



佛山市恒星机械厂

Foshan Heng Xing Machinery Factory

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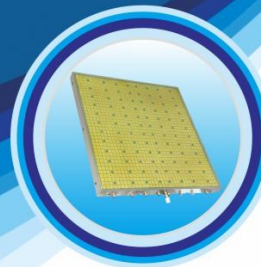
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品质固本，诚信立足，创新致远
Quality, Integrity, Innovation



佛山市恒星机械厂

Foshan Heng Xing Machinery Factory

公司简介

佛山市恒星机械厂成立于2000年，是一家集专业设计、开发、生产陶瓷模具于一体的大型机械企业，产品适用于高档抛光砖、地板砖、外墙砖、内墙砖及各种异形砖的压制。

公司拥有一支优秀的员工队伍，先进的加工生产设备，以及经验丰富的技术团队，并拥有现代化的生产车间，及一大批先进的机械设备和检测仪器，可设计生产18mmx18mm至1200mmx2400mm等一系列陶瓷设备。本公司全体员工经过长期不懈的努力，开发了一批具有领先技术的高端产品，引领同行。产品包括：普通总成，双浮动总成，下浮动总成，等静压模芯，排气模芯，等静压排气模芯，超薄胶模芯及仿古设计模芯等产品。部分产品在同行业中经常处于被模仿对象。

公司采用先进的科学管理模式，积极实施ISO9001-2000质量管理体系，确保产品质量和服务令客户满意。

公司经过长期努力，在国内外开拓了广阔的市场。在国内，与楼兰等众多知名陶瓷企业建立了长期稳定的合作伙伴关系。公司除努力服务好本土客户外，还积极开拓海外市场，产品远销印度尼西亚，马来西亚，孟加拉，印度，越南，泰国及非洲等国家和地区。

“以人为本、团结、奋进、创新”是佛山市恒星机械厂所有员工一贯的精神。追求更好、精益求精是公司的质量方针，客户100%的满意使我们的最终目标！

欢迎全球各地的客户莅临本公司参观、指导、合作。我们期待着您的到来！



努力做的更好

HengXing | 01



Company Introduction

Established in the year of 2000, Foshan Heng Xing Machinery Factory is a sophisticated company integrated in specially and professionally designing, developing and manufacturing moulds and punches for Ceramic Wall/Floor/Roof tiles. Heng Xing's products are applicable to the production of high-class polished tiles, floor tiles, exterior and interior wall tiles, and various rustic designs tiles.

Boasting a team of professional and qualified staff members, and a team with rich experience, as well as a modern workshop where a number of advanced mechanical equipment and detecting instruments are available, Heng Xing has the ability to design and produce a series of moulds and punches for ceramic tiles varied from the size of 18mmx18mm to 1200mmx2400mm. Our technical team, through continuous and unremitting efforts and struggles, has created and developed a series of high end products to enable us to lead a large margin in the industry. The high quality products include: Entry Mould Set, Double Floating Mould Set, Lower Floating Mould Set, Isostatic Punch, Exhaust Punch, Isostatic Exhaust Punch, Ultra-thin Rubber Punch and Rustic Design Punches and so on. Among those products, some of them are often copied and imitated by other ceramic machinery factories.

We have adopted the scientific administration mode and positively executed the ISO9001-2000 Quality Control System in order to assure that our customers are always satisfied with the quality of products as well as the excellent service.

Fo Shan Heng Xing Machinery Factory, through unremitting efforts, has developed broad market in domestic and overseas. We had built stable and long term cooperation with famous domestic ceramic companies like LOLV. Except offering excellent service to the local customers, our company also work hard for developing the overseas market, nowadays our products are sold as far as Indonesia, Malaysia, Bangladesh, India, Vietnam, Thailand and Africa and so on.

Fo Shan Heng Xing Machinery Factory and her staffs always bear the spirit of Human Oriented, Solidarity, Advancing and Innovation. Pursue after the better and keep improving are the company's quality standards, as well 100% satisfactory of the customers are our final targets!

Friends and all customers around the world are warmly welcome to our company for visiting, instructing and cooperation. We are always expecting you!

HengXing | 02

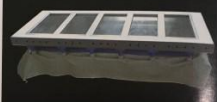
普通总成

Normal Entry Mould

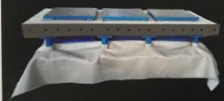
250*500—4W



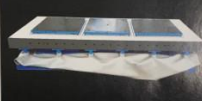
300*600—5W



400*400—3W



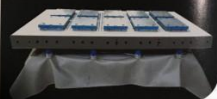
500*500—3W



250*400—7W



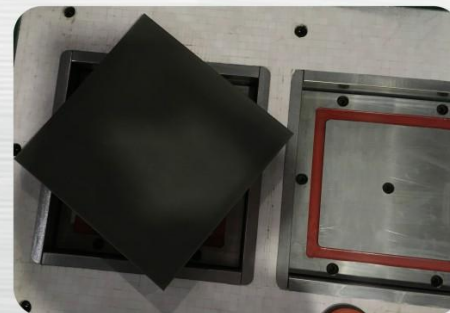
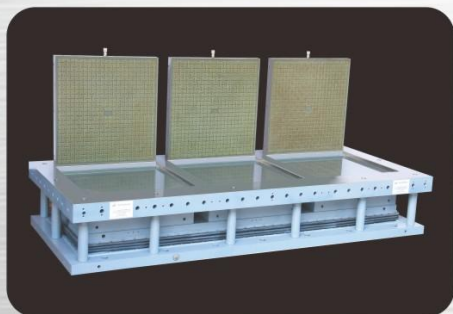
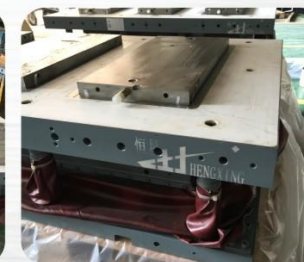
200*300—10W



