



鍵|財|機|械

CHIEN TSAI

MACHINERY ENTERPRISE CO., LTD.



**AUTOMATIC THREAD ROLLING MACHINE**



## 📍 公司據點

<https://www.jiancai.com.tw/>

### 鍵財機械企業股份有限公司

820110 高雄市岡山區本工東二路30號  
TEL : +886-7-622-5858  
FAX : +886-7-623-3030  
E-MAIL : jiancai@jiancai.com.tw

### CHIEN TSAI MACHINERY ENTERPRISE CO., LTD.

**Kaohsiung Headquarter**  
No. 30, Bengong E. 2nd Rd., Gangshan Dist.,  
Kaohsiung City, 820110, Taiwan (R.O.C.).  
TEL : +886-7-622-5858  
FAX : +886-7-623-3030  
E-MAIL : jiancai@jiancai.com.tw

### 浙江鍵財機械有限公司

浙江省嘉興市嘉善縣姚庄鎮福泰路88號  
TEL : +86-573-84775599  
FAX : +86-573-84775579  
E-MAIL : jcmjiancai@163.com

### ZHEJIANG JIANCAI MACHINERY CO., LTD.

No.88, Futai Road, Yaozhuang Town, Jiaxing City,  
Zhejiang Province, China.  
TEL : +86-573-84775599  
FAX : +86-573-84775579  
E-MAIL : jcmjiancai@163.com

## 📍 辦公室據點

### 鍵財機械企業股份有限公司-台北辦公室

24802新北市五股區孝義路26-1號  
TEL : +886-2-2291-8967~8  
FAX : +886-2-2291-2719

### Taipei Office

No.26-1, Xiaoyi Rd., Wugu Dist., New Taipei City  
24802, Taiwan (R.O.C.)  
TEL : +886-2-2291-8967~9、2291-5535~6  
FAX : +886-2-2291-2719

### 鍵財機械(上海)有限公司-上海辦公室

TEL : +86-21-6959-2966、6959-0535  
FAX : +86-21-6959-0420、6959-2969  
E-MAIL : jcmjiancai@163.com

### Shanghai Office

TEL : +86-21-6959-2966、6959-0535  
FAX : +86-21-6959-0420、6959-2969  
E-MAIL : jcmjiancai@163.com

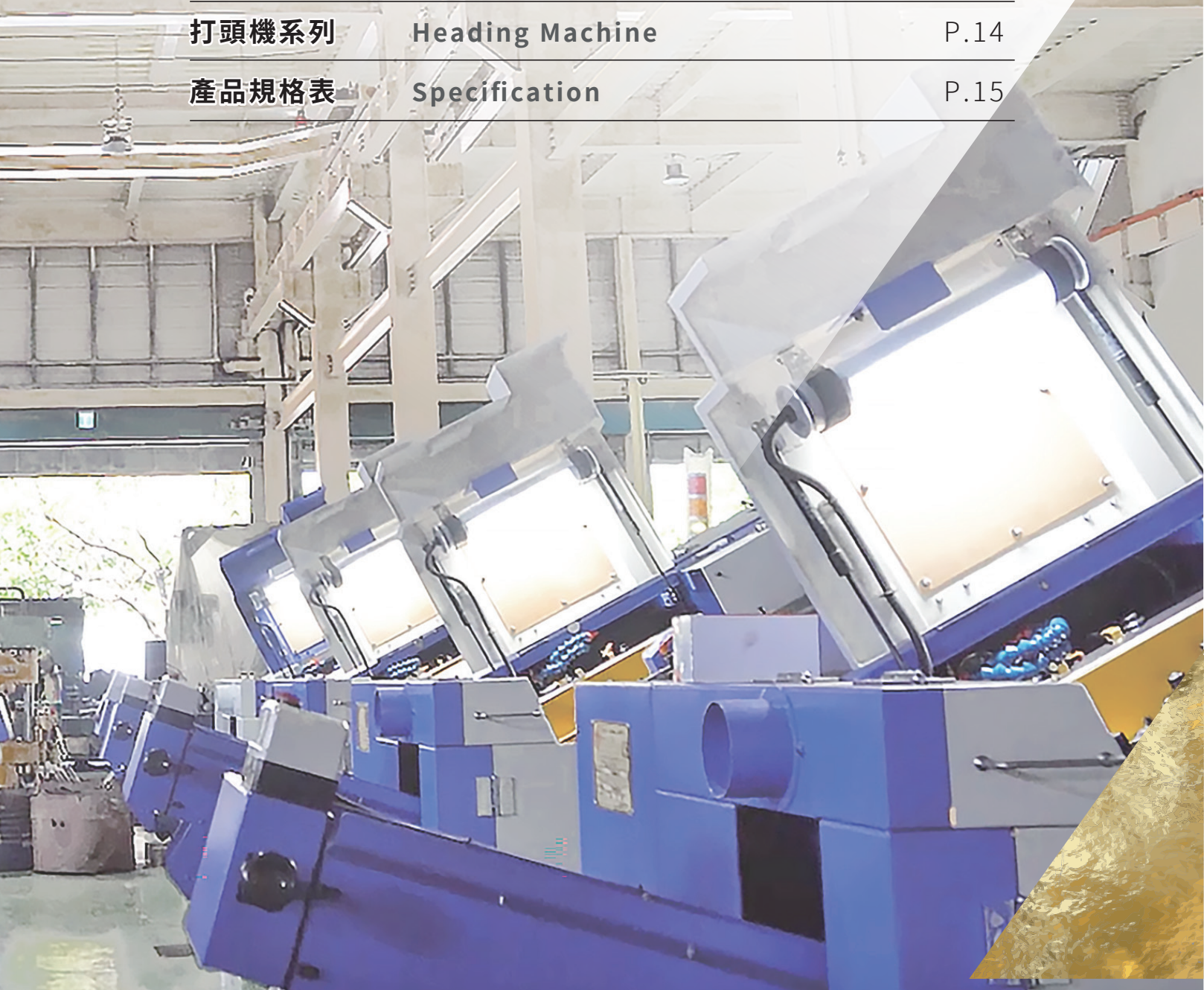
# CONTENTS

*Customer excellence &  
Customer excellence*

「客戶至上」及「不斷創新」

# 目錄 / INDEX

公司簡介	Company introduction	P.1
送料方式	Feeding System	P.3
自動軋牙機系列	Automatic Thread Rolling Machine	P.5
選購配備	Option	P.9
打頭機系列	Heading Machine	P.14
產品規格表	Specification	P.15



# COMPANY INTRODUCTION



鍵財機械企業股份有限公司創立於1973年台北，由創辦人陳建財董事長帶領之工作團隊，致力於螺絲搓牙機之設計與生產，並在其辛勤經營下，企業日漸茁壯。鍵財機械迄今累積四十多年機械製造、設計之經驗及技術，銷售量和機型更為業界翹楚客群遍及台灣、日本、亞洲、歐美等地，深受國內外企業肯定。目前除了已取得外銷歐盟CE認證，未來將計畫朝向ISO14001認證努力。

客戶至上及不斷創新是鍵財機械所秉持之經營理念，從協助客戶安排設備之產前規劃至售後服務，均以客戶需求為主要導向。近期，鍵財機械更以國際化的事業，持續創新設計，全面開發市場並積極建立完整服務網絡，進而提供一流品質與服務。

## COMPANY INTRODUCTION

Chien Tsai Machinery Enterprise Co. Ltd was established by the chairman Mr. C. T. Chen in Taipei in the year of 1973.

