

2013

年制造我国第一台 250KJ 数控全液压模锻锤
In 2013, the first set 250KJ CNC fully hydraulic die forging hammer was finished in China.

2012

年制造我国第一台 400KJ 数控液压对击锤
In 2012, the first set 400KJ CNC hydraulic counterblow hammer was finished in China.

2011

年制造我国第一台 125KJ U 型机身数控全液压模锻锤
In 2011, the first set 125KJ CNC fully hydraulic die forging hammer with U shape hammer body was finished in China.

2010

年完成我国第一台 320KJ 蒸空模锻锤数控化改造
In 2010, the first set 320KJ steam forging hammer CNC innovation was developed in China.

2009

年完成我国第一台 250KJ 蒸空模锻锤数控化改造
In 2009, the first set 250KJ steam forging hammer CNC innovation was developed in China.

2008

年完成我国第一台 125KJ 蒸空模锻锤数控化改造
In 2008, the first set 125KJ steam forging hammer CNC innovation was developed in China.

2006

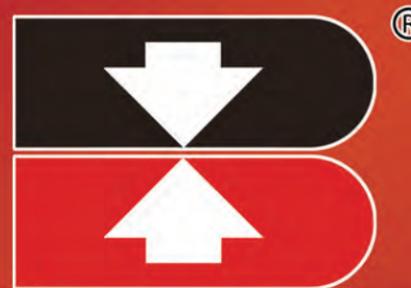
研制出我国第一台 100KJ 机身微动数控液压对击锤
In 2006, the first set 100KJ CNC hydraulic counterblow hammer with micro-motion of the machine body was developed in China.

2004

年完成我国第一台 80KJ 蒸空模锻锤数控化改造
In 2004, the first set 80KJ steam die forging hammer CNC innovation was developed in China.

2002

年完成出我国第一台具有国际同类产品先进水平的数控全液压模锻锤
In 2002, the first set CNC fully-hydraulic die forging hammer with the international advanced level of similar products was developed in China.



BAIXIE

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关于百协

ABOUT BAIXIE

持续创新 不断改进

INNOVATING CONTINUOUSLY, IMPROVING CONSTANTLY,

打造数控锻锤世界第一品牌

CREATING THE FIRST BRAND OF CNC FORGING HAMMER IN THE WORLD

百协锻锤
BAIXIE

中国数控锻锤制造基地——江苏百协精锻机床有限公司（原海安县百协锻锤有限公司），坐落在中国最具活力的长三角北翼江苏海安经济开发区，位于中国东部交通大动脉沈海高速海安出口处，是中国唯一专业生产数控模锻锤的厂家，是一家集科研、生产、销售为一体的江苏省高新技术企业，南通市产学研示范企业。

百协公司具有制造中国最大规格 1000KJ 数控锻锤的综合实力，拥有 TK6916、T6920D 等重型数控落地镗铣加工设备，拥有起吊单件 120 吨能力的大型产品总装车间。公司通过 ISO9001 质量管理体系认证和 CE 认证，并获得数控锻锤出口许可证。

百协公司已成为：

- 中国最专业的数控锻锤制造商；
- 中国最早的数控锻锤制造商；
- 中国门类最齐全的数控锻锤制造商；
- 国产最大规格的数控锻锤制造商；
- 国内出口量最大的数控锻锤制造商；
- 国内市场占有量最大的数控锻锤制造商。

数控锻锤是百协公司的主导产品。最新推出的 400KJ 数控全液压对击锤，是国内首创、国际领先，是借鉴了国内外大吨位锻锤先进技术最新设计，通过独特的液压联动对击系统、先进的液压动力驱动系统及可人机对话的程序打击控制系统，实现锻锤的高效、节能、环保、高精度、高可靠运行，与同类模锻设备相比具有显著的性价比优势。

百协数控锻锤已成功应用于汽车、摩托车、工程机械、液压管件、五金工具、手术器械、不锈钢餐具及航空航天工业，是高精度异型零件如连杆、曲轴、摇臂、转向节、拨叉、连接板、不锈钢刀叉、手术器械理想的现代化锻造成形设备，是自动化精密锻造生产线的核心设备。

百协数控锻锤已畅销全国，并出口至德国、印度、俄罗斯、泰国、巴西、土耳其、越南、马来西亚、叙利亚、台湾等国家和地区，深受客户的一致好评。

百协公司全体员工将以“百炼成钢，协力奋进，锻造精品，锤炼人生”的企业精神，始终致力于精密锻造设备及工艺的开发与应用研究，以其先进的技术装备、不断创新的锻锤理论与实践成果昂首屹立于世界先进锻造装备工业之林！

CNC forging hammer manufacturing base in China, Jiangsu Baixie Precision Forging Machinery Co.,Ltd. (formerly Haian Baixie Forging Hammer Co.,Ltd.), locating in Jiangsu Haian Economy & Development Zone in the north of Yangtze River Delta, situating in the Haian Exit of Yanhai Highway, is the only professional manufacturer of CNC die forging hammer in China, Jiangsu High & New Technology Enterprise with R&D, manufacture and sales and Nantong Industry-academy-research Demonstrative Company.

