



GREWIN INDUSTRIAL GROUP CO.,LTD.

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NAME: GWA680-120 Automatic Toroidal Core Winder



About Machine :

The automatic toroidal core winder for producing of toroidal core made from grain oriented steel or non-oriented steel for small transformers, transmitters, instrument and voltage transformers, chokes and variable voltage transformers. The machine with the highest quality components and materials, and through the application of an advanced design, very significant economies are provided in low running costs, high speed operation and low maintenance.

The machine is equipped with Panasonic PLC system and HMI touch screen to control the decoiler, winding machine and laser welder. The decoiler feeds the materials to winding machine, the material through the leveling unit, deburring unit pinch roller unit, then machine hand will clamp and feed material from cutting molds to the mandrel, then the servo motor drive the mandrel to wind materials into toroidal core, the laser system welds the end layer with perfect welding spot, at last, the mechanical arm pick up the cores automatically.

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Main Features:

Automatic feeding, punching, winding, cutting, welding and collecting with high speed and efficiency.

PLC system and HMI touch screen to control servo motors, moving parts and pneumatic components.

Continuous feeding, adjustable tension, accurate counting, closed-loop monitoring, automatic alarm.

Automatic laser welding with perfect welding spot, pick up cores by machine hand.

Equipped with lifting platform, leveling unit, deburring unit, tungsten alloy cutting and punching mould.

Equipped with 1000W LED continuous laser welder, and the laser output can be adjustable.



Toroidal Cores

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SPECIFICATION:

A) Toroidal Core Winder (GWA680-50/GWA680-100/GWA680-150)

Shape	Toroidal Core		
Servo Motor	5		
Mandrel Diameter	Ø8- Ø40mm	Ø10- Ø80mm	Ø20- Ø120mm
ID (Min)	Ø8	Ø10	Ø20
OD(Max)	Ø50mm	Ø100mm	Ø150mm
Material Width	5-20mm	5-30mm	10-50mm
Material Thickness	0.18-0.5mm	0.18-0.5mm	0.18-0.5mm
Accuracy	< 0.1mm	< 0.1mm	< 0.1mm
Voltage	380VAC, 50/60Hz, with wire 4mm ²		
PLC	Panasonic		
Air pressure	6kgf/cm ²		
Power	5KW	6KW	8KW
Main Unit Size (LxWxH)	1750x950x1530mm	1800x1000x1530mm	1900x1200x1820mm
Decoiler Size (LxWxH)	1500x750x1410mm	1500x750x1410mm	1500x750x1410mm
Welder Size (LxWxH)	1100x700x1000mm	1100x700x1000mm	1100x700x1000mm
Total Weight	1310KG	1430KG	1550KG
Language	Chinese/English		

Toroidal Core Winder (GWA680-200/GWA680-250/GWA680-500)

Shape	Toroidal Core		
Servo Motor	5		
Mandrel Diameter	Ø40- Ø180mm	Ø40- Ø200mm	Ø100- Ø450mm
ID (Min)	Ø40	Ø40	Ø100
OD(Max)	Ø200mm	Ø250mm	Ø500mm
Material Width	20-80mm	20-100mm	20-120mm
Material Thickness	0.18-0.5mm	0.18-0.5mm	0.18-0.5mm
Accuracy	< 0.2mm	< 0.3mm	< 0.3mm
Voltage	380VAC, 50/60Hz, with cable above 4mm ²		
PLC	Panasonic		
Air pressure	6kgf/cm ²		
Power	13KW	14KW	20KW
Size (LxWxH)	2300x1500x1760mm	2450x1500x1750mm	3100x1700x1750mm
Decoiler Size (LxWxH)	1910x1320x1130mm	1910x1320x1130mm	1910x1320x1130mm
Welder Size (LxWxH)	1100x700x1000mm	1100x700x1000mm	1100x700x1000mm
Total Weight	2420KG	2500KG	2650KG
Language	Chinese/English		

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B) High Speed Decoiler (GWA680-120)

Type	One Side
Expansion	Manual
Max. Coils OD	1200mm
Expand Range ID	450-508mm (Standard)
Max. Coils Loading	1000kg
Max. Feeding Speed	250m/min
Size (LxWxH)	1910x1320x1130mm
Weight	950KG

C) Continuous Laser Welder

Max. Laser Output	1000W
Spot Size	0.5-5mm
Operation Mode	Continuous
Focal Length	150mm
Laser Cable	5m
Cooling Mode	Water-Cooling
Size (LxWxH)	1100x700x1000mm
Weight	180KG

List of components:

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No.	Parts name	Quantity	Origin
1	Panasonic FP Series high performance control system	1	Japan
2	Panasonic servo motor / drive device (for punching die moving)	1	China
3	Panasonic servo motor / drive device (for clamping & feeding)	1	China
4	Panasonic servo motor / drive device (for winding)	1	China
5	Panasonic servo motor / drive device (for cutting)	1	China
6	Panasonic servo motor / drive device (for pushing)	1	China
7	Taiwan Hiwin precision screw	1	Taiwan
8	Taiwan Hiwin precision screw nut	1	Taiwan
9	Taiwan Hiwin precision screw	2	Taiwan
10	Taiwan Hiwin precision screw nut	2	Taiwan
11	Taiwan Hiwin precision linear guideway	3	Taiwan
12	Taiwan SESAME precision servo reducer	2	Taiwan
13	Tungsten alloy punching and cutting die	1	China
14	Taiwan WEINVIEW 10 inch touch screen	1	Taiwan
15	Japanese SMC pneumatic components	-	Japan / China
16	Japanese NSK precision bearings for ball screws (P4 class)	3	Japan
17	All bearings from Japanese NSK/KOYO	-	Japan
18	Taiwanese POINT Heat exchange cooler	1	China
19	Korean AUTONICS encoder	1	Korea
20	Korean Autonics metal detector and origin detector	12	Korea
21	Taiwan CPG gear motor and reducer.(for Lifting)	1	China
22	Taiwan CPG gear motor and reducer.(for Decoiler)	1	China
23	Panasonic inverter (for Decoiler)	1	China
24	Components in control cabinet (Mitsubishi, Schneider, Siemens)	-	Japan / Europe
25	Taiwan ONN 3 colors warning lamp.	1	China
26	Germany Siemens buttons	3	China
27	Toroidal operation system	1	China

PACKAGING:

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Packaging Material: Carton/Wooden case with foam inside.

- 1.General package(Paper carton or plastic bag): For small equipped parts for Digital CNC Wire Coil Winding Machine, Package it with form and pack paper to guarantee unbroken during the transport.
2. Wooden case package: For larger scale Digital CNC Wire Coil Winding Machine ,we have special skilled carpenter, who would make the proper wooden case with exact thickness,density,length.
3. The up arrow ↑marked on the outer wooden case. Buffer material would be put in the wooden case to prevent crack and shock.



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We-GREWIN INDUSTRIAL GROUP is expert in winding machines lines for 28Years. Our Grewin have ISO9001:2015,CE approvals,Machines'Patents,"high-tech enterprises"by the government.



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