

# 厦门合利成环保科技有限公司

全自动正负压伺服三工位成型一体机点检表

XHL-C-QR-SC04-1

|           |                   |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |             |             |  |           |          |  |
|-----------|-------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------------|-------------|--|-----------|----------|--|
| 生产机台:     | CX-2              |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | 日期:         | 22.2.18     |  | 产品名称:     | 148 伺服平衡 |  |
| 材质:       | PET 树脂            |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | 颜色:         | 透明          |  | 厚度:       | 0.34 mm  |  |
| 材质规格/模穴   | 0.54x0.85 PET 16R |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | 产品重量        | 8.9g        |  | *成型上模合模速度 | 1400 转   |  |
| *压力 (Mpa) | 0.6 2             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *正压力 (Mpa)  | 0.6         |  | *成型上模开模速度 | 1500 转   |  |
| *成型下模合模速度 | 1500 转            |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *裁断上模合模速度   | 1450 转      |  | *裁断下模合模速度 | 1500 转   |  |
| *成型下模开模速度 | 1500 转            |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *裁断上模开模速度   | 1450 转      |  | *裁断下模开模速度 | 1450 转   |  |
| 点检时间:     | 8:30              |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
| 上炉温<br>控  | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
|           | 360               | 350 | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | OFF |             | 3           |  |           |          |  |
| 点检时间:     | 10:30             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 360       | 350               | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | OFF | 3   |             |             |  |           |          |  |
| 点检时间:     | 12:30             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 360       | 350               | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 373 | OFF | 3   |             |             |  |           |          |  |
| 点检时间:     | 14:30             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 360       | 350               | 351 | 350 | 372 | 360 | 350 | 350 | 350 | 373 | 360 | 350 | 350 | 350 | 372 | OFF | 3   |             |             |  |           |          |  |
| 点检时间:     | 16:35             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 359       | 351               | 352 | 351 | 372 | 360 | 360 | 351 | 351 | 372 | 360 | 350 | 350 | 350 | 373 | OFF | 3   |             |             |  |           |          |  |
| 点检时间:     | 18:25             |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 259       | 251               | 352 | 352 | 375 | 360 | 361 | 352 | 351 | 375 | 361 | 352 | 352 | 352 | 373 | OFF | 3   |             |             |  |           |          |  |
| 点检时间:     | 上炉温               |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     | *4 NO / OFF |             |  |           |          |  |
|           | 1                 | 2   | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 下炉温<br>控    | *1 NO / OFF |  |           |          |  |
| 1         | 2                 | 3   | 4   | 5   | 6   | 7   | 8   | 9   | 10  | 11  | 12  | 13  | 14  | 15  | 16  | 3   |             |             |  |           |          |  |

备注: 一般情况下, 温度的稳定性在±15度, 点检频率1次/2H。

审核:

李 李

点检人:

李 李