

MJS1812A数控曲线锯



一、技术参数Parameter:

MJS1812A数控曲线锯 技术 参 数 (Specification)		
最大锯切尺寸	Max. working size	1200mm×1250mm×150mm
最大加工速度	Max. working speed	0-20M/min
最大回程速度	Max feeding back speed	40 M/min
锯轮直径	Saw wheel diameter	800mm (铝轮) (aluminum saw wheel)
锯轮宽度	Saw wheel width	60mm
最小锯切半径	Min. working radius	R60mm
工作台进给方式	Working table working way	精密直线导轨 High precision linear guide
压料方式(选装)	Pressure way	滚筒压料 (可放多层) Roller press (can press multilayer)
锯条张紧方式	Saw blade tensioning	气压张紧0.4Mpa Air press tensioning(0.4Mpa)
锯条宽度	Saw blade width	12mm ~ 15mm
锯条长度	Saw blade length	5400mm
锯条转弯角度	Angle of turn	- 75 ~ + 75
锯轮转速	Saw wheel rotation	450 ~ 700rpm
锯切电机 (变速)	Saw motor	7.5kw(配7.5 kw变频器)
X轴 (伺服)	X axis (Servo)	1.0kw
Y轴 (伺服)	Y axis (Servo)	1.0kw
Z轴 (伺服)	Z axis (Servo)	0.4kw×2
X轴驱动方式	X axis working way	精密齿轮齿条High precision gear rack
Y轴驱动方式	Y axis working way	精密滚珠丝杆High precision rack
控制系统	control system	CNC(自主研发) CNC(Independent research and development)
电柜尺寸 (长×宽×高)	Cabinet size (L×W×H)	1250mm×700mm×1850mm(236KG)
机头尺寸 (长×宽×高)	Head size (L×W×H)	1510mm×800mm×2450mm(1194KG)
机身尺寸 (长×宽×高)	Dimensions (L×W×H)	3000mm×2000mm×1670mm(1164KG)
总重量	Total weight	2582kg

二、功能: 专业用于拼板开弯料, 多用于做餐桌椅/床靠背/椅扶手等。

Function:profession to process thechair/desk/bed feet etc.

三、性能优势 Advantage

1、高效 Highefficient

(1) 电脑绘图排版: 固高科技CNC系统(CNC system) DELL显示屏(display screen), 可重复使用图形, 无需手单件划线, 批量生产时远超过传统划线效率, 一次装夹多层板连续锯切。Computer compose type: Use Googol brand CNC system and DELL Display screen. Can use the drawing repetition. High Efficient when volume production.

(2) X轴精密齿条: 工作台平稳进退, 前进速度可以在20-40米之间高效精准, 对防尘要求低, 减少维修。

X-axis transmission: Machine use high precision rack to Make sure the work table remove Smoothly, feeding speed range: 25-40m/s.

(3) X轴传动: 伺服电机配合高精密齿条进给平稳快速, 高效精准。

X-axis transmission: Servomotor combine with the high precision rack. more efficient.

4) 结实框架机身: 机架用方厚管焊接而成, 整机刚性好, 经过热处理防止变形, 导轨滑块流畅, 机身与锯头固定连接不震动, 锯切快速精准。

Machine frame: Machine use enough rolled steel and the Material through to the heat treatment To make sure the machine frame durable And not easy to deformation. Also can Make sure the guide rail remove smoothly

2、高精:

(1) 导轨滑块: X/Y轴采用国际一线品牌德国力士乐Rexroth的25#导轨滑块, 滑块间隙小于5C配合进退料移动平稳, 锯切高效精准。

(其它品牌采用台湾ABBA广东江门国产)

Guide rail sliding block: X/Y Axis use Germany brand Rexroth 25# Guide rail sliding block. Gap is smaller 0.05mm. Cutting More accurately.

(2) Y轴精密滚珠丝杆: 采用 $\phi 32$ 台湾品牌ABBA精密丝杆, 以40米/分的速度进退刀定位精准, 预留加工余量小、锯路小。

Y-axis transmission: Machine use $\phi 32$ lead screw for Feeding. Max 40m/min speed. To make sure the axis location Accurately, small tolerance and The radian in small deviation.