Baixie has capacity to manufacture China largest 1000 KJ CNC forging hammer, with heavy CNC pit boring & milling equipment such as TK6916, T6920D and so on, and spacious assembly workshop with craning capacity of 120 tons. Baixie has passed ISO9001 Quality Management System Certificate, TÜV Rheinland CE certificate and Export License for CNC forging hammer.

Baixie has been:

- the most professional manufacturer of CNC forging hammers in China;
- the earliest manufacturer of CNC forging hammers in China;
- the most complete manufacturer of CNC forging hammers in China;
- the greatest manufacturer of CNC forging hammers in China;
- the only exporter & manufacturer of CNC forging hammers in China;
- the largest market occupation of CNC forging hammers in China.

CNC forging hammer is the main product of Baixie. Its new 400 KJ CNC counterblow hammer is first in China and advanced in the world. It adopts the advanced technology of the large forging hammer at home and abroad, special hydraulic coupled counterblow system, advanced hydraulic driving system and person-machine program control system ensure its high effect, energy save, environmental protection, best precision and high reliability, which has the advantages of quality and price compared with other similar products.

Baixie's CNC forging hammers have been widely applied in automobile, motorcycle, engine machine, hydraulic tube, hardware, surgical instruments, stainless steel tableware and spaceflight industry. They are the ideal equipment to produce complicated parts, such as connecting rods, bend axes, rockers, steering knuckle, fork, tie plate, stainless steel knives and forks and surgical instruments, the key equipment of precise forging line.

Baixie CNC forging hammer has been sold very well in China, and also been exported to Germany, India, Russia, Thailand, Brazil, Turkey, Vietnam, Malaysia, Syria, Taiwan and so on, and got high reputation all over the world.

All the staffs in Baixie will insist on our spirit "Work in collaboration, Apply in specialty, Update in reality, Improve in time". Baixie will concentrate on development and research on precision forging equipment; stand firmly in the field of the world advanced forging equipment industry with high technology machine, innovated forging theory and practical achievement.





百协荣誉

GLORY OF BAIXIE





顾客为本 诚信服务

CUSTOMER ORIENTED & SINCERE SERVICE



①	②	③	④	
		⑤		⑥
⑨		⑦		⑧



1. 巴西、土耳其和德国客户来百协考察
customers from Brazil, Turkey and Germany visiting Baixie
2. 越南客户来百协考察
customers from Vietnam visiting Baixie
3. 土耳其客户来百协考察
customers from Turkey visiting Baixie
4. 德国客户来百协考察
customers from Germany visiting Baixie
5. 泰国客户来公司洽谈
customers from Thailand visiting Baixie
6. 德国WIHA工程师来百协考察
engineers from Germany WIHA visiting Baixie
7. 印度客户来百协接受培训
customers from India receiving training in Baixie
8. 叙利亚客户来百协接受培训
customers from Syria receiving training in Baixie
9. 清华大学锻压机械专家颜永华教授在百协考察
professor, Mr. Yan Yonghua from Tsinghua University, a forging machinery specialist visiting Baixie





