



YANGLI 扬力集团

江苏扬力数控机床有限公司

JIANGSU YANGLI CNC MACHINE TOOL CO., LTD.

扬力集团
YANGLI GROUP

数控激光切割机

GL系列数控光纤激光切割机

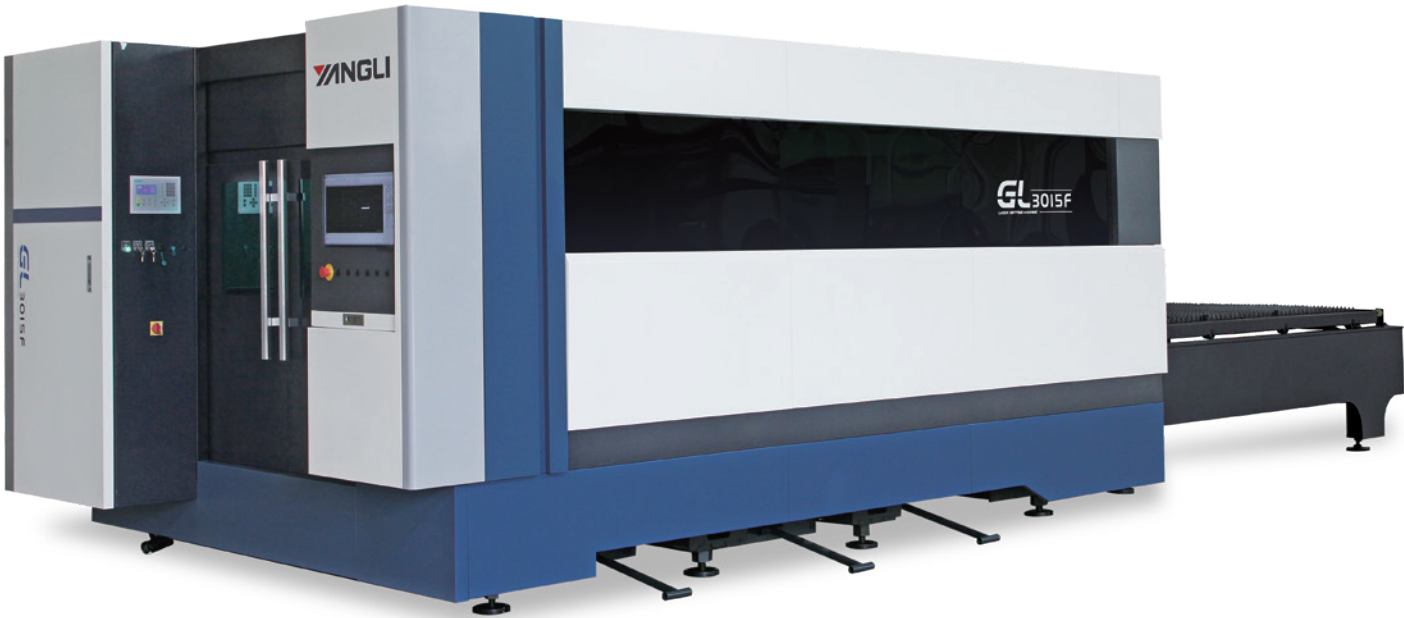
GL Series CNC Fiber Laser Cutting Machine

主要技术特点:

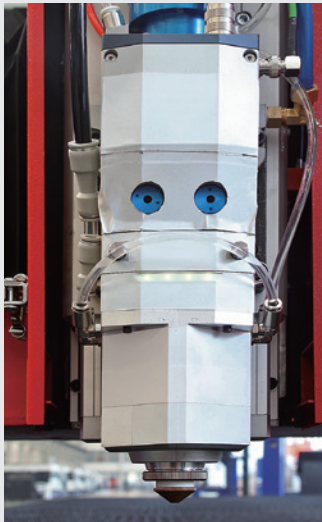
主机采用龙门式双驱结构,刚性好,运行平稳;机身钢板焊接并经壁炉退火去应力处理,精度持久稳定;传动部件采用全套进口齿轮齿条,加工精度高,使用寿命长;采用进口IPG光纤发生器,电光转换效率高,运行成本低;光路采用光纤传输,使用简单,维护成本低,自动编程软件可手动和自动任意的套料,操作灵活,材料利用率高。

Features:

Gantry and double-driven structure of the machine features high rigidity and steady movement. Steel-weld machine frame gets annealing treatment with constant accuracy. Transmission mechanism, rack and pinion enjoys high accuracy and long service life. IPG fiber laser features high electro-optic transfer efficiency, low running cost. The optic path of laser fiber travel is simple and free of maintenance. Auto programming software is of auto and manual nesting function, leading flexible operation and complete material using.



高精度密封型丝杆滑台
High precision sealed screw slide



高性能激光切割头(选件)
Hi-performance laser cutting head (optional)

GL系列数控光纤激光切割机主要技术参数
Technical Parameter of GL Series CNC Fiber Laser Cutting Machine

名称	Description	单位 Unit	GL3015F	GL4015F	GL4020F	GL6020F	GL6025F	GL8025F
板材加工范围	Sheet size	mm	3000×1500	4000×1500	4000×2000	6000×2000	6000×2500	8000×2500
X轴行程	X axis	mm	3050	4050	4050	6050	6050	8050
Y轴行程	Y axis	mm	1525	1525	2025	2025	2525	2525
Z轴行程	Z axis	mm	250	250	250	250	250	250
X、Y轴定位精度	X,Y positioning accuracy	mm/m	0.02	0.02	0.02	0.02	0.02	0.02
X、Y轴重复定位精度	X,Y repeat positioning accuracy	mm	±0.02	±0.02	±0.02	±0.02	±0.02	±0.02
X、Y轴最大速度	X,Y speed	m/min	120	120	120	120	120	120
发生器功率	Laser power	W	1000 / 1500 / 2000 / 3000 / 4000 / 6000 / 8000 / 10000 / 12000 / 15000 / 20000 / 30000					
机床外形尺寸	Machine dimension	m	8.8×4.4×2.1	11×4.4×2.1	11×5×2.1	15×5.1×2.1	15×5.7×2.1	20×5.7×2.1

数控激光切割机

GL系列板管复合数控光纤激光切割机

GL Series CNC Fiber Laser Cutting Machine

主要技术特点：

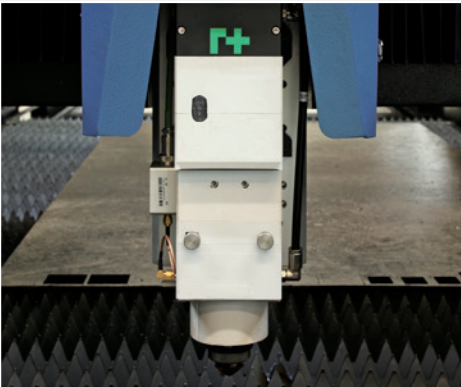
GL3015FT型板管复合数控光纤激光切割机是集板料切割和管材切割为一体的激光切割系统。一台设备上可切割板材和管材，节约成本，性价比高。主机采用龙门双驱结构，刚性好，运行平稳；机身钢板焊接并经壁炉退火去应力处理，精度持久稳定；整机采用开放式一体化设计，外观简洁大方；采用柏楚控制系统，德国进口高精度齿轮齿条，保证了机床可靠稳定的加工精度；双W旋转，不存在滞后，除可以切割方管、圆管、矩形管等标准管材，还可以切割六边形管、腰形管、椭圆形管等异形管材。

Features:

GL3015FT CNC Fiber Laser Cutting Machine for Tube & Sheet is to cut metal sheet and various tube with high performance and low cost. The machine is of gantry double-drive structure with high rigidity and stability. The machine frame is welded with steel plate and gets annealing treatment to relieve stress for reliable accuracy. The integrated machine design is of simple outlook. The machine is of Friendness Cypcut control, German precision rack & pinion, double W rotation avoiding delay. Cutting square, round, rectangular, hexagonal, waist, oval tubes etc.



