

防火板热压系统

HPL Hot Press System



防火板热压系统

—技术与工艺的完美体现!

HPL Hot Press System

—Perfect combination of art & technology



防火板热压机组(波兰项目) HPL press group Poland project

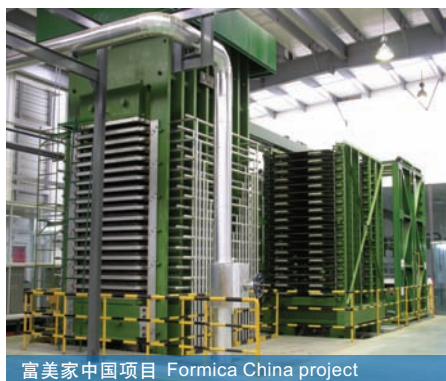
- 防火板以其美观、防火、耐用等优越的性能，被广泛应用于高档厨柜、办公家具、工业装潢、车船内装饰、展览用材等领域。
- 经过多年努力，迪芬巴赫上海板机已成功开发了多种模式的防火板热压机组，设备质量稳定，赢得了较大的国内市场，并已远销波兰、泰国等国家。
- 防火板热压系统一般由热压机、装卸板系统、配板系统、真空吸板机、液压系统、电器控制系统等组成。
- With beautiful appearance, fire-proof and durable application, HPL laminates have been widely used in many fields, e.g. kitchen utensil, office furniture, industrial decoration, inner decoration of car and vessel, exhibition material.
- With great efforts, Dieffenbacher SWPM has made rapid progress in developing different models of HPL hot press system. It occupies considerable domestic market share and has been exported to Poland, Thailand etc.
- HPL hot press system mainly consists of hot press, loading/unloading system, conveyors, vacuum suction hoister, hydraulic system, electric and automation control system etc.



防火板热压系统的生产工艺流程分： 单侧进出和前进后出两种模式

There are two standard layouts i.e. one side in-feed/out-feed system and caul plate returning system

- 单侧进出模式工艺流程为：先由真空吸板机在配板运输机上配板，并通过配板运输机、升降式进出料运输机逐层将板坯送入移动式装板料架，装板料架移动至压机前的装板工位后，由推拉板架将整车板坯一次送入压机进行热压、冷压等工艺过程。热压、冷压完毕后，成型板材在压机的同侧由推拉板架装入移动式卸板料架，并通过配板运输机、真空吸板机进行分板、配板，从而完成一个工艺流程。
- 前进后出模式工艺流程为：先由真空吸板机在配板运输机上配板，配板运输机将配制好的板坯由装板运输机送入装板机，装板机将整车板坯一次送入压机进行热压、冷压等工艺过程。热压、冷压完毕后，由卸板机同时将所有成型板从压机的另一侧内拉出，并逐层通过移动式卸板运输机、回转运输机、配板运输机、真空吸板机进行分板、配板，从而完成一个工艺流程。
- One side in-feed/out-feed system mainly consists of vacuum suction hoister, conveyors, lifting in-feed/out-feed device, movable loading/unloading device, pusher-puller, hot press etc.
- Caul plate returning system mainly consists of vacuum suction hoister, caul plate returning conveyors, loader, hot press, unloader etc.



热压机 Hot Press



- 板坯进行热压、冷压同机操作，确保高品质成品板的生产工艺要求。
- 主机加热冷却系统分别有蒸汽加热/水冷却、过热水加热/冷却两种方案可供选择。
- 压板有效幅面：4'×8'、5'×8'、5'×10'、5'×12'、7'×9'、7'×14'
- 单位面压：80-120kg/cm²
- Hot press can process both hot/cold pressing, to meet technics requirement of production for high quality finished laminates.
- Heating/cooling system: steam heating and water cooling or superheated water heating and water cooling
- Size of finished laminates: 4'×8', 5'×8', 5'×10', 5'×12', 7'×9', 7'×14'
- Specific pressure: 80-120kg/cm²



液压系统 Hydraulic System

- 压机的液压系统采用低压大流量泵组以大幅减少热压机闭合的时间，同时提高热压机的产量；采用高压大、小流量泵组节约能耗。
- 热压机机械周期包括进板、快速闭合、压力上升、压力释放、压机张开、出板。
- Low pressure and big flow hydraulic pump group is used in hydraulic system to increase the production capacity by reducing press closing time.High pressure big/small flow hydraulic pump are adopted for energy saving.
- Mechanical cycle includes mat loading, press closing, pressure building up and releasing, press opening.