320*320—6W

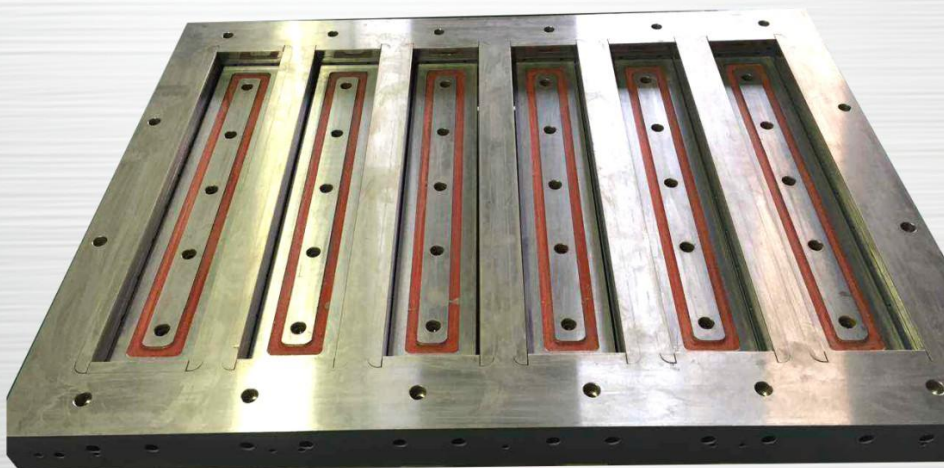


300*300—8W



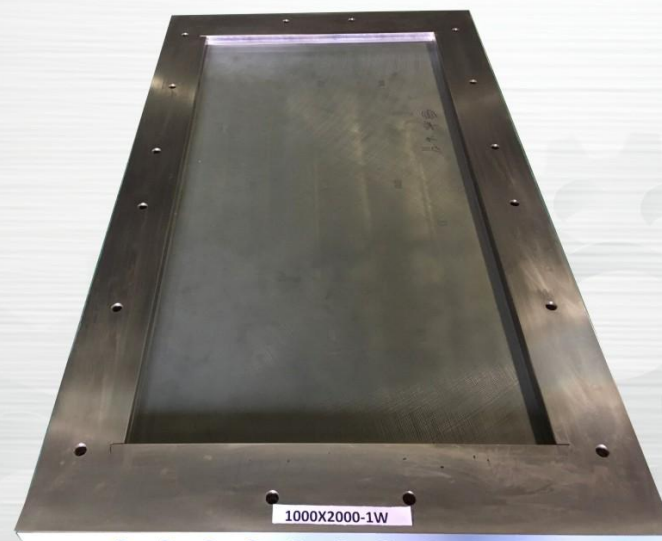
模具总成 Dieset

150X900-6W



模具总成 Dieset

1000X2000-1W



双浮动总成 Double floating mold



双浮动总成主要是解决压砖时面朝上（正打），与常规总成所不同的是它的刚性和紧密等特征，这使它更适用于大尺寸的产品。双浮动总成更值得关注的是其中液压回路使内部动作高度统一，防止了无法控制的磨损和变形。这种总成专用于生产一些精美砖或是生产不是很稳定的情况。

采用双浮动总成的优点如下：

1. 砖完全在上模框内成型，其与上下模芯紧密结合。
2. 实际上，上下侧板没有接触，这样可确保逐步并均匀地排气并防止有烂砖或开裂（甚至是很厚的砖，超过20mm）。
3. 可直接在压机上调节砖的厚度，调整范围可达5mm，上模框的返回速度，也就是活塞运动可以被这种设备上的特殊装置调整。
4. 从上模中出砖的过程中，砖没有经受任何压力，变化和下降一直在下模框上保持静止状态。

