PRACTICAL AND THEORETICAL WORK ON PLATE GRIPS CONNECTING THE AUTOMATIC MIRRORS TO THE WINDSHIELD, THE WINDSHIELD AND MIRROR TO EACH OTHER IS TAXABLE

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Annotation:
This article serves as an important resource in determining the importance of plastina handles in the automotive industry and the possibilities of improving their design. The study is also focused on meeting the needs of consumers, taking into account safety and ergonomic requirements

Keywords: structural features of mirror and mirror handles, materials, mechanical properties, rigid and elastic handles, design options.

Applied to the windshield and window with controlled pneumatic pressure. The application temperature is usually between C on the glass surface. * In real practical work, there were some problems when removing the button / pillow in the robotic arm from # 9214 with a diameter of 25 mm (plaid paper liner) to # 9270 with a diameter of 28 mm (PET liner) vertically from the liner. route without liner twisting and partial SBT lifting. This was mainly influenced by two factors: 1. PET liner is tougher than paper and has a higher viscosity with SBT 2. The SBT pad with a diameter of 28 mm can be changed or reconfigured machine parameters to ensure that the liner with high viscosity moves along the reverse roll during extraction due to the greater surface area compared to the previous small diameter and to allow easy release. The problem was solved at the same time by replacing the # 9270 PET separator liner with a paper type emitting liner applied to glass buttons on glass soles, similar to the hardening of the # 3m TM SBT, similar to the lower viscosity and stiffness of the paper at the 3M production source. Autoclave treatment process (in a linear process) autoclave processes used to produce laminated glass are almost perfect for treating SBT. It is not possible to hold the autoclave at least 30 minutes at a high temperature, but to achieve a pressure of up to 13 bars, which is about 100% moistened and heals the button attached to the glass. This is a very important factor that determines the final strength of the structural bond. The aging requirements of moisture included in some OEM specifications with GMP/N 96321150 when using simple sintered metal buttons may fail despite the high moisture resistance characteristics. The

use of sand-treated sintered stainless steel knobs gives a higher surface area for adhesion, or black chrome knobs form a barrier on the surface (moisture) and have successfully passed very strict moisture tests. Such combinations of a banded button are preferred by many OEMs. The process of fast oven cooking at high temperature (the process of working outside the network) may require small, high-power ovens under certain conditions, such as a converter or a buyer not having access to the autoclave / autoclave process. A button glass with a ribbon window is usually applied to a glass base at ambient or room temperature (> 23 C). In this case, 3M TM SBT is effectively applied as pressure-sensitive adhesive tape, and the button joint must have sufficient pressure (>5kg / CM) to achieve minimal surface contact (wetting) before using the stove process. to treat the adhesive to maximize adhesion [1-5].

It should be remembered that with the help of 3M TM SBT, when glass buttons are applied to glass substrates at a temperature of> 60 C, the epoxy adhesive begins the process of rapid hardening. After the start of the treatment process, the process proceeds slowly over time, even at lower or ambient temperatures. Also keep in mind that 9270 heals faster and also starts the healing process at low temperatures, so if the window glass is applied at high temperatures, there should be a minimum delay in the autoclave or before the final processing. in a high temperature oven to better control the overall treatment process. If, for some reason, the treatment process remains uncontrolled, which at worst reflects button malfunctions or, at best, leads to poor bonding and wetting problems, especially when treating faster, care should be taken when removing 9214 paper or 9270 paper. Pre-made tape film from the assembly of the mirror button. In semi-or fully automatic applications, this can be very important because a) the natural adhesion of the SBT to the release liner and B) the PET is harder than the paper liner. Both factors can lead to the installation of a mirror button, especially if the equipment is not properly designed or is not designed to solve such problems, the 9270 rises badly and awkwardly with SBT precut. 6. The mirror button or sensor bracket must match the curvature of the glass (see substrates / glass geometry). How to measure humidity? A simple bond strength measurement can be used, for example, with a torque-measuring test (see on-line tests in customer locations) soaked or, in other words, as a reliable method to measure the effective contact area of a surface. To SBT glass. The image on the right shows a button failure with low torque after normal treatment. Due to the fact that the failure mode is combined (at least in the center), and with a clean adhesive break around the button, only a partial systemic connection was achieved along the general surface.

Wetting when applying pressure to the bottle caused failure, and the main cause was found to be outside the normal tolerance of the button Crown. Individual / moving range (I / MR) tables can be constructed using Minitab or Statistica statistical software programs to continuously record Nm power data. When the data is recorded sufficiently, 3σ upper and lower control limits are automatically generated from the mean of the moving values [6-9].

GMP / n 96321150 is equipped with a plate handle. This type of plastina grips is used from GM plant automables to Lasetti Gentras. The camchliki automatic carbide is not used for automakers. The reason mirror does not fit into the original option. The advantage is that it does not form an entry line in the window during the process of entering the plate machined into the windshield (GMP/N 96321150).

Static or dead load window buttons are applied to a suitable glass plate and treated before attaching a 2.7 kg load to the window button. The installation is placed in the climate room at an angle of 45 and left for a while under the necessary conditions. Typical time of failure in the application and treatment of stainless steel windshield buttons for a cut cushion before 2.7 Kg 550 mm # 9214 # 9263 # Kg load 50 C and 95% RH 1800 hours 1800 hours 3000 hours car crash simulation situations by applying a large dynamic force using a hammer with a mass corresponding to a full Window Window that causes a break between the

For all the above test methods, the preferred failure mode at the break is always for the failure of the union inside the SBT, sometimes called Foam splitting. 8. Competitive technology PVB adhesive material Poly-Vinylbutyral is used as a binder for the production of almost all global layered security Windows. Therefore, PVB extruded film is a relatively inexpensive and easily available material for window manufacturers to use as a binder for window buttons. It is not universally applicable, but can be selected when it is necessary to process large-scale applications on-line and until precise pressure is applied to the glass from fully automated systems for heating and gluing PVB pads. Recently, a ceramic printed frit for opaque black PVB glass has been specifically produced for non-existent applications.

Figure 1 3M structural connecting tape is a scheme for testing the ability to load a plate handle attached to a window.

The windshield is machined into the test Jack at an angle of 45 degrees and the plastina handle is machined through a 3m structural connecting tape to the window. 2.5 kg of cargo osin is placed on the plastina handle after the Plastina handle has been machined, and 25 minutes were observed in the test. The results of the test are made in the form of a graph [10-12].

Conclusion

This research focuses on an in-depth study of the theoretical and practical aspects of connecting plate grips between the windshield and the mirror of cars. In theoretical analysis, the structural features of mirror and mirror handles, material selection and mechanical properties are presented. Applied research, on the other hand, looked at the assembly process, safety requirements and ergonomic aspects of the handles.

The results showed that different constructive solutions and materials differ among themselves, and each has its own advantages and disadvantages. With the help of new materials and innovative designs, there are options to increase the efficiency of the handles. Research plays an important role in addressing the importance of plastina handles in the automotive industry and the needs of consumers. All this serves to ensure the safety and comfort of the car.