With experiences spanning more than 45 years in serving thread roller machines to the customers worldwide, we have accumulated the ample references to maintain our edge from keen market competition, meanwhile reserving the greater capabilities and flexibilities to reflect the potential demands behind the prevailing market trends.

With constant improvement to develop qualified operating system for the conformity of ISO 14001 as well as CE regulation to ensure equipment operator could stay away from any hazard amid working. Meanwhile, our continuous innovation also makes our machine suit the requirement on enhancing production efficiency.

“Customer excellence” and “Continual innovating” are in line with our key philosophy to develop trust-oriented relationships with all the cooperated partners and equipment end users, and meanwhile combining with the new respective and extracted from the past experiences, Chien Tsai Machinery now is confidently demonstrating our readiness to cope with the tremendous alteration from the market.



浙江鍵財機械有限公司  
Zhejiang Jiancai Machinery Co., Ltd



## 生產範圍

螺絲搓牙機、打頭機、割溝機、  
割尾機系列產品  
搓牙尺寸：外徑1~38mm  
長度：1~600mm



## 生產規模

高雄廠  
浙江廠  
員工總數：240人  
最大月產能：250台  
最大年產能：2300台



## 服務據點

台北	聖保羅
高雄	孟買
浙江	伊斯坦布爾
上海	莫斯科

## Production range

Automatic thread rolling machine, auto-  
matic heading machine, slotting machine,  
and screw point cutting machine.  
The external diameter of thread rolling  
machines varies from 1mm to 38mm with  
length up to 600mm.

## Production Scale

### KAOSIUNG HEADQUARTER ZHEJIANG FACTORY

Staff number is reached to 240.  
The maximum capacity of month :  
250 sets/month  
The maximum capacity of year :  
2,300 sets/year

## Service Locations

Taipei	SAO PAULO
Kaohsiung	MUMBAI
Zhejiang	ISTANBUL
Shanghai	MOSCOW

# FEATURES

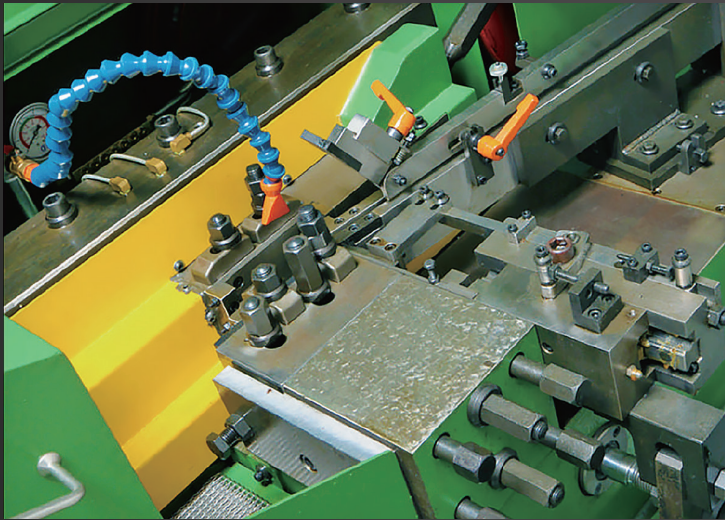
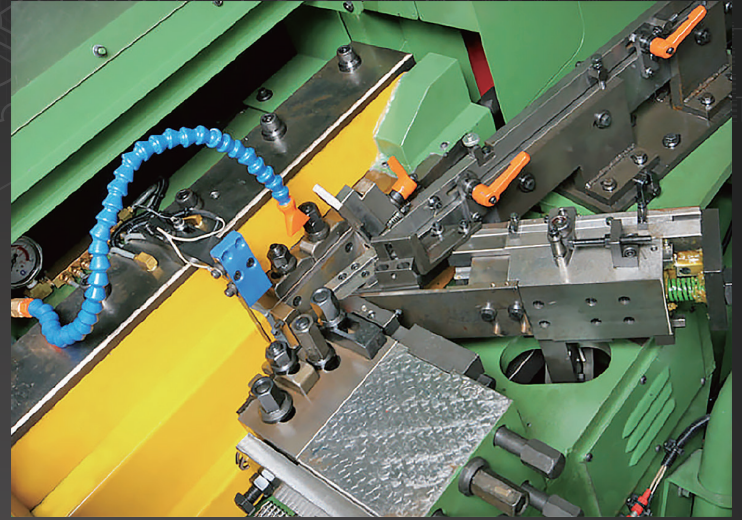


