

KZL32 气动拉紧机

Model KZL32 Pneumatic Tensioner

KZS32 气动锁扣机

Model KZS32 Pneumatic Sealer

使用说明书

OPERATING MANUAL



诚信为本

精品源于人品

概 述

Summary

KZL32型气动捆扎拉紧机、KZS32型气动捆扎锁扣机是一种新颖的机械化程度较高的捆扎工具，二机必须联合使用才能完成全部捆扎动作(拉紧、锁扣、折断)。

Model KZL32 pneumatic bundling tensioner . Model KZS32 pneumatic bundling sealer are novel bundling tools which have high level of mechanization z, two tools should be united that all actions (tensioning, sealing, breaking) can be finished .

本机是一种气动式捆扎工具，具有重量轻，操作简便，安全可靠，捆扎迅速牢固，且劳动强度低，适用于对钢材、管材、板材等物件的捆扎。

these tools are pneumatic bundling tools, which have many characteristics such as lightweight, simple operation, safty and can be suitable for bundling steel, tube and plate.

一、技术规范

Technical Specifications

KZL32型气动捆扎拉紧机

Model KZL32 pneumatic bundling tensioner

- | | |
|-------------------------|----------------|
| 1、使用气压: | |
| Air pressure | 0.4~0.6MPa |
| 2、机体重量: | |
| Weight of tool | ≤5Kg |
| 3、空载钢带速度: | |
| No-load speed of strap: | ≥5m/min |
| 4、拉紧力: | |
| Tenston | 8.5KN |
| 5、钢带规格: | |
| Steel strap type | 32×(0.8~1.2)mm |

KZS32型气动捆扎锁扣机

Model KZS32 pneumatic bundling tensioner

- | | |
|-----------------------|----------------|
| 1、使用气压: | |
| Air pressure: | 0.4~0.6MPa |
| 2、机体重量: | |
| Weight of tool: | ≤3Kg |
| 3、夹口承受拉力: | |
| Pulling to the notch: | ≥16.85KN |
| 4、钢带规格: | |
| Steel strap type: | 32×(0.8~1.2)mm |

二、安装要求 Installation

使用该捆扎机时, 车间内应具有 $0.8\text{m}^3/\text{min}$ 气流量和 $0.4\sim 0.6\text{MPa}$ 的压缩空气源, 捆扎全过程平均耗气约为 1m^3 。压缩空气需通过油水分离器、压力调节阀、注油器(简称气源三联件)进入捆扎机。每条分支管路, 应从总管上部引出, 分支管路的内径大致为 14mm 。详见图1。

There should be $0.8\text{m}^3/\text{min}$ air flow and a 0.4 to 0.6 Mpa compressed air source in the workshop. The average air consumption during bundling is 1m^3 . The compressed air should go into the tool through the filter, the regulator and the lubricator (called three-union in short) respectively. Branch lines are taken from the top of main. The air hose is 14 -mm I.D. See Fig.1.



图1(Fig1)

三、使用方法及步骤 Operating Instructions

1、如图2所示, 先将锁扣套在捆扎用的钢带上, 并将钢带绕物体一周再插入锁扣, 在离锁扣外大约 50mm 处折过来。

As indicated in Fig. 2, thread the strap through a seal. Encircle the bundle and rethread the strap end through the seal. Bend the strap back under the seal, about 50mm

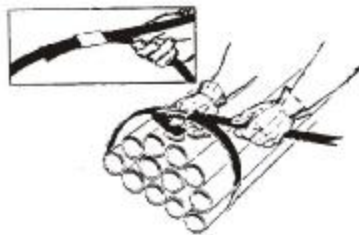


图2(Fig2)

2、如图3所示, 握住发动机箱体, 并用大拇指按下杠杆A, 让穿过扣子的上层钢带插入进给轮和滚柱之间, 然后松开杠杆。

Hold the motorbox, Press the gripper lever A with the thumb. Place the top strap into the interval between the Feedwheel and the Gyrowheel, then loose the gripper lever A as shown in Fig.3.

