



千控科技

Qian Kong Technology

2024

后工序包装线

部件功能及运行参数详解

Detailed explanation of the functions and operating parameters of the post-process packaging line components

2024-07-10

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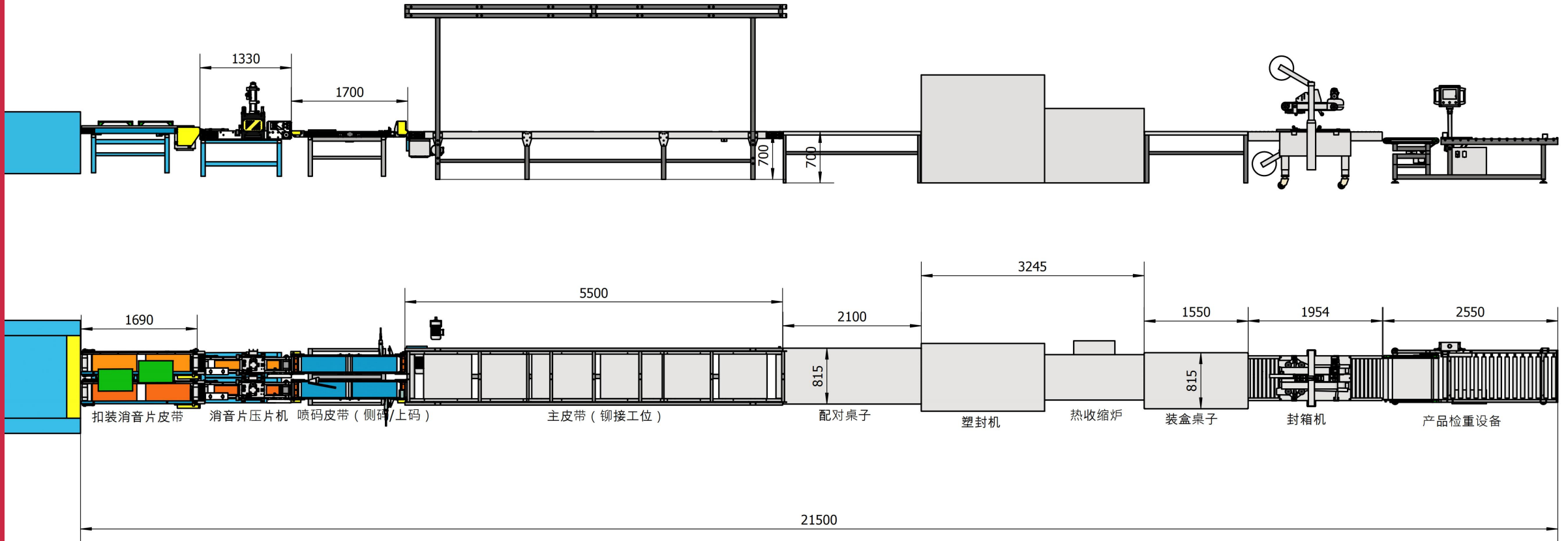


