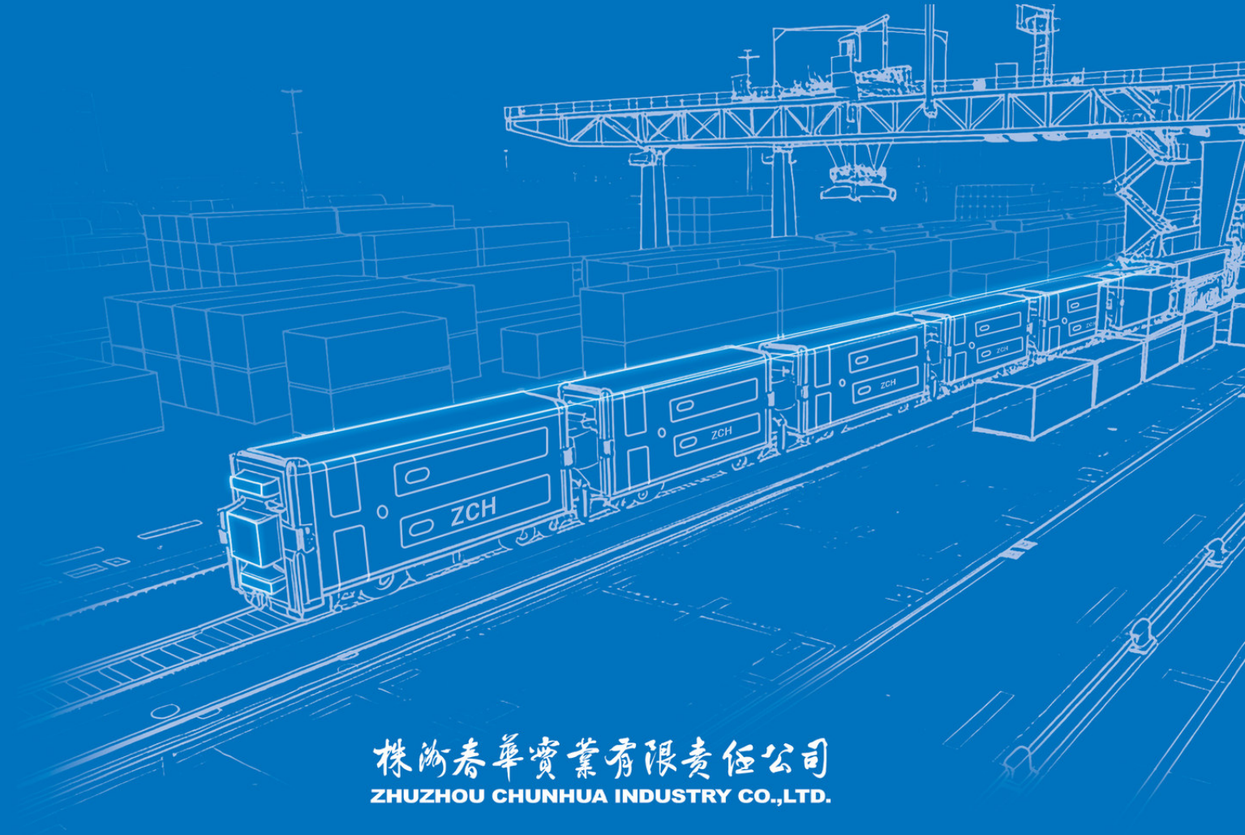
春華實業
CHUNHUA INDUSTRY

CHUNHUA

株洲春華實業有限責任公司
ZHUZHOU CHUNHUA INDUSTRY CO.,LTD.

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株洲春華實業有限責任公司
ZHUZHOU CHUNHUA INDUSTRY CO.,LTD.

