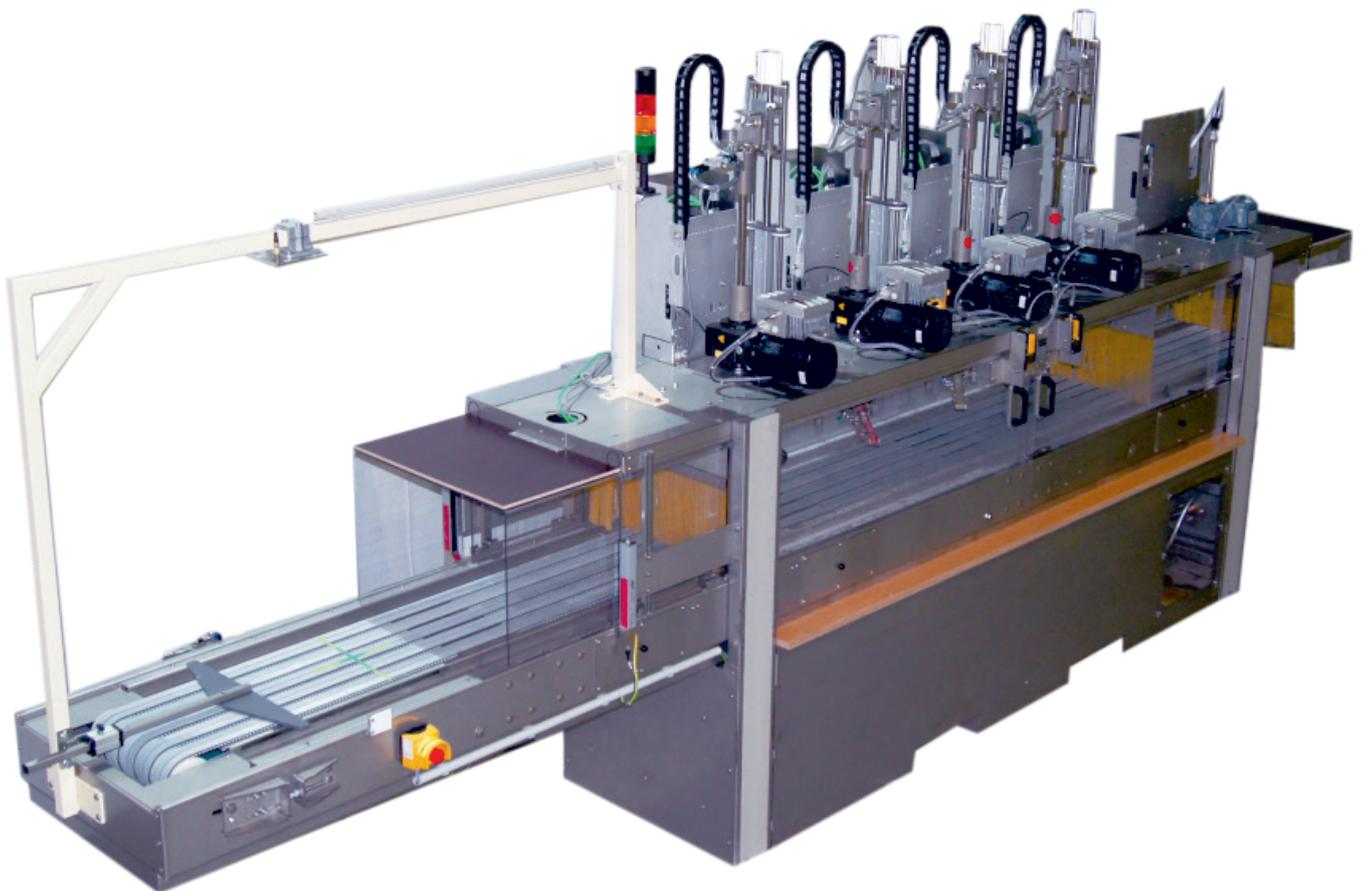


LIPPERT

MEMBER OF SCHUG GROUP

Universal Base Polishing Machine
AV 600-S/400/4-N-R
AV 600-S/540/4-N-R



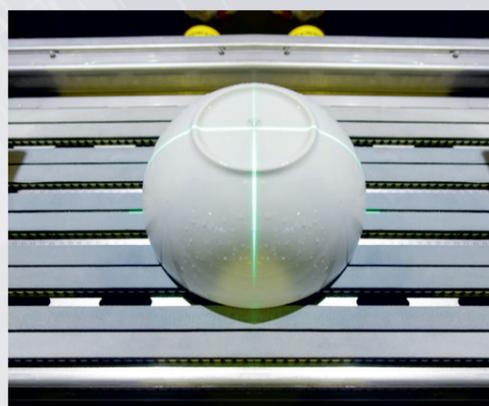
UNIVERSAL BASE POLISHING MACHINE AV 600-S

BENEFITS

- High degree of flexibility due to mixed operation (no adjustment necessary)
- Highest polishing quality due to circular polishing from glaze to glaze, even with very coarse bases, such as isostatically pressed plates
- Simple machine concept and thus low investment costs
- Low operating costs and high availability as a result of very long service life of the diamond abrasives
- Extremely wide range of application: plates, bowls and dishes with double bases or non-rotationally symmetrical bases (square bases, oval bases, curved platters)
- High degree of reliability and long-lasting design with minimum moving parts above the polishing area
- High output



Polishing of square bases and counter bases



Loading point with laser cross line



Circular polishing of base contour



Enclosed polishing space with overhead polishing spindles

DESCRIPTION

This logical further development of LIPPERT's proven universal base polishing machine AV 600 for bases of plates, dishes and cups is now able to handle and polish different items, one after the other, in order of your choice.

