

HYDRAULIC CNC TURRET PUNCH T30

T30

数控转塔冲床

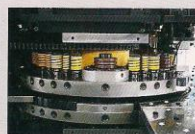
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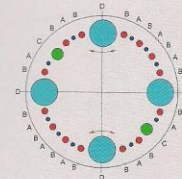
液压站
Hydraulic unit



自动旋转工位
Self-rotation station



FANUC OiP数控系统
CNC Controlling system



模具分布图
Tooling layout



气动浮动夹钳
Pneumatic floating clamp



交流伺服电机
AC servo motor

工位类别 Station types	30 工位 30 station	尺寸范围 Dimension range
A	10	Ø3 ~ Ø12.7mm
B	14	Ø12.7 ~ Ø31.75mm
C	2	Ø31.75 ~ Ø50.8mm
D	4	Ø50.8 ~ Ø88.9mm

TECHNICAL PARAMETER:

HYDRAULIC CNC TURRET PUNCH T30	
Nominal force	: 300 KN
Work piece size	: 1500×4000 mm
Max work piece weight	: 156 Kg
Max work piece thickness	: 6.35 mm
Max punch diameter	: Φ88.9 mm
Number of stations	: 30
Working accuracy	: ±0.10 mm
Max. Hit Speed	: 600 HPM
Work piece travelling speed	: 106 m/min
Turret speed	: 30 r/min
Frame construction	: Straight – side Frame
Throat depth	: 1275 mm
Number of control axis	: 4 axes (X, Y, T, C , Z)
Max rotary station punch diameter	: Φ88.9 mm
Repeatability	: 0.02 mm
Lubrication device	: Available
Number of clamp	: 2
Clamp type	: Pneumatic type
Heat treatment of the frame	: Annealing
Tool type	: Long Guide Sleeve type (AMADA)
Turret construction	: Thick turret
Power capacity	: 25 KW
Air pressure	: 0.55 Mpa
Machine dimension (L*W*H)	: 5650*4200*2010 mm
Brand New	: China

MACHINE FEATURES

- 1) Advance and reliable Hydraulic drive system can select stroke automatically corresponding to different thickness of metal sheet and is convenient to realize special process of Louver, blanking, etc. The Punch is equipped with auto Hydraulic overload protection device, and guarantees consistent pressing force for quality products.
- 2) The punch is of FANUC OIP CONTROL System.
- 3) Index stations are of worm wheel structure with max. Punching diameter of $\Phi 88.9$.
- 4) Dual Turret is of long insert structure ensuring coaxiality of the punch and dei, which gives long life to the tool and turret.
- 5) Imported pneumatic and hydraulic components guarantee reliability of the machine.
- 6) Imported ball screws with long travel and linear guide ways ensure transmission precision.
- 7) The worktable with hard brush and steel ball reduces noise and shock of the machine and protect surface of the work piece
- 8) The machine is straight-side frame, which is annealed for eliminating inner stress.
- 9) The clamps with auto protection function, in the protective zone, only excise movement without punching action for continuous operation.
- 10) Centralized lubrication devise provides lubricant oil to the desired points to reduce friction of pairing elements for long machine life.
- 11) Tool station layout consists of A, B, C, D, which is convenient for the customer and save the tool cost.
- 12) Common requirement is for site foundation preparation and machine installation is simple.

MAIN IMPORTED COMPONENTS LIST

NO	DESCRIPTION	SPECIFICATION	QUANTITY	MANUFACTURER
1	CNC CONTROL	FANUC OI PC	1 SET	JAPANESE FANUC
2	SERVO MOTOR		1 SET	JAPANESE FANUC
3	H+L CARD	HS3	1	GERMAN HYDRAULIC
4	POWER SWITCH	VCF-3	1	SCHNEIDER
5	USP	6EP1436-3BA00	1	GERMAN SIEMENS
6	EMERGENCY STOP	XB2BS542C	1	SCHNEIDER
7	FLAT BUTTON	XB2BA31C	4	SCHNEIDER
8	FLAT BUTTON	XB2BA11C	2	SCHNEIDER
9	SELECT SWITCH	XB2BG21C	1	SCHNEIDER
10	SELECT SWITCH	XB2BD33C	1	SCHNEIDER

11	PROXIMITY SWITCH	BI2-EG08-AP6X	1	TURCK
12	PROXIMITY SWITCH	BI2-M12-RP6X	2	TURCK
13	FEELER	ZB2BE102C	1	FOR EMERGENCY STOP, SCHNEIDER
14	16-CORE SHIELDED CABLE	16×0.25	30M	GERMANY
15	HYDRAULIC SYSTEM	HKL/30T	1	GERMAN H+L
16	HYDRAULIC CONNECTOR	A16-RS	1	GERMAN EMB
		A12-RS	1	GERMAN EMB
		A8-RL/WD	2	GERMAN EMB
17	BALLSCREW	R40-25B1-PFDW-1588-1750-0.012	1	HIWIN
		R40-25B1-PFDW-1588-1750-0.012	1	HIWIN
18	LINEAR GUIDEWAY	HGW25CA2R2260ZAP I	2	HIWIN
19	COUPLING	ROTEX GS 24/28 98SHA-GS 2.0- Φ19×30 2.0- Φ20×30	1	GERMAN KTR
		ROTEX GS 14 98SHA-GS1.0- Φ10×11 2.0- Φ14×11	2	GERMAN KTR
		ROTEX GS 14 98SHA-GS1.0- Φ14×11 1.0- Φ14×11	2	GERMAN KTR
		ROTEX GS 14 98SHA-GS1.0- Φ14×11 1.0- Φ14×11	4	GERMAN KTR
		ROTEX GS28/38 98SHA-GS2.5- Φ38×35/2.5- Φ35×35	1	GERMAN KTR
20	BEARING(BALLSCREW)	7205B/DB	8	JAPANESE NSK
21	BEARING (TURRET)	33220、 33117	4	FRENCH TIM
22	BEARING (INDEX STATION)	71902C	16	JAPANESE NSK
23	OIL SEAL	10×17×3	4	SOG
24		15×21×3	4	SOG
		20×26×4	4	SOG
		30×40×4	11	SOG
		35×45×4	9	SOG
		38×48×4	2	SOG

25	PNEUMATIC CYLINDER	KCDQ2B80 -30D-A93L	2	KOREAN ARK
		KMDBF50-50-A54K	2	KOREAN ARK
		CDQ2KB32-30D-73L	2	JAPANESE SMC
		KCDQ2B25-40DM-A73K	2	KOREAN ARK
26	RESTRICTOR	AS1201F-M5-06	4	JAPANESE SMC
		AS3201F-02-06S	2	JAPANESE SMC
		AS2201F-03-06S	2	JAPANESE SMC
27	CONNECTOR	PC0602	2	KOREAN SANG
		PC06M5	2	KOREAN SANG
		PC1002	1	KOREAN SANG
		PL1003	2	KOREAN SANG
		PUT06	7	KOREAN SANG
		KQL06-03S	2	JAPANESE SMC
28	FLOATING CONNECTOR	JB80-16-200	2	JAPANESE SMC
29	TRI-PIECE	AC30A-03D	1	JAPANESE SMC
30	AIR PRESSURE METER	GP46-10 -01L5	1	JAPANESE SMC
31	BUS BOARD	SS5Y5 -41-05-C6	1	JAPANESE SMC
32	SOLENOID VALVE	SY5140 -5D	5	JAPANESE SMC
33	SILENCER	AN203-02	4	JAPANESE SMC
34	MULTI-CLAMP	TM	6	JAPANESE SMC
		TM	1	JAPANESE SMC
35	PLUG	KQ2P-06	1	日本SMC

FAUNC OiP CONTROL SYSTEM

1) SYSTEM CONFIGURATION

- A) Step punch function, graphic function, applicable program and data of CNC memory and definition 0.1μm.
- B) Simple international G code for operation.
- C) Standard RS232 interface with the PC.
- D) Advanced AC servo system and servo motor modular design for easy maintenance.
- E) Outstanding MMC dialogue function between the machine and operator.
- F) Color TFT 10.4" display.
- G) Programming on line and background programming.
- H) Distance diagnosis function.

2) SYSTEM FUNCTIONS

- A) Linear axis: X-axis, Y-axis; Rotary axis: T-axis, C-axis.
- B) Self-diagnosis function.
- C) International G code programming.
- D) Soft limit protection function and repositioning function.

- E) Pitch compensation function and reverse gap compensation function.
- F) Different operation modes such as Auto, Manual, Semi-auto, etc.
- G) Clamp protection function.
- H) Parameter programming function and subroutine recall function.
- I) Quick positioning function.
- J) Various M function and other supporting function.
- K) Absolute, incremental programming; conditional and non-conditional skip function.
- L) Warning indication for overload, overflowing, over-travel and various mechanical and electronic faults.
- M) The control system is special for CNC turret punch.

SUPPLY RANGE

- 1) One set of CNC turret punch (include 30 pair of standard Chinese tools).
- 2) Accessories with the machine:

1	Foundation iron block	: 240x240	: 6
2	Adjusting bolts	: M42x2	: 6 pairs
3	Foot pedal	: YDTF-11	: 1

- 3) Tools for machine installation and maintenance

1	Philips screwdriver		: 1
2	In-line screwdriver		: 1
4	Socket hexagon spanner	: 1.5-14	: 1 SET
5	Open spanner	: 5.5-24	: 1 SET
6	Adjustable wrench	: 12"	: 1

- 4) Documents with the machine

1	Packing list	: 1	
2	Quality certificate	: 1	
3	Instruction manual (mechanical)	: 1	
4	Instruction manual (electronically)	: 1	
5	Foundation drawing	: 1 set	: Deliver to the user upon the contract takes into effect.
6	Electrical diagram	: 1 set	
7	System documents	: 1 set	
8	Parameters Disk	: 1	
9	Auto Programming Software	: 1	

5) 32- STATION LAYOUT

Station type	Dimension range	Stations for each type
A	: $\phi 3 - \phi 12.7$	: 14
B	: $\phi 12.7 - \phi 31.75$	: 10
C	: $\phi 31.75 - \phi 50.8$	: 2
D	: $\phi 50.8 - \phi 88.9$	: 4

Note: Above-mentioned 30- station standard tools are of square, rectangle, round and oval shapes. Additional payment is for special tools.

6) Environment Conditions for the Machine

- A) Power: 380V $\pm$ 10%, 50HZ
- B) Temperature: 5 - 40°C (for machine operation)
- C) Relative Humidity: 20 – 80%RH
- D) Keep machine away from a strong shock source and electromagnetic source.
- E) Free from harmful and corrosive gas and dust.