



全自動鎢棒切斷機 **HH-CT I**
Automatic carbide rod cutting machine

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技術資料	
入力電壓	三相五線制AC220/380V 50/60Hz
氣壓源	4~6bar
砂輪馬達	無刷伺服馬達 3.7KW
砂輪規格	外徑φ150(HH-CT I)/φ200(HH-CT II) 厚度1.00mm
砂輪轉速	1500~4500 rpm
外型尺寸(長寬高)	168×105×146cm
重量	850kg
切割精度	長度公差 ±0.05mm 垂直度公差 ±0.02以下(*)
產能	1700~1800支/10小時(φ4.2×55Lmm)

(*) : 棒材的彎曲會直接影響切割品質

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HSIEN HUNG TECHNOLOGY CO.,LTD.

專用機 Specialized Machine / 自動化設備 Automation Equipment

全自動鎢棒切斷機
Automatic carbide rod
cutting machine
HH-CT II



Technical data	
Power supply	Three-phase five-wire system AC220/380 50/60Hz
Air pressure	4~6bar
Spindle motor	Match servo motor 3.7KW
Specification of grinding wheel	OD φ150mm, 1.0t mm (HH-CT I) / OD φ200mm, 1.0t mm (HH-CT II)
Spindle speed	1500~4500 rpm
Dimension (Length*width*Height)	1680*1050*1460mm
Weight	850kg
Cutting accuracy	Tolerance of length ±0.05mm Tolerance of verticality less than ±0.02 (*)
Production capacity	1700~1800 pcs/10 hours

(*) : Carbide rod bending will directly affect the quality of cutting

www.hht-tw.com

HMI觸控式操作介面 HMI touch control interface

- 三種切斷模式：
Three different cutting modes:
- 1.自動模式：自動入料、量產、長度設定等長
Auto mode: auto-filling, mass production, each segment length setting the same
 - 2.自訂模式：自動入料、量產、長度可設定不等長
Customizable mode: auto-filling, mass production, each segment length can be setting the same or differently
 - 3.單支加工：人工入料、單支、長度可設定不等長
Single mode: manual filling, single piece, each segment length can be setting the same or differently

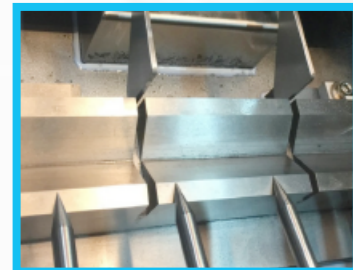
進刀機構：搖臂式、電動缸驅動(HH-CT I)/立式、滑台螺桿驅動(HH-CTII)
Feed device: swing type, electrical cylinder driving (HH-CT I)/Vertical, sliding screw driving (HH-CTII)

- ★ 採用高慣量伺服馬達，進刀速度穩定
MHMD servo motor, stable feed speed.
- ★ 脈波控制位置，能因應不同棒材外徑，經程式運算後，自動調整入刀位置/切斷位置/退刀位置，降低空行程造成時間上的浪費
Pulse control position, according to different rod diameter via algorithms, automatically adjust feed/cut/withdraw position, saving time causing by extra motion
- ★ 藉由砂輪片外徑監控，能得知砂輪片磨損的情況，自動做補正，以及提醒更換刀片
Grinding wheel is monitored, due to wear condition, it can be automatically calibrated. Also, it's always be notified when grinding wheel is time to be replaced.



