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(54) **METAL PLATING APPARATUS FOR PLATING METAL WITH ZINC**

(57) A metal plating apparatus for plating metal with zinc is provided with a rotating device and a plurality of stirring devices. The rotating device has a driving assembly having a driving gear, and a rotating assembly. The rotating assembly is connected with and controlled by the driving assembly, and has a sustaining pillar. A rotating seat is mounted on the sustaining pillar and engaged with the driving gear. The stirring devices are

mounted on the rotating seat radially and spaced from each other. The metal plating apparatus improves productivity through shifting locations of the stirring devices by the rotating device and plating metal with a peripheral supporting apparatus, and improves working efficiency through decreasing occupied space and the number of operating personnel.

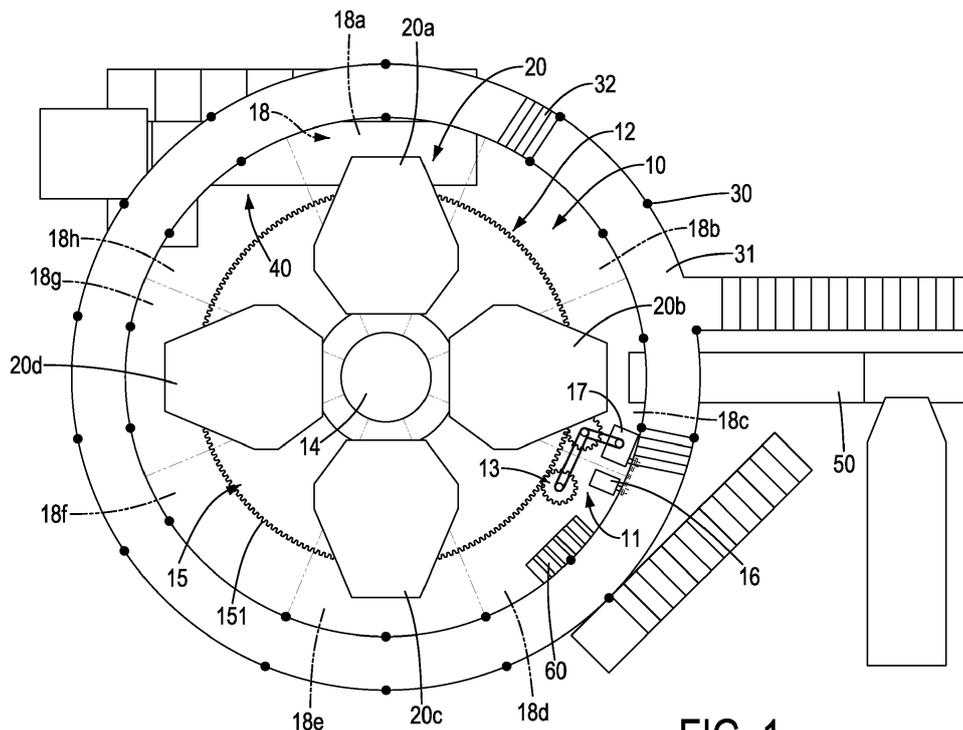


FIG. 1

Description

1. Field of the Invention

[0001] The present invention relates to a metal plating apparatus for plating metal with zinc, especially to a metal plating apparatus for plating metal with zinc that improves working efficiency.

2. Description of the Prior Art

[0002] Most of small size metal parts, such as screws, are made of iron, so the metal parts are prone to rust. In order to prevent rusting and improve antioxidant capacity, the metal parts may undergo a surface plating treatment with zinc for forming a protection layer on surfaces of the metal parts. The surface plating treatment with zinc is performed with a horizontal rotating device mounted with a stirring device, and the stirring device cooperates with a feeding conveyor and an unloading conveyor disposed on an outer periphery of the stirring device. The metal parts enter a barrel of the stirring device through the feeding conveyor. The stirring device is capable of adjusting an elevation angle of the barrel and rolling the barrel so that the metal parts are plated with zinc. During the plating, different chemicals are added. The horizontal rotating device is capable of turning the stirring device and adjusting an orientation of the barrel to let other auxiliary devices add the chemicals into the barrel. After finishing plating metal parts with zinc in the barrel, the horizontal rotating device turns the stirring device to orient to the unloading conveyor, and the stirring device adjusts the elevation angle of the barrel so that the metal parts in the barrel can be poured to the unloading conveyor.

