

产品方案书

PRODUCT SOLUTION

Model: ZY-B1(JCX)D

左/右半 J 型 Left/right half J	中间 J 型(牛角型) Middle J shape (horn)	直通 J 型 Full J shape	直通 C 型 Full C shape	斜边 (斜直) Bevel (Bevel Straight)	钻石型 Diamond	水滴型 Waterdrop

共用一种尺寸槽型款 槽型尺寸大小一样
SHARE THE SAME GROOVE SHAPE AND SIZE

各种形状板厚 屏幕一键切换即可 不用调节
ONE CLICK SWITCH ON THE SCREEN FOR VARIOUS SHAPE NO NEED ADJUSTMENT

18mm	22mm
------	------

形状 Shape	左右半 J、中间半 J、直通 J C、钻石型、水滴型 Left/right half J shape-Middle half J shape-Full J/C-Diamond shape-Water drop shape		斜边 (斜直)
板厚 Thickness	18mm	22mm	18/22/25mm

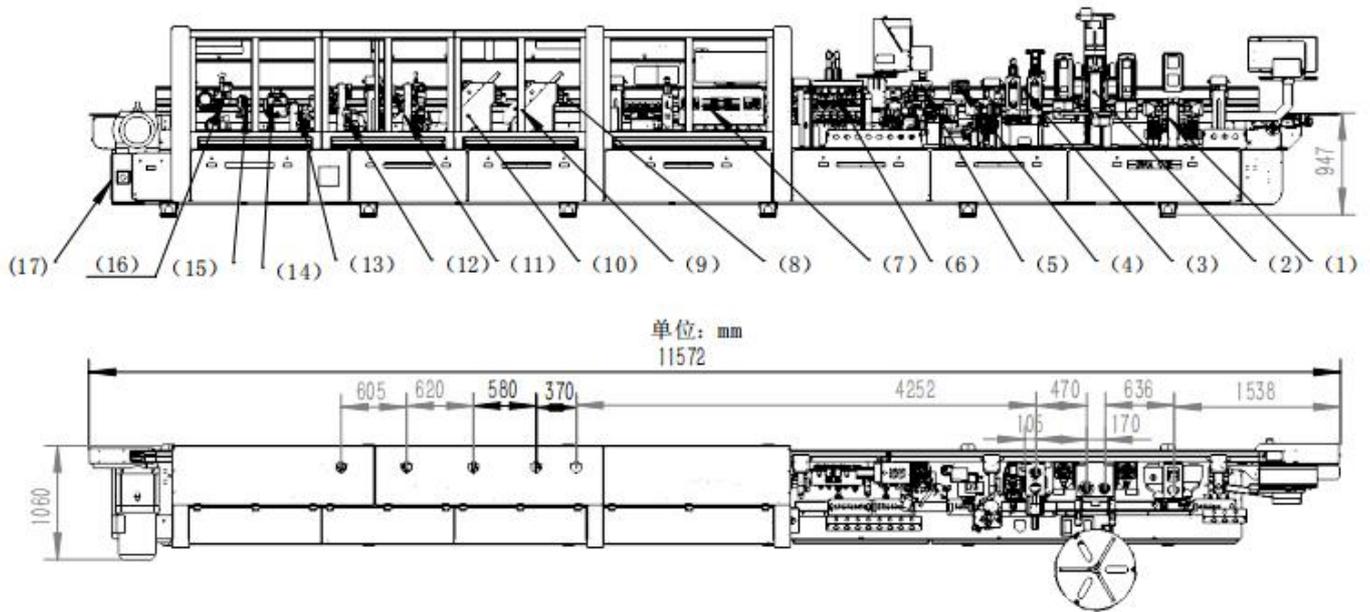
2025. 05. 16

一. 产品介绍 Product introduction

型号 Model: ZY-B1 (JCX)D

功能配置示意图, 尺寸配置仅供参考, 以实际为准.

Functional configuration figure and size for reference only, base on actual condition.



工艺流程: 分离 (1) 预铣 (2) 伺服成型铣 (3) 辅助铣 (4) 板涂胶 (5) 带涂胶 (6) 斜边压贴 (7) 成型压贴 (8) 预粗修 (9) 齐头 1 (10) 齐头 2 (11) 粗修 (12) 精修 (13) 下刮边 (14) 斜边平刮 (15) 柔性平刮、清洁 (16) 抛光 (压轮输送)

Process technology: Spray separate agent (1)Pre-milling (2)Servo profile milling (3)Assist milling (4)Panel gluing (5)PVC tape gluing (6)Bevel pressing (7)Profile pressing (8)Rough pre-trimming (9)End cutting 1 (10)End cutting 2 (11)Rough trimming (12)Fine trimming (13)Down scraping (14)Bevel flat scraping (15)Flexible flat scraping & Cleaning (16) Buffing (Press wheel conveying)

二. 主要参数 Main parameters

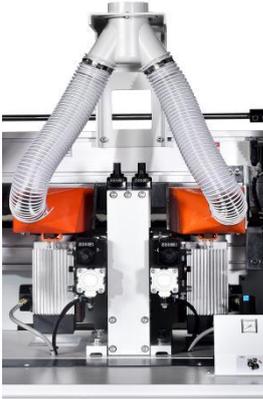
(打*数据以实际为准 with* data based on actual condition)

