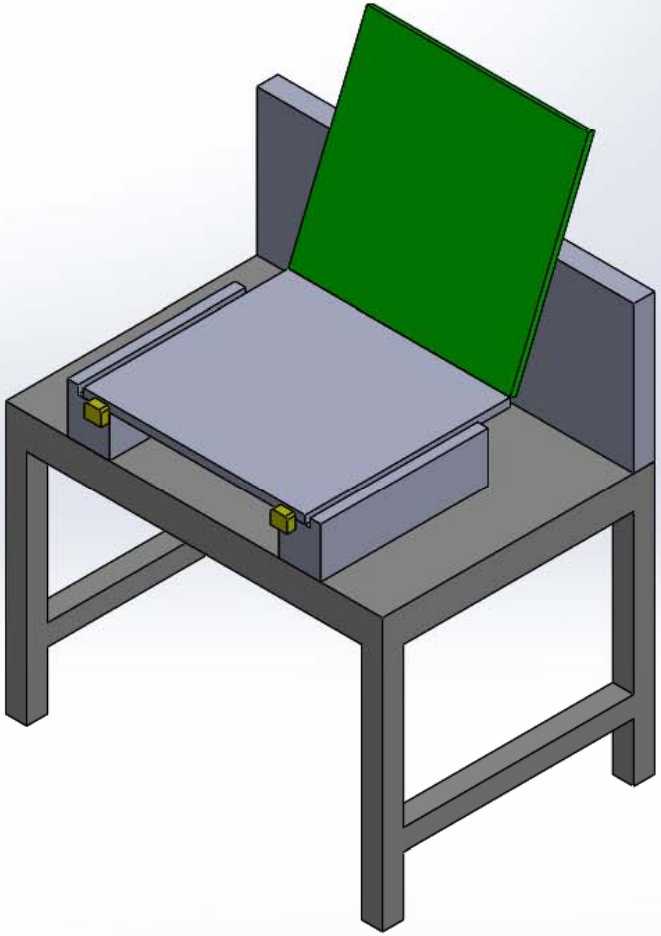
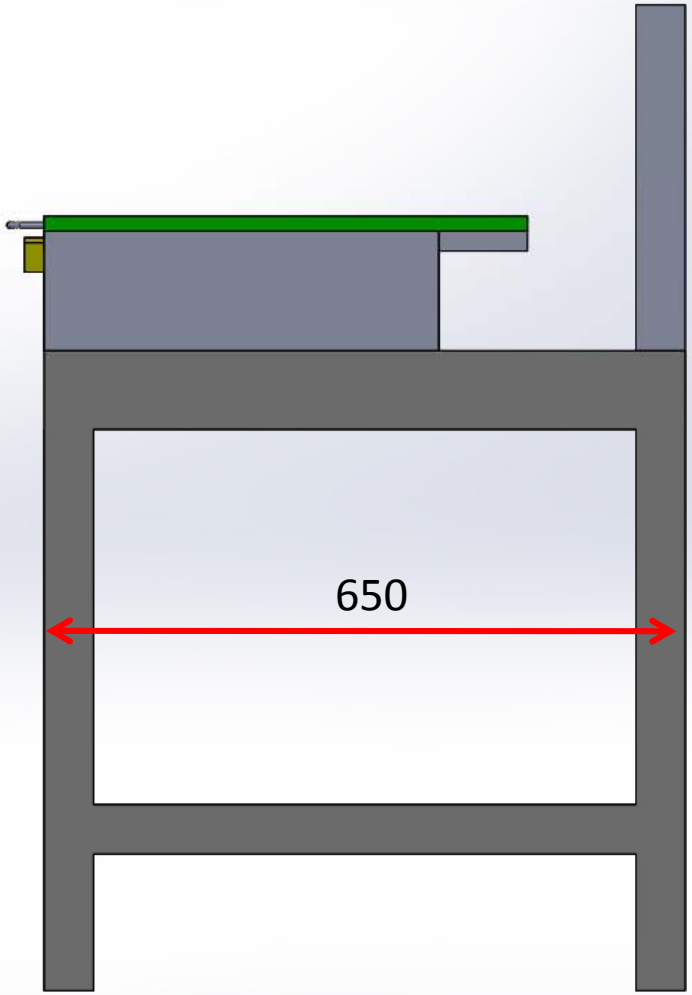