[0003] However, each stirring device needs to cooperate with one horizontal rotating device. Besides, each one of a feeding conveyor, an unloading conveyor and an auxiliary device for adding chemicals cooperates with a respective stirring device individually. To improve production capacity by increasing the number of the stirring device, numbers of the horizontal rotating device, the auxiliary device, the feeding conveyor and the unloading conveyor are also increased. Thus, the whole apparatus occupy huge space and needs more manpower to operate, which decreases the working efficiency.

[0004] To overcome the shortcomings, the present invention provides a metal plating apparatus for plating metal with zinc to mitigate or obviate the aforementioned problems.

[0005] The main objective of the present invention is to provide a metal plating apparatus for plating metal with zinc which overcomes the shortcomings of the conventional plating apparatus that occupies huge space and needs a lot of people to operate for improving productivity but decrease working efficiency, because one stirring device needs to cooperate with one horizontal rotating device, and each one of a feeding conveyor, an unloading conveyor and an auxiliary device cooperates with one

respective stirring device individually.

[0006] The metal plating apparatus for plating metal with zinc has

- 5 • a rotating device including
 - a driving assembly comprising a driving gear,
 - a rotating assembly connected with and controlled by the driving assembly, and the rotating assembly including a sustaining pillar, and
 - a rotating seat mounted on the sustaining pillar and engaged with the driving gear; and
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- 15 • a plurality of stirring devices mounted on the rotating seat radially and spaced apart from each other.

[0007] Then, an outer periphery of the metal plating apparatus is disposed with a feeding device, an unloading device and a pouring auxiliary device. The rotating seat of the rotating device turns the stirring devices so that the stirring devices can shift position according to different working processes through the rotating device. Thus, the stirring devices on the rotating seat are capable of cooperating with the feeding device, the unloading device and the pouring auxiliary device, and plating metal parts with zinc automatically. So the metal plating apparatus improves both productivity and working efficiency, and decreases occupying space and the number of operating personnel.

[0008] Other objectives, advantages and novel features of the invention will become more apparent from the following detailed description when taken in conjunction with the accompanying drawings.

35 Description of the drawings

[0009]

Fig. 1 is a plan view of a metal plating apparatus for plating metal with zinc in accordance with the present invention;

Fig. 2 is a side view of the metal plating apparatus in Fig. 1;

Fig. 3 is a front view of the metal plating apparatus in Fig. 1;

Fig. 4 is an operational schematic view of the metal plating apparatus in Fig. 1;

[0010] With reference to Figs. 1 and 2, one preferred embodiment of a metal plating apparatus for plating metal with zinc in accordance with the present invention is provided including a rotating device 10 and a plurality of stirring devices 20.

[0011] The rotating device 10 includes a driving assembly 11 and a rotating assembly 12. The driving as-

assembly 11 comprises a driving gear 13. The rotating assembly 12 is connected with and controlled by the driving assembly 11. The rotating assembly 12 includes a sustaining pillar 14, and the sustaining pillar 14 is mounted with a rotating seat 15 thereon. The rotating seat 15 is engaged with the driving gear 13. The rotating seat 15 is divided into a plurality of radial working areas 18, and each one of the working areas 18 is disposed with a sensor (not illustrated in the drawings) for detecting a location of the stirring device 20 that is mounted on the rotating seat 15. The driving assembly 11 comprises a motor 16, the motor 16 is connected with a reducer 17, and the reducer 17 is connected with the driving gear 13. The rotating seat 15 includes a tooth portion 151 at an outer surface of the rotating seat 15, and the tooth portion 151 engages with the driving gear 13. The rotating device 10 can adopt 360-degree-rotation power supply with an electric rail. The stirring devices 20 are mounted radially on the rotating seat 15 of the rotating device 10, and the stirring devices 20 are spaced apart from each other. In accordance with Figs 2 and 3, each one of the stirring devices 20 includes a base 21, a barrel assembly 22, an elevation angle adjusting element 23 and a barrel rotating element 24. The base 21 is mounted securely on the rotating seat 15. The barrel assembly 22 is mounted on the base 21 and includes a barrel 25. The barrel 25 forms an accommodating space 26 and an opening 27. The accommodating space 26 is inside the barrel 25, and the opening 27 is at an outer surface of the barrel 25. The opening 27 communicates with the accommodating space 26. The elevation angle adjusting element 23 is mounted on the base 21, and a top end of the elevation angle adjusting element 23 is connected with the barrel assembly 22. The barrel rotating element 24 is mounted on the base 21, and the barrel rotating element 24 is connected with and drives the barrel assembly 22.

