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GUANGU

MAGNETIC POLISHER



- Solve surface treatment problems such as hardware burrs, welding spots, and knife marks at one time

CONTENTS

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Table of contents

COMPANYPROFILE	1
COMPANY CULTURE	2
CERTIFICATE OF ASSETS	3
Features	4-5
Equipment advantages and application range	6
Product parameters	7-14
Grinding Consumables	15
Grinding Case	16-18
Use Answer	19
Code Display Solution	20
Panel Introduction	21
Equipment Daily Maintenance	22



冠古科技

COMPANYPROFILE

Guangu Technology (Suzhou) Co., Ltd. is located in Suzhou City, Jiangsu Province, which is known as the "Jiangnan Water Town". Since its establishment, it has focused on R&D, design, production and sales of water treatment, magnetic grinding and polishing machines, magnetic rolling and polishing machines for deburring the dead corners of precision metal parts, and other automation machines. Guangu strives to become a well-known domestic brand of deburring machines and magnetic polishing machines for precision small parts.

Aiming at the current problem of metal surface polishing, cleaning and deburring in China, Guangu has launched a fully polishing equipment to deburr inner hole and dead corner that can replace manual work efficiently: magnetic polishing machine, magnetic grinding machine, magnetic rolling and polishing machine, magnetic deburring machine, all Automatic polishing and grinding equipment such as automatic deburring machines and related grinding and polishing consumables.

Guangu magnetic polishing machine has undergone precise and rigorous engineering design, strict production management and quality control system, so that each part has undergone strict inspection from material selection, processing and production, assembly, debugging and other links. The core components of the equipment are all first-line brand accessories , welcome to visit the factory for samples.

CORPORATE CULTURE



vision

Be a respected equipment manufacturer



Mission

Promote the charm of China's intelligent manufacturing



system of values

Create benefits for customers and create happiness for employees



Talent Concept

The right man is for the right job



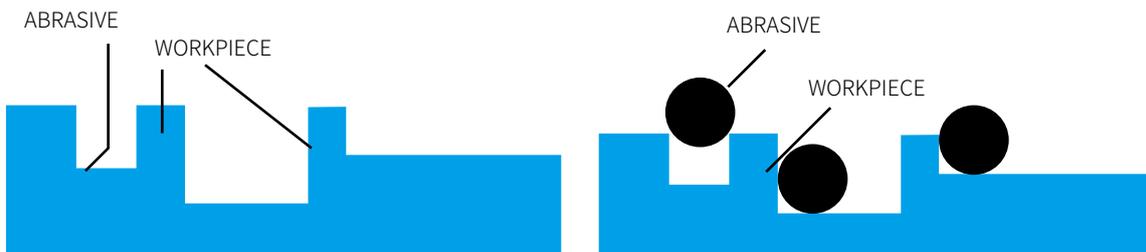
Features

Device Overview

Thank you for purchasing Guangu magnetic polishing machine! Guangu magnetic polishing machine is a new type of polishing and deburring machine cleaning equipment independently developed. The company's equipment adopts first-line brand accessories at home and abroad. It is simple, easy to operate, and unique in design, which fundamentally solves the problem of traditional polishing, cleaning and deburring. It solves the post-processing problems such as polishing and grinding of damaged workpieces, dead angles, inside pipes, through holes, blind holes, etc., and improves the polishing efficiency and product quality.

Working Principle

Guangu magnetic polishing machine uses super electromagnetic force to drive small magnetic grinding steel needles, so that the polishing needles generate high suspension flow, reversing and tumbling, and the steel needles gently slide over the surface of the workpiece, rub on the inner holes, inner and outer teeth and surfaces of the workpiece to achieve polishing cleaning, removal of oil and impurities, removal of burrs, etc. Achieve precision polishing effect without affecting the accuracy or damaging the workpiece.



