

定位旋转设备 Positioning & Rotating Equipment

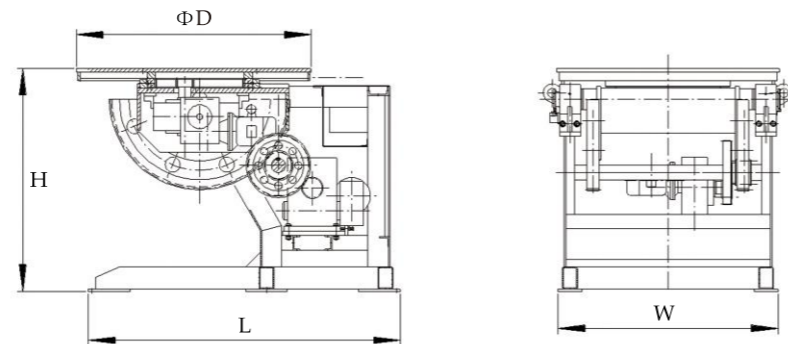
焊接变位机 Welding Positioner

焊接变位机主要是通过工作台的升降、回转、翻转等运动使工件处于最佳焊接位置，有侧翻式、头尾式、升降式及双回转式、水平回转式等多种结构形式。可与焊接操作架配套组成自动焊接专机，还可与机器人配套实现自动化焊接。本公司可根据用户的工作和工艺要求，设计定制各种特制焊接变位机。

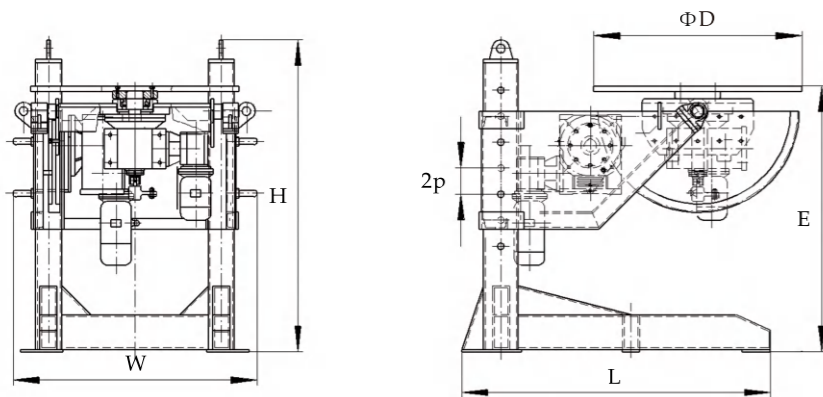
Welding positioner is mainly used to place the work piece in the best position for welding and assembling with the work bench elevating, turning, tilting, its series includes tilting, head and tail stocks, elevating, and double turning positioner, cradle type. The positioner can be supplied for interfacing with robot or welding manipulators, to realize the welding automation. At the same time we can design and customize various type of special positioner according to the technological requirement and different work piece given by the customer.



