

NEW

Q35Y series IRONWORKER

- Hydraulic transmission, is the latest product of the multi-function joint punching and shearing machine, shearing, punching, die cut flat steel, square steel, round steel, angle steel, channel steel, I-beam carried, and equipped with shear blockfeeding devices.



Technical Parameters

MODEL	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40
Punching Pressure (T)	60T	90T	120T	160T	200T
Max.cutting thickness of sheet plates (mm)	16	20	25	30	40
Material strength (N/mm)	≤450	≤450	≤450	≤450	≤450
Angle of shear (°)	7°	8°	8°	8°	8°
Flat bar shearing (T×W)	16×250 8×400	20×330 10×480	25×330 16×600	30×335 20×600	40×335 30×600
Max.length of cylinder stroke (mm)	80	80	80	80	100
Trips frequency (times/min)	11-20	12-20	8-18	6-16	6-16
Depth of throat (mm)	300	355	400	600	530
Punch depth (mm)	16	20	25	28	35
Max.punching diameter (mm)	25	30	35	38	40
Motor Power (KW)	5.5	7.5	11	15	18.5
Overall dimensions (L×W×H) (appro.)	1740×810×1830	1950×900×1950	2355×960×2090	2800×1050×2450	2900×1100×2500

Technical Parameters

(I-beam, channel steel needs to be ordered separately)

MODEL	SECTION	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40
Round Bar	●	45	50	60	65	70
Square Bar	■	40×40	50×50	50×50	55×55	60×60
Equal Angle	L	90°Shearing	120×120×12	140×140×12	160×160×14	180×180×16
		45°Shearing	50×50×5	70×70×10	60×60×6	80×80×8
T-Bar	T	90°Shearing	125×125×12	140×140×12	160×160×14	180×180×16
		45°Shearing	60×60×8	70×70×10	80×80×10	80×80×10
I-beam	I	120×74×5	160×88×6	200×102×9	280×124×10.5	300×130×13
Channel	C	120×53×5.5	160×63×6.5	200×75×9	280×86×11.5	300×89×11.5

Sorry no notice if parameter change!

NEW

HYDRAULIC ANGEL-ADJUSTABLE NOTCHING MACHINE



- Hydraulic bottom-drive, Integral cast steel ensures the cutting accuracy and service life.
- Cutting angle from 40-135 degrees.
- High-carbon chromium alloy, adjustable double-edged blade.
- Cutting gap quick adjustment, double protractor can symmetrically or separately adjust the cutting angle.
- High-quality worktable, concentrated buttons, pedal switch, convenient and high-efficiency.
- Large worktable fixed clamp eliminates plate torque when cutting, visible and transparent safety shield.
- Optional double workbenches, rectangle shearing dies, press brake dies, punching dies.

Model	Max. Plate Thickness (mm)		Max. Plate Length (mm)	Cutting Angle (°)	Stroke Times (n/min)	Workbench length (mm)	Motor Power (kw)	Cutting Dimension (mm)			Weight (kg)
	MS	SS						L	W	H	
4 x 220	0.5-4.0	0.5-2.0	220	45° -135°	≥35	850	3	890	870	1080	860
6 x 220	0.5-6.0	0.5-3.0	220	45° -135°	≥30	850	4	950	920	1150	970

HYDRAULIC ANGEL-FIXED NOTCHING MACHINE



- Use hydraulic under-drive type
- Steel plate of whole machine adopts overall welding structure 90° fixed-angle cutting
- Single-stage & step-stages operation function select
- Positioning device of variable-angle-bit
- Centralized lubricating system
- Polished workbench surface, smooth and level, not hurts workpieces

Model	Max. Plate Thickness (mm)		Max. Plate Length (mm)	Cutting Angle (°)	Stroke Times (n/min)	Workbench length (mm)	Motor Power (kw)	Cutting Dimension (mm)			Weight (kg)
	MS	SS						L	W	H	
4x250	0.5-4.0	0.5-2.0	250	90°	≥35	850	4	910	760	1050	680
6x250	0.5-6.0	0.5-3.0	250	90°	≥35	850	4	910	810	1050	710

JB23 SERIES OPEN BACK & INCLINABLE PRESS



- Casting body, stable performance.
- The inclinable frame made of cast iron make work piece or scrap slide down from the die.
- Rigid rotated bond clutch, simple structure
- The friction brake is used. Fixed with the slide, the overload protector will be damaged to protect the machine from overloading.
- Adopts horizontally placed crankshaft, easily maintain



