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冠古磁力抛光机

GUANGU MAGNETIC POLISHER



一次性解决五金件毛刺，焊斑，刀纹等表面处理难题

Solve surface treatment problems such as hardware burrs, welding spots, and knife marks at one time

CONZTS

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企业简介

COMPANYPROFILE

冠古科技（苏州）有限公司地处素有“江南水乡”美称的江苏省苏州市，自创立以来专注于从事精密金属零部件内孔死角去毛刺磁力研磨抛光机，磁力滚抛机，水处理设备等自动化设备的研发设计与生产销售，致力打造成精密小零件去毛刺机和磁力抛光机国内知名品牌。

针对目前国内存在的金属表面抛光清洗去毛刺难题，冠古推出了高效代替手工的全自动内孔死角去毛刺抛光设备：磁力抛光机，磁力研磨机，磁力滚抛机，磁力去毛刺机，全自动去毛刺机等自动化抛光研磨设备及相关研磨抛光耗材。

冠古磁力抛光机均经过精密严谨工程设计、严格生产管理和质量控制系统、做到每个零件从材料选择、加工生产、组装、调试等各个环节经过严格检验，设备核心部件均采用一线品牌配件，欢迎来厂参观试样。

Guangu Technology (Suzhou) Co., Ltd. is located in Suzhou City, Jiangsu Province, which is known as the "Jiangnan Water Town". Since its establishment, it has focused on deburring the dead corners of precision metal parts, magnetic grinding and polishing machines, magnetic rolling and polishing machines, and water treatment. R&D, design, production and sales of equipment and other automation equipment, and strive to become a well-known domestic brand of precision small parts deburring machines and magnetic polishing machines.

Aiming at the current problem of metal surface polishing, cleaning and deburring in China, Guangu has launched a fully automatic inner hole dead corner deburring polishing equipment that can replace manual work efficiently: magnetic polishing machine, magnetic grinding machine, magnetic rolling and polishing machine, magnetic deburring machine, all Automatic polishing and grinding equipment such as automatic deburring machines and related grinding and polishing consumables.

Guangu magnetic polishing machine has undergone precise and rigorous engineering design, strict production management and quality control system, so that each part has undergone strict inspection from material selection, processing and production, assembly, debugging and other links. The core components of the equipment are all first-line brand accessories, welcome to visit the factory for samples.

企业文化

CERTIFICATE OF ASSETS



愿景

vision

做一家受人尊重的设备厂商
Be a respected equipment manufacturer



使命

Mission

扬中国智造魅力
Promote the charm of China's intelligent manufacturing



价值观

system of values

为客户创造效益、为员工创造幸福
Create benefits for customers and create happiness for employees



人才理念

Talent Concept

人适其位，位适其人
suitable person, suitable person



产品特点

Features

设备简介

Equipment introduction

感谢您购买冠古磁力抛光机！冠古磁力抛光机是自主研发的一种新型抛光去毛刺机清洗设备，公司设备采用国内外一线品牌配件，简单，易操控，独特的设计，从根本上解决了传统抛光清洗去毛刺的难题。解决了伤工件、死角、管内、通孔、盲孔等抛光研磨等后处理难题，提升了抛光效率及产品的品质。

Thank you for purchasing Guangu magnetic polishing machine! Guangu magnetic polishing machine is a new type of polishing and deburring machine cleaning equipment independently developed. The company's equipment adopts first-line brand accessories at home and abroad. It is simple, easy to operate, and unique in design, which fundamentally solves the problem of traditional polishing, cleaning and deburring. It solves the post-processing problems such as polishing and grinding of damaged workpieces, dead angles, inside pipes, through holes, blind holes, etc., and improves the polishing efficiency and product quality.

工作原理

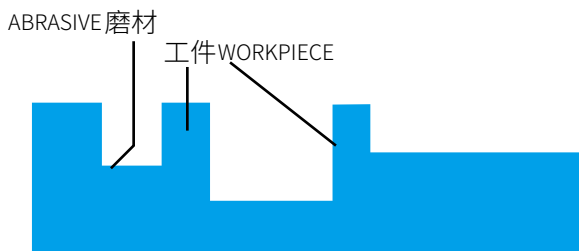
Working Principle

冠古磁力抛光机是利用超强的电磁力，传动细小的磁力研磨钢针，使抛光针产生高悬浮流动，换向翻滚，钢针轻轻滑过工件表面、在工件内孔，内外牙及表面摩擦，达到抛光清洗、去除油污杂质、去除毛刺批锋等。达到精密抛光效果，不影响精度、不损伤工件。

Guangu magnetic polishing machine uses super electromagnetic force to drive small magnetic grinding steel needles, so that the polishing needles generate high suspension flow, reversing and tumbling, and the steel needles gently slide over the surface of the workpiece, in the inner hole of the workpiece, the inner and outer teeth and Surface friction, to achieve polishing cleaning, removal of oil and impurities, removal of burrs, etc. Achieve precision polishing effect without affecting the accuracy or damaging the workpiece.

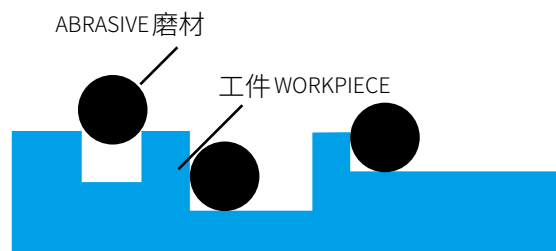
磁力抛光机与传统抛光机研磨示意图

Grinding Schematic Diagram Of Magnetic Polishing Machine And Traditional Polishing Machine



磁力抛光机磁针可研磨金属工件的孔内、夹缝、直角、螺牙等精细研磨速度快

The magnetic needle of the magnetic polishing machine can grind the inside of the hole, the crack, the right angle, the thread of the metal workpiece, etc., and the fine grinding speed is fast



传统抛光机在研磨金属工件时，孔内、夹缝、直角无法研磨

When the traditional polishing machine grinds metal workpieces, the inside of the hole, the gap, and the right angle cannot be ground