高性能控制系统
Hi-performance control



配备瑞士RayTools光纤切割头，具有使用成本低、精度高、可靠性好
Swiss raytools fiber cutting head features low cost

GL系列板管复合数控光纤激光切割机主要技术参数
Technical Parameter of GL Series CNC Fiber Laser Cutting Machine for Sheet and Tube

名称	Description	单位 Unit	GL3015FT	GL4015FT	GL4020FT	GL6020FT	GL6025FT
板材切割范围	Sheet size	mm	3000×1500	4000×1500	4000×2000	6000×2000	6000×2500
管材加工范围	Tube diameter	mm	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220
X轴行程	X axis	mm	3050	4050	4050	6050	6050
Y轴行程	Y axis	mm	1525	1525	2025	2025	2525
Z轴行程	Z axis	mm	250	250	250	250	250
U轴行程	U axis	mm	6000	6000	6000	6000	6000
X、Y轴定位精度	X,Y positioning accuracy	mm/m	0.02	0.02	0.02	0.02	0.02
X、Y重复定位精度	X,Y repeat positioning accuracy	mm	±0.02	±0.02	±0.02	±0.02	±0.02
X、Y轴最大速度	X,Y speed	m/min	120	120	120	120	120
发生器功率	Laser power	W	1000 / 1500 / 2000 / 3000 / 4000 / 6000 / 8000 / 10000 / 12000 / 15000 / 20000 / 30000				
机床外形尺寸	Machine dimension	m	9.5×5.4×2.1	11×5.4×2.1	11×6×2.1	15×6×2.1	15×6.7×2.1

PL系列数控光纤激光切管机

PL Series CNC pipe Cutting Machine

主要技术特点：

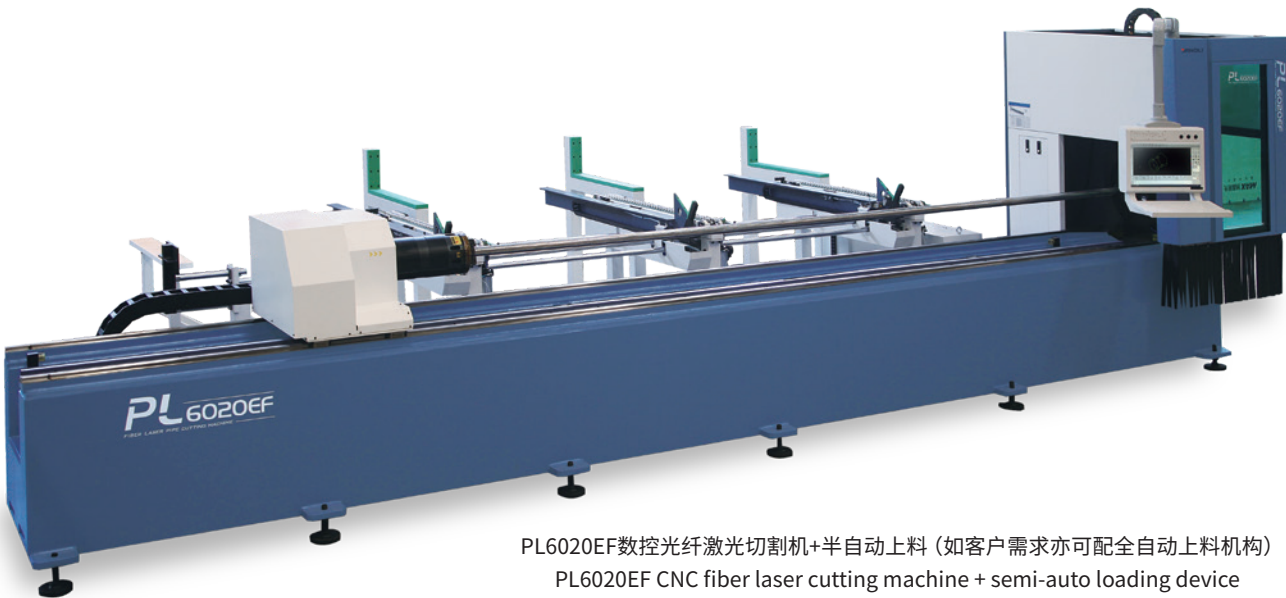
PL系列数控光纤激光切管机是高效、实用的专业激光切管机，机床采用气动两动式卡盘，夹持管材有较高的定心精度和重复定位精度；采用高精度齿轮齿条传动，配有专用光纤切割头，专业的套料软件，管材利用率高。标配后随动托料装置，伺服电机驱动，跟随管材外轮廓轨迹浮动，可选配前随动托料、前固定托料和自动上料等相关功能部件。

Features:

Hi-efficient and economic PL series pipe cutter is of pneumatic dual-motion chuck, with high centering and repeat positioning accuracy. It is equipped with precision rack and pinion, fiber cutting head, nesting software for high pipe utilization, servo motors, rear pipe support device floating with pipe profile. The optional are front follow-up pipe support device, front stationary pipe-support device, auto pipe loading and unloading device etc.



PL6020EF 数控光纤激光切管机
PL6020EF series cnc pipe cutting machine



PL6020EF数控光纤激光切割机+半自动上料（如客户需求亦可配全自动上料机构）
PL6020EF CNC fiber laser cutting machine + semi-auto loading device
(Auto loading device is available when required)

□ 主要技术参数

□ Technical Features

名称	Description	单位 Unit	PL6020EF	PL6024EF
管材加工范围	Tube processing area	mm	6000×φ20-200	6000×φ20-240
下料	Cutting	mm	选配	选配
下料长度	Unloading length	mm	-	-
X轴行程	X axis	mm	6700	6700
Y轴行程	Y axis	mm	350	350
Z轴行程	Z axis	mm	300	300
W轴行程	W axis		无限回转 Infinite rotation	无限回转 Infinite rotation
X、Y轴定位精度	X,Y positioning accuracy	mm/m	±0.02	±0.02
X、Y轴重复定位精度	X,Y repeat positioning accuracy	mm	±0.03	±0.03
加速度	Acceleration	g	0.7	0.7
X、Y轴进给速度	X,Y feeding speed	m/min	85	85
W轴转速	W axis rotation speed	r/min	100	100
上料方式	Tube loading		手动 Manual	手动 Manual
发生器功率	Laser power	W	500 / 700 / 1000 / 1500 / 2000 / 3000	
机床外形尺寸	Dimension(L×W×H)	m	8.5×4×3	8.5×4×3

CL系列卷料激光切割机

CL Series Coil Fed Laser Cutter

主要技术特点:

主机采用龙门式双驱结构,刚性好,运行平稳;机身钢板焊接并经壁炉退火去应力处理,精度持久稳定;采用进口光纤激光发生器,运行成本低;采用全套高性能光纤专用激光切割头,带有透镜保护镜,延长了聚焦镜的使用寿命;采用激光专用控制系统,可实现零件程序的模拟运行,模拟显示零件加工过程,可自动套料,材料利用率高。

可选配开卷矫平送料系统和下料系统,形成卷料加工的自动化激光切割生产线。

Features:

Gantry-type cross beam and dual-drive structure of the machine ensures high rigidity and stability. Annealing treatment of machine frame reduces stress and brings stable accuracy. The machine consists of imported laser source with low running cost, advanced laser cutting head with durable focus lens, special controller with simulation processing and nesting function.

The optional are coil straightening device and unloading device, which performs as a coil fed laser cutting line.

