

Pre-Treatment Plant VBA 6-353/453/D23

The pre-treatment plant serves to clean and prepare the steel blanks of grinding tools for the subsequent diamond or CBN electro-plating process.

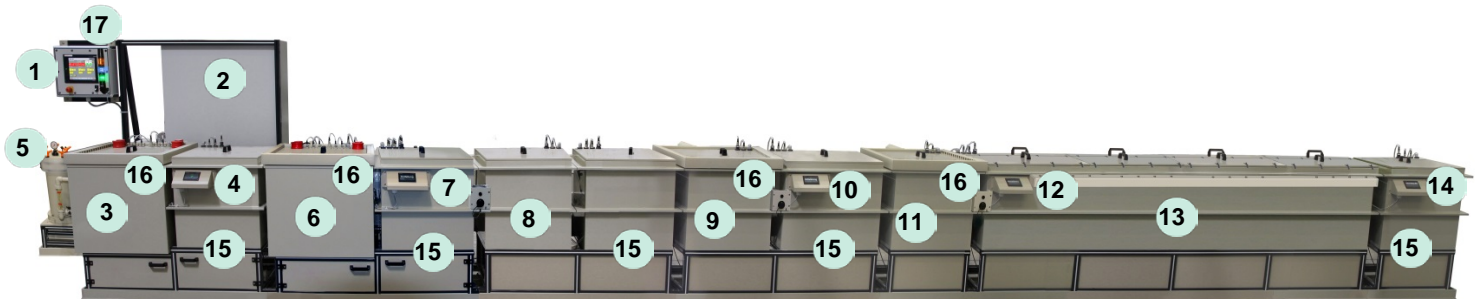
Pre-treatment comprises two warm-process baths: preliminary degreasing with oil separator and electrolytic degreasing. Furthermore it comprises 3 cold-process baths: decapation, activation and Nickelstrike as well as the intermediary rinsing baths.

The parts – already fitted into the corresponding contact and holding fixtures – are transported from one bath to the next in the sequence of the single process steps.

For temporary storage of the processed parts an active-keeping buffer is provided.

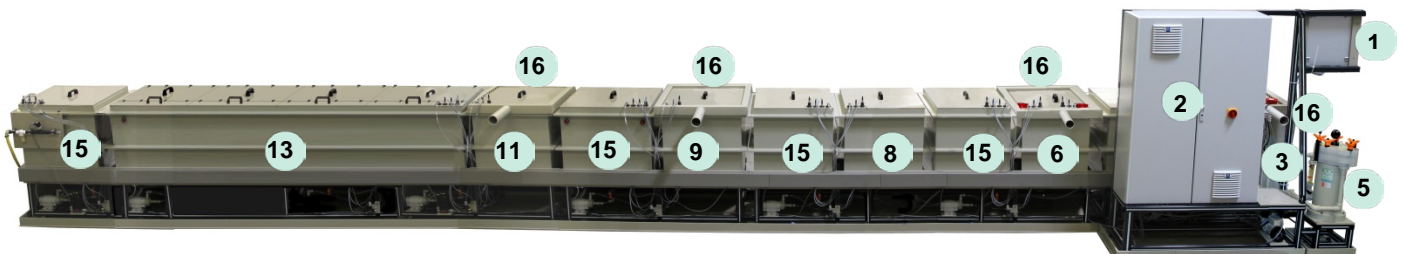
Programming and pre-set of the process and bath parameters is done by means of the Touch screen operator terminal. To control the individual process steps each process bath is fitted with a corresponding control panel.

Front view



- | | |
|--|---|
| 1. Process-bath control PBS-845/001 including Touch screen operator terminal for process control and programming:
- Temperature
- Current
- Voltage
- Process time
- Heating cycles | 6. Warm-process bath (electrolytic degreasing – anodic/cathodic; polarity reversible) |
| 2. Electronics cabinet (Service access on rear side) | 7. Process control panel for electrolytic degreasing |
| 3. Warm-process bath (preliminary degreasing) | 8. Cold-process bath (Decapation) |
| 4. Process control panel for preliminary degreasing | 9. Cold-process bath (Activation) |
| 5. Oil separator of preliminary degreasing | 10. Process control panel for activation |
| | 11. Cold-process bath (Nickelstrike) |
| | 12. Process control panel for Nickelstrike |
| | 13. Active-keeping buffer |
| | 14. Process control panel for active-keeping buffer |
| | 15. Standing sink (5 pcs) |
| | 16. Rim exhaustion (4 pcs) |
| | 17. Signal lamp |

Rear view

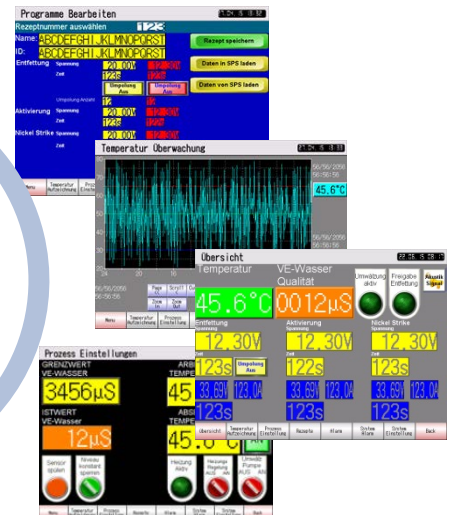


Technical data:

- Bath volume: Process baths: appr. 180 l each; rinsing baths: appr. 180 l each active-keeping buffer appr. 750 l.
- Bath temperature: max. 80°C (preliminary degreasing); 60°C (electrolytic degreasing bath); room temperature (all other baths)
- Dimensions (L x W x H): appr. 9100 x 708 x 1000 mm
- Power ratings: appr. 20 KVA, 3 x 400 V, 3 x 16 A, 50 Hz
- Warm-process baths of PP, heat insulated,
- Cold-process and rinsing baths of PP
- Pipes of PP
- 1 centrifugal pump each to circulate the warm-process baths
- Rim exhaustion for process baths (connection to fan, DN 76 mm)

Optional:

- Level stabilisation of process baths
- Flow-standing sink technology in the rinsing baths
- Expansion possible to a semi-automatic pre-treatment plant VBA 6-355/455/D45



Pre-set and monitoring of the process and bath parameters by means of the Touch screen operator terminal (PBS-845/001 control)



Control panel for process control (Example: degreasing)

