



SDRI
信源装备

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.

蓄电池扩网极板生产线

PLATE WITH EXPANDED GRID PRODUCTION LINE

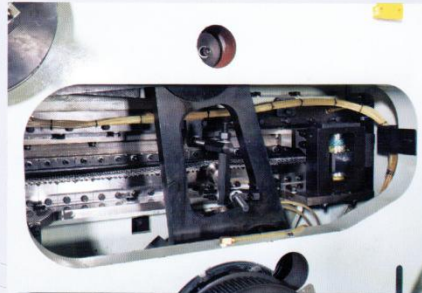
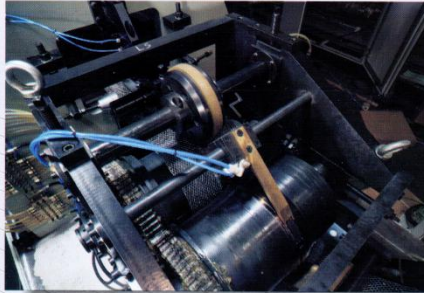
» 设备用途 Machine Function

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、扩网、涂膏到分切、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, stacking and so on.
- ☆ 扩网机采用往复双模双片宽设计，速度可达36m/min，每分钟可生产约500片板栅，生产效率很高；
The performer uses the design which is double-mode double-plate width, and its speed can be up to 28m/min, and can produce about 500 plates per minute, so production efficiency is very high.
- ☆ 同一生产线可生产正极板和负极板；
The same production line can produce positive plate and negative plate;
- ☆ 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3~4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 production. The entire production line needs only 3~4 people, 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。仅极耳冲缺有落料，减少了落料的回收成本及材料消耗；
The whole process applies cold processing, non-pollution, non-material loss. Only the polar ear punching has blanking, which reduces the material recycling cost and material consumption;
- ☆ 整线采用PLC控制，先进可靠。
The whole line adopts PLC control, advanced and reliable.





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» 生产线组成

铅带对焊机
Strip welder



储存放料装置
Strip accumulator



开卷机
Strip decoiler

铅带对焊机
Strip welder



储存放料装置
Strip accumulator



扩网机
Expander

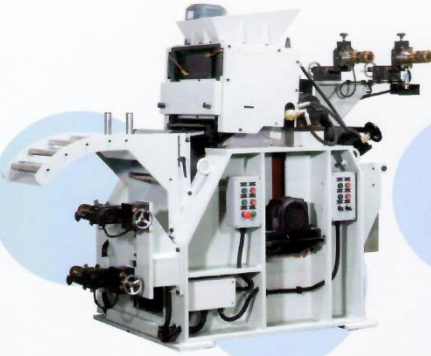
扩网机
Expander



堆垛机
Plate stacker



涂板机
Drum paster



分切机
Rotary plate divider



涂板机
Drum paster



分切机
Rotary plate divider

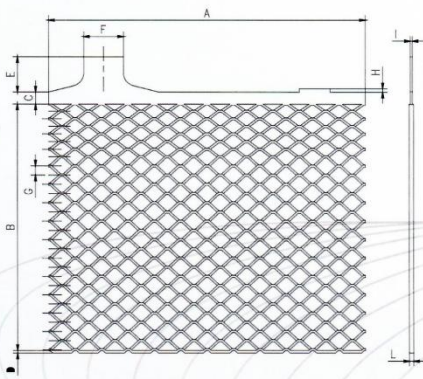


快速干燥炉
Flash drying oven

堆垛机
Plate stacker



可生产的板栅尺寸 The whole line adopts PLC control, advanced and reliable



板栅尺寸 Producible plate grid dimensions	
A	108mm~144mm
B	max134mm
C	min5mm
D	min1mm
E	min15mm
F	12mm~20mm
G	max5.5mm
H	0.25mm~0.5mm
I	0.75mm~1.2mm
L	1.0mm~1.5mm

技术参数 Technical parameters

1、最大速度 Max. Speed	28m/min
2、用电功率 Electrical power	136kw
3、压缩空气用量 Consumption of compressed air	2m ³ /min (6bar)
4、天然气用量 Natural gas consumption	8m ³ -41m ³ /h
5、生产线占地面积 Floor area of production line	35m×6.5m