## 斜送料方式(CTR)

素材進料與中仁成30°

## Feeding System (Series CTR)

Feeding with 30° angle with main slider



## 直接送料方式(CR&ZR)

素材進料與中仁成90°

## Feeding System (Series CR & ZR)

Feeding with 90° angle with main slider



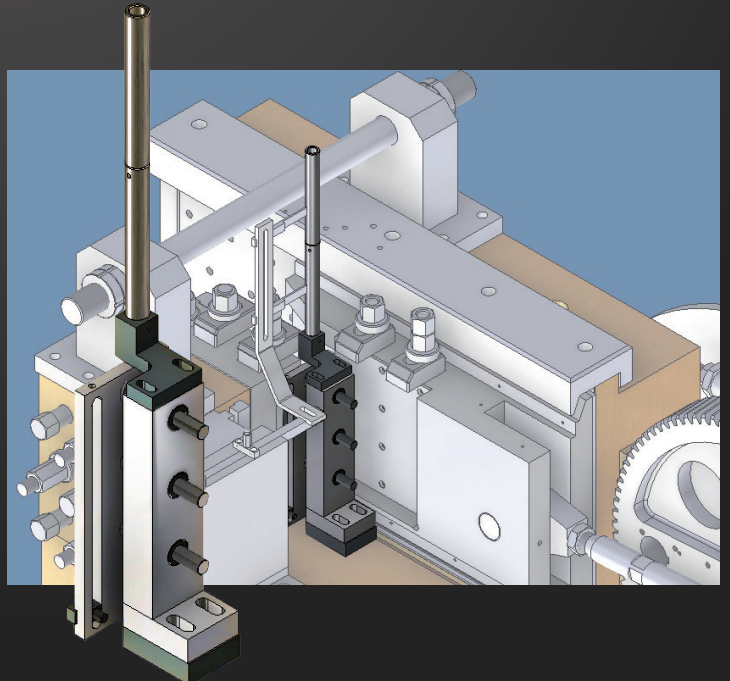
## 無頭螺絲送料機構

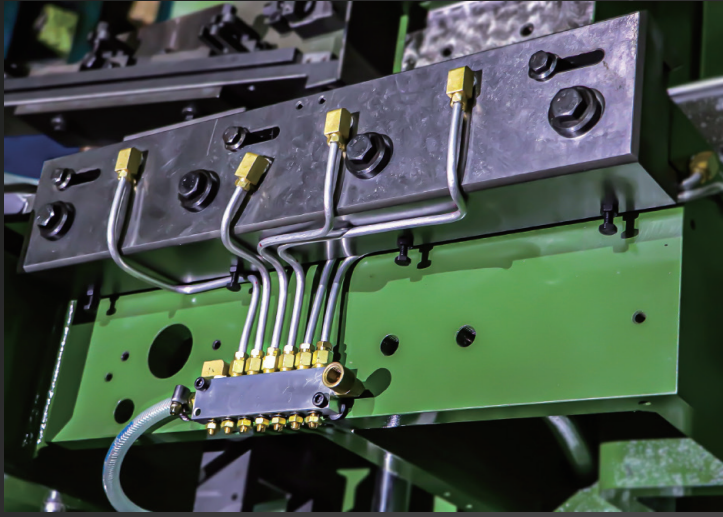
透過無頭螺絲送料機構，可以解決生產無頭螺絲的瓶頸，提高機械的附加價值。

## Headless Screw Feeding System

Headless Screw Feeding System solves problems in headless screw bottleneck with advanced value in machinery.

— VIDEO ONLINE —



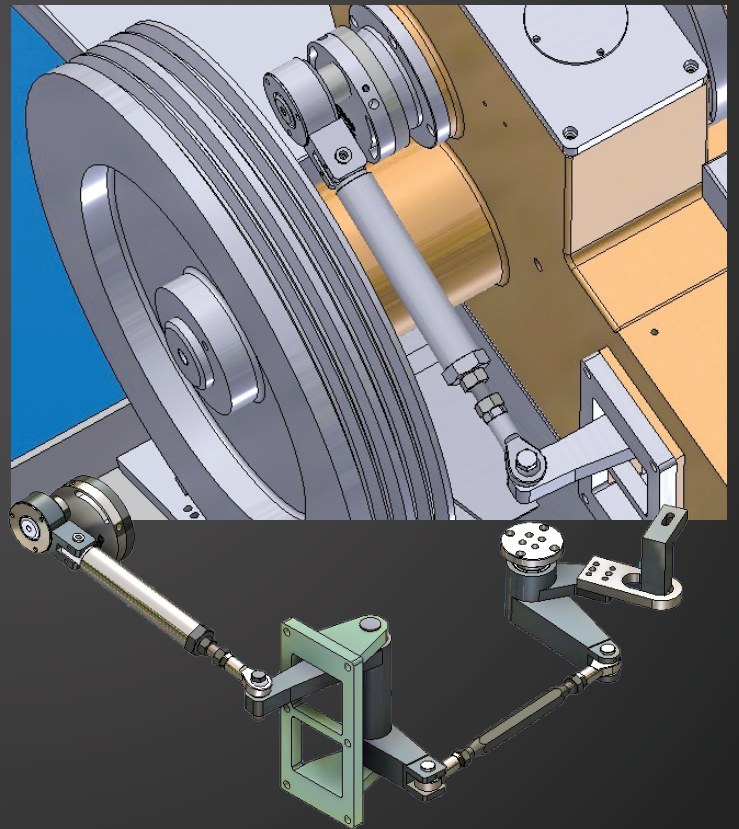
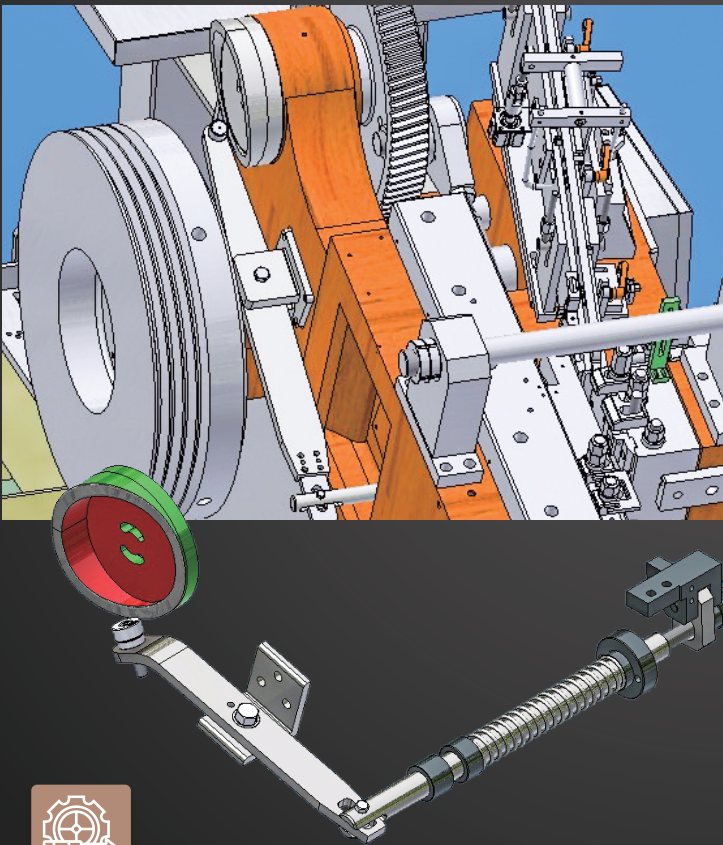


### 強制給油

取代舊有的油鐘給油潤滑，可避免因人為疏失造成主滑台毀損，透過精密的過濾系統，潤滑油可有效地循環再利用，除可降低生產成本，更可提高機械的使用年限。

#### Pressurized Central Lubrication

It replaces traditional acrylic oiler which can damage the main slider. This precision filter system not only lowers direct cost in production but also extend the life of oil by recycling. Coolant and lubricant oil do not mix.



