

THP Series

Slab Side Rubber
Oil Seal Vulcanization
Molding Machine

真空油封橡膠硫化機系列



We are proud to say Tung Yu is
your first choice of
hydraulic forming machinery.

東毓深耕成型技術 持續擴展應用領域



Tung Yu - Tailor-Made Solutions Provider

Tung Yu, with ISO 9001 approved and CE certified, is highly experienced in the field of hydraulic machinery since 1983. Tung Yu manufactures a wide assortment of products, from 5 tons hydraulic press to 13,000 tons conveyor belt production line and we offer a comprehensive One-Stop Shopping service for customers. Our product line includes: Compression Molding Machines, Rubber and [Liquid] Silicon Injection Molding Machines, Conveyor Belt Vulcanizing Machines, Tire Molding Machines, Retreading and Solid Tire Molding Machines.

東毓油壓機械股份有限公司，自1983創立以來，秉持著董事長楊楨彬先生之「穩健踏實、永續經營」經營理念，以「誠信」立足市場。『Tung Yu』品牌行銷全球六十餘國。承製能力範圍廣闊，鎖模力由5噸小型油壓沖床至13,000噸的輸送帶硫化機，均能承製。主要機械產品線：熱壓成型機、橡矽膠(液態)射出成型機、輸送帶硫化機、輪胎硫化機、翻新胎硫化機以及各式油壓機械，產品應用領域跨足各大產業。未來發展以創新為目標，深耕「力量與熱量載具」之核心技術，成為成型技術的領先者，為客戶創造最大價值。



總公司 Headquarters



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(India) Liaison Office

THP Series Machine Ranges THP系列機型

- | | |
|--|---|
| 03 Custom-made Machine
客製化機型 | 10 Auxiliary Machine
輔助設備 |
| 05 Standard Range
標準機型 | 13 Oil Seal & Rubber Parts
Trimming Machine
油封及橡膠件整修機系列 |
| 09 THP Model Guide and Specifications
THP型式說明與規格表 | 18 Global Sales Network
全球銷售網絡 |

THP-V-250-3RT-S-PCD (CE)

Rubber Oil Seal Vulcanization Molding Machine (Slab Side Type) 真空油封橡膠硫化機

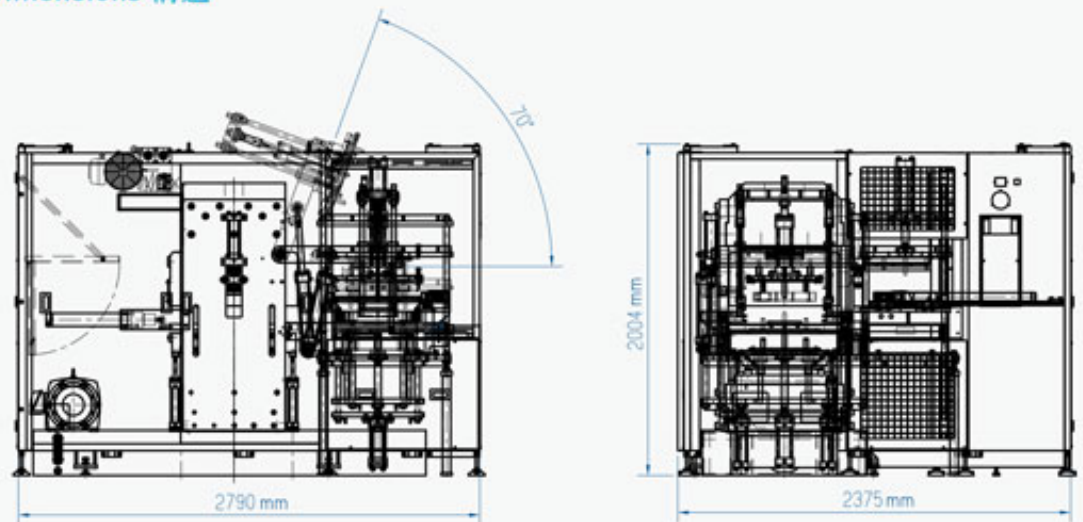
Mechanical features at a glance

- Upper plate turnover degree is adjustable for easily clean.
- Low working height for ergonomic engineering.
- Open working area with safety light curtain protection for easily process monitor.
- Suitable for 2 or 3 layer molds.
- 可調式翻板角度，方便模具卸載。
- 低工作高度，符合人因工程。
- 開放式工作區域，搭配安全光柵保護，方便流程監控。
- 適用2層及3層模具。





