

新生

大型部品自动检查机

2021/11/26

上海索広映像有限公司

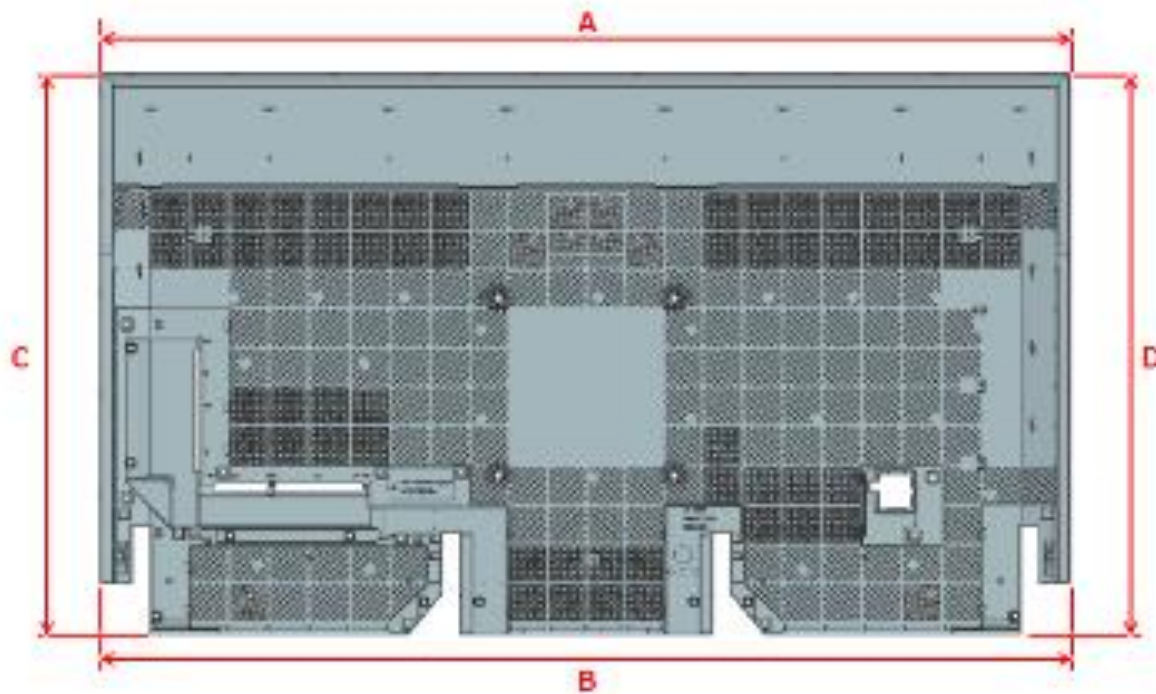
SSVE (Shanghai Suoguang Visual Products Co.,Ltd.)