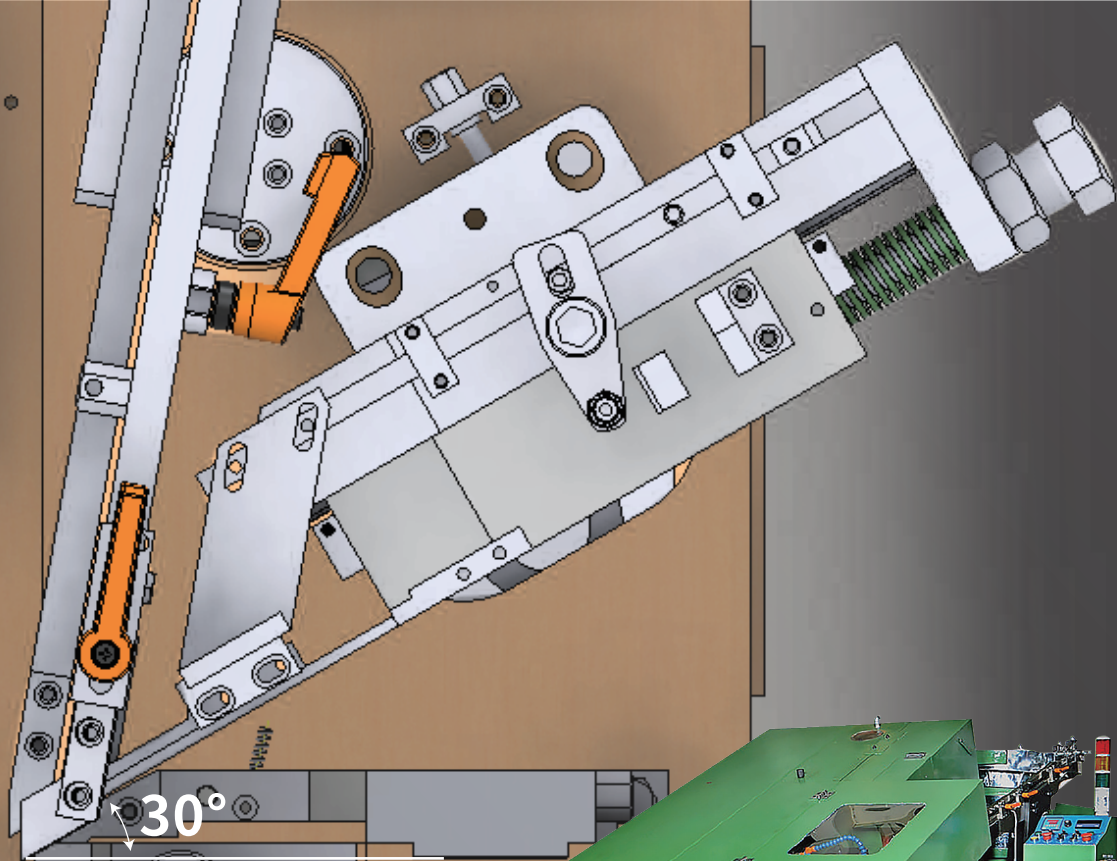
**凸輪送料機構：**送料可停頓，時間調整要求不高，適合中低速生產。

**Cam Feeding：** Be suitable for medium and low speed production with less precise timing adjustment and pause feeding.

**偏心送料機構：**送料無停頓，調整時間需精準，適合中高速生產。

**Eccentric Disc Feeding：** Be suitable for medium and high speed production with precise timing adjustment as no pause feeding.