Dimensions 構造



Features 特寫說明

- Cavity plate moves to right and knock out for parts collecting automatically.
- Could be equipped with conveyor belt for automation system improvement.
- 模穴板右移拍出成品自動收料。
- 可搭配輸送帶裝置，提升自動化流程。

THP-V-250-3RT-S-PCD (CE)

Rubber Oil Seal Vulcanization Molding Machine (Slab Side Type)

真空油封橡膠硫化機

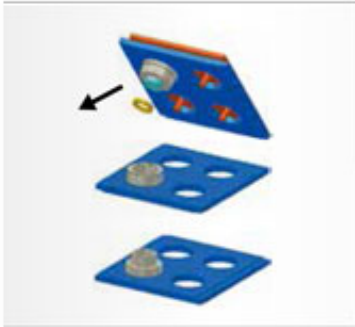
Mechanical features at a glance

- Equipped with top, lower and middle plate for various molds design to knock out products.
- Full caging with light curtain for safety operation.
- Mold in/out, bumping and stripping all completed in one cycle automatically, every stage is free adjustable.
- Simplicity in mechanism for easy maintenance.
- 搭配上拍、下拍及中拍可運用於各種模具設計拍出成品。
- 全包式圍網設計，搭配光柵裝置，確保操作安全。
- 進退模、排氣、離型全自動循環，每階段可自由控制。
- 機構設計精簡，維修保養更方便。

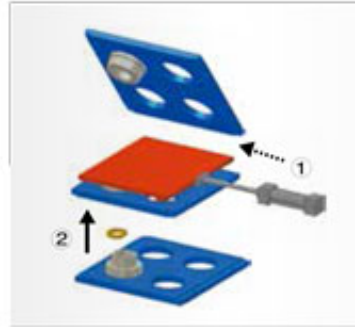


3-Layer Mold (3RT) Opening Way 3層模具(3RT)離型方式示意圖

Upper Plate Ejection Device
上拍板 頂出裝置



Middle Plate Left Side Ejection Device
中拍板左移 頂出裝置

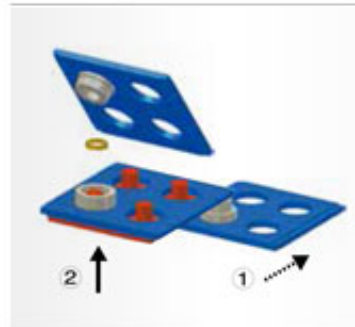


1. Middle plate moves to left side.
2. Middle bolster plate lifts upwards and eject by middle plate.
1. 中拍板左移
2. 中模架板上升，利用中拍板頂出成品

Lower Plate Ejection Device
下拍板 頂出裝置



Middle Mold with Lower Plate Ejection Device
中模下拍板 頂出方式



1. Lower mold move backwards.
2. Lower plate lift up and eject.
1. 下模後退
2. 下拍板上升，頂出中模成品

Optional Accessories 選購配備



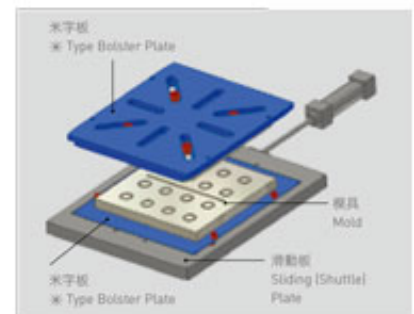
Full Color Touch Screen
大尺寸彩色人機

Ease of operation, parameter setup and monitoring.
方便人員操作，參數設定與監控。



Safety Sensor & Light Curtain
安全電眼

Combined with PLC control system, ensures full protection of operators.
搭配PLC程式控制，確保操作人員安全。



