

镜腿制作建议,大部分流程都和醋酸一样,只是少了烤料的动作,减少了工序和能源损耗				
TEMPLE PROCESSING REMINDERS, ALMOST SAME WITH ACETATE EXCEPT NO NEED TO BAKE SO HEXETATE TREATMENTS REDUCE SOME MANPOWER AND ENERGY				
制程序号	制程名称 (脚)	设备、仪器、制夹具、工具、物料	参数条件/要求	不良处理方式/注意事项
sequence number	description (temple process)	equipment,appliance, fixture tooling, tooling,material	Parameter condition/requirement	Precaution for bad treatment method
101	烤料		无需烤料	材料特性及不缩水不变形故无需烤料
101	baking materials		no need baking materials	The reason for NO NEED to baking the material are: A.material characteristic has no shrinkage issue B. NO deformation issue
102	冲脾	开料机、冲模、夹模、胶板料、直尺、卡尺、水槽、温度计	也可以用75° 度热水浸泡15分±5分。	1. 如果非加温冲脾的情况下,可能会出现边缘发白现象。 2. 边缘发白在后续加工环节中,加热后将自行褪去,并不影响性能,所以无需关注
102	punch	cutting machine, punch mould, clip pould,plastic material,ruler,caliber ruler, sink, thermometer	can put into hot water with the 75°around 15±5 minutes	1. If it is not under the hot environment, cutting temple may have edge whitish  2. The situation of the edge turning white may happen in the subsequent processing, but it will fade away by itself, and will not affect the material functional performance. No need to pay attention to this situation
103	打磨铰链槽	自动变频打磨机、布轮、沙粉、胶脾	1. 转速: 1600转/分±100转/分  2. 胶件紧贴力度要均匀, 磨胶件的力度控制在2-3秒, 时间久了会烧焦。	常规加工方式, 无注意事项
103	polish the Hinge groove	utomatic frequency conversion grinding machine, polishing cloth - wheel ,emery powder	1.rotations per minute: 1600/min±100  2.the appress strength should be equal and the time should keep around 2-3 seconds,too long time will make the product burn	Normal processing method
104	打脾	插针机、高频机、硬模、水槽、温度计、卡尺、胶脾、金牌	1. 温度: 220℃ 2. 时间15秒~16秒	1. 在打半针时可能会因材料冷却速度较快, 并且粘度较大。在打入半针后, 应不停留快速拔出插针, 避免插针被黏住而拔不出, 或者拉伤半脾造成损伤导致易开裂。  2. 在打插针时应该注意, 材料温度及时间应高于普通CA, 故需注意材料应该软透, 而避免因材料为软透情况下, 打入插针而导致损伤。
104	metal core shooting	Metal core shooting machine,High frequency machine, Hard Tooling,water shank,thermometer,caliber ruler	1.temperature: 220℃ 2.time: 15-16 seconds	1.In the sitution of making platic temples and tips, the material gets cold very quickly,and viscosity will be high. After metal core shooting into temple tips, should not stay too long and take out the metal core quickly to avoid the cores gets sticky or get cracked  2.when putting metal cores into temple tips,please be noted that the HEXETATE temple plastic material is soft enough, because the temperature and time is higher than normal CA, we should avoid the defeats when metal core putting into the soft and hot HEXETATE Temples
108	压铰链	压铰链机、夹具	1, 模具的温度调到90° ±5° 2, 下压时间3~4秒	常规加工方式, 无注意事项
108	Hinge Pressing	Hinge Pressing Machine,fixture	1.The temperature of the mould should around 80°±5 2, The press time should be 3-4 seconds	Normal processing method
111	弯脾	加热机、弯脾夹具、胶脾、图纸	加热时间25秒 温度85℃	1. 如若温度或时间不到位, 可能会造成弯角处有少许发白或者白色条纹状 2. 处理方式热风吹风或者热水 加热即可自行褪去。 3. 温度不到位, 会造成材料自身回弹性与插针受力, 造成损伤。
111	Tips Bending	Heating machine,Bending Machine, drawings	heating time:25 second Tempreture:85℃	1.If the temperature and time is not reach the requirement,in the corner will turn white or some white wave  2.Solution is treating the white part with hot ovan or hot water 3.If the temperature can not reach the requirement,it will create defeats due to metal pins press and self elasticity of the material
