

Automatic CNC

CNC自動全張鐵皮送料沖床

Automatic CNC Sheet Feeding Press

S-B23BH+S-B86B+
S-B85SA+S-B85ST

CE
available

ISO 9001
BSMI
REGISTERED



兩片罐身
Two Piece Can



Shin-I
新 益
SINCE 1956

新益機械工廠股份有限公司
SHIN-I MACHINERY WORKS CO., LTD.

CNC自動全張鐵皮送料沖床(兩片罐身)

Automatic CNC Sheet Feeding Press (for two piece can)

此套CNC全張鐵鋁皮送料沖床為四軸同步運動之現代化兩片罐用生產系統，第一台沖床S-B85SA執行第一工程沖杯，第二台沖床S-B85ST執行第二工程引伸及修邊，採用精密線性伺服馬達、運動控制系統及觸控式人機介面，PLC控制系統，可程式控制整合料片交接系統，使送料精準確實，安全可靠。此系統實為高速兩片罐生產線之最佳選擇。

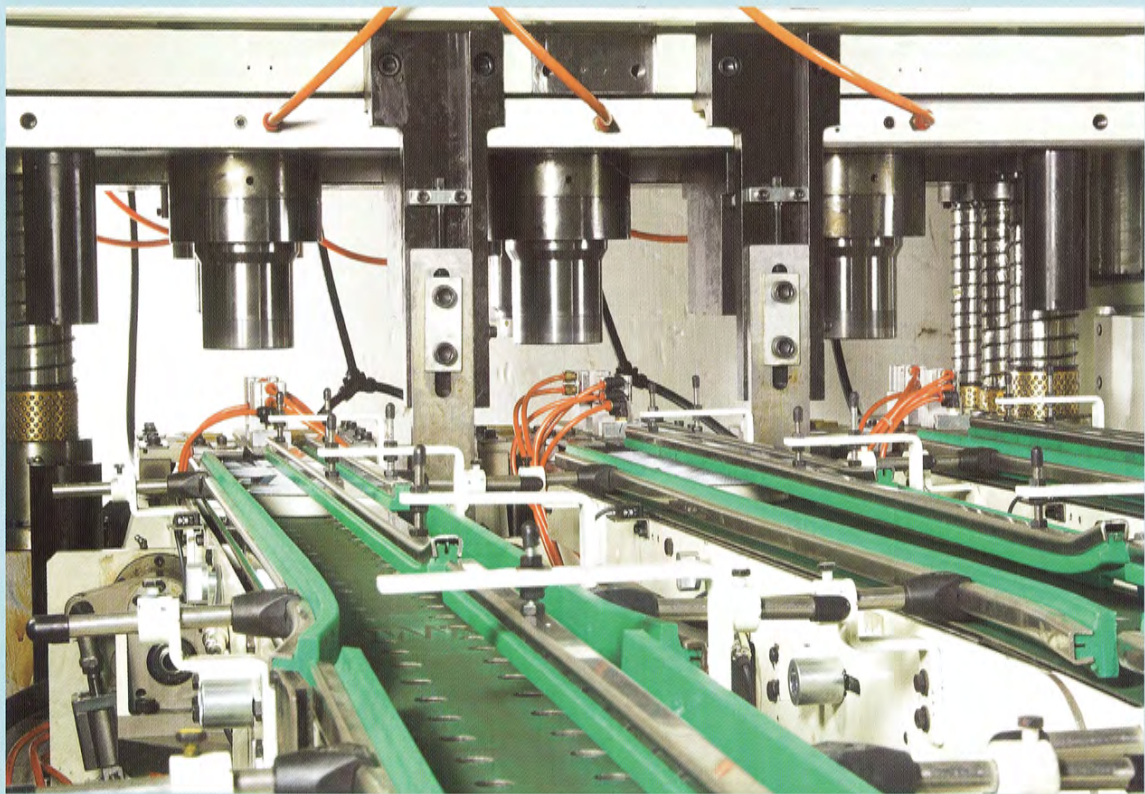
This CNC sheet feeding press equipped with four axis synchronized movement is suitable for tin or aluminum two piece can making. First press S-B85SA undertakes 1st drawing process while second press S-B85ST fulfill 2nd drawing process as well as trimming process. Precise linear servo motors with touchable Human-Machine Interface system and PLC control system are incorporated. Programmable integrated sheet take-over system can get precise sheet feeding to make this system the best choice for two piece can making.