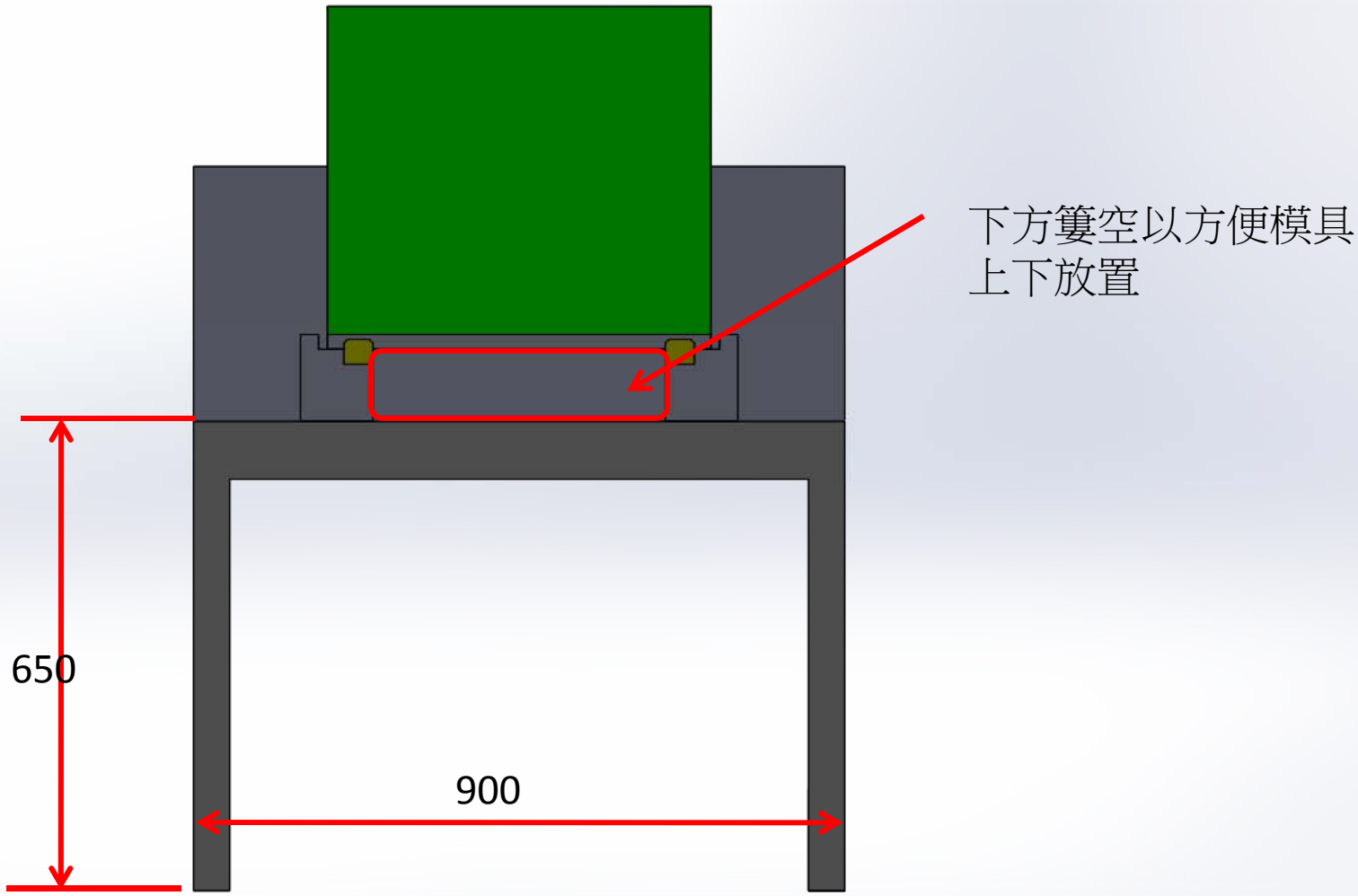
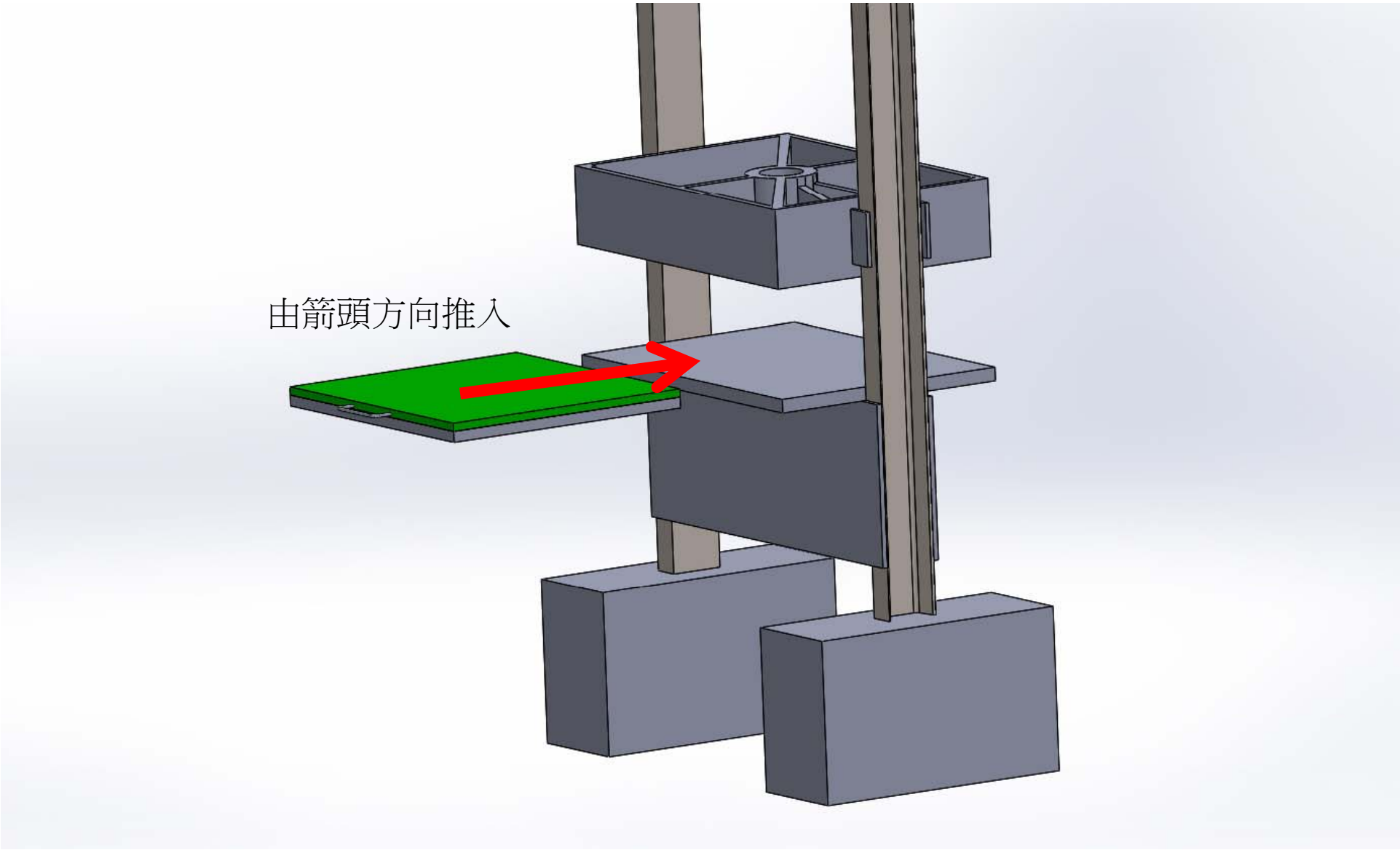
製造步驟

