

QZD-SK40 CNC re-bar threading machine

Operating instruction



Hebei Xushi Weiye Machinery Manufacturing CO.,LTD

Address: Qiaoxi street, Wuqiang county, Hengshui city, Hebei, China

Mobile phone: +86-15933856555

Email: export01@xswy-machinery.com

Website: www.xswy-machinery.com

Introduction to thread rolling machine

The thread rolling machine contains 4 power mechanisms, head rotating motor, head translation motor, clamping motor, water pump, a touch screen, a pedal switch, an emergency stop switch, and an electronic control system. The head rotating motor drives the three sets of threading rollers in the machine head to make a rotary motion, and the steel bars are stripped and threaded. The head translation motor drives the threading head to advance and retreat. The clamping motor drives the clamping mechanism to tighten and relax the steel bars. The water pump delivers coolant to cool and lubricate when the steel bar is machined. The touch screen sets parameters such as the length of the thread, and performs self-test and condition monitoring on the machine. The pedal is a start switch in the automatic state of the machine. Emergency stop switch, stop the machine in emergency. The electronic control system inputs three-phase 380V+N (Neutral wire), control three power motors.

Note: The machine box should be reliably grounded.

Main features:

Compared with the traditional manual and pneumatic threading machine, this threading machine is a fully automatic CNC threading machine, removed external detection switch.

High precision, high efficiency, low failure and high reliability. It has a unique advantage for lengthening the thread and the assembly line.

Work flow:

Turn on the power, after the machine self-test, under the automatic interface:

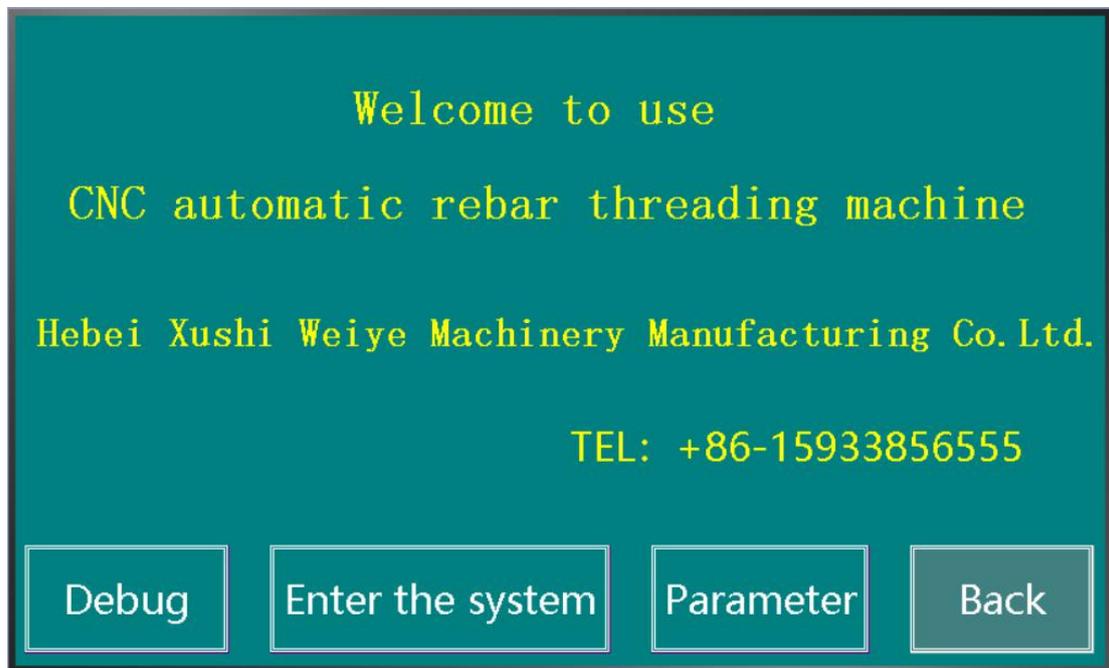
1. First, place the reinforcement bar to the right position.
2. Step on the pedal switch or tap the auto start button on the touch screen.
3. The machine first automatically tightens, then the head rotates and moves forward, stripping ribs and then threading. After the set length, the machine head stops rotating and stops moving forward.
4. The head is reversed and retracted to the origin.
5. When the clamp is opened, the steel bar can be taken out and the machine head automatically moves to the starting position. The process ends.
6. Put in the next rebar. Carry out the next processing.

