



SDRI
启源装备

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

蓄电池拉网极板生产线

PLATE WITH ROTARY EXPANDED GRID PRODUCTION LINE

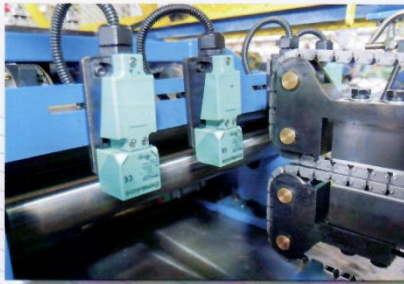
» 设备用途 Machine Function

该生产线用于蓄电池极板的自动连续化生产。

The line is used for continuous automatic production of battery plate.

» 设备特点 Machine Features

- ☆ 该生产线可完成从铅带开卷、拉网、涂膏、分切、快速烘干、堆垛等全部工艺过程；
The production line can complete the whole process from lead strip decoiling, spreading, pasting, dividing cutting, flash drying and stacking;
- ☆ 拉网机由于采用了连续旋转滚切，拉展部分采用静音链条，因此，整机运行噪音小，速度可以达到40米/分钟或500~700片/分钟，并且运行可靠，维护方便；
Because of the continuous rotary rolling cutting and the silent chain used in the stretching part, the whole machine has low noise, and the speed can reach 40 meters / minute or 500 ~ 700 pieces /minute. It is reliable and easy to maintain.
- ☆ 采用连续板栅生产工艺大大提高了生产自动化水平，整条生产线仅需4~5人（包括出垛搬运3人），降低了电池的生产成本，同时改善了板栅的均匀性；
The continuous plate grid production technology has greatly improved the automation level. The entire production line needs only 4~5 people(including 3 people for stack moving), reducing production costs of batteries, improving the evenness of the grid;
- ☆ 全过程为冷加工、无污染、无铅料损耗；
The whole process is cold processing, pollution-free, lead-free material loss;
- ☆ 整线采用PLC控制，先进可靠。
The whole production line adopts PLC control, which is advanced and reliable.





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» 生产线组成

铅带冷压对焊机
Cold welding



储存放料装置
Strip accumulator



拉网机
Rotary expander



开卷机
Strip decoiler

铅带冷压对焊机
Cold welding



储存放料装置
Strip accumulator



拉网机
Rotary expander

极耳滚切机
Tab blanker



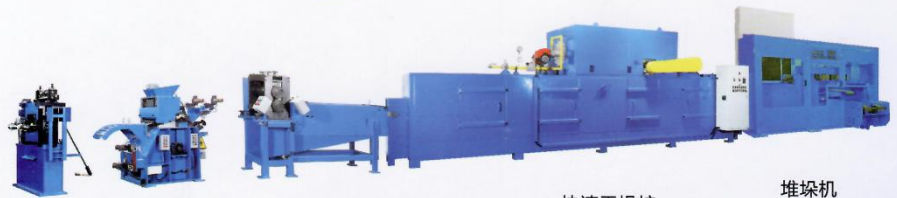
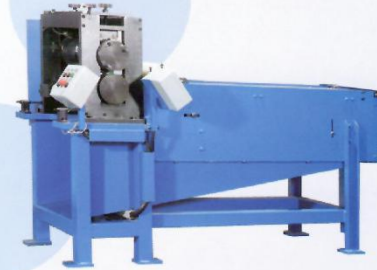
堆垛机
Stacker



涂板机
Drum paster



分切机
Rotary plate divider



极耳滚切机
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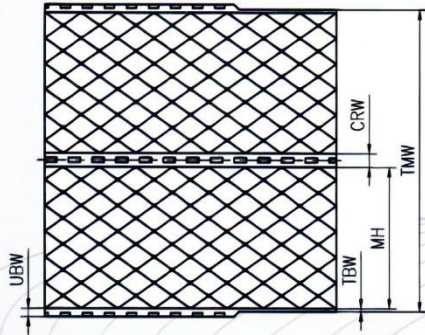
涂板机
Drum paster

分切机
Rotary plate divider

快速干燥炉
Flash drying oven

堆垛机
Plate stacker

» 网带及可成形的板栅尺寸 Mesh belt and formable grid size



尺寸 Dimension	最小值 Minimum	最大值 Maximum
中心带宽(CRW)	16 mm	/
板栅总宽(TMW)	112mm	381 mm (裁边后 After trimming)
修剪前的边框宽(UBW)	9.5 mm	/
修剪后的边框宽(TBW)	1.0 mm	/

» 技术参数 Technical parameters

- | | |
|--|---|
| 1、网孔尺寸及筋条大小由供需双方协商确定 | Mesh size and rib size shall be confirmed by the supplier and the buyer |
| 2、最大速度: 40米/分钟 | Maximum speed: 40 m / min |
| 3、装机功率: 30KW | Installed power: 30KW |
| 4、压缩空气用量 2m ³ /min (6bar) | Compressed air consumption: 2m ³ /min (6 bars) |
| 5、天然气用量 8 m ³ ~41 m ³ /h | Natural gas consumption: 8 m ³ ~41 m ³ /h |
| 6、生产线占地面积 36m×6.5m | Production line area 36m×6.5m |

