



**Metal Deburring Machine
Operation Instruction**

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Preface

Thank you for purchasing the laser cutting machine of Smith Machinery Company. We will serve you sincerely. If you are using our product for the first time, please carefully read this Guide before installation and use.

This operation instruction, working only as a using guide, helps operators to know how to operate the equipment safely and maintain it normally. Manufacture equipment will be upgraded aperiodically without prior notice and there will be changes in partial functions and pages. Consult with manufacture technical staff when any problem cannot be resolved through reading this instruction book.

The user shall read the operation instruction before installing and operating the equipment, preventing faults and personal injuries during equipment usage and repair.

Since this equipment belongs to serialized products, partial diagram forms and descriptive items in this instruction book are taken as references.

Attention

If you find the accessories do not match with the packing list when you open the box or if you have any questions about the use of the machine, please contact the cutting department of our factory by letter in time, and please indicate the product model, specification and factory number in the letter. In order to help you better understand the machine, please read the instruction manual carefully before installation and use. Please read the manual carefully before installing and using the machine. You must understand the installation, adjustment, operation and other matters in the manual. Pay special attention to safety measures and electrical installation. For the use of the process due to improper operation or unsuitable use of maintenance caused by the machine damage and personal injury by the use of their own responsibility.

2 Equipment Usage and Main Technical Parameters

2.1 Equipment Usage and Features

The deburring machine is use for the burrs from High-power laser cutting, laser air cutting, plasma, water jet cutting and punching. Depending on the shape, material and dimensions of the component, various grinding and deburring machines are used for mechanical deburring.

- 1) With the equipment body welded by high strength sectional materials, the equipment is rigid enough and has a high service life.
- 2) The large diameter of the sanding belt driven roller increases the sanding belt's service life. Therefore, the sanding belt can work stably together with accurate dynamic balance.
- 3) In addition, the sanding belt driven roller uses the rubber covered roller to ensure a good polishing effect.
- 4) The conveyor belt resistant to wear and ironing is used for feeding. With the variable-frequency variable-speed function equipped, the feeding speed can reach 15 m/min, realizing high production efficiency.

2.2. Main Equipment Configuration and Parameters

2.2-1 Models Basic Configurations

Model	Power (Kw)	Power Cable	Breaker	Air Piping (OD)	Air Pressure
SSD1300	57	$\geq 25\text{mm}^2$	250A	Ø8	0.4 ~ 0.7Mpa
SSD1000	50	$\geq 25\text{mm}^2$	250A	Ø8	0.4 ~ 0.6Mpa
SS1300	43	$\geq 16\text{mm}^2$	200A	Ø8	0.4 ~ 0.6Mpa
SS1000	36	$\geq 16\text{mm}^2$	150A	Ø8	0.4 ~ 0.6Mpa
SSS1000	51	$\geq 25\text{mm}^2$	250A	Ø8	0.4 ~ 0.6Mpa
SS630	13	$\geq 10\text{mm}^2$	100A	Ø8	0.3 ~ 0.5Mpa

2.2-2 Main equipment parameters

Processing width	0-1600 mm (according to the model)
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Processing thickness	2-50 mm
Processing length	≥ 10 mm
Sanding belt motor	5.5-30 kw (according to the model)
Sanding belt speed	1100m/min
Sanding belt dimensions	(according to the model)
Automatic feeding system motor	4 kW
Conveyor belt adjustable speed	0-7m/min
Jacking system	1.1 Kw - 2.2 KW (according to the model)
Brush roller motor	2.2kw*2
Working air pressure	0.4-0.7 MPa
Control way	Touch screen +PLC
Adjusting accuracy	0.02 mm
Weight	1500 kg - 5800 kg (according to the model)

3. Equipment Basic Components

This equipment is composed of:

- 1) Machine body: connects equipment parts such as the sanding belt drive mechanism, feed mechanism, elevator mechanism, etc.
- 2) Lifting handwheel (equipped on partial models of equipment): is used for fine tuning of material feeding workbench lifting.
- 3) Power mechanisms: provide power for operations of the sanding belt drive mechanism, feed mechanism, elevator mechanism, and the chamfering mechanism.
- 4) Lifting mechanism: The material feeding workbench supported at the top of the guide screw can be lifted and lowered based on the guide screw lifting and lowering, which is driven by the reducer through chain transmission.

- 5) The feed mechanism is composed of the conveyer belt driving roller, conveyer belt driven roller, swaging roller, and machine tool body. The 4 kW motor adjusts the speed using the reducer and the frequency changer, reaching the feeding speed of 0-7m/min.
- 6) Swaging roller: There are seven swaging rollers, which are driven feed rollers and play the role of swaging. Locations and pressing force of rollers will affect polishing quality of large workpieces. Factory parameters have been properly adjusted and do not need to be adjusted with no special necessity.
- 7) Brush roller: is used to remove burrs occurred after the sanding belt is polished.
- 8) Electrical control box: Electrical components of the machine are converged in it. Refer to the attached diagrams for the electrical schematic diagrams.
- 9) Operation panel: is used for equipment operation control and status display.

4. Equipment Installation

The customer shall check whether any part inside the equipment is loosened or falls off after disassembling the equipment. The equipment can be installed for use after it is confirmed that there is no any exception.

4.1 Equipment Levelling

Four eyes at the top of the equipment are used when the equipment is lifted. To keep balance, long wire ropes (or chains) shall be used and the wire ropes (or chains) shall be solid and reliable. Or, forklift is used for loading and unloading. Forklift operations shall be performed at the specified parking place.

If the ground is hard, the equipment can be installed on it. To ensure the equipment levelness in vertical and horizontal directions, you can place a levelling ruler on the delivery platform, place a gradienter on the levelling ruler, and then adjust the sizing block.

If the ground is soft and cannot bear the equipment weight, a cement base shall be irrigated as the foundation with preformed holes kept. Expansive cement and foundation bolts shall be placed inside the preformed holes. Install the equipment, adjust it to the proper horizontal positions in both vertical and horizontal directions, and lock the nuts of foundation bolts after cement inside the preformed holes is dried.

Note: Concrete with strength grade of C10 and above shall be used as the base material. The embedding of foundation bolts shall be completed through secondary pouring of the preformed holes. Fine aggregate concrete with higher strength grade than foundation concrete shall be used

inside the preformed holes. Expansive cement would be the best choice. Equipment foots shall be fixed at the same horizontal plane. The equipment shall not have any shake when working normally. Flammable and explosive sundries shall not be placed around the equipment and the road shall be unobstructed to prevent this equipment from inflicting with others. Items about equipment placing shall be arranged according to the actual situation.