型号 Model	ZY-B1 (JCX)D
工作气压 Working pressure	0.6MPa
*总功率 Total power	64kw
进给速度 Feeding speed	7m/min
加工形状 Process profile available	1) 左右部分小角度 J 型 Left/right partial small angle J; 2) 左右部分大角度 J 型 Left/right partial big angle J; 3) 直通 Full J; 4) 直通 Full C; 5) 中间小角度 J 型 Middle small angle J shape;

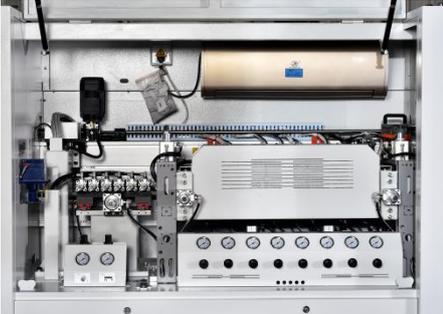
	6) 中间大角度 J 型 Middle big angle J shape; 7) 左右部分钻石 J 型 Left/right partial diamond J shape; 8) 左右部分水滴 J 型 Left/right partial water drop shape;	
板料厚度 Panel thickness	J/C shape 型: 18/22mm 斜边 Bevel shape X (见附图 45 degree see figure)	
板料最小尺寸 长*宽 (其中长为封面) Panel minimum size L* W (L is edge banding)	1) 左右部分小角度 J 型 Left/right partial small angle J; 2) 左右部分大角度 J 型 Left/right partial big angle J; 3) 直通 Full J; 4) 直通 Full C; 5) 中间小角度 J 型 Middle small angle J shape; 6) 中间大角度 J 型 Middle big angle J shape; 7) 斜边 X bevel edge;	≥ 300*150mm
	8) 左右部分钻石 J 型 Left/right partial diamond J shape; 9) 左右部分水滴 J 型 Left/right partial water drop shape;	≥ 450*150mm
封边带厚度 Edge banding tape thickness	J/C shape 型 0.52-0.54mm 斜边 X bevel edge 0.8-1.5mm	
封边带材质 Edge banding tape material	PVC 建议用麻面或木纹面、柔韧性好材质 PVC Pitted or wood surface with good flexibility suggested	
*外形尺寸 Overall size	11572*1200*2000mm	
*重量 Weight	5400kg (参考值 reference value)	
工控一体机 Industrial control integrated machine	21.5" 电容触摸平板电脑 21.5' Capacitive touch panel computer	
	运行内存 4G/硬盘 64G Running memory/ hard disk	
	Win10 操作系统 Operative system	
	数据端口开放、支持网络连接 Data port open, network connection supported	

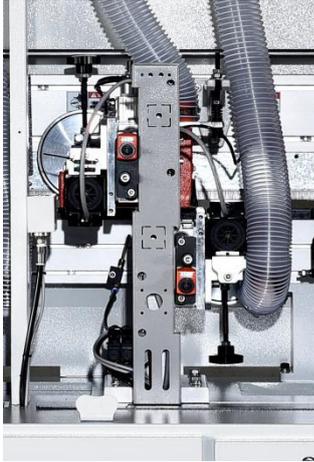
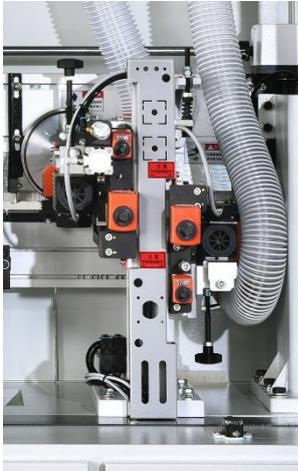
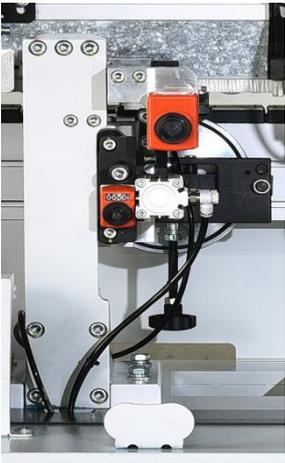
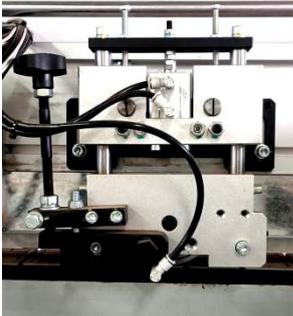
三、功能作用 Function introduction

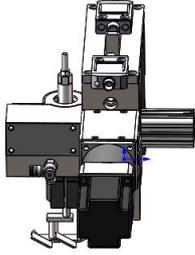
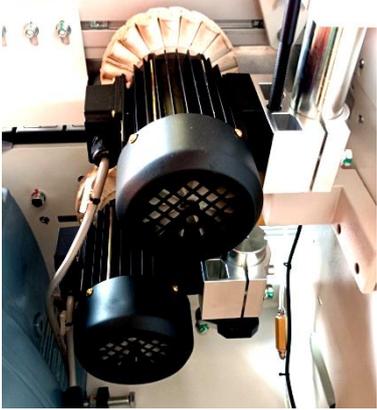
序号 No	功能单元 Function unit	参考图片 Reference Image	功能介绍 Introduction
1	操作界面 Interface		1) 21.5" 电容触摸平板电脑 Capacitive screen touch panel computer 2) 运行内存 4G/硬盘 64G Running memory/hard disk 3) Win10 操作系统 Operation system 4) 数据端口开放、支持网络连接 Data port open, network connection support 5) 所有功能设置了一键启动, 操作简单 All function setting with one clip starting, easy operation

