



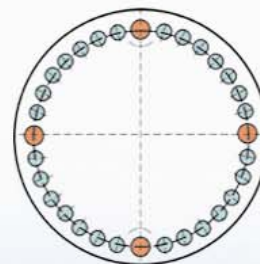
MEIK
Jiangsu Jinfangyuan CNC Machine Company Limited

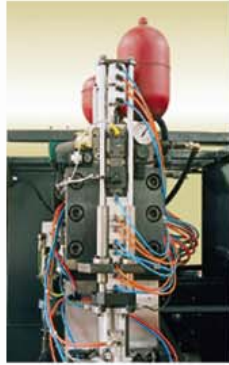


JIAN GSU JIN FANG YUAN

RT SERIES CNC TURRET PUNCH MACHINE

RT SERIES CNC TURRET PUNCH MACHINE TURRET AND STATION





High Speed Hydraulic Ram

The imported world famous hydraulic system has a high speed, high efficiency and it is very reliable. It makes the stroke variable, drop quickly, slow punch and full speed return. It increases the punch rate while you can get a qualified part. You can get full punch force in the full stroke with quite low noise.

The stroke is adjustable which make it easy to complete special tasks, such as louver, emboss, extrusion. It is equipped with Wheel tool from Wilson Tool International. The system is anti-overload automatically.

Featured Auto Index

Combined with synchronized belt and worm wheel transfer which can get high accuracy 0.01° ; Sectionalized worm wheel constructs eliminate the clearance. The flexible designs of this structure make it easy to expand the two auto-index stations to 4 or 5.



The First Class CNC Controller

Equipped with the first class SIEMENS or FANUC control system and servo unit, It can make the machine very reliable.

Features:

- Field programming or in office Programming
- Universal ports RS232
- Pulse coder semi-close loop feed back
- AC servo drive system
- Self diagnose function
- Gripper auto protection
- G code program
- Long distance diagnose



Unique Turret

The pair of upper and lower turret is machined together by the special machine tool in order to ensure alignment. Bushed turret is equipped with 4 keyways for manual setting of specific tools.

The unique tooling replacement mechanism is adopted for easy tooling set up.



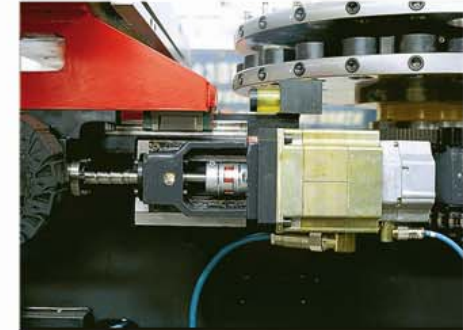


Auto Program Software(Optional)

Equipped with tool management, auto-punch, optimized punch path: transfer the drawing from CAD file, Process, Tool library, Micro-joint, optimized the special tool, auto-reposition.

Ballscrew And Guideway

Fitted with precision large lead ballscrew and lead guideway from Japan or Germany.



Brush Table

With moving large brush table, sheet can be supported fully during punch and make the tool change easily. It lowers down the noise, vibration and wear of the sheet, which make the sheet free of scratch. You can change the brush table easily into steel ball table as you like.

Vacuum Slug Extraction

Fitted with RT punching machines, the vacuum slug extraction system can prevent the slug being safely extracted from rebounding during high speed punching.





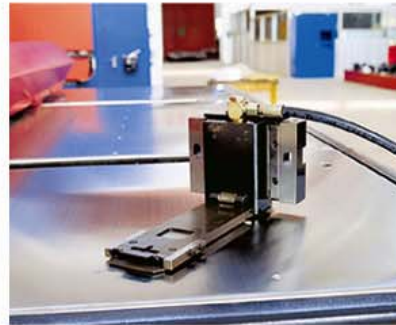
Pneumatic Clamp

Fitted with floating pneumatic clamp, it can float when the sheet has a up-down notion. This can keep the sheet in a good motion condition.

With the thin clamp you can get small dead zone while the clamp can go into the gap between the upper and lower turret. This increases the production range of the sheet.

Central Auto-Lubrication System

This system can send the oil easily to anywhere that need to be lubricated. Decreasing the friction, increasing the life of the moving part.



