

CNC Hydraulic Shearing Machine QC11Y-6x2500



DESCRIPTION:

- CNC Shearing Machine device is a very suitable for torsional axis shearing machine, providing solutions for most of the wiggle or gate machine both complete and economy, with high performance, flexible configuration, compact structure, easy to use, high reliability characteristic Servo control, can realize the back gauge and high accuracy of control block. The gap (G-axis) is controllable. Unilateral and bilateral location, to improve the positioning precision and reduce screw clearance. The action cut is controllable. Pneumatic feeding causes to convey the material to be nimble. Back gauge can automatically home. Back gauge can be adjusted through the manual keys. The pages of system parameter and diagnosis are hidden, requires a specific password can enter into.
- Fabricated steel structure, with compact, construction and good rigidity stability
- Integrated hydraulic transmission system, with good reliability
- Back gauge using intelligent digital display device, shear quantity can be automatic counted, distance of back gauge can be set according to requirements of customers
- Moving orbit of the blade beams inclines forwards to the supporting surface of the bottom blade, so you can gain fine shear surface. Jacking screws of the top blade provide a fine adjustment to minimize “rag” or “burring” on the sheared edge of the material. The hold-down assembly adopts the butterfly springs. There are antiskid heel block on the hold-down device of hold-down plate. The pressure is bigger, but

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it doesn't damage the sheet-metal surface Our shearing machine is driven by a self-contained, totally enclosed gearbox mounted directly on the main shaft. Its construction is compact and the gear is well lubricated with low noise and long life

- Our shearing machine hasn't the clutch and the flywheel. It shears the sheet-metal directly driven by the magnetic brake motor. This reduces the idle time of the motor and saves the energy
- Front and back gauges are provided with the scale plate displaying the scale. The back gauge may be easily adjusted in synchronism

MAIN FEATURES:

1. Advanced integrated hydraulic system with an excellent reliability.
2. The rolling guide with 3-point support and improves the shearing quality.
3. Rapidly, accurately and conveniently adjusting the blade clearance with the handwheel.
4. The rectangular Monoblock blades featuring long lifetime with 4 cutting edges.
5. The adjustable rake angle can minimize plate deformation.
6. As the cutting beam has been designed in inner-inclined structure, it is easy for plates to fall down and the accuracy of products can be also guaranteed.
7. Shearing in sections; shadow-line cutting.
8. Back gauge control;
9. BUS mode control servo system;
10. Stroke length limitation;
11. Double programmable digital output;
12. Program memory of up to 40 programs up to 25 steps per program;
13. One side positioning;
14. Retract function;

SPECIFICATIONS:

| MODEL | QC11Y-6x2500 |
|----------------------------------|----------------------|
| Max cutting thickness | 6 mm |
| Max cutting width | 2500 mm |
| Intensity of tension for plate | 450N/mm ² |
| Ram Stroke(time/min) | 16-35 |
| Travel of back-gauge | 20-600mm |
| Cutting angle | 0.5°-1.5° |
| Throat depth | 100mm |
| Main Motor Power | 7.5 kw |
| Weight | 5500 Kg |
| Machine Size (With Steel pallet) | 3300x1800x2050 mm |

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MAIN COMPONENT OF THE MACHINE:

1. Main electrical equipment's
2. Main oil seals of the cylinders
3. Advanced integrated hydraulic system
4. Use low noise gear pump
5. Use High quality CNC controller
6. Servo control;
7. Ball screw;
8. Fully Safety guard protect the rear, throat and front;
9. Foot Pedal with emergency stop;
10. The safety of electrical cabinet with interlock;
11. With working piece receiver;

MACHINE STANDARD APENDIX:

1. Places feet bolt: 4 pieces
2. Nut: 4 pieces
3. Adjusting screw: 4 pieces
4. Gasket: 4 pieces
5. Oil gun: 1 pieces
6. Sufficient nitrogen tool: 1 set
7. Operation instruction book: 1 book

ESTUN E200P Controller System Parameter:

There are a number of materials, needs to be processed into workpiece, the require as following:

- Depth of bending is 100.00mm
- Position of the back gauge is 80.00mm
- Distance of retracting is 5.00mm
- Time for the back gauge retract waiting is 2.00s
- Time for the block holds the pressure is 3.00s
- Workpiece is 10

Parameter & Setting:

- XP (80.00mm) YP (100.00mm) DX (5.00mm) HT (3.00s) DLY (2.00s) PP (10)
- There is a number of sheet metal need for three bends, processing 50. Requirements are follows:
- The first bending: 50mm
- The second bending: 100mm
- The third bending: 300mm

According to the process condition of workpiece and tool, analysis data are as follows:

- The first bending: Position of the back gauge is 50.00mm, Depth of bending is 85.00mm, Distance of retracting 5.00mm;
- The second bending: Position of the back gauge is 100.00mm, Depth of bending is 85.00mm, Distance of retracting 5.00mm;
- The third bending: Position of the back gauge is 300.00mm, Depth of bending is 85.00mm, Distance of retracting 5.00mm.

Step Parameter:

- Table 3-3 The description of Step parameters
- Parameter Default Range Unit Description
- XP (0.00 0~9999.999 mm/inch)
- Program position of X-axis. YP (0.00 0~9999.999 mm/inch)
- Program position of Y-axis. DX (0.00 0~9999.999 mm/inch)
- Retract distance of X axle. OPEN DIST (0.00 0~999.999 mm/inch)
- After bending, the distance of the Y-axis opening. Repeat Times 1~99.