調要壓合物料(依圖面規格)
將布先放置於治具底部
將模具加溫(固定溫度範圍內)
將混合好的材料倒入治具(定量)
放入油壓機內壓合
將治具放入冷卻水槽內(降溫)
再上層加一成布
進烤箱加溫(固定溫度)
放入油壓機內壓合
將治具放入冷卻水槽內(降溫)
取出後將零件取出
以刀模沖出所需尺寸
防磨襯套點膠
包覆膠膜
依圖面規格沖出

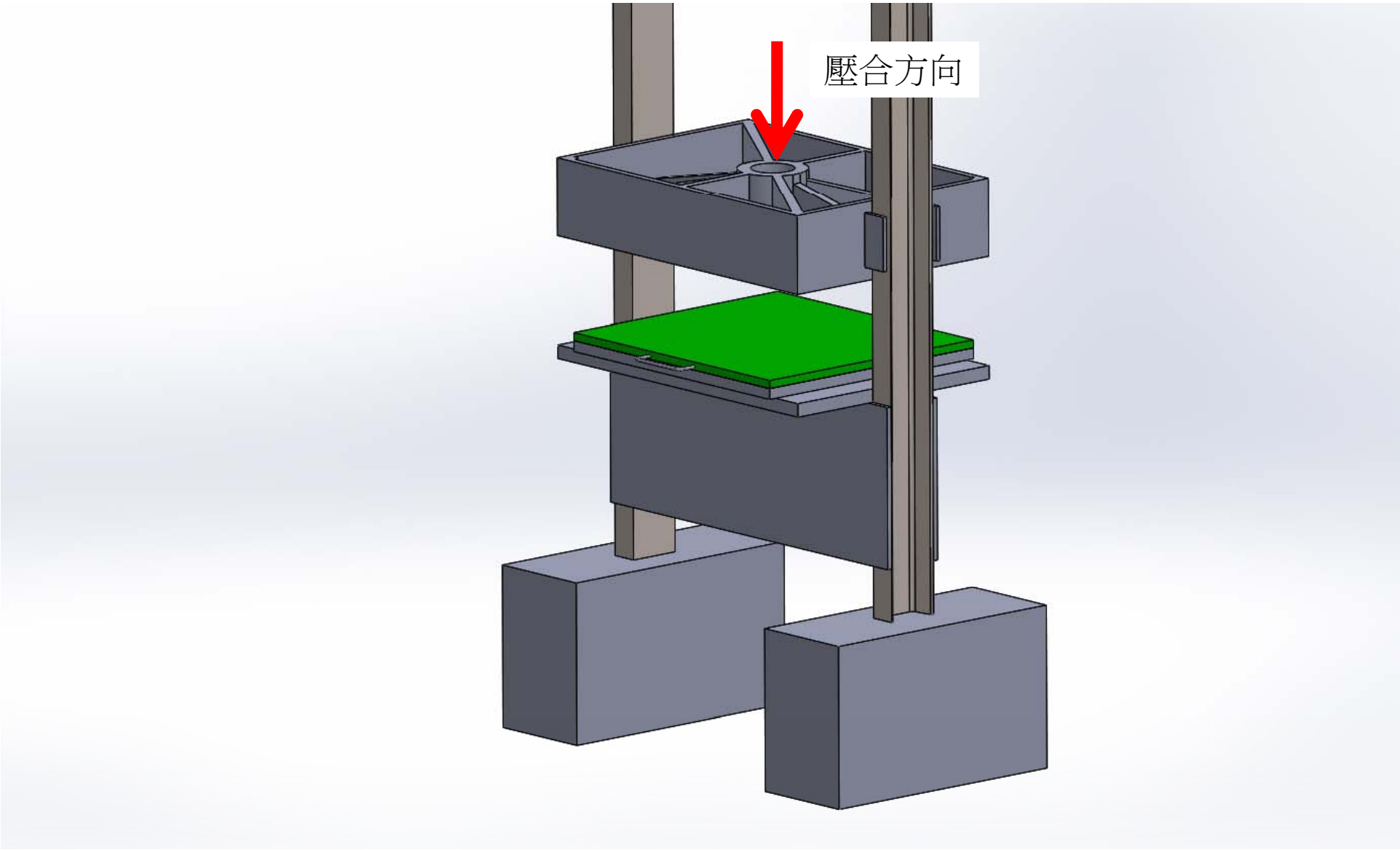



650

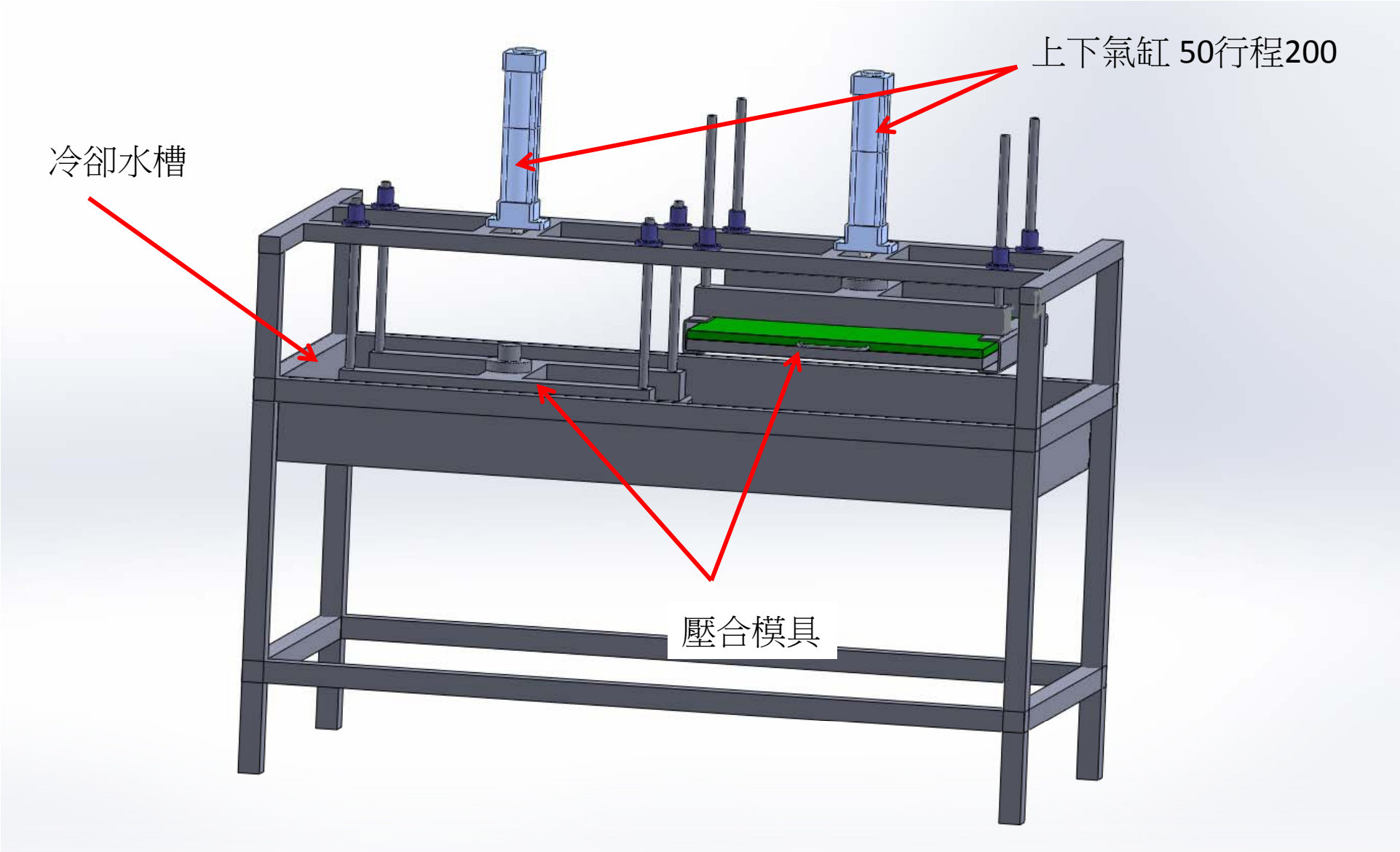

下方簍空以方便模具
上下放置
650
900


由箭頭方向推入

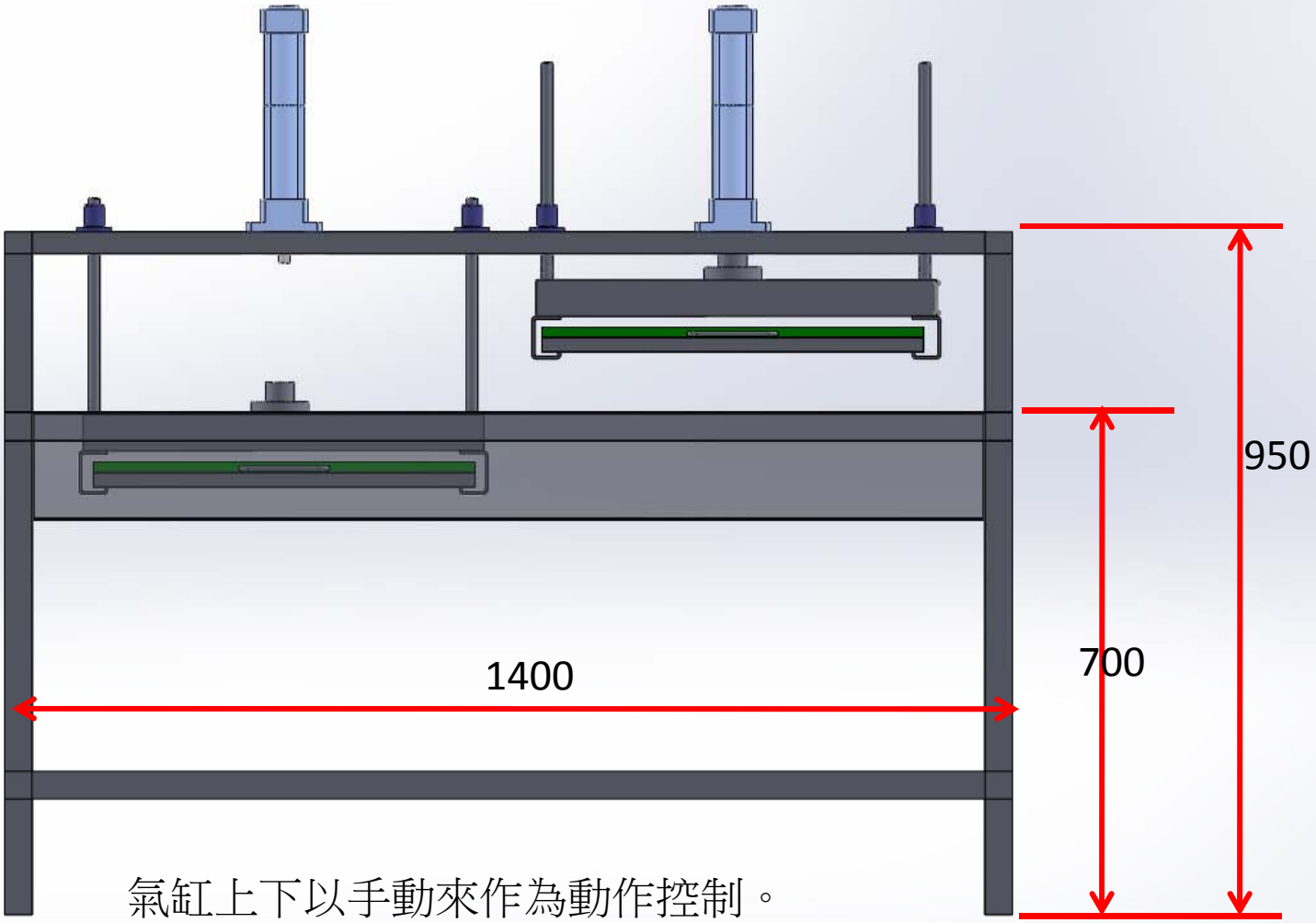