企业文化

CORPORATE CULTURE

公司始终贯彻“以人为本

开拓创新，精益求精，顾客满意”的宗旨

The company has always adhered to the principle of putting people first

The aim of innovation, striving for excellence and customer satisfaction

春華實業 CHUNHUA INDUSTRY

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ZHUZHOU CHUNHUA INDUSTRY

COMPANY PROFILE
公司简介



株洲春华实业有限责任公司

株洲春华实业有限责任公司，前身为中国中车原株洲车辆厂锻冶分厂，2004年8月经改制成为非公有制企业，是中国国家铁路集团有限公司轨道交通车辆配件专业定点生产企业，国家“专精特新”小巨人企业，国家高新技术企业、省级技术中心企业、湖南省两型工业示范企业、“湖湘精品”试点企业、湖南省制造业重点产业链群重点企业、湖南省先进制造业重点培育关键零部件企业。

公司总部坐落于湖南省株洲市荷塘区金山工业园467号，现有控股株洲春华新能源装备有限责任公司、参股武汉华迈科畅钢结构有限责任公司，并设有锻业分公司。公司占地面积8万平方米，生产厂房面积3.6万平方米，员工近300人。公司通过了ISO9001、ISO14001、ISO45001三标体系认证、CRCC铁路产品认证，IATF16949体系认证、EN15085国际焊接体系认证和国家安全质量标准化三级考评。

公司主要生产轨道交通车辆配件、新能源液冷板、高原氧舱、锻铸件(含大型铝合金锻件)、冲压件、轨道智能检测监测系统、拉铆钉系列、新能源电驱桥独立悬架、铝合金搅拌摩擦产品、工程机械零部件等200多种产品。产品主要供应中国中车、中国兵器工业、中国船舶工业等下属企业，以及神华公司、铁建重工、中联重科和全国各铁路局等单位。

Zhuzhou Chunhua Industrial Co., Ltd., formerly the Forging & Smelting Branch of the former Zhuzhou Rolling Stock Factory under CRRC, was restructured into a non public owned enterprise in August 2004. It is a designated professional manufacturer of rail transit vehicle components for China State Railway Group Co., Ltd., a national “Specialized, Refined, Differential and Innovative” Little Giant Enterprise, a national high tech enterprise, a provincial level technical center enterprise, a Hunan Province Two Type Industry Demonstration Enterprise, a pilot enterprise for “Huxiang High Quality Products”, a key enterprise of Hunan Province’s major manufacturing industrial chains, and a key cultivated key component enterprise for Hunan Province’s advanced manufacturing industry.

The company’s headquarters is located at No. 467 Jinshan Industrial Park, Hetang District, Zhuzhou City, Hunan Province. It holds controlling stakes in Zhuzhou Chunhua New Energy Equipment Co., Ltd., has equity participation in Wuhan Huamaikechang Steel Structure Co., Ltd., and operates a Forging Branch. Covering a land area of 80,000 square meters, the company has a production plant area of 36,000 square meters and employs nearly 300 staff members. The company has obtained certifications including ISO9001, ISO14001 and ISO45001 triple system certification, CRCC railway product certification, IATF 16949 system certification, EN 15085 international welding system certification, and Level 3 assessment for national safety and quality standardization.

The company mainly manufactures more than 200 types of products, including rail transit vehicle components, new energy liquid cooled plates, plateau oxygen chambers, forgings and castings (including large size aluminum alloy forgings), stampings, intelligent rail inspection and monitoring systems, blind rivet series, new energy electric drive axles with independent suspension, aluminum alloy friction stir welding products, and construction machinery parts. Its products are supplied to subsidiaries of CRRC, China North Industries Group Corporation, China State Shipbuilding Corporation, as well as Shenhua Group, China Railway Construction Heavy Industry, Zoomlion, and railway bureaus nationwide.

HONORS AND QUALIFICATIONS

荣誉资质







TECHNOLOGY CENTER
技术中心

研发硬件设施完善
The hardware facilities for research and development are complete

研发管理体系健全
The R&D management system is sound

战略清晰研发创新
Clear strategy, research and development innovation

株洲春华实业有限责任公司技术中心成立于2005年，有强大的产品研发团队。在生产经营的过程中，建立了多个产品研发实验室，集理论研究、数据采集、产品研发与结论检验于一体，建立了完整的研发管理体系和激励机制，于2011年8月通过省级技术中心评定。公司技术力量雄厚，新产品开发能力强，曾先后完成了博茨瓦纳车、泰国车、阿联酋硫磺漏斗车、安哥拉棚车、澳大利亚MRL矿石漏斗车、巴西矿石敞车、塞拉利昂矿石漏斗车、沙特柴油罐车、香港工程平车等出口车型配件的生产制造任务。2024年公司荣获“湖南省科技进步二等奖”。

