

INDUSTRIAL JIUHE FURNACE

www.szjiuhe.com.cn



蘇州工業園區久禾工業爐有限公司

Suzhou Industrial Park Jiuhe Industrial Furnace Co.,LTD

地址：蘇州工業園區銀勝路55號 郵編Zip code：215126

Address: No.55,YinSheng Road,Suzhou Industrial Park China

電話Tel：86-512-62827866 (0) 13776110999

傳真Fax：86-512-62828786 電郵Email：jy@szjiuhe.com.cn



JIUHE INDUSTRIAL
FURNACE

久禾工業爐

企业简介

苏州工业园区久禾工业炉有限公司是专业从事各种热处理设备的研发、设计、制造、销售和服务的高新技术企业。公司占地25000平方米,生产制造车间13000余平方米,具有专业的技术设计及管理团队。公司采用国际领先技术及管理体制,研制开发了多型具有国际先进技术水平的热处理设备,填补了行业部分空白,在国内外享有较高的知名度。所生产的热处理设备广泛应用于航空、汽车、摩托车、工程机械、军工等各机械行业,部分产品出口至东南亚、美国、德国、西班牙、俄罗斯、墨西哥等国家和地区。

“高效、节能、环保、无故障”是公司的宗旨,公司不断加强与国外领先技术的交流合作,根据客户不同产品工艺要求,进行针对性特殊设计与制造,一套设备造就一个精品工程。已与公司建立良好商务合作关系客户:中国一汽、东风汽车、中国重汽、柳州五菱、江淮汽车、江铃汽车、中国二重、中国一拖、北方车辆、山推股份、徐工股份、潍柴股份、海尔股份、法国VALEO、日本DENSO、美国ITW、德国PFG、西班牙Inautek、印尼KOYORAD、印度CK、泰国RAD、韩国DOOWON.....



COMPANY PROFILE

Suzhou Industrial Park is a high-tech enterprise specializing in the R & D, design, manufacture, sales and service of all kinds of heat treatment equipment. Company covers an area of 25000 square meters, production workshop of more than 13000 square meters, has a professional technical design and management team. The company adopts the international advanced technology and management system, developed a number of international advanced level of heat treatment equipment, to fill the gaps in the industry, at home and abroad enjoy a high visibility. Heat treatment equipment widely used in the production of various machinery industry, aviation, automobile, motorcycle, engineering machinery, military industry, some products exported to Southeast Asia, the United States, Germany, Spain, Russia, Mexico and other countries and regions.

"Efficient, energy saving, environmental protection, no fault" is the tenet of the company, the company continued to strengthen exchanges and cooperation with foreign advanced technology, according to customer requirements of different production processes, for the special design and manufacture, a set of equipment to create a quality project. Have established good business relationship with customers: China FAW, Dongfeng Motor, Chinese heavy truck, Liuzhou Wuling, JAC, JMC, China, China, a double North vehicle, Shantui, Xugong, Weichai, Haier shares, France VALEO, Japan DENSO, American ITW, German PFG, Inautek, KOYORAD, Spain CK India, Indonesia Thailand, South Korea DOOWON RAD.....

网带式天然气加热热处理调质生产线

Net-belt gas heating heat treatment hardening and tempering production line

采用进口的燃烧系统，热效更高，使用成本更低；采用工控机（人机界面）进行控制，控温精确操作方便，维护保养简单；可广泛用于汽车、工程机械各类锻件及中小零部件的调质、渗碳、碳氮共渗等热处理。

Adopt imported combustion system, with high heat response and lower usage cost; adopt Industrial Personal Computer (IPC) to implement control to achieve accurate temperature control, convenient operation and simple maintenance. It can be widely used in hardening and tempering, carburization, carbonitriding and other heat treatment of automobile, various forge pieces and medium and small sized components and parts of engineering machinery.

典型零件：转向节、曲轴、链轨节、连杆、紧固件等汽车零部件的热处理

Typical parts: Heat treatment for automobile parts, such as steering knuckles, crankshaft, track link, connecting rods, fasteners etc.