The magnetic needle of the magnetic polishing machine can grind the inside of the hole, the crack, the right angle, the thread of the metal workpiece, etc., and the fine grinding speed is fast

When the traditional polishing machine grinds metal workpieces, the inside of the hole, the gap, and the right angle cannot be ground

▲

Grinding Schematic Diagram Of Magnetic Polishing Machine And Traditional Polishing Machine

Features |

Equipment introduction

- 01 Realize deburring, chamfering, polishing, cleaning and other multiple functions.
- 02 For irregular parts, holes, tubes and other dead corners, cracks can be polished and cleaned.
- 03 Low grinding cost, 304 stainless steel magnetic needle, extremely low consumption.
- 04 The grinding speed is fast, the average grinding time is 5-15 minutes each time, the workpiece can be changed quickly, and the grinding workpiece can be changed without stopping the machine.
- 05 Variable frequency adjustment to meet various polishing requirements.
- 06 Polished without dead ends.
- 07 The operation is simple, safe and technology-free, and one person can control several machines.
- 08 The equipment voltage, motor frequency, and running time are intuitive and clear, and easy to operate.
- 09 After the finished parts are ground, there will be no deformation, no dead angle, no damage to the surface, and no impact on precision.

Equipment advantages and application range

Equipment introduction

Braking function: automatic braking with electronic anti-phase current output electrodes. Advantages: no friction, no loss, durability, and energy saving.

The equipment adopts the overall structural frame.

The national standard steel plate shell has no gaps as a whole, and the structure is firm, thick and stable. Five-process high-temperature anti-stripping and anti-corrosion treatment.

Safety measures: start by light contact, design of all cooling components in the control part, no leakage, safe.

Rotation: During work, the turntable has no power loss, and the 4KW motor has no deceleration phenomenon between no-load and load at any speed,It can be detected for 1000 hours without stopping. The equipment is stable and energy-saving.

Equipment introduction

It is suitable for grinding and polishing metal workpieces such as gold, silver, copper, aluminum, zinc, magnesium, and stainless steel. Such as: gold and silver jewelry, fashion accessories, metal parts of electronic products, precision bolts, metal products with complex shapes, stationery accessories, instrument accessories.

1- Centering, cutting, CNC automatic lathe parts

2- Aerospace, medical device parts

3- Precision spring, shrapnel parts

4- Zinc alloy, aluminum alloy die-casting parts

5- Precision stamping parts

6- Electronic Computer Communication Parts

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG8520
Power supply	AC380V(50\60HZ)16A
Equipment size	640*520*1088
Grinding tank size	Φ 350(Cylindrical Barrel)
Motor power	2.2KW*1
Machine weight	168kg
Operation mode	Forward and reverse
Maximum processing capacity	0-10KG
Auxiliary material	Stainless Steel Needle 3kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG8620
Power supply	AC380V(50\60HZ)16A
Equipment size	740*620*1088
Grinding tank size	Φ 450(Cylindrical Barrel)
Motor power	3.0KW*1
Machine weight	188KG
Operation mode	Forward and reverse
Maximum processing capacity	0-12KG
Auxiliary material	Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS

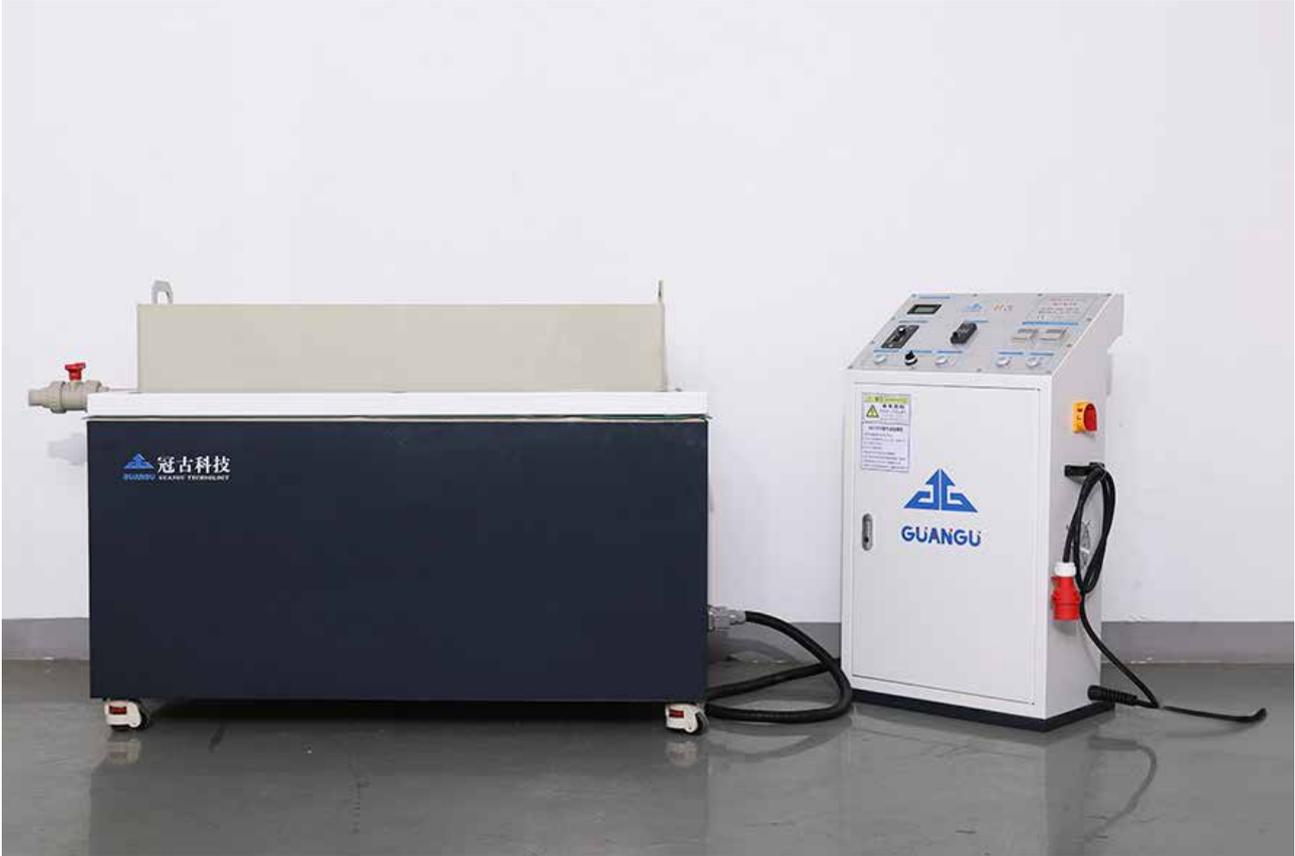
Model	GG8720
Power supply	AC380V(50\60HZ)16A
Equipment size	840*720*1088
Grinding tank size	Φ 500(Cylindrical Barrel)
Motor power	4.0KW*1
Machine weight	218KG
Operation mode	Forward and reverse
Maximum processing capacity	0-18KG
Auxiliary material	Stainless Steel Needle 6kg, Grinding Liquid 50L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG8850
Power supply	AC380V(50\60HZ)16A
Equipment size	1200*720*1088
Grinding tank size	900*500(Square Bucket)
Motor power	4.0KW*1
Machine weight	288KG
Operation mode	Forward and reverse and translation
Maximum processing capacity	0-30KG
Auxiliary material	Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS

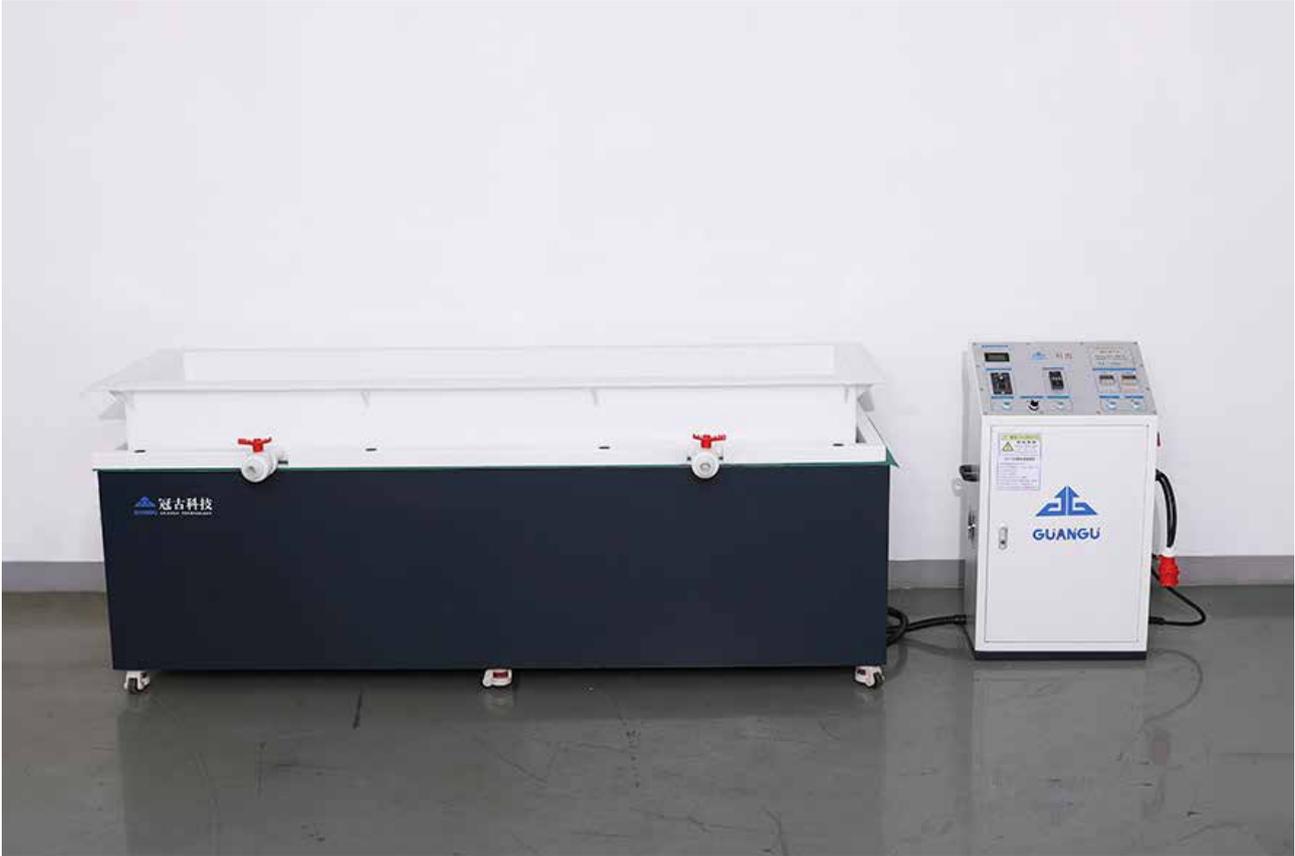
Model	GG1380
Power supply	AC380V(50\60HZ)16A
Equipment size	1380*800*1088
Grinding tank size	1200*600(Square Bucket)
Motor power	5.5KW*1
Machine weight	410KG
Operation mode	Forward and reverse and translation
Maximum processing capacity	0-35KG
Auxiliary material	Stainless Steel Needle 10kg, Grinding Liquid 50L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG1980
Power supply	AC380V(50\60HZ)16A
Equipment size	1980*720*1088
Grinding tank size	1800*520(Square Bucket)
Motor power	4.0KW*2
Machine weight	580KG
Operation mode	Forward and reverse and translation
Maximum processing capacity	0-60KG
Auxiliary material	Stainless Steel Needle 4kg, Grinding Liquid 25L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS,Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG2380
Power supply	AC380V(50\60HZ)16A
Equipment size	2380*800*1088
Grinding tank size	2200*600(Square Bucket)
Motor power	5.5KW*2
Machine weight	660KG
Operation mode	Forward and reverse and translation
Maximum processing capacity	0-70KG
Auxiliary material	Stainless Steel Needle 14kg, Grinding Liquid 100L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