The operation interface is as follows:

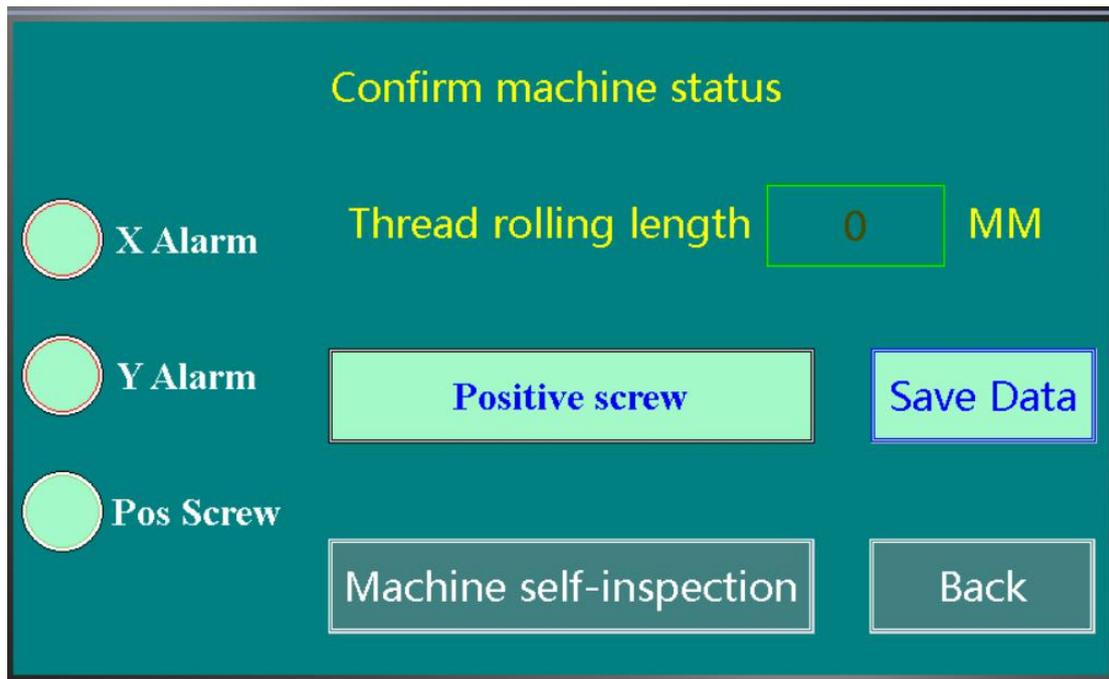
1. Choose “English system” after starting up.