*Type Bolster Plate
米字型模架板

By fixing “*” type bolster plate, THP series machines can be used for O-rings, gaskets and various rubber parts.
THP機型加裝米字型模架板(米字板)後，即可使用板模生產O型環、墊片及其他橡膠產品。

THP-V-150-2RT-S-PCD

Rubber Oil Seal Vulcanization Molding Machine (Slab Side Type)

真空油封橡膠硫化機

Mechanical features at a glance

- Vacuum cover design - reduces curing time and increases production efficiency.
- High speed vacuum system - eliminates air inside cured rubber to have products with zero defect quality.
- Mold in/out, bumping and stripping all completed in one cycle automatically, every stage is free adjustable.
- 真空罩裝置—硫化時間大幅縮短，生產效率提升。
- 高速真空系統—原料流動性佳、消除成品內包氣泡，成品零缺點。
- 進退模、排氣、離型全自動循環，每階段可自由控制。

Products 製造成品

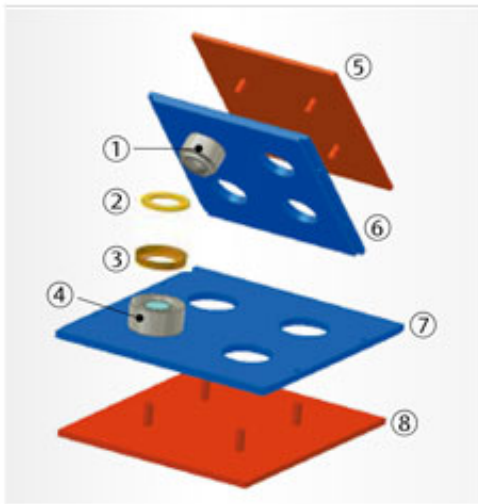
- Oil seals
- Bearing seals
- Automotive parts
- 工業用油封
- 機械軸封
- 汽機車用油封



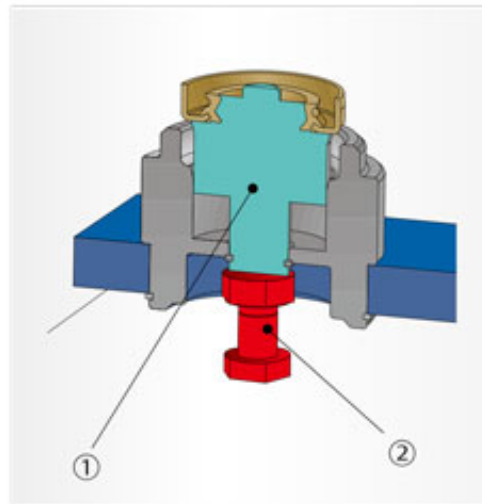
Features 特寫說明

- Plate turn over at 60° , for easy parts removal.
- 翻板角度達60° ，方便成品取出。

Demolding Mechanism 脫模機構說明



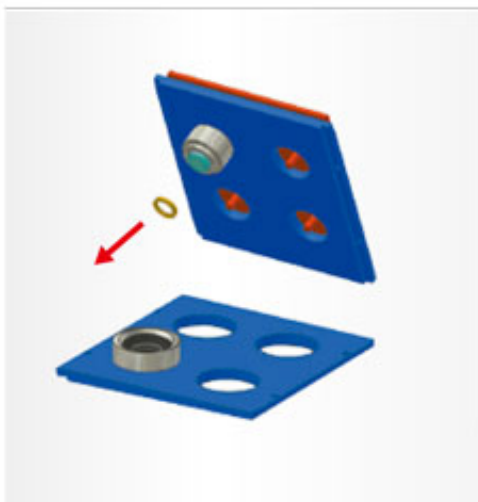
- | | |
|-----------------------|--------|
| 1.Upper Mold | 1.上模 |
| 2.Rubber compound | 2.膠料 |
| 3.Metal Insert | 3.鐵殼 |
| 4.Lower Mold | 4.下模 |
| 5.Upper Clapper Plate | 5.上拍板 |
| 6.Upper Bolster Plate | 6.上模架板 |
| 7.Lower Bolster Plate | 7.下模架板 |
| 8.Lower Clapper Plate | 8.下拍板 |



