

高端通讯电子全自动线圈生产线

Full-automatic production line of coil for high-end communication electronics



HFD3全自动切料绕线沾锡排版机主要由自动切断上料机，自动绕线机，自动沾锡机，自动排版机四部分组成，本机为自动绕线部分。绕线机系四轴联动，绕线圈数精确可设定，绕线速度自动可调，主轴标准转速13,000rpm,最高转速可达20,000rpm。

主轴电机采用进口高性能伺服电机，主轴轴承采用高精度，高转速进口轴承，三轴运动部件采用进口高精度丝杆及线性轴承保证了导针的重复定位精度。所有关键元器件采用国际知名品牌。控制上采用了进口的控制器和人机界面，方便参数设定。故障自动报警，并提示故障点，保证了绕线的质量。

HFD3 full-automatic coil production line mainly consist of automatic cutting and loading machine, automatic winding machine, automatic soldering machine and automatic arranging machine. This is the automatic winding machine. The winding machine has a four-spindle linkage. The number of turns can be set precisely and the winding speed is adjustable. The standard spindle speed is 13,000 rpm, while the maximum spindle speed is 20,000 rpm.

Spindle motor adopts imported servo motor with high performance, spindle bearing adopts high-precision and high-speed imported bearing, and moving parts of three spindles adopt imported and high-precision screw rod and linear bearing in order to ensure the repeated positioning accuracy of guide pin. All key components employ internationally renowned brand. Imported controller and human-computer interface are employed for control to facilitate parameter setting. Moreover, automatic fault alarm and fault point prompt ensure the winding quality.

型号 (Model)	HFR2425
主轴数 (Spindle number)	24
主轴转速 (Spindle speed)	标准 (Standard): 13000rpm MAX:20000rpm
主轴间距 (Spindle interval)	25mm
绕线线径 (Wire diameter)	Φ 0.02" Φ 0.114mm
控制系统 (Control system)	方式: 可编程控制器(PLC)、工控机(PC) (Mode: Programmable logic controller, industrial personal computer)
控制轴数 (Number of control spindle)	4轴 (Four spindles)
主轴电机功率 (Spindle motor power)	1.8KW
电机总功率 (Total motor power)	3.0KW
电源 (Power supply)	380V(三相五线制),50Hz 中国大陆标准电网 (380V (three-phase five-wire), 50Hz, standard power grid of Mainland China)
气源 (Air supply)	0.4-0.6MPa
最大回转直径 (Max. swing diameter)	Φ 20mm
功能 (Function)	带料经模具冲压切断后，骨架由自动上料机自动送到随行工装载体上，由随行工装自动上料至绕线主轴、自动绕线、自动沾锡、自动检测、不良品自动剔除、自动排版。随行工装循环周转、张紧力自动调节、主轴转速连续可调、绕线圈数可调。(After strip is punched and cut by the die, bobbin is sent to the carrier of the accompanying fixture by automatic loading machine and automatically loaded onto the winding spindle by the accompanying fixture, and then goes through the processes including winding, soldering, detecting, defect rejection and arranging automatically. The fixture cycles continuously. Other functions such as automatic tension adjustment, continuously adjustable spindle speed and adjustable number of turns are also available.)