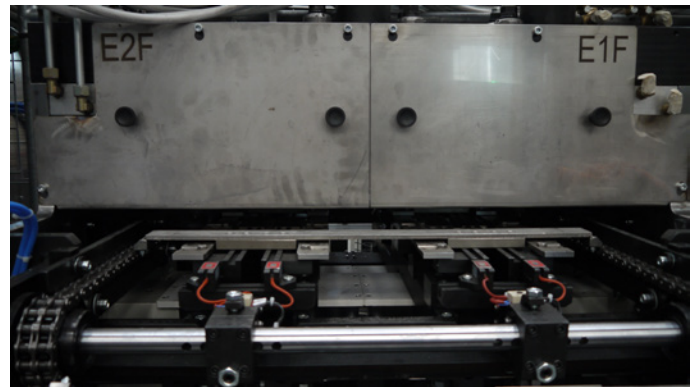
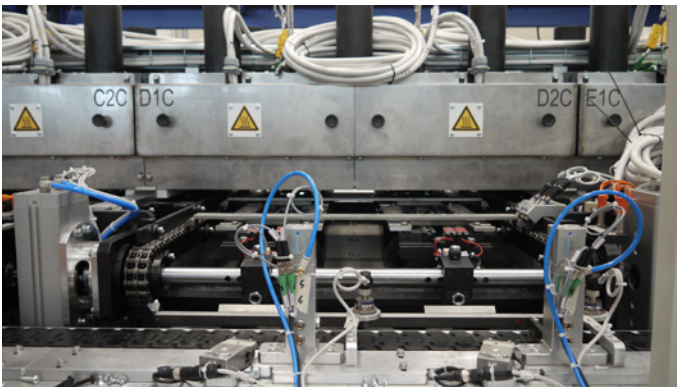


SCORCHING MACHINE 10 WORK TRACKS

MAIN FUNCTION

Carry out the scorching treatment on the friction surfaces of the brake pads.



DESCRIPTION

The sequence of operations starts with the feeding of brake pads toward special stops, for buffering; then brake pads are positioned on the working surface by a tilter unit.

Next, the brake pads are drawn onto a hot-plate unit, where a pushing unit compresses them and the first scorching step is performed; in the second step the brake pads, already submitted to the previous treatment, are conveyed to the cold-plate station, where the pads are cooled and their original parallelism is restored.

The finished parts are automatically unloaded to the exit conveyor belt.

The machine is also equipped with setting controls,

which make it universal and therefore suitable to accept any type of brake pad; it is only necessary to know the part size limits.

SPECIFICATIONS

WORKING CYCLE
AUTOMATIC

IN: automatic brake pad feed on loading conveyor belt.

OUT: automatic brake pad unloading through exit conveyor belt.

The cycle time is conditional upon two factors: the first factor, quantified in 5 seconds, is characterised by

the sorting of brake pads feeding from the hot station towards the cold station, while the second factor depends on the brake pad sizes, therefore on the time required for the scorching operation, normally ranging from 30 to 60 seconds.

$$T_{tot} = T_1 + T_2 = 7 + 30 = 37 \text{ sec.}$$

(in 35 seconds, the machine can work simultaneously n°10 brake pads)

HOURLY OUTPUT

~ 973 pcs/hour (at 100% efficiency).

HOT STATION

Operative temperature of plates: 750° C (adjustable).
Operating pressure of plates: variable between 1000 N and 4000 N a 6 bar.

COLD STATION

Operative temperature of plates: 25° C (obtained by circulating industrial water inside the plates).
Operating pressure of plates: variable between 5000 N and 29000 N a 6 bar.