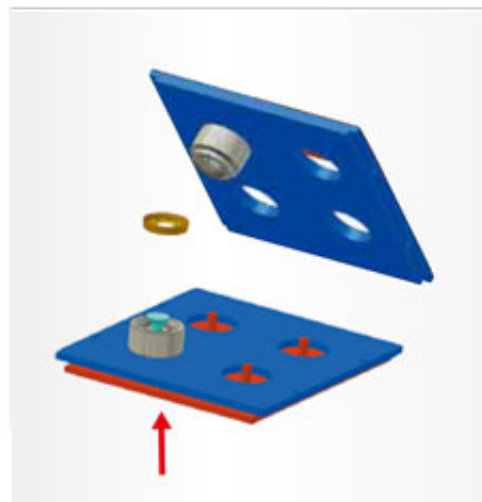
- | | |
|-------------|------|
| 1.Mold Core | 1.模心 |
| 2.Eject Pin | 2.頂針 |

2-Layer Mold (2RT) Opening Way 2層模具(2RT)離型方式示意圖

Upper Clapper Plate Ejection Device
上拍板，頂出裝置



Lower Clapper Plate Ejection Device
下拍板，頂出裝置



THP Model Guide 型式說明

THP

Slab-side Type
旁板型

Vacuum Device
真空裝置

Clamping Force (ton)
鎖模力 (噸)

Layer of Mold Strip
離型模數

No. of Station
連結台數

S

Main Ram Outside Type
主缸外露型

Control System
電氣控制方式

Code 代號	Description 說明
Omit 無	No Vacuum 無真空
V	Vacuum 有真空裝置

Code 代號	Description 說明
80	[=80 tons]
100	[=100 tons]
150	[=150 tons]
250	[=250 tons]

Code 代號	Description 說明
2RT	2-layer mold strip 二層脫模
3RT	3-layer mold strip 三層脫模

Code 代號	Description 說明
Omit 無	Single station 單機
2	Double stations 雙聯台
3	Three-station 三聯台
4	Four-station 四聯台

Code 代號	Description 說明
PCD	PLC+HMI (touch screen) PLC+觸控螢幕

THP Series Technical Specifications 機器規格表

Machine Type	機型		THP-V-80	THP-V-100	THP-V-150	THP-V-250
Clamping Force	鎖模力	ton	80	100	150	250
Piston Diameter	活塞直徑	mm	φ 225	φ 250	φ 300	φ 400
Heating Platen Size	熱盤尺寸	mm	250x300	350x400	450x480	570x610
Bolster Plate Size	模架板尺寸	mm	290x320	390x420	500x520	620x620
Daylight	最大開檔	mm	200			
Stroke	最大行程	mm	140			
Vacuum Accessories	真空方式		Vacuum Cover Type 真空罩式			
Power Consumption	使用功率	kW	4.8	8.76	8.76	18.2
Turnover Degree	翻轉角度		60° [2RT]		45° [2RT]	
			45° [3RT]			
Dimension (mm)	外觀尺寸	2RT	1165 x 1976 x 1987	1145 x 2080 x 2000	2362 x 1365 x 1982	1032 x 3026 x 2085
		3RT	1534 x 1970 x 1870	1510 x 2262 x 1926	2362 x 1365 x 1982	1718 x 3139 x 2073

TR-250-PCD

Precision Rubber Slicer

精密橡膠切片機

Mechanical features at a glance

- Advanced digital HMI controller for easy setup and operation.
- Parameter recording for fast mold changing efficiency.
- Front die can be easily changed to different shapes as required.
- Cutter with advanced balance design that runs stably and silently.
- 採先進PCD數位式觸控系統，操作設定更便利。
- 附模組記憶功能，方便換模操作，節省人工切料時間。
- 特殊模頭設計，可依不同需求變化切片形狀。
- 刀頭特殊平衡設計，運轉安靜穩定。



