

WSK035C全自动磨面倒角一体机



设备用途与性能特征

- 本机床为单/多晶硅磨面倒角一体机，适用于太阳能行业，对切方后单晶硅或切方后多晶硅长方体硅块四个平面的研磨加工及对四条直角边的倒角、滚圆加工。一次装夹能同时完成磨面、倒角、滚圆工序。提高了硅块表面光洁度，修正了经线切割工序在硅块表面形成的显微裂纹，提高了硅块切片的成品率。
- 本机床全封闭设计，操作简单只需将工件放置于上料台，其余工序均为自动循环，提高干净卫生的操作环境，减少操作人员的劳动强度，自动化程度进一步提升。
- 机床所有电器元件均采用施耐德、SMC、费思托等国际国内知名品牌，保证机床的稳定性。
- 机床配备上料横向进料机构、上料工件横向夹紧定位机构及自动对中机构，实现自动送料，使工件处于机床中心位置，保证两平面的磨削量均匀一致，材料损耗最少。
- 机床配备工件夹紧机构及回转机构，装夹工件自动化，实现一次装夹，完成所有磨面及倒角、滚圆加工。提高工作效率，夹紧质量也得到保证。
- 机床配备自动测量系统，可以准确测量出工件磨削前后的尺寸大小，以便于均匀的分配磨削余量。

Application and Features

- This machine used for monocrystalline/ polysilicon grinding and chamfering, is applied in PV industry. It mainly grind four surfaces of monocrystalline or polysilicon ingots, and also chamfer and roll four angle edges. In one clamping, grinding, chamfering, rolling process can be finished synchronously, which can increase surface smoothness and revise microcrack in cutting process, and finally increase rate of finished products.
- This machine applies fully-closed design. Easy to operate, put the workpiece on the feeding table, other process can automatically circulate, which can improve the operating environment, decrease the labor intensity, and further promote automation.
- All electrical components apply international and domestic outstanding brands such as Schneider, SMC, Faito, ensuring a stable running.
- This machine equipped transverse feeding unit, feeding transverse clamping unit and automatic centering unit. It can feed automatically, which lays workpiece at center position of machine, ensuring grinding capacity even and uniform and decreasing material loss.
- This machine equipped clamping unit and rotary unit, automatic clamp, one clamp, finish all grinding, chamfering, and rolling, which can improve work efficiency.
- This machine equipped automatic measuring system, which can accurately measure workpiece size before and after grinding, to distribute grinding allowance evenly.

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WSK035C全自动磨面倒角一体机规格参数

Specification of WSK035C CNC Grinding Chamfering Rolling Machine

加工工件参数 work piece parameter

规格 Specification	156×156、220×220mm
长度 Length	150-900mm

主要参数 main parameter

两平面的平行度 Parallelism of two plane	<0.1mm
尺寸误差量 Size tolerance	<0.1mm
粗糙度 Roughness	<Ra0.2um
金钢石砂轮尺寸 Diamond wheel size	Φ250×60×Φ38.1

配套设施 matched facility

压缩空气接口 Compressed air interface	Φ12mm, 60L/min
冷却水接口 Cooling water interface	RC1", 15L/min
环境温度 Environmental temperature	0℃-35℃

能源供给 power supply

电源连接 Power connection	220/380V, 3PH, 50HZ
负载功率 Load power	45KW

外形尺寸 outline size

机床外形尺寸 (长×宽×高) Equipment size (L*W*H)	5320×2775×2240mm
机床重量 Weight	≈11000kg

设备示意图 sketch