型号	调质处理产量	渗碳处理产量	设备总长
JH822-880-GH	800-950kg/h	540-600kg/h	34m
JH822-1080-GH	1100-1300kg/h	750-820kg/h	38m
JH822-1010-GH	1400-1500kg/h	920-1020kg/h	38m
JH822-1310-GH	2500-2600kg/h	1800-1900kg/h	44m
JH822-1312-GH	3500-3000kg/h	1850-2250kg/h	44m

○ 渗碳层 $\leq 0.30\text{mm}$ 以上数据仅供参考，实际参数以方案为准。

可控气氛网带式电加热热处理调质/渗碳生产线

Controlled atmosphere net-belt electrical heating heat treatment hardening and tempering/carburization production line

广泛适用于各种汽车及工程机械金属零件的批量渗碳、碳氮共渗和保护气氛调质淬火处理；控制先进、节能卓越、原版技术、进口品质；炉温均匀，运转平稳，气氛碳势自动控制，主要元件采用进口品牌，使用寿命长。

It is widely used in batch carburization, carbonitriding and protective atmosphere hardening and tempering quenching treatment of various automobiles and metal parts of engineering machinery, characterized with such merits as advanced control, excellent energy conservation, original technology and imported qualify, so as to achieve uniform furnace temperature, stable operation and automatic control of atmosphere carbon potential. Adopt imported brand for critical elements to achieve long service life.

典型零件：连杆、曲轴、紧固件等汽车零部件的热处理

Typical parts: Heat treatment for automobile parts, such as connecting rods, crankshaft and fasteners etc.



型号	中高碳钢 一小时产量 (kg)	中高碳钢 一个月产量(T)	低碳钢 一小时产量(kg)	低碳钢 一个月产量(T)	全套总输出 电力(kw)	全套使用电力(kw) 中碳85%低碳70%	全套总长度 (m)
JH802-1	198-220	123-138	84-120	52-75	203-218	173/142	27995
JH802-2	352-385	220-242	201-240	127-150	290-320	247/203	31495
JH802-3	414-485	259-299	313-350	195-218	353-393	300/247	31995
JH802-4	506-572	316-358	413-463	258-289	439-464	373/307	31995
JH802-5	720-780	450-486	546-598	341-373	513-543	436/359	35995
JH802-6	1000-1100	624-686	833-917	520-572	615-655	522/430	39430
JH802-7A	1250-1375	780-858	1010-1146	624-715	773-828	657/541	39430
JH802-7	1500-1650	936-1030	1249-1375	779-858	928-993	788/650	39430
JH802-8	1800-1980	1123-1236	1499-1650	935-1030	1105-1175	939/774	43430

○ 主要参数（1个月产量以26天算）

可控气氛网带式轴承热处理生产线

Controllable atmosphere belt bearing heat treatment assembly line

广泛使用于各种中小型轴承零件的批量渗碳、碳氮共渗和保护气氛淬火热处理。全电脑自动化控制、节能卓越、原版技术、国际品质。工件淬火变形控制具有领先水平。

Widely used in batch carburization, carbonitriding and protective atmosphere quenching heat treatment of small-and medium-sized bearing parts. Fit is fully computerized automatic control, excellent energy conservation, original technology and international quality.

典型零件：汽车轴承、家用电器轴承、精密轴承等调质、渗碳热处理

Typical parts: Quenching and tempering as well as carburizing heat treatment for automobile bearings, household appliances bearings and precise bearings



型号	额定功率 (kw)	生产线总功率 (kw)	使用温度 (℃)	工作尺寸 (mm)	生产线总长 (m)	参考总量 (kg/h)	
						淬火	渗碳
RCWC9-40×320×8-G	65-80	160-180	950	400×3200×80	20-23	150	60
RCWC9-40×470×8-G	75-90	180-200	950	400×4700×80	21-25	220	100
RCWC9-50×470×8-G	120-130	220-250	950	500×4700×80	21-25	300	150
RCWC9-50×600×8-G	150-160	250-280	950	500×6000×80	23-27	380	180
RCWC9-60×470×8-G	150-160	250-280	950	600×4700×80	22-26	360	160
RCWC9-60×600×8-G	160-180	260-300	950	600×6000×80	23-27	450	220
RCWC9-60×800×8-G	200-220	320-360	950	600×8000×80	26-30	550	300
RCWC9-80×470×8-G	160-180	280-320	950	800×4700×80	24-28	460	220
RCWC9-80×600×8-G	200-220	320-360	950	800×6000×80	26-30	550	280
RCWC9-80×800×8-G	230-260	360-400	950	800×8000×80	28-32	750	380
RCWC9-80×1000×8-G	280-300	400-450	950	800×10000×80	30-35	1000	550
RCWC9-100×470×8-G	200-220	320-350	950	1000×4700×80	24-28	550	250
RCWC9-100×600×8-G	220-250	350-380	950	1000×6000×80	26-30	700	350
RCWC9-100×800×8-G	280-300	400-450	950	1000×8000×80	28-33	1000	550
RCWC9-100×1000×8-G	300-350	450-500	950	1000×10000×80	30-35	1300	750