TR-V-240-PCD

Precision Rubber Slicer

精密橡膠切片機

Close Loop and Smart E-weight Data Transfer 閉環迴路+飛切系統

Mechanical features at a glance

- Simplify process decrease adjusting time.
- Equipped with smart E-weight data feedback system (close loop), enable to adjust cutter speed and working pressure automatically.
- Weight precision within $\pm 1\%$ (95% finished product).
- With clean window design for easily removing remaining and changing rubber compounds.
- Equipped with vacuum system to get rid of air inside rubber compounds.
- Cutter with advanced balance design that runs stably and silently.
- 縮短調整時間。
- 本機使用量測系統搭配油路與重量回饋控制，自動依實際需求調整擠出壓力與切刀速度。
- 重量精度: $\pm 1\%$ 內 (95%成品)。
- 掃除窗設計易於清理更換膠料。
- 內建真空系統，減少膠料氣泡。
- 特殊刀柄配重設計，運轉安靜穩定，增加切刀使用壽命。



Process 製造循環圖



TR Series Precision Rubber Slicer 精密橡膠切片機

Machine Type	機型		TR-V-240-PCD	TR-250-PCD	
Volume of Material barrel (Max. Batch Capacity)	料筒置料 (一次最大可裝膠料容)	L	40	45	60(Option) [選配]
Horsepower	使用馬力		15HPx4P	15HPx4P	
Cutter Motor	切刀馬達		Servo Motor 伺服馬達	Inverter Motor 變頻馬達	
Vacuum Pump	真空泵浦	kW	0.55	Option 選配	
Rubber Clean Window	膠料清除窗		Standard 標準配置	Option 選配	
Finished Product Size (O.D.)	成品尺寸(外徑)	mm	5-80	5-80	80-160 (Option)(選配)
			0.3-300	0.3-900	
Weight of Finished Product	成品重量	g	The data will be limited by different cutter speed, die mold, extruding pressure and rubber compound hardness. 需搭配切刀速度、模具、擠出壓力調整及膠料硬度限制		
Precision of Finished Product	成品精度		95% Finished Product within ±1% 95%成品在±1%	95% Finished Product within ±1.5% 95%成品在±1.5%	
Quantity of Cutter	切刀數量		Single-cutter 單刀型		
Cutter Speed	最高刀速	rpm	400	250	
Speed Changing of Cutter	刀速變速方式		Free-stage Adjustable 可無段調整		
Temp. of Material Barrel	料筒溫度	°C	Max.90°C		
Temp. Precision of Material Barrel	料筒溫度精度	°C	±5°C		
Heat Transfer	傳熱方式		Water 水		
Weight of Final Remains	最後殘料重量	kg	約 5 (Approx.)		
Feed Capacity Control Way	成品料重控制方式		Feed Back System 飛切系統	Auto Setting and Stop 自動設定	
Digital Touch Screen Controller	PCD數位式觸控系統		Standard 標準配置		
Dimensions	外觀尺寸	mm	(L)5128 X (W)1080 X (H)1911	(L)4230 X (W)1310 X (H)1980	(L)4862 X (W)1310 X (H)1980
Net Weight	機台淨重	kg	5040	2550	3900

NR Series

Vacuum Type Rubber Parts Trimming Machine

真空式橡膠件整修機

This machine is used for cutting the flash of the circle rubber parts .

本真空式油封整修機用以切削圓形橡膠件的毛邊。

Features 特點

- Manual feed and auto trim.
- The vacuum generator will suck the oil seal through the mold during the cutting period to get the best cutting precision.
- There are many cutting mode for the user to choose. To cut the inner and outer flash simultaneously.
- The user can choose the Inverter to adjust the spindle speed.
- The light curtain and fence will protect the operator's safety and keep the working environment clean. (CE type)
- 手動送料自動修邊。
- 利用真空特性配合模具吸住加工物件以切割毛邊，以得到最好切割品質。
- 多種切割模式可供選擇。內外毛邊切除一次完成。
- 使用者可選擇使用變頻器以調整主軸轉速。
- 光幕保護操作者安全，圍籬維護環境乾淨。[CE型式]



NRC Series

Collet Chuck Type Trimming Machine

夾頭式油封整修機

This machine is used for cutting the flash of the metal case oil seal.