采用双浮动总成打砖产品特点：

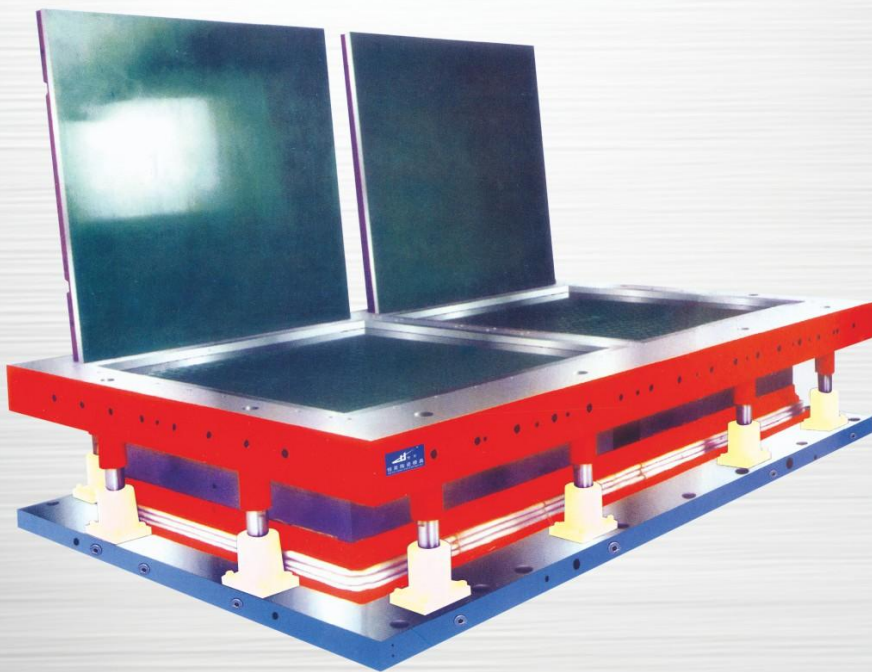
1. 砖表面光滑精美。
2. 完全消除磨损和划痕。
3. 压出的砖没有先前压砖时留下剩余物的压痕。
4. 可减少磨边余量5mm，节约了粉料。
5. 成形砖坯的尺寸上面小、下面大，只需一次磨边即可。
6. 压砖过程中不跑粉，并且可使用下等静压模芯，这样就可很好地解决了砖坯大小头、窄腰的问题。

Double floating mould with the advantages of rigidity and compactness compared with other normal molds, is mainly used to press the tiles on the front face, so they are more applicable to the large-sized tiles. Special attention should be paid to the hydraulic circuit which enables the uniform action of the internal parts, avoiding any uncontrollable abrasion or deformation. This mold is dedicated to the manufacture of luxurious tiles or to the unstable productive situation.

The advantages of double floating system are as follows:

1. The tile is formed completely inside the upper frame, where it is compacted between the two punches.
2. The fact that there is no contact between the upper and lower liners ensures gradual and uniform exhaust, preventing from any damaging or cracking (even though for the tiles as thick as more than 20mm).
3. It's possible to adjust, in the range of 5mm, the thickness of the tile by direct operation on the press.
4. During ejection from the upper cavity, the tile always keeps zero motion inside the lower frame without any outside stress, changing or descending.
5. Only one time of edge-grinding is needed because the tile's upper size is smaller while the lower bigger.
6. No powder would leak from the cavity and the lower isostatic punch is applicable to this mould, which can resolve the problems of any deformation or distortion.

下浮动总成 Lower Floating Mould



浮动总成的工作原理及特点：

浮动总成是一种在模框与模板之间配置数个液压油缸支柱且液压油路内藏的总成结构。

工作原理：

当上冲头下插入布满粉料的模腔内设定深度时，固定在上磁吸板上的限位块随行即顶住模框平面，迫使模框与上冲头同步下沉直至粉料被压成砖坯，即砖在被限位的型腔上部成型。此时上冲头，模框，下模芯夹着成型的砖坯同步上浮，模框到位停止，砖坯被下模芯顶出模腔，上冲头继续上行到终点。

特点：

1. 砖坯在型腔上部成型，由上、下模芯夹住砖坯出模腔，顶出行程短。在随着封闭型腔上浮的过程中成型砖坯依然受着压力，其泥料间的粘合力大大增加，从而提高了砖坯的整体强度和边部的成型效果。
2. 增大型腔下部的定位的下排气通道，缩小排气回程，冲压频率可相应提高。
3. 由于上冲头的定位和下排气通道的增大，减小了上下模芯刃口的侧板的磨损，延长了模具的使用周期。

Operating principle and characteristics of the floating die set:

The floating mould is in the form of assembly structure where several hydraulic pillars are installed between the mould frame and mould plate, and the hydraulic oil circuit is hidden inside.

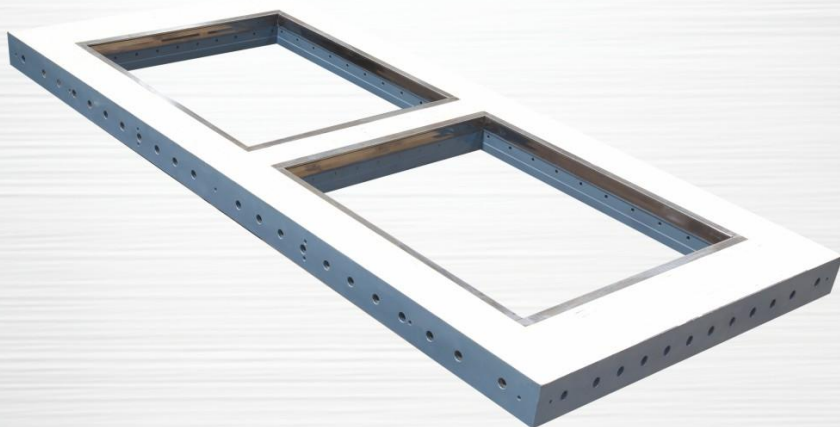
Operating principle:

When the upper punch falls into the cavity filled with earth powder to a preset depth, the mechanical limit unit fixed at the upper magnetic plate would resist against the mould frame so as to force the frame and upper punch descend together until the powder has been pressed into a piece of green tile, which means that the tile is formed inside the upper part of the cavity. Then the upper punch, frame and lower punch will rise up together with the green tile which will then be ejected out by the lower punch after the frame stops, but the upper punch will continue to ascend to the terminal.

