

配件手册

Accessories Manual

——双压带干式磨边机

Double Belt dry type squaring machinery



请妥善保存此手册以备查阅 Please keep this manual for future reference

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电源电压	1
Supply Voltage 380 V / 50 Hz	1
装机功率	1
Installation Power 219 kW	1
气源压力	1
Air Pressure ≥ 0.6 MPa	1
平均耗气量	1
Average gas consumption 50 L/min	1
外形尺寸	1
Dimension 6600(Length) x 2500(Width) x 2100(Height)	1
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第1章 概述

Chapter 1 Overview

1.1 性能参数

1.1 Items Parameters

项目 Items	参数 Parameters
	双压带干式磨边机 Double belt dry type squaring machinery
电源电压 Supply Voltage	380 V / 50 Hz
装机功率 Installation Power	219 kW
气源压力 Air pressure	≥0.6 MPa
平均耗气量 Average gas consumption	50 L/min
外形尺寸 Dimension	6600(Length) x 2500(Width) x 2100(Height)

1.2 设备概述

1.2 Equipment Overview

设备功能描述：磨边倒角自动化生产线是墙地砖加工自动生产线中必不可少的机械设备。主要用于墙地砖四边的侧磨修整，及倒角磨削修整，能有效地消除墙地砖的收缩不定、“大小头”、“波浪边”及微量崩边等缺陷。磨边机除用于陶瓷砖的磨削修边外，还可用于大理石、人造玉、花岗石等材料的磨削修边，其加工宽度范围可在 200~1200mm 之间任意调整，最大加工厚度 20mm。

设备结构描述：磨边线分进砖线架、前磨边主机、中间调头线架、后磨边主机、出砖线架五大部分。前磨边主机主要有输送机构、对中机构、压砖机构、磨边倒角机构及调宽机构。前后磨边主机在机构上基本相同，唯一不同的是后主机多了推砖机构。另外，磨边机必须配备除尘系统。

Equipment function description: The automatic production line of edge grinding and chamfering is an indispensable mechanical equipment in the automatic production line of wall and floor tile processing. It is mainly used for side grinding and finishing of the four sides of wall and floor tiles, and chamfer grinding and finishing, which can effectively eliminate the defects of wall and floor tiles such as indeterminate shrinkage, "small head", "wave edge" and slight chipping. In addition to the grinding and trimming of ceramic tiles, the edging machine can also be used for the grinding and trimming of marble, artificial jade, granite and other materials. The processing width can be adjusted between 200 and 1200mm. The maximum processing The thickness is 20mm.

Equipment structure description: The edge grinding line is divided into five parts: the brick line frame, the front edge grinding machine, the middle turning line frame, the rear edge grinding machine, and the brick line frame. The front edging machine mainly includes conveying mechanism, centering mechanism, brick pressing mechanism, edging chamfering mechanism and width adjusting mechanism. The front and rear edging hosts are basically the same in mechanism, the only difference is that the rear host has an extra brick pushing mechanism. In addition, the edge grinding machine must be equipped with a dust removal system.

1.3 使用机器的注意事项

1.3 Precautions for using the machine

- ①、保证正常的电源电压
- ①、Ensure normal power supply voltage
- ②、供气压不能低于额定气压
- ② The supply air pressure cannot be lower than the rated air pressure
- ③、机器不使用时请关掉电源
- ③, please turn off the power when the machine is not in use
- ④、按照说明书定期保养设备
- ④ Maintain the equipment regularly according to the instructions
- ⑤、勿随意更换或拆卸机器上的零件
- ⑤ Do not replace or disassemble the parts on the machine at will
- ⑥、机器工作请勿站在机器工作范围内以免被弄伤
- ⑥. Do not stand in the working range of the machine to avoid injury

第2章 组件图及明细表

Chapter 2 Components diagram and detailed list

2.1 磨头组件及明细表

2.1 Grinding head assembly and detailed list

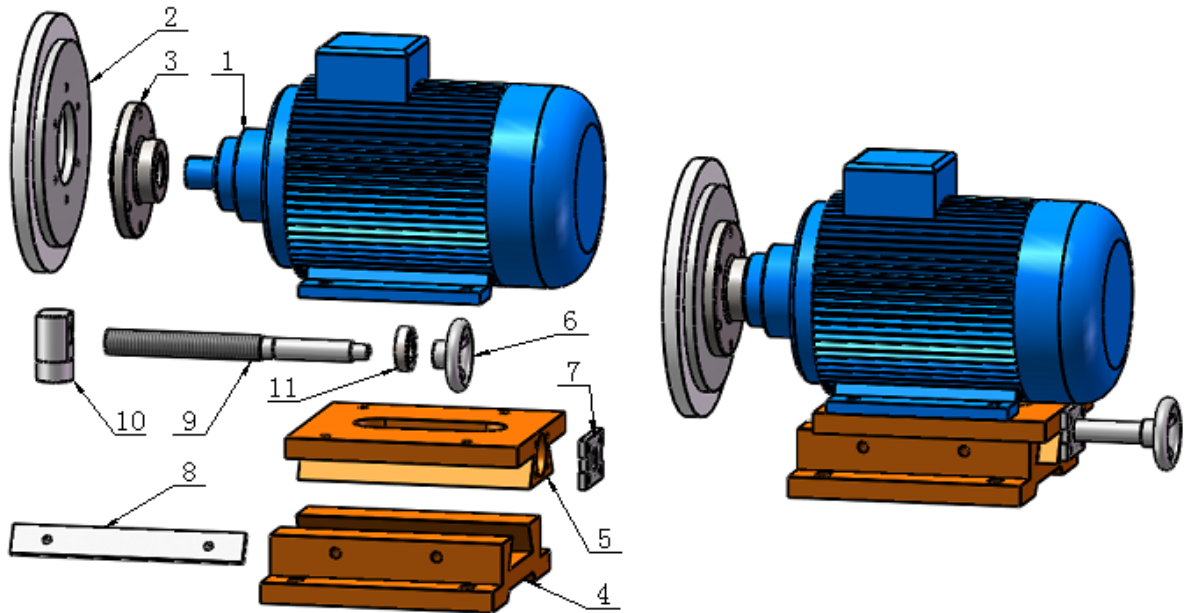


表1 磨头组件明细表

Schedule 1 grinding head assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	猪嘴电机 (380v) Pig mouth motor (380v)	1	
2	φ250 磨边轮 φ250 grinding wheel	1	
3	φ200 磨轮法兰 φ200 grinding wheel flange	1	45#
4	底座 Pedestal	1	HT200
5	电机滑座 Motor Sliding pedestal	1	HT200
6	调节座手轮 Adjusting Pedestal handling wheel	1	HT150
7	调节座压盖 Adjusting pedestal pressure cover	1	A3
8	镶条 Embed bar	1	A3
9	调节座丝杆 Adjusting pedestal bolt	1	45#
10	调节座螺母 Adjusting pedestal nut	1	45#
11	深沟轴承 6004	1	

	Deep groove bearing 6004		
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2.2 上倒角组件及明细表

2.2 Upper chamfering assembly and detailed list

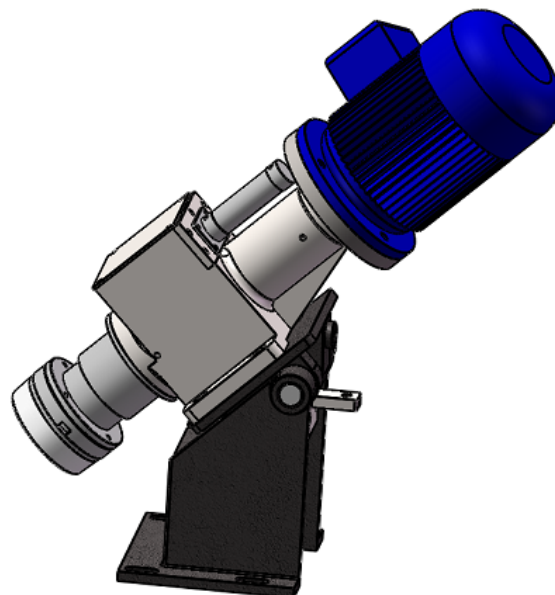
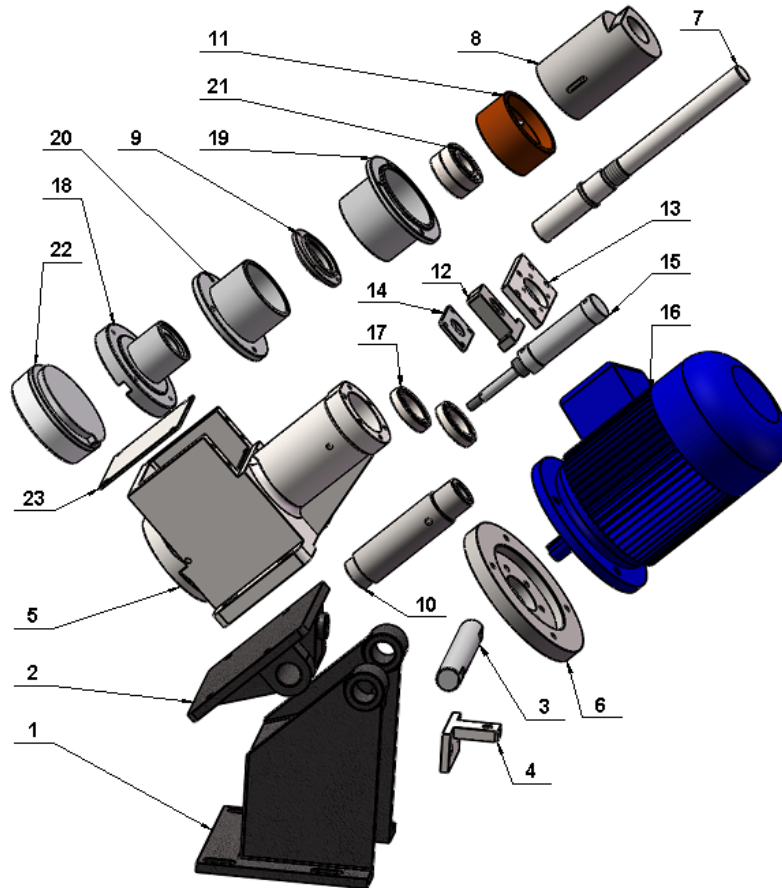