Then you will see the following interface,

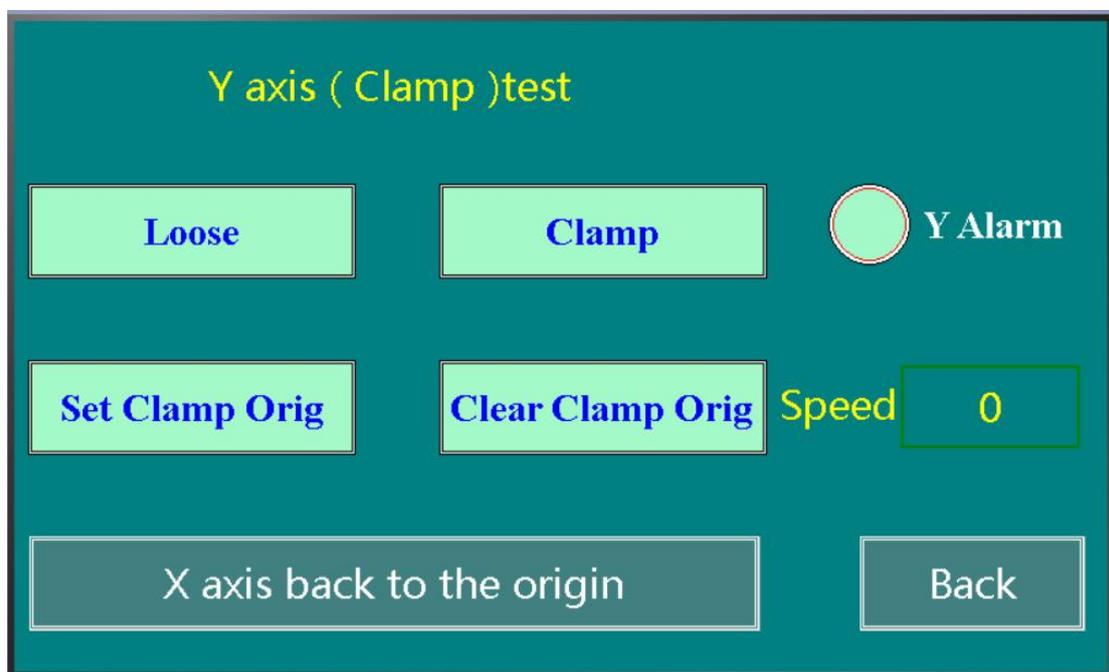


2. Click "Enter the system", enter into "Confirm machine status"



Set thread length in the space as your request, machine default positive screw, if you want change it to negative screw, click "Positive screw".

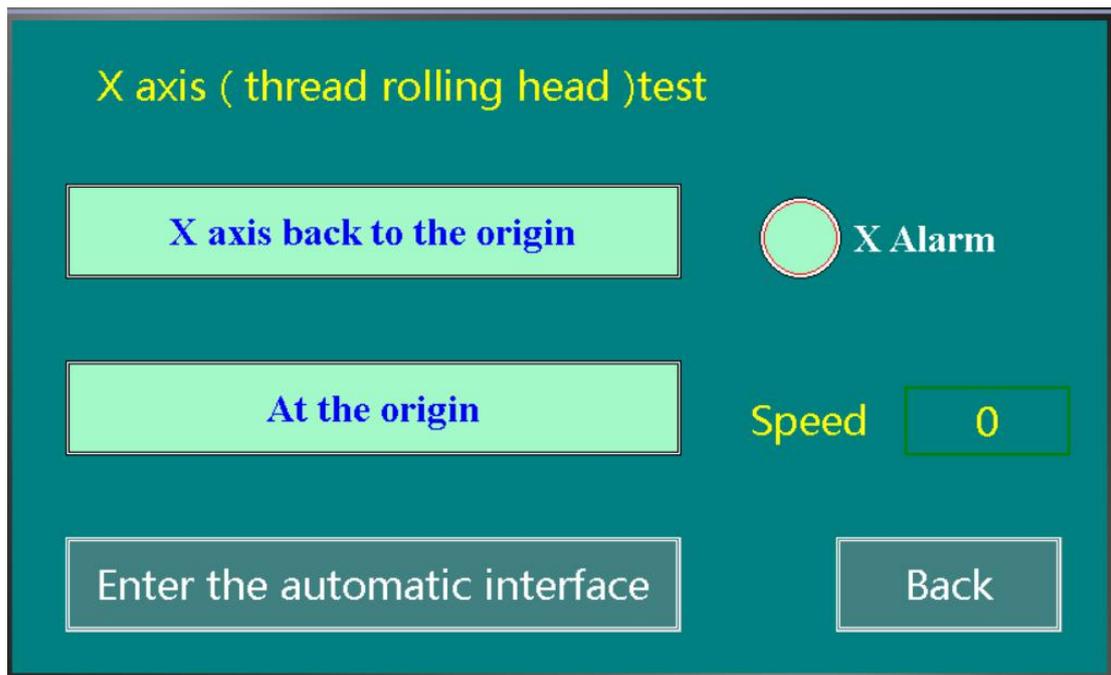
3. Click "Machine self-inspection", enter into "Y axis (clamp) test",



Click "Loose", and "Clamp", the clamping device will have the corresponding action. When the clamping device is at the appropriate opening, click "Set Clamp Orig", this position is the maximum open position you set, when opened to this location, it will automatically stop.