○ 主要参数 (1个月产量以26天算)

网带式连续正火炉生产线（加热源：气/电）

Net-belt continuous normalizing furnace assembly line (heating source: gas/electricity)

适用于汽车、工程机械及摩托车精锻工件的正火处理。设备具有高效、节能、工件冷却均匀，冷却风速根据工件特点变频可调，控制系统采用工控机控制，自动化程度高。以消除应力、得到需要的金相组织和硬度。

It can apply to precision work piece normalization of automobile, engineering machinery and motorcycle. The equipment is characterized with high efficiency, energy conservation, even cooling of work piece, adjustable cooling speed based on work piece features, and the control system is controlled by Industrial Personal Computer with high automaticity, so as to eliminate stress and obtain required metallographic structure and hardness.

典型零件：连杆、球笼、齿轮、轮毂等零部件前道正火处理

Typical parts: prior normalization of connecting rod, cage, gear, hub and other parts



网带式连续等温正火炉生产线（加热源：气/电）

Net-belt continuous isotherm normalizing furnace assembly line
(heating source: gas/electricity)

适用于汽车、工程机械、摩托车等精锻工件的等温正火处理。设备具有高效、节能、工件冷却均匀，冷却风速根据工件特点变频可调，控制系统采用工控机控制，自动化程度高。以消除工件应力、得到需要的金相组织和硬度。

It can apply to isotherm normalization of automobile, engineering machinery and motorcycle. The equipment is characterized with high efficiency, energy conservation, even cooling of work piece, adjustable cooling speed based on work piece features, and the control system is controlled by Industrial Personal Computer with high automaticity, so as to eliminate stress and obtain required metallographic structure and hardness.

典型零件：轿车齿轮（轴）和卡车齿轮锻件的等温正火处理

Typical parts: isothermal normalizing treatment of car gear (shaft) and truck gear forging



网带式连续锻后控温冷却线

Net-belt continuous post-forging temperature controlling cooling line

用于将经感应加热、压机成形后还处于奥氏体状态的零件，经自动温度分选后进入控温冷却炉，在控制冷却的条件下，使产品在一定冷速，一定温度下冷却，从而获得均匀的组织理想的硬度。

It can apply to the parts which are induction heated and are under austenite condition after being pressed forged, and the parts will be delivered to temperature controlling cooling furnace after being selected by automatic temperature. Under controlled cooling condition, the product will be cooled at certain cooling speed and temperature, so as to obtain even organization and ideal hardness.

典型零件：非调质钢材料的连杆、曲轴等零件的控温冷却

Typical parts: Controlled cooling for connecting rod and crank of non-quenching and tempering steel material



热处理生产线全自动电气控制系统

Automatic electrical control system of heat treatment production line

全线电气控制集中布置。整套生产线作业程序由一台PLC集中控制运行及超温、液位低、传动异常、碳势偏差等故障声光报警和安全连锁，并设有模拟屏随时观察工况。温度及碳势控制用智能仪表控制，有自动和手动两种方式。生产线各单机均设有单动及联动，在发生卡料故障时可正转与反转。

Centralized layout for electrical control of the whole line. The operating procedures of the entire production line is controlled by a PLC, including the operation and acousto-optic failure alarm, such as over-temperature, low-level, abnormal transmission and the deviation of carbon potential, and security chain, and a mimic board is set for observing the working conditions at any time. There are automatic and manual smart instrument controls for temperature and carbon potential control. Each unit of production line is equipped with single-action and linkage, which can rotate and reverse in the event of a failure of blocking material.