□ 主要技术参数

□ Technical Data

参数 Specification		型号 Type	单位 Unit	CL3013F	CL3016F	CL4013F	CL4016F
名称 Description							
板材加工范围	Sheet size		mm	3000×1300	3000×1600	4000×1300	4000×1600
Y轴行程	Y axis		mm	3050	3050	4050	4050
X轴行程	X axis		mm	1325	1625	1325	1625
Z轴行程	Z axis		mm	80	80	80	80
最大料宽	Coil width		mm	1300	1600	1300	1600
精度 Accuracy	X、Y轴定位精度 X,Y positioning accuracy		mm/m	0.02	0.02	0.02	0.02
	X、Y轴重复定位精度 X,Y repeat positioning accuracy		mm	±0.02	±0.02	±0.02	±0.02
速度 Speed	X/Y轴联动速度 X/Y combined speed		m/min	120	120	120	120
发生器功率	Laser source capacity		W	500 / 700 / 1000 / 1500 / 2000 / 3000 / 4000 / 6000			
机床外形尺寸	Dimension		m	8×4.7×2	8×5×2	10×4.7×2	10×5×2



CL3013F卷料激光切割机
CL3013F coil fed laser cutter

WL系列超大幅面数控激光切割机

WL Series Large CNC Laser Cutting Machine

主要技术特点:

整机采用双边龙门驱动结构,高精度机架采用多段拼接结构,预留拼接接口,扩展性好;配有专用数控系统,全套进口传动系统,采用全套进口德国Precitec高性能自动调焦激光切割头;采用跟随式除尘系统,除尘装置对切割头的运动进行实时动态跟随。

Features:

This machine is of gantry double-drive structure with several sections combined frame which has more connection device and is accurate.This machine is of control, imported transmission device, German PRECITEC auto focusing laser cutting head, dust exhaust device following up cutting head.

主要技术参数

Technical Features

名称	Description	单位 Unit	WL13032F	WL25032F	定制款
板材加工范围	Sheet size	mm	13000×3200	25000×3200	(13000~50000) × (2500~5000)
X轴行程	X axis	mm	13050	25050	(13000~50000)+50
Y轴行程	Y axis	mm	3225	3225	(2500~5000)+25
Z轴行程	Z axis	mm	200	200	200
X、Y轴定位精度	X,Y positioning accuracy	mm/m	±0.05	±0.05	±0.05
X轴重复定位精度	X repeat positioning accuracy	mm/12m	±0.1	±0.1	±0.1
Y轴重复定位精度	Y repeat positioning accuracy	mm	±0.05	±0.05	±0.05
加速度	Acceleration	g	0.5	0.3	定制
X、Y轴联动速度	Combined speed of X/Y axis	m/min	80	80	定制
发生器功率	Laser source capacity	w	10000 / 12000 / 15000 / 20000 / 30000		
机床外形尺寸(L×W×H)	Dimension(L×W×H)	m	18.5×7×3.5	30.5×7×3.5	定制



WL15040F 超大幅面数控激光切割机
WL15040F Large CNC laser cutting machine

BL系列数控光纤激光切割机

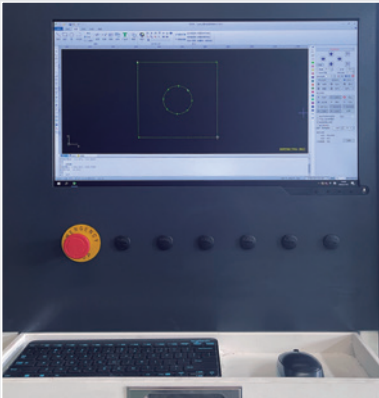
BL Series CNC Fiber Laser Cutting Machine

主要技术特点：

主机采用龙门双驱结构，刚性好，运行平稳；机身钢板焊接并经壁炉退火去应力处理，精度持久稳定；整机采用开放式一体化设计，外观简洁大方，安装方便快捷；采用光纤激光发生器，光电转换效率高，切割速度快，具有免维护、使用成本低、功能强、稳定性高等优点，进口高精度齿轮齿条，定位精度高。

Features:

Gantry and double-driven structure of the machine features high rigidity and steady movement. Steel-weld machine frame gets annealing treatment with constant accuracy. Integration design offers simple outlook and convenient installation. Fiber laser features high electro-optic transfer efficiency, fast cutting, maintenance-free, low cost, powerful function, high stability etc. Hi-precision rack and pinion ensures high positioning accuracy.



高性能控制系统
High performance control



高精度主机身
Main machine frame with Hi-accuracy

BL系列数控光纤激光切割机主要技术参数
Technical Parameter of BL Series CNC Fiber Laser Cutting Machine

名称	Description	单位 Unit	BL3015F	BL4015F	BL4020F	BL6020F	BL6025F	BL8020F	BL8025F
板材加工范围	Sheet size	mm	3000×1500	4000×1500	4000×2000	6000×2000	6000×2500	8000×2000	8000×2500
X轴行程	X axis	mm	3050	4050	4050	6050	6050	8050	8050
Y轴行程	Y axis	mm	1515	1515	2025	2025	2025	2025	2025
Z轴行程	Z axis	mm	80	80	80	80	80	80	80
X、Y轴定位精度	X,Y positioning accuracy	mm/m	0.02	0.02	0.02	0.02	0.02	0.02	0.02
X、Y轴重复定位精度	X,Y repeat positioning accuracy	mm	±0.02	±0.02	±0.02	±0.02	±0.02	±0.02	±0.02
X、Y轴最大速度	X,Y speed	m/min	120	120	120	120	120	120	120
发生器功率	Laser power	W	1000 / 1500 / 2000 / 3000 / 4000 / 6000 / 8000 / 10000 / 12000 / 15000 / 20000 / 30000						
机床外形尺寸	Machine dimension	m	5×3.8×1.8	6×3.8×1.8	5.8×4.6×1.8	8×4.6×1.8	8×5.1×1.8	10×4.6×1.8	10×5.1×1.8

BL系列数控板管复合数控光纤激光切割机

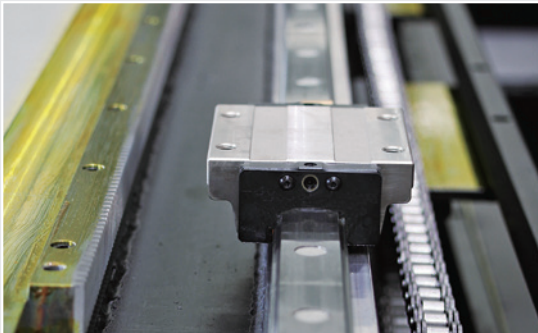
BL Series CNC Fiber Laser Cutting Machine for Tube & Sheet

主要技术特点：

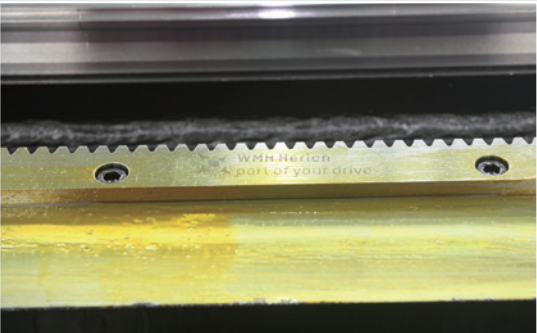
BL3015FT型板管复合数控光纤激光切割机是集板料切割和管材切割为一体的激光切割系统。一台设备上可切割板材和管材，节约成本，性价比高。主机采用龙门双驱结构，刚性好，运行平稳；机身钢板焊接并经壁炉退火去应力处理，精度持久稳定；整机采用开放式一体化设计，外观简洁大方；采用柏楚控制系统，进口高精度齿轮齿条，保证了机床可靠稳定的加工精度；双W旋转，不存在滞后，除可以切割方管、圆管、矩形管等标准管材，还可以切割六边形管、腰形管、椭圆形管等异形管材。

Features:

BL3015FT CNC Fiber Laser Cutting Machine for Tube & Sheet is to cut metal sheet and various tube with high performance and low cost. The machine is of gantry double-drive structure with high rigidity and stability. The machine frame is welded with steel plate and gets annealing treatment to relieve stress for reliable accuracy. The integrated machine design is of simple outlook. The machine is of Friendness Cypcut control, Precision rack & pinion, double W rotation avoiding delay. Cutting square, round, rectangular, hexagonal, waist, oval tubes etc.



