

罐蓋出口輸送機及排廢料滾輪
End Discharge Conveyor and Scrap Ejector

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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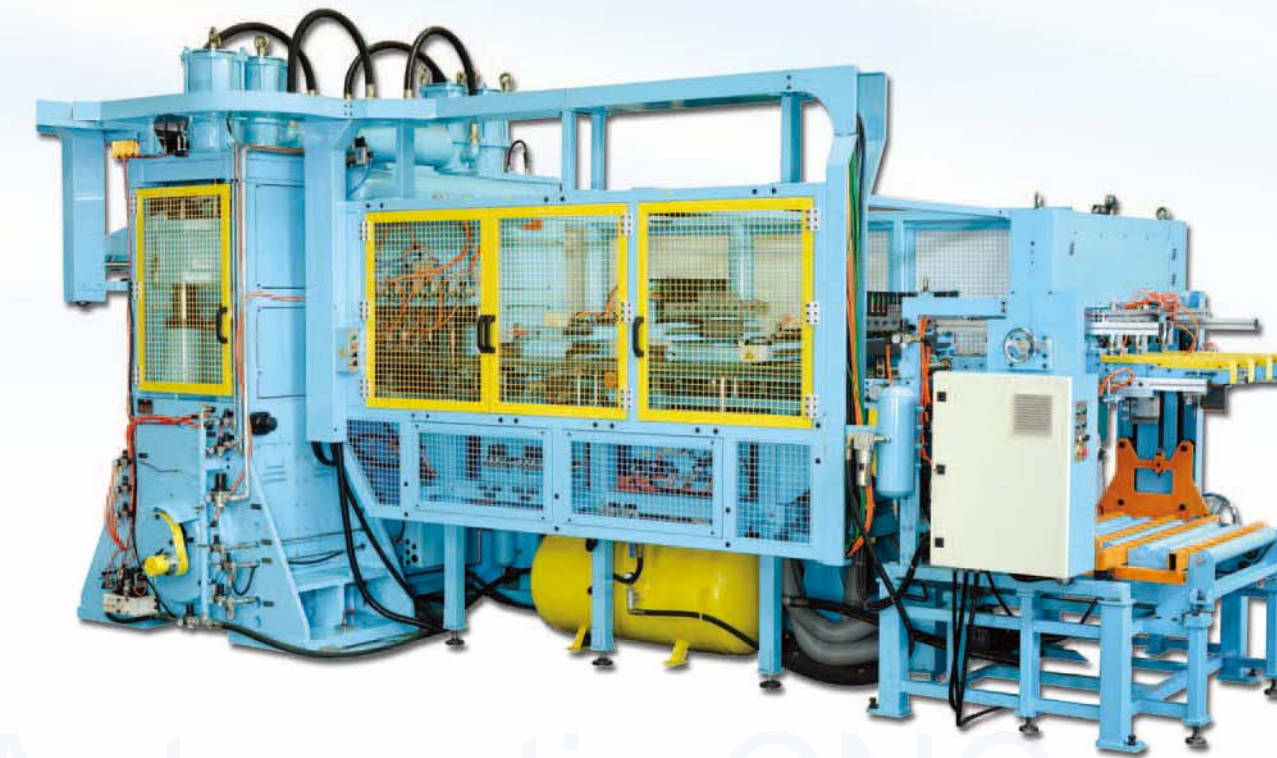


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2012.07.500

Automatic CNC CNC自動全張鐵皮送料沖床 Automatic CNC Sheet Feeding Press

S-B23E+S-B86B+S-B85SB



Double action is also available.



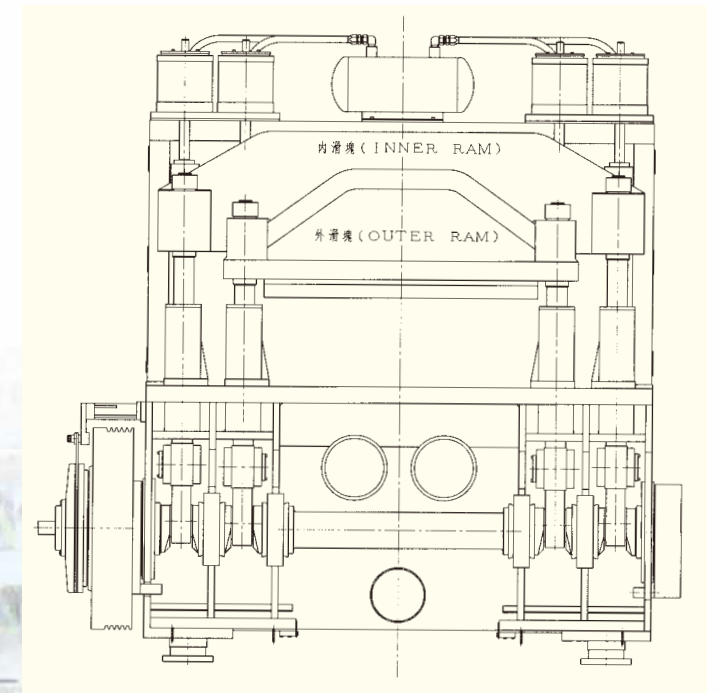
CNC自動全張鐵皮送料沖床

Automatic CNC Sheet Feeding Press

此套CNC全張鐵皮送料沖床為四軸同步運動之現代化沖蓋用沖床，採用線性馬達，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，利用人機介面作為執行資料計算傳輸及顯示，安全可靠。
*單曲軸雙滑塊設計之沖床S-B85A (配合出口翻轉罐蓋導路) 亦可提供，使沖剪毛邊位於罐蓋捲緣內側，可以有效減少罐蓋因堆疊運送所產生之擦傷。

This CNC sheet feeding press equipped with four axis synchronized movement is suitable for tin or aluminum end stamping. Linear 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 calculation, transmission and display.

*Press model S-B85A single crankshaft with double action is also available to make the cutting burr stay at the inner side of the curl. This can avoid the scratch on the end seaming panel while ends are piled up during transportation.



