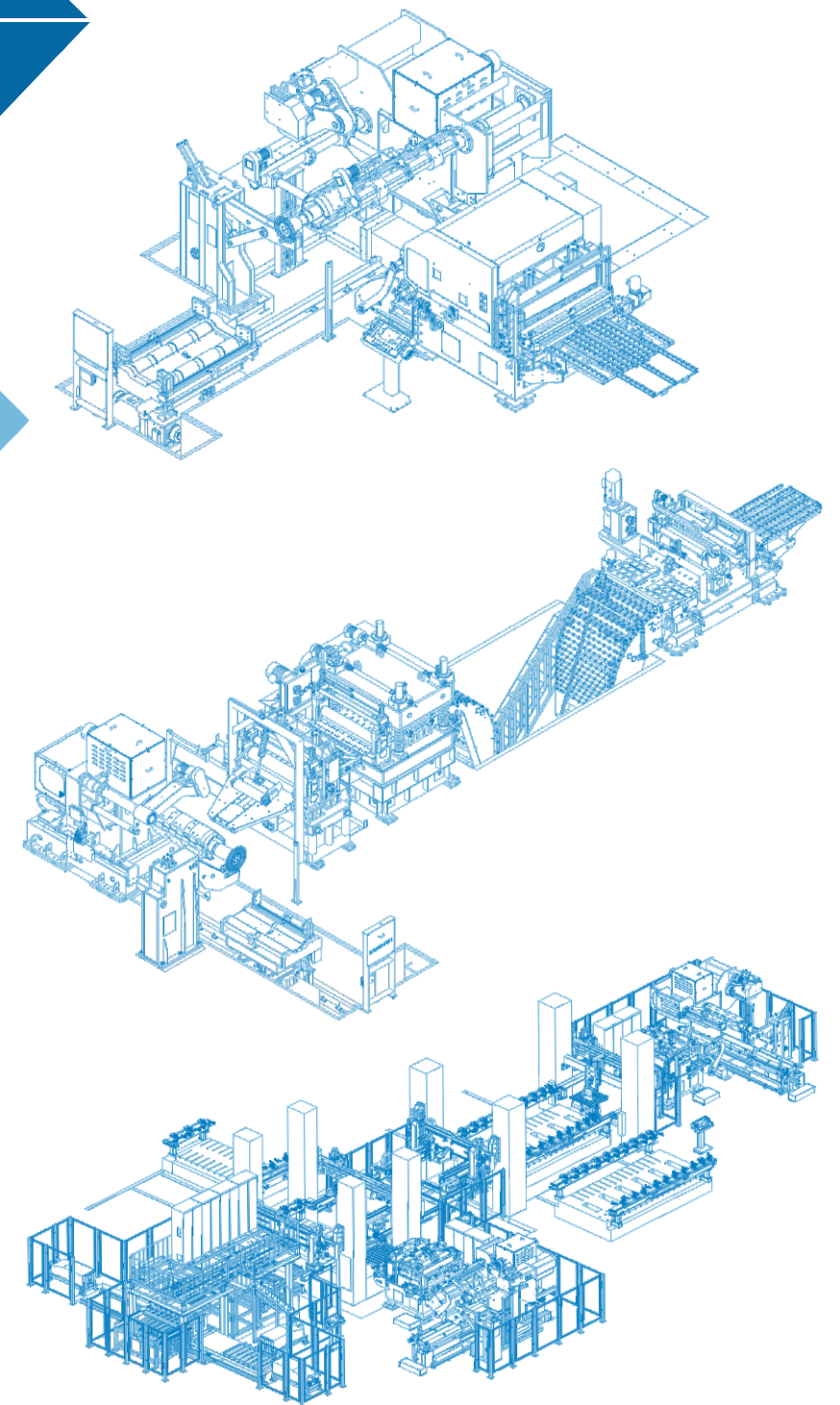


卷料加工生产线

COIL HANDLING SYSTEMS



广东瑞辉智能科技有限公司
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AGENT



遇见瑞辉

遇见一个 冲压自动化世界

RNC / RNC-HA / RNC-F

NC 滚轮送料机

NC ROLL FEEDER

通过CCS (电脑控制伺服系统), 高精度的实现了以往不可能的多种数值控制。可以简单地快速、准确的操作。

Previously unattainable high-precision numerical control is made possible by CCS (computer controlled servo), for fast and accurate performance.



规格: Specification

型号 Model	板幅 (mm) Stock width	板厚 (mm) Stock Thickness	板厚 × 板幅 (mm) Stock Thickness × Stock width	送料线高度 (mm) Pass Line	释放随动次数 (SPM) Releasing Performance	伺服马达 (kw) Motor
RNC-100	20~100	0.1~3.2	3.0 × 100 / 3.2 × 80	70~170	~200	AC 0.4
RNC-200	20~200	0.1~3.2	2.3 × 200 / 3.2 × 80	70~170	~200	AC 0.4
RNC-300	20~300	0.1~3.2	2.0 × 300 / 3.2 × 80	70~170	~200	AC 0.75
RNC-200HA	20~200	0.3~3.2	2.3 × 200 / 3.2 × 80	70~170	~80	AC 0.4
RNC-300HA	20~300	0.3~3.2	2.0 × 300 / 3.2 × 80	70~170	~80	AC 0.75
RNC-400HA	20~400	0.3~3.2	1.6 × 400 / 3.2 × 50	70~170	~80	AC 0.75
RNC-600HA	20~600	0.3~3.2	1.2 × 600 / 3.2 × 50	70~170	~60	AC 1.3
RNC-800HA	20~800	0.3~3.2	1.0 × 800 / 3.2 × 50	70~170	~60	AC 2.9
RNC-200F	20~200	0.2~3.2	2.3 × 200 / 3.2 × 100	70~170	~200	AC 0.4
RNC-300F	20~300	0.2~3.2	2.3 × 300 / 3.2 × 80	70~170	~200	AC 0.4
RNC-400F	20~400	0.2~3.2	1.6 × 400 / 3.2 × 60	70~170	~150	AC 0.75

※规格及外观由于改进有可能在未通知时变化
※Specifications are subject to change for improvement without notice

RLF Series

精密整平机

COMPACT STRAIGHTENER

支持最大材料宽为~300mm, 板厚0.1~1.4mm的薄板精密整平机, 出色的矫正能力最适合各种精密零件的加工。

The RLF series offers a precision straightener that can process material width up to 300mm, and can be adjusted to handle stock thicknesses between 0.1 and 1.4mm. This is the optimum model for processing all kinds of precision components which require outstanding straightening performance.



规格: Specification

型号 Model	板幅(mm) Stock width	板厚(mm) Stock Thickness	工作滚轮直径 Work Roller diameter	工作滚轮支数 Number of Work Rolls	辅助滚轮 Back Up Roll	矫正速度 Speed Range (m/min)	马达容量 Motor (kw)
RLF-200	20~200	0.1~1.4	Φ 12	上Upper11/下Lower11	14Hi	5~30	1.5
RLF-300	20~300	0.1~1.4	Φ 12	上Upper11/下Lower11	14Hi	5~30	1.5

矫正能力 Straightening performance

板厚 (mm) stock Thickness	0.1 ~ 0.4	0.5	0.6	0.8	1	1.2	1.4
板幅 (mm) stock width	200	200	200	145	109	85	70
	300	262	210	146	108	84	68

- 给油装置 Oiling device**
 电动泵强制给油至工作滚轮
 该装置减轻了维修保养的工作量, 支持机械最佳运转。剩余油量可目视确认, 并且容易补给。
 An electromotive pump forces oil to the work rolls
 This oiling device eliminates the need for troublesome maintenance work and supports the optimal operation of the remaining quantity of oil can be checked at a glance, and oil can easily be added.
- 矫正量调整 Controlling the amount of flatness-adjustment**
 多个调节手柄使矫正量的调整变得很容易
 通过调节手柄, 在机器的入口侧、出口侧、正面、背面均可以对矫正量进行调整, 非常顺利。
 The amount of flatness-adjustment can be easily controlled through the operation of handles
 The amount of flatness-adjustment can be controlled not only at the inlet and outlet sides, but also at the back and front sides simply through the operation of handles.
- 工作滚轮 Work rolls**
 22 根业界最小直径的工作滚轴, 确保加工精度
 业界最小直径12mm的工作滚轮, 去除卷材的弯曲应力。可以矫正最大宽度300mm的薄板材料, 满足了日益增长的高精度部件的加工需求。
 Precision machining using 22 work rolls with the thinnest diameter
 22 work rolls with the thinnest diameter [φ 12mm] on the market remove residual stress. Wide sheet metals of up to 300mm in width can be handled, which satisfies the increasing demand for precision components machining.
- 移动装置 Caster base**
 作为标准装备的闭锁脚轮, 方便移动、固定
 带闭锁脚轮的移动装置, 使设备能够灵活放置, 方便布局。
 A caster base with locking casters for easy movement and fixing is included as standard equipment.
 The caster base enables flexible setting of the leveler.
- 驱动装置 Drive unit**
 兼具高规格组件的驱动装置
 驱动装置采用了传动功率高的油浴式齿轮箱和万向接头, 保证了设备机型小但规格高。变频控制使无级变速成为可能。
 Drive unit with specifications of a higher-grade unit
 The drive unit is compact but has the highest-level specifications such as superior electromotive efficiency, oil-bath type gearbox, and a universal joint. The inverter in the drive unit enables flexible speed change.
- 保持料环, 支持设备最佳运转**
 变频器运转总是与生产线速度保持高度一致。平滑的加速减速减轻了材料及送料机等设备的负荷。正、逆运转可经由开关轻易转换。
 The cam maintains the appropriate tension of the material and supports optimal operation
 The inverter ensures that the inverter always operates optimally in accordance with the line speed. Smooth acceleration and deceleration reduces loads imposed on materials and equipment such as the feeder. Forward and backward operations can easily be changed simply by flicking a switch.
- 轻量凸轮检测**
 Detection by a lightweight cam
 独创的天线式检测杆
 可检测操作力10g的超轻量导体, 半导体薄板金属材料。此外, 独特的弯曲形状可以防止材料表面受其接触而擦伤。
 Inventive antenna type detection bar
 The ultra lightweight detection bar can be operated with only 10g of operation force and can detect both conductive and non-conductive thin sheet metal. Furthermore, a unique curved shape prevents scratches on the material surface for worryless operation.

STRAIGHTENER 精密矫直机系列

RLV-F Series

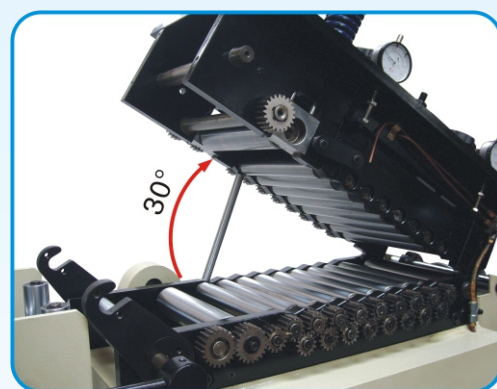
精密矫直机系列

COMPACT STRAIGHTENER

适合0.1~1.5mm的薄板矫直，上下滚轮全同步驱动，可变频调速，上工作辊可以掀开清洗。
针对薄板精密矫直具有非常有利的条件。

The sheet for 0.1~1.5mm straight, upper and lower roller synchronous drive, variable frequency speed, on the work roll can be opened for cleaning.
The sheet straightening has very favorable conditions.

最大掀开角度



可掀开式设计

17根小直径工作滚轮

17根小直径工作滚轮消除卷材的弯曲应力，确保精密加工所需的高平坦度

辅助滚轮

对应材料宽度300mm以上之系列产品，额外配备了辅助滚轮，用以抑制工作滚轮的弯曲，强化了矫平的精密性。

17 Smaller Diameter Work Rolls

17 smaller diameter work rolls remove the coil set from the material and ensure the high level of material flatness that precision processing demands.

