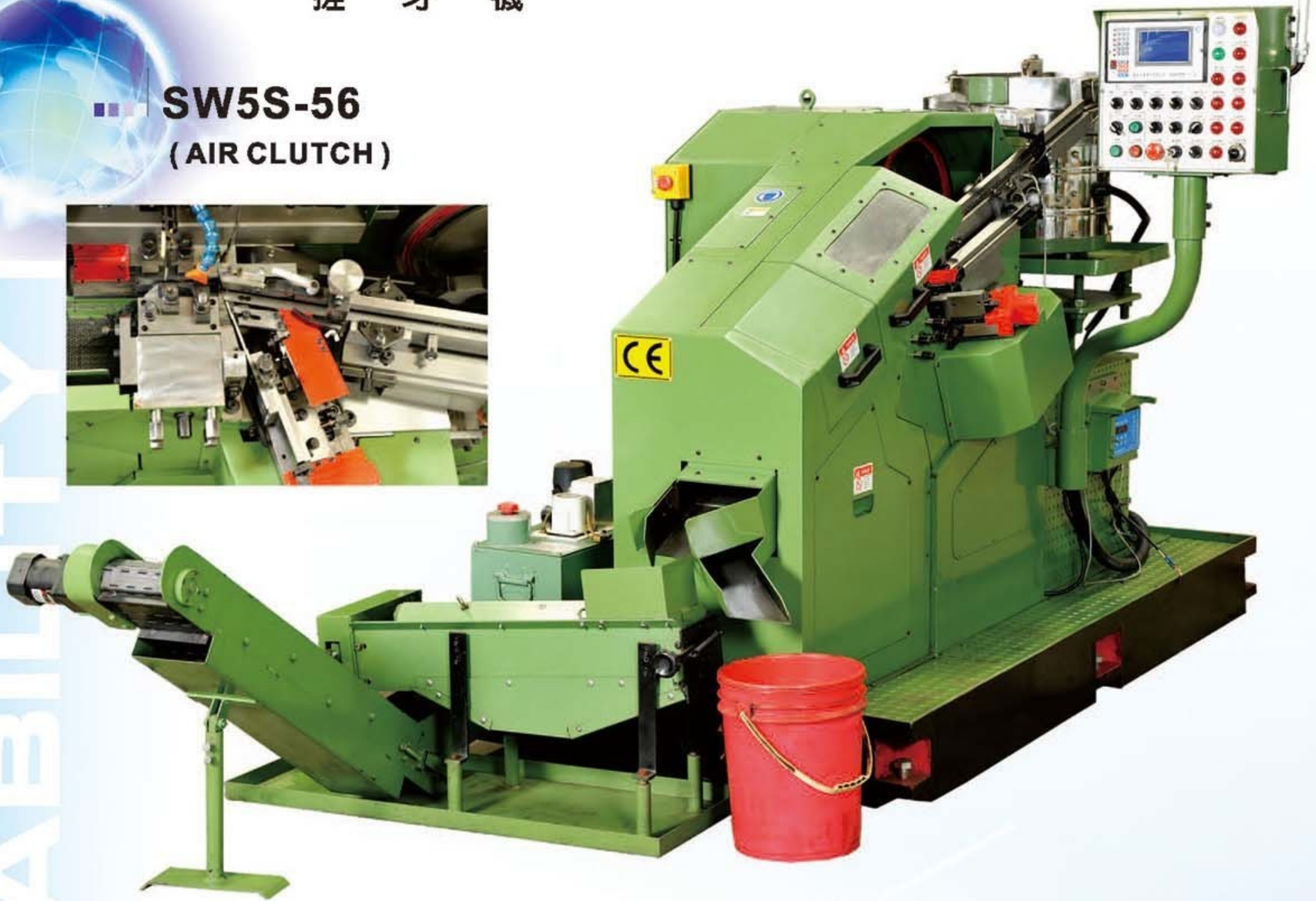


# THREAD ROLLING MACHINE

搓 牙 機



SW5S-56  
(AIR CLUTCH)



當生產中因螺絲浮動而產生不良品時，擋料片會擋住螺絲而且機器會自動停止。

When screws bounce or float cause of defective products in manufacture, stopper will block up the defective ones and the machine will stop automatically.