2	<p>分 离 Separate agent spray</p>		<p>在板材涂胶前,对板材上下面喷分离剂,使得胶水同板材不沾 Spray separate agent before panel gluing to avoid pasting.</p>
3	<p>预 铣 Pre-milling</p>		<p>采用双 2.2KW 高频电机;将工件涂胶面铣削平整。有效消除崩边,减少胶线,封边效果更美观 Use double 2.2kw high frequency motor, the cut the edge banding side to be flat by milinng, to avoid edge damage and reduce glue line, makes the effectness look more beautiful.</p>
4	<p>成型铣 Profile milling</p>		<p>1) 铣刀电机:配 9kw,分正反铣刀。铣刀均采用金刚石材质,刀具更佳耐用,噪音小。 Milling cutter motor, equipped with 9kw, with forward and reverse cutter, which use diamond material, to make cutters more durability, and less noise.</p> <p>2) 伺服控制直接电脑屏幕一键切换调节铣刀前后上下,智能操控,无需手动调节,效率高 Servo control the screen of the computer directly, one clip to replace and adjust the cutter forward,reverse,up and down, intelligent control, no need adjustment manually, with high efficiency.</p>
5	<p>辅助铣 Assist milling</p>		<p>对造型进行精铣,使得造型更美观 Fine milling for the profile,and makes it more pretty.</p>

<p>6</p>	<p>带开槽 Tape slotting</p>		<p>对斜边转角处封边带开一道小槽，易于贴成型，更美观 Slot a line at the corner of the bevel edge tape, makes it easy to profile pressing and looks more pretty.</p>
<p>7</p>	<p>涂胶 Gluing</p>		<p>1) 涂胶方式采用封边带上涂胶 Gluing method is gluing onto the banding tape 胶锅是上置胶锅装置，自动吸胶到快速预溶盒在通过预溶盒把胶水打入胶锅，上置胶锅优势胶水不会碳化，胶线会更小。Glue pot is upper device, suck the adhesive automatically into the pre-melting box, where it pump the adhesive into the pot. The advantage of upper pot will not carbonize, and adhesive line would be smaller.</p> <p>2) 此结构设计是我公司申请专利技术，可防止封边条容易跑偏，卷带现象。 This mechanism design is our patent technology, it can avoid tape deviation and winding.</p> <p>3) 此涂胶方式为，造型部分为带涂胶，直边为板涂胶，两种涂胶方式结合使得粘贴更牢固，封边更稳定。The gluing method is tape gluing for the profile part, and panel gluing for the straight part. Both methods make the lamination more firmly, stable for the edge banding as well.</p>

<p>8</p>	<p>斜边压贴 Bevel pressing</p>		<p>斜边压贴装置:对直边部分和斜边部分采用交替压贴成型,使得粘贴更牢固。 Bevel profile pressing device: rotatory profile pressing for the part of straight and bevel, make the lamination more firmly.</p>
<p>9</p>	<p>成型压贴 Profile pressing</p>		<p>软成压贴装置:采用浮动贴合多组压轮,使得粘贴更吻合,更牢固,该结构申请专利技术,对应的形状从送带到压贴一次成型,无需人工调节,各种形状操作界面一键选择即可自动切换。 Pressing device: use multiple group pressing wheel for float lamination, make it more coincide and firmly. This technology has applied patent right. the corresponding shape from feeding to pressing for one time forming, no need adjustment manually, every profile can be one clip switch on the operative interface.</p>
<p>10</p>	<p>预粗修 Rough pre-trimming</p>		<p>通过此机构将上面封边条进行初步铣削,减少后续修边铣削量,使得修边更稳定美观。 Use this mechanism to primary milling the up tape, to reduce the amount of trimming for next step, makes the trimming more stable and beautiful.</p>
<p>11</p>	<p>齐头 End cutting</p>		<p>齐头共配2个电机,分为前齐头,后齐头,用于齐平封边端面。此机构采用特殊锯片,使得切削面更平整。Equipped with 2 motors, including head cutting and tail cutting, cuts edges to be flat. This mechanism uses special sawing blades, which makes the cutting sides to be more flat.</p>

<p>12</p>	<p>粗修 Rough trimming</p>		<p>此机构刀具为平刀，削去板材多余的封边带，主要铣削异形上封面多余边带。 This mechanism is flat blade tool, which removes the excess tape on the special shape by milling.</p>
<p>13</p>	<p>精修 Fine trimming</p>		<p>修边带独立定位独自调出完美圆弧效果。调节进退是采用滑块导轨方式，调节精准高，长时间使用稳定。Adjust perfect arc effectness by trimming tape positions dependently. Use slider rail way to adjust forward and backward, with high precise, long time stable using.</p>
<p>14</p>	<p>下刮边 Down edge scraping</p>		<p>对斜边下直边刮边，刮除精修刀纹，使得转角更圆润美观 Scrap the down straight edge, makes the corner look more rounded and more beautiful.</p>
<p>15</p>	<p>斜边平刮 Bevel edge flat scraping</p>		<p>对斜边上封边面刮边，使得效果更佳。 Scrap the top edge of the bevel, makes the effectness much better</p>

