

# MODULE REPAIRING MACHINE

## 组件返修机

ALU-HSR组件返修机，可拆卸与更换不良电池片和汇流条，兼容电池片166\*166mm-230\*230mm/9BB-20BB，兼容组件尺寸最大为2700\*1500mm。

ALU-HSR module repairing machine, can remove and replace bad cells and busbars, compatible with 166\*166mm-230\*230mm/9BB-20BB cells, compatible module size up to 2700\*1500mm.

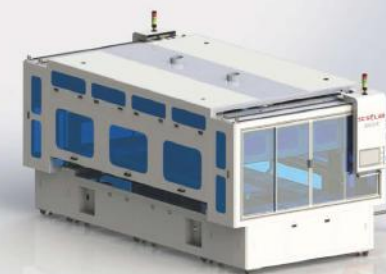


### 功能描述

- 自动切换程序可实现210组件（不含跳线），半片组件和双玻组件的返修。
- 拆卸焊头每个单独控制，可对单组电池串拆卸和焊接。
- 外置送料单元，可进行OK串上料和NG串下料，并带有判断电池串方向的相机。
- 具有独特的理片结构；理片范围±20mm。
- 兼容更大尺寸的组件：2700\*1500(mm)。

### Features

- Compatible for 210 modules (excluding jumper wire), half-cell modules and double glass modules repairing.
- The disassembling welding head is controlled individually, can disassemble and weld a single string.
- External feeding unit for OK string feeding and NG string unloading, with a camera to judge the direction of string.
- Have unique deviation correction mechanism, deviation correction range ±20mm.
- Compatible with larger modules: 2700\*1500(mm).



### 设备技术性能

电池片规格: 166\*166-230\*230(mm)/9-20(BB);  
 组件规格: A、166\*166-185\*185电池片: 6串\*10半片\*2, 6串\*11半片\*2, 6串\*12半片\*2, 6串\*12半片\*2, 片间距0.5-4(mm), 串间距1-4(mm);  
 B、210\*210电池片: 6串\*10半片\*2, 6串\*15三分片\*2, 片间距1-4(mm), 串间距1-4(mm);  
 玻璃尺寸: 最大 2700\*1500(mm); 最小 1640\*980(mm)  
 汇流带规格: 卷状供料, 料厚0.18-0.45(mm), 宽4/5/6/7/8mm, 卷重≤30kg  
 汇流带与焊带拉力: > 5N/mm (喷涂助焊剂)  
 节拍: 单串更换整体节拍85s  
 破损率: < 0.2‰(以片计算)  
 良率: ≥99% (按组件单位计, 流入汇流带焊接机的组件排版精度需在±0.5mm以内, 多主栅标准相同)  
 稼动率: > 98% (不含维护时间)  
 焊接方式: 电磁感应  
 组件输入/输出高度: 950-980(mm)  
 向上折弯U/L形引线高度范围: 10-25(mm)

### Functionality

Cell size: 166\*166-230\*230(mm)/9-20(BB)  
 Module specifications:  
 A, 166\*166-185\*185 cell: 6 strings\*10 half-cell\*2; 6 strings \*11 half-cell\*2; 6 strings \*12 half-cell\*2; 6 strings\*12 half-cell\*2; cell spacing 0.4-5 (mm), string spacing 1-4(mm);  
 B, 210\*210 cell: 6 strings\*10 half-cell\*2; 6 strings\*15 one-third cell \*2; piece spacing 1-4(mm), string spacing 1-4(mm)  
 Glass size: Max 2700\*1500(mm); Min 1640\*980(mm)  
 Bus-bar specification: roll feeding, material thickness 0.18-0.45(mm), width 4/5/6/7/8mm, roll weight ≤30kg  
 Bus-bar and welding belt tension: >5N/mm(spraying flux)  
 Cycle time: 85s  
 Fragmentation rate: <0.2‰  
 Yield: ≥99%  
 Utilization rate: >98%  
 Welding mode: electromagnetic induction  
 Module input/output height: 950-980(mm)  
 Bend up U/L lead height range: 10-25(mm)

### 技术参数 Specifications

项目 Item	数值 Value
电源 Power requirement	AC380V±5%, 3P+1N+1PE (3相5线制) AC380V±5%, 3P+1N+1PE(3-phase5-wire system)
气源 Air pressure	0.5-0.8(MPa)的干燥、干净压缩空气; 用量: 2m³/min 0.5-0.8(MPa)dry and clean compressed air; dosage: 2m³/min
功率 Power	额定50kW, 平均功率约35kW Rated 50kW, average power about 35kW
重量 Weight	6500kg
外形尺寸 Dimension(L×W×H)	5280*3866*2520(mm)