Back Up Rolls

The RKL-300 and RKL-500, which handle up to 300mm and 500mm width have additional back up rolls. These rolls will reduce the deflection of work roll making straightening performance more precise.



规格: Specification

型式	Model	RLV-150F	RLV-200F	RLV-300F	RLV-400F	RLV-500F	RLV-600F
材料最大宽度	Max Material Width (mm)	150	200	300	400	500	600
材料厚度	Material Thickness (mm)	0.1~1.5	0.1~1.5	0.1~1.5	0.1~1.5	0.1~1.3	0.1~1.2
送料速度	Speed (M/Min)	6~22					
马达	Motor (HP)	1	1	1	2	3	3
变频器	Inverter	有 Provided					
矫直滚轮	Work Rolls	上/Upper8 下/Lower9 全驱动 All Drive Function					
导料滚轮	Pinch Rolls	上1/Upper1 下1/Lower1 全驱动 All Drive Function					
背压滚轮	Back up rolls	无 N/A			有 Provided		
调整装置	Adjustment	四点式分厘表微调 4 Points Fine Micro Adjustment					
感应方式	Loop Control	感应台式 Touch Sensor					
开口装置	Work Roll Opening	手动操作 Manual Operation					
驱动方式	Drive Method	侧齿轮方式全滚轮驱动 All Rolls are Driven with Side Gear					
供应电源	Power Supply	三相 3Phase 220V/380V/50HZ					

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STRAIGHTENER 整平机

RKL Series

精密整平机

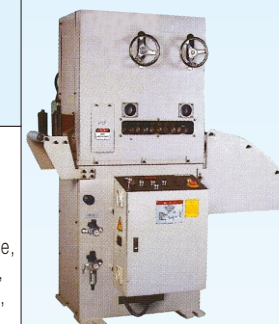
PRECISION STRAIGHTENER

用19支加工滚轮去除材料的残留应力。高水平地实现产品的平坦度，充分满足精密加工中的精度要求。

19 smaller diameter work rolls remove the coil set from the material and ensure the high level of material flatness that precision processing demands.

规格: Specification

型号 Model	板幅 (mm) Stock width	板厚 (mm) Thickness	驱动方式 Drive Method	驱动马达 Motor	矫正速度 (m/min) Line Speed	工作滚轮数 (支) Number of Work Rolls	辅助滚轮 Back Up Roll	开口装置 Work Roll Opening	标准配置 Standard Attachment
RKL-300	~300	0.2~1.6	侧齿轮方式全滚轮驱动 All Rolls are Driven with Side Gear	3.7KW 齿轮传动马达变频器控制 3.7KW Geared Motor, INVERTER Controlled	6~24	上Upper9 / 下Lower10	0	90mm 手动操作 90mm Manual Operation	扳手式1列入口宽度导块, 材料末端检测, 料环检测(光电式) Entry stock side guide, End of stock sensor, No-loop detector (photo electric type).
RKL-500	~500								



矫正能力 Straightening performance

型号 Model	板幅 (mm) stock Width		
	0.2~1.2	1.4	1.6
RKL-300	300		
RKL-500	500		462

※上表中的屈服点应力为245N/mm²(拉伸强度为392N/mm²).
※The above figures are the material having yield strength of 245N/mm² (tensile strength of 392N/mm²).

19根小直径工作滚轮

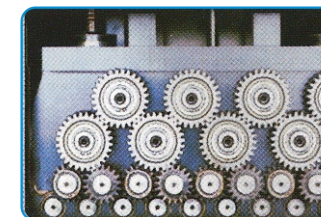
19根小直径工作滚轮消除卷材的弯曲应力，确保精密加工所需的高平坦度

辅助滚轮

对应材料宽度300mm、500mm之RKL-300、RKL-500系列产品，额外配备了辅助滚轮，用以抑制工作滚轮的弯曲，强化了矫平的精密性。

升降式上工作滚轮开口结构

采用了倍受好评的LCC SA系列NC整平送料机之升降式开口结构，容许上滚轮装置大角度打开，清洁和保养工作变得非常容易。



直接驱动的变频控制齿轮马达

采用了3.7kw变频控制齿轮马达，更容易变更矫正速度以配合生产线速度。并且无链条、直接驱动之高精度齿轮的采用，使工作滚轮动态达到极限依然平稳运转。为用户生产高精度产品提供保障。

19 Smaller Diameter Work Rolls

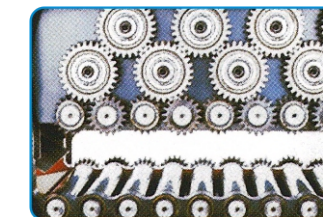
19 smaller diameter work rolls remove the coil set from the material and ensure the high level of material flatness that precision processing demands.

Back Up Rolls

The RKL-300 and RKL-500, which handle up to 300mm and 500mm width have additional back up rolls. These rolls will reduce the deflection of work roll making straightening performance more precise.

Lifters for Opening the Upper Work Roll Units

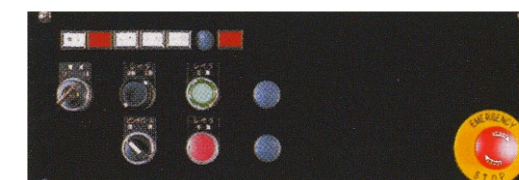
The RKL Series has adopted the lifters of our popular LCC SA model NC Straightener Feeder, allowing the upper work roll units to be opened widely for easy cleaning and maintenance.



90mm大开口量
90mm wide opening gaps

Geared Motor with Inverter Control

Adopting the 3.7kw geared motor with Inverter control allows the feed speed to change easily, in addition, a direct drive mechanism without a chain and precision gear has been adopted. These features create maximum smoothness of the work roll movement producing a precise end product.



操作面板
OPERATION PANEL

MT / ME

开卷机

UNCOILER

心轴扩缩方式分别有手动式和气动式，可根据卷材的宽度及重量选择所需机型。

Manual or pneumatic models can be selected for inner diameter adjustment, There is wide selection to choose from depending on width and weight of coil.



规格: Specification

型号 Model	板幅 (mm) Stock width	卷料重量 (KG) Coil Weight	马达 (kw) Motor	压料臂 Pressing Arm	卷筒扩缩方式 Coiling block expansion mode	卷材内径 (mm) Material ID	卷材外径 (mm) Material OD
MT-300	20 ~ 300	800	0.75	/	手动式 Manual	Φ508	Φ930
MT-400	20 ~ 400	1000	0.75	/	手动式 Manual	Φ508	Φ930
MT-500	20 ~ 500	1500	1.5	/	手动式 Manual	Φ508	Φ930
MT-600	50 ~ 600	2000	1.5	/	液压式 Hydraulic	Φ508	Φ1200
MT-800	50 ~ 800	3000	2.2	/	液压式 Hydraulic	Φ508	Φ1200
ME-300	70 ~ 300	800	0.75	气动 Pneumatic	手动式 Manual	Φ508	Φ930
ME-400	70 ~ 400	1000	0.75	气动 Pneumatic	手动/液压式 Manual / Hydraulic	Φ508	Φ930
ME-500	70 ~ 500	1500	1.5	气动 Pneumatic	液压式 Hydraulic	Φ508	Φ1200
ME-600	100 ~ 600	3000	1.5	气动 Pneumatic	液压式 Hydraulic	Φ508	Φ1200
ME-800	100 ~ 800	5000	2.2	气动 Pneumatic	液压式 Hydraulic	Φ508	Φ1200

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GCF / SFS / MDW

高速送料线

S ROLL FEEDER

主要用于马达转、定子的冲压叠片。利用回转凸轮机构实现间歇性送料，依靠稳定的齿轮传动机构来保证送料精度和稳定性，最高冲压速度可达400次/分钟以上。

Mainly used for motor rotor and stator stamping lamination. Intermittent feeding with rotary cam mechanism. Rely on the stability of the gear transmission mechanism to ensure the accuracy and stability of feed, the highest punching speed could reach 400 times/min.



GCF 高速齿轮更换式送料机 High speed gear change type feeder

规格: Specification

型式	Model	GCF-200	GCF-300
板幅	Stock width (mm)	200	300
板厚	Stock Thickness (mm)	0.35-1.6	0.35-1.6
分割数	Indexing-cam number	4	3
送料长度	Length of angle (mm)	11.5 ~ 240 (其他为特定品)	
送料角度	Pilt release angle	180°	
放松角度	Feed angle	135° ~ 195°	
送料方向	Feed direction	左 ~ 右 L-R	

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SFS S型高速精密矫正机 "S" type high-speed material straightener

规格: Specification

型式	Model	SFS-200	SFS-300
板幅	Stock width (mm)	200	300
板厚	Stock Thickness (mm)	0.35-1.6	
最大送料速度	Max. Material Speed (m/min)	40	
矫正滚轮	Straighten Rollers	上9/下10 (upside 9/downside 10)	
电源	Power	三相 3Phase 220V/380V/50HZ	

MDW 双头材料架 MDW Double end material rack

规格: Specification

型式	Model	MDW-200	MDW-300
板幅	Stock width (mm)	200	300
板厚	Stock Thickness (mm)	0-1.6	0-1.6
扩张范围	Extent Expansion (mm)	Φ460-530	
材料外径	Material O.D (mm)	Φ1200	
最大料重	Max. Load (kg)	1000 × 2	2000 × 2

※特殊规格依客户需求洽商订制
※Any specification available. Custom-made orders welcome
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其他为特定品

1. 齿轮送料机即凸轮送料机，主要配合双头材料架及S型整平机使用，适用于要求高速加工且需要高精度送料的冲制品。
2. 不需要调整送料步距。送距仅靠凸轮变换即可，送距的变更是由1-4个齿轮的变换而成；
3. 利用精密凸轮驱动的间歇送料方式；
4. 仅下部滚轮驱动而上部滚轮则由弹簧压着；
5. 插入材料时，上下滚轮的放松则由空气阀的手动开关操作即可；
6. 上下滚轮皆有镀铬处理，硬度达到HRC60以上；
7. 放松装置为偏心凸轮，故放松角度可由0° ~ 180° 之范围内随意调整；
8. 可依据冲床处理轴不同旋转方向进行特殊订货；
9. 采用箱体式结构，结构紧凑，不易变形。

Others can be customize

1. Gear feeding machine is Cam feeding machine, mainly use with double material rack and S type leveling machine, applicable to the punching products which requests with high speed processing and high precision.
2. No need to adjust the feeding step distance. The distance can be changed by 1-4 gears.
3. Intermittent feeding mode driven by precision cam
4. Bottom roller driven only and the top roller pressed by springs.
5. When material inserted, top and bottom rollers will be released by control the manual switch of the air valve.
6. All the rollers are coated with hard chrome plating, hardness over HRC60.
7. Releasing device is an eccentric cam, the releasing angle can be adjusted from 0° to 180°
8. Can be customize according to the different rotation direction of the shaft of the press.
9. Box type with compact structure, not easy to cause deformation.