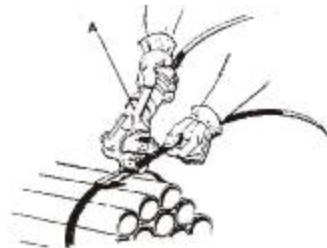


图3(Fig3)

3. 发动机箱体尾部的进气开关具有停止、半开、全开三档位置，如图4所示，顺时针方向旋转进气开关，进给轮转动并将穿过扣子的钢带拉紧到饱和状态时，进给轮便停止转动，但进气开关仍固定在“全开”位置上。

There are three grades of the air-in switch (stop, semi-operate, operate) at the end of the motor as shown in Fig.4 Turn the Feed-wheel begins to turn and tension the strap to saturation state until the Feedwheel stop turning, but the air-in switch is still fixed on "operate"

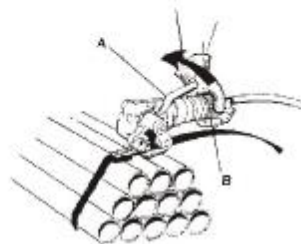


图4(Fig4)



图5(Fig5)

4. 如图5所示，将气动捆扎锁扣机的轧紧刀放在扣子上，按下阀按钮使锁紧机进行锁紧动作，作业完毕，松开阀按钮，锁扣机工作便告结束。

Place the notcher of the pneumatic bundling sealer on the seal. Press the valve button to lock the seal. After that, loose the valve button. Refer to Fig.5.

5. 如图6所示，将拉紧机作向上垂直位置的倾斜动作，以折断钢带。钢带折断后即将进气开关作逆时针方向旋转到“停止”位置上。

Break the strap at the seal by sloping the tensioner vertically then turn the air-in switch along contra-clockwise to "stop". See Fig.6.



图6(Fig6)

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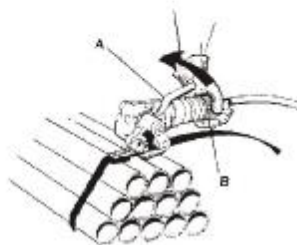


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图6(Fig6)

四、维护与保养

Maintenance

1、发动机和缸体内必须经常保持适量的润滑油，为此，应在注油器中注满22#气轮机油，才能保持固定的供油量。当发动机运转时，从注油器中下滴的润滑油为40~60滴/min，此外，如果每班操作前，能有若干滴润滑油直接进入机器内，那将使操作更为顺利。注油器和过滤器每使用六个月应用煤油清洗一次。

Fill the lubricator with 22# steam turbine oil to keep a quantity of lubricating oil in the motor and the cylinder when the motor is running. The oil must drop through the lubricator at a rate of 40 drops to 60 drops per minute, anymore, if some drops can be filled into the tool directly before daily operation, the operation will be successful. Clean the lubricator and the filter with Kerosene at least one time in six months during operation.

2、必须将压缩空气的压力调整在0.4~0.6MPa范围内，否则将造成气压不足，影响打包质量。

Adjusting the air pressure within the range of 0.5MPa to 0.6MPa to obtain enough air pressure, otherwise, the bundling quality will be affected.

3、必须定期检查过滤器和压力调节阀，并定期排除过滤器中的积水。

Check the filter and the regulating valve regularly. Drain the water from the filter daily.

4、应注意进给轮与滚轮之间的间隙是在0.1~0.3mm范围内，否则应予调整。

Be careful of the interval which is from 0.1mm to 0.3mm between the feedwheel and the gyrowheel, otherwise, it should be adjusted.

5、在使用期间应经常使滑动或转动部件保持适量的润滑油，并及时消除进给轮上的铁屑。

During the operation, keep a quantity of lubricating oil in turning or rolling parts. Eliminate the iron filings on the feedwheel in time.