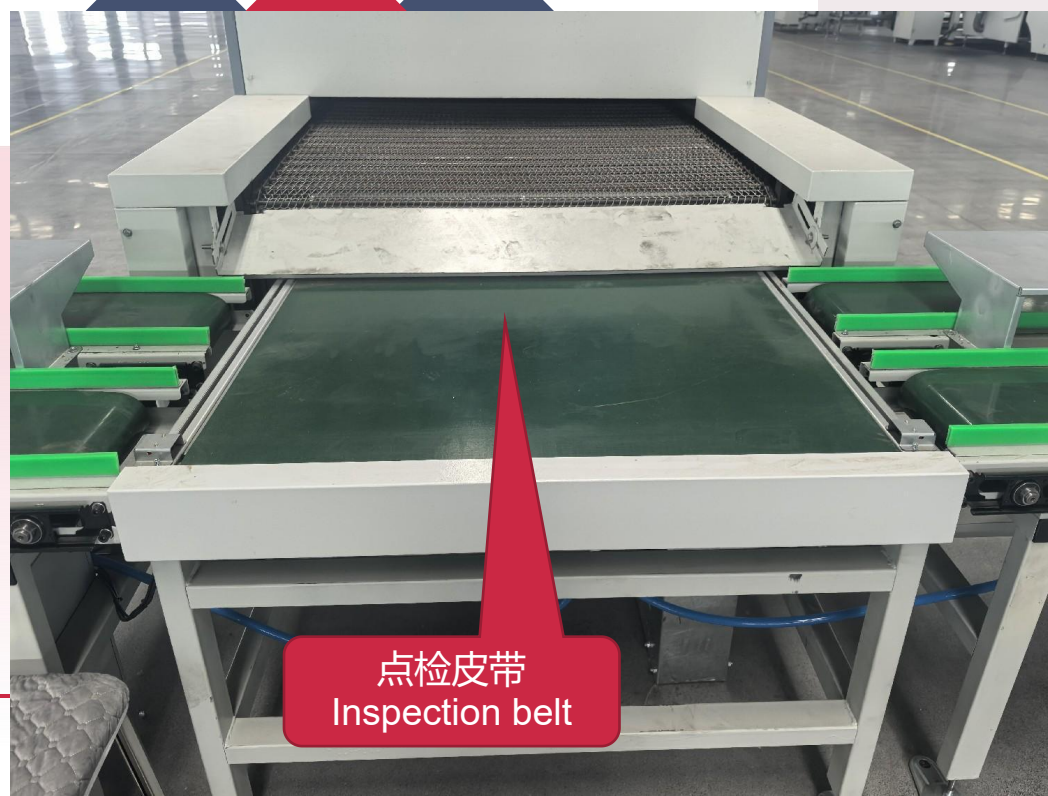
OE 车间



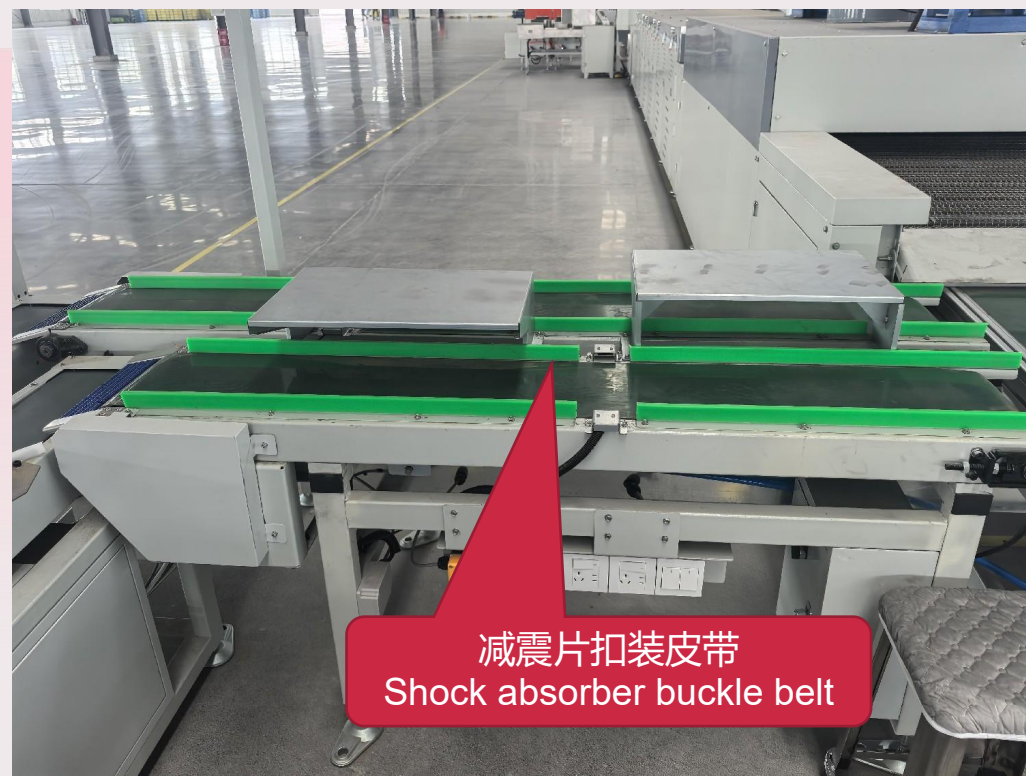
称重机功能部件简介

Introduction to weighing machine functional components





点检皮带
Inspection belt



减震片扣装皮带
Shock absorber buckle belt



压粘单元
Pressure bonding unit



进口导向
Entrance Guide



出口过渡
Export transition



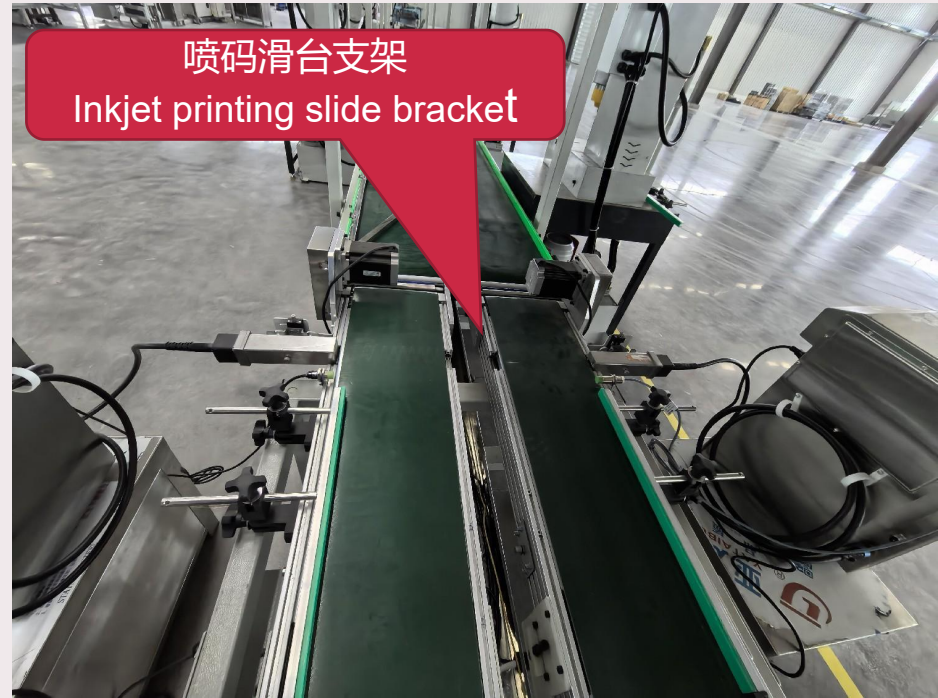
安全光栅
Safety light curtain

增压气缸
Booster Cylinder





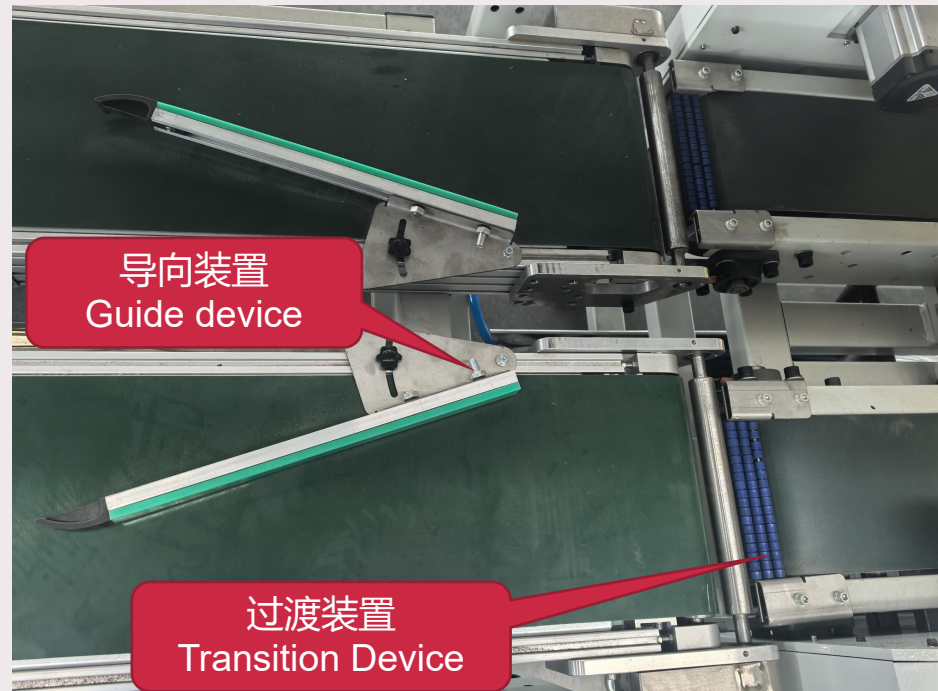
喷码单元
Coding unit



喷码滑台支架
Inkjet printing slide bracket



导向调整手柄
Guide adjustment handle



导向装置
Guide device

过渡装置
Transition Device





铆接工位
Riveting station



配对工位
Pairing station

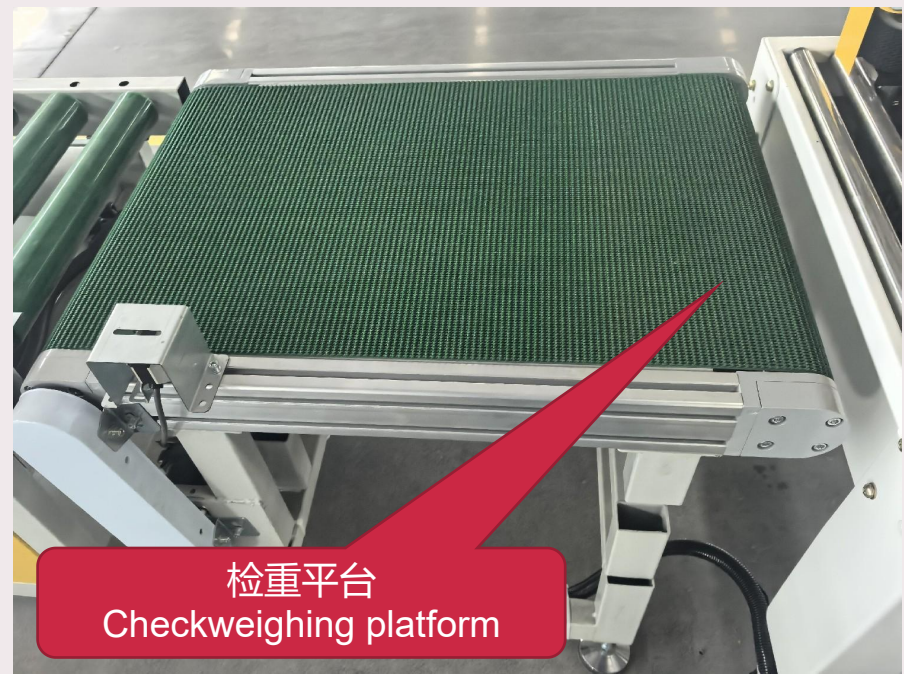


