



SANDING DEBURRING AND HAIRLINE MACHINE **LSP-H1350**

The information reserves the right to be modified without prior notice.

MAIN PROCESSING SCOPE OF THE EQUIPMENT

1. Processing products:

stainless steel, carbon steel, aluminum plate, copper plate, all kinds of non-ferrous metals, etc

2. Device functions:

This equipment is a set of dry sand belt and four sets of universal sand sheet roller brush and a set of sand belt station and a set of Pulling ribbons combination model. It is mainly used to deal with the edge of the workpiece, the hole deburring treatment and the realization of metal sheet surface drawing, oxidation, polishing and other processing. The burrs produced in the process of stamping, cutting, laser cutting, plasma cutting, flame cutting and so on can be removed at one time in all directions, so that all edges and holes of the workpiece can achieve a small R arc effect, and the processing process is safe and reliable, so that the workpiece can achieve perfect quality.

THE WORKING PRINCIPLE OF THE EQUIPMENT

The equipment first removes large burrs such as slag particles on the surface of the workpiece through a set of sand belt stations. Then, through eight sets of universal sand sheet rolling brush combination, two adjacent sand sheet rolling brush positive and negative rotation, sand sheet rolling brush combination rotation, high-speed centrifugal grinding, scraping, cutting, file and other forces on the edge of the workpiece, the inner hole, no dead Angle to remove burrs, so that the workpiece edge, the inner hole burr removal and uniform R Angle (R Angle size can be achieved by choosing different processes and abrasive belt). Then use a set of wire drawing wheels to polish and draw the surface of the product. Through processing, high processing efficiency. At the same time, the sand belt station, the sand sheet rolling brush station, the Ribbon pulling station can also operate independently: the independent operation of the sand belt station can realize the metal sheet surface drawing, polishing, peeling, melting slag and other processing; The independent operation of the sand sheet rolling brush can achieve 360 degrees without dead Angle deburring treatment, especially for laser cutting, CNC punching under the sheet metal, not only the burrs are removed clean, and no damage to the film, the sheet

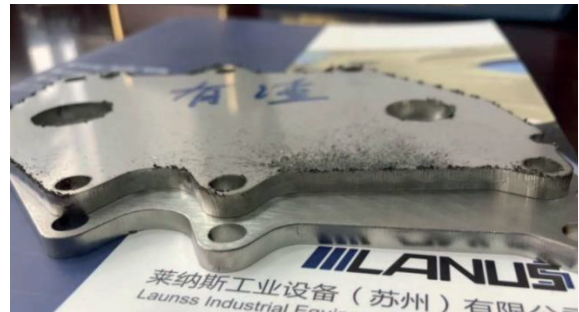
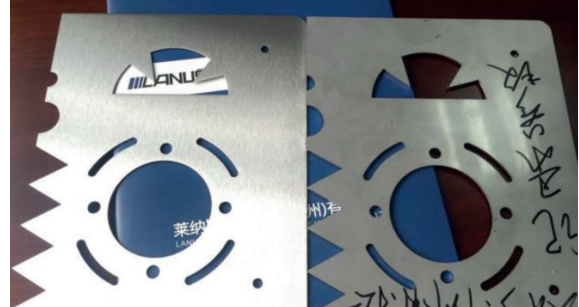
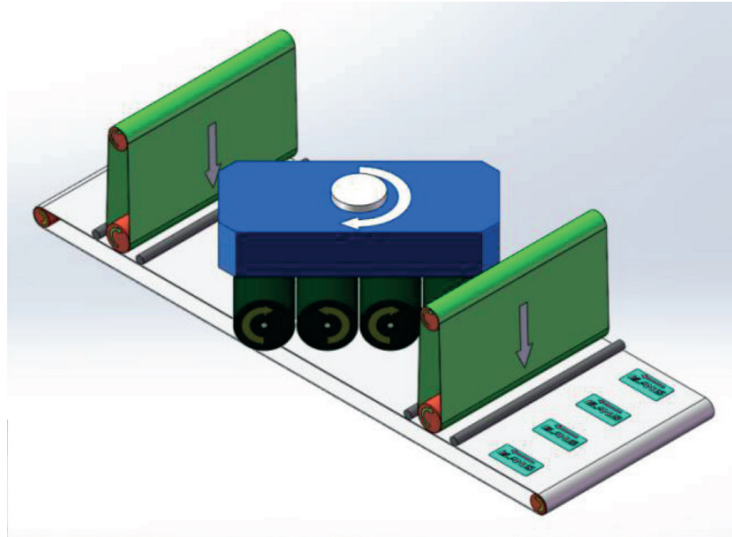
THE WORKING PRINCIPLE OF THE EQUIPMENT