电控系统

Electrics and Automation System

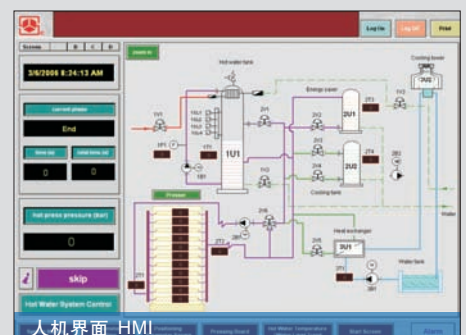


现场操控 Site operation

- 防火板热压机组的功能可通过PLC上位机控制来实现及监控管理。
- PLC控制为西门子、欧姆龙或者其他客户要求的品牌。
- 设备附近的操作台能使操作更加简便。
- HPL hot press is controlled and monitored by PLC and visualization system to fulfill its function
- PLC are from Siemens, Omron or any other brands per customer's individual requirement.
- Operating console near the equipment makes the operation more convenient and faster.



现场操作台 Operating platform

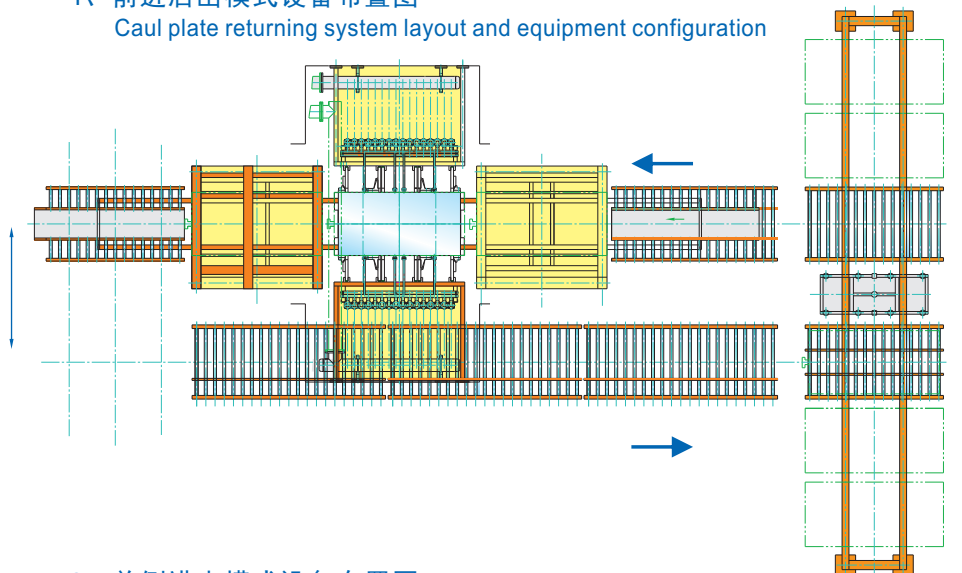


人机界面 HMI

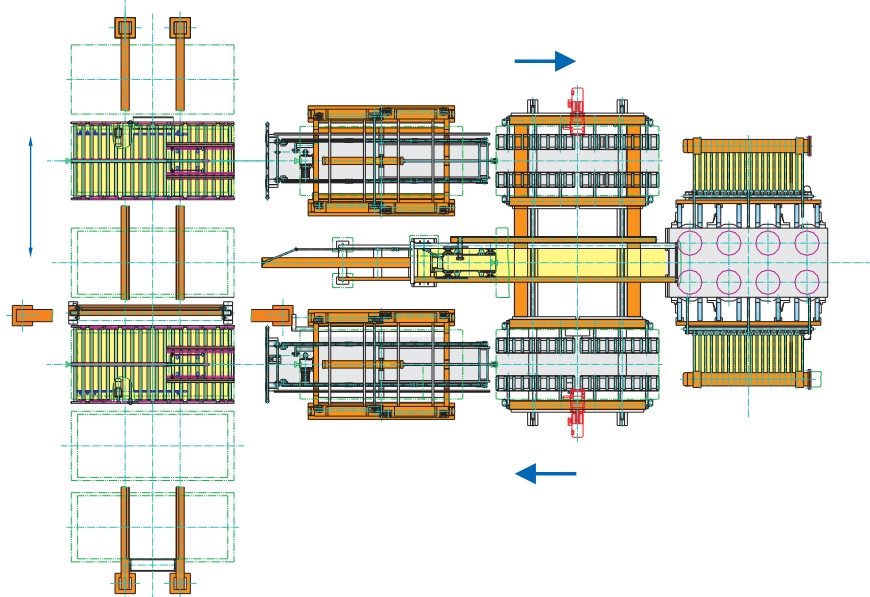
防火板热压系统设备布置图 Layout and Equipment Configuration

- 结合最新技术和客户的特殊要求，迪芬巴赫上海板机设计、制造并调试防火板热压机组。
- Dieffenbacher SWPM design, supply and commissioning HPL hot press system, with the latest technology and customer oriented solution.
- 下列设备布局仅供参考，可根据客户的特殊要求做进一步调整。
- Following layouts in general are for reference only, and will be subject to further adjustment based on customer's special request.

1、前进后出模式设备布置图
Caul plate returning system layout and equipment configuration



2、单侧进出模式设备布置图
One Side in-feed/out-feed layout and equipment configuration



DIEFFENBACHER
SWPM

迪芬巴赫集团

DIEFFENBACHER GROUP

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