PRODUCT PARAMETERS



PARAMETERS AND SPECIFICATIONS	
Model	GG2980
Power supply	AC380V(50\60HZ)16A
Equipment size	2980*720*1088
Grinding tank size	2800*520(Square Bucket)
Motor power	4.0KW*3
Machine weight	780KG
Operation mode	Forward and reverse and translation
Maximum processing capacity	0-80KG
Auxiliary material	Stainless Steel Needle 24kg, Grinding Liquid 150L, Rubber Pad 1PCS, Separator 1PCS, Steel Needle Separator 1PCS, Instructions 1PCS.

GRINDING CONSUMABLES

Magnetic steel needle regular size table (special can be customized)



SIZE (dia*len) mm					
0.2*5MM	0.3*5MM	0.4*5MM	0.5*3MM	0.5*5MM	0.5*8MM
0.6*5MM	0.7*5MM	0.8*3MM	0.8*5MM	0.8*10MM	1.0*5MM
1.0*8MM	1.0*10MM	1.2*5MM	1.2*8MM	1.2*10MM	1.5*5MM
1.5*8MM	1.5*10MM	1.8*5MM	1.8*8MM	2.0*5MM	2.0*8MM

Guangu Magnetic Grinding Steel Needle Selection Instructions

The thicker the magnetic steel needle, the stronger the polishing strength. Of course, the polishing and grinding strength can also be controlled by adjusting the operating frequency of the control panel of the magnetic polishing machine. When choosing a stainless steel needle for the first time, you must first understand the material of the processed parts. For stainless steel For hard parts such as steel and iron, it is recommended to choose a stainless steel needle with a diameter above 0.8. For copper and aluminum parts with soft materials, it is recommended to choose a stainless steel needle with a diameter below 0.8. In addition, the final stainless steel needle model, the hole diameter of the part to be processed and other gaps can also be determined by actually trying several times to determine the thickness of the steel needle abrasive. Generally, it is recommended to use a 5mm long steel needle for polishing.

PRECAUTIONS

The stainless steel magnetic needle is a semi-permanent grinding material, which can be used continuously for many times. The stainless steel magnetic needle is a tiny needle-shaped object, and it should be handled carefully when using it. When the stainless steel needle is not in use, please clean it and dry it before storing.