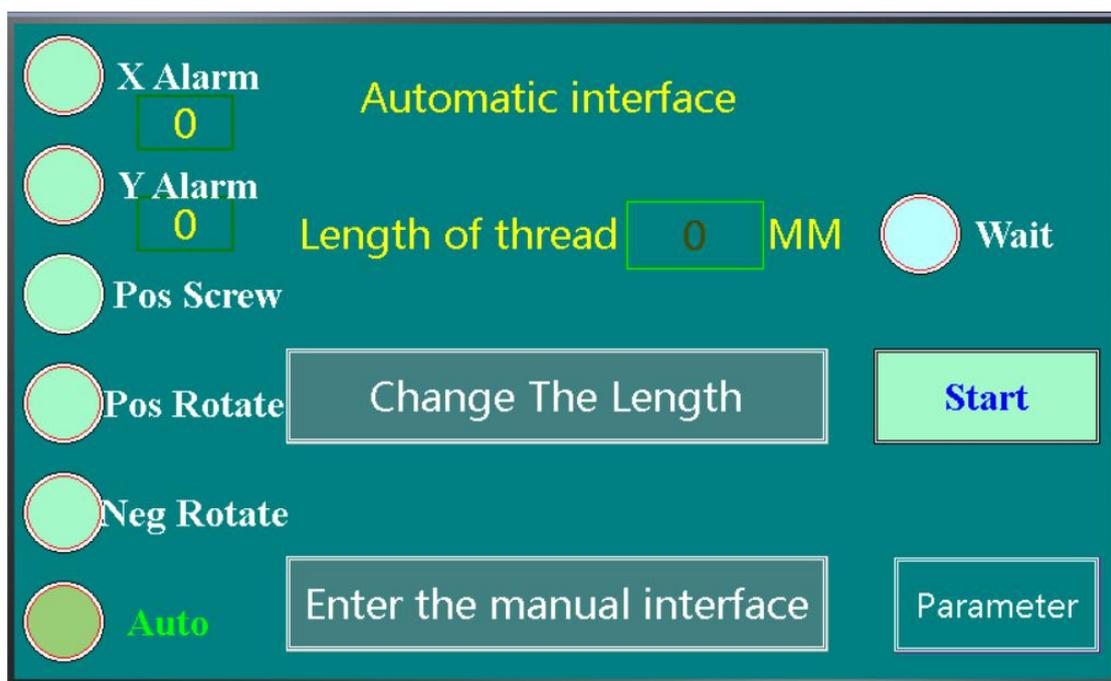
If you want to set the opening bigger, click "Clear Clamp Orig", then click "Loose" to the appropriate opening, click "Set Clamp Orig" again.

4. Click "X axis back to the origin", enter into "X axis (thread rolling head) test",



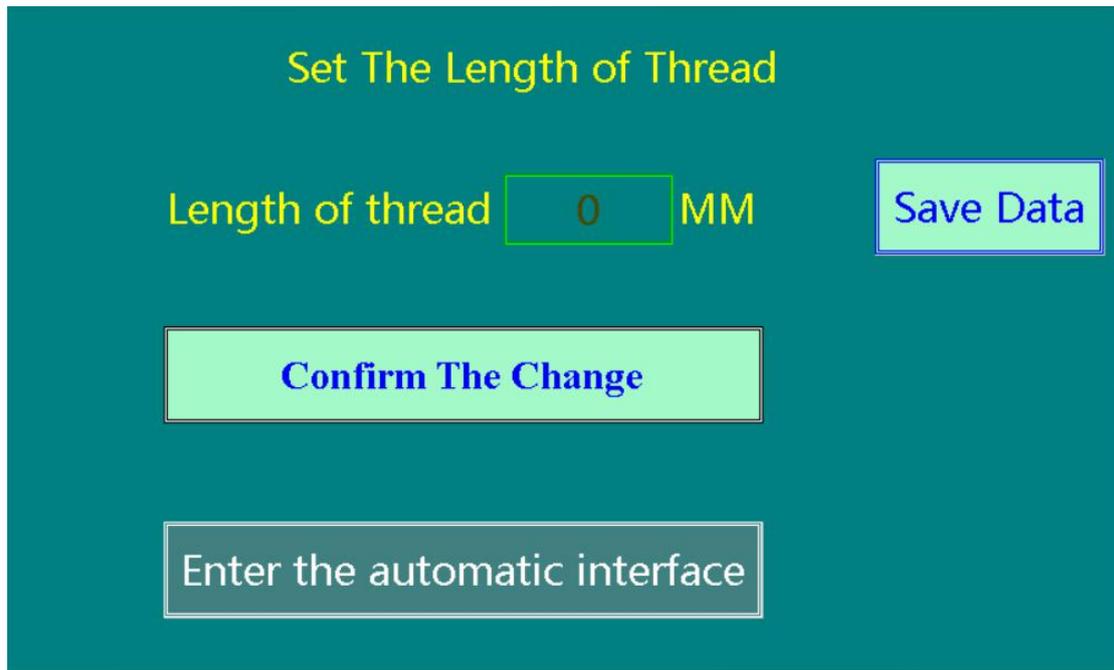
Click "X axis back to origin", the head will move towards the origin, making the head and casing close, after closing, the head will automatically stop moving. when the operator confirms that this action is normal, click "At the origin". If it is not normal, please cut off the power to check whether the machine is stuck by foreign bodies. Do not check the machine under the power on condition to avoid accidental injury.

