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KBR

科博尔集团



上海科博尔铸件（集团）有限公司
Shanghai Keboer Casting (Group) Co., LTD



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关于我们 About us

上海科博尔铸件（集团）有限公司是一家专业生产数控机床、阀门泵体、机壳、工程机械铸件等机械行业用灰铸铁、球墨铸铁铸件的企业，并已通过IOS9001:2015质量管理体系认证。

工厂位于安徽省宁国市，占地120亩，建筑面积9.1万平方米，年产量3万吨。

公司于2003年在苏州成立，2022年搬迁到安徽。采用树脂砂工艺和覆膜砂工艺生产铸件，拥有10多年工程专业技术人员36人，高级工程师8人，生产工人200余人，可以完成高要求的铸件产品，产品主要出口欧美、日本等国家。

Shanghai Keboer Castings (Group) Co., Ltd. is a professional manufacturer of gray cast iron and ductile cast iron castings for CNC machine tools, valve pump bodies, casings, construction machinery castings and other machinery industries, and has passed the IOS9001:2015 quality management system certification.

The factory is located in Ningguo City, Anhui Province, covering an area of 120 acres, construction area of 91,000 square meters, annual output of 30,000 tons.

The company began casting production in 2003, using resin sand process and coated sand process to produce castings, with more than 10 years of engineering pro and technical personnel 36 people, senior engineers 8 people, more than 200 production workers. Products are mainly exported to Europe, America, Japan and other countries.



覆膜砂工艺
Coated sand process



树脂砂工艺
Resin sand process



灰铁铸件
Gray iron casting



球铁铸件
Ductile iron casting



CNC 机加工
CNC machining



质量与检验
Quality & inspection



覆膜砂工艺 Coated sand process

我们利用高硬度灰铁来制作模具，利用高精度加工中心来加工模具，可以保证产品的精度误差在0.5MM，模具使用次数可以达到10万次以上。适合制作精密度高，表面漂亮，重量1吨内的产品。

利用射型机把200目的砂子喷射到模具当中，制作用来浇铸的砂壳，浇铸后需要保温7-12小时。

We use high-hardness gray iron to make molds, and use high-precision machining centers to process molds, which can ensure that the accuracy error of the product is 0.5MM, and the mold can be used more than 100,000 times. Suitable for making products with high precision and small weight.

The molding machine is used to spray 200 mesh sand into the mold to make the sand shell for casting, which needs to be kept warm for 7-12 hours after casting.



覆膜砂-砂壳
Coated sand - sand shell



射型机-制作砂壳

Shooting machine - Making sand shell



砂壳-涂抹材料

Sand shell - Coating material



加工中心 - 四轴
Machining center - four-axis

重量: 55Kg
材料: 灰铁HT300

Weight : 55Kg
Material : HT300



泵体 - 离心泵
Pump body - centrifugal pump

重量: 19Kg
材料: 球铁QT450

Weight : 19Kg
Material : QT450



树脂砂工艺 Resin sand process

模具通常由金属或木材制成，以确保其强度和稳定性。在模具内部涂上一层特殊的树脂涂料，利用制砂机把树脂砂灌进模具当中，并压实，形成一层坚固的砂型。将液态金属或合金倒入砂型内，保温7-24小时，即可取出成型的铸件。模具价格较为便宜，适合制作大型铸件。

科博尔树脂砂工艺可以生产50-10000kg的铸件。

Molds are usually made of metal or wood to ensure their strength and stability. A special resin coating is applied to the inside of the mold, and the resin sand is poured into the mold using a sand making machine and compacted to form a solid sand mold. The liquid metal or alloy is poured into the sand mold and kept warm for 7-24 hours, and the molded casting can be removed.

The mold price is relatively cheap, suitable for the production of large castings and precision requirements are not strict products.