13	<p>伺服刮刀 Servo scrapper</p>		<p>自动刮除封边后板材表面多余胶水以及多余边条，使得表面更平整干净。 Automatically remove redundant glue and tape by scraping after edge banding, makes the surface flatter and cleaner</p>
14	<p>清 洁 Cleaning</p>		<p>在抛光之前喷涂清洁油性水雾,用来减少胶线和板材污染的问题，提高封边质量 Spray oil water mist before buffing, to reduce pollution between glue line and panel, enhance the quality of edge banding</p>
15	<p>抛 光 Buffing</p>		<p>抛光封边面，使得效果更漂亮 Buffing the edge banding surface, makes th effectness more beautiful.</p>
16	<p>输送电机 Conveyor motor</p>		<p>输送电机采用 7.5KW 变频调速 Adopts 7.5kw frequency control motor for the conveyor</p>

四. 配件品牌 Spare part brand

序号 No	配件名称 Name	品牌名 Brand name	品牌图片 Logo
1	交流接触器 AC contractor	德国 Germany / 西门子	
2	齐头气缸 Pneumatic cylinder for end cutting	日本 Japan / SMC	
3	中间继电器 Intermediate relay	日本 Japan / 欧姆龙	
4	旋转编码器 Rotary encoder	韩国 South Korea / 奥托尼克斯	
5	PLC	韩国 South Korea / LS	
6	气动元件 Pneumatic Spare parts	台湾 Taiwan/ 亚德客	
7	变频器 Frequency converter	台湾 Taiwan / 台达	
8	工控一体机 Industrial control integrated machine	中国 China/ 源控	
9	齐头高速电机 High speed motor for end cutting	中国 China/长川电机	
10	粗修高速电机 High speed motor for rough trimming	中国 China/长川电机	
11	精修刀 Trimming cutter	金刚石材质 diamond material	***
12	刮边刀 Scraper	金刚石材质 material	***

五. 板型参数 Panel Profile Parameters

封边顺序要求：先封对立两个面或其中一个面异形，再封相邻面直边，不支持相邻面都封异形

Edge banding steps: special shape edge banding first, and then goes the neighbor straight edge; neighbor special profiles edge banding are not supported.

以下标注尺寸为木板封边前尺寸 The sizes below are for panels before processing:

1、部分 J 型（其中 A≥80）和全通 J 型板厚度：18mm

Partial J shape & full J shape with 18mm thickness panel

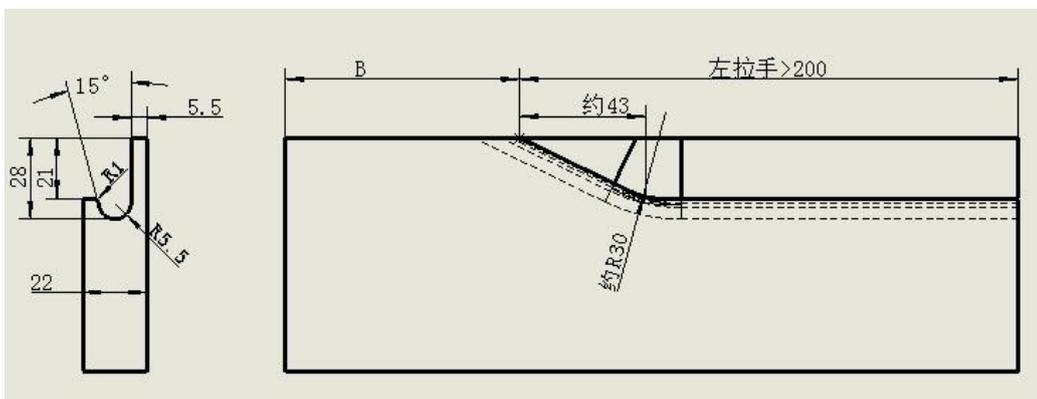
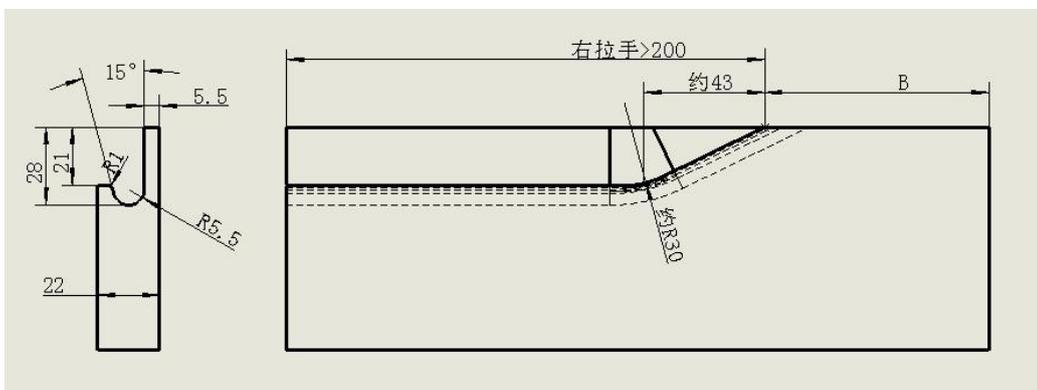
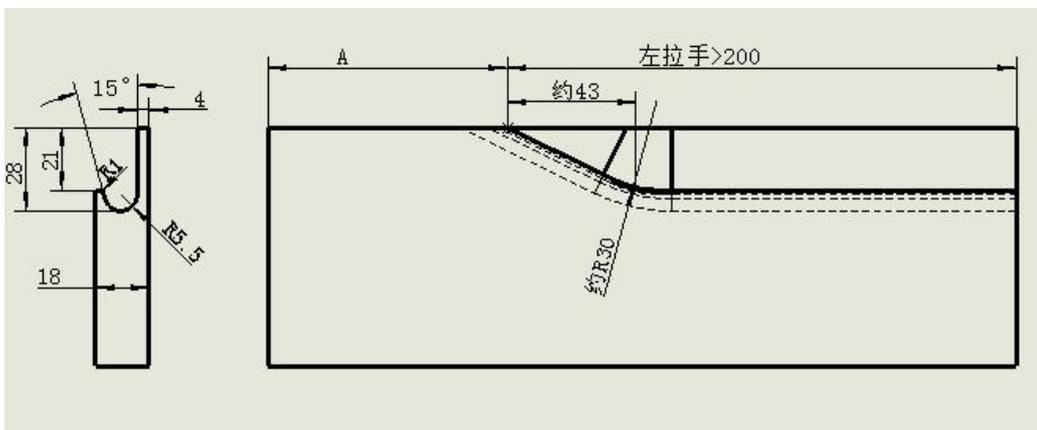
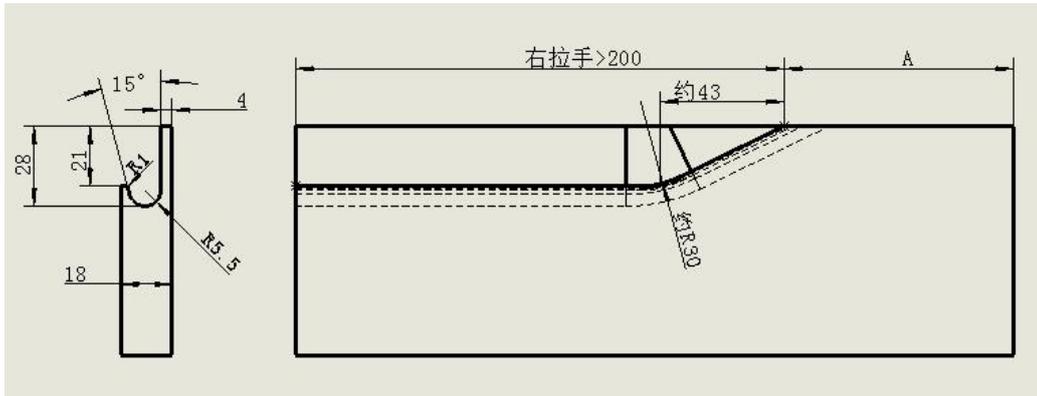
（封边带厚度 tape thickness: 0.52- 0.54mm），封边带宽度 tape width: 58mm;

