

切斷兼倒角機 / HH-C&C02  
Cutting and Chamfering machine

規格說明		Technical Data	
外型尺寸	1900W×1200D×1800H mm	Outside Dimensions	1900W×1200D×1800H mm
重量	900 kg	Weight	900 kg
動力需求	AC220V 三相四線(R·S·T·E)·50A or AC380V 三相五線(R·S·T·E·N)·40A	Power requirements	AC220V three-phase with four wire (R·S·T·E)·50A or AC380V three-phase with five wire(R·S·T·E·N)·40A
氣壓壓力需求	4~6 bar	Air pressure requirement	4~6 bar
適用棒材外徑範圍	φ3.2~φ20 mm	Applicable bar diameter range	φ3.2~φ20 mm
每段長度範圍	38~200L mm	Range of length	38~200L mm
每段長度公差	±0.05mm	Tolerance of each length	±0.05mm
切斷面垂直度公差	±0.02mm	Sectional squareness tolerance	±0.02mm
倒角公差	<0.1mm	Chamfer tolerance	<0.1mm
切斷片/倒角砂輪轉速	Max.4500rpm	Cutting wheel / chamfering wheel speed	Max.4500rpm
夾頭轉速	Max.800rpm	Chuck speed	Max.800rpm
切削液	油性	Coolant	Oil based emulsion

\* 該機不包含切削液過濾設備與油霧分離機

\* Filtration system and oil mist separator are not included within the machine.

產能 / 切斷與倒角, 一切一根長棒310Lmm來計算

Productivity / calculation of cutting and chamfering is based on 310Lmm long rod.

規格 (mm)	(秒/支)	Specification (mm)	(Sec/pcs)
Φ4x50L(切6段)	214	Φ4x50L (Cut to 6 pieces)	214
Φ6x50L(切6段)	238	Φ6x50L (Cut to 6 pieces)	238
Φ8x60L(切5段)	220	Φ8x60L (Cut to 5 pieces)	220
Φ10x75L(切4段)	255	Φ10x75L (Cut to 4 pieces)	255
Φ12x75L(切4段)	301	Φ12x75L (Cut to 4 pieces)	301
Φ16x100L(切3段)	186	Φ16x100L (Cut to 3 pieces)	186

註 / 兩項因素會直接影響產能, 切斷砂輪的損耗狀況與切削液的品質

Note / Two factors will directly affect the production capacity, cutting off the wear of the grinding wheel and the quality of the cutting fluid.

23677新北市土城區亞洲路108巷14號

No.14, Ln. 108, Yazhou Rd., Tucheng Dist., New Taipei City 23677, Taiwan (R.O.C.)

Tel : 02 2269-4388

Fax : 02 2269-4412

E-mail : hht.md@msa.hinet.net 統一編號 : 2840 9464

**HHT** 憲宏科技股份有限公司  
**HSIEN HUNG TECHNOLOGY CO.,LTD.**

專用機 Specialized Machine / 自動化設備 Automation Equipment

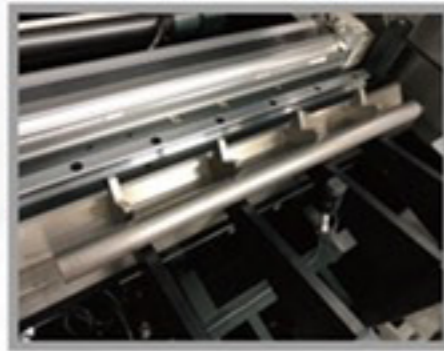


**HH-C&C02**

[www.hht-tw.com](http://www.hht-tw.com)