metal will not have scratches; The independent operation of the drawing wheel station can realize the polishing and drawing treatment of the metal surface. Because this device uses a special soft abrasive wire, designed only for the characteristics of burrs, it is a non-damaging (in the case of film) sheet metal surface effect deburring equipment, and has superior processing efficiency for special-shaped workpieces. The conveying system is equipped with strong vacuum negative pressure adsorption to fix the workpiece. The workpiece above 50mm×50mm (non-porous workpiece) can be processed without tooling, and the special workpiece can be fixed with matching tooling. Conveying system variable frequency stepless speed regulation. Optional wet vacuum cleaner, reduce safety risks, efficient treatment of grinding dust, through the top high-pressure high-flow fan grinding processing dust into the dust removal chamber, through the water spray dust settling in the water, the dust for environmental protection filtration and absorption, clean air discharged into the atmosphere. For operation.

Advantages of using the equipment:

1. Improve production efficiency: continuous feeding through the type of processing, can meet the demand of order processing volume;
2. Improve product quality: the workpiece processing consistency is good, the surface treatment effect is far beyond the manual treatment effect;
3. Cost saving: the cost of processing workparts per unit area is much lower than that of manual processing;
4. Safety and environmental protection: dust absorption, workers' operation safety, improve workers' working environment.

**SCHEMATIC DIAGRAM OF THE EQUIPMENT STRUCTURE AND THE
COMPARISON BEFORE AND AFTER THE DEBURR PROCESSING**



MAIN TECHNICAL PARAMETERS OF THE EQUIPMENT:

working width	≤1330mm
Processing thickness	0.5~80mm
Minimum processing size	50mm×50mm (workpieces without holes)
The power of the machine	68KW (without dust removal)
Sand belt size	Φ 1910mm ×1350mm
Sand rolling brush size	Φ 300mm ×400mm
Pulling ribbon size	Φ 1910mm ×1350mm
Delivery speed	0.5~6m/min variable frequency adjustable
Sand belt line speed	18 m /s
Rolling brush rotation speed	8~26m/s variable frequency adjustable
Rolling brush public speed	1~15r / min variable frequency adjustable
Number of roller-brush planetary revolution shaft heads	1
Number of rolling-brush planetary rotation shaft heads	8
Machined thickness servo adjustment precision	0.01mm
Rolling brush compensation servo adjustment precision	0.01mm
Grinding consumables	Sand belt + rolling brush+scouring pad hairline belt
Dust air volume	5000m ³ /h
contour size of the unit	Length 4200mm wide 2300mm height 2400mm
The weight of the whole machine is about	6.5T

MAIN CONFIGURATION LIST OF THE EQUIPMENT:

Project name	Specifications	Qty	Function	Brand
Sand belt main grinding wheel	Ø 185mm ×1350mm	2	For sand strip grinding	Lanuss
Sand belt main motor	15KW	2	For sand band power	Shiyang
Rolling brush rotary motor	11KW	1	For rolling and brush small shaft rotation power	Shiyang
Rolling brush revolution gear motor	1.5KW	1	For the brush to roll the transfer power	CPG
Roller brush lifting servo motor	750W	1	Used for rolling brush wear compensation	Vitron/Huichuan
conveyer belt	1350mm	1	It is used for transportation and feeding	Lanuss
Conveyor belt drive motor	4KW	1	Used to transport power	LeiBo
Transmission reducer	BKA87	1	For conveying transmission	LeiBo
Workbench lift servo motor	750W	1	For machining the thickness adjustment	Vitron/Huichuan
Sand belt deviation correction detection switch		2	For sand belt deviation correction detection signal	BANNER,USA
Zhang tight cylinder	ACQ100×30	2	It is used to tighten the sand belt	AirTAC
Rectify the deviation cylinder	SDA63×5	2	It is used for sand band correction	AirTAC
Rotary brush frequency converter	11KW	1	Used for three groups of roller brush rotation speed regulation	Schneider