部分 J 型（其中 A≥80）和全通 J 型板厚度：22mm

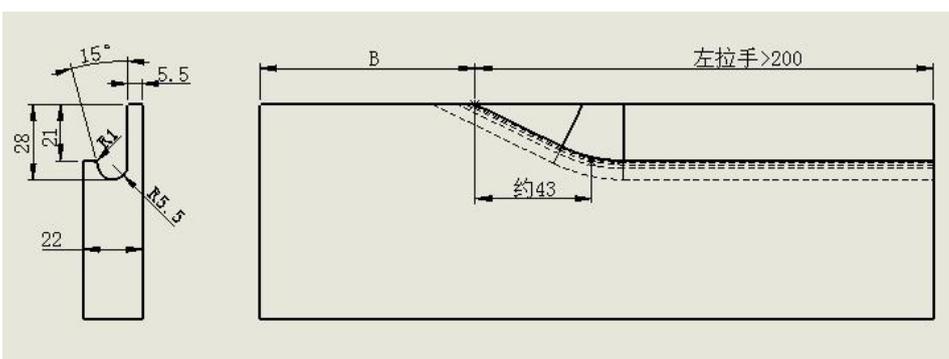
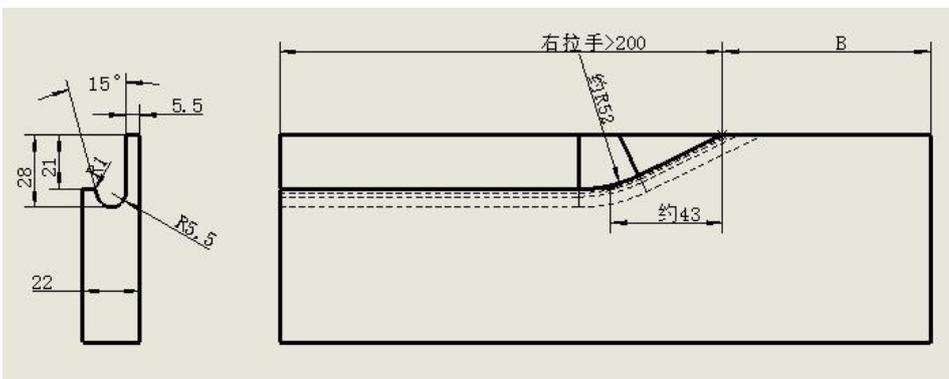
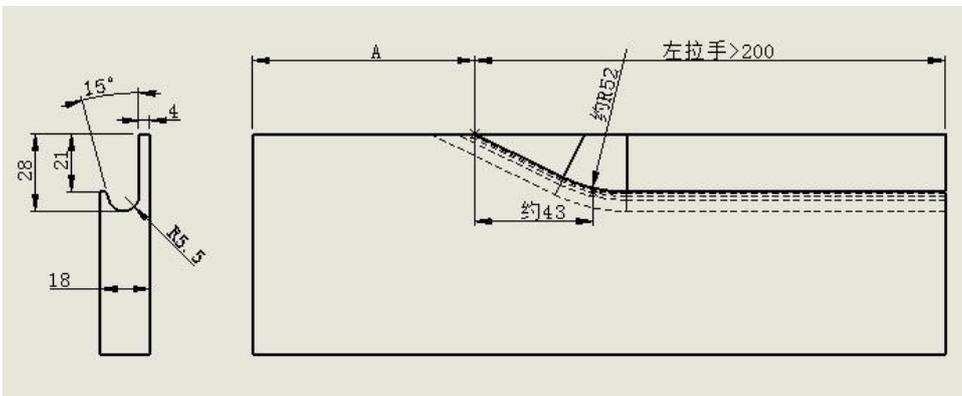
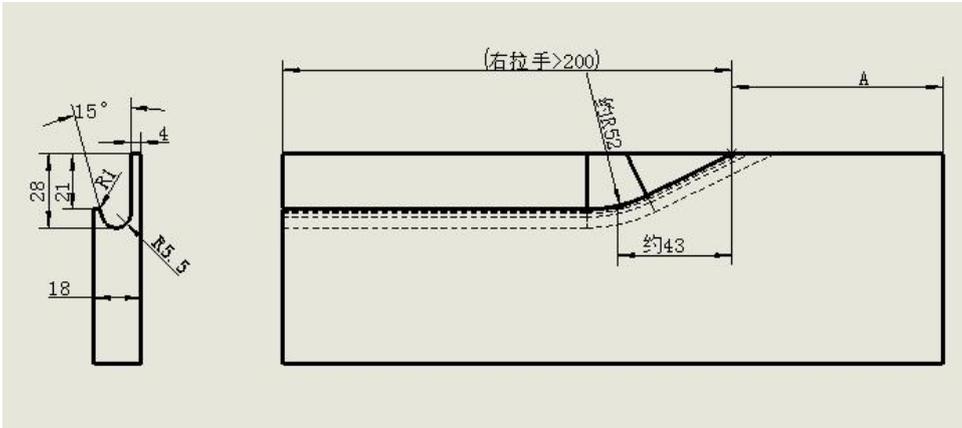
Partial J shape & full J shape with 22mm thickness panel