UNCOILER WITH STRAIGHTENER 开卷矫直一体机

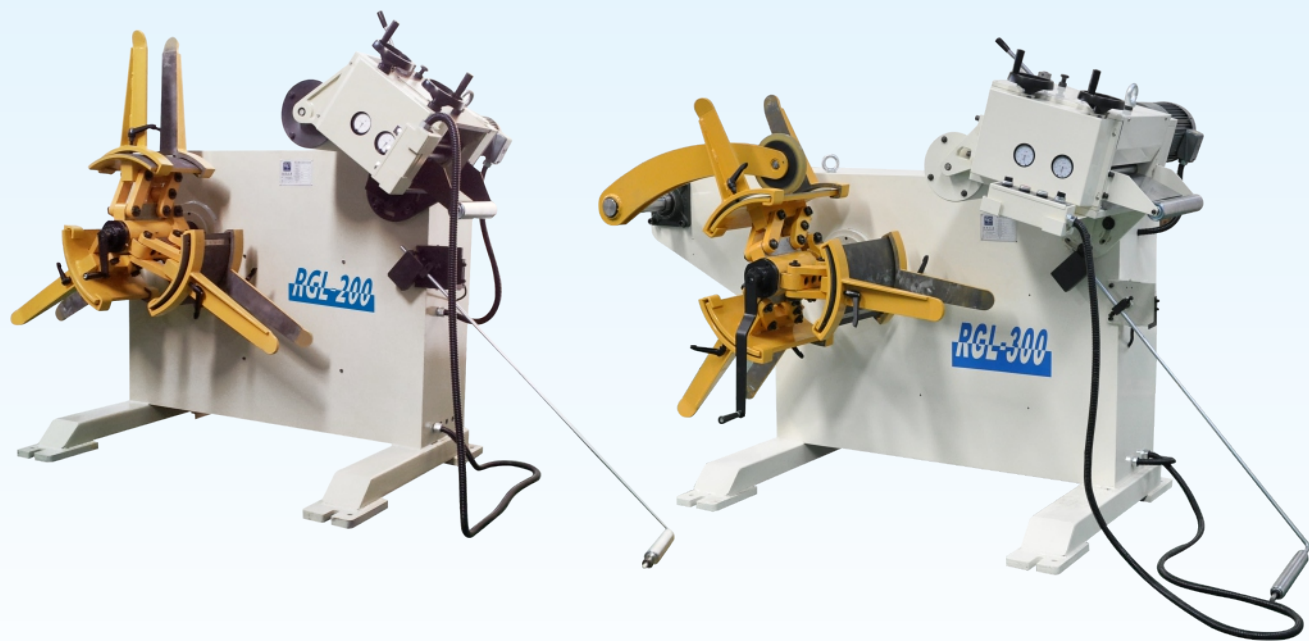
RGL Series

开卷矫直一体机

UNCOILER WITH STRAIGHTENER

由于开卷机和整平机的一体化，得以节省空间；加之整平机可方便的调节工作角度，故可根据现有空间灵活设机

By combining the uncoiler and straightener, we have succeeded in creating this new space saving model. The position of straightener is easily changeable for more flexible machine layout.



标准配件: Standard Accessories

- ※ 所有滚轮皆镀铬处理
- ※ RGL-200: 涡轮式微调装置
- ※ RGL-300以上: 四点涡轮式微调装置
- ※ 电控用Timer式控制
- ※ All roller are hard chrome plated
- ※ The RGL-200: turbine type adjustment device
- ※ The RGL-300 above four points in turbine type adjustment device
- ※ In the Timer type electronic control.

规格: Specification

型式	Model	RGL-200	RGL-300	RGL-400	RGL-500	RGL-600
板幅	Width of Material (mm)	200	300	400	500	600
板厚	Thickness of Material (mm)	0.3 ~ 3.2				
送料速度	Line Speed (m/min)	16				
矫正滚轮	Straightener Roll(Qty)	上3/Top3 下4/Bottom4 (下滚轮4支具有驱动功能4 Bottom Rolls have Drive Function)				
驱动滚轮入料/出料	Pinch Roll(Inlet/Outlet) (Qty)	入料Inlet:2 出料Outlet:2				
料架荷重	Max. Material Weight (kg)	1000	1000	1500	2000	2000
扩张范围	Extent Expansion(mm)	460 ~ 520				
材料外径	Coil O.D. (Mm)	1200	1200	1200	1200	1200
扩张方式	Mandrel Expansion	手动式 Manual				
供应电源	Power Supply	三相 3Phase 220V/380V/50HZ				

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UNCOILER WITH STRAIGHTENER 开卷矫直一体机

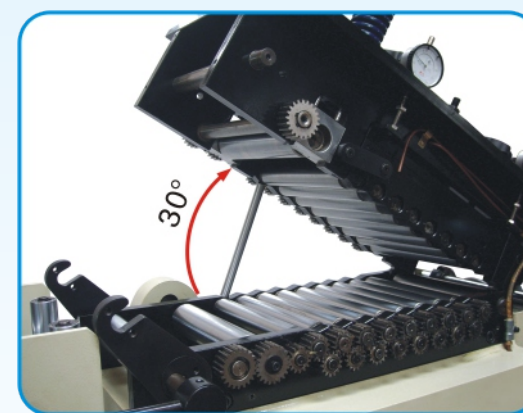
RUS-F Series

开卷矫直一体机

UNCOILER WITH STRAIGHTENER

上部工作滚轮采先进日本4点式分厘表微调装置，适矫直机精密度要求较高的加工品质需求。滚轮材质采轴承钢(SUJ2)，经热处理淬火HRC 60° 后镀铬再研磨；硬度高、耐磨、寿命长。采用日本制精密培林，精密度高，寿命长。加装齿轮组黄油润滑装置。可配合任何送料机使用。

The upper work rollers adopt 4 point micrometer adjustment device, suitable for straightening machine precision requires high processing quality requirements. The roller shaft is made Bearing steel (SUJ2), the heat treatment quenching 60 ~ HRC after hard chromium plating and grinding; high hardness, wear resistance, long service life. The Japanese system of precision bearing, High precision, long service life. Add gear lubrication system. Can be used with any feeding machine.



上齿轮座可掀开式设计，方便滚轮清洁与保养



17根小直径工作滚轮

17根小直径工作滚轮消除卷材的弯曲应力，确保精密加工所需的高平坦度

辅助滚轮

对应材料宽度200mm、300mm之RUS-200F、RUS-300F系列产品，额外配备了辅助滚轮，用以抑制工作滚轮的弯曲，强化了矫平的精密性。

17 Smaller Diameter Work Rolls

17 smaller diameter work rolls remove the coil set from the material and ensure the high level of material flatness that precision processing demands.

Back Up Rolls

The RUS-200F and RUS-300F, which handle up to 200mm and 300mm width have additional back up rolls. These rolls will reduce the deflection of work roll making straightening performance more precise.

规格: Specification

型式	Model	RUS-200F	RUS-300F	RUS-400F	RUS-500F	RUS-600F
料宽	Material Width (mm)	200	300	400	500	600
材料厚度	Strip Thickness (mm)	0.1 ~ 1.5	0.1 ~ 1.5	0.1 ~ 1.5	0.1 ~ 1.3	0.1 ~ 1.2
材料荷重	Max. Material Weight (kg)	500	1000	1500	1500	2000
扩张范围	Extent Expansion(mm)	390 ~ 520				
材料外径	Coil O.D. (Mm)	1000	1200	1200	1200	1200
矫正滚轮	Straightener Rolls (qty)	上Upper8/下Lower9(全驱动All Drive Function)				
导料滚轮	Pinch Rolls (qty)	上1/Upper1下1/Lower 全驱动All Driven Function				
背压滚轮	Back up rolls	无N/A		有Provided		
调整装置	Adjustment	四点式分厘表微调4 Points Fine Micro Adjustment				
矫正速度	Speed Range (m/min)	22				
扩张方式	Mandrel Expansion	手动式 Manual				
感应方式	Loop Control	感应台式 Touch Sensor				
压料手臂	Air Hold Down Arm	无N/A				
供应电源	Power Supply	三相 3Phase 220V/380V/50HZ				

※规格及外观由于改进有可能在未通知时变化
※Specifications are subject to change for improvement without notice

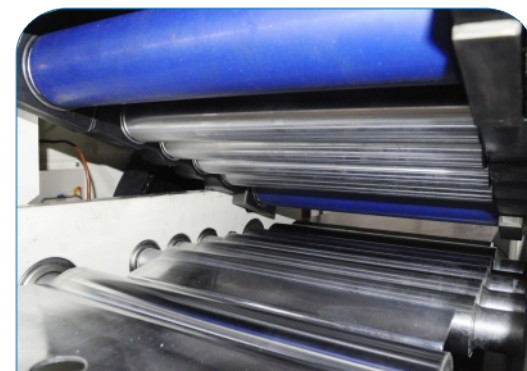
MAC1 Series

NC整平送料机

STRAIGHTENER FEEDER

对应材料的最大宽度为300mm，厚度为3.2mm。该设备集开卷、整平、送料功能为一体，面市以来一直畅销不衰，是小型高性能整平送料装置的标准机型。

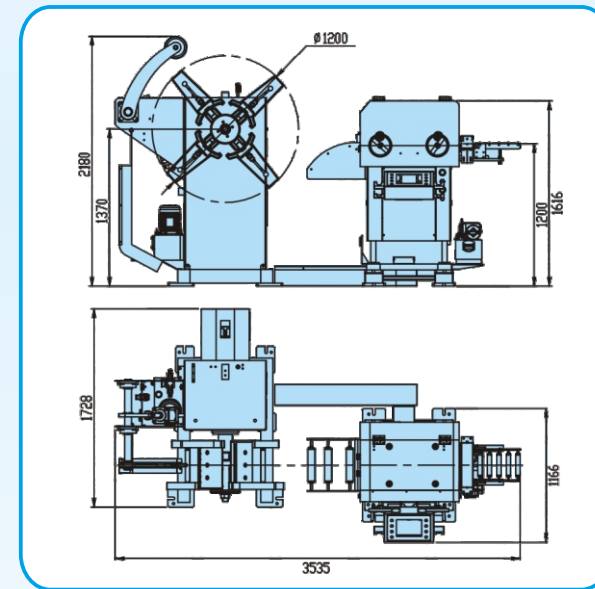
MAC1/MAC1-F handles material up to 300mm width and 3.2mm thickness. This is the standard compact, high-performance straightener feeder system, and this model has been a best seller since it was put into the market.



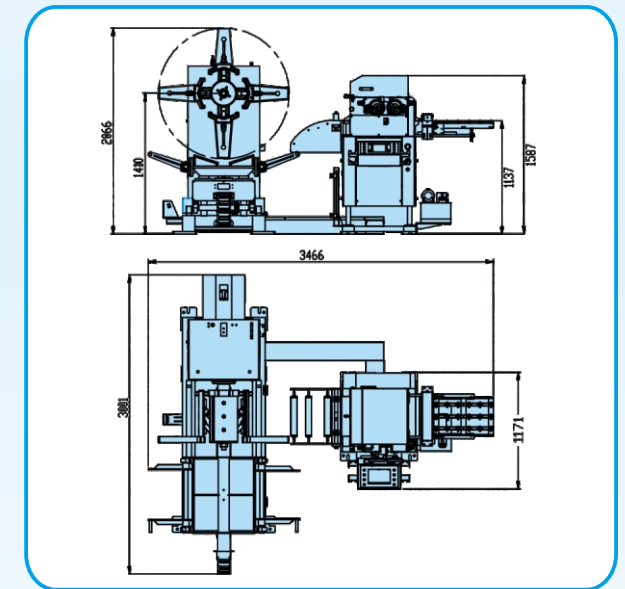
MAC1

NC整平送料机

STRAIGHTENER FEEDER



MAC1-300



MAC1-400F

整平机开口机构(选购)

通过整平上部的开口，使其维护及清扫作业变的非常容易。

Straightener port opening mechanism (Alligator Head/optional)

Maintenance and roll cleaning is made easy by an opening at the top of the straightener.

