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生产工艺流程

原材料钢卷人工行吊上卷小车→液压单头开卷→导卫纵剪→边丝收卷机→预分料张力台→收卷机→卸料→入库

Process flow

Loading→Hydraulic single-head expansion decoiler→Guide and guard slitting machine→Scrap collector→Pre-distributor tension device→Recoiler→Unloading trolley→Stocking



描述

机组适用范围:

(一)、原料参数:

- 1、剪切材料: 冷轧钢板、镀锌钢板
- 2、卷钢厚度: 0.3~2.0mm
- 3、卷钢宽度: 500~1500mm
- 4、钢卷内径: $\Phi 508$
- 5、钢卷外径: $\leq \Phi 1600\text{mm}$
- 6、钢卷重量: 10t Max

(二)、成品参数:

- 1、钢卷内径: $\Phi 508\text{mm}$
- 2、钢卷外径: $\leq \Phi 1600\text{mm}$
- 3、钢卷重量: 10T Max
- 4、宽度精度: $\pm 0.1\text{mm}$
- 6、条料直线度: 1mm/1000mm

(三)、设备参数:

- 1、纵剪条数: 3~7条
- 2、纵剪速度: max 50m/min
- 3、总功率: 60KW
- 4、设备走向: 面对操作台, 从左向右

Description

1. Range of application

(1). Technical parameters of material

1. Material: HRC, CRC, HDG
2. Steel coil thickness: 0.3-2.0mm
3. Steel coil width: 500-1500mm
4. Steel coil I.D.: $\Phi 508\text{mm}$
5. Steel coil O.D.: $\leq \Phi 1600\text{mm}$
6. Steel strip weight: 10T Max

(2). Technical parameters of finished product

1. Steel coil I.D.: $\Phi 508\text{mm}$
2. Steel coil O.D.: $\leq \Phi 1600\text{mm}$
3. Steel strip weight: 10T Max
4. Width accuracy: $\pm 0.1\text{mm}$
5. Slitting straightness error: 1mm/1000mm

(3). Equipment specification

1. Slitting number: 3~7 pcs
2. Slitting speed: max 50m/min
3. Total power: about 60kw
4. Operation direction: from left to right



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液压内涨式单头开卷机

Hydraulic expansion decoiler

带卷宽度：0-1500mm
钢卷重量：10T
卷筒直径：Φ480-510mm
离地面中心高度：1M

Coil width: 0-1500mm
Coil weight: Max. 10T
Drum diameter: Φ480-510mm
The distance between center height and the ground: 1M

送料导卫机

导卫纵剪机是将开卷后的料进行导卫纠偏后纵剪分条，导卫纠偏主要是解决钢板的行走方向以利钢板进行纵切确保直线度
水平上下辊直径Φ120mm
立辊左右Φ65mm
送料电机3KW(摆线减速)
速度：0~10m/min (交流电机)

Guide and guard feeding machine

After decoiler the guide and guard slitting machine will guide and guard the material and slitting them. The main function of guide and guard is deal with the feeding direction of the steel sheet, to make sure the straightness.
Level up and down rollers diameter: Φ120mm,
Vertical roll: Φ65mm,
Feeding motor: 3KW(cycloid decelerate)
Speed: 0~10m/min(AC motor)

纵剪机主机

刀轴直径：Φ180mm，刀轴材质：42CrMc
剪切宽度：1500mm
剪切厚度：0.3-2.0mm
最大剪切条数：3-7条
刀片规格：Φ180mm×Φ280mm×10mm;
刀垫衬套规格：Φ180mm×Φ240mm×Hmm
纵剪电机30KW
速度：0~50m/min (交流调速电机)
主轴承精度等级：P5。

Slitting machine

Material of cutter shaft: 42CrMc
Diameter of cutter shaft: Φ180mm
Slitting width: 1500mm
Slitting thickness: 0.3-2.0mm
Slit strip number: 3-7 pcs
Blade size: Φ180×Φ280×10mm
Motor power: 30KW
Design speed: 0-50m/min
Spacer size: Φ180×Φ240×Hmm
Main bearing accuracy class: P5



收卷机

主功率：45KW(调速)
收卷最大重量：10T
卷筒外径：Φ460~Φ508
主轴内涨油缸规格：Φ140×100mm
机架材料：钢板焊接
楔型滑块45#钢调质
主轴42CrMo调质处理

Hydraulic recoiler

Main Power: 45 KW(speed governing)
Max. loading weight: 10T
Coiling block OD: Φ460~Φ508
Spindle up cylinder specifications: Φ140 × 100 mm
Machine frame material: welded plate
Wedge-shaped slider 45 # quenched steel
Spindle 42CrMo quenched



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