拉紧机零件明细表 Tensioner Parts List

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY
1	齿 轮 箱 Gearbox		1
2	滚针轴承(6941/8) Needle bearing	8×14×10	1
3	内六角螺钉 Socket head cap screw	M6×20	4
4	弹性垫圈 Elastic Washer	φ6	4
5	锥 蜗 杆 Tapered worm		1
5-2	锥 蜗 轮 Tapered wormwheel		1
6	单列向心轴承(60103) Single-row radial ball bearing	17×35×10	1
7	衬 圈 Bushing		1
8	挡 圈 Axial hamper		1
9	第二空转体 The second idler		1
9-1	单列向心轴承(102) Single-row radial ball bearing	15×32×9	1
10	夹 紧 器 Clipper		1
11	行 星 齿 轮 Epicyclic gear		4
11-1	滚针轴承(SZ-416) Needle bearing	6×10×11	4
12	齿 轮 轴 Gear shaft		4
13	第二空转体垫圈 The second idler washer		1
13-1	第一空转体垫圈 The first idler washer		1
14	第一空转体 The first idler		1
15	单列向心轴承(103) Single-row radial ball bearing	17×35×10	3
16	单列向心轴承(101) Single-row radial ball bearing	12×28×8	1
17	内 齿 轮 Epicyclic internal gear		1
18	隔 圈 Separation ring		1
19	单列向心轴承(80200D) Single-row radial ball bearing	10×30×9	1
20	气 缸 前 盖 Front cylinder head		1
21	气 缸 Cylinder		1
22	气 缸 后 盖 Rear cylinder head		1
23	转 子 环 Rotator ring		1
24	圆 柱 销 Cylindrical pin	φ4×35	1

续 continued

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY
25	弹性圆柱销 Elastic tapered pin	φ3×10	2
26	圆锥销 Tapered pin	φ8×25	2
27	密封垫 Washer		1
28	托架销 Bracket pin		1
29	夹紧弹簧 Clip spring		1
30	定位弹簧 Positioner		1
30-1	钢 球 Ball	φ4	1
31	转 子 Rotator		1
32	滑 片 Slip slice		5
33	单列向心轴承(80029D) Single-row radial ball bearing	9×26×8	1
34	垫 圈 Washer		1
34-1	平端螺钉 Flae screw	M5×10	1
35	轴承后盖 Rear bearing head		1
36	发动机组合件 Engine assembly		1
37	卡紧箍 Staking hoop		1
38	壳 体 Shell		1
39	调速圈 Adjustable-speed ring		1
40	节流阀 throttling valve		1
41	塔形弹簧 Tower spring		1
42	壳 盖 Shell head		1
43	平端螺钉 Round-head screw	M5×10	7
44	轴承盖 Bearing head		1
45	单列向心轴承(102) Single-row radial ball bearing	15×32×9	2
46	轴 套 Housing		1
47	轴用挡圈 Truarc	φ17×1	1
48	主 轴 Spindle		1
49	孔用挡圈 Shaft-usage hamper	φ35×1.5	1
50	进给轮 Feedwheel		1