The Technical Center of Zhuzhou Chunhua Industrial Co., Ltd. was founded in 2005 with a strong product R&D team. During production and operation, multiple product R&D laboratories have been established, integrating theoretical research, data acquisition, product development and result verification. A complete R&D management system and incentive mechanism have been put in place. The center was approved as a Provincial-level Technical Center in August 2011. Boasting robust technical strength and strong new product development capability, the company has successively completed manufacturing of components for export rolling stock, including Botswana wagons, Thailand wagons, UAE sulphur hopper wagons, Angola covered wagons, Australia MRL ore hopper wagons, Brazil open-top ore wagons, Sierra Leone ore hopper wagons, Saudi diesel tank wagons and Hong Kong engineering flat wagons. In 2024, the company won the Second Prize of Hunan Provincial Science and Technology Progress Award.

专业技术人才 TECHNICAL TALENT

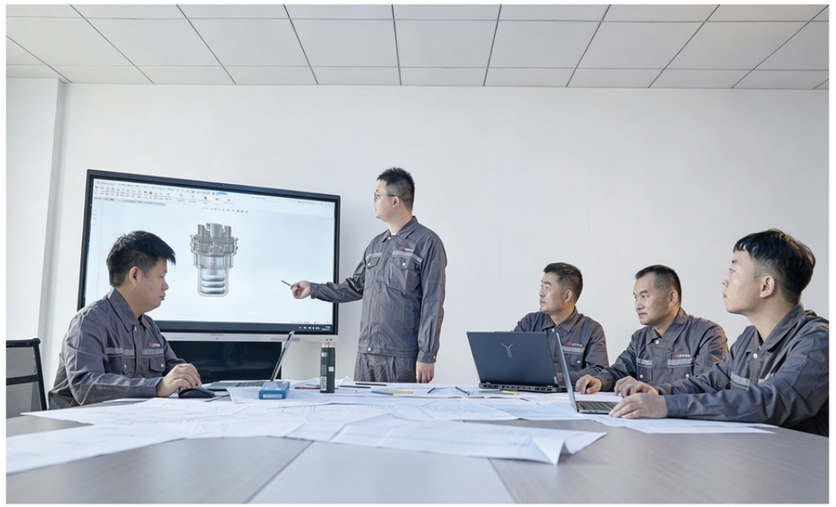
研发人员55人，占总人数的18% 其中高级工程师 8人， 工程师20人 ， 助理工程师27人 ，外聘高校和科研院所的知名专家教授2人。

The company has 55 R&D personnel, accounting for 18% of the total workforce. Among them are 8 senior engineers, 20 engineers and 27 assistant engineers, plus 2 renowned professors and experts externally engaged from universities and research institutes.

8
高级工程师
Senior Engineer

55
专业研发人员
R&d personnel

2
知名专家教授
Experts professors









FORGED PARTS

锻压件系列

生产设备 EQUIPMENT

公司现有各型锻压设备**60余台套**，锻件年**生产能力为16000t**，单件模锻最大加工能力为**300kg**，单件自由锻件最大加工能力为**400kg**。

The company currently has over 60 sets of various forging and pressing equipment. Among them, The company's annual production capacity of forgings is 16,000 tons, with a maximum processing capacity of 300 kilograms for single die forgings and 400 kilograms for single free forgings.



5000t/2500t双动压力自动生产线

5000t/2500t Double-Action Automatic Press Production Line

最大装模尺寸：4000x4700；最大压力：5000t；最大压边力：2500t。主要用于直径2000-3800mm各种封头的整体冷、热拉伸成形，大型压型件的冷、热压成形。

Maximum mold installation size: 4000x4700; Maximum pressure: 5000t Maximum blank holder force: 2,500 tons. It is mainly used for the overall cold and hot stretching forming of various heads with diameters ranging from 2000 to 3800mm, as well as the cold and hot pressing forming of large profiled parts.

