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GWS700 Computer automatic core winding machine (5 axis)

(1) Technical specifications

Equipment name: Computer automatic core winding machine (5 axes)

Equipment model: GWS700

Equipment size: 175CM*85CM*160CM

Equipment weight: 950KG

Power supply specification: 380VAC 50/60HZ

Power consumption: 1000W

Air pressure: 8KG

Interface introduction: Simplified Chinese

Production function: Circular square

Circular production efficiency: stacking thickness 5mm about 300 pieces per hour

Square production efficiency: stacking thickness 5mm about 200 pieces per hour

Number of servo axes: 5 axes

Minimum inner diameter: 10mm

Maximum inner diameter: 70mm

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Maximum outer diameter: 100mm

Steel sheet width: 5-30mm

Steel sheet thickness: 0.15-0.35mm

Precision on both sides of the core: <0.1mm

Outer diameter of the unwinding rack: 750mm

(2) Machine introduction

- 1) Computer-automated production provides high precision and high efficiency, reducing post-processing costs and labor requirements.
- 2) Fully closed-loop monitoring of the entire feeding, clamping, buckling, lifting, winding, cutting, welding and each process, which are completed simultaneously during the rolling production process.
- 3) The human-machine interface has clear and easy-to-understand pictures, and the control system has multiple automatic calculation functions. Input basic parameters to start production.
- 4) The entire machine uses world-famous imported accessories, including Taiwan Delta servo system and computer, SMC pneumatic components, Taiwan servo reducer, and other European and Japanese electrical accessories, etc.

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(3) Introduction to the machine

1) Use five-axis Delta servo motor

A) First axis: die-cutting moving servo motor, which moves backward after the sheet is cut, allowing the clamping robot to feed the material to the spindle.

B) Second axis: material-cutting servo motor, connected to imported servo reducer and punching structure, can generate pressure below 2 tons, and can cut silicon steel sheets of 0.35mm or less.

C) Third axis: spindle servo motor, connected to imported servo reducer, drives the spindle to roll the material, with strong torque and high rotation positioning accuracy.

D) Fourth axis: material-returning servo motor, responsible for flattening and pushing out the iron core during the production process.

E) Fifth axis: clamping and feeding servo motor, which clamps the sheet to the roll die hook pin and buckles it firmly.

2) This machine uses Panasonic's high-performance PLC control system, with accurate output pulses, faster and more stable operation speed, and multiple operations written into the program, which can greatly reduce the operator's debugging time. All actions of the entire machine are equipped with self-protection programs to prevent unnecessary damage. Fully closed-loop control monitors the entire production process, including

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clamping, buckling, lifting, winding, cutting, welding, demoulding, etc. The human-machine interface uses a 10-inch color screen from Taiwan Vinylon, and the interface is clear, simple and easy to understand.

3) Precision ball screws are all from well-known Taiwanese brands, providing excellent precision and durability.

4) Pneumatic components use SMC series, including various cylinders, solenoid valves, magnetic sensors, precision pressure regulators, filters, air pipes and all joints, etc.

5) Electric lifting platform, in order to match coiling molds of different diameters, the workbench can be adjusted at will according to the diameter of the mold, which is convenient and quick to use.

6) Heat exchanger, in order to reduce the temperature of the control cabinet, a dedicated heat exchanger is added to cool down, which helps to slow down the aging of electrical components and keep the machine in the best operating state.

7) Carbide molds, the cutting and punching mold blades are made of carbide, and the effective shearing times can reach 300W times.

8) The machine is equipped with an automatic unloading device to facilitate operators to control and install materials.

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(4) List of main accessories

NO.	Parts Name	QTY	Brand
1	Panasonic High-speed large-scale PLC control system	1	Japan
2	Delta 400W servo motor/actuator (for robot)	1	Taiwan
3	Delta 400W servo motor/actuator (For moving knife)	1	Taiwan
4	Delta 750W servo motor/actuator (Spindle winding)	1	Taiwan
5	Delta 750W servo motor/actuator (For material removal)	1	Taiwan
6	Delta 750W servo motor/actuator (For cutting)	1	Taiwan
7	Taiwan Shixie Precision Servo Reducer	2	Taiwan
8	Taiwan Weilun 10-inch touch screen	1	Taiwan
9	Hiwin Slider (20mm) Pipe Position and Manipulator	1pcs	Taiwan
10	Hiwin rail (20mm) pipe position and	0.5m	Taiwan

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	robot		
11	Hiwin Slider (15mm) Cutting edge	4pcs	Taiwan
12	Hiwin rail (15mm) Cutting edge	0.3m	Taiwan
13	Hiwin screw (40mm) for stripping	0.4m	Taiwan
14	Hiwin nut (40mm) for pipe	1pcs	Taiwan
15	Hiwin Screw (20mm) Robot	0.5m	Taiwan
16	Hiwin Nut(20mm) Robot	1pcs	Taiwan
17	Japan NSK precision screw bearing	3pairs	Japan
18	Carbide cutting die 1 set	1pcs	China
19	Korea Autonics Metal Sensor, Photoelectric Sensor	16	South Korea
20	Electrical components of electric control box(Fuji, idec, ABB, Siemens, Panasonic)		Japan/Europe
21	German Siemens button, emergency stop, warning lights, etc.		China

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