



科达陶机



科达制造



KEDA GROUP

科达制造股份有限公司

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陶瓷整厂工程

日用瓷解决方案

Complete Plant Solution for Tableware

公司简介

COMPANY PROFILE

让幸福更久远
GREEN SOLUTION · GREENER LIFE

科达制造股份有限公司创建于1992年，于2002年在上交所上市。业务涵盖建材机械、环保节能、锂电材料三大领域，拥有广东和安徽两大生产基地，4000多名员工。公司主营陶瓷机械业务，具有强大的陶瓷整厂整线工程研发、制造和服务实力，业务遍及全球50个国家和地区。

在“创新永无止境，永远追求更好”的经营理念指导下，科达致力于传统制造向自动化、智能化方向发展，努力践行“让幸福更久远——为节能减排提供装备与服务”的企业使命！

科达等静压成形日用瓷整厂生产线是近年来科达为日用瓷企业上规模、上档次而自主研发的具有世界先进水平的餐具生产线。基于多年陶瓷粉料成形工艺的经验积累，并借鉴当今世界先进的陶瓷餐具生产工艺，应用了盘、碗类制品的等静压成形工艺，科达经艰苦努力开发而成的自动化陶瓷餐具生产线，包括浆、釉料制备——喷雾干燥——等静压成形——修坯——施釉——烧成等工序，达到了当今陶瓷餐具生产工艺的世界先进水平。

KEDA Industrial Group Co., Ltd. was established in 1992 and IPO on Shanghai Exchange in 2002. Businesses scope includes building materials machinery, cleaning energy and materials for lithium batteries. It owns two production bases in Guangdong and Anhui, and has more than 4000 employees. With the powerful R&D ability, strong manufacturing strength and excellent service, its businesses cover 50 countries and regions around the world.

Under the guidance of business concept "Limitless creativity and boundless pursuit of excellent", KEDA works toward automation and intelligentialize, adhere to the enterprise mission of "green solution, Greener life"!

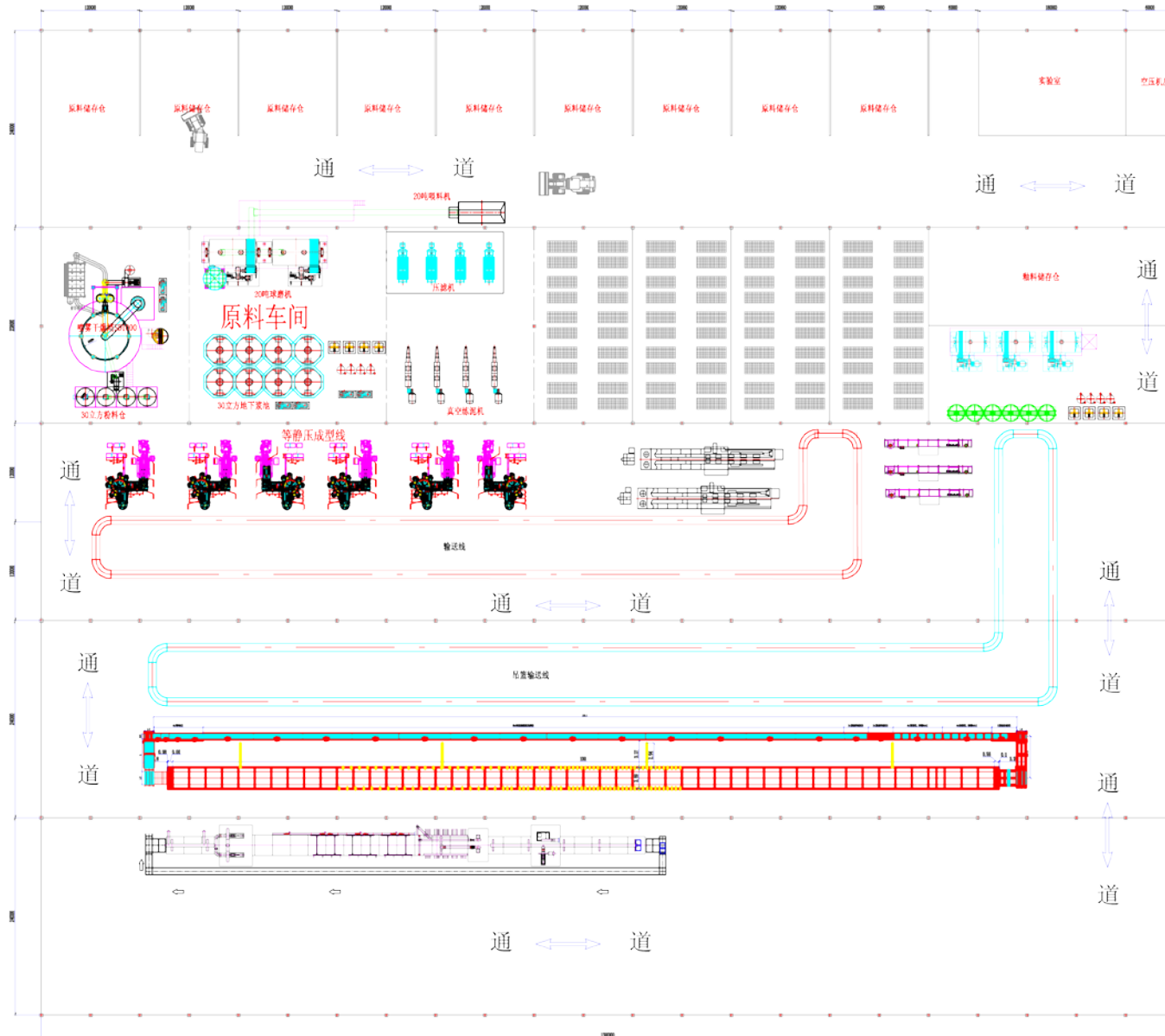
To meet the growing demand of the tableware enterprises, KEDA has developed the isostatic pressing complete plant production line for tableware, which integrates multiple working procedures of slurry/glaze preparation, spray drying, isostatic pressing, fettling, glazing, firing and world advanced technology of ceramic tableware.