B最高可以調升25mm. 當在生產相同尺寸但是牙長較短的螺絲時，只要調整A, B及C的高度至所需的高度即可，不需要再使用任何墊片。

B can be lifted up to 25mm. While making the same size of screws but the length of thread is shorter, just adjust the height of A, B and C. It is not necessary to put any washers.



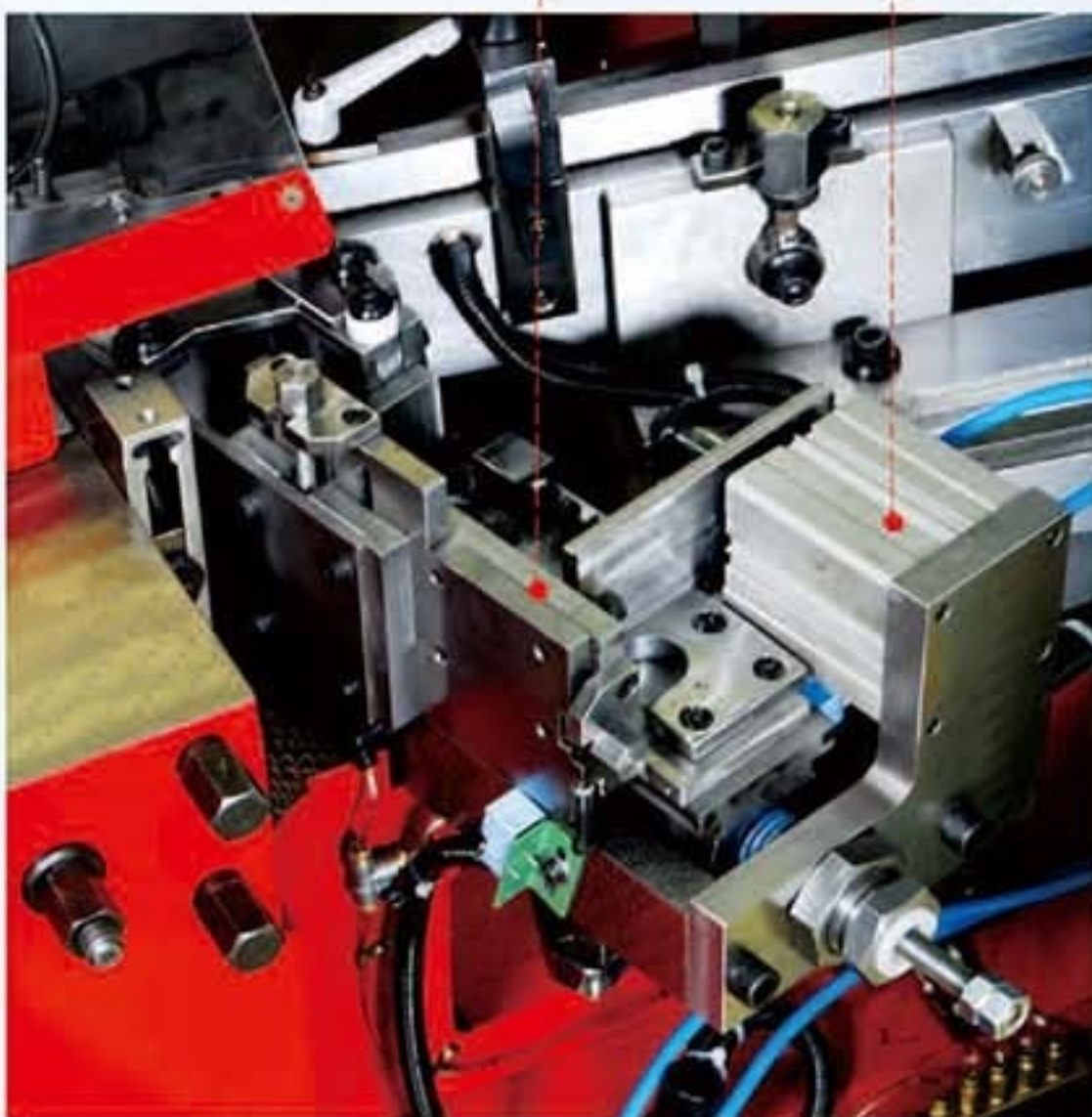
**自動檢測器**具有檢測螺絲長度、螺絲直徑以及牙長不符合設定範圍的功能，線材不穩定時，也會顯示異常，同時也具有在生產尖尾螺絲時檢測是否有燒焦的功能。

Auto checker has the functions of detecting screw length, screw diameter and screws with the thread which are not in the setting limit and it will show detective parameter if the quality of material is not stable. It also can detect screws which are burned in manufacture of point screws.