产品特点

Features

功能特点

Equipment introduction

- 01 实现去除毛刺、倒角、抛光、洗净等多重功效。
Realize deburring, chamfering, polishing, cleaning and other multiple functions.
- 02 对于不规则状零件、孔状、管状等死角、夹缝均可抛光清洗。
For irregular parts, holes, tubes and other dead corners, cracks can be polished and cleaned.
- 03 研磨成本低、304 不锈钢磁针，消耗极低。
Low grinding cost, 304 stainless steel magnetic needle, extremely low consumption.
- 04 研磨速度快，平均每次研磨 5-15 分钟，换工件快，不停机可换研磨工件。
The grinding speed is fast, the average grinding time is 5-15 minutes each time, the workpiece can be changed quickly, and the grinding workpiece can be changed without stopping the machine.
- 05 可变频率调节、满足各种抛光要求。
Variable frequency adjustment to meet various polishing requirements.
- 06 抛光无死角。
Polished without dead ends.
- 07 操作简单安全、免技术，一人可操控数台机器。
The operation is simple, safe and technology-free, and one person can control several machines.
- 08 设备电压、电机频率、运转时间直观明了，易操作。
The equipment voltage, motor frequency, and running time are intuitive and clear, and easy to operate.
- 09 零件成品研磨后，不变形，无死角，不损伤表面，不影响精度。
After the finished parts are ground, there will be no deformation, no dead angle, no damage to the surface, and no impact on precision.

设备优点及应用范围

Equipment advantages and application range

设备优点

Equipment introduction

刹车功能：采用电子反相电流输出电极自动刹车，优点：无摩擦，无损耗，耐用，节能。

Braking function: automatic braking with electronic anti-phase current output electrodes. Advantages: no friction, no loss, durability, and energy saving.

设备采用整体结构框架。

The equipment adopts the overall structural frame.

国标钢板外壳，整体无缝隙，结构坚固厚实稳定。五道工序高温防脱漆防腐处理。

The national standard steel plate shell has no gaps as a whole, and the structure is firm, thick and stable. Five-process high-temperature anti-stripping and anti-corrosion treatment.

安全措施：轻触点启动，控制部分全冷元件设计，不漏电，安全。

Safety measures: start by light contact, design of all cooling components in the control part, no leakage, safe.

转动：工作中，转盘无功率损耗，4KW 电机在任何速度，空载和负载间无减速现象，完全够用，1000 小时不停机检测，设备稳定节能。

Rotation: During work, the turntable has no power loss, and the 4KW motor has no deceleration phenomenon between no-load and load at any speed.

应用范围

Equipment introduction

适用于非导磁性金属：金、银、铜、铝、锌、镁、不锈钢等金属类工件的研磨抛光。如：金银首饰、时尚配饰、电子产品金属制件，精密螺栓、形状复杂的金属制品、文具配件、仪表仪器配件。

It is suitable for grinding and polishing metal workpieces such as gold, silver, copper, aluminum, zinc, magnesium, and stainless steel. Such as: gold and silver jewelry, fashion accessories, metal parts of electronic products, precision bolts, metal products with complex shapes, stationery accessories, instrument accessories.

1- 走心、走刀、CNC 自动车床零件
Centering, cutting, CNC automatic lathe parts

2- 航空航天，医疗器械零件
Aerospace, medical device parts

3- 精密弹簧、弹片零件
Precision spring, shrapnel parts

4- 锌合金、铝合金压铸零件
Zinc alloy, aluminum alloy die-casting parts

5- 精密冲压零件
Precision stamping parts

6- 电子 电脑 通信零件
Electronic Computer Communication Parts

产品参数

Product parameters



参数及配备	
型号 Model	GG8520
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	640*520*1088
研磨槽尺寸 Grinding tank size	Φ 350(圆桶)
电机功率 Motor power	2.2KW*1
机器重量 Machine weight	168kg
运转方式 Operation mode	正反转 Forward and reverse
最大加工量 Maximum processing capacity	8-10KG
辅材 Auxiliary material	不锈钢针 3kg、研磨液 25L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 3kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

Product parameters



参数及配备

型号 Model	GG8620
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	740*620*1088
研磨槽尺寸 Grinding tank size	Φ 450
电机功率 Motor power	3.0KW*1
机器重量 Machine weight	188KG
运转方式 Operation mode	正反转 Forward and reverse
最大加工量 Maximum processing capacity	10-12KG
辅材 Auxiliary material	不锈钢针 4kg、研磨液 25L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1 份。 Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数 Product parameters



参数及配备	
型号 Model	GG8720
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	840*720*1088
研磨槽尺寸 Grinding tank size	Φ 500(圆桶)
电机功率 Motor power	4.0KW*1
机器重量 Machine weight	218KG
运转方式 Operation mode	正反转 Forward and reverse
最大加工量 Maximum processing capacity	15-18KG
辅材 Auxiliary material	不锈钢针 6kg、研磨液 50L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1 份。 Stainless Steel Needle 6kg, Grinding Liquid 50L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