高速自動軋牙機

# CTR系列

30°送料

High Speed Automatic Thread Rolling



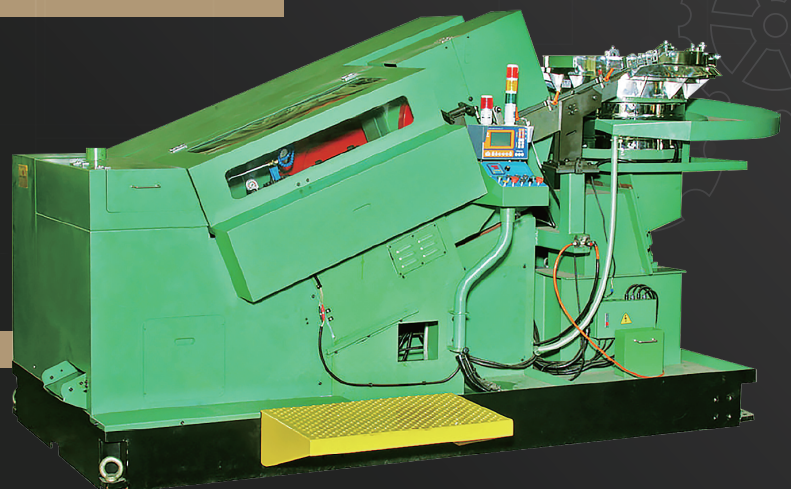
CTR8N

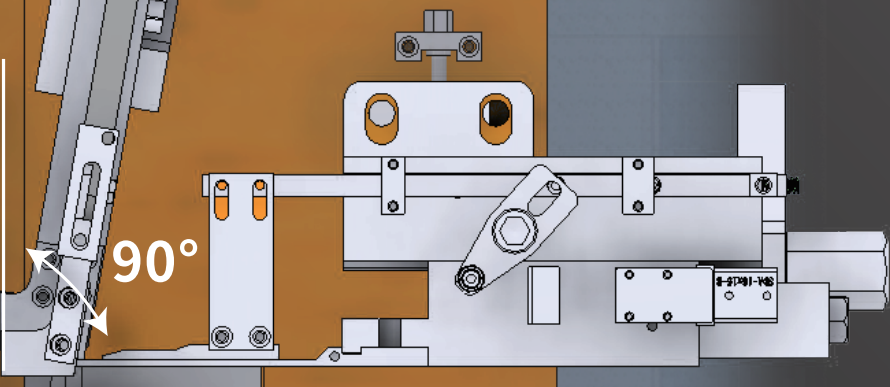
Machine - 30° Feeding



CTR6N

CTR19N





自動 軋 牙 機  
**CR 系列**  
90°送料

**CR10N**

Automatic Thread Rolling Machine 90° Feeding



**CR08N**

**CR12N**



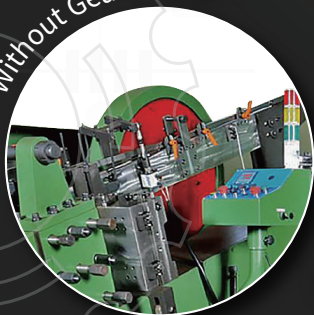
# 自動 輾 牙 機 Z R 系列 90° 送料

Automatic Thread Rolling Machine 90° Feeding

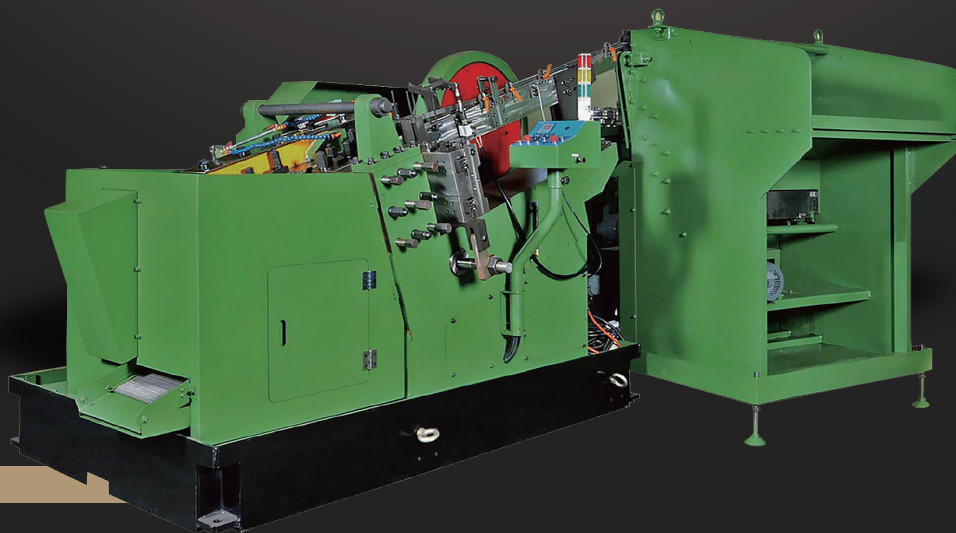


**ZR30N**

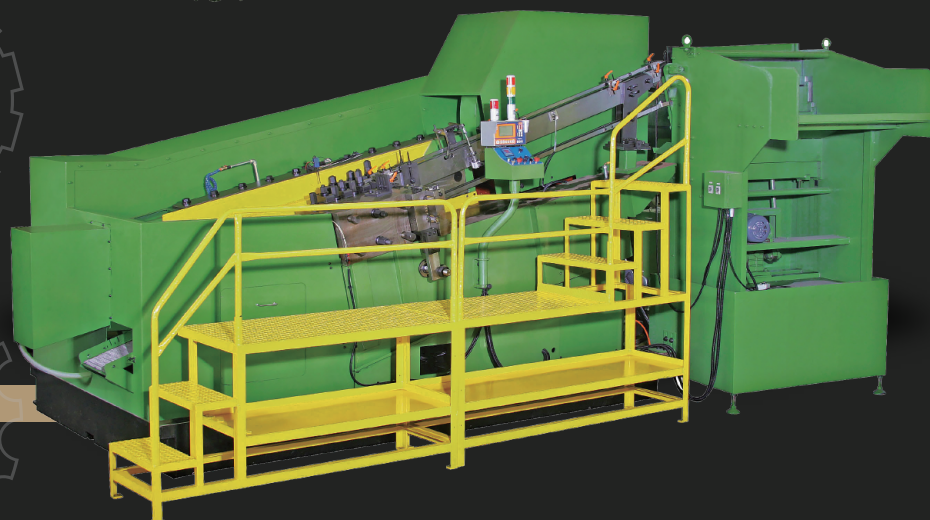
Without Gear Box



**ZR60N**



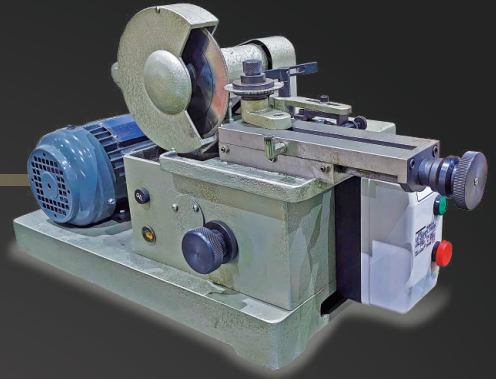
**ZR90N**





### 研磨機

MINI PUNCH GRINDING  
MACHINE

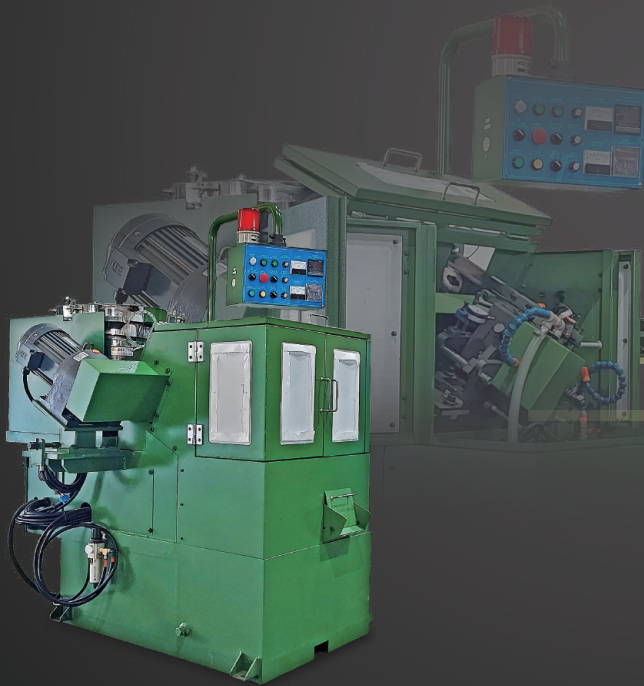
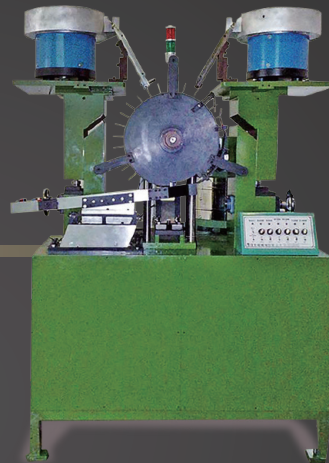


### 銑刀研磨機

SLOTING CUTTER GRINDING MACHINE

### 華司組立機

SCREW WASHER ASSEMBLING MACHINE



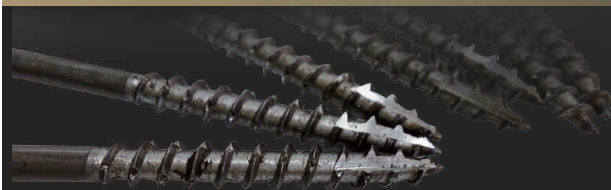
### 雙刀割溝機

SLOTING MACHINE

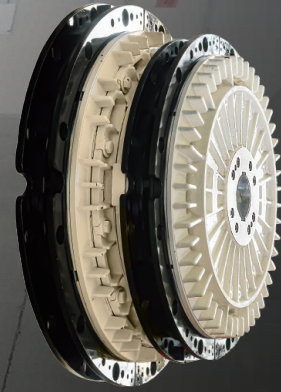


### 割尾機

SCREW POINT CUTTING MACHINE



## OPTION | 設備配件



### 氣壓式離合器 Air Clutch

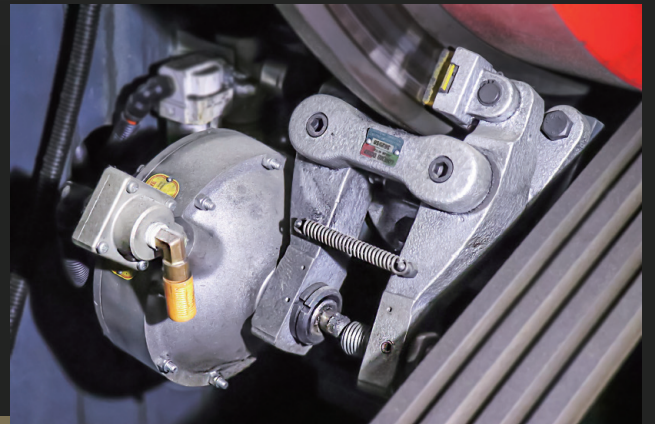
發生異常時，可以瞬間脫離動力源，並做剎車動作

To rapidly detach from the power resource and conduct braking action whenever the machine is stopped.