**Feeding**

**Stopper**



**當感應器無法感應到螺絲但是定位感應器連續感應到50支螺絲時，機器會自動停止。**

有可能是振動盤缺料或是螺絲卡在振動盤或流道中而造成。

When sensor doesn't induct screws but positioning sensor inducts 50 pieces of screw continuously, the machine will stop. It means vibrator is short of screws or screws are stuck in vibrator or screws are stuck in track.



**機器發生任何異常時，機器會自動停止並且將送料機構往回拉，不會將螺絲送至牙板座，擋料片會自動關閉，保護牙板不致受損。**

When the machine has any problems, the machine will stop automatically and the feeding system will be pulled backward.

So, screws won't go to the rolling die holder and the stopper will be closed to avoid the rolling die being damaged.



# THREAD ROLLING MACHINE

搓 牙 機

■ ■ ■ SW8L-105 (STANDARD TYPE)



■ ■ ■ SW8L-105 兩用  
(DOUBLE SIZE)



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型號 Model	SW3S-26	SW5S-45		SW5S-56		SW5L-66	SW6S-56	SW6L-81	SW8L-105	
		ST	AC	ST	AC				ST	AC
最大線徑 Max. Wire Dia. /(mm)	3mm	5mm		M5	M6	5mm	6mm	6mm	8mm	
最大首下長 Max.Shank Length Under Head	20mm	40mm		50mm		60mm	50mm	75mm	100mm	
最大牙長 (機械牙為準) Max. Thread Length (Machine Screw)	20mm	40mm		40mm	50mm	60mm	50mm	75mm	100mm	
牙板尺寸 Rolling Die Dimension	64 x 76 x 19	75 x 90 x 25 90 x 105 x 25		90x105x25		90x105x25	102x115x25	102x115x25	127x140x25	
產能(分鐘) Capacity(Min)	350~500pcs	270~350pcs		250~300pcs		200~250pcs	160~200pcs	150~180pcs	120~150 pcs	130~180 pcs
馬力 Motor	2HPx1/4x1/8	3HPx1/4x1/8		5HPx1/2x1/8		5HPx1/2x1/8	5HPx1/2x1/8	7.5HPx1/2x1/8	10HP	20HP
送料座 Feeding System	Vibrating Feeder	Vibrating Feeder		Vibrating Feeder		Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	
淨重 Net Weight /(Kgs)	800Kgs	1200 Kgs	1500 Kgs	1500 Kgs	2800 Kgs	1300Kgs	1600Kgs	1700Kgs	2500 Kgs	4500 Kgs

型號 Model	SW8L-160	SW8L-210	SW10-160	SW12-270	SW12-160AC	SW16-160AC	SW20-160AC SW20-210AC
最大線徑 Max. Wire Dia. /(mm)	8mm	8mm	10mm	12mm	12mm	16mm	20mm
最大首下長 Max.Shank Length Under Head	155mm	205mm	155mm	260mm	100mm	155mm	200mm
最大牙長 (機械牙為準) Max. Thread Length (Machine Screw)	100mm	100mm	155mm	150mm	100mm	100mm	100mm
牙板尺寸 Rolling Die Dimension	127x140x25	127x140x25	150x165x25	190x215x35	190x215x35	230x265x38	230x265x38
產能(分鐘) Capacity(Min)	100~110pcs	100~110pcs	100~140pcs	50~70pcs	90~110pcs	50~90pcs	50~80pcs
馬力 Motor	15HPx1/2x1/8	15HPx1/2x1/8	20HPx1/2x1/8	30HPx1/2x1/8	20HPx1/2x1/8	40HPx1/2x1/8	40HPx1/2x1/8
送料座 Feeding System	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder	Vibrating Feeder
淨重 Net Weight /(Kgs)	2600Kgs	2700Kgs	5000Kgs	11000Kgs	7500Kgs	11500Kgs	11500Kgs

規格如有變更，恕不另行通知。 Modification subjected to change without any notice.



