

钝化机

FINISHING MACHINE

P30-1

适用于刀具的钝化
抛光

Designed for tool edge
finishing and polishing



功能优势 Function Advantages



独特的一体式传动头

区别于易晃动的分体式结构，一体式传动头使刀具旋转更稳定，抛光完整性更好。

Unique Integrated Driving Head

Different from separate structure, which shakes easily, the integrated driving head enables a more stable tool rotation and a better polishing integrity.

快换式自动锁紧夹头连杆

Fast-changing Connector for Automatic Chuck-locking

夹头可选:

钻夹式夹头 (标配)

适用于小型刀具, 可实现简易更换装卸。

强力ER夹头 (选配)

适用于大直径刀具, 夹持稳定, 不易掉刀。

Chucks Available:

Drill Clamping Chuck (Standard)

Applied for small tools, easy changing, loading and unloading.

Hi-power ER Chuck (Optional)

Applied for tools in big diameter, stable clamping, avoid tool-dropping.



抛光功能: 表面抛光显著提高刀具寿命

对涂层刀具在涂层前进行大约5~30分钟的抛光处理, 可显著降低切削槽及刀具表面的粗糙度, 从而有效提高刀具刃口涂层的附着力, 降低崩口机率, 延长刀具使用寿命。

Polishing: Tool Surface Polishing Largely Prolong Tool Life

5~30 minutes' tool surface polishing before tool coating can significantly reduce roughness of cutting groove and tool surface, thus to effectively improve the adhesion of tool edge coating, reducing the breaking probability and prolonging tool life.

钝化功能 (倒圆处理): 刃口钝化效果高度一致

根据倒圆要求, 加工过程一般可控制在1~20分钟, 钝化程度控制在 μ 级, 刃口钝化效果保持高度一致性。

Finishing(Rounding): Tool Edge Finishing Keeps Highly Consistent

According to roundness requirement, the finishing process can generally be controlled in 1~20 minutes under the level μ , highly maintaining finishing consistency.



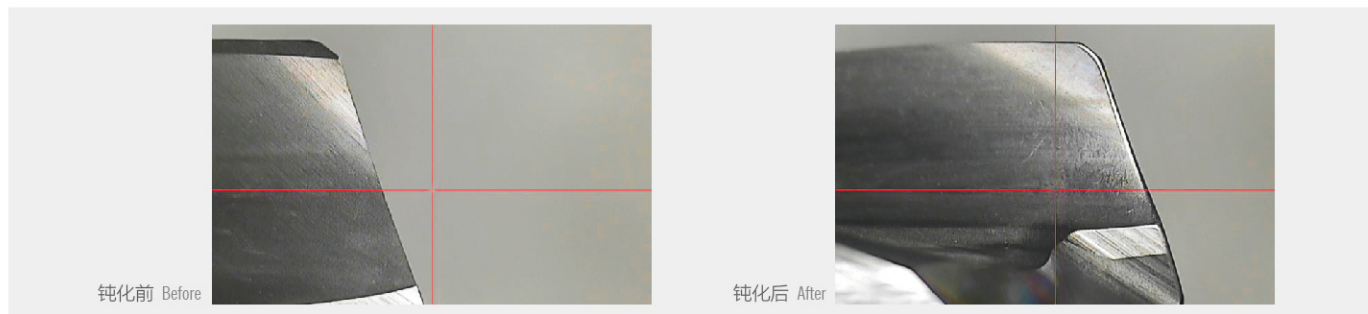
涂层后处理: 颗粒清除提高切削效率

刀具表面在物理涂层过程中会产生微颗粒, 经过大约3~5分钟的抛光处理即可将这些颗粒彻底清除 (对涂层效果无任何影响), 从而减少切削阻力, 提高切削效率。

After-coating Process: Clear Particles To Improve Cutting Efficiency

Micro-particles generate in the process of physical coating. After about 3-5 minutes polishing treatment, these particles can be completely removed (no impact on the coating result), reducing cutting resistance and improving cutting efficiency.

