



# 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

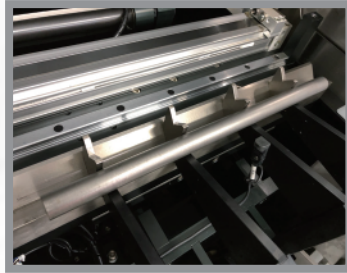


## **HH-C&CO2**

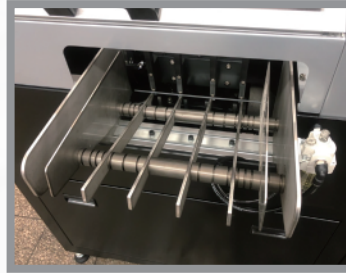
[www.hht-tw.com](http://www.hht-tw.com)



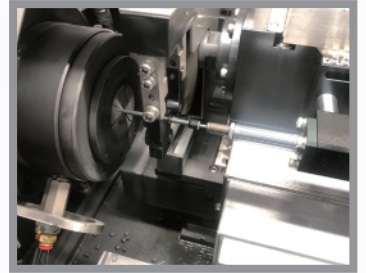
10吋人機操作介面  
10-inch HMI



入料緩衝裝置  
Feeding buffer device



長度可調式入料槽  
Length adjustable  
feed tank



前端檔位裝置  
Front-end positioning  
device

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



完成品 Finished Product

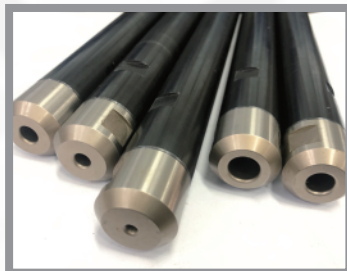
前端

尾端

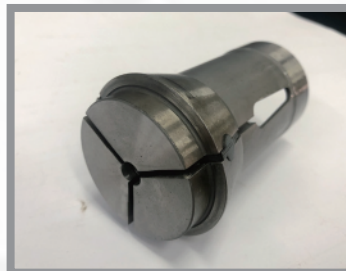
★ 切削端面完整無凸點  
Complete cutting face without bumps



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



棒材導引管  
Bar guiding tube



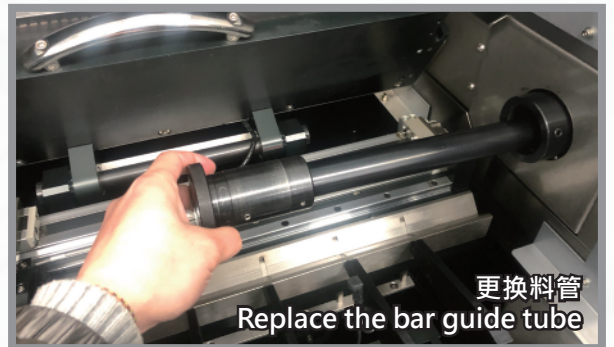
筒夾  
Collet



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: 切削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.



## 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

規格 (mm)	(秒/支)
Φ4x50L(切6段)	214
Φ6x50L(切6段)	238
Φ8x60L(切5段)	220
Φ10x75L(切4段)	255
Φ12x75L(切4段)	301
Φ16x100L(切3段)	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

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

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

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

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