检测项目内容：

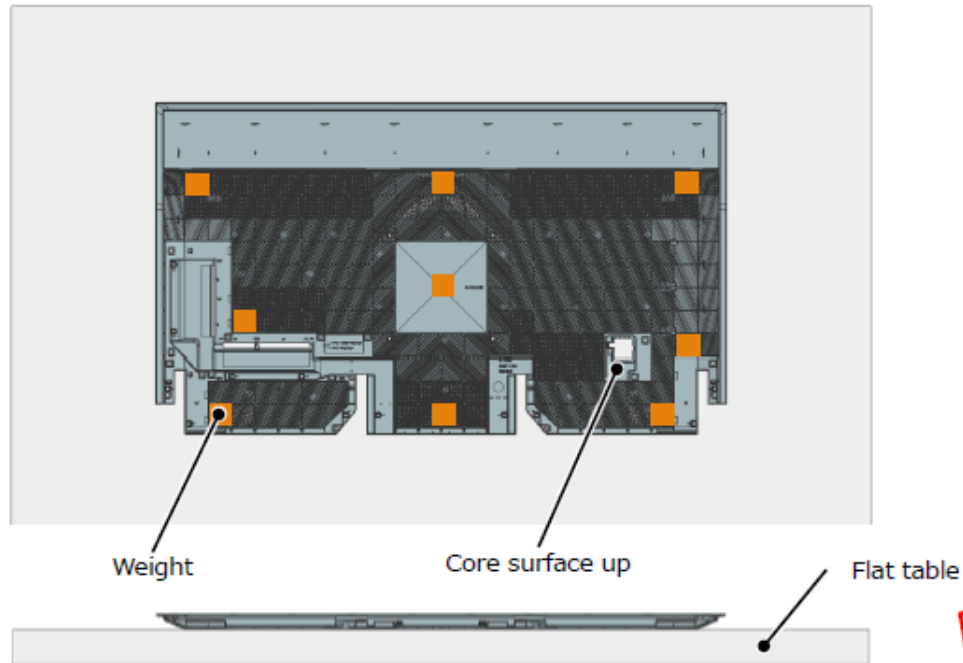
主要检测项目：

- 1.外径寸法： OUTLINE DIMENSION长宽尺寸， 变形 ---优先
- 2.混料防止： 同一幅模具的部品， 不同镶块检测 *同一部品上的洞孔不同
- 3.子部品的缺失检测
- 4.外观检查（熔接线， 色差， BURR...） ---以后再检讨

<Measurement places>



OUTLINE DIMENSION



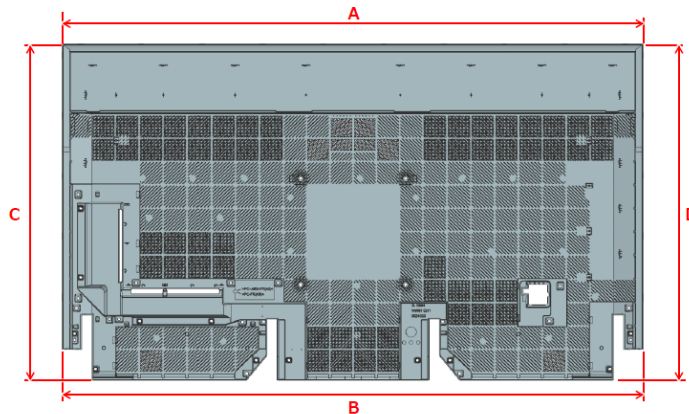
<Measurement method>

1. Prepare sample as below.
 - * Passing more than 1hour after injection
 - * Aging more than 30min at normal condition (Temp:15~25℃ / Humi:50~70%)
2. Put sample in condition core surface up on flat table.
3. Put some weight like the left figure.
4. Measure outside dimension by caliper.

设计指示的测量方法

Weight position is tentative.

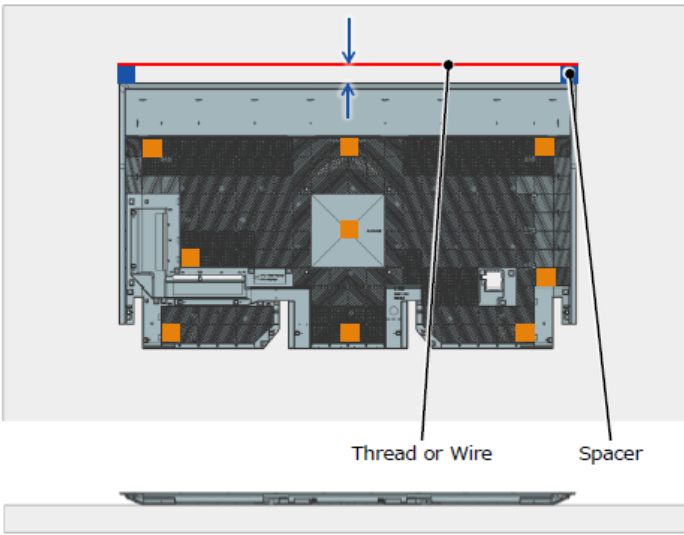
<Measurement places>



55" 外形尺寸 $1229.4 \pm 0.6\text{mm} \times 707.8 \pm 0.4\text{mm}$
85" 外形尺寸 $1278.8 \pm 0.8\text{mm} \times 1073.9 \pm 0.6\text{mm}$

