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XI'AN QIYUAN MECHANICAL AND ELECTRICAL EQUIPMENT CO., LTD. 西安启源机电装备有限公司

# 铅带纵剪生产线

LEAD STRIP SLITTING LINE

## » 生产线概述

QDJX-300/60型铅带纵剪生产线，是将成卷的铅带分切成一定宽度的铅带，然后按一定的卷取张力卷绕成卷材的生产加工设备。

我公司设计的QDJX-300/60型铅带纵剪生产线，主要有以下特点：

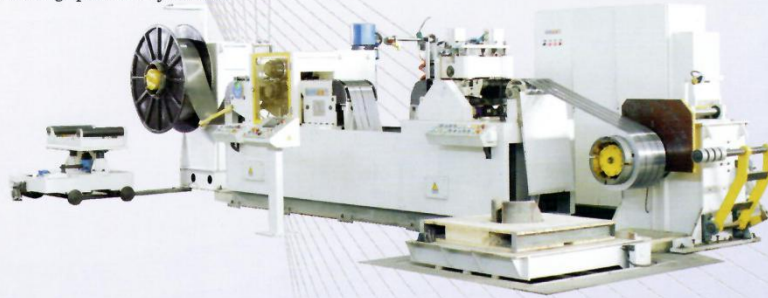
- 1、采用高精度的隔套刀实现无张力纵剪，一方面可实现无废料纵切，另一方面能有效保证带料的剪切精度。
- 2、采用多组高精度辊式张力机对各条带料分别产生张力，避免了对带材表面的损伤，又保证了各条带料收卷松紧一致。
- 3、采用了高刚性、高精度结构的收卷机，确保带材收卷质量。
- 4、全线布局合理、操作方便、生产可靠性高。
- 5、选用进口控制器实现全线的逻辑控制，增加了系统的稳定性和可靠性，并可通过触摸屏进行人机对话。
- 6、采用进口调试器控制各主要单机的速度。一方面可实现在手动状态下开卷机、纵剪机、收卷机单动操作；开卷机、纵剪机、收卷机三机联动，剪切速度自动匹配；另一方面在自动剪切时，能实现全线速度匹配，剪切速度可调。

General Introduction

QDJY-300/60 Lead Strip Slitting Line is the production and processing equipment used to cut lead strip into a certain width and then roll the coil into a certain winding tension.

It has the following features:

1. Using high precision sleeve cutter to achieve not only tension-free slitting, but also no waste. effectively ensures the cutting accuracy.
2. A number of high-precision roller type tensioners are adopted to generate tension for each material strip, to avoid surface damage to the strip, and ensure equal rewinding tightness for each strip.
3. High rigidity, high-precision rewinding machine is adopted to ensure the rewinding quality.
4. Reasonable layout, easy operation and high production reliability.
5. Imported controller is applied to achieve full -line logic control, increasing stability and reliability of the system, and enabling man-machine conversation by touch screen.
6. Imported debugger controls the speed of the main motors. On the one hand, in manual mode, unwinding machine, slitting machine, rewinding machine can function separately or jointly, the slitting speed automatically adjusted; On the other hand, in automatic mode, full-line speed matching can be achieved, and slitting speed is adjustable.



## » 主要技术参数

一、生产线使用的卷料要求 (注: 以下参数可根据用户要求进行调整)

Coil material requirements for production line ( Note: The following parameters can be adjusted by the customer )

1. 材质: 铅酸蓄电池铅带 Material: lead-acid battery lead belt
2. 带料厚度: 0.7~0.9mm Coil material thickness:
3. 带料宽度: 320 mm Coil material width:
4. 卷料外径:  $\leq \Phi 1200\text{mm}$  Outer diameter of coil material
5. 卷料卷筒内径:  $\Phi 450\text{mm}$  Inner diameter of coil material cylinder
6. 卷料卷筒外径:  $\Phi 1300\text{mm}$  Outer diameter of coil material cylinder
7. 卷料及卷筒重量: 约3.5t Weight of coil material and coil material cylinder

二、生产线主要技术参数: Main parameters of production line

1. 剪切条数: 4条 (各条宽度一致) Slitting strips: 4 (width of 4 strips should be the same.)
2. 收卷成品内径:  $\Phi 450\text{mm}$  Inner diameter of finished coil
3. 收卷成品外径:  $\leq 1200\text{mm}$  Outer diameter of finished coil
4. 剪切宽度误差:  $\pm 0.1\text{mm}$  Tolerance of slitting width
5. 直线度:  $\leq 0.5\text{mm}/2\text{m}$  Straight ness
6. 剪切速度: 0~60m/min (可调) Slitting speed
7. 外形尺寸 (长 $\times$ 宽 $\times$ 高): 约9m $\times$ 4.3m $\times$ 2m External dimensions (L\*W\*H) about 9m\*4.3m\*2m
8. 生产线总装机功率: 约45kw Total installed power of production line about 45kW
9. 生产线用气量: 400L/min(0.6Mpa) Gas consumption of production line 400L/m (0.6Mpa)