可实现低摩擦、平滑运动和长期免维护的超超高刚性导轨
The guideway featuring low-friction, smooth-movement, free of maintenance and hi-rigidity



高精度研磨级的齿轮、齿条
Hi-precision polished worm and rack

□ BL系列板管复合数控光纤激光切割机主要技术参数

□ Technical Parameter of BL Series CNC Fiber Laser Cutting Machine for Sheet and Tube

名称	Description	单位 Unit	BL3015FT	BL4015FT	BL4020FT	BL6025FT	BL8025FT
板材加工范围	Sheet size	mm	3000×1500	4000×1500	4000×2000	6000×2500	8000×2500
切管管径范围	Tube diameter	mm	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220	φ 20 ~ φ 220
X轴行程	X axis	mm	3050	4050	4050	6050	8050
Y轴行程	Y axis	mm	1515	1515	2025	2025	2525
Z轴行程	Z axis	mm	250	250	250	250	250
U轴行程	U axis	mm	6000	6000	6000	6000	6000
X、Y轴定位精度	X,Y positioning accuracy	mm/m	0.02	0.02	0.02	0.02	0.02
X、Y重复定位精度	X,Y repeat positioning accuracy	mm	±0.02	±0.02	±0.02	±0.02	±0.02
X、Y轴最大速度	X,Y speed	m/min	120	120	120	120	120
发生器功率	Laser power	W	1000 / 1500 / 2000 / 3000 / 4000 / 6000 / 8000 / 10000 / 12000 / 15000 / 20000 / 30000				
机床外形尺寸	Machine dimension	m	9×5.3×1.8	9×5.3×1.8	9×5.7×1.8	9×6.2×1.8	10×6.2×1.8

数控激光切割机

RL系列机器人三维激光切割机

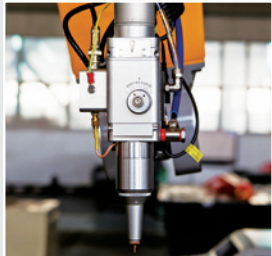
RL Series Robot 3D Laser Cutting Machine

主要技术特点:

主机采用龙门架式结构,机架钢板焊接并经壁炉退火去应力处理,精度持久稳定;采用工业机器人加光纤激光发生器的组合方案,一次性完成加工、修边、切孔等工艺;采用进口IPG光纤激光发生器,光电转换效率高,运行成本低;光路采用光纤传输,维护成本低;采用专用冷水机组,双温控制,冷却效果好;全套进口光纤切割头,具有随动控制和防碰撞功能;法国STAUBLI公司6轴机器人,采用机器人专用控制器CS8C,具备示教编程功能,定位精度高,操作简便,更适合冲压覆盖件的切割需求;配有氧气切割辅助气体供应系统,自动控制不同的切割气压,操作方便快捷。

Features:

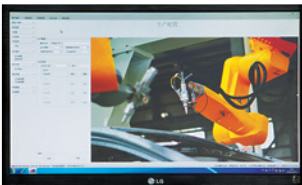
Gantry machine structure and steel-weld machine frame gets annealing treatment with constant accuracy. Industrial robot and fiber laser ensure processing, polishing and cutting. IPG Fiber laser features high electro-optic transfer efficiency and low running cost. Water chiller with dual temperature offers quick and effective cooling. Imported laser cutting head is of follow-up control and anti-collision function. French STAUBLI 6-axis robot features special control CS8C with demonstration programming function, which is accurate and convenient and suitable for cutting form cover. Oxygen supply device controls cutting pressure with convenient operation.



全套进口光纤切割头
Imported laser cutting head



法国STAUBLI公司6轴机器人
French STAUBLI 6-axis robot



机器人专用控制器CS8C
Features special control CS8C

RL2000型机器人三维激光切割机主要技术参数

Technical Data for RL2000 Robot 3D Laser Cutting Machine

名称	Description	单位 Unit	RL2000		
切割板材厚度 (500W)	Sheet metal thickness (500W)	mm	碳钢 Carbon steel		4
切割板材厚度 (1000W)	Sheet metal thickness (1000W)	mm	碳钢 Carbon steel		4
切割板材厚度 (2000W)	Sheet metal thickness (2000W)	mm	碳钢 Carbon steel		4
机器人有效半径	Robot effective radius	mm	2010		
机器人工作范围 Robot work range	轴1 Axis 1		±180°		
	轴2 Axis 2		±137.5°		
	轴3 Axis 3		±160°		
	轴4 Axis 4		±270°		
	轴5 Axis 5		+135°/-110°		
	轴6 Axis 6		±270°		
机器人重复定位精度	Re-positioning accuracy	mm	±0.05		
控制轴数	Control axis		6		
机器人负载	Loading weight	kg	14		
机床重量	Machine weight	kg	7000		
机床外形尺寸	Machine dimensions	m	8.3×4.0×3		



EP系列伺服主传式数控冲床

EP Series CNC Servo-Drive Turret Punch

高速、静音、高精度、节能
HIGH-SPEED, QUIET, HI-ACCURACY, ENERGY-SAVING

主要技术特点:

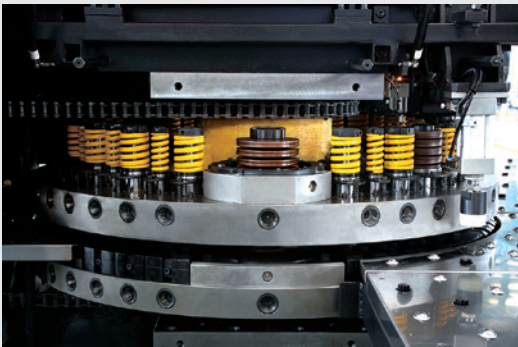
主机采用闭式宽机身结构,壁炉回火去应力处理,稳定性好;流线型设计,动感美观;侧面定位、镶套结构厚转塔,定位精确、导向好、精度高;间隙可调式蜗轮蜗杆机构旋转工位,精度高;直驱式伺服主传动结构,性能稳定,高速静音,节能环保,节电60%;德国SIEMENS或日本FANUC Oip数控系统,功能强、操作简便;高速静音大导程丝杠、直线导轨,国际化配套的气动和电气元件,高性能全自动浮动夹钳,细毛刷结构工程塑料板工作台或钢球毛刷结构不锈钢工作台。

Features:

The machine is of wide closure-type frame, which is solid, receiving tempering treatment. It has following features: streamline body with side pin-positioning, sleeve structure and thick turret, accurate positioning, good guiding, high accurate adjustable worm and gear mechanism, Direct-driven servo main transmission mechanism, reliable performance, hi-speed and no noise, energy-saving by 60%. powerful and convenient German SIEMENS / Japanese FANUC Oip CNC econroller, long ballscrew and guideway with high speed, universal pneumatic and electric parts, auto floating clamp and stainless worktable with full fine brush, Engineering plastic worktable or steel ball & brush on it.



FANUC 数控系统
FANUC CNC Controlling system



厚转塔结构
Thick turret structure
采用球墨铸铁、长镶套式结构,延长使用寿命
It is of spheroidal graphite cast iron and long-bushing structure for long service life.