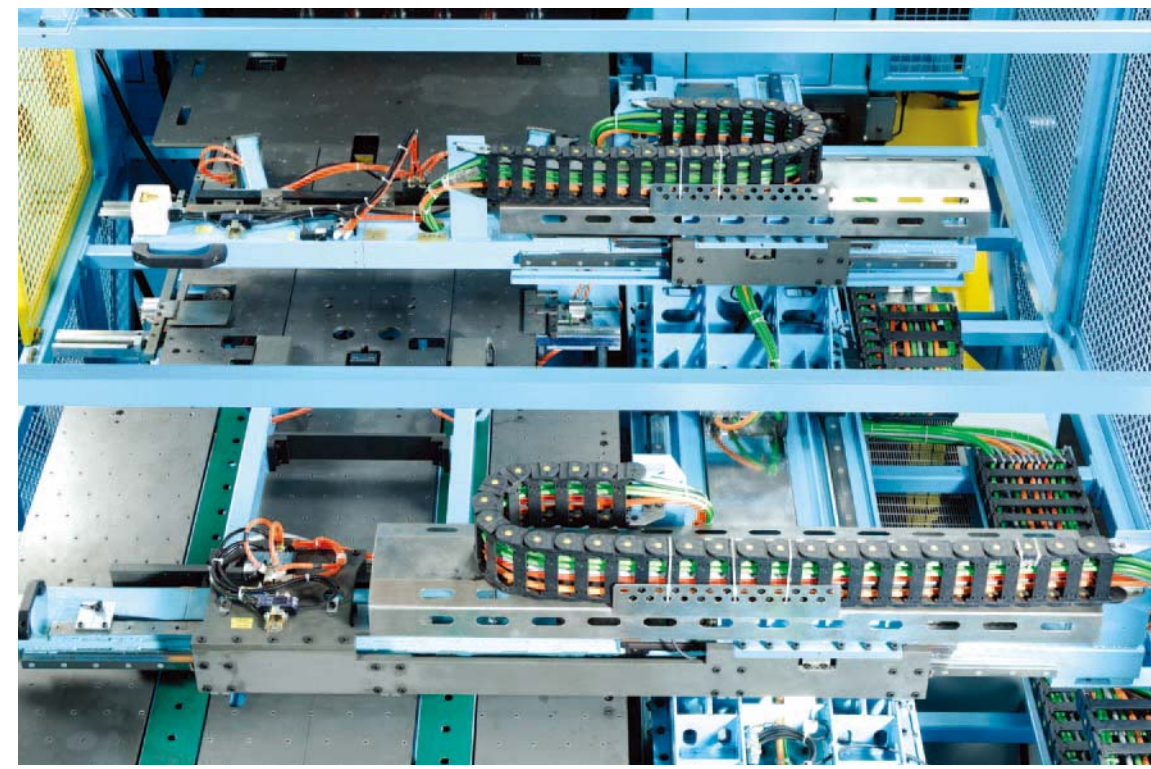
S-B85A

特點

- 採用精密線性馬達、運動控制系統及觸控式人機介面。
- 送料運動曲線自動產生及傳輸下載，換型參數設定容易。
- 採用穩定性高之線性馬達，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線性馬達溫度。
- 附電眼偵測送料夾是否確實夾料。
- 多重安全控制，如氣壓不足、無油、馬達過載、出口卡蓋等停機控制及各軸極限安全防護。
- 配備空氣離合器，確實可靠。
- 導柱式沖模可由沖床側向推入，換型快速。
- 排蓋控制時序採用電子凸輪調整，以防止雙沖。
- 曲柄軸位於沖床本台下方，其軸襯及滑塊導桿軸襯採用自動機油循環潤滑系統及油路堵塞顯示安全控制，並配有油溫冷卻機。
- 沖床上方配備四個（S-B85A）滑塊緩衝氣缸平衡滑塊及模具重量。
- 適用於直邊或預波鐵鋁皮，可為直邊或預波側前進入沖模。

Features

- A reliable Human Machine Interface touchable screen is introduced as a main control unit.
- Movement orbit generate and download automatically, easy for different end size parameters set up.
- With reliable European linear motors to reduce the inertia at high speed.
- Equipped with sensors to detect if the clips certainly clip the sheet.
- 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 .
- Tooling with pillar die set can be easily pushed into via rollers buried on bolster.
- End ejection is controlled by electronic cam adjustment to avoid double punch .
- Crankshaft is located at lower mainframe , bushes on crankshaft are properly lubricated by an automatic oil pump ; besides , oil tube block detection is incorporated .
- Four sets (S-B85A) of air cushion cylinders located at press upper side to balance the weight of rams and toolings .
- Suitable for square or pre-scrolled tin /aluminum sheet , can be straight side or pre-scrolled side head into tooling .



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



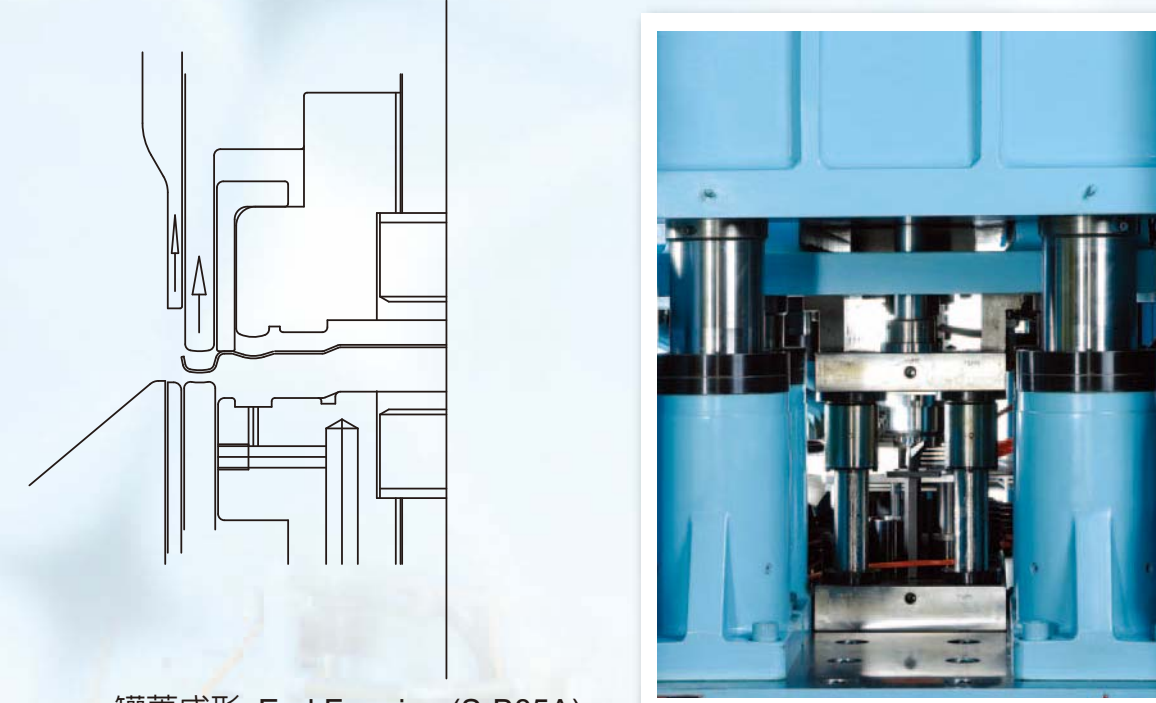
定位吸盤及夾爪
Positioning Suction Pad and Grippers