生产现场
Production site





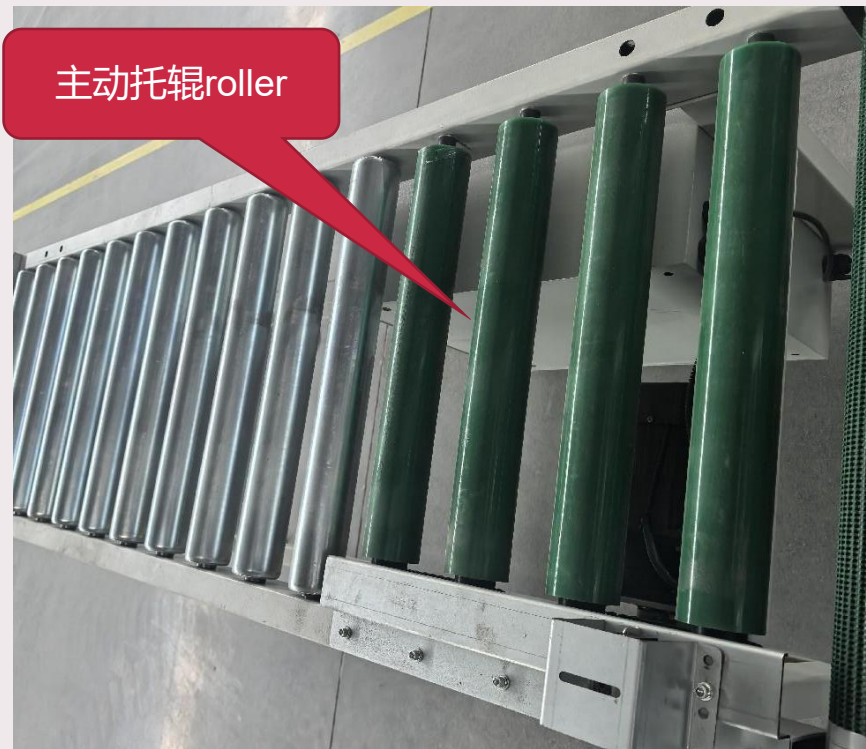
封箱机
Carton sealing machine



检重平台
Checkweighing platform

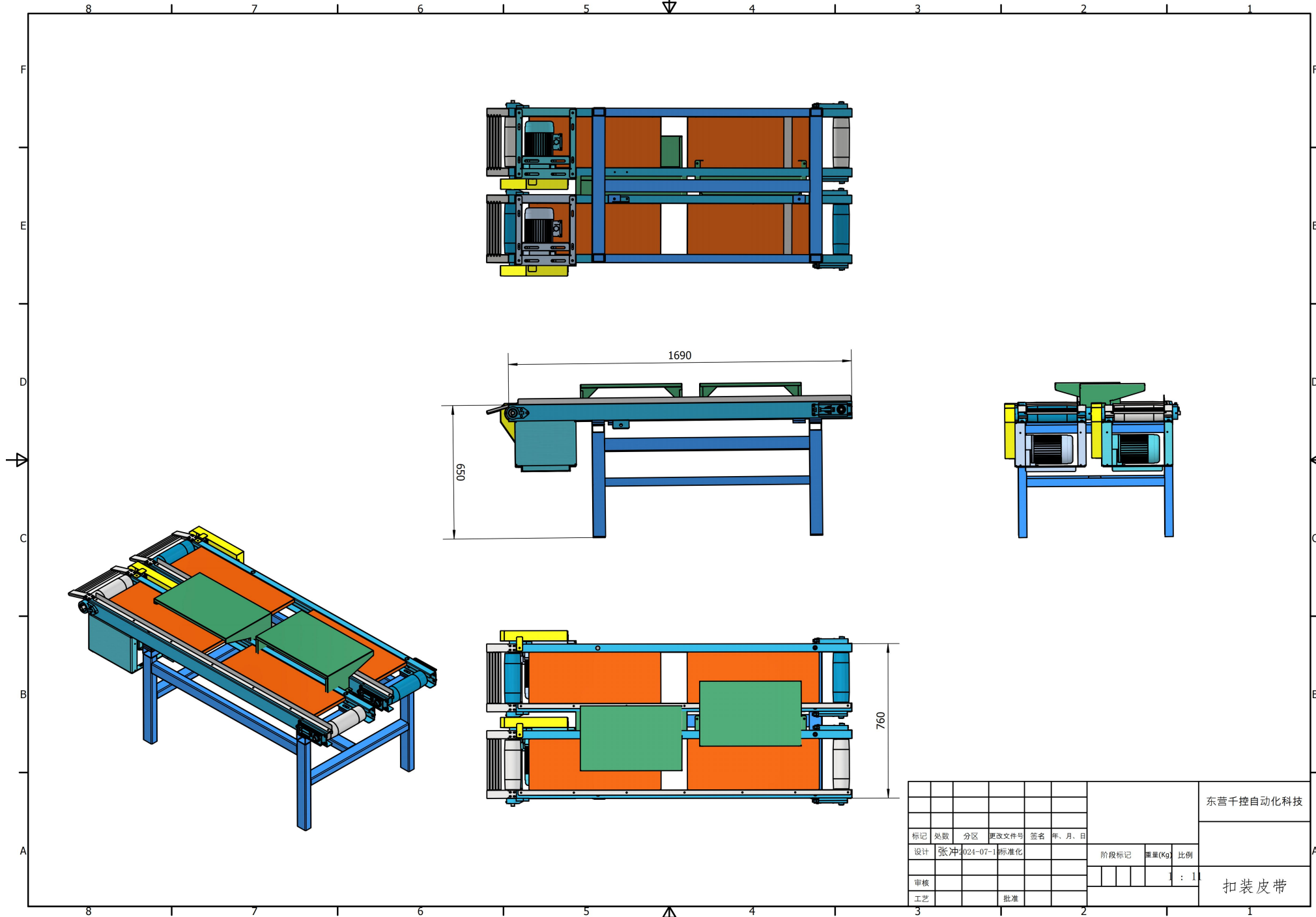


检重线
Checkweighing line



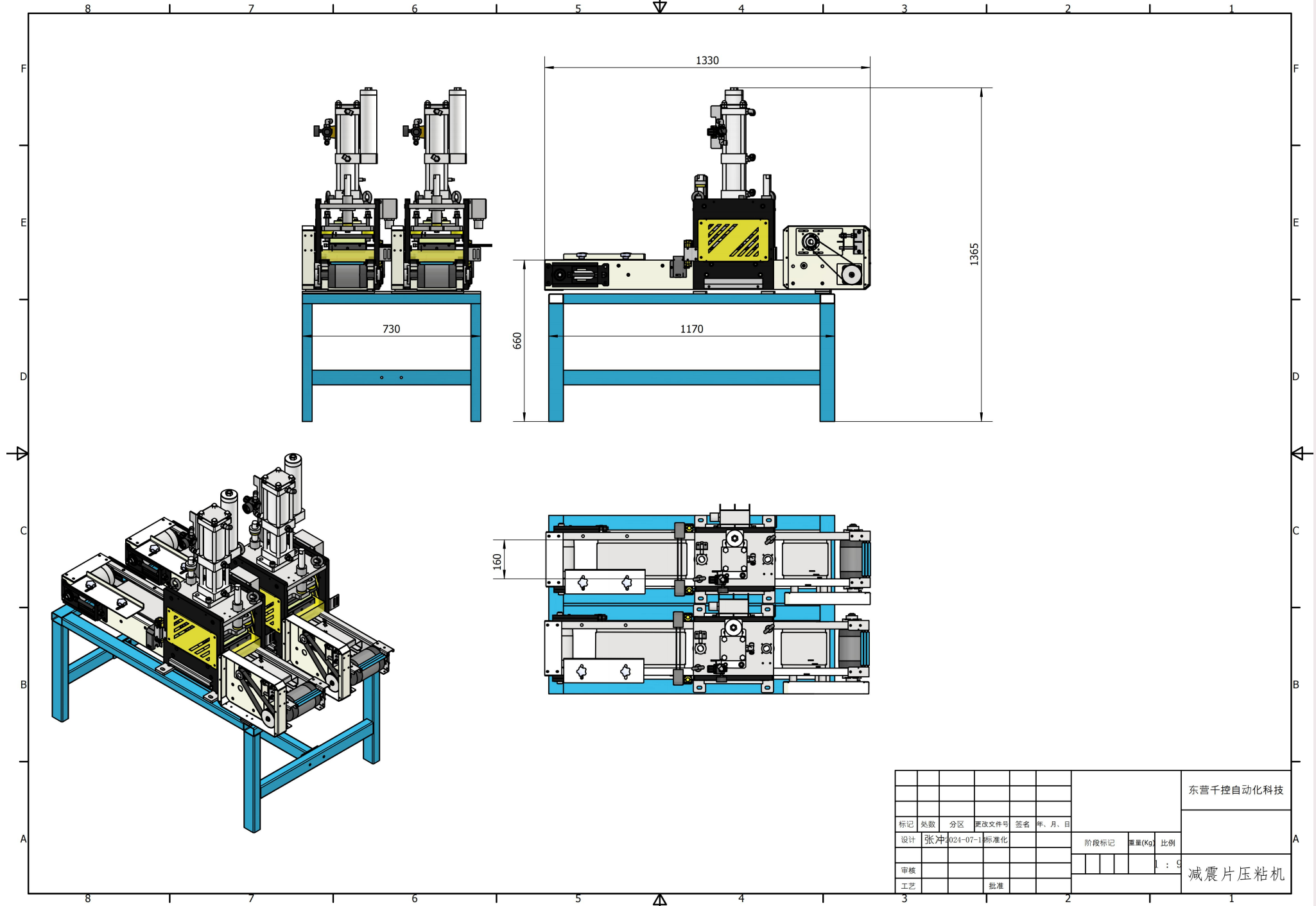
主动托辊roller





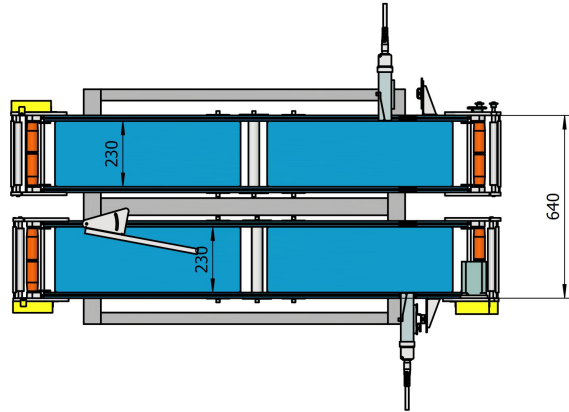
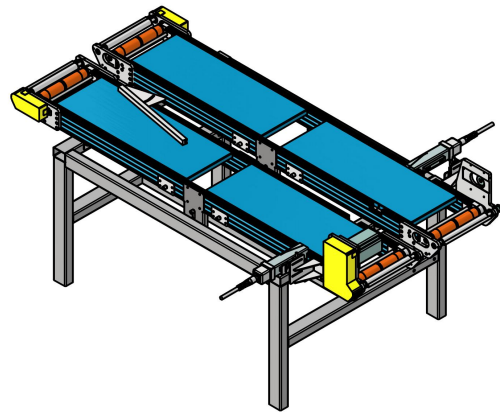
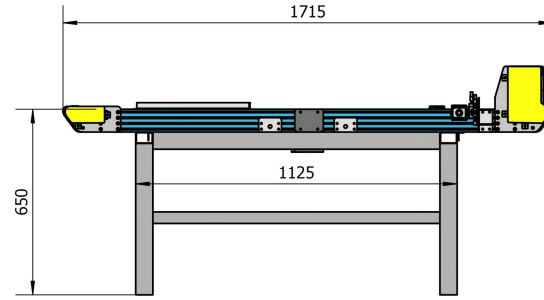
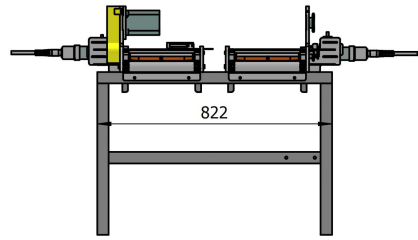
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设计	张冲	2024-07-1	标准化			阶段标记	重量(Kg)	比例
审核								: 1
工艺			批准			扣装皮带		





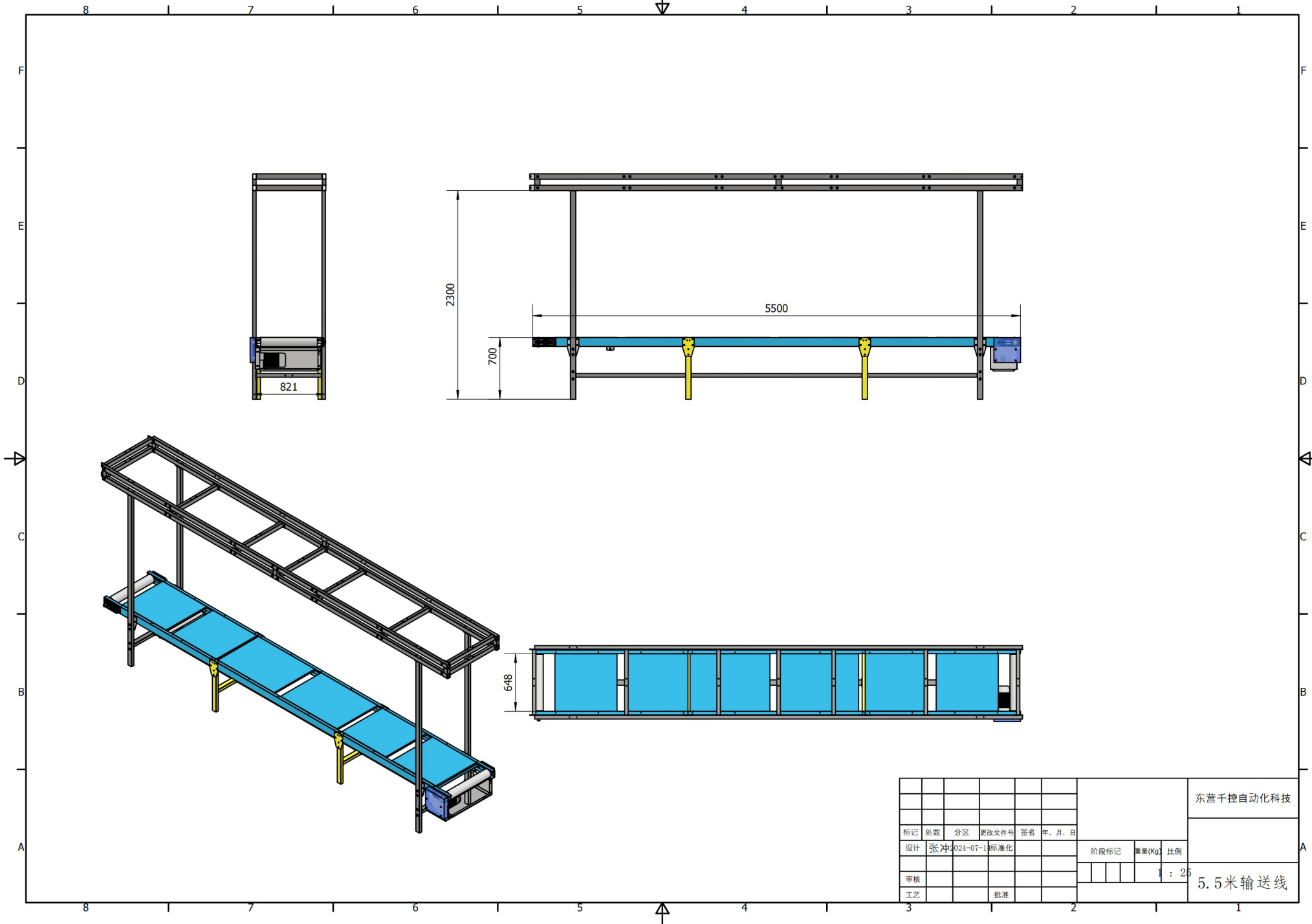
					东营千控自动化科技	
