

配件手册

Accessories Manual

——双压带湿式磨边机

Double Belt Water 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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第1章 概述 I Summary

1.1 性能参数 Performance parameter

项目 Facility	参数 Parameter
	双压带干式磨边机 Double pressure belt wet squaring machine
电源电压 mains voltage	380 V / 50 Hz
装机功率 power	110.25 kW
气源压力 air supply pressure	≥0.6 MPa
平均耗气量 average air consumption	12 L/min
总耗水量 gross water consumption	560 L/min
外形尺寸 size	6710(Length) x 2900(Width) x 2200(Height)

1.2 设备概述 1.2 Facility summary

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。

Description: auto squaring & chamfering line is necessary for wall tile/floor tile
processing. It's mainly use for grinding and chamfering wall/floor tile edge, it can also
eliminate the shrinkage of floor/wall tile with high efficiency. What's more, our equipment
also can be used for grinding marble stone, kindly note that working width can be adjust
from 200 to 1200mm. Maximum thickness is 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。

Structure description: grinding line: 1 brick rack, 2 grinding machine(front machine) 3 switching rack, 4 grinding machine(rear machine), 5 out brick rack. Grinding machine (front machine basically involve transmission part, centering part, molding part, squaring & chamfering part and width adjustment part. Rear machine is same as front machine but tile pushing part is added for rear squaring machine.

1.3 使用机器的注意事项 Operation notes

- ①、保证正常的电源电压
- ②、供气压不能低于额定气压
- ③、机器不使用时请关掉电源
- ④、按照说明书定期保养设备
- ⑤、勿随意更换或拆卸机器上的零件
- ⑥、机器工作请勿站在机器工作范围内以免被弄伤

- ①Please ensure the power is smooth
- ②Working air pressure should not be lower than limited
- ③Please turn off the power when not to use machine
- ④Regular maintenance of equipment according to the manual
- ⑤ Please do not change or remove the machine parts
- ⑥ Please do not stand in the machine working scope when machine is working

第2章 组件图及明细表

II Pictures of components & details

2.1 磨头组件及明细表 Grinding head components & details

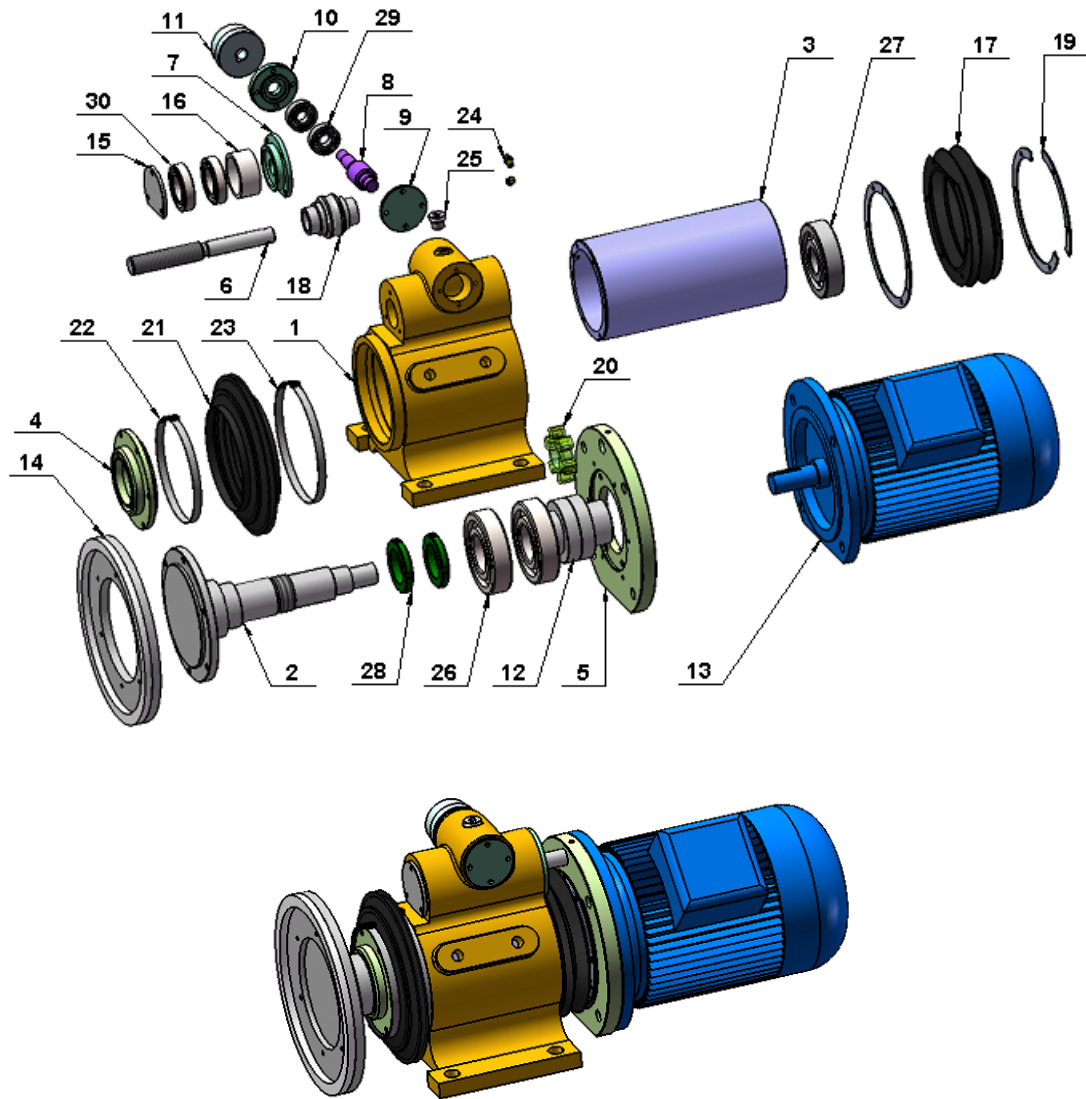


表1 磨头组件明细表

No.	Code	Components	Qty	Material
1		356B 磨头座 (水磨磨头座) 356B Grinding base (wet grinding)	1	HT200
2		356 磨头轴 (水磨磨头轴) 356 grinding axis (wet grinding axis)	1	45#
3		356 支撑套 (水磨支撑套筒) 356 support sleeve (support sleeve for wet grinding)	1	45#
4		356 透盖 (水磨透盖)	1	45#

