

Technical sheet-hard Anodization																										
Item	Step description	QTY	Tem	DK	Time	Rectifier	Material & preservation	Inner size			effective volume	Drain outlet			over flow	water supply			heating		cooling			sol ution cir culation	fil ter	Mark
							Bath	L	W	H		valve	waste water type	plug		direct water suppl y	flow meter	auto spray	material	power	mat erial	area	met hod			
			°C	A/dm ²	min	A/V		mm	mm	mm	L															
2	Soak 浸泡	1	60				δ15 PP	4000	550	1200	2200	☆	①		○			SUS304	40							
3	anodic cleaner阳极清洗	1					δ15 PP	4000	450	1200	1800	☆	①	☆	○								☆			
4	Rinse 1水洗→	1					δ15 PP	4000	450	1200	1800	☆	①	☆	○								☆			
5	rinse Acid dip 酸浸	1					δ15 PP	4000	450	1200	1800															
6	Rinse 1水洗→	1					δ15 PP	4000	450	1200	1800	☆	①	☆	○								☆			
7	Rinse 2水洗↑	1					δ15 PP	4000	450	1200	1890	☆	①		○								☆			
8-1	CN copper coating 氰化镀铜	1	45-55		5-10	3000/12	δ15PP	4000	650	1200	2600							TI	45				/h	☆		
8-2	CN copper coating 氰化镀铜	1	45-55		5-10	3000/12	δ15PP	4000	650	1200	2600							TI	45				/h	☆		
9	Rinse 1水洗→	1					δ15 PP	4000	450	1200	1800	☆	③	☆	○								☆			
10	Rinse 2水洗↑	1					δ15 PP	4000	450	1200	1890	☆	③		○								☆			
11	acid dip 酸浸	1					δ15 PP	4000	450	1200	1890															
12	Rinse 水洗→	1					δ15 PP	4000	450	1200	1890	☆	①	☆	○								☆			
13-1	Copper acid bath.酸铜	1	20-30		120-240	3000/12	δ15 PP	4000	700	1200	2800									TI	3	☆	/h	☆	阴极移动cathode move	
13-2	Copper acid bath.酸铜	1	20-30		120-240	3000/12	δ15 PP	4000	700	1200	2800									TI	3	☆	/h	☆	阴极移动cathode move	
13-3	Copper acid bath.酸铜	1	20-30		120-240	3000/12	δ15 PP	4000	700	1200	2800									TI	3	☆	/h	☆	阴极移动cathode move	
13-4	Copper acid bath.酸铜	1	20-30		120-240	3000/12	δ15 PP	4000	700	1200	2800									TI	3	☆	/h	☆	阴极移动cathode move	
14	Rinse 1水洗→	1					δ15 PP	4000	450	1200	1800	☆	②	☆	○								☆			
15	Rinse 2水洗↑	1					δ15 PP	4000	450	1200	1890	☆	②		○								☆			
16	Anti tarnish抗氧化	1					δ15 PP	4000	450	1200	1800															
1/17	Unloading/ Loading下料/上料	1																								
Note:		1.crane No: 1 pc, Mas lifting weight: 500KG, 2.cycle time: ≥30min/rack, flight bar No: 10 Pcs 3.the line with 2 set of waste air suction and treatment tower: acid-alkali waste air appr.: 28281m3/h, Fan power: 22KW, CN waste air appr.: 9545m3/H,Fan power: 7.5KW 4.Heating method: electric heating, temperature control automatically, initial temp as 20℃, temp rising time:150min. 5 Chiller capacity: 80000Kcal, input water temperature12℃, Output water temp 5℃ 6.Automatic line need city water: 3T/hour, (caiculated as 3hours water replace)																								
							☆	city water:	○	pure water																

waster watre 1: acid-alkali waste water(include oil); 2:

