

# 拉丝模高精密线抛光机 规矩成方圆

产品名称	拉丝模高精密线抛光机 规矩成方圆
公司名称	张家港市金方圆机电仪器厂
价格	.00/个
规格参数	型号:XP-2A 品牌:规矩成方圆 电源电压:220V
公司地址	中国 江苏 张家港市 张家港市塘桥花园工业园
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## 产品详情

型号	XP-2A	品牌	规矩成方圆
电源电压	220V	抛光轮直径	25 ( mm )

xp-2a双头高速精密线抛光机

xp-2a dual heads high speedprecise wire polishing machine

一、概述该机为我公司引进西德修制模技术生产的，为抛光天然钻石拉丝模和聚晶拉丝模的各个区域和控制最终尺寸而精心设计的，该机具有二组独立而完整的工作装置。主要特点有：1、能同时抛光拉丝模的入口、定径、出口等各个区域，该机设计了模座角度0-20度可任意设定，同时又可以按设定的角度自动摆动，达到了节省时间，提高效益的目的。2、为了达到加工微丝模的要求（最小加工孔径为0.015mm的模具），该机又设计了可无级调速、长行程匀速的冲程线架和可无级调速的模座，具备了修造微丝模的基本条件。3、确保加工模具孔形的真圆度，该机又设计了稳定、高精度自定心的模座，从而提高模具的品质。4、降低劳动强度，提高效率，采用高精度的时间电路，数字设定，数字显示，直观方便。5、更好适应微丝模的修造，采用坚固稳重的机架，进一步提高设备在工作状态下的稳定性。

a.introduction

the machine is produced in our company by introducing west germany mould repaired technology and well-designed for polishing natural diamond wire drawing dies and polycrystal drawing dies and controlling the ultimate dimension. it has two independent and complete devices. main specification is as follows:

1) simultaneously polish wire drawing dies entrance, diameter, exit and other areas, the mold base angle can be arbitrarily set within 0-20 degree, moreover, it can swing automatically according to the angle setting up, achieving the results of saving time and improving efficiency.

2) in order to achieve processing minor dies requirements (dies minimum processing hole diameter is 0.015mm), the machine has also been designed stepless speed regulation, the long route of uniform speed line-stroke shelf and stepless speed regulation mould base, equipped with the basic conditions for minor dies.

3) to ensure the degree of processing die's hole circle, it is also designed into a stable, high accurate self-centering mold base, thereby improving the dies quality.

4) reduce labor intensity and improve efficiency, and it is visual and convenient with high-precision timing circuits, digital set and figures show,.

5) easier to adapt to the minor dies produced and repaired, and by using the steady and firm stand, the equipment stability under work improves.

二、主要技术参数电源：220v 50hz

550w加工孔径范围：0.015~3.00mm模壳最大直径：小于30mm模座摇摆角度：0-20度模座转速：

0-1400转/分（无级）冲程速度：0-300次/分（无级）冲程幅度：80mm定时时间：1秒~99分99秒

b.main technical parameters

power source:220v 50hz 550w

processing hole diameter: 0.015~3.00mm

dies shell maximum diameter: smaller than30mm

mould base swing angle:0-20 degree

mould base rotating speed: 0-1400 revolution/minute (stepless)

stroke speed:0-300 times/ minute (stepless)

stroke range:80mm

regular time: 1s~99m99s

三、工作原理及主要部件功能

1、工作原理通过穿入模孔内的金属丝（上面涂有抛光磨料）的上下往复运动和模盘带动模具旋转来达到抛光模腔的目的。2、主要部件功能。（1）模盘用于固定模具和对模具的自动定中心，模盘带动模具作旋转运动，通过控制板上的旋转调节旋钮调速。（2）夹丝钳抛光线由上下夹丝钳夹紧，抛光线可通过上夹丝钳的丝杆螺母副来调节张紧，改变夹片的厚度可以夹紧不同直径的抛光线。

c.the principle and main components function

1)working principle

through metal wire (coated polishing grinding compound) which is threaded into the dies hole moving up and down, back and forth and the mode disk driving mold rotation to achieve the purpose of polishing die cavity.