*治具检查精度由治具供应商定义

WARPING CHECK (1)

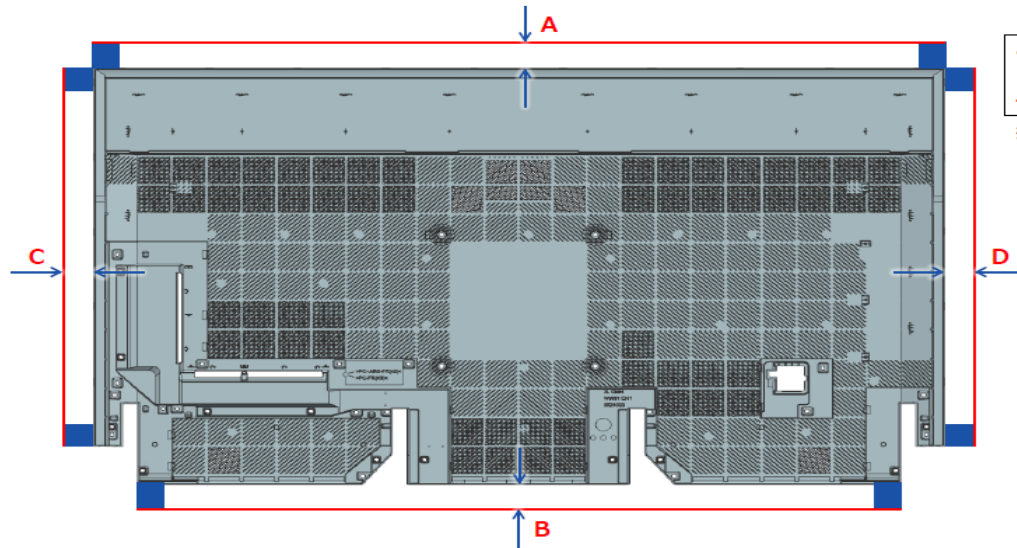


<Measurement method>

1. Prepare sample as below.
 - * Passing more than 1hour after injection
 - * Aging more than 30min at normal condition (Temp:15~25°C / Humi:50~70%)
2. Put sample in condition core surface up on flat table
3. Put some weight like the left figure.
4. Measure the gap between sample and thread or wire by scale.

Weight position is tentative.

<Measurement places>



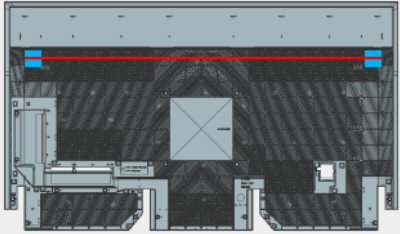
<Specification>

$$-1 \leq \text{Warping} \leq +1$$

※ Warping
= Measurement value - Spacer height

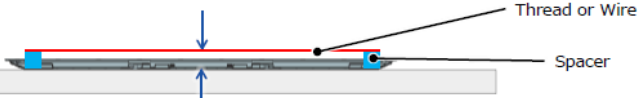
Warping变形量

WARPING CHECK (2)



<Measurement method>

1. Prepare sample as below.
 - * Passing more than 1hour after injection
 - * Aging more than 30min at normal condition
(Temp:15~25℃ / Humi:50~70%)
2. Put sample in condition core surface up on flat table
3. Measure the gap between sample and thread or wire by scale.