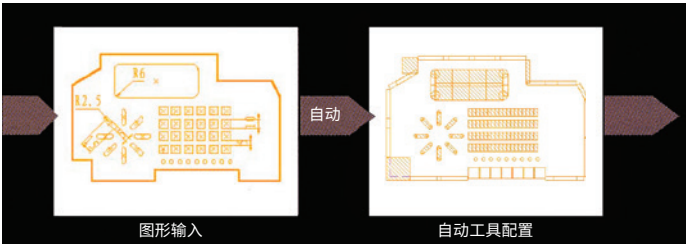
EP主要技术参数

EP Technical Data

规格 Specification		型号 Type	EP20 / EP30 / EP50				
名称 Description							
公称力 Nominal force	kN		200 / 300 / 500				
加工板材尺寸(含一次再定位) Max. sheet size (include one repositioning)	mm		1250×2500	1250×4000	1250×5000	1500×4000	1500×5000
滑块行程 Ram stroke	mm		32				
工件最大厚度 Max. sheet thickness	mm		6.35 / 8				
一次冲孔最大直径 Max. punching dia.	mm		Φ88.9				
模位数 Tool station	个		30				
孔距精度 Punching accuracy	mm		±0.10				
冲孔频率 Punching frequency	hpm		700				
板料最大移动速度 Sheet feeding speed	m/min		106				
床身结构 Frame structure			封闭式				
控制轴数 Controlling axis	个		5轴				
转塔转速 Turret speed	r/min		30				
旋转工位一次冲孔最大直径 Max. punching dia. at index station	mm		Φ88.9				
工件最大质量 Max. sheet weight	kg		156	156	210	210	235
空气压力 Air pressure	MPa		0.55				
外形尺寸长-宽-高Dimension (L×W×H)	mm		5200×3000×2200	5200×4200×2200	5200×5200×2200	5700×4200×2200	5700×5200×2200

数控转塔冲床功能部件

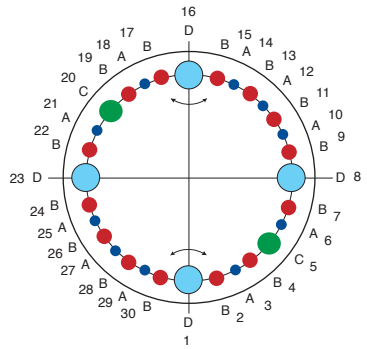
Functional Parts of CNC Turret Punching Machine



- 进口自动编程软件
能根据CAD的图形自动进行模具配置,生成数控系统要求的代码,能够自动识别超程、死区以及成形孔的避让。
- Imported automatic programming software
This software can automatically choose the tools according to the CAD drawing, and can appear the requested codes by the control system, and can automatically realize the over stroke and dead zone and avoid the punched holes.

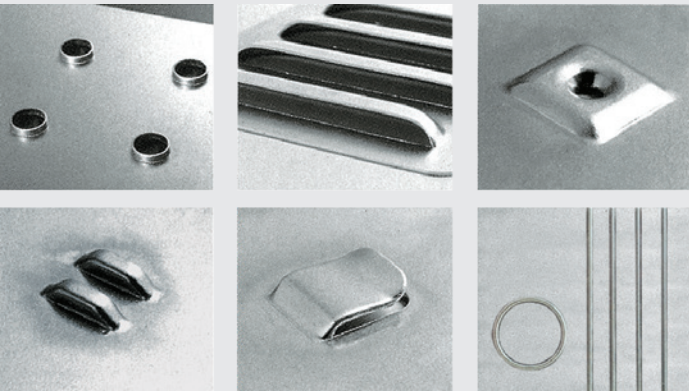
转塔布置图 Turret Layout

工位类别 Station types	30工位 30 station	尺寸范围(mm) Dimension range
A	10	Ø3~Ø12.7
B	14	Ø12.7~Ø31.75
C	2	Ø31.75~Ø50.8
D	2	Ø50.8~Ø88.9
D(旋转)	2	Ø50.8~Ø88.9

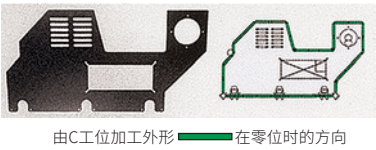


30工位模具分布图
30 station tooling layout

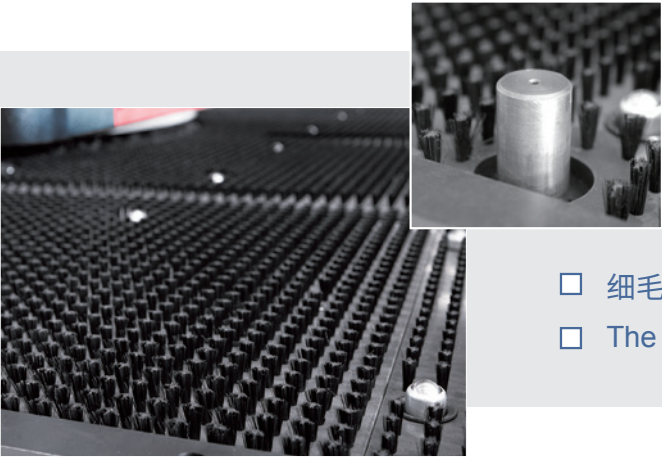
- 直驱式伺服主传动
性能稳定,高速静音,节能环保,节电60%
- Direct driving servo mechanism
Stable function, hi-speed and noise-free, environmental-friendly, energy-saving by 60%



- 丰富的加工图形(由特定的模具加工而成)
- Various working graphs (with specical toolings)



- 自动旋转工位(专利技术)
2套自动分度工位采用剖分式蜗轮蜗杆结构,由数控系统控制,任意改变角度,使加工柔性更大、模具的需求量大大减少,缩短了加工时间。
- Self-rotation station (Patented)
The 2 auto-indexing stations are of worm and wheel construction and are controlled by CNC control system and the rotation can be made freely for a bigger working range, less toolings and working time.



- 细毛刷工作台面
- The worktable with thin brush

FMC-P 冲床上下料装置

Punching machine

FMC-P冲床上下料装置

FMC-P punching machine

主要技术特点：

FMC-P冲床上下料装置,包括装置主体、控制柜、操作台、原料台、成品台等部分,可实行自动化操作:自动抓取待加工板料、自动上料、自动下料;同时,控制系统具有一键启动功能,用户操作简单方便,安全性高,可靠性高,能够节约人力成本,提高生产效率。

Features:

FMC-P punching machine loading and unloading device includes the main body of the device, control cabinet, operation platform, raw material platform, finished product platform, etc. It can implement automated operations: automatic grabbing of the sheet metal to be processed, automatic loading, and automatic unloading; At the same time, the control system has a one click start function, which is easy and convenient for users to operate, has high safety and reliability, can save labor costs, and improve production efficiency.



高可靠性专用系统
Reliable special system

EB3612型全电伺服数控折弯机

EB3612 All-electric Servo CNC Press Brake

主要技术特点:

EB3612 型全电伺服数控折弯机,机身采用钢板焊接,整机经回火处理,保证了机身的刚性和加工精度。伺服电机带动滚珠丝杠来推动滑块上下运动,当板料折弯时,主伺服电机工作;非板料折弯时,主伺服电机停止工作,无液压油,更加节能环保。数控系统采用汇川公司的EP700B系统。磁栅尺精确检测滑块的位置并反馈到数控系统,由数控系统来对伺服电机进行补偿,从而达到闭环的目的。功能齐全的后挡料机构,可选控制多个后挡料轴。该机型具有速度快,精度高的特点。

Features:

EB3612 all-electric servo CNC bending machine is of steel plate welding for the body, and the machine frame is tempered to ensure its rigidity and machining accuracy. The servo motor drives the ball screw to push the ram up and down. When the sheet is bent, the main servo motor works; When no sheet bending, the main servo motor stops working. There is no hydraulic oil, which is more energy-saving and environmentally friendly. The CNC system is of EP700B system of INOVANCE Company. The magnetic scale accurately measure the ram position and feed it back to the CNC system, which compensates the servo motor to achieve closed-loop control. A complete backgauge has different axes choice. The machine is fast and accurate.