5. After the machine is normal automatically, click "Enter the automatic interface", enter into "Automatic interface",



Click "Start" or pedal to start processing.

5.1.If the length needs to be modified after the processing,click “Change The Length”,enter into “Set The Length of Thread”,

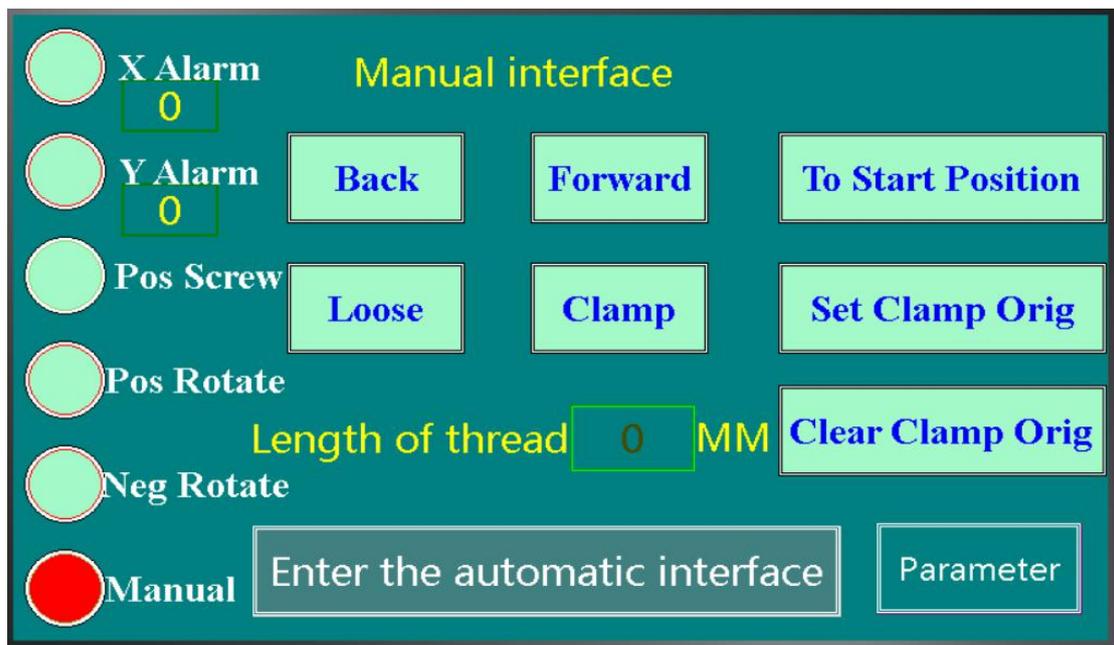


After modifying the length ,click “Save Data”. It will default to this value when it is powered on again.

Click “Confirm The Change”.The head will move to the origin and then to the starting position.

Return to the automatic interface, you can start processing.