Hydraulic Clamp (Option)

Fitted with 3 hydraulic clamps, different material can be fitted in and the press can be adjusted suitably. Thin clamp makes the clamp to move into the gap easily and eliminate the additional movement of the NC axis. So it increases the efficiency. Detect device always make the CNC controller to control the actually position of the clamps.



High Precision Tool

Of high quality alloy steel for durability
Spring stripping mechanism with guide construction for distortion free holes

Plain work pieces with little burrs
The work range can be expanded with auto-index stations. Special tools are available for irregular holes. RT can be fitted with Wilson tools from USA with a long tool life and no shim needed after regrinding.

参数 Specification	单位 Unit	RT-300			
公称力 Punch force	KN	300			
最大加工板材尺寸 Max.sheet working size	mm	1250x2500	1250x4000	1250x5000	1500x4000
最大加工板材重量 Max.sheet working weight	kg	150	240	300	300
最大加工板材厚度 Max.sheet thickness	mm	6.35	6.35	6.35	6.35
一次冲孔最大直径 Max.punch diameter	mm	∅88.9	∅88.9	∅88.9	∅88.9
工位数 Number of tool stations	个	24/32	24/32	24/32	24/32
孔距精度 Positioning repeatability	mm	±0.10	±0.10	±0.10	±0.10
打标速度 Max.hit speed	hpm	1900-2400	1900-2400	1900-2400	1900-2400
1mm步距时冲孔频率 1mm step hit speed	hpm	1000	1000	1000	1000
25mm步距时冲孔频率 25mm step hit speed	hpm	370	350	350	350
板材最大移动速度 Max.traversing speed	m/min	96	96	96	96
转盘速度 Turret rotation	rpm	40	40	40	40
控制轴数 Machine axes	个	4+1	4+1	4+1	4+1
旋转工位个数 No.of index station	个	2/3/4	2/3/4	2/3/4	2/3/4
旋转工位最大直径 Max.rotation diameter	mm	∅88.9	∅88.9	∅88.9	∅88.9
空气压力 Compressed air pressure	mpa	0.6	0.6	0.6	0.6
外型尺寸 Shipping dimensions	mm	5020 x 2680 x 2466	5020 x 4000 x 2466	5020 x 5000x 2466	5770 x 4000x 2466
机器重量 Machine weight	ton	18	19.5	21	22.5

工位数 Number of toolstations	∅ 31.75-88.9		∅ 31.75
	SSO	A	B
24	2	2	20
32	2	2	28

Brief Introduction

The RT series CNC turret punching machine with international advanced technology is produced in cooperation with Switzerland RASKIN.

It is equipped with hydraulic system manufactured in Germany, numerical proportionate servo valve. Punching speed is up to 1000 times per minute.

The turret adopts the specialized fixture for pair processing, ensuring the coaxiality of the upper and lower dies, which can extend their service life greatly. The inlay structure simplifies the structure of the turret, which also helps to extend its service life.

The pneumatic, hydraulic and electric components are all world famous products like Festo and Schneider, thus ensuring the reliability of the whole unit.

The pressure adjustable hydraulic clamps are used to hold materials of different nature and thickness at different pressure, thus ensuring that the plates can be held tightly while leaving no dent on the soft and thin plates.

The vacuum waste collector is installed to ensure that waste can drop through the waste hole during high speed cutting, eliminating waste rebounding, which can extend the life of the die.

The worktable with hard brush and ball is wide enough to reduce the noise and vibration while the machine is running, and protect the plate from getting scratched.

The large lead ballscrew and linear guideway from Bosch-Rexroth, NSK are used to ensure processing accuracy.

The O-type body has gone through second aging treatment to eliminate stress to a large extent.

WILSON dies ensures long service life.

The CNC system has clamp self-protection function.

The auto-index can reach 88.9mm and can be expanded to 4.

It has the concentrated lubricating mechanism to improve move parts life.

The integrated beam and carriage structure enhances the rigidity and accurate positioning, which ensures stable feeding at high speed and prevent Axis X and Y of the worktable having dynamic offset.

FANUC CNC system, RS232, pulse encoder semi loop feedback, numerical AC servo driver and motor, strong self diagnostic and protection function to realize remote diagnosis.