80000kN摩擦压力机

80000kN friction press

工作台尺寸：1300*2136mm	Workbench size: 1300*2136mm
滑块行程：800mm	Slider stroke: 800mm
锻件重量：30-300kg	Forging weight: 30-300kg





1600T电动螺旋压力生产线

1600T Electric Screw Press Production Line

公称力：16000kN	Nominal Force: 16000kN
允许打击力：25000kN	Allowable strike force: 25000kN
运动部分能量：290KJ	Motion part energy: 290KJ
滑块行程：650mm	Ram Sttroke: 650mm
行程次数：15min^{-1}	No. of Stroke: 15min^{-1}

主要产品 MAIN PRODUCTS



锻造钩舌
Forging hook tongue



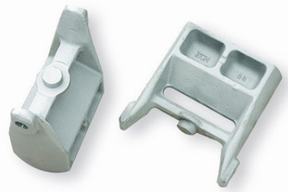
封头
Capped end



锻造摇动座
Rocking seat



柔性对角连接杆
Flexible diagonal connecting rod



中心楔块
Center wedge



丛板
Plexus plate



铝合金锻件
Aluminum alloy forging



摇动座支承
The wearing plate



轴承盖
Bearing Cover



19寸刀毂
19-inch Tool Hub

BLIND RIVET SERIES

拉铆钉系列

生产设备 EQUIPMENT

公司现有拉铆钉生产设备**8台套**，其中两台多工位冷镦机采用**国际领先的高速冷镦成形技术**，生产能力为Φ5至Φ45尺寸区间各型拉铆钉（拉锦销）及其配套使用的各型套环。

The company owns 8 sets of blind rivet production equipment. Among them, two multi-station cold heading machines adopt the internationally leading high-speed cold heading forming technology, with a production capacity of various types of blind rivets (riveting pins) and their matching rings in the size range of Φ5 to Φ45.



CBF-254S型多工位冷镦螺栓成型机

CBF-254S multi-station cold heading bolt forming machine

最大镦锻坯料：Φ26x175mm
Maximum upsetting billet: Φ26x175mm

镦锻速度：40-60件/分钟
Upsetting speed: 40-60 pieces per minute

最大镦锻力：4300kN
Maximum upsetting force: 4300kN

YW-C-NF41B6S型高速冷镦螺帽成型机

YW-C-NF41B6S high-speed cold forged nut molding machine

最大镦锻坯料：Φ45x75mm
Maximum upsetting billet: Φ45x75mm

镦锻速度：60-90件/分钟
Upsetting speed: 60-90 pieces per minute

最大镦锻力：4500kN
Maximum upsetting force: 4500kN





CPR-25LL搓丝机
CPR-25LL Thread rolling machine



GST-680网带式托辊型淬火炉生产线
GST-680 Roller belt quenching furnace

主要产品 MAIN PRODUCTS





T12型拉铆钉及套环
T12 type rivet and the ring



T16型拉铆钉及套环
T16 type rivet and the ring



T22型拉铆钉及套环
T22 type rivet and the ring



短尾铆钉及套环
Short tailed rivet and collar



BOM钉及套环
BOM Rivet & Sleeve Series



圆头铆钉及套环
Round head rivets and collar

产品系列 Product series	型号 Model				
拉铆钉及套环系列 Rivets and ring series	LMY-T12-6	LMY-T16-12	LMY-T20-31	LMY-T22-24	LMTF-T12G
	LMY-T12-12	LMY-T16-18	LMY-T20-37	LMY-T22-31	LMTF-T16G
	LMY-T12-18	LMY-T16-24	LMY-T20-44	LMY-T22-37	LMTP-T2OG
		LMY-T16-31		LMY-T22-44	LMTP-T22G
短尾铆钉及套环系列 Short tail rivets and ring series	LMDY-T12系列	LMDY-T16系列			
	LMDY-T12-10	LMDY-T16-10	LMDY-T16-25	LMDY-T16-40	LMDTF-T12G
	LMDY-T12-15	LMDY-T16-15	LMDY-T16-30		LMDTF-T16G
	LMDY-T12-25	LMDY-T16-20	LMDY-T16-35		
BOM钉及套环系列 BOM Rivet & Sleeve Series	LMB-T16-19	LMB-T16-12			