JH21 SERIES OF PNEUMATIC FRICTION CLUTCH HIGH-PERFORMANCE PRESS

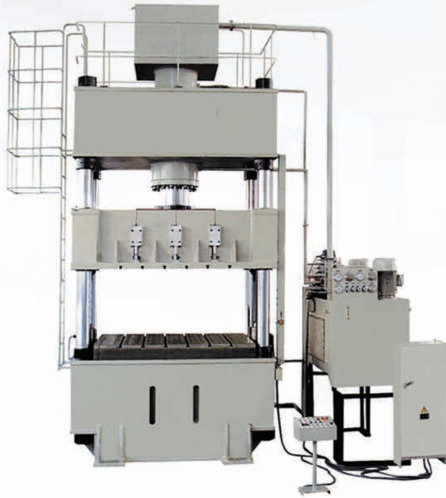


- Welded body with steel plate, higher stiffness and accuracy.
- Adopts longitudinally placed crankshaft, compact structure and handsome appearance.
- Achieves die height adjustment electrically with digital display.
- Slider, square figure long guide with six frictions and bronze liner, which is higher precision.
- Adopts combined friction clutch and brake, engages stably and runs sensitively
- Fixed with the slide, the mechanical overload protector will be damaged to protect the machine from overloading.
- Lift balance cylinder, makes the slider rod balance.



NEW

Y27 SERIES SINGLE-MOVEMENT HYDRAULIC PRESS FOR SHEET METAL DRAWING(STAMPING)



- With a three-beam and four-column structure, this type of press is designed economically and practically.
- The hydraulic system adopts advanced cartridge inserted valve integrated system which has large flow, low pollution, easy control, reliable performance. hydraulic integrated system adopts independent control unit.
- The independent electrical control system ensures the performance of system reliability and operability.
- The machine uses button centralized control, which can be operated in manual/semi-automatic model.
- The pressure of work, the fast down and slow down speed can be adjusted according to process needs.



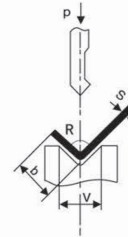
Item	Unit	Y27-200	Y27-250	Y27-315	Y27-400	Y27-500	Y27-630	Y27-800	Y27-1000	Y27-1600
Nominal force	KN	2000	2500	3150	4000	5000	6300	8000	10000	16000
Return force	KN	240	400	600	500	900	850	900	1250	200
Working pressure	Mpa	25	25	25	25	25	25	25	25	25
Cushion pressure	KN	400	400	630	1000	1600	2500	1000	1600	2400
Cushion return force	KN	250	320	360	360	780	720	3000	5000	5000
Daylight of slide	mm	1120	1120	1250	1250	1500	1500	1800	1800	2000
Stroke	Upper slide	mm	710	710	800	800	900	900	1200	1200
	Cushion	mm	250	250	300	300	350	350	365	400
Table size	L-R	mm	1000	1100	1260	1250	1400	1600	3200	4000
	F-B	mm	940	1000	1160	1250	1400	1600	2200	2500
Cushion size	L-R	mm	660	700	820	820	970	1120	2550	3820
	F-B	mm	600	600	700	820	900	1120	1700	1800
Speed of slide	Descent	mm/s	150	130	100	130	120	130	300	350
	Pressing	mm/s	5-12	7-15	5-12	4-10	7-15	5-12	8-22	12-30
Table hight above floor	Return	mm/s	95	90	60	70	80	85	200	300
		mm	700	700	600	600	550	500	900	400
Overall Dimensions	L-R	mm	3100	3250	3100	3150	5800	4150	5400	6200
	F-B	mm	1350	1350	2100	2300	2600	2600	2900	3200
Motor power	KW	15	22	22	22	2x22	2x22	96	160	200

Sorry no notice if parameter change!

LIST OF BENDING PRESSURES

V	4	6	8	10	12	14	16	18	20	24	28	32	36	40	45	55	60	65	70	80	90	100	120
b	2.8	4	5.5	7	8.5	10	11	12.5	14	17	20	22	25	28	31	38	42	46	49	56	63	70	85
R	0.7	1	1.3	1.6	2	2.3	2.6	3	3.3	3.8	4.5	5	6	6.5	7	9	10	11	12	13	14	16	19
0.5	40	30																					
0.6	60	40	30	30																			
0.8		70	50	40	30																		
1		110	80	70	60																		
1.2			120	100	80	70	60																
1.5				150	120	110	90	80															
2					220	190	170	150	130	110													
2.5						250	220	200	170	150	130												
3							330	290	250	210	180	160											
3.5								400	330	290	250	220	200	180									
4									440	370	330	290	260	230									
4.5										470	410	370	330	300	240								
5											510	450	400										
6														520	430	390	360	340	300				
8																700	640	600	520	460	420		
10																			810	720	650		
12																					950	780	
14																						1300	1100

This Chart is calculated according to the plate of tensile strength $\sigma_b=450\text{N/mm}^2$ and length $L=1\text{m}$, the force can be got according to the proportion while different kind of plate and length to be bent.



$$p=650S^2L/V (\sigma_b=450\text{N/mm}^2)$$

P:Bending force(KN)
S:The thickness of the plate(mm)
L:The width of the plate(m)
V:V-width of the bottom die (mm)

Calculation Formula for Plate Bending Force

Processing Workpiece Drawing