[0012] The metal plating apparatus includes a plurality of erect pillars 30 and a viewing platform 31. The erect pillars 30 are mounted around and surround the rotating assembly 12, and the erect pillars 30 are spaced apart from each other. The viewing platform 31 is mounted on the erect pillars 30 and spaced apart from an outer periphery of the rotating seat 15. At least one flight of stairs 32 is disposed on the viewing platform 31.

[0013] According to Fig. 1, the rotating seat 15 of the metal plating apparatus is divided into eight working areas 18, which sequentially are a first working area 18a, a second working area 18b, a third working area 18c, a fourth working area 18d, a fifth working area 18e, a sixth working area 18f, a seventh working area 18g and an eighth working area 18h. The metal plating apparatus comprises four stirring devices 20 mounted on the rotating seat 15.

[0014] With reference to Figs. 1 and 4, an outer periphery of the metal plating apparatus may be disposed with a peripheral supporting apparatus comprising an unloading device 40 disposed adjacent to the first working area 18a, a feeding device 50 disposed adjacent to the

third working area 18c and a pouring auxiliary device 60 disposed adjacent to the fourth working area 18d. The unloading device 40 comprises an unloading conveyor and an unloading shaking table. The feeding device 50 comprises a feeding conveyor and a feeding shaking table. Then refer to Fig. 4, the four stirring devices 20 are divided into a first stirring device 20a, a second stirring device 20b, a third stirring device 20c and a fourth stirring device 20d. When the first stirring device 20a is located at the first working area 18a, the second stirring device 20b is located at the third working area 18c, the third stirring device 20c is located at the fifth working area 18e and the fourth stirring device 20d is located at the seventh working area 18g.

[0015] The first working area 18a of the metal plating apparatus performs an unloading task with a cooperation of the unloading device 40; the second working area 18b performs a bead pouring task with a cooperation of a water-bead tank; the third working area 18c performs a screw feeding task with a cooperation of the feeding device 50; the fourth working area 18d performs a pouring task of pouring initiator, hydrochloric acid, copper powder and stannous chloride with a cooperation of the pouring auxiliary device 60; the fifth working area 18e, the sixth working area 18f and the seventh working area 18g perform a zinc powder titration task with a cooperation of a zinc powder titration pump; and the eighth working area 18h performs a washing task with a cooperation of a washing device. The beads are used as a medium, and diameters of the beads that are poured into the barrel 25 are different from each other. The hydrochloric acid is used for cleaning surfaces of the screws and promoting plating effect.

[0016] In accordance with Fig. 4, when the first stirring device 20a is located at the first working area 18a, the first stirring device 20a performs an unloading action with a cooperation of the unloading device 40. At the meantime, the second stirring device 20b is located at the third working area 18c and performs a feeding action with a cooperation of the feeding device 50; the third stirring device 20c is located at the fifth working area 18c and performs the zinc powder titration task; and the fourth stirring device 20d is located at the seventh working area 18g and performs the zinc powder titration task.

