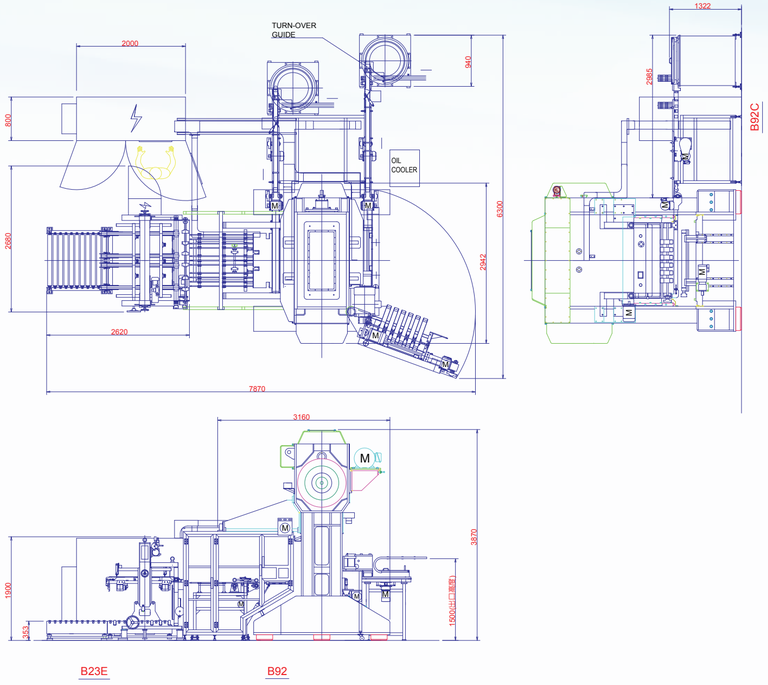
CNC自動全張鐵皮送料沖床(雙排多模)

Automatic CNC Sheet Feeding Press (double row multiple dies)

此套CNC全張鐵鋁皮送料雙排多模沖床為直線送料之現代化高速沖蓋用沖床，採用伺服馬達，PLC控制系統，可程式控制整合料片交接系統，送料精準確實。另外，利用人機介面作為核心控制執行資料傳輸及顯示，實為高速製蓋線之最佳選擇。

This CNC sheet feeding press with straight sheet feeding system and double row multiple dies is suitable for high speed alu or tin end making. Servo motors and PLC control system are incorporated. Programmable integrated sheet take-over system can get precise sheet feeding. Besides, a reliable Human Machine Interface touchable screen is introduced as a main control unit for data transmission and display. This is the best choice for high speed end making.



規格 Specification

機型 MACHINE TYPE	S-B23E, S-B92, S-B92C
適用罐徑 Range of end dia.	113 D ~ 401 D
沖模模數 Number of tooling set	8 ~ 16 sets (依罐蓋及鐵皮尺寸而異，depend on end size and sheet size)
每分鐘產能 Capacity per min.	variable 140 ~ 220 strokes
適用鐵皮尺寸 Sheet Size range	950 mm W (Max)x 1150 mm L (Max)
沖床噸數 Capacity of press	120 tons.
沖床主馬達 Main motor for press	40 HP x 6 P
排蓋輸送帶馬達 End discharge conveyor	2 HP x 6 P x 2 sets
滑塊面積 Area of outer ram	1400 x 500 mm
台盤面積 Area of bolster	1400 x 500 mm
滑塊最大閉模高 Max. die height of outer ram	520 mm
滑塊行程 Stroke of outer ram	100 mm
安裝面積及高度 Floor space overall height	7980 L x 6300 W x 3870 +/- 50 H mm
淨重 Net weight (approx)	1,550 , 27,000 , 650 Kgs

其它罐蓋用 CNC 整張沖之沖床，X-Y 軸送料單排多模沖床及低速 X-Y 軸送料單雙模沖床亦可供應。
Other CNC sheet feed press such as Single Row Multiple Dies X-Y axis Sheet Feed Press and Low Speed Singe (or Double) Die X-Y axis Sheet Feed Press are also available.

註：規格如有變更，恕不另通知 Subject to change without notice.
實際產能依罐蓋尺寸而定 Actual capacity depends on end size.

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AGENT：

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CNC自動全張鐵皮送料沖床

Automatic CNC Sheet Feeding Press

S-B23E+S-B92+S-B92C

CE available

ISO 9001 BSMI REGISTERED

Shin-I 新益 SINCE 1956

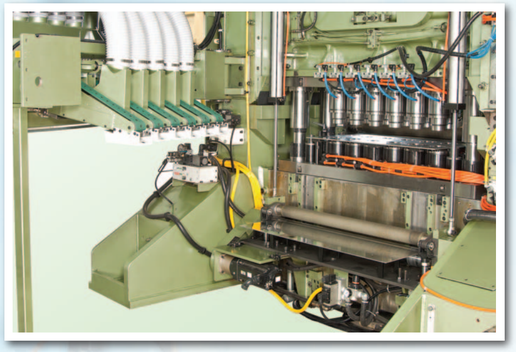
新益機械工廠股份有限公司
SHIN-I MACHINERY WORKS CO., LTD.