表2 上倒角组件明细表

Schedule 2 Upper chamfering assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	373C 翻板座 (矮) 373C flap seat (short)	1	HT200
2	373C 翻板 373C flap	1	HT200
3	373C 销轴 373C pin shaft	1	45#
4	373C 倒角座支撑块 373C chamfer base support block	1	A3
5	373C 倒角头支座 373C Chamfer Head Support	1	HT200
6	373C 连接法兰 373C connecting flange	1	45#
7	373C 滑动轴 373C sliding axle	1	45#
8	373C 滑套 373C sliding sleeve	1	45#
9	373C 端盖 373C end cap	1	45#
10	373C 滑动套 373C sliding sleeve	1	45#
11	373C 铜套 373C copper sleeve	1	
12	373C 气缸连接块 373C cylinder connecting block	1	A3
13	373C 气缸连接板 (大) 373C cylinder connecting plate (large)	1	A3
14	373C 气缸连接板 (小) 373C cylinder connecting plate (small)	1	A3
15	373C 气缸 373C cylinder	1	
16	倒角电机 Chamfering motor	1	
17	深沟球轴承 61908 Deep groove ball bearings 61908	2	
18	373C 右砂轮安装盘 373C Right Grinding Wheel Mounting Plate	1	铝合金 Aluminum alloy
19	373C 水罩安装法兰 373C water cover mounting flange	1	铝合金 Aluminum alloy
20	373c 夹盘安装法兰 373c chuck mounting flange	1	铝合金 Aluminum alloy
21	角接触球轴承 7206 Angular contact ball bearings 7206	2	
22	上倒角轮 (右) Upper chamfering wheel (right)	1	
23	373C 磨头定位盖 373C grinding head positioning cover	1	A3

2.3 下倒角组件及明细表

2.3 Lower chamfering assembly and detailed list

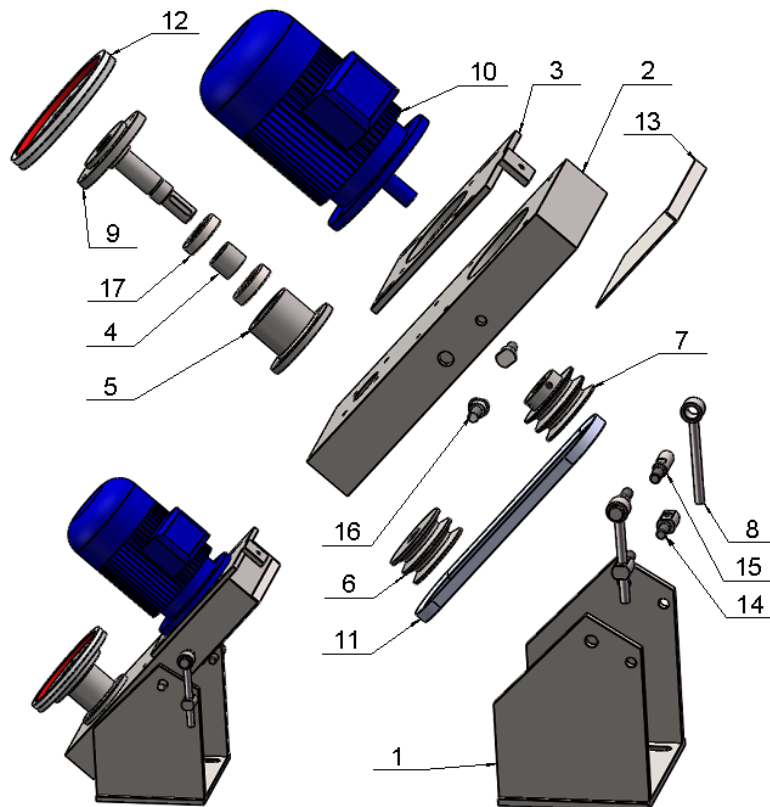


表3 下倒角组件明细表

Schedule 3 Lower chamfering assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	下倒角座板 Lower chamfer base plate	1	A3
2	旋转支架（下倒角箱体） Rotating bracket (bottom chamfered box)	1	A3
3	下到角电机托板 Bottom to corner motor bracing plate	1	A3
4	下倒角磨头轴隔套 Lower chamfer grinding head shaft spacer	1	45#
5	下倒角磨头轴筒 Lower chamfer grinding head shaft	1	45#
6	下倒角被动轮 Lower chamfered passive wheel	1	HT200
7	下倒角主动轮 Lower chamfer driving wheel	1	HT200
8	下到角调节螺杆焊套 Bottom to angle adjustment screw welding sleeve	2	45#

9	下倒角磨头轴 Lower chamfer grinding head shaft	1	45#
10	倒角电机 Chamfering motor	1	
11	皮带（下倒角）Belt (bottom chamfer)	1	橡胶
12	磨边轮（下倒角轮）Edging wheel (lower chamfering wheel)	1	
13	下倒角盖板 Lower chamfer cover	1	A3
14	下倒角销轴 2 Lower chamfer pin 2	2	45#
15	下到角定位销 2（调节轴）Bottom to corner positioning pin 2 (adjustment shaft)	2	45#
16	下倒角旋转支撑轴 Lower chamfer rotation support shaft	2	45#
17	深沟球轴承 6206 Deep groove ball bearings 6206	2	

2.4 右后支承板组件及明细表

2.4 Right rear bracing plate assembly and detailed list

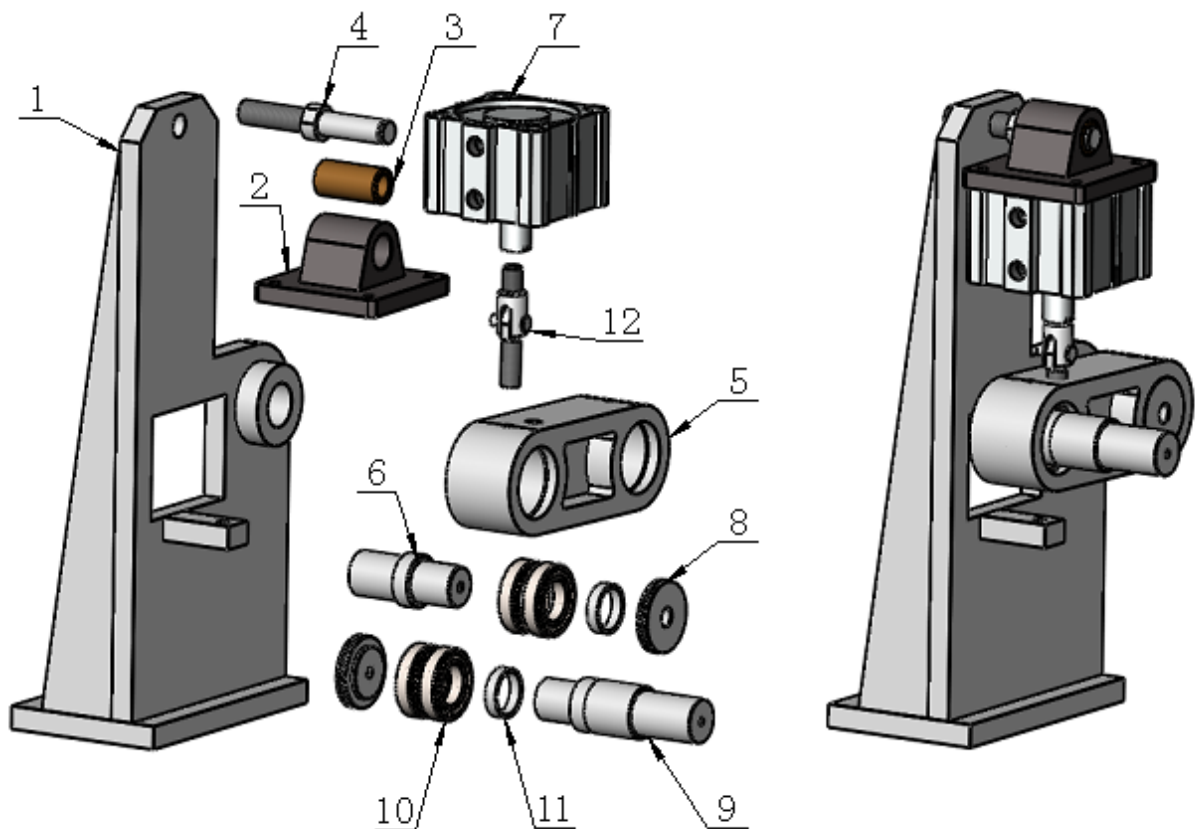


表4 右后支承板组件明细表

Schedule 4 Right rear bracing plate assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
1	右后支承板（高） Right rear support plate (high)	1	A3

2	气缸连接法兰 Cylinder connecting flange	1	A3
3	气缸连接轴铜套 Cylinder connecting shaft copper sleeve	1	锡青铜 Tin bronze
4	气缸支承轴 Cylinder support shaft	1	45#
5	水磨右转臂 Wet grinding right turning arm	1	HT200
6	水磨转臂短轴 Wet grinding turning arm short shaft	1	45#
7	压梁气缸 QGY100X30 Pressure beam cylinder QGY100X30	1	
8	转臂轴盖板 Boom shaft cover	2	A3
9	转臂长轴 Long shaft of boom	1	45#
10	深沟球轴承 6007 Deep groove ball bearings 6007	4	
11	转臂隔套 (Ø42xØ36x10) Boom spacer (Ø42xØ36x10)	2	A3
12	气缸活节 Cylinder joint	1	A3

2.5 右前支承板组件及明细表

2.5 Front right bracing plate assembly and detailed list

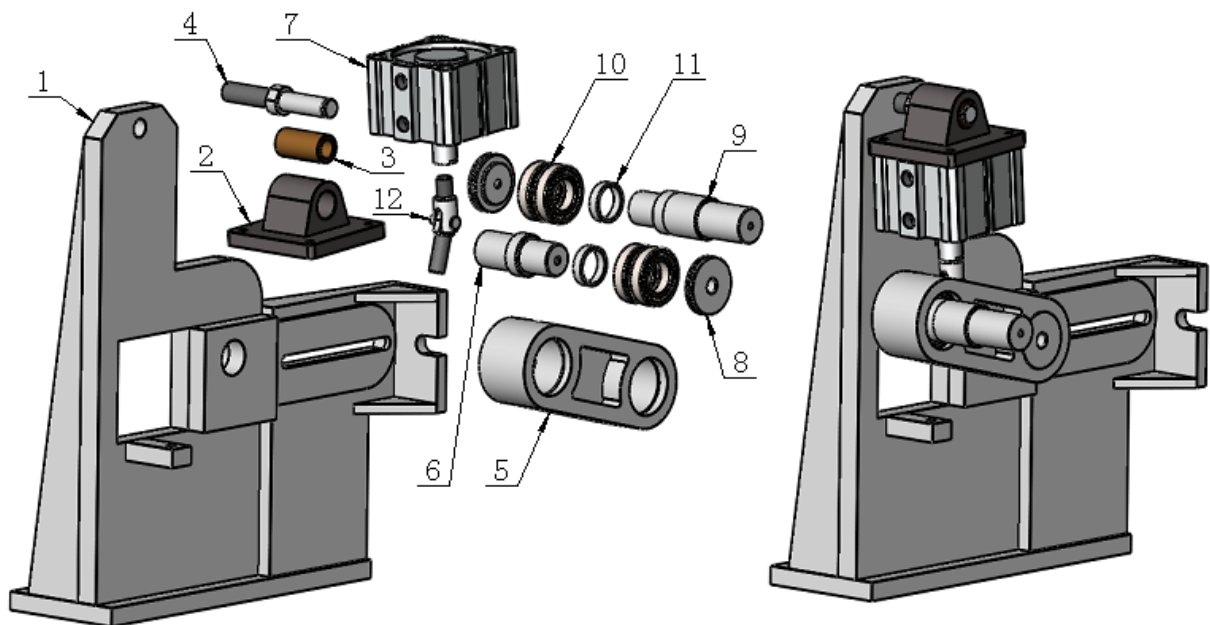


表5 右前支承板组件明细表

Schedule 5 Front right bracing plate assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
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1	右前支承板（高） Right front support plate (high)	1	A3
2	气缸连接法兰 Cylinder connecting flange	1	A3
3	气缸连接轴铜套 Cylinder connecting shaft copper sleeve	1	锡青铜 Tin bronze
4	气缸支承轴 Cylinder support shaft	1	45#
5	水磨右转臂 Wet grinding right turning arm	1	HT200
6	水磨转臂短轴 Wet grinding turning arm short shaft	1	45#
7	压梁气缸 QGY100X30 Pressure beam cylinder QGY100X30	1	
8	转臂轴盖板 Boom shaft cover	2	A3
9	转臂长轴 Long shaft of boom	1	45#
10	深沟球轴承 6007 Deep groove ball bearings 6007	4	
11	转臂隔套（ $\varnothing 42 \times \varnothing 36 \times 10$ ） Boom spacer ($\varnothing 42 \times \varnothing 36 \times 10$)	2	A3
12	气缸活节 Cylinder joint	1	A3