112	滚粗桶	重竹DB110滚筒机、滚桶 12*12*10菱形举木(新芯)、一级粗滚油、胶脾	1. 滚桶18H-20H 2. 每槽装脾200~300付 3. 滚筒时间与普通醋酸相同, 即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性, 所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾, 可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
112	Rough Tumbling	Same with Acetate Tumbling woods	1. Tumbling 18H-20H 2. 200~300 pairs temples per barrel 3. Tumbling time can be same with Acetate	1.the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.it should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed
115	滚中桶	多重竹复合竹板滚筒机、7*7*7菱形举木(新芯)、三级滚光油、胶脾	1. 每槽装脾200~300付 2. 滚筒时间为18H-20H 3. 二级粗滚粒(7*7*7菱形举木)、0.3KG三级粗滚油 4. 滚筒时间与普通醋酸相同, 即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性, 所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾, 可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
115	Medium Tumbling	Same with Acetate Tumbling woods	1. Tumbling 18H-20H 2. 200~300 pairs temples per barrel 3. Tumbling time can be same with Acetate	1.the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.it should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed
116	滚光桶	多重竹复合竹板滚筒机、5*5*5举木子弹(新芯)、四级滚光油、胶脾	1. 一个小桶300付左右 2. 滚筒时间为3H-4H 43. 油0.3kg 4. 滚筒时间与普通醋酸相同, 即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性, 所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾, 可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
116	Light Tumbling	Same with Acetate Tumbling woods	1. Tumbling 3H-4H 2. 200~300 pairs temples per barrel 3. Tumbling time can be same with Acetate	1.the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.it should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed
119	抛光	自动变频打磨机、布轮、蜡粉、胶脾	1. 频率50HZ; 50HZ 2. 转速: 1600转/min±100转/min; 3. 工件与布轮接触的持续时间都不能超过3~4S, 以免打磨部位烧焦。	常规加工方式, 无注意事项
119	Polishing	Automatic frequency conversion polish machine, cotton wheel,wax	1.Frequency 50HZ  2.Rotations per minute: 1600/min±100  3.The contact time for the tooling and cloth wheel can not over3~4S,otherwise the polish part will burn	The normal processing method like Acetate,no special matters needing attention

前圈制作建议. 大部分流程都和醋酸一样，只是少了烤料的动作，减少了工序和能源损耗				
FRAME PROCESSING REMINDERS, ALMOST SAME WITH ACETATE EXCEPT NO NEED TO BAKE SO HEXETATE TREATMENTS REDUCE SOME MANPOWER AND ENERGY				
制程序号	制程名称 (前圈)	设备、仪器、制夹具、工具、 物料	参数条件/要求	不良处理方式/ 注意事项
sequence number	description (FRAME process)	equipment,appliance, fixture tooling, tooling,material	Parameter condition/ requirement	Precaution for bad treatment method
201	开料	开料机. 刨机	需加热冲料，温度75℃，时间30秒	1. 如果非加温冲载的情况下，可能会出现边缘发白现象。 2. 边缘发白在后续加工环节中，加热后将自行褪去，并不影响性能，所以无需关注
201	Cutting	Cutting machine Planer	Warm up when cutting the material Temperature:75℃ Time: 30 seconds	1. If it is not under the hot environment, cutting temple may have edge whitish  2. The situation of the edge turning white may happen in the subsequent processin,but it will fade away by itself, and will not affect the material functional performance. No need to pay attention to this situation
202	压中梁	750全自动弯机	加热时间5-6秒，温度100℃	1. 压中梁因根据中梁厚度自行调节温度及时间。 2. 如果温度及时间不到位，可能造成中梁部分有发白。 3. 中梁部位发白可以加热后自行褪去。