壓合製程



冷卻水槽

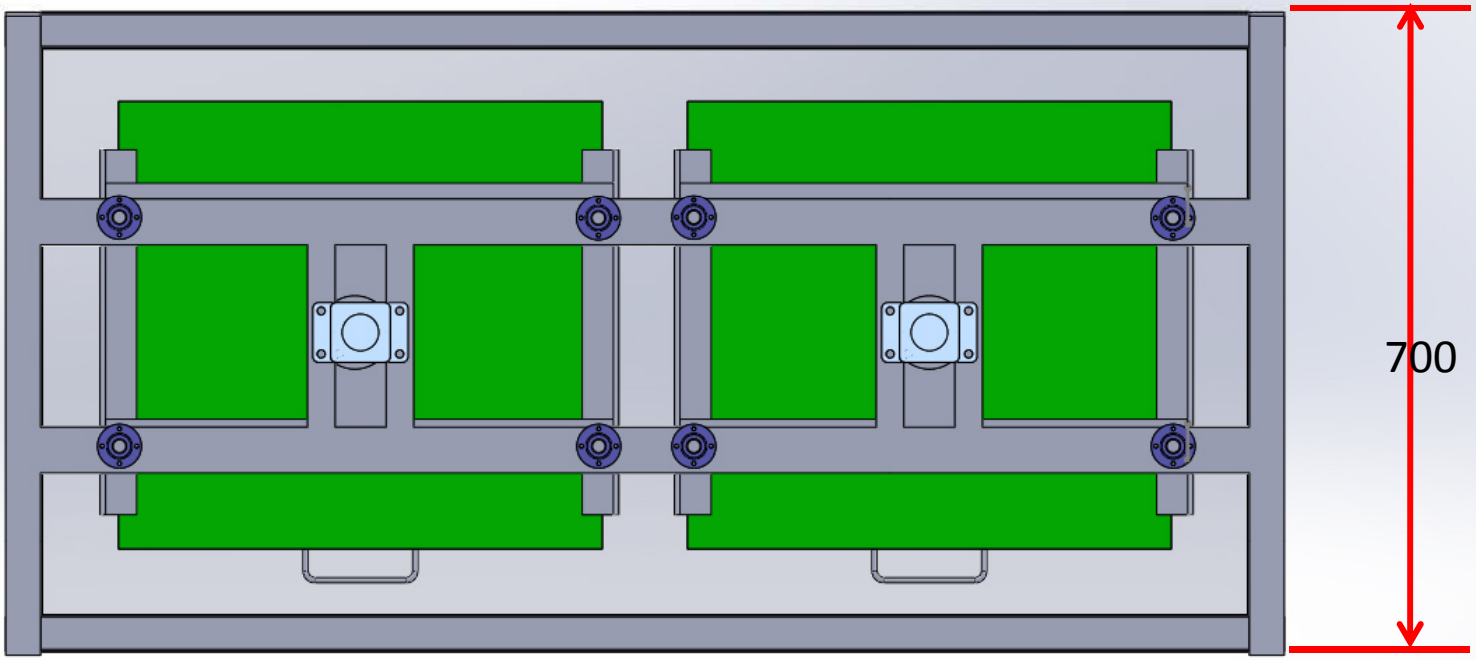


冷卻水槽(前視圖)



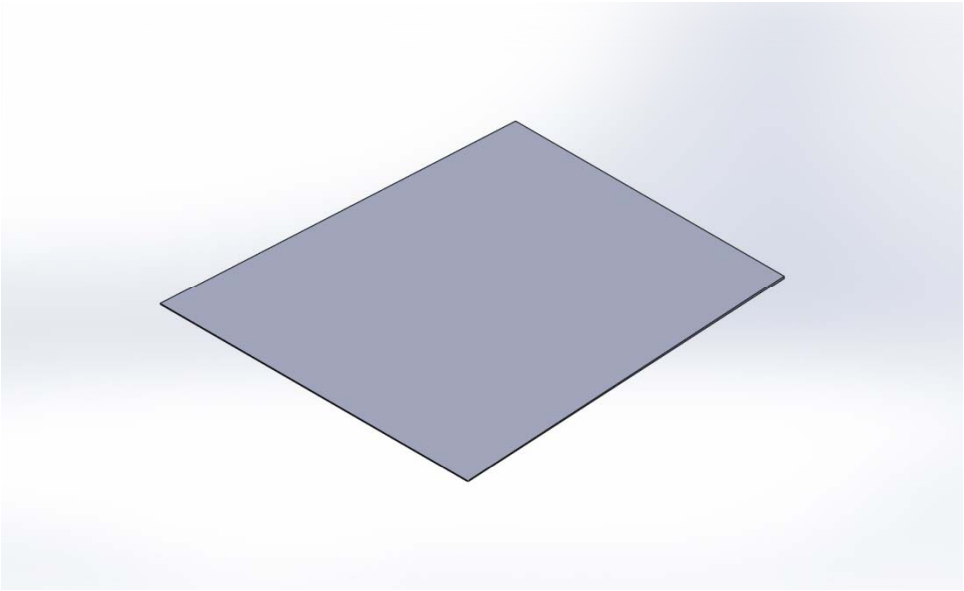
氣缸上下以手動來作為動作控制。

冷卻水槽(上視圖)

