

# Self-drilling Screw Point Forming Machine



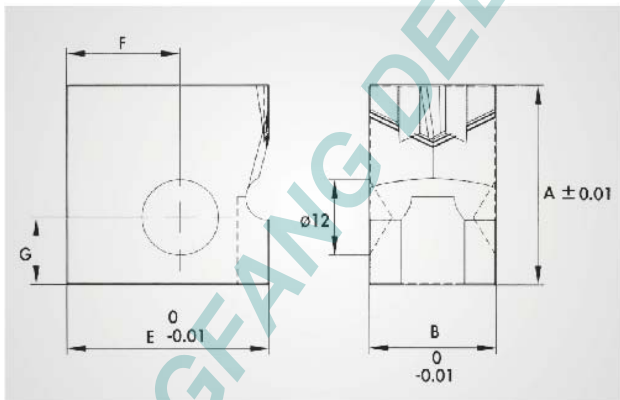
Automatic Feeding



# Self-drilling Screw Point Forming Machine

Specification	Model (-SD for Stainless Steel Materials)			
	ZW14-130L	ZW14-130L-SD	ZW14-210L	ZW14-210L-SD
Capacity PCS/min	120-520	Single 120-520 Double 60-150	80-520	Single 80-520 Double 40-150
Weight Approx KG	2180	2188	2410	2418
Main Motor KW	7.50		7.50	
Lubricant Motor KW	0.75		0.75	
Vibrating Motor KW	0.20		0.20	
Inverter KW	7.50		7.50	
Brake Mechanism	Air Clutch		Air Clutch	
Control System	Automatic PLC		PLC	
Checking System	Automatic Detection HMI Display		Automatic Detection HMI Display	
Vibrator mm	φ 620 with PU Coating		φ 820 with PU Coating	
Screw Diameter mm	φ 2.80-5.45/#6-14		φ 2.80-5.45/#6-14	
Screw Length mm	9.5-130		9.5-210	
Dimension Approx cm	195*165*165		230*190*190	

## Machine Parts and Drill Point Dies



Style I

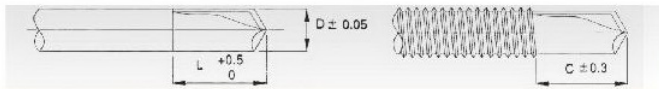
Style II

Style III

DIE STYLE	Style I	Style II	Style III
A	31.75	31.75	45.00
B	12.70	20.00	30.00
E	25.40	32.00	32.00
F	11.4	18.0	16.0
G	10.7	10.7	16.0



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## NO.1 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L1-22	2.2	2.5	1.7	Style I Style II
L1-23	2.3			
L1-27	2.7			
L1-28	2.8	2.4		
L1-29	2.9			
L1-30	3.0			
L1-31	3.1	3.5	3.2	
L1-32	3.2			
L1-33	3.3			
L1-34	3.4			
L1-35	3.5			
L1-36	3.6			
L1-37	3.7			
L1-38	3.8	4.2	4.0	
L1-39	3.9			
L1-40	4.0			
L1-41	4.1	5.2	5.0	Style II
L1-43	4.3			
L1-45	4.5			
L1-47	4.7			
L1-49	4.9			
L1-51	5.1			
L1-53	5.3			
L1-55	5.5	6.4	6.2	
L1-57	5.7			

## NO.2 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L2-22	2.2	3.2	2.2	Style I Style II
L2-23	2.3			
L2-27	2.7			
L2-28	2.8	3.9	3.0	
L2-29	2.9			
L2-30	3.0			
L2-31	3.1	4.5	3.9	
L2-32	3.2			
L2-33	3.3			
L2-34	3.4			
L2-35	3.5			
L2-36	3.6			
L2-37	3.7			
L2-38	3.8	5.1	4.8	
L2-39	3.9			
L2-40	4.0			
L2-41	4.1	6.0	5.9	Style II
L2-43	4.3			
L2-45	4.5			
L2-47	4.7			
L2-49	4.9			
L2-51	5.1			
L2-53	5.3			
L2-55	5.5	7.2	7.0	
L2-57	5.7			

## NO.3 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L3-23	2.3	3.8	3.7	Style I Style II
L3-27	2.7			
L3-28	2.8			
L3-29	2.9	4.5	3.7	
L3-30	3.0			
L3-31	3.1			
L3-32	3.2			
L3-33	3.3	5.5	4.7	
L3-34	3.4			
L3-35	3.5			
L3-36	3.6			
L3-37	3.7			
L3-38	3.8			
L3-39	3.9			6.8
L3-40	4.0			
L3-41	4.1			
L3-43	4.3	8	6.7	Style II
L3-45	4.5			
L3-47	4.7			
L3-49	4.9			
L3-51	5.1			
L3-53	5.3	9.3	8.0	
L3-55	5.5			
L3-57	5.7			

## NO.4 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L4-28	2.8	5	4.5	Style II Style III
L4-32	3.2	6	5.5	
L4-34	3.4	7	6.2	
L4-39	3.9	9	7.8	
L4-43	4.3	12.5	10.7	
L4-45	4.5			
L4-47	4.7			
L4-49	4.9			
L4-51	5.1			
L4-53	5.3			
L4-55	5.5			
L4-57	5.7			

## NO.5 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L5-49	4.9	15	13.7	Style II Style III
L5-51	5.1			
L5-53	5.3			
L5-55	5.5			
L5-57	5.7			

## NO.6 DRILL POINT DIES

DP DIE CODE	Drill Dia. (D <sub>ø</sub> )	Flute Length (L)	Drill Length (C)	Dp Diw style
L6-49	4.9	17.7	16.7	Style II Style III
L6-51	5.1			
L6-53	5.3			
L6-55	5.5			
L6-57	5.7			