202	Bridge Pressing	750 plate automatic bender	time to warm: 5-6 seconds,,temperature:100 ℃	1. Adjust the temperature and time when pressing the bridge according to the thickness of the bridge.  2. if the temperature and time are not suitable,it may cause the middle part turn white
203	铣内孔	CNC铣内孔机. 夹具、刀具	1, 转速在20000~22000转 2, 刀具选用 Φ6. 0mm	常规加工方式，无注意事项
203	Milling hole	CNC milling inner machine, Fixtures, cutting tools	1, rotation rate: appx. 20000~22000 rotation/min 2, knife tool :Φ6.0mm	The normal processing method like Acetate,no special matters needing attention
204	拼叶子	自动拼料机	1, 鑫茂鸿机器气压3KG. 拼接3秒. 震动延时5秒; 2, 轩菱机器气压4KG. 震动时间7S. 震动延时0. 8. 起震延时1. 5S. 保持时间2. 0S. 震动强度350M 3, 捷瑞机器气压2. 2KG. 夹紧时间0. 50S. 压料进时间1. 50S. 定位退时间0. 50S. 压料退时间0. 50S. 减压启动1. 00S. 震动停时间1. 00S. 震动时间8. 00S. 夹料退时间0. 50S. 出料时间0. 50S	1. 拼叶子及庄头，因各品牌拼料机设备不同，可自行调节 2. 参数条件为我司收集的加工数据仅供参考。 3. 也可用拼料水拼接
204	Nospad Leaves lamination	Automatic lamination machine	1, XIN MAO HONG mahcine : air press 3kg, join 3 seconds,delay for the Vibration: 5 seconds  2, XUAN LIN machine: air press 4kg, join 7 seconds, delay for the Vibration: 0.8 seconds, Initiation delay : 1.5S,keep time: 2.0S,shockproofness : 350m  3, JIE RUI machina: air press 2.2 kg, clamping time: 0.5X, press the material time: 1.5S, time for returned fixed position : 0.5S, time for returned press material time: 0.5S, Decompression starting: 1.00S, stop time for the vibration : 1.00S, time for the vibration: 8 .00S, returned for clip material: 0 .5S, pouring time: 0.5S	1. Nospad leaves lamination can be adjusted according to in-house machine or technology facilities  2.Parameter conditions are for reference only  3.Also can be used with Aggregate water  4.Be careful: material lamination is valid only HEXETATE with HEXETATE, NO HEXETATE with ACETATE
205	拼庄头	XMH-PLJ/3拼接机	1, 气压为80P±10P; 2, 时间: 加紧时间1s. 上升时间2. 5s, 定位断开延迟时1s, <b>震动时间要10s+1/-0s</b> , 震动延迟1s; 3, 叶子及圈料的两边厚度公差在+0. 2mm/-0. 1mm	1. 拼叶子及庄头，因各品牌拼料机设备不同，可自行调节。 2. 参数条件为我司收集的加工数据仅供参考 3. 也可用拼料水拼接
205	Rivet Part Lamination	Laminate Machine suggest:XXMH-PLJ/3	the way to laminate rivet part is same with ACETATE but HEXETATE can be laminated with HEXETATE, not with ACETATE	1. Rivet part lamination can be adjusted according to in-house machine or technology facilities  2.Parameter conditions are for reference only  3.Also can be used with Aggregate water  4.Be careful: material lamination is valid only HEXETATE with HEXETATE, NO HEXETATE with ACETATE
206	车内外圈、叶 子及花式	CNC机(四轴)	1、车内外圈主轴转速20000~22000转 2、叶子. 庄头10000~12000转 3、进给量2. 0~2. 5米/min 4、刀具选用 Φ6. 0mm±0. 05mm; 5、气压调至7PA+/-1	材料特性不缩水。故无需开大内圈。即内圈公差可为+/-0 MM。
206	cut the inner and outer rim, leaves and rivets	CNC machine (four-axis)	1、minspeed of mainshaft when cutting the inner and outter ring : 20000~22000 rotations/min 2、leaves and End piece: 10000~12000 rotation /min 3、feed rate: 2.0-2.5 meter/min 4、knife tool :Φ6.0mm±0.05mm; 5、adjust the air pressure to 7PA+/-1	Due to NO SHRINKAGE RATE, no need to enlarge the inner ring szie.It means the tolerance of the inner ring should be +/-0 MM
207	滚粗桶	重竹DB110滚筒机、滚桶 12*12*10菱形举木(新芯)、 一级粗滚油、胶脾	1. 滚桶18H-20H 2. 每桶装脾200~300付 3. 滚筒时间与普通醋酸相同，即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性，所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾，可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