<Measurement places>

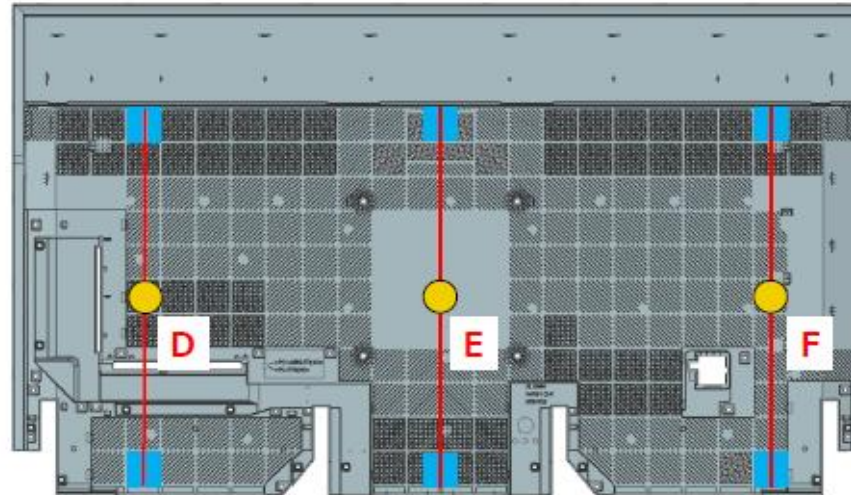
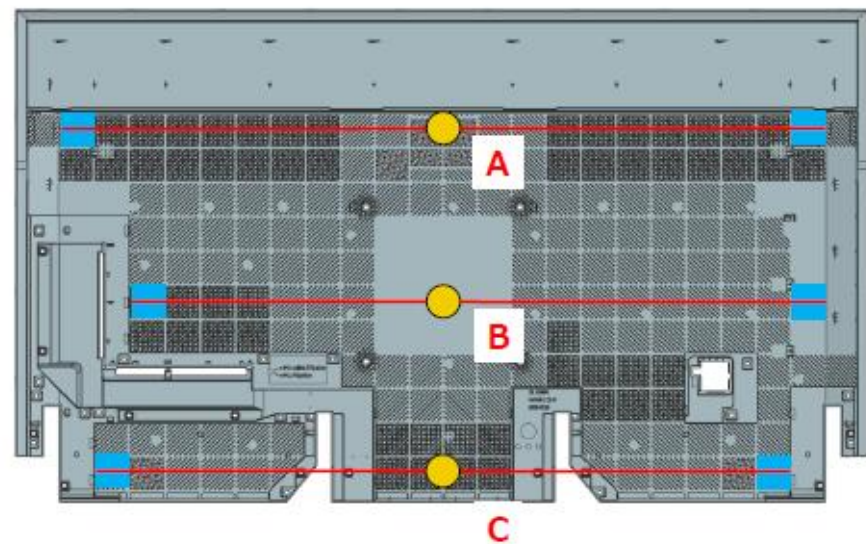
● : Measurement points