		356 penetrable cover (for wet grinding)		
5		356 连接法兰 (水磨连接法兰) 356 connection flange (for wet grinding)	1	45#
6		356 调节螺杆 (水磨调节螺杆) 356 adjusting screw stem (for wet grinding)	1	45#
7		端盖 04 (水磨) Cover 04 (for wet grinding)	1	45#
8		356 调节蜗杆 (水磨调节蜗杆) 356 adjusting turbo pole (for wet grinding)	1	45#
9		端盖 01 (水磨) Cover 01 (for wet grinding)	1	45#
10		端盖 02 (水磨) Cover 02 (for wet grinding)	1	45#
11		356 手轮 (水磨手轮) 356 hand wheel (for wet grinding)	1	45#
12		356B 联轴器 (水磨联轴器) 356B shaft coupling (for wet grinding)	1	
13		电机 (水磨) motor (for wet grinding)	1	
14		磨轮 (水磨) squaring wheel (for wet grinding)	1	
15		端盖 03 (水磨) cover 03 (for wet grinding)	1	45#
16		356B 隔套 (水磨隔套) 356B spacer (for wet grinding)	1	45#
17		356B 后防水胶套 (水磨后防水胶套) 356B rear waterproof rubber sleeve (for wet grinding)	1	rubber
18		356 调节蜗轮 (水磨调节蜗轮) 356 control cochlear wheel (for wet grinding)	1	45#
19		356 防尘罩压板 (水磨防尘罩压板) 356 pressing plate for dust cap (for wet grinding)	6	A3
20		356 联轴节 75 (水磨六角胶) 356 coupler 75 (wet grinding six corner glue)	1	rubber
21		356B 前防水胶套 (水磨前防水胶套) 356B forth waterproof rubber sleeve (for wet grinding)	1	rubber
22		喉箍 (118-140) clamp (118-140)	1	
23		喉箍 (143-165) clamp (143-165)	1	
24		油嘴 oil nozzle	2	
25		透气塞 (M16) porous plug	1	
26		深沟球轴承 6310 deep groove ball bearing 6310	2	
27		深沟球轴承 6407 deep groove ball bearing 6407	1	
28		圆螺母 M48X1.5 round nut M48×1.5	2	
29		深沟球轴承 6203 deep groove ball bearing 6203	2	
30		深沟球轴承 6007 deep groove ball bearing 6007	2	

2.2 上倒角 379 组件及明细表

Upper chamfering 379 components & details



表2 上倒角组件明细表

Sheet 2 Upper chamfering 379 components & details

No.	Components	Specification	Qty	Note
1	调节管 adjusting pipe		1	
2	张紧块 tensioning block		1	
3	主动轴 active axis		1	
4	夹套 sleeve		1	
5	连接轴 connection axis		1	
6	电机法兰 motor flange		1	
7	轴承隔套 bearing spacer sleeve		1	
8	379 盖板 379 covering plate		1	
9	翻板总成 plate assembly		1	
10	固定套（铝）fixing sleeve (aluminum)		1	
11	旋转套（铝）rotation sleeve (aluminum)		1	
12	夹套（铝）sleeve (aluminum)		1	
13	379 倒角气缸 379 chamfering cylinder		1	
14	气缸螺母 cylinder nut		1	
15	倒角支座 chamfering base		1	
16	支撑套 support sleeve		1	
17	轴承 bearing	6009	1	
18	轴承 bearing	6207	1	
19	内卡 inner block	Ø75	1	
20	骨架密封 framework seal	80X100X10	1	
21	内六角螺丝 inner hexagon screw	M4X10	12	

22	圆螺母 round nut	M16X1.5	1	
23	圆螺母 round nut	M35X1.5	2	
24	平键 flat key	10X8X90	2	

2.3 上活动轮组件及明细表 Upper running wheel components & details

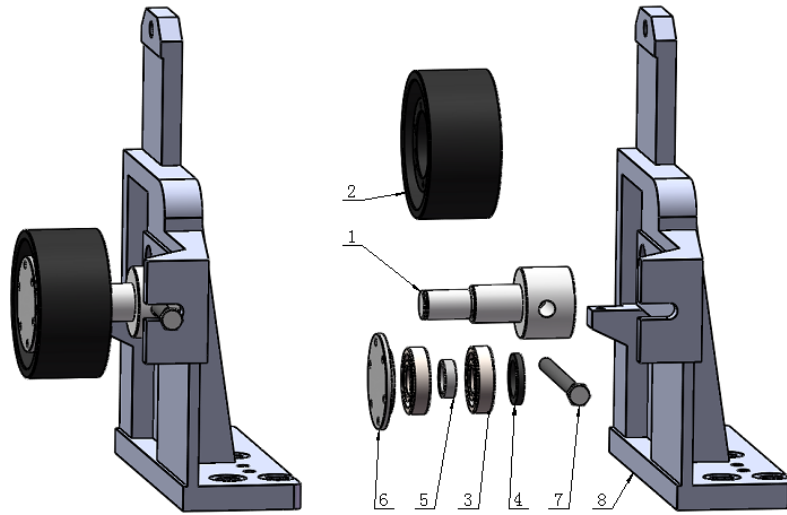


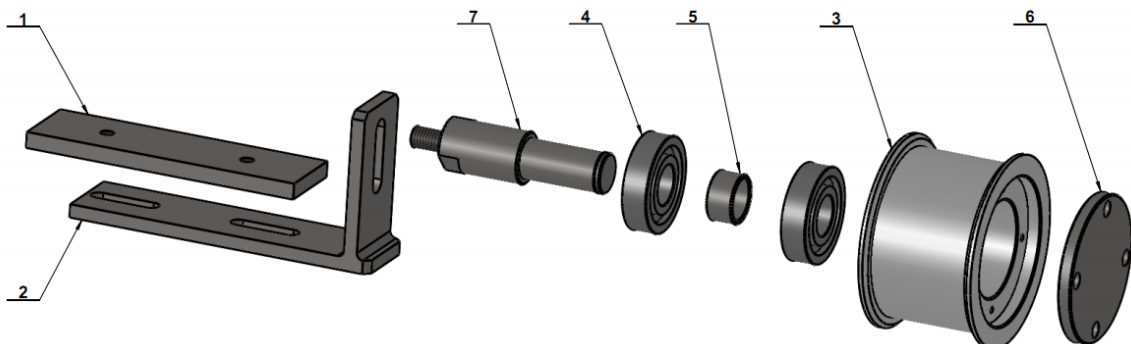
表3 上活动轮组件明细表

Sheet 3 Upper running wheel component & details

No.	Component	Specification	Qty	Material
1	75 带上活动轮轴 75 belt upper running wheel axis		1	45#
2	75 带活动轮 75 belt running wheel		1	HT200
3	深沟球轴承 deep groove ball bearing	6307	2	
4	油封 oil seal	Φ45	1	
5	活动轮隔圈 running wheel ring spacer		1	45#
6	活动轮端盖 running wheel cover		1	Q235A
7	调节螺丝 adjusting screw	M16x200	1	
8	前支承板 (右) forth supporting plate		1	HT200