2.6 左后支承板组件及明细表

2.6 Rear left bracing plate assembly and detailed list

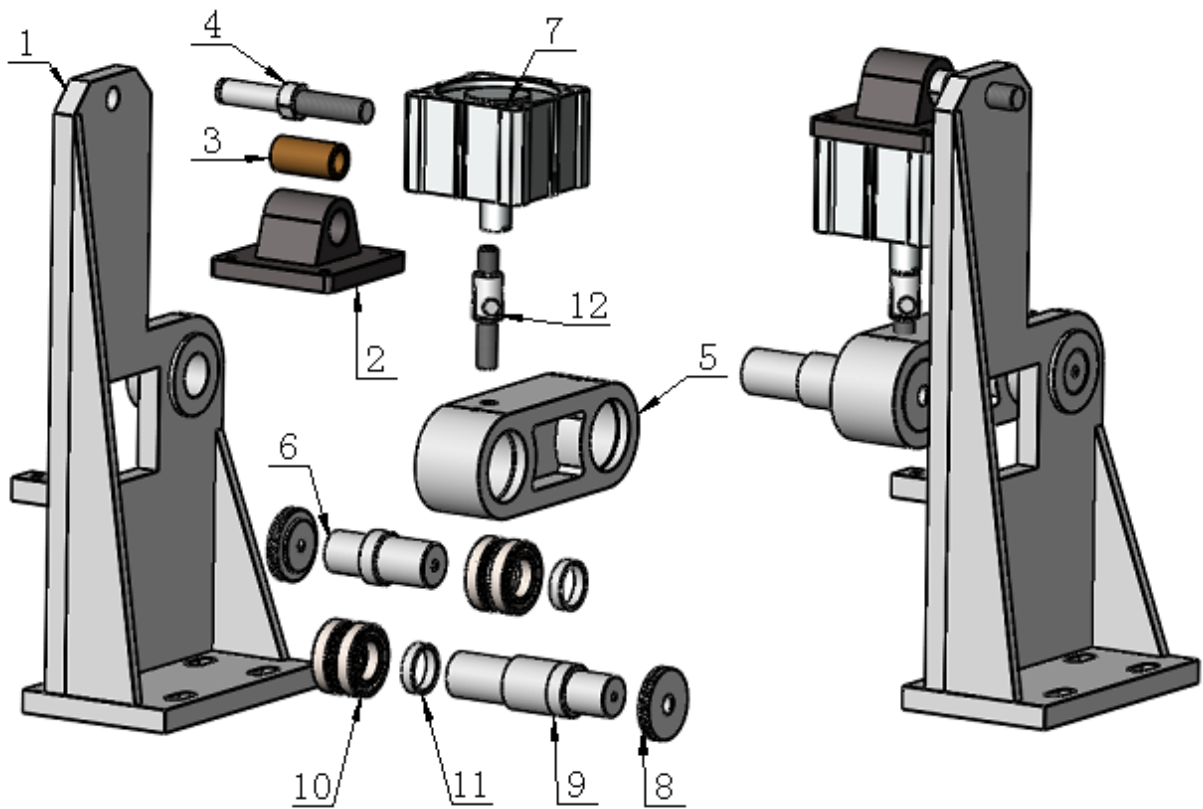


表6 左后支承板组件明细表

Schedule 6 Rear left bracing plate assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
1	左后支承板（高） Rear left support plate (high)	1	A3
2	气缸连接法兰 Cylinder connecting flange	1	A3
3	气缸连接轴铜套 Cylinder connecting shaft copper sleeve	1	锡青铜 Tin bronze
4	气缸支承轴 Cylinder support shaft	1	45#
5	水磨左转臂 Wet grinding left turning arm	1	HT200
6	水磨转臂短轴 Wet grinding turning arm short shaft	1	45#
7	压梁气缸 QGY100X30 Pressure beam cylinder QGY100X30	1	
8	转臂轴盖板 Boom shaft cover	2	A3
9	转臂长轴 Long shaft of boom	1	45#
10	深沟球轴承 6007 Deep groove ball bearings 6007	4	
11	转臂隔套（ $\varnothing 42 \times \varnothing 36 \times 10$ ） Boom spacer ($\varnothing 42 \times \varnothing 36 \times 10$)	2	A3

12	气缸活节 Cylinder joint	1	A3
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2.7 左前支承板组件及明细表

2.7 Front left bracing plate assembly and detailed list

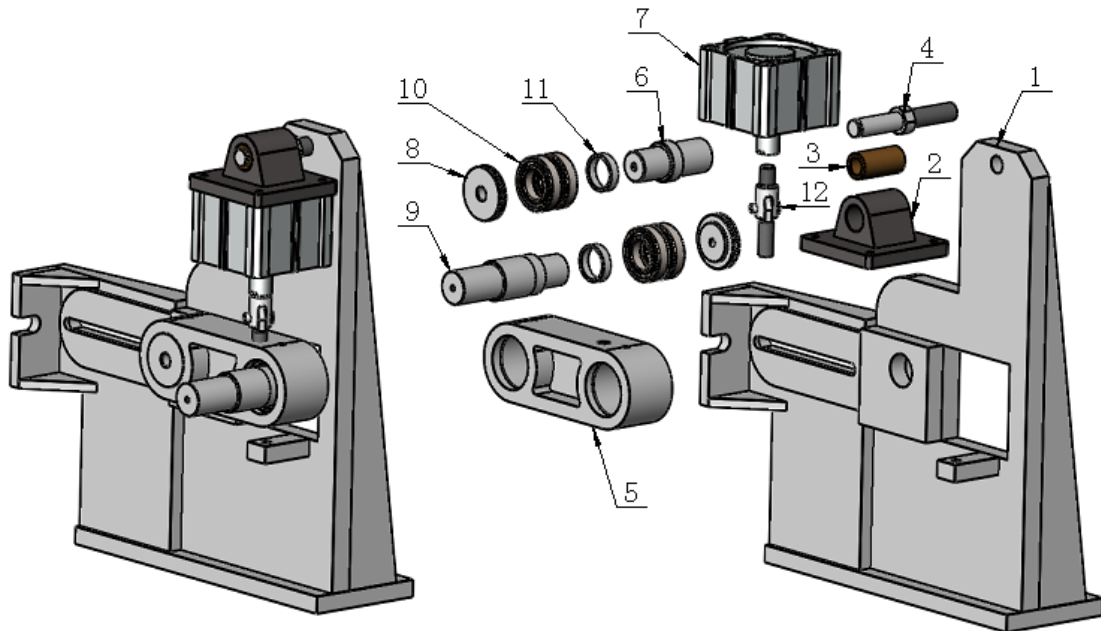


表7 左前支承板组件明细表

Schedule 7 Front left bracing plate assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
1	左前支承板（高）Front left support plate (high)	1	A3
2	气缸连接法兰 Cylinder connecting flange	1	A3
3	气缸连接轴铜套 Cylinder connecting shaft copper sleeve	1	锡青铜 Tin bronze
4	气缸支承轴 Cylinder support shaft	1	45#
5	水磨左转臂 Wet grinding left turning arm	1	HT200
6	水磨转臂短轴 Wet grinding turning arm short shaft	1	45#
7	压梁气缸 QGY100X30 Pressure beam cylinder QGY100X30	1	
8	转臂轴盖板 Boom shaft cover	2	A3
9	转臂长轴 Long shaft of boom	1	45#
10	深沟球轴承 6007 Deep groove ball bearings 6007	4	
11	转臂隔套 (Ø42xØ36x10) Boom spacer (Ø42xØ36x10)	2	A3

12	气缸活节 Cylinder joint	1	A3
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2.8 皮带托轮组件及明细表

2.8 Belt support wheel assembly and detailed list

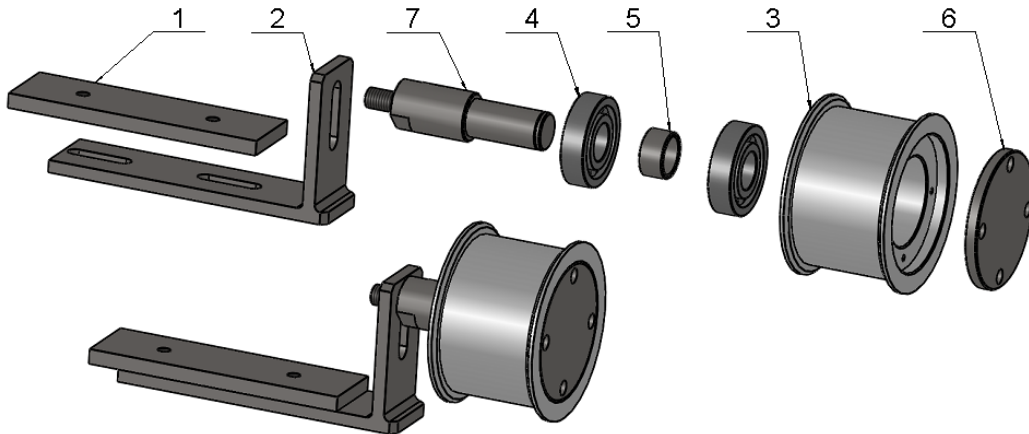


表8 皮带托轮组件明细表

Schedule 8 Belt support wheel assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	焊接底板 Welded bottom plate	1	A3
2	调节支架 Adjusting bracket	1	A3
3	皮带托轮 Belt bracing wheel	1	HT200
4	深沟球轴承 6306 Deep groove bearing 6306	2	
5	托轮隔圈 Bracing wheel spacer	1	45#
6	托轮端盖 Bracing wheel end cap	1	HT200
7	托轮轴 Bracing wheel shaft	1	45#