As items enter the polishing tunnel, a measuring system establishes their height and automati-

cally adjusts the following polishing units to the required height for the respective item.

This offers operators a completely new opportunity, as they can now polish the fired items directly after glost firing and in the order of their choice and then stack them without needing to use paper intermediate layers.

OPERATING SEQUENCE

By means of a cross laser, a reticle is projected onto the feed position of the conveyor system and serves as an orientation aid for the operator. Upon entering the polishing tunnel, the article is measured and the height information is transferred to the respective polishing unit. Thus, the respective polishing head automatically adjusts to the required article height.

Depending on the requirements of the ceramic material or polishing quality, the machine can be configured with three or four polishing spindles, surface polishing wheel, plate or cup polishing heads. If required, a base contour polishing head suitable for cups is available as well, to polish even smaller base diameters.

All polishing heads are equipped with water-cooled diamond polishing wheels or diamond po-

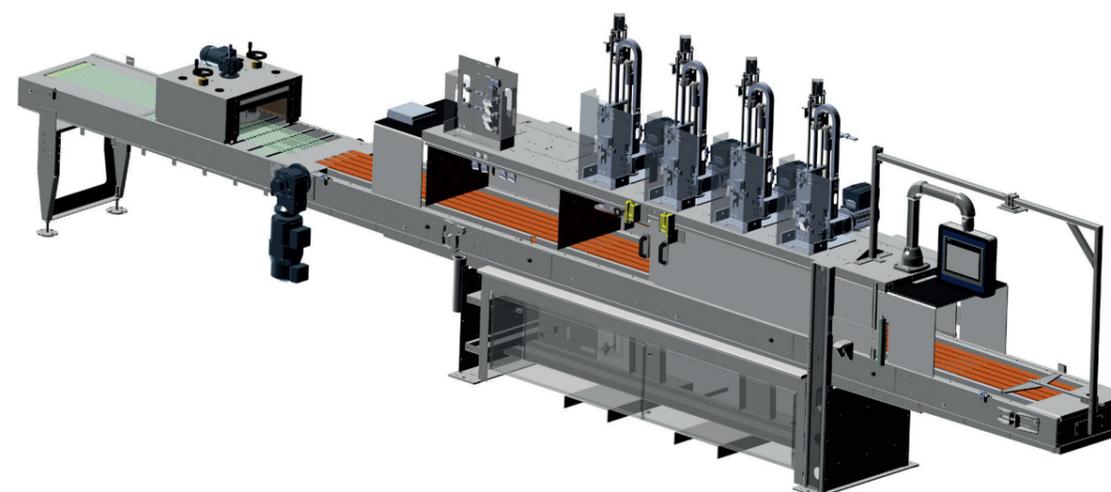
lishing belts, featuring outstanding polishing quality and long service life. After the polishing process, the articles are cleaned by spraying them with water from above.

Outside the polishing tunnel follows a separate station for spraying the articles via compressed air.

However, when leaving the machine, the articles are still damp and some marks of polishing residues might remain visible, especially on dark glazes. If required, the machine can be supplemented by a separate article washing system.

After the spraying process, the items can be manually removed from the conveyor system.

SYSTEM LAYOUT





TECHNICAL DATA

AV 600-S/400/4-N-R - AV 600-S/540/4-N-R

■ Output	1,100 pcs/h at 1.0 sec polishing time	1,000 pcs/h at 1.0 sec polishing time
	900 pcs/h at 2.0 sec polishing time	800 pcs/h at 2.0 sec polishing time
	750 pcs/h at 3.0 sec polishing time	650 pcs/h at 3.0 sec polishing time

The maximum output depends on the polishing time and continuous operation of the machine. The stated output can be achieved when batches of identical items are polished. In case of continuous product change, the output decreases slightly.

■ Product types	Plates, bowls, oval plates, square plates, cups	
■ Number of polishing stations	2 – 4 (freely configurable)	
■ Spindle spacing	400 mm	540 mm
■ Total length polishing machine	7,100 mm	8,500 mm
■ External dimensions of articles	round	min. 75 mm
	rectangular	max. 360 x 360 mm
■ Base diameter of articles	min. 60 mm	min. 60 mm
	max. 250 mm	max. 330 mm
■ Double base diameter	min. 60 mm	
Double bases can be polished if the following conditions are met:		
<ul style="list-style-type: none"> ▪ Use of a flat polishing blade (0°) ▪ The base height is sufficient ▪ The double base must be designed as round, oval shaped or rectangular contour. Linear double bases cannot be polished. 		
■ Article height	min. 15 mm max. 150 mm	
■ Electrical connected load	3.3 kW	
■ Cooling water connection	Temperature	max. 30 °C
	Pressure	5 bar
■ Compressed air supply	6 bar	