2.4 皮带托轮组件及明细表

Belt roller components & details



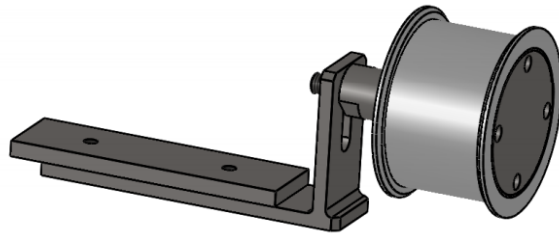
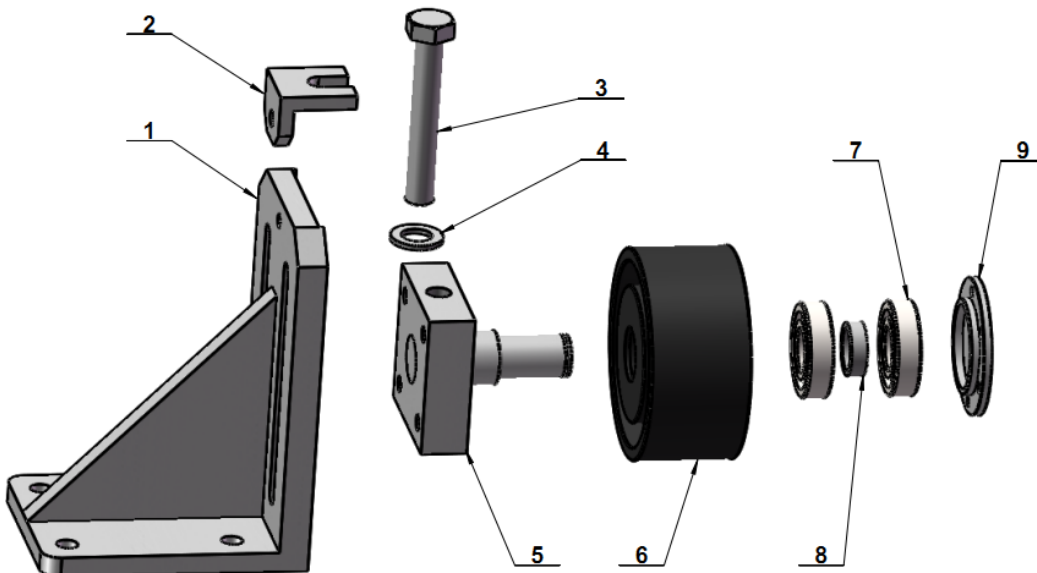


表4 皮带托轮组件明细表
Sheet 4 Belt roller component & details

No.	Component	Qty	Material
1	焊接底板 welding base	1	A3
2	调节支架 adjusting bracket	1	A3
3	150 带皮带托轮 150 belt pvc belt roller	1	HT200
4	深沟球轴承 6306 deep groove ball bearing 6306	2	
5	托轮隔圈 roller ring spacer	1	45#
6	托轮端盖 roller cover	1	HT200
7	托轮轴 roller axis	1	45#

2.5 下活动轮组件及明细表

Lower running wheel components & details



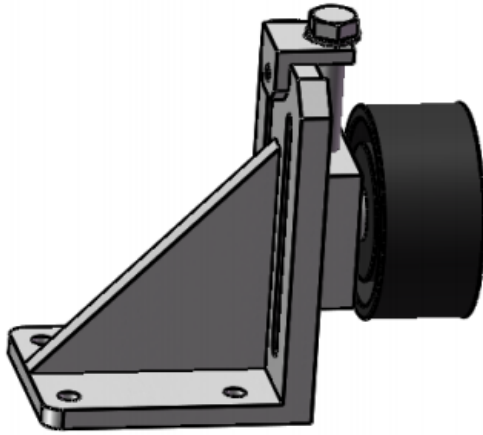


表5 下活动轮组件明细表
Sheet 5 Lower running wheel component & details

No.	Component	Qty	Material
1	大梁被动轮底座 Girder passive wheel base	1	HT200
2	调节支架 adjusting bracket	1	A3
3	六角螺栓 M24X150 hexagon screw M24×150	1	
4	平垫 Φ24 flat washer Φ24	1	
5	150 带下活动轮轴 150 belt lower running wheel axis	1	45#
6	150 带活动轮 150 belt running wheel	1	HT200
7	深沟球轴承 6307 deep groove ball bearing 6307	2	
8	活动轮隔圈 running wheel ring spacer	1	45#
9	活动轮端盖 running wheel cover	1	HT200

