

光杆排线器总成、排线器配件及加工，

产品名称	光杆排线器总成、排线器配件及加工，
公司名称	侯马经济技术开发区祁氏机械有限公司华东办事处
价格	.00/个
规格参数	是否提供加工定制:是 品牌:山西 - 强力 型号:GP20C型总成
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产品详情

是否提供加工定制	是	品牌	山西 - 强力
型号	GP20C型总成	电源电压	220/380
主轴方向	正反均可	适用线径	0.1-16 (mm)
步序记忆容量	-		

gp系列光杆排线器操作使用说明

the user ' s guide for operation of the gp series plain shaft traversing drive

使用前请认真阅读本说明书

please read this manual carefully before you use the machine.

从主机拉出来的线经过排线器顶部的导线轮（筒）缠绕在收线盘上，光杆的动力最好由收线轴传给，其速比可根据用户需求自行配比，一般应在1:1~1:5范围内。光杆排线器的动力也可单独设计，特殊情况下，也可使排线器带动收线盘运动，从主机放出的线不动。

排线器带动线缆行走走到收线盘边缘时，换向臂上碰轮即碰到定位块实现瞬间换向，时间不超过一秒。

适用于1200转/分高速工作，满足于往复运动极为频繁的场所。

the wire drawn from the main frame is wound up onto the take-up reel through the wire guide pulley/pipe over the traversing drive. it ' s recommended the plain shaft be powered by the shaft of the take-up reel, and the speed ratio

can be set according to customer ' s requirement, typically in the range of 1:1~1:5. the dynamic force of the plain shaft traversing drive can be designed independently. in a special case, the take-up reel can be powered by the traversing drives while the wire released by the main frame is immobile.

when the traversing drive guides wire/cable onto the edge of take-up reel, the trigger roller of the reversal arm snap the end stop, by which the instantaneously reversal is realized, in 1 second or less.

applicable to the high speed condition of 1200 rpm and where the reciprocating movement occurs frequently.

排线器应用示意图

application diagram of the traversing drive

gp15~60型排线器安装调试

installation and adjustment of traversing drives gp15~60

光杆转向

direction of shaft rotation

光杆一定要旋转串入机箱，防止与机箱两端防尘板发生碰撞。光杆表面硬度hrc50-62，光洁度0.8、直径偏差 $\pm 0.02\text{mm}$ ，其长度最好控制在其直径的20~30倍以

内。

gp15-40型，面对刻度板a光杆b向下转为工作转向（逆时针），这时换向臂上碰轮c装在刻度板a这边（参照图1），gp50型以上面对刻度板a光杆b向上转为工作转向（顺时针），这时，换向臂上碰轮c装在刻度板另一边（参照图2）。如收线轴传给光杆的转向与上述相反，可将换向臂或光杆做180°调整即可，否则不能换向，也就是说收线轴传给光杆的方向正反均可，但须注意调整换向臂或光杆的安装方向。

the shaft must be, in series, put through the deadeyes of several bearings inside the drive housing, taking care to prevent the shaft from colliding against the dustproof shields at both ends of the housing. shaft surface hardness: hrc50-62; surface finish: 0.8; diameter deviation: $\pm 0.02\text{mm}$; and the length of shaft shall be controlled in the range of 20-30 times of the shaft diameter.

as for gp15-40, when you face the scale dial (a), the downward turning of shaft (b) is defined as the working rotation direction (anticlockwise), and the trigger roller (c) on the reversal arm is mounted at the end near the scale dial (a), see photo 1. as for gp50 or plus, when you face the scale dial (a), the upward turning of the shaft (b) is defined as the working rotation direction (clockwise), and the reversal arm trigger roller (c) is mounted at the end away from the scale dial, see photo 2. if the rotation direction of the shaft transmitted from the take-up reel shaft is opposite to that of abovementioned, just adjust the reversal arm or the plain shaft for 180 degrees, otherwise the reversal could not be effected. in other word, the shaft direction transmitted by the take-up reel shaft can be either positive or negative, but care must be taken to adjust the mounting direction of the reversal arm or the plain shaft.