<Specification>

$$-5 \leq \text{Warping} \leq +5$$

※Warping
= Measurement value - Spacer height









Warping变形量

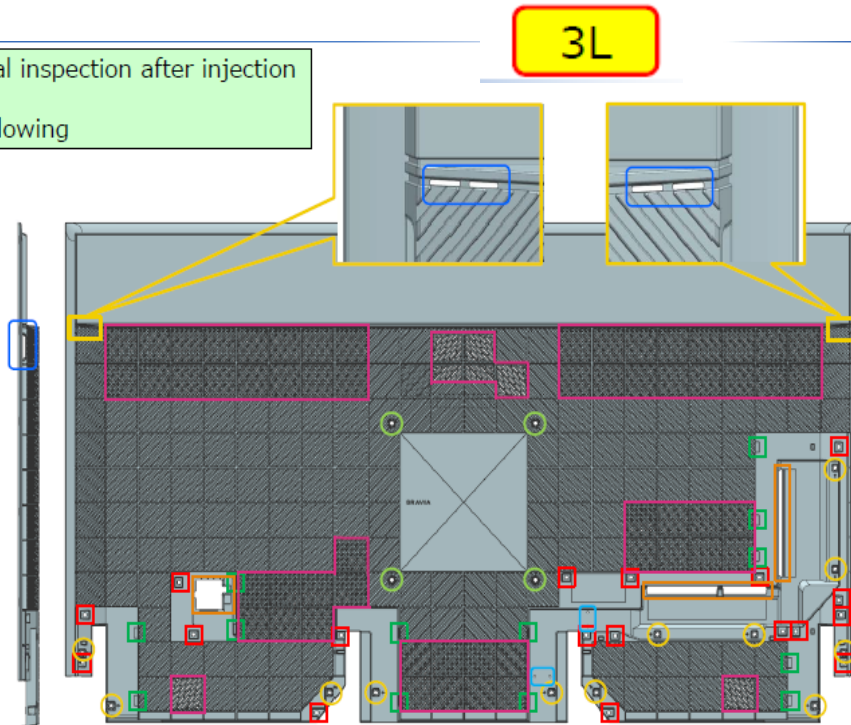


FINISHING CHECK

Frequency : 100% visual inspection after injection
 By whom : Operator
 Checking places : Refer to following









<Checking places>

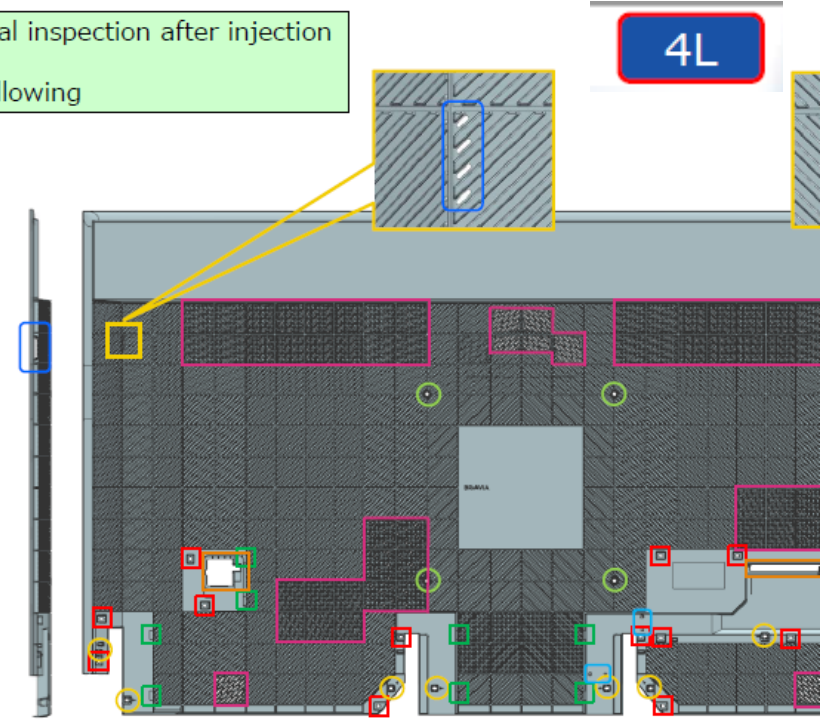
No.	Mark	Name	Q'ty
①		Catch hole	18
②		Cover hook hole	13
③		Screw hole	12
④		Screw hole for wall mount	4
⑤		Terminal hole	3
⑥		Ventilation hole	8
⑦		Clamper hole	2
⑧		TW hole	4



Frequency : 100% visual inspection after injection
 By whom : Operator
 Checking places : Refer to following