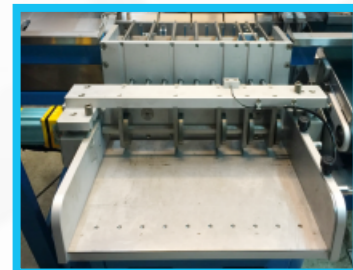
砂輪片外徑監控 自動測量砂輪外徑，並予以補正 Grinding wheel diameter monitoring automatic measure OD of grinding wheel and self calibration

- ★ 採用IP68G/IP69K級防護結構的光電感測器
Photoelectric sensor as protective system IP68G/IP69K
- ★ 並配置專用吹嘴，隨時清潔測頭，更加提升防護力
Install special mouthpieces, clean probe at any time for sensor protection



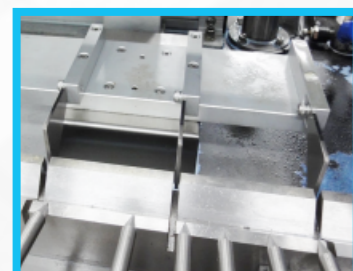
機型分兩款 單/雙V型溝槽可互換 Two cutting types single and double V grooves

- 1.一刀切一支：單V型溝槽(棒材適用範圍 $\phi 2.00 \sim \phi 25 \text{mm}$)
One piece/cut: single V groove (Rod range: $\phi 2 \sim \phi 25 \text{mm}$)
- 2.一刀切兩支：雙V型溝槽(棒材適用範圍 $\phi 2.00 \sim \phi 12 \text{mm}$)
Two pieces/cut: double V grooves (Rod range: $\phi 2 \sim \phi 12 \text{mm}$)



自動送料機構 Auto filling device:

- ★ 棒材範圍：外徑 $\phi 2 \sim \phi 25 \text{mm}$ · 長度 $80 \sim 420 \text{mm}$
Rod range: $\phi 2 \sim \phi 25 \text{mm}$, Length $80 \sim 420 \text{mm}$
- ★ 獨特設計，不會因上料掉落，造成圓棒交錯在置料槽，產生卡料
Special design avoid previous lifting material falling down, then cause material stuck at preparation zone
- ★ 滾輪攪動置料槽，防止堆疊產生卡料
Rolling system prevent material stack on preparation zone



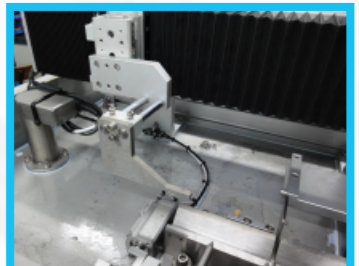
緩衝機構 Buffer device:

- ★ 緩衝棒材滑落V型溝槽的撞擊力道，延長V型溝槽的壽命
In order to extend life time of V groove, this device can reduce impact strength
- ★ 雙V型溝槽使用時，除了緩衝作用外，也將第二根棒材放入第二V型溝槽
Beside buffering, double V groove can also place second rod to correct 2nd groove position



高精密推桿 High precision push rod

- ★ 由光學尺監控推桿每段輸出的長度，並有檔位機構做推桿過行程時，棒材推回補正，確保每斷棒材長度與推桿推出為一至
In order to confirm length of each cutting rod and push rod as same, Linear Scales supervise push rod; offset device calibrate pushback into proper position



檔位機構 Push rod offset device

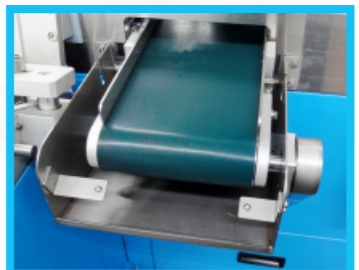


壓制機構 具三大功能性，並以數值化輸入調整 Pressing device with 3 major functions and digitizations adjustment

1. 可調整壓制的力量/速度/順序
The force/speed/order of pressing is adjustable.
2. 圓棒壓制不正確時，警報通知
The rod pressing incorrectly, the alarm is notified.
3. 不同棒材外徑時，壓制高度自動補正
Automatic calibrate clamping height for different rod diameter.



輸送帶輸出裝置 廢料與成品統一排出 Conveyor belt device: uniform output waste part and finished material



抽屜式切削液水箱 整體性美觀兼具節省空間擺設 Draw-out type cutting fluid tank: Integrity, Beauty and space saving.