4.2 Fixed Mount Disassembly

To prevent damage to the internal structure in the transportation process, temporary fixing parts irrelevant to the actual use inside or outside the equipment shall be removed after the equipment is fixed.

4.3 Equipment Electricity Wiring and Grounding

Ensure that the main power supply in the workshop can meet the power consumption demand. Check and make the main voltage to match the equipment working voltage. Determine the cable cross sectional area according to the equipment total power and ensure the equipment must be grounded reliably.

Determine the cable inlet, connect the cable to the equipment distribution bus, and check the motor rotation direction and feeding direction.

Note: Wiring shall be performed according to requirements on the electrical schematic diagram equipped with the equipment randomly. The equipment electrical system shall be wired and maintained by well-trained electricians.

4.4 Installation of Equipment Dust Suction System

All suction inlets and dust collect plants on the equipment are connected by the user. Ensure that all suction inlets on the equipment are firmly connected with the dust suction pipe.

Ensure the vacuum degree of 110 - 130 mm water column height at the inlet after the dust suction pipe is connected to the suction inlet.

The average airflow velocity of the dust suction device must reach 25 - 30 m/s and the air flow for dust suction shall reach 120, 000 m³/h;

Note: The dust collect plant shall be away from the heat dissipation plant and moist & HV place.

4.5 Connection Between Compressed Air and Equipment

Ensure that air supply in the workshop can meet the equipment requirement. Sufficient air supply can ensure that the equipment has the optimal using performance. Compressed air from the air source shall meet parameters required by the equipment:

----- Internal diameter of air supply pipe	$\geq \Phi 6.5 \text{ mm}$
----- Air pressure	0.3 - 0.7 Mpa
----- Air consumption	$1.48 \text{ m}^3/\text{min}$

Connect the air supply pipe with the air inlet end of the oil-water separator at the equipment bottom. Know the principles and operations of the pneumatic elements according to the pneumatic schematic diagram.

1) Oil-water separator

The oil-water separator is used to separate impurities like water content and oil content from the compressed air. Manually drain away water periodically.

2) Manual valve

This switch is installed at the beam end on the equipment operation side and used for tensioning the sanding belt.

3) Two-position five-way solenoid valve

Five two-position five-way solenoid valves are used to control the direction of the sanding belt oscillating cylinder on the sander head, actions of the pressed pneumatic cylinder, and the braking of the main motor.

4) One-way throttle valve

The one-way throttle valves are installed at both sides of the sanding belt and used for adjusting the airflow size, changing the swing frequency of the sanding belt.

5) Pressure relief valve and pressure gage

One pressure relief valve and one pressure gage are integrated on the oil-water separator, and used for adjusting the equipment's proper gas consumption. The user shall adjust the pressure relief valve to ensure the working air pressure of about 0.5 Mpa, to tension the sanding belt and stabilize the sanding belt.

5. Equipment Safety Control System

To ensure the equipment's safe working and high precision machining performance, and prevent the operator from being damaged and the workpiece, sanding belt, and conveyer belt from being damaged, this equipment is equipped with the following different and interlocked safety devices according to General Safety Rules for National Mechanical Equipment.

5.1 Equipment Emergency Braking

Both the equipment control panel and the rear closure plate are equipped with an emergency stop button. In an emergency situation, you can press the emergency stop button to brake the machine immediately.

5.2 Sanding Belt Protection

The machine shall be braked immediately if the sanding belt is off the roller due to off tracking.

5.3 Motor Protection

The motor automatic overload protection function is equipped in the control line.

5.4 Feeding Workbench Lifting Protection

If the feeding workbench lifting deviates by 0-50 mm opening range, the upper/lower limit switch will be touched. Then the feeding workbench will stop lifting immediately. If in operations, the range is exceeded with the set thickness, press the emergency stop button.

5.5 Air Pressure Protection

Models equipped with air pressure sensors will monitor the working air pressure in real time. When the air supply pressure is smaller than the set minimum pressure or higher than the maximum pressure, the equipment will alarm.

5.6 The equipment will be braked immediately when the equipment alarms due to other abnormal conditions.

Note: The braking process will last for 3-8s for different pressure values and the brake pad attrition rate.

6 Equipment Basic Operations

6.1 Precautions for Equipment Operations

- 1) Before operating the equipment with high performance and advanced technology, you must read the equipment operation instruction carefully and be clear about the operating procedures shown on the setup unit. Therefore, this equipment can be reasonably operated and maintained in various working environments.
- 2) Ensure that the equipment is effectively grounded.
- 3) Personal belongings are the caused for leading to the server injuries. Before the machine is started, articles such as watches and bracelets shall be well placed. Tighten the sleeve openings, tie the longhair, take off the tie, and do not wear slippers.
- 4) Never process any oversize or small-sized workpieces. The workpiece feed speed and processing volume shall be confirmed in accordance with specific conditions. Do not start the machine at an excessive speed or with the excessive processing volume.
- 5) Ensure that thickness of any workpiece placed in the machine is consistent with the set actual polishing thickness. Workpieces with different thickness cannot be polished together. Two or more workpieces cannot be piled for polishing.
- 6) Never use a sanding belt with scratches or cracks. Before the sanding belt is installed, ensure that each working roller's surface is smooth with no dirt and indentation and the sanding belt running direction is consistent with the direction of the sign on the back. After the sanding belt is installed, check the sanding belt actuating device and ensure that the actuating device is locked with the center bracket solidly.
- 7) Check whether each safety device is installed in place and turn off all doors.

- 8) Before any cleaning or maintenance, the machine must be stopped with the power off and a dedicated warning must be used to remind staff around.
- 9) Keep working surfaces inside the equipment and the surrounding floor clean and lubricate the machine periodically according to the lubrication requirements. The above operation is the significant premise to ensure equipment machining precision and service life prolonging.
- 10) Check the ampere meter monitoring value on the control panel at any time when the equipment works, to predict whether there is any overload phenomenon.

6.2 Equipment operation processes

- 1) Before the equipment is powered on, check whether there are any remaining workpieces inside the equipment and whether the current, voltage and air pressure are normal.

Measure the thickness of the workpiece and adjust it to the appropriate thickness of the workpiece (emphasis on trying the thickness of the workpiece first)

Pull hand pull valve tension belt, this switch is installed at the end of the beam on the control side of the equipment

Start the conveyor belt forward rotation first when you ready to put the parts on.