树脂砂-砂壳
Resin sand - sand shell



混砂机 - 制作砂壳

Sand mixer - Making sand shells



树脂砂 - 砂壳检查

Resin sand - shell inspection



加工中心 - 底座
Machining center - Base

重量: 570Kg Weight : 570Kg
材料: 灰铁HT300 Material : HT300



数控机床- 底座
CNC machine tools - Base

重量: 3258Kg Weight : 3258Kg
材料: 灰铁HT350 Material : HT300



灰铁铸件
Gray iron casting

灰铸铁，碳以片状石墨形式存在于铸铁中。断口呈灰色。有良好的铸造、切削性能，耐磨性好。用于制造机床，机架、箱体等铸件。有效承载面积比较小，石墨尖端易产生应力集中。灰铸铁具有良好的铸造性能、良好的减振性、良好的耐磨性能、良好的切削加工性能、低的缺口敏感性。

Gray cast iron, in which carbon is present in the form of flake graphite. The fracture is gray. It has good casting and cutting properties and good wear resistance. Used to manufacture machine tools, frames, boxes and other castings. The effective bearing area is relatively small, and the graphite tip is easy to produce stress concentration.

Gray cast iron has good casting performance, good vibration damping, good wear resistance, good cutting performance and low notch sensitivity.



灰铸铁金相
Gray cast iron metallography



数控机床-底座

Machine tools - base

工艺：树脂砂工艺
重量：6519Kg
材料：HT350

Process : Resin sand
Weight : 6519Kg
Material : HT350



数控机床-鞍座

Machine tools – Saddle

工艺：覆膜砂工艺
重量：86Kg
材料：HT300

Process : Coated sand
Weight : 86Kg
Material : HT300

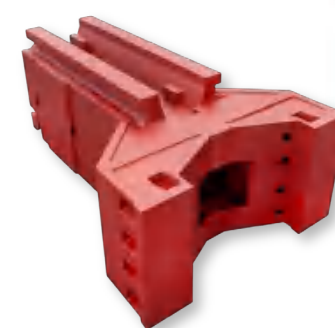


齿轮箱

Gear case

工艺：覆膜砂工艺
重量：6Kg
材料：HT200

Process : coated sand
Weight : 6Kg
Material : HT200



数控机床-立柱

Machine tools – Columns

工艺：树脂砂工艺
重量：1328Kg
材料：HT300

Process : Resin sand
Weight : 1328Kg
Material : HT300



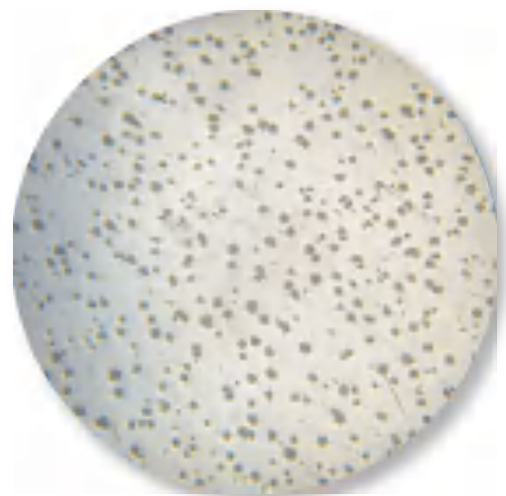
球铁铸件

Ductile iron casting

球墨铸铁通过在液态灰口铸铁中加入球化剂和孕育剂，使片状游离石墨变成球状石墨，从而显著提高了铸铁的机械性能，特别是塑性和韧性。由于强度高、韧性好、耐磨性好等特点，广泛应用于各种机械零件，如轴、联轴器、齿轮、泵体、阀门、缸体等。

By adding nodular and inoculant to liquid gray cast iron, the flake free graphite becomes spherical graphite, which significantly improves the mechanical properties of cast iron, especially plasticity and toughness .

Due to the characteristics of high strength, good toughness , good wear resistance and so on, widely used in all kinds of mechanical parts, such as shaft, coupling, gear, pump body, valve, cylinder body .