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& PERFECT QUALITY



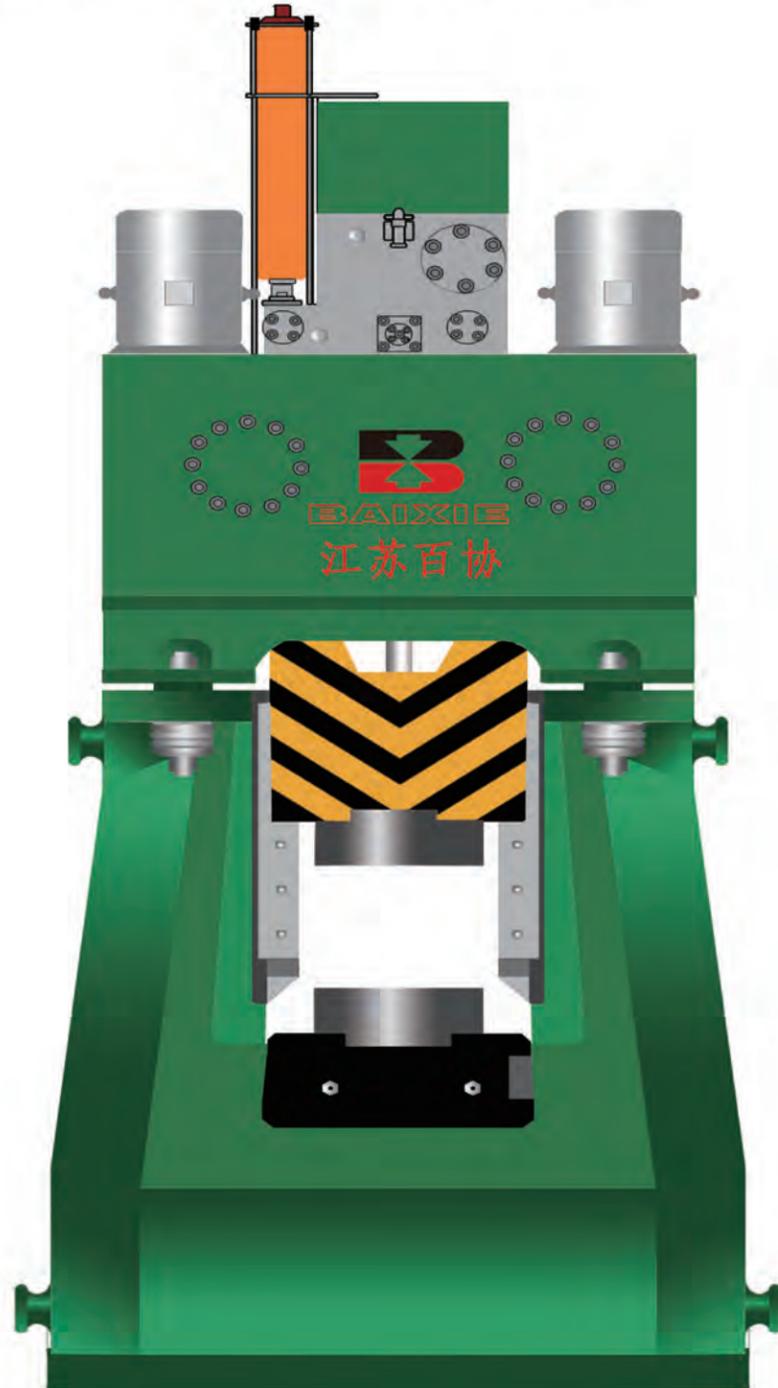


现代科技 彰显魅力

MODERN TECHNOLOGY & CHARM DISPLAY

CHK 系列数控全液压模锻锤

Series CHK CNC Fully-Hydraulic Die Forging Hammer



技术特征

- 全液压动力驱动系统，避免油气互串；
- 高度集成的液压控制系统，蓄能器直接安装在阀块上，实现无管联接，提高了液压系统的效率，更有利于设备维护；
- 液压系统卸压情况下进行慢升慢降动作，操作更安全；
- 先导阀及主阀采用锥阀结构，响应速度快，密封性好，不易产生内泄露；
- 先进的高低压双重密封结构，避免了液压油的泄露；
- 独特的可摆动油缸及锤杆导向结构，能适应偏心锻造，有利于延长锤杆寿命；
- 整体U型钢锤身，放射状导轨结构，锤头导向精度保持性好；
- 三面镶入式导轨定位，从而使导轨螺丝不受剪切力；
- 触摸式人机界面，故障自动诊断和报警，方便于设备的操作和维护；
- 打击能量的数字化精确控制，避免了打击过程中富余能量的危害。

优点

- 高效、节能、安全、可靠、环保；
- 坚固、耐用、刚性好、精度高；
- 回程速度快，不闷模；
- 操作简单、灵活；
- 可配套自动化生产线；
- 适应性强。

适应性

- 多品种小批量生产；
- 异型零件的精密锻造；
- 多模膛锻造及闭式模锻造；
- 粉末锻造、合金钢及有色金属锻造。

Technical feature

- Fully hydraulic driving system, avoiding oil and steam air crossing;
- High integrated hydraulic control system and accumulator fixed directly on main valve block without any pipe connecting, improving hydraulic system efficiency and easy to maintenance;
- Slow up and down in the case of releasing hydraulic system pressure, safer to operate;
- Taper priority valves and main valves structure, to get high response speed, good sealing performance and no internal leakage;
- Advanced high and low pressure double sealing structure, avoiding oil leakage;
- Special swayable oil cylinder and piston rods guiding structure, suitable for off-center forging and extending piston rod life;
- One piece casting U frame and radial wide guide rails, to get stable and high ram accuracy;
- Inlaid guide rails allocation in three side, get no shearing stress to guide rails screw;
- Touch screen man-machine interface and automatic malfunction diagnosis and alarm, easy for machine operation and maintenance;
- Digitized and exacted controlling striking energy, avoiding surplus energy harm during striking.

Advantages

- High efficiency, energy saving, safety, reliability and environmental protection;
- Firmness, durability, good rigidity and high accuracy;
- Return quickly, unclosed die;
- Easy and flexible operation;
- Be equipped with automatic forging line;
- Wide application.

