

THREE STATION CURVED SURFACE POLISHING MACHINE

三工位曲面抛光机YJ-QPL1088A

本机器主要用于铝合金前盖单面抛光；本设备为多工位分站式不间断高效曲面扫光设备，上盘采用两个独立升降调节的抛光盘，可同时安装不同的耗材，下盘工件盘采用多工段不间断工作方式，不需停机取放片，实现了连续性不停机工作。

This machine is mainly used for polishing aluminum alloy front cover. The upper plate adopts two independent lifting adjustment polishing disc, and the lower plate adopts multi-section uninterrupted working mode, without stopping to take and put the piece, to achieve continuous non-stop work.



笔记本金属后盖

设备特点

- 机器采用简易的行星研磨抛光原理，两个上盘分别能独立驱动，可同时安装不同的抛光耗材高速旋转，能实现更好的抛光效果；
- 下盘有三个工位，每个工位3个下载盘；下载盘能公转和自转，能有效的保证产品周边扫光效果一致性；
- 机台前侧设有专用取放片工位，无机械动作，操作安全，效率高；
- 采用全新的真空吸附结构和真空控制系统，可自动化、精确化的控制每个工位的真空；
- 机器整体结构紧凑，运行平稳。通过回转体来实现下载盘的公转和自转，增加了机器的传动精度和平稳性；
- 机器采用自动排水结构，并安装自动洗机及真空管道清洗功能，提高了机台的可维护性；
- 机器操作平面控制值1.1米左右，适应人群广泛；
- 上盘升降采用气缸加线性滑轨抬升形式，实现加压的平稳可靠；
- 上抛光盘上面使用毛刷等软抛光材料，减少机器的振动；
- 电机均采用变频电机且使用变频调速器控制，能在有效设置范围内以任意速度工作，实现平稳的停止、加速、减速及换向运转；
- 上盘下降过程中，设置了快降和缓降，缓降行程在气缸行程范围内可调，缓降速度也可根据工件抗冲击程度自由调整。

MAIN TECHNICAL FEATURES

- Two upper plate can drive independently, can install different polishing material at high speed at the same time, can achieve better polishing effect.
- The lower plate has three station, each station 3 download plate.
- Side before the machine is equipped with special take put location, no mechanical action, safe in operation and high efficiency.
- Adopt new vacuum adsorption structure and vacuum control system.
- Machine compact structure, smooth operation.
- The machine adopts automatic drainage structure, and installs automatic washing machine and vacuum pipe cleaning function, improves the maintainability of the machine.
- Machine operation plane control values of 1.1 meters, widely adapt to the crowd.
- Upper plate lifting adopts cylinder linear slide.
- Used above the brush on soft polishing materials, reduce the vibration of the machine.
- All the motors are controlled by frequency conversion motor and frequency converter.
- Variable frequency speed governor realizes soft start, and soft stop.

主要技术参数 MAIN TECHNICAL SPECIFICATIONS

项目/Items	规格/Specs
上抛光盘(Upper polishing plate)	Ø1088mm 共二件(Two pcs)
上抛光盘转速(Upper polishing plate rotation speed)	0-118rpm
下载盘(Lower carrier)	Ø500mm 共九件(Nine pcs)
下载盘自转转速(Lower carrier rotational speed)	0-18rpm
下载盘公转转速(Lower carrier revolution speed)	0-6rpm
上盘主气缸缸径(Upper plate main cylinder diameter)	φ125mm
上盘减速机规格及转矩(Specification and torque of upper gear reducer)	FFAF67/580Nm
上盘行程(Upper plate stroke)	~300mm
上盘电机(Upper plate motor)	3相7.5kw 1450rpm 共二个(Two pcs)
下盘行星电机(Lower planetary motor)	3相2.2kw 1450rpm 共二个(Two pcs)
砂泵功率(Slurry pump power)	0.75 kw
时间设定范围(Time setting range)	0-9999s
高压气源/耗气量(High pressure air supply / Air consumption)	0.55-0.65(Mpa) / (10×N)L/H(N为每小时循环工作次数)
真空 / 耗气量(Vacuum / Air consumption)	≤-0.07MPa / >20(L/H)(与治具和工件之间的密合度有关)
装机容量(Installed capacity)	~20.5KVA
机器外形尺寸(Size)	2812 x 2746 x 2502mm
机器重量(Weight)	~4400kg