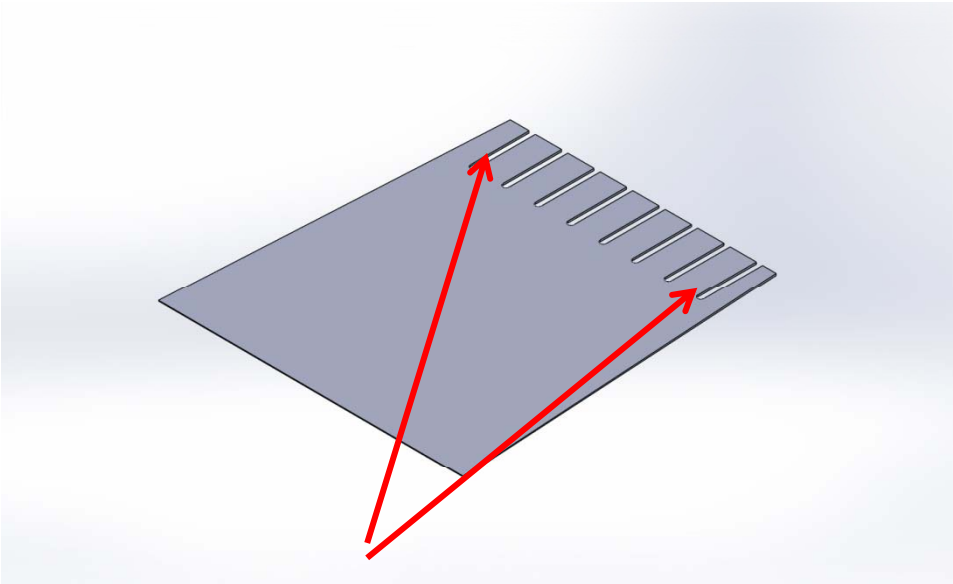


經外型加工

壓合後防磨襯布

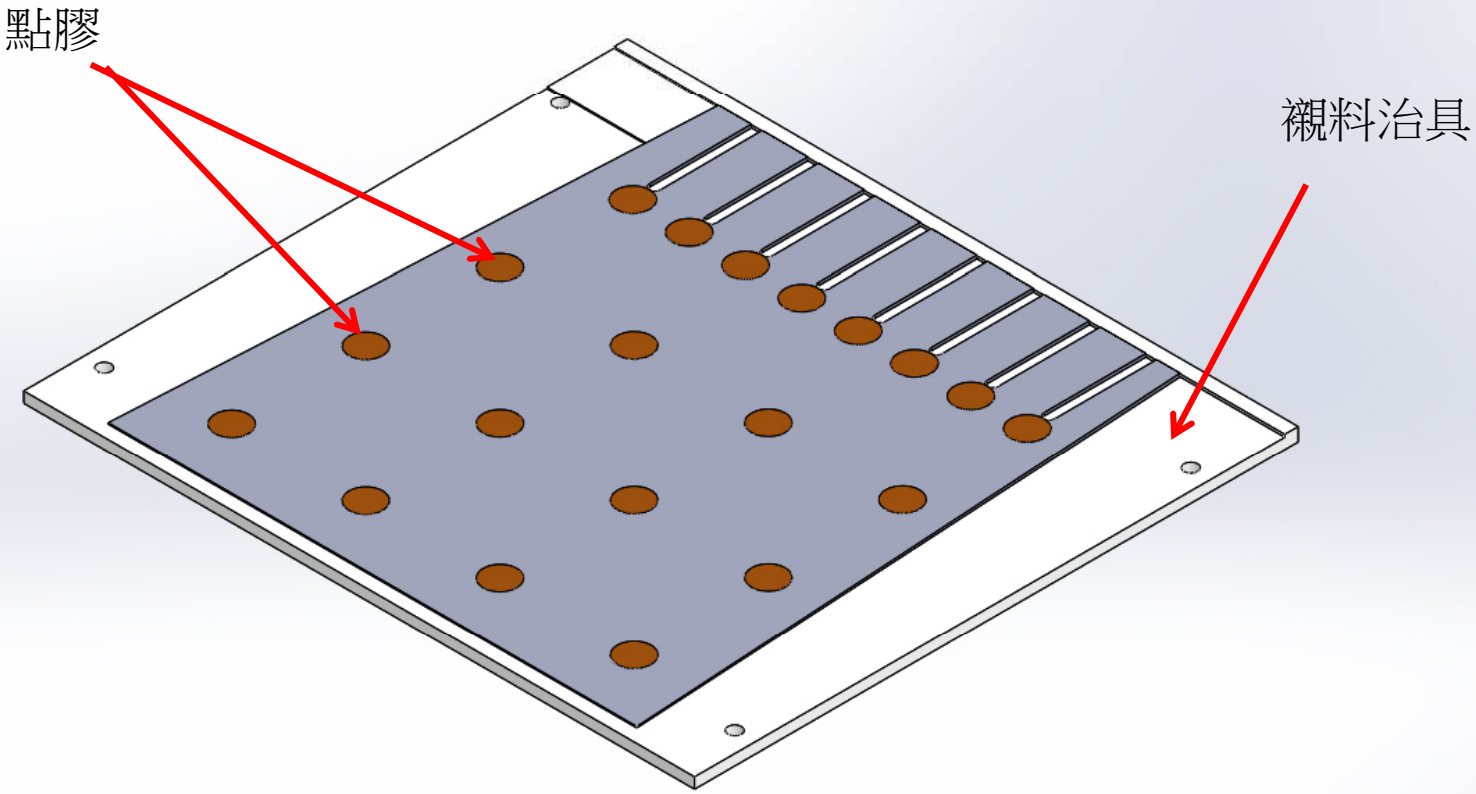


經過外型加工



沖切加工

防磨襯布點膠