空氣離合器 Air Clutch

動作原理

鐵鋁皮於送料機內經分離器分離後由真空吸盤送入CNC送料機，經由吸盤導正後，後段夾爪夾住料片先將料片送至沖床並負責最初沖孔之送料工作，然後前後段夾爪交接並由前段夾爪負責後續沖孔之送料工作，此時後段夾爪退回原點準備夾送下一張料。Y軸負責前後移動而X軸負責左右移動。沖最後一孔後，前段夾爪退回交接區準備接收下一張料片，此時後段夾爪立刻夾送下一張料片進入沖床所以無空沖。外滑塊執行剪切，內滑塊執行罐蓋成形。沖製好之罐蓋由高壓空氣自沖模處排出後由輸送機帶出，鐵鋁皮廢料由滾輪排出。



罐蓋成形 End Forming (S-B85A)

沖模側向入口及雙滑塊 (S-B85A)
Tooling Entrance and Dual Rams



沖模及導柱模座
Punch Toolings and Pillar Die Set



線性伺服馬達
Linear Servo Motor

Working Principle

In the sheet feeder, sheet is separated by separating device then is fed by vacuum pads into CNC feeding unit. Sheet is positioned well by a suction pad then rear clips hold the sheet and send it into tooling for initial stamping. Then, front clips take over the sheet for further stamping. At this time, rear clips withdraw back to origin for next sheet feeding. Y axis for straight sheet feeding while X axis for zig zag sheet feeding. After last stamping, front clips is to withdraw back to take-over area for next sheet feeding. Right at this moment, rear clips hold the new sheet and immediately send it into tooling; therefore, no idle stroke. Outer ram undertakes cutting while inner ram fulfills end forming. Ends are ejected out by air blowing and carried away by conveyors, sheet scrap is ejected by rollers.

規格 Specification

機型 MACHINE TYPE	S-B23E, S-B86B, S-B85SB (or S-B85A double action)
適用罐徑 Range of end dia.	200 D ~ 603 D
沖模模數 Number of tooling set	2 ~ 8 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 ~ 200 strokes (100 ~ 150 strokes*)
適用鐵皮尺寸 Sheet Size range	(700 ~ 1067) W x (830* ~ 1067) L mm
沖床噸數 Capacity of press	110 tons (30 / 60 tons for S-B85A)
線性馬達推力 Linear Motor Force	最大推力 Max force X1/X2 2470N, Y1/Y2 5180N (X1/Y1 as Front set, X2/Y2 as Rear set)
沖床主馬達 Main motor for press	30 HP x 6 P
排蓋輸送帶馬達 End discharge conveyor	1 HP x 6 P
排廢料馬達 Scrape discharge conveyor	1 HP x 6 P
外滑塊面積 Area of outer ram	1350 x 300 mm
內滑塊面積 Area of inner ram	1640 x 200 mm (for S-B85A)
台盤面積 Area of bolster	1640 x 300 mm
外滑塊最大閉模高 Max. die height of outer ram	380 mm
內滑塊最大閉模高 Max. die height of inner ram	510 mm (for S-B85A)
外滑塊行程 Stroke of outer ram	60 mm
內滑塊行程 Stroke of inner ram	80 mm (for S-B85A)
安裝面積及高度 Floor space overall height	7400 L x 6200 W x 3400 +/- 50 H mm
淨重 Net weight (approx)	1,550 , 2,700 , 12,700 Kgs

其它罐蓋用 CNC 整張沖之沖床，高速直線送料雙排多模沖床及低速 X-Y 軸送料單雙模沖床亦可供應。
Other CNC sheet feed press such as High Speed Double Row Multiple Dies Straight 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.