[0017] After the stirring devices 20 accomplish the tasks at the working areas 18, the driving assembly 11 can work and drive the rotating seat 15 of the rotating assembly 12 so that the stirring devices 20 are shifted to the next working areas 18. Scilicet, the first stirring device 20a is shifted to the second working area 18b and performs bead pouring task, the second stirring device 20b is shifted to the fourth working area 18d and performs the pouring tasks of pouring initiator, hydrochloric acid, copper powder and stannous chloride, the third stirring device 20c is shifted to the sixth working area 18f and performs the zinc powder titration task, and the fourth stirring device 20d is shifted to the eighth working area 18h and performs the washing task. After the sensor de-

fects the stirring devices 20 on the rotating seat 15 are at a right location, the driving assembly 11 stops turning the rotating seat 15. When the tasks are finished, the driving assembly 11 turns the rotating seat 15 again. Time duration of each one of the stirring devices 20 staying at the working area 18 is approximately twelve minutes.

[0018] The elevation angle adjusting element 23 of each one of the stirring devices 20 is used for adjusting an elevation angle of the barrel 25 to suit with different tasks. The barrel rotating element 24 can roll the barrel 25 to mix the beads, the screws, the initiator and the zinc powder which are poured into the barrel 25. Besides, the operators can walk onto the viewing platform 31 to check the operation in the barrel assembly 22.

[0019] Consequently, the metal plating apparatus for plating metal with zinc comprises the stirring devices 20 mounted on the rotating seat 15 and the driving assembly 11 to rotate the rotating seat 15, shifting the locations of the stirring devices 20 to cooperate with the peripheral supporting apparatus. Thus, the present metal plating apparatus does not need to dispose a horizontal rotating device under each one of the stirring devices 20, but allows each one of the stirring devices 20 to cooperate with the peripheral supporting apparatus alternately. Therefore, the present metal plating apparatus improves both productivity and working efficiency by decreasing occupied space and the number of operating personnel, and providing an automatic process.

Claims

1. A metal plating apparatus for plating metal with zinc, and **characterized in that** the metal plating apparatus includes:

- a rotating device (10) including
 - a driving assembly (11) comprising a driving gear (13),
 - a rotating assembly (12) connected with and controlled by the driving assembly (11), and the rotating assembly (12) including a sustaining pillar (14), and
 - a rotating seat (15) mounted on the sustaining pillar (14) and engaged with the driving gear (13); and
- a plurality of stirring devices (20) mounted on the rotating seat (15) radially and spaced apart from each other.

2. The metal plating apparatus as claimed in claim 1 further comprising:

- a plurality of erect pillars (30) mounted around and surrounding the rotating assembly (12) and spaced from each other; and

- a viewing platform (31) mounted on the erect pillars (30) and spaced from an outer periphery of the rotating seat (15), the viewing platform (31) comprising at least one flight of stairs thereon.

3. The metal plating apparatus as claimed in claim 1 or 2, wherein

- the rotating seat (15) is divided into
 - a plurality of working areas (18) disposed radially, and
- each one of the working areas (18) is disposed with
 - a sensor for detecting whether the stirring device (20) mounted the rotating seat (15) is at a right location.

4. The metal plating apparatus as claimed in anyone of claims 1 to 3, wherein the rotating seat (15) is divided into a first working area (18a), a second working area (18b), a third working area (18c), a fourth working area (18d), a fifth working area (18e), a sixth working area (18f), a seventh working area (18g) and an eighth working area (18h).

5. The metal plating apparatus as claimed in anyone of claims 1 to 4, wherein a number of the stirring devices (20) is four.

6. The metal plating apparatus as claimed in anyone of claims 1 to 5, wherein each one of the stirring devices (20) includes

- a base (21) mounted securely on the rotating seat (15);
- a barrel assembly (22) mounted on the base (21) and including
 - a barrel (25) forming
 - an accommodating space (26) inside the barrel (25), and
 - an opening (27) at an outer surface of the barrel (25), the opening (27) communicating with the accommodating space (26);
- an elevation angle adjusting element (23) mounted on the base (21), and a top end of the elevation angle adjusting element (23) connected with the barrel assembly (22); and
- a barrel rotating element (24) mounted on the base (21), and connected with and driving the barrel assembly (22).

7. The metal plating apparatus as claimed in anyone of claims 1 to 6, wherein

- the driving assembly (11) includes

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- a motor (16);
- a reducer (17) connected with the motor (16) and connected with the driving gear (13); and

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- the rotating seat (15) includes

- a tooth portion (151) at an outer surface of the rotating seat (15); the tooth portion (151) is engaged with the driving gear (13).