Application

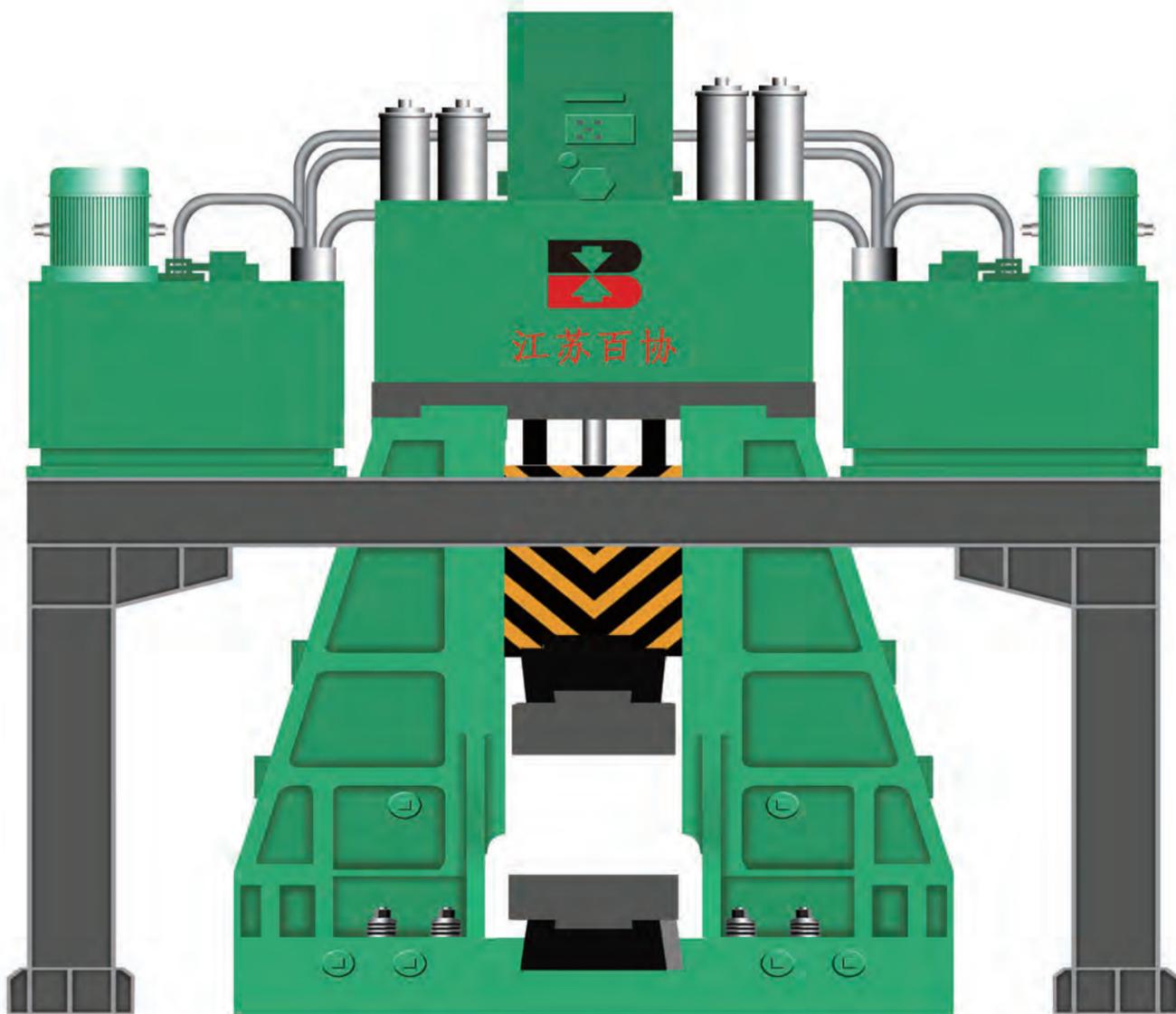
- Parts with small batch but many kinds;
- Precision forging of irregular and complex parts;
- Forge with several mold cavities and closed forging;
- Powder forgings, alloy steel forgings and non-ferrous metal forgings.

技术参数 Technical parameters

规格 SPEC.	CHK	16	25	31.5	50	63	80	100	125
打击能量 Striking energy	kJ	16	25	31.5	50	63	80	100	125
锤头质量 Ram weight	kg	1100	1700	2150	3400	4200	5400	6800	8400
打击频率 Striking frequency	min ⁻¹	100	90	90	90	80	80	75	70
电机功率 Motor power	kW	30	55	55	2X55	2X55	2X90	2X90	2X110
机器质量 Machine weight	T	26	40	51	85	100	125	150	198

CTKA 系列数控全液压模锻锤

Series CTKA CNC Fully-Hydraulic Die Forging Hammer



基本结构

- 全液压动力系统高度集成，无需泵房、地面液压站；
- 可编程打击控制，数字化输入；
- 长锤头结构，可提高工作精度；
- 打击能量、打击步序可任意设定，无富余能量的打击，可降低打击噪音、提高模具寿命；
- 人机界面，故障自动诊断，可中英文显示。

Basic construct

- High integrated fully hydraulic driving system, no need of pump chamber and hydraulic station;
- Programmable striking control and digital inputting;
- Long hammer tup enhancing working accuracy;
- Striking energy and striking sequence set optionally without surplus striking energy avoiding noise and increasing the die life;
- Man-machine interface and automatically malfunction diagnosis, Chinese and English display.