GRINDING CASE

Copper case



Deoxidation



Crafts



Refrigeration accessories



Communication accessories

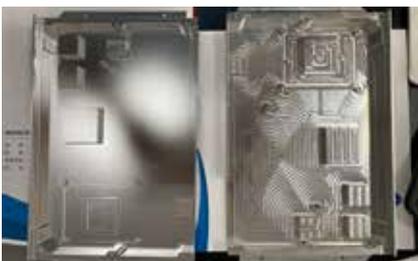


Power Accessories

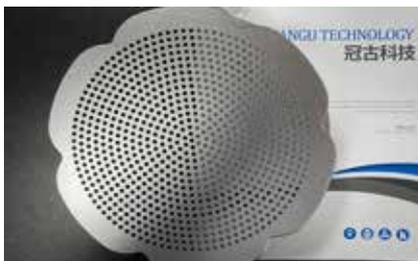


Welding Parts

Aluminum case



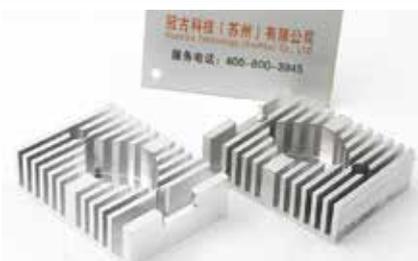
CNC machining parts



Medical Accessories



Cut Pieces



Aluminum Radiator



Aluminum Die Casting



Aluminum forgings

GRINDING CASE

Stainless steel case



Instrumentation



Electronic Product



Laser Cutting



Desoldering spot



CNC machining



Gear deburring

Iron parts/carbon steel parts case



45 steel



Quenching and polishing



Iron

GRINDING CASE

Alloy parts/3D printing/other cases



Superalloy



Powder Metallurgy



Tantalum alloy



3D printing



Zinc alloy



Titanium alloy



Silver jewelry



Zinc alloy



Magnesium Alloy

USE ANSWER

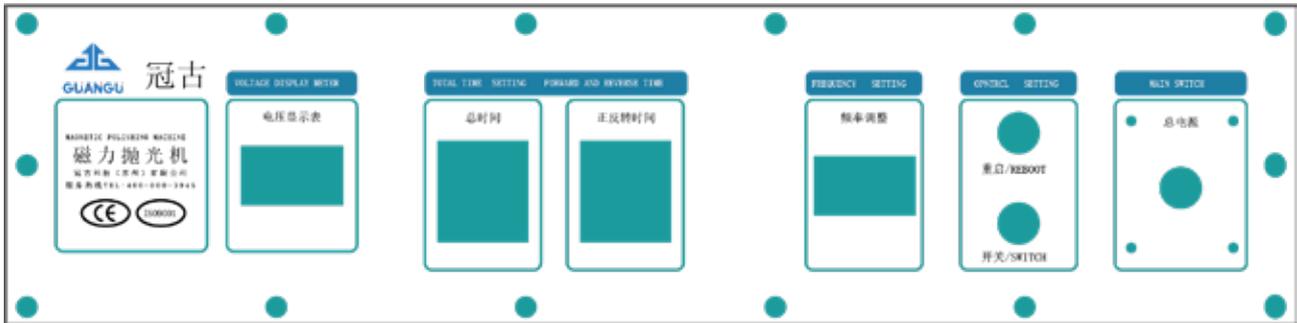
Phenomenon	reason	Countermeasures
Water leaks from the bottom of the polishing bucket	Bucket bottom pierced with polished needles	Remove the needle with pliers and add some glue to the bottom of the barrel
	Polished barrels for low wear	buy new barrels
timer does not flash	switch not activated	Press the start switch to time
Polishing barrel is fragile	high water temperature	Change the water in time (normal water temperature is within 50 degrees)
	There are polishing needles in the polishing tank	Regularly clean and keep the grinding tank clean
Polishing barrel turns while grinding	Water on the surface of the polishing pad or no polishing pad	Drain moisture, plus silicone anti-vibration pad
The machine vibrates a lot	A certain foot of the machine is not in the force-bearing position	Adjust the length of the foot to balance the stress position
	Excessive polishing needle placement	Reduce polishing needles
Pin stuck in workpiece slot	The length of the polishing needle does not match the size of the workpiece	Adjust the size of the polishing needle
Poor deburring effect	Severe workpiece-to-workpiece collisions	Make a fixture to fix the workpiece
	The polishing needle is too strong	Adjusting the polishing needle
Poor deburring effect	Insufficient grinding	Increase the frequency to minimize the distance between the barrel and the machine
The workpiece is dull	The polishing needle is not strong enough	Replace the thick/long polishing needle to check whether the polishing needle is sufficient
	The polishing agent conflicts with the product material	Replace/Adjust Polishing Fluid
Polishing the workpiece is inefficient	Polishing needle too thin/short	Adjusting the Magnetic Polishing Needle Model
	less polish	Increase the polishing agent and replace it with a high-quality polishing agent
	The workpiece is oily	Polish after degreasing
	Too much polishing water	reduce water
Polished barrel, blackened needle	Workpiece excess	Reduce to the appropriate number of workpieces, subject to workpiece tumbling
	The workpiece is oily	Wash the polishing barrel and polishing needle separately before using
Indicates that the machine does not operate when it is normal	abnormal voltage	Check if the voltage is lower than 380V
	Excessive polishing needle placement	Reduce polishing needles
	Show EO (protection)	Cut off the main power supply and restart the device after the display goes out After the main power supply is displayed and goes out, press the red button on the governor colored stop/reset key
power trip	damp inside the machine	Change the environment of the machine to the sun for a few hours or use electricity hot blow dryer
The surface of the machine is hot	working environment is too hot	Replacing the fan on the back of the machine
	The cooling fan of the machine is broken	Replacing the fan on the back of the machine
The machine smells like burnt paint	Working voltage is too high	Solve the machine using power
The voltmeter has no display and the machine has no action	Power input no voltage	Check front-end power
	machine malfunction	Notify Guangu Company for after-sales maintenance