2.9 下活动轮组件及明细表

2.9 Lower moveable wheel assembly and detailed list

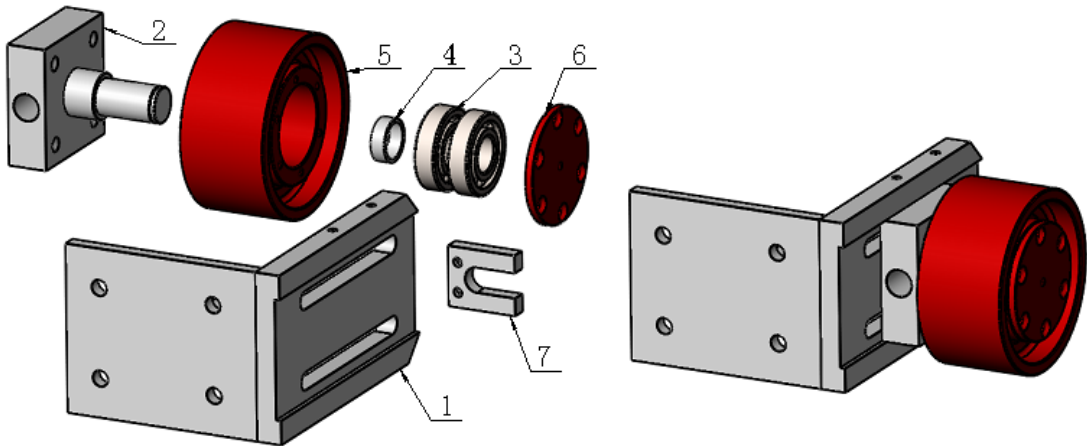


表9 下活动轮组件明细表

Schedule 9 Lower moveable wheel assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	下活动轮座 Lower moveable wheel base	1	A3
2	下活动轮轴 Lower moveable wheel shaft	1	45#
3	深沟球轴承 6307 Deep groove bearing 6307	2	
4	活动轮隔圈 Moveable wheel spacer	1	A3
5	活动轮 Moveable wheel	1	HT200
6	活动轮端盖 Moveable wheel end cap	1	45#
7	下活动轮调节板 Lower moveable wheel adjusting plate	1	A3

2.10 对中组件及明细表

2.10 Centering assembly and detailed list

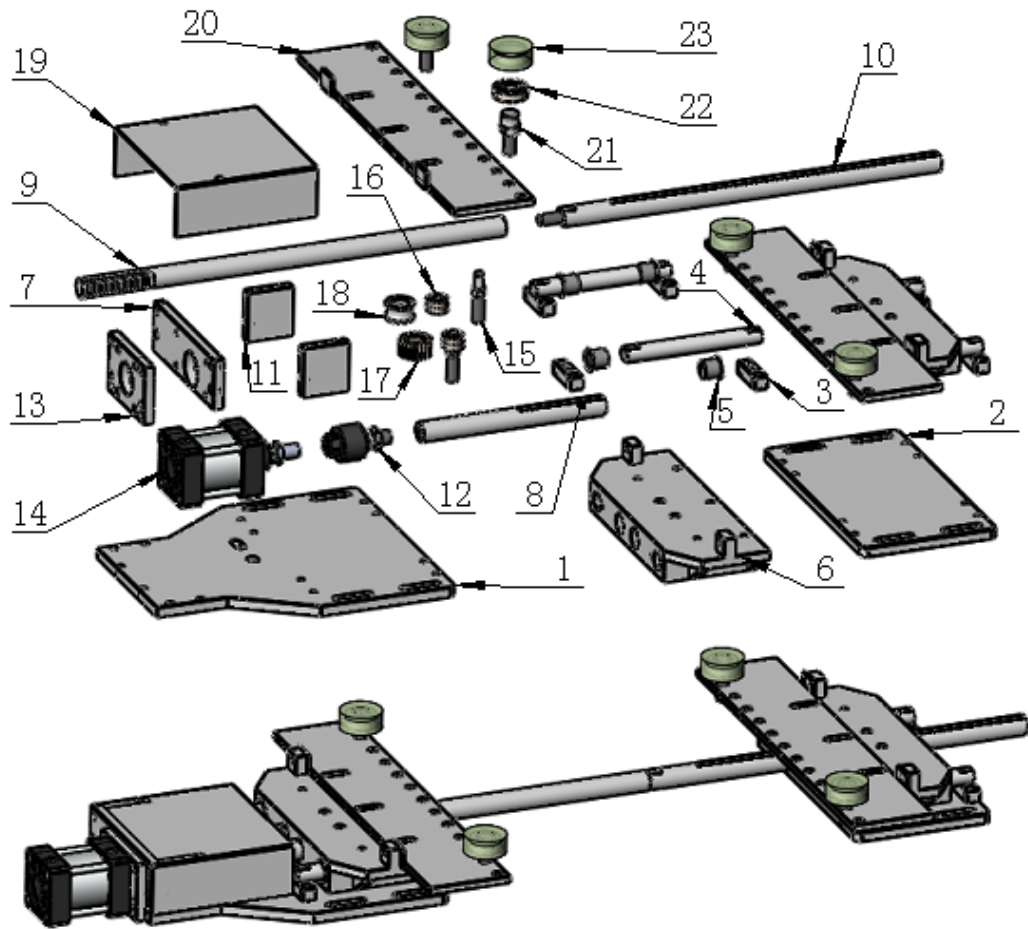


表10 对中组件明细表

Schedule 10 centering assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
1	400 对中机构固定板 A 400 centering mechanism fixing plate A	1	
2	400 对中机构固定板 B 400 centering mechanism fixing plate B	1	
3	400 对中导轴固定块 400 centering mechanism fixing block	8	
4	400 对中导轴 400 centering shaft	4	
5	对中轴承 Centering shaft	8	
6	400 对中活块 400 centering moveable block	2	
7	400 对中气缸固定板 B 400 centering cylinder fixing plate B	1	
8	400 对中主动齿条轴 (模数 2) 400 centering active rack shaft (module 2)	1	
9	400 对中被动齿条轴 (模数 2) 400 centering passive rack shaft (module 2)	1	

10	650 型 400 对中连接轴 650 type 400 centering connecting shaft	1	
11	气缸固定板 A Cylinder fixing plate A	2	
12	浮动接头 F-M20150F Floating joint F-M20150F	1	
13	80 对中气缸连接板 80 centering cylinder connecting plate	1	
14	对中气缸 SC80x25 Centering cylinder SC80x25	1	
15	对中齿轮轴 Centering gear shaft	2	
16	深沟球轴承 6201 Deep groove ball bearings 6201	4	
17	对中齿轮 (2M, 22Z) Centering gear(2M,22Z)	1	
18	压紧轮 Pinch wheel	1	
19	对中齿轮箱盖 Centering gear box cover	1	
20	400 型对中底板 400 type centering plate	2	
21	对中胶轮轴 Centering rubber wheel shaft	4	
22	深沟球轴承 6205 Deep groove ball bearings 6205	4	
23	对中胶轮 Centering rubber wheel	4	

2.11 调宽组件及明细表

2.11 Width adjusting assembly and detailed list

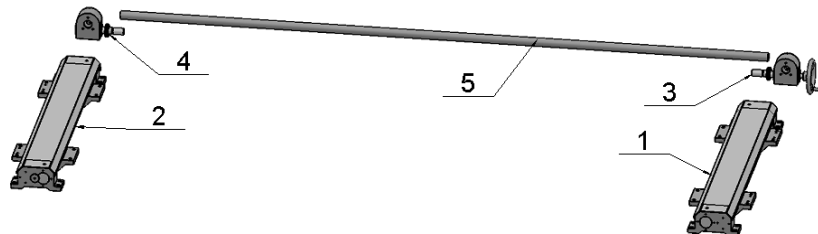


表11 调宽组件明细表

Schedule 11 Width adjusting assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	主动调宽座组件 Active width adjustment base assembly	1	
2	被动调宽座组件 Passive width adjustment base assembly	1	
3	主动调宽涡箱组件 Active widening scroll box assembly	1	
4	被动调宽涡箱组件 Passive width adjustment scroll box assembly	1	
5	调宽连接杆 Widening connecting rod	1	45#

2.11.1 主动调宽座组件及明细表

2.11.1 Active width adjustment base assembly and detailed list

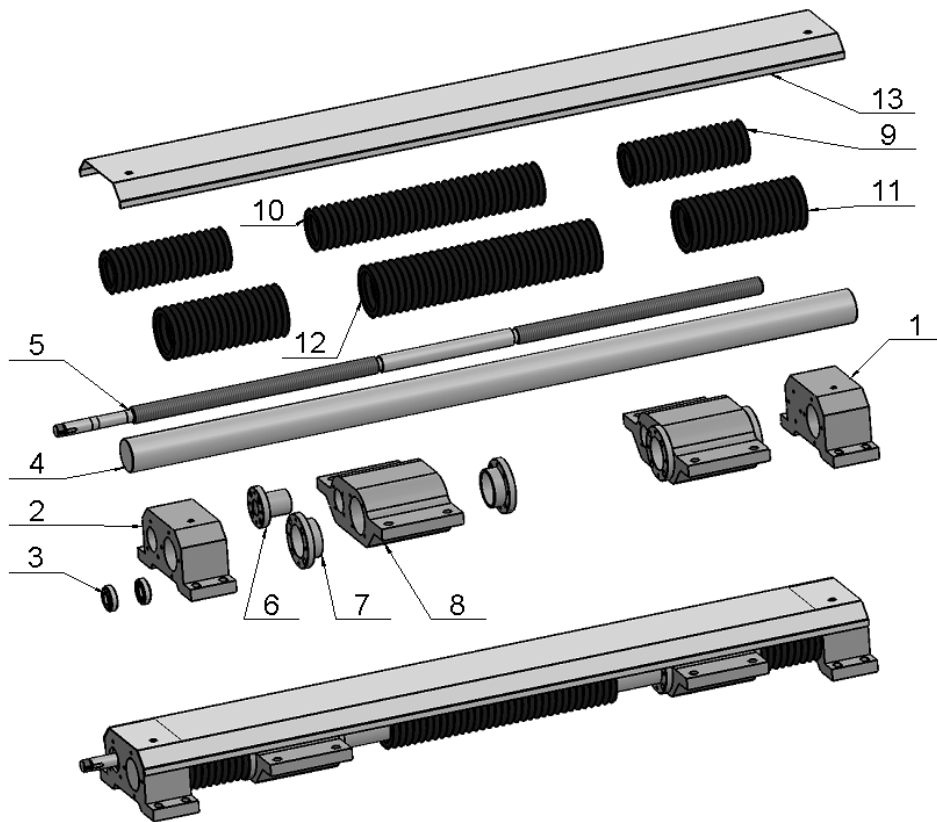


表12 主动调宽座组件明细表

Schedule 12 Active width adjustment base assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	单孔固定座 Single hole fixing base	1	HT200
2	双孔固定座 Two-hole fixing base	1	HT200
3	圆锥滚子轴承 30205 Tapered roller bearing 30205	2	
4	大梁调宽滑轴 Beam width adjustment sliding shaft	1	镀铬杆 Chrome rod
5	大梁调宽丝杆 Beam width adjustment screw	1	45#
6	调宽铜螺母 Adjustable copper nut	2	5A02
7	调宽滑套 Adjustable sliding sleeve	4	45#
8	调宽滑动座 Adjustable sliding base	2	HT200
9	防尘罩 (Φ120x16 格) Dust cover (Φ120x16 grid)	2	橡胶 rubber
10	防尘罩 (Φ120x32 格) Dust cover (Φ120x32 grid)	1	橡胶 rubber
11	防尘罩 (Φ150x16 格) Dust cover (Φ150x16 grid)	2	橡胶 rubber
12	防尘罩 (Φ150x32 格) Dust cover (Φ150x32 grid)	1	橡胶 rubber
13	调宽防尘盖 Widened dust cover	1	A3

2.11.2 被动调宽座组件及明细表

2.11.2 Passive width adjustment base assembly and detailed list

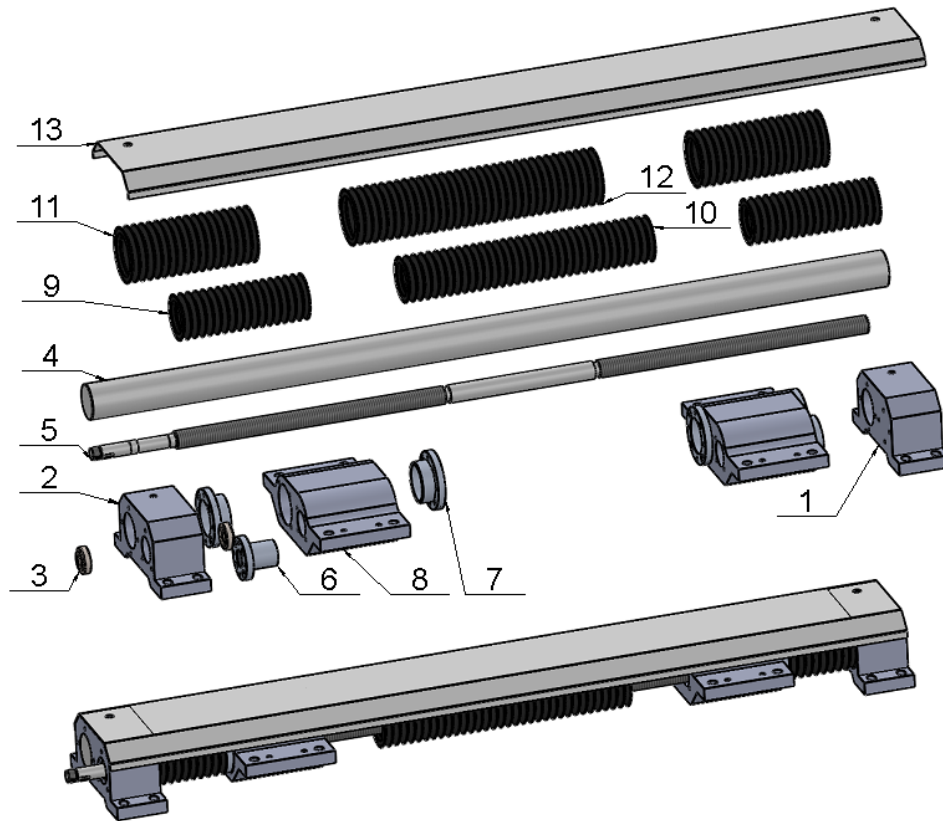


表13 被动调宽座组件明细表

Schedule 13 Passive width adjustment base assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	单孔固定座 Single hole fixing base	1	HT200
2	双孔固定座 Two-hole fixing base	1	HT200
3	圆锥滚子轴承 30205 Tapered roller bearing 30205	2	
4	大梁调宽滑轴 Beam width adjustment sliding shaft	1	镀铬杆
5	大梁调宽丝杆 Beam width adjustment screw	1	45#
6	调宽铜螺母 Adjustable copper nut	2	5A02
7	调宽滑套 Adjustable sliding sleeve	4	45#
8	调宽滑动座 Adjustable sliding base	2	HT200
9	防尘罩 (Φ120x16 格) Dust cover (Φ120x16 grid)	2	橡胶 rubber
10	防尘罩 (Φ120x32 格) Dust cover (Φ120x32 grid)	1	橡胶 rubber
11	防尘罩 (Φ150x16 格) Dust cover (Φ150x16 grid)	2	橡胶 rubber
12	防尘罩 (Φ150x32 格) Dust cover (Φ150x32 grid)	1	橡胶 rubber
13	调宽防尘盖 Widened dust cover	1	A3

2.11.3 主动调宽蜗箱组件及明细表

2.11.3 Active width adjustment scroll box assembly and detailed list

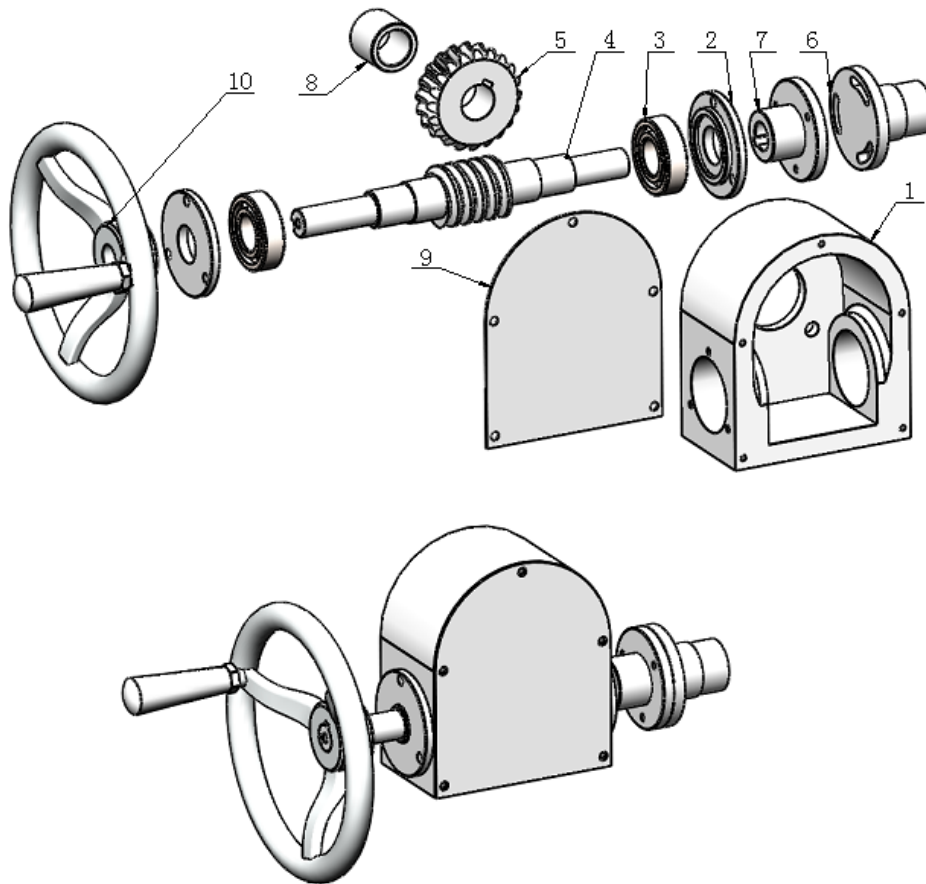


表14 主动调宽涡箱组件明细表

Schedule 14 Active width adjustment scroll box assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	调宽涡箱 Adjustable scroll box	1	HT200
2	涡箱透盖 Volute cover	2	A3
3	深沟球轴承 6205 Deep groove ball bearings 6205	2	
4	调宽涡杆（长） Width adjustable scroll rod (long)	1	45#
5	调宽蜗轮 Widened turbine	1	45#
6	50 法兰 B 50 flange B	1	45#
7	50 法兰 A 50 flange A	1	45#
8	调宽隔套 Adjustable spacer	1	45#
9	调宽涡轮箱盖板 Widened turbine box cover	1	A3
10	调宽 φ200 手轮 φ200 widening handling wheel	1	HT150

2.11.4 被动调宽涡箱组件及明细表

2.11.4 Passive width adjustment scroll box assembly and detailed list

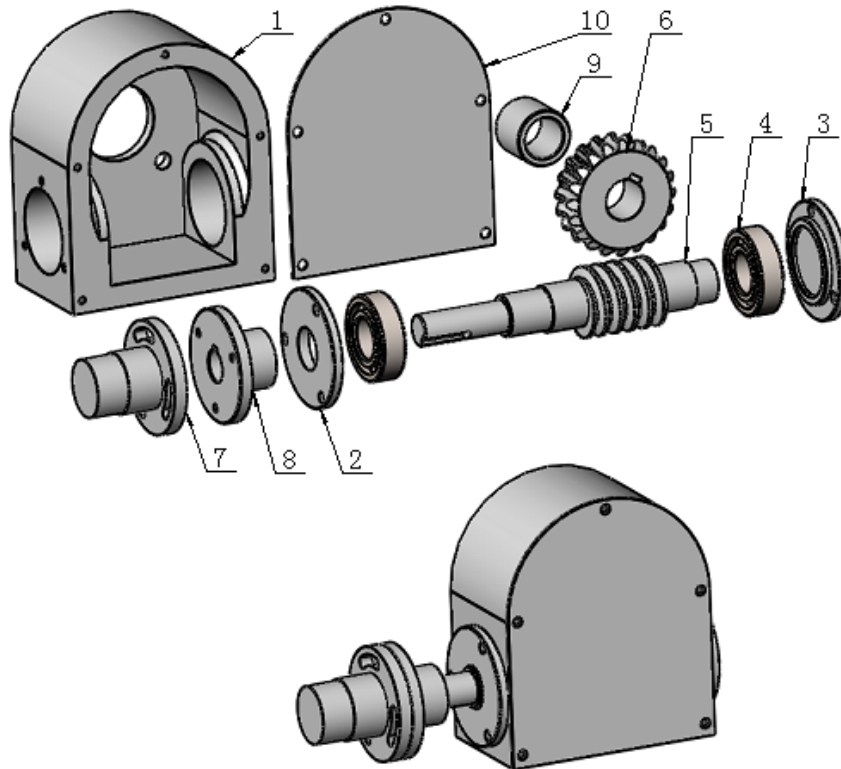


表15 被动调宽涡箱组件明细表

Schedule 15 Passive width adjustment scroll box assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	调宽涡箱 Widening scroll box	1	HT200
2	涡箱透盖 Volute cover	1	A3
3	涡箱闷盖 Volute cover	1	A3
4	深沟球轴承 6205 Deep groove bearing 6205	2	
5	调宽涡杆（短） Adjustable scroll rod (short)	1	45#
6	调宽涡轮 Widening turbine	1	45#
7	50 法兰 B 50 flange B	1	45#
8	50 法兰 A 50 flange A	1	45#
9	调宽隔套 Widening spacer	1	45#
10	调宽涡轮箱盖板 Widened turbine box cover	1	A3