# HEADING MACHINE

打 頭 機



SWHM6LL-150



SWHM5S-50



TOP STABILITY

# TOP STABILITY



型號 Model	SWHM5S-35	SWHM5S-50	SWHM5L-65	SWHM5L-75	SWHM6L-100	SWHM6LL-150	SWHM6LL-200
最大可製外徑 Blank Dia. Max. /(mm)	2~5φ	2~5φ	2~5φ	2~5φ	3~6φ	3~6φ	3~6φ
最大可製長度 Blank Length Max. /(mm)	5~35	10~50	16~65	20~75	25~40	40~100	80~150 120~200
主機尺寸 Main Die Dia. /(mm)	34.5 x 67.5	34.5 x 67.5	34.5 x 79.5	34.5 x 100.5	50 x 150.5	60 x 200.5	60 x 260.5
一沖二沖沖模尺寸 1st & 2nd Punch Dia. /(mm)	31φ x 56.5	31φ x 56.5	31φ x 56.5	31φ x 60	36φ x 70	38φ x 90	38φ x 90
剪模尺寸 Cut-off Die Dia. /(mm)	19φ	19φ	19φ	19φ	25φ	25φ	25φ
剪刀尺寸 Cutter / (mm)	9.5 x 30 x 65	9.5 x 30 x 65	9.5 x 30 x 65	9.5 x 30 x 65	11.5 x 50 x 80	11.5 x 50 x 75	11.5 x 50 x 85 11.5 x 50 x 85
主機台衝程 Main Silder Stroke /(mm)	64	80	92	120	170	220	270
產能 (分鐘) Capacity (Min)	175~200pcs	150~180pcs	130~180pcs	80~120pcs	90~100pcs	四段變速 55,65,80,90	四段變速 55,65,80,90
主馬達 Main Motor	3HP	3HP	3HP	5HP	10HP	10HP	10HP
幫浦馬力 Oil Pump	1/4HP	1/4HP	1/4HP	1/4HP	1/4HP	1/4HP	1/4HP
後沖棒 Back K.O.	7.5 x 75	7.5 x 75	7.5 x 75	7.5 x 83	9.5 x 145	9.5 x 195	9.5 x 240
淨重 Net Weight /(Kgs)	1450	1450	1480	1680	2800	5500	6000
毛重 Gross Weight	1600	1600	1630	1880	3000	6000	6500
機械尺寸 Machine Dimension /(cm)	200x106x115	190x110x118	190x110x118	240x113x125	310x123x170	445x155x175	510x165x185

規格如有變更，恕不另行通知。 Modification subjected to change without any notice.





