

# CNC Wire Rotating Spring Forming Machine

## 数控弹簧转线成形机

型号: CNC642A 型(JS-Z50K-4.2-ZX-6)

### 机器特点

CNC642A型数控万能弹簧转线成形机采用电脑控制系统和五套伺服马达, 凸轮轴、送线轴、转芯轴、转线轴、辅助轴, 实现五轴联动, 八个工位连续工作, 标准五轴。(可配卷曲装置及二次成形加工座)适合于生产各种压簧、矩形簧、钢皮涡簧、塔形簧、双扭簧、扁簧等高难度异形弹簧, 极大的增加了弹簧加工范围。有跟踪检测功能, 如有不合格产品能自动停机。

### 技术参数 Specification

型号 Model	CNC642A	
Wire Diameter(mm) 线径 (mm)	Φ1.4-Φ4.2	
Outside Diameter(mm) 外径 (mm)	MaxΦ70	
Feeding Length(mm) 送料指令值(mm)	±0.01-±9999.99	
Wire Feed Speed 送料速度	0-70m/min	
Can Setting Value 凸轮指令值	±0.1° -359.9°	
Wire Feed Servo 送料伺服马达(KW)	5.5KW	
Cam Servo 凸轮伺服马达	Moter	7KW
Zaxis Servo 转芯伺服马达		1.5KW
Wire Rotate Servo 转线伺服马达		3.8KW
Spinner Servo 卷曲伺服马达	1KW(定配)	
Power AC 电源	380V±10%V 50Hz	
Dimensions(LxWxH) (mm) 尺寸(长x宽x高) (mm)	2400x1300x2250	
Machine Weight 机器重量(kg)	3200	

Model:CNC642A Type

### Machine Features

CNC642A wire rotating spring forming machine adopts CNC control system and five sets of servo motors. The cam axis, feeding axis, quill rotary axis, wire rotation axis and auxiliary axis, five axis are interconnected when running. Eight-position working continuously, standard five-axis. (servo spinner and second hook station can be added) It is suitable for making various compression spring, square spring, scoll spring, tower spring, double torsion spring, flat spring and such difficult abnormality springs. Greatly enlarge the spring processing range. The machine has tracking detection, if there is subquality product, the machine will automatically stop.

### 送线系统 Feeding system

送线系统水平装在机器转线机构中, 每2个送线轮为一对, CNC642A装有3组送线轮, 线径不同时须装适合之送线轮。电脑控制之送线系统, 每一运动单位约为0.01mm, 每命令最大为99999.99个运动单位。里面采用汽车发动机润滑方式。特点: 耐磨、噪声极小, 与控制系统同步精度高。

The feeding system are equipped horizontally at the rotation system of the machine, two rollers as one group. CNC642A has three group feeding rollers. Different wire size need different feeding rollers. The computer control the feeding system, the moving unit is 0.01mm, the maximum moving length is 99999.99 unit. Adopt the car engine lubricating method inside. The feature: abrasion-proof, minimum noise, high precision synchronism with the control system.



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