2.12 压梁组件及明细表

2.12 Pressure beam assembly and detailed list

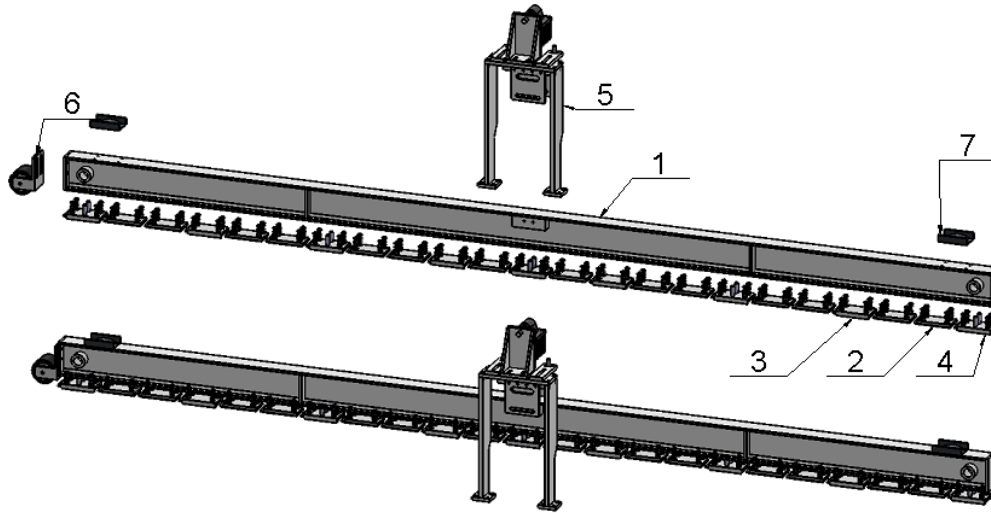


表16 压梁组件明细表

Schedule 16 Pressure beam assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	压梁 Pressure beam	1	
2	不锈钢托槽 Stainless steel bracing channel	2	
3	压梁托板组件 Pressure beam bracing plate assembly	15	
4	压梁托槽组件 (4 孔) Pressure beam bracing channel assembly(4 holes)	4	
5	压梁托槽组件 (6 孔) Pressure beam bracing channel assembly(6 holes)	5	
6	压梁 7 字架组件 Pressure beam "7" shaped frame assembly	2	
7	压梁过渡轮组件 Pressure beam transition wheel assembly	1	

2.12.1 压梁托板组件及明细表

2.12.1 Pressure beam support plate assembly and detailed list

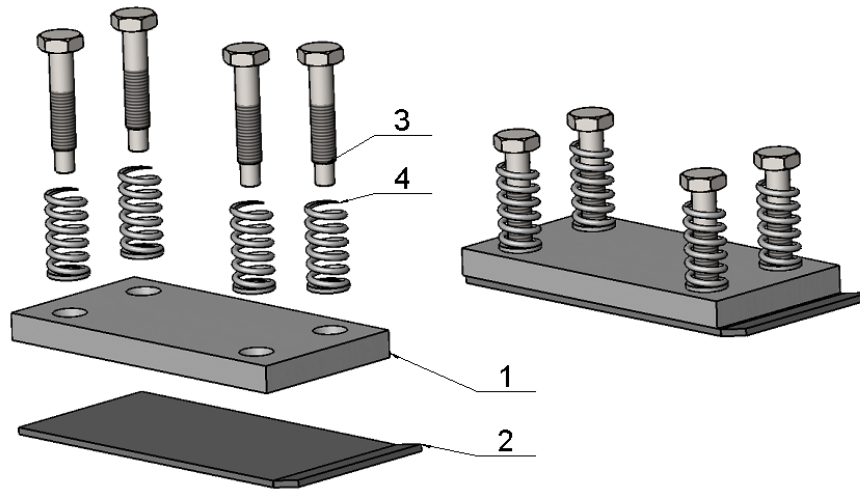


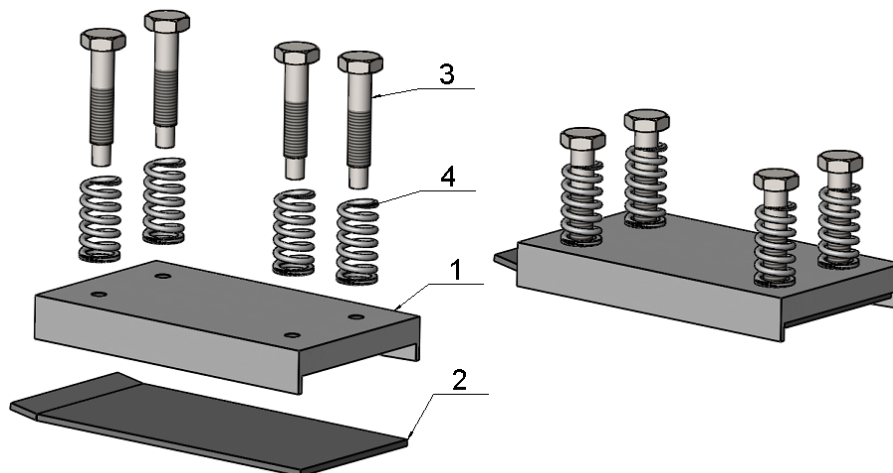
表17 压梁托板组件明细表

Schedule 17 Pressure beam support plate assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	压梁托板 Pressure beam bracing plate	1	A3
2	压梁导槽焊接垫板 Pressure beam guide groove welding backing plate	1	AISI201
3	压梁螺丝 (常) Pressure beam screw (normal)	4	普通碳钢 Ordinary carbon steel
4	压梁弹簧 (常) Pressure beam spring (normal)	4	弹簧钢 Spring steel

2.12.2 压梁托槽组件（4孔）及明细表

2.12.2 Pressure beam support channel(4 holes) assembly and detailed list



表

18 压梁托槽组件（4孔）明细表

Schedule 18 Pressure beam support channel(4 holes) assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	压梁托槽（4孔） Pressure beam bracing channel(4 holes)	1	A3
2	压梁导槽焊接垫板 Pressure beam guide groove welding backing plate	1	AISI201
3	压梁螺丝（常） Pressure beam screw (normal)	4	普通碳钢 Ordinary carbon steel
4	压梁弹簧（常） Pressure beam spring (normal)	4	弹簧钢 Spring steel

2.12.3 压梁托槽组件（6孔）及明细表

2.12.3 Pressure beam support channel(6 holes) assembly and detailed list

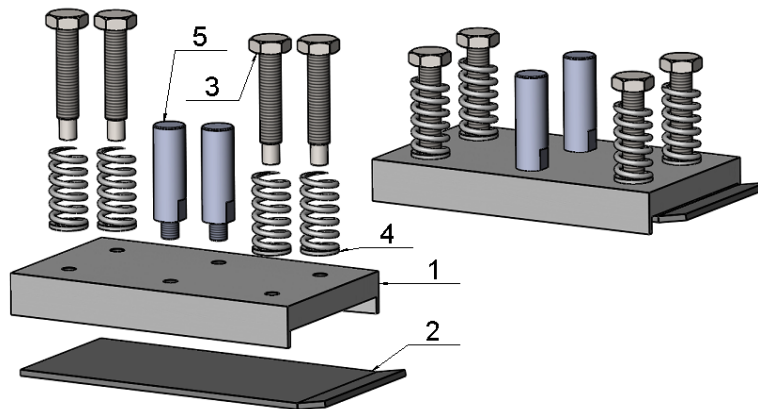


表19 压梁托槽组件（6孔）明细表

Schedule 19 Pressure beam support channel(6 holes) assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	压梁托槽（6孔） Pressure beam bracing channel(6 holes)	1	A3
2	压梁导槽焊接垫板 Pressure beam guide groove welding backing plate	1	AISI201
3	压梁螺丝（常） Pressure beam screw (normal)	4	普通碳钢 Ordinary carbon steel
4	压梁弹簧（常） Pressure beam spring (normal)	4	弹簧钢 Spring steel

5	压梁导柱 Pressure beam guide pillar	2	45#
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2.12.4 压梁 7 字架组件及明细表

2.12.4 Pressure beam "7" shaped frame assembly and detailed list

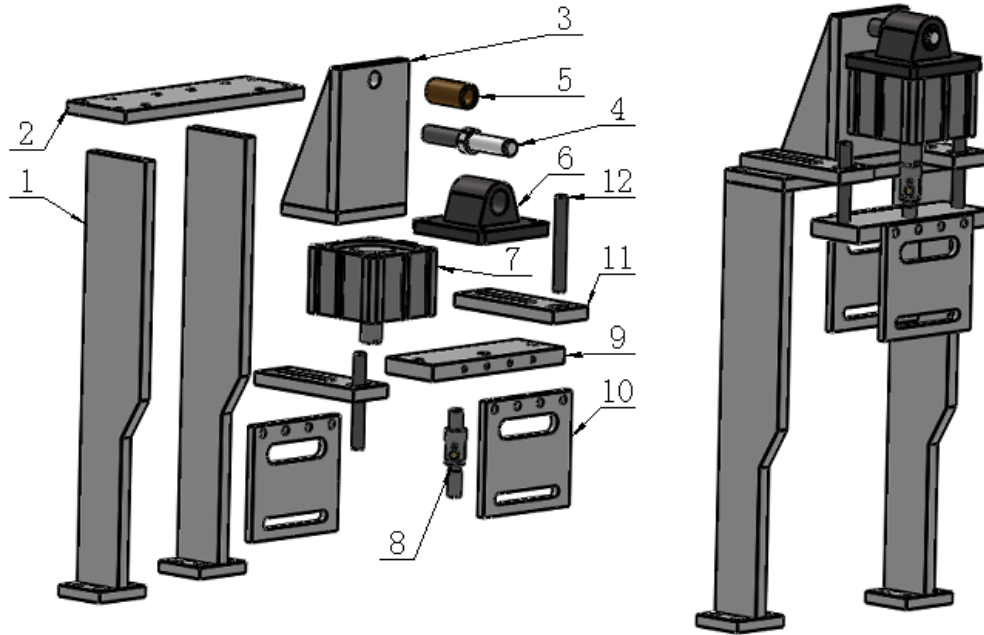


表20 压梁 7 字架组件明细表

Schedule 20 Pressure beam "7" shaped frame assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	干磨 7 字架 Dry squaring "7" shaped frame	2	
2	干磨四方块 Dry grinding rectangle squares	1	
3	气缸支撑座 Cylinder bracing base	1	
4	气缸连接轴 Cylinder connecting shaft	1	
5	气缸连接轴铜套 Cylinder connecting shaft copper cover	1	
6	气缸连接法兰 Cylinder connecting flange	1	
7	压梁气缸 QGY100X30 Pressure beam cylinder QGY100X30	1	
8	气缸活节 Cylinder joint	1	
9	75 带压梁连接座 75 belt pressure beam connecting base	1	
10	压梁连接板 Pressure beam connecting plate	2	
11	压梁限位板 Pressure beam limit plate	2	
12	M14x100 丝杆 M14x100 screw	2	