2.6 转臂组件及明细表 Swivel arm components & details

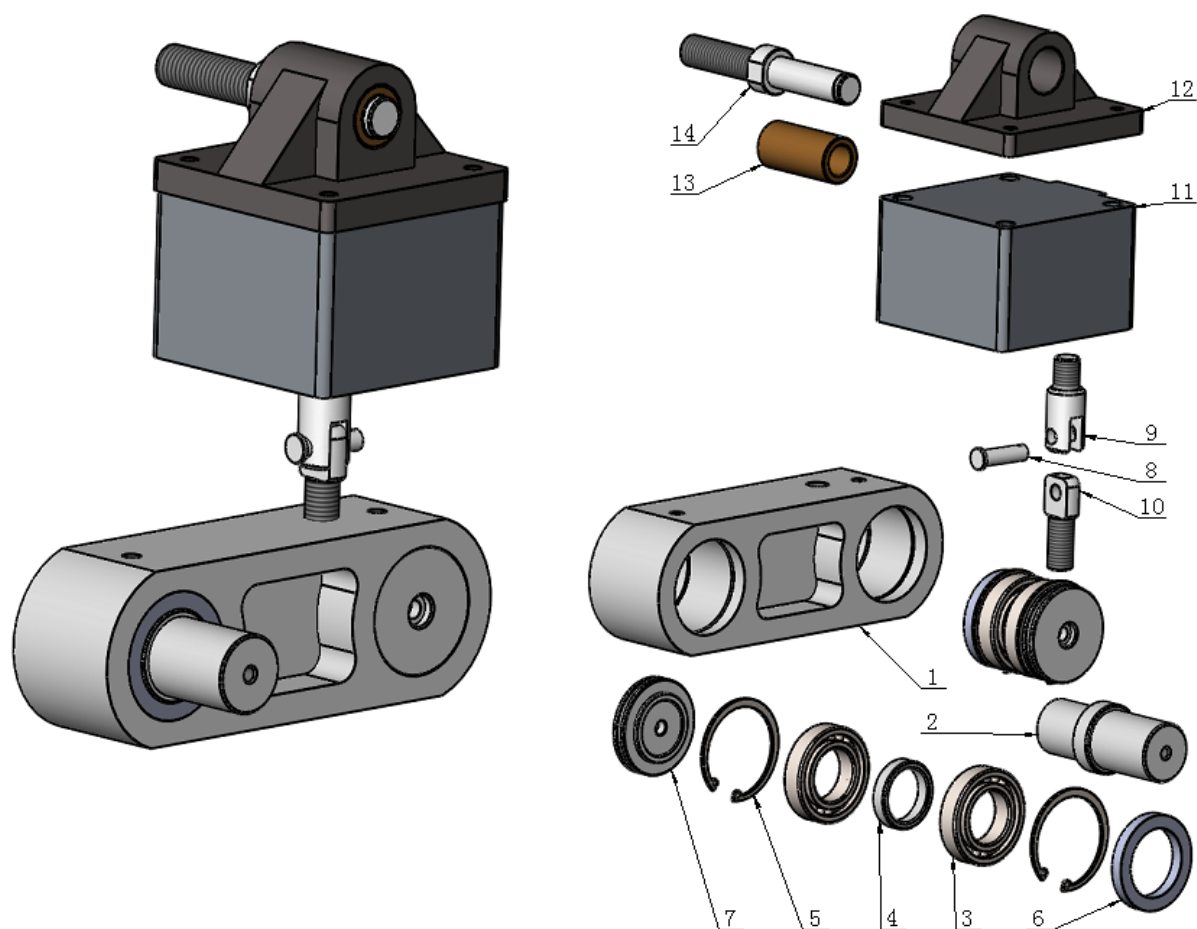


表6 转臂组件明细表

Sheet 6 Swivel arm components & details

No.	Component	Specification	Qty	Material
1	水磨机转臂(右) swivel arm of wet squaring machine (right)		1	HT200
2	水磨转臂短轴 swivel arm short axis of wet squaring machine		1	45#
3	深沟球轴承 deep groove ball bearing	6007	4	
4	转臂隔套 swivel arm spacer sleeve		2	45#
5	内卡簧 inner clamp spring	$\phi 62$	4	
6	骨架密封 framework seal	45X62X8	2	
7	转臂轴盖板 swivel arm axis cover		2	Q235A
8	转臂气缸连接销 swivel arm cylinder link pin		1	45#
9	转臂气缸上接头 swivel arm cylinder upper connector		1	45#
10	转臂气缸下接头 Swivel arm cylinder lower connector		1	45#
11	气缸 cylinder	QGY100X30	1	
12	气缸连接法兰 cylinder connection flange		1	HT200

13	气缸连接轴铜套 cylinder connection axis brass sleeve		1	brass
14	气缸连接轴 cylinder connection axis		1	45#

2.7 对中组件（1000 型 400 对中）及明细表

Middle components (1000 type 400 middle) & details

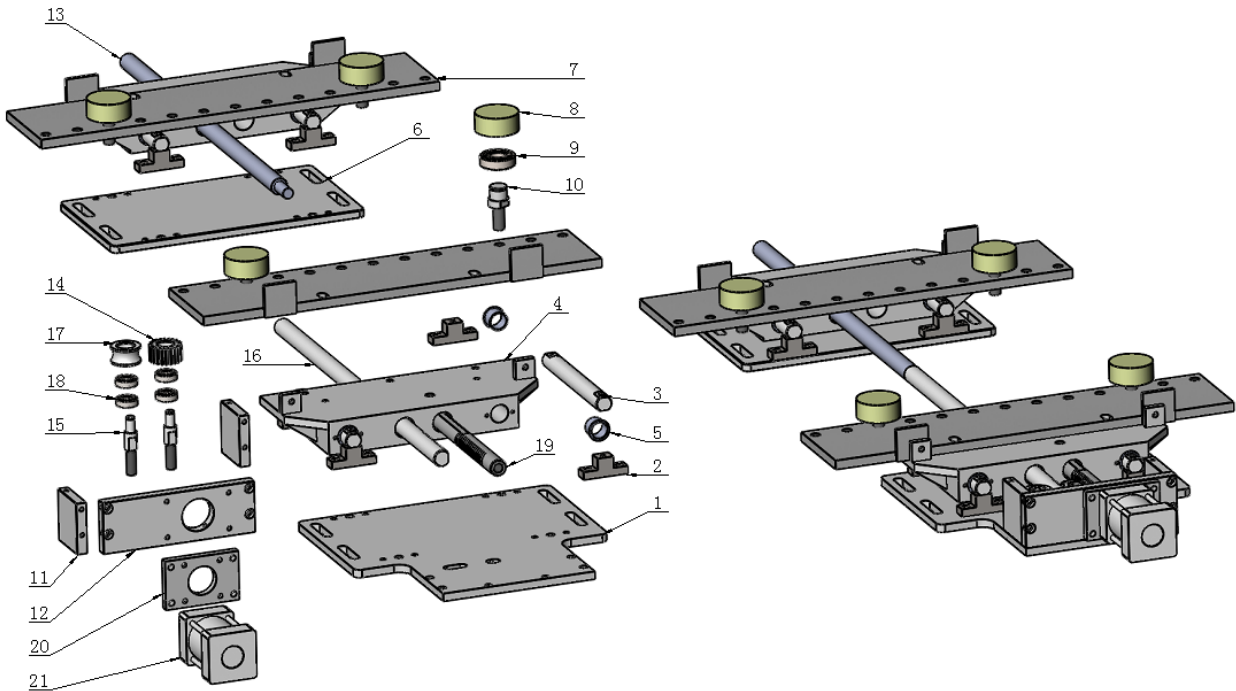


表7 对中组件（1000 型 400 对中）明细表

Sheet 7 Middle components (1000 type 400 middle) & details

No.	Component	Specification	Qty	Material
1	400 对中机构固定板 A 400 middle component fixing board A		1	Q235A
2	对中导轴固定块 2.0 middle guide axis fixing block 2.0		8	Q235A
3	400 对中导轴 400 middle guide axis		4	45#
4	400 对中活块 400 middle moveable block		2	HT200
5	对中 igus 轴承 middle igus bearing		8	
6	400 对中机构固定板 400 middle component fixing board		1	Q235A
7	400 对中板 400 middle board		2	Q235A
8	对中胶轮 middle plastic wheel		4	聚氨酯 Polyurethane
9	深沟球轴承 deep groove ball bearing	6205zz	4	
10	对中胶轮轴 middle plastic wheel axis		4	45#
11	气缸固定板 A cylinder fixing board A		2	Q235A
12	气缸固定板 B cylinder fixing board B		1	Q235A
13	1000 型连接轴 1000 type connection axis		1	45#
14	摆动齿轮（对中） Oscillating gear shaft		1	45#

15	摆动齿轮轴（对中） Oscillating gear shaft (middle)		2	45#
16	被动齿条轴（对中） passive rack shaft(middle)		1	45#
17	压紧轮（对中） pressing wheel (middle)		1	45#
18	深沟球轴承 deep groove ball bearing	6201	4	
19	主动齿条轴（对中） active rack shaft(middle)		1	45#
20	对中气缸连接板 middle cylinder connection board		1	Q235A
21	对中气缸 middle cylinder	SC63x25	1	

