

## Specification for CNC Servo Punch and Shear Unit

No.	Name		Parameter	Unit
1	Punching pressure		294(30)	KN(T)
2	Punching style		Servo motor drive(Z axis)	
3	Shear pressure		196(20)	KN(T)
4	Shear style		Servo motor drive (M1,M2 axis)	
5	Frame structure		O type punch frame +C type shear frame	
6	Max sheet dimension (X axis, not include first positioning)	X axis	3000	mm
		Y axis	1500	mm
7	Max sheet thickness (Q235sheet)		6.35( punch),4( shear)	mm
8	Max. one-time punching diameter		Φ88.9	mm
9	Max. Punching stroke		38	mm
10	Max. Shear stroke		90	mm
11	Single stroke shear (X*Y)		1000*1528	mm
12	Blade length for X axis		1004	mm
13	Blade length for Y axis		1532	mm
14	Punching times per minute		1500	cpm
15	Max. punching frequency (1mm step, 5mm punching stroke)	X axis	700	cpm
		Y axis	450	cpm
16	Max. punching frequency (25.4mm step, 5mm punching stroke)	X axis	400	cpm
		Y axis	280	cpm
17	Clamps		4	pc
18	Re-positioning gas cylinder		2	set
19	station(index station)		38(2B)	pc
20	Control axis		12(X, Y1, Y2, Z, T, C, M1, M2, N, L1, L2, L3)	pc
21	Tool style		Long die	
22	Worktable structure		Brush with ball	
23	Max sheet speed	X axis	100	m/min
		Y axis	80	m/min
		combined	120	m/min
24	Turret speed		30	rpm
25	Index tool speed		60	rpm
26	Punching precision		±0.1	mm
27	Max. loading weight of worktable		230	Kg
28	Capacitance module capacity		0.6	mF