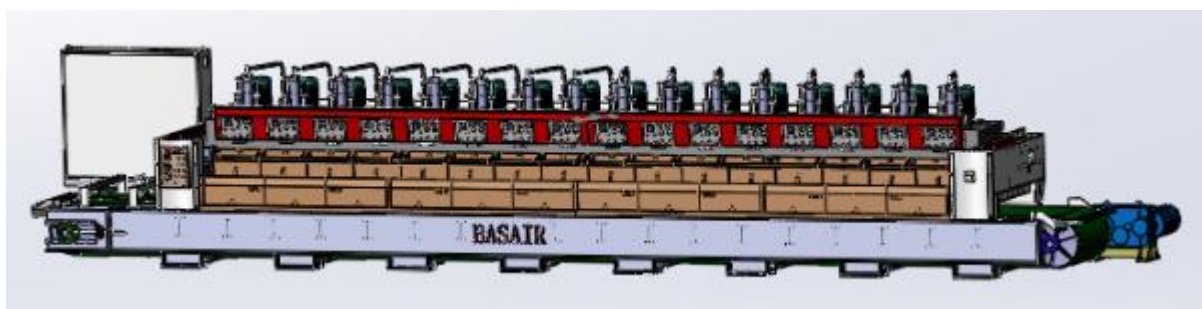




配件手册

Parts manual



——BP1000/16 抛光机

BP1000/16 polishing machine

佛山市巴赛尔机电技术有限公司

FoShan Basair Mechanical & Electrical Co.,

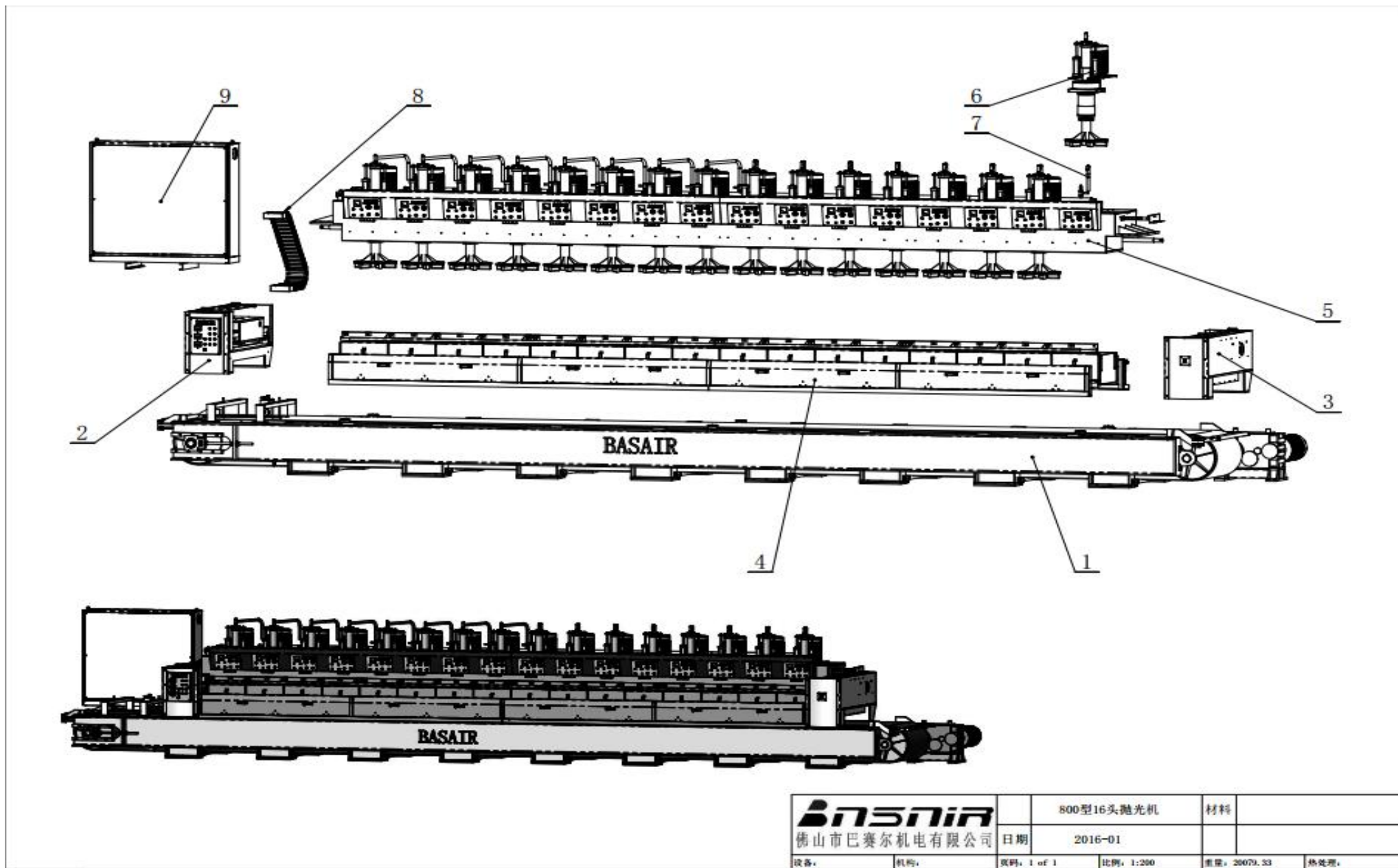


图 1 BP1000/16 抛光机 总图 picture1 BP1200/16 polishing machine general drawing

表 1 BP1000/16 抛光机各部件组成表
table1 The composition of each part of BP1000/16 polishing machine

序号 No.	名 称 Name	数量 Qty.	材料 materials	单重 Single weight	总重 Total weight	备 注 remark
1	机架组件 Rack rack assembly	1				
2	马鞍（左）组件 Saddle (left) assembly	1				
3	马鞍（右）组件 Saddle (right) assembly	1				
4	挡水门钣金组件 Stopper sheet metal assembly	1				
5	16头横梁组件 16-head beam assembly	1				
6	磨头部分组件 Part of the polishing head assembly	16				
7	胶水管 PVC hose	16	橡胶 rubber			
8	拖链组件 Drag chain assembly	1				
9	动力电柜 Power electric cabinet	1				

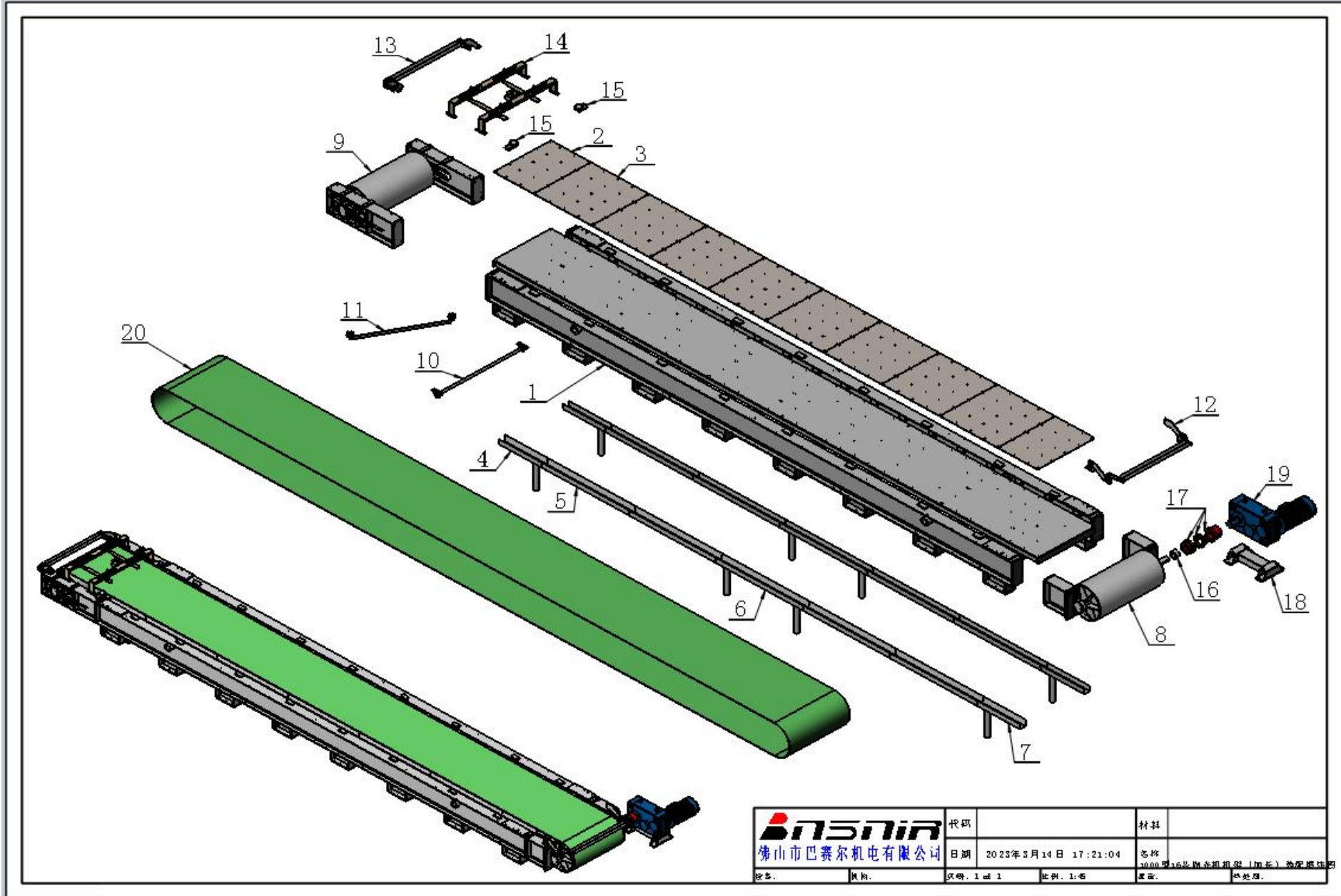


图 2 BP1000/16 抛光机——机架部分装配图 picture2 BP1000/16 polishing machine -- Rack part assembly drawing

表 2 BP1000/16 抛光机——机架部分配件明细表
table2 BP1000/16 Polishing machine -- List of parts of the frame

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	16 头 1000 机架(一体式) model 1000 16-head rack (integrated)	10800*1800*670	1	6077	6077
2	1000 抛光机耐磨底板 D model 1000 polishing machine wear resistant base plate D	1150*798*5.5	2	11.56	23.12
3	1000 抛光机耐磨底板 A model 1000 polishing machine wear resistant base plate A	1158*1150*5.5	8	16.79	134.32
4	860 下水槽 A 860 down tank A	860*610*130	2	6.33	12.66
5	1740 水槽 (底部开孔) 1740 Sink (bottom hole)	1740*130*110	8	8.64	69.12
6	1740 下水槽 (底部开孔) 1740 Lower sink (bottom hole)	1740*610*130	2	12.76	25.52
7	860 下水槽 B 860 down tank B	860*610*130	2	6.33	12.66
8	1000 主动辊筒组件 Model 1000 active roller assembly	1798*593*879	1	675.38	675.38
9	1000 被动辊筒组件 Model 1000 Passive roller assembly	1793*593*1320	1	842.12	842.12
10	皮带辊筒组件 Belt roller assembly	Φ40*1800	4	18.31	73.24
11	皮带挡砖组件 Belt block assembly	1600*80*160	1	5.73	5.73
12	过渡辊棒组件 (主动端) Transition roller assembly (active end)	1650*240*620	1	24.33	24.33
13	过渡辊棒组件 (被动端) Transition roller assembly (passive end)	1650*206*350	1	23.2	23.2
14	重砖检测组件 Heavy brick detection assembly	1500*350*900	1	54.06	54.06
15	皮带限位轮组件 Belt limit wheel assembly	204*91*120	6	3.13	18.78
16	主传动联轴器隔套 Main drive coupling sleeve	Φ130*Φ85*70	1	4	4
17	联轴器 Shaft coupling	Φ210*280	1	44.92	44.92
18	抛光机主传动机架 Polishing machine main drive frame	750*460*150	1	56.97	56.97
19	减速机 REDUCER		1		
20	1000 机 16 头抛光带 Model 1000 machine 16 polishing belt	26200*1200*9	1		

