

AUTO BUSSING MACHINE

全自动叠焊机

功能描述

- 节拍快：常规组件节拍 $\leq 15s$ 。
- 纠偏范围广： $\pm 30mm$ ，理片精度 $\leq 0.3mm$ ，支持叠串一次纠偏。
- 维修空间敞亮，切单时效快：30min-60min。
- 汇流条上料不停机。
- 虚焊检测功能。
- 助焊剂具有流量监测功能，喷头堵塞时开启反吹。
- 兼容50公斤以下汇流条。
- 旁路焊跳线采用模块化设计，可根据需要选配。
- 汇流条冲孔，刮黑漆（激光）功能可选配。

Features

- High-speed cycle time: $\leq 15s$ (conventional module).
- The deviation correction range $\pm 30mm$, cell accuracy $\leq 0.3mm$, the lamination is supported for one-time deviation correction.
- Maintenance space clear, cutting single aging fast: 30min-60min.
- Bus bar feeding non-stop.
- With virtual welding detection function.
- The flux has a flow monitoring function, and the backflush is turned on when the nozzle is blocked.
- Compatible with $\leq 50kg$ bus bar.
- Bypass welding jumper adopts modular design, can be optional.
- Bus bar punching, black paint scraping (laser) function is optional.



设备技术性能

电池片规格：156*156-230*230(mm)/5BB-24BB
 汇流带规格：卷状供料，料厚0.20-0.45(mm)，宽4/5/6/7/8(mm)
 焊带卷重量：大卷料卷50kg
 组件节拍：15s
 拉脱力与焊接效果：5BB $\geq 4N$ ，MBB $\geq 2N$
 纠偏特性：理片精度高 $\leq 0.3mm$ ，纠偏范围广 $\pm 30mm$
 视觉检测：头中尾共配置相机15个，支持叠片纠偏
 焊接方式：电磁焊接
 选配功能：单跳线、引出线冲孔、引出线冲圆角，引出线激光除黑漆、虚焊检测、换料不停机



Functionality

Cell specification: 156*156-230*230(mm)/5BB-24BB
 Bus-bar specification: roll feeding, material thickness 0.20-0.45(mm), width 4/5/6/7/8(mm)
 Welding tape reel weight: 50kg for large reel
 Cycle time: 15s
 Pull-off force and welding effect: 5BB $\geq 4N$, 9BB $\geq 2N$
 Correction characteristics: high cell precision $\leq 0.3mm$, wide correction range $\pm 30mm$
 Visual inspection: 15 cameras in the head, middle and tail, supporting lamination correction
 Welding method: electromagnetic welding
 Optional functions: single jumper, lead line punching, lead line rounding, lead line black paint scraping(laser), virtual welding detection, non-stop refueling



技术参数 Specifications

项目 Item	数值 Value
适用玻璃尺寸 Applicable glass size	1640*2650(mm), 900*1500(mm)
节拍 Cycle time	$\leq 15s$
功率 Power	峰值50kW, 平均功率约30kW Peak 50kW, average power about 30kW
电源 Power requirement	AC380V $\pm 5\%$, 3P+1N+1PE (3相5线制 3-phase 5-wire system)
气源 Air pressure	0.5-0.8(MPa)的干燥、干净压缩空气; 用量: 2m ³ /min 0.5-0.8(MPa) dry and clean compressed air; dosage: 2m ³ /min
重量 Weight	7000kg
外形尺寸 Dimension(L*W*H)	5635*2840*2450(mm)