S-B86B 送料台及送料四軸
Sheet Feeding Table and Four Axis

特點

- 1.採用精密線性伺服馬達、運動控制系統及觸控式人機介面。
- 2.送料運動曲線自動產生及傳輸下載，換型參數設定容易。
- 3.採用穩定性高之精密線性伺服馬達，降低高速運動時產生之慣性。配有自動偵測超溫、超速及超極限位置停車控制，安全可靠。並配備水冷式冷卻機降低馬達溫度。
- 4.自動檢核產生之運動曲線是否超出各軸之能力範圍，安全保證。
- 5.附電眼偵測送料夾是否確實夾料及夾罐爪是否確實夾罐。
- 6.多重安全控制，如氣壓不足、無油、馬達過載、出口卡罐等停機控制及各軸極限安全防護。
- 7.配備空氣離合器，確實可靠。
- 8.導柱式沖模可由沖床側向推入(S-B85SA)，換型快速。
- 9.排罐控制時序採用電子凸輪調整，以防止雙沖。
- 10.曲柄軸軸襯及滑塊導桿軸襯採用自動機油循環潤滑系統並配有油溫冷卻機。
- 11.沖床上方配備滑塊緩衝氣缸平衡滑塊及模具重量。
- 12.適用於直邊或預波鐵鋁皮。
- 13.第二工程引伸為順沖及逆沖均可。



S-B85ST 入口
Entrance of **S-B85ST**

Features

1. With reliable precise linear servo motors and human-machine interface (touchable screen).
2. Movement orbit generate and download automatically, easy for different end size parameters set up.
3. With reliable precise linear servo motors to reduce the inertia at high speed. In addition, automatic detection device for over temperature, speed and over limit position is introduced to guarantee safety. Moreover, a water cooling system is incorporated to control the linear servo motor temperature.
4. Created movement orbit is confirmed automatically to ensure if it is within the safety range on each axis.
5. Equipped with sensors to detect if the clips or claws certainly hold the sheet or can.
6. Multiple safety control : for example , machine stop for low air pressure 、lack of oil 、jam at exit. Moreover, safety range detection on each axis is equipped.
7. Equipped with air brake clutch, safe and reliable.
8. Tooling with pillar die set can be easily pushed into via rollers buried on bolster (for S-B85SA).
9. Can ejection is controlled by electronic cam adjustment to avoid double punch.
10. Bushes on crankshaft and ram guiding posts are properly lubricated by recycling oil driven by an automatic oil pump. An oil cooler is used for temperature control.
11. Two sets of air cushion cylinders located at press upper side to balance the weight of rams and toolings.
12. Suitable for straight or pre-scrolled tin /aluminum sheet.
13. Suitable for redraw or reverse-draw on second drawing operation.



送料夾及1st引伸沖模
Sheet Clips and 1st Drawing Tooling



S-B85SA 出口
Outlet of S-B85SA

動作原理

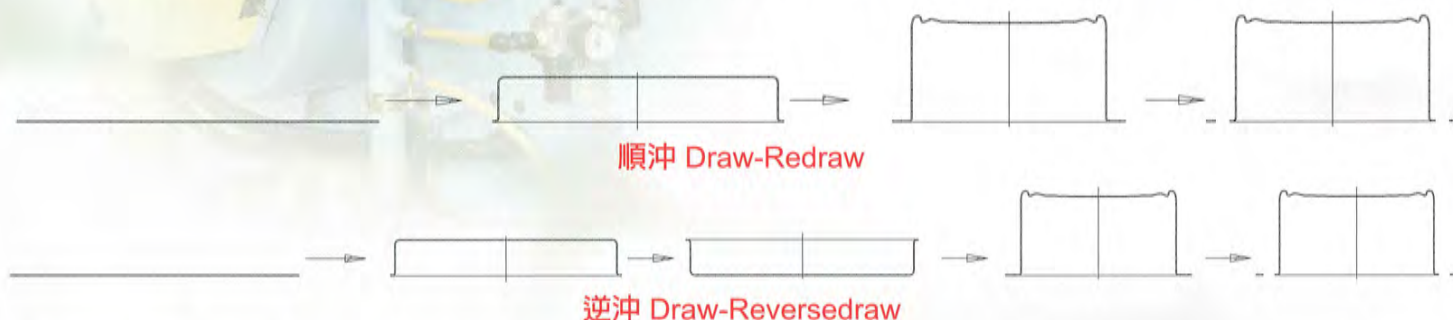
鐵鋁皮於送料機S-B23BH經分離器分離後由真空吸盤送入CNC送料機S-B86B，經由吸盤及導軌導正後由X2及Y2軸將料片送至沖床沖罐杯，待X1及Y1軸後退後由四軸同步送料同時由X2及Y2軸將料片交由X1及Y1軸負責後續送料工作，X2及Y2軸後退至送料機出口端夾新材料片，料片連續供應過程中沖床無空沖。由第一台沖床S-B85SA沖製好之罐杯由高壓空氣自沖模處排出後由輸送機帶出進入第二台沖床S-B85ST，鐵鋁皮廢料由滾輪排出。罐杯由尼龍及橡膠材質之夾爪送入S-B85ST執行第二工程引伸及修邊。修邊好之罐身及廢料由高壓空氣自沖模處排出後由輸送機帶出。