Product parameters

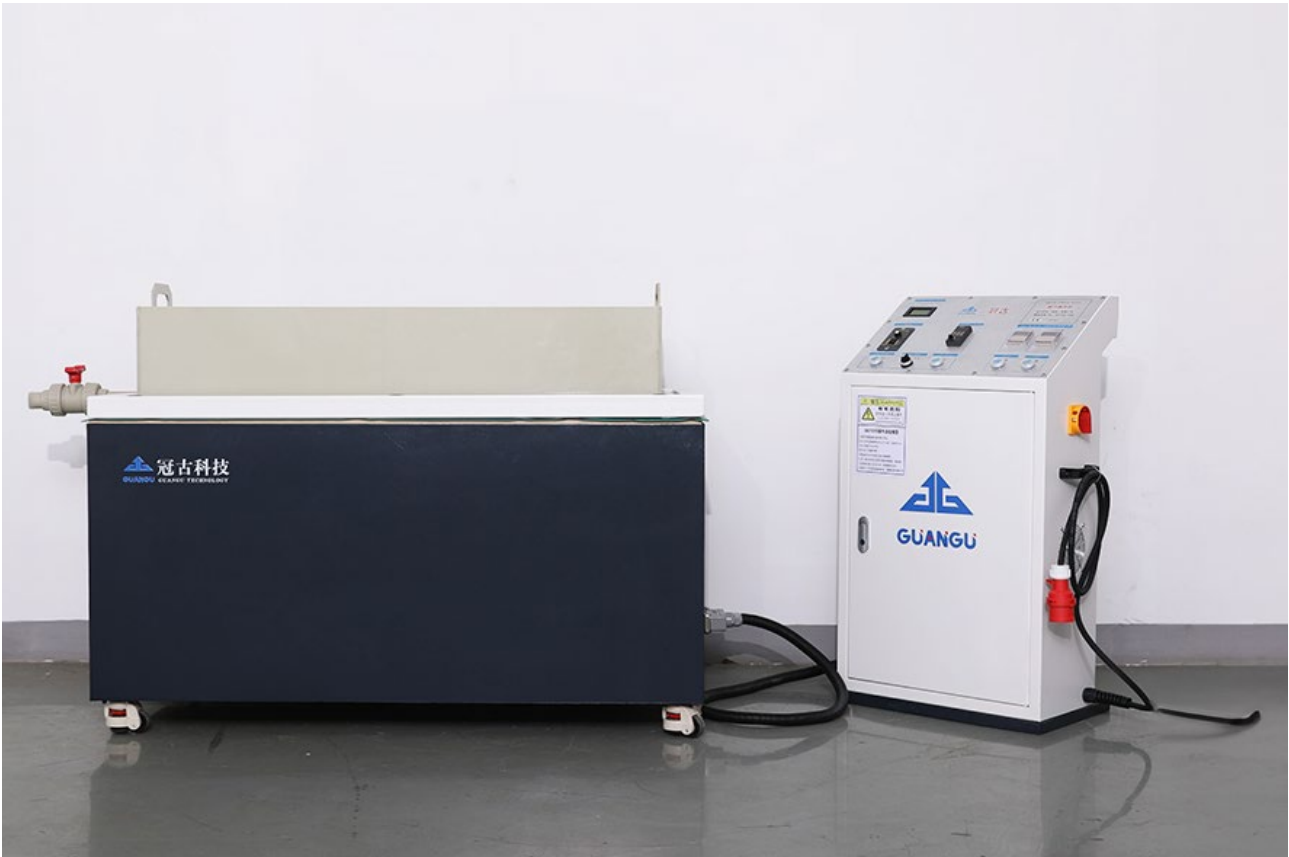


参数及配备

参数及配备	
型号 Model	GG8850
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	1200*720*1088
研磨槽尺寸 Grinding tank size	900*500(方桶)
电机功率 Motor power	4.0KW*1
机器重量 Machine weight	288KG
运转方式 Operation mode	正反转及平移 Forward and reverse and translation
最大加工量 Maximum processing capacity	20-30KG
辅材 Auxiliary material	不锈钢针 8kg、研磨液 50L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

Product parameters

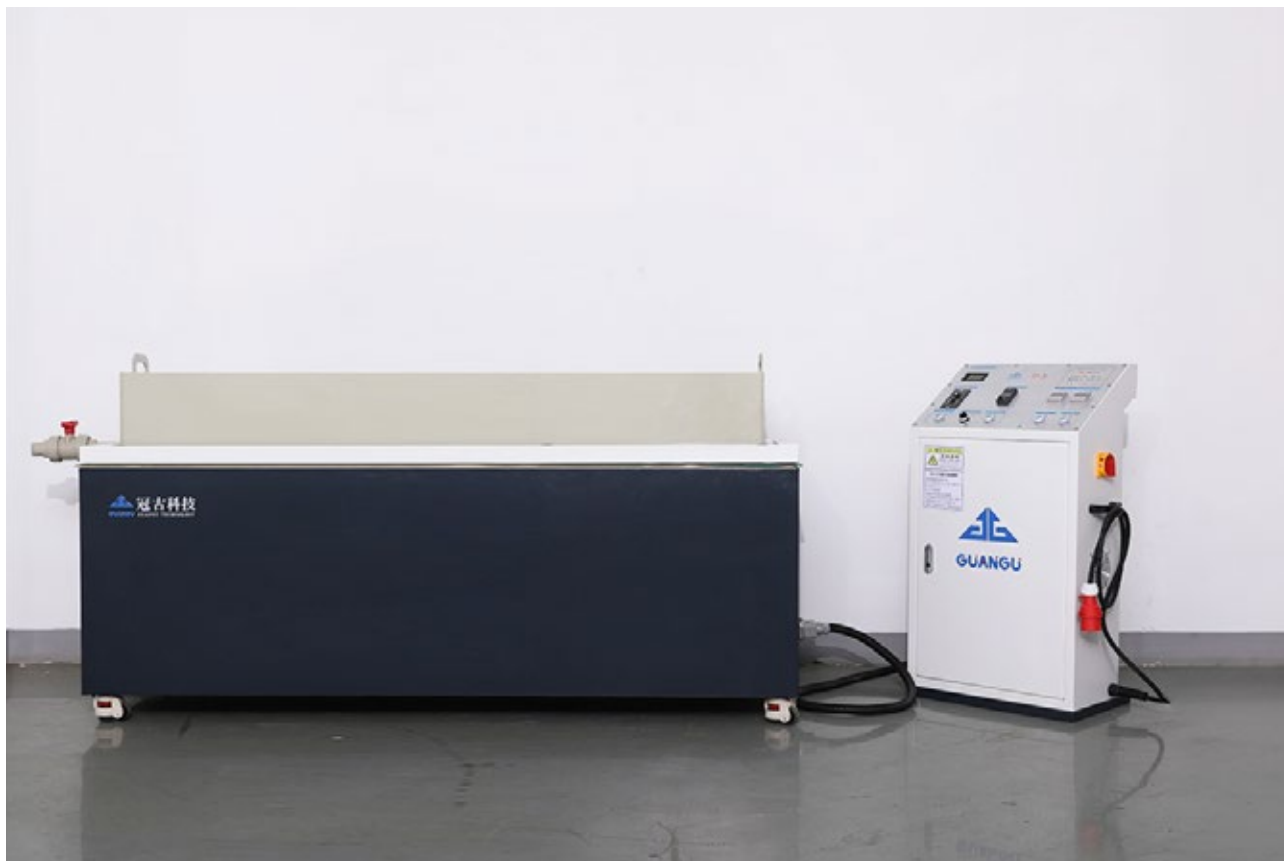


参数及配备

参数及配备	
型号 Model	GG1380
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	1380*720*1088
研磨槽尺寸 Grinding tank size	1200*520(方桶)
电机功率 Motor power	4.0KW*1
机器重量 Machine weight	410KG
运转方式 Operation mode	正反转及平移 Forward and reverse and translation
最大加工量 Maximum processing capacity	25-35KG
辅材 Auxiliary material	不锈钢针 10kg、研磨液 50L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 10kg, Grinding Liquid 50L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