207	Rough Tumbling	Same with Acetate Tumbling woods	1. Tumbling 18H-20H 2. 200~300 pairs per barrel 3. Tumbling time can be same with Acetate	1.the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.it should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed
209	弯圈	弯圈机. 烤炉. 600弯胶膜、 循环水槽. 温度计、角度板、 量筒	1, 弯圈烤炉温度135±10℃，旋转的频率设定8S(10S转盘会旋转一次); 2, 弯圈下压时间 8±1s; 3, 循环水槽的水温设定15±2℃。	1. 弯圈因根据厚度及面弯调节温度及时间。 2. 时间过短或者温度过低，会导致材料自身的回弹性，而造成面弯回弹。
209	Rim(frame) Bending	same way with Acetate	1. oven temperature when bending the ring: 135±10℃, Rotation frequency setting: 8S(10S the turntable will rotate one time)  2. press time for bending the ring: 8±1S 3. Water temperature setting of circulating water: 15±2℃	1. bending ring should adjust the temperature and times as to the thickness  2. too short time or too low temperature will cause the resilience of the material itself and Surface bending springback
210	滚中桶	多重竹复合竹板滚筒机、 7*7*7菱形举木(新芯)、三 级滚光油、胶脾	1. 每桶装脾200~300付 2. 滚筒时间为18H-20H 3. 二级粗滚粒(7*7*7菱形举木)、0. 3KG三级粗滚油 4. 滚筒时间与普通醋酸相同，即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性，所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾，可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
210	Medium Tumbling	Same with Acetate Tumbling woods	1. Tumbling 18H-20H 2. 200~300 pairs temples per barrel 3. Tumbling time can be same with Acetate	1.the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.it should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed
212	滚光桶	多重竹复合竹板滚筒机、 5*5*5举木子弹(新芯)、四 级滚光油、胶脾	1. 一个小桶300付左右 2. 滚筒时间为3H-4H 43. 油0. 3kg 4. 滚筒时间与普通醋酸相同，即按照普通醋酸标准时间即可。	1. 材料对滚光油有较高的附着性，所以在滚油的添加量需要适度控制。 2. 滚油添加过多会造成表面发雾，可用超声波水洗去后重新抛光。 3. 滚筒时间应根据需要自行调节。
212	Light Tumbling	Same with Acetate Tumbling woods	1. Tumbling 3H-4H 2. 200~300 pairs temples per barrel 3. Tumbling time can be same with Acetate	1. the material has high adhesive property for the barrel oil,so we should control the adding amount of the oil  2.If add too much barrel oil,it will cause mist of the surface.It should use Sonic washing first,than polish again  3.The time of the barrel should be ajusted if needed

装配建议				
FRAME&TEMPLATE ASSEMBLING REMINDERS				
制程序号	制程名称 (前圖)	设备、仪器、制夹具、工具、 物料	参数条件/要求	不良处理方式/ 注意事项
sequence number	description (Assembling)	equipment,appliance, fixture tooling, tooling,material	Parameter condition/ requirement	Precausion for bad treatment method
303	切庄头	切脾机	1, 锣切机的转速2800转/分 2, 参照生产图纸要求的倾角、开放大小、长短, 按照上述工序的公差要求。	常规加工方式, 无注意事项
303	rivet part cutting	cutting machine	1, Rotation of the cutting machine: 2800/min 2, Pls refer to the requirement of the production drawing, angle of inclination, opening size, length,as to the tolerance requirements of the above procedure.	normal processing method ,no special matters needing attention
305	抛光	自动变频打磨机. 布轮、紫光蜡	1, 转速: 1600转/min±100转/min; 2, 工件与布轮接触的持续时间都不能超过3~4s, 以免打磨部位烧焦。	常规加工方式, 无注意事项
305	Polishing	Automatic frequency conversion grinding machine 、 cloth wheel、 Purple wax	1, Rotation rate: 1600rotation /min±100 rotation /min 2. Contact time for the tooling and cloth wheel can not over3~4s,otherwise the polish part will burn	normal processing method ,no special matters needing attention