规格: Specification

型号	Model	MAC1-300	MAC1-400
板幅	Stock Width(mm)	50~300	50~400
板厚	Stock Thickness(mm)	0.2~3.0	0.2~3.0
卷材重量	Max.Coil Weight(kg)	3000	3000
卷材外径	Max.Coil O.D.(mm)	1200	1200
卷材内径	Coil I.D.(mm)	508	508
最大送料长度	Feed Length(mm)	~400※	~400※
生产线速度	Max.Line Speed(m/分)	16~24	16~24
工作滚轮	Work Roll Number(支)	Upper4/下Lower3	Upper4/下Lower3
送料滚轮	Feed Roll number(组)	1	1
主电机	Main Motor(kw)	AC2.0	AC2.0
料架扩张方式	Mandrel Expansion	※1 手动(气压)By manual (pneumatic) / 油压 hydraulic	※1 手动(气压)By manual (pneumatic) / 油压 hydraulic
料架电机	Reel Motor(kw)	1.5	1.5
使用电源电压	Power (V)	三相 3Phase 220V/380V/50HZ	三相 3Phase 220V/380V/50HZ
使用空气压	Operating Air(Mpa)	0.49	0.49

矫正能力表 Straightening performance

板厚(mm)Stock Thickness	板幅(mm)Stock Width	
0.2	300	400
0.4		
0.6		
0.8		
1.0		
1.2	250	190
1.4		
1.6		
2.0		
2.3		
3.0	160	100

※1:(气压)是选装件。气压扩缩时的卷材重量是()内的数值。
 ※1:(Pneumatic):Option in case of pneumatic mandrel expansion is provided, refer to coil weight().
 ※2:选择配置
 ※2:Optional equipment , in case of pneumatic mandrel expansion is provided, refer to coil weight().

※上表中的降服点应力为245N/mm²(拉伸强度为392N/mm²)。
 ※The above figures are the material having yield strength of 245N/mm² (tensile strength of 392N/mm²).
 ※规格及外观由于改进有可能在未通知时变化
 ※Specifications are subject to change for improvement without notice

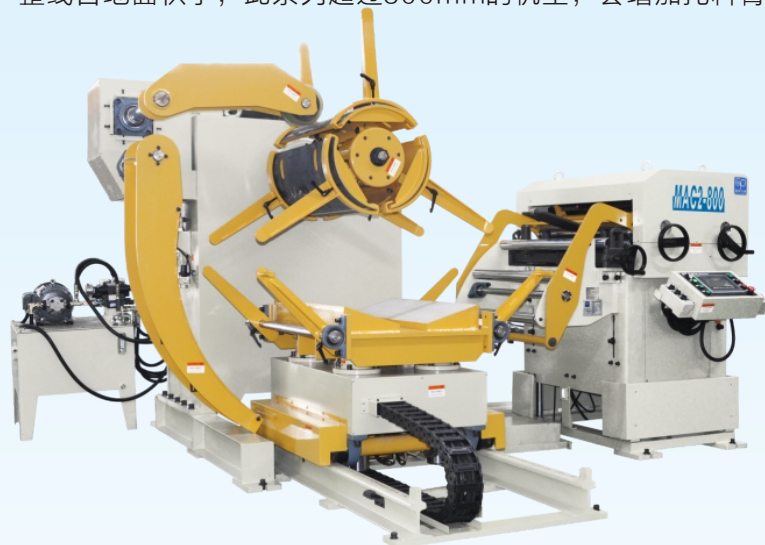
STRAIGHTENER FEEDER NC整平送料机

MAC2 Series

NC整平送料机

STRAIGHTENER FEEDER

适用于0.3~3.2mm厚度的材料进行矫直，棍系一般采用上6下5结构,目前对应材料的最大宽度为800mm. 整线占地面积小，此系列超过500mm的机型，会增加托料臂和入口压料装置，用于辅助入料；



It is suitable for punching, uncoiling, and leveling feeding of medium and thin sheet coils with a thickness of 0.3 to 3.2mm width of 50mm to 800mm. The realization of super flatness The adoption of 11 working rollers (upper 6/lower 5) realizes the highest level of flatness in the field of medium and thin plates and medium and thick plates. It can serve precision high-speed punch presses with increased demand.

直接驱动的变频控制齿轮马达

直接驱动的变频控制齿轮马达更容易变更矫正速度以配合生产线速度。并且，无链条、直接驱动之高精度齿轮的采用，使工作滚轮动态达到极限依然平稳运转。为用户生产高精度产品提供保障。

Geared Motor with Inverter Control

Geared Motor with Inverter control allows the feed speed to change easily, in addition, a direct drive mechanism without a chain and precision gear has been adopted. These features create maximum smoothness of the work roll movement producing a precise end product.



超平坦度的实现

11支工作滚轮(上6/下5)的采用，实现了中薄板中厚板领域的最高水平的平坦度。它可服务于需求增大的精密高速冲床。

High Degree of Flatness

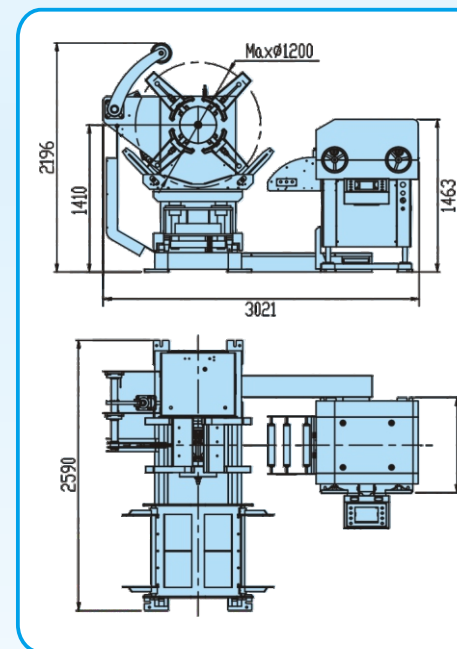
Combining the power of the heavy duty HL unit with the straightening performance of 11 work rolls(6 upper and 5 lower), the HL unit gives material a high degree of flatness to the materials from up to 6.0mm thick.



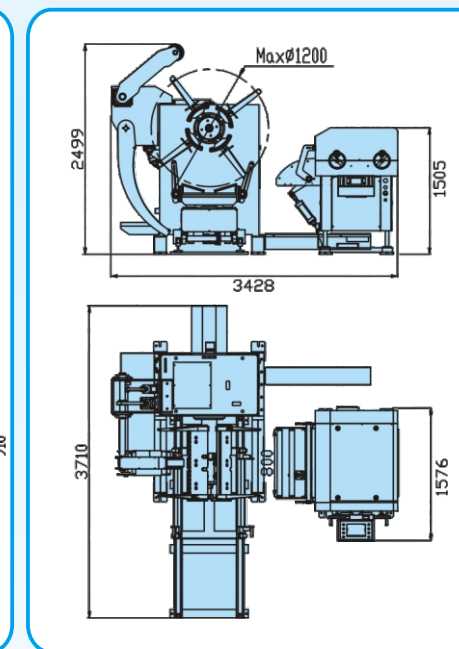
MAC2

NC整平送料机

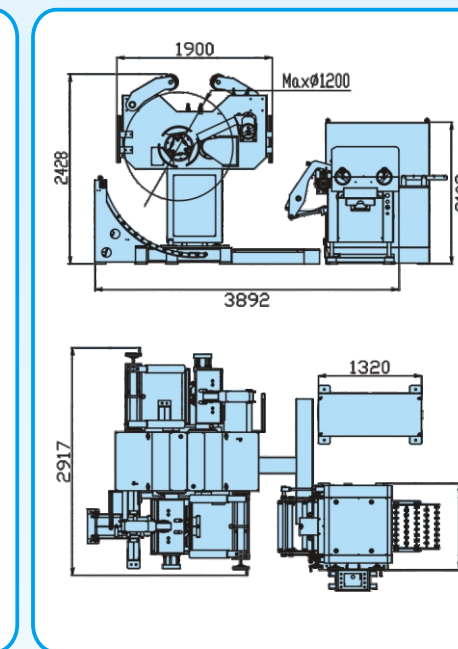
STRAIGHTENER FEEDER



MAC2-400



MAC2-800



MAC2-600SL

材料厚度 Thickness 0.3~3.2mm

规格: Specification

型号 Model	MAC2-400	MAC2-600	MAC2-800
板幅 Stock Width(mm)	50~400	50~600	50~800
板厚 Stock Thickness(mm)	0.3~3.2	0.3~3.2	0.3~3.2
卷材重量 Max.Coil Weight(kg)	3000	3000 5000	5000 7000
卷材外径 Max.Coil O.D.(mm)	1200	1200	1200
卷材内径 Coil I.D.(mm)	508	508	508
最大送料长度 Feed Length(mm)	~500※	~500※	~500※
生产线速度 Max.Line Speed(m/min)	16~24	16~24	16~24
工作滚轮 Work Roll Number(支)	上upper6/下lower5	上upper6/下lower5	上upper6/下lower5
送料滚轮 Feed Roll number(组)	1	1	1
主电机 Main Motor(kw)	AC2.9	AC4.4	AC4.4
料架扩张方式 Mandrel Expansion	油压hydraulic	油压hydraulic	油压hydraulic
料架电机 Reel Motor(kw)	1.5	1.5 2.2	2.2 3.7
使用电源电压 Power (V)	三相 3Phase 220V/380V/50HZ		
使用空气压 Operating Air(Mpa)	0.49	0.49	0.49

矫正能力表 Straightening performance

板厚(mm) Stock Thickness	板幅(mm) Stock Width	
0.3	400	600
0.4		
0.6		
0.8		
1.0		
1.2		
1.4	470	800
1.6		
1.8		
2.0		
2.3		
2.5		
2.8	300	360
3.2		
	230	300
	150	230
	110	150
	110	110

※1:(气压)是选装件。气压压缩时的卷材重量是()内的数值。

※1:(Pneumatic):Option in case of pneumatic mandrel expansion is provided, refer to coil weight().

※上表中的降服点应力为245N/mm²(拉伸强度为392N/mm²)。

※The above figures are the material having yield strength of 245N/mm² (tensile strength of 392N/mm²).