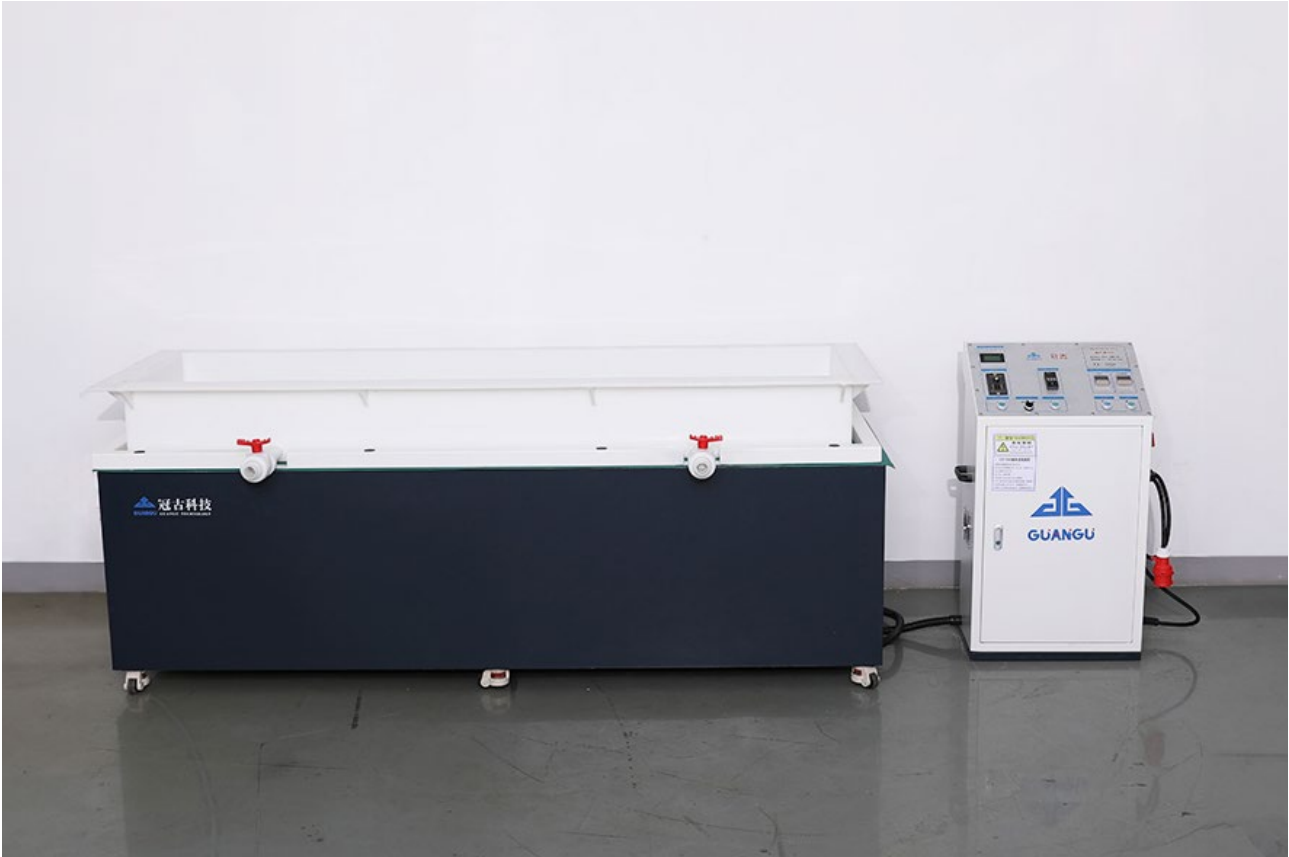
Product parameters



参数及配备	
型号 Model	GG1980
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	1980*720*1088
研磨槽尺寸 Grinding tank size	1800*520(方桶)
电机功率 Motor power	4.0KW*2
机器重量 Machine weight	580KG
运转方式 Operation mode	正反转及平移 Forward and reverse and translation
最大加工量 Maximum processing capacity	40-60KG
辅材 Auxiliary material	不锈钢针 12kg、研磨液 100L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

Product parameters



参数及配备	
型号 Model	GG2380
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	2380*800*1088
研磨槽尺寸 Grinding tank size	2200*600(方桶)
电机功率 Motor power	5.5KW*2
机器重量 Machine weight	660KG
运转方式 Operation mode	正反转及平移 Forward and reverse and translation
最大加工量 Maximum processing capacity	50-70KG
辅材 Auxiliary material	不锈钢针 14kg、研磨液 50L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 14kg, Grinding Liquid 100L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

产品参数

Product parameters



参数及配备	
型号 Model	GG2980
电源 Power supply	AC380V(50\60HZ)16A
设备尺寸 Equipment size	2980*720*1088
研磨槽尺寸 Grinding tank size	2800*520(方桶)
电机功率 Motor power	4.0KW*3
机器重量 Machine weight	780KG
运转方式 Operation mode	正反转及平移 fForward and reverse and translation
最大加工量 Maximum processing capacity	60-80KG
辅材 Auxiliary material	不锈钢针 24kg、研磨液 150L、胶皮垫 1PCS、分离筛 1PCS、钢针分离器 1PCS、说明书 1份。 Stainless Steel Needle 24kg, Grinding Liquid 150L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

研磨耗材 Grinding Consumables

磁力钢针常规尺寸表（特殊可定制）

Magnetic steel needle regular size table (special can be customized)



尺寸（直径 * 长度 mm）					
0.2*5MM	0.3*5MM	0.4*5MM	0.5*3MM	0.5*5MM	0.5*8MM
0.6*5MM	0.7*5MM	0.8*3MM	0.8*5MM	0.8*10MM	1.0*5MM
1.0*8MM	1.0*10MM	1.2*5MM	1.2*8MM	1.2*10MM	1.5*5MM
1.5*8MM	1.5*10MM	1.8*5MM	1.8*8MM	2.0*5MM	2.0*8MM

冠古磁力研磨钢针选择说明

Guangu Magnetic Grinding Steel Needle Selection Instructions

磁力钢针越粗，抛光力度越强，当然也可通过调整磁力抛光机控制面板的工作频率来掌控抛光研磨力度，首次选择不锈钢钢针时，首先要对待加工零件的材质有所了解，对于不锈钢和铁类等材质较硬的零件，建议选择 $\text{Ø}0.8$ 以上的不锈钢针，对于材质较软的铜、铝零件，建议选择 $\text{Ø}0.8$ 以下的不锈钢磁针。此外，也可通过实际尝试几次来确定最终的不锈钢针型号，待加工零件的孔径以及其他夹缝，决定钢针磨料的粗细，一般建议使用 5mm 长的钢针进行抛光。

The thicker the magnetic steel needle, the stronger the polishing strength. Of course, the polishing and grinding strength can also be controlled by adjusting the operating frequency of the control panel of the magnetic polishing machine. When choosing a stainless steel needle for the first time, you must first understand the material of the processed parts. For stainless steel For hard parts such as steel and iron, it is recommended to choose a stainless steel needle with a diameter above 0.8. For copper and aluminum parts with soft materials, it is recommended to choose a stainless steel needle with a diameter below 0.8. In addition, the final stainless steel needle model, the hole diameter of the part to be processed and other gaps can also be determined by actually trying several times to determine the thickness of the steel needle abrasive. Generally, it is recommended to use a 5mm long steel needle for polishing.