固定式变位机 Fixed Positioner



升降式变位机 Elevating Welding Positioner



定位旋转设备 Positioning & Rotating Equipment

焊接变位机 Welding Positioner

固定式变位机 Fixed Positioner

型号 Model	额定负载 Rated load Cap tons	电机功率 kW Power		最大重心距 Max Gravity height mm	最大偏心距 Max centroid Eccentricity mm	工作台 Table		直径 mm Diameter ΦD	90度回转 Max Rotation Φ @ 90degree	翻转角度 Tilt Angle (degree)	外形尺寸 Dimensions	设备重量 Weight tons
		回转 Rotation	翻转 Tilt			速度 Speed (rpm)						
						回转 Rotation (variable)	翻转 Tilt (constant)					
WP0.1	0.1	0.06	man.	150	100	0.40-4.0	man.	400	600	0-90	560 × 400 × 420	0.2
WP0.3	0.3	0.37	man.	200	150	0.10-1.0	man.	600	800	0-90	930 × 660 × 720	0.3
WP0.6	0.6	0.75	0.75	200	150	0.10-1.0	1.1	1000	1500	0-90	1200 × 900 × 850	0.7
WP1	1	1.1	1.5	250	200	0.05-0.5	0.67	1200	2000	0-120	1400 × 1200 × 1200	1
WP2	2	1.1	1.5	300	200	0.05-0.5	0.23	1400	2100	0-120	2100 × 1500 × 1350	2
WP3	3	1.5	2.2	300	200	0.05-0.5	0.23	1400	2100	0-120	2100 × 1500 × 1350	2.5
WP5	5	2.2	3	300	200	0.05-0.5	0.14	1500	2500	0-120	2200 × 1500 × 1450	3.7
WP8	8	2.2	4	400	200	0.02-0.2	0.14	2000	3200	0-120	2700 × 2000 × 1850	4.5
WP10	10	3	5.5	400	200	0.02-0.2	0.14	2000	3200	0-120	2700 × 2000 × 1850	5.8
WP15	15	3	5.5	450	200	0.015-0.15	0.1	2200	3200	0-120	3300 × 2230 × 2000	8
WP20	20	4	7.5	450	200	0.015-0.15	0.1	2300	3200	0-120	3300 × 2230 × 2000	11
WP30	30	7.5	11	500	200	0.015-0.15	0.1	2500	3400	0-120	3675 × 3000 × 2750	18
WP40	40	11	11	500	200	0.015-0.15	0.1	2500	3400	0-120	4000 × 3000 × 3300	22
WP50	50	11	15	500	200	0.015-0.15	0.1	3000	4200	0-120	4525 × 3500 × 4100	27
WP75	75	15	15	500	300	0.015-0.15	0.05	3500	4200	0-120	5100 × 3600 × 4400	41
WP100	100	15	18.5	600	300	0.015-0.15	0.05	4000	5700	0-120	5600 × 4200 × 4500	65

升降式变位机 Elevating Welding Positioner

型号 Model	额定负载 Rated load Cap tons	电机功率 kW Power		最大重心距 Max Gravity height mm	最大偏心距 Max centroid Eccentricity mm	工作台 Table		直径 mm Diameter ΦD	90度回转 Max Rotation Φ @ 90degree	翻转角度 Tilt Angle (degree)	外形尺寸 Dimensions		设备重量 Weight tons
		回转 Rotation	翻转 Tilt			速度 Speed (rpm)					L × W × H (mm)	Emin-max/p(m)	
						回转 Rotation (variable)	翻转 Tilt (constant)						
EWP1	1	1.1	1.5	250	150	0.12-1.2	0.67	900	1500	0-135	1210 × 1500 × 1670	1.1 × 1.7/0.15	1.2
EWP2	2	1.1	1.5	300	150	0.05-0.5	0.23	1200	2000	0-135	1780 × 1320 × 1800	1.2 × 1.8/0.15	1.6
EWP4	4	1.5	2.2	300	150	0.05-0.5	0.23	1400	2100	0-120	2140 × 1500 × 2100	1.3 × 1.9/0.15	2.8
EWP6	6	2.2	3	300	150	0.05-0.5	0.14	1500	2500	0-120	2760 × 1630 × 2600	1.6 × 2.4/0.2	5.0
EWP8	8	2.2	4	400	200	0.02-0.2	0.14	1600	2800	0-120	2950 × 1850 × 2800	1.7 × 2.6/0.22	6.5
EWP10	10	3	5.5	400	200	0.02-0.2	0.14	1800	3000	0-120	3300 × 2000 × 3100	1.9 × 2.9/0.24	7.8
EWP15	15	3	5.5	400	200	0.02-0.2	0.1	2000	3200	0-120	3600 × 2200 × 3450	2.1 × 3.2/0.25	12
EWP20	20	4	7.5	400	200	0.02-0.2	0.1	2200	3400	0-120	4000 × 2400 × 3800	2.3 × 3.5/0.3	18