### 氣動式剎車 Air-brake

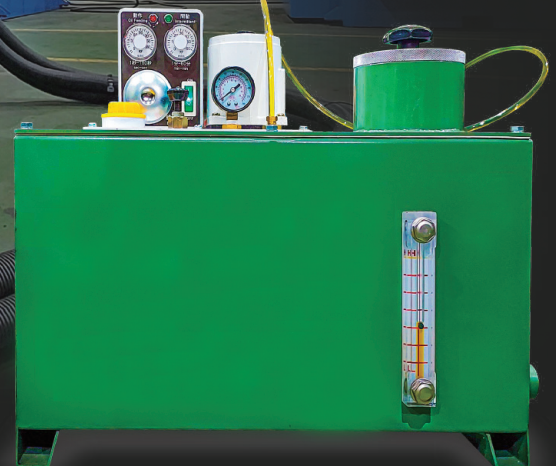
狀況發生時，可緊急停止

To immediately stop machine movement when the anomaly is taking place.



### 間歇式自動給油 Centralized Lubrication System

定量給油，容積式分配器，使每個出油孔流量均為相同  
To regularly deliver lubricant oil through volumetric distributor in order to ensure the oil flow of each oil outlet remains the same.



## 製程監控系統 Process Monitoring System

判斷螺絲異常，有多段計數功能，如生產數量、牙版總數量、異常總數量

To help the equipment end user to analysis the anormal from the production and meanwhile possess multi-segment counting function such as total productivity, total quantity of consuming thread rolling dies, and complete information relating to anormal quantity.



## 不良檢出 Auto Check With Counter

可計數，並記錄不良率  
Counting quantities and recording defective rate.

## 電眼式計數器 (需搭配人機介面及PLC) Sensor Counter ( required HMI and PLC)

透過機構調整電眼距離可精準計數，配合人機及PLC呈現可視化及聯網功能  
To count piece precisely by adjusting sensor position in mechanism design. Showing data visualization and web connection function with HMI and PLC control.



## 電流過載檢知表 Overcurrent Detection

預防電流過載而導致馬達燒毀，配合停料裝置  
Prevent the motor burned from .



## 氣壓閥防撞裝置 Anti-collision Device

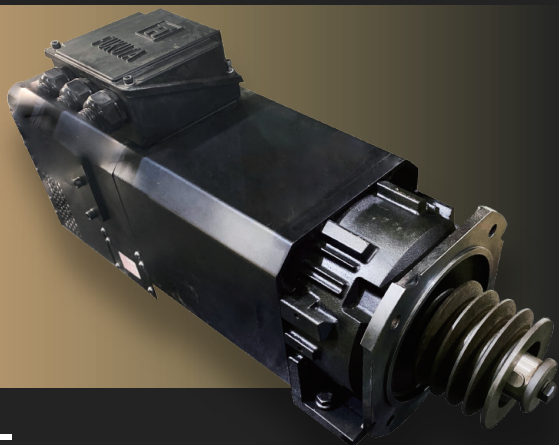
預防撞車時連續送料  
To immediately interrupt the part feed when feeding system accidentally gets crashed.



## 人機介面 HMI

隨著PLC及人機介面之整合，相關人員甚或主管可隨時從人機介面上瀏覽相關生產數據，亦可透過故障訊息之顯示進而節省故障排除之時間

With the integration of PLC and HMI system, the production information could be easily reviewed by the relevant personnel or managers,



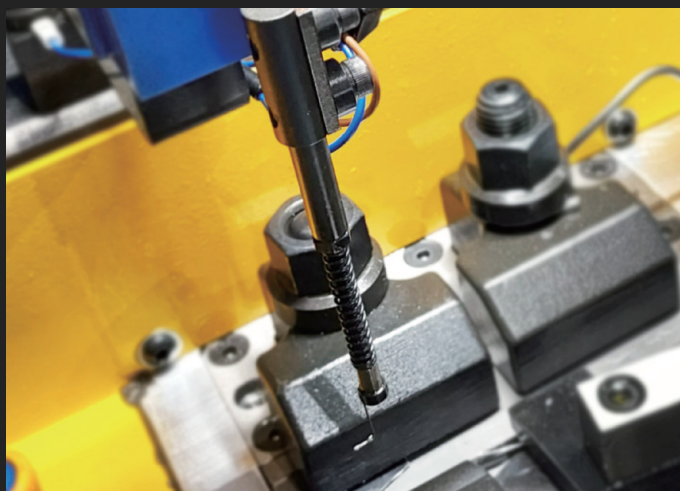
## 伺服馬達 Servo Motor

省電、扭力固定、進而優化主要機件壽命  
Power-Saving and Stable torque to enhance the durability of the crucial units.



## 變頻器 Inverter

保護馬達，調整速度  
Protect the motor and adjust the speed.



## 浮頭偵測 (彈片式、探針式) Contactor



接觸偵測 Contact detection

# 鍵財軋牙機 - 機聯網系統 Machine Connection System



將工廠內各種自動化設備、電力等基礎架構、管理系統以網絡串連起來，透過系統整合各種數據，經由軟體分析、統計後，顯示工廠的即時生產狀態，達到工廠內部種種活動資訊的可視化。

A computerized system in manufacturing to track and document various data as real-time monitoring system to enable the control of multiple elements of the production process.

## 軟體分析 Software analysis

- 製成總覽 Production overview
- 機台信息 Quipment info
- 機台類別 Equipment category
- 樓層監控 Floor monitoring
- 數據分析 Data analysis

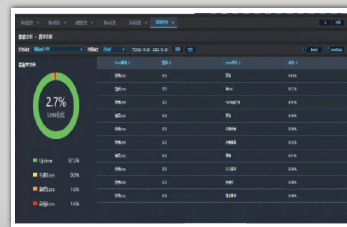


網路相機  
拍攝作業情形  
Webcam film operation process.

網路伺服器  
Web server

辦公室及現場電腦，使用網路瀏覽器管理生產資訊  
Manage production elements in office PC and workshop PC by internet.

◀ 數據分析：  
異常分析畫面  
Data analysis:  
Error analysis page



現場人機介面(HMI)作為閘道

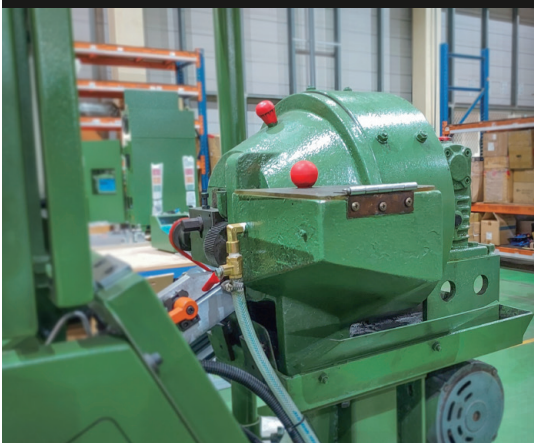
智慧型手機\平板  
使用網路瀏覽器管理生產資訊

Smart phone/Pad to manage production by internet.