Characteristics:

1. The green tile is formed in the upper part of the cavity and then ejected out of the frame by upper & lower punches, which indicates the ejection journey is short. In the floating process of the closed cavity the strengthened and its edges improved.
2. The exhaust passages at the lower part of the cavity would be enlarged and the exhaust return journey be shortened so that the pressing frequency is accordingly increased.
3. The wear-out of the edges of upper & lower punches as well as the liners would be decreased and the life span of the mould be lengthened because of the positioning of upper punch and enlargement of exhaust passage.

耐磨模框 Wear-resistant Frame



模框使用耐磨板材料：

模框侧板通常用耐磨硬质合金制造，经久耐用，可达到冲压数百万次以上无磨损，但是模框表面可达不到这个标准。在使用一段时间后，模框表面会出现凹凸不平的现象。造成砖坯质量不同程度的降低，针对这种问题，恒星公司的技术部门，经反复试验，终于总结出一种方法，用一种超耐磨，高分子材料，配以超强粘合剂，将其固定在模框表面。这种方法能达到模框连续冲压数百万次无磨损的效果。从而大大节约换模时间，减小停机次数，达到提高生产效率的目的。

Wear-resisting material adopted for the frame:

The liners are always made of carbide that is hard and strong, so that it can be used for pressing for more than million times without any abrasion. But the surface of the frame, not as strong as that, would be damaged after a period of using, which would degrade the quality of green tile. Regard to this problem, Heng Xing Company, through repeated and numerous experiments, has finally concluded a solution: we use a kind of ultra-wear-resisting and high-molecular material to fix, stuck by a super bond, on the surface of the frame. This solution enables the frame to be used for millions of times without any abrasion or wear-out. As a result, the service time of the mould increases while the number of shut-down times reduces, achieving high efficiency.

合金侧板 Tungsten Liner

在侧板砖坯成形部位，采用高硬度耐磨合金制作，使其寿命大幅度提高，冲压次数可达300-400万次。



Wear-resisting carbide insert is adopted for the liners to greatly increase its service time, and it can be used for pressing for as many as 3,000,000-4,000,000 times.

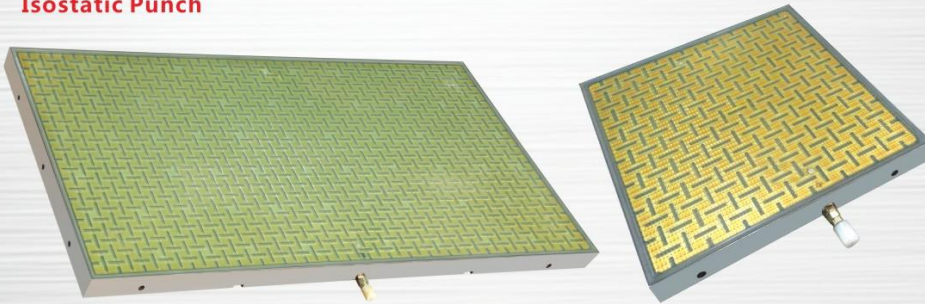


模芯介绍 PUNCHES Introduction

模芯介绍：等静压模芯，排气模芯，等静压排气模芯，镜面模芯，超薄胶模芯。

PUNCHES Introduction: Isostatic Punch, Exhaust Punch, Isostatic Exhaust Punch, Mirror Punch, Ultra-thin Rubber Punch