注意事项 Precautions

不锈钢磁针为半永久性磨材，可多次连续使用，不锈钢磁针为微小针状物体，使用时应小心操作。不锈钢针不使用时，请清洗干净并干燥后保存。

The stainless steel magnetic needle is a semi-permanent grinding material, which can be used continuously for many times. The stainless steel magnetic needle is a tiny needle-shaped object, and it should be handled carefully when using it. When the stainless steel needle is not in use, please clean it and dry it before storing.

研磨案例

Grinding case

铜件案例

Copper case



去氧化层
Deoxidation



工艺品
Crafts



制冷配件
Refrigeration accessories



通信配件
Communication accessories



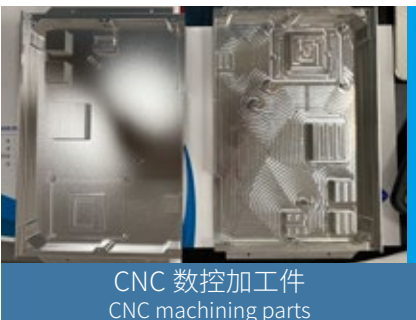
电力配件
Power Accessories



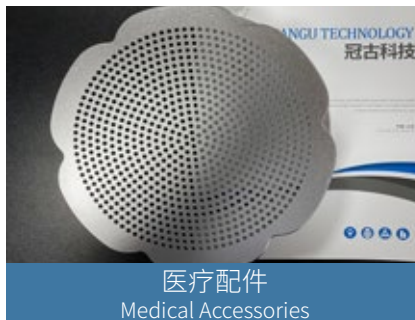
焊接件
Welding Parts

铝件案例

Aluminum case



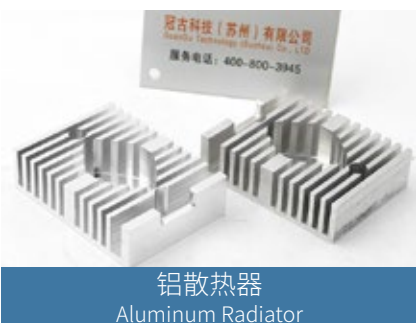
CNC 数控加工件
CNC machining parts



医疗配件
Medical Accessories



切割件
Cut Pieces



铝散热器
Aluminum Radiator



铝压铸件
Aluminum Die Casting



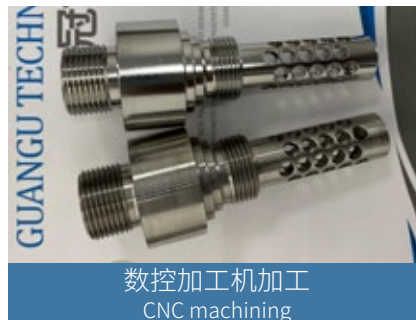
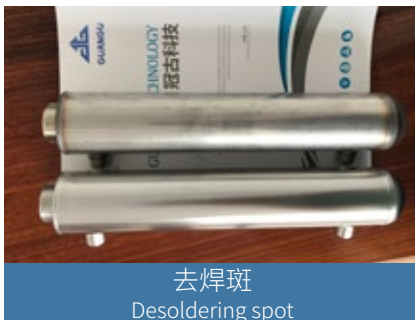
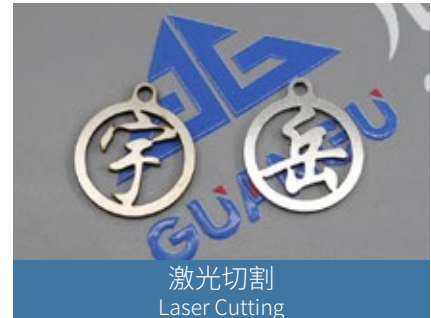
铝锻造件
Aluminum forgings