規格 Specification

機型 MACHINE TYPE	S-B23BH	S-B86B
適用罐徑 Range of can size	圓罐 202 D ~ 401 D (max 60 mm H), 長形矮罐	
沖模模數 Number of tooling set	2 ~ 4 sets depend on can size	
每分鐘產能 Capacity per min	80 ~ 115 strokes / min.	
適用鐵鋁皮尺寸 Sheet Size range	(700~1067 mm)	
沖床噸數及行程 Press tonnage and stroke	X	
需要馬力 Horse power required	1 3/4 HP	total 60 HP for four axis
滑塊面積 Area of ram	X	
台盤面積 Area of bolster	X	
最大閉模高 Max die shut height	X	
安裝面積及高度 Floor space overall height	2820 L x 2120 W x 2250 H mm	3730 L x 3270 W x 2910 H mm
淨重 Net weight (approx)	2700 Kgs	3400 Kgs

註：規格如有變更，恕不另通知 Subject to change without notice.

實際產能依罐身尺寸而定 Actual capacity depends on can size.

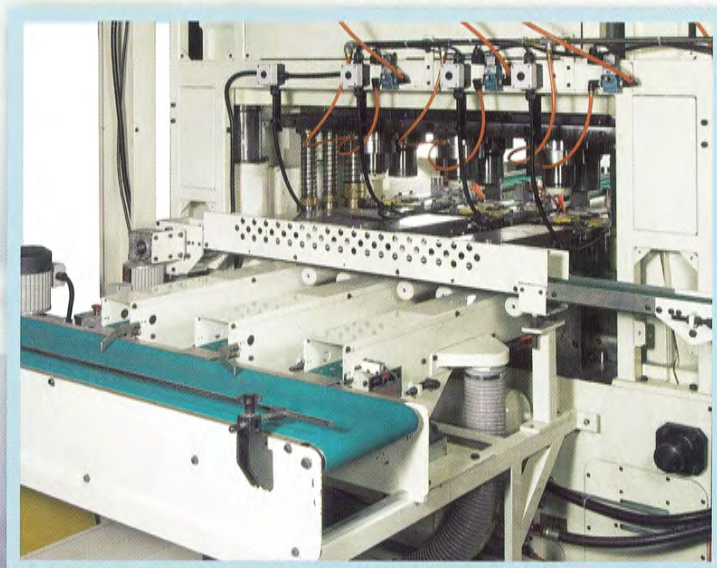


Working Principle

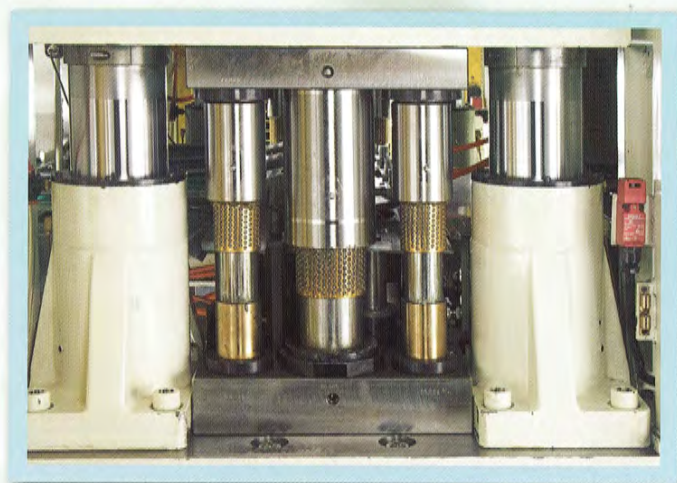
On the sheet feeder S-B23BH sheet is separated by a separating device then is fed by vacuum pads into CNC feeding unit S-B86B. Sheet is positioned well by a suction pad and a side guide then X2 and Y2 axis clip the sheet and move the sheet to the first press S-B85SA to stamp cup. When X2 and Y2 axis withdraw, four axis undertake sheet feeding at the same time. At this moment, X1 and Y1 take over the sheet for following stamping, X2 and Y2 withdraw back to clip a new sheet. Cups are ejected out by air blowing and carried away by conveyors, sheet scraps are ejected by rollers. Cups are transferred to the second press S-B85ST by conveyors and carried into drawing and trimming tooling by claws made of nylon or rubber. Trimmed cans and trimmed scraps are ejected out by air blowing and carried away by conveyors