钝化前后对比 Comparison





砂盘设计独特:

可根据刀具长度, 钝化深度, 自动定义砂盘上下行程。

砂盘更换轻便:

只需1人即可独自轻松完成砂种更换。

Specially Designed Sand-container:

Sand-container up-down travel path can be automatically defined according to the tool length and finishing depth.

Easy-changing of Sand-container:

Sand-changing can be easily done by only one person.



程序模块化设计

一次性编程, 循环使用可自动调用;
程序集成砂种, 钝化抛光工艺。

Program Modularization Design

One-time programming, recycle operating can be automatically invoked;

Program integrated with sand type, finishing and polishing process.

磨料 Abrasive



U14

钝化砂 Finishing Sand

钝化厚度: 20-30 μm

应用: 硬质合金钻头的钝化

Finishing Thickness: 20-30 μm

Application: Carbide drill finishing



U60

钝化抛光砂 Finishing&Polishing Sand

钝化厚度: 10 μm

应用: 硬质合金铣刀的钝化与抛光

Finishing Thickness: 10 μm

Application: Carbide end-mill finishing and polishing



U120

抛光砂 Polishing Sand

钝化厚度: 1-2 μm

应用: 硬质合金刀具和金属零件的抛光

Finishing Thickness: 1-2 μm

Application: Carbide tool and metal parts polishing



U600

抛光砂 Polishing Sand

钝化厚度: 0.2-0.5 μm

应用: 金属零件及工具的抛光

Finishing Thickness: 0.2-0.5 μm

Application: Metal parts and tool polishing



核桃颗粒 Walnut Grain

钝化抛光磨料

Finishing & polishing abrasive

技术参数 Technical Data

外型尺寸: 长x宽x高	1100x1100x1930mm (含机脚)
净重	约600kg
噪声	≤80dB
供电电源	3相 380(±10%)V 2.5kW 50/60Hz
磨料桶容积	约84L
可装磨料深度	约270mm
可加工刀具最大尺寸 (自动模式下)	
最大直径	≤Φ20mm (或根据用户需要定制)
最大长度 (包括夹头长度)	≤260mm
可同时加工工件数量	直径Φ3≤d≤Φ20mm工件30件
回转机构转速	±15~55rpm 范围内无级可调
正反切换时间	约0.5秒
加工升降速度	14mm/s (不可调)

Machine Dimensions (Width X Depth X Height)	1100x1100x1930mm (Including Machine Feet)
Net Weight	Appr. 600 Kg
Noise	≤80dB
Power Supply	3 Phase 380 (+ 10%) V 2.5kw 50/60hz
Abrasive Bucket Volume	Appr. 84 L
Abrasive Depth	Appr. 270 Mm
Maximum Size Of Tools (Automatic Mode)	
Maximum Diameter	≤ φ 20 Mm (Or Customized Design)
Maximum Length (Including Chuck Length)	≤260 Mm
Synchronously Processing Tool Qty	Tool Diameter φ 3≤d≤ φ 20mm 30pcs
Rotation Speed	±15~55 Rpm, Step-less And Adjustable In This Range
Positive And Reverse Switching Time	About 0.5 Seconds
Processing Lifting Speed	14mm/s (Nonadjustable)

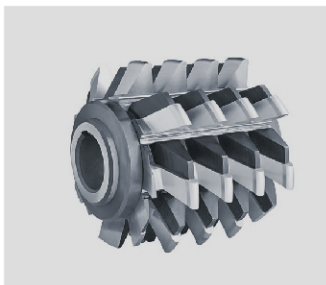
应用领域 Applications



钻头 Drill



铣刀 End-mill



滚刀 Hobe



齿轮 Gear



金属零件 Metal Parts



金属零件 Metal Parts



骨科植入件 Orthopedic Implant



骨锉 Rasper

HALLER 苏州哈勒智能装备有限公司 Suzhou Haller Intelligent Equipment Co., Ltd.

苏州市相城区富元路富阳工业坊10号厂房 215131
No.10, FuYang Industrial Park, FuYuan Road, XiangCheng District, 215131, Suzhou, China
电话(Tel): +86 (0) 512 6983 3910 传真(Fax): +86 (0) 512 6983 3906
邮箱(E-mail): info@szhaller.com 网址(Web): www.szhaller.com