性能特点

- 高效、节能；
- 稳定的锻件质量；
- 较低的运行费用；
- 广泛的适用性；
- 较低的投资成本；
- 简单的维护与操作。

Performance and features

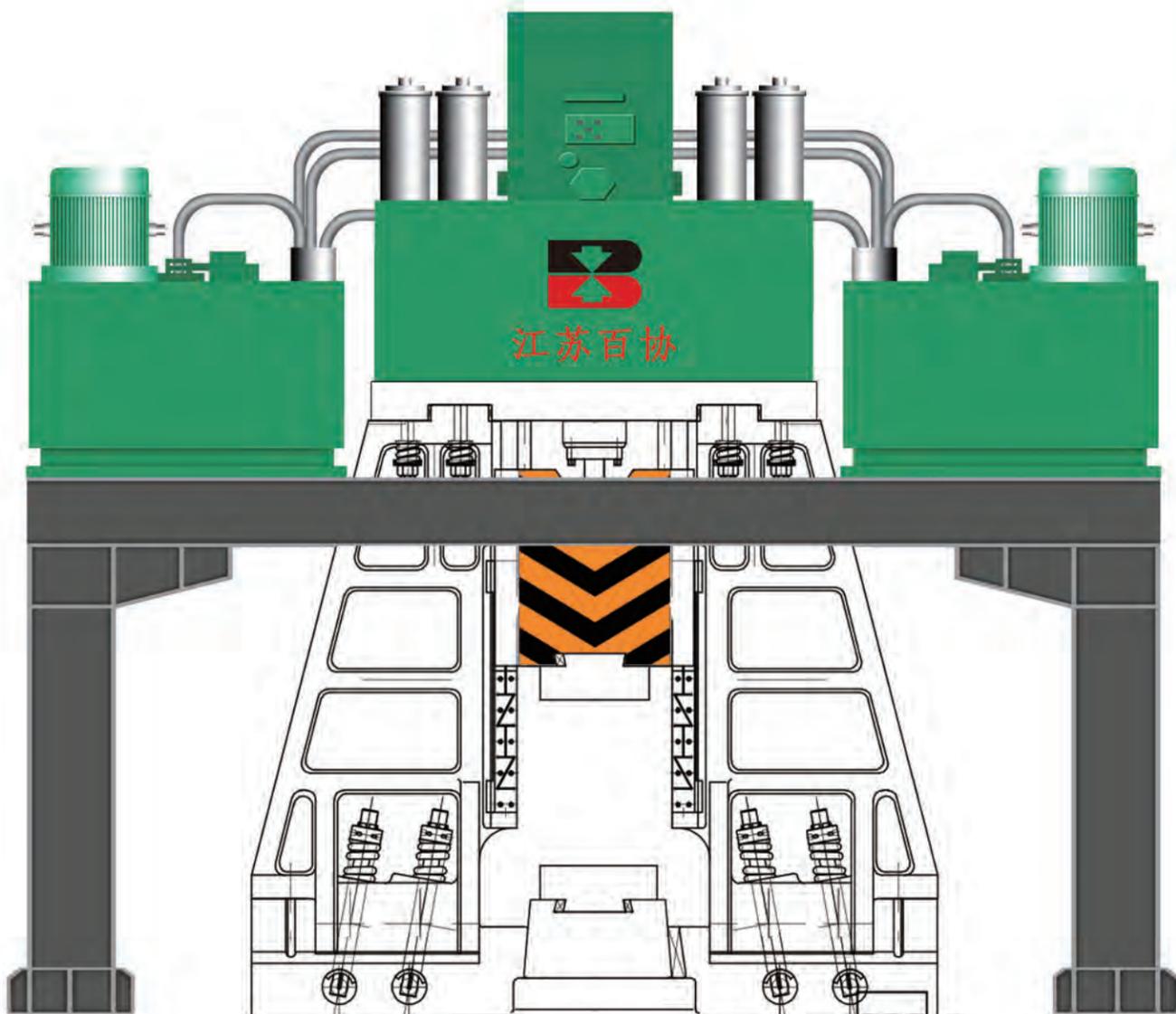
- High efficient, energy saving;
- Consistent quality of forging;
- Lower run cost;
- Wide application;
- Lower investment cost;
- Easy maintenance and operation.

技术参数 Technical parameters

规格 SPEC.	CTKA	160	200	250	320	400
打击能量 Striking energy	kJ	160	200	250	320	400
锤头质量 Ram weight	kg	9000	10000	11500	13000	17000
打击行程 Striking stroke	mm	1000	1050	1100	1200	1300
打击频率 Striking frequency	min ⁻¹	60	55	50	45	45
电机功率 Motor power	kW	4x75	4x90	4x90	4x110	6x110

CTK 系列数控全液压模锻锤(换头)

Series CTK CNC Fully-Hydraulic Die Forging Hammer
(Hydraulic drive conversion)



基本结构

- 全液压动力系统高度集成, 无需泵房、地面液压站;
- 可编程打击控制, 数字化输入;
- 长锤头结构, 可提高工作精度;
- 打击能量、打击步序可任意设定, 无富余能量的打击, 可降低打击噪音、提高模具寿命;
- 人机界面, 故障自动诊断, 可中英文显示。

Basic construct

- High integrated fully hydraulic driving system, no need of pump chamber and hydraulic station;
- Programmable striking control and digital inputting;
- Long hammer tup enhancing working accuracy;
- Striking energy and striking sequence set optionally without surplus striking energy avoiding noise and increasing the die life;
- Man-machine interface and automatically malfunction diagnosis, Chinese and English display.