S-B85SA	S-B85ST
罐 Club Can、Dingley Can, 橢圓罐 Oval Can	
ding on can size	
depending on can size	
W x 1067 mm L	
110 ton / 150 mm	110 ton / 180 mm
30 HP x 4 P	30 HP x 4 P
1350 x 380 mm ²	1380 x 550 mm ²
1350 x 380 mm ²	1380 x 550 mm ²
400 mm	600 mm
2125 L x 2935 W x 2855 H mm	2150 L x 3120 W x 3355 H mm
12500 Kgs	15700 Kgs

精準 Precision
確實 Certainty



S-B85ST 出口
Outlet of S-B85ST

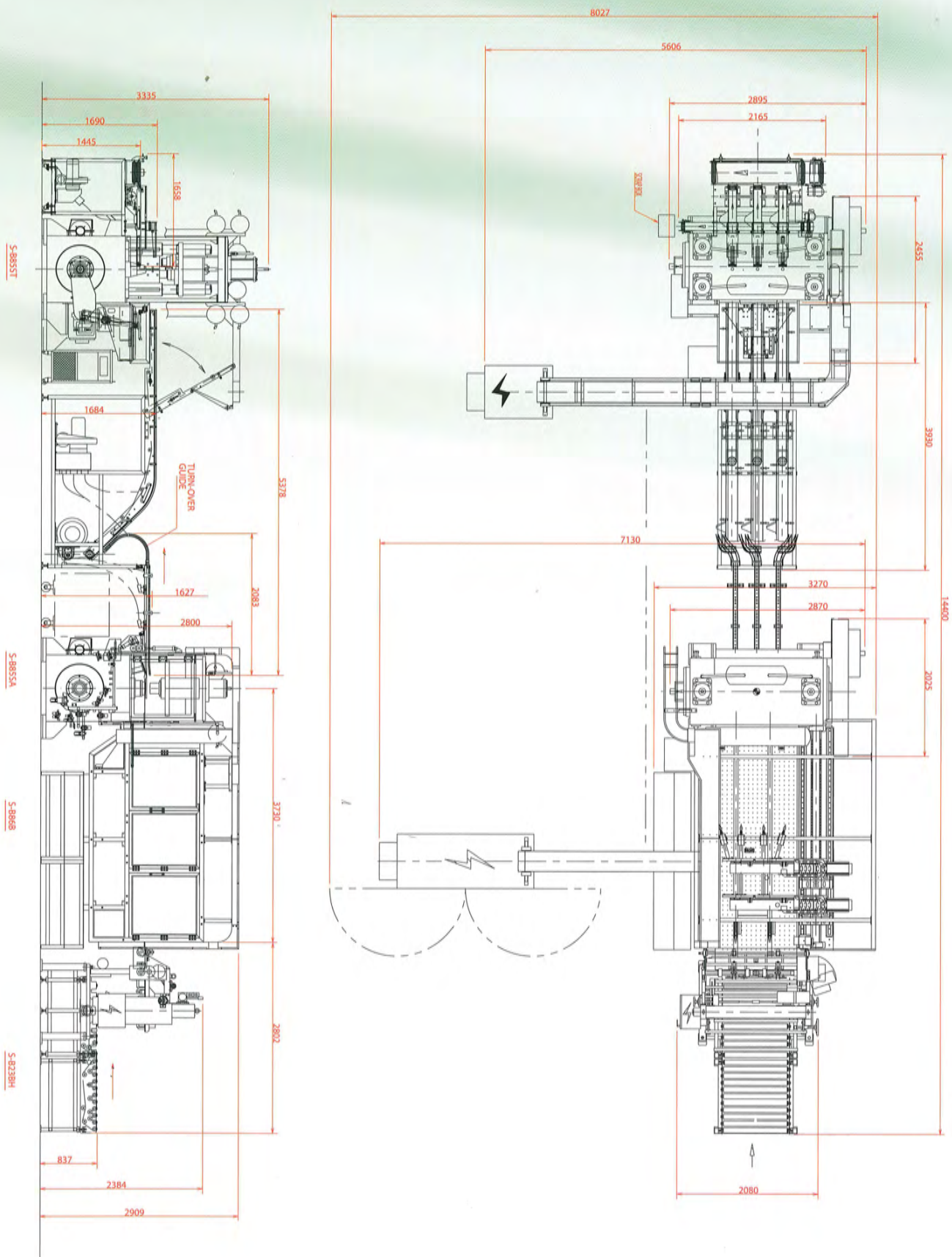


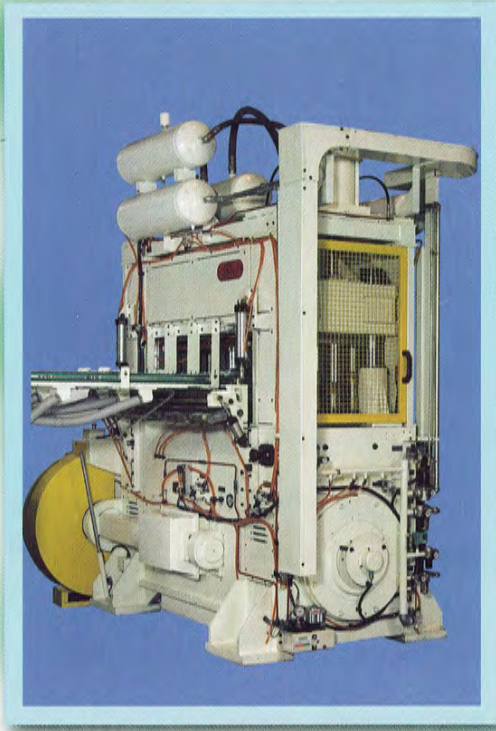
S-B85SA 冲模側向入口及滑塊
Tooling Entrance and Ram



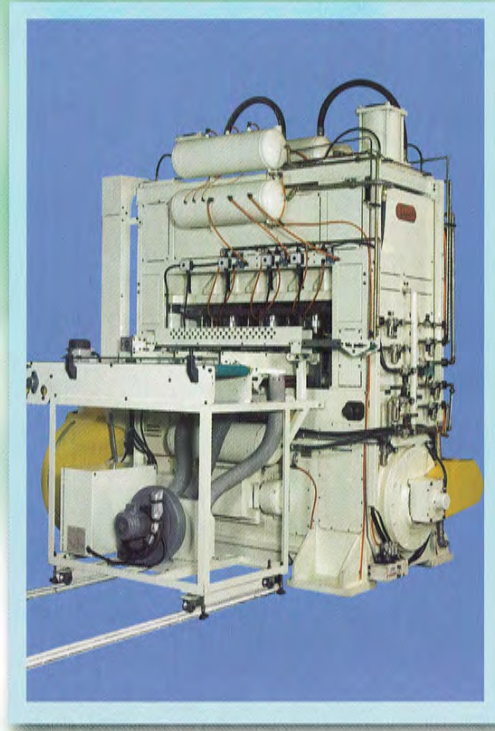
2nd 引伸冲模及修邊模
2nd drawing tooling and trimming tooling







S-B85SA 冲床



S-B85ST 冲床

主要產品 Main Business

- 馬口鐵罐空罐製罐設備整廠輸出（用以生產飲料罐、食品罐、高壓噴霧罐、二片引伸罐、油漆罐、一加侖油罐、奶粉罐及其他空罐）
- 食品罐頭機械（真空封罐機、加湯機.....等）
- 爪蓋製造全線設備
- 高壓噴霧罐上下蓋製造全線設備
- 詳細資料請參觀我們的網頁
- Complete line of tin can making machinery for food, beverage, aerosol, DRD, paint, milk powder and other cans.
- Food canning machinery including vacuum seamer, liquid filler...etc.
- Twist-off cap (lug cap) production line.
- Aerosol cone/dome forming and lining machine.
- Punch dies and other toolings for can making industry.
- Please visit our web site for more information.

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