Notes:

- a) Control cabinet includes: power indicator, speed indicator, speed adjustment, overturn (tilt) up and down, forward and reverse rotation, stop, fault & reset
- b) Remote control box allows adjustment of table rotating speed (digital display in rpm), forward and reverse rotation, and stop
- c) "T" shaped channels on work table surface
- d) Shot blasted frame at SA 2 1/2, before being painted
- e) The information contained in this brochure is intended to be accurate. However the manufacturer retain the rights to make changes in design which may not be include herein

Optional:

- i) Foot control pedal for changing rotation direction and stop
- ii) variable speed on tilt

定位旋转设备 Positioning & Rotating Equipment

头尾式变位机 Head Tail Positioner

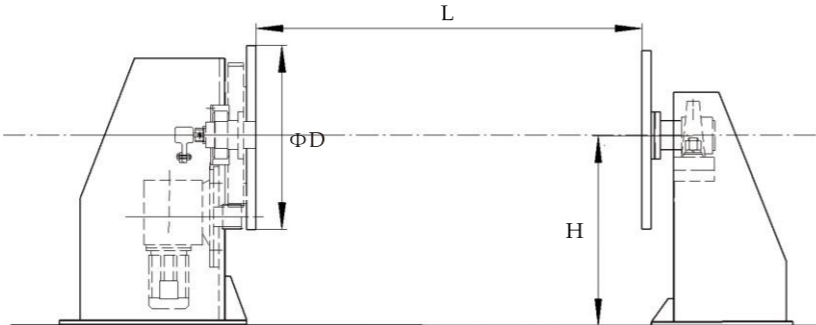
单回转焊接变位机用途最为广泛，可使工件上平行回转主轴的焊缝变位到船型焊位置，其他焊缝变位到平焊位置。其结构特点：

- ◎新型蜗轮蜗杆减速机，结构紧凑、可靠性高。
- ◎末级回转支承，提供更高的抗倾覆力和扭矩。
- ◎加厚前板箱体结构，强度更高、稳定性更好。
- ◎焊接箱式结构，刚度高变形小。
- ◎良好的旋转导电结构，可靠稳定。
- ◎回转分为定速和变速，分别配合手工和自动焊接；也可以配合焊接机器人使用。
- ☆☆尾架部分可以根据客户要求设计成移动式。

Head & tail stock positioner widely used in all line of mechanical welding plant, deflection of workpiece can make parallel axis of rotation to ship welding seam deflection. The structural features:

- + Worm gear and worm reducer, compact structure, high reliability.
- + Slewing bearing providing higher resistance to overthrow force and torque.
- + Former board cabinet, thickening, strength, higher stability.
- + Welding box frame, high stiffness distortion.
- + Excellent welding wire, electric equipment, especially in the automatic welding, welding current, voltage stability.
- + Including: constant and variable speed two type, with manual and automatic welding respectively, Also can use with welding robot.

☆☆Tail stock can be designed according to customer requirements into mobile.