When the above phenomenon occurs, please refer to the information in the table below to verify the reasons and countermeasures for your reference.

CODE DISPLAY SOLUTION

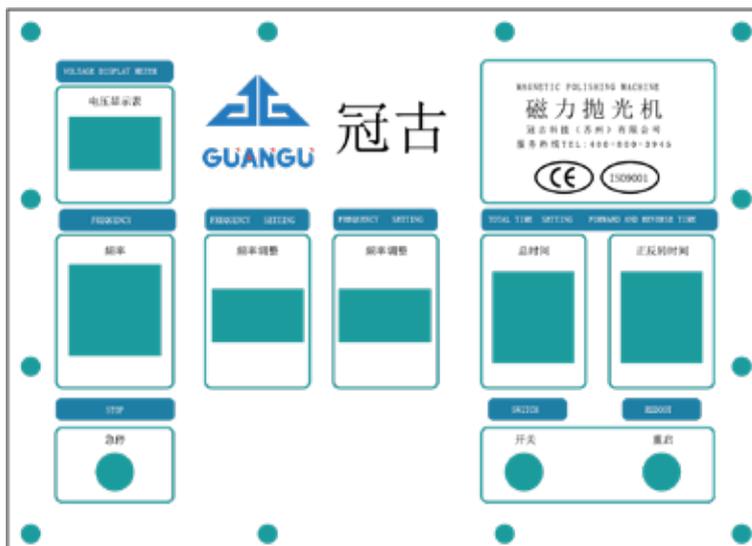
UL --	The inverter detects that there is an abnormal sudden increase of overcurrent at the output	Check whether the output power of the motor matches the output power of the inverter Check whether there is a short circuit between the inverter and the motor Increase the acceleration time (P10,12) Check whether the motor is overloaded
OU	The inverter detects that there is an overvoltage phenomenon in the internal DC high voltage	Check whether the input voltage is within the rated input voltage range of the inverter and detect whether there is a surge voltage. The internal DC high-voltage side voltage of the inverter is too high due to the motor inertia rising voltage. At this time, you can increase the deceleration time or install a braking resistor (optional).
OH	The inverter detects that the internal temperature is too high and exceeds the protection level	Check whether the ambient tempratue is too high or exceed the protection level. Check whether the air inlet and outlet are blocked.Check whether the heat sink is abnormal. Check whether the ventilation space of the inverter is sufficient.
LU	Inverter detects internal DC	Check whether the input power is normal
	High side too low	
OL	The inverter detects that the output exceeds the tolerable current, and the tolerance is 150% of the rated current of the inverter, which can withstand 60s.	Check whether the motor is overloaded, reduce the torque of p54, increase the output capacity of the inverter
OL1	Internal electronic thermal point relay protection; motor load is too large	Check whether the motor is overloaded Check whether the rated current value of the P52 motor is appropriate Check the electronic thermal relay function setting to increase the motor capacity
OL2	The motor load is too large	Check whether the motor load is too large Check the setting value of the over-torque detection level (P60-62)
bb	Set this time with external multi-function input terminals (M2~M5) AC motor driver	When it is clear that the signal source "bb" disappears immediately, the AC motor driver stops outputting and whether the output wiring is poorly insulated
ocA	Overcurrent during acceleration	Increase the acceleration time and reduce the torque setting value of P54. Replace the inverter with a larger output capacity. Is the insulation of the output connection of the inverter poor?
ocd	Overcurrent occurs during deceleration	Increase the deceleration time and replace the inverter with a larger output capacity
ocn	When the external multi-function input terminals (M2-M5) set the external abnormality (EF), the AC motor driver stops outputting	After clearing the source of the fault, press the "RESET" button
	Data write error in internal memory IC	Check that the input power voltage is normal and restart the machine
cf2	Internal memory IC data reading error	Check whether the connectors of the internal power supply board of the inverter and the control board are fully connected, press the RESET key and reset the internal parameters to factory settings
GFF	Grounding protection or fuse fault grounding protection The inverter has abnormal output phenomenon, and the output terminal is grounded (the grounding current is higher than 50% of the rated current of the inverter). The power module may have been damaged. This protection system will fail the fuse of the inverter instead of the human body; The LED indicator on the main circuit board shows whether the fuse is faulty	Ground protection; determine whether the IGBT power module is damaged Check whether the ground wire on the output side is poorly insulated Fuse failure; replace the fuse to determine whether the IGBT power module is damaged Check whether the ground wire on the output side is poorly insulated