EP700B数控系统
EP700B CNC control



□ 主要技术参数
□ Technical Data

参数 Specification		型号 Type	单位 Unit	EB3612	EB6325
名称 Description					
公称力	Nominal force		kN	360	630
最大折弯长度	Bending length		mm	1250	2500
立柱间距	Frame distance		mm	1000	2060
滑块行程	Ram stroke		mm	180	180
最大开启高度	Max. open height		mm	430	520
喉口深度	Throat gap		mm	200	410
工作台宽度	Worktable width		mm	50	100
快下速度	Approach speed		mm/s	200	200
工进速度	Bending speed		mm/s	50	50
回程速度	Return speed		mm/s	200	200
后挡料行程	Backgauge stroke		mm	500	600
机床外形尺寸 Machine dimension	长 L		mm	1700	2950
	宽 W		mm	1650	1650
	高 H		mm	2700	2700

KB系列机械补偿数控折弯机

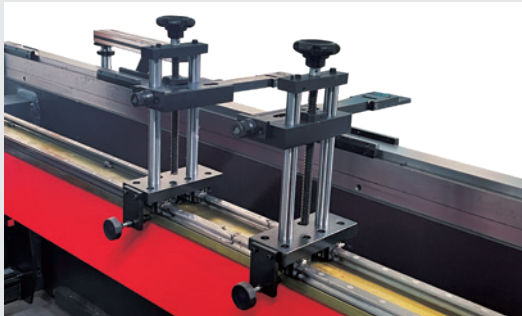
KB Series CNC Control of Mechanical Compensation

主要技术特点：

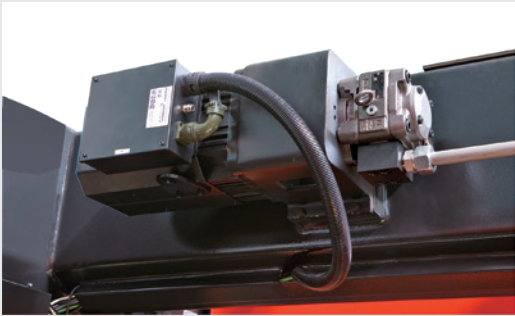
KB系列机械补偿数控折弯机,采用机械式挠度补偿系统,确保工件折弯成型后角度的一致性,采用伺服电机驱动液压泵,电液伺服阀同步控制,控制精度高,速度快,节能40%;机身采用钢板焊接,整机经回火处理;数控系统采用荷兰DELEM公司的DA53T、DA58T、DA66T;后挡料机构可控制多个后挡料轴;配有上模快速夹紧装置。

Features:

KB series of CNC pressbrake is of mechanical deflection compensation device for consistent bending angle, Servo motorized hydraulic pump of electro-hydraulic servo for high precision synchronization control and fast speed, Energy-saving 40% of steel-welded machine frame with annealing treatment. PB series is of CNC pressbrake is of DELEM DA53T, DA58T, and DA66T as optional, of multi-axes backgauge and the punch quick-clamp device.



折弯机标配为3+1轴
The press brake is of 3+1 axis



伺服主电机
Main servo-motor

KB系列机械补偿数控折弯机主要技术参数

Technical Data for KB Series CNC Control of Mechanical Compensation

参数 Specification		型号 Type	单位 Unit	KB0615	KB0625	KB1032	KB1042	KB1632	KB1642	KB2532	KB2542
名称 Description											
公称力	Nominal force		kN	630	630	1000	1000	1600	1600	2500	2500
最大折弯长度	Bending length		mm	1500	2500	3200	4200	3200	4200	3200	4200
立柱间距	Frame distance		mm	1100	2060	2700	3700	2700	3700	2700	3700
最大开启高度	Max. open height		mm	520	520	520	520	520	520	520	520
滑块行程	Ram stroke		mm	215	215	215	215	215	215	215	215
喉口深度	Throat gap		mm	410	410	410	410	410	410	410	410
工作台宽度	Worktable width		mm	100	100	100	100	100	100	100	100
快进速度	Approach speed		mm/s	200	200	200	200	180	180	160	160
工进速度	Bending speed		mm/s	18	18	16	16	18	18	14	14
返程速度	Return speed		mm/s	200	200	200	200	200	200	165	165
后挡料行程	Backgauge stroke		mm	600	600	600	600	600	600	600	600
机床外形尺寸 Machine dimension	长 L		mm	1850	2850	3500	4500	3500	4500	3500	4500
	宽 W		mm	1650	1650	1650	1650	1650	1650	1730	1730
	高 H		mm	2600	2650	2700	2700	2700	2700	2700	2700

KBC系列机械补偿数控折弯机

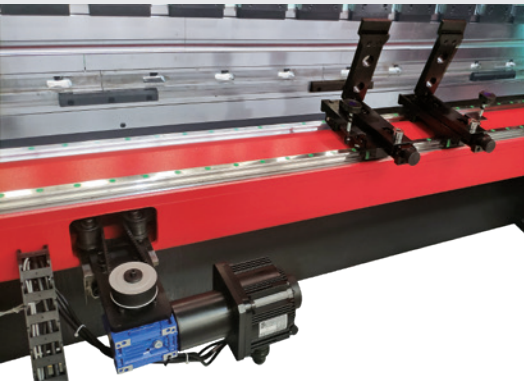
KBC Series CNC Control of Mechanical Compensation

主要技术特点：

KBC系列机械补偿数控折弯机，采用机械式挠度补偿系统，确保工件折弯成型后角度的一致性，采用伺服电机驱动液压泵，电液伺服阀同步控制，控制精度高，速度快，节能40%；机身采用钢板焊接，整机经回火处理；数控系统采用扬力自主开发的MT15、MT19（选配）系统；后挡料机构可控制多个后挡料轴；配有上模快速夹紧装置。

Features:

KBC series of CNC pressbrake is of mechanical deflection compensation device for consistent bending angle, Servo motorized hydraulic pump of electro-hydraulic servo for high precision synchronization control and fast speed, Energy-saving 40% of steel-welded machine frame with annealing treatment. CNC system is the MT15 or MT19 (optional) system developed by YANGLI, and DA66T as optional, of multi-axes backgauge and the punch quick-clamp device.



标配4+1轴后挡料
Standard 4+1 axes backgauge



自主研发MT15数控系统
CNC system MT15 developEd by YANGLI

KBC系列机械补偿数控折弯机主要技术参数
Technical Data for KBC Series CNC Control of Mechanical Compensation

参数 Specification 型号 Type		单位 Unit	KBC0615	KBC0625	KBC1032	KBC1042	KBC1632	KBC1642	KBC2532	KBC2542
名称 Description										
公称力	Nominal force	kN	630	630	1000	1000	1600	1600	2500	2500
最大折弯长度	Bending length	mm	1500	2500	3200	4200	3200	4200	3200	4200
立柱间距	Frame distance	mm	1100	2060	2700	3700	2700	3700	2700	3700
滑块行程	Ram stroke	mm	215	215	215	215	215	215	215	215
最大开启高度	Max. open height	mm	520	520	520	520	520	520	520	520
喉口深度	Throat gap	mm	410	410	410	410	410	410	410	410
工作台宽度	Worktable width	mm	100	100	100	100	100	100	100	100
快进速度	Approach speed	mm/s	200	200	200	200	180	180	160	160
工进速度	Bending speed	mm/s	18	18	16	16	18	18	14	14
返程速度	Return speed	mm/s	200	200	200	200	200	200	165	165
后挡料行程	Backgauge stroke	mm	600	600	600	600	600	600	600	600

PB系列机械补偿数控折弯机

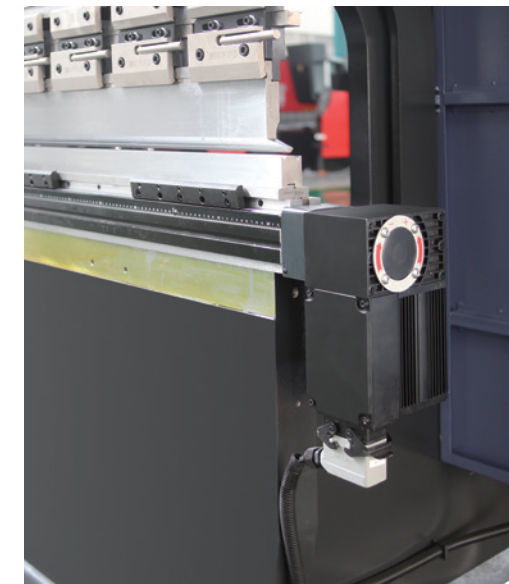
PB Series CNC Control of Mechanical Compensation

主要技术特点：

PB系列机械补偿数控折弯机,采用机械式挠度补偿系统,确保工件折弯成型后角度的一致性,采用电液伺服阀同步控制,控制精度高,速度快;机身采用钢板焊接,整机经回火处理;数控系统采用荷兰DELEM公司DA53T、DA58T、DA66T;后挡料机构可控制多个后挡料轴;配有上模快速夹紧装置。

Features:

PB series of CNC pressbrake is of mechanical deflection compensation device for consistent bending angle, of electro-hydraulic servo for high precision synchronization control and fast speed, of steel-welded machine frame with annealing treatment. PB series is of CNC pressbrake is of DELEM DA53T, DA58T, and DA66T as optional, of multi-axes backgauge and the punch quick-clamp device.