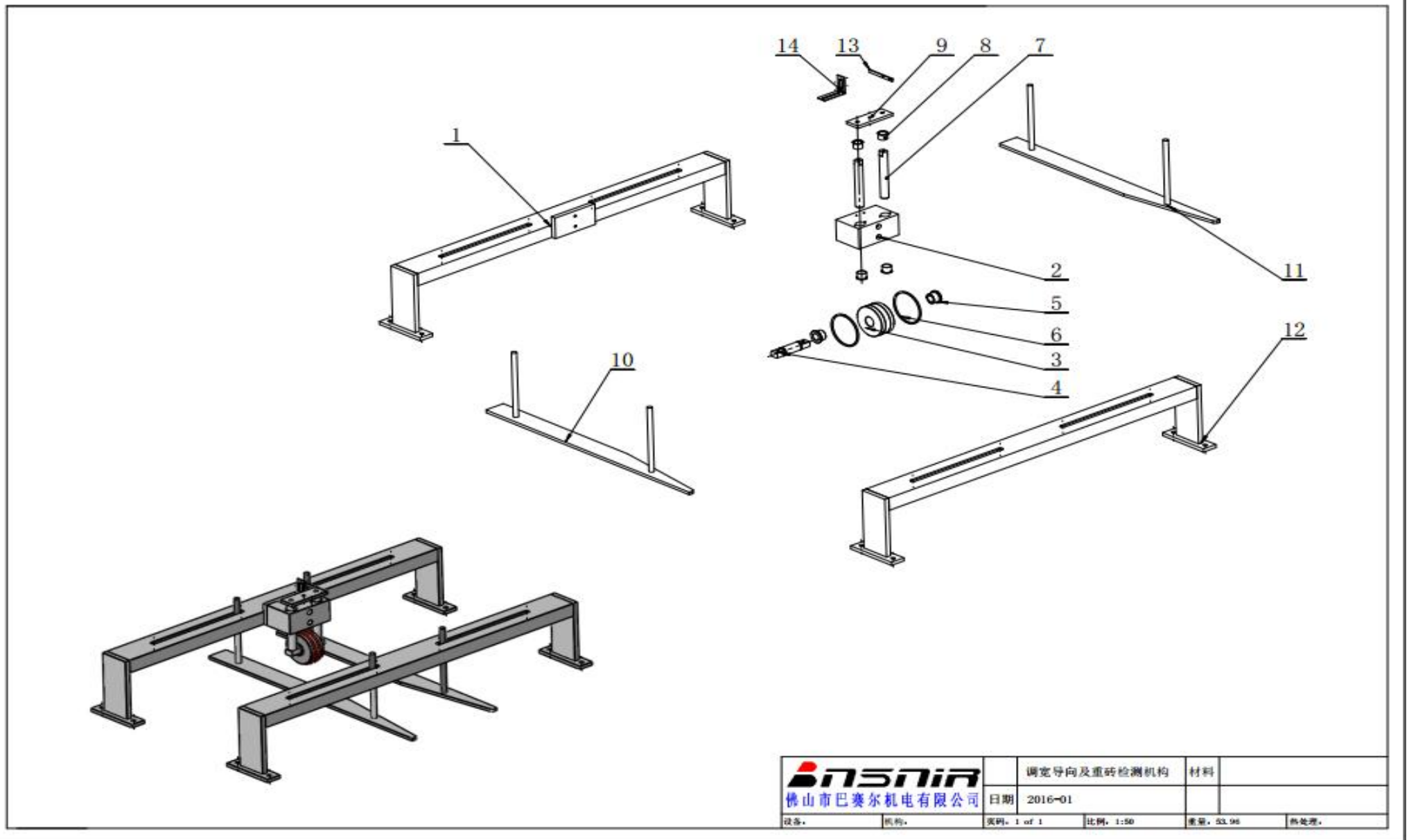


图 2—1 机架部分——调宽导向及重砖检测机构装配图 picture2-1 Rack part -- Assembly drawing of width adjustment guide and heavy brick detection mechanism

表 2—1 机架部分——调宽导向及重砖检测机构配件明细表
Table 2-1 Rack Part -- Detail List of accessories for adjusting width guide and heavy brick inspection mechanism

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	重砖检测后焊接架 Welding frame after heavy brick inspection	1500*267*156	1	20.75	20.75
2	重砖检测活块 Heavy brick test after welding frame heavy brick test live block	160*100*80	1	1.23	1.23
3	重砖检测轮 Heavy brick detection wheel	Φ110*50	1	0.48	0.48
4	重砖检测轮轴 Heavy brick check axle	Φ25*130	1	0.45	0.45
5	对中 igus 轴承 Aligning igus bearings	Φ28*Φ25*21.5	2	0.01	0.02
6	胶圈 rubber ring	Φ120*5.7	2		
7	重砖检测滑轴 Heavy brick detection sliding shaft	Φ25*180	2	0.66	1.32
8	对中 igus 轴承 Aligning igus bearings	Φ28*Φ25*21.5	4		
9	重砖检测高度调节板 Heavy brick detection height adjustment plate	140*50*10	1	0.53	0.53
10	左导向板 Left guide plate	900*70*10	1	4.24	4.24
11	右导向板 Right guide plate	900*70*10	1	4.24	4.24
12	重砖检测前焊接架 Welding frame before heavy brick inspection	1500*235*180	1	19.16	19.16
13	重砖检测感应片 Heavy brick detection sensing piece		1		
14	重砖检测电眼支架 Heavy brick was used to detect the electric eye bracket	83*63*30	1	0.08	0.08

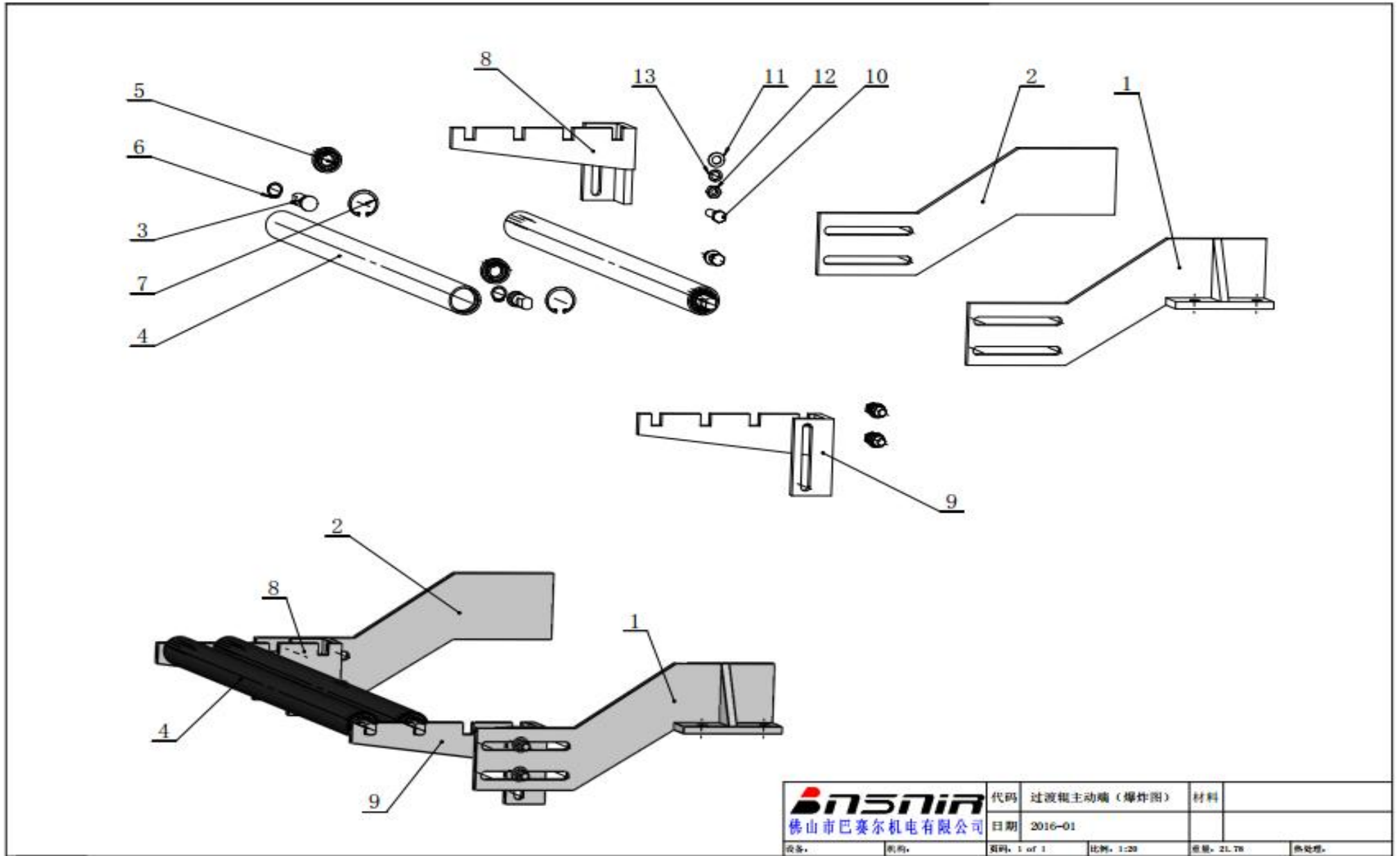


图 2—2 机架部分—过渡辊主动端装配图 picture2-2 Gantry parts-the active end assembly of the transition roll

 佛山市巴赛尔机电有限公司		代码	过渡辊主动端（爆炸图）	材料	
		日期	2016-01		
设备	名称	页码	1 of 1	比例	1:20
		重量	21.78	热处理	

表 2—2 机架部分——过渡辊主动端配件明细表

Table 2-2 Frame part - Transition roll active end accessories list

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	过渡辊支架 3 (主动右) Transition roll Support 3 (active right)	450*215*70	1	5.32	5.32
2	过渡辊支架 3 (主动左) Transition Roll Support 3 (active left)	450*215*70	1	5.32	5.32
3	过渡辊轴 Transition roll shaft	Φ25*110	4	0.26	1.04
4	过渡胶辊筒 Transition rubber roller	Φ48*1300	2	6.7	13.4
5	深沟球轴承 deep groove ball bearing	6004	4		
6	轴用卡簧 Spring for shaft	Φ20	4		
7	孔用卡簧 Hole with clip spring	Φ42	4		
8	过渡辊支架 2 (被动左) Transition roll Support 2 (passive left)	280*130*80	1	2.56	2.56
9	过渡辊支架 2 (被动右) Transition roll Support 2 (passive right)	280*130*80	1	2.56	2.56
10	外六角螺栓 outer hexagon bolt	M12X50	4		0
11	平垫圈 flat washer	Φ12	4		0
12	六角螺母 hex nut	M12	4		0
13	弹簧垫圈 spring washer	Φ12	4		0

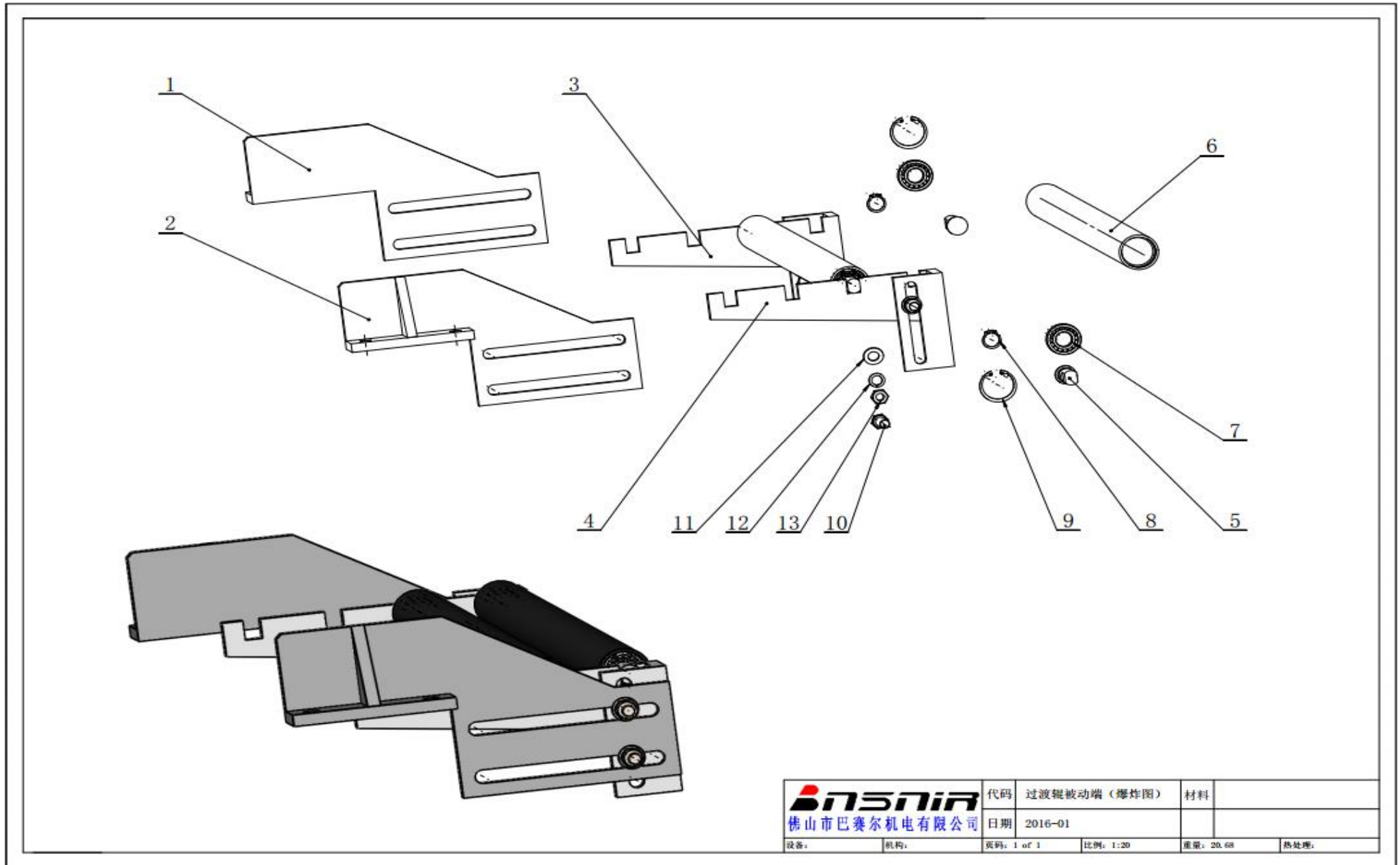


图 2—3 机架部分——过渡辊被动端装配图 picture2-3 Gantry part -- Assembly diagram of passive end of transition roll

