

Auto Cut Laminator

Mach
630NP

Standard specification sheet

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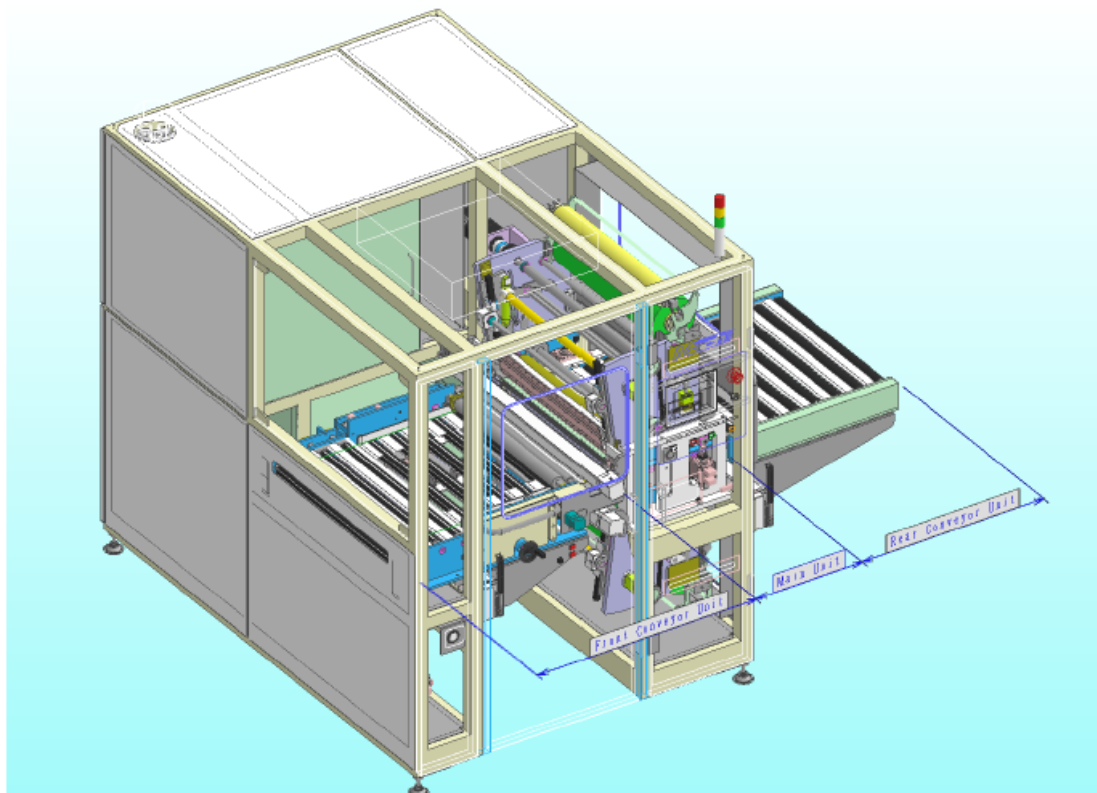


1. System Overview

This machine is auto cutting laminator system. After tacking DFR upper and lower side to the panel which came from front-end machine same time, the machine laminates by heating roll, after auto-cutting DFR by detection rear edge of panel, the machine feeds out the panel to back-end.

Basic Configuration

- (1) Front Conveyor Unit
- (2) Main Unit
- (3) Rear Conveyor Unit



2. System specification

1) Main Unit

Laminating section	<p>Laminating Roll: $\phi 50\text{mm}$ (Roll core: $\phi 47\text{mm}$) Standard specification: Silicon rubber T=1.5mm Hardness 70°</p> <p>Roll surface material: Silicon rubber, Viton, EPDM (Option)</p> <p>Roll thickness: Selectable 1.5~3.0mm</p> <p>Roll hardness: Selectable 50~80° →(Roll thickness and hardness is depended on each material.)</p> <p>Back-up Roll: $\phi 80$ Metal</p> <p>Roll pressure: Max 500kgf (Air pressure 0.5MPa) Recommend 0.3MPa</p> <p>Laminating temperature: Max 130°C</p> <p>Laminating heater: IR heater Temperature control method: PID control</p> <p>Laminating speed: 1~5.5m/min</p>
Tacking section	<p>Tacking heater: Sheath heater (K thermocouple)</p> <p>Tacking rubber: Heat conductive silicon rubber</p> <p>Tacking pressure: Max 40kgf</p> <p>Tacking temperature: Max 60°C</p>
Cutter section	<p>Cutter blade: $\phi 64$ Disc cutter (Common use with Mach630up)</p>
Dry film setting	<p>Setting by DF unit (Common use with Mach630up, only 3 inch)</p>

1) Front Conveyor Unit

Panel transfer section	Roller transfer system Material: Nitric rubber
Conveyor speed	1~5.5m/min
Panel positioning	Width direction: By centering bar Front/Rear: Control by front/rear edge detection function with photo sensor

2) Rear Conveyor Unit

Panel transfer section	Roller transfer system Material: Nitric rubber
Conveyor speed	1~5.5m/min

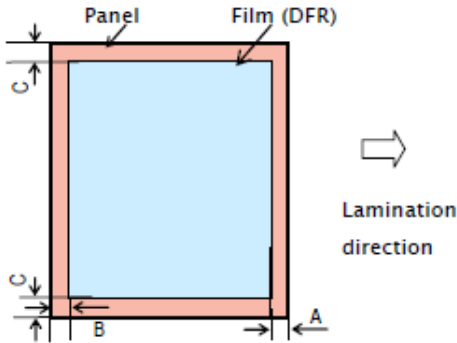
3) Panel specification

Panel size	Min : 250W × 250L Max : 640W × 640L (mm)
Thickness	0.1 ~ 4.0 mm (Core=0.04~2.0mm with Option) *Need test in advance with Option.