性能特点

- 高效、节能;
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Performance and features

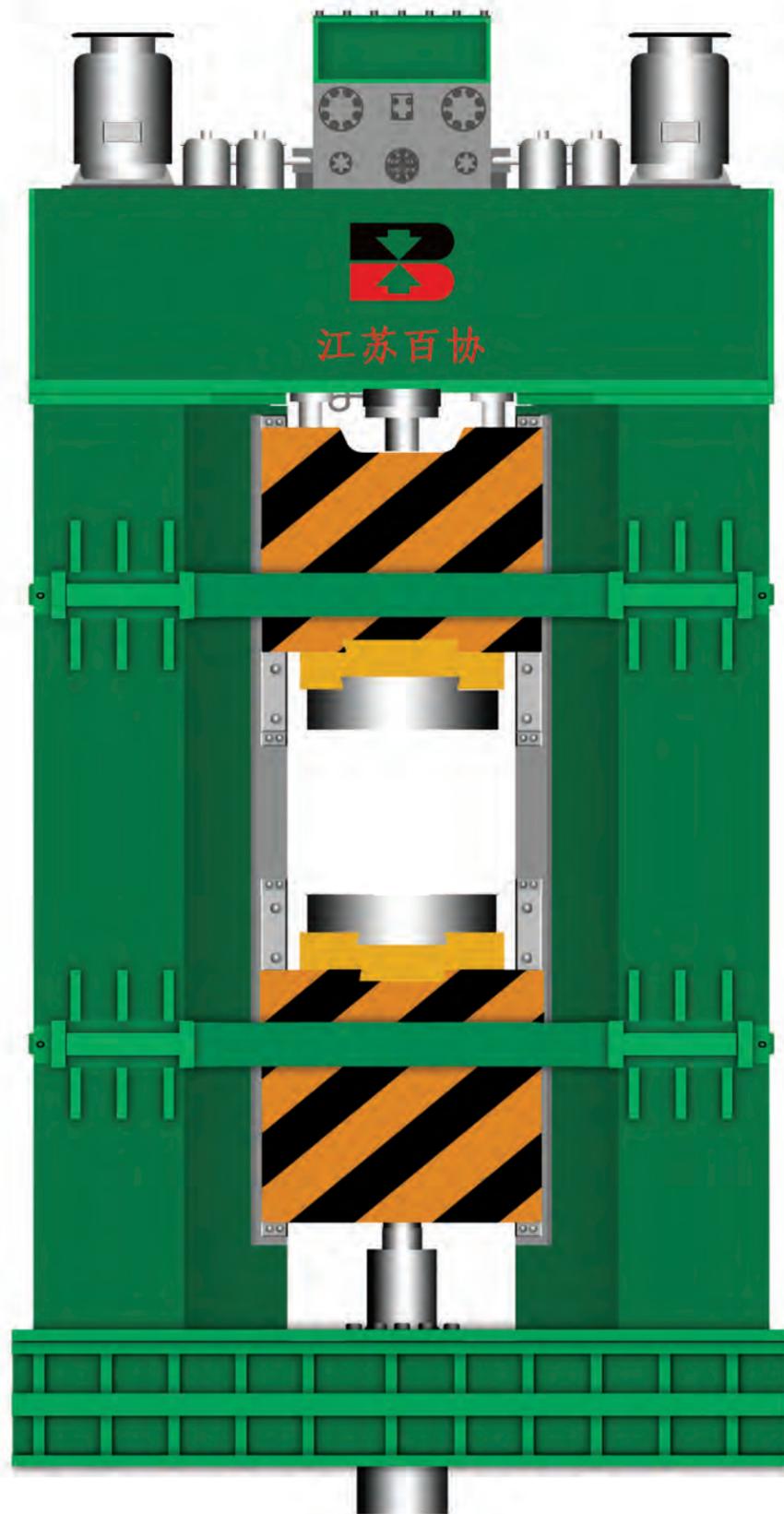
- High efficient, energy saving;
- Consistent quality of forging;
- Lower run cost;
- Wide application;
- Lower investment cost;
- Easy maintenance and operation.