平面布置图

LAYOUT

▾ 日产 5 万件
 Output:
 50000 pcs/day



坯料制备

RAW MATERIAL PREPARATION



釉料制备

GLAZE PREPARATION



喷雾干燥塔

SPRAY DRYER

型号 (Mode)	KT003	KT005	KT010	KT015	KT020	KT025	KT032
水份蒸发量 Water evaporation (kg/h)	300	500	1000	1500	2000	2500	3200
单位热耗 Heat consumption (kcal/kg*H ₂ O)	950	950	900	850	850	850	850
粉料产量 Powder output (kg/h)	700	1120	2241	3362	4482	5603	7172
喷嘴数量 Nozzle (pcs)	2	8	10	12	16	18	24
塔内真空度 Vacuum degree (Pa)	100~300						
燃料 (热风炉) Fuel (Hot air generator)	天然气、液化石油气、发生炉煤气、重油、柴油、混合油、水煤浆、煤 (可利用窑炉余热或其它余热) NG, LPG, producer gas, heavy oil, diesel oil, mixture oil, coal water slurry, coal (recycled heat from kiln or other)						
干燥器内径 A Dryer inner diameter (mm)	3500	4800	5600	6000	6500	7000	7200
装机功率 Installed power (kw)	11.5	11.5	24	29.5	48	52	77
最大安装高度 Max. installation height (m)	15.0	15.6	16.4	17.5	18.0	19.2	20.5



等静压成形线

ISOSTATIC PRESSING LINE

KDR400A 全自动日用瓷等静压成型机

Isostatic Press for Tableware

KDR400A 全自动日用瓷等静压成型机是科达在多年来成功研发和生产陶瓷压砖机的基础上，根据日用瓷盘碟类的生产工艺要求和等静压成型的特点，自主研发的具有世界先进水平的一款日用瓷盘坯成型机。

该机主要应用于高档日用瓷盘、碟的粉料压制成型，是基于工业化大生产的全自动生产设备。最大压制盘坯直径为 $\phi 365\text{mm}$ ；能生产圆形、异形（方形、椭圆形等）、有饰边和浮雕要求的盘、碟类制品。

- ◎ 主机采用经典成熟的三梁四柱结构，立柱分段预紧，弹性变形小，具有超强的抗疲劳能力。
- ◎ 拉杆作中梁导向，工作精度极佳。
- ◎ 使用快速更换模具装置，能大大缩短更换模具的时间，安装拆卸模具方便。
- ◎ 模具中的软模采用特殊材料制成，具有超强的耐磨性及韧性。
- ◎ 先进的伺服闭环控制技术保证坯体厚度的误差极小。液压系统稳定、可靠。
- ◎ 电气系统采用了西门子 PLC 控制技术，可靠性高，操作性高。可实时显示主缸、静压缸压力曲线和主缸位移曲线。
- ◎ 具有配方存储、自动报警和远程监控等功能。
- ◎ Classic and mature 3-beam, 4-column structure: whole preloaded column with less elastic deformation and with strong anti-wearing capacity.
- ◎ Pull rod guiding center beam guarantees high precision.
- ◎ Rapid mould-changing, convenient mould assembly/disassembly greatly shortens the time.
- ◎ Special material guarantees super antiwear and tenacity of soft mould.
- ◎ Advanced servo closed-cycle control technology guarantees minimal thickness error; stable and reliable hydraulic system.
- ◎ Siemens PLC control technology for electrical system, which is highly reliable and practical; it can display main cylinder, isostatic cylinder pressure curve and main cylinder displacement curve.
- ◎ Formula storage, auto alarm and remote control function.

Automatic Isostatic Press KDR400 is used for ceramic tray pressing; it is a KEDA self-dependent invention with internationally advanced technology based on experience of ceramics press manufacturing, and accords with tray technical requirements and features of isostatic pressing.

It is developed on the basis of industrialized production. The maximum diameter of product is $\phi 365\text{mm}$; and it can produce round or special (square, oval) shaped tray or dish ware with border and relievo.



技术参数 Technical Parameter

闭合压力 Closing pressure	结构形式 Structure	生产成瓷口径 Product diameter	压坯最大高度 Max. height	最大产量 Max. output	中梁行程 Crossbeam stroke	压框内模具数 Mould qty	主缸最高压力 Cylinder max. pressure	等静压压力 Isostatic pressure	液压油量 Hydraulic oil	压缩空气压力 Compressed air pressure	压缩空气流量 Compressed air flow	冷却水压 Cooling water pressure	冷却水量 Cooling water	装机功率 Installed power	整机净重 Net weight
4000 KN	卧式 Horizontal type	$\phi 160-\phi 300(\text{mm})$	90 mm	350-500 件 /小时 pcs/h	250mm	1	32.3MPa	30MPa	300L	0.6MPa	1.8~2 m ³ /min	0.2MPa	4-6m ³ /h	40kW	14000kg

KDR600 全自动日用瓷等静压成型机

Isostatic Press for Tableware

KDR600 全自动日用瓷等静压成型机是科达在多年来成功研发和生产陶瓷压砖机的基础上，根据日用瓷盘碟类的生产工艺要求和等静压成型的特点，自主研发的具有世界先进水平的一款日用瓷盘坯成型机。

该机主要应用于高档日用瓷盘、碟的粉料压制成型，是基于工业化大生产的全自动生产设备。最大压制盘坯直径为 $\phi 365\text{mm}$ ；能生产圆形、异形（方形、椭圆形等）、有饰边和浮雕要求的盘、碟类制品。

- ⊙ 主机采用经典成熟的三梁四柱结构，立柱分段预紧，弹性变形小，具有超强的抗疲劳能力。
- ⊙ 拉杆作中梁导向，工作精度极佳。
- ⊙ 使用快速更换模具装置，能大大缩短更换模具的时间，安装拆卸模具方便。
- ⊙ 模具中的软模采用特殊材料制成，具有超强的耐磨性及韧性。
- ⊙ 先进的伺服闭环控制技术保证坯体厚度的误差极小。液压系统稳定、可靠。
- ⊙ 电气系统采用了西门子 PLC 控制技术，可靠性高，操作性高。可实时显示主缸、静压缸压力曲线和主缸位移曲线。
- ⊙ 具有配方存储、自动报警和远程监控等功能。
- ⊙ Classic and mature 3-beam, 4-column structure: whole preloaded column with less elastic deformation and with strong anti-wearing capacity.
- ⊙ Pull rod guiding center beam guarantees high precision.
- ⊙ Rapid mould-changing, convenient mould assembly/disassembly greatly shortens the time.
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技术参数 Technical Parameter

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6000KN	卧式 Horizontal type	$\phi 160-\phi 340(\text{mm})$	130mm	350—500 件/小时 pcs/h	300mm	1	31.8MPa	$\leq 30\text{MPa}$	400L	0.6MPa	1.8~2 m ³ /min	0.2 MPa	4-6m ³ /h	50kw	17500kg

KRXH400 全自动日用瓷回转台式修坯机

Isostatic Press for Tableware

KRXH400 全自动日用瓷回转台式修坯机是配套全自动等静压瓷盘成型机使用的，能高效快速修整日用瓷盘、碟类口沿及底足的，具有世界先进水平的一款自动化设备。

本设备主要应用于日用瓷盘毛坯口沿及底足的修整，最大修坯直径为 $\phi 400\text{mm}$ ，能适应圆形、异形（方形、椭圆形等）等形状的盘、碟类制品。

- ◎ 模块化设计，多工位同步动作，实现不间断修坯功能。
- ◎ 单机按功能分拆设计，主要分为接坯、进坯、修坯、出坯、叠坯 5 大部分，安装简便。
- ◎ 各调节位置采用手轮调节，转产更方便。
- ◎ 全电机采用变频控制，保证不同制品在修坯过程中的速度匹配。
- ◎ 采用高精度位置检测元件，可靠性高，保证修整异形盘外形过程的一致性。
- ◎ Modular design, multi-work position simultaneous actions for continuous trimming.
- ◎ Function modular design, the structure including tile receiving, feeding, trimming, discharging and stacking unit, easier installation.
- ◎ Handle wheel adjustment for convenient product changing.
- ◎ Inverter controlled motor guarantees stable speed variation for different products.
- ◎ High precision test unit guarantees uniformity of special product.

KDR400 isostatic fettling machine is an auto machine with internationally advanced technology. Supporting the use of the isostatic press for tableware.

It is mainly used for tableware green body trimming, up to body diameter 400mm, and it can be used for round or special shaped items.



技术参数 Technical Parameter

修坯对象 Product (mm)	修坯规格 Product Height (mm)	修坯高度 Product Height (mm)	修坯次数 Frequency (pcs/min)	码垛高度 Stack height (mm)	压缩空气压力 Compressed air pressure(MPa)	压缩空气用量 Compressed air consumption(L/min)	外形尺寸 (长 × 宽 × 高) Overall dimension (L x W x H) (mm)	总重 Total weight (kg)	总功率 Total power (kW)
日用瓷盘、瓷碟、斗碗 Tableware dish, tea cup, bowl	圆盘口沿直径 Round dish dia.: $\Phi 160 \sim \Phi 400$ 异形盘口沿对角边长 Special dish diagonal: 160~400	≤ 100	圆盘 Round dish: 8 异形盘 special dish: 5	850	≥ 0.5	1000	5500×5400×2075	2144	10.75

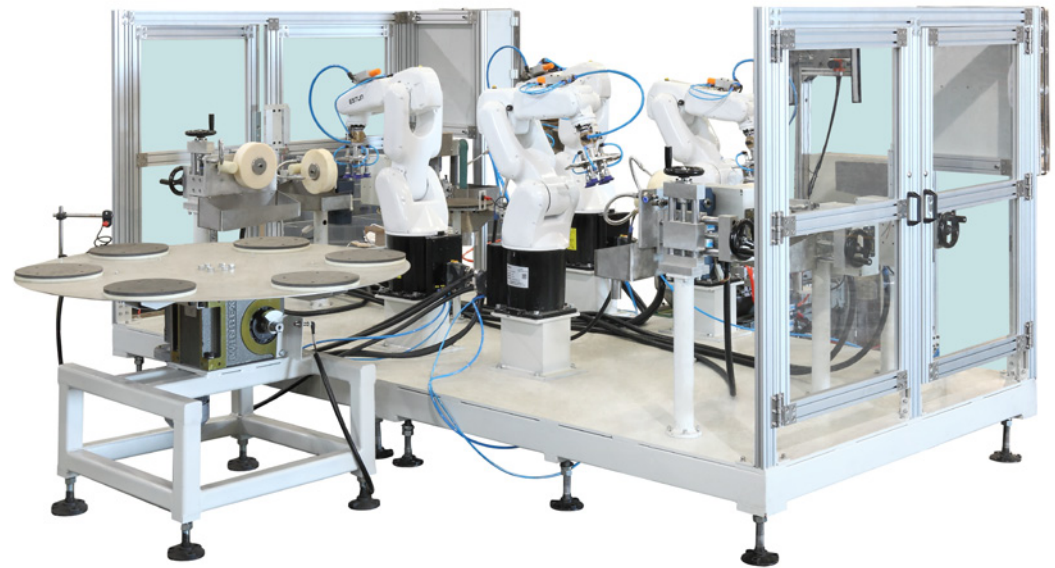
KRXJ 160/400 全自动日用瓷机器人修坯机

Isostatic Press for Tableware

全自动日用瓷机器人修坯机可完全代替人工修坯，降低工人的劳动强度、提高生产率、提升产品质量、改善工作环境；填补国内日用瓷异形盘坯修坯技术的空白，满足大多数厂家需求。是一款具有国际领先水平的自动化生产设备。