1. 等静压模芯 Isostatic Punch



油板式等静压模芯

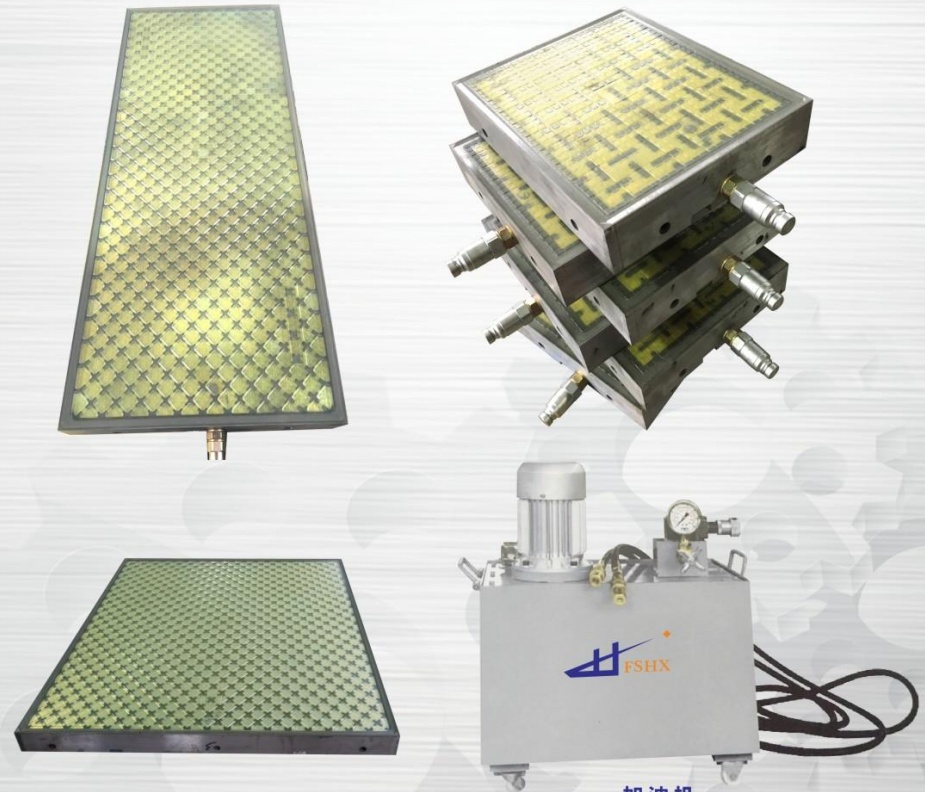
不同于其他公司的设计，独特内部设计，恒星专利产品，其主要特点：

1. 补偿效果明显，一般500*500mm仿古砖，釉面砖烧成尺码控制在0.6mm以内，玻化砖控制在0.7mm以内；
2. 砖底平整度好，底纹凹凸控制在0.25mm以内，并且可以跟任何形状，任何纹路的瓷砖底纹搭配，这是其他等静压模芯无法达到的。

Oil-Plate-Type Isostatic Punch

Heng Xing Isostatic punch has special inside structure, which is our company patent design. The main characteristic as below:

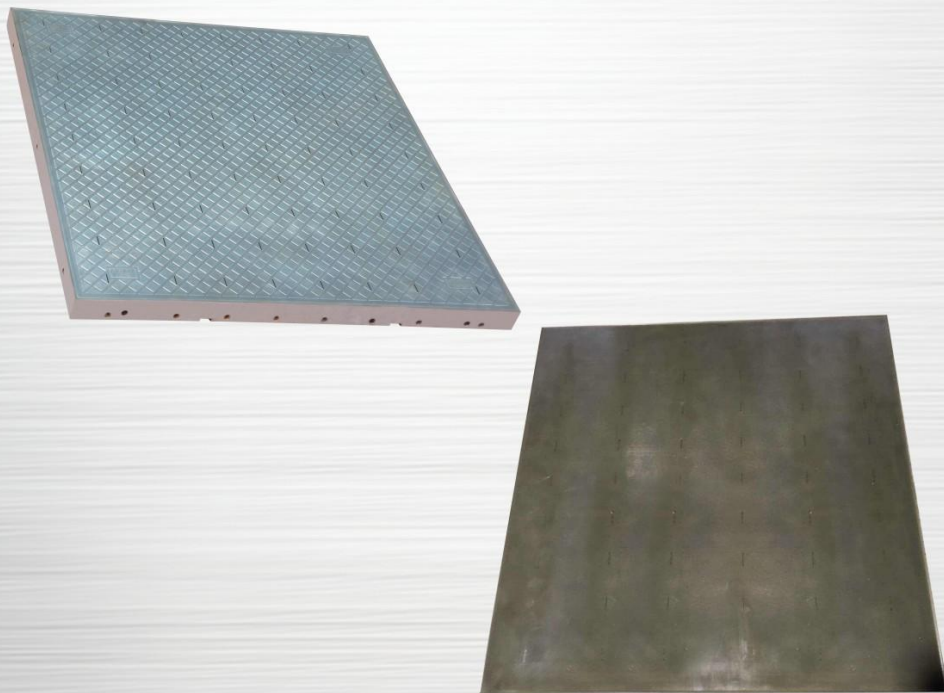
1. With its obviously compensation effect, take 500*500 mm size for example, the size after kiln can be controlled within 0.6 mm for Rustic tiles & Glazed tiles (Lappato, GVT), for Polishing tiles the size after kiln can be controlled within 0.7mm.
2. The flatness of the bottom of the tiles is very well, and the concave-convex of the shading can be controlled within 0.25mm, also it can be match with any design of shading of any tile. This is the characteristic which other isostatic pressing punch unreachable with.



加油机
Refueling Machine

模芯介绍 PUNCHES Introduction

2. 排气模芯 Exhaust Punch



排气模芯特点：

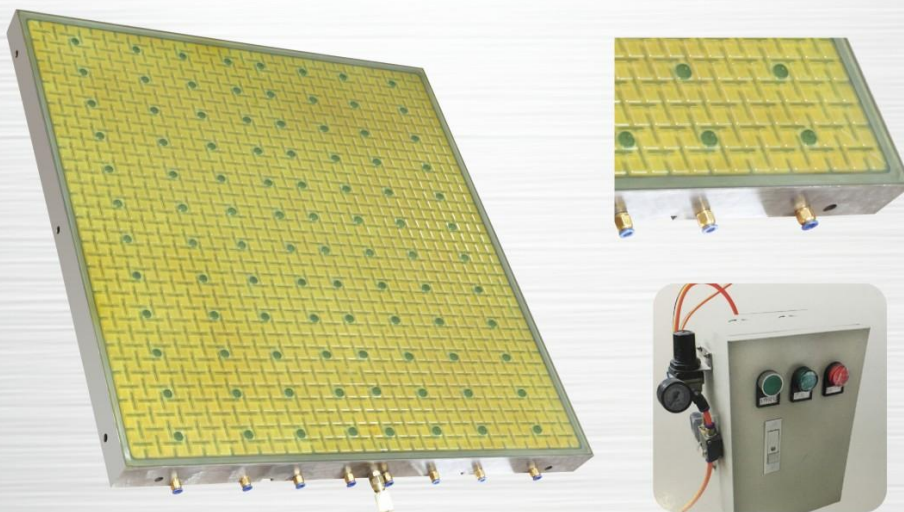
1. 可以完全消除砖坯的因排气不良产生的分层问题：针对厂家 粉料的情况在模芯的工作面部位，设有高效排气通道，从而提高成品成率。
2. 提高单机产量：由于排气模芯的特殊构造，可有效缩短压制砖坯时的排气时间和排气次数，从而提高单机产量。
3. 与其他模具厂同类产品不同之处：能达到排气不漏粉、不堵塞、不需安装吹气管，维修方便等特点。
4. 排气模芯分三种：
 - ①、微缝式排气模芯：适用于超微粉、颗粒、梦幻等抛光砖。
 - ②、等静压排气模芯：由于它的特殊结构，使它的特殊结构，使它可以保存等静压模芯的功能，同时又具备排气模芯效果。适用于一般耐磨砖、普通抛光砖、仿古砖等。
 - ③、微孔式排气模芯：主要适用于微粉渗花抛光砖及普通渗花抛光砖等。

Characteristics of Exhaust Punch:

1. This series of punches can totally solve the problem of cracking resulting from poor exhaust so that the rate of finished product is increasing in a big margin.
2. The individual output rises up owing to the special structure of the exhaust punch which may effectively shorten the exhaust time and reduce the number of exhaust times.
3. Compared with the same kind of products from other factories, our products have the advantages of no-leakage, no-blockage, no need to install blow pipe, easy maintenance, etc.
4. The exhaust punch is divided into three species as below:
 - Micro-slit-type exhaust punch: applicable to the ultra-micro powder polished tile, grain polished tile, fancy polished tile, etc.
 - Isostatic exhaust punch: its special structure grants it both the functions of isostatic punch and exhaust punch, applicable to the common abrasive tile, normal polished tile, rustic tile, and so on.
 - Micro-pore-type exhaust punch: mainly applicable to the micro-powder patterned polished tile and normal patterned polished tile.

模芯介绍 Punches Introduction

3.等静压排气模芯 Isostatic Exhaust Punch



等静压排气模芯

由于它的特殊结构，使它可以保存等静压模芯的功能，同时又具备排气模芯的效果。适用于一般耐磨砖、普通抛光砖、仿古砖等。

Isostatic Exhaust Punch

Isostatic exhaust punch ,one punch has two functions. One is isostatic function,the other is exhaust function .This punch could avoid the crack,lamination and also could make sure the tile body in the perfect condition.Its special structure grants it both the function of isostatic punch and exhaust punch,applicable to the common abrasive tiles,normal polished tile,rustic tile and so on.It is best for double charge tiles.

4.镜面模芯 Mirror Punch



镜面模芯:

镜面模芯特点：目前，部分专门生产高档抛光砖的企业，其坯本粉料的结构，越来越复杂。如加入熔块颗粒等形状不规则“块状”物体。常规胶面模芯已不能适应新的技术要求。经常会出现上模脱模时“块状”物挂在上模胶面上，造成砖坯表面产生深浅不一的小凹坑，导致砖坯质量下降。针对这种问题，我们设计出一种表面高光洁度的钢模芯。“镜面模芯”可使成型后的砖表面光滑及密度高等。

Mirror Punch:

At present,the composition and structure of the powder of the enterprises dedicated to high-level polished tiles is being more and more complicated,e.g.,some irregular articles are added into the powder.Therefore,the normal rubberized punch is no longer suitable for or applicable to the new technical process.It often happens that some irregular articles are stuck on the punch when removing the upper punch ,resulting in small holes on the surface of green tile.However,our company has designed and manufactured a brand new steel punch whose surface is as smooth and clear as mirror.The advantage of mirror punch is the formed tile is consequently intensified and its surface is very smooth and perfect.

模芯介绍 PUNCHES Introduction

5. 超薄胶模芯 Ultra-thin Rubber Punch



超薄胶模芯特点：

1. 模芯压胶之前“钢体表面经平面磨床加工”精磨之后其平整度达到0.03mm以内，然后在其表面压上一层厚度为0.2-0.25mm的高硬度胶面。
2. 以上技术克服了“镜面钢模芯”贴粉问题，同时又解决了“普通胶模芯”成型坯面粗糙问题，达到压制出来的砖坯表面平滑，光洁度高的特点。

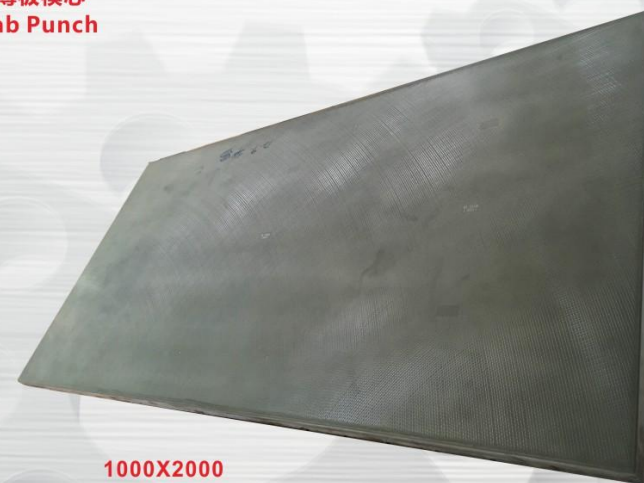
The Characteristics of Ultra-thin Rubber Punch:

1. The punch steel body surface had been processed by grinding machine before it has been taped. The flatness can be controlled within 0.03mm after this grinding processing. Then the surface of punch taped with high hardness colloid, and the thickness within 0.2-0.25mm.
2. Above technology not only had overcome the shortages such as sticking powder onto "punch with mirror surface" but also solved the shortages as "Ordinary Type Colloid Punch" which can cause the rough surface of brick after presser. So the Ultra-thin Colloid Punch has the characteristics for the brick with smooth surface and high fineness.

6. 普通下模芯 Normal Lower Punch



7. 超大型薄板模芯 Big Slab Punch



1000X2000

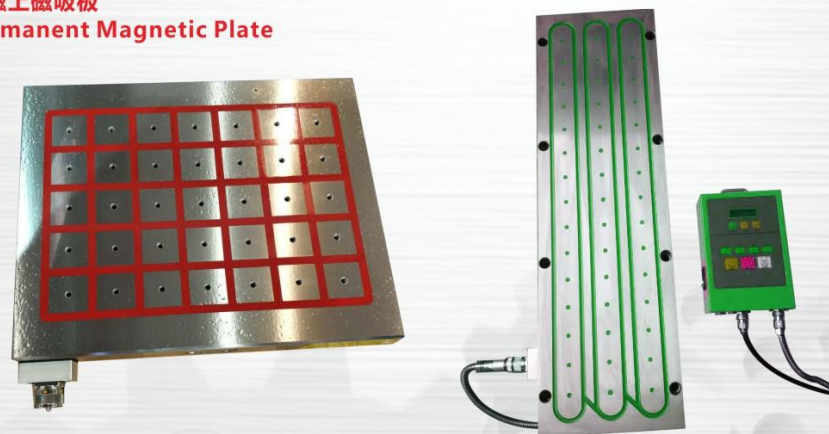
上磁吸板 Permanent Magnetic Plate

1. 普通电磁上磁吸板 Normal Electromagnetism Upper Plate



Power Supply Box.
磁电箱

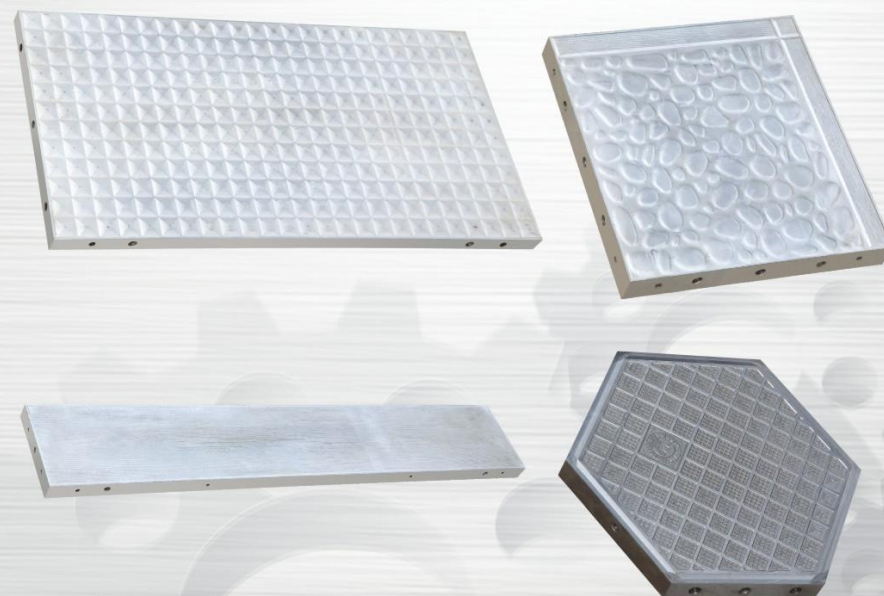
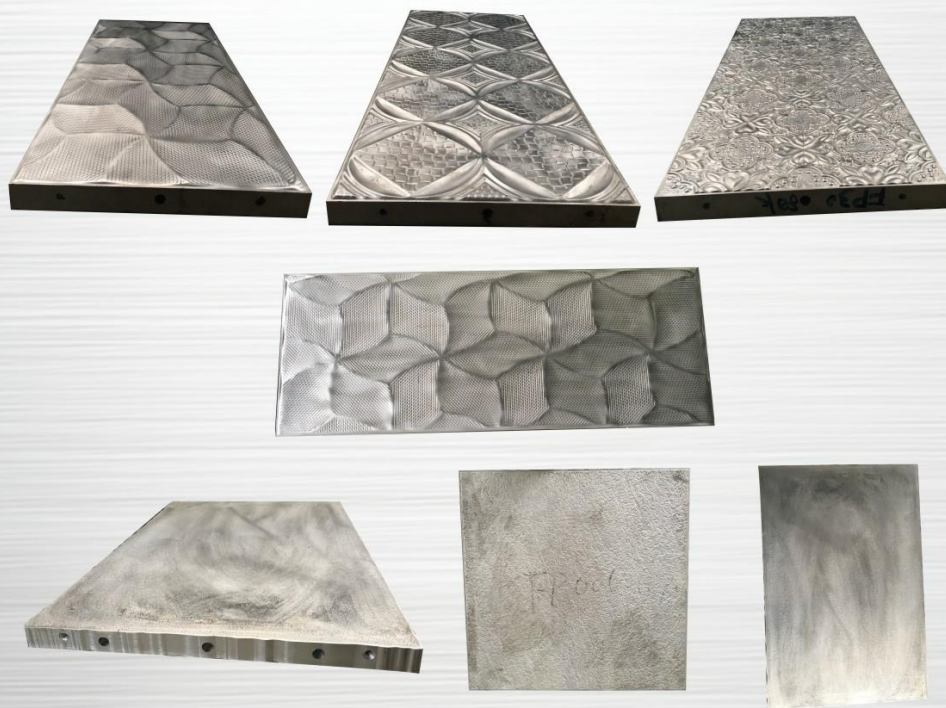
2. 永磁上磁吸板 Permanent Magnetic Plate