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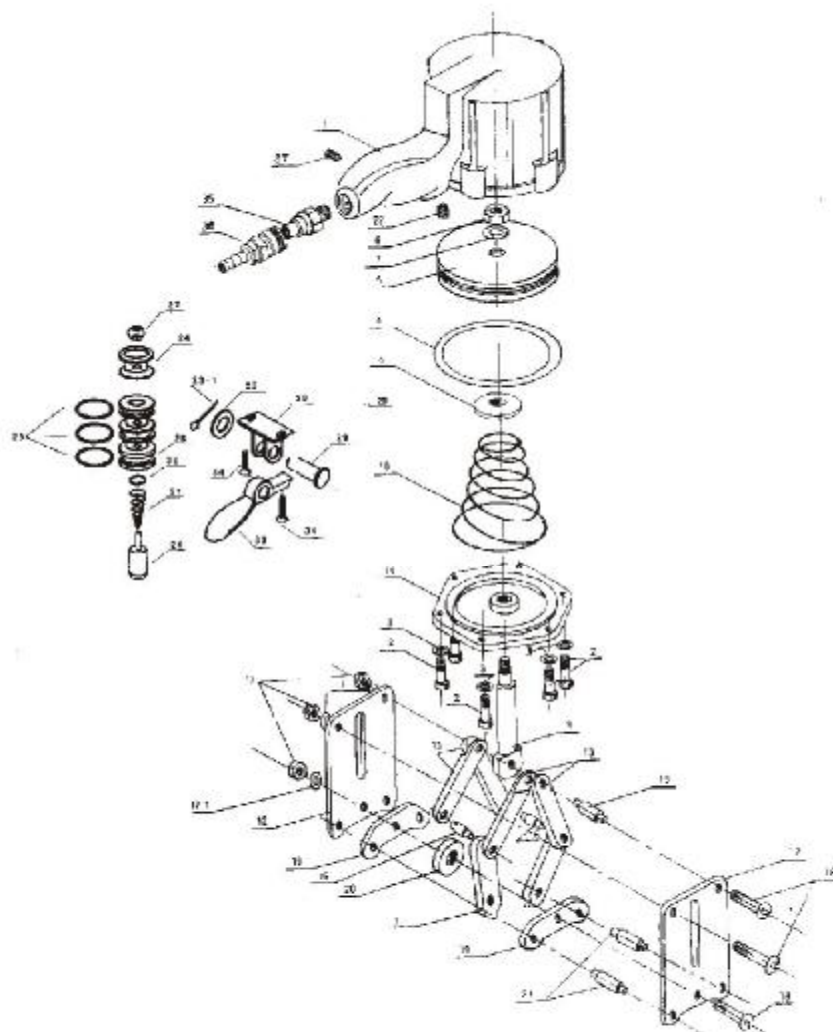
序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY
51	托 架 Bracket		1
52	轴 承 Bearing		1
53	内六角螺钉 Socket head cap screw	M6×25	2
54	齿轮箱底板 Gearbox base plate		1
55	平端螺钉 Flat screw	M4×12	5
56	平端螺钉 Flat screw	M6×14	1
57	杠 杆 Lever		1
58	紧固螺钉 Shcc	M6×8	2
59	夹 紧 座 Clip stand		1
60	弹性垫圈 Elastic washer	φ6	2
61	夹紧器弹簧 Clipper spring		1
62	夹紧器轴销 Clipper shaft pin		1
63	进气接头 Air entrance joint		1
64	快速接头 Interlocking Key		1
65	紧固螺钉 Raised-head screw	M6X8	1
66	滚 柱 Roller		1
67	滚柱轴 Roller shaft		1
68	螺 母 Nut	M8	1
69	垫 圈 Washer	φ8	1
70	紧固螺钉 Shcc	M5×8	1
71	堵 头 Locking ping		1
72	限位板 cutter		1
73	螺 钉 Shcc	M6×25	1