MAIN CONFIGURATION LIST OF THE EQUIPMENT (CONT):

Project name	Specifications	Qty	Function	Brand
Roller brush revolution frequency converter	1.5KW	1	Used for rolling brush revolution speed regulation	Schneider
Transmission motor frequency converter	4KW	1	Used to transport speed	Schneider
Vacuum adsorption fan inverter	15KW	1	For vacuum negative pressure adsorption	Schneider
Vacuum adsorption fan	15KW	1	For vacuum negative pressure adsorption	Elektrow, Germany
High speed bearing		1	For high speed rotation	NSK
low-voltage apparatus		1	For electrical control	Schneider
control system	PLC	1	Used for complete machine control	Siemens
touch screen	7 Inch	1	Used for complete machine control	Siemens

REQUIREMENTS FOR INSTALLATION:

1. Adequate horizontal installation space (6m*5.5m).
2. 380V, 60HZ power supply ($\pm 10\%$).
3. Clean compressed air supply.

RANDOM INFORMATION:

(TWO USER MANUALS, INCLUDING THE FOLLOWING CONTENTS, A SET OF RANDOM TOOLS)

1. Mechanical schematic diagram
2. Electrical schematic diagram
3. Specifications and models of vulnerable parts
4. Product qualification certificate
5. One detailed instruction manual

VIII. PRODUCT INSTALLATION AND PERSONNEL TRAINING

FOR EQUIPMENT OUTSIDE CHINESE MAINLAND, THIS SERVICE IS CHARGED ADDITIONALLY

1. After the equipment arrives at the delivery place of the Demander, the Demander shall bear the costs of unloading and handling, and the Demander shall immediately cooperate with the Supplier's engineer to carry out the equipment landing, installation and debugging. The domestic demand shall conduct acceptance 3 days after the completion of commissioning. If the demander delays to cooperate with the supplier engineer in equipment landing, installation, commissioning or arranging acceptance, it shall be deemed to have been qualified. If the demander uses the equipment without the acceptance inspection, the demander shall be deemed to have passed the acceptance inspection. If the demander fails to raise a written objection during the acceptance period (that is, 3 days after the completion of the commissioning) to the supplier about the product quality, it shall be deemed to have passed the acceptance inspection, regardless whether it has signed or sealed the acceptance form.

PRODUCT INSTALLATION AND PERSONNEL TRAINING (CONT.)

FOR EQUIPMENT OUTSIDE CHINESE MAINLAND, THIS SERVICE IS CHARGED ADDITIONALLY

2. After the demander passes the acceptance inspection, the supplier shall conduct a free training to the demander's personnel. The training content includes equipment principle, equipment construction, process instructions, equipment maintenance, safety protection, operation and simple troubleshooting, etc. The training time is about 1 to 2 days.

QUALITY ASSURANCE AND AFTER-SALES SERVICE

FOR EQUIPMENT OUTSIDE CHINESE MAINLAND, THIS SERVICE IS CHARGED ADDITIONALLY

1. The processing products shall be seriously deformed or obviously exceed the processing capacity of the equipment and shall not be illegal operation, otherwise the service life of the equipment will be affected.
2. The whole equipment machine is guaranteed for one year, and the warranty period starts from the date of acceptance. Damaged parts (conveyor belts, rubber rollers, etc.) and consumables are not covered by the warranty. During the warranty period, if Party A fails to use the contract equipment according to the equipment operation rules and equipment use environment requirements, or damage the contract equipment and consumables caused by intentional or negligence or force majeure, it is not covered by the free warranty, and the expenses incurred shall be borne by Party A.
3. Party B shall provide lifelong maintenance (if the warranty scope exceeds the warranty period, Party B may charge maintenance fees) and provide free consultation and software upgrade services. However, because Party A violates such services herein, Party B may refuse to provide such services.
4. Party B shall respond immediately after receiving the notice of Party A's repair report. If the problem cannot be solved through telephone, fax, network and other communication channels, Party B promises to send maintenance personnel to Party A's site within 24 hours. (Except for force majeure factors).