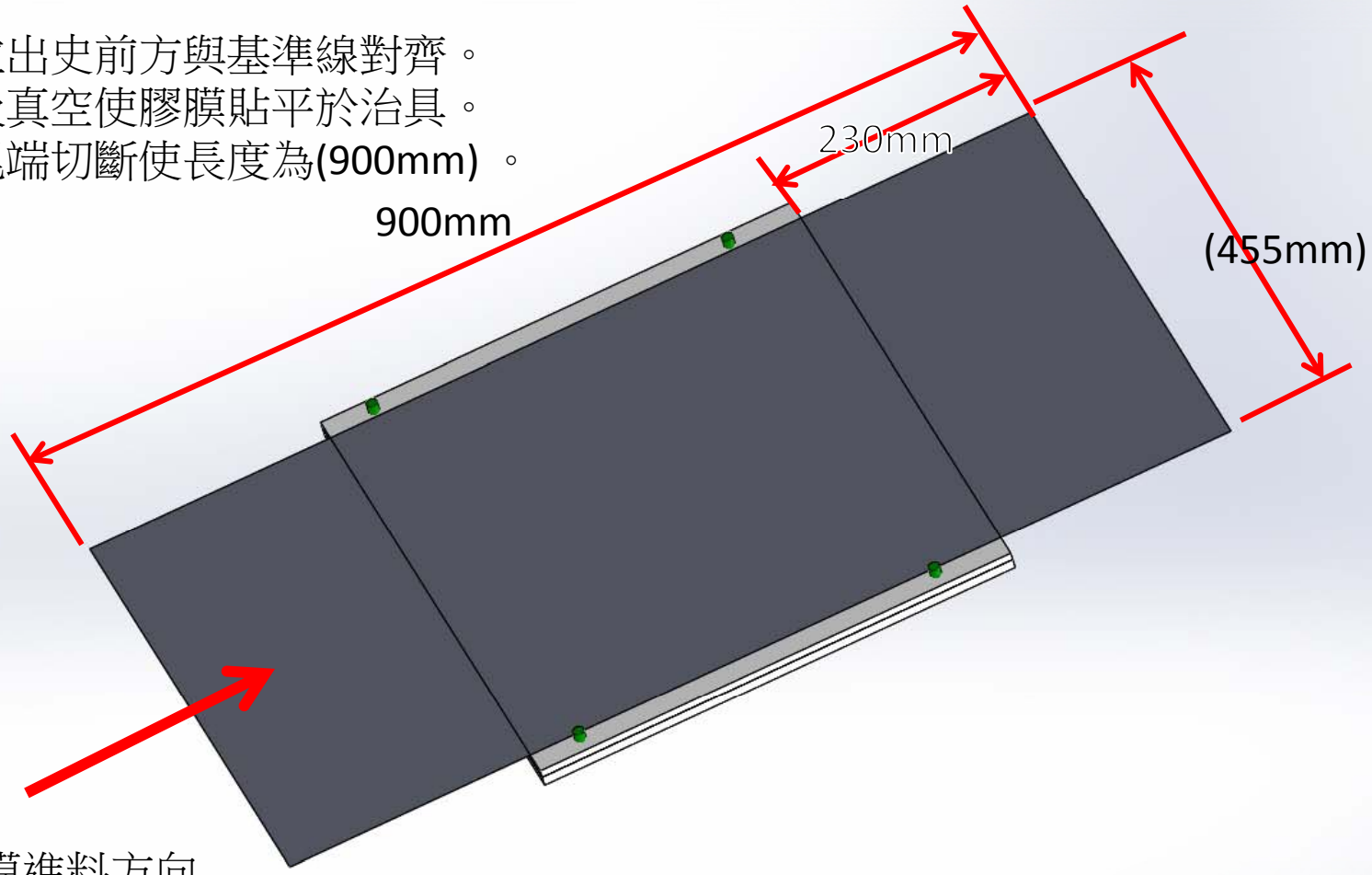
膠膜動作

步驟：

1.將膠膜拉出史前方與基準線對齊。

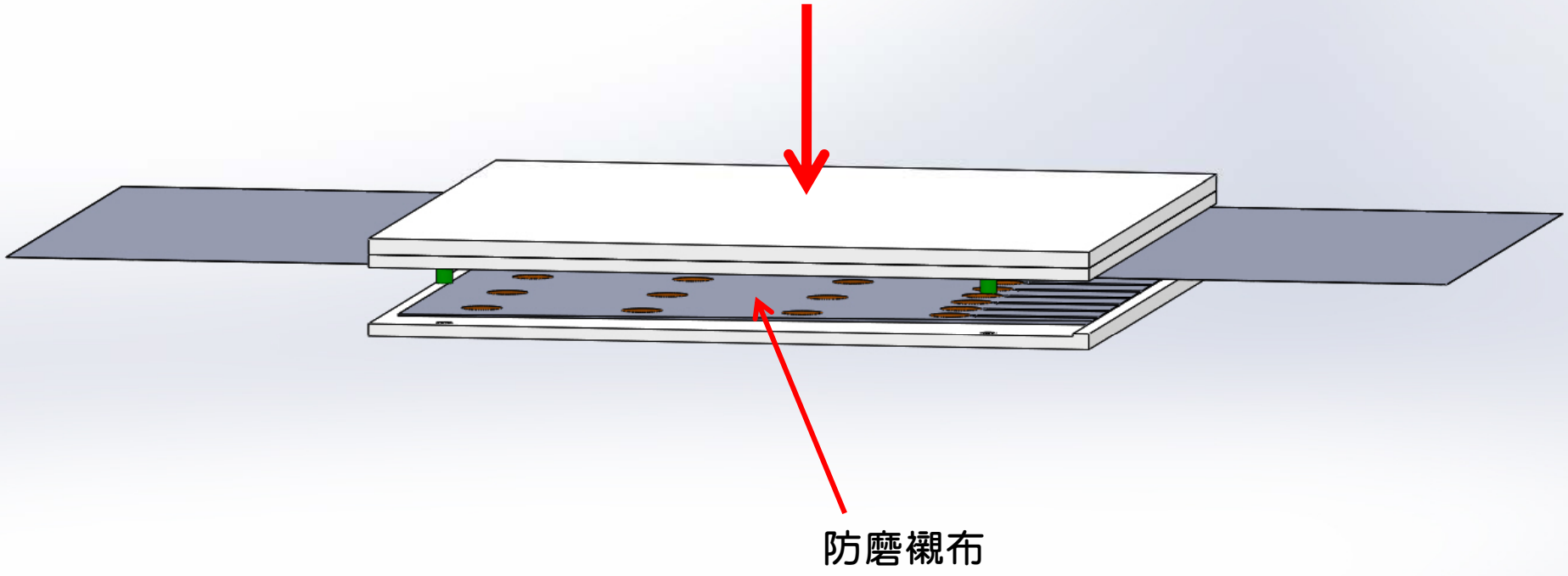
2.將治具吸真空使膠膜貼平於治具。

3.將膠膜尾端切斷使長度為(900mm) 。