<Checking places>

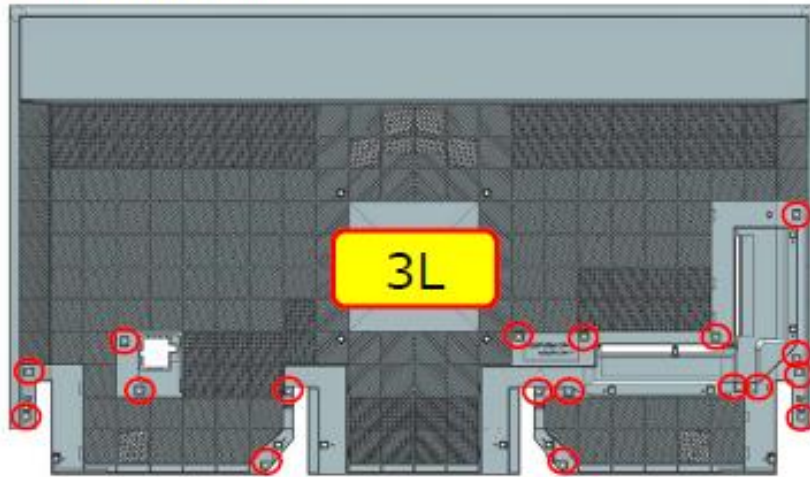
No.	Mark	Name	Q'ty
①		Catch hole	19
②		Cover hook hole	13
③		Screw hole	12
④		Screw hole for wall mount	4
⑤		Terminal hole	3
⑥		Ventilation hole	7
⑦		Clamper hole	2
⑧		TW hole	4



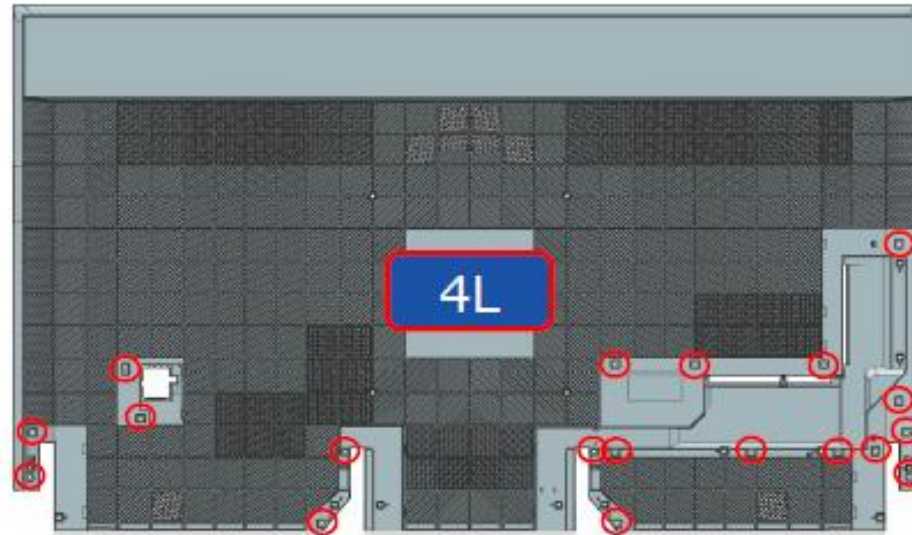
检测子部品缺失

Frequency	: 100% visual & finger inspection after assembly
By whom	: Operator
Specification	: No missing and floating of catcher
Checking places	: Refer to following

<Checking places>



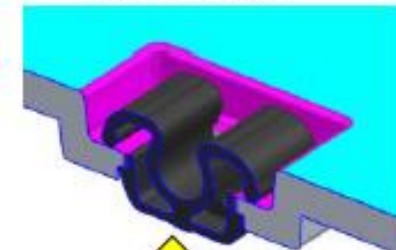
3L : 18 places



4L : 19 places



※ Confirm catcher is NOT popped-out by pushing from core side



Approx. 3kgf
(Use Small cover 100% check)

要求说明

- 1) 该检测治具兼容4款后盖产品（55 “~85” ）的尺寸检查，生产节拍低于30S/台，最终提供给索广的部品供应商生产线使用。
- 2) 部品的重量是85 “: 7700g, 55” : 3100g, 部品的公差要求 $\pm 0.6\text{mm}$ （移动平台，校验标准件，Sensor）
- 3) 治具的测量方式需要符合设计指示的测量方法如下图：
①放置在平板上 ②部品固定位置上需压块防止变形），放置压块请考虑使用液压系统,高度不在一个平面上
- 4) 测定结果记录保存和可导出（部品上有QR条形码）
- 5) 治具流出的检验容错率为0，索广会提前提供实物样品做验证。
- 6) 治具完成前的检证，进度管理，问题分析全部由治具厂家对应完成。

EOF