# NUT FORMER

螺帽成型機



## NUT FORMER

螺帽成型機

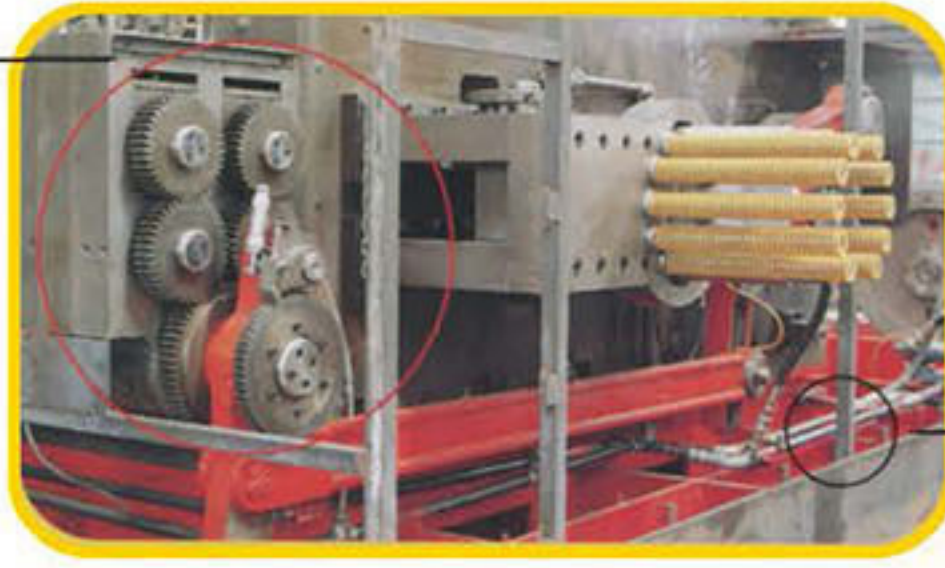


TOP STABILITY

# TOP STABILITY

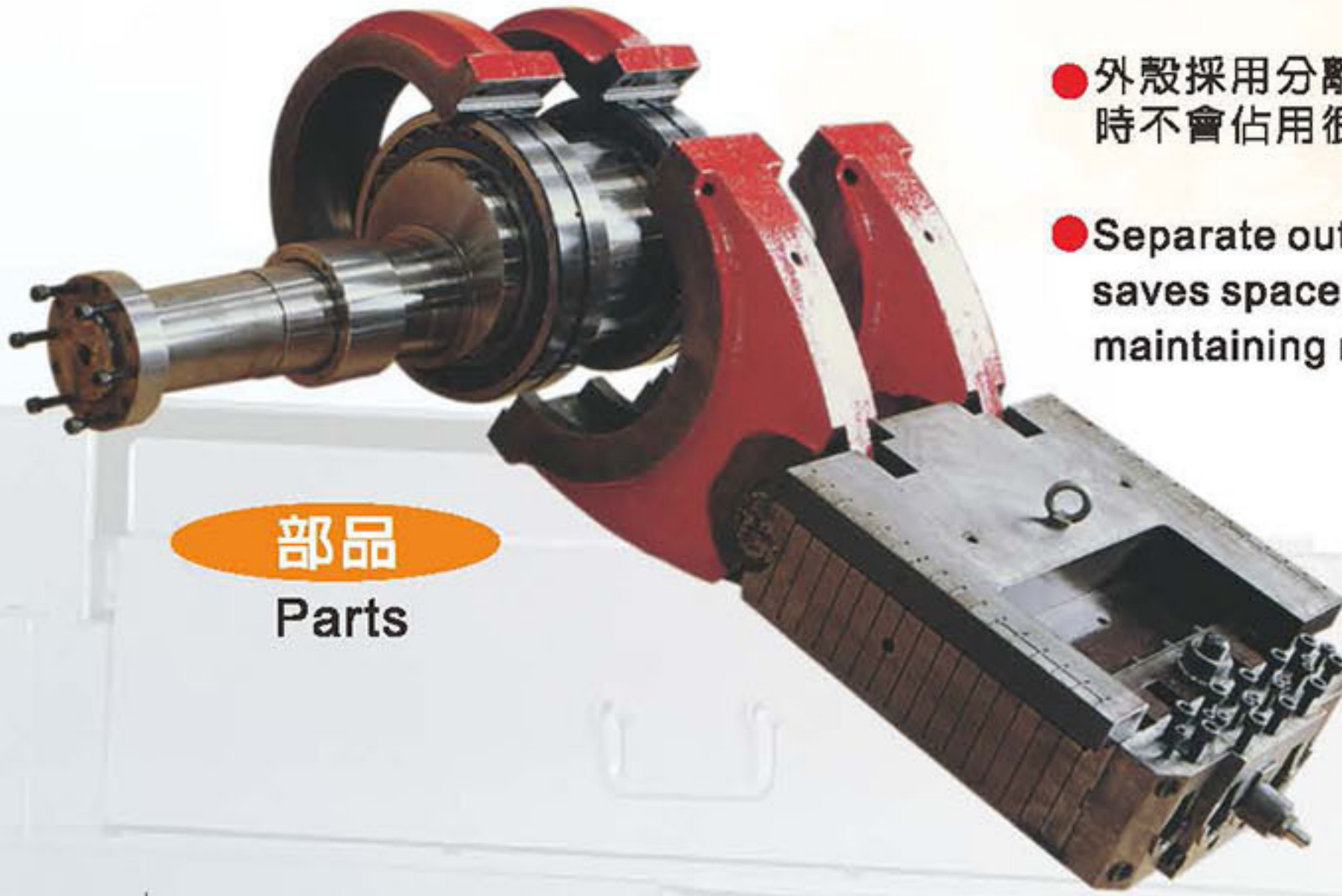
●進料、停料、  
採用氣壓式電源控制。

●Air-pressure electric  
generator control  
adopted for feeding  
and stopping.



●外殼採用分離式，保養  
時不會佔用很大空間。

●Separate outer shell  
saves space as  
maintaining machine.