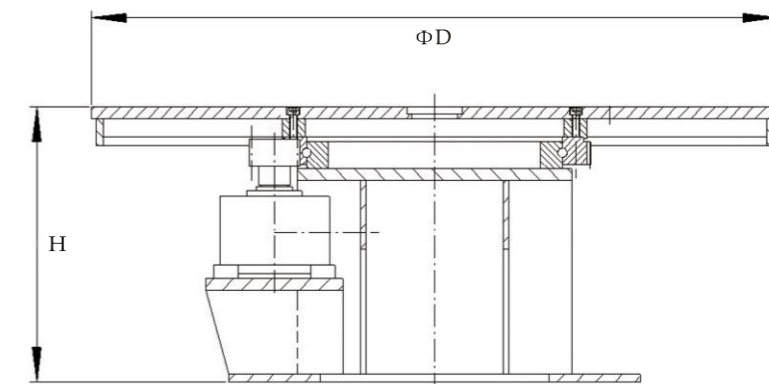
型号 Model	额定负载 Rated load Cap tons	电机功率 Power kW	驱动扭矩 Driving Moment Newtons- meter	最大偏 心距 Max centroid Eccentricity mm	工作台 Table		回转中心高 mm Revolve center height H	设备毛重 tons Weight
					速度 Speed (rpm)	直径 mm Diameter Φ D		
HT0.5	0.5	0.75	2100	300	1.5	600	600	0.9
HT1	1	0.75	2100	200	1.5	800	800	1.5
HT2	2	1.1	4600	150	1.5	800	800	1.8
HT3	3	1.5	6400	150	1.5	800	800	3.2
HT5	5	1.5	9000	150	1	800	800	5.1
HT7.5	7.5	2.2	13500	150	1	1000	800	8
HT10	10	2.2	13500	100	1	1000	1000	10
HT15	15	3	18000	100	1	1000	1000	13
HT20	20	3	30000	100	0.8	1000	1000	14
HT30	30	4	36000	100	0.5	1000	1000	20
HT50	50	4	60000	100	0.4	1500	1200	23
HT100	100	5.5	120000	100	0.2	1500	1200	26

定位旋转设备 Positioning & Rotating Equipment

水平回转平台 Floor Turntable Positioner



型号 Model	额定负载 Rated load Cap tons	电机功率 Power kW	驱动扭矩 Driving Moment Newtons- meter	最大偏 心距 Max centroid Eccentricity mm	工作台 Table		外形尺寸 Dimensions	设备毛重 tons Weight
					速度 Speed (rpm)	直径 mm Diameter Φ D		
FT0.2	0.2	0.18	40	100	0.20 ~ 2	600	600 × 600 × 300	0.5
FT0.5	0.5	0.18	80	100	0.1 ~ 1.0	800	800 × 800 × 300	0.9
FT1	1	0.25	100	100	0.1 ~ 1.0	1000	1000 × 1000 × 500	0.9
FT2	2	0.37	320	100	0.05 ~ 0.5	1200	1000 × 1000 × 500	1.0
FT3	3	0.55	400	100	0.05 ~ 0.5	1500	1500 × 1500 × 600	1.1
FT5	5	0.75	600	100	0.05 ~ 0.5	1500	1500 × 1500 × 650	1.1
FT10	10	1.1	1200	100	0.05 ~ 0.5	1800	1800 × 1800 × 650	1.5
FT20	20	1.5	2400	100	0.02 ~ 0.2	2000	2000 × 2000 × 750	2.5
FT40	40	2.2	4500	100	0.02 ~ 0.2	2200	2200 × 2200 × 750	3.1
FT50	50	2.2	6000	100	0.015 ~ 0.15	2500	2500 × 2500 × 750	4.5
FT60	60	3	8500	100	0.015 ~ 0.15	2800	2800 × 2800 × 800	6.5
FT100	100	4	12000	100	0.01 ~ 0.1	2800	2800 × 2800 × 1000	7.8
FT150	150	5.5	15000	100	0.01 ~ 0.1	2800	2800 × 2800 × 1200	8.5
FT200	200	5.5	21000	100	0.01 ~ 0.1	3000	3000 × 3000 × 1200	12.0