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STRAIGHTENER FEEDER NC整平送料机

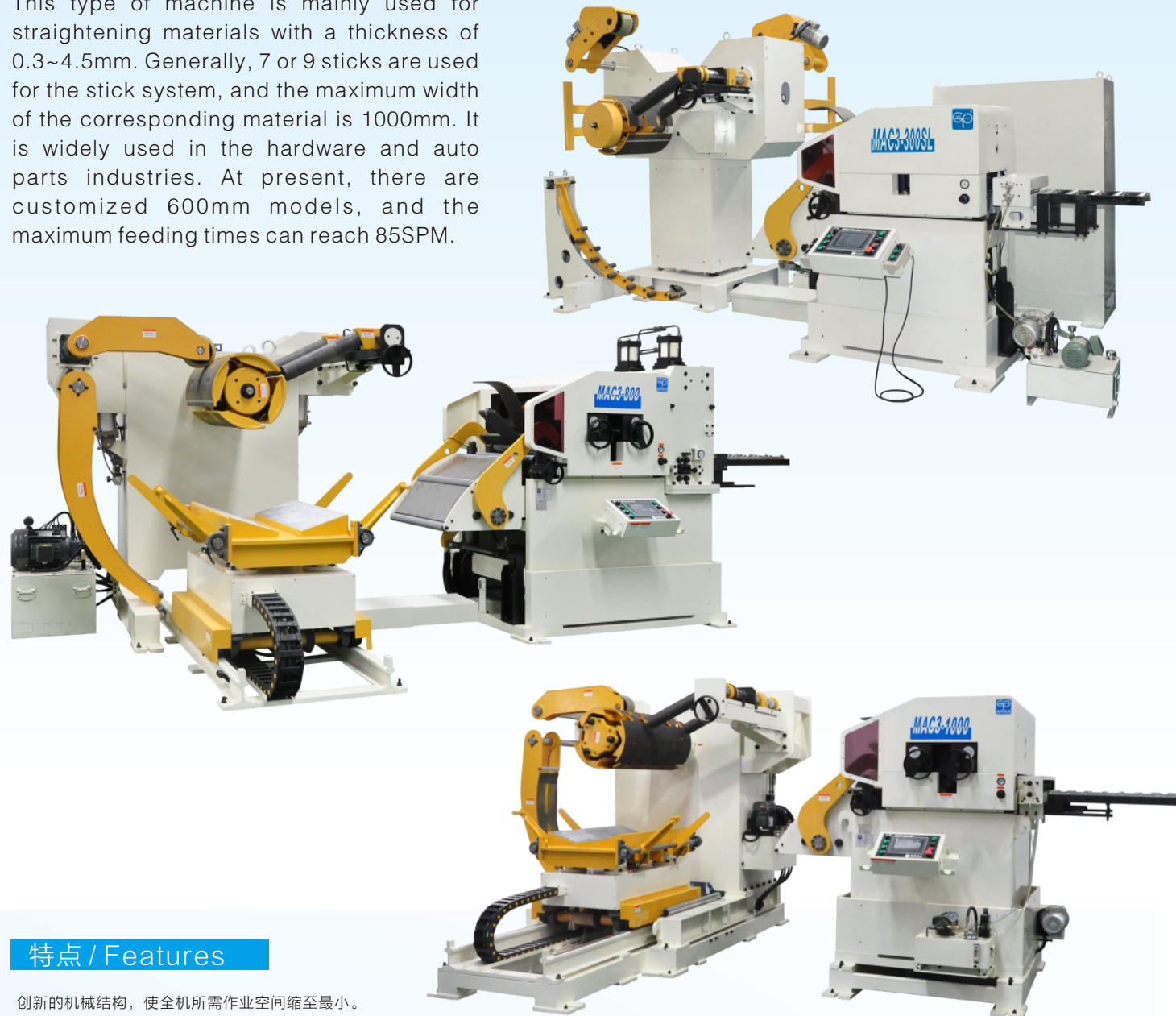
MAC3 Series

NC整平送料机

STRAIGHTENER FEEDER

此类机型主要针对0.3~4.5mm厚度的材料进行矫直，棍系一般采用7支或9支,对应材料的最大宽度为1000mm。广泛应用于五金、汽车零部件行业。目前有客户定制600mm机型，最高送料次数可达85SPM。

This type of machine is mainly used for straightening materials with a thickness of 0.3~4.5mm. Generally, 7 or 9 sticks are used for the stick system, and the maximum width of the corresponding material is 1000mm. It is widely used in the hardware and auto parts industries. At present, there are customized 600mm models, and the maximum feeding times can reach 85SPM.



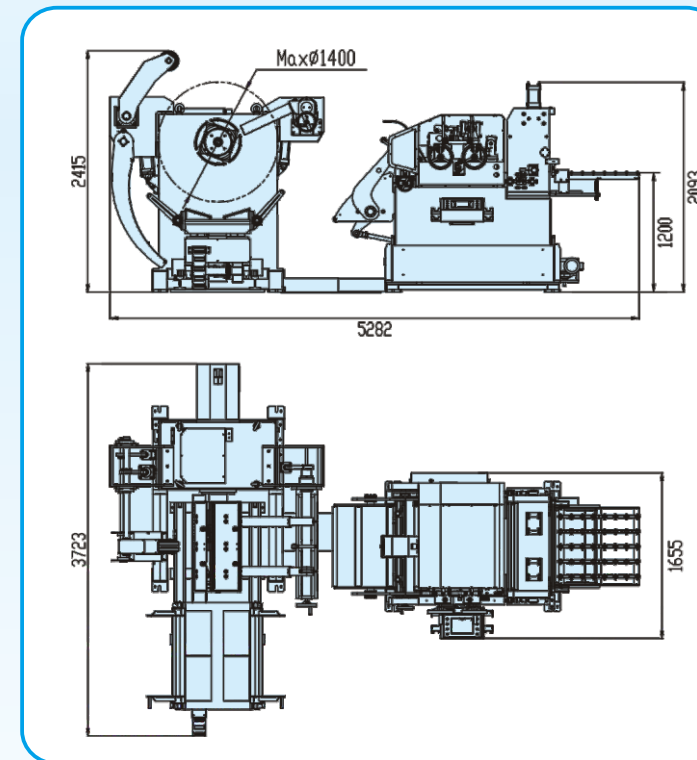
特点 / Features

- 创新的机械结构，使全机所需作业空间缩至最小。
New concept and design reduces space requirements.
- 采用人机界面，操作简单，方便送料。
Human machine interface, Simple to operate, easy material feed,
- 采用日系伺服马达，确保高精度送料。
Japanese servo motor, Guarantee very high material feed precision.
- 送料滚轮及整平滚轮经特殊热处理，硬度高（HRC60°）、耐磨、寿命长。
Feeder rollers and level rollers have undergone special heat treatment for high precision leveling, hard-chrome plated and ground with min. HRC 60°、Uses in the process wear-resisting. The service life is long.
- 多样的机种选择，更适合冲床大小及作业的需求。若有特殊规格需求，本公司亦可承制。
Special order options available for all press sizes, ex save material with the Zig Zag Electronic Roller Feeder.

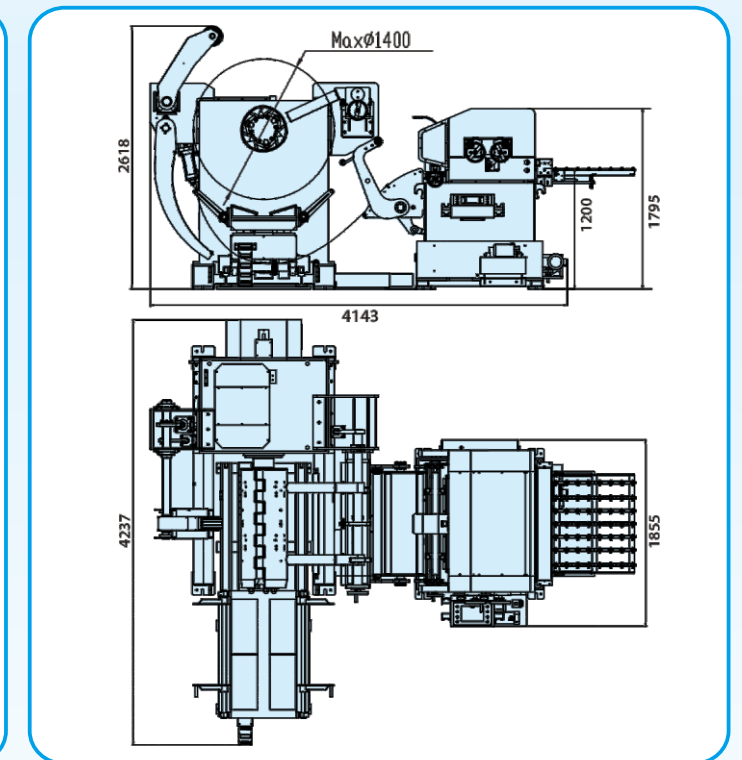
MAC3

NC整平送料机

STRAIGHTENER FEEDER



MAC3-800



MAC3-1000

材料厚度 Thickness 0.3~4.5mm

规格: Specification

型号 Model	MAC3-400	MAC3-600	MAC3-800	MAC3-1000
板厚 Stock Thickness(mm)	0.3~4.5	0.3~4.5	0.3~4.5	0.3~4.5
板幅 Stock Width(mm)	50~400	50~600	70~800	70~1000
卷材重量 Max.Coil Weight(kg)	5000	5000	5000 7000	7000
卷材外径 Max.Coil O.D.(mm)	φ 1400	φ 1400	φ 1400	φ 1400
卷材内径 Coil I.D.(mm)	φ 508	φ 508	φ 508	φ 508
最大送料长度 Feed Length(mm)	~500※	~500※	~500※	~500※
生产线速度 Max.Line Speed(m/min)	16~24	16~24	16~24	16~24
工作滚轮 Work Roll Number(支)	上up4/下down3	上up4/下down3	上up4/下down3	上up4/下down3
送料滚轮 Feed Roll number(组)	1	1	1	1
主电机 Main Motor	AC4.4	AC4.4	AC5.5	AC7.5
料架扩张方式 Mandrel Expansion	油压hydraulic	油压hydraulic	油压hydraulic	油压hydraulic
料架电机 Reel Motor(kw)	2.2	2.2	2.2 3.7	3.7
使用电源电压 Power (V)	三相 3Phase 220V/380V/50HZ			
使用空气压 Operating Air(Mpa)	0.49	0.49	0.49	0.49

矫正能力表 Straightening performance

型号Model	MAC3-400	MAC3-600	MAC3-800	MAC3-1000
板厚(mm) Stock Thickness	0.3~0.8			1000
	1.0		800	750
	1.2		700	600
	1.6	400	590	480
	1.8		500	420
	2.0		430	370
	2.3		360	320
	2.8	370	290	250
	3.2	300	250	220
4.5	160	160	150	110

※上表中的降服点应力为245N/mm²
※The above figures are the material having yield strength of 245N/mm² max.

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STRAIGHTENER FEEDER NC整平送料机

MAC4 Series

NC整平送料机

STRAIGHTENER FEEDER

此类机型主要针对0.6~6.0mm厚度的材料进行矫直，棍系一般采用7支或9支,对应材料的最大宽度为2000mm. 适合于各种五金、电子、电器、模具及汽车零件之连续冲压加工，送料矫正，准确耐用；

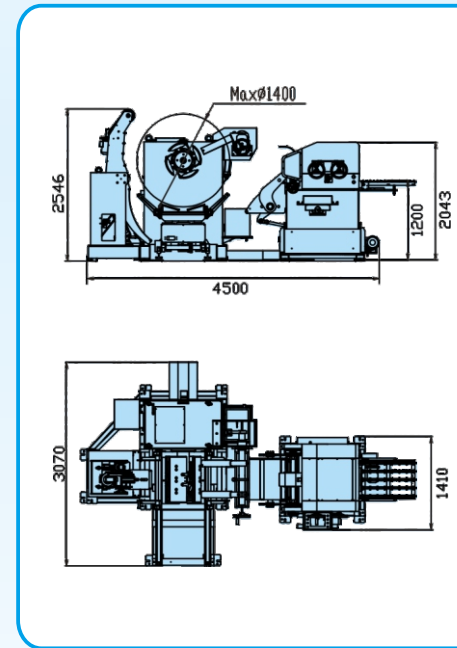
This type of machine is mainly used for straightening materials with a thickness of 0.6~6.0mm. Generally, 7 or 9 sticks are used for the stick system, and the maximum width of the corresponding material is 2000mm. Suitable for continuous stamping processing of various hardware, electronics, electrical appliances, molds and auto parts, feeding correction, accurate and durable;