表 2—3 机架部分——过渡辊被动端配件明细表

Table 2-3 Rack Part -- Detail of accessories for the passive end of the transition roll

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	过渡辊支架 1 (被动左) Transition Roll Support 1 (passive left)	350*189*70	1	4.32	4.32
2	过渡辊支架 1 (被动右) Transition Roll Support 1 (passive right)	350*189*70	1	4.32	4.32
3	过渡辊支架 2 (被动左) Transition roll Support 2 (passive left)	280*130*80	1	2.56	2.56
4	过渡辊支架 2 (被动右) Transition roll Support 2 (passive right)	280*130*80	1	2.56	2.56
5	过渡辊轴 Transition roll shaft	Φ25*110	4	0.26	1.04
6	过渡胶辊筒 Transition rubber roller	Φ48*1300	2	6.7	13.4
7	深沟球轴承 deep groove ball bearing	6004	4		
8	轴用卡簧 Spring for shaft	Φ20	4		
9	孔用卡簧 Hole with clip spring	Φ42	4		
10	外六角螺栓 outer hexagon bolt	M12X50	4		
11	平垫圈 flat washer	Φ12	4		
12	弹簧垫圈 spring washer	Φ12	4		
13	六角螺母 hex nut	M12	4		

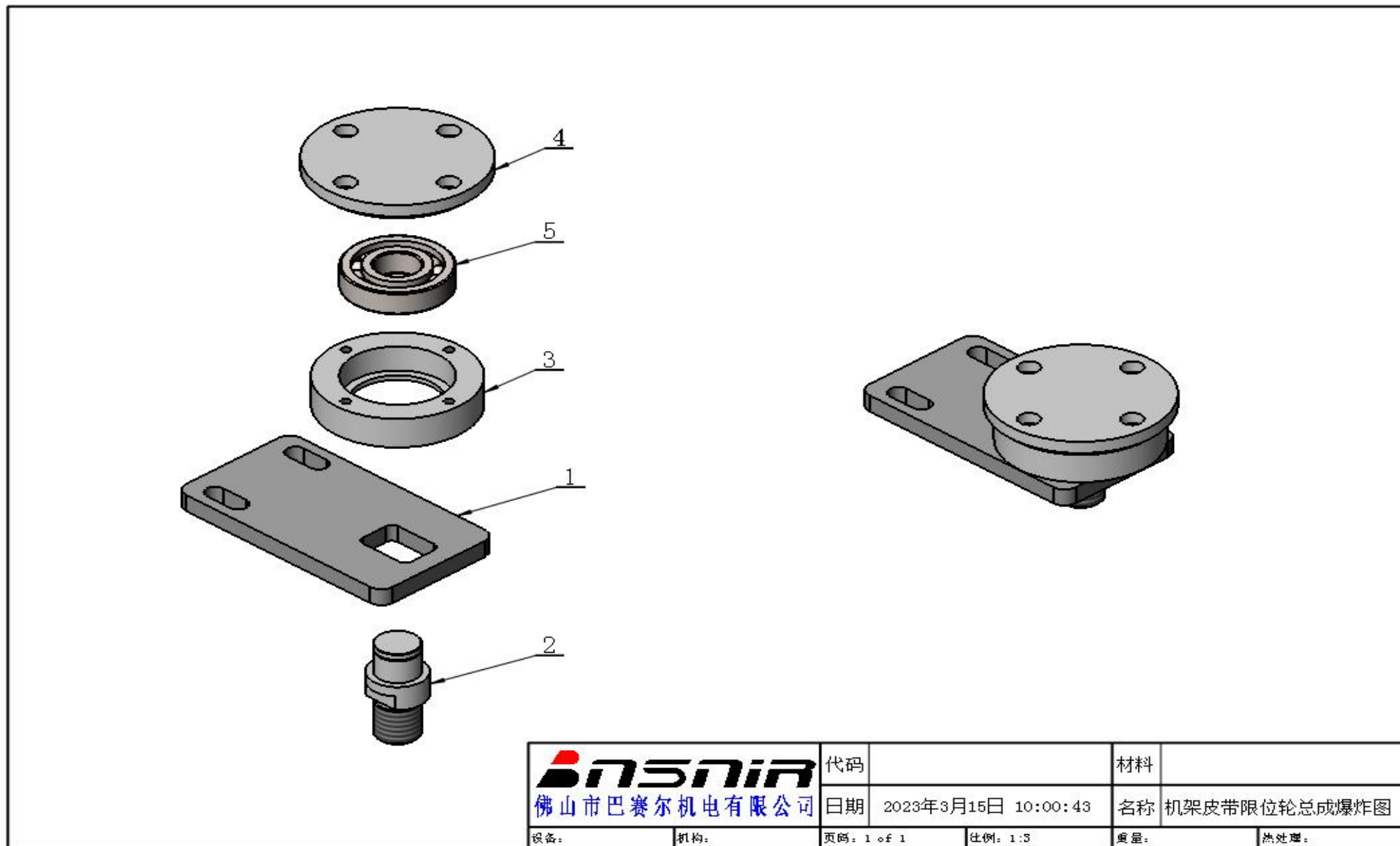
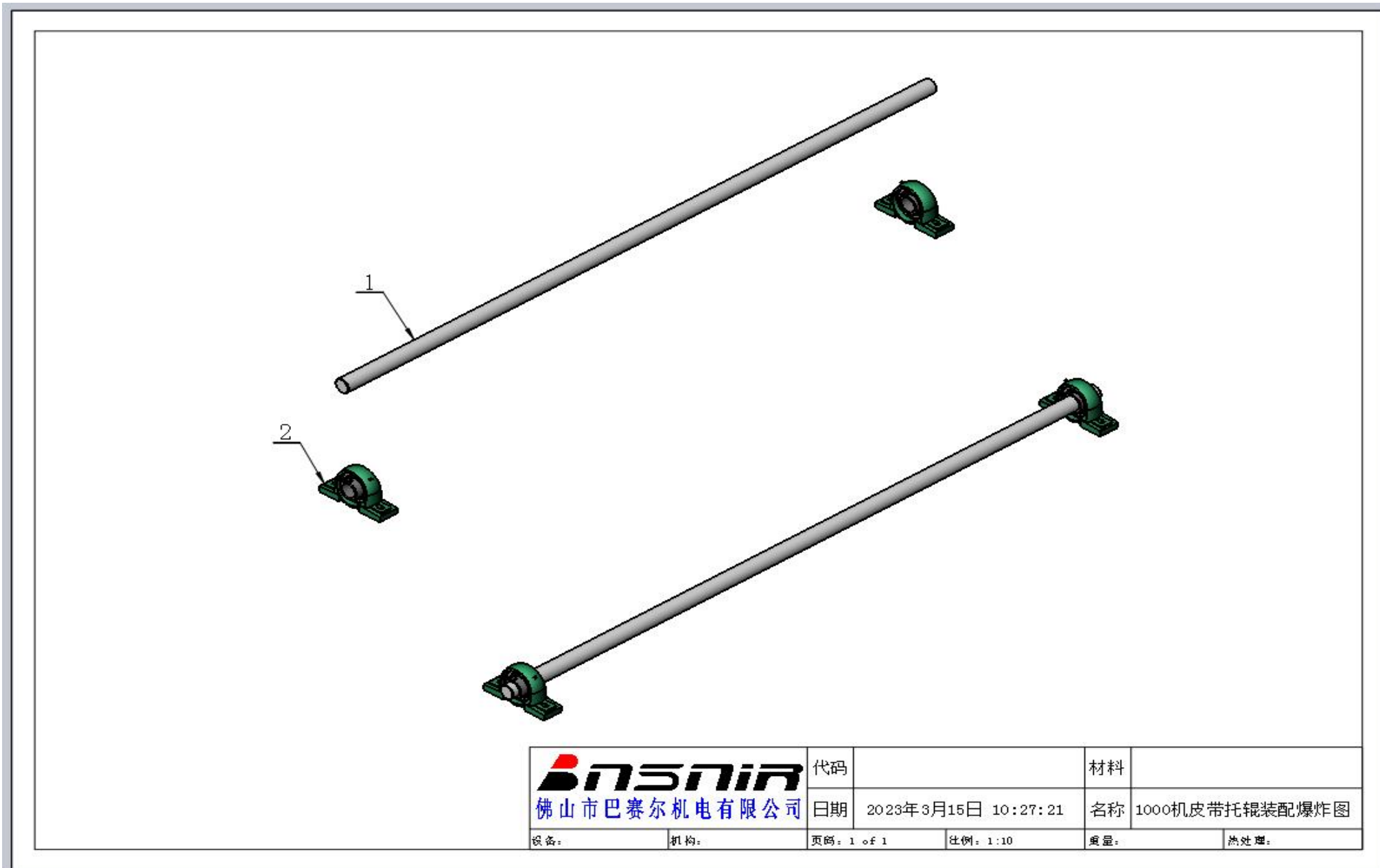


图 2—4 机架部分——皮带限位轮装配图 picture 2-4 Rack part -- Belt limit wheel assembly drawing

表 2—4 机架部分——皮带限位轮配件明细表

Table 2-4 Rack part -- Belt limit wheel accessories List

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	限位轮安装板 Limit wheel mounting plate	180*100*14	6	1.9	11.4
2	皮带限位轮轴 Belt limit axle	Φ40*80	6	0.5	3
3	皮带限位轮 Belt limit wheel	Φ107*25	6	0.98	5.88
4	皮带限位轮盖 Belt limit wheel cover	Φ120*17	6	1.12	6.72
5	深沟球轴承 deep groove ball bearing	6306	6		



	代码		材料	
	日期	2023年3月15日 10:27:21	名称	1000机皮带托辊装配爆炸图
设备:	机构:	页码: 1 of 1	比例: 1:10	重量:
				热处理:

图 2—5 机架部分——皮带托辊装配图 picture2-5 Rack part -- Belt idler assembly diagram

表 2—5 机架部分——皮带托辊配件明细表
Table 2-5 Rack part -- Belt idler accessories List

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	1000 皮带托辊 Model 1000 belt idlers	Φ40*1800	4	17.75	71
8	带立式座轴承 With vertical seat bearing	UCP208	8		