## OPTION | 入料周邊配件



圓斗 Feeding Drum



震動盤 Vibrator



層斗 Layer Hopper

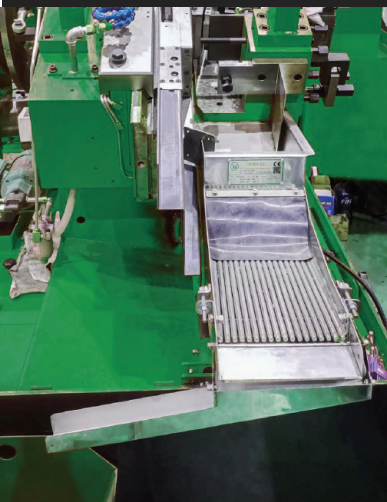


提升機 Elevator Conveyor



儲料斗 Storage Hopper

## OPTION | 下料周邊配件

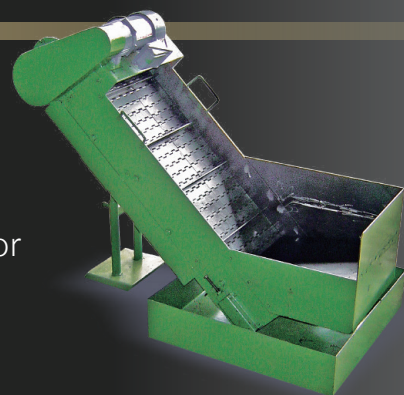


雙滾輪  
Double Roller Chip Separator

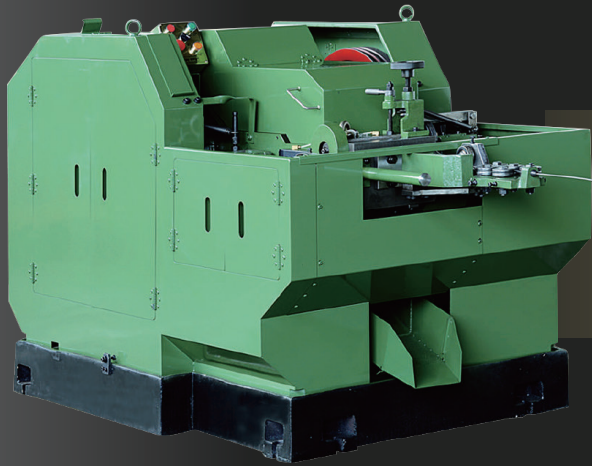


平送式鐵屑分離機  
Iron Scrap Separator

輸送機  
Conveyor

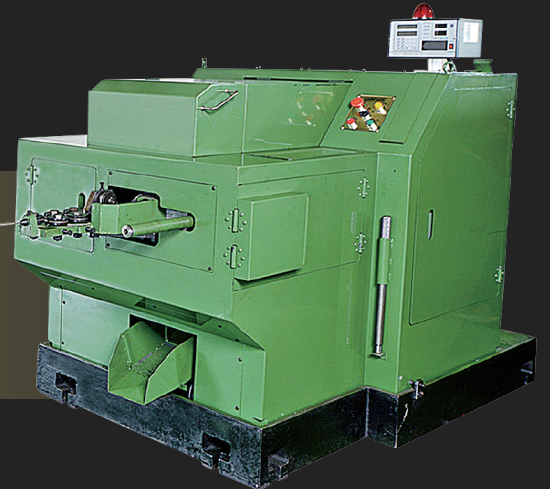
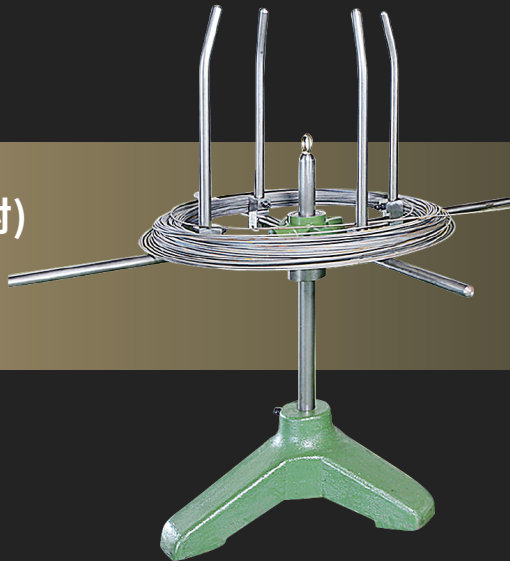


# 打頭機系列 HEADING MACHINE

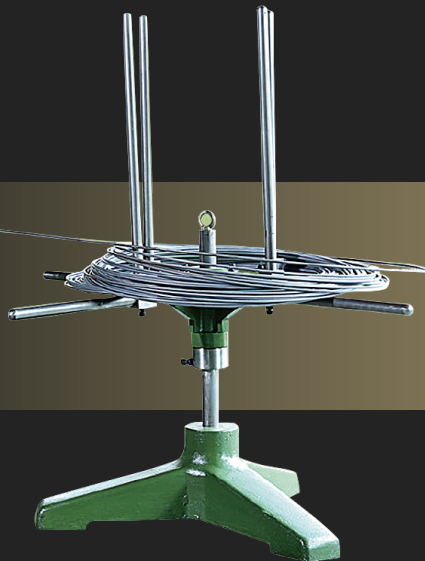
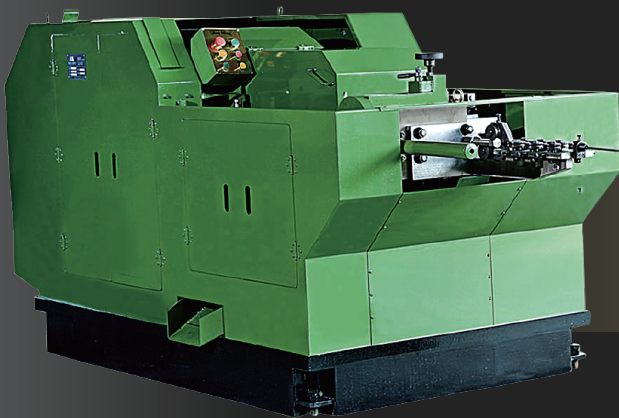


15系列  
Series of 15

15系列(全密封)  
Series of 15  
Full Cover



20系列(半密封)  
Series of 20  
Semi-Cover



# 設備規格 Machine Specification

序號 ITEM	機型 MODE	外徑 DIAMETER	長度(mm) SCREW LENGTH	牙長(mm) THREAD LENGTH	牙板 MOVING DIES STATIONARY LENGTH	馬力(HP) MAIN MOTOR	產量(PCS/MIN.) MAX. OUTPUT	重量(KG) APPROX. WT.	機台尺寸(mm) MACHINE SIZE

## CTR 30° feeding 《可更改5°牙板》

1	CTR2	1-3	25	20	51/64/19	1	270-330	1000	1068x968.5x1215
2	CTR4	2-4	38	32	65/75/20	2	230-300	1200	1417x1170x1383
3	CTR5	3-5	38	32	76/89/25	3	170-280	1400	1900x1100x2100
4	CTR5N	3-5	38	38	76/89/25	3	170-280	1500	1900x1200x1400
5	CTR6N	4-6	50-75	50	90/105/25	5/7.5	170-260	2000	2200x1400x1700
6	CTR8N	5-8	75-100	50	108/127/25+127/140/25	7.5/10	110-230	2400	2400x1400x1800
7	CTR9N	6-9	100	50	127/140/25	15	100-210	4400	2700x1600x1800
8	CTR10N	6-10	100-250	65	150/165/25	20	80-170	4800	3100x1700x2000
9	CTR12N	8-12	100-350	75	190/215/35	30	75-130	6000	3800x1700x2200
10	CTR16N	10-16	150-200	80	230/265/38	40	70-110	8800	3700x2000x2600
11	CTR20N	14-20	150-200	80	290/330/50	50	65-70	13500	4200x2000x3400
12	CTR24N	16-24	200	150	380/420/50	60	35-60	23500	4900x2400x2600
13	CTR30N	20-30	200	150	450/500/60	75	25-40	(30000)	(5200x2400x3000)
14	CTR38N	24-38	300	150	550/600/60	100	20-35	(50000)	6400x3600x4000

