



GREWIN INDUSTRIAL GROUP CO.,LTD.

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NAME: GWS-660 Computer automatic iron core winding machine

1. Machine introduction

- (1) Computer automated production, providing high precision, high efficiency, reduce post-processing costs and labor needs.
- (2) Full closed-loop monitoring of the entire feeding, clamping, buckle, topping, winding, cutting, welding and each process, in the winding production process to complete synchronously.
- (3) Human-machine interface, the picture is clear and easy to understand, the control system has a number of automatic calculation functions, and the input basic parameters can be changed into production.
- (4) The whole machine adopts world famous imported accessories, including Yaskawa servo system and Panasonic computer, SMC pneumatic components, Taiwan servo reducer, and other European and Japanese electrical accessories

2. Introduction of the machine

- (1) Use 5-axis servo motor
 - A. The first axis: the cutting die moving servo motor, the sheet material is cut off to move back, so that the clamping manipulator to the main shaft Feed.
 - B. The second axis: cutting servo motor, connected to the imported servo reducer and punching structure, can produce 15 tons
The following pressure can cut off 0.5mm or less silicon steel sheet.
 - C. The third axis: spindle servo motor, connected to the imported servo reducer, drive the spindle coil, strong torque
Large, high rotation positioning accuracy.
 - D. Fourth axis: return servo motor, in the process of production, responsible for the iron core by flat push out.
 - E. Fifth axis: clip feed servo motor, send the sheet clip to the winding die hook nail to fasten.
- (2) The machine adopts Panasonic high-performance PLC control system, accurate output pulse, faster and more stable running speed
If multiple operations are written into the program, the debugging time of the operator can be greatly reduced. All movements of the machine are provided
I protect the program from unnecessary damage. Fully closed loop control monitors the

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entire production process, including clamping materials, Buttoning, topping, winding, cutting, welding. Demoulding, etc. The man-machine interface adopts Taiwan Vinylon 10-inch color screen Screen, the interface is clear and simple to understand.

(3) Precision ball screws are famous brands in Taiwan, providing excellent accuracy and durability.

(4) Pneumatic components using Japan SMC series, including each cylinder, solenoid valve, magnetic sensor, precision

Pressure regulator, filter, air pipe and all fittings etc.

(5) Electric lifting platform, in order to cooperate with different diameters of the rolling mold, the workbench can be based on the diameter of the mold

Meaning to adjust the height, easy to use.

(6) Heat exchanger, in order to reduce the temperature of the control cabinet, a special heat exchanger is added to cool down, which helps

Slow down the aging of electrical components, so that the machine is in the best condition of operation.

(7) carbide die, cutting die punching die knife edge made of carbide, effective cutting times Up to 300W.

(8) The machine is equipped with an automatic discharge device, which is convenient for the operator to control and install materials.

(9) The machine is equipped with a mechanical hand receiving function to prevent the core from falling down

3. List of main accessories

NO.	Part name	Quantity	Brand
1	Panasonic high speed large PLC control system	1	Japan Panasonic
2	Yaskawa 750W servo motor/Trunk motor (hand grip)	1	Japan Yaskawa
3	Yaskawa Shifter 2KW servo motor/body actuator (Shifter)	1	Japan Yaskawa
4	Yaskawa 11KW servo motor/Trunk actuator (spindle winding)	1	Japan Yaskawa
5	Yaskawa 5KW servo motor/body actuator (for material return)	1	Japan Yaskawa
6	Yaskawa 3KW servo motor/body actuator (for cutting)	1	Japan Yaskawa
7	Taiwan World Association Precision Servo Reducer 2 Taiwan World Association	2	Taiwan World Association
8	Taiwan Willon 10-inch touch screen 1 Taiwan Willon	1	Taiwan Velenton
9	Hiwin slider (40mm) tube position and	1	Taiwan Shangyin

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	manipulator 1 Taiwan silver		
10	Hiwin guide rail (40mm) tube position and manipulator 0.5m Taiwan Silver	0.5m	Taiwan Shangyin
11	Hiwin slider (40mm) cutting edge 4 Taiwanese silver	4	Taiwan Shangyin
12	Hiwin guide rail (40mm) cutting edge 0.3m Taiwan silver	0.3m	Taiwan Shangyin
13	Hiwin screw (40mm) 0.4m Taiwan silver for material return	0.4m	Taiwan Shangyin
14	Hiwin flyer (40mm) tube position with 1 Taiwan silver	1	Taiwan Shangyin
15	Hiwin screw 40mm) Manipulator 0.5m Taiwan Shang Yin	0.5m	Taiwan Shangyin
16	Hiwin Screwmother (40mm) manipulator 1 Taiwan silver	1	Taiwan Shangyin
17	Japan NSK precision screw matching bearing 3 pairs of Japan NSK	3pairs	Japan NSK
18	carbide cutting die 1 set 1 piece of China	1	China
19	Korea Autonics Metal sensor, photoelectric sensor 16 Korea	16	Korea
20	Electrical components for electric control boxes (Fuji, idec, ABB, Siemens, Panasonic) - Japan/Europe	-	Japan / Europe
21	German Siemens system, emergency stop system, warning lights, etc...	-	China

4. Technical specifications

- Equipment name: Computer automatic iron core winding machine
- Device model: GWS-660
- Equipment size: 295CM*200CM*200CM
- Equipment weight: 3000KG
- Power supply specification: 380VAC 50/60HZ
- Power consumption: 1000W
- Air pressure: 7KG
- Interface introduction: Simplified Chinese
- Production function: Toroidal
- Number of servo axes :5 axes
- Minimum inner diameter: 60mm

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- Max inner diameter: 550mm
- Max outside diameter: 850mm
- Steel sheet width: 15-150mm
- Steel sheet thickness: 0.2-0.5mm
- Accuracy on both sides of the core: <0.2mm
- Discharge machine: machine includes
- Maximum material diameter: 1300mm
- Inner diameter expansion range: 450-520mm
- Maximum load: 1T
- Maximum discharge speed: 200m/min
- Laser welding: body accessories
- Maximum output power: 1000W
- Light output mode: Energy fiber (Mitsubishi, Japan)
- Installed capacity: 6KW
- Equipment size: Laser host: 120CM(L)X70CM(W)X100CM(H)
- Weight: Laser machine host: 380KG



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