2.8 调宽组件及明细表

Width control components & details

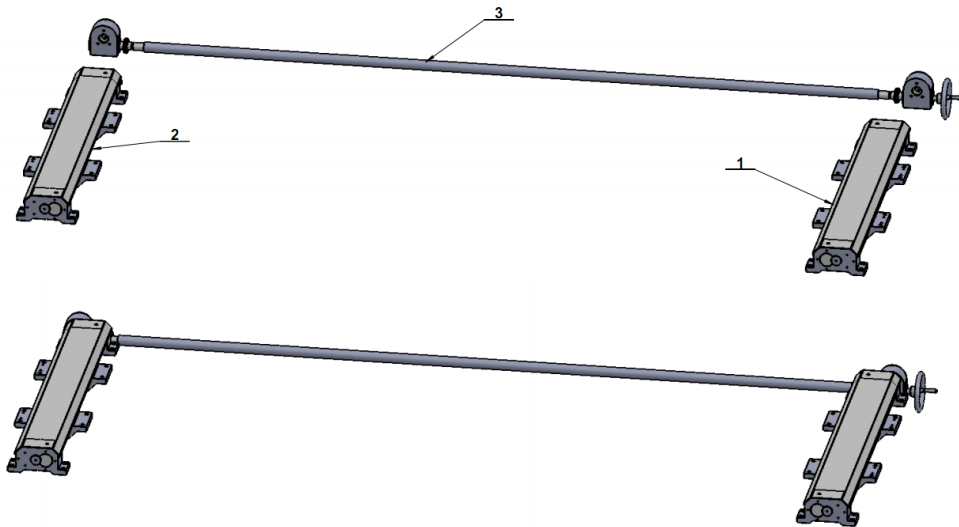


表8 调宽组件明细表

Sheet 8 Width control components & details

No	Component	Qty	Material
1	主动调宽座组件 active width control base	1	
2	被动调宽座组件 passive width control base	1	
3	主动调宽蜗箱组件 active width control cochlear box	1	
4	被动调宽蜗箱组件 passive width control cochlear box	1	
5	调宽连接杆 width control connection pile	1	45#

2.8.1 主动调宽座组件及明细表

Active width control components & details

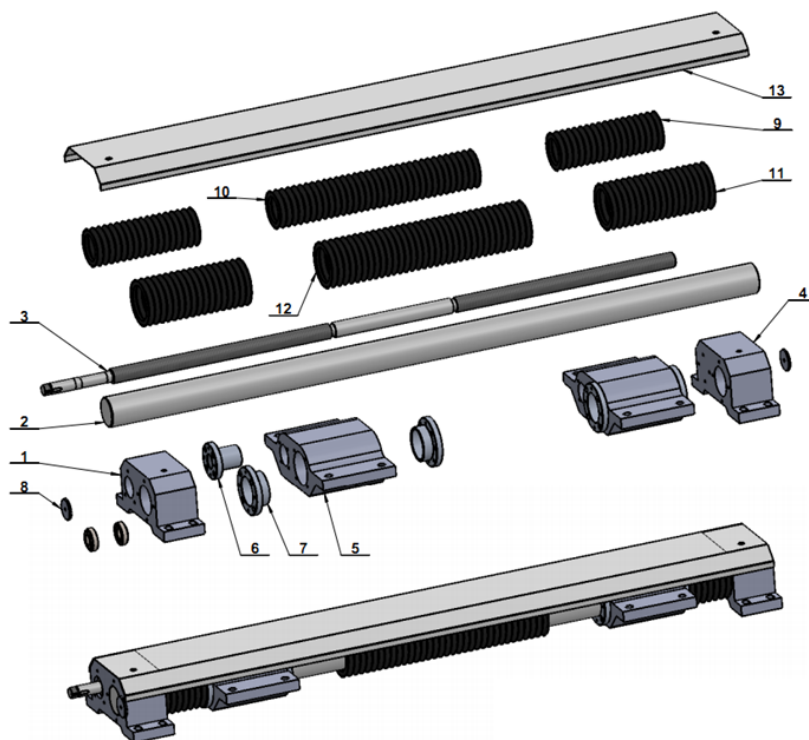


表9 主动调宽座组件明细表

No.	Component	Qty	Material
1	双孔固定座 double holes fixing base	1	HT200
2	1000 型大梁调宽滑轴 1000 type girder width control sliding axis	1	45#
3	1000 型大梁调宽丝杆 1000 type girder width control screw	1	45#
4	单孔固定座 single hole fixing base	1	HT200
5	调宽滑动座 width control sliding base	2	HT200
6	调宽铜螺母 width control brass nut	2	5A02
7	调宽滑套 width control sliding sleeve	4	45#
8	磨边机主动垫片 squaring machine washer	2	
9	防尘罩 (Φ120x16 格) anti dust cover(Φ120x16 lattice)	2	rubber
10	防尘罩 (Φ120x32 格) anti dust cover(Φ120x32 lattice)	1	rubber
11	防尘罩 (Φ150x16 格) anti dust cover(Φ150x16 lattice)	2	rubber
12	防尘罩 (Φ150x32 格) anti dust cover(Φ150x32 lattice)	1	rubber
13	1000 型调宽防尘板 1000 type width control anti dust board	1	A3
14	圆锥滚子轴承 30205 tapered roller bearing 30205	2	