5.2 After the processing, click “Enter the manual interface”, you can enter the manual interface.

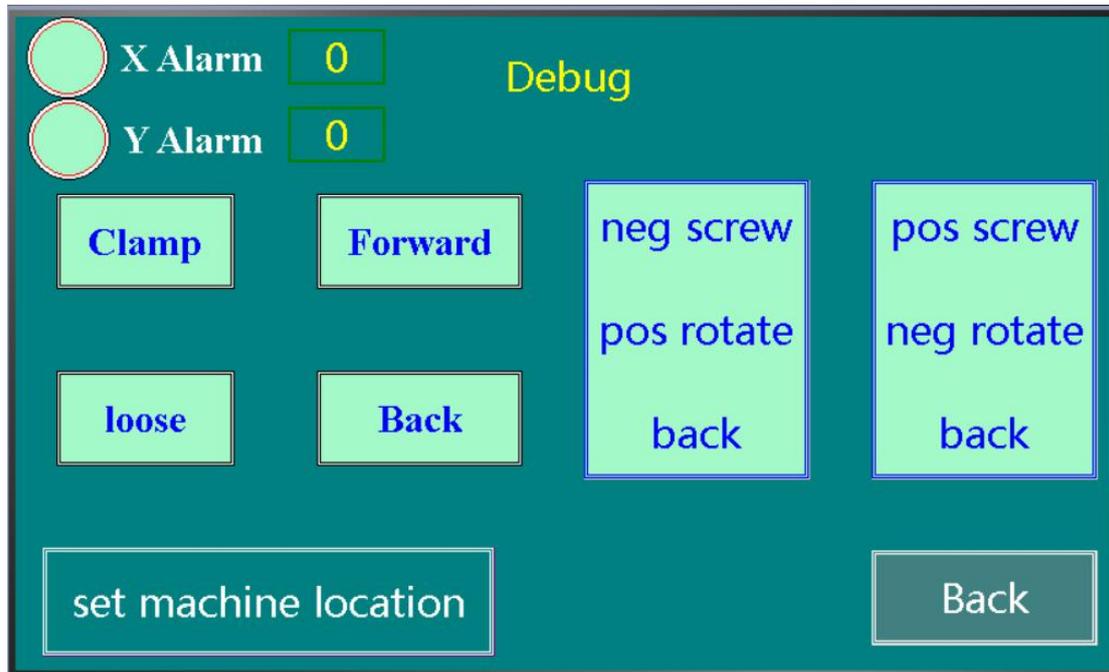


The manual interface can “Forward”,“Back”,,”Loose”,“Clamp”,“To Start Position”. Reset the opening and closing of the clamping device.

6.Factory debugging interface introduction:

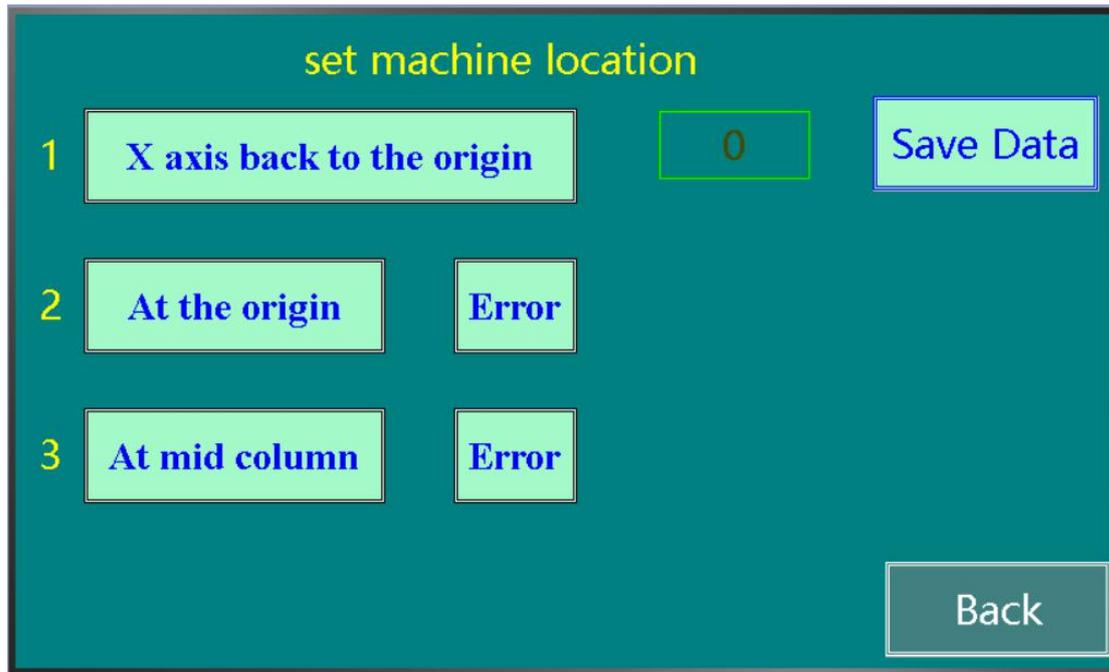
The following is the factory debugging interface, it can “Forward”, “Back”, “Clamp”, and “loose”.