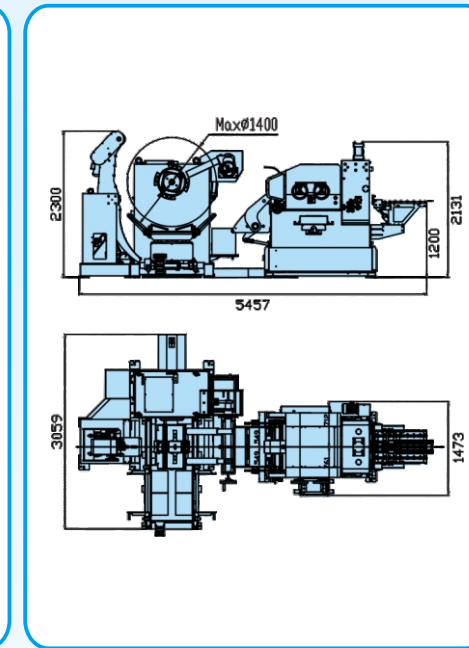
MAC4

NC整平送料机

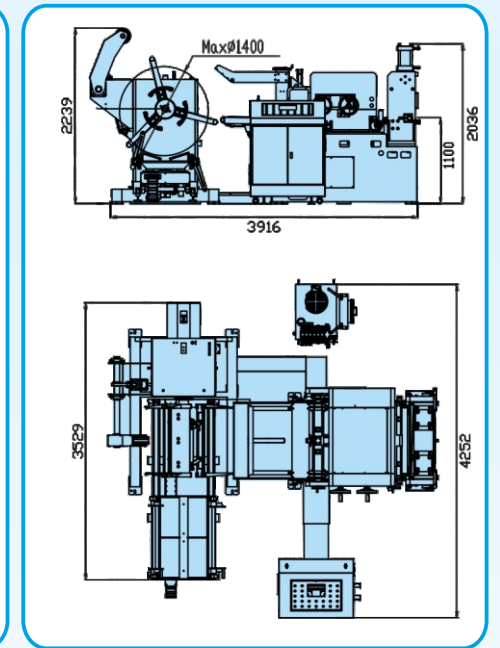
STRAIGHTENER FEEDER



MAC4-600



MACJ4-600



MAC4-800S

材料厚度 Thickness 0.6~6.0mm

规格: Specification

型号 Model	MAC4-400	MAC4-600	MAC4-800	MAC4-1000	MAC4-1300
板幅 Stock Width(mm)	70~400	70~600	70~800	70~1000	70~1300
板厚 Stock Thickness(mm)	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0
卷材重量 Max.Coil Weight(kg)	5000	5000	7000	7000	7000
卷材外径 Max.Coil O.D.(mm)	1400	1400	1400	1400	1400
卷材内径 Coil I.D.(mm)	~508※	~500※	~508※	~500※	~500※
最大送料长度 Feed Length(mm)	16~24	16~24	16~24	16~24	16~24
生产线速度 Max.Line Speed(m/min)	Upper4/Flower3	Upper4/Flower3	Upper4/Flower3	Upper4/Flower3	Upper4/Flower3
工作滚轮 Work Roll Number(支)	1	1	1	1	1
送料滚轮 Feed Roll number(组)	AC5.5	AC7.5	AC7.5	AC11.0	AC11.0
主电机 Main Motor	油压hydraulic	油压hydraulic	油压hydraulic	油压hydraulic	油压hydraulic
料架扩张方式 Mandrel Expansion	2.2	2.2	3.7	3.7	3.7
料架电机 Reel Motor(kw)	0.49	0.49	0.49	0.49	0.49
使用电源电压 Power (V)	三相 3Phase 220V/380V/50HZ				
使用空气压 Operating Air(Mpa)					

矫正能力表 Straightening performance

型号 Model	MAC4-400	MAC4-600	MAC4-800	MAC4-1000	MAC4-1300			
板厚(mm) Stock Thickness	0.6~1.3	400	600	800	1000	1300		
	2.0					1170		
	2.3					933		
	2.5							
	2.8							
	3.2					714	714	714
	4.0					457	457	457
	4.5					361	361	361
	5.0					293	293	293
6.0	203	203	203					

※ 上表中的降服点应力为392N/mm²
※ The above figures are the material having yield strength of 392N/mm² max.

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MAC4-F Series

整平送料机

STRAIGHTENER FEEDER



具有高刚性、高平坦度11支工作滚轮
With high rigidity and High Flatness the 11 work rolls

对应材料最大宽度600~1300mm、厚度6.0mm。采用11支工作滚轮提高了整平信赖性、使薄板~中厚板极其平坦、及框架刚性的强化更使高强度材的矫正成为可能、可对应高精度、高速冲床。大角度开口机构可方便地进行滚轮的清扫、维护作业。为提高薄板~中厚板冲压效率及生产性、最新机型 MAC4 - F系列诞生了。

This series handles material from 600mm to 1,300mm wide and up to 6.0mm thick. The 11 work rolls offer an extraordinary level of flatness to the materials. The HL series featured that adapting all rolls driven with universal joint (MAC4-F) and strengthen body frame for straightening high tension materials. A straightener port opening mechanism has been added, allowing for improved maintenance and cleaning the rolls. The HL series underwent a new model for meeting the demand of both productivity and efficiency in pressroom.



可打开工作滚轮机构

以出口处变芯轴为轴心最大可打开20度。大开口使滚轮的清扫作业变的非常容易。内部构造一目了然，机构深处的检查、维护更加方便。

Easy Access to Work Rolls

The work rolls on the HL can be opened to a maximum of 20 degrees, making roll cleaning much easier. The machine was designed to allow easy access to the inside structure for improved maintenance.



卷料头压平装置

操作少力，增加安全性，将卷料前端面压平，方便材料进入滚轮。

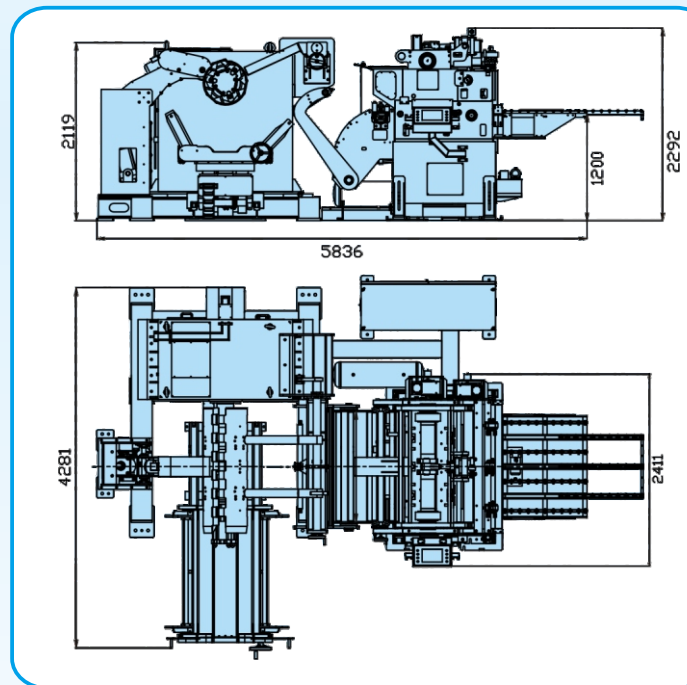
Coil Material Entry Support Assembly

Save Man Power Increase Safety, Easily move the material into pinch rollers.

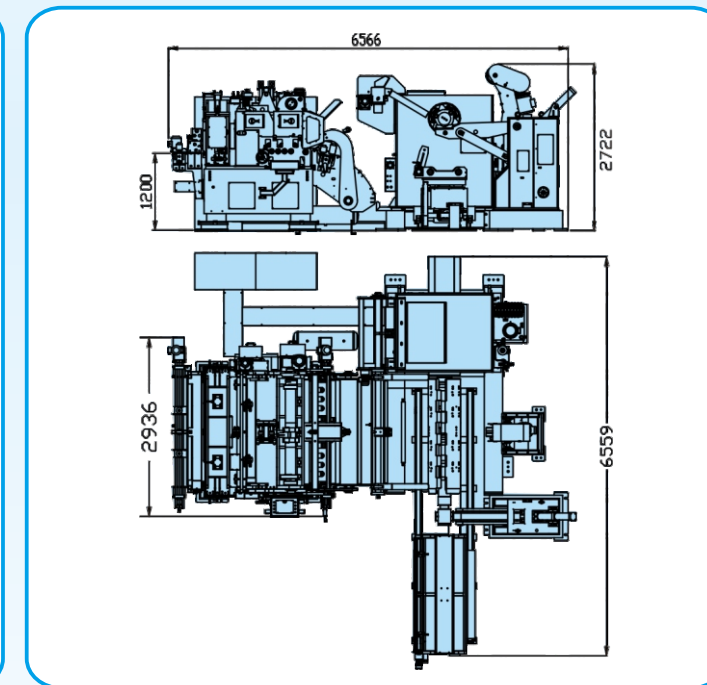
MAC4-F

整平送料机

STRAIGHTENER FEEDER



MAC4-1300F



MAC4-1700H

规格: Specification

型号 Model	MAC4-600F	MAC4-800F	MAC4-1000F	MAC4-1300F	MAC4-600H	MAC4-800H	MAC4-1000H	MAC4-1300H
板幅 Stock Width(mm)	70~600	70~800	70~1000	70~1300	70~600	70~800	70~1000	70~1300
板厚 Stock Thickness(mm)	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0	0.6~6.0
卷材重量 Max.Coil Weight(kg)	5000	5000	7000	10000	5000	5000	7000	10000
卷材外径 Max.Coil O.D.(mm)	1400	1400	1400	1400	1400	1400	1400	1400
卷材内径 Coil I.D.(mm)	508	508	508	508	508	508	508	508
最大送料长度 Feed Length(mm)	~500*	~500*	~500*	~500*	~500*	~500*	~500*	~500*
生产线速度 Max.Line Speed(m/min)	16~24	16~24	16~24	16~24	16~24	16~24	16~24	16~24
工作滚轮 Work Roll Number(支)	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5	Upper6/Downer5
送料滚轮 Feed Roll number(组)	1	1	1	1	1	1	1	1
主电机 Main Motor	AC7.5	AC11.0	AC11.0	AC11.0	AC15.0	AC15.0	AC15.0	AC22.0
料架扩张方式 Mandrel Expansion	油压Hydraulic	油压Hydraulic	油压Hydraulic	油压Hydraulic	油压Hydraulic	油压Hydraulic	油压Hydraulic	油压Hydraulic
料架电机 Reel Motor(kw)	2.2	2.2	3.7	7.5	2.2	2.2	3.7	7.5
使用电源电压 Power (V)	三相 3Phase 220V/380V/50HZ							
使用空气压 Operating Air(Mpa)	0.49	0.49	0.49	0.49	0.49	0.49	0.49	0.49

*送料长度超过500mm时，需要交替运转切换(选择件)

*In Case Feeding length is 500mm or longer, MASTER CONTROL Funlion (Option) must be provideo.

矫正能力表(高涨力材): Straightening performance(For High tention materials)

型号Model	MAC4-600F	MAC4-800F	MAC4-1000F	MAC4-1300F	MAC4-600H	MAC4-800H	MAC4-1000H	MAC4-1300H
板厚(mm) Stock Thickness	2.3	255	252	250	246	558	558	558
	2.5	232	230	228	225	472	472	472
	2.8	205	203	202	199	376	376	376
	3.2	177	175	174	171	288	288	288
	4.0	138	136	135	133	184	184	184
	4.5	120	119	118	116	148	148	148
	5.0	106	105	104	103	118	118	118
6.0	81	81	81	81	82	82	82	

*上表中的降服点应力为600N/mm²

*The above figures are the material having yield strength of 600N/mm² max.

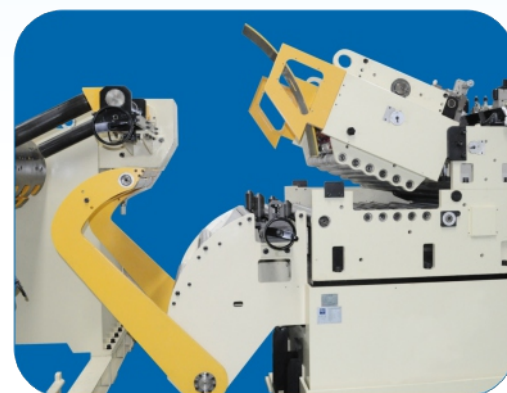
*规格及外观由于改进有可能在未通知时变化

*Specifications are subject to change for improvement without notice

MAC5 Series

NC整平送料机

STRAIGHTENER FEEDER



9支工作滚轮 9 Work Rolls

PV体现了送料技术的一个新层次，由于机器属重力型兼有9支工作滚轮，从而拥有了处理厚度达9mm材料的能力，获得高次元的平坦度。

The PV represent a new standard in feeding technology, with the ability to handle Plate up to 9.0mm(0.35") thick, Combining the power of the heavy-duty PV unit with the straightening performance of 9 work rolls (5 upper and 4 lower), the PV gives material a high degree of flatness.

