

6 Station Turret Punching Rig For The Production of Window Locks



Performance

Line speed : 50 M/min Max velocity
Max component length : 600mm
Coil - 11mm x 2mm austenitic stainless steel

TURRET PUNCH & CTL RIG

A heavy duty punching rig comprising of:-

FRF75-150 SERVO ROLLFEED

Servo rollfeed unit for feeding punch station with accurate lengths for punching operations carried out periodically along components.

6 STATION TURRET PUNCH

A Heavy Duty Power Frame system utilising Amada Thick Turret punch Tooling.

Each frame has a separate H+L Block Cylinder & control valve.

The system utilises 4 "D" station tools & 1 "A" station.

TURRET PUNCH SHEAR

A "B" station turret punch Style crop tool.

A robust construction to crop the punched sections to length (11 x 2mm)

The crop tool has a separate H+L Block Cylinder & control valve.

Guide assemblies are mounted between all the punch tools to ensure the strip stays central while being punched.



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LINE CONTROLS

The line control system stores programs within its memory. These production programs are then called up via the touch screen HMI and are then run off to the desired quantity.

The Software system will Fully Automatically set the Punching Head to the correct Axis position for the hole patterns required as dictated in the program file. The software will also Fully Automatically run batches of these components & then move onto other batches all driven from the production downloaded to the machine.



The control desk has a touch screen HMI for the operator to select production from the Ethernet.

Electrical Controls for the machine are housed in appropriate control desk situated at the front of the line.

Wiring between machines and enclosures will be via surface mounted trunking.