適用於鐵殼型油封的內外毛邊的切削。

Features 特點

- Manual feed and auto trim.
- The #25 collet chuck grabs the oil seal to cut the flash.
- There are many cutting mode for the user to choose. To cut the inner and outer flash simultaneously.
- Right cutting angle is 0° - 90° .
- 手動送料自動修邊。
- 利用#25型彈性夾頭夾住加工物件以切割毛邊。
- 多種切割模式可供選擇，內外毛邊切除一次完成。
- 右切割角度為 0° - 90° 。



ATAS Series

Oil Seal Trimming and Spring Loading Machine

油封修邊及裝彈簧機

This machine is suitable to cut the flash and load the spring with high volume oil seals in the production line.
本機器適用於生產線上多量少樣油封的切削毛邊及裝填彈簧。

Features 特點

- The vacuum generator/gripper feeds the oil seal to precisely fit it onto the cutting mold and then cut the flash.
- Magnet rotator/Vibrating tray feeds the spring to appropriate location.
- The tooling is pulled fast by the air cylinder to combine the oil seal with the spring.
- It will check if the spring is being correctly loaded by metal probe and sort out defects.
- 吸盤/夾爪將油封精確的置放於主軸之上然後切割毛邊。
- 磁盤/震動盤將彈簧送至正確掛簧位置。
- 氣缸快速的推動治具來將油封與彈簧組合。
- 以探針確認彈簧是否正確裝填並將不良品分離。



RRT

Ring Cone Type Trimming Machine

輪轉式油封修邊機

Features 特點

- Auto feed and auto trim.
- Cutting the outer and inner flash at a time.
- One person operates 2 or 3 machines at the same time.
- 自動送料自動修邊。
- 內外徑一次切割完成。
- 操作人員可一次操作 2-3台機器。



KS-1

Knife Grinding Machine

磨刀機

Features 特點

- The water cooling system will cool down the grinding temperature to avoid the overheating of the blade.
- The gear handle and double slides help the operator to orientate the blade precising and easily.
- 採水冷式冷卻刀片以避免刀片過熱。
- 齒輪把手及雙十字滑座協助使用者精確定位。



TEST-H-PCD / TEST-S-PCD

Twin-shaft Oil Seal Gyration Testing Machine

雙軸油封迴轉試驗機

Mechanical features at a glance

- Suitable for oil seal high pressure condition and abrasion testing.
- Testing shaft can gyrate clockwise / anti-clockwise.
- Attached with temperature recorder to record details of temperature, speed and gyration / start / stop time.
- PC connection control system can be customized.
- Fully automatic control and setting (including pressure and temperature).
- 適用於油封高壓、耐磨耗測試。
- 附加溫度計錄器，完整記錄溫度、迴轉速度及迴轉/啟動/停止時間。
- 連線監控系統可依客戶需求規劃設計。
- 全自動控制(凡壓力、溫度設定及控制裝置)。

Standard 標準型

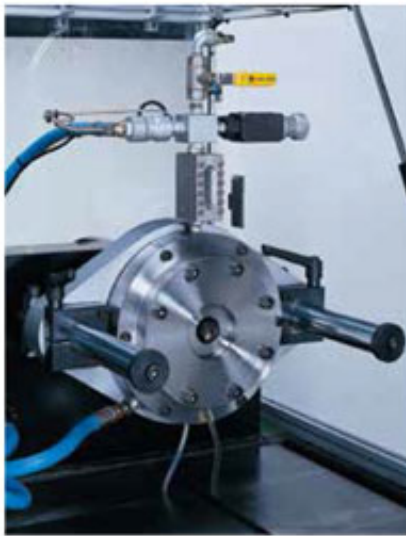


High Pressure Type 高壓軸轉型



※Remarks: 1. TEST-S-PCD with shell gyration type and TEST-H-PCD with shaft gyration type is available.
2. For usage of oil temperature over 150°C, appropriate type of oil should be prepared by buyer.
3. Optional up to 10,000rpm.
4. Pressure setup available for low & middle pressure type.
5. Expect for shell gyration and micro-pressure type, it'll be equipped with safety fence and pressure protection device.

