

压管机,缩管机使用操作说明

产品名称	压管机,缩管机使用操作说明
公司名称	深圳市台鸿机械设备有限公司
价格	面议
规格参数	加工定制:是 额定载荷:400T 功率:3KW
公司地址	深圳市坪山大工业区台商工业园
联系电话	13602591469

产品详情

压管机,缩管机使用操作说明适用范围:

该压管机是在压力作用下使金属接头产生变形,从而平稳、精确地扣压在胶管上的专用设备、如(液压机械、注塑机、挖机、装载机、吊机、汽车空调管),从而平稳、精确地扣压在胶管上的专用设备、如(液压机械、注塑机、挖机、装载机、吊机、汽车空调管),是液压机械厂,挖机维修点,的必选设备,本机自1999年开始投入市场,2年内故障率不到1%,是一款性能稳定,简单易用,经济型的压管机.

applies range:

the pressure tube machine is in pressure role xia makes metal joints produced deformation, thus smooth, and precise to withheld in glue tube shang of dedicated equipment, and a s (hydraulic mechanical, and injection machine, and dug machine, and mount machine, and hanging machine, and car air conditioning tube), is hydraulic machinery factory, dug machine maintenance points, of will selected equipment, this machine since 1999 began inputs market, 2 years within fault rate not to 1%, is a paragraph performance stable, simple easy, budget of pressure tube machine.

压管机,缩管机使用操作说明产品技术参数如下:

1. 压管通径: 6~ 51mm(最大2英寸,最小2分)
2. 电机功率: 2.2kw
3. 额定电压:三相ac380v或单相ac220v
4. 最高油压:31.5mpa

5. 油泵流量:2.5ml/rev
6. 最大扣压力: 3000kn
7. 随机配套模具: 1/4 3/8 1/2 5/8 3/4 1 1,1/4 1,1/2 2
8. 外型尺寸:700mm*400mm*700mm(l*w*h)
9. 整机重量(不含油):200kg
- 10.可装50升46#液压油.

product technical parameters are as follows:

1. pipe diameter: 6~ 51mm (maximum 2 inch, min 2 min)
2. motor power: 2.2kw
3. rated voltage: three-phase ac380v or single-phase ac220v
4. mtp 31.5mpa
5. oil pump flow rate: 2.5ml/rev
6. maximum deduction pressure: 3000kn
7. random supporting mold: one-fourth three-eighths one-second three-fourths 1,1/4 1,1/2 your 1/2
8. dimensions: 700mm*400mm*700mm (l*w*h)
9. weight (without oil): the 200kg
- 10.50 litres 46# hydraulic oil.

压管机,缩管机使用操作说明一、工作原理油泵在电机驱动下,输出液压油,推动扣压油缸内的柱塞向前运动,使柱塞、前缸盖上的两个内锥套推动具有对称锥面的模座径向收缩,实现模块对胶管的扣压。当收缩量达到标尺调定值时,扣压自动停止,电磁换向阀换向后,液压油进入两个开模油缸,推动扣压柱塞反向运动,模座在弹簧作用下带动模块复原。

one, works

under the pump and motor-driven, hydraulic oil output, push forward and withheld the piston in the cylinder movement, on the piston and cylinder head before the two symmetrical conical clamping sleeve push in radial shrinkage, realize the hose crimping module. when contraction ruler set value is reached, withheld automatically stops after the solenoid valve, hydraulic oil enters the two open mold oil cylinder, push withheld plunger reverse movement, clamping spring drive module recovery.

压管机,缩管机使用操作说明二、安装调试1. 搬运: 机器宜采用叉车搬运,并以机器底部受力,机身不允许倾斜。严禁搬抬锁头及标尺部位。2. 安装: 机器需水平固定于稳固的地基上,

并作接地处理。3. 注油：打开机壳，油箱中加入50l长城牌46#抗磨液压油。4. 接电：将电源线接在机器规定的电源上，点动电机观察旋向，电机旋向应与油泵所指方向一致。5. 检查标尺：标尺位于油缸前端面上（见上图），用于调节扣压管套收缩量的大小。顺时针调整，收缩量减小；逆时针调整，收缩量增大。标尺座靠三个螺钉上的弹簧弹力压在油缸端面上，用手拉动标尺（垂直油缸端面方向），标尺座应灵活离开油缸端面，松开后，靠弹簧弹力自动压紧在油缸上。开始扣压前，应仔细检查标尺伸缩是否灵活。不可将标尺用螺钉紧固在油缸上，否则会损坏标尺。6. 压力调整：机器系统最大压力为20mpa，靠溢流阀调整。顺时针调整压力增大，逆时针调整压力减小。（出厂时已调好，必要时可以自行调整）7. 开模速度调整：开模速度的快慢，由分流阀控制，顺时针调整，开模速度加快，逆时针调整，开模速度减慢，但开模速度过快会使噪音增大。（出厂时已调好，必要时可以自行调整）