无级调速

stepless adjustment of speed

只要将调速手柄a在刻度板b上0-10范围内拨动，即可实现从静止、微动到最大节距行走的无级调速，调整节距大小请参照数据表格。

just a push to speed adjustment handle (a) within the scope of 1-10 on the scale dial (b), will realize the stepless adjustment from standstill, slow motion to the travel of maximum pitch. for pitch adjustment, please refer to the data table.

释放机构

release mechanism

只需将释放手柄a旋转90°，也就是由i位推到o位，即可卸去排线器推力，可手至排线器于工作区间任意位置。释放手柄o位为释放状态，i位为工作状态。

just a turning of the release lever (a) for 90 degrees, i.e. from position i to position o, will remove the thrust force of the traversing drive and then the traversing drive can be pushed by hand freely within the working interval. the release lever at position o means in the release condition, and at position i means in the working condition.

排线器常见故障及排除方法

common problems and troubleshooting of the traversing drive

推力小

insufficient thrust

可将排线器下部两端两个调压螺盖a或顶部中间调压螺盖b按顺时针方向向内微调直至产生所需推力即可。

clockwise and slightly adjust two pressure-adjusting blind nuts (a) on the bottom of the traversing drive or the pressure-adjusting blind nut (b) in the center of the top of the traversing drive, in clockwise way, until the required thrust force is achieved.

不换向

reversal failed

不换向或换向过慢，可检查换向臂c与其它机件之间有无卡死阻碍现象，如有可进行人工校正，弹力不足可更换弹簧，并在机件上有相对运动的地方涂油，保持良好润滑，减小磨损。

if the reversal is too slow or not available, check the reversal arm (c) and other parts for swiveling blockage, which must be manually corrected. in case of insufficient resilience, change the spring and apply the grease at the location of parts where there is relative motion so as to keep good lubrication condition and reduce the friction.

排线不均匀

uneven traversing

来回行走速度不均，可松开刻度板上两个固定螺丝a、b，或左或右微动刻度板，使之来回行走均匀。测量方法可用卡尺、铅笔在光杆上划螺旋线简易测量（仅适用于铁壳喷漆型排线器，参照图1）。

in case of any asymmetry of the reciprocating travel speed, you can correct it by loosening two check screws (a and b) on both sides of the scale dial, and then slightly move the scale dial left or right. the measurements can be simply made by drawing and measuring the helical line with calipers and a pencil (only applicable for the traversing drive of spray-painted iron housing, see photo 1).

gplx15-30型排线器排线不均匀，可松开排线器上顶丝d，向左或向右微动调整（参照图2）偏心调套e，可以多试几次，达到满意效果时，拧紧顶丝d即可。

if the traversing drives of models gplx15-30 don't travel symmetrically, you can loose the head screw (d) on the traversing drive, and adjust eccentric sleeve slightly by left or right turning (see photo 2). you can try several times until the satisfying result is reached, and then tighten the top screw (d) again.

排线器总成轨道与轴承间隙调整：

adjustment of the clearance between the rail and the bearing of the traversing drive assembly:

当轴承a在轨道b上运行间隙过大或过紧时，可松开螺栓d，旋转六方偏心柱c以达到合适的运行间隙。

loosen the bolt (d) and turn the hexagonal eccentric post (c) to make an adequate running clearance, if the bearing (a) runs on the rail (b) with too tight or loose clearance.

注意：

note:

因产品质量的不断提高，设计的不断完善，本产品数据如有与样本不符之处，请以所购产品为准，数据变动之后，恕不另行通知。如有技术数据需要确认，可以与技术室或供应处联系：

this company reserves its right to continually improve quality and perfect the design. if there's any discrepancy between data of the product and the data of the sample, the data of products as are purchased shall prevail. the data in this manual are subject to change without notice. for confirmation of the technological data, please contact the technical office or supply division.

gp15~60型排线器总成名称及装配数据表

names and specifications of the gp15-60 traversed dr