2.8.2 被动调宽座组件及明细表

Passive width control components & details

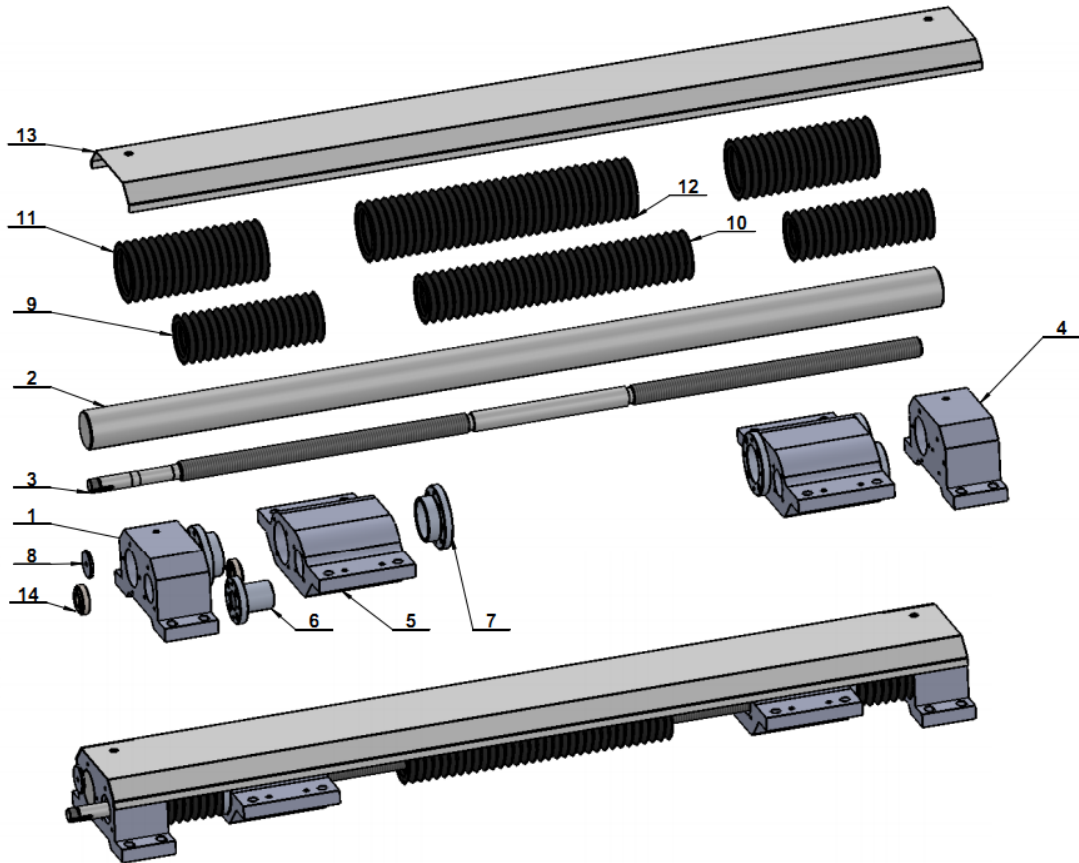


表10 被动调宽座组件明细表

Sheet 10 Passive width control components & details

No.	Component	Qty	Material
1	双孔固定座 double holes fixing base	1	HT200
2	1000 型大梁调宽滑轴 1000 type girder width control sliding axis	1	45#
3	1000 型大梁调宽丝杆 1000 type girder width control screw	1	45#
4	单孔固定座 single hole fixing base	1	HT200
5	调宽滑动座 width control sliding base	2	HT200
6	调宽铜螺母 width control brass nut	2	5A02
7	调宽滑套 width control sliding sleeve	4	45#
8	磨边机主动垫片 squaring machine washer	2	
9	防尘罩 (Φ120x16 格) anti dust cover(Φ120x16 lattice)	2	Rubber
10	防尘罩 (Φ120x32 格) anti dust cover(Φ120x32 lattice)	1	Rubber
11	防尘罩 (Φ150x16 格) anti dust cover(Φ150x16 lattice)	2	Rubber
12	防尘罩 (Φ150x32 格) anti dust cover(Φ150x32 lattice)	1	Rubber
13	1000 型调宽防尘板 1000 type width control anti dust board	1	A3

14	圆锥滚子轴承 30205 tapered roller bearing 30205	2	
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2.8.3 主动调宽蜗箱组件及明细表

Active width control cochlear box components & details

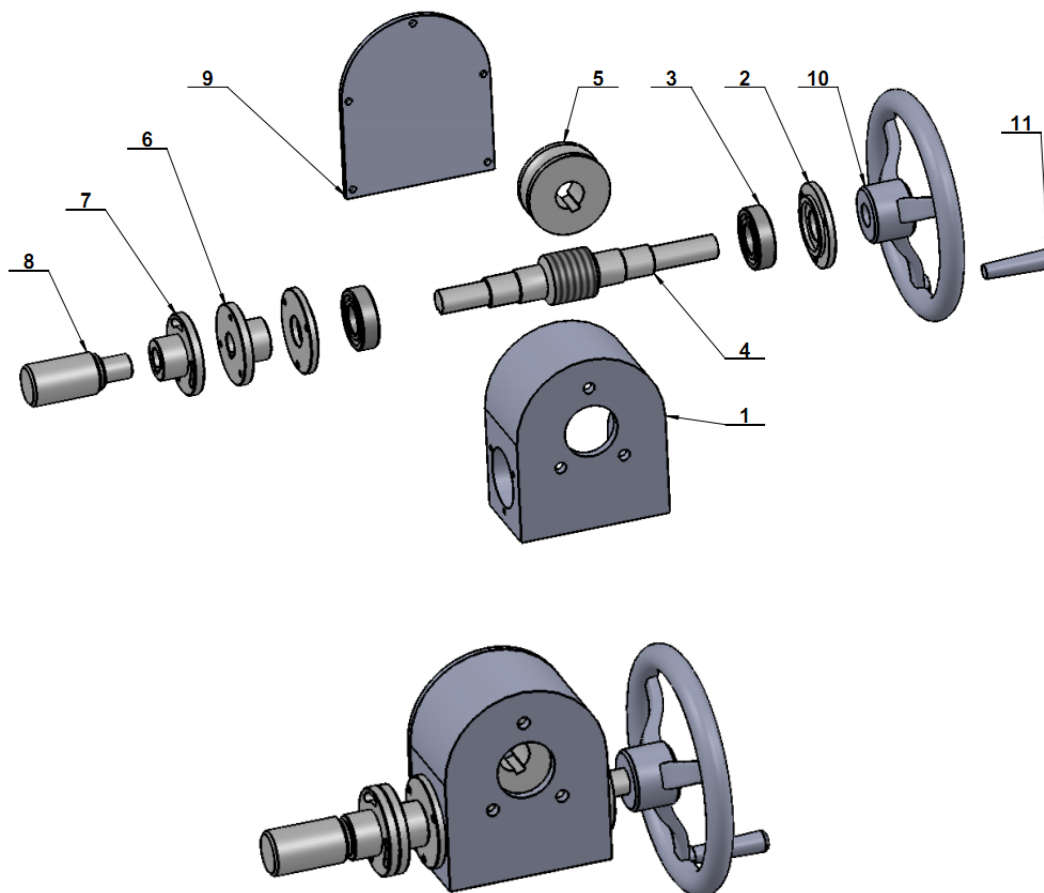


表11 主动调宽蜗箱组件明细表

Sheet 11 Active width control cochlear box components & details

No.	Component	Qty	Material
1	调宽蜗箱 width control cochlear box	1	HT200
2	蜗箱透盖 cochlear box penetrable cover	2	
3	深沟球轴承 6205 deep groove ball bearing 6205	2	
4	调宽蜗杆 (长) width control turbo pole (long)	1	45#
5	调宽蜗轮 width control turbo wheel	1	
6	50 法兰 B 50 flange B	1	45#
7	50 法兰 A 50 flange A	1	45#
8	连接轴头 L=50 connection axis head L= 50	1	45#
9	调宽蜗轮箱盖板 width control cochlear box cover	1	A3
10	调宽 $\phi 200$ 手轮 width control $\phi 200$ hand wheel	1	HT150

11	调宽手轮手柄 width control hand wheel shaft	1	HT150
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2.8.4 被动调宽蜗箱组件及明细表