部品

Parts

成品

Finished Products

## 螺帽成型機規格表 NUT FORMER Specification

型號 Model	BF-NF 11B	BF-NF 14B	BF-NF 17B	BF-NF 19B	BF-NF 22B	BF-NF 24B	BF-NF 27B	BF-NF 30B	BF-NF 33B	BF-NF 36B	BF-NF 41B	BF-NF 46B	BF-NF 50B
規格 Specification													
模數 Forging Station	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	5S / 6S	6S	6S
最大切斷直徑(mm) Max. Cut-off Dia.	11	14	16	19	22	24	26	30	33	36	41	45	50
最大切斷長度(mm) Max. Cut-off Length	(8)	(15)	(15)	(20)	(25)	(25)	(30)	(35)	(35)	(45)	(45)	(50)	(55)
後托頂出長度(mm) Max. Kick-out Length	(12)	(20)	(20)	(25)	(30)	(35)	(40)	(45)	(45)	(50)	(60)	(60)	(60)
母模中心距離(mm) Center Distance Between Dies	50	60	70	80	80	100	100	120	140	150	165	190	190
主滑塊行程(mm) Ram Stroke	56	80	90	90	110	120	125	146	146	160	240	240	240
壓造力(噸) Forging Power (ton)	60	90	110	150	200	250	300	360	450	530	630	800	800
產品(吋) Product Size(Inch/mm)	4#~1/4 M2.5~M6	1/4~3/8 6~8	1/4~7/16 6~10	1/2~1/2 8~12	5/16~9/16 8~14	3/8~5/8 10~16	3/8~5/8 10~18	1/2~3/4 12~20	1/2~7/8 12~20	5/8~1 16~24	3/4~11/8 20~27	7/8~11/4 22~30	1~1/4 M27~M36
每分鐘最大產能 output (pcs/min)	(350)	(250)	(220)	(180)	(160)	(145)	(130)	(100)	(85)	(75)	(75)	(65)	(50)
主馬達(HP) Main Motor (HP)	(15)	(20)	(20/30)	(30)	(40)	(50)	(50)	(75)	(100)	(170)	(250)	(350)	(400)
油壓馬達(HP) Pump Motor (HP)	1	1/1	1/1	1/2	1/2	1/2	1/3	1/3	1/3	1/3	1/3	1/2/2	1/2/2
油用量(加侖) Lubricant (gallon)	200	300	300	350	350	380	420	620	620	750	900	1350	1350
機械重量(噸) Net Weight (ton)	4.5 5.0	7.5 8	8 10	12 14	15 17	20 23	24 28	40 41	41 45	55 63	65 71	108	135
佔地面積長 (M)	2.5	3.1	3.5	3.85	4.0	4.5	4.7	5.5	6.0	6.4	6.7	7.2	7.5
寬 LxWxH (M)	1.63	1.9	2.0	2.15	2.25	2.25	2.7	3.25	3.35	3.7	3.8 4.0	4.7	5.0
高 (M)	1.2	1.4	1.1	1.6	1.7	1.75	1.95	2.2	2.25	2.4	2.5	2.9	3.15
Floor Area Required													

※本表括弧內的數據，有關速度與產品長度為配合設計，僅供參考（一般螺帽不在此限）。本機械模數不包括切模，佔地面積不包線架尺寸。

※The numbers in the brackets, relevant to speed and length, are just for referencr. (Standard hex nuts are out of the rule.)

The number of dies does not include cutting quill assembly core, and the floor area required excludes the area of wire stand.



# SELF-DRILLING SCREW FORMING MACHINE

鑽尾螺絲成型機

ST-1405



型號 Model	ST-1405	ST-1606	ST-1808
傳動方式 Transmission	日内瓦機構 Geneva Organization	分割器 Index	雙凸輪傳動 Twin Cams
送料定位方式 Feeding / Positioning	X	X	分割器 Index
變頻器 Inverter	10HP	15HP	15HP
馬達 Motor	7.5HP (6P)	10HP (6P)	10HP (6P)
速度 Speed	120 ~ 450 rpm(Max:500)	120 ~ 520 rpm(Max:600)	40 ~ 250 rpm
控制方式 Control	PLC 控制方式 (Program Logical Control)  LED 故障顯示 (Light Emitted Display)	PLC 控制方式 (Program Logical Control)  LED 故障顯示 (Light Emitted Display)	PLC 控制方式 (Program Logical Control)  LED 故障顯示 (Light Emitted Display)
製造能力 Production Ability	Die $\phi$ 2.8~5.2 (#6~#12)  Length 9.5 ~ 125 mm	Die $\phi$ 2.8~6.0 (#6~#16)  Length 9.5 ~ 150 mm	Die $\phi$ 2.8~7.0 (#6~#18) Length 10 ~ 200 mm  特別定製 (Special order) Max:370m
機械尺寸(cm) Machine Dimension	190 x 140 x 160	190 x 150 x 180	185 x 195 x 185
機械重量 (噸) Net Weight (kg)	2200	2500	3500

規格如有變更，恕不另行通知。 Modification subjected to change without any notice.