(封边带厚度 tape thickness: 0.52- 0.54mm), 封边带宽度 tape width: 58mm;

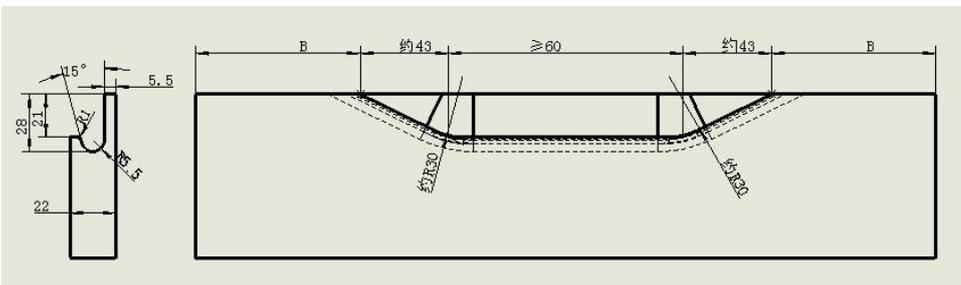
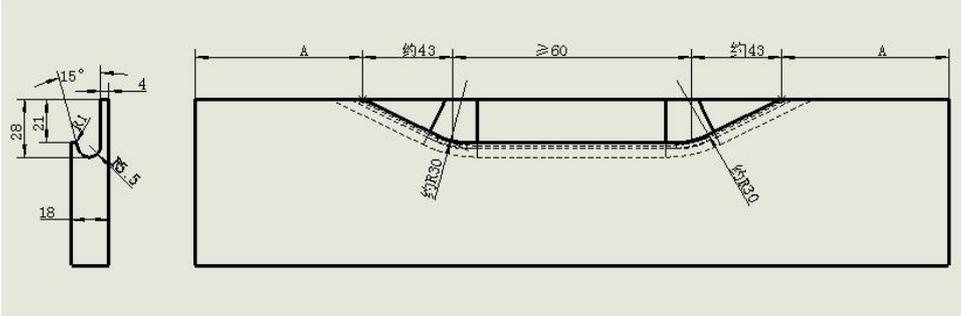
(1) 左右部分小角度J型 Left/right partial small angle J shape



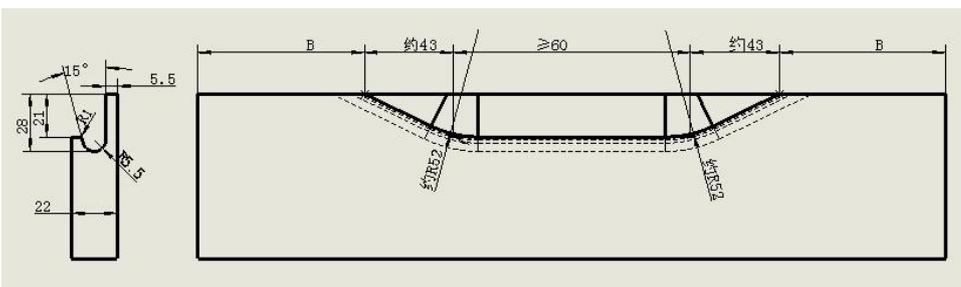
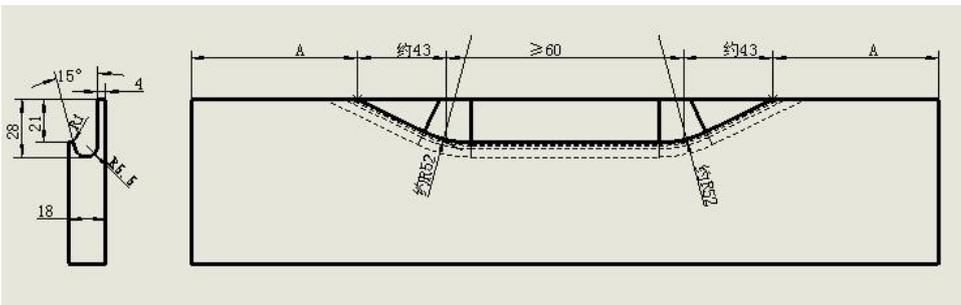
(2) 左右部分大角度J型 Left/right partial big angle J shape:



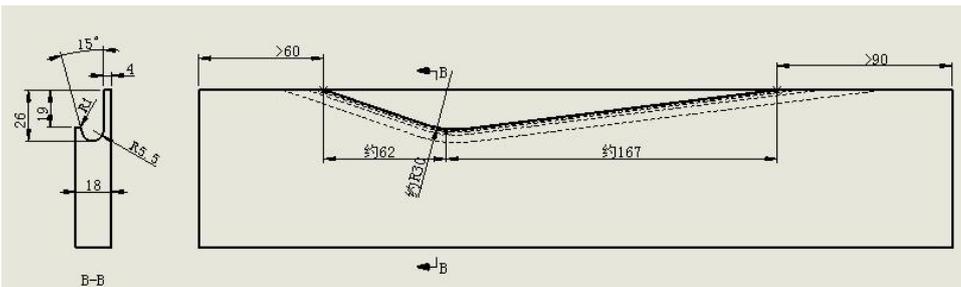
(3) 中间小角度J型 Middle small angle J shape:

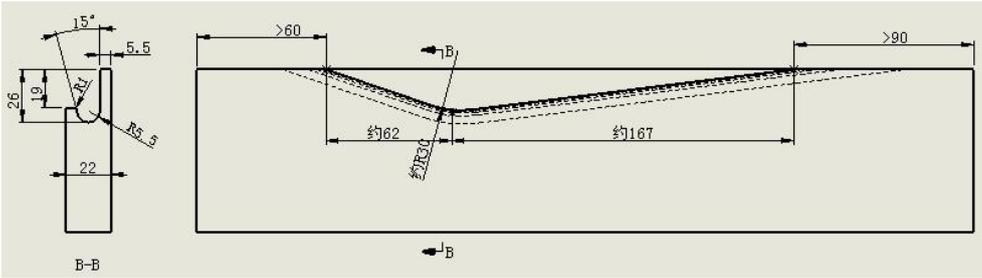


(4) 中间大角度J型 Middle big angle J shape:

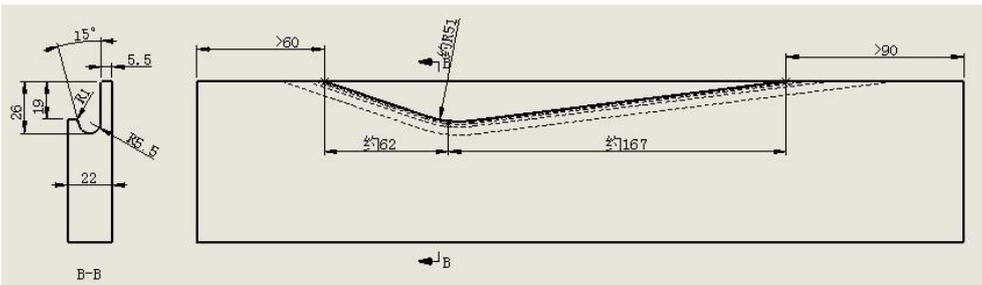
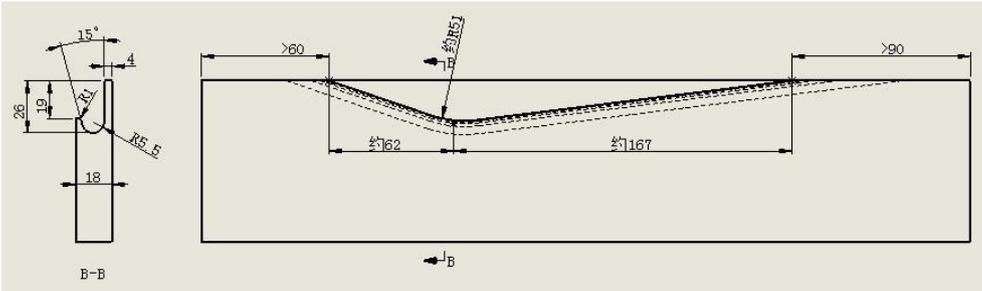


(5) 左右部分钻石J型 Left/right diamond J shape:





(6) 左右部分水滴 J 型 Left/right partial water drop J shape:

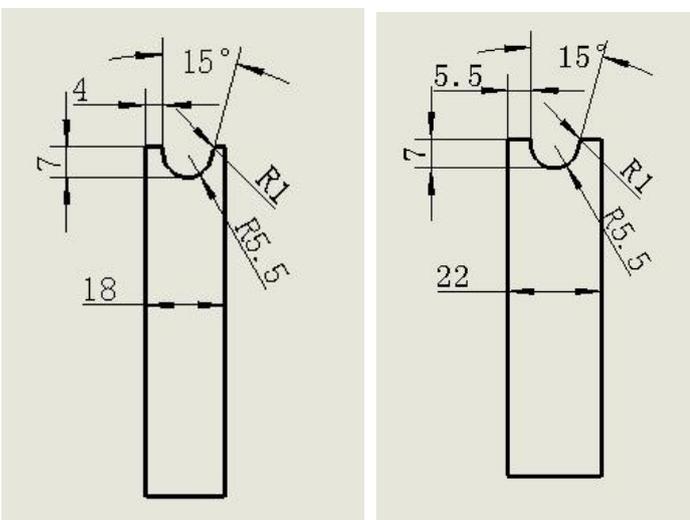


2、 全通 C 型板厚度 18 (封边带厚度: 0.52- 0.54mm), 封边带宽度: 42mm

Full C shape thickness 18mm(tape thickness: 0.52- 0.54mm), tape width: 42mm;

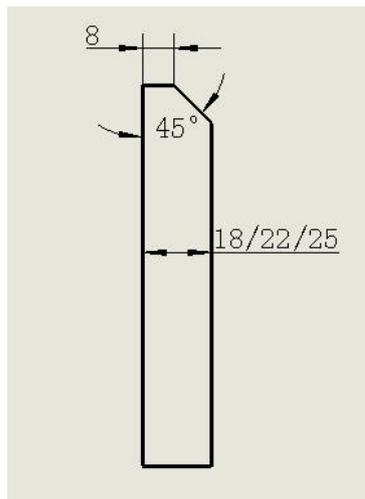
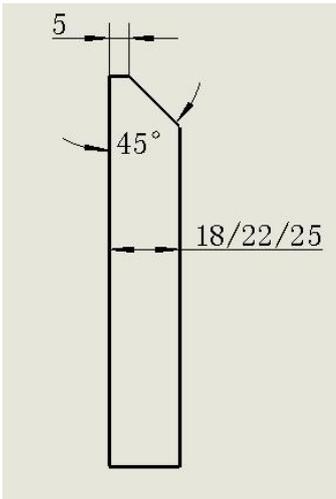
全通 C 型板厚度 22 (封边带厚度: 0.52- 0.54mm), 封边带宽度: 42mm;

Full C shape thickness 22mm(tape thickness: 0.52- 0.54mm), tape width: 42mm



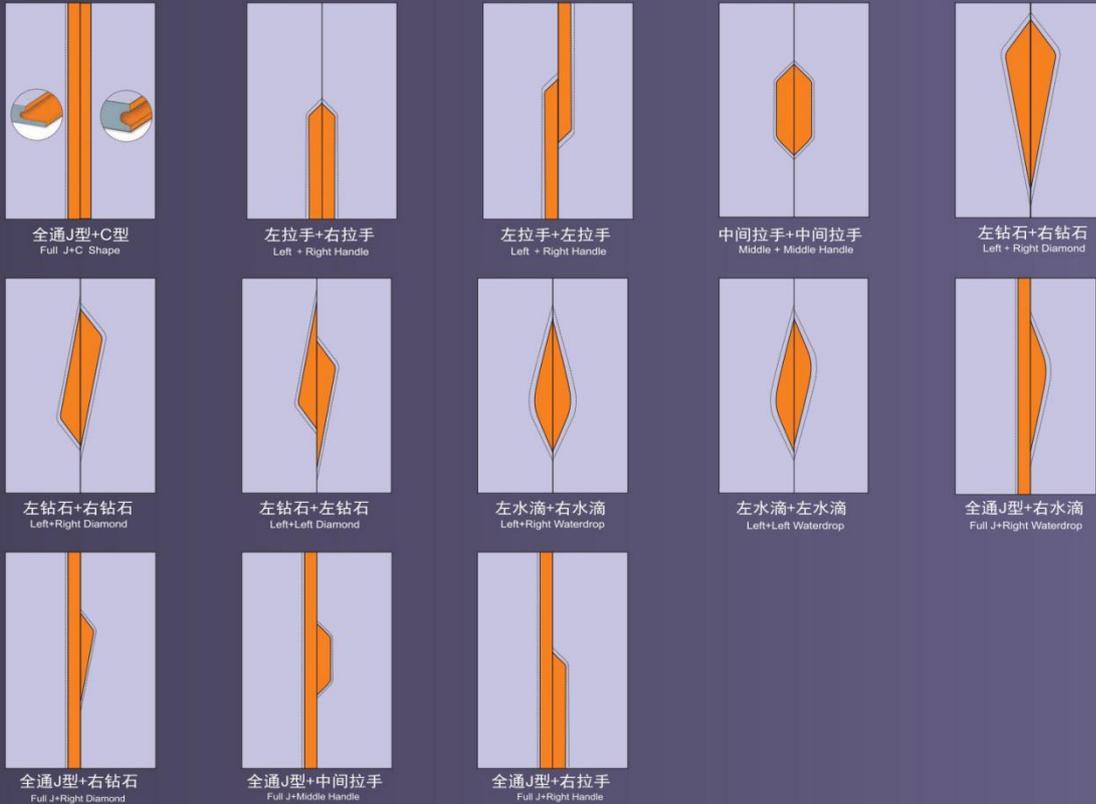
3、 斜边 X, 封边带厚度 0.8-1.5mm

Bevel edge, banding tape thickness is 0.8-1.5mm



六. 工艺搭配 Profile matching

柜体组合 - 搭配样例 Cabinet Body Combination - Matching Examples



橱柜组合 - 搭配样例 Cabinet Combination-Matching Examples



七. 应用场景 Application