When an accident occurs during the ferrule process, an emergency stop or power failure,this screen can also be accessed after power up.First clamp the steel bar, and clearly whether it is a positive or negative threads,then click the positive back or the negative back, then you can exit the thread.



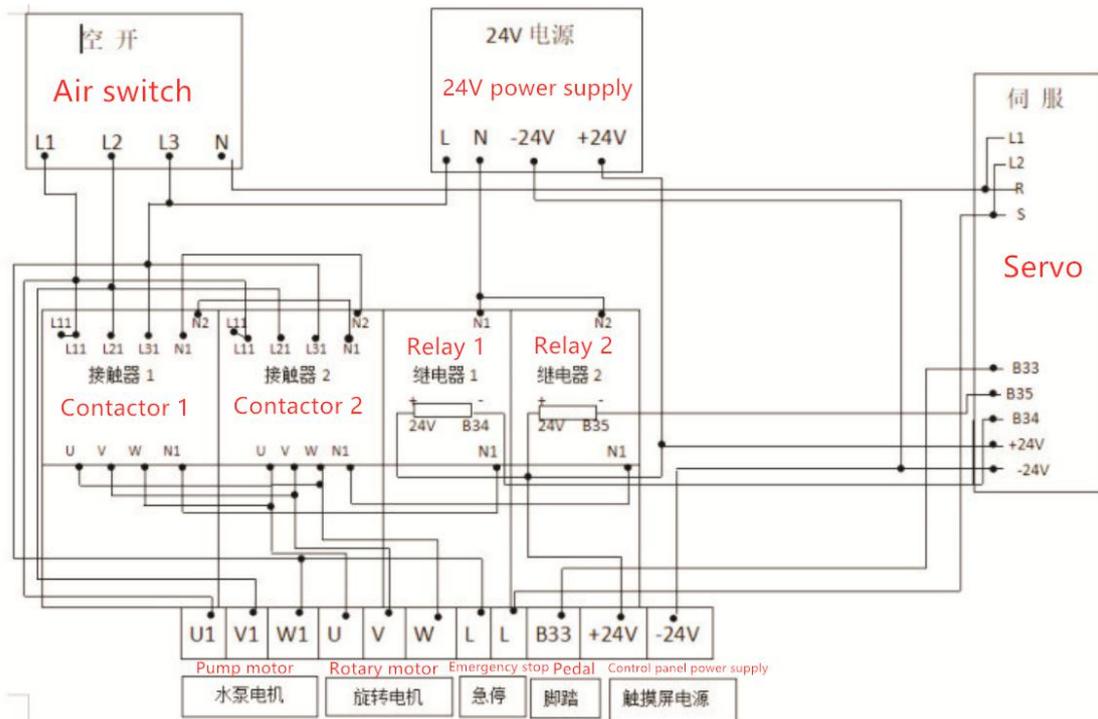
The new machine, or after a period of use, the mechanical positioning device moves, causing the length of the thread to be inaccurate, click “set machine location” to set machine location.

Note: Entering this interface requires a password.



- 1)press "X axis back to the origin"to move the head to the origin.
- 2)press "At the origin" when the head cover completely closes the cutter,
- 3)press "At mid column" when the head cover is just in contact with the middle column.(If steps 2 and 3 are not correct, click the "Error" button and the motor will stop immediately and restart from the first step.)

Wiring diagram



Note: 2 lines of pedal, connected to B33, -24V.

Note: The rotary motor can adjust the rotation direction by adjusting any two lines of U, V, W. The pump motor is similar.