## HOOK MACHINE 線材成型機

### SW-30



Model	SW-30	
送線長度(mm) Length of wire feeding	200	200
線材硬度(Carbon) Hardness of wire	80(Carbon)	80(Carbon)
鋼線(mm) Wire size	0.6 ~ 0.4	0.4 ~ 6.0
加工速度 Processing Speed	一分鐘90條 (90pcs/min)	一分鐘80條 (80pcs/min)
滑座沖力(kgs) Slide Power	1500	1500
馬力 Motor	3HP/2.2KW	5HP/3.7KW

規格如有變更，恕不另行通知。  
Modification subjected to change without any notice.

## WASHER ASSEMBLING MACHINE 華司組合機

### SWA-068



螺號 Model	SWA-035	SWA-068
螺絲外徑 Screw Dia.	3 ~ 5mm	6 ~ 8mm
螺絲長度 Screw Length	8 ~ 30mm	10 ~ 75mm
速度 Speed	100 ~ 300pcs	60 ~ 160pcs

規格如有變更，恕不另行通知。  
Modification subjected to change without any notice.

# BOLT FORMER 螺絲成型機



CBF SERIES-3 STATIONS								
M/C TYPE	CBF-43S	CBF-63S	CBF-83S	CBF-83L	CBF-103S	CBF-103L	CBF-133S	CBF-133L
FORGING STATION	3	3	3	3	3	3	3	3
FORGING LOAD(kg)	16,000	35,000	60,000	60,000	80,000	80,000	115,000	115,000
MAX. CUT-OFF DIA. (mm)	φ5	φ8	φ10	φ10	φ12	φ12	φ15	φ15
MAX. CUT-OFF LENGTH (mm)	66	70	75	135	105	192	145	250
MAX. OUTPUT (pcs/min)	300	260	240	180	200	140	160	100
P.K.O. STROKE (mm)	10	12	12	16	15	15	26	25
K.O. STROKE (mm)	56	52	52	115	80	162	102	230
MAIN MOTOR (HP)	10	15	20	25	25	30	40	40
CUT-OFF DIE DIA.(mm)	φ38x30L	φ30x45L	φ53x56L	φ30x50L	φ45x59L	φ45x59L	φ63x69L	φ55x70L
PUNCH DIA.(mm)	φ31x65L	φ40x90L	φ45x95L	φ45x140L	φ53x115L	φ53x112L	φ60x130L	φ60x179L
MAIN DIE DIA.(mm)	φ38x85L	φ50x85L	φ60x80L	φ60x150L	φ75x108L	φ75x200L	φ186x135L	φ86x265L
MACHINE WT. (APPROX.)(kg)	5,600	7,500	10,000	14,000	14,000	19,500	19,500	31,000
NORMAL SIZE OF BOLT (mm)	2-4	3-6	5-8	5-8	6-10	6-10	8-12.7	8-12.7
SHANK LENGTH OF BLANK(mm)	6-50	10-50	15-50	30-107	15-70	60-152	20-100	70-204