## CR 90° feeding

1	CR02	1-3	25	20	51/64/19	1	270-330	1000	1300x1000x1650
2	CR05	2-5	50	50	76/89/25	3	170-280	1400	1550x1400x1800
3	CR06	4-6	50-75	50	90/105/25	5/7.5	170-240	1800	2100x1200x1600
4	CR06N	4-6	50-75	50	90/105/25	5/7.5	170-240	2000	1900x1530x2050
5	CR08N	5-8	75-300	75	108/127/25+127/140/25	7.5/10	110-180	2500	2400x1400x1800
6	CR10N	6-10	100-400	100	150/165/25	15	80-110	4700	3000x1800x2000
7	CR12N	8-12	100-400	100	190/215/35	20	80-100	7400	3400x2100x2300
8	CR16N	12-16	150-300	150	230/265/38	30	50-60	9800	3800x2200x2300
9	CR20N	14-20	200-400	150	290/330/50	40	40-50	14000	4000x2200x2300
10	CR24N	16-24	200-400	150	380/420/50	60	35-45	23500	4900x2400x2600
11	CR816	10-16	76	15	230/265/38	7.5	60-80	3800	3500x1400x2400
12	CR824	16-24	100	10	380/420/50	10	55-60	7500	4600x1600x2700
13	CR1224	16-24	150-200	50	380/420/50	30	40-60	15000	4900x2300x2700










## ZR 90° feeding (GEAR OUTSIDE)

1	ZR15L	2.5-5	50-75	75	76/89/25	3	100-160	1200	1750x1600x1850
2	ZR15H	3-5	50-75	75	90/105/25	5	130-220	1800	1900x1530x2050
3	ZR20H	5-8	75-200	100	108/127/25+127/140/25	7.5/10	110-160	2000	2000x1600x1700
4	ZR25N	6-9	100-200	100	127/140/25	7.5	100-150	3300	2800x1600x1700
5	ZR30N	6-10	100-300	100	150/165/25	15	50-120	3900	2900x1600x1800
6	ZR40N	8-12	100-200	100	190/215/35	20	60-90	6700	3000x1700x2100
7	ZR60N	10-16	150-300	100	230/265/38	30	50-60	7600	3400x1700x2100
8	ZR70N	14-20	200-300	150	290/330/50	40	40-50	13000	4000x2200x2400
9	ZR80N	16-24	200-300	150	380/420/50	60	35-45	18500	4900x2400x2700
10	ZR90N	20-30	200-350	150	450/500/60	75	25-35	26000	5200x2400x3000
11	ZR98N	24-38	250-400	150	550/600/60	100	20-35	48000	7000x2800x3200

註：以上表格參數為6.8級及以下標準碳鋼機械牙為基準計算所得，故需生產其他材料、等級之產品，須與本公司業務進一步溝通確認。我司保留對該表格數據的最終解釋權。

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## 打頭機 HEADING MACHINE

序號 ITEM	機型 MODE									
		外徑 (mm) BLANK DIAMETER	長度 (mm) BLANK LENGTH	主模外徑 (mm) DIE DIA	切模外徑 (mm) CUT OFF DIE DIA	沖模外徑 (mm) PUNCH DIE	馬力 (HP) MAIN MOTOR	產量 (PCS/MIN.) MAX OUTPUT	重量 (KG) APPROX WT	機台尺寸 (mm) MACHINE SIZE
1	JM0528	0.8-2.6	28	20	13.5	18	1HP 4P	200-220	550	700x1500x1000
2	JM1030	3.5	30	30	15	24/20	2HP 4P	180-200	1100	1550x930x1070
3	JM1538	5	38	34.5	19	31	3HP 4P	180-200	1700	1890x1070x1110
4	JM1552	5	52	34.5	19	31	3HP 4P	130-160	1700	1890x1070x1110
5	JM1564	5	64	34.5	19	31	3HP 4P	130-160	1750	1890x1070x1110
6	JM1576	5	76	34.5	19	31	3HP 6P	100-120	1750	2100x1100x1120
7	JM2076	6	76	45	25	36	5HP 6P	100-120	2600	2550x1120x1180
8	JM20102	6	102	45	25	36	5HP 6P	65-90	3700	3158x1350x1290
9	JM20152	6	152	60	25	38	7.5HP 6P	45-65	4200	3750x1410x1470
10	JM25102	8	102	60	28	38	7.5HP 4P	65-90	4900	3590x1660x1520

## 割溝機 SLOTTING MACHINE

序號 ITEM	機型 MODE	規格 (mm) STANDARD	桿長 (mm) SCREW LENGTH	產量 (PCS/MIN.) MAX. OUTPUT	馬力 (HP) MAIN MOTOR	重量 (KG) APPROX WT	機台尺寸 (mm) MACHINE SIZE
1	SRD-5	1.6-6	5-45	20-80	轉盤 1HP-6P 銑刀 3HP-4P	1000	1610x980x1760

## 割尾機 SCREW POINT CUTTING MACHINE

序號 ITEM	機型 MODE	外徑 (mm) DIAMETER	長度 (mm) SCREW LENGTH	產量 (PCS/MIN.) MAX. OUTPUT	馬力 (HP) MAIN MOTOR	重量 (KG) APPROX WT	機台尺寸 (mm) MACHINE SIZE
1	NS06	3-6	15-100	100-420	轉盤 1HP-8P 銑刀 3HP-6P	1200	1900x1300x1600
2	NS10	4-10	150-400	60-150	轉盤 1HP-8P 銑刀 3HP-6P	1800	1900x1300x1600

## 華司組立機 SCREW WASHER ASSEMBLING MACHINE

序號 ITEM	機型 MODE	規格 (mm) STANDARD	產量 (PCS/MIN.) MAX. OUTPUT	馬力 (HP) MAIN MOTOR	重量 (KG) APPROX. WT.
1	MT-1202	2x15	10-300	1/4	360
2	MT-1203	3x20	10-300	1/4	360
3	MT-1204	4x50	10-300	1/4	1200
4	MT-1205	5x50	10-220	1/4	1200
5	MT-1206	6x50	10-220	1/4	1200
6	MT-1208	8x75	10-150	1/4	1500
7	MT-1210	10x75	10-150	1/4	1500



註：以上表格參數為6.8級及以下標準碳鋼機械牙為基準計算所得，故需生產其他材料、等級之產品，須與本公司業務進一步溝通確認。我司保留對該表格數據的最終解釋權。

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