锁扣机零件明细表 Sealer Parts List

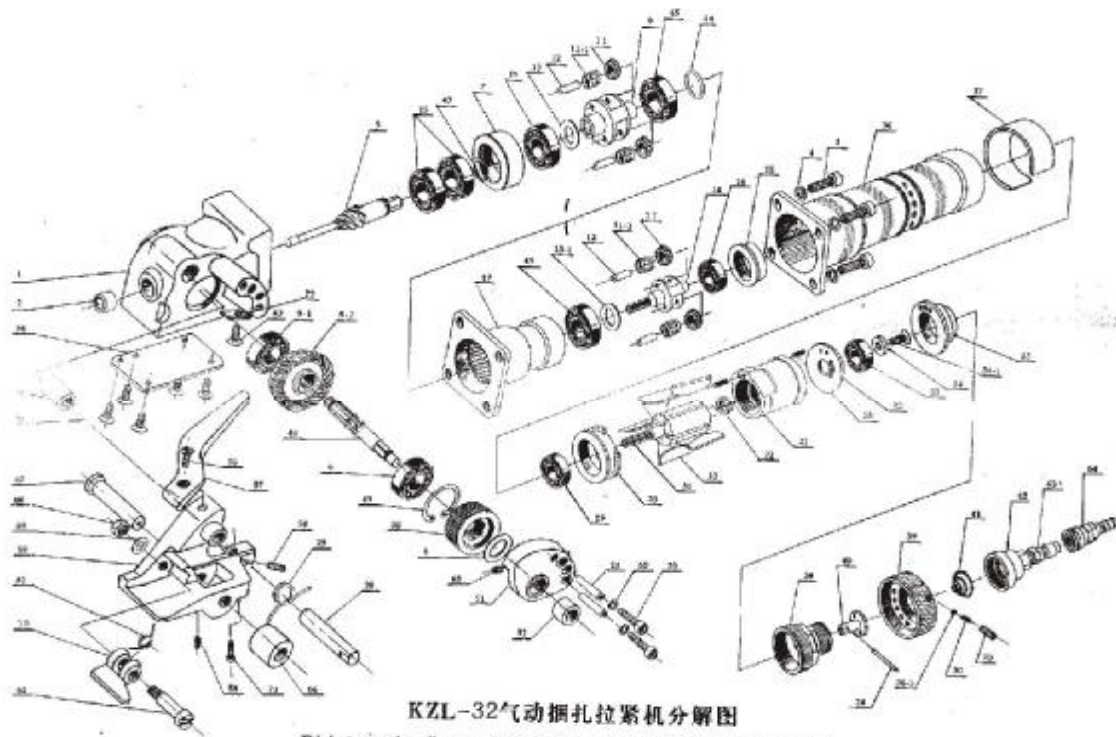
序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数量 QTY
1	缸 体 Cylinder		1
2	内六角螺钉 Socket head cap screw	M6×25	6
3	弹性垫圈 Elastic washer	φ6	6
4	活塞密封圈 Piston O-ring	φ5.7× φ100	1
5	活 塞 Piston		1
6	螺 母 Nut	M10	1
7	垫 圈 Washer	φ10	1
8	活塞杆垫圈 Ram washer		1
9	活 塞 杆 Ram		1
10	弹 簧 Spring		1
11	夹 紧 刀 Notcher		2
12	侧 板 Side plate		2
13	链 板 Chain plate		4
14	缸体底板 Cylinder base plate		1
15	中心销 Center pin		1
16	链 销 Chain pin		2
17	螺 母 Nut	M8	3
17-1	垫 圈 Washer	φ8	3
18	密配螺栓 Closely fitted bolt		3
19	砧 座 Saddle		2
20	砧 座 垫 Saddle gasket		1
21	轧紧刀销 Notcher pin		2
22	沉头螺钉 raised-head screw	M10×12	1
23	孔用挡圈 Hole-usage hamper	φ20×1	1
24	阀 盖 Valve head		1
25	气门密封圈 Valve O-ring	φ20× φ2.4	1
26	阀 杆 Valve link		1
27	阀 Valve		1

续 continued

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY
28	阀 套 Valve bush		1
29	密 封 圈 O-ring	$\phi 8 \times 1.9$	1
30	套 筒 Sleeve		1
31	阀套弹簧 Valve bush spring		1
32	按钮密封圈 Button O-ring	$\phi 14 \times \phi 2.4$	1
33	阀 按 扭 Valve button		1
34	销 pin	$\phi 2 \times 28$	1
35	进气接头 Air entrance joint		1
36	快速接头 Interlocking Key		1
37	紧定螺钉 Shcc	M5×10	1



KZS-32型气动捆扎锁扣机分解图
 Disintegration figure of Model Kzs-32 pneumatic bundling sealer



KZL-32气动捆扎拉紧机分解图

Disintegration figure of Model KZL32 pneumatic bundling sealer