Start the first sand roller under downward pressure and observe whether the adjustment cylinder runs smoothly.

Normal (cylinder running time is about every 0.5-2 seconds to run back and forth) after the current is stable, then start the second sand roller, and so on.

- 5) When use the edge rounding function, please start the rotation axis first before you start running the brush rollers.

- 6) When the machine ready to work, put a workpiece to see the workpiece grinding effect. Making sure there is a good deburring effect before starting batch production. Do not put the different thickness workpieces on the conveyor table at the same time. Putting the workpiece back and forth, left and right to keep distance and do not put superimposed.

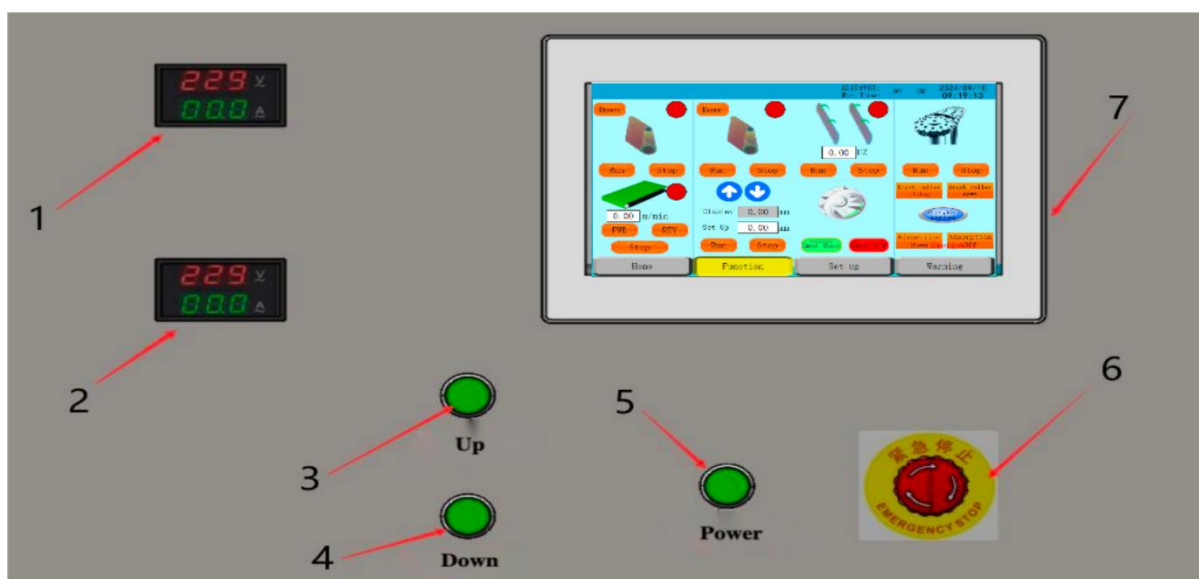
- 7) After the end of production, stop the operation in sequence (1. Stop the sand belts 2. Stop edge-rounding part 3. Stop conveyor belt) Check whether there are any remaining workpieces in the equipment after completely shutdown.

8) Clean the inside and outside of the equipment, check whether the cots, motors, bearings, cylinders, electrical appliances are loose and worn, check the comprehensive equipment maintenance.

9) Attention! When the vacuum adsorption equipment needs edge-rounding, first observe the conveyor belt corresponding to the vacuum adsorption tank on the platform, start the vacuum fan, and then operate according to the above steps

6.3 Electrical Part Operating Instructions

6.3-1 Operations on the Control Panel



No.1 Volt-Ammeter meter No.2 Volt-Ammeter meter

No.3 Conveyor table up No.4 Conveyor table down

No.5 Power switch No.6 Emergency stop

No.7 Control screen

Ampere-voltage meters 1 and 2 are used to show working current and voltage of two main motors. When the displayed current exceeds 30A, the main motor is overloaded. At this time, belt grinding or feed rate shall be reduced to reduce the main motor load.

Parts 3 and 4 are the buttons that control the workbench lifting or lowering.

Part 5 refers to the power supply switch. After the machine is connected to the power supply or the machine is stopped abnormally, press this switch and you will hear the pickup of the contactor. At this time, control circuits for operations on the touch screen are required for power supply. Then, other control operations can be performed. Otherwise, control buttons on the touch screen cannot work.

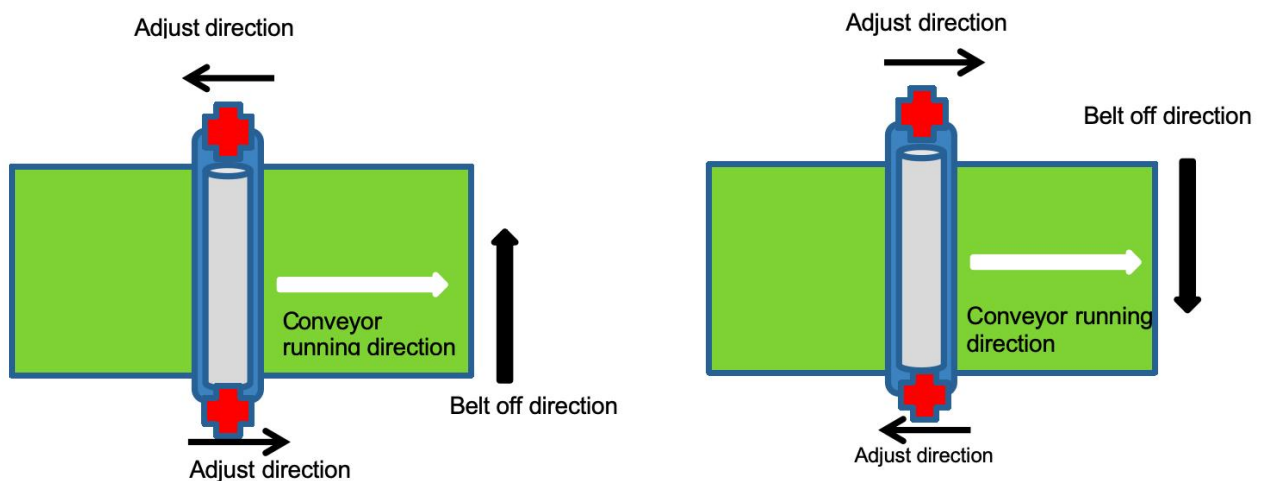
Part 6 is the control system stop button. After you press this switch, the control circuits are powered off and the main motor is braked. Note: Do not use this button in non-emergency situations. Otherwise, the machine will be damaged. This button shall return to the original position after its work is completed. If this button is not reset, the machine cannot be started.