※註：1.亦有標準殼轉型及高壓軸轉型。
2.欲使用高於150°C之油溫測試需由客戶自備合適條件之油品。
3.選配轉速達10,000rpm。
4.低壓及中壓可設定壓力。
5.低壓以上之規格搭配防護罩與超壓自動洩壓保護設備，確保操作安全。



High pressure Type
高壓軸轉型



Standard Type
標準型

TEST Series Oil Seal Gyration Testing Machine 油封迴轉試驗機

Machine Type	機型		Shell Gyration 殼轉	Micro-pressure 微壓	Low Pressure 低壓	Medium Pressure 中壓	High Pressure 高壓
Testing Pressure Range	可測試壓力 範圍	kg/cm ²	MAX: 0.3	MAX: 0.3	0.5~6	5~30	30~210
Pressure Adjustment	壓力調整方式		Manual 手動			Proportional 比例式	
Spindle Range	可測軸徑範圍	mm	φ 15~ φ 120	φ 10~ φ 200	φ 10~ φ 170	φ 10~ φ 80	φ 10~ φ 80
The Shell /Housing Diameter	最大殼徑		φ 150	φ 250	φ 200	φ 120	φ 110
Testing Spindle Speed Range	測試軸可調轉 速範圍	rpm	200~6000	200~10000	200~6000 (10000選配)	200~6000	200~3000
Testing Temperature (MAX)	最高使用溫度	°C	120°C				
Inspection of Seal Leaking	洩漏檢測方式		Visual Check 目視	By Oil Mass of Leaking Cup 量杯目視		By Leaking Cup or Auto Detect 量杯或自動檢出	
Setting of Testing Parameter 每一模式可設定之條件							
(1)Testing Time	(1)運轉時間	1H	•	•	•	•	•
(2)Stop Time	(2)停止時間	1min	•	•	•	•	•
(3)Testing Speed	(3)轉速設定	rpm	•	•	•	•	•
(4) Temperature	(4)溫度	°C	•	•	•	•	•
(5)Testing Pressure	(5)壓力	kg/cm ²				•	•
(6)Testing Gyration (Clockwise / Counter Clockwise)	(6)轉向(正逆)		•	•	•	•	•
Cycle Numbers	模式循環數		Max. 9999 Cycles				

TRD

Seal Shell (Metal Insert)
Rotary Air-dryer
油封鐵殼風乾迴轉機



Machine Type 機型			TRD Single 單聯	TRD Double 雙聯
Capacity per time	處理能力	kg/time	20	20x2
Rotary Speed	轉速	rpm	Adjustable 可變式	
Total Power	總用電量	kW	1.2	2.4
Machine Dimension WxLxH	尺寸	mm	850x1450x1150	1270x1450x1150
Machine Weight	重量	kg	150	250

TA

Seal Shell (Metal Insert)
Adhesive Applying Machine
浸藥附著機



Machine Type 機型			TA-30	TA-50
Capacity per time	處理能力	kg/time	30	50
Electrical Power	電熱	kW	7	
Total Power	總用電量	kW	8	
Air Pressure	空氣壓力	kg/cm ²	5~7	
Machine Dimension WxLxH	尺寸	mm	1600x1700x2250	1900x1700x2250
Machine Weight	重量	kg	2500	2800

TS

Automatic Feeding & Cutting Machine
橡膠自動切斷機



Machine Type 機型			TS-20	TS-25
Blade Width	刀寬度	mm	608	759
Width of Machine	機械寬度	mm	1130	1260
Height of Machine	機械高度	mm	1280	
Cutting Speed	每分鐘切料	times/min	57	
Horse Power	馬力	HP	1	
Width Range	調整切斷寬度	mm	1-95	
Weight	重量	kg	420	460

TD

Rubber Slitting Machine
橡膠分條機



Machine Type 機型			TD-20	TD-25
Blade Width	刀寬度	mm	608	760
Width of Machine	機械寬度	mm	1068	1220
Height of Machine	機械高度	mm	1200	
Cutting Speed	每分鐘切料	mm/min	8200	
Horse Power	馬力	HP	1	
Weight	重量	kg	230	260



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