



济南时代百超科技有限公司

JINAN SUPERTIME TECHNOLOGY CO.,LTD.

专业数控设备开发、设计、制造

**Professional Consultants,Engineers,
Manufacturers & Exporters of CNC Machine Tools**

做百年百超

打造中国铁塔钢构设备第一品牌

EVERLAST DEVELOPING SUPERTIME

BECOMING THE FIRST BRAND OF TOWER AND STRUCTURE MACHINERY IN CHINA

诚信为本 客户至上

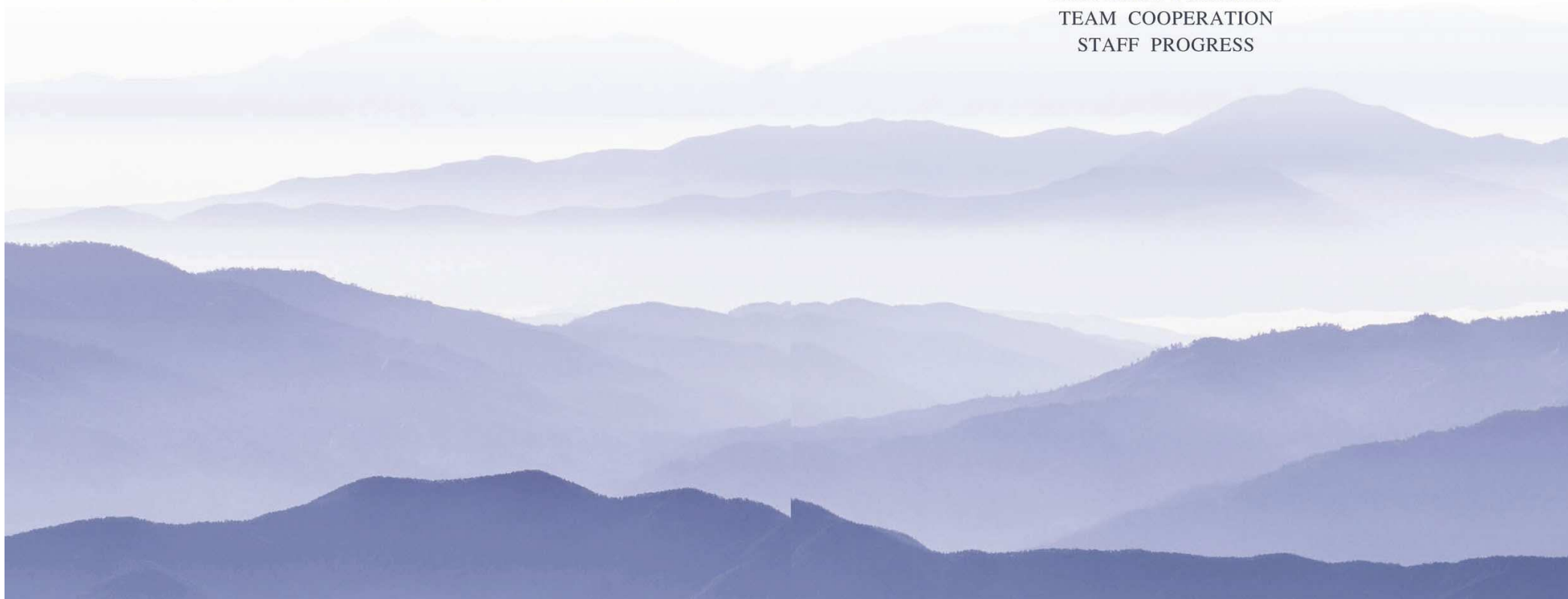
团队合作 自我成长

SINCERE AND TRUSTWORTHY IS OUR PRINCIPLE

CUSTOMER FOREMOST

TEAM COOPERATION

STAFF PROGRESS





COMPANY INTRODUCTION

企业简介

济南时代百超科技有限公司坐落在济南临港经济开发区，是国家认定的高新技术企业。公司占地 30000 平方米，拥有标准厂房 7000 平方米，各种加工、检验设备 200 余台（套），是一家集科研、开发、制造、销售于一体的高新技术企业。公司主要从事数控钻、铣、冲及其它光机电液一体化数控成套加工设备的开发、制造和销售，旨在快速跟踪国际新技术，不断创新；用信息技术改造传统产业，大力开发光机电液一体化的数控成套加工设备，提高民族工业的自我装备水平；集中在电力、钢结构、化工、汽车等对国计民生影响比较大的行业内，重点发展关键成套技术和数控成套设备，以更好地服务于客户。公司现有主导产品涉及到电力铁塔、发电装备、钢构、中央制冷、汽车、环保、工程机械等行业，共计二十余种产品。

公司坚持以技术创新和优质产品持续满足顾客需求为方针，不断加强技术研发和创新能力，科技人员占员工总数的 50% 以上。公司的技术队伍，以几位在数控设备领域有近二十年设计经验的高级工程师为核心，培养了一批年轻的机械和电气工程师，为公司现有产品不断改进和新产品开发提供了有力的技术保障。能够根据用户特殊要求开发设计各种专用设备。

时代百超一向注重售后服务品质，以让用户放心、省心为己任，不断帮助客户创造价值，以“成就客户，造福员工；敬业报国，追求卓越；为客户提供最优产品和最佳服务”作为我们的企业使命。

公司本着诚信为本的企业精神，愿与新老用户携手共创佳绩，努力打造中国光机电液一体化数控成套加工装备的典范。

Jinan Supertime Technology Co., Ltd. is located in Lingang Economic and Development Zone, Jinan city, China, 30,000 square meters, which has 7,000 square meters of modernized standard workshop, equipped with more than 200 sets of machining and inspecting equipments. It is a high-tech enterprise certificated by Chinese Government, mainly engaged in developing, manufacturing and selling of CNC drilling, milling, punching, and other Optical-electronic-mechanical Integration CNC equipments. The purpose of Supertime is to timely and promptly track international new technologies and make continuous innovation in technology for manufacturing high-grade equipments, to advance the level of equipment manufacture industry with information technology. Focus on the industries of steel construction, electric power generation, chemical industry, automobile which influence in national economy. The leading products supply for steel tower, power supply, steel structure, refrigeration, automobile, environmental protection, engineering machinery etc.

It is our guideline to satisfy the requirement of customers continuously. Supertime has engaged a team of highly competent and committed staff and workers. More than fifty percent of staff is engineering and technical personnel. It is the superiority in technology which can ensure that the existing products can be improved and the new products can be researched and innovated continuously. Some specialized design can be provided follow the customer's requirement.

Our business concept is based on Honesty! Quality highest! Service first!

DEVELOPING TOGETHER

共同发展



国外客户 Brand Name Customers

Egypt Albabtain
Iran TAKAB
Indian AMITASHA
Indian KARAMTIARA
Indian KALPATARU
Indian MASTECH
Indian TRADING
Indian SKIPPER
Vietnam SANNAM

Pakistan Engineering
Indonesia P.T. GROWTH
Indonesia P.T. BANGUN

Brasil SAE
Poland Staler
.....



