

Qiaolian.Ironworker

Qiaolian Laser Technology(Xuzhou) Co.,Ltd

Q35Y系列液压联合冲剪机

Q35Y series hydraulic combined punching and shearing machine



机器采用了更先进的液压系统，在确保安全第一的前提下，对板材、方钢、圆钢、角钢、槽钢、工字钢进行高效的剪切、冲孔、模剪或者折弯。可选配的智能后挡料能够精确且高效的为您控制落料长度。

The more advanced hydraulic system of our machines puts your safety as supremacy. And it can do these jobs high-efficiency for you: Punch, Angle Shear, Flat Shear, Round/Square Bar Shear, Rec. Notch, V-Notch, Channel Shear, I-beam Shear, T-bar Shear, Press Brake, Angle Bending and Pipe Notching. Intelligent back gauge makes your work pieces more accurate.

技术参数 Technical parameters

型号 Model	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40	Q35Y-50
冲压力 (吨) Pressure (Ton)	65	90	120	160	200	250
可剪最大板厚 (毫米) Max.shearing thickness (Flat bar)(mm)	16	20	25	30	35	50
板料强度 (牛顿/毫米 ²) Material tensile strength (N/mm ²)	≤450	≤450	≤450	≤450	≤450	≤450
一次行程剪板尺寸(厚×宽)(毫米) Flat bar shearing capacity (mm)	16×250 8×400	20×330 10×480	25×330 16×600	30×330 20×600	35×400 25×700	40×400 30×750
滑块行程Max stroke length (mm)	80	80	80	80	80	80
行程次数 (次/分) Cycles/Min (Max stroke length) (spm)	12	12	10	10	10	10
喉口深度 (毫米) Throat depth (mm)	300	355	400	600	600	600
冲孔厚度 (毫米) Punching thickness (mm)	16	20	25	30	35	40
最大冲孔直径 (毫米) Max.Punching diameter (mm)	25	30	35	38	40	40
主电机功率 (千瓦) Motor power (kw)	4	5.5	7.5	11	15	18
外形尺寸(长×宽×高)毫米 Overall dimensions L×W×H (mm)	1650×800×1800	1830×860×1800	2200×1000×2100	2650×1050×2300	2860×1150×2400	3000×1440×2450
机器重量 (公斤) N.W (kg)	1600	2300	3800	6300	8800	12800

Q35Y联合冲剪机-温控、自动压料系列

Q35Y combined punching and shearing machine -Temperature control, automatic holding tight system



双联动、温控系统、自动压料系统均得益于采用更大流量的双联泵，以及优化过的液压系统。这使得机器的冲孔工位和剪切工位可以同时稳定的工作，稳定性超出市场上同类产品数倍。

These series ironworkers have special double pump and two control foot paddles. It makes the punch station and shear stations can be safely performed simultaneously. Temperature control system and automatic holding tight system are optional. The optimized hydraulic system makes the stability of our machines much higher than other suppliers in China.

工字钢、槽钢、T型钢则需特殊订货。I-beam, channel steel, T steel, need special order.

型钢种类 Steel	圆钢 Round Bar	方钢 Square Bar	等边角钢 Angle Steel		T型钢 T-Bar		工型钢 I-beam steel	槽钢 Channel steel
			90° 剪切 90°Shearing	45° 剪切 45°Shearing	90° 剪切 90°Shearing	45° 剪切 45°Shearing		
断面 Fracture surface								
Q35Y-16	45	40 × 40	125 × 125 × 12	50 × 50 × 5	125 × 125 × 12	60 × 60 × 8	126 × 74 × 5	126 × 53 × 5.5
Q35Y-20	50	50 × 50	140 × 140 × 12	50 × 50 × 5	140 × 140 × 12	70 × 70 × 10	160 × 86 × 6	160 × 60 × 6.5
Q35Y-25	60	50 × 50	160 × 160 × 14	60 × 60 × 6	160 × 160 × 14	80 × 80 × 10	200 × 102 × 9	210 × 75 × 9
Q35Y-30	65	55 × 55	180 × 180 × 16	60 × 60 × 6	180 × 180 × 16	80 × 80 × 10	280 × 124 × 10.5	280 × 86 × 11.5
Q35Y-40	70	60 × 60	200 × 200 × 18	100 × 100 × 10	160 × 160 × 16	80 × 80 × 10	300 × 126 × 11	300 × 89 × 12
Q35Y-50	80	65 × 65	200 × 200 × 20	120 × 120 × 10	180 × 180 × 16	80 × 80 × 10	320 × 130 × 10	320 × 92 × 12

液压联合冲剪机

Hydraulic combined punching and shearing machine



带有全自动液压压料装置的联合冲剪机
Ironworker with automatic holding tight system



后挡料
Back gauge

液压双联冲孔机

Hydraulic dual-work punching machine



液压三联冲孔机

Hydraulic combined punching machine



Q35Y系列液压冲孔机

Q35Y series hydraulic punching machine



更为先进的液压系统，在安全第一的前提下，对板材、角钢、槽钢、工字钢进行高效的冲孔；可冲圆孔、方孔、长方形孔、长圆形孔或者百叶窗形孔。特殊的定制模具使得机器可以折弯和冲压。

The more advanced hydraulic system of our machines puts your safety as supremacy. And can do these jobs high-efficiency for you: Plate Punching, Angle Steel Punching, C-Channel Punching, I-beam Punching. It can do round hole punching, square hole punching, oblong hole punching, slot hole punching and louver punching. Use specific mold it can work as press machine or press brake.

技术参数

Technical parameters

型号 Model	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40	Q35Y-50
冲压力 (吨) Pressure (Ton)	65	90	120	160	200	250
滑块行程Max stroke length (mm)	80	80	80	80	100	100
行程次数 (次/分) Cycles/Min (Max stroke length) (spm)	12	12	12	12	12	12
喉口深度 (毫米) Throat depth (mm)	300	350	400	600	650	650
冲孔厚度 (毫米) Punching thickness (mm)	16	20	25	30	35	40
最大冲孔直径 (毫米) Max.Punching diameter (mm)	25	30	35	38	40	40
外形尺寸(长×宽×高)毫米 Overall dimensions L×W×H(mm)	1200×790×1800	1360×790×1900	1720×1000×2140	1900×1040×2300	2200×1150×2400	2400×1140×2450
主电机功率 (千瓦) Motor power (kw)	4	5.5	7.5	11	15	18.5
机器重量 (公斤) N.W (kg)	1200	1600	2600	4200	5200	6200

Q35Y系列液压联合冲剪机

Q35Y series hydraulic combined punching and shearing machine



Q35Y-12



Q35Y-15

技术参考 Technical parameters

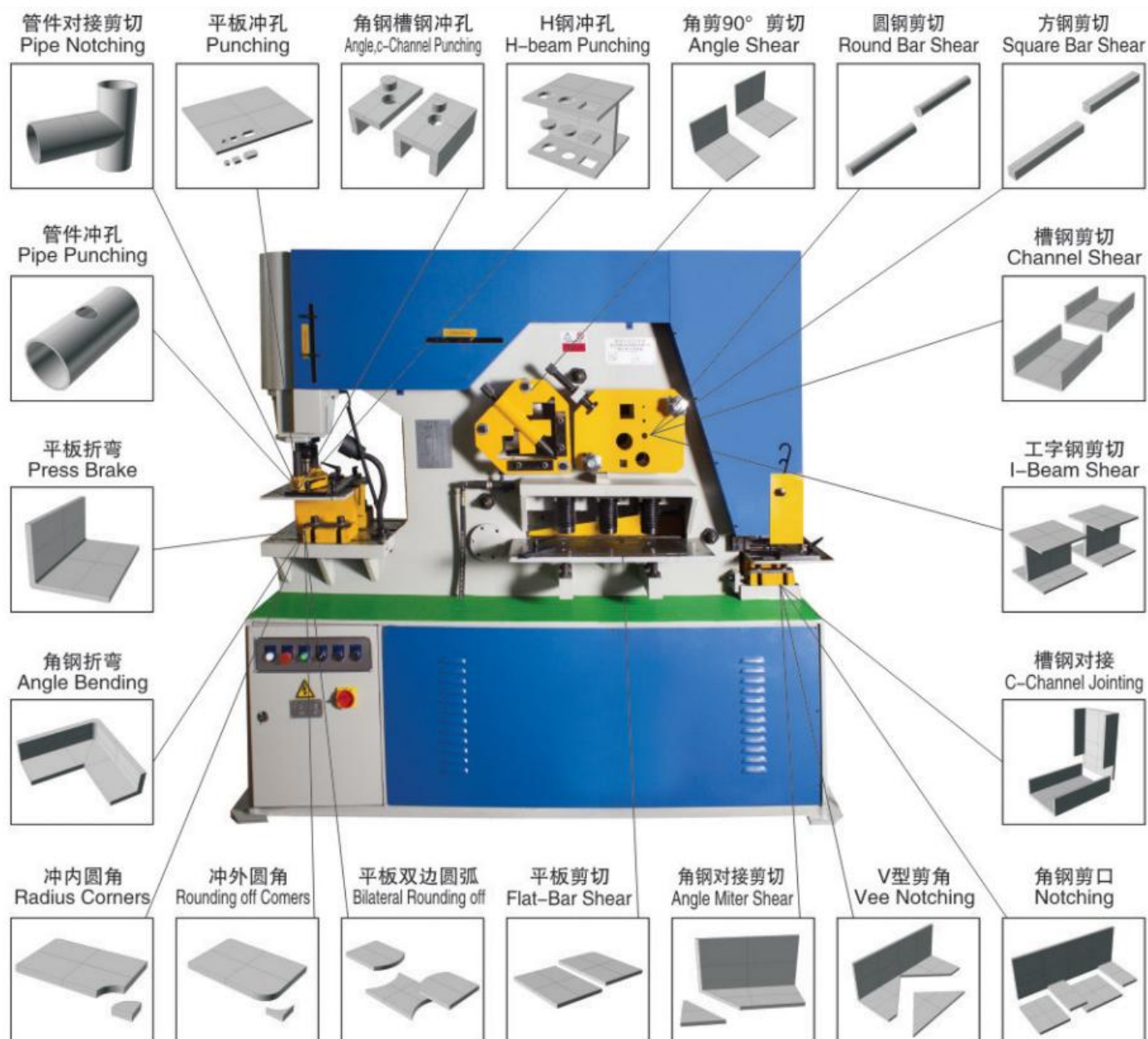
型号 Model	Q35Y-12	Q35Y-15
冲压力 (吨) Pressure (Ton)	40	50
可剪最大板厚 (毫米) Max shearing thickness(Falt bar) (mm)	13	15
板料强度 (牛顿/毫米 ²) Material tensile strength (N/mm ²)	≤450	≤450
一次行程剪板尺寸 (厚×宽) (毫米) Sheraing size of one stroke (mm)	200×13	200×15
滑块行程Max stroke length (mm)	32	50
行程次数(20mm行程) (次/分) Cycles/Min (20mm stroke) (spm)	23	20
喉口深度 (毫米) Throat depth (mm)	175	175
直径×最大冲孔厚度 Punching capacity(Diameter×thickness)	φ20×15	φ22×15
最大冲孔直径×厚度 Punching capacity(Diameter×thickness)	φ38×8	φ38×8
最大圆钢剪切 Max bar shear	30	30
最大方钢剪切 Max steel shear	25	30
最大槽钢剪切 Max channel steel shear	76×38	80×45
等边角钢90° 剪切 angle steel 90 ° shear	80×8	100×10
等边角钢45° 剪切 angle steel 45 ° shear	50×6	70×6
主机功率 (千瓦) Motor power (kw)	3	3
外形尺寸 (长×宽×高) 毫米 Overall dimensions L×W×H (mm)	1060×550×1480	1450×590×1620
机器重量 (公斤) N.W (kg)	800	1000

液压联合冲剪机

Hydraulic combined punching and shearing machine

Q35Y系列联合冲剪机功能丰富：冲孔、角钢剪切、板材剪切、圆钢/方钢剪切、普通模剪、V形模剪、槽钢剪切、工字钢剪切、T形钢剪切、折弯以及管子切口。被广泛的应用于建筑业、船舶制造业、电力及通讯铁塔制造业、桥梁、高速铁路、起重设备制造等工业企业。

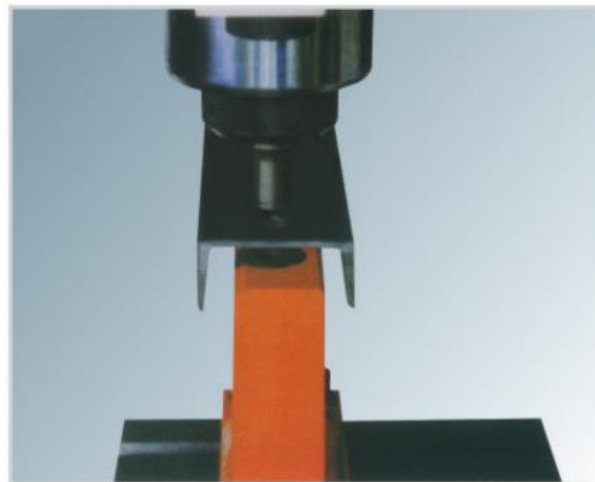
Q35Y series hydraulic Ironworkers are featuring multiple functions, which includes: Punch, Angle Shear, Flat Shear, Round/Square Bar Shear, Rec. Notch, V-Notch, Channel Shear, I-beam Shear, T-bar Shear, Press Brake, Angle Bending and Pipe Notching. It can be widely used in Construction industry, Shipyard, Electric, Bridge, Automobile industry, Hoisting & Transportation, Communication tower and other machinery factories etc.





槽钢侧面冲孔模具

Overhang die holder for punching channel flanges and angles. (optional on single cylinder models)



槽钢正面冲孔模具

Single hole die holder for punching channel webs. (optional on double cylinder models)



折弯模具

Multi vee press brake



V形切口模具

Large vee-notcher (Punchside)



冲大孔径模具

Large hole punching



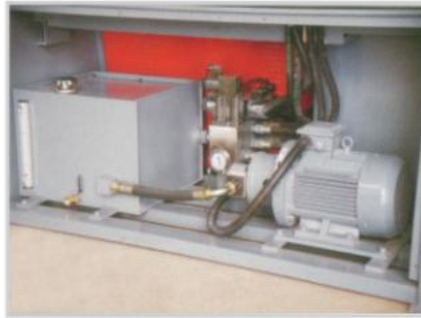
管子切口模具

Pipe notcher



低压24伏直流控制为机器提供安全保护

Electric cabrnat with low 24 volt DC control circuit provides full Protection and safety.



高品质的马达和通用的内置滤油器使保养更为简便

Quality high horse powermotors, with universal oil filter for ease of maintenance



扁钢剪切部位

Flat Bar Shearing Station



角钢剪断和45° 剪切，四面刃口都可以调换

Single shear with no material loss and minimun deformation 45° miter-cut is easy and clean featuring blades with four usable cutting edges



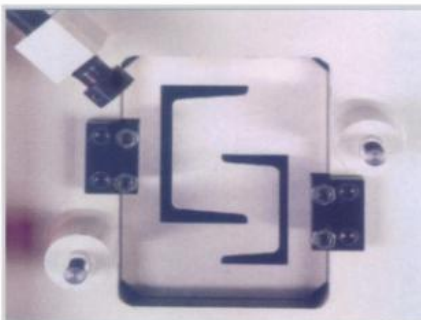
工字钢冲孔

Double punching on Joist steel



圆钢、方钢、槽钢、I字钢剪断

Round and Square bar shear with multiple holes for variety of Sizes Adjustable hold down for clean square cutting,Optional Channel and Joist shear.



槽钢模具

Channel blades



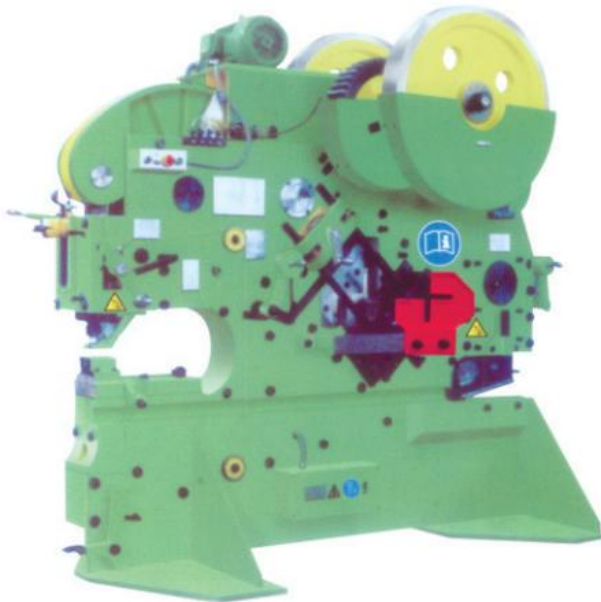
挡料定位

1米后挡料螺栓连接

1m Standard back gauge

QA34-25机械联合冲剪机

QA34-25 mechanical combined punching and shearing machine



采用机械动力，机架为铸钢和钢板焊接结构，具有很好的强度和刚度。能对方钢、圆钢、槽钢、工字钢、角钢进行剪切、冲孔以及模剪。

Mechanical Power; Body frame is welded by cast steel and steel plate, so it has enough strength and rigidity. The mechanical ironworker can shear round/square bar, channel steel, I-beam steel, angle steel; also can punch and notch.

技术参考 Technical parameters

型号 Model	QA34-25
冲压力（吨） Pressure（Ton）	110
可剪最大板厚（毫米） Max.shearing thickness (Flat bar)（mm）	25
板料强度（牛顿/毫米 ² ） Material tensile strength（N/mm ² ）	≤450
剪切角Cutting angle (degree)	11°
一次行程剪板尺寸(厚×宽)(毫米) Flat bar shearing capacity (mm)	28×160
滑块行程Max stroke length（mm）	36
行程次数（次/分） Cycles/Min (Max stroke length)（spm）	25
喉口深度（毫米） Throat depth（mm）	600
冲孔厚度（毫米） Punching thickness（mm）	25
最大冲孔直径（毫米） Max.Punching diameter（mm）	35
主电机功率（千瓦） Motor power（kw）	7.5
外形尺寸(长×宽×高)毫米 Overall dimensions L×W×H（mm）	2885×1290×2460
机器重量（公斤） N.W（kg）	7000

工字钢、槽钢，T型钢则需特殊订货。I-beam, channel steel, T steel, need special order.

型钢种类 Steel	圆钢 Round Bar	方钢 Square Bar	等边角钢 Angle Steel		T型钢 T-Bar		工形钢 I-beam steel	槽钢 Channel steel
			90° 剪切 90°Shearing	45° 剪切 45°Shearing	90° 剪切 90°Shearing	45° 剪切 45°Shearing		
断面 Fracture surface								
QA34-25	65	55×55	150×150×18	110×110×14	150×150×18	110×110×4	300×126×9	300×82×7.5

Q35-16机械联合冲剪机

Q35-16 mechanical combined punching and shearing machine



采用机械动力，机架为铸钢和钢板焊接结构，具有很好的强度和刚度。能对方钢、圆钢、槽钢、工字钢、角钢进行剪切、冲孔以及模剪。

Mechanical Power; Body frame is welded by cast steel and steel plate, so it has enough strength and rigidity. The mechanical ironworker can shear round/square bar, channel steel, I-beam steel, angle steel; also can punch and notch.

技术参考 Technical parameters

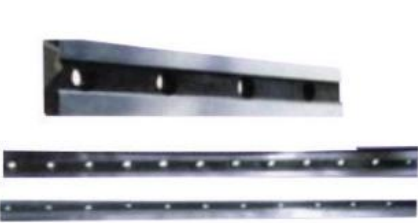
型号 Model	Q35-16
冲压力 (吨) Pressure (Ton)	63
可剪最大板厚 (毫米) Max.shearing thickness (Flat bar) (mm)	16
板料强度 (牛顿/毫米 ²) Material tensile strength (N/mm ²)	≤450
剪切角Cutting angle (degree)	13°
一次行程剪板尺寸(厚×宽)(毫米) Flat bar shearing capacity (mm)	20×140
滑块行程Max stroke length (mm)	26
行程次数 (次/分) Cycles/Min (Max stroke length) (spm)	36
喉口深度 (毫米) Throat depth (mm)	450
冲孔厚度 (毫米) Punching thickness (mm)	16
最大冲孔直径 (毫米) Max.Punching diameter (mm)	28
主电机功率 (千瓦) Motor power (kw)	4
外形尺寸(长×宽×高)毫米 Overall dimensions L×W×H (mm)	1877×1945×725
机器重量 (公斤) N.W (kg)	2830

工字钢、槽钢，T型钢则需特殊订货。I-beam, channel steel, T steel, need special order.

型钢种类 Steel	圆钢 Round Bar	方钢 Square Bar	等边角钢 Angle Steel		T型钢 T-Bar		工型钢 I-beam steel	槽钢 Channel steel
			90° 剪切 90°Shearing	45° 剪切 45°Shearing	90° 剪切 90°Shearing	45° 剪切 45°Shearing		
断面 Fracture surface								
Q35-16	45	40×40	125×125×12	100×100×10	125×125×12	100×100×10	180×94×6.5	180×68×7

机床主要配件

The main parts of machines



□ 剪板机刀片 Flat bar shears blades



□ 冲剪机刀片 Profile steel shear blades



□ 冲剪机冲模 Punch dies



□ 模剪刀片可剪不同的角度
Notcher blades multi-angle notch



槽钢模板
Holder for Channel shear

角度模板
Holder for angle steel shear

安装车间

Installation workshop

我们将标准贯彻到产品的每个细节，配以严格的管理机制，使得我们的机器拥有一致的稳定性和高质量。卓越的设计能力保证我们的产品始终处于行业的领先地位；精英汇聚的团队，为客户提供专业化、个性化、全天候、全方位的服务。

We definitely follow the same standard in the whole production process and insert the standards into each component and installation step. It comes with strictly management rules, which bring our machines stable performance and high quality. Excellent design capabilities enable our products leading in industry. Elite teams can provide customers with professional, customized, and all-round services around the clock.





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