技术参数 Technical parameters

规格 SPEC.	CTK	25	50	75	125	250	320	400
打击能量 Striking energy	kJ	25	50	75	125	250	320	400
锤头质量 Ram weight	kg	1750	3400	5100	8000	11500	13000	17000
打击行程 Striking stroke	mm	720	850	900	1000	1100	1200	1300
打击频率 Striking frequency	min ⁻¹	90	80	70	60	50	45	45
电机功率 Motor power	kW	55	2x55	2x90	4x55	4x90	4x110	6x110

CDKA 系列数控全液压对击锤

Series CDKA CNC Fully Hydraulic Counterblow Hammer



基本配置

- 锤杆、活塞所用密封件均为进口件；
- 配有自动润滑系统；
- 配有油温、压力数字显示在线检测器（德国）；
- 配有德国西门子电子控制系统；
- 配有德国西门子人机界面；
- 配有旁路循环冷却、过滤系统；
- 所用主油泵为斜轴式柱塞泵；
- 配有42个故障检测点（液压、电器），其中36个为自动检测点；
- 钢板焊接结构；
- 等质量锤头通过液压联动实现等行程悬空对击。

性能特点

- 高度集成的动力头采用数控全液压驱动原理，真正实现无管化连接，基本无泄露，高效、节能；
- 多项安全措施、周到的在线检测、简介的系统设计，确保安全、可靠；
- 具有一般、数控两种能量控制方式，可任意变换、设定，操作简单；
- 所用液压机90%为标准易购件，原理结构简单，生产运行费用低。

Basic disposition

- Imported sealed parts used in the hammer rod and piston;
- Automatic lubricating system;
- On-line digital display detector of oil temperature and pressure (Germany);
- Electronic control system of SIEMENS;
- Man-machine conversation screen of SIEMENS;
- Bypass circular cooling and filter system;
- Main oil pumps: angle-type plunger pumps;
- 42 malfunction check points (hydraulic, electronic) with 36 automatic check points;
- Welding hammer framework;
- The counterblow hammer's tups which have the equal weight strike each other with equal striking stroke by the hydraulic driving.

Performance and features

- High integrated power units adopts CNC fully hydraulic driving to realize no pipes connecting to ensure no leakage, high efficiency and energy saving;
- Multinomial safety measure, circumspect on-line detecting and simplified system design can ensure safety and reliability;
- Normal CNC energy control ways can be adjusted and set optionally and easily;
- 90% hydraulic parts are standard and easily purchased with simple construct and lower run cost.

技术参数 Technical parameters

规格 SPEC.	CDKA	160	200	250	320	400
打击能量 Striking energy	kJ	160	200	250	320	400
上锤头质量 Ram weight (up)	kg	18000	23000	29000	35000	48000
下锤头质量 Ram weight (down)	kg	20000	25000	32000	39000	52000
上锤头打击行程 Striking stroke (up ram)	mm	630	700	700	700	700
下锤头打击行程 Striking stroke (down ram)	mm	630	700	700	700	700
打击频率 Striking frequency	min ⁻¹	50	50	45	45	40
主电机功率 Main motor power	kW	220	264	360	440	528



百协品牌 领航锻造

BAIXIE BRAND THE PIONEER IN FORGING



山东威力 CHK25kJ -CHK100kJ 12条工具模锻线
CHK25kJ -CHK100kJ hand tools
die forging lines in Shandong Maxpower(12 lines)



景县 CHK16kJ-CHK31.5kJ 5条叉车配件模锻线
CHK16kJ-CHK31.5kJ forklift parts
die forging lines in Jingxian(5 lines)



瑞安南方 CHK31.5kJ-CHK80kJ 5条模锻线
CHK31.5kJ-CHK80kJ
die forging lines in Rui'an Nanfang(5 lines)



台湾 CHK31.5kJ-CHK100kJ 5条模锻线
CHK31.5kJ-CHK100kJ
die forging lines in Taiwan(5 lines)



长春一汽 CTK75kJ-CTK250kJ 5条模锻线
CTK75kJ-CTK250kJ
die forging lines in Changchun FAW(5 lines)



景县 CHK25kJ-CHK31.5kJ 4条模锻线
CHK25kJ-CHK31.5kJ
die forging lines in Jingxian(4 lines)



靖江正茂 CHK16kJ-CHK125kJ 4条锚链模锻线
CHK16kJ-CHK125kJ anchor chain
die forging lines in Jingjiang Zhengmao(4 lines)



江苏 CHK16kJ-CHK50kJ 4条模锻线
CHK16kJ-CHK50kJ
die forging lines in Jiangsu(4 lines)



山东神力 CHK31.5kJ-CHK80kJ 4条索具模锻线
CHK31.5kJ-CHK80kJ rigging
die forging lines in Shandong Shenli(4 lines)



上海手术器械 CHK16kJ-CHK25kJ 4条手术剪模锻线
CHK16kJ-CHK25kJ surgical scissors
die forging lines in Shanghai(4 lines)



台湾柏伟 CHK31.5kJ-CHK80kJ 4条直角接头模锻线
CHK31.5kJ-CHK80kJ straight joint
die forging lines in Taiwan Bothwell(4 lines)



河北明达 CHK25kJ-CHK31.5kJ 3条模锻线
CHK25kJ-CHK31.5kJ
die forging lines in Hebei Mingda(3 lines)



昆山 CHK16kJ-CHK50kJ 3条模锻线
CHK16kJ-CHK50kJ
die forging lines in Kunshan(3 lines)



美国史丹利 CHK31.5kJ-CHK50kJ 3条工具模锻线
CHK31.5kJ-CHK50kJ hand tools
die forging lines in USA Stanley(3 lines)