Part 7 refers to the WECON PI-series 10.2-inch HD HMI PI3102i touch display screen. Refer to operating instructions in WECON PI-series 10.2-inch HD HMI PI3102i for operations and usage.

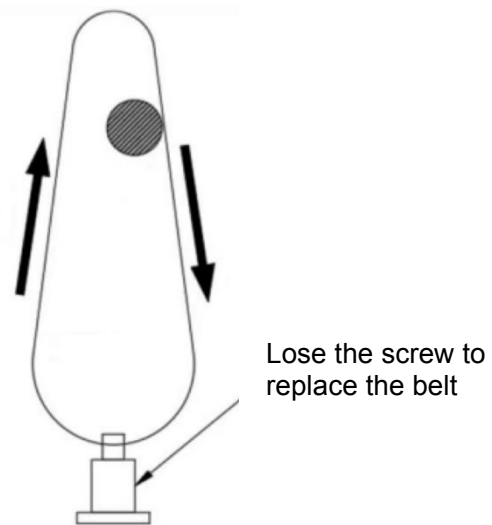
7. Equipment Adjustment

7.1 Equipment Debugging

- 1) After the equipment is powered on, start the machine, determine whether the power phase sequence is correct by manually clicking the platform lifting/lowering, and ensure that the machine running direction is correct.
- 2) Manually adjust the platform to adjust the current thickness to 30 and modify the set thickness to 20. Start and observe the platform adjustment direction and whether the final values are correct, with a deviation of less than or equal to 0.05 mm.
- 3) Start the conveyor belt and keep it running forward at a speed of 10 m/min. In normal situations, keep it in idle running for 3 minutes and observe whether the belt is off tracking. If it is, make adjustment until it can run stably. See the following figure for the adjustment method:



- 4) Start the Edge-rounding motor, and observe whether all motors work normally and whether the running directions are correct.
- 5) With normal supply, the manual valve can be used to control the loosening and tensioning of the sanding belt. Select a sanding belt with proper specification and install it according to the direction shown inside the sanding belt.



- 6) When the sanding belt is loosened, adjust the sanding belt and make it to be in the middle of the rubber covered roller. At this time, the optoelectronic switch and the limit switch shall be not triggered.
- 7) Click the sanding belt for starting and ensure that the sanding belt is correctly installed.
- 8) Click the sanding belt for starting and ensure that the sanding belt is correctly installed. Refer to the schematic diagram pasted on the equipment. Continue to adjust the handle until the sanding belt running is stable and balanced.

8 Equipment Lubrication and Maintenance

8.1 After work of each shift is completed

- 1) Clean the whole equipment to ensure that surfaces of the feeding workbench panel and sanding roller are free of dust.
- 2) Check the compressed air filter and clean coagulation in it.
 - After work of each week is completed,
- 3) Lubricate all lubricating points of the equipment according to lubrication requirements shown in the table.
- 4) Check the air filter and clean coagulation in it.

8.2 After work of each month is completed

- 1) Lubricate all lubricating points of the equipment according to lubrication requirements shown in the table.
- 2) Check the tensiety of the equipment feeding transmission and lifting transmission chains. If necessary, tighten the chains.
- 3) Check the tensiety and degree of wear of each transmission triangular belt. Tighten or replace the belt if necessary.

8.3 Pay attention to the following matters during lubrication

- 1) During lubrication, clean the nozzle with a brush and no sundries are allowed.
- 2) Proper grease shall be filled to lubricate the bearing. The filling quantity accounts for 1/3-1/2 of the space between the bearing and the housing.
- 3) Bearing lubrication shall be made when the equipment keeps still. After the lubrication, the bearing shall be manually rotated for a few minutes, balancing the grease inside the bearing. Do not start the equipment immediately at a high speed
- 4) Make selections according to different season temperature during lubrication:

No.	Name	Lubrication Time	Quantity	Lubricant
1	Feed roller bearing	3000 h	Appropriate amount	Molybdenum disulfide lubricant
2	Sanding belt bearing	1000 h	Appropriate amount	Molybdenum disulfide lubricant
3	Tensioning the roller bearing	5000 h	Appropriate amount	Molybdenum disulfide lubricant
4	Sanding belt balance-roller bearing	1000 h	Appropriate amount	Molybdenum disulfide lubricant
5	Motor	2400 h	Appropriate amount	Sodium soap grease
6	Lifting screw	400 h	Appropriate amount	Engine oil #20-40
7	Tensioning air cylinder	200 h	Appropriate amount	Engine oil #20-40
8	Feed reducer	1500 h	Replace	Middle load industrial gear oil
10	Chain, sprocket bearing	1000 h	Appropriate amount	Molybdenum disulfide lubricant

9. WECON PI-series 10.2-inch HD HMI PI3102i

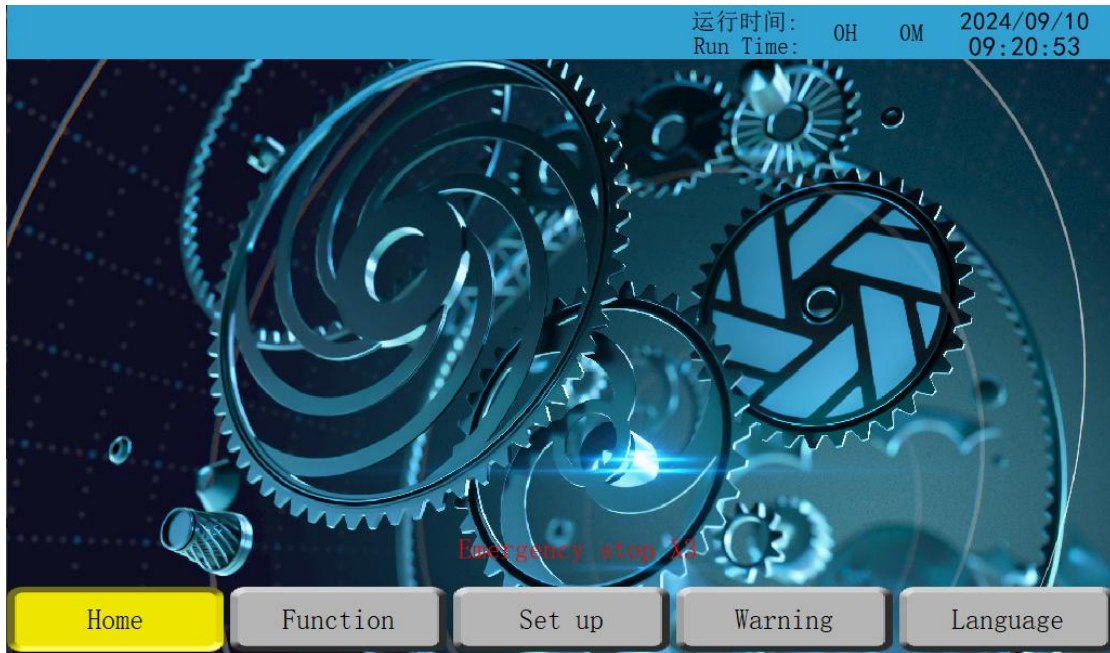
WECON PI-series 10.2-inch HD HMI PI3102i, with brown-out storage, is an intelligent displacement controller, which allows site function setting.