机械式挠度补偿系统自动补偿滑块挠度变形对折弯精度的影响。
Mechanical compensation device is to automatically offset the ram deflection deformation affecting bending accuracy.



高精度磁栅尺安装在C型架上,实时测量滑块位置并反馈到数控系统。
High-precision magnescale on C-frame makes real-time measurement of ram position and sends the feedback to CNC controller.



双折边专用模具(选件)
Double-bending tooling(optional)



标准配置的折弯模具
Standard bending tooling



多槽模具图(选件)
Multi-V die(optional)

大型数控折弯机 Large CNC Press Brake

大型数控折弯机

Large CNC Press Brake



双机联动型数控折弯机

CNC Tandem Pressbrake



数控折弯机功能部件
Functional Parts of CNC Pressbrake



荷兰DELEM DA53T 数控系统, 10.1" 真彩显示 (标配)
DELEM DA53T control system from Holland, 10.1" color display (standard)



荷兰DELEM DA58T数控系统, 15" 真彩显示 (选件)
DELEM DA58T control system from Holland, 15" color display (option)



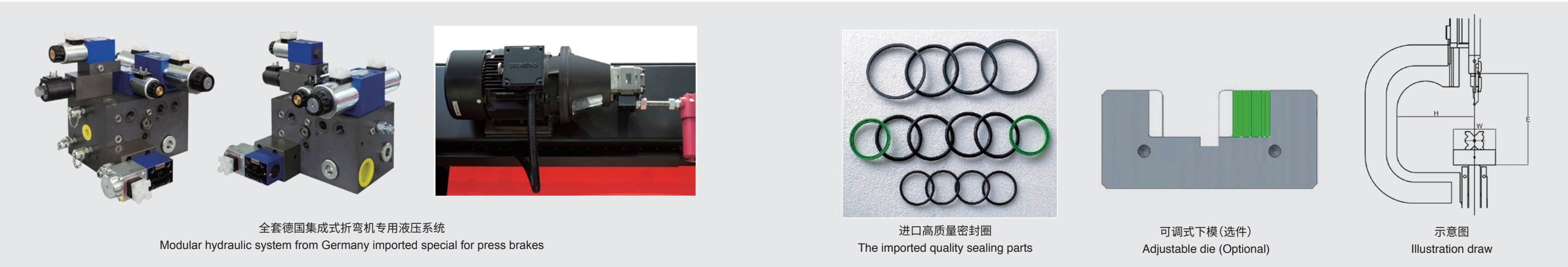
荷兰DELEM DA66T数控系统, 17" 真彩显示 (选件)
DELEM DA66T control system from Holland, 17" color display (option)

PB系列数控折弯机主要技术参数
Technical Data of PB Series CNC Press Brakes

参数Specification		型号Type	PB0615	PB0625	PB1032	PB1042	PB1632	PB1642	PB2532	PB2542	PB3030	PB3040	PB3050	PB4040	PB4050	PB4060
名称Description																
公称力		kN	630	630	1000	1000	1600	1600	2500	2500	3000	3000	3000	4000	4000	4000
Nominal force																
最大折弯长度		mm	1500	2500	3200	4200	3200	4200	3200	4200	3000	4000	5000	4000	5000	6000
Working length																
立柱间距		mm	1100	2060	2700	3700	2700	3700	2700	3700	2500	3150	4050	3150	4050	5050
Frame distance																
最大开启高度E		mm	520	520	520	520	520	520	520	520	520	520	520	520	520	520
Max. shut height E																
滑块行程		mm	215	215	215	215	215	215	215	215	215	215	215	320	320	320
Ram stroke lenght																
喉口深度H		mm	410	410	410	410	410	410	410	410	410	410	410	410	410	410
Throat gap H																
工作台宽度W		mm	50	50	60	60	60	60	60	60	250	250	250	250	250	250
Worktable width W																
快进速度		mm/s	160	160	180	180	160	160	130	130	80	80	80	80	80	80
Idle speed																
工进速度		mm/s	11	11	10	10	11	11	9	9	8	8	8	8	8	8
Work speed																
返程速度		mm/s	140	140	130	130	145	145	105	105	85	85	85	80	80	80
Return speed																
后挡料行程		mm	600	600	600	600	600	600	600	600	500	500	500	500	500	500
Backgauge stroke																
机床外型尺寸	长 L	mm	1850	2850	3500	4500	3500	4500	3500	4500	3300	4300	5300	4300	5300	6400
	宽 W	mm	1650	1650	1650	1650	1650	1650	1730	1730	1950	1950	1950	2100	2100	2100
	高 H	mm	2600	2650	2700	2700	2700	2700	2700	2700	2670	2670	2620	3100	3100	3170
Shipping dimenstions																
机床重量		kg	5000	6000	8000	9500	10000	12000	12500	15000	20000	22000	26000	27000	32000	38000
Machine weight																

注: 1.工作台宽度根据模具结构不同而不同 2.根据用户要求, 以上参数可作调整 3. PB系列数控折弯机均可实现双机或多机联动 4. 上述型号规格产品不需用户开挖地基即可安装
Note: 1.Width of the worktable is in accordance with the tool type 2.The above parameters can be changed based on customers' requirement
3.Tandem press brake or multi-press-brake is available 4. The foundation pitch is not needed for above machines
5.It's the estimated weight here.The actual product shall prevail

数控折弯机功能部件
Functional Parts of CNC Pressbrake



□ PB系列数控大吨位折弯机主要技术参数
□ Technical Data of PB Series Large CNC Press Brakes

参数Specification		型号Type	PB5040	PB5050	PB5060	PB6060	PB6070	PB6080	PB8060	PB8070	PB8080	PB10060	PB10080	PB100120	PB120080	PB120120	PB16080	PB160120	PB20080	PB200120
名称Description																				
公称力		kN	5000	5000	5000	6000	6000	6000	8000	8000	8000	10000	10000	10000	12000	12000	16000	16000	20000	20000
最大折弯长度		mm	4000	5000	6000	6000	7000	8000	6000	7000	8000	6000	8000	12000	8000	12000	8000	12000	8000	12000
立柱间距		mm	3050	4050	5050	5050	6050	6200	4760	5760	6200	4760	6200	9050	6200	9050	6200	9050	6200	9050
最大开启高度E		mm	700	700	700	740	740	740	920	920	920	920	920	920	1020	1020	1020	1020	1020	1020
滑块行程		mm	320	320	320	320	320	320	400	400	400	400	400	400	400	400	400	400	400	400
喉口深度H		mm	400	400	400	400	400	400	500	500	500	600	600	600	600	600	600	600	600	600
工作台宽度W		mm	300	300	300	300	300	300	400	400	400	400	400	400	400	400	400	400	500	500
快进速度		mm/s	75	75	75	80	80	80	75	75	75	70	70	70	65	65	60	60	60	60
工进速度		mm/s	8	8	8	8	8	8	8	8	8	8	8	8	7	7	7	7	7	7
返程速度		mm/s	75	75	75	80	80	80	75	75	75	70	70	70	65	65	60	60	60	60
后挡料行程		mm	700	700	700	700	700	700	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000
机床外形尺寸 Shipping dimenstions	长 L	mm	4500	5500	6500	6500	7500	8500	6500	7500	8500	6500	8500	12500	8500	12500	8500	12500	8500	12500
	宽 W	mm	2700	2700	2700	2700	2700	2700	3120	3120	3120	3520	3520	3520	4250	4250	4470	4470	4820	4820
	高 H	mm	5000	5000	5000	5200	5200	5200	5800	5800	5800	6000	6000	6000	6750	6750	7500	7500	9050	9050
机床重量		kg	40000	45000	55000	65000	70000	76000	102000	108000	115000	110000	135000	185000	160000	225000	215000	265000	270000	332000