热处理生产线全自动电脑控制界面

Full automatic computer-controlled interface of heat treatment production line

全自动电脑控制系统由工控机、可编程序控制器（PLC）、操作执行元件等组合而成。通过电脑可查询整个生产线的各种工艺参数，通过电脑可总揽全部设备的运行状态，可供用户随时打印数据和图表。

Automatic computer-controlled system is constituted by IPC, programmable logic controller (PLC) and operating actuator. Inquiry each process parameters of the entire production line through the computer, grasp the running states of all equipment through the computer and printing data and charts are available for users at any time.

（1）系统总揽：整条生产线平面布置图，同时在每一部分分别显示出相应的工作方式、工步、基本位置状态、温度设定值、温度过程值、碳势设定值、碳势过程值和工艺时间。System overview: the floor plan of the entire production line, and shows in each part the working mode, working steps, basic position state, temperature settings, temperature process values, carbon potential settings, carbon potential process values and process time.

（2）工艺参数的输入：工艺号、各区的温度、碳势和工艺时间。Input of process parameters: process No. and temperature, carbon potential and the process time of each area.

（3）故障报警：显示当前故障、显示历史故障、故障查询。Failure alarm: displays the current fault, fault history and fault diagnosis.

（4）数据记录：实时记录各段的温度、碳势以及工艺时间，并能进行储存，以便随时查询。Data record: real-time recording of temperature, carbon potential and process time of each section, which can be stored for inquiry at any time.

（5）历史曲线：各段温度曲线和碳势曲线。Historical curve: the curve of the temperature and the carbon potential of each section.

（6）数据导出：通过U盘可随时导出数据，进行数据存档。Data export: export data at any time through the U disk for data archiving.

辊棒式调质热处理生产线（加热源：气/电）

Roller type tempering heat treatment production line
(heating sources: gas/electricity)

适用于管材、棒料及工程机械各类型履带板的淬火、回火连续生产线，设备具有炉温均匀性好，高效、节能、自动化程度高等特点，所处理产品硬度均匀，变形量小，单件能耗低。

热处理自动连续生产线工作流程为：

上料——淬火加热——淬火出料——冷却——回火布料——回火——回火冷却——下料

For pipe, bar and various types of engineering machinery types of creeper tread quenching and tempering continuous production line of construction machinery is featured in good furnace temperature uniformity, high efficiency, energy saving, high degree of automation, having hardness uniformly treated and less deformation and achieving low energy consumption of one piece.

The process of heat treatment automatic continuous production line is:

Feeding - heating with quenching - the material discharging with quenching - Cooling - tempered cloth -tempering - cooling with tempering - cutting

典型零件：用于管材、棒料及各类节距的履带板淬火、回火

Typical parts: quenching and tempering of pipe, bar and track links with all pitches



铝合金锻前加热炉

Aluminum alloy forging heating furnace

适用于汽车、摩托车等铝合金零件的锻造前坯料加热热处理。整机控制系统采用工控机控制，自动化程度高，炉温均匀性精度高。

Suitable for automotive, motorcycle etc. Aluminum Alloy forging parts blank before heat treatment. The control system adopts computer control, high degree of automation, high precision temperature uniformity.

典型零件：铝合金棒料、圆坯等铝合金原材料

Typical parts: Aluminum alloy bar, round billet and other aluminum alloy raw materials



周期式连续铝合金固溶、时效热处理炉

Periodic aluminum alloy solid solution, aging heat treatment furnace

适用于汽车、摩托车等铝合金零件的固溶、时效热处理。整机控制系统采用工控机控制，自动化程度高，炉温均匀性精度高。

Suitable for automotive, motorcycle etc. Aluminum Alloy parts of solution and aging heat treatment. The control system adopts computer control, high degree of automation, high precision temperature uniformity.

典型零件：铝合金转向节、控制臂、轮毂等铝合金锻件

Typical parts: Aluminum alloy steering knuckle, control arm, hub and other aluminum alloy forgings



连续式铝合金固溶热处理炉

Continuous aluminum alloy solid solution heat treatment furnace



连续式铝合金时效热处理炉

Continuous aluminium alloy aging heat treatment furnace



典型零件：铝合金转向节、控制臂、轮毂等铝合金锻件

Typical parts: Aluminum alloy steering knuckle, control arm, hub and other aluminum alloy forgings