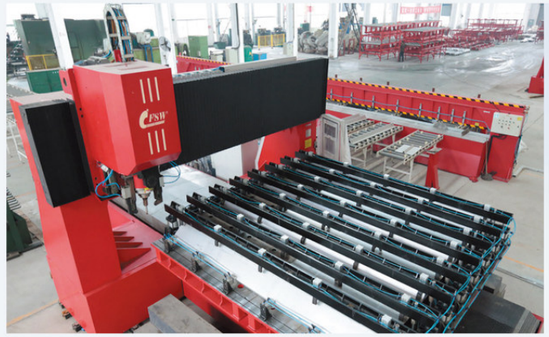
ALUMINUM ALLOY

铝合金系列

生产设备 EQUIPMENT

搅拌摩擦焊设备采用**国内外最先进**的水平立焊式摩擦焊系统和二维定梁式搅拌摩擦焊系统，配套设备为国内先进的铝合金型材专用切割设备。

The friction stir welding equipment adopts the most advanced horizontal vertical friction welding system and two-dimensional fixed beam friction stir welding system at home and abroad. The supporting equipment is the advanced domestic special cutting equipment for aluminum alloy profiles.



FSW-LM-25二维定梁龙门式搅拌摩擦焊系统

FSW-LM-25 longmen type friction stir welding system with two dimensional fixed beam

零件焊接形式：直线焊缝、平面曲线焊缝
Welding forms of parts: straight weld seams, planar curve weld seams

焊接厚度：2-25mm
Welding thickness: 2-25mm

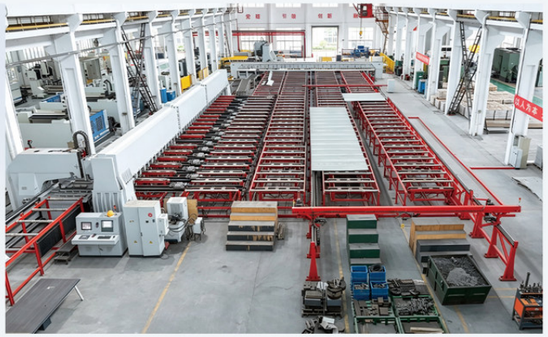
最大焊程：4000x4000mm
Maximum weld stroke: 4000x4000mm

FSW-4LH-4012水平立焊式搅拌摩擦焊系统

FSW-4LH-4012 horizontal vertical welding type friction stir welding system

焊接厚度(双面焊接)：2-12mm；焊程：21000mm；焊接型材宽度：900mm；焊接型材最大高度：220mm；立柱跨度：21600mm；XYZ轴定位精度：0.3mm/5m

Welding thickness (double-sided welding) : 2-12mm; Welding distance: 21000mm Welded profile width: 900mm; Maximum height of welded profiles: 220mm; Column span: 21600mm; XYZ axis positioning accuracy: 0.3mm/5m