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设计	张冲	024-07-1	标准化			阶段标记 重量(kg) 比例
审核						1 : 1
工艺			批准			减震片压粘机





						东营千控自动化科技		
标记	处数	分区	更改文件号	签名	年、月、日			
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审核								1 : 12
工艺			批准			喷码皮带总装		

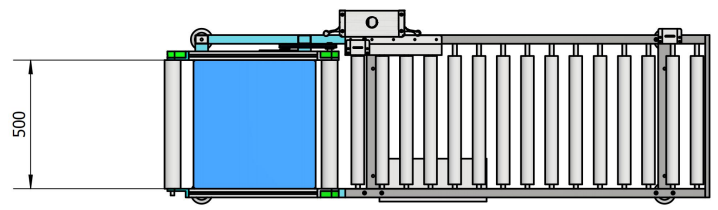
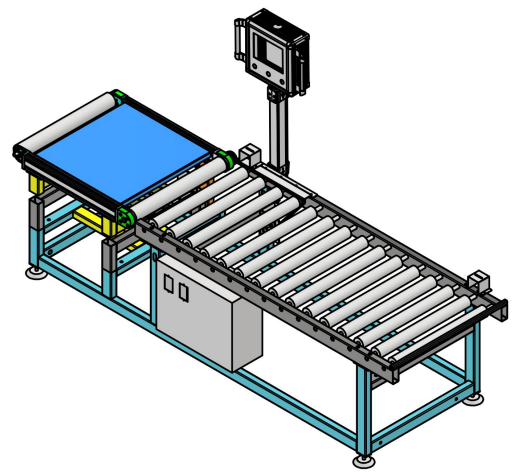
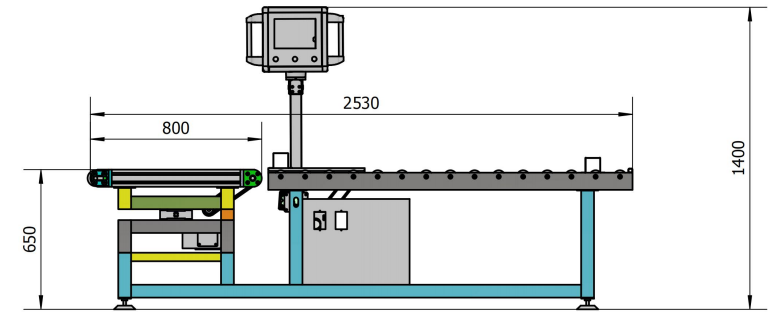
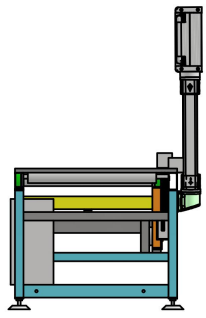




						东营千控自动化科技		
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设计	张冲	024-07-1	标准化					1 : 25
审核								
工艺				批准				

5.5米输送线





						东营千控自动化科技		
标记	处数	分区	更改文件号	签名	年、月、日			
设计	张冲	4024-07-1	标准化			阶段标记	重量(Kg)	比例
审核								1:16
工艺			批准			包装箱检重称		