4) Specification of Dry-film resist

DFR Width	250~630mm
Film outside diameter	With DF unit: MAX ϕ 200mm (It is common use with Mach630up.) Without DF unit: Max ϕ 280mm
Core inside diameter	ϕ 3 inch (6 inch is option.)
Resist thickness	10~120 μ m (Actual result) *Need test in advance.

5) Tacking position accuracy

Tacking position accuracy	 <p>Front/Rear A,B : ± 0.5mm Left/Right C : ± 0.5mm</p> <p>These numbers are the mechanical accuracy which is excepted panel size gap, DFR roll accuracy and some function. This measuring used SUS gauge panel made by manufacture.</p>
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6) Productivity

510L panel	264 panel/hours Process condition: Lamination speed 3.0m/min Tacking time 3.0 sec(actual result) Panel GAP 20mm
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7) Control component

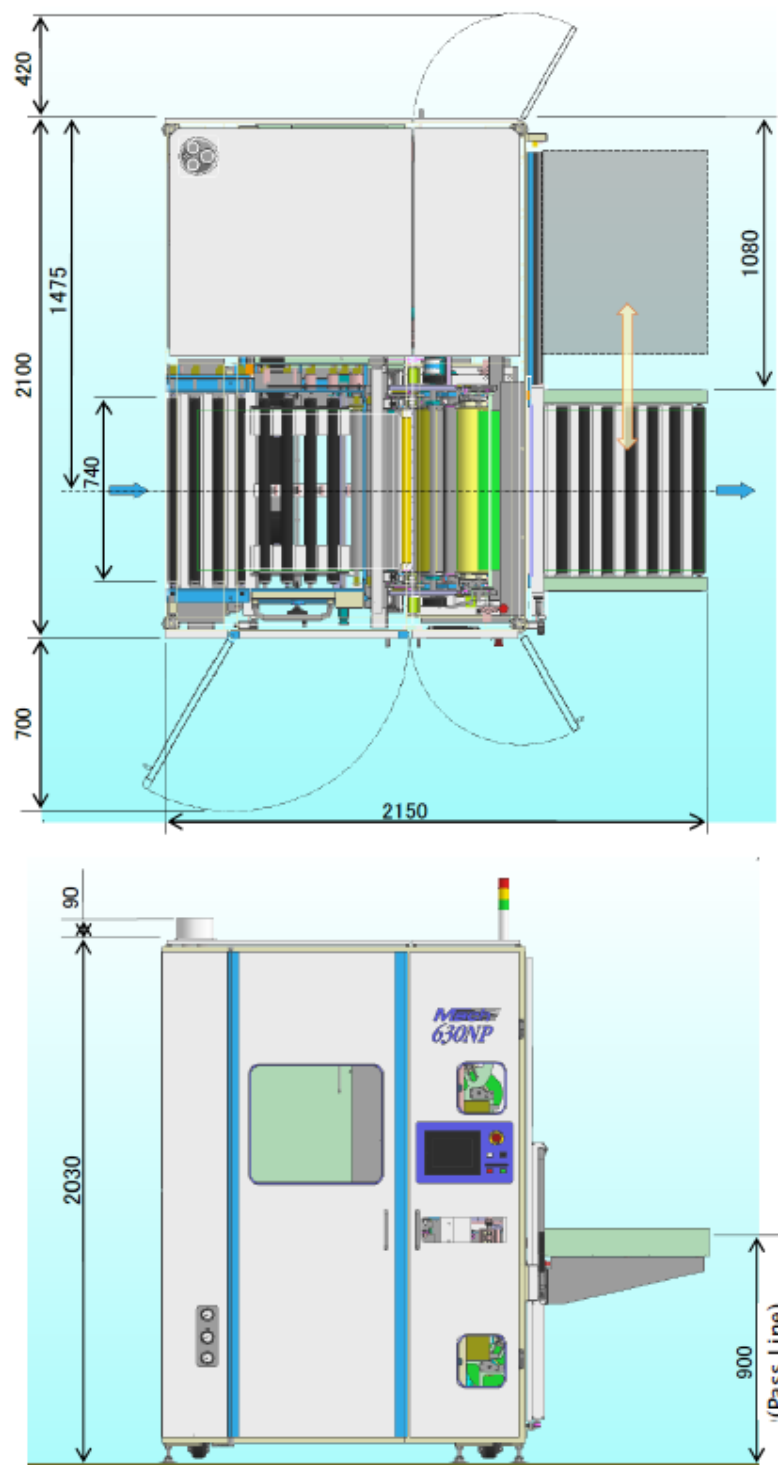
Operation switch	7.5 inch color LCD touch panel
Display language	Japanese, English, Chinese and others switch
Control equipment	Sequencer (PLC: MITSUBISHI) Signal connection with Loader/Un-Loader machine

3. Utility

Power	3 phase, 200V/220V, 50/60Hz, 10kW Use baraker of 50A
Pneumatic Supply	0.5 MPa, 100 L/min, Rc1/4
Exhaust	φ150 mm exhaust duct, 9.5 m ³ /min

4. Machine dimension

Size	W2150 X D2100 X H2120 (not including maintenance area)
Weight	Around 1.5 ton
Pass line	900mm



※These specifications are changed without a notice for improvement.