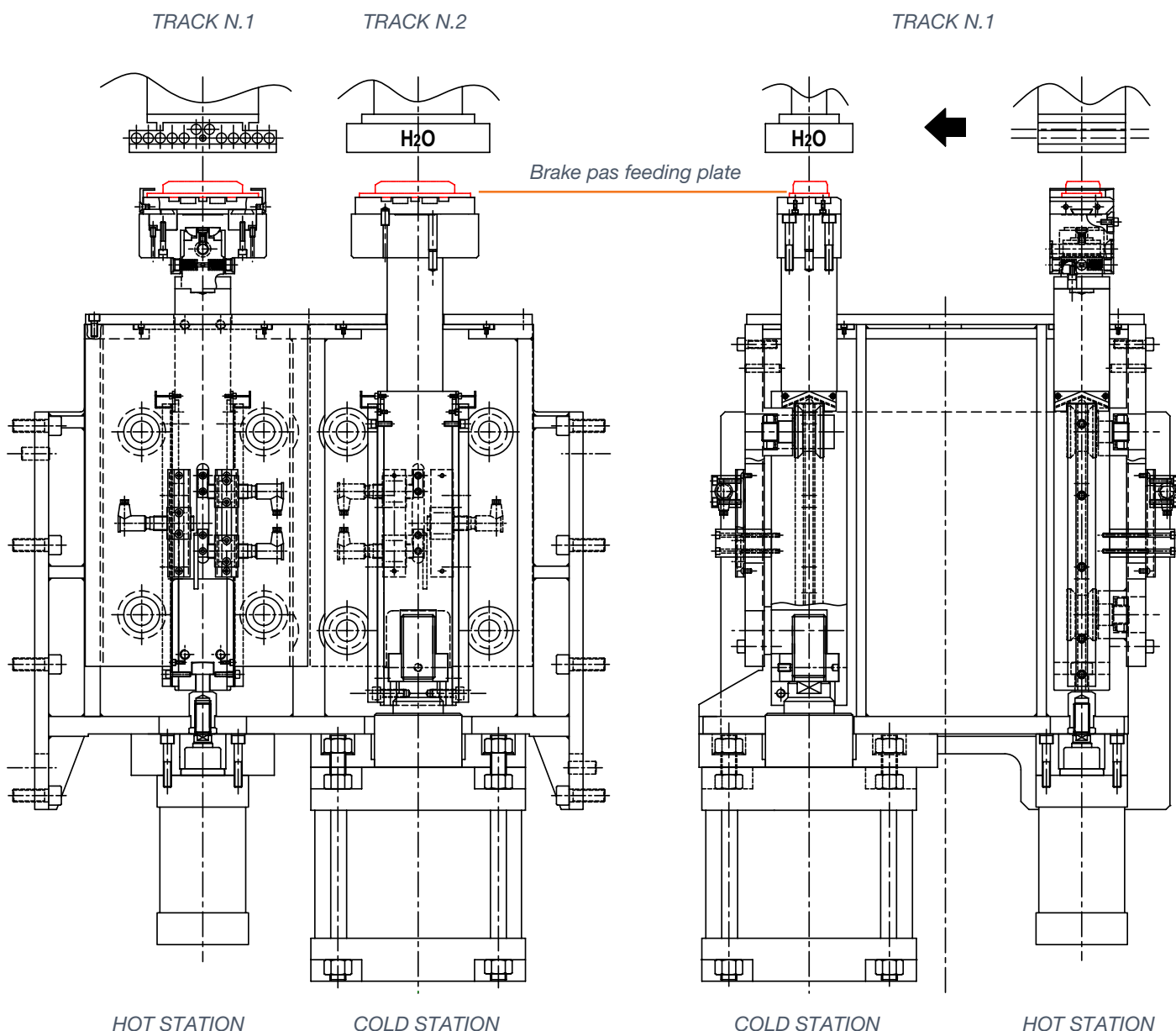
FUNCTIONING PLANT

Overall dimensions on the ground: 6500 x 2400 x h 2100 mm, weight: ~ 15000 Kg.

SAFETY GUARDS

Structure consisting of extruded aluminium alloy section bars, oxidised, and steel wire net gratings, provided with n°10 openings, fitted with safety microswitches with positive lock, equally distributed on the front and rear sides of the machine, in order to have direct access to the 4 working modules.

DIAGRAM



WORKING BRAKE PAD SIZES

LENGTH	min [mm]	60
	max [mm]	220
WIDTH	min [mm]	30
	max [mm]	110
THICKNESS	min [mm]	15
	max [mm]	30
MATERIAL	special friction mix	



Machined pads