second, installation and commissioning

1. handling: machines suitable for forklift handling and loading at the bottom of the machine, the fuselage tilting is not allowed. lift lock and rod parts is strictly prohibited. 2. installation: required level is fixed at the machine on a solid foundation and ground handling. 3. oiling: to open the cabinet, added 50l to the tank wall 46# anti-wear hydraulic oils. 4. power: plug the power cord connected to the machine specified on the power supply, move the motor to observe rotation direction, and should be consistent with the oil pump in the direction of motor rotation direction. 5. check the rulers: ruler located on the cylinder head surface (pictured above), to adjust withholding tube shrink quantity sizes. adjust clockwise, shrinkage decrease and counterclockwise adjustment, increased shrinkage. ruler near the three screws on the spring force on the cylinder face, hand pulling rod (vertical end face of the cylinder orientation), rulers should be flexible and leave the cylinder face, untied, by spring force automatically pressed on the cylinder. before you start withholding, you should carefully check the ruler scale is flexible. rod screws must not be fastened in the cylinder, otherwise it will damage the ruler. 6. pressure adjustments: machine system max pressure 20mpa, relying on relief valve adjusted. clockwise adjustment increases pressure, counterclockwise to adjust the pressure decreases. (factory-tuned, can adjust if necessary) 7. the mould opening speed adjustment: mould opening speed of, shunt valve controls clockwise adjust the opening speed, counterclockwise to adjust opening slow, but die too fast will make noise to increase. (factory-tuned, can adjust if necessary) 压管机, 缩管机使用操作说明

三、操作1. 机器初次使用时应空扣压20~30次，观察各部位均正常后方可使用。锁管机在冬季使用时应空载扣压20-30次，以使油温增高一些。2. 按下开模按钮，打开模具座。根据所扣压胶管规格选用相应的模具安装在模座上，并调整标尺刻度。（详见技术参数参考表）3. 把带有接头的胶管置于锁头内适当位置，使得一次扣压全部长度。4. 按下扣压按钮执行扣压操作，直至锁头停止扣压为止。5. 按下开模按钮，取出扣压成的胶管总成。用游标卡尺检测扣压后的管套外径尺寸，如与参数表不符，应精调标尺刻度，并重复上述操作，直到符合要求为止。

c operation

1. initial use of the machine should be free to withhold 20~30 times, observe each part correctly before use. lock in winter should be unloaded to withhold 20-30, so that the oil temperature increases. 2. press the opening button, open the mould. depending on the crimping hose sizes selecting appropriate tooling die on, and adjust the ruler ticks. (see the technical data reference tables) 3. hose with connectors placed in the lock position, making a withholding of full length.

4. withholding button is pressed the executive to withhold actions until the lock stop with held so far.

5. press the opening button, remove the withholding of a hose assembly. using a vernier caliper testing after withholding tube od, as inconsistent with the parameter table should be fine tuning ruler ticks, and repeat, until you meet the requirements.压管机,缩管机使用操作说明

四、试例扣压 19 层胶管（按jb1885-77标准制造）从锁管技术参数参考表中查得 19 层胶管胶套外径扣压前为39mm，扣压后为35mm，应选用得模具内径为 34，对应标尺为3.5。将内径为 34模具置于模具内，并将标尺刻度旋至3.5处，将胶管剥皮后与接头组装好。按“操作”中得步骤进行扣压操作，扣压完毕后测量管套外径，如测得尺寸为 35 mm，则完成扣压。如扣压直径不符，精调标尺后重新扣压，例：测得尺寸为 35.5mm，则逆时针调整标尺1.75圈即可。因胶管及管套的生产厂家不同，产品的具体尺寸、材质可能不尽相同，因此表中数据仅供参考，具体扣压尺寸应以压力实验为依据。

four rubber tubes, test cases to withhold phi 19 (manufactured according to jb1885-77 standards)

from the tube technical parameters in the reference table is read-locked hose rubber sleeve outer diameter 19 39mm before withholding, withheld after the 35mm, should select the die diameter for phi 34, ruler of 3.5. inner diameter for phi 34 mold placed in the mold, and ruler ticks spin to 3.5, rubber tube skinned assembled with joints. press "action" to withhold action steps in, and withheld after the measuring pipe diameter, such as 35 mm size is measured is finished, the withholding. if the crimping diameter deviations from, withholding again after fine tuning scale, for example: measured size is 35.5mm, then counter-clockwise to adjust the ruler 1.75 times. because of different plastic pipe and tubing manufacturer, products of specific sizes and materials may vary, so the data in the table are for reference only, specifically withheld dimensions are based on a stress test.

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五、 注意事项1. 扣压时要尽可能将接头置于模具中心，不要压在六角螺母上。2. 防止工具和其他异物进入锁头。3. 每次在工作完毕后必须使八块模座张开到最大程度，这样可使弹簧处于张开状态。否则将损坏弹簧。4. 工作时不要把手伸进锁头内。5. 剥皮工具必需牢固安装于剥皮电机连接盘上，剥皮机构不工作时把剥皮工具卸掉，以免意外伤人。6. 维修时必须切断电源。7. 因不同厂家的管套内径差异较大，胶管剥皮时，剥皮刀具径向位置调整应以每批所用管套内径为依据。

v, note

1. withheld to joints as far as possible into the mold center, not on the hexagonal nut.

2. prevention tools and other foreign matter from entering the lock.

3. after each working eight-block clamp opening must be made to the maximum extent, so that the spring is in the opened state. otherwise it will damage the springs.

4. do not put his hands into the headlock.

5. skinner must be firmly installed in the skinning on the motor plate, machine not working remove skinner, to prevent accidental injury.

6. maintenance must be powered off.

7. due to different manufacturers of tube diameter difference hose when skinning, skinning tool radial position adjustment should be based on each batch of tubes for sleeve inside diameter.

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技术咨询电话：13560810757陈工

本产品的加工定制是是，额定载荷是400T，功率是3KW，类型是压管机,啤管机,扣管机，品牌是台湾，新旧程度是全新，型号是SP系列,P系列,DX系列，规格是1.5寸,2寸