Passive width control cochlear box components & details

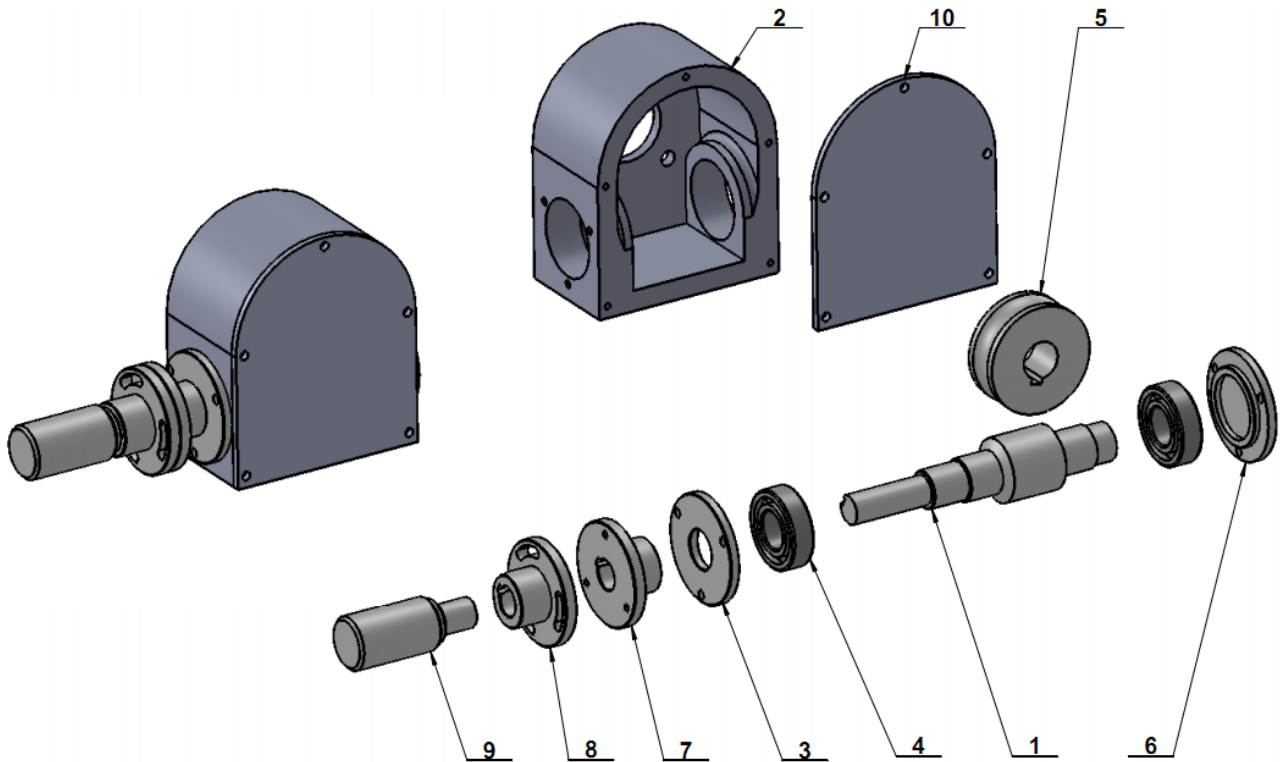


表12 被动调宽蜗箱组件明细表

Sheet 12 Passive width control cochlear box components & details

No.	Component	Qty	Material
1	调宽蜗杆（短） width control turbo pole (short)	1	45#
2	调宽蜗箱 width control cochlear box	1	HT200
3	蜗箱透盖 cochlear box penetrable cover	1	
4	深沟球轴承 6205 deep groove ball bearing	2	
5	调宽蜗轮 width control turbo wheel	1	
6	蜗箱闷盖 cochlear box cover (non-penetrable)	1	
7	50 法兰 B 50 flange B	1	45#
8	50 法兰 A 50 flange A	1	45#

9	连接轴头 L=50 connection axis head L= 50	1	45#
10	调宽涡轮箱盖板 width control cochlear box cover	1	A3

2.9 压梁组件及明细表

Pressure beam components & details

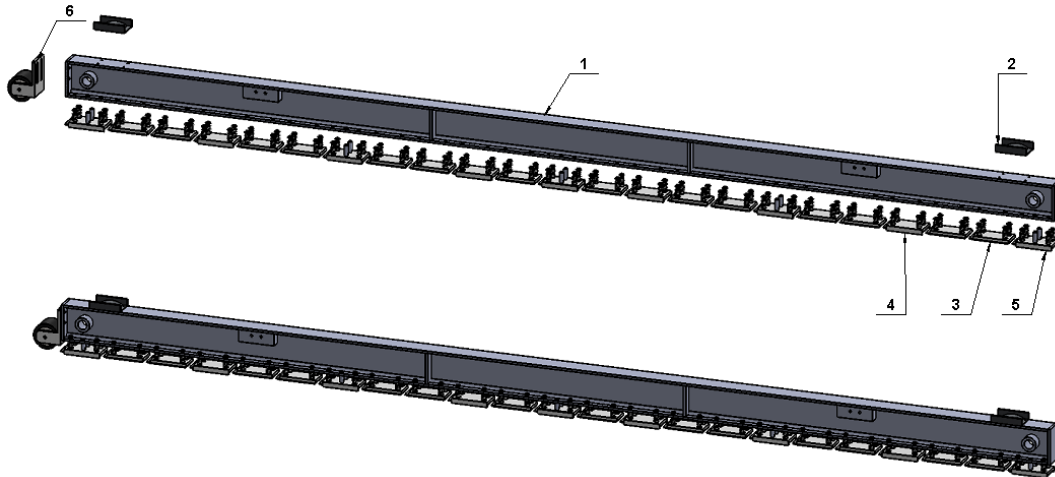


表13 压梁组件明细表

Sheet 13 Pressure beam components & details

No.	Component	Qty	Material
1	压梁 pressure beam	1	
2	不锈钢托槽 stainless steel tray	2	
3	压梁托板组件 pressure beam support board component	7	
4	压梁托槽组件 (4 孔) pressure beam tray component (4 holes)	3	
5	压梁托槽组件 (6 孔) pressure beam tray component (6 holes)	6	
6	压梁过渡轮组件 pressure transition wheel component	1	

2.9.1 压梁托板槽组件及明细表

Pressure beam tray component & details

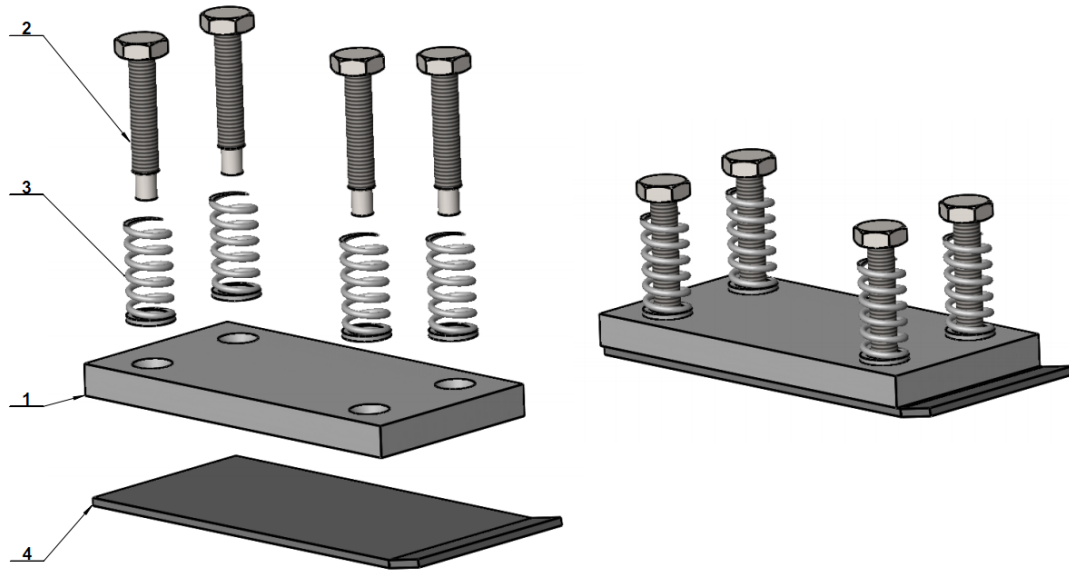


表14 压梁托板槽组件明细表

Sheet 14 Pressure beam tray component & details

No.	Component	Qty	Material
1	压梁托板 pressure beam support board	1	A3
2	压梁螺丝（常） pressure beam screw (general)	4	Common carbon steel
3	压梁弹簧（常） pressure beam spring (general)	4	65Mn
4	压梁导槽焊接垫板 welding board for pressure beam guide tray	1	AISI201