滚轮开口装置

Easy Access to Work Rolls

PV工作滚轮以出口处变芯轴为轴心，最大可打开20度，使得清扫作业更容易。同时，机器的内部构造一目了然，更好的改善了机构深处的检查，维护作业。

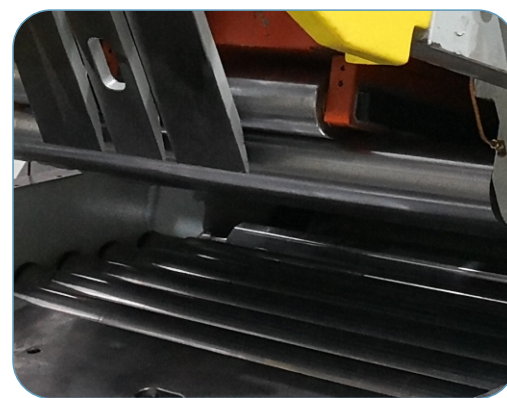
The work rolls on the PV can be opened to a maximum of 20 degrees, making roll cleaning much easier. The machine was designed to allow easy access to the inside structure for improve maintenance.

电动调整矫正量

Electronic Straightening Adjustment

以电动式的矫正量调整取代之前的手动式转柄矫正量调整，使得操作更加容易。

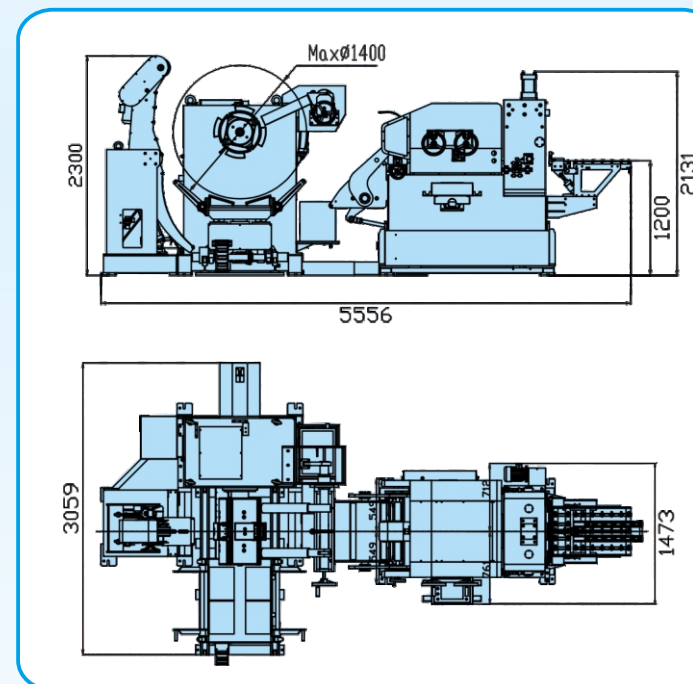
The PV features an automatic system, for straightening adjustment, unlike previous models which adjusted straightening with manual wheels. The new electronic straightening system is easy to use and allows for faster setting up.



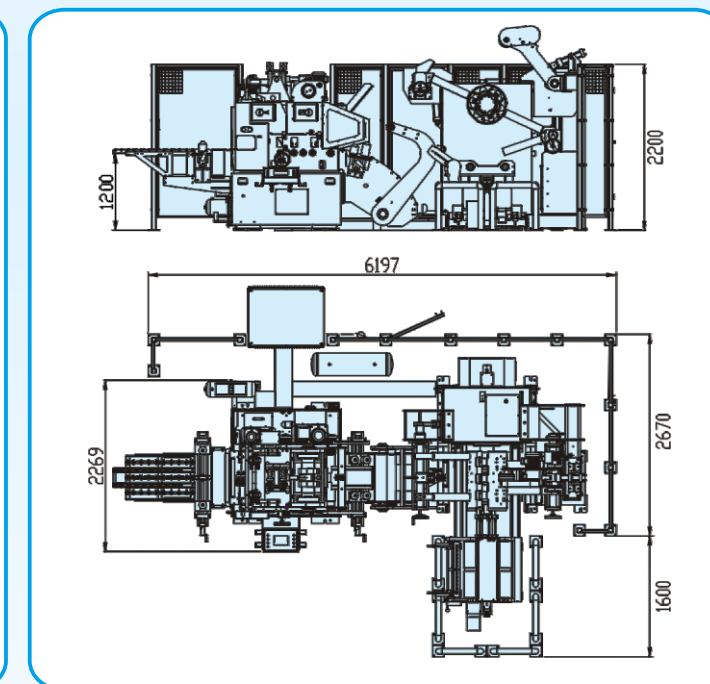
MAC5

NC整平送料机

STRAIGHTENER FEEDER



MACJ5-600



MAC5-600H

强力厚板专用 Thickness 0.8 ~ 9.0mm

规格: Specification

型号	Model	MAC5-600H	MAC5-800H	MAC5-1000H	MAC5-1300H
板副	Stock width (mm)	100~600	100~800	100~1000	100~1300
板厚	Stock Thickness (mm)	0.8~9.0	0.8~9.0	0.8~9.0	0.8~9.0
卷材重量	Coil Weight(kg)	5000	7000	10000	10000
卷材外径	Max Coil O.D.(mm)	Φ 1400	Φ 1400	Φ 1400	Φ 1400
卷材内径	Coil I.D.(mm)	Φ508	Φ508	Φ508	Φ508
最大送料长度	Feed Length (mm)	0~500	0~500	0~500	0~500
生产线速度	Max Speed (m/min)	22	22	22	22
工作滚轮	Work Roll	上Upper 5/下Lower4	上Upper 5/下Lower4	上Upper 5/下Lower4	上Upper 5/下Lower4
送料滚轮	Feed Roll	上Upper 1/下Lower1	上Upper 1/下Lower1	上Upper 1/下Lower1	上Upper 1/下Lower1
主电机	Main Motor(kw)	AC22	AC22	AC30	AC30
料架扩张方式	Uncoil Expansion	液压 Hydraulic	液压 Hydraulic	液压 Hydraulic	液压 Hydraulic
料架电机	Uncoil Motor(kw)	5.5	7.5	11	22
工作电源电压	Power (V)	AC380/50HZ	AC380/50HZ	AC380/50HZ	AC380/50HZ
工作空气压力	Primary Air (Mpa)	0.5	0.5	0.5	0.5

矫正能力表 Straightening performance

型号Model	MAC5-600H	MAC5-800H	MAC5-1000H	MAC5-1300H
板厚(mm) Stock Thickness	0.8			
	1.4			
	1.6			
	1.8			
	2.0	600		
	2.3		800	
	2.8			1000
	3.2			
	4.0			
	4.5		648	800
	5.0	530	530	530
6.0	450	450	450	
7.0	331	331	331	
8.0	253	253	253	
9.0	200	200	200	

※上表中的降服点应力为245N/mm²
※The above figures are the material having yield strength of 245N/mm² max.

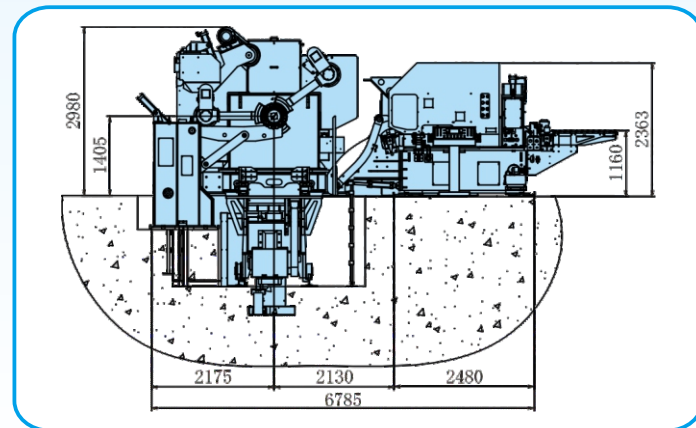
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STRAIGHTENER FEEDER 整平送料机

MAC6 Series

NC整平送料机

STRAIGHTENER FEEDER



MAC6-1000F



规格: Specification

型号 Model	MAC6-600H	MAC6-800H	MAC6-1000H
板幅 Stock width (mm)	100~600	100~800	100~1000
板厚 Stock Thickness (mm)	2.0~12	2.0~12	2.0~12
卷材重量 Coil Weight Max. (Max.)(kg)	7000	7000	10000
卷材外径 Coil O.D.Max.(mm)	Φ 1400	Φ 1400	Φ 1400
卷材内径 Coil I.D.(mm)	Φ 508	Φ 508	Φ 508
最大送料长度 Feed Length (mm)	1~500	1~500	1~500
生产线速度 Line Speed Max. (Max.)(m/分)	16	16	16
工作滚轮(支) Number of Work Rolls	上Upper3/下Lower3	上Upper3/下Lower3	上Upper3/下Lower3
送料滚轮(组) Number of Feed Rolls	上Upper1/下Lower1	上Upper1/下Lower1	上Upper1/下Lower1
主电机 Main Motor (kw)	AC22	AC30	AC37
料架扩充方式 Mandrel Expansion	液压 Hydraulic	液压 Hydraulic	液压 Hydraulic
料架电机 Reel Motor (kw)	7.5	7.5	11
使用电源电压 Power Supply (v)	AC380/50HZ	AC380/50HZ	AC380/50HZ
使用空气压 Operating Air (Mpa)	0.5	0.5	0.5

※规格及外观由于改进有可能在未通知时变化
※Specifications are subject to change for improvement without notice

矫正能力: Straightening performance

型号 Model	MAC6-600H	MAC6-800H	MAC6-1000H
板厚 Stock Thickness (mm)	2.0~4.5	2.0~4.5	2.0~4.5
5	600	800	1000
6			700
7		610	610
8	480	480	480
9	390	390	390
10	320	320	320
11	270	270	270
12	200	200	200

※上表中的降服点应力为245N/mm² (拉伸强度为392N/mm²)
※The above figures are the material having yield strength of 245N/mm² (tensile strength of 392N/mm²).

OTHERS

INFORMATION

Control panel



从设定准备阶段到运转, 保养所需要的资讯, 由设定, 准备, 运转, 保养 4 种基本模式来进行一元化管理。是搭载各种新技能, 用以对应制品的多样化, 高度化, 缩短作业时间的综合作业系统。

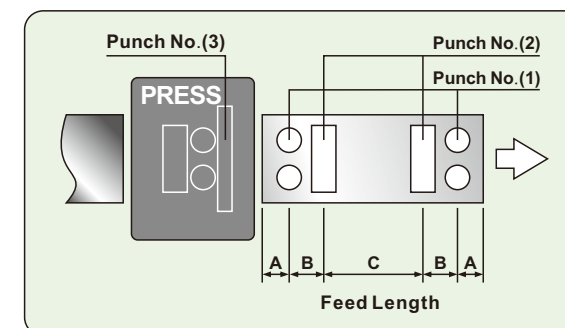
This control panel provided a total operation system for programs of setting, preparing, operation and maintenance, which designed to answer the industry's demand for advancement and diversification of coil handing with high level and efficiency.

Information of RUIHUI & Today

复数式模具选择 Programmable Punch Gaging

RUIHUI 合理化技术的投入使用, 满足了冲压机多段送料的强烈需求。

用户可设定每一段的送料长度、冲压次数、模具编号、加工条件等。1组最大可设 99段, 至50组(总共)到500段)。复数冲压加工及送料机的设置操作越发简便。



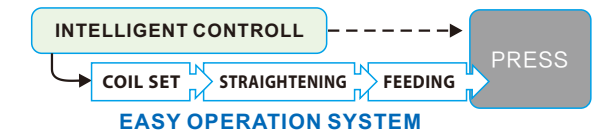
Provided to allow the user to program the feed length, press stroke number, die codes and status of press operation, This setting can be set for every procedure. Maximum of 99 programmed procedures can be used to produce a single part, up to 50parts.(Total programmed procedure can be 500.) Thus,the intricate press and feeder set-up operation becomes easier.