特 點

- 採用人機介面觸控螢幕作為控制介面。
- 送料換型參數設定容易。
- 採用穩定性高之伺服馬達，降低高速運動時產生之慣性。
- 入出口滾輪相互配合使料片前進定位確實，出口滾輪並兼具排廢料功能。
- 多重安全控制，如氣壓不足、無油、油壓過載、馬達過載、出口卡蓋等停機控制安全防護。
- 配備空氣離合器，確實可靠。
- 導柱式沖模可由廢料側推入，搭配快速移模機構及輔助舉模定位裝置，換型快速。
- 氣動式入口面板升降，氣動滾輪台升降及可移動式排蓋輸送機，方便調整及維護模具。
- 排蓋控制時序採用電子凸輪調整，以防止雙沖。
- 曲柄軸全軸承裝載並採用自動機油潤滑與冷卻機冷卻系統。
- 曲柄軸配置動平衡裝置可抵消運動慣性。
- 適用於直邊或預波鐵鋁皮，預波側前進入沖模。
- 電動閉模高調整。

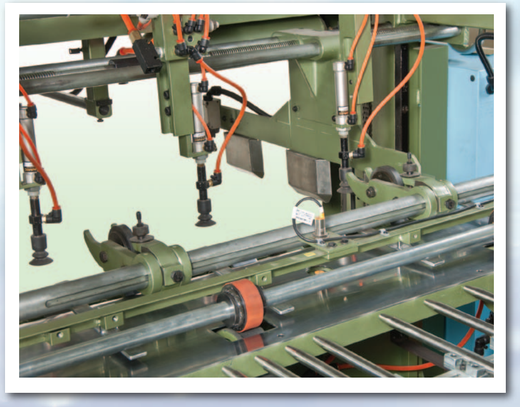
Features

- A reliable Human Machine Interface touchable screen is introduced as a main control unit.
- Easy to change any sheet feeding parameters for different end size.
- Reliable precise servo motors are incorporated to reduce possible inertia.
- Sheet is sent forward by the precise movement from inlet and outlet feeding rollers. Scrap is ejected by outlet rollers.
- 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．
- Equipped with air brake clutch，safe and reliable．
- Roller rails as well as liftable roller support at bolster are used for easy tooling loading and removing.
- Pneumatic inlet sheet guide plate, pneumatic roller holder and moveable discharge conveyor make it easy to access tooling for maintenance.
- End ejection is controlled by electronic cam adjustment to avoid double punch．
- Bushes on crankshaft are properly lubricated by an automatic oil pump; besides, an oil cooler is introduced.
- On the crankshaft, balance blocks are used to reduce inertia.
- Suitable for square or pre-scrolled tin /aluminum sheet, pre-scrolled side head into tooling．
- Die shut height adjustable by motor and gear driving.

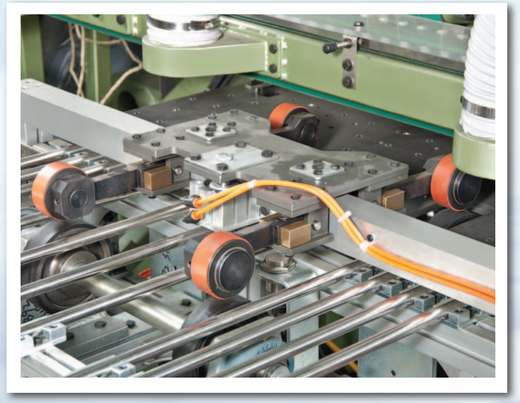


廢料出口側 Scrap Discharge Side

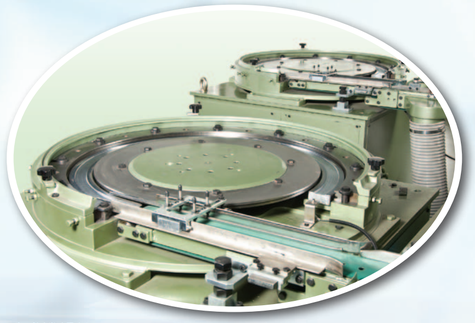
沖模入口 Tooling Entrance



送料機出口
Discharge of Feeding Machine



送料平台
Feeding Table



臥式捲緣機 Horizontal Curler

動作原理

料片由送料機送至沖床入口前端之送料輸送機定位後，由伺服馬達帶動之入口送料滾輪開始送料片到沖模，模具上模由曲柄滑塊上下帶動沖製罐蓋，每沖蓋一次入口滾輪移動料片前進一次直到伺服馬達帶動之出口滾輪接收料片移動工作及排廢料，入口滾輪再送下一張料片。沖出之料片由沖床雙邊之排蓋輸送機排出直接送入二台臥式捲緣機捲緣。

Working Principle

In the sheet feeder, sheet is separated by separating device then is fed by vacuum pads into CNC feeding unit．Inlet rollers driven by servo motor send sheet into tooling, a ram driven by a crankshaft move vertically to stamp the sheet. Immediately after each stamping, sheet is fed forward accordingly until outlet rollers take over the sheet for further feeding and scrape ejection. Ends are ejected out by air blowing and carried away by two conveyors at press both sides and directly to two horizontal curlers, sheet scrap is ejected by outlet rollers．