2.9.2 压梁托槽组件（4孔）及明细表

Pressure beam tray component & details (4 holes)

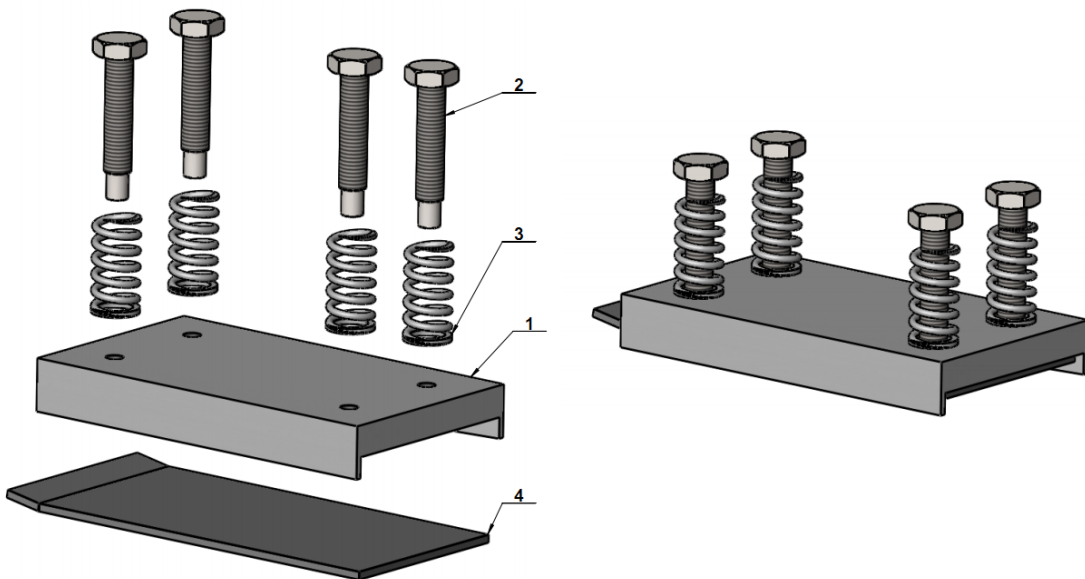


表15 压梁托槽组件（4孔）明细表

Sheet 15 Pressure beam tray component & details (4 holes)

No.	Component	Qty	Material
1	压梁托槽 (4 孔) pressure beam tray (4 holes)	1	A3
2	压梁螺丝 (常) pressure beam screw (general)	4	Common carbon steel
3	压梁弹簧 (常) pressure beam spring (general)	4	65Mn
4	压梁导槽焊接垫板 welding board for pressure beam guide tray	1	AISI201

2.9.3 压梁托槽组件 (6 孔) 及明细表

Pressure beam tray component & details (6 holes)

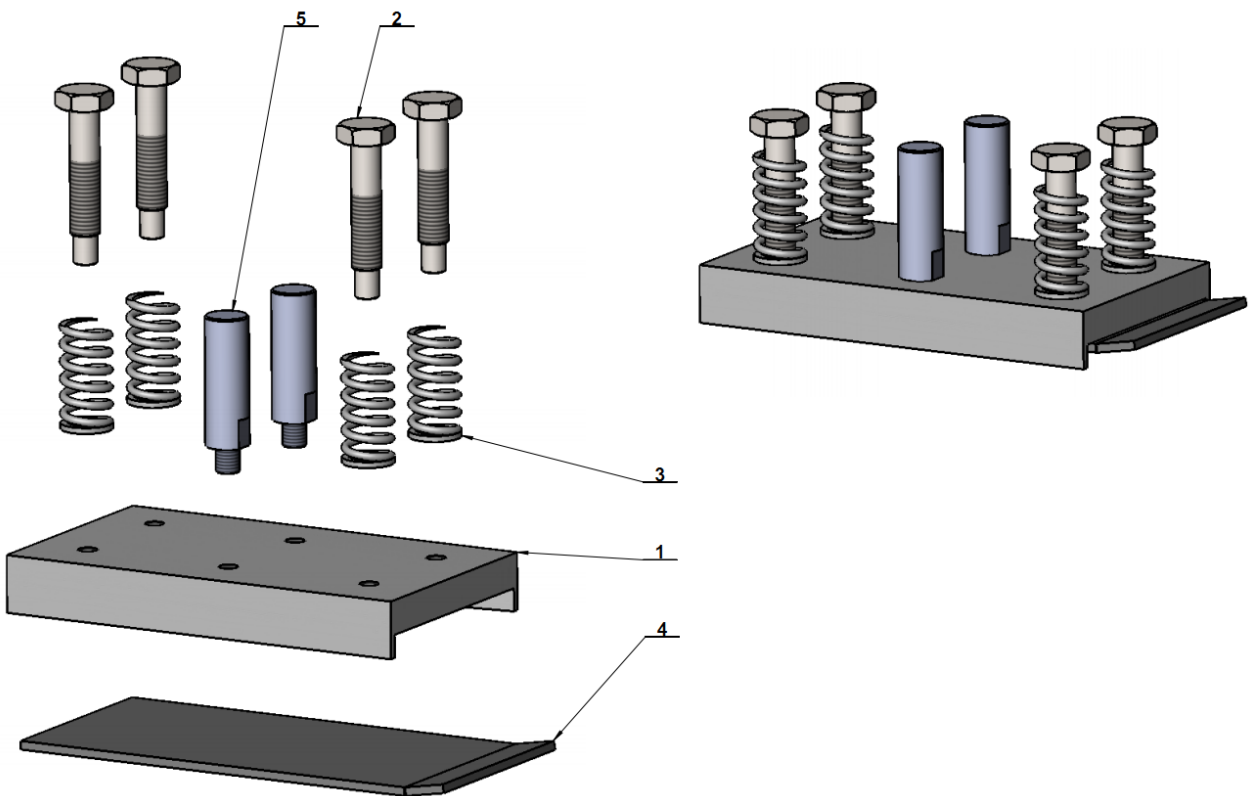


表16 压梁托槽组件 (6 孔) 明细表

Sheet 16 Pressure beam tray component & details (6 holes)

No.	Component	Qty	Material
1	压梁托槽 (6 孔) pressure beam tray (6 holes)	1	A3
2	压梁螺丝 (常) pressure beam screw (general)	4	Common carbon steel
3	压梁弹簧 (常) pressure beam spring (general)	4	65Mn

4	压梁导槽焊接