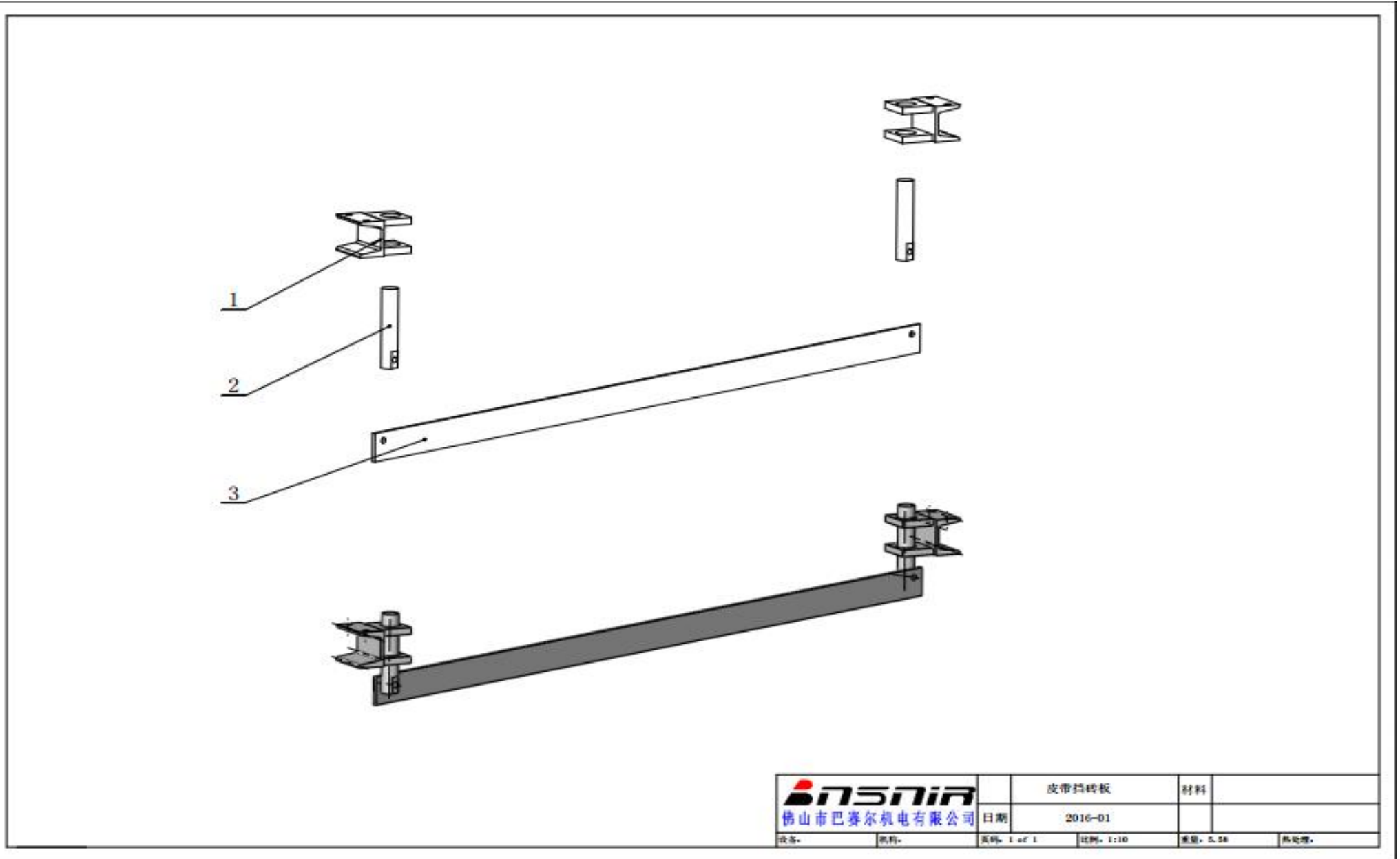


图 2—6 机架部分——皮带挡砖板装配图 picture 2-6 Rack part -- belt block board assembly drawing

表 2—6 机架部分——皮带挡砖板配件明细表
Table 2-6 Rack part -- Belt block board accessories list

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	皮带挡砖板卡套 Belt block board card sleeve	80*90*63	2	0.86	1.72
2	挡板导柱 Baffle guide post	Φ 25*140	2	0.52	1.04
3	不锈钢挡板 Stainless steel baffle	1500*50*5	1	2.97	2.97

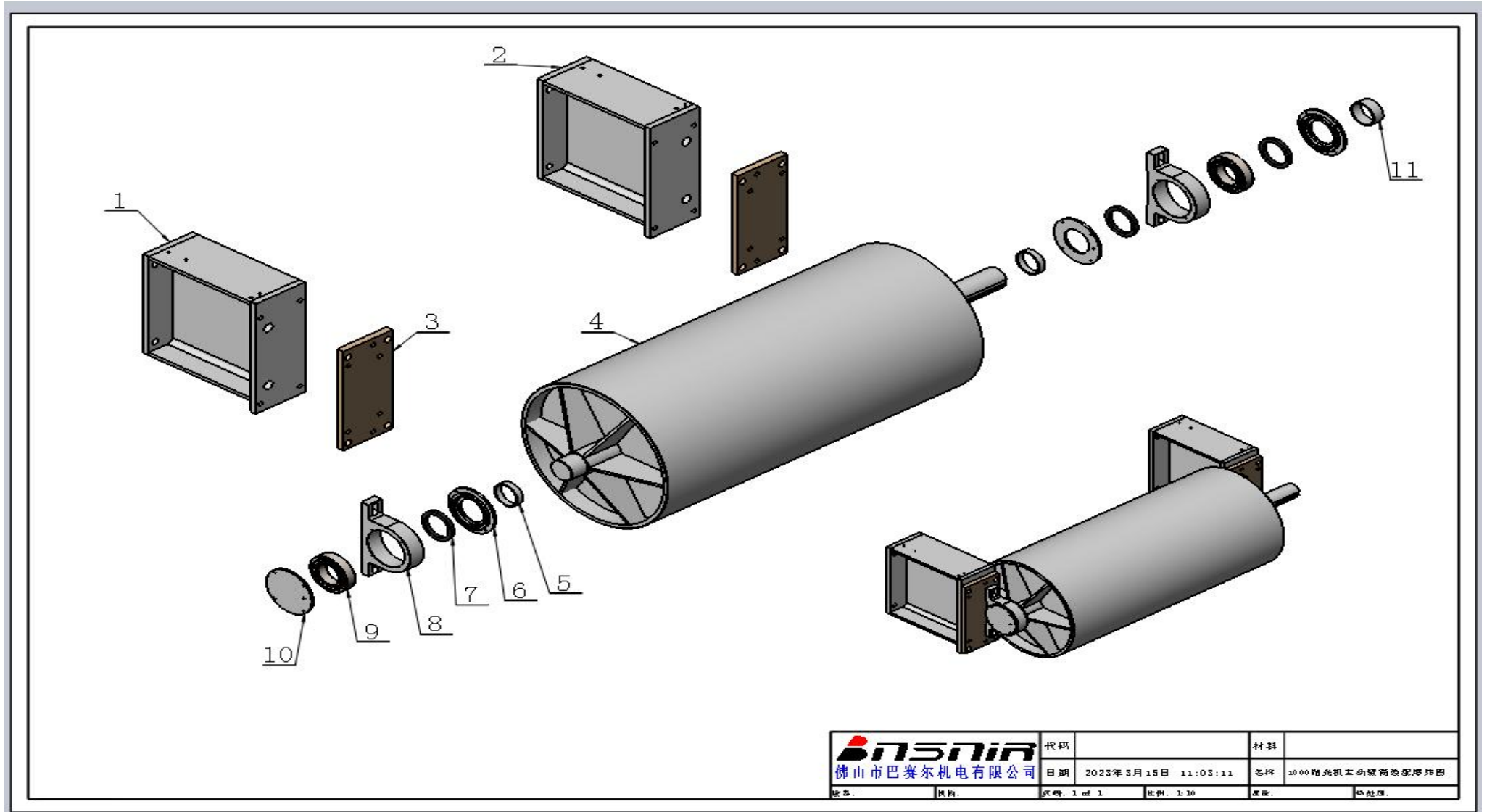


图 2—7 机架部分——主动辊筒组件装配图 picture2-7 Gantry Part -- Assembly drawing of the drive roller assembly

表 2—7 机架部分——主动辊筒组件配件明细表
Table 2-7 Rack Part -- Detail of the components of the active roller

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	抛光机主动辊筒支架 Active roller support of polishing machine	456*500*200	1	64.86	64.86
2	抛光机主动辊筒支架镜像 Mirror image of polishing machine active roller support	456*500*200	1	64.86	64.86
3	主动辊筒调整板 Active roller adjustment plate	450*200*25	2	16.98	33.96
4	1000 抛光机主动辊筒 Active roller of 1000 polishing machine	Φ593*1765	1	483.56	483.56
5	防水轴承隔套 A Waterproof bearing sleeve A	Φ95*Φ85*23	2	0.25	0.5
6	BS 防水 UCT217 盖 A BS waterproof UCT217 cover A	Φ185*Φ97*18	3	1.57	4.71
7	骨架油封 framework oil seal	Φ120*Φ95*12	2		
8	KD 抛光机主动轴承座 KD polishing machine active bearing housing	326*199*56	2	8.3	16.6
9	调心滚子轴承 self-aligning roller bearing	22217	2		
10	KD 防水 UCT217 盖 B KD waterproof UCT217 cover B	185*18	1	2	2
11	防水轴承隔套 B Waterproof bearing sleeve B	Φ95*Φ85*38	1	0.42	0.42

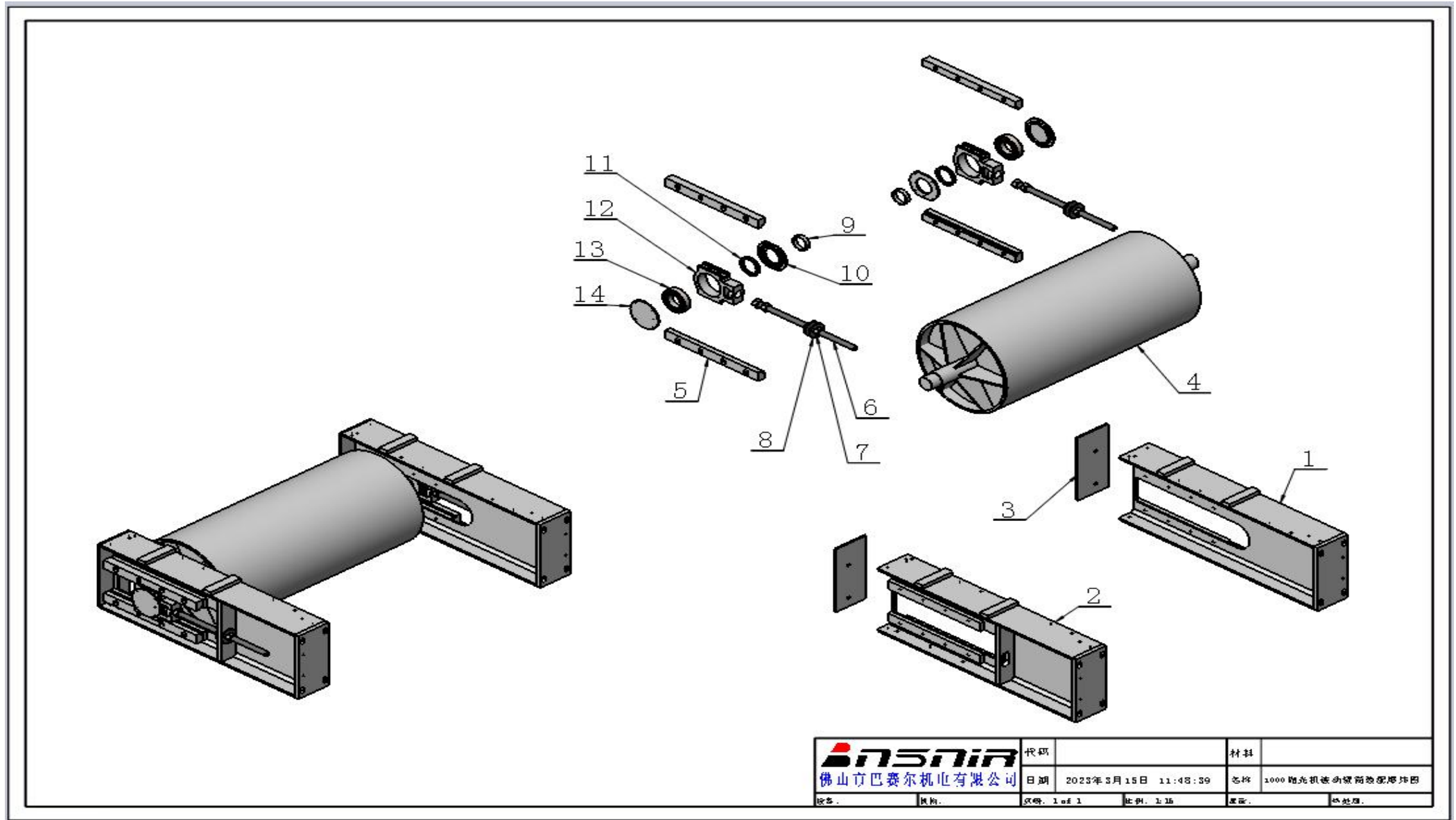


图 2—8 机架部分——被动辊筒组件装配图 picture2-8 Rack Part -- Assembly of passive roller assembly

表 2—7 机架部分——被动辊筒组件配件明细表
Table 2-7 Rack Part - Passive roller Assembly accessories List

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	抛光机被动辊筒支架 Passive roller support of polishing machine	1310*475*200	1	131.13	131.13
2	抛光机被动辊筒支架镜像 Mirror image of passive roller support of polishing machine	1310*475*200	1	131.13	131.13
3	抛光机被动辊筒支架封板 Polishing machine passive roller bracket sealing plate	450*200*10	2	7	14
4	1000 抛光机被动辊筒 Passive roller of 1000 polishing machine	Φ593*1760	1	485.94	485.94
5	UCT 支承条 UCT support strip	610*60*44	4	11.64	46.56
6	螺杆 screw	M30*650	2		
7	螺母 nut	M30	8		
8	厚平垫 Thick flat pad	Φ30	4	8.3	16.6
9	防水轴承隔套 A Waterproof bearing sleeve A	Φ95*Φ85*23	2	0.25	0.5
10	BS 防水 UCT217 盖 A BS waterproof UCT217 cover A	Φ185*Φ97*18	2	1.49	2.98
11	骨架油封 framework oil seal	Φ120*Φ95*12	2		
12	KD 抛光机被动轴承座 KD polishing machine passive bearing housing	262*198*56	2	8.94	17.88
13	调心滚子轴承 self-aligning roller bearing	22217	2		
14	KD 防水 UCT217 盖 B KD waterproof UCT217 cover B	185*18	2	2	4

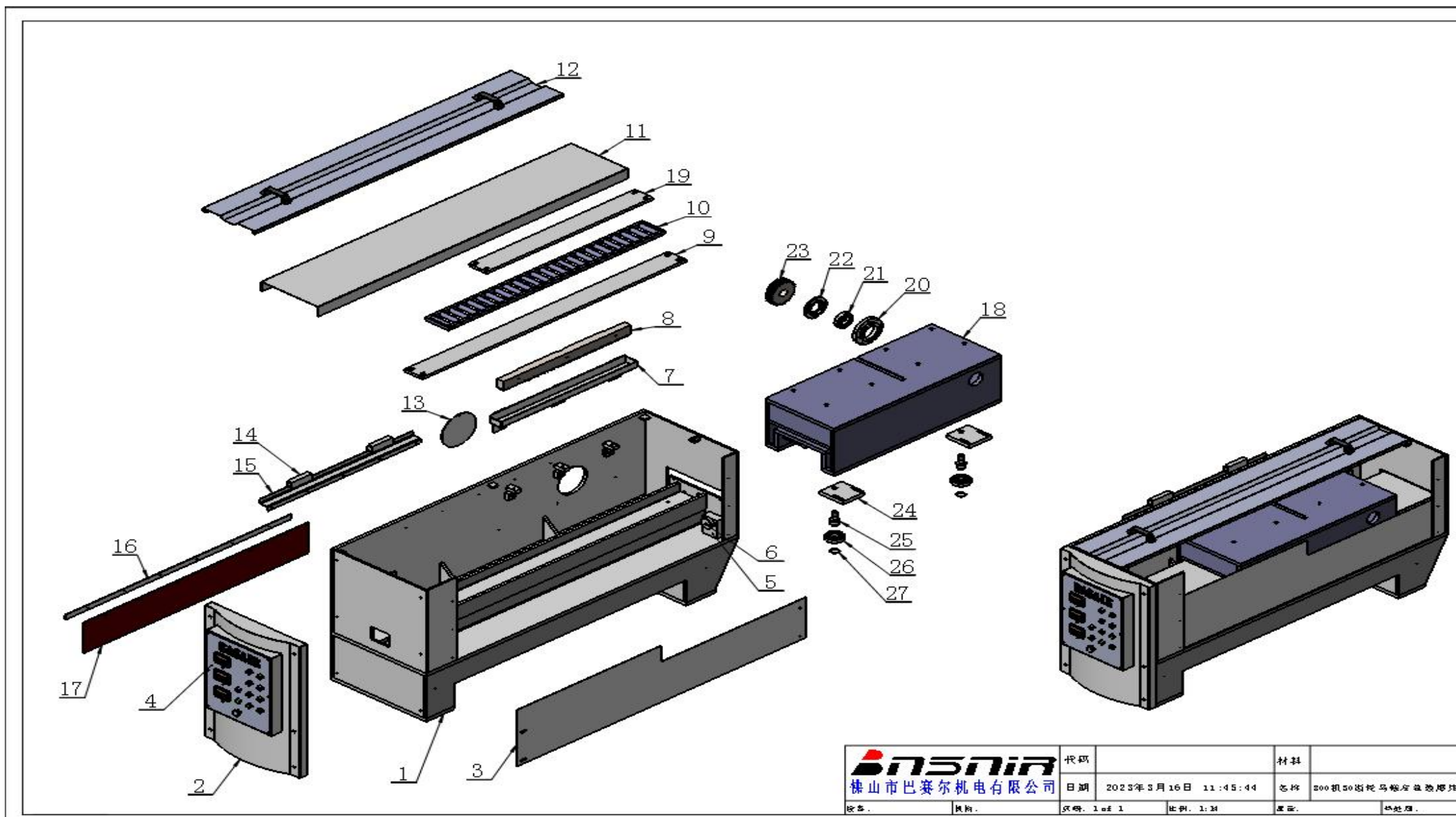


图 3—1 BP1000/16 抛光机——马鞍(左)装配图 picture3-1 Assembly drawing of BP1000/16 polishing machine -- saddle (left)

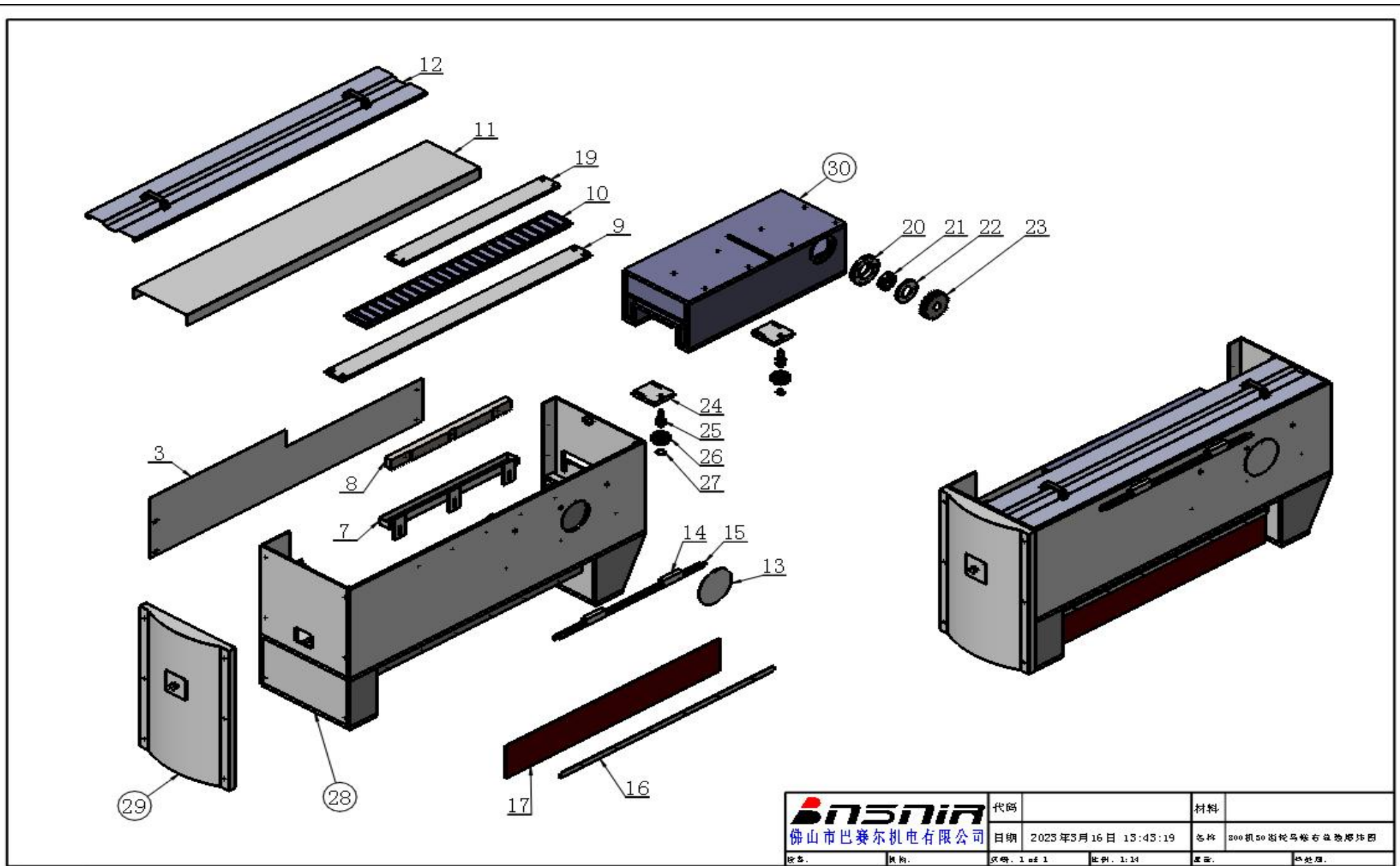


图 3—2 BP1000/16 抛光机——马鞍(右)装配图 picture 3-2 Assembly drawing of BP1000/16 polishing machine -- saddle (right)

表 3 BP1000/16 抛光机——左右马鞍配件明细表

Table 3 BP1000/16 Polishing machine -- Detail of left and right saddle accessories

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	1000 机 30 齿马鞍左 1000 machine 30 tooth saddle left	1930*812*525	1	643.89	643.89
2	左支座前罩 (控制板) Left support front cover (control panel)	812*525*115	1	11.05	11.05
3	1000 机马鞍内侧挡水板 Inner water retaining plate of 1000 machine saddle	1800*350*2	2	8.32	16.64
4	主传动控制面板 Main drive control panel	470*350*3	1	3.53	3.53
5	缓冲块安装板 Buffer block mounting plate	110*80*40	4	2.75	11
6	缓冲块 bumper block	Φ 60*20	4		
7	1000 齿轮油槽 1000 gear oil tank	956*120*67	2	3.83	7.66
8	1000 摆动齿条 1000 swing rack	904*61*40 (模数 4)	2	14.44	28.88
9	1640 支座垫板 1640 support plate	1640*100*15	2	19.1	38.2
10	26 滚珠排 26 ball row		2		
11	1000 机滚珠排防尘板 1000 machine ball exhaust dustproof board	1917*314*62	2	13.27	26.54
12	1000 机支座防护罩 1000 machine support shield	1905*290*20	2	11.21	22.42
13	马鞍孔盖板 Saddle hole cover plate	Φ 190*2	2	0.44	0.88
14	电眼撞块 Electric eye bump block	120*39*25	4	0.85	3.4
15	1000 马鞍刻度尺 1000 saddle scale	1050*55*44	2	2.28	4.56
16	1000 机胶板压板 1000 machine rubber plate pressure plate	1450*30*3	2	1.02	2.04
17	1000 机胶板条 1000 machine glue slats	1450*190*3	2		
18	滑座左 Slide seat left		1		
19	横梁座垫板 Cross beam seat plate	920*100*15	2	10.84	21.68

20	摆动轴承座 Swing bearing housing	$\Phi 148 * \Phi 77 * 29$	2	1.74	3.48
21	深沟球轴承 deep groove ball bearing	6209	2		
22	轴承压盖 Bearing gland cover	$\Phi 116 * \Phi 56 * 15$	2	0.55	1.1
23	摆动齿轮 Swing gear gear	30 齿, 模数 4	2		
24	限位轮座 Limit wheel seat	130*120*20	4	2.17	4.34
25	限位轮轴 Limit axle	$\Phi 40 * 80$	4	0.38	1.52
26	深沟球轴承 deep groove ball bearing	6307	4		
27	轴用卡簧 Spring for shaft	$\Phi 35$	4		
28	1000 机 30 齿马鞍右 1000 machine 30 tooth saddle right	1930*812*525	1	643.89	643.89
29	右支座前罩 Right bearing front cover	812*525*88	1	9	9
30	滑座右 Slide seat right		1		

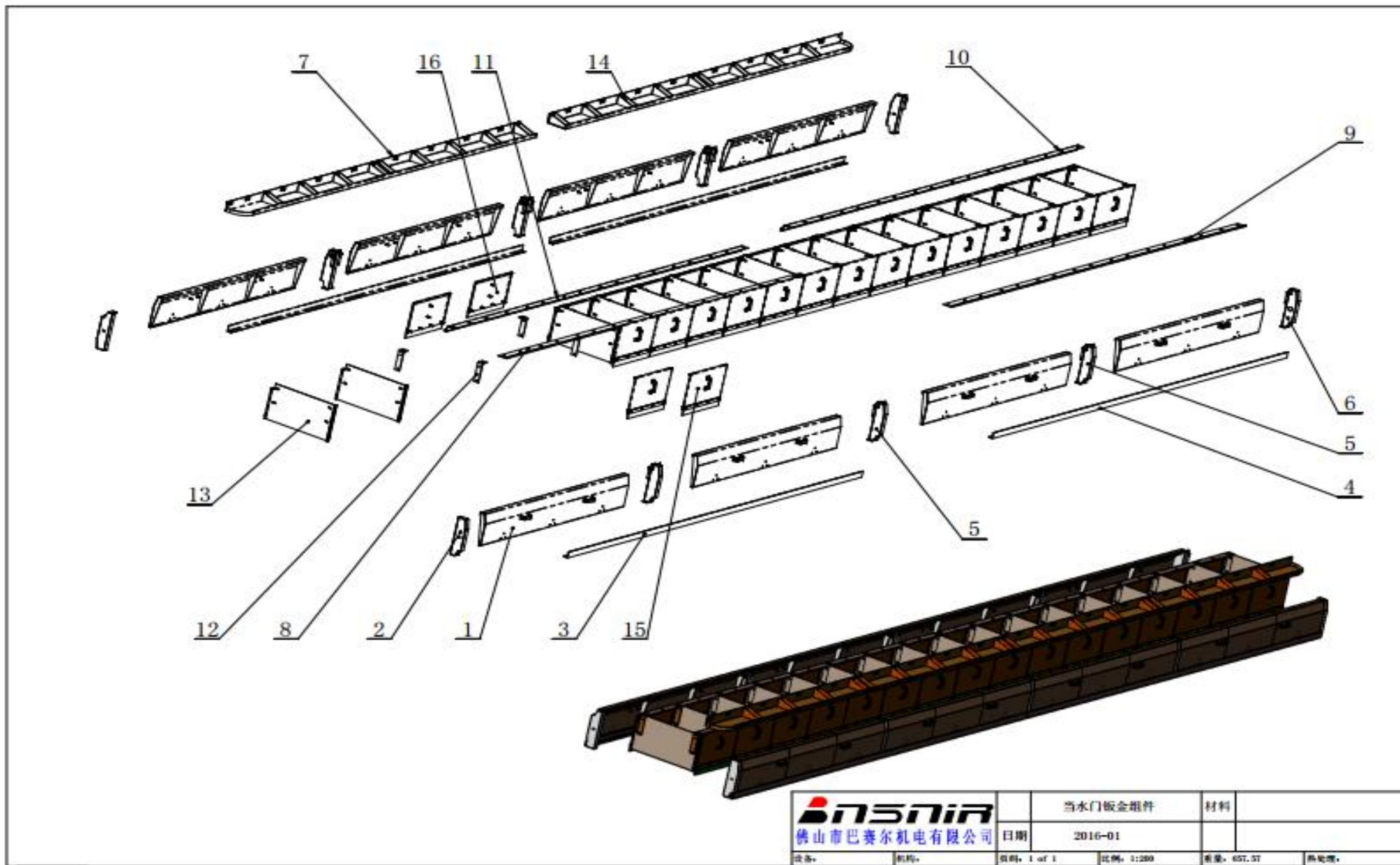


图 4 BP1000/16 抛光机 挡水门钣金组件装配图 picture4 Assembly drawing of the sheet metal assembly of the retaining door of BP1000/16 polishing machine

表 4 BP1000/16 抛光机挡水门钣金配件明细表
Table 4 BP1000/16 polishing machine retaining door sheet metal accessories list

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	挡水挂门 1675 Water retaining door 1675	1675*337*98	8	19.5	156
2	左门柱 A2.0 Left post A2.0	360*100*80	2	2.1	4.2
3	挡水门底梁 A Gate bottom beam A	4650*63*40	2	18.15	36.3
4	挡水门底梁 B Bottom beam B of water retaining gate	4650*63*40	2	18.15	36.3
5	中间门柱 A2.0 Middle post A2.0	360*100*120	6	2.52	15.12
6	右门柱 A2.0 Right post A2.0	360*100*80	2	2.1	4.2
7	16 头磨块托槽 A 16 head grinding block bracket A	4620*200*100	1	32.36	32.36
8	16 头机前沿挂槽 A 16 head machine front hanging slot A	2910*89*18	1	6.93	6.93
9	16 头机前沿挂槽 B 16 head machine front hanging slot B	2910*89*18	1	6.93	6.93
10	16 头机后沿挂槽 A 16 head machine rear hanging slot A	2910*89*58	1	10.44	10.44
11	16 头机后沿挂槽 B 16 head machine rear hanging slot B	2910*89*58	1	10.44	10.44
12	16 头隔板吊板 16 head separator hanging board	210*65*50	34	0.62	21.08
13	16 头磨头隔板组件 16 head grinding head separator assembly	684*385*25	17	4.47	75.99
14	16 头磨块托槽 B 16-head grinding block bracket B	4620*200*100	1	32.36	32.36
15	16 前挡水板组件 Front baffle assembly	574*440*56	16	6.76	108.16
16	16 后挡水板组件 16 Rear baffle assembly	574*385*56	16	6.24	99.84

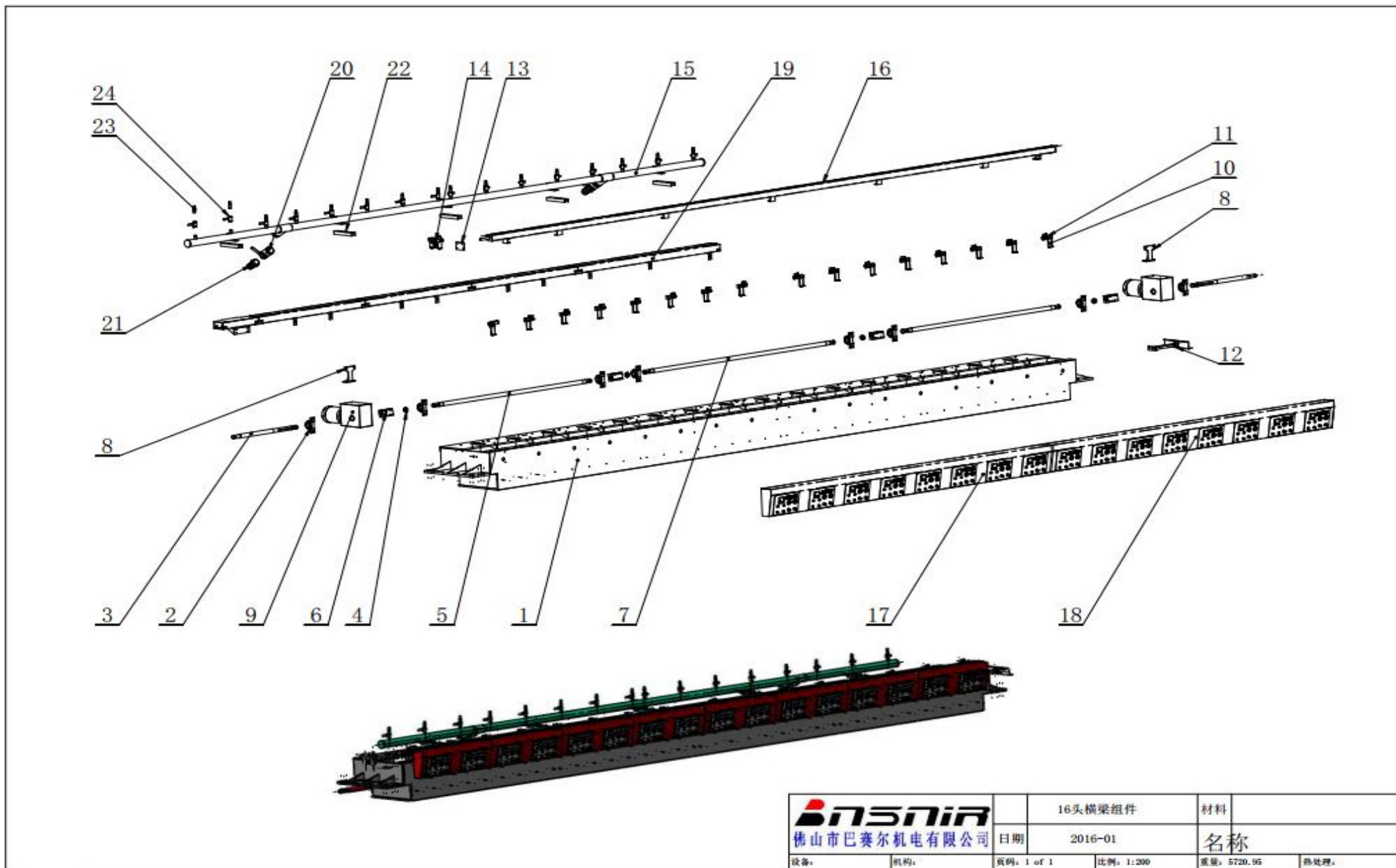


图 5 BP1000/16 抛光机——横梁组件装配图 picture 5 BP1000/16 polishing machine -- beam assembly drawing

表 5 BP1000/16 抛光机——横梁组件配件明细表
Table 5 BP1000/16 Polishing machine -- Cross beam Assembly accessories List

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重(kg)Total weight
1	16 头抛光机横梁 16-head polishing machine beam	10130*835*530	1	4450	4450
2	UCP 210		8	2.7	21.6
3	1034 传动轴 1034 Drive shaft	Φ52*1034	2	15.8	31.66
4	48 半开环 48 Half open loop	Φ60*Φ43*20	4	0.18	0.72
5	抛光机摆动轴 Polishing machine swing shaft	Φ52*2562	2	42	84
6	长轴 long axis	Φ52*3098	1	50.94	50.94
7	48 半开联轴器 48 half open coupling	160*90*35	3	4.57	13.71
8	扭力臂(标准) Torsion arm (standard)	206*160*75	2	2.47	4.94
9	KA77-4P-2.2-M3 减速器 KA77-4P-2.2-M3 reducer		2	237	473.48
10	电磁阀安装板 Solenoid valve mounting plate	124*60*25	16	0.2	3.2
11	电磁阀 Q25DC-L8 Solenoid valve Q25DC-L8		16	1.26	20.16
12	开关架 2 Switch frame 2	458*400*93	1	2.7	2.7
13	三联体安装板 Triplex mounting plate	130*100*12	1	1.2	1.2
14	气动三联件 AC2500 Pneumatic triplex AC2500		1	7.69	7.69
15	16 头水管部件 16 pipe parts	Φ89*8410	1	118	118.2
16	总气管组件 Total tracheal assembly	80*80*9200	1	90.3	90.32
17	16 头磨头面板槽架 A 16 head grinding head panel slot rack A	4612*367*163	1	105	105.38

18	16 头磨头面板槽架 B 16 head grinding head panel slot rack B	4612*367*163	1	105	105.38
19	16 头横梁线槽 16 beam line grooves	9088*191*93	1	109	109
20	3 寸球阀 3 inch ball valve		1		
21	3 寸胶管直接头 3 inch hose direct head		1		
22	水管安装支架 Water pipe mounting bracket	300*63*40	5	2.1	10.5
23	6 分 (3/4") 胶管直接头 (3/4") hose direct head		16		
24	6 分 (3/4") 球阀 (3/4") ball valve		16		

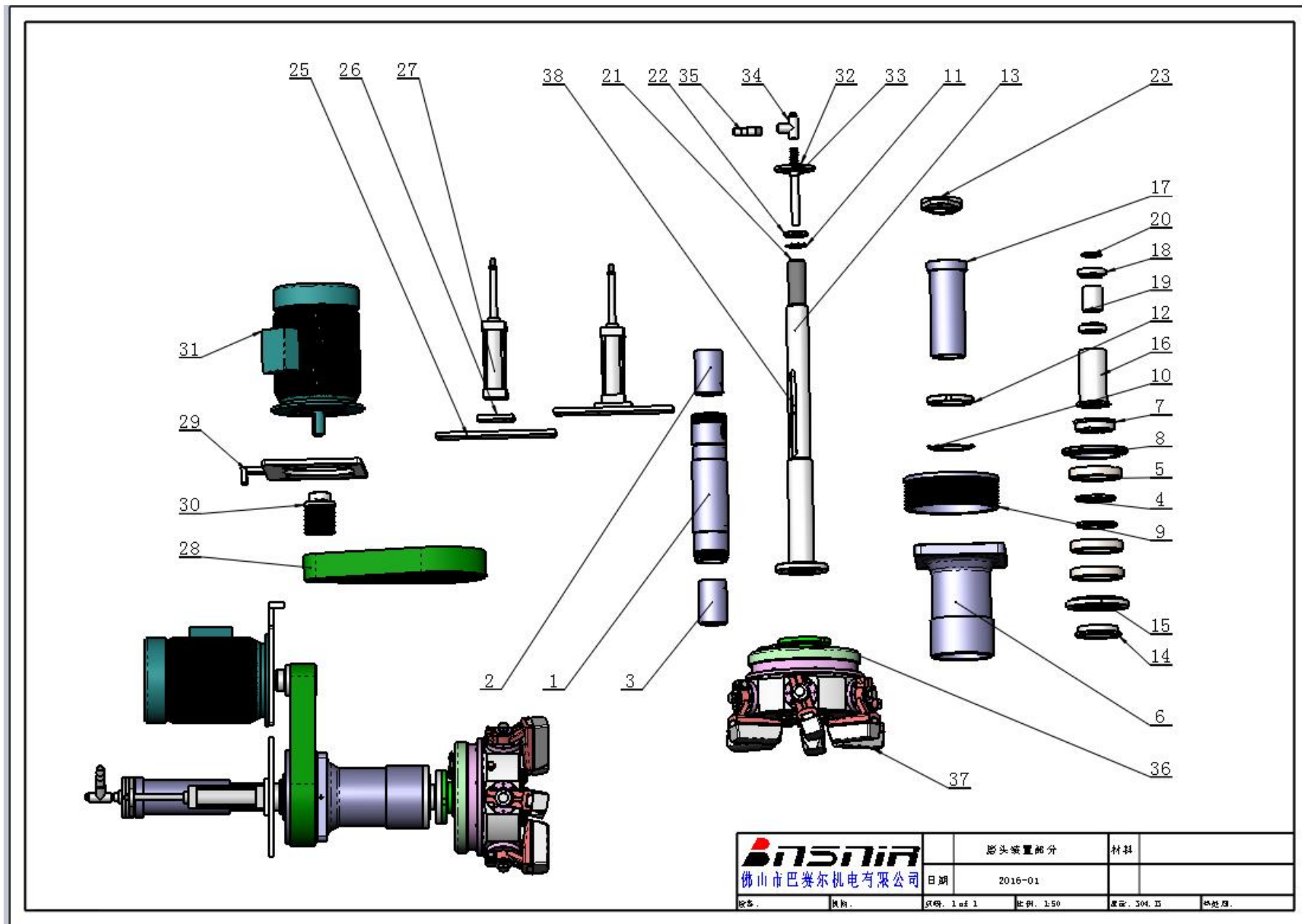


图 6-1 BP1000/16 抛光机——磨头上部及磨头部分装配图 picture6-1 BP1000/16 polishing machine -- Assembly drawing of grinding head and part of grinding head

表 6-1 BP1000/16 抛光机——磨头上部及磨头部分配件明细表

Table 6-1 BP1000/16 Polishing machine -- Detail list of grinding head and parts of grinding head

序号 No.	名称 Name	规格 size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	传动套 TPSA0101 Transmission sleeve TPSA0101	$\Phi 114 * \phi 82 * 476$	1	14.4	14.4
2	上轴套 TPSA0302 Upper sleeve TPSA0302	$\Phi 90 * \phi 70 * 140$	1	2.5	2.5
3	下轴套 TPSA0303 Lower sleeve TPSA0303	$\Phi 90 * \phi 80 * 140$	1	1.46	1.46
4	轴肩挡圈 retaining ring for shaft shoulder	$\Phi 130 * \phi 100 * 8$	2	0.24	0.48
5	深沟球轴承 6022 Deep groove ball bearing 6022		3		0
6	轴承座 TPSA02 Bearing housing TPSA02	$\Phi 203 * \phi 155 * 350$	1	49.8	49.8
7	轴套 axle sleeve	$\Phi 135 * \phi 110 * 30$	1	0.76	0.76
8	上端盖 TPSA09 Upper end cover TPSA09	$\Phi 210 * \phi 130 * 20$	1	1.9	1.9
9	大带轮 TPSA11 Large pulley TPSA11	$\Phi 305 * \phi 110 * 100$	1	19.5	19.5
10	圆螺母止动垫圈 55 Round nut stop washer 55		1		0
11	圆螺母止动垫圈 110 Round nut stop washer 110		1		0
12	圆螺母 M110X2 Round nut M110X2		1		0
13	主轴 principal axis	$\Phi 170 * \phi 30 * 1020$	1	28.9	28.9
14	传动套帽 Transmission sleeve cap	$\Phi 150 * \phi 110 * 28$	1	1.16	1.16
15	下端盖 lower cover	$\Phi 203 * \phi 132 * 25$	1	1.92	1.92
16	护套 protecting bush	$\Phi 110 * \phi 82 * 180$	1	1.34	1.34
17	连接套 TPSA07 Connecting sleeve TPSA07	$\Phi 130 * \phi 90 * 308$	1	0.776	0.776
18	圆锥滚子轴承 32011 Tapered roller bearing 32011		2		0
19	轴承隔套 distance sleeve of bearing	$\Phi 65 * \phi 55 * 77$	1	0.57	0.57

20	挡圈 check ring	$\Phi 65 * \phi 55 * 6$	1	0.04	0.04
21	孔用卡簧 40 Hole with clip spring 40		1		0
22	圆螺母 M55X2 Round nut M55X2		1		0
23	压盖 cover clamp	290*130*35	1	2.87	2.87
24	导向键 feather key		1	0.38	0.38
25	气缸安装板 Cylinder mounting plate	386*80*14	2	3.31	6.62
26	气缸连接板 Cylinder connection plate	118*76*14	2	0.88	1.76
27	气缸 10A-5R FB 63 B 150 10A-5 FB 63 B 150 Cylinder of air		1 1	3.86	7.72
28	联组窄 V 带 9Jx1420 The narrow V band of the combined group was 9Jx1420		1	0.98	0.98
29	四极 5.5KW 调整板 Quadrupole 5.5KW adjustment plate	400*396*50	1	10.7	10.7
30	四极 5.5KW 用小带轮 TPSA10 Quadrupole 5.5KW with small puller TPSA10	$\Phi 100 * \phi 38 * 129.5$	1	4.214	4.214
31	Y132S-4 极电机 5.5KW Y132S-4 pole motor 5.5KW		1	183.2	183.2
32	进水法兰盘 Inlet flange	$\Phi 130 * \phi 24.5 * 25$	1	1.09	1.09
33	磨盘上部进水管 Upper intake pipe of grinding disc	$\Phi 26 * \phi 21 * 250$	1	0.26	0.26
34	三通水管 Three-way water pipe		1	0.64	0.64
35	6 分胶管直接管 Hose direct tube		1	0.14	0.14
36	磨盘 Polishing head		1	31.59	31.59
37	磨块 grinding block		6		
38	导向键 18*10.5*280 feather key 18*10.5*280		2		

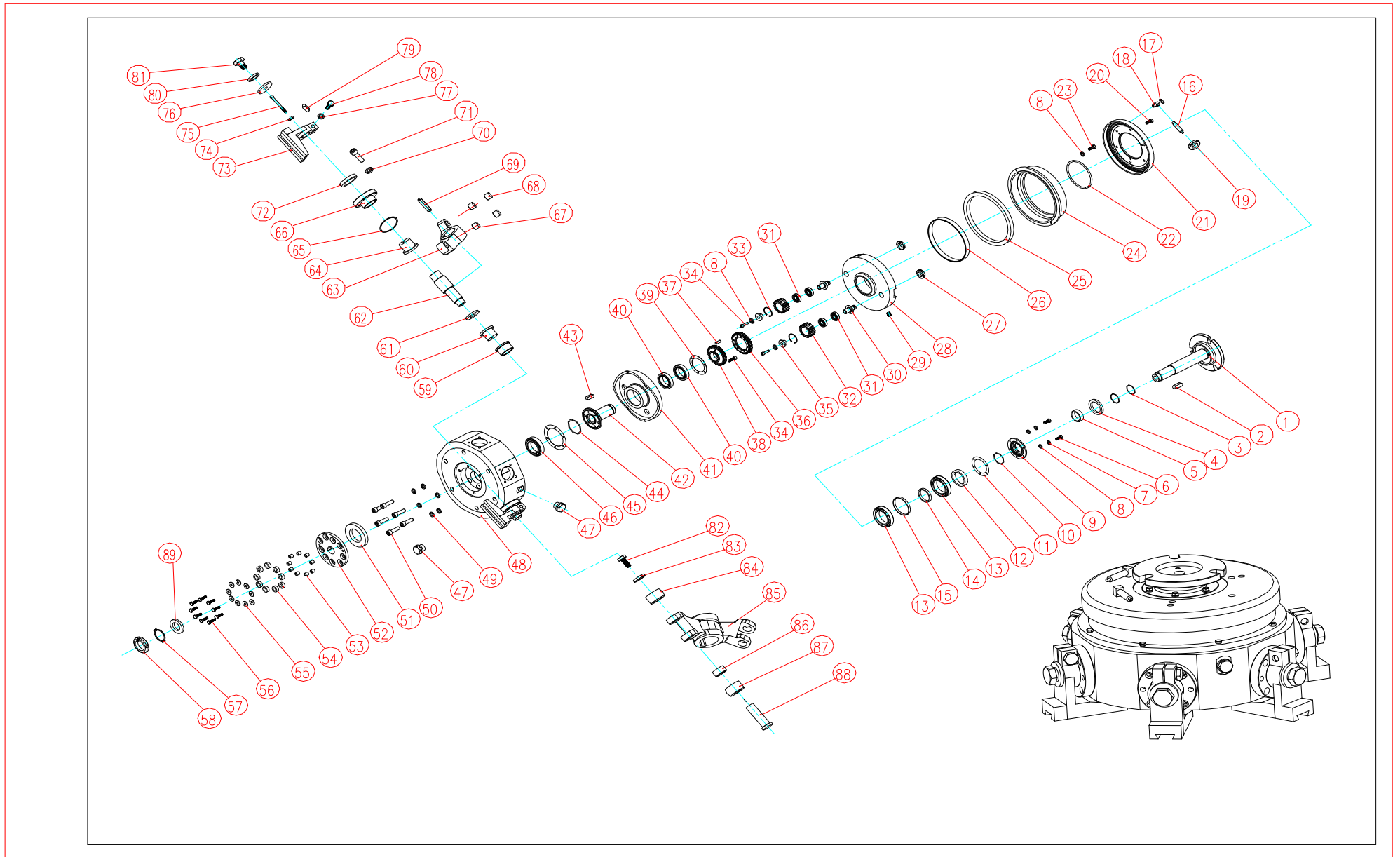


图 6-2 BP1000/16 抛光机——磨头装配图
picture6-2 BP1000/16 polishing machine --polishing head assembly drawing

表 6-2 BP1000/16 抛光机——磨头配件明细表

Table 6-2 BP1000/16 Polishing machine -- polishing head accessories List

序号 No.	代号 Code	名称 Name	型号(规格) size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
1	KD268C-12	轴 axle	Φ170*Φ20*282	1	4.8	4.8
2	GB/T1096-2003	平键 flat key	12*36	1		
3	GB/T3452.1-1992	O型密封圈 O-ring seal	45*3.55	2		
4	GB13871-1992	旋转轴唇形密封圈 the early bird catches the worm	FB 55 75 8	1		
5	KD268C-13	小镶套 Small set	Φ55*Φ46*16	1	0.078	0.078
6	GB/T5781-2000	六角头螺栓 hexagon bolt	M6*20	6		
7	GB/T97.1-2002	平垫圈 flat washer	6	6		
8	GB/T93-1987	弹簧垫圈 spring washer	6	16		
9	KD268C-11	顶盖 head cover	Φ138*Φ60*29	1	0.84	0.84
10	GB/T3452.1-1992	O型密封圈 O-ring seal	80*3.55	1		
11	KD268C-16	调整垫(1) Adjusting pad (1)		1		
12	KD268B-27B	锁紧螺母 locknut	Φ80*M64*15	1	0.21	0.21
13	GB/T292-1994	角接触球轴承 angular contact ball bearing	7013AC/DB	1		
14	KD268C-14	内隔套 Inner septum sleeve	Φ75*Φ65*10	1	0.085	0.085
15	KD268C-15	外隔套 Outer septum sleeve	Φ100*Φ90*10	1	0.091	0.091
16	KD268B-01	油路外接头 Oil circuit external joint		2		
17	GB/T3452.1-1992	O型密封圈 O-ring seal	10*1.8	2		
18	KD268B-02A	油接头 Oil joint	15*15*34	2	0.033	0.066
19		管接头螺母 Nuts for pipe joints	M12*1	2		
20	GB/T819.1-2000	十字槽沉头螺钉 cross recessed countersunk head	M6*14	3		

		screw				
21	KD268C-08	防水罩 waterproof cover	Φ 360* φ 172*40	1	7.5	7.5
22	GB/T3452.1-1992	O型密封圈 O-ring seal	170*2.65	1		
23	GB/T5781-2000	六角头螺栓 hexagon bolt	M6*25	8		
24	KD268B-18	磨头盖 polishing head cover	Φ 380* φ 288*77	1	8.5	8.5
25	GB13871-1992	旋转轴唇形密封圈 Rotary shaft lip seal ring	FB 280 320 20	1		
26	KD268B-21	镶套 Helisert	Φ 280* φ 270*28	1	0.95	0.95
27	GB/T812-1988	圆螺母 round nut	M24*1.5	2		
28	KD268C-10	固定盖 Fixed cover	Φ 270* φ 91*61	1	24	24
29	GB/T77-2000	内六角平端紧定螺钉 flat point set screw	M8*10	1		
30	KD268C-07	中间轴 intermediate shaft	Φ 52*74	2	0.3	0.6
31	GB/T276-1994	深沟球轴承 deep groove ball bearing	6305	4		
32	KD268C-04	中间齿轮 intermediate gear	齿数 24 模数 3.5	2	0.8	1.6
33	GB/T893.1-1986	孔用弹性挡圈 circlip for hole	62	2		
34	GB/T70.1-2000	内六角圆柱头螺钉 hexagon socket cap screws	M6*20	8		

续表 6-2 BP1000/16 抛光机——磨头配件明细表

Table 6-2 BP1000/16 Polishing machine -- polishing head accessories List

序号 No.	代号 Code	名称 Name	型号(规格) size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
35	KD268C-05	压盖 cover clamp	Φ32*Φ7*16	2	0.041	0.082
36	KD268C-09	主动齿轮 driving gear	齿数 41 模数 3.5	1	1.7	1.7
37	GB/T119.2-2000	圆柱销 straight pin	8*25	3		
38	KD268C-06	从动齿轮 driven gear	齿数 39 模数 3.5	1	1.1	1.1
39	KD268C-24	调整垫 (4) Adjusting pad (4)		1		
40	GB/T297-1994	圆锥滚子轴承 tapered roller bearing	32013	2		
41	KD268C-03A	凸轮 cam	Φ273*Φ91*46	1	6.4	6.4
42	KD268C-02B	旋转轴套 Rotating shaft sleeve	Φ140*Φ47*159	1	2.8	2.8
43	GB/T1096-2003	平键 flat key	14*28	1		
44	GB/T3452.1-1992	O 型密封圈 O-ring seal	118*2.65	1		
45	KD268C-21	调整垫 adjustable pad		1		
46	GB/T9163-1988	关节轴承 knuckle bearing	GE40ES	1		
47	KD268B-37	螺塞 plug screw	Φ28*23	7	0.064	0.448
48	KD268C-01A	磨头座 polishing head holder	Φ405*Φ62*122	1	34.3	34.3
49	GB/T93-1987	弹簧垫圈 spring washer	12	6		
50	GB/T70.1-2000	内六角圆柱头螺钉 hexagon socket cap screws	M12*25	6		
51	KD268B-44	弹垫 spring washer	Φ116*Φ68*14.5	1	0.78	0.78
52	KD268B-41A	联轴器 coupling	Φ183*Φ40*42	1	3.3	3.3
53	KD268B-39	隔套 spacer bush	Φ16*Φ10*16	9	0.015	0.135
54	KD268B-38B	胶垫 rubber mat	Φ32*Φ16*12	9		
55	KD268B-40A	垫 pad	Φ24*Φ10.5*4	9		

56	GB/T5781-2000	六角头螺栓 hexagon bolt	M10*35	9		
57	GB/T858-1988	止动垫圈 lock washer	36	1		
58	GB/T812-1988	圆螺母 round nut	M36*1.5	1		
59	KD268B-08	套 cover	Φ 56* φ 40*30	6	0.18	1.08
60	KD268B-09	摆杆轴压盖 Swing rod shaft gland	Φ 45* φ 100*36	6		
61	KD268C-23	垫片 gasket	Φ 64* φ 35*5	6	0.086	0.516
62	KD268C-18	摆杆轴 Swing rod shaft	Φ 45* φ 12*155	6	1.1	6.6
63	KD268B-04B	被动摆杆 Passive swing bar	178*55*51	3	0.97	2.91
64	KD268C-19C	轴承座套 bearing sleeve	64*45*38	6	0.26	1.56
65	KD268C-22	调整垫(3) Adjusting pad (3)		6		
66	KD268C-20	小轴承座 Small bearing housing	Φ 108* φ 55*45	6	1	6
67	KD268B-06	防松螺钉 stop screw	Φ 16*10	6		
68	KD268B-05	球面螺钉 Spherical screw	Φ 16*15	6		
69	GB/T1096-2003	平键 flat key	10*50	6		
70	GB/T93-1987	弹簧垫圈 spring washer	8	24		
71	GB/T70.1-2000	内六角圆柱头螺钉 hexagon socket cap screws	M8*25	24		

续表 6-2 BP1000/16 抛光机——磨头配件明细表

Table 6-2 BP1000/16 Polishing machine -- polishing head accessories List

序号 No.	代号 Code	名称 Name	型号(规格) size	数量 qty.	单重 (kg) Single weight	总重 (kg) Total weight
72	GB13871-1992	旋转轴唇形密封圈 Rotary shaft lip seal ring	FB 45 62 8	6		
73	KD268B-10	磨块座 Grinding block holder	361*146*65	6	2.2	13.2
74	GB/T93-1987	弹簧垫圈 spring washer	10	6		
75	GB/T70.1-2000	内六角圆柱头螺钉 hexagon socket cap screws	M10*100	6		
76	KD268B-14	压紧端盖 Press the end cover tightly	Φ52*Φ21*6	6	0.08	0.48
77	GB/T93-1987	弹簧垫圈 spring washer	14	6		
78	GB/T5781-2000	六角头螺栓 hexagon bolt	M14*45	6		
79	GB/T1096-2003	平键 flat key	C10*28	6		
80	GB/T93-1987	弹簧垫圈 spring washer	20	6		
81	GB/T5781-2000	六角头螺栓 hexagon bolt	M20*40	6		
82	GB/T5781-2000	六角头螺栓 hexagon bolt	M8*20	6		
83	KD268B-36	轴端压盖 Shaft end gland	Φ24*Φ9*4	6	0.012	0.072
84	KD268B-35	从动滚轮 return idler	Φ40*Φ16*17	6		
85	KD268B-03B	主动摆杆 Active swing bar		3		
86	JB/T7918-1997	滚针轴承 needle bearing	K 16*20*17	6		
87	KD268B-34	主动滚轮 driving roller	Φ40*Φ20*17	6		
88	KD268B-33	滚轮轴 roller shaft	Φ22*57	6	0.09	0.54
89	GB/T97.1-2002	平垫圈 flat washer	36	1		

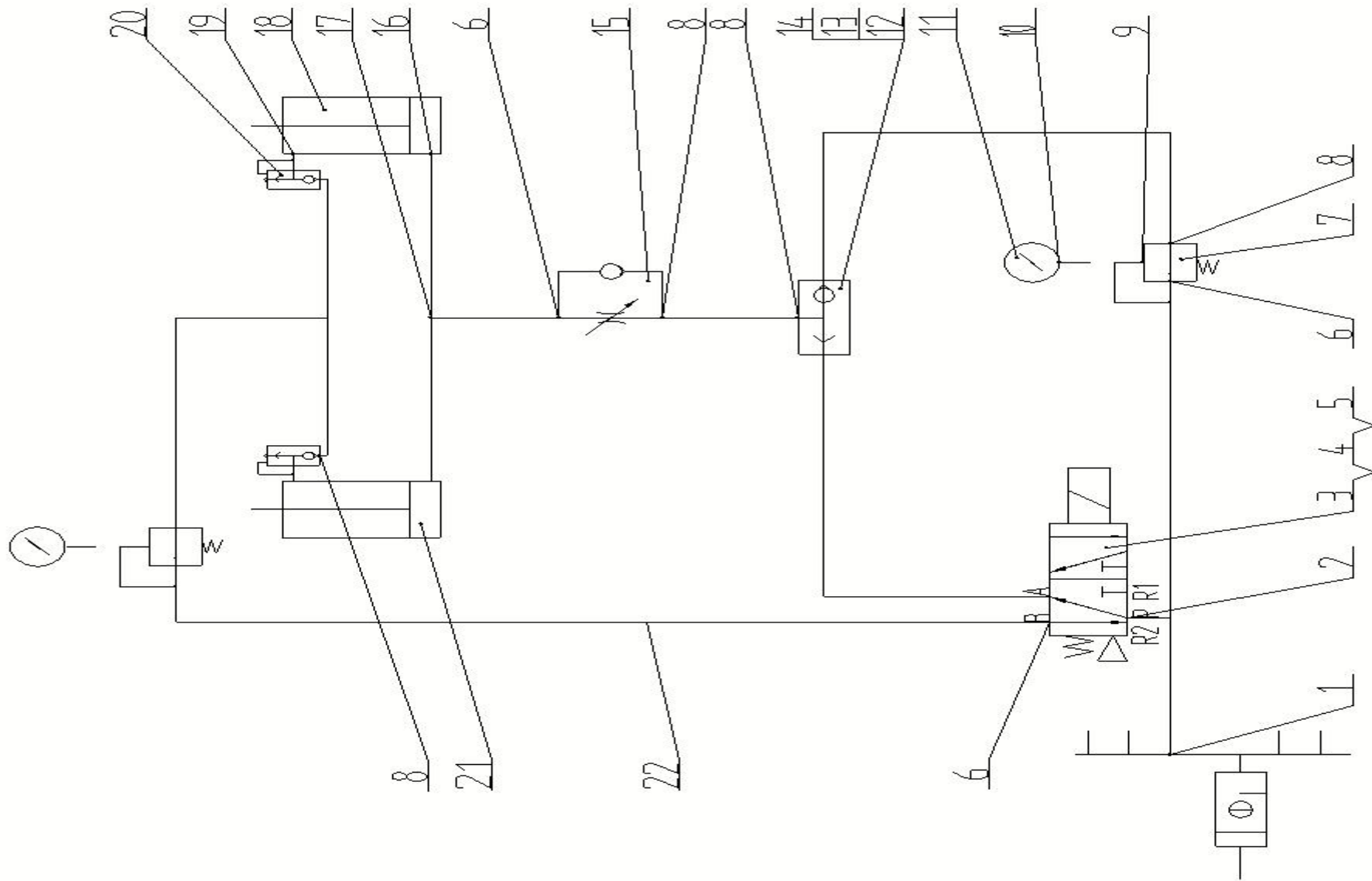


图 7 磨头控制气动系统 picture7 Grinding head control pneumatic system

表 7 磨头控制气动系统
Table 7 Grinding head control pneumatic system

序号 No.	代号 Code	名称 Name	数量 qty.	材料 materials	单重 (kg) Single weight	总重 (kg) Total weight
1		快速接头 SPL6-01 Quick coupling SPL6-01	16			
2		快速接头 SPB6-02 Quick connector SPB6-02	16			
3		电磁阀 Q25DC-L8 Solenoid valve Q25DC-L8	16			
4		螺丝 M4 X40 Screw M4 X40	32			
5		螺母 M4 Nut M4	32			
6		快速接头 SPL6-02 Quick coupling SPL6-02	90			
7		减压阀 QTYC-L8 Pressure reducing valve QTYC-L8	32			
8		快速接头 SPC6-02 Quick connector SPC6-02	32			
9		快速接头 SPC6-01 Quick connector SPC6-01	32			
10		快速接头 SPLF6-01	32			
11		压力表 40X1/8" PT 1MPa Pressure gauge 40X1/8 "PT 1MPa	32			
12		梭动阀 KS-L8 Shuttle valve KS-L8	16			
13		螺丝 M5 X30 Screw M5 X30	32			
14		螺母 M5 Nut M5	32			
15		限流器 QLA-L8 The current limiter is QLA-L8	16			
16		快速接头 SPC6-03 Quick connector SPC6-03	32			
17		快速接头 SPE-06	32			
18		气缸 10A-5R FB 63 B150 Cylinder 10A-5R FB 63 B150	16			
19		快速阀接头 Quick valve joint	32			
20		快速排气阀 KP-L8 Quick exhaust valve KP-L8	32			
21		气缸 10A-5 FB 63 B150 Cylinder 10A-5 FB 63 B150	16			
22		气管 6X1 Trachea 6X1	100 米			