检重线历史数据采集与分类 黄色首件采集 绿色正常 红色异常

Historical data collection and classification of weight inspection line Yellow first piece collection Green normal Red abnormal

2023/8/21	9:31:14	370	10.33	16.22	5.88999939
2023/8/21	9:32:13	340	10.33	888.00	877.6700001
2023/8/21	9:34:32	120	10.35	10.33	-0.020000458
2023/8/21	9:35:13	430	10.34	10.33	-0.010000229
2023/8/21	9:35:52	450	10.35	10.33	-0.020000458
2023/8/21	9:36:41	910	10.37	10.33	-0.039999962
2023/8/21	9:42:50	920	10.35	10.33	-0.020000458
2023/8/21	9:43:30	900	10.36	10.33	-0.029999733
2023/8/21	9:43:57	440	10.35	10.33	-0.020000458
2023/8/21	9:53:02	470	10.36	10.33	-0.029999733
2023/8/21	9:53:55	620	10.35	10.33	-0.020000458
2023/8/21	10:01:18	210	10.37	10.33	-0.039999962
2023/8/21	10:01:56	960	10.35	10.33	-0.020000458
2023/8/21	10:02:34	10	10.35	10.33	-0.020000458
2023/8/21	10:06:00	50	10.36	10.33	-0.029999733
2023/8/21	10:12:46	270	10.37	10.33	-0.039999962
2023/8/21	10:14:02	0	10.36	10.33	-0.029999733
2023/8/21	10:15:01	330	10.35	10.33	-0.020000458
2023/8/21	10:21:25	570	10.37	10.33	-0.039999962
2023/8/21	10:27:30	20	10.34	10.33	-0.010000229
2023/8/21	10:37:19	120	10.35	10.33	-0.020000458
2023/8/21	10:37:57	110	10.34	10.33	-0.010000229
2023/8/21	10:39:03	120	10.34	10.33	-0.010000229
2023/8/21	10:40:39	100	10.35	10.33	-0.020000458
2023/8/21	10:41:22	300	10.37	10.33	-0.039999962



磨合胶涂覆机

摩擦剂涂覆机产品介绍:

Introduction of Friction Agent Coating Machine:

1.该设备针对刹车片产品, 可实现多种不同胶类材料的涂覆。

This equipment can coat a variety of different glue materials for brake pad products.

2.胶辊间隙可以通过精密螺栓双向自由调节, 精准控制。

The rubber roller gap can be freely adjusted in two directions through precision bolts for precise control.

3.涂覆机构左右两侧各设计有升降机构, 根据实际涂覆效果可联立也可单独调节。

The left and right sides of the coating mechanism are designed with lifting mechanisms, which can be adjusted together or individually according to the actual coating effect.

4.涂覆辊与从动辊均采用模块化设计, 可快速切换不同规格。

Both the coating roller and the driven roller adopt modular design, which can quickly switch to different specifications.

5.输送带通过创新设计可以自由调整两带间距, 从而能够有效避让拉仲点。

The conveyor belt can freely adjust the distance between the two belts through innovative design, thus effectively avoiding raised points.

6.输送带及涂覆辊采用步进电机作为驱动, 位置及速度控制精准, 可实现订制花纹的涂敷。

The conveyor and coating roller are driven by stepper motors, with precise position and speed control, enabling customized pattern coating.

7.标配PLC和人机界面以此来实现更方便的人机交互。

Equipped with human-computer interaction interface.

8.输送带的输送方式包括连续式和步进式两种, 能够满足多种涂覆需求。

The conveyor conveying methods include continuous and step-by-step, which can meet a variety of coating needs.

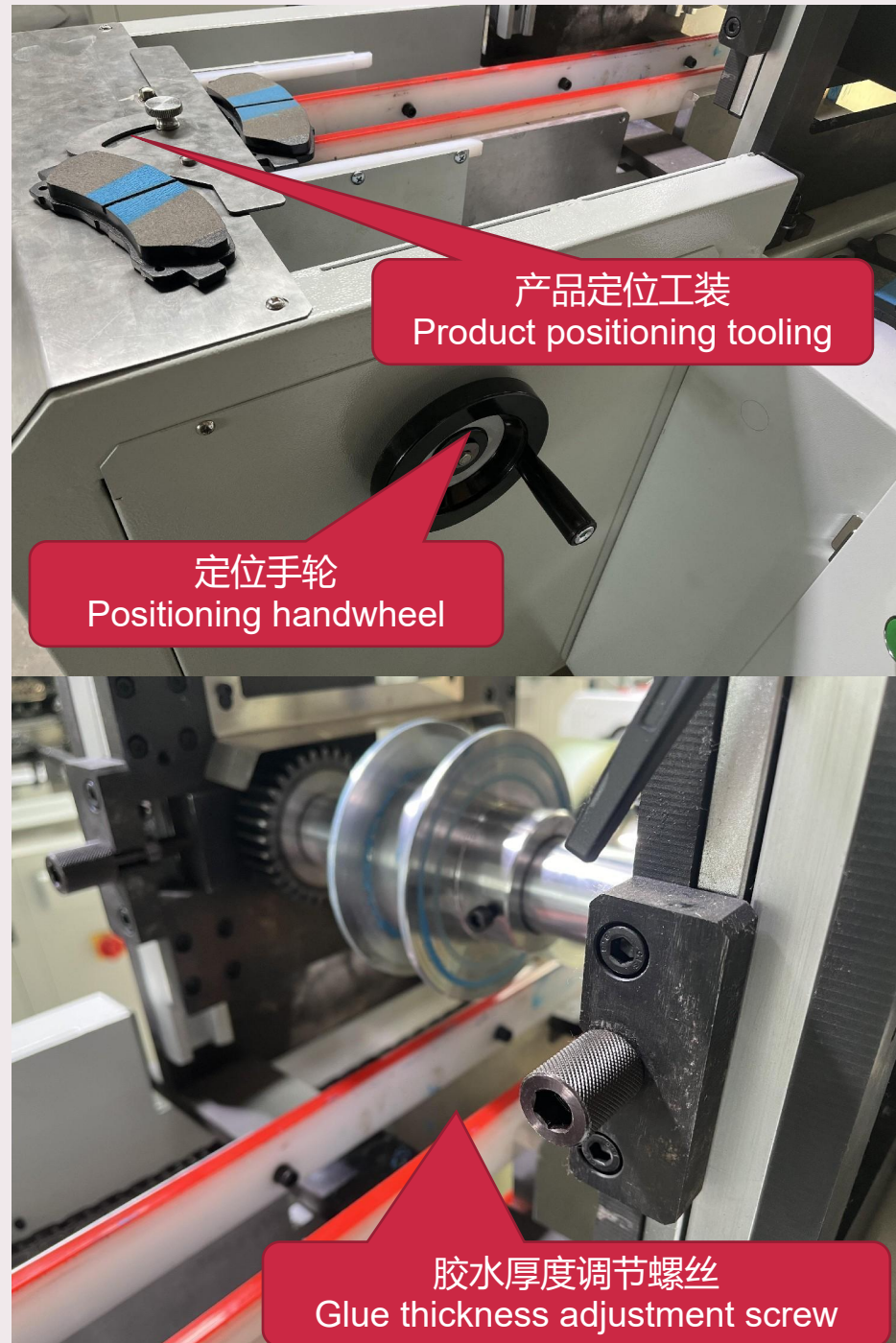


参数	MODEL	QK-170-TF
涂覆宽度	Coating width	30-170mm
最大通过高度	Maximum passing height	100mm
胶辊间隙	Roller gap	0-1.5mm
钢背定位调节	Distance between positioning platest	30-270mm
输送带间距调节	Distance between conveyor belts	30-170mm
涂覆角度调节	Coating angle	0±45°
生产节拍	Cycle time	2-3S
设备总功率	Total power	1000W
设备重量	Weight	300KG
工作台高度	Workbench height	900mm
整机外形尺寸	Dimensions of the machine	L1200*W660*H1480mm