CBF SERIES-4 STATIONS													
M/C TYPE	CBF-44S	CBF-64S	CBF-84S	CBF-104S	CBF-134S	CBF-134L	CBF-134LL	CBF-164S	CBF-164LL	CBF-204S	CBF-204L	CBF-204LL	CBF-254S
FORGING STATION	4	4	4	4	4	4	4	4	4	4	4	4	4
FORGING LOAD(kg)	16,000	40,000	60,000	80,000	120,000	120,000	120,000	210,000	210,000	350,000	350,000	350,000	430,000
MAX. CUT-OFF DIA. (mm)	φ5	φ8	φ10	φ12	φ15	φ15	φ15	φ18	φ21	φ23	φ23	φ23	φ26
MAX. CUT-OFF LENGTH (mm)	66	95	100	133	140	190	285	195	350	195	240	360	253
MAX. OUTPUT (pcs/min)	300	240	200	160	150	120	80	110	70	95	80	65	70
P.K.O. STROKE (mm)	10	12	19	20	26	30	30	30	40(46)	46	46	46	40
K.O. STROKE (mm)	56	80	85	110	102	160	280	170	320	170	220	325	175
MAIN MOTOR (HP)	10	20	30	30	40	50	50	60	75	75	75	100	125
CUT-OFF DIE DIA.(mm)	φ42x30L	φ30x45L	φ35x50L	φ45x59L	φ63x69L	φ63x69L	φ55x70L	φ60x90L	φ64x100L	φ75x120L	φ75x120L	φ75x120L	φ80x130L
PUNCH DIA.(mm)	φ31x65L	φ40x90L	φ45x115L	φ53x115L	φ60x130L	φ60x130L	φ60x229L	φ75x185L	φ75x185L	φ90x215L	φ90x215L	φ90x215L	φ120x270L
MAIN DIE DIA.(mm)	φ38x85L	φ50x110L	φ60x120L	φ75x135L	φ86x135L	φ86x190L	φ86x305L	φ100x190L	φ100x345L	φ125x200L	φ125x240L	φ125x345L	φ140x250L
MACHINE WT. (APPROX.)(kg)	6,500	10,000	14,500	18,000	21,000	26,000	38,000	43,000	60,000	62,000	62,000	75,000	105,000
NORMAL SIZE OF BOLT (mm)	2-4	3-6	5-8	6-10	8-12.7	8-12.7	8-12.7	10-16	10-16	12-20	12-20	12-20	14-25.4
SHANK LENGTH OF BLANK(mm)	6-50	10-75	15-77	15-102	20-100	25-152	80-254	20-152	100-305	25-152	25-200	100-305	HEX 36-176 SOCKET 36-186

CBF SERIES-5 STATIONS										
M/C TYPE	CBF-45S	CBF-65S	CBF-85S	CBF-105S	CBF-135S	CBF-135L	CBF-165S	CBF-205S	CBF-205L	CBF-255L
FORGING STATION	5	5	5	5	5	5	5	5	5	5
FORGING LOAD(kg)	16,000	40,000	80,000	90,000	130,000	130,000	220,000	350,000	350,000	440,000
MAX. CUT-OFF DIA. (mm)	φ5	φ8	φ10	φ12	φ15	φ15	φ18	φ23	φ23	φ30
MAX. CUT-OFF LENGTH (mm)	66	95	100	133	140	190	190	195	240	370
MAX. OUTPUT (pcs/min)	220	220	160	150	105	105	95	85	75	55
P.K.O. STROKE (mm)	10	15	26	20	26	30	35	46	46	45
K.O. STROKE (mm)	51	80	85	110	110	160	165	180	220	315
MAIN MOTOR (HP)	10	20	30	30	50	50	75	100	100	150
CUT-OFF DIE DIA.(mm)	φ42x30L	φ30x45L	φ35x62L	φ45x59L	φ63x69L	φ63x69L	φ64x100L	φ75x120L	φ75x120L	φ90x150L
PUNCH DIA.(mm)	φ31x65L	φ40x90L	φ45x115L	φ53x115L	φ60x130L	φ60x130L	φ75x185L	φ90x215L	φ90x215L	φ120x270L
MAIN DIE DIA.(mm)	φ38x71L	φ50x110L	φ60x120L	φ75x135L	φ86x190L	φ86x190L	φ108x200L	φ125x200L	φ125x240L	φ148x355L
MACHINE WT. (APPROX.)(kg)	8,000	13,000	16,000	20,000	31,000	31,000	52,000	75,000	75,000	140,000
NORMAL SIZE OF BOLT (mm)	2-4	3-6	5-8	6-10	8-12.7	8-12.7	10-16	12-20	12-20	16-25.4
SHANK LENGTH OF BLANK(mm)	10-51	10-75	15-77	15-102	20-100	20-152	25-152	25-152	25-200	60-305

規格如有變更，恕不另行通知。 Modification subjected to change without any notice.

**SW12-160AC**  
(AIR CLUTCH)



# TOOLINGS



# ROLL & COLLECTED SCREWS



50 PCS-STRIP



100 PCS-COIL

由交流道至上穩機械約 2.5KM  
From intercession to Top Stability about 2.5Km



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