球墨铸铁金相

Ductile cast iron metallography



电机-连接器

工艺：覆膜砂工艺
重量：45Kg
材料：QT400-10

Motor – Connector

Process : coated sand
Weight : 45Kg
Material : QT400-10



水泵-飞轮

工艺：覆膜砂工艺
重量：36Kg
材料：QT450-15

Water pump – Flywheel

Process : coated sand
Weight : 36Kg
Material : QT450-15



联轴器

工艺：覆膜砂工艺
重量：16Kg
材料：QT500-7

Coupling

Process : coated sand
Weight : 16Kg
Material : QT500-7



轴承座

工艺：覆膜砂工艺
重量：29Kg
材料：QT400-10

Bearing block

Process: coated sand
Weight: 29Kg
Material: QT400-10



CNC 机加工 CNC machining

三个加工车间装备有龙门加工中心（最大可加工长4米、宽2米、高0.8米的工件）、镗床（可加工高精度工件）、卧式加工中心、立式加工中心（最大可加工长1.8米 宽0.9米的工件），以及磨床、摇臂钻、淬火机一台（热处理）、三坐标（检测加工精度）等。可以完成30-50微米的精加工产品还有粗加工产品。

The three machining workshops are equipped with gantry machining center (maximum length of 4 meters, width of 2 meters, height of 0.8 meters), boring, horizontal machining center, vertical machining center (maximum length of 1.8 meters and width of 0.9 meters), as well as grinding machine, rocker drill, quenching machine, three coordinates. Keboer can finish 30-50 microns of finished products and rough finished products.



立式加工中心
Vertical machining center



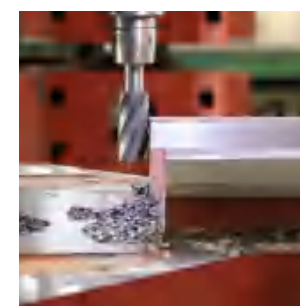
数控机床-工作台 Machine tools – workbench

精度：0.05毫米 Accuracy : 0.05 mm
重量：126Kg Weight : 126Kg
材料：HT300 Material : HT300



铸造 - 铁模具 Casting – Mold

精度：0.1毫米 Accuracy : 0.1mm
重量：38Kg Weight : 38Kg
材料：HT300 Material : HT300



数控机床-立柱 Machine tool – Column

精度：0.05毫米 Accuracy: 0.05 mm
重量：856Kg Weight: 856Kg
材料：HT300 Material: HT300



联轴器 (粗加工) Coupling (Roughing)

精度：0.1毫米 Accuracy: 0.1 mm
重量：16Kg Weight: 16Kg
材料：QT400-10 Material: QT400-10



质量与检验

Quality & inspection

科博尔可以完成铸造相关的全部检验：抗拉强度，硬度，烧灼减量。原材料手工化学成份检测，硬度，金相，抗拉强度，成份，3D扫描。光谱分析仪，抗拉强度测试仪，显微镜，硬度计，箱式电阻炉，智能型砂强度仪，电热恒温干燥箱，CET智能发气性测试仪，超声探伤仪，3D扫描仪。

Keboer can perform all the tests related to casting: tensile strength, hardness, burn reduction. Raw material manual chemical composition testing, hardness, metallography, tensile strength, composition, 3D scanning.

Spectrum analyzer, tensile strength tester, microscope, hardness tester, box-type resistance furnace, intelligent sand strength meter, electric thermostatic drying oven, CET intelligent gas tester, ultrasonic flaw detector, 3D scanner.



铸件3D扫描

Casting 3D scanning



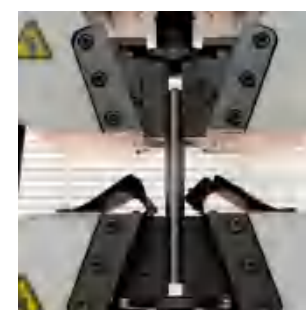
硬度检测

Hardness testing



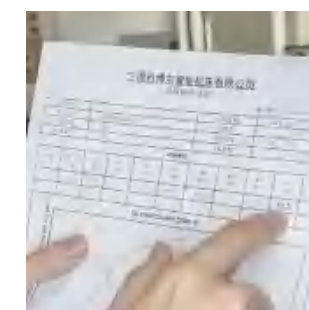
金相检测

Metallographic detection



抗拉实验

Tensile test



材料: QT400-15 Material : QT400-15
结果: QT400-18.5 Result : QT400-18.5



探伤检测

Flaw detection



产品: 联轴器 Products : Couplings
结果: 无气孔 Results : No stomata