金牌客户 Brand Name Customers

安徽宏源	福建坚石
金华送变电	锦州义兴
江西送变电	无锡太湖
长安铁塔	吉林电业局
武汉铁塔	山西送变电
鲁能泰山	新疆送变电
青岛远征	青岛武晓
湖州飞剑	福建二电建
山东上冶	云南东电
广东白云	湖南线材
海城银峰	杭州电联
云南哨鑫	嘉兴铁塔
中兴通讯	辽河油田
东北送变电	大港油田
成都东方

以上排名不分先后顺序



QUALIFICATION AND HONORS

资质荣誉



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数控角钢自动冲孔、打号、切断生产线

CNC Angles Automatic Punching, Marking, Shearing Production Line



JX2020 JX1412

数控角钢自动冲孔、打号、切断生产线

CNC Angles Automatic Punching, Marking, Shearing Production Line

生产线由送进料台单元、翻转上料单元、料道单元、打号单元、冲孔单元、剪切单元、成品料台单元、液压系统、电气控制系统等几部分组成。

The production line is composed of infeed transfer table unit, rotating loading unit, feeding conveyor unit, marking unit, two punching units, shearing unit, outfeed conveyor unit, hydraulic system and electrical control system etc.

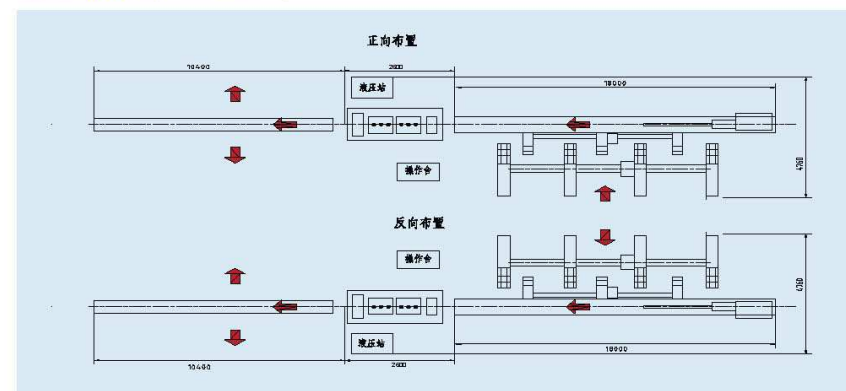
产品特点 Product feature

▲ JX2020 每侧的冲孔单元安装三套冲孔模具；JX1412 每侧的冲孔单元安装二套冲孔模具；模架、冲头和底模更换方便；打号单元安装四组可更换的字盒；三个数控伺服轴完成角钢的孔距和两侧面的准距调整，自动定位精度高；液压元件、气动元件、电气元件选用世界名牌保证了系统的长期可靠运行；采用我公司最新版计算机控制软件，方便编程和管理。

Model JX2020 is equipped with three punches in each side of punching unit; Model JX1412 is equipped with two punches in each side of punching unit; It is easy to change the punch holders, punches and dies; The marking unit is equipped with four groups of character drawer. The three CNC axes can achieve the adjustment of hole distance and stadia. High precision automatic positioning. International brand hydraulic elements, pneumatic elements, electric elements ensure that the system can run long time reliably. Using the newest Supertime software, easy programming and management.



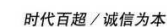
布置图 Lay out drawing



技术参数 Specification

型号 Model		JX2020	JX1412
加工角钢范围 (mm) Angle size	Q345	63 × 63 × 4–200 × 200 × 20	40 × 40 × 3–140 × 140 × 12
	Q235A		40 × 40 × 3–140 × 140 × 14
最大冲孔能力 (直径 × 厚度 mm) Max.punching capability (D × T)	Q345	Φ26 × 20	Φ26 × 12
	Q235A	Φ26 × 20	Φ26 × 14
冲孔公称力 (kN) Punching nominal force		1000	550
打号公称力 (kN) Marking nominal force		550/1000/1250	550/1000
切断公称力 (kN) Shearing nominal force		1200	900
最大角钢长度 (m) Angle length max.		14	10/12
准距加工范围 (mm) Range of stadia.		30–175	20–110
每侧冲头数目 Punches number/ each side		3	2/3
打号字头组数 Marking groups		4	
字头尺寸 (mm) Dimension of characters		14 × 10 (依用户要求) 14 × 10 (By users' request)	
切断方式 Shearing mode		双刃切断或单刃切断 Double blades shearing or single blade shearing	
数控轴数 CNC axes No.		3	
最大角钢送进速度 (m/min) Max. feeding speed		50	
机器外形尺寸 (m) Overall dimension (L × W × H)		32 × 7 × 2.6	24.5/26.5 × 7 × 2.2
净重 (kg) Net weight		19000	17000

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.



数控角钢自动冲孔、打号、单刃切断生产线 CNC Angles Automatic Punching, Marking, Single Shearing Production Line



JX1412A
 数控角钢冲孔、打号、单刃切断生产线
 CNC Angles Automatic Punching, Marking, Single Shearing Production Line

生产线由送进料台单元、翻转上料单元、料道单元、打号单元、冲孔单元、剪切单元、成品料台单元、液压系统、电气控制系统等几部分组成。

The production line is composed of infeed transfer table unit, rotating loading unit, feeding conveyor unit, marking unit, two punching units, shearing unit, outfeed conveyor unit, hydraulic system and electrical control system etc.

产品特点 Product feature

▲ JX1412A 每侧的冲孔单元安装二套冲孔模具；模架、冲头和底模更换方便；打号单元安装四组可更换的字盒；三个数控伺服轴完成角钢的孔距和两侧面的准距调整，自动定位精度高；液压器件、气动器件、电气元件选用国内和国际名牌保证了系统的长期可靠运行；采用我公司最新版计算机控制软件，方便编程和管理。

Model JX1412A is equipped with two punches in each side of punching unit. The marking unit is equipped with four groups of character drawers. The three CNC axes can achieve the adjustment of hole distance and stadia, high precision positioning. International brand hydraulic elements, pneumatic elements, electric elements equipped on the machine to ensure that the system can run long time reliably. Using the newest Supertime software, easy programming and management.

▲ X 轴带有编码器；组成闭环电路控制，孔距定位精准。

“X” axis is equipped with an encoder, so closed-loop control system makes positioning accurately.

▲ 剪切单元采用单刃，节约材料，增加独立的压料装置，压料平稳、压料力大，减少断面变形，能更好地保证设备的稳定性。Shearing unit is single blade cutting, economize materials, equipped with material press unit, press balanced, enhance press force, ensure the machine running stably.



技术参数 Specification

型号 Model		JX1412A
加工角钢范围 (mm) Angle size	Q345	40 × 40 × 3–140 × 140 × 12
	Q235A	40 × 40 × 3–140 × 140 × 14
最大冲孔能力 (直径 × 厚度 mm) Max.punching capability (D × T)	Q345	Φ26 × 12
	Q235A	Φ26 × 14
冲孔公称力 (kN) Punching nominal force		550
打号公称力 (kN) Marking nominal force		600/1000
切断公称力 (kN) Shearing nominal force		1800
最大角钢长度 (m) Angle length max.		10/12
准距调节范围 (mm) Adjustment range of stadia.		20–110
每侧冲头数目 Punches number/each side		2/3
打号字头组数 Marking groups		4
字头尺寸 (mm) Dimension of characters		14 × 10 (依用户要求) (By user's request)
切断方式 Shearing mode		单刃剪切 Single blade shearing
数控轴数 CNC axes No.		3
角钢送进速度 (m/min) Infeed speed		50
机器外形尺寸 (m) Overall dimension (L × W × H)		24.5/26.5 × 7 × 2.2
净重 (kg) Net weight		17000

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

数控角钢自动钻孔、打号生产线

CNC Angles Automatic Drilling , Marking Production Line



JX2532

数控角钢钻孔、打号生产线

CNC Angles Automatic Drilling, Marking Production Line

本生产线由送进料单元、翻转上料单元、料道单元、打号单元、两合钻孔单元、成品料台单元、液压系统、电气控制系统等几部分组成。

The production line is composed of infeed transfer table unit, rotating loading unit, feeding conveyor unit, marking unit, two drilling units, outfeed conveyor unit, hydraulic system and electrical control system etc.

产品特点 Product feature

▲实现三轴 CNC 控制，伺服驱动进给，孔距和准距可以精确定位；钻孔主轴转速由变频器控制无级调速；钻孔的进给速度可以由调速阀无级调节。CNC control of three axes and servo infeed, ensure exact positioning; the speed of drilling spindle is stepless adjusted by frequency inverter; and the feeding speed is stepless adjusted by governor valve.

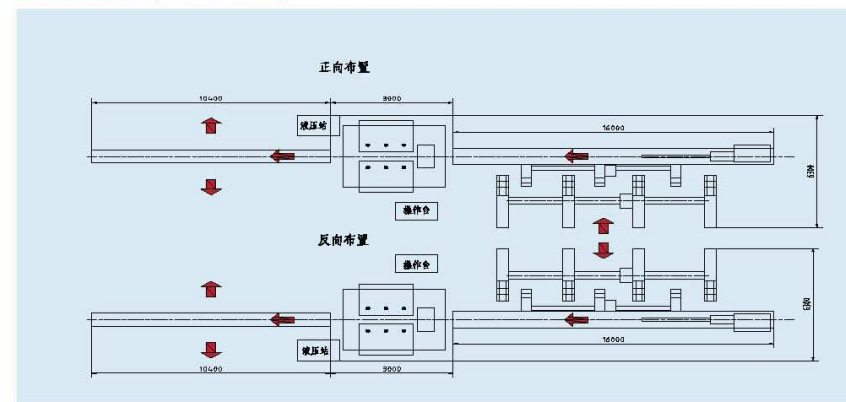
▲工件尺寸人工输入，也可以读取放样软件生成的 CAD 图形。可以通过 USB 或网络传输工件程序。

Workpiece program can be inputted by manual, also can be created by lofting software automatically and transmitted through USB or network, workpiece program can display simulate graphic.

▲用户可选择加装剪切单元，剪切单元采用双刃剪切。Shearing unit is optional, using double blades cutting.



布置图 Lay out drawing



技术参数 Specification

型号 Model	JX2532
加工角钢范围 (mm) Angle size	140 × 140 × 10~250 × 250 × 32
最大钻孔直径 (mm) Max.drilling dia.	Φ40
打号公称力 (kN) Marking nominal force	1030/1250
最大角钢长度 (m) Max. angle length	14 或 12 (用户自选) 14 or 12 (By users' request)
准距调节范围 (mm) Range of stadia.	40~220 (无级变速) 40~220 (Stepless adjustment)
每侧钻头数目 No.of drills on each side	3
打号字头组数 Marking groups	1 或 4 (用户自选) 1 or 4 (By users' request)
每组字头数 (个) No.of characters per group	15
字头尺寸 (mm) Dimension of characters	14 × 10 × 19
数控轴数 No.of CNC axes	3
角钢最大进给速度 (m/min) Max.infeed speed	40
钻孔最大主轴行程 (mm) Max.drilling stroke	120
钻孔主轴转速 (r/min) Rotation speed of spindles	180~560 (无级变速) 180~560 (Stepless adjustment)
机器外形尺寸 (m) Overall dimension (L × W × H)	29 × 8.9 × 2.5
净重 (kg) Net weight	16500

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

数控角钢高速自动钻孔、打号生产线 CNC Angles High Speed Automatic Drilling, Marking Production Line



JX2532F 数控角钢高速自动钻孔、打号生产线 CNC Angles High Speed Automatic Drilling, Marking Production Line

由送料单元、翻转上料单元、送料单元、打号单元、两台钻孔单元、成品料台单元、液压系统、电气控制系统等几部分组成。

The production line is composed of infeed transfer table unit, rotating loading unit, feeding conveyor unit, marking unit, two drilling units, outfeed conveyor unit, hydraulic system and electrical control system etc.

产品特点 Product feature

- ▲采用数控技术，伺服电机送料，效率高，工作精度稳定。
Adopt CNC technology, servo motor infeeding, with high efficiency, stable working precision.
- ▲关键的液、气、电元件全部采用国内和国际名牌。
Key hydraulic, pneumatic and electric elements are all domestic and international brand.
- ▲编程简易而且可以直接使用放样软件所生成的程序数据。
Easy programming and can directly use the program data made by lofting software.
- ▲软件为中文/英文界面，操作简单，可显示工作图形。
Software with Chinese, English interface, easy operation, and can display the drawing of workpiece.
- ▲上料、打号、钻孔、下料均自动进行。
Loading, marking, drilling and unloading are all performed automatically.
- ▲编制程序时，只需键入工件尺寸，孔径，准距，工件数，或直接使用



CAD/CAM 放样软件生成的工件程序。

Just need to input size of work piece, diameter of holes, stadia and quantity of workpiece when edit program, or use CAD/CAM lofting software direct conversion.

▲该机安装托料和垂直压料装置，能适应弯曲较大的角钢。

The machining line is installed with supporting & straight pressing device.

▲具有免切功能，可以加工定尺料。

With avoided shearing functions, so as to process fixed length angles.

▲具有故障自我诊断功能。

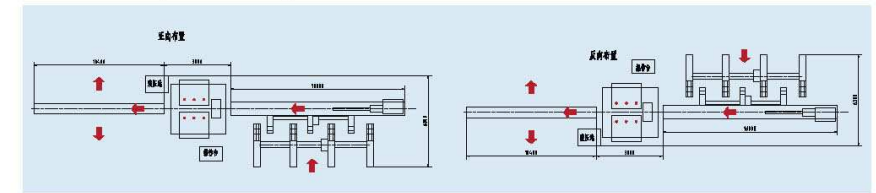
With self-diagnosis failures function.

▲用户可选择加装剪切单元，剪切单元采用双刃剪切。

Shearing unit is optional, using double blades cutting.



布置图 Lay out drawing



技术参数 Specification

型号 Model	JX2532F
加工角钢范围 (mm) Angle size	140 × 140 × 10~250 × 250 × 32
最大角钢长度 (m) Max. length of Angle	12 or 14 By customer's request
打号公称力 (kN) Marking force	1000/1250
打号字头组数 Marking groups	1/4
字头尺寸 (mm) Dimension of characters	14 × 19 × 10
准距调节范围 (mm) Range of stadia	40~220(无极变速)(Stepless adjustment)
每侧钻头数目 (piece) No. of drill per side	3
钻削主轴锥孔 Taper of drilling spindle	BT40
最大钻孔直径 (mm) Max. drilling dia.	Φ26
钻削主轴行程 (mm) Drilling stroke	150
最高主轴转速 (r/min) Max. rotation speed of spindle	6000
最大进给速度 (m/min) Max. feeding speed	40
最大动力头滑板移动速度 (m/min) Max. moving speed of slipway of drilling head	10
最大动力头给进速度 (m/min) Max. feeding speed of drilling head	14
数控轴数 CNC axes No.	9
机器外形尺寸 (m) Overall dimension (L × W × H)	32 × 9 × 2.5
机床重量 (T) Net weight	About 30

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

数控液压冲孔机 / 冲钻复合机 CNC Hydraulic Punching/Drilling and Marking Machine



CJ100 CJZ100
数控液压冲孔机 / 冲钻复合机
CNC Hydraulic Punching/Drilling and Marking Machine

用于输电铁塔、通讯铁塔或钢结构加工中的连接板及其他机械、化工等行业中的平板类材料，进行冲孔、钻孔和打号。
由主机、X、Y 轴工作台、液压系统、电气控制系统、钻孔单元（CJZ100）等组成。

This machine is used for punching or drilling, marking of connection plate on power-transmission tower and steel structure industry.

产品特点 Product feature

- ▲加强的 C 型钢焊接结构机身，刚性好，使用寿命长。
Main frame is fortified C-type welding structure, with strong rigidity and longevity of service.
- ▲设有三个模位（其中一个可设为打号工位），模位更换自动进行。
Three stations(one can be used as marking station), automatic allocation station.
- ▲工件由滚珠工作台支撑，滑动阻力小。
Worktable with ball-bearings supports workpiece, grip resistance is less.
- ▲X 轴及 Y 轴运行由伺服电机及精密滚珠丝杠驱动，加工精度高，运行稳定，寿命长。
X-axis and Y-axis are driven by servo-motor and ball screw, ensuring higher positioning precision, stable operation and longevity of service.
- ▲两轴 CNC 控制，保证精确定位。
Two axes CNC, ensuring high precision positioning.
- ▲工件程序人工输入，也可以读取放样软件生成的 CAD 图形。可以通过 USB 或网络传输工件程序；可以显示模拟图形以便检查程序。
Workpiece programming manually, also can be created by lofting software automatically and then transmitted through USB or network, simulant workpiece graphics can be displayed in order to make program checking more conveniently.

www.jntime.cn



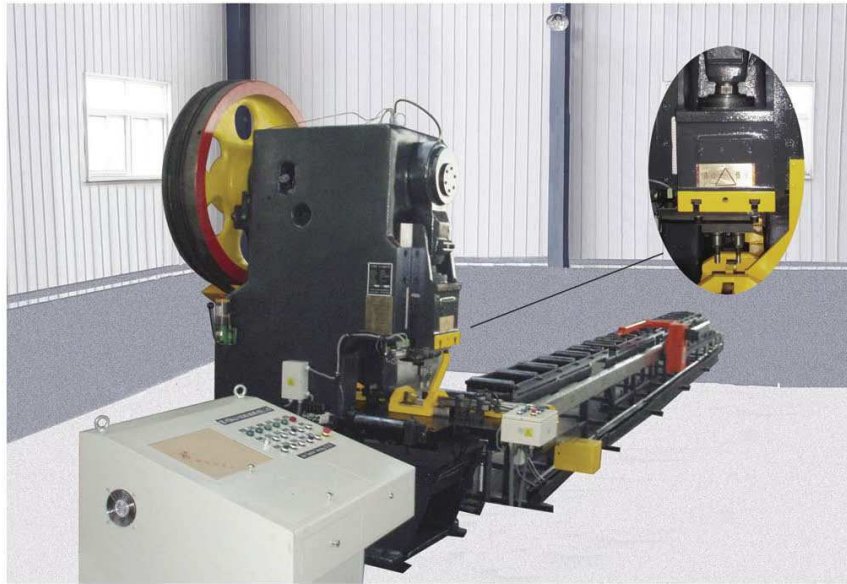
技术参数 Specification

型号 Model	CJ100	CJZ100
冲孔力 (kN) Punching force	1000	
打号力 (kN) Marking force	800	
工作厚度范围 (mm) Thickness range of workpiece	5-25	35
最大工件尺寸 (mm) Max. workpiece dimension	1500 × 800	
模位数 Number of stations	3	4
最大冲孔直径 (mm) Max. punching dia.	Φ26	
最大钻孔直径 (mm) Max. drilling dia.	Φ50	
孔到板边最小距离 (mm) Min. margin distance from a hole center	冲孔 26 Punching	
	钻孔取决于孔径 Up to diameter while drilling	
液压滑块行程 (mm) Stroke of hydraulic slide	50	
压缩空气压力 (MPa) Air pressure	0.5	
字头数量 Characters number	14 or 18	
字头尺寸 (mm) Dimension of characters	14 × 10	
液压泵电机功率 (kW) Motor power of hydraulic pump	15	
伺服电机功率 (kW) Power of servo motor	2 × 2	
钻削主轴行程 (mm) Stroke of drilling spindle	180	
钻削主轴转速 (无级调节, rpm) Speeds of drilling spindle (stepless adjustment, rpm)	120-560	
钻削主轴功率 (kW) Power of main spindle	5.5	
加工精度 Working precision	符合 GB/T2694-2003 要求 According to standard GB/T2694-2003	
机器净重 (kg) Net weight	6500	7000
机器外形尺寸 (m) Overall dimension (L × W × H)	3020 × 2522 × 1875	3020 × 3420 × 2722

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

数控角钢半自动生产线 (机械式)

Semi-Automatic CNC Production Line for Angles(Mechanical)



JC160 JC200

数控角钢半自动生产线 (机械式)

Semi-Automatic CNC Production Line for Angles(Mechanical)

由机械压力机、模具、送进料道、数控送进小车、成品料道、电气控制系统组成。

This production line is composed of mechanical punching machine, moulds, feeding conveyor unit, NC feeding carriage, outfeed conveyor unit, electrical control system etc.

产品特点 Product feature

- ▲配置高速压力机。
High speed press mechanical machine.
- ▲孔距、准距数字控制。
Hole distance & stadia controlled by CNC system.
- ▲可冲两种直径的孔。
Two kinds of different diameter holes.
- ▲读取 CAD/CAM 放样软件生成的数据。
Read the data of CAD/CAM lofting software.



技术参数 Specification

型号 Model	JC160	JC200
机械功能 Functions	冲孔 Punching	冲孔 Punching
加工角钢范围 (mm) Scope of angle	L40 × 40 × 3~L160 × 160 × 12	L40 × 40 × 3~L200 × 200 × 12
最大冲孔直径 (mm) Max. diameter of punching	Φ26	Φ26
冲头数目 Punches	2	2/3
冲孔准距 (mm) Stadia. of punching	边长 Length of side ≥ 40~63 准距 Stadia ≥ 42 边长 Length of side ≥ 70~100 准距 Stadia ≥ 32 边长 Length of side ≥ 100~110 准距 Stadia ≥ 42	
冲孔最小端距 Min. end distance of punching	25	
打号力 (kN) Marking force		1000
冲孔公称力 (kN) Nominal force of punching	800(1000)	1000
伺服电机定位速度 (m/min) Positioning speed of servo motor	X ≤ 30 Y ≤ 15	
编程方式 Progrmming mode	键盘输入, RS232 接口输入, 软盘输入, USB 接口输入 Input by keyboard, RS232 interface, floppy disk and usb interface	
加工精度 Precision	符合 GB2694 的要求 According to GB2694	
机器外形尺寸 (m) Overall dimension (L × W × H)	18.9 × 2.3 × 2.6	22.5 × 6 × 1.8
机器重量 (kg) Net weight	8000	12000

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

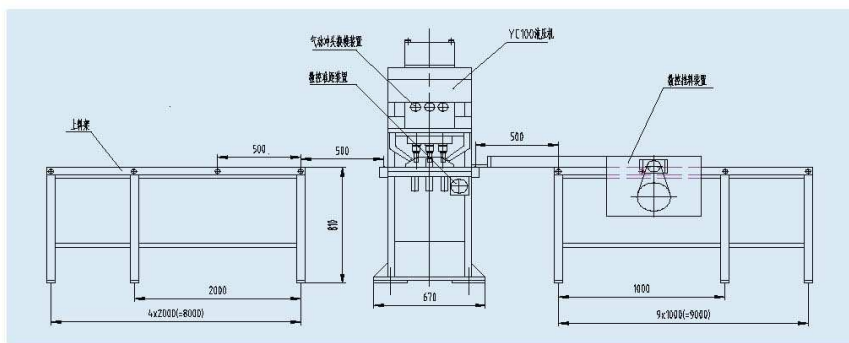
数控角钢半自动生产线 (液压式) Semi-Automatic CNC Production Line for Angles(Hydraulic)



YC100 数控角钢半自动生产线 (液压式) Semi-Automatic CNC Production Line for Angles(Hydraulic)

由液压主机、模具、送料道、数控送料小车、成品料道、液压站、电气控制系统组成。
This production line is composed of hydraulic punching machine, moulds, feeding conveyor unit, NC feeding carriage, outfeed conveyor unit, hydraulic system & electrical control system etc.

工艺图 Technology drawing



产品特点 Product feature

- ▲配置液压主机，冲压平稳。
Hydraulic punching machine, punching balance.
- ▲孔距、准距数字控制。
Hole distance & stadia controlled by NC system.
- ▲可冲三种直径的孔或两种直径的孔和打号。
Three kinds of different diameter holes, or two kinds of different diameter holes and one marking.
- ▲读取 CAD/CAM 放样软件生成的数据。
Read the data of CAD/CAM lofting software.

技术参数 Specification

型号 Model		YC100
加工角钢范围 Angle size	16Mn	40 × 40 × 3–160 × 160 × 16
	Q235A	
最大冲孔能力 (直径 × 厚度 mm) Max. punching capability (D × T)		Φ 26 × 16
冲孔公称力 (kN) Punching nominal force		1000
打号公称力 (kN) Marking nominal force		1000
孔径种类 Punches number		2
打号字头数 Number of letters		12
字头尺寸 (mm) Size of letter		14 × 10
伺服电机功率 (kW) AC servo motor power	X 轴 (侧挡料) X axis(side stop)	1.5
	Y 轴 (改变准距) Y axis (changing of stadia.)	1.0
X 轴最大行程 (m) Max. stroke of X axis		8–10
X 轴定位速度 (m/min) Positioning speed of X axis		20
制件精度 Precision of workpiece		符合 GB2694–2003 的要求 According to GB 2694–2003
净重 (kg) Net weight		6500

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

DZ 系列液压角钢打号机 / QD 系列液压角钢剪切机

DZ Hydraulic Marking Machine/QD Hydraulic Shearing Machine

产品特点 || Product feature

▲主要用于单独的打号或剪切辅助工作，采用一体化结构，液压驱动占地面积小，操作方便，也可以采用一台液压站驱动打号和剪切单元，组成简易的打号、剪切生产线。
This machine mainly used in single marking or assisting shearing work, using incorporate structure, hydraulic drive, occupy small land, easy for operation; customers can also use one hydraulic station to drive one shearing unit and one marking unit, compose a simple marking, shearing production line.



技术参数 || Specification

型号 Model	DZ125	DZ100	DZ70
打号压力 (kN) Marking nominal force	1250	1000	630
打号行程 (mm) Marking stroke	45	45	45
字头盒组数 Marking groups	1	1	1
字头尺寸 Size of letter	用户定 User-Defined	用户定 User-Defined	用户定 User-Defined
打号速度 (次/分钟) Marking speed (times/min)	10-15	15-20	15-20

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.



技术参数 || Specification

型号 Model	QD200	QD140A	QD140
剪切力 (kN) Shearing nominal force	1200	1800	900
剪切范围 (mm) Size of angle	63 × 63 × 4- 200 × 200 × 20	30 × 30 × 4- 140 × 140 × 12	30 × 30 × 4- 140 × 140 × 12
剪切次数 (次/分钟) Shearing speed (times/min)	10-15	15-20	15-20
剪切方式 Shearing mode	双刃 Double shearing	单刃 Single shearing	双刃 Double shearing

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.



建议：一台角钢打号机和一台角钢剪切机共用一个液压站，组成角钢打号、剪切简易生产线。
Suggestion: Assemble one angle marking machine with one angle shearing machine use the same hydraulic station to make a simple line of marking and shearing of angles.

QJ 系列液压角钢切角机

QJ Hydraulic Notching Machine of Angles

产品用途 || Product usage

主要用于角钢切角，也可配上模具冲孔，打号，折弯，剪切一机多用。
Used for notching of angles and also can be used for punching, marking, bending, shearing by changing of the mould.

产品特点 || Product feature

▲开式C形结构，切角模为直角双刃口，回转式多方位切角模，只需要调整回转模架即可，切不同角度角钢，角钢不需要转动，因此切角作业占地面积小，切角误差小。
The machine with opening C-type structure, its cutting mould is right-angled double-blade mode. Multi-directions rotational notching mould can cut out different angle degree of angles only need to adjust rotation die-carrier so as not to rotate angles so notching with little error only need small working area.
▲本机还可以根据客户需要增加打号、冲孔、折弯及剪切功能，通过交换模具即可进行打号或冲孔作业。
The machine can be installed marking, punching, bending, shearing functions by customer's request, that is, only need to exchange moulds as to achieve marking or punching of angles.



技术参数 || Specification

型号 Model	QJ140	QJ160	QJ180
机器功能 Functions	用于铁塔生产中角钢的切角，更换模具即可打号、冲孔。 Used for hotching of angles in steel tower industry ,and also used for marking & punching if replace mould.		
公称压力 (kN) Nominal pressure	500	600	700
油缸行程 (mm) Stroke of oil cylinder	50	50	50
行程次数 (times/min) Times of stroke	20-25	20-25	20-25
电机功率 (kW) Power of motor	15	15	15
可切角钢范围 (mm) Scope of angles	L40 × 40 × 3-140 × 140 × 12	L40 × 40 × 3-160 × 160 × 16	L40 × 40 × 3-180 × 180 × 20
切角模回转角度 Rotary die corner angle	± 45° 手动 manual		
切角模外形尺寸 (mm) Dimensions of notching mould	650 × 650 × 500	700 × 700 × 500	830 × 700 × 600
外形尺寸 (mm) Overall dimension (L × W × H)	1270 × 1020 × 1800	1300 × 1020 × 1880	2260 × 1120 × 1900

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

XGJZ100 型型钢校直机

XGJZ100 Section Straightener Machine

产品用途 ||| Product usage

主要用于各类型材（如：角钢、槽钢、工字钢、H型钢、方钢、圆钢、钢管及轴类）进行校直或弯曲，广泛应用于电力、桥梁、建筑机械、铁塔、钣金及维修等行业。还可作卧式压力机使用。

Mainly used in all kinds of section materials (for example: angle steel, channel steel, I-steel, H-steel quadrate steel, round steel, steel pipe and axis class) to straight or bend, widely used in electric, bridge, construction machine, steel tower sheet metal etc. It also can be used for horizontal pressure machine.



产品特点 ||| Product feature

▲型钢校直机机身采用C型钢焊接结构，具有刚度好、承载力大、操作方便等优点。

The section straightener fuselage is the C steel welding structure, has the merits of good rigidity, large supporting capacity, easy operating and so on.

▲传动类型有液压传动和机械传动两种，可由用户自主选择。

Transmission styles include hydraulic transmission and engine transmission, it can be choosed by user.

▲操作工位又分为单工位和双工位，每个工位都有单独配置的封闭宽度调节装置及辊道托架装置、操作中更加轻松、灵活及安全。

Operation location is divided into the single location and the double location, each location all has the alone disposition width adjusting device and in the table bracket installment, the operation is more facile, nimble and safe.

▲封闭宽度在工作中可调，即实现动态调节，给操作者带来极大方便及工作效率大为提高。

Seal width in work adjustable, namely the realization of dynamic adjustment, brings the enormous convenience and enhance the working efficiency to the operator greatly.

▲可根据用户要求增加加长托架。

Can be equipped with the longer bracket by user defined.

技术参数 ||| Specification

型号 Model	XGJZ100
加工角钢尺寸 (mm) Angle size	30 × 30 × 4~200 × 200 × 20
校直公称力 (kN) Straightener nominal force	1000
滑块行程 (mm) Slide stroke	20
滑块行程次数 (次/分钟) times/min Slide stroke times	25
最大封闭宽度 (mm) Max. width	220
封闭宽度调节量 (mm) Adjustable width	100
滑块中心至机身距离 (mm) The distance from center of slide to fuselage	135
滑砧最大支承中心距 (mm) Distance between centres of slide	800
滑砧中心高度 (mm) Height of slide center	200
工位数 Work place No.	1
电机功率 (kW) Motor power	7.5
机身外形尺寸 (mm) Overall dimension (L × W × H)	2318 × 1380 × 1340
设备总重量 (T) Net weight	3.5

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

HF 系列钢管合缝机

HF Series Seam Line for Steel Tube



产品特点 ||| Product feature

▲本机上部安装有下压主油缸，两侧各安装一个夹紧油缸，夹紧油缸在两侧的提升油缸带动下可上下移动，配合加长压杆可对 Φ350~Φ1500mm 范围内各种直径的钢管进行合缝作业。

The machine have press cylinder, and one clamp cylinder each side. It process the steel tube seam from Φ350~Φ1500mm. It can be equipped with electric drive raceway, debase the work intension.

▲根据用户的要求，前后可配电动驱动滚道，降低了工人的劳动强度。

▲该机还可配上前后支架对钢管进行校直作业，一机两用。

It can collocate bracket for straight the tube.

▲在侧夹紧缸的前端面新增导向套，解决了侧缸因受偏载负荷，密封圈受到不对称力挤压，导致密封圈受损，从而导致油缸漏油的情况。

There are guide sleeve at the clamp cylinder, avoid the asymmetry processing and the oil leakage for the over load.

▲油缸行程加大，便于调节和使用。

Increase the route of the cylinder for adjusting and using.

▲框架机身，增强设备的刚性和稳定性。

Frame structure, boost up the stability of the machine.

技术参数 ||| Specification

型号 Model	HF150
机器功能 Machine functions	卷制或折弯成型的钢管合缝、校直 Roll or fold bending the moudle tube
上缸压力 (kN) Up cylinder press	1000/2500 (用于校直) (For straight)
上缸行程 (mm) Up cylinder route	540
两侧夹紧缸压力 (kN) Clamp cylinder press	250
两侧夹紧缸行程 (mm) Clamp cylinder route	650mm
加工钢管直径范围 (mm) Steel tube size	Φ350~Φ1500
两侧提升缸调节行程 (mm) Lift cylinder route	600
钢管运动调节方式 Adjust the motion of tube	手动或机动 Hand or machine
电机总功率 (kW) Motor power	11/18.5
外形尺寸 (mm) Overall dimension (L × W × H)	4500 × 1100 × 3500

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ZH 系列法兰组焊机

ZH Series Flange Welding Line



ZH1013、ZH1313、ZH1613

ZH 系列法兰组焊机

ZH Series Flange Welding Line

由主从卡盘、支管组装单元（可选多组）、托料装置、导轨等组成。

This machine is composed of main & idle chuck, branch pipe assembling unit (equipped with two or more sets by user defined) & guiding table.

产品特点 Product feature

▲主、支管组装台移动及主、从卡盘转动均采用电机驱动数字显示（或数控控制）。

The movement of main & idle-working table and rotation of main & idle-chuck all adopt motor driving and digital display(or CNC control).

▲该机用于钢管与两端法兰盘及支管和支管法兰的定位组装焊接。

The machine is used for positioning, assembling and welding between steel pipe and flange, and between branch pipe and branch flange.

▲操作简单，定位准确、方便，工作效率高，占地面积小，节约工装费用。

Simple operation, accurate and easy positioning, high working efficiency, small working area, save loading time.

▲软件为中文 / 英文界面，PLC 控制，人机界面显示，操作简单，可靠性高。

It is controlled by PLC system and HI, easy operation and stable operation.

▲该设备的主、从卡盘组装和支管组装由电机驱动，移动位置数显或数控。工件旋转，支管定位也可采用电机驱动，实现角度数显或数控，操作方便，支管焊接位置角度准确。

The machine should be driven by motor, with NC or CNC display, simple operation, accurate welding angle of branch pipe.

▲可选装两组或多组支管组装。

Equipped with two or more sets of branch pipe assembling by user defined.

技术参数 Specification

型号 Model	ZH1013	ZH1313	ZH1613
主工作台尺寸 (mm) Size of main working table	16500 × 800 × 250	16500 × 800 × 250	16500 × 1500 × 320
主、从卡盘可装法兰直径 (mm) Flange diameter of main & idle clamping chuck	Φ250-Φ1000	Φ250-Φ1300	Φ250-Φ1600
卡盘中心高 (mm) Center height of chuck	800	800	1200
副工作台尺寸 (mm) Size of vice-working table	14000 × 200 × 250	14000 × 200 × 250	14000 × 200 × 250
可加工钢管长度 (m) Length of steel pipe	13	13	13
支管组装台可装法兰尺寸 (mm) Size of fixed flange on the vice-working table	Φ150-Φ500	Φ150-Φ500	Φ150-Φ500
支管组装台中心高 (mm) Center height on vice-working table	800	800	1200
支管组装台旋转角度 Rotary angle on vice-working table	± 90°	± 90°	± 90°
主、支管组装台移动速度 (m/min) Movement speed of main & vice-working table	3	3	3
电机总功率 (kW) Total power of motor	14	14	15

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

CJ 系列双工作台式数控平板钻孔机

CJ Series CNC Plate Drilling Machine With Double Working Tables



CJ1610Z,CJ1616Z,CJ2016Z
CJ 系列双工作台式数控平板钻孔机
 CJ Series CNC Plate Drilling Machine With Double Working Tables

由主机、工作台、排屑器、液压系统、电气控制系统组成。
 This machine is composed of mainframe, working table, chip cleaner, hydraulic system & electrical control system etc.

产品特点 Product feature

▲ A 形数控滑台钻削动力头、可控制孔深，具有钻盲孔、扩孔、倒角功能。
 Type A CNC slider and drilling unit spindle, can control depth of holes, with function of drilling blind hole, reaming, chamfer angle.

▲ 在 X、Y 方向自动进行钻孔加工。
 Can automatically find holes to drill at X、Y axis.

▲ 4 个加工位置，12 个液压夹紧钳，能够装夹四组工件、钻孔的同时可进行装卸工作。
 4 processing zones, 12 rapid hydraulic clamps, capable of clamping four sets of workpieces, and unload workpieces when drilling simultaneously.

▲ CNC+PLC 控制，LCD 监控。
 CNC+PLC system, LCD monitor.



▲ 编程软件基于 windows 平台，带有 CAD 接口，编程快速方便，预览图形直观。
 Programming software based on Windows platform with CAD connection, fast and convenient programming, and visual previewing.

▲ 自动排屑，冷却液循环使用。
 Automatic chip removal, coolant circulate cooling.

▲ 关键的机械、液压、电气元件及部件选用国内外知名公司产品。
 Main machinery, hydraulic, electric components are chosen from international brand.

▲ 整体优化集成设计，不需要制作设备地基。
 Optimized integration design for whole machine, no foundation requirements.

技术参数 Specification

型号 Model		CJZ1610Z/A	CJZ1616Z/A	CJZ2016Z/A
最大工件尺寸 (mm) Max. size of workpiece { L × W }	1 件 one piece	1600 × 1000	1600 × 1600	2000 × 1600
	2 件 two pieces	800 × 1000	800 × 1600	1000 × 1600
	4 件 four pieces	800 × 500	800 × 800	1000 × 800
最大工件厚度 (mm) Max. thickness of workpiece		最大 80 (可选 100)，较薄钢板可以重叠加工 Max. 80 (100 are selective), can overlap processing for thinner steel plate		
数控轴数 Number of axes		2 或 3 2 or 3		
夹紧缸个数 Number of tank for clamp		12		
最大钻孔直径 (mm) Max. diameter of drilling		Φ50		
主轴转速范围 (r/min) Range of spindle rotation speed		130-560，变频器无极调速 130-560, Stepless adjustment		
机床总功率 (kW) Total power		12/10	12/10	12/10
外形尺寸 (mm) Overall dimension { L × W × H }		3790 × 1810 × 2790	4000 × 2550 × 2790	4000 × 2550 × 2790
机床重量 (kg) Net weight		5000	5500	6500

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

CJ 系列龙门式数控平板钻孔机

CJ Series Gantry Type CNC Plate Drilling Machine



CJ2020Z, CJ2525Z-1/2, CJ3030Z-2, CJ4040Z-2/3, CJ5050Z-3/4, CJ7050Z-4C

CJ 系列龙门式数控平板钻孔机
CJ Series Gantry Type CNC Plate Drilling Machine

本机床主要由床身（工作台）、龙门、垂直滑枕式钻削头、液压系统、冷却系统、自动润滑系统、数控系统、电气控制系统、排屑器组成。

The machine is mainly composed of bed(worktable), gantry, vertical ram-type drilling spindle, hydraulic system, cooling system, auto-lubricating system, CNC system, electrical system and chip-conveyor etc.

产品特点 Product feature

▲ 龙门横梁上装有一个或者多个可移动的滑板，滑板采用两条直线滚动导轨副导向，采用伺服电机和精密滚珠丝杠副分别驱动。

One or more movable slides are equipped on the cross beam of gantry. The slides are guided by two liner roller guide pairs and driven by AC servo motor and precise ball screw respectively.

▲ 横梁上的滑板装有垂直数控进给滑枕式钻削头，钻削头采用专用变频电机驱动。钻孔进给行程具有自控功能，即无需输入钻头长度，当钻头快速接近工件后，自动切换为工进速度；钻头钻透工件后，可自动切换为快速退回。

The slides on the cross beam are equipped with vertical CNC feeding ram-type drilling spindle, which adopts special conversion motor. Stroke self-controlled drilling unit can make the drill approach workpiece rapidly, when the drill touches the workpiece, it can change the feeding speed immediately to preset working speed automatically. After the hole is drilled through, the drill returns automatically and rapidly.

▲ 床身两侧面有两条高承载力的直线滚动导轨副，龙门纵向移动通过带同步功能的 CNC，驱动 AC 伺服电机和精密滚珠丝

杠双侧同步移动。

Heavy-load liner roller guide pairs are equipped on two sides of the machine bed respectively. The longitudinal movement of the gantry's two sides is driven synchronously via AC servo motor and precise ballscrew.

▲ 液压系统，用于完成工件的夹紧和松开动作，在钻削过程中维持足够的夹紧力。

Hydraulic system, used to clamp and release the workpiece, keep enough clamping force during drilling process.

▲ 数控系统采用西班牙 FAGOR 系统，并配有 RS232 接口和 LCD 液晶显示屏。

It adopts FAGOR CNC system, equipped with RS232 interface and LCD screen.

▲ 编程软件基于 windows 平台，带有 CAD 接口，编程快捷方便，预览形象直观，软件可自动识别法兰和平板。

Programming software based on Windows platform with CAD connection, fast and convenient programming and visual preview. It can recognize the flange or plate automatically.

技术参数 Specification

型号 Model		CJ2020Z	CJ2525Z-1/2	CJ3030Z-2	CJ4040Z-2/3	CJ5050Z-3/4	CJ7050Z-4
加工对象 Workpiece	最大加工范围 (mm) Max. range of workpiece	2000×2000	2500×2500	3000×3000	4000×4000	5000×5000	7000×5000
	最大加工工件厚度 (mm) Max. thickness of workpiece	80/200			80/300		
钻削主轴 Drilling spindle	最大钻孔直径 (mm) Max. drilling dia.	Φ50					
	主轴转速 (r/min) Rotation speed of spindle	120~450 (无级调速 stepless speed adjustment)					
	主轴电机功率 (kW) Spindle motor power	1×7.5	1×7.5 或 2×7.5 1×7.5 or 2×7.5	2×7.5	2×7.5 或 3×7.5 2×7.5 or 3×7.5	3×7.5 或 4×7.5 3×7.5 or 4×7.5	4×7.5
排屑及冷却 Chip removal and cooling	自动排屑自动冷却 Automatic chip removal, coolant circulation cooling	冷却压力 0.4~0.6 MPa Cooling pressure 0.4~0.6 MPa					
电气系统 Electric system	数控轴数 No. of axes	4 或 5 4 or 5	4 或 6 4 or 6	4 或 6 4 or 6	8 或 10 8 or 10	8 或 10 8 or 10	10
	数控系统 CNC system	西班牙 FAGOR8055 数控系统 + 三菱 PLC Spain FAGOR8055 CNC system + Mitsubish PLC					
主机 Host machine	设备总功率 (kW) Total power	25	25/32	40	40/48	48/54	54
	外形尺寸 (mm) Overall dimension (L×W×H)	3200×3200× 2750	4500×3700× 2800	8800×6500× 3300	10700×7500 ×3300	11400×8500× 3300	13400×8600× 3300
	设备净重 (T) Net weight	20	25	28	40	58	90

注：以上参数如有变更，恕不另行通知。Remark: We reserve the right to make alterations without notice.

SWZ 系列数控型钢三维钻床

SWZ Series CNC Section Steel 3-D Drilling Machine



SWZ700、SWZ1000、SWZ1250
SWZ 系列数控型钢三维钻床
 SWZ Series CNC Section Steel 3-D Drilling Machine

由主机、液压系统、输送料道、电气控制系统组成。
 This machine is composed of mainframe, hydraulic system, feeding conveyor unit & electrical control system etc.

产品特点 Product feature

- ▲ 该钻床具有三个动力头，工件通过时三个面上的孔均可加工完毕。
Equipped with three drilling spindles, the drilling process finished when the work piece going through the equipment.
- ▲ 三个动力头可以同时钻孔，采用自控行程钻削动力头方式。
Three drilling spindles can drill holes simultaneously, equipped with self-controlled stroke drilling spindles.
- ▲ 不需要设定工件厚度及钻头长度，自动进行快进和工进转换，加工效率高。
No need to set thickness of work piece and length of drills, with automatic speed conversion, high efficiency from rapid

feeding to work feeding.

- ▲ CNC+PLC 控制，上位机监控，编程软件基于 WINDOWS 平台，编程快速方便，预览图形直观。
CNC & PLC control systems, CRT display, operating software based on WINDOWS platform, simply and convenient programming and visual preview.
- ▲ 采用雾化冷却装置，延长钻头使用寿命。
High-grade atomizing cooling system, prolong the drill's work life.
- ▲ 每个动力头配备知名公司生产的主轴减速机。
Each drilling spindle, equipped with professional gear-motor from famous products.
- ▲ 关键的液压、电气元件及部件选用国内外知名公司产品。
Main primary hydraulic pressure, electric components are domestic and international famous products.

技术参数 Specification

型号 Model		SWZ700	SWZ1000	SWZ1250
加工 H 型钢截面尺寸 (腹高 × 翼宽 mm) Size of H-beam Web(H)×flange(W)	最大 Max.	700 × 400	1000 × 500	1250 × 600
	最小 Min.	200 × 75	200 × 75	200 × 75
钻孔直径 (mm) Dia. of drilling	垂直钻削 Vertical drilling	Φ 12~Φ33.5	Φ 12~Φ33.5	Φ 12~Φ40
	水平钻削 Horizontal drilling	Φ 12~Φ31.5	Φ 12~Φ31.5	
钻削主轴数量 Number of spindle		上单元、固定侧、移动侧各 1 个，共 3 个 One vertical, two horizontal (Left and right), three in all		
主轴转速范围 (r/min) Spindle rotation speed		180~650 变频调速 180~650 (Frequency inverter)		
轴向工进速度 (mm) Feeding speed vertical spindle		20~200		
进给行程 (mm) Feeding distance	上单元主轴 Vertical spindle	240	240	240
	下单元主轴 Horizontal spindle	150	150	150
机床总功率 (kW) Installation power		26	26	26
主机外形尺寸 (mm) Overall dimension (L × W × H)		4430 × 2080 × 3030	4730 × 2080 × 3130	4930 × 2080 × 3230
整机重量 (kg) Net weight		5800	6000	7000

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REVIEW OF
SUPERTIME
百超风采



SUPERTIME



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