## 2)main components function

### a.mode disk

to be used for fixing mold and setting dies center automatically, disk drive module rotation, and by rotation regulated button on controlling board to regulate speed.

### b.wire clamp

polishing wire is gripped by the clamp up and down, and can be regulated through the up clamp screw nut. the change of the thickness of the plate can grip different diameters of the polishing wire.

四、安装1、因本机重量较重，安装必须平稳。放置该机的工作台必须牢固。2、把机器插头同220v、50hz交流电源相连接（外壳须可靠接地）。

### d.installation

1. as a result of the heavier machinery weight, the installation must be steady. it must be put on a solid platform.
2. connect the machine plug with 220v, 50hz ac power (shell must be connected to the ground).

五、操作方法开机前，先检查机器各部件是否完好，将所有开关处于关闭状态，调速旋钮旋至“0”位，即最低速度。1、打开总电源开关，调节照明灯至最佳角度，清洁模盘、模腔。2、把烂好的线穿过模孔，把模子放在模盘内，再把线穿过盖帽，然后将盖帽旋紧。3、拉出抛光线，下端固定在下夹丝钳上。调整上夹丝钳至最低位置，拉直抛光线，上端固定于上夹丝钳，调节螺母张紧抛光线。4、调整所需时间，按下时间继电器正下方的开关，这时时间继电器数字显示亮。5、先按下“旋转”开关，再调整转速调节钮，调至所需要的转速。6、加入抛光磨料后，再按下“上下”开关，旋转上下振动调节钮，调至所需上下振动速度。（每次加工后，上下振动调节钮须逆时针旋转至最小位置）。7、定时器自动切断电源表示一个加工程序的结束，重新工作只需按下“复位”开关。8、该机带电动摇摆功能，调节角度旋钮（需用力转动）至所需角度，按下“摆动”开关，此时模具就按所调节的角度自动摆动，也可关掉“摆动”开关，按指示的角度抛光。

### e.operation manual

check whether all machine parts are in good condition before the machine start. all the switches must be in a closed state, the rotation speed knob to "0", that is, the minimum speed.

- 1.open the power switch, adjust the lights to the best point of view, and clean the disk mode and cavity.
- 2.thread wire through the dies hole, put dies in the disk mode, then thread through the wire blocks, and finally tightened up blocks.
- 3.pull out polishing wire with the lower end fixed on the down wire clamp. adjust up wire clamp to the lowest position, straighten the polishing wire with the upper end fixed on the up wire clamp, and screw nut to tighten the polishing wire.
- 4.adjust the time required, press the switch under the time relay, then time relay figure show lights on.
- 5.press "spin" switch, and then adjust rotation speed adjustment knob to the needed speed.
- 6.add into the polishing grinding compound, and then press "up & down" switches, spin up & down vibration knob to the

required vibration speed. (every time after processing, up & down vibration knob should spin counter-clockwise to the smallest location).

7. cutting off power automatically by the timer means a processing procedure over, and restart only need to press "reset" switch.

8. the machine has a function of electrical swing. regulate angle switch (force required) to the needed angle, press "swing" switch, then dies swing automatically according to the regulated angle. when turn off the "swing" switch, the machine polishes according to the indicated angle.

六、维护保养保持设备清洁，特别是模盘以及其它配合和运动部位。七、设备外形尺寸450 × 740 × 860八、设备组成清单xp-2a线抛光机 1台产品说明书 1份产品检验合格证 1份f.maintenance

keep equipment clean, especially for mould disk, as well as other parts of movement.

g. machine dimension :450 × 740 × 860

h. machine package list

xp-2a line polishing machine1

products operation manual1

products test certification1