全自动化系统 Fully Automated System

送料装置采用RUIHUI高新技术, 实现了从卷材设定到送料的全自动华运作。

根据“工序设定功能”, 预先设定矫正量(采用 ASC 装置来自动调整矫正量)、送料长度等参数, 使卷材从设定到整平、送料一系列动作自动、精确运行。其简单、易用的特性大减轻了现场操作人员的负担。

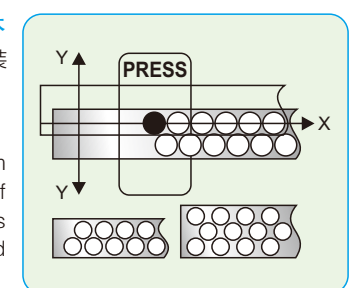
The coil setting, straightening, and feeding of coiled material is fully automated by part number entry that has pre-set programmed parameters. This user friendly feature unburdens the operator and saves costly change-over time.



左右移动式送料 Zig-Zag Feed

大幅度提高了成品率, 降低材料成本
该特制送料系统(选装)可移动送料装置进行左右移动式送料, 达到废料最小化, 降低材料成本。

This specialized feeding system shifts the feeder so nestong of blanks from a single die provides the user minimum scrap and maximum blank yield.



RBT-2 SERVO

2轴伺服机械手

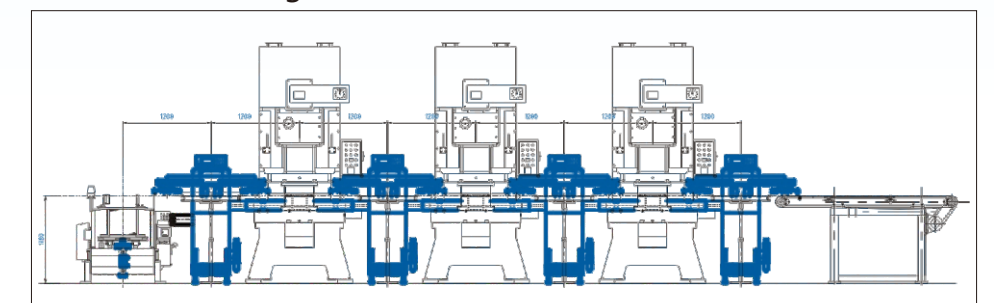


技术规格 : Specification

型号	Model	RBT-2	RBT-2
送料行程	Feed Length (mm)	~1200	~1500
升降幅度	Up/Down Stroke (mm)	~100	~100
循环时间	Cycle Time (sec)	1.7~	2.5~
最大工件重量	Max. Workpiece Weight (kg)	4.0×2	4.0×2
往返送料精度	Repeatability (mm)	±0.3	±0.3
动力源驱动加伺服电机	Motor Power (kw)	2.0进给(送料用) 2.0上下(上下用)	
工件抓取方法	Workpiece Pick Up	真空吸盘·电磁吸盘(Vacuum·Magnet)	
主机重量	Machine Weight (kg)	约400	

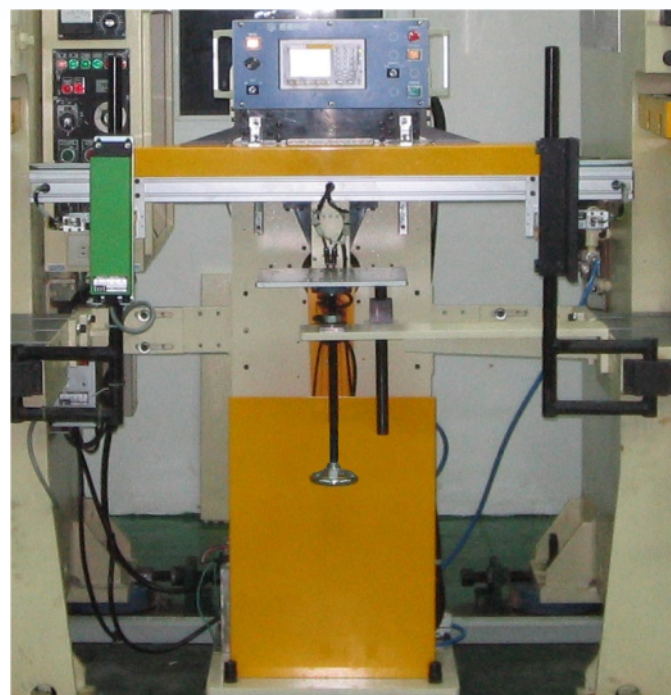


参考图 : Ref.Diagram



具有极高的自由度，是冲床间材料搬运的新一代生力军。

二轴伺服电机驱动



※规格及外观由于改进有可能在未通知时变化
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COIL MULTISTAGE COMPOUND PRODUCTION LINE

卷料多工位复合式生产线

主要特点:

- ※ 生产模式多样化
- ※ 料垛自动切换, 可不停机
- ※ 移送横杆一键自动拆装
- ※ 节省劳动力, 降低成本
- ※ 提高生产效率和产品质量的稳定性

Main features:

- ※ Diversification of production mode
- ※ Material automatic switching with machine keep working.
- ※ Transfer bar exchange automatic by one key
- ※ Save labor, lower the cost
- ※ To improve the stability of production rate and product quality.

组成:

- ※ 开卷机构
- ※ 校平装置
- ※ 定尺送料
- ※ 数控涂油装置
- ※ 双工位拆垛机构
- ※ 三次元双横杆驱动机构
- ※ 多工位压力机
- ※ 冲压模具
- ※ 产品输出机构
- ※ 整线安全防护

Constitute:

- ※ Uncoiling device
- ※ Leveling device
- ※ Sizing feed
- ※ Numerical control oiling device
- ※ Double station unstacking mechanism
- ※ Three dimensional double bar drive mechanism
- ※ Multiple position press
- ※ Die
- ※ Product output mechanism
- ※ Safety protection

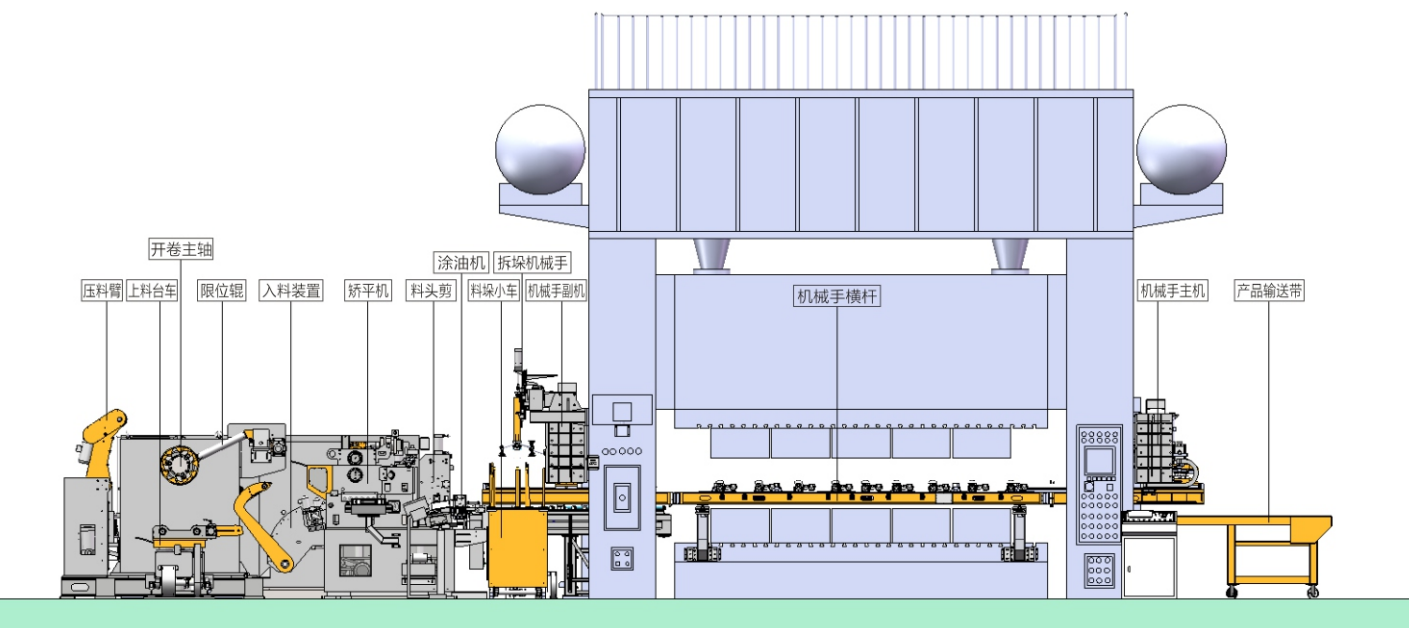
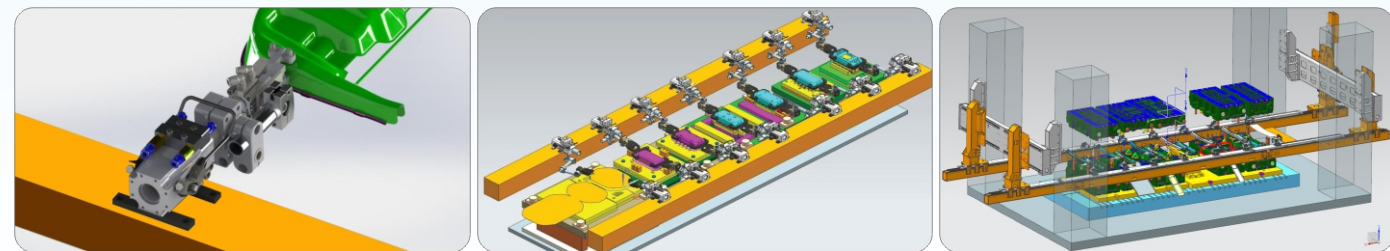
生产模式:

卷料: 开卷→校平→定尺送料→首工位落料冲压→双横杆顺序搬送冲压→产品输出
 开卷→校平→定尺送料→级进模冲压→产品输出
 片料: 双工位自动拆垛→双料检测→料片穿梭定位→双横杆顺序搬送冲压→产品输出

Production Models:

Coil material: Uncoiling–leveling–sizing feed–first station blanking punching–double bar order transfer stamping–product output
 Uncoiling–leveling–sizing feed–progressive die stamping–product output

Sheet material: Double station unstacking–double detection–shuttle positioning–double bar order transfer punching–product output



3DNC

卷料多工位复合式生产线

COIL MULTISTAGE COMPOUND PRODUCTION LINE



规格: Specification

型号	Model	3DNC602015	3DNC905025	3DNC1205530	3DNC1508030	3DNC1509030
最大料片	Max. sheet	1000*400	1100*600	1100*1000	1600*1000	1800*1000
最小料片	Min. sheet	400*200	400*200	400*300	600*300	600*300
进给行程(X)(可编程)	Feed stroke	600	900	1200	1500	1500
夹紧行程(Y)(单边可编程)	Clamp stroke	200	500	550	800	900
举升行程(Z)(可编程)	Lift stroke	150	250	300	300	300
生产节拍	Production takt	10-25	10-25	10-22	10-22	10-20
冲床吨位	Tonnage of press	800T	1000T	1200T	1600T	2500T
冲床行程	Press stroke	600	600	800	800	800
侧开口宽度	Side opening width	≥2200	≥2300	≥2300	≥3200	≥3400