KDR400 isostatic fettling machine is an auto machine with internationally advanced technology. Supporting the use of the isostatic press for tableware.

- ◎ 自动化程度和生产效率高，能耗低，大大降低工人劳动强度；
- ◎ 采用视觉识别系统识别坯体中心位置、边沿轮廓、方位；视觉识别精度高，将识别信息传给机器人，取坯和修坯定位精准；
- ◎ 机器人修坯运行稳定可靠，破损率极低、质量高、速度快，适合各种形状的异形盘修坯。
- ◎ Modular design, multi-work position simultaneous actions for continuous trimming.
- ◎ Function modular design, the structure including tile receiving, feeding, trimming, discharging and stacking unit, easier installation.
Handle wheel adjustment for convenient product changing.
- ◎ Inverter controlled motor guarantees stable speed variation for different products.



技术参数 Technical Parameter

修坯对象 Product (mm)	修坯规格 Product Height (mm)	修坯规格 Product Height (mm)	修坯高度 Product Height (mm)	修坯次数 Frequency (pcs/min)	码垛高度 Stack height (mm)	码垛数量 Stack qty. (Mpa)	码垛台工位数 Stack working unit qty. (pcs/min)
日用瓷盘、瓷碟、斗碗 Tableware dish, tea cup, bowl	4 台 /6 轴, 臂长约 730mm 4sets/6axis, arm length 730mm	圆盘口沿直径 Round dish dia.:Φ160~Φ400 异形盘口沿对角边长 Special dish diagonal: 160~400 (修大圆弧曲线)	≤ 80	非圆型对称异形盘最快速度 4-5 个 /min Max. speed for unround symmetric special dish: 4-5 pcs/min 非圆型不对称异形盘最快速度 3-4 个 /min Max. speed for unround asymmetric special dish: 3-4pcs/min	750	10 寸半圆盘: 4 层【√】 10 inch half round dish: 4layer 8 寸圆盘: 6 层【√】 8 inch round dish: 6layer	6 个

辊道窑

ROLLER KILN

辊道窑 -KYG1.58/100-1Q

Roller kiln-KYG1.58/100-1Q



- ◎ 产品规格：等静压盘、碗，注浆及滚压产品
- ◎ 有效装载宽度：1320mm
- ◎ 有效装载高度：≥ 430mm（前窑段辊上7层棚板）
- ◎ 窑炉长度：100m
- ◎ 窑炉产量：5万件/d（按盘、碗、杯混装计）
- ◎ 窑炉垫板：430x330x12mm
- ◎ 烧成温度：1280℃
- ◎ 烧成周期：5h，在3.5-8h内可调
- ◎ 温度控制：温控表 + 助燃风自控阀 + 燃气电磁阀 + 比例阀（压力控制）
- ◎ 助燃风入烧嘴温度：100±10℃
- ◎ 能耗：≤ 1817 Kcal/Kg 瓷（每吨瓷耗天然气 230m³）
- ◎ 45°斜齿轮传动

- ◎ Product: isostatic pressing dish, bowl, grouting and rolling product
- ◎ Valid loading width: 1320mm
- ◎ Valid loading height: ≥430mm (7-layer shed board on the front kiln roller)
- ◎ Kiln length: 100m
- ◎ Output: 50000pcs/d (dish, bowl, cup mixed)
- ◎ Bearing plate size: 430x330x12mm
- ◎ Firing temperature: 1280℃
- ◎ Firing cycle: 5h, adjustable within 3.5-8h
- ◎ Temperature control: temperature control meter + combustion air auto-control valve + gas solenoid valve + proportional valve (pressure control)
- ◎ Combustion air temperature before burner: 100±10℃
- ◎ Energy consumption: ≤1817 Kcal/kg (230m³ natural gas per ton of ceramic tiles)
- ◎ 45° bevel gear drive

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