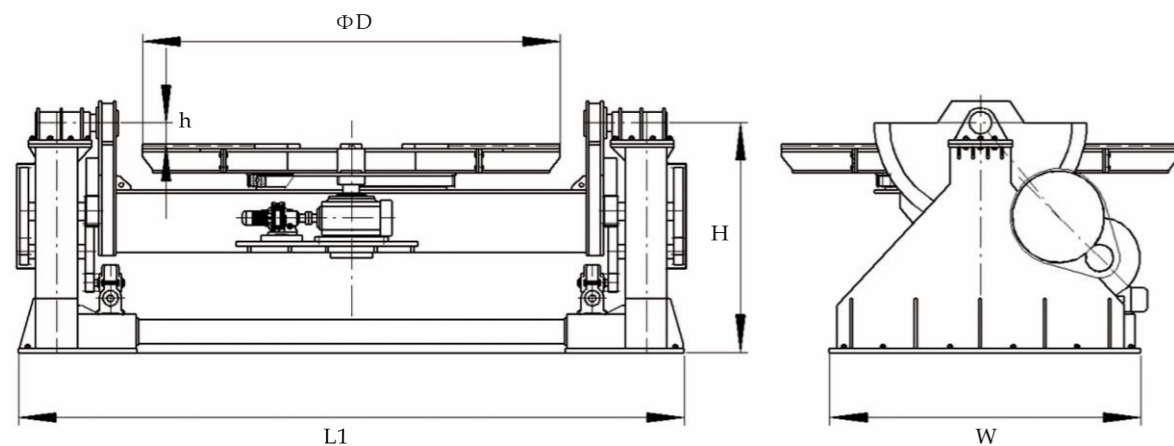


定位旋转设备 Positioning & Rotating Equipment

双座式变位机
Cradle Welding Positioner



型号 Model	额定负载 Rated load Cap tons	电机功率 kW Power		最大重心距 Max Gravity height mm	最大偏心距 Max eccentricity mm	工作台 Table			90度回转直径 Max Rotation @ 90degree mm	翻转角度 Tilt Angle (degree)	外形尺寸 Dimensions		设备毛重 Weight tons
		回转 Rotation	翻转 Tilt			速度 Speed (rpm)		直径 Diameter ΦD mm			L × W × H (mm)	h (m)	
						回转 Rotation (variable)	翻转 Tilt (constant)						
CWP20	20	5.5	2 × 3	800	300	0.02 ~ 0.2	0.1	3200	4000	-45° ~ +90°	5572 × 2800 × 2300	200	25
CWP30	30	11	2 × 5.5	1200	400	0.02 ~ 0.2	0.1	4000	4000		6370 × 2800 × 2300	200	34
CWP50	50	15	2 × 7.5	1200	400	0.02 ~ 0.2	0.1	4000	4000		6370 × 2800 × 2300	200	35
CWP60	60	18.5	2 × 11	1800	300	0.02 ~ 0.2	0.1	5000	5500		8100 × 4000 × 3100	300	65
CWP80	80	22	2 × 15	1800	300	0.02 ~ 0.2	0.1	5000	5500		8100 × 4000 × 3100	300	68
CWP100	100	2 × 15	2 × 18.5	2000	300	0.02 ~ 0.2	0.1	5000	6000		9300 × 4300 × 3500	300	75
CWP150	150	2 × 18.5	2 × 22	2000	300	0.02 ~ 0.2	0.1	5000	7000		1100 × 4450 × 4800	300	85



定位旋转设备 Positioning & Rotating Equipment

双立柱式升降变位机
Double column elevating Positioner

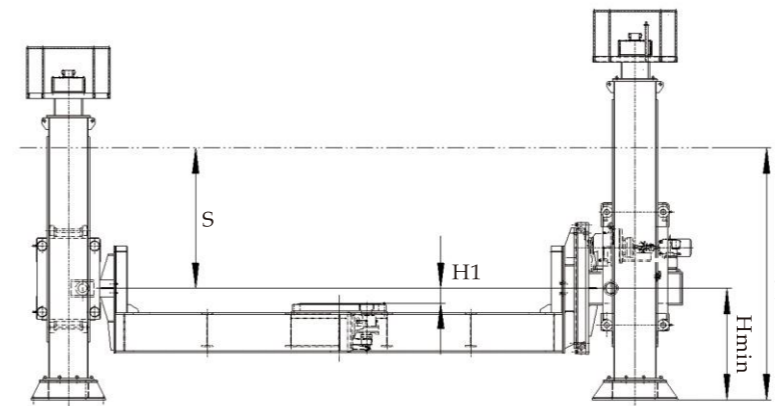


升降形式的焊接变位机主要用于解决高位置焊缝焊接问题，同时可以提供较低的安装位置，使工件装卡更为容易，配合单回转或双回转机构，可使装卡在工作台上的被焊构件得到更为理想的焊接位置。

- ◎丝杠提升（或链条），配合安全螺母，安全可靠。
- ◎高强度立柱，配合变频器，平稳无冲击。
- ◎双座采用同步或异步升降，安装快捷、调试维修方便。

Dwp type elevating welding positioner is mainly used for solving problems of high position, also can weld seam provide low installation position, make the workpiece clamp and fix more easily or double, including single revolve and double revolve frame, can make the work piece on better welding position.

- + Ball screw (or chain), with security nut, safe and reliable.
- + High strength, cooperate, inverter, no impact on the smooth.
- + Using electrical synchronous on elevating action, easily fast installation, commissioning, maintenance convenience.



型号 Model	额定负载 Rated load Cap tons	翻转部分 Tilting		升降部分 Elevating				工作台 Table		
		速度 Speed rpm	重心距 gravity centre dist. mm	速度 Speed m/min	最低 Min ctr dist. Hmin mm	最高 Max ctr. Dist. Hmax mm	有效行程 Elevating stroke S mm	最大偏心距 Max eccentricity mm	速度 Speed rpm	工作台中心距 Table surf to ctr H1 mm
DWP1	1	2	200	1	800	1600	800	200	N/A	N/A
DWP2	2	2	200	1	800	1600	800	200	N/A	N/A
DWP3	3	1.8	200	1	800	1600	800	300	N/A	N/A
DWP4	4	1.5	200	1	800	1600	800	300	N/A	N/A
DWP5	5	1.5	200	1	1000	2000	1000	300	N/A	N/A
DWP6	6	1.5	200	1	1000	2000	1000	300	N/A	N/A
DWP8	8	1.5	200	1	1000	2000	1000	300	N/A	N/A
DWP10	10	1	300	1	2000	3000	1000	150	0.05 ~ 0.5	100
DWP20	20	1	300	1	2000	3000	1000	150	0.05 ~ 0.5	100
DWP30	30	0.5	450	0.5	2000	3500	1500	150	0.05 ~ 0.5	150
DWP50	50	0.5	450	0.5	2000	3500	1500	150	0.05 ~ 0.5	150
DWP80	80	0.2	600	0.2	2600	4100	1500	250	0.02 ~ 0.2	250

定位旋转设备
Positioning & Rotating Equipment

焊接变位机
Welding Positioner



批量变位机
Welding positioner



批量变位机
Welding positioner



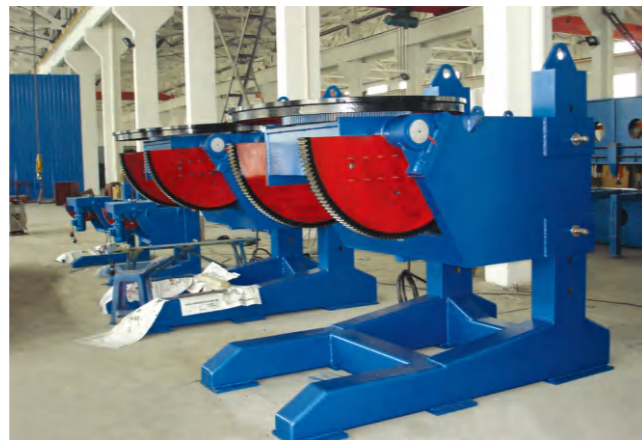
双卡盘管子变位机
Welding positioner with chuck



管子变位机
Pipe positioner



批量变位机
Welding positioner



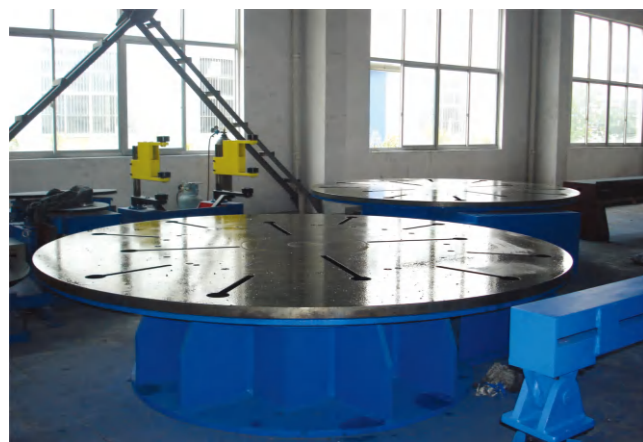
升降变位机
Elevating welding positioner



L型变位机
L type elevating positioner



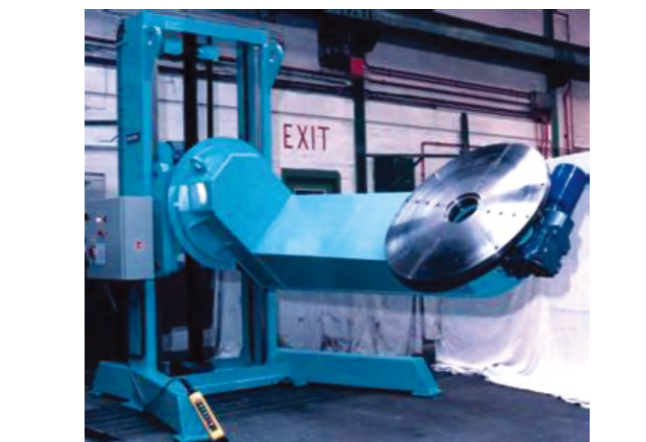
升降变位机
Elevating welding positioner



60t回转平台
FT60 Floor turntable positioner



100t头尾变位机
HT100 Head tail positioner



L型升降变位机
L type elevating positioner



双座变位机
Cradle welding positioner

定位旋转设备
Positioning & Rotating Equipment

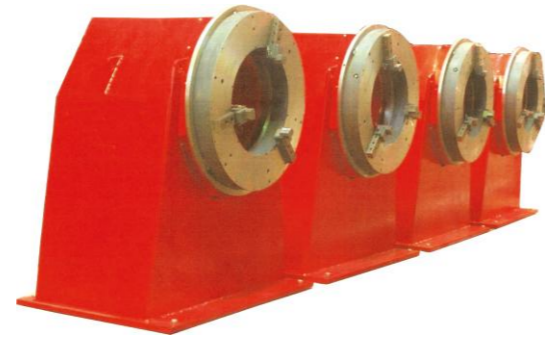
焊接变位机
Welding Positioner

定位旋转设备 Positioning & Rotating Equipment

焊接变位机
Welding Positioner



头尾式变位机
Welding positioner with chuck



管子变位机
Pipe positioner



135° 翻转变位机
135° tilting positioner



焊接变位机
Welding positioner



升降变位机
Elevating welding positioner



双座变位机
Cradle welding positioner



管子变位机
Pipe positioner



头尾式单回转变位机
Head and tail stocks and single turning positioner



双座变位机
Cradle welding positioner



30吨升降变位机
DWP30 Double column elevating Positioner



头尾式变位机
Head tail welding positioner



头尾式变位机
Head tail welding positioner



L型双回转变位机
Scraper pan positioner



液压升降变位机
Hydraulic elevating positioner



特制变位机
Custom built positioner



120吨特制变位机
WP120 custom built positioner

定位旋转设备 Positioning & Rotating Equipment

焊接变位机
Welding Positioner