研磨案例

Grinding case

不锈钢件案例

Stainless steel case



铁件 / 碳钢件案例

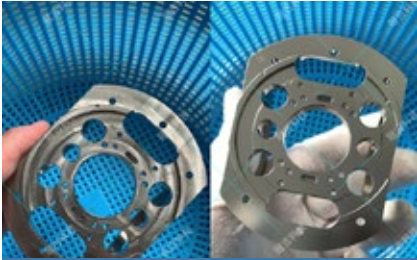
Iron parts/carbon steel parts case



研磨案例

Grinding case

合金件 /3D 打印 / 其他案例
Alloy parts/3D printing/other cases



高温合金
Superalloy



粉末冶金
Powder Metallurgy



钽合金
Tantalum alloy



3D 打印
3D printing



锌合金
Zinc alloy



钛合金
Titanium alloy



银饰品
Silver jewelry



锌合金
Zinc alloy



镁合金
Magnesium Alloy

使用解答

Use answer

现象	原因	对策
抛光桶底部漏水	桶底部刺有抛光针	用钳子将针去除，在桶底加点胶水
	抛光桶低磨损	购置新桶
计时器不闪动	未启动开关	按启动开关即可计时
抛光桶易坏	水温高	及时换水（正常水温在 50 度内）
	抛光槽内有抛光针	时常清理、保持研磨槽内清洁
抛光桶在研磨时转动	抛光垫表面有水或无抛光垫	清干水分，加上硅胶防震垫
机器震动大	机器某个脚不在受力位置	调整脚的长短平衡受力位置
	抛光针放置过量	减少抛光针
工件槽内卡针	抛光针长短，大小与工件尺寸不符	调整抛光针尺寸大小长短
工作表面有麻点	工件与工件之间严重碰撞	做夹具固定工件
	抛光针型号太大	调整抛光针
去毛刺效果差	研磨力度不够	调高频率，尽量减少桶与机器间距离
工件无光泽	抛光针力度不够	更换粗 / 长的抛光针检查抛光针是否足量
	抛光剂于产品材质冲突	更换 / 调整抛光液
抛光工件效率低	抛光针太细 / 短	调整磁力抛光针型号
	抛光剂少	增加抛光剂，更换品质优良的抛光剂
	工件有油污	先除油后抛光
	抛光水放置过量	减少水
	工件过量	减至合适工件数量，以工件翻滚为准
抛光桶、针发黑	工件有油污	单独清洗抛光桶和抛光针后再使用
指示正常时机器不动作	电压不正常	检查电压是否低于 380V
	抛光针放置过量	减少抛光针
	显示 EO（保护）	切断总电源待显示熄灭后重启设备 切断总电源待显示熄灭后按调速器上红色的 stop/reset 键
电源跳闸	机器内部潮湿	将机器更换环境晒太阳几小时或用电热吹风机吹干
机器表面发热	工作环境太热	更换机器背面的扇热风扇
	机器散热风扇坏	更换机器背面的扇热风扇
机器有焦漆味	工作电压过高	解决机器使用电源
电压表无显示、机器无动作	电源输入无电压	检查前端电源
	机器故障	通知冠古公司售后维修

当出现以上现象，按下表所表示信息，对证原因，对策供您参考答案

使用解答

Use answer

Phenomenon	reason	Countermeasures
Water leaks from the bottom of the polishing bucket	Bucket bottom pierced with polished needles	Remove the needle with pliers and add some glue to the bottom of the barrel
	Polished barrels for low wear	buy new barrels
timer does not flash	switch not activated	Press the start switch to time
Polishing barrel is fragile	high water temperature	Change the water in time (normal water temperature is within 50 degrees)
	There are polishing needles in the polishing tank	Regularly clean and keep the grinding tank clean
Polishing barrel turns while grinding	Water on the surface of the polishing pad or no polishing pad	Drain moisture, plus silicone anti-vibration pad
The machine vibrates a lot	A certain foot of the machine is not in the force-bearing position	Adjust the length of the foot to balance the stress position
	Excessive polishing needle placement	Reduce polishing needles
Pin stuck in workpiece slot	The length of the polishing needle does not match the size of the workpiece	Adjust the size of the polishing needle
Poor deburring effect	Severe workpiece-to-workpiece collisions	Make a fixture to fix the workpiece
	The polishing needle is too strong	Adjusting the polishing needle
Poor deburring effect	Insufficient grinding	Increase the frequency to minimize the distance between the barrel and the machine
The workpiece is dull	The polishing needle is not strong enough	Replace the thick/long polishing needle to check whether the polishing needle is sufficient
	The polishing agent conflicts with the product material	Replace/Adjust Polishing Fluid
Polishing the workpiece is inefficient	Polishing needle too thin/short	Adjusting the Magnetic Polishing Needle Model
	less polish	Increase the polishing agent and replace it with a high-quality polishing agent
	The workpiece is oily	Polish after degreasing
	Too much polishing water	reduce water
	Workpiece excess	Reduce to the appropriate number of workpieces, subject to workpiece tumbling
Polished barrel, blackened needle	The workpiece is oily	Wash the polishing barrel and polishing needle separately before using
Indicates that the machine does not operate when it is normal	abnormal voltage	Check if the voltage is lower than 380V
	Excessive polishing needle placement	Reduce polishing needles
	Show EO (protection)	Cut off the main power supply and restart the device after the display goes out After the main power supply is displayed and goes out, press the red button on the governor colored stop/reset key
power trip	damp inside the machine	Change the environment of the machine to the sun for a few hours or use electricity hot blow dryer
The surface of the machine is hot	working environment is too hot	Replacing the fan on the back of the machine
	The cooling fan of the machine is broken	Replacing the fan on the back of the machine
The machine smells like burnt paint	Working voltage is too high	Solve the machine using power
The voltmeter has no display and the machine has no action	Power input no voltage	Check front-end power
	machine malfunction	Notify Guangu Company for after-sales maintenance

代码显示解答

Code display solution

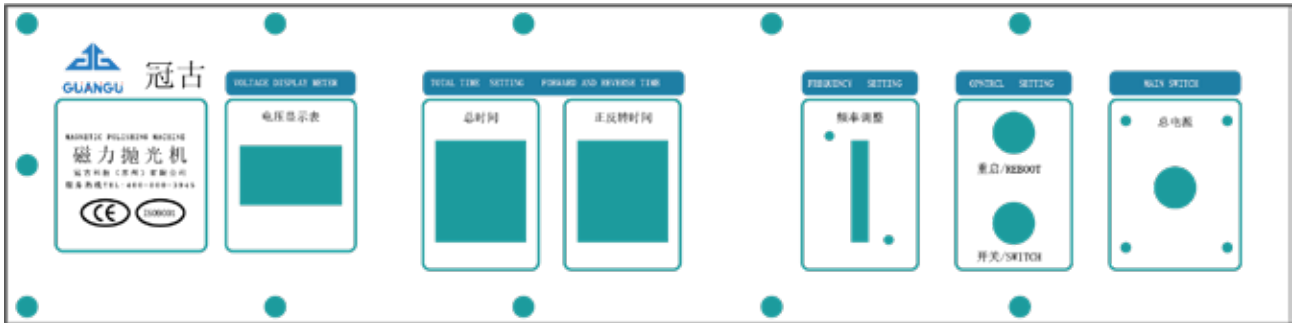
OC	变频器侦测输出有异常突增的过电流产生	检查电机输出功率与变频器输出功率是否相符合检查变频器与电机之间的连线是否有短路现象增大加速时间 (P10,12) 检查电机是否有超额负载
Ou	变频器侦测内部直流高压有过压现象产生	检查输入电压是否在变频器额定输入电压范围内并检测是否有突波电压产生, 由于电机惯量回升 电压造成变频器内部直流高压侧电压过高此时可 增加减速时间或加装刹车电阻 (选用)
OK	变频器侦测内部温度过高, 超过保护位准	检查环境温度是否过高、过高, 超过保护位准 检查进出口风口是否堵塞检查散热片是否有异常检查变频器通风空间是否足够
Lu	变频器侦测内部直流	检查输入电源是否正常
	高压侧过低	
OL	变频器侦测输出超过可承受的电流, 耐量 150% 的变频器额定电流, 可承受 60s。	检查电机是不是过载减低 p54 转矩 提升值增加变频器输出容量
OL1	内部电子热动点驿保护; 电机负载过大	检查电机是不是过载检查 P52 电机额定电流值是否适当 检查电子热动电驿功能设定增加电机容量
OL2	电机负载太大	检查电机负载是否过大检查过转矩检出位准设定值 (P60-62)
bb	与外部多功能输入端子 (M2~M5) 设定此一时交流电机驱动器	清楚信号来源“bb”立刻消失功能时, 交流电机驱动器 停止输出输出连线是否绝缘不良
ocA	加速中过电流	增加加速时间减低 P54 转矩设定值更换较大输出容量变频器输出连线是否绝缘不良
ocd	减速中过电流产生	增加减速时间更换较大输出容量变频器
ocn	当外部多功能输入端子 (M2-M5) 设定外部异常 (EF) 时, 交流电机驱动器停止输出	清楚故障来源后按“RESET”键即可
	内部存储器 IC 数据写入异常	检查输入电源电压正常后重新开机
cf2	内部存储器 IC 数据读出异常	检查变频器内部电源板与控制板的连接 器是否接合完整按下 RESET 键并将内部 参数重置为出厂设定值
OFF	接地保护或保险丝故障 接地保护变频大有异常输出现象、输出端接地 (接地电流高于变频器额定电流的 50% 以上) 功率模块可能已经损坏, 此保护系会对变频器而非人体 保险丝故障; 由主电路板的 LED 指示灯显示保险丝是否故障	接地保护; 确定 IGBT 功率模块是否损坏检查输出侧接地线是否绝缘不良保险丝故障; 更换保险丝确定 IGBT 功率模块是否损坏检查输出侧接地线是否绝缘不良

代码显示解答

Code display solution

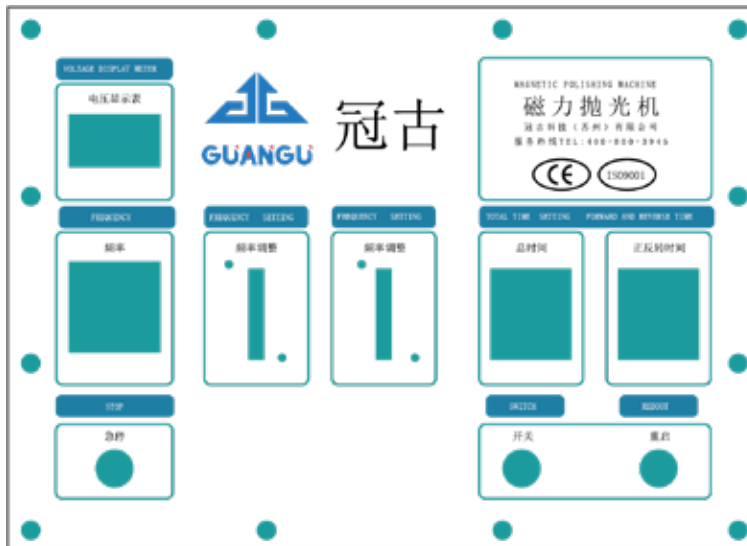
OC	The inverter detects that there is an abnormal sudden increase of overcurrent at the output	Check whether the output power of the motor matches the output power of the inverter Check whether there is a short circuit between the inverter and the motor Increase the acceleration time (P10,12) Check whether the motor is overloaded
OU	The inverter detects that there is an overvoltage phenomenon in the internal DC high voltage	Check whether the input voltage is within the rated input voltage range of the inverter and detect whether there is a surge voltage. The internal DC high-voltage side voltage of the inverter is too high due to the motor inertia rising voltage. At this time, you can increase the deceleration time or install a braking resistor (optional).
OH	The inverter detects that the internal temperature is too high and exceeds the protection level	Check whether the ambient temperature is too high, too high, and exceed the protection level. Check whether the inlet and outlet air outlets are blocked. Check whether the heat sink is abnormal. Check whether the ventilation space of the inverter is sufficient.
LU	Inverter detects internal DC	Check whether the input power is normal
	High side too low	
OL	The inverter detects that the output exceeds the tolerable current, and the tolerance is 150% of the rated current of the inverter, which can withstand 60s.	Check whether the motor is overloaded, reduce the torque of p54, increase the output capacity of the inverter
OL1	Internal electronic thermal point relay protection; motor load is too large	Check whether the motor is overloaded Check whether the rated current value of the P52 motor is appropriate Check the electronic thermal relay function setting to increase the motor capacity
OL2	The motor load is too large	Check whether the motor load is too large Check the setting value of the over-torque detection level (P60-62)
bb	Set this time with external multi-function input terminals (M2~M5) AC motor driver	When it is clear that the signal source "bb" disappears immediately, the AC motor driver stops outputting and whether the output wiring is poorly insulated
ocA	Overcurrent during acceleration	Increase the acceleration time and reduce the torque setting value of P54. Replace the inverter with a larger output capacity. Is the insulation of the output connection of the inverter poor?
ocd	Overcurrent occurs during deceleration	Increase the deceleration time and replace the inverter with a larger output capacity
ocn	When the external multi-function input terminals (M2-M5) set the external abnormality (EF), the AC motor driver stops outputting	After clearing the source of the fault, press the "RESET" button
	Data write error in internal memory IC	Check that the input power voltage is normal and restart the machine
cf2	Internal memory IC data reading error	Check whether the connectors of the internal power supply board of the inverter and the control board are fully connected, press the RESET key and reset the internal parameters to factory settings
OFF	Grounding protection or fuse fault grounding protection The inverter has abnormal output phenomenon, and the output terminal is grounded (the grounding current is higher than 50% of the rated current of the inverter). The power module may have been damaged. This protection system will fail the fuse of the inverter instead of the human body; The LED indicator on the main circuit board shows whether the fuse is faulty	Ground protection; determine whether the IGBT power module is damaged Check whether the ground wire on the output side is poorly insulated Fuse failure; replace the fuse to determine whether the IGBT power module is damaged Check whether the ground wire on the output side is poorly insulated

