

Ultrasonic Die Polishing Machine BD 140 M

Die Polishing Machine

SPECIFICATIONS:

Die size worked	: 0.10 to 3.0 mm
Electrical supply	: 220-240V 3A 50/60Hz 1 Ph
Ultrasonic generator	: 140W 20Khz
Finish	: Grey hammer with S.S panels
Needle holders	: for Ø 2.5 - 3 - 4 - 5 mm needles
Needles	: Ø 2.5 - 3 - 4 - 5 mm

DIMENSIONS:

Width	: 512 mm
Height	: 750 mm
Depth	: 400 mm
Weight	: 55 Kg



Ultrasonic Die Polishing Machine BD 140 M

The BD 140 M has been specially developed to polish natural and polycrystalline diamond dies from 0,10 mm up to 3,0 mm after maintaining the accurate and consistent die geometry realized on the US shaping machine such as BD 140 A or BD 140 SA.

The machine comprises a self contained bench unit housing the ultrasonic generator, working head and die table assembly. The working part of the machine is fitted with an acoustic enclosure which can easily be swung open to afford access to the die table.

All the controls are clearly arranged on the front panel to optimise ease of operation. The die table is supported in air bearings which enables the die pressure to be finely controlled depending on the size of die under repair. The angle of the die table swing can be readily adjusted on the front panel and set to the required angle for mirror polishing.

Hardened steel consumable needles are fitted into aluminum alloy tools, and are ground to the angles required. Needle changing is simple and clean without the need for solder or brazing and up to 15/20 dies can be worked with a single needle.

Standard needle sizes are 2.5 mm, 3 mm, 4 mm and 5 mm.

The use of the special «needle press» is highly recommended to fix the needle into the aluminum needle holders.



The machine can rapidly de-ring, reshape and if required, enlarge the bore of worn dies. But the primary purpose of this machine is final polishing.

Mirror polishing of the entire profile can be carried out without operator supervision, the working period being controlled by a process timer. The surface polish of large P.C.D. dies can be obtained without size enlargement if drawing rings have not been allowed to develop. The unit is supplied complete and ready to use.