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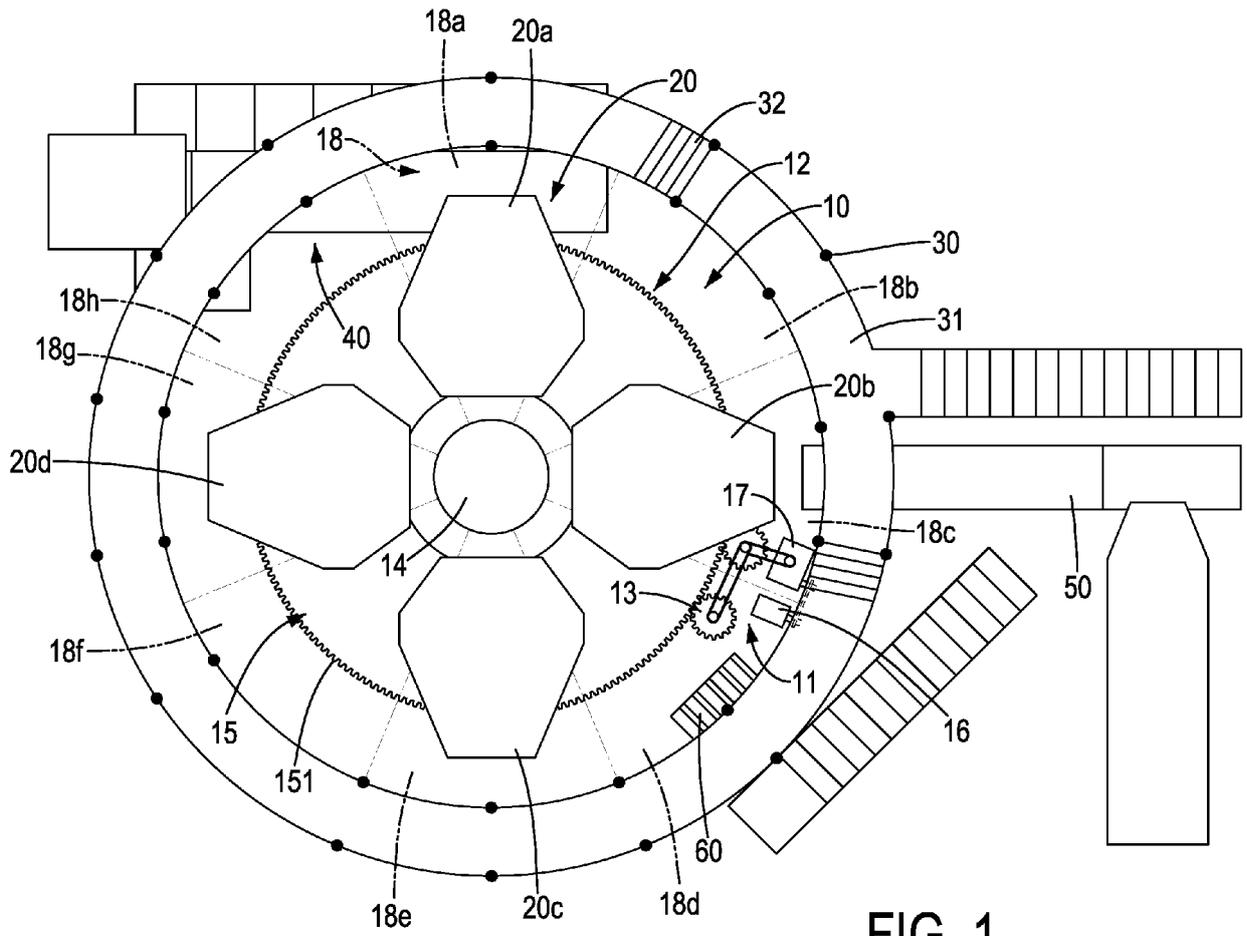


FIG. 1

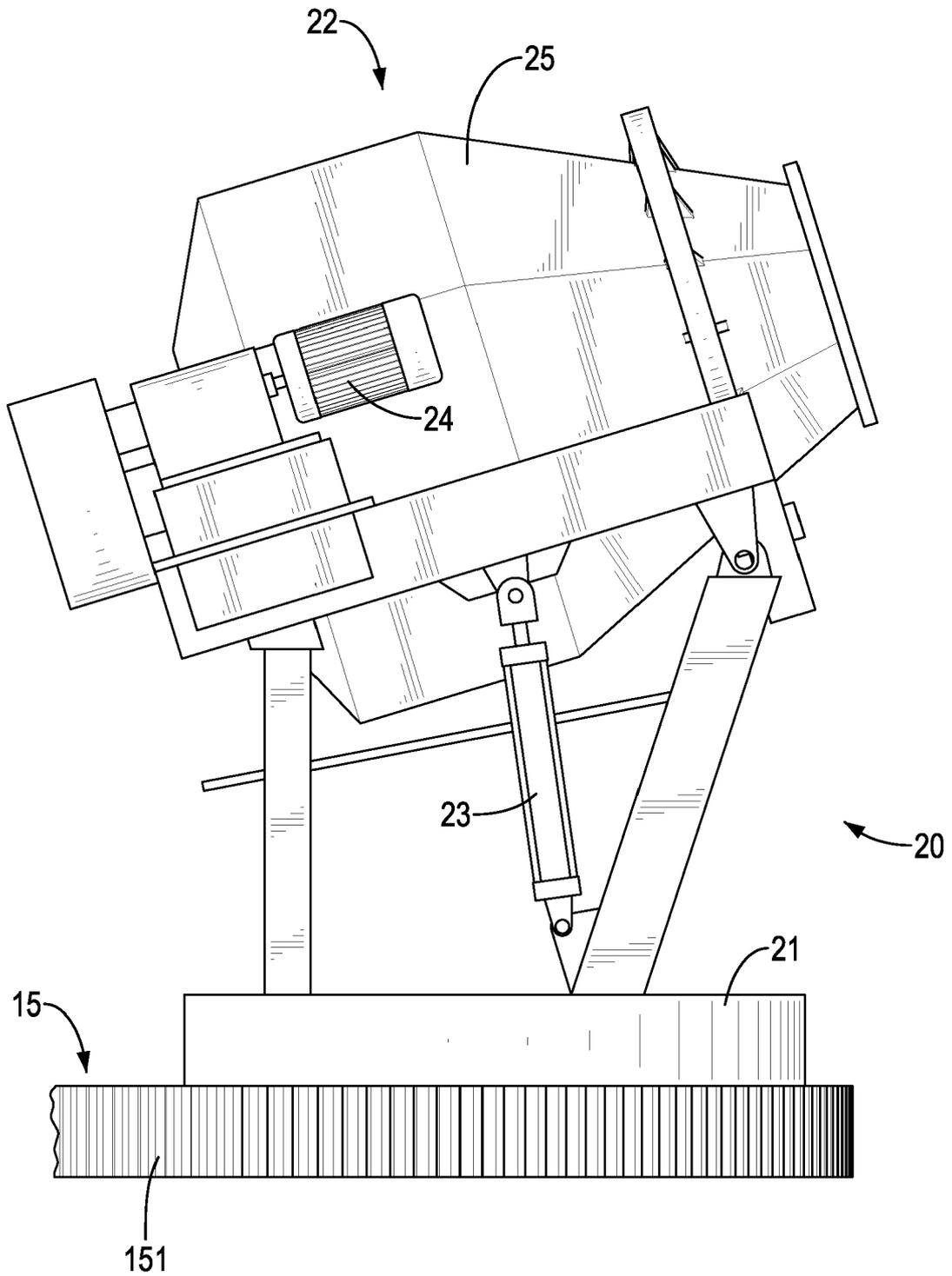


FIG. 2

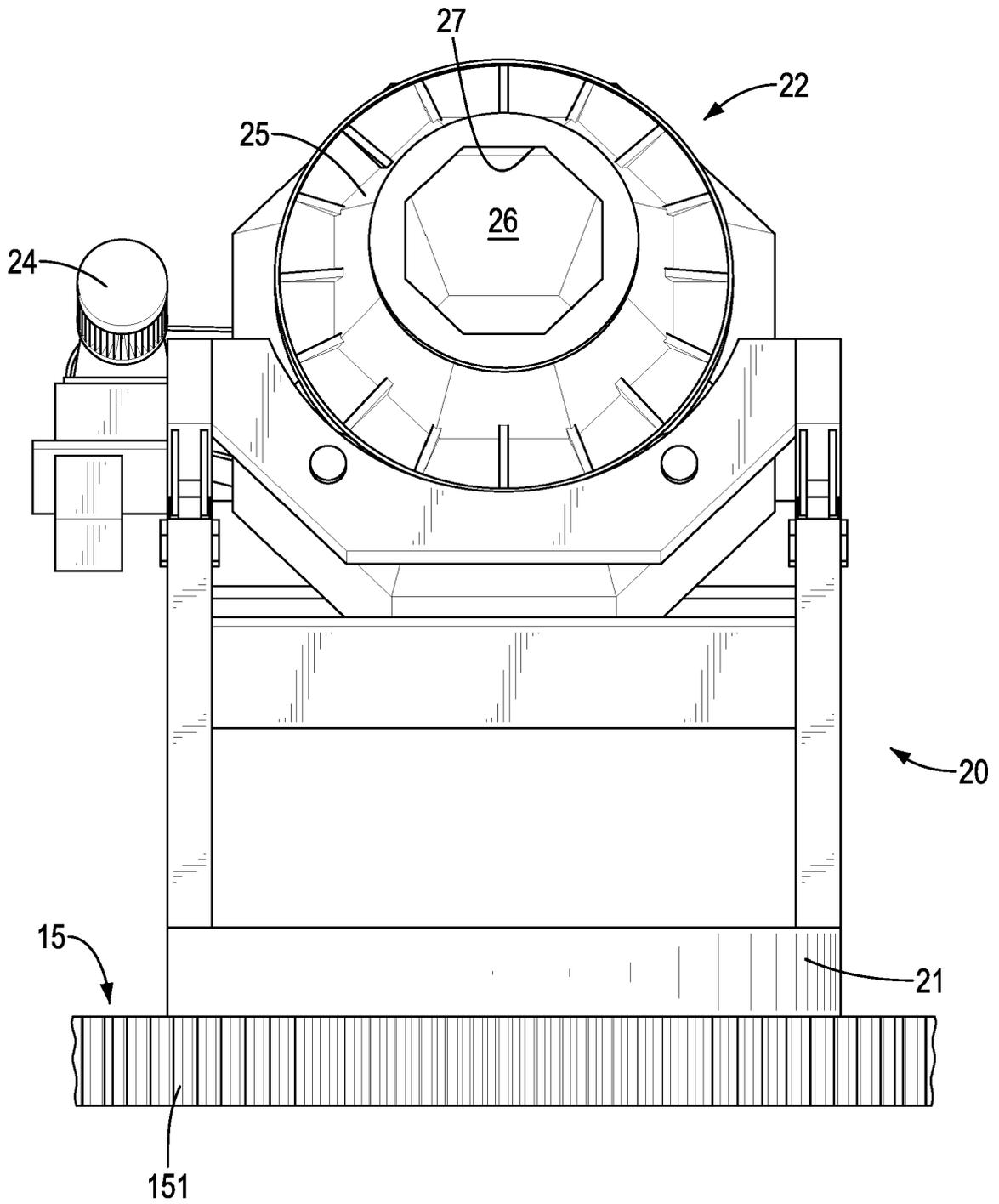
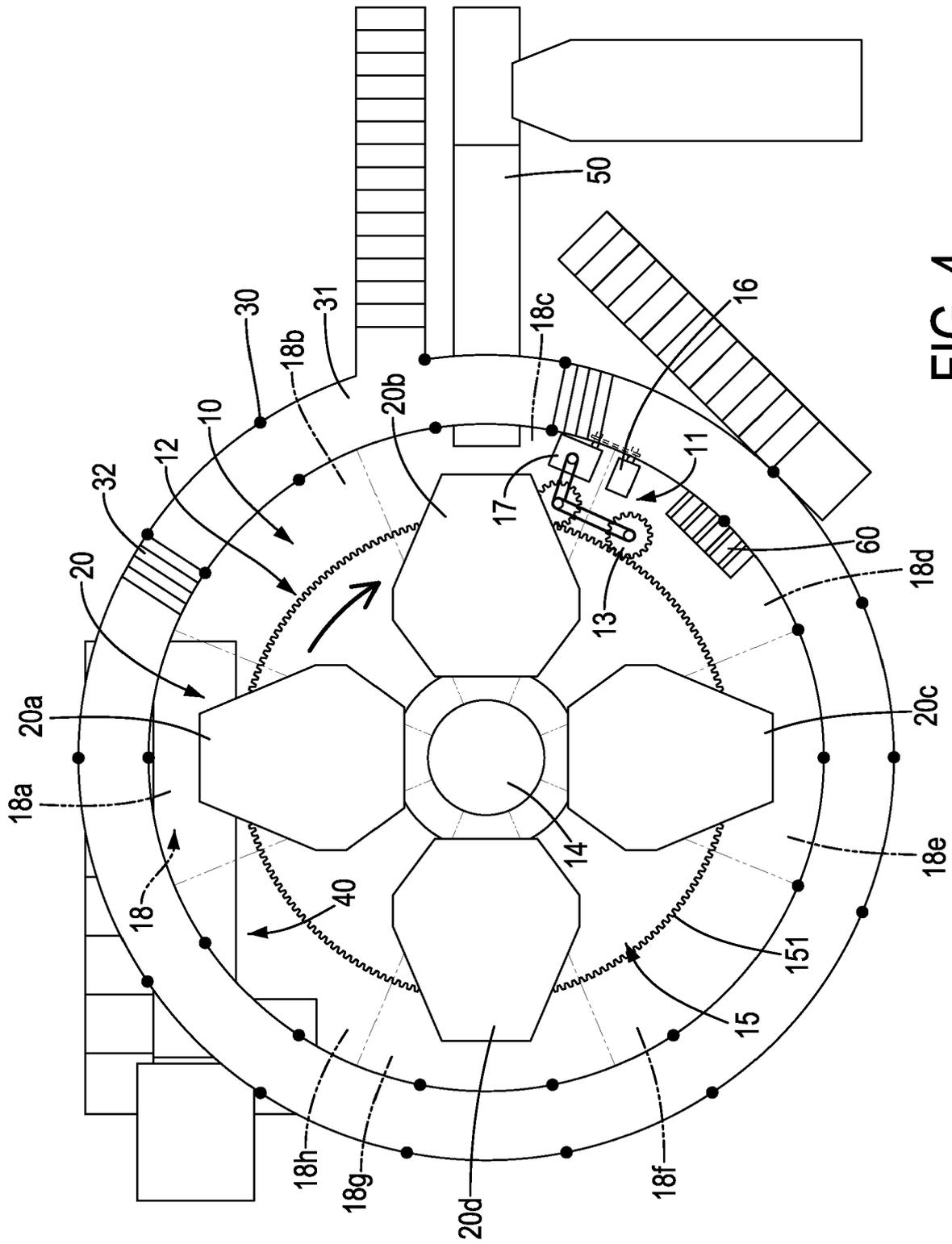


FIG. 3





EUROPEAN SEARCH REPORT

Application Number
EP 16 18 2758

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
A	CN 103 447 199 A (FUJIAN SBS ZIPPER SCI & TECH) 18 December 2013 (2013-12-18) * abstract; figures * -----	1-7	INV. C23C24/04
A	US 3 442 691 A (PEARSON JOHN W) 6 May 1969 (1969-05-06) * the whole document * -----	1-7	
A	"Mechanical Galvanizing: New Way to Bulk Coat Parts", MACHINE DESIGN,, vol. 52, no. 20, 1 September 1980 (1980-09-01), page 12, XP001302788, * the whole document * -----	1-7	
			TECHNICAL FIELDS SEARCHED (IPC)
			C23C
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 13 January 2017	Examiner Brisson, Olivier
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 16 18 2758

5 This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
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