Characteristics: Cortex A35°1.2GHz CPU; resolution ratio: 1024*600

High speed for picture switch and update

Large map storage capacity, high software security, and stable communication

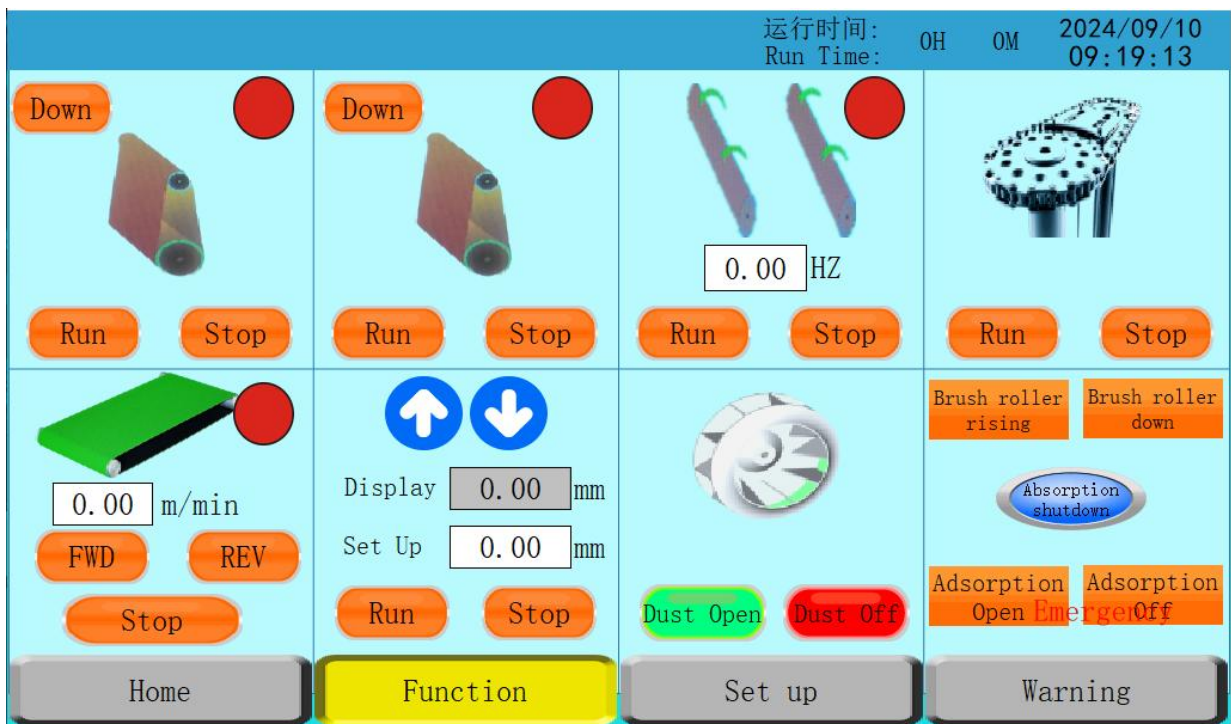
Convenient use of PIStudio software configuration



9.1 Home Screen

Home Screen is the promotional page of the company and no any operation is required on this page. Enter the Home Screen after the equipment is started.

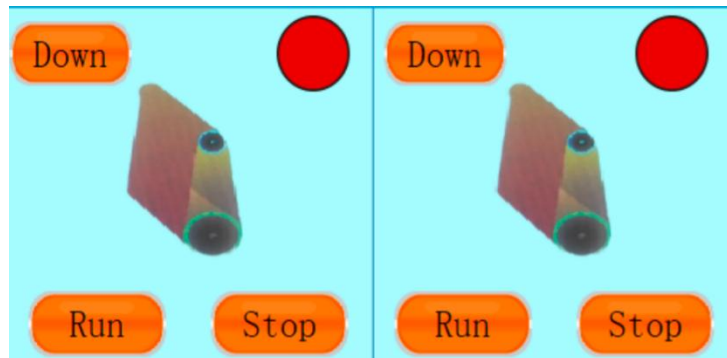
9.2. Operation Interface





On the interface, 1# sanding belt control, 2# sanding belt control, brush roller axial-direction control, and brush roller radial-direction control are shown in the first row from the left to the right.

On the interface, conveyer belt control, polishing thickness control, dust exhausting fan control, and chamfer height control are shown in the second row from the left to the right.

a. Sanding belt control part



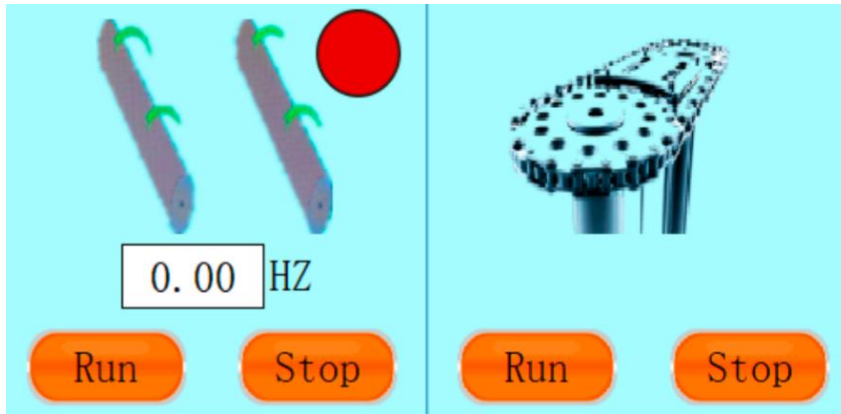
After "Run" is clicked, the motor is started and the sanding belt works.  indicator turns green and flashes.