2.12.5 压梁过渡轮组件及明细表

2.12.5 Pressure beam transition wheel assembly and detailed list

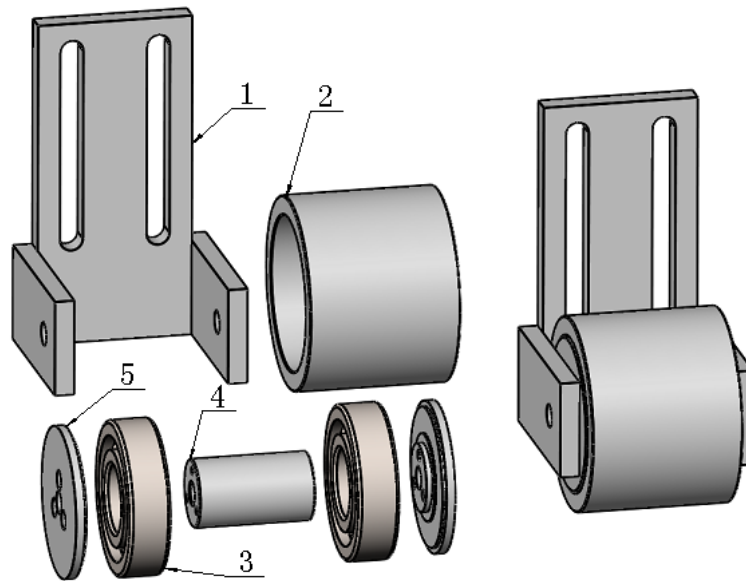


表21 压梁过渡轮组件明细表

Schedule 21 Pressure beam transition wheel assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	压梁过渡轮调节座 Pressure beam transition wheel adjusting base	1	
2	压梁过渡轮 Pressure beam transition wheel	1	
3	深沟球轴承 6307 Deep groove ball bearings 6307	2	
4	压梁过渡轮轴 Pressure beam transition axle	1	
5	定位盖 $\varnothing 80 \times 10$ Positioning cover $\varnothing 80 \times 10$	2	

2.13 压砖轮组件及明细表

2.13 Tile pressure wheel assembly and detailed list

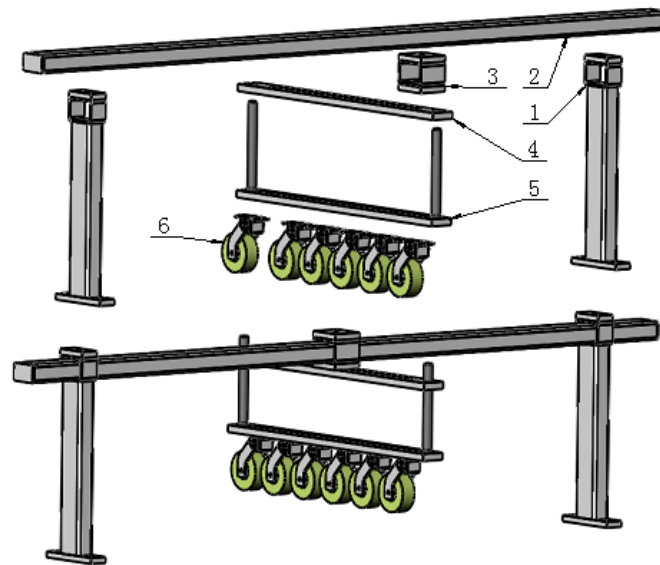


表22 压砖轮组件明细表

Schedule 22 Tile pressure wheel assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	备注 Remark
1	压轮焊接支撑架 Pressure roller welding support frame	2	
2	压轮横梁 Pressure wheel beam	1	
3	活动调节座 Moveable adjusting base	1	
4	前机压轮固定板 Front machine pressure wheel fixing sheet	1	
5	压轮调节板 Pressure wheel adjust sheet	1	
6	压轮 Pressure wheel	6	

2.14 主传动组件及明细表

2.14 Active transition assembly and detailed list

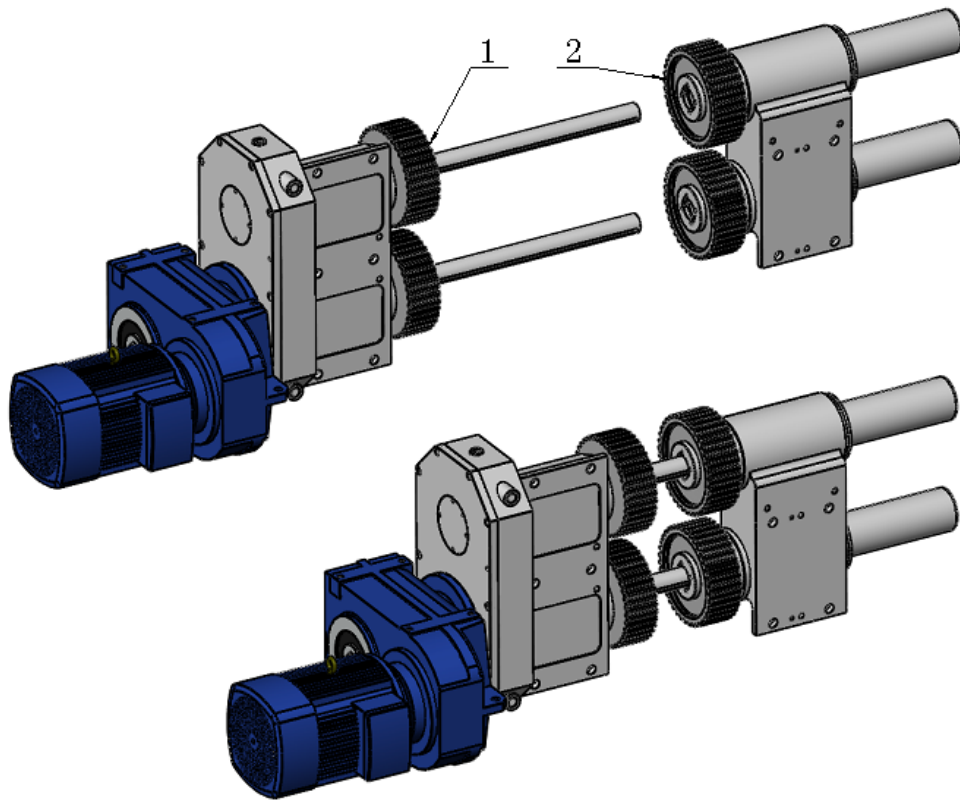


表23 主传动组件明细表

Schedule 23 Active transition assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	齿轮箱总成 Gear box assembly	1	
2	传动支承座总成 Transmission support seat assembly	1	

2.14.1 齿轮箱总成及明细表

2.14.1 Gearbox assembly and detailed list

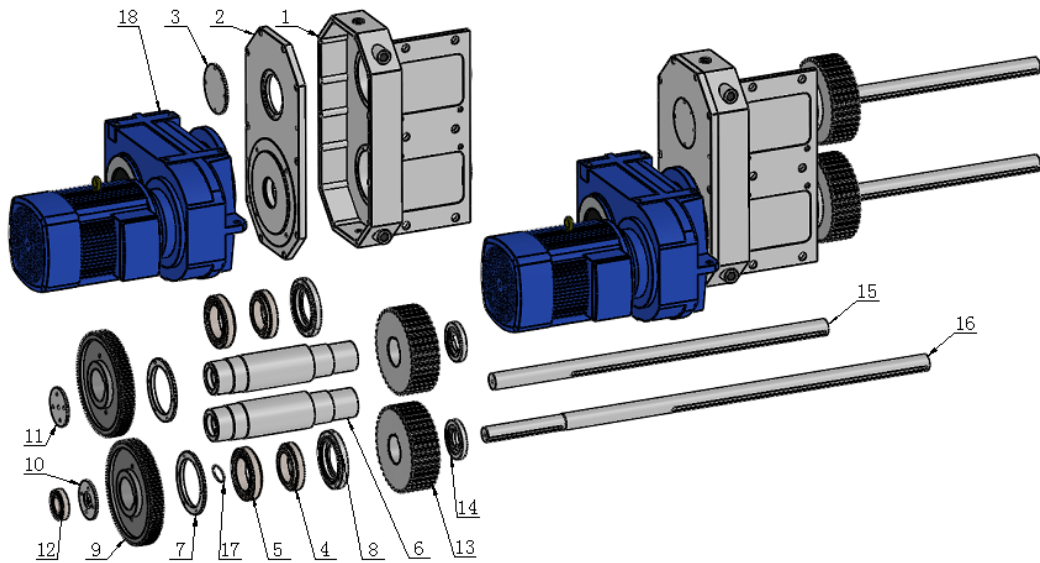


表24 齿轮箱总成明细表

Schedule 24 Gearbox assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	C8 齿轮箱 C8 gearbox	1	
2	C8 齿轮箱盖 C8 gearbox lid	1	
3	齿轮箱盖板 (钢件) gearbox cover sheet	1	
4	圆锥滚子轴承 32017 Tapered roller bearing 32017	2	
5	圆锥滚子轴承 32019 Tapered roller bearing 32019	2	
6	空心轴 428 Hollow shaft 428	2	
7	大轴承端盖 Large bearing end cover	2	
8	小轴承端盖 Small bearing end cover	2	
9	95 齿齿轮 (90 内孔) 95 tooth gear (90 inner hole)	2	
10	主动齿轮端盖 Driving gear end cover	1	
11	被动齿轮端盖 Passive gear end cover	1	
12	深沟球轴承 6209 Deep groove ball bearings 6209	1	
13	75 带 38 齿同步轮 (Ø80) 75 belt 38 tooth synchronous wheel (Ø80)	2	
14	75 带同步轮压盖 75 belt synchronous wheel gland	2	
15	650 主传动被动轴 650 main drive passive shaft	1	
16	650 主传动主动轴 650 main drive active shaft	1	
17	O 型圈 (外 51X3.1) O-ring (outer 51X3.1)	1	
18	主传动减速机 F87 Main drive reducer F87	1	