注: 1.工作台宽度根据模具结构不同而不同 2.根据用户要求, 以上参数可作调整 3.PB系列数控折弯机均可实现双机或多机联动
4.上述型号规格产品需用户根据生产商提供的地基图纸, 开挖地基才可安装 5.机床重量为估算重量, 具体以实物为准
Note: 1.Width of the worktable is in accordance with the tool type 2.The above parameters can be changed based on customers' requirement
3.Tandem press brake or multi-press-brake is available 4. The foundation pitch based on manufacturer's drawings is needed for above machines
5.It's the estimated weight here.The actual product shall prevail

FB系列数控多边折弯中心

FB Series of auto Multi-edge Folding Centre

主要技术特点:

FB系列数控多边折弯中心,是专门针对箱柜、电器柜等行业而开发的自动化折弯产品,可以根据折弯工艺自动上折、下折动作实现圆弧、压死边、各种角度的组合折弯,为企业节省大量的人工和模具成本。采用全伺服控制,重载滚珠丝杠驱动,速度快,稳定性高,无液压油,节能环保,且经久耐用;采用基于PC自主开发数控系统,采用EtherCAT总线技术,具有折边所需的专用软件功能。

Features:

FB series of auto multi-edge folding centre is for making bin, electric cabinet etc. Arc, hemming, various angle bending can be made on the machine by folding up and folding down, which saves labor and die cost. The machine features fast speed and high reliance with servo control and heavy-duty ballscrew drive, energy-saving and environment-friendly free of hydraulic oil. It is of EtherCAT bus technology and special folding software function.



全伺服传动
All servo drive



折边专用控制系统
Special folding control

主要技术参数 Technical Data

参数 Specification		型号 Type	单位 Unit	FB1500A	FB2000A	FB2500A
名称 Description						
折弯长度	Bending length		mm	1500	2000	2500
进料宽度	Feeding width		mm	1200	1200	1500
折弯高度	Bending height		mm	170	170	170
最小板厚	Minimum thickness		mm	0.4	0.4	0.4
折弯角度	Bending angle		deg	±45	±45	±45
折弯板厚 Sheet thickness	碳钢 Mild steel		mm	2	2	2
	不锈钢 Stainless steel		mm	1.5	1.5	1.5
	铝 Aluminum		mm	2.5	2.5	2.5
最小成型尺寸 Minimum folding size				205×205 (含二次移位, 视具体工件而定) (second displacement, based on actual product)	225×225 (含二次移位, 视具体工件而定) (second displacement, based on actual product)	225×225 (含二次移位, 视具体工件而定) (second displacement, based on actual product)
数控系统 CNC control				自主开发 Independent development		
润滑方式	Lubrication			自润滑 Auto lubrication	自润滑 Auto lubrication	自润滑 Auto lubrication
送料方式	Feeding			上压式 Press up	上压式 Press up	上压式 Press up
控制轴数	Control axis			13轴 13 axes	13轴 13 axes	13轴 13 axes
机床外形尺寸 Machine dimension	长 L		mm	2300	2800	3400
	宽 W		mm	4000	5400	5800
	高 H		mm	2600	2700	2900

MS8-6×3200数控闸式剪板机

MS8-6×3200 CNC Guillotine Shear

主要技术特点:

MS8系列数控闸式剪板机具有剪切角、剪程、刀口间隙及后挡料数控自动调节,上下刀片均有4条刀刃,整机经回火处理,带有气动后托料装置,采用荷兰DELEM公司DAC360专用剪板机数控系统。

Features:

MS8 series CNC shear can automatically adjust its rake angle, shearing length, blade gap and back gauge travel. There are four cutting edges on upper and low blades. The whole frame is treated with annealing. The shear uses DELEM DAC360 CNC control system from Holland, and pneumatic back material support device.



MS8-6×3200数控闸式前送料剪板机

MS8-6×3200 CNC Guillotine The Front-feeding Shear



前送料剪板机工作台
Worktable of the front-feeding shear



MS8系列数控剪板机主要技术参数 Technical Data for MS8 Series CNC Shears

参数Specification			型号Type			
名称Description			6×3200	6×4200	8×3200	8×4200
可剪板厚	Shearing thickness	mm	6	6	8	8
普通钢板	Mild steel					
可剪板宽	Workpiece width	mm	3200	4200	3200	4200
剪切角	Rake angle	°	0.5~2.0	0.5~2.0	0.5~2.0	0.5~2.0
后挡料行程	Backgauge length	mm	1000	1000	1000	1000
后挡料速度	Backgauge speed	mm/s	200	200	200	200
后挡料定位精度	Backgauge accuracy	mm	±0.10	±0.10	±0.10	±0.10
油箱容积	Oil tank capacity	L	200	200	200	200
整机重量	Machine weight	kg	7500	10000	10000	12000
机床 外形尺寸 Shipping dimenstions	长 L	mm	3888	5000	4000	5120
	宽 W	mm	2580	2700	2750	2890
	高 H	mm	1750	1930	1876	1986

注:6毫米以下前送料剪板机,一次送料行程为2500mm
Note: one feeding travel of the front-feeding shear of less than 6mm is 2500mm



车间一角
View of workshop



大型加工设备
Large machining equipment



意大利PAMA加工中心
Italian PAMA boring and milling machine



机身壁炉回火
Machine frame annealed in electrical grate



转台式抛丸清理机
Rotary abrator



企业简介

江苏扬力数控机床有限公司为扬力集团控股的子公司,是数控金属板材加工设备产业基地骨干企业、高新技术企业。公司于2018年3月通过ISO9001-2015质量管理体系认证,产品远销国内外。

本公司主要研发、生产数控激光切割机、数控转塔冲床、数控折弯机和数控剪板机等板材加工设备制造基地。主要产品有 BL、GL系列数控光纤激光切割机及板管复合激光切割机,CL系列卷料激光切割机,PL系列数控光纤切管机,RL系列三维数控激光切割机,ML系列CO₂激光切割机;EP系列伺服数控转塔冲床,MP系列数控转塔冲床,HB系列高速数控折弯机,PB系列机械补偿数控折边机,MB系列数控折弯机;FB系列数控多边折弯中心,MS系列数控剪板机;MF系列板材加工柔性生产线和AP系列汽车大梁平板冲床等钣金加工设备。

公司先后在江淮、浙江、东南、西南、沪宁及北方地区建立了六个分公司和一百多个支公司、办事处。一体化、终端化的售后服务,解决了用户的后顾之忧。

The brief introduction to the company

Jiangsu Yangli CNC Machine Tool Co., Ltd is a subsidiary of Yangli Group. It is a key machine manufacturer in the CNC metal-processing industry base. The company passed the ISO9001-2015 quality management certification in March of 2018. Its machines are popular in China and abroad.

The company makes the CNC laser cutting machine, CNC punching machine, CNC pressbrake, CNC shear, etc. The main products are BL, GL series CNC fiber laser cutting machines, CNC fiber laser cutting machines for pipe and sheet, CL series coil fed laser cutter, PL series fiber laser pipe cutter, RL series 3D laser cutting machines, ML series CO₂ laser cutting machines, EP series CNC servo-drive turret punching machines, MP series CNC turret punching machines, HB series CNC hi-speed pressbrake, PB Series CNC Control of Mechanical Compensation, MB series CNC pressbrake, FB Series of auto Multi-edge Folding Centre, MS series CNC shear, MF flexible sheet processing line and AP series punching unit for automotive frame, etc.

The company has 6 branches in Jianghuai, Zhejiang, Southeast of China, Southwest of China, Shanghai-Nanjing and North China, including more than 100 subsidiaries and representative offices. The complete and excellent after-sales service provides various solutions to customers requirements.

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