After "Stop" is clicked, the sanding belt stops automatically and the indicator  turns red and stops flashing. (At this time, the brake does not work. Under effect of inertia, it takes a long period from the sanding belt motor stopping to the complete machine stop).


During normal work, ensure that this button "Down" is green. This function is released when the equipment is abnormally stopped and the brake is enabled. The sanding belt working space enlarges, playing the role of protection. This function is prohibited during the polishing process. This function is not necessary. Consult the manufacture to check whether this function is equipment on the machine.

The method for operating sanding belt 1# is the same as that for operating sanding belt 2#. To ensure the polishing effect, sanding belt 1# and sanding belt 2# shall be simultaneously used.

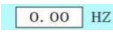
b. Edge-rounding control part



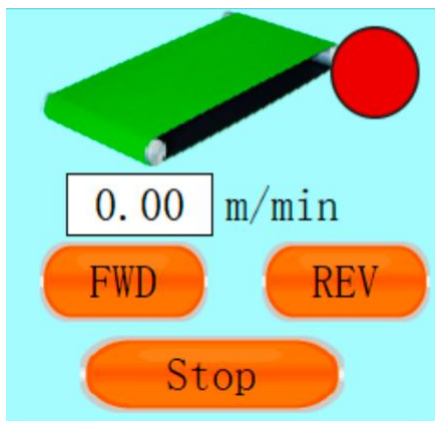
After “Run” is clicked, the chamfer motor is started and the indicator  turns green and flashes.

After “Stop” is clicked, the chamfer motor stops and the indicator  turns red and stops flashing.

Two directions shall be separately controlled and shall be turned on simultaneously when being used.

The rotating speed is adjusted by entering values to  with the unit of HZ. Refer to the national power supply frequency for the adjustment range.

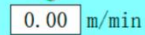
c. Conveyor belt control part



After “FWD ”is clicked, the conveyor belt drives the workpiece to move inward the machine. To ensure the normal working direction, this function is used and the button turns green.

After “REV ”is clicked, the conveyor belt moves in a direction that is reverse to the forward direction. This function is used when the equipment is debugged and in special condition. When this function is used, the button turns green.

After “Stop ” is clicked, belt running forward/backward is stopped.


Adjust the conveyor belt speed by entering values in  . Relevant values can be modified according to the polishing effect. Refer to the equipment parameter table for the value adjustment range. It cannot be set to an excessive large value.


d. Platform lifting/lowering control part



Click “Run” to automatically lift/lower the platform to the set thickness;

In the process of automatically adjust the platform lifting/lowering, click "Stop" to stop the lifting/lowering.

When the platform lifts automatically or is manually lifted, this indicator  flashes.

When the platform lowers automatically or is manually lowered, this indicator  flashes.

The current thickness is displayed on and the value cannot be modified.

Values on the Set up" can be manually modified to the required values. (This value shall be within the normal stroke range. Refer to the equipment parameter table for the specific range value.)

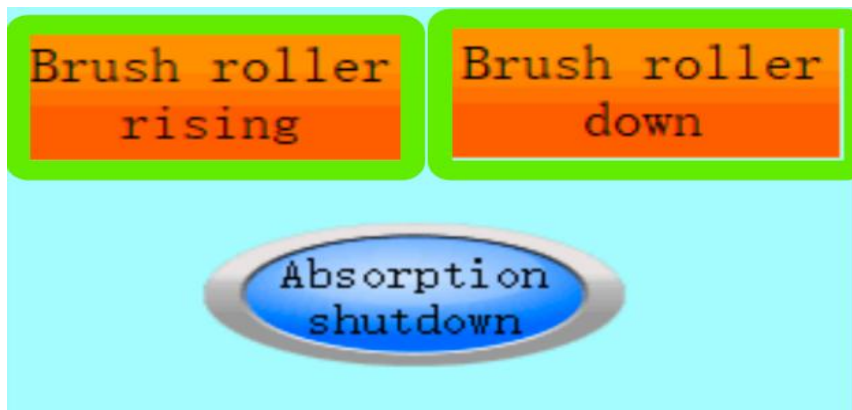
e. Fan control par



Click “Dust Open ”to start the dust exhausting fan. Click “Dust Off " to stop the dust exhausting fan.

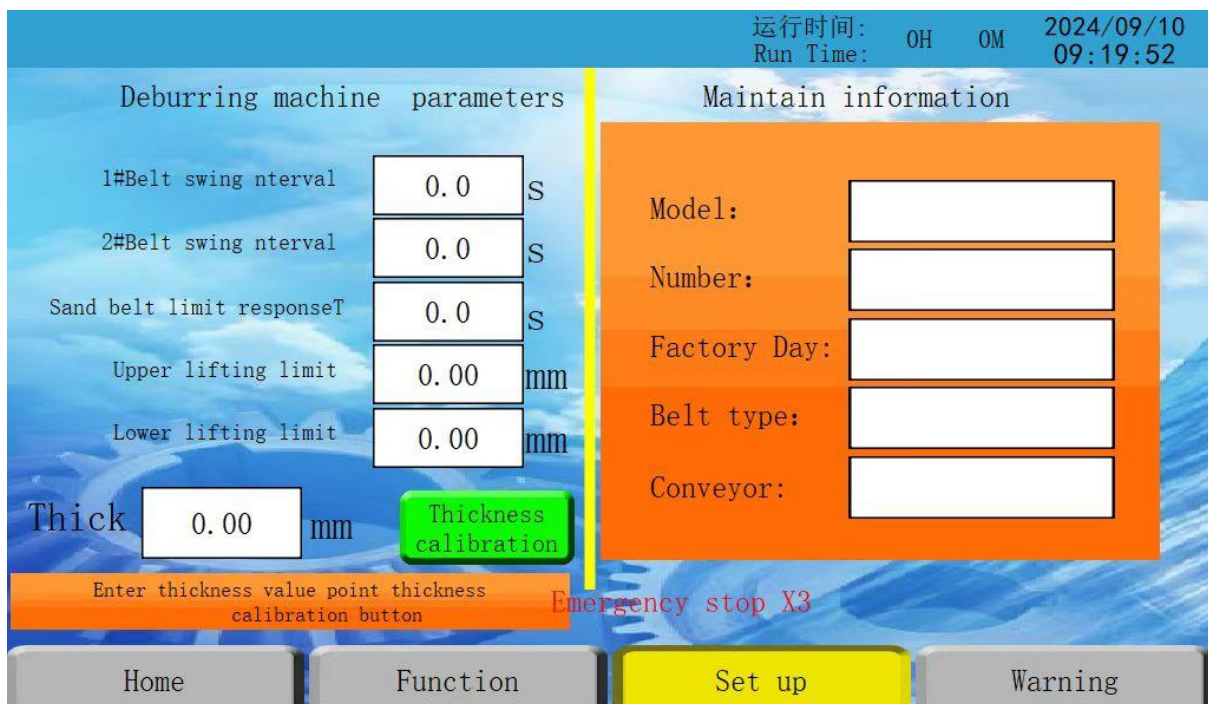
The dust exhausting fan is not a must, and the customer can configure devices according to the interfaces reserved by the manufacture. Valid dedusting is required for using the equipment.