PANEL INTRODUCTION



▲ Frequency conversion series panel

▶ Pan control panel ▼



- Main power supply: The main switch of the input power of the machine. When it is off, all the circuits inside the machine are powered off. When you want to use the equipment, you must turn the main power supply to the on state (ON is on, OFF is off)

- Switch: (red button) press down the timer to start working (can play the role of on and off)

- Restart: (green button) This button is to be switched on and off and the total time will be counted up to work after restarting (pressing is equal to zeroing the total time)

- Frequency: Control the moving speed of the geared motor in the equipment

- Frequency adjustment: Display the working frequency of the motor, and you can adjust the frequency of the motor running (0-60HZ). Do not work at low frequency for a long time, otherwise the motor may be damaged. The parameters have been set before leaving the factory (just adjust the cylindrical frequency Size) Setting parameters privately may affect the normal operation of the device

- Total time: you can set the time for the machine to work for one cycle

- Positive and negative time: You can set the cycle time of positive and negative rotation. Generally, the setting time of positive and negative rotation should not be less than two minutes. It takes time to start and brake to stop during work. If the rated time is set too short, it will take up the normal grinding time

- Voltage and current display: display the voltage of the input power supply and the current during operation

Fuse: When the input current is abnormal, it can protect other electronic components and circuits inside the machine

Equipment daily maintenance

1. When using the equipment, prevent the liquid from splashing on the surface of the operating machine. When the polishing liquid splashes on the machine, it should be wiped clean in time
2. In order to keep the surface of the machine clean and prolong the service life of the machine, wipe the surface with a cloth after using the equipment
3. When the equipment is not in use, the control panel can be covered with a plastic bag
4. Lightning protection, in the event of lightning, it is necessary to turn off the power of the machine and unplug the power plug to prevent it from being damaged by lightning
5. The grinding barrel is damaged, and the polishing needle is strong when the equipment is running, so when the barrel is placed in the polishing tank, if there is a polishing needle in the polishing tank, it should be cleaned in time

Dear user, thank you for purchasing and using Guangu magnetic grinding machine equipment. Proper daily use and maintenance of machinery and equipment can avoid component damage caused by human factors and prolong the service life of the machine.



冠古科技

"EMPOWERING INNOVATION, INSPIRING SOLUTIONS."