主营: 全自动称料机, 钢背滚胶机, 钢背自动钻孔机, 报警线自动钻孔机, 输送线及非标定制设备

山东省东营市广饶县广饶工业园

15020596667

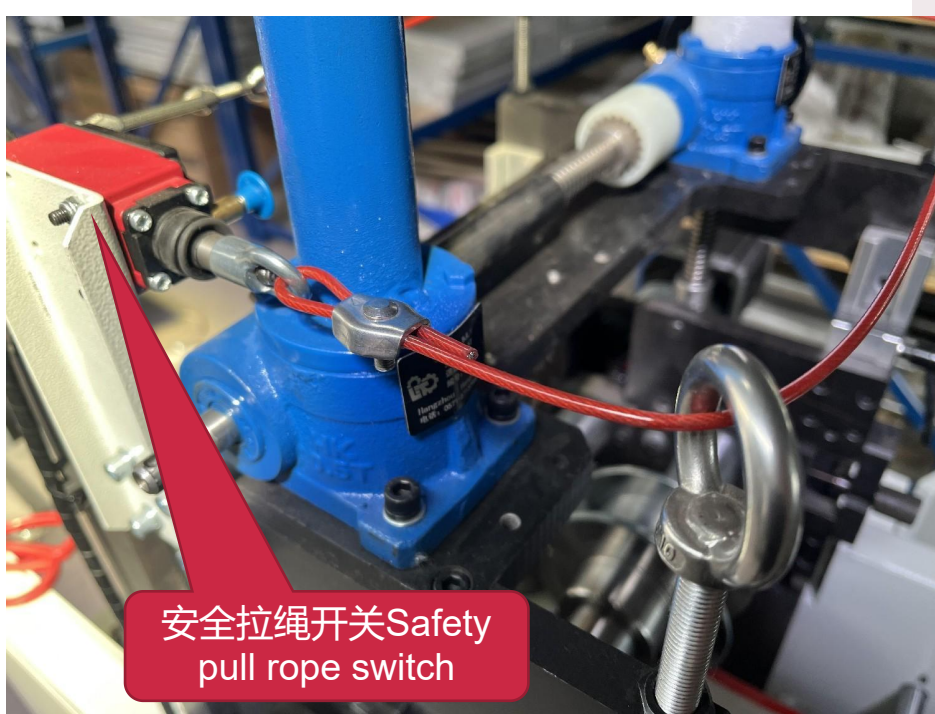


产品定位工装
Product positioning tooling

定位手轮
Positioning handwheel

胶水厚度调节螺丝
Glue thickness adjustment screw





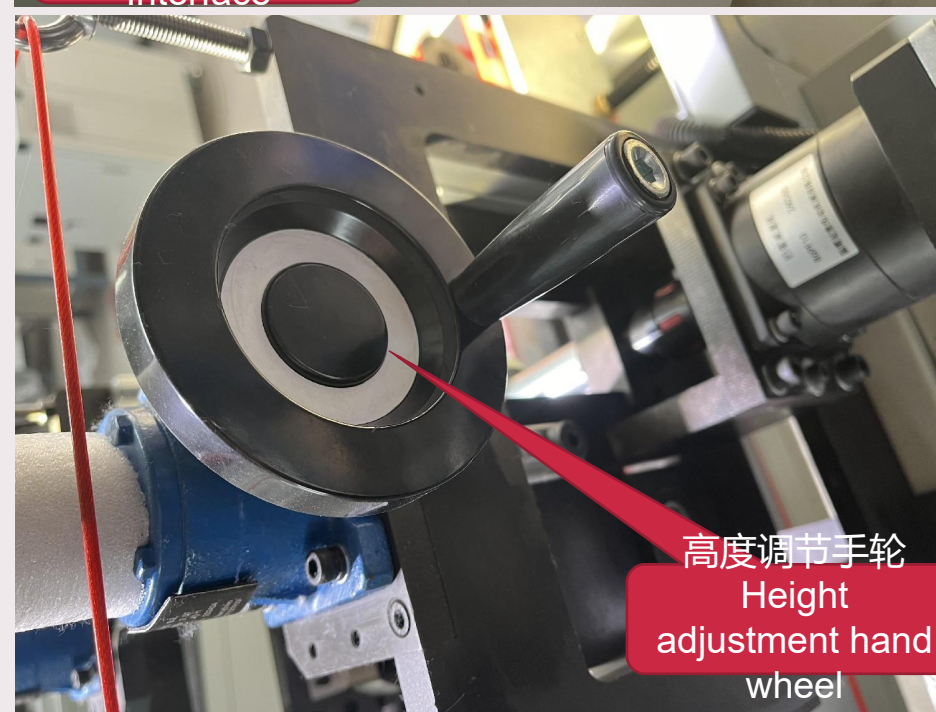
安全拉绳开关Safety
pull rope switch



人机界面Human
Machine
Interface

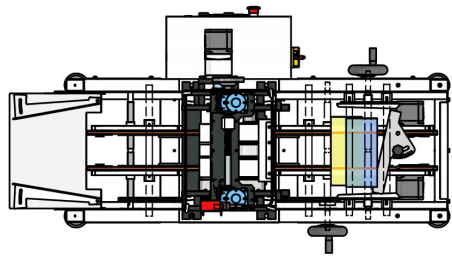
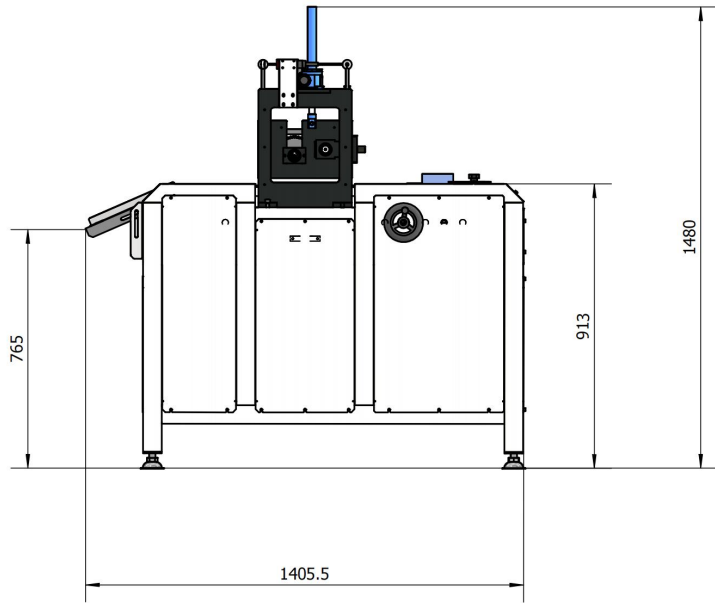
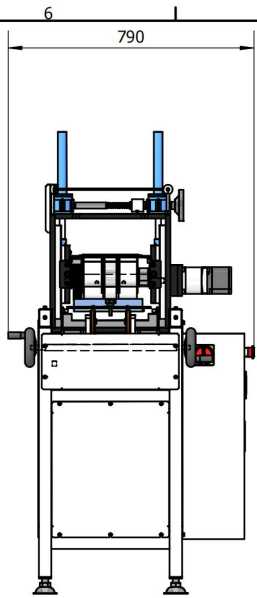


双独立输送皮带Dual
independent
conveyor belts

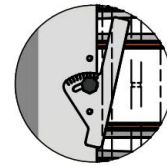


高度调节手轮
Height
adjustment hand
wheel



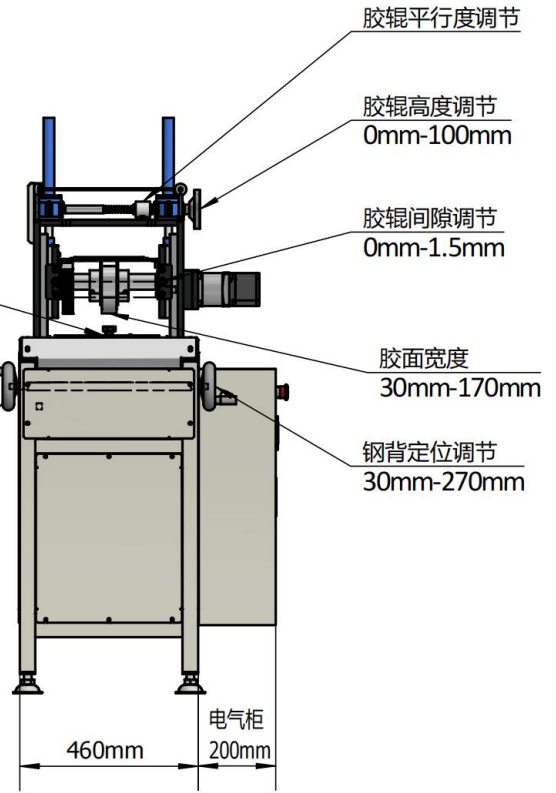


标记	处数	分区	更改文件号	签名	年、月、日				
设计	张冲	4024-05-0	标准化				阶段标记	重量	
审核									
工艺			批准						



涂层角度调节
±45°

输送带间宽调节
30mm-170mm



胶辊平行度调节

胶辊高度调节
0mm-100mm

胶辊间隙调节
0mm-1.5mm

胶面宽度
30mm-170mm

钢背定位调节
30mm-270mm

460mm
电气柜
200mm



报警线钻孔机

报警线钻孔机设备简介:
Introduction to Alarm Cable Drilling Equipment:

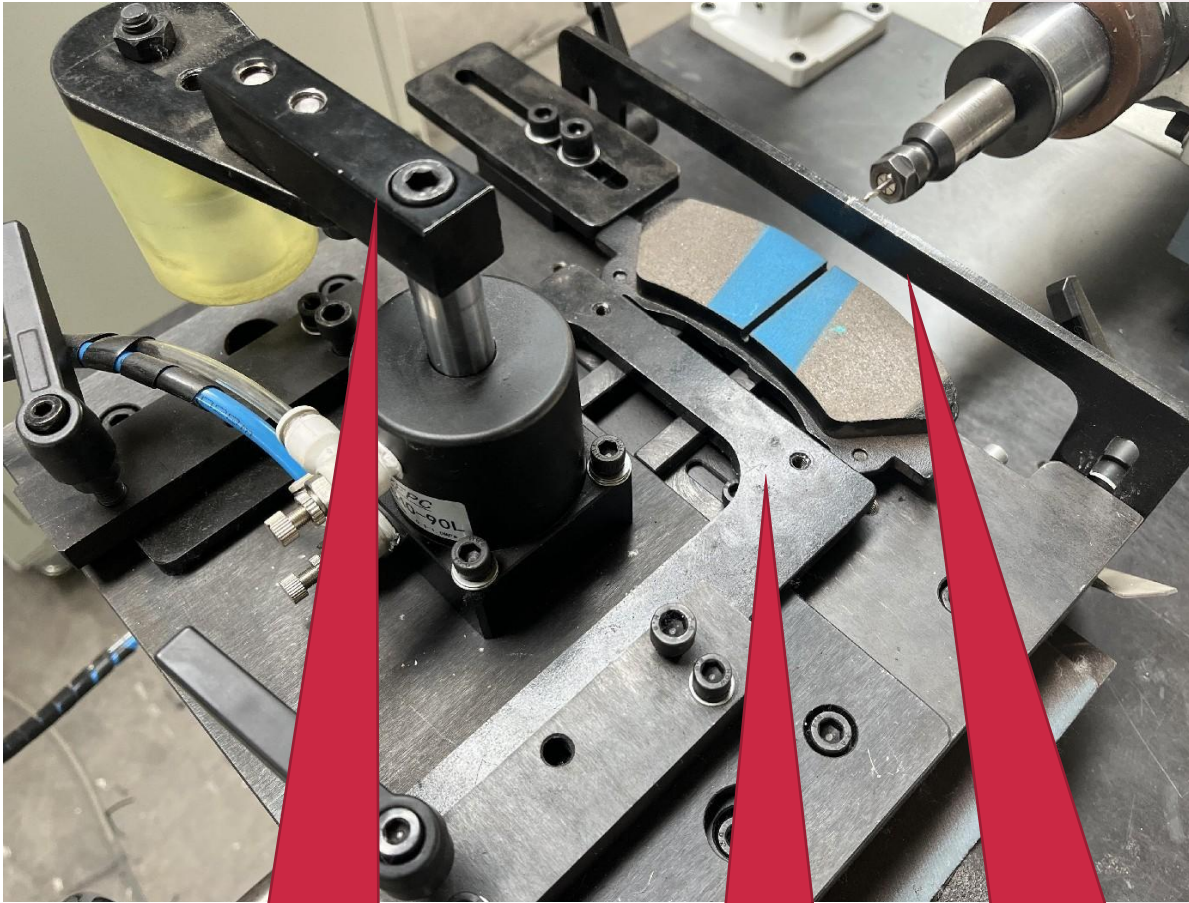
1. 该设备采用伺服钻孔动力头，丝杆精确定位，通过触摸屏设定进给深度，自由设定进刀、退刀次数，打孔高效稳定、一致性高。
The equipment uses a servo slide and precision screw for precise positioning. The feed depth can be set through the touch screen, and the number of feed and retraction times can be conveniently set. It has high drilling efficiency and high stability.
2. 标配内外弧打孔工装，内外弧快速切换。
Equipped with internal and external arc drilling tooling, it can quickly switch between internal and external arc modes.
3. 打孔平台由两组燕尾滑台组成十字滑台形式，可快速自由调整打孔位置。
The drilling platform is a cross dovetail slide, which can quickly and easily adjust the drilling position.
4. 打孔平台配有L型支架，可快速调整位置，以避免钢背上的拉伸点。
The drilling platform is equipped with an L-shaped bracket, which can be easily adjusted to avoid the bumps on the steel back.
5. 模块化ER夹头，快换方便、稳定可靠。
Equipped with modular ER chuck, easy and reliable replacement.
6. 标配PLC和人机界面以实现更方便的人机交互。
Equipped with human-computer interaction interface.



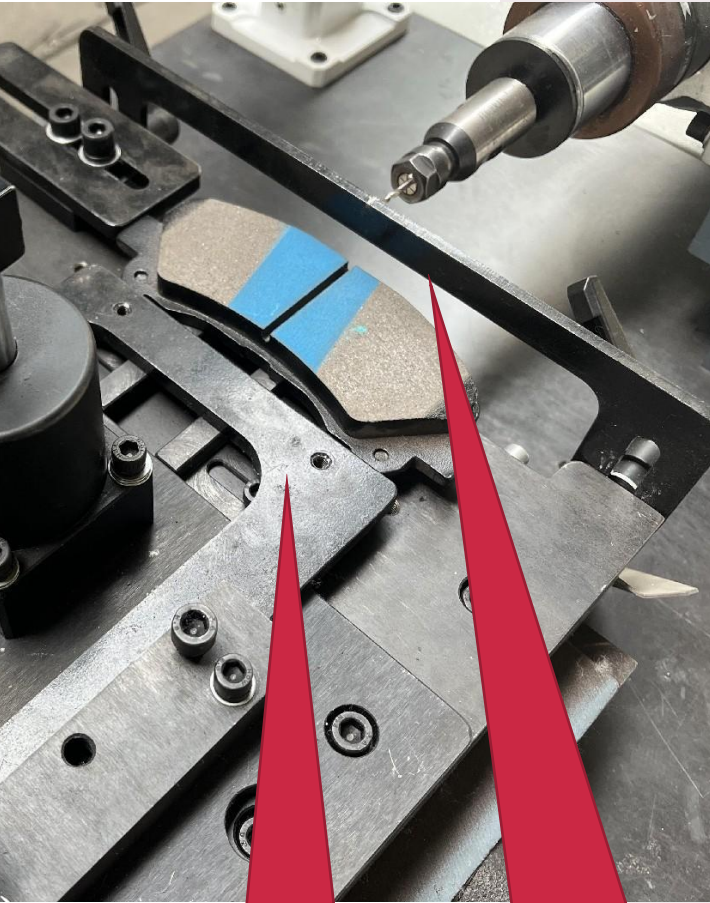
参数	MODEL	QK-100-ZK
钻孔直径	Hole diameter	2-10mm
钻孔深度	Hole depth	< 30mm
钻孔类型	Hole type	内-外弧/Internal-external arc
动力头高度调节	Spindle distance	110mm
动力头进给行程	Spindle feed stroke	100mm
燕尾滑台行程	Dovetail slide stroke	120mm
生产节拍	Cycle time	4-5S
设备总功率	Total power	1KW
设备重量	Weight	400KG
工作台高度	Workbench height	800mm
整机外形尺寸	Dimensions of the equipment	L860*W600*H1400mm

主营：全自动称料机，钢背滚胶机，钢背自动钻孔机，报警线自动钻孔机，输送带及非标定制设备





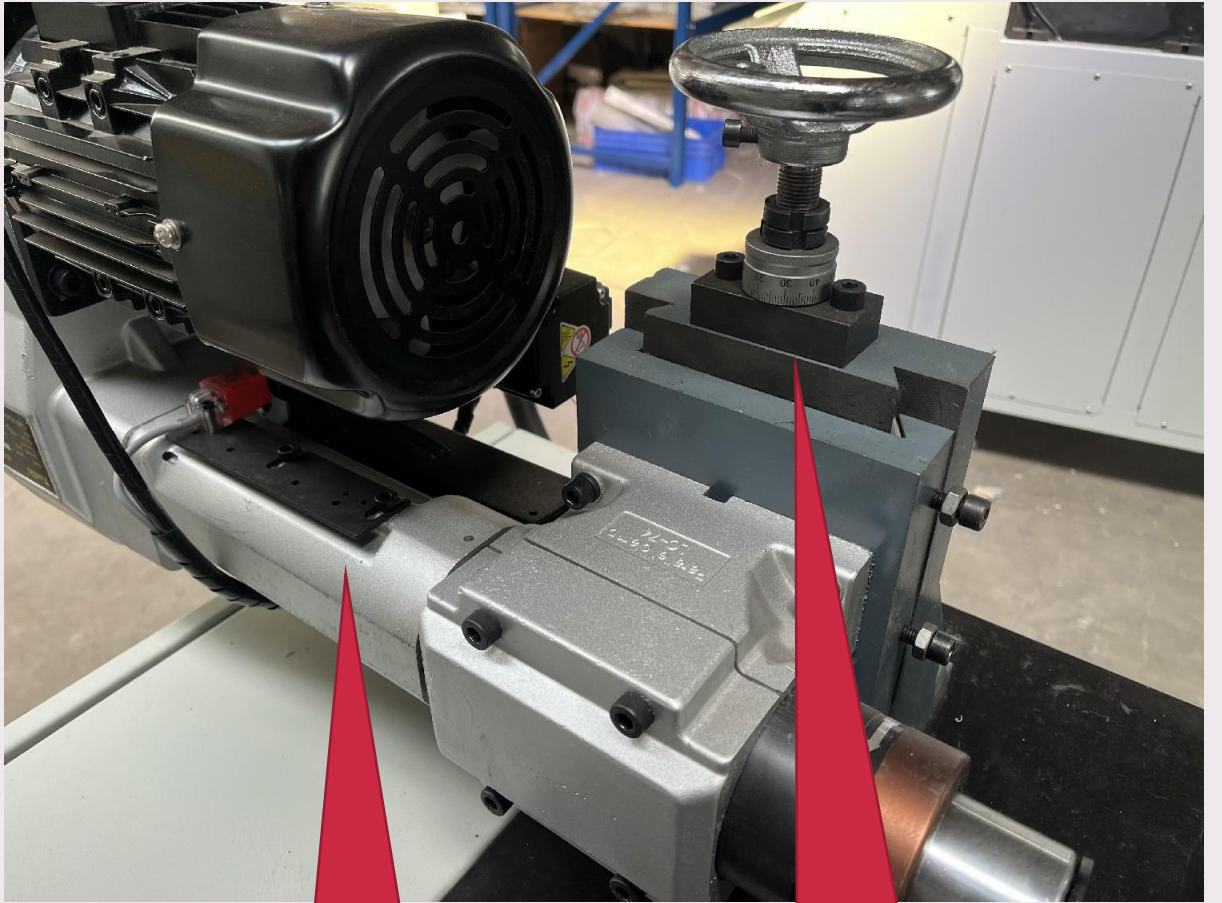
旋转夹紧装置
Rotating clamping device



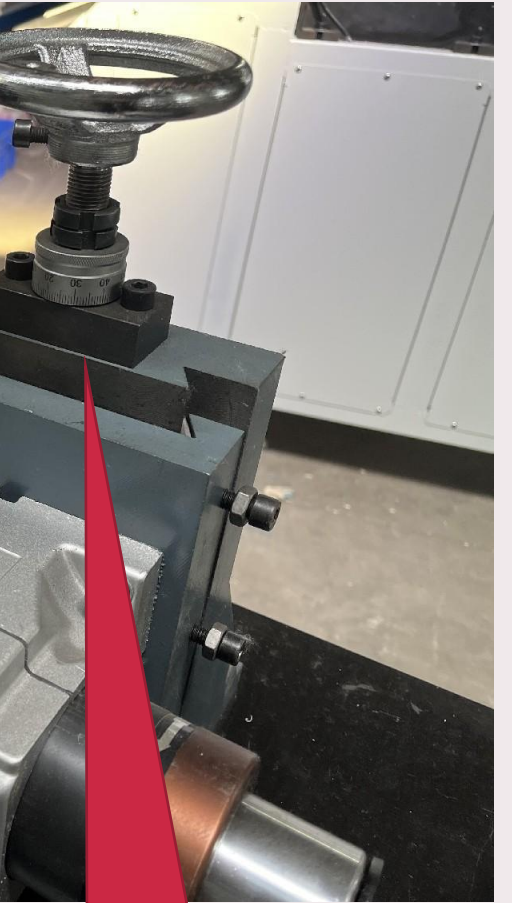
定位工装
Positioning tooling



外弧定位板
Outer arc positioning plate

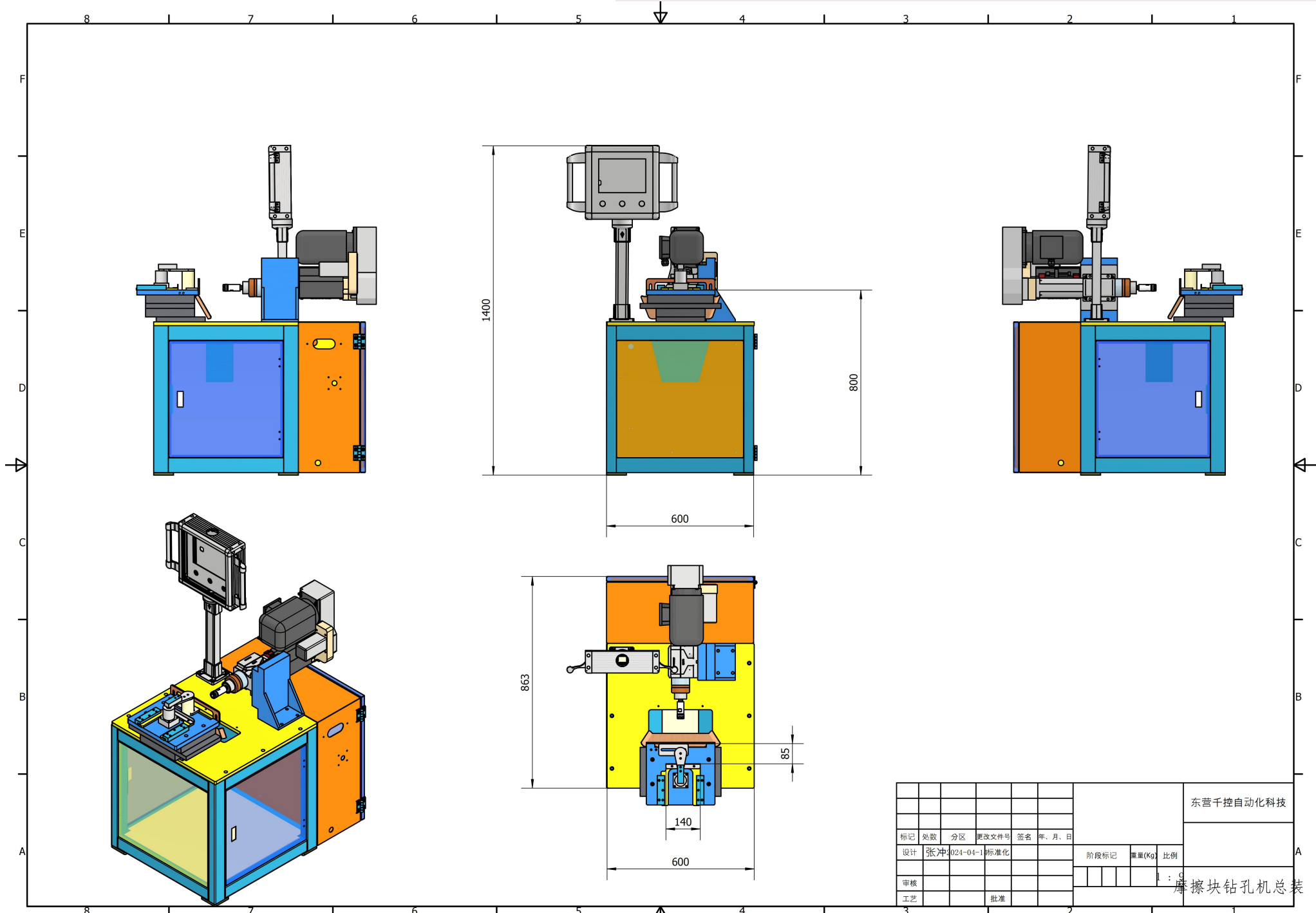


钻孔动力头
Drilling head



高度调节滑台
Height adjustment slide





					东营千控自动化科技			
标记	处数	分区	更改文件号	签名	年、月、日	阶段标记	重量(Kg)	比例
设计	张冲	024-04-1	标准化					
审核								
工艺								
					摩擦块钻孔机总装			



2024

Thank
you