百协品牌 领航锻造

BAIXIE BRAND, THE PIONEER IN FORGING



台湾 CHK31.5k-CHK100k 3条法兰模锻线
CHK31.5k-CHK100k flange
die forging lines in Taiwan(3 lines)



常州 CTK125k 2条汽配模锻线
CTK125k auto parts
die forging lines in Changzhou(2 lines)



德阳东汽 CHK80k-CTK125k 2条叶片模锻线
CHK80k-CTK125k turbine
die forging lines in Deyang(2 lines)



江苏宏宝 CHK25k 2条模锻线
CHK25k
die forging lines in Jiangsu Hongbao(2 lines)



苏州 CHK16k 2条自动化餐厨具模锻线
CHK16k tableware automatic
die forging lines in Suzhou(2 lines)



广东华劲 CHK125k 模锻线
CHK125k
die forging lines in Guangdong Huajin



湖北谷城 CHK125k 模锻线
CHK125k
die forging lines in Hubei Gucheng



湖北十堰 CHK125k 模锻线
CHK125k
die forging lines in Hubei Shiyang



西安丰通 CHK125k 飞机叶片模锻线
CHK125k turbine
die forging line in Xi'an Fengtong



安徽 CHK80k 转向节模锻线
CHK80k steering knuckle
die forging line in Anhui



姜堰信盛 CHK80k 法兰模锻线
CHK80k flange
die forging line in Jiangyan Shinsei



日照 CHK80k 汽配模锻线
CHK80k auto parts
die forging line in Rizhao



大连吉田 CHK63k 连杆模锻线
CHK63 con-rods
die forging line in Dalian Jitian



大连四通 CHK63k 连杆模锻线
CHK63 con-rods
die forging line in Dalian Sitong



百协品牌 领航锻造

BAIXIE BRAND, THE PIONEER IN FORGING



重庆江东 CHK50kJ 模锻线
CHK50kJ
die forging line in Chongqing Jiangdong



浙江 CHK50kJ 模锻线
CHK50kJ
die forging line in Zhejiang



河北南宫 CHK31.5kJ 连杆模锻线
CHK31.5kJ con-rods
die forging line in Hebei Nangong



青岛 CHK31.5kJ 工具模锻线
CHK31.5kJ hand tools
die forging line in Qingdao



上海四合 CHK31.5kJ 五金模锻线
CHK31.5kJ hand tools
die forging line in Shanghai Sihe



重庆超强 CHK31.5kJ 连杆模锻线
CHK31.5kJ con-rods
die forging line in chongqing Chaoqiang



青岛 CHK31.5kJ 五金模锻线
CHK31.5kJ hand tools
die forging line in Qingdao



昆山 CHK25kJ 连杆模锻线
CHK25kJ con-rods
die forging line in Kunshan



CDKA400kJ 数控全液压对击锤
CDKA400kJ
CNC fully hydraulic counterblow hammer



青海 CTK320kJ 曲轴模锻线
CTK320kJ crankshaft
die forging line in Qinghai



山东 CTK250kJ 铁路配件模锻线
CTK250kJ railway parts
die forging line in Shandong



CTKA250kJ 数控全液压模锻锤
CTKA250kJ
CNC fully hydraulic die forging hammer



湖北三环 CTK250kJ 模锻线
CTK250kJ
die forging line in Hubei Tri-ring



南京南汽 CTK80kJ 模锻线
CTK80kJ
die forging line in Nanjing Nanqi



百协品牌 领航锻造

BAIXIE BRAND THE PIONEER IN FORGING



越南 CHK16k-CHK63k 5条工具模锻线
CHK16k-CHK63k hand tools
die forging lines in Vietnam(5 lines)



巴西 CHK25k 3条工具模锻线
CHK25k hand tools
die forging lines in Brazil(3 lines)



土耳其 CHK31.5k-CHK63k 2条模锻线
CHK31.5k-CHK63k
die forging lines in Turkey(2 lines)



泰国 CHK25k-CHK31.5k 2条模锻线
CHK25k-CHK31.5k
die forging lines in Tailand(2 lines)



越南 CHK25k 2条工具模锻线
CHK25k hand tools
die forging lines in Vietnam(2 lines)



越南 CHK25k-CHK50k 2条模锻线
CHK25k-CHK50k
die forging lines in Vietnam(2 lines)



越南 CHK16k-CHK25k 2条模锻线
CHK16k-CHK25k
die forging lines in Vietnam(2 lines)



印度 CTK125k 模锻线
CTK125k die forging line in India



台湾 CHK100k 模锻线
CHK100k die forging line in Taiwan



马来西亚 CHK50k 模锻线
CHK50k die forging line in Malaysia



德国 CHK31.5k 模锻线
CHK31.5k die forging line in Germany



土耳其 CHK31.5k 模锻线
CHK31.5k die forging lines in Turkey



叙利亚 CHK25k 模锻线
CHK25k die forging line in Syria



俄罗斯 CHK25k 工具模锻线
CHK25k hand tools die forging line in Russia



百协锻锤 锻造精品

**BAIXIE FORGING HAMMER
& FORGE REFINE PRODUCT**