面板介绍 Panel introduction



▲ 变频系列面板

平移控制面板 ▼



• 总电源：机器输入电源的总开关、关闭状态时机器内部所有电路断电，要使用设备时要将总电源调到开（ON 是开，OFF 是关）

• 开关：（蓝色键）按下去计时器开始工作（可以起到开与关的作用）

• 重启：（绿色键）此按钮要开关并重启后总时间计时到了可以起作用（按下等于总时间归零）

• 频率：控制减速电机在设备内移动速度

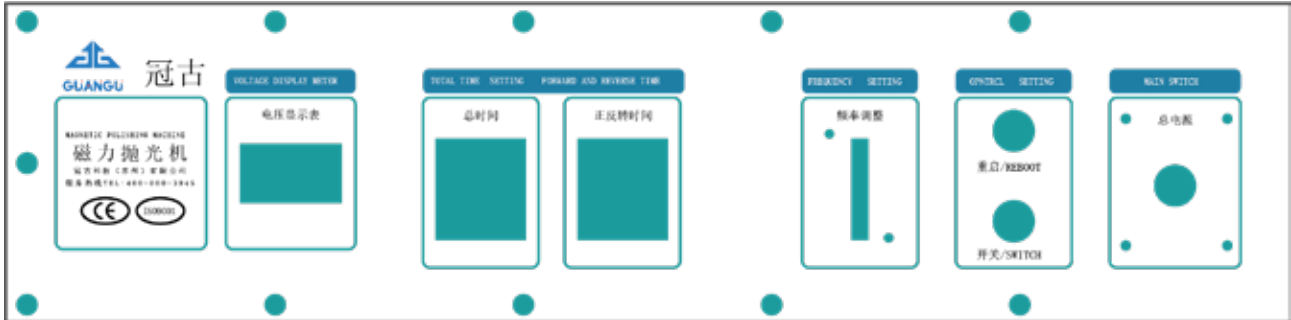
• 频率调整：显示电机工作的频率，可以调整电机运行的频率（0-60HZ），不能长时间在低频率下工作，否则可能损坏电机，参数在出厂时已设置好（只需调圆柱形频率大小）

私自设置参数可能影响设备的正常工作

- 总时间：可以设定机器工作一个周期的时间
- 正反时间：可以设置正反转的循环时间，一般正反设置时间不要低于两分钟，工作时启动与刹车停下来都需要时间，要是设置额定时间太短会占用正常的研磨时间
- 电压电流显示：显示输入电源的电压与工作时的电流
- 保险丝：当输入电流不正常时可以保护机器内部其他电子元件及电路

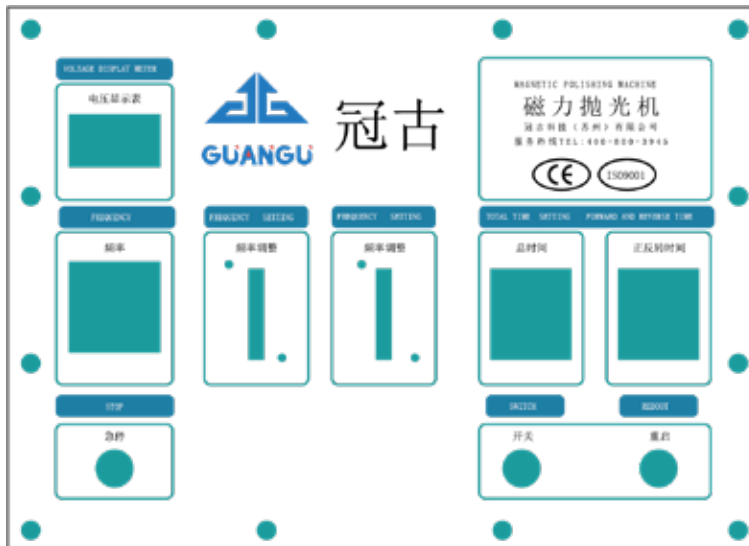
面板介绍

Panel introduction



▲ Frequency conversion series panel

Pan control panel ▼



- Main power supply: The main switch of the input power of the machine. When it is off, all the circuits inside the machine are powered off. When you want to use the equipment, you must turn the main power supply to the on state (ON is on, OFF is off)

- Switch: (red button) press down the timer to start working (can play the role of on and off)

- Restart: (green button) This button is to be switched on and off and the total time will be counted up to work after restarting (pressing is equal to zeroing the total time)

- Frequency: Control the moving speed of the geared motor in the equipment

- Frequency adjustment: Display the working frequency of the motor, and you can adjust the frequency of the motor running (0-60HZ). Do not work at low frequency for a long time, otherwise the motor may be damaged. The parameters have been set before leaving the factory (just adjust the cylindrical frequency Size) Setting parameters privately may affect the normal operation of the device

- Total time: you can set the time for the machine to work for one cycle

- Positive and negative time: You can set the cycle time of positive and negative rotation. Generally, the setting time of positive and negative rotation should not be less than two minutes. It takes time to start and brake to stop during work. If the rated time is set too short, it will take up the normal grinding time

- Voltage and current display: display the voltage of the input power supply and the current during operation

Fuse: When the input current is abnormal, it can protect other electronic components and circuits inside the machine

设备日常保养

Equipment daily maintenance

1. 在使用设备时防止液体溅到操作机器表面，抛光液溅到机器上时应及时擦拭干净
 2. 为了保持机器表面整洁延长机器使用寿命，在使用设备后用布将其表面擦拭干净
 3. 设备不使用时可用胶袋套住控制面板
 4. 防雷击，在发生雷电天气时需关闭机器电源以及拔掉电源插头，防止被雷击坏
 5. 研磨桶损坏，设备运行时抛光针力度强，所以把桶放置到抛光槽内时、如抛光槽内有抛光针要及时清理干净
1. When using the equipment, prevent the liquid from splashing on the surface of the operating machine. When the polishing liquid splashes on the machine, it should be wiped clean in time
 2. In order to keep the surface of the machine clean and prolong the service life of the machine, wipe the surface with a cloth after using the equipment
 3. When the equipment is not in use, the control panel can be covered with a plastic bag
 4. Lightning protection, in the event of lightning, it is necessary to turn off the power of the machine and unplug the power plug to prevent it from being damaged by lightning
 5. The grinding barrel is damaged, and the polishing needle is strong when the equipment is running, so when the barrel is placed in the polishing tank, if there is a polishing needle in the polishing tank, it should be cleaned in time

尊敬的用户，感谢您购买、使用冠古磁力研磨机设备。机器设备日常使用和保养得当，可避免人为因素造成的元件损坏、延长机器的使用寿命。

Dear user, thank you for purchasing and using Guangu magnetic grinding machine equipment. Proper daily use and maintenance of machinery and equipment can avoid component damage caused by human factors and prolong the service life of the machine.

