

CNC Spring Making Machine

十一轴数控弹簧成形机

型号: CK11200(JS-Z51K-20-11)

机器特点

11轴数控弹簧机有11套伺服电机,完全抛弃了传统5轴操作繁琐的凸轮变径机构,由数控系统直接控制弹簧外径和变径,新工人易学易懂。送线机构优化了6套伺服电机,送线电机总功率达到90kw,控制系统可控制单个电机(做小线径弹簧任选)或6个电机高速同步稳定送线,卷制大线径弹簧时六组送线轮使各送线轴受力小,钢丝原外形精度不被压伤,足够的送线牵引力确保送线精度,达到了欧洲同类产品的生产速度和一致性精度;自身重量匹配足够,辅助芯刀机构采用液压锁紧功能,且升降后由液压顶紧固定,操作方便,震动小,切口精度高;换钢丝后钢丝弯头机构加快弹簧第一圈弯圆;直切、对切、摆切、扭切功能齐全;控制系统匹配远程互联网络接口,软件具有图示化自动编程模板,输入所需数值后,系统自动生成弹簧程序,略加修改就可完成所需卷制的弹簧。可配备影像检测仪。

技术参数 Specification

型号 Model	CK11200	
Servo Axes 伺服轴数	11	
Wire Diameter 线径范围(mm)	10.0-20.0	
Outside Diameter 最大外径(mm)	250	
Wire Feed Length 送料长度	Limitless 无限	
Wire Feed Speed 送料速度(m/min)	96	
Production Rate 生产速度(pcs/min)	可生产汽车悬架簧 18-23	
Left or Right Winding Rate 左右旋绕比(Dm/d)	3	
Wire Feed Cam 送料轮(组)	6	
Wire Feed Axis 送料轴(kw)	15×6	
Diameter Axis 外径轴(kw)	7×2	
Pitch Axis 节距推刀轴(kw)	5.5	
Upper Cutting Axis 上切刀轴(kw)	30	
Lower Cutting Axis 下切刀轴(kw)	30	
Servo Motor 伺服马达总动力(kw)	169.5	
Dimensions 机器尺寸	长L (mm)	4600
	宽W (mm)	2600
	高H (mm)	3000
Machine Weighing Weight 机器过磅重量(kg)	32000	

说明: 机器过磅重量是主机重量(不含送线架、电柜、刀具和附件的重量)。

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Machine Features

The 11-axis CNC spring machine has 11 sets of servo motors, completely abandoning the traditional 5-axis operation of the cumbersome cam reducing mechanism. The numerical control system directly controls the outer diameter and the variable diameter of the spring and the new workers are easy to learn and understand. The feeding system has 6 sets of servo motors optimized for the 6-axis function. The total power of the wire-feeding motor reaches 90kw. The control system can control a single motor (optional for small-diameter springs) or 6 motors for high-speed feeding wires synchronously and stably. When the large-diameter spring is rolled, the six sets of wire feeding wheels make the force of each wire feeding shaft small, the original shape accuracy of the steel wire is not crushed, and the sufficient wire pulling force ensures the wire feeding precision, achieving the production speed and consistency accuracy of similar products in Europe; the weight matching is sufficient, and the auxiliary core knife mechanism adopts the hydraulic pressure. The locking function is fixed by the hydraulic top after lifting, the operation is convenient, the vibration is small, and the cutting precision is high; after the wire is changed, the wire elbow mechanism accelerates the first circle of the spring; the straight cutting, the cutting, the cutting, the twisting function Complete; the control system matches the remote internet interface. The software has a graphical automatic programming template. After inputting the required values, the system automatically generates a spring program, which can be used to complete the required rolling spring. Can be equipped with an image detector.



送线机构为6套伺服电机送线



封闭型安全防护送料架



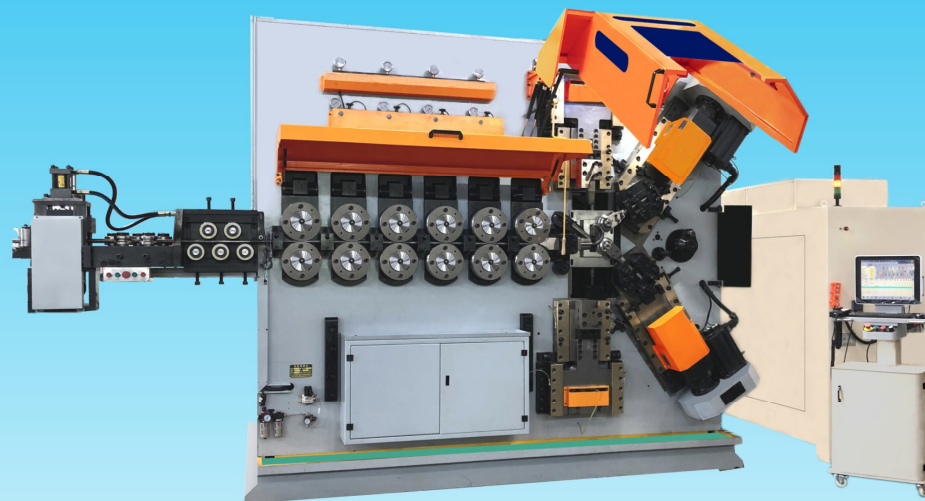
CK11200

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十一轴数控弹簧成形机

发明专利技术

Invention patent technology



● 本样本的外观、参数等如有更改,以实物和协议为准。