f. Edge-rounding adjustment part



This part is manually controlled through the point contact way. Use of excess stroke is prohibited.

9.3. Parameter Interface



The displayed thickness value cannot be changed and is consistent with the current thickness on the running interface.

The set thickness value cannot be changed and is consistent with the set thickness on the running interface.

The thickness calibration value can be changed. When the displayed thickness value is inconsistent with the actual workpiece thickness, manually adjust the platform height until the best polishing effect of the workpiece is reached. Then, manually input the workpiece's actual

1A	1B	1C	1D	1E	1F	1G	1H	1I	1J	1K	1L	1M	1N	1O	1P	1Q	1R	1S	1T	1U	1V	1W	1X	1Y	1Z	2A	2B	2C	2D	2E	2F	2G	2H	2I	2J	2K	2L	2M	2N	2O	2P	2Q	2R	2S	2T	2U	2V	2W	2X	2Y	2Z	3A	3B	3C	3D	3E	3F	3G	3H	3I	3J	3K	3L	3M	3N	3O	3P	3Q	3R	3S	3T	3U	3V	3W	3X	3Y	3Z	4A	4B	4C	4D	4E	4F	4G	4H	4I	4J	4K	4L	4M	4N	4O	4P	4Q	4R	4S	4T	4U	4V	4W	4X	4Y	4Z	5A	5B	5C	5D	5E	5F	5G	5H	5I	5J	5K	5L	5M	5N	5O	5P	5Q	5R	5S	5T	5U	5V	5W	5X	5Y	5Z	6A	6B	6C	6D	6E	6F	6G	6H	6I	6J	6K	6L	6M	6N	6O	6P	6Q	6R	6S	6T	6U	6V	6W	6X	6Y	6Z	7A	7B	7C	7D	7E	7F	7G	7H	7I	7J	7K	7L	7M	7N	7O	7P	7Q	7R	7S	7T	7U	7V	7W	7X	7Y	7Z	8A	8B	8C	8D	8E	8F	8G	8H	8I	8J	8K	8L	8M	8N	8O	8P	8Q	8R	8S	8T	8U	8V	8W	8X	8Y	8Z	9A	9B	9C	9D	9E	9F	9G	9H	9I	9J	9K	9L	9M	9N	9O	9P	9Q	9R	9S	9T	9U	9V	9W	9X	9Y	9Z	10A	10B	10C	10D	10E	10F	10G	10H	10I	10J	10K	10L	10M	10N	10O	10P	10Q	10R	10S	10T	10U	10V	10W	10X	10Y	10Z	11A	11B	11C	11D	11E	11F	11G	11H	11I	11J	11K	11L	11M	11N	11O	11P	11Q	11R	11S	11T	11U	11V	11W	11X	11Y	11Z	12A	12B	12C	12D	12E	12F	12G	12H	12I	12J	12K	12L	12M	12N	12O	12P	12Q	12R	12S	12T	12U	12V	12W	12X	12Y	12Z	13A	13B	13C	13D	13E	13F	13G	13H	13I	13J	13K	13L	13M	13N	13O	13P	13Q	13R	13S	13T	13U	13V	13W	13X	13Y	13Z	14A	14B	14C	14D	14E	14F	14G	14H	14I	14J	14K	14L	14M	14N	14O	14P	14Q	14R	14S	14T	14U	14V	14W	14X	14Y	14Z	15A	15B	15C	15D	15E	15F	15G	15H	15I	15J	15K	15L	15M	15N	15O	15P	15Q	15R	15S	15T	15U	15V	15W	15X	15Y	15Z	16A	16B	16C	16D	16E	16F	16G	16H	16I	16J	16K	16L	16M	16N	16O	16P	16Q	16R	16S	16T	16U	16V	16W	16X	16Y	16Z	17A	17B	17C	17D	17E	17F	17G	17H	17I	17J	17K	17L	17M	17N	17O	17P	17Q	17R	17S	17T	17U	17V	17W	17X	17Y	17Z	18A	18B	18C	18D	18E	18F	18G	18H	18I	18J	18K	18L	18M	18N	18O	18P	18Q	18R	18S	18T	18U	18V	18W	18X	18Y	18Z	19A	19B	19C	19D	19E	19F	19G	19H	19I	19J	19K	19L	19M	19N	19O	19P	19Q	19R	19S	19T	19U	19V	19W	19X	19Y	19Z	20A	20B	20C	20D	20E	20F	20G	20H	20I	20J	20K	20L	20M	20N	20O	20P	20Q	20R	20S	20T	20U	20V	20W	20X	20Y	20Z	21A	21B	21C	21D	21E	21F	21G	21H	21I	21J	21K	21L	21M	21N	21O	21P	21Q	21R	21S	21T	21U	21V	21W	21X	21Y	21Z	22A	22B	22C	22D	22E	22F	22G	22H	22I	22J	22K	22L	22M	22N	22O	22P	22Q	22R	22S	22T	22U	22V	22W	22X	22Y	22Z	23A	23B	23C	23D	23E	23F	23G	23H	23I	23J	23K	23L	23M	23N	23O	23P	23Q	23R	23S	23T	23U	23V	23W	23X	23Y	23Z	24A	24B	24C	24D	24E	24F	24G	24H	24I	24J	24K	24L	24M	24N	24O	24P	24Q	24R	24S	24T	24U	24V	24W	24X	24Y	24Z	25A	25B	25C	25D	25E	25F	25G	25H	25I	25J	25K	25L	25M	25N	25O	25P	25Q	25R	25S	25T	25U	25V	25W	25X	25Y	25Z	26A	26B	26C	26D	26E	26F	26G	26H	26I	26J	26K	26L	26M	26N	26O	26P	26Q	26R	26S	26T	26U	26V	26W	26X	26Y	26Z	27A	27B	27C	27D	27E	27F	27G	27H	27I	27J	27K	27L	27M	27N	27O	27P	27Q	27R	27S	27T	27U	27V	27W	27X	27Y	27Z	28A	28B	28C	28D	28E	28F	28G	28H	28I	28J	28K	