铝合金型材专用切割设备

Special cutting equipment for aluminium alloy profile

最大单面切割厚度：200mm
Maximum single-sided cutting thickness: 200mm

切割长度：15000mm
Cutting length: 15,000mm

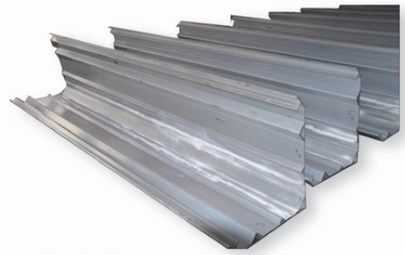
切割精度：1/10000
Cutting accuracy: 1/10000

各轴行程：X:15500、S:±N x 360°
Stroke of each axis: X:15500, S:±N x 360°

主要产品 MAIN PRODUCTS



侧墙版
Side wall plate



漏斗脊
Funnel ridge



搅拌摩擦焊板
Friction-Stir Welded plate



搅拌摩擦焊板
Friction-Stir Welded plate



液冷板
Liquid Cold Plate



轨交液冷箱体
Rail-transit Liquid-Cooled Enclosure

STRUCTURAL COMPONENTS

结构件系列

● 生产设备 EQUIPMENT



激光切管机

Laser Tube Cutting Machine



激光切板机

Laser Sheet Cutting Machine



激光自动焊接工作站

Automatic Laser Welding Workstation



CMT机器人焊接工作站

CMT Robotic Welding Workstation

● 主要产品 MAIN PRODUCTS



高原睡眠舱

Plateau Oxygen Supplied Sleep Cabin



高原氧舱

Plateau Oxygen Chamber



新能源电驱桥独立悬架

New Energy Electric Drive Axle with Independent Suspension

KEY COMPONENTS OF RAIL TRANSIT

轨道交通关键零部件系列

生产设备 EQUIPMENT



缓冲器组装线
Buffers assembly line



手制动机组装线
Hand brake unit assembly line



大功率手制动机试验台
High power hand brake

主要产品 MAIN PRODUCTS



HM-1型缓冲器
HM-1 type buffer



MT-2型缓冲器
MT-2 type buffer



MT-3型缓冲器
MT-3 type buffer



新型试验缓冲器
New type test buffer



短尾缓冲器
Short tail buffer



NSW-1型手制动机
NSW-1 type hand brake



FMG手制动机
FMG hand brake

LIQUID COOLING PLATE MACHINING CLUSTER

液冷板加工设备集群

生产设备 EQUIPMENT

钎焊生产线是一套集成化连续式自动化焊接成套装备，主要用于液冷板、铝合金组件、换热器等工件的精密钎焊加工。

The brazing production line is an integrated continuous type automatic welding complete equipment, which is mainly used for precision brazing of workpieces such as liquid cooling plates, aluminum alloy assemblies and heat exchangers.



自动化钎焊线 Automated brazing line



加工中心设备集群
Machining Center Equipment Cluster



自动化喷涂线
Automatic Spraying Line

研发平台及试验检测设备

DEVELOPMENT PLATFORM AND TEST& INSPECTION EQUIPMENT

公司为**省级企业技术中心企业**，能独立完成各种技术创新和产品研发活动。目前有原值**6000万元**的试验、检测设备**20余台**。

The company is recognized as a Provincial Enterprise Technology Center and can independently carry out various technological innovation and product R&D activities. It currently has more than 20 sets of test and inspection equipment with an original value of 60 million yuan.



缓冲器冲击试验线
Buffer impact test line



冲击试验基地
Impact test base

本试验线主要用于铁道车辆缓冲器性能数据采集、试验、检测和评定，适用于铁道车辆冲击试验、车钩及缓冲器性能试验、各种货物装车冲击试验、货物包装及加固试验、零部件抗冲击震动和强度试验、车辆溜放阻力试验等。

This test line is mainly used for the collection of performance data of railway vehicle buffers, testing, inspection and evaluation. It is applicable to railway vehicle impact tests, coupler and buffer performance tests, various cargo loading impact tests, cargo packaging and reinforcement tests, component shock and vibration resistance and strength tests, vehicle roll resistance tests, etc.



X射线数学成像检测
X-ray Digital Radiography System



水密检测设备
Watertightness Test Equipment



气密检测设备
Air tightness Test Equipment



绝缘检测设备
Insulation Test Equipment



真空箱氦检漏回收系统
Vacuum Chamber Helium Leak Detection & Recovery System



光谱分析仪
Spectrometer



循环试验机
Cycle testing machine



材料试验机
Material testing machine



落锤试验机
Drop testing machine



三坐标检测设备
Three-coordinate measurement

AFTER-SALES SERVICE

品质服务 售后无忧



01 在客户正常使用和维护的前提下，各产品按照其保修期进行维护。

02 在保质期内正常使用出现的质量问题，公司**免费维修**和更换已损部件，针对保质期外出现的问题，公司实行**终身维修服务**。

03 公司在接到客户对配件的需求信息并确认后，**充分满足客户需求**，同时公司的售后服务工程师做专门的售后服务；

01 Under the premise of normal use and maintenance by the customer, each product will be maintained in accordance with its warranty period.

02 For quality problems that occur during normal use within the warranty period, the company will provide free repair and replacement of damaged parts. For problems that occur outside the warranty period, the company offers lifetime maintenance services.

03 Upon receiving and confirming customers' demand for spare parts, the company will fully meet customer requirements. Meanwhile, the company's after sales engineers will provide dedicated after sales services.

SERVE CUSTOMERS

服务客户

目前，公司客户单位有：中国中车、中国兵器工业、中国船舶工业等下属企业，以及神华公司、铁建重工、中联重科和全国各铁路局等单位。

At present, the company's customers include subsidiaries of CRRC, China North Industries Group Corporation, China State Shipbuilding Corporation, as well as Shenhua Group, China Railway Construction Heavy Industry, Zoomlion, and railway bureaus nationwide.