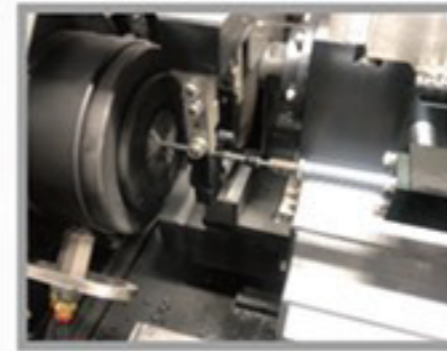
10吋人機操作介面  
10-inch HMI



入料緩衝裝置  
Feeding buffer device



長度可調式入料槽  
Length adjustable  
feed tank

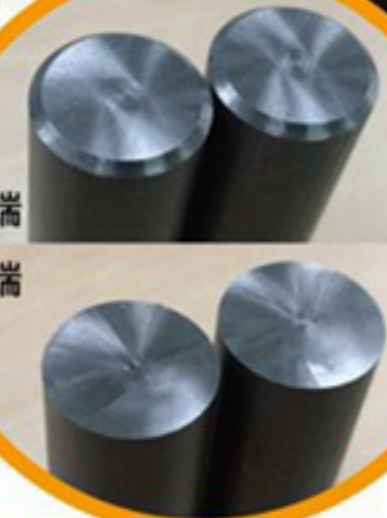


前端擋位裝置  
Front-end positioning  
device

## 切斷兼倒角機 Cutting and Chamfering machine HH-C&C02

完成品 Finished Product

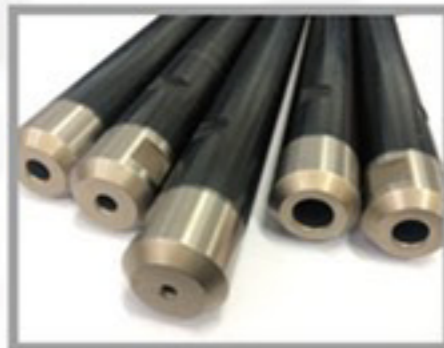
前端  
尾端



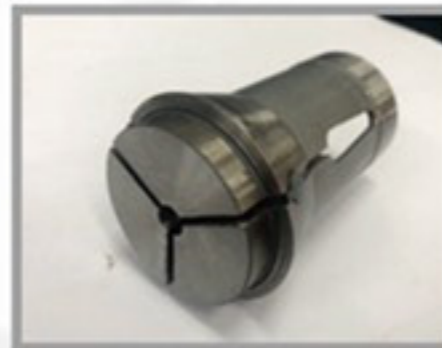
★ 切削端面完整無凸點  
Complete cutting face without bumps



切斷刀片/倒角砂輪  
Cutting wheel/Chamfering  
grinding wheel



棒材導引管  
Bar guiding tube



筒夾  
Collet



輔助挾持滾輪組  
Auxiliary clamping roller set



### 機器特點 Machine characteristics

- ★ 入料機構: 更換不同棒徑時, 機器會自動調整, 並增設一入料緩衝裝置, 可避免V型滑道因長期受撞擊損傷, 壽命長, 亦可確保棒材穩定落入滑道  
Feeding system: machine can automatic adjust when change different dimension's rod. Additional buffer device installation can avoid V shape track impact damage, increase life time. Mean while it can make sure the rod/bar steady fall in to track.
- ★ X/Y軸滑台: 以硬軌滑台面接觸式穩固佳, 產生間隙時, 可調整併可保持精度, 耐候性佳  
X/Y axis slide table: steadiness is based on contacted with slide table on hardness guideway, even there is the gap between, still can be adjusted and maintain accuracy at worse working condition.
- ★ 切削過程中, 可設定三段不同的進給速度: 第一段進刀速度: 切斷刀片接近棒材邊緣時、第二段切削速度: 棒材切斷中、第三段切斷速度: 接近切斷點  
During cutting process, there are three cutting speed can be setup. First stage cutting feed: when cutting blade approach to edge of rod; second stage cutting speed: when cutting blade cut the rod; third stage cut off speed: when cutting blade approach to cut off point.
- ★ 降低人員使用量, 1人可掌控5台機台以上  
One operator is possible to handle more than 5 machines, reduce unnecessary personnel.
- ★ 僅需屏幕上設定好工作條件(棒材外徑, 長度, 倒角量), 機器自動調整位置, 換線速度快(約15分鐘)  
Quick change (about 15 mins): all of parameters (OD of rod/bar, length, and amount of chamfer) only need to setup on screen, the machine can automatically adjust to proper position.
- ★ 配件更換快速, 模組化設計, 無需再做調整, 即可完成定位  
Fast replacement of parts, modular design, no need to make adjustments to complete positioning
- ★ 倒角方式: 是利用 x/y 滑台兩軸同步方式完成45度的倒角; 並且在研磨的時, 砂輪整個研磨面積都有使用到, 損耗均勻, 提升砂輪使用效率  
Chamfering method: The x / y slide table is used to synchronize the two axes to complete a chamfer of 45 de gree s When grinding, the entire grinding area of the grinding wheel is used, the loss is uniform, and the efficiency of the grinding wheel is improved.
- ★ 兩端面定位: 推料裝置精確推出棒材, 前端擋位裝置做定位限制  
Two-end positioning: the pusher accurately pushes the bar, and the front end positioning device is used for positioning limitation.
- ★ 切斷砂輪監控: 依照設定的裁切次數, 自動測量切斷砂輪的外徑值, 並且修正切斷砂輪磨損的量  
Cutting wheel monitoring: According to the set cutting times, the outer diameter of the cutting wheel is automatically measured, and the amount of cutting wheel wear is corrected.



更換料管  
Replace the bar guide tube



更換筒夾  
Replace the collet



更換輔助挾持滾輪組  
Replace the auxiliary clamping roller set