2.14.2 传动支承座总成及明细表

2.14.2 Transition support base assembly and detailed list

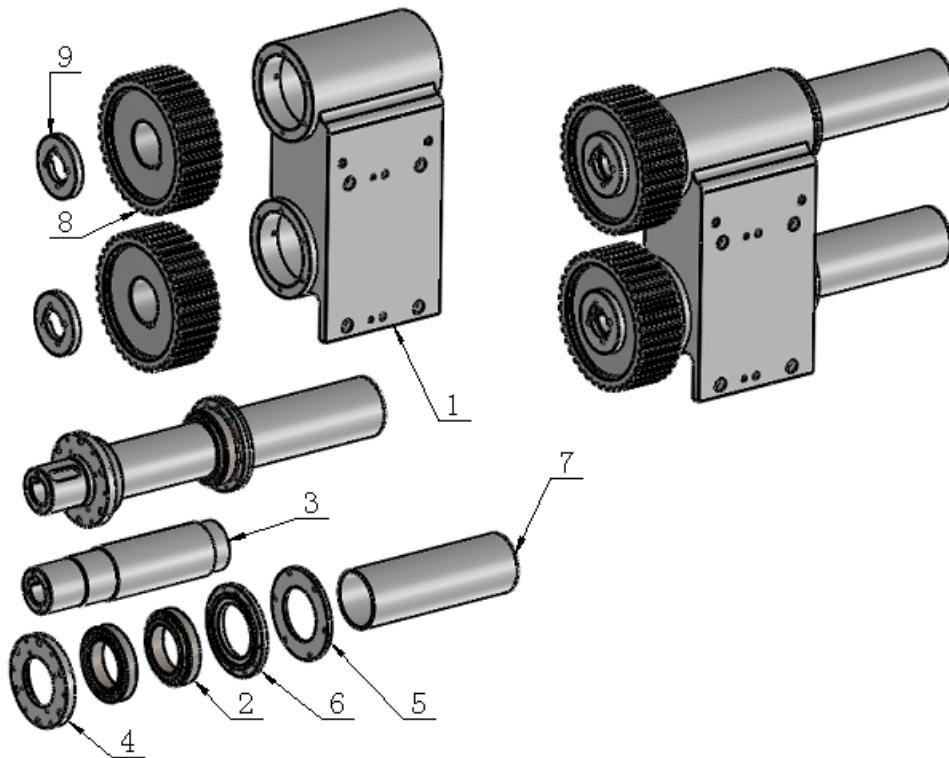


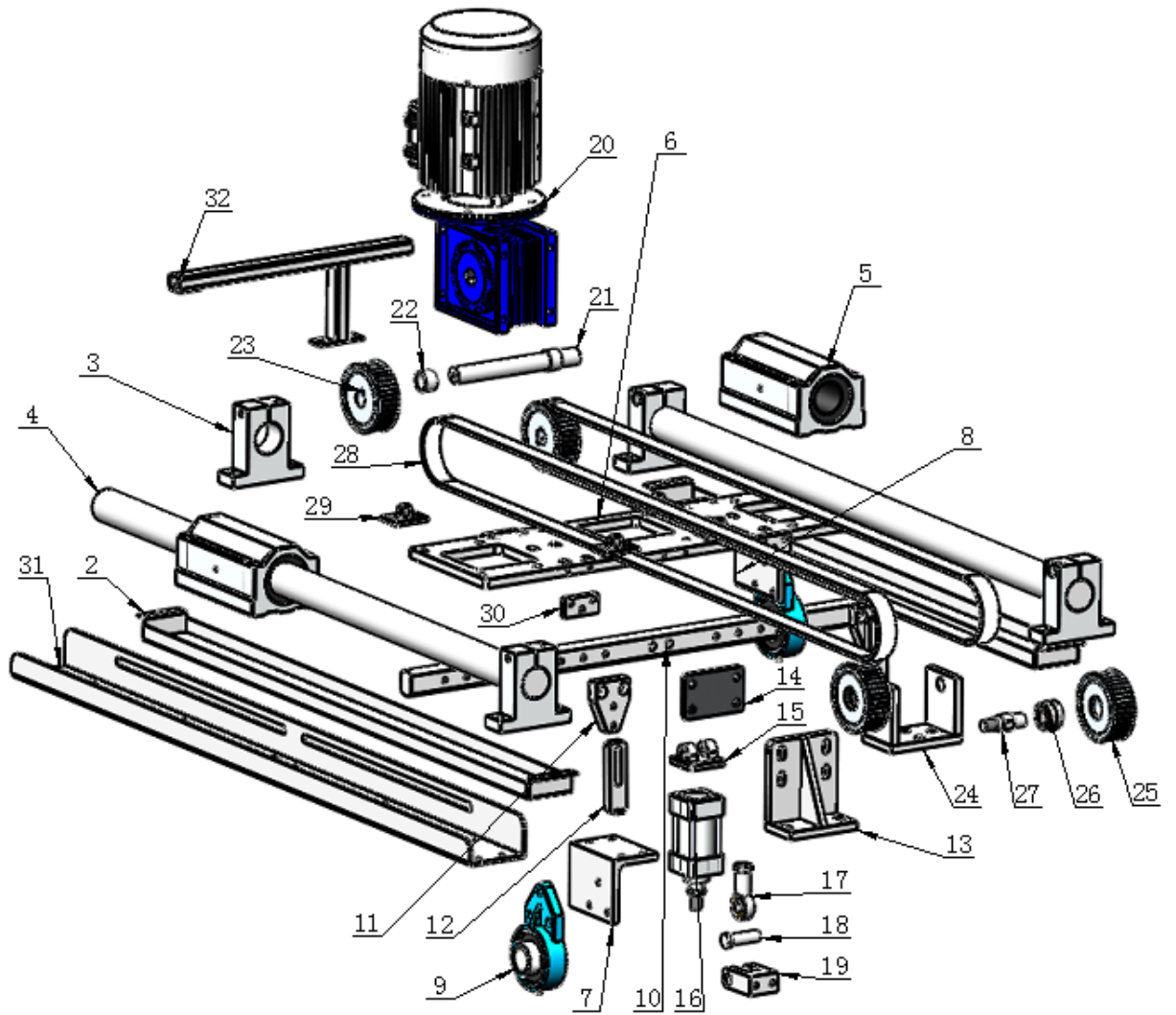
表25 传动支承座总成明细表

Schedule 25 Transition support base assembly detailed list

序号 No.	名称 Component Name	数量 Qty.	材料 Material
1	C8 传动支承座 C8 transmission support seat	1	
2	圆锥滚子轴承 32017 Tapered roller bearing 32017	4	
3	空心轴 374 Hollow shaft 374	2	
4	小轴承端盖 Small bearing end cover	2	
5	新轴套法兰 New sleeve flange	2	
6	650 新轴套 650 new bushing	2	
7	端盖罩 End cap	2	
8	75 带 38 齿同步轮 (Ø80) 75 belt 38 tooth synchronous wheel (Ø80)	2	
9	75 带同步轮压盖 75 belt synchronous wheel gland	2	

2.15 推砖总成及明细表

2.15 Tile push assembly and detailed list



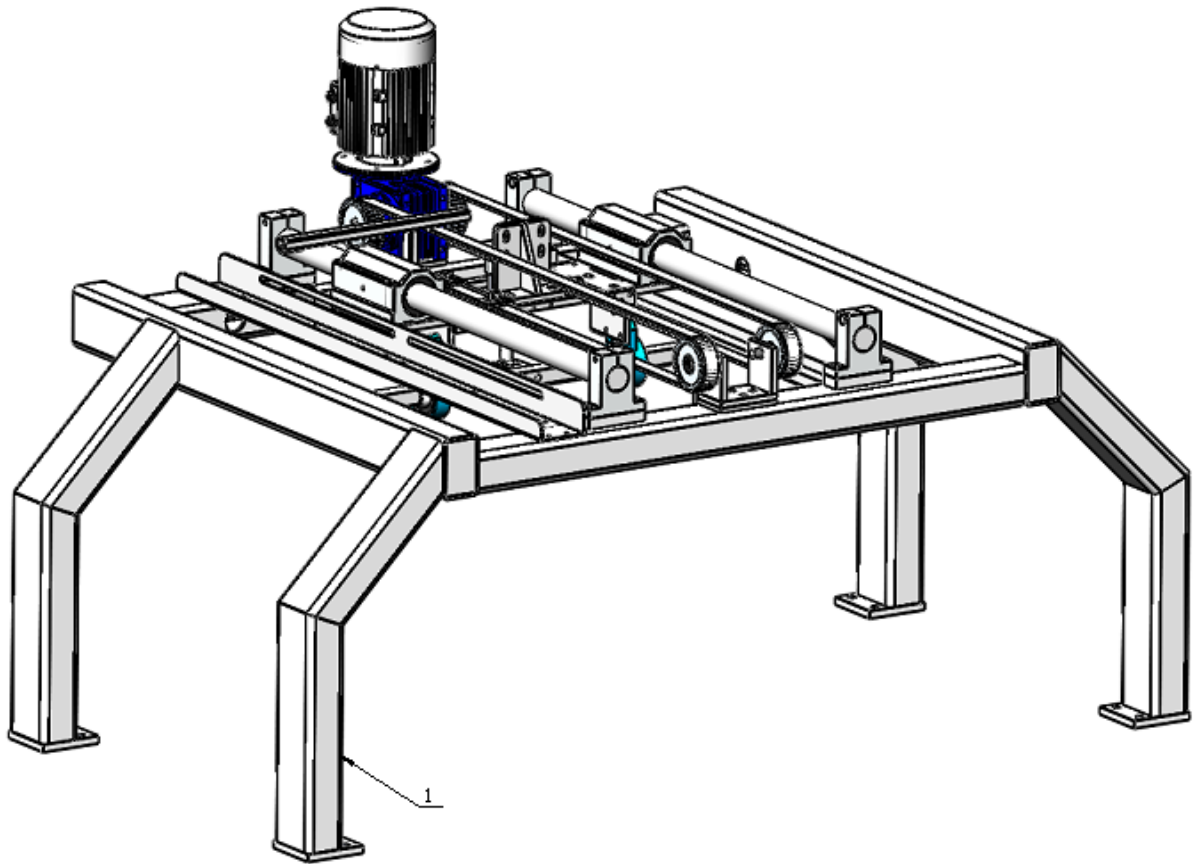


表26 推砖总成明细表

Schedule 26 Tile push assembly detailed list

序号 No	名称 Component Name	数量 Qty	材料 Material
1	1000 型推砖架	1	
2	推砖油槽	2	
3	轴心支撑座 SK50	4	
4	导轴 Ø50x1200	2	
5	直线轴承 SCS50LUU	2	
6	推砖滑板	1	
7	UCFB208 轴承座 (右)	1	
8	UCFB208 轴承座 (左)	1	
9	UCFB 208	2	
10	推砖转轴 2	1	
11	推砖座 2	2	
12	推砖爪 30x15x110	2	
13	推砖气缸座	1	
14	Ø50CBB 单耳座	1	
15	Ø50CB 双悬耳	1	
16	推砖气缸 SC50X25	1	
17	鱼眼接头 M16X1.5 / Ø16	1	

18	滚轮轴	1	
19	连杆	1	
20	电机+方箱 1.1KW-RV63-10-90B5	1	
21	推砖主动轮轴	1	
22	隔套 Ø30xØ25x20	1	
23	主动轮 (M8, 40 齿)	2	
24	同步轮支架 A	1	
25	被动轮 (M8, 40 齿)	2	
26	深沟球轴承 6004	4	
27	推砖被动轮轴	2	
28	同步带 30M8-2624	2	
29	皮带扣	4	
30	推砖微调板	4	
31	推砖电眼支架	1	
32	推砖托架 A	1	

注：配件手册型号仅供参考，具体型号以实际机型为准！

Note: The model of the accessory manual is for reference only, and the specific model is subject to the actual model!