永磁上磁吸板，节能环保，操作稳定安全，磁吸力大；克服了普通上磁吸板需要长时间通电的缺点，操作简单，通磁、退磁只需按一下开关键即可；同时也解决了在生存过程中突然停电造成的生产暂停及安全隐患。从而使永磁上磁吸板具有安全性，经济性和实用性。

Permanent Magnetic Plate is energy saving, safe and stable operation, as well as the strong magnetism; This kind of design overcomes the shortage of the normal magnetic plate, which needs to be connected with electricity all the time. Also, it works simply, in-magnetizing and off-magnetizing are just pressing the switch button. Meanwhile, this advantage could solve the production stop problem when the power cuts suddenly and the safety problem. All those advantages make this permanent magnetic plate more safe, more economical and more practicable.

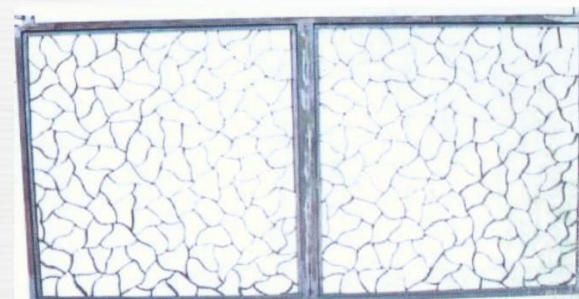
仿古母模设计 Rustic Master Moulds



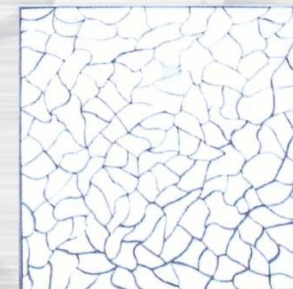
SMU、锁模块 SMU,Die Locker



格栅 Grid

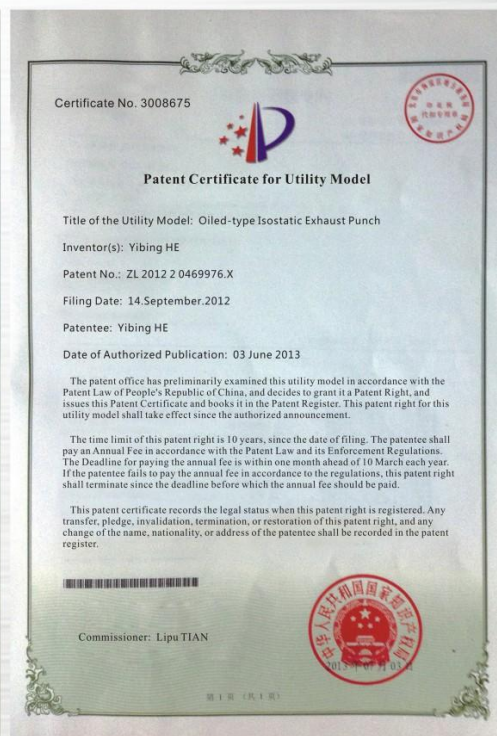
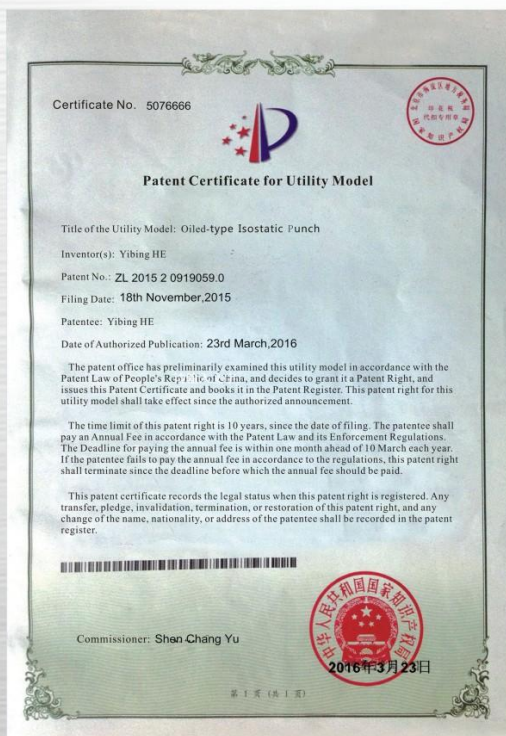


微粉砖格栅 Powder Grid



专利证书

Patent Certificates



车间机床设备

Work Shop Machines photos