(3) Y轴台达伺服电机: 高精度高扭矩, 定位精度高达0.01mm。

Y-Axis Delta servo motor: high precision and high Torque to make sure in high positioning (0.01mm)

3、标准化: 电脑绘CAD图排版标准, 锯条根据电脑排版轨迹快速摆出曲线锯切标准。锯条摆动装置旋转部件灵活快速摆出角度, 锯头与机身固定连接不震动不易断锯条。

Saw blades swing system: when machine working, the saw Blade will swing due to the copper Bush, the underbed is not removing. This system is good stability to make The saw blade more durable

4、省工: 电脑标准CAD图, 不需传统手工划线: 气动压料装置: 采用气动压紧板材, 拼板弯曲可以压直, 一次开多层板, 安全高效低成本, 是其品牌三至四倍效率。

Pressing device: Machine use the pneumatic pressing Device, so can process the curve wood And also can press few pieces wood at One time to increase the process efficiency

5、省料: 电脑排版标准预留加工余量小, 摆出曲线精准, 锯条锯路小, 每件板件大板比手工划线多出几件成品。

Save material: Computer compose type reduce less rest material. Small saw kerf .compare with the manual can produce more product.

6、安全: 气动夹料一次夹紧多层板, 不需手动近距离接触锯条保障生产安全, 减低工伤风险。

Safe: pneumatic press device can press few pieces in one time. No need manual to touch the saw blade. reduce the injury risk of the worker.

四、全自动张紧、高配锯轮、断锯条监测、变频调速：

- Autotensioning.High configuration saw wheel. Detection device.frequency speed control
- 1、铝 轮：锯切曲线用窄锯条摆角度，较轻的铝轮运转时惯性较小不易断锯条，锯轮外圆包进口平型带锯条摆动防止打滑，高效精准。
Saw wheel:According to thesaw blade need to rotate the Angle, so it need to use the narrowsaw Blade.The saw wheel will have big inertia When removing,so use the aluminum wheel Can reduce the saw blade breakage.Alsothe Saw wheel have the flat belt to increasethe Saw blade force of friction, so that the saw Blade can cut inhigh precision .
- 2、重型轴承装置：锯轮内部采用NSK重型分离轴承32013，斜珠接触面大确保锯条张紧时可以承受更大拉力，使两锯轮张紧时变型小，减少锯轮外圆磨损，不易断条。
Heavy bearing:Thesaw whell use the NSK brand heavy Bearing 32013 to make sure whenthe saw blade Tension is oversize can bear the tensile Force.It can extend thesaw wheel life and The saw blade life.
- 3、锯轮张紧导向：采用国际品牌德国力士乐35#导轨滑块导向，张紧锯轮时滑块隙较小，锯轮不摆动，锯条稳定性好，不易断条。
Saw wheel tensioning guide rail: Machine usethe Germany brand Rexroth35# guide rail to make sure The saw blade remove smoothly to extend the Sawwheel and the saw blade life.
- 4、全自动张紧系统：使用全自动张紧功能，一个人可以快速完成更换锯条，系统有自动保压功能，在锯条锯切时发热时自动升压保压，锯条稳定，不易断条或跑锯。
Saw wheel tensioningsystem:Machine use the pneumatic tensioning system, more stability and easy for the saw bladetensioning.Also is easy to change the saw blade andmake sure the saw blade at the stableposition and extend the saw blade life,increase the process efficiency
- 5、断锯条监测装置：锯条断裂时气缸上推锯轮，电磁阀自动检测气缸活塞移动，信息传递到电脑系统控制自动停机，防止锯条外飞，保证生产安全。
Saw blade broken Detection device:whenthe saw blade Broken,the air cylinder will push the saw wheel up.The solenoid valve will check the air cylinder situation andsent the information to the computer control system to stop the machineworking.prevent the saw blade out and protect the production safe.

五、优质电器配置：

- 1、国际一线品牌电器：台达PLC/西门子接触器/热继电器施耐德接触器，故障率低，机器内部采用欧州标准安全电压110V。
(其它品牌全是国产的普通品牌)
Electric device: Machine use the Delta frequency Converter/SIEMENS contactor Thermorelay/Schneider cocontactor etc To make surethe machine more durable
- 2、台达变频器 (7.5kw)：变频调速根据木材硬度调整锯轮线速，适合锯切不同硬度的木材，稳定精准，锯条更耐用。
Delat frequency changer (7.5KW):frequency Speed control
According to the wood hardness.suitable for different kind of wood cutting.stableand high precision.
- 3、注油机：整机滑块的供油系统，保持导轨滑块流动性。
Lubricators:whole machinehave the lubricators system.Make sure the Guide railsliding block not rust.

六、主要配件品牌：

变压器 (transformer)	九川电器JIUCHUAN
按钮开关 (button switch)	西门子二工Siemens
断路开关 (shutdown switch)	施耐德Schneider
交流接触器 (AC contactor)	施耐德Schneider
锯轮轴承 (Bearing)	NSK
滚珠丝杆(ball screw)	TBI/ABBA
CNC系统(CNC system)	固高科技Googol
显示屏(display screen)	DELL
伺服系统(servosystem)	台达Delta
变频器驱动锯轮 frequency changer	台达Delta
导轨滑块Guide rail slidingblock	德国力士乐Rexroth