28L	28M	28N	28O	28P	28Q	28R	28S	28T	28U	28V	28W	28X	28Y	28Z	29A	29B	29C	29D	29E	29F	29G	29H	29I	29J	29K	29L	29M	29N	29O	29P	29Q	29R	29S	29T	29U	29V	29W	29X	29Y	29Z	30A	30B	30C	30D	30E	30F	30G	30H	30I	30J	30K	30L	30M	30N	30O	30P	30Q	30R	30S	30T	30U	30V	30W	30X	30Y	30Z	31A	31B	31C	31D	31E	31F	31G	31H	31I	31J	31K	31L	31M	31N	31O	31P	31Q	31R	31S	31T	31U	31V	31W	31X	31Y	31Z	32A	32B	32C	32D	32E	32F	32G	32H	32I	32J	32K	32L	32M	32N	32O	32P	32Q	32R	32S	32T	32U	32V	32W	32X	32Y	32Z	33A	33B	33C	33D	33E	33F	33G	33H	33I	33J	33K	33L	33M	33N	33O	33P	33Q	33R	33S	33T	33U	33V	33W	33X	33Y	33Z	34A	34B	34C	34D	34E	34F	34G	34H	34I	34J	34K	34L	34M	34N	34O	34P	34Q	34R	34S	34T	34U	34V	34W	34X	34Y	34Z	35A	35B	35C	35D	35E	35F	35G	35H	35I	35J	35K	35L	35M	35N	35O	35P	35Q	35R	35S	35T	35U	35V	35W	35X	35Y	35Z	36A	36B	36C	36D	36E	36F	36G	36H	36I	36J	36K	36L	36M	36N	36O	36P	36Q	36R	36S	36T	36U	36V	36W	36X	36Y	36Z	37A	37B	37C	37D	37E	37F	37G	37H	37I	37J	37K	37L	37M	37N	37O	37P	37Q	37R	37S	37T	37U	37V	37W	37X	37Y	37Z	38A	38B	38C	38D	38E	38F	38G	38H	38I	38J	38K	38L	38M	38N	38O	38P	38Q	38R	38S	38T	38U	38V	38W	38X	38Y	38Z	39A	39B	39C	39D	39E	39F	39G	39H	39I	39J	39K	39L	39M	39N	39O	39P	39Q	39R	39S	39T	39U	39V	39W	39X	39Y	39Z	40A	40B	40C	40D	40E	40F	40G	40H	40I	40J	40K	40L	40M	40N	40O	40P	40Q	40R	40S	40T	40U	40V	40W	40X	40Y	40Z	41A	41B	41C	41D	41E	41F	41G	41H	41I	41J	41K	41L	41M	41N	41O	41P	41Q	41R	41S	41T	41U	41V	41W	41X	41Y	41Z	42A	42B	42C	42D	42E	42F	42G	42H	42I	42J	42K	42L	42M	42N	42O	42P	42Q	42R	42S	42T	42U	42V	42W	42X	42Y	42Z	43A	43B	43C	43D	43E	43F	43G	43H	43I	43J	43K	43L	43M	43N	43O	43P	43Q	43R	43S	43T	43U	43V	43W	43X	43Y	43Z	44A	44B	44C	44D	44E	44F	44G	44H	44I	44J	44K	44L	44M	44N	44O	44P	44Q	44R	44S	44T	44U	44V	44W	44X	44Y	44Z	45A	45B	45C	45D	45E	45F	45G	45H	45I	45J	45K	45L	45M	45N	45O	45P	45Q	45R	45S	45T	45U	45V	45W	45X	45Y	45Z	46A	46B	46C	46D	46E	46F	46G	46H	46I	46J	46K	46L	46M	46N	46O	46P	46Q	46R	46S	46T	46U	46V	46W	46X	46Y	46Z	47A	47B	47C	47D	47E	47F	47G	47H	47I	47J	47K	47L	47M	47N	47O	47P	47Q	47R	47S	47T	47U	47V	47W	47X	47Y	47Z	48A	48B	48C	48D	48E	48F	48G	48H	48I	48J	48K	48L	48M	48N	48O	48P	48Q	48R	48S	48T	48U	48V	48W	48X	48Y	48Z	49A	49B	49C	49D	49E	49F	49G	49H	49I	49J	49K	49L	49M	49N	49O	49P	49Q	49R	49S	49T	49U	49V	49W	49X	49Y	49Z	50A	50B	50C	50D	50E	50F	50G	50H	50I	50J	50K	50L	50M	50N	50O	50P	50Q	50R	50S	50T	50U	50V	50W	50X	50Y	50Z	51A	51B	51C	51D	51E	51F	51G	51H	51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2	SSD1000	1000 *L	48	3800	Magnet absorption/vacuum absorption/pulse dust connection
3	SSD1300	1300 *L	55	4500	Magnet absorption/vacuum absorption/pulse dust connection
4	SSD1600	1600 *L	72	5600	Magnet absorption/vacuum absorption/pulse dust connection
5	SSS1000	1000 *L	50	3200	Magnet absorption/vacuum absorption/pulse dust connection

***L refers to the workpiece length with no dimensional limit. Table 2 - configuration**

No.	Name	Specification	Brand
1	PLC+display screen	LX3V2424MT + PI3102I -10 inch	WECON
2	Contact	NXC series	CHINT
3	Sensor	PSK1-C1C-R1/8	Autonics
4	Motor	5.5KW~30KW	Weinuo/Dingge
5	Transducer	3KW~11KW	Derris
6	Slip ring	MT3899F	MOFLON
7	Mounted bearing	207/209/210 etc.	Harbin/TR
8	Conveyor belt	PVC	HONGZHENBELT

The manufacture reserves the right to change part brands due to equipment upgrading or update without further notice.