

CNC SHEARING MACHINE



Model: QC11Y-6-25W

Features

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.

Main Features

- ✦ Advanced integrated hydraulic system with an excellent reliability
- ✦ The rolling guide with 3 point support and improves the shearing quality.
- ✦ Rapidly, accurately and conveniently adjusting the blade clearance with the hand wheel.
- ✦ The rectangular Monoblock blades featuring long lifetime with 4 cutting edges.
- ✦ The adjustable rake angle can minimize plate deformation.
- ✦ As the cutting beam has been designed in inner-rotated structure, it is easy for plates to fall down and the accuracy of products can be also guaranteed.
- ✦ Shearing in sections; shadow line cutting.
- ✦ Back gauge control
- ✦ BUG mode control servo system.
- ✦ Stroke length limitation.
- ✦ Double programmable digital output
- ✦ Program memory of up to 40 programs up to 20 steps per program.
- ✦ One side positioning.
- ✦ Return function.

Technical Parameter	
Cutting thickness	6mm
Cutting width	2500mm
Intensity of tension for plate	450N/mm ²
Stroke Number(time/min)	≥ 14
Travel of back-gauge	20-600mm
Cutting angle	0.5°-1.5°
Throat depth	100mm
Power of main motor	7.5KW
Weight	5500KG
Dimensions	L*W*H=3300X1800X2050mm
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) DIY (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 1~99.

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;