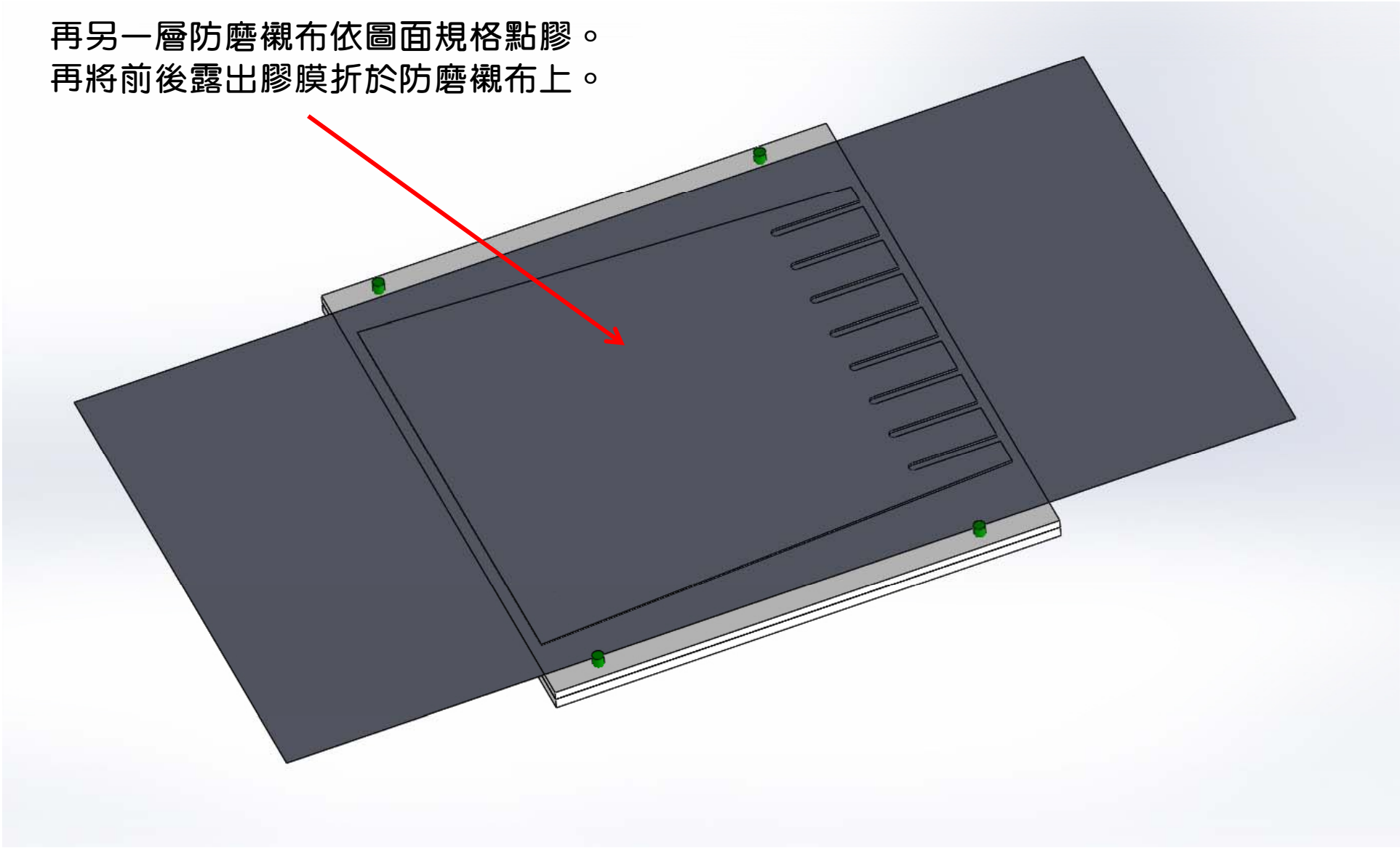
襯布與膠膜結合動作

將上製成動作治具壓在點膠後的襯布上。



承上製程將治具反正

再另一層防磨襯布依圖面規格點膠。
再將前後露出膠膜折於防磨襯布上。



承上製程依圖面說明動作