CURVED SURFACE POLISHING MACHINE

曲面抛光机YJ-QPL900B

本机器主要用于2.5D、3D玻璃以及其它硬、脆材料的异形表面单面抛光。
本设备为多工位分站式不间断高效曲面扫光设备，上盘采用三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。

The machine is mainly used for single-sided polishing of 2.5D, 3D glass and other hard and fragile materials. This equipment is a multi-station uninterrupted and efficient surface sweeping equipment, the upper plate adopts three independent lifting adjustment polishing discs, different consumables can be installed at the same time, and the lower plate adopts multi-section uninterrupted working mode, which does not need to stop the machine to pick up and drop the product. The continuous non-stop work is realized.


手表片


手机盖板

设备特点

- 机器采用简易的行星研磨抛光原理，三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；
- 下盘有四个工位，每个工位3个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，操作更安全，效率更高；
- 采用全新的真空吸附结构和真空控制系统，能更自动化，精确化的控制每个工位的真空；
- 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；
- 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

- Three upper plates fixed with different polishing consumable parts can rotate separately.
- There are four lower plates; each plate has three load plates. The load plates can rotate and revolute at an adjustable speed, which increased the polishing uniformity.
- The front side of the machine is equipped with a special pick-up and playback station, no mechanical action, safer operation and higher efficiency.
- Work pieces fixed by vacuum suction. Brand new vacuum system can precisely control the vacuum of each lower plate.
- The machine adopts automatic drainage structure, and installs automatic washing machine and vacuum pipe cleaning function, which improves the maintainability of the machine.
- The lifting form of cylinder and linear slide rail is adopted to realize the stability and reliability of pressurization.
- Soft polishing materials such as brushes are used on the polishing disc to reduce the vibration of the machine.
- Frequency conversion motor is controlled by frequency conversion governor, which can work at any speed within the effective setting range, and realize steady stop, acceleration, deceleration and direction changing.
- Upper plate slow down speed can be adjusted within the cylinder stroke according to the material of work piece.

主要技术参数 MAIN TECHNICAL SPECIFICATIONS

项目/Items	规格/Specs
上抛光盘(Upper polishing plate)	Ø900mm 共三件(Three pcs)
上抛光盘转速(Upper polishing plate rotation speed)	0-118rpm
下载盘(Lower carrier)	Ø408mm 共十二件(Twelve pcs)
下载盘自转转速(Lower carrier rotational speed)	0-24 rpm
下载盘公转转速(Lower carrier revolution speed)	0-6 rpm
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 共三个(Three pcs)
下盘行星电机(Lower planetary motor)	3相2.2kw 1450rpm 共三个(Three 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) / (15×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)	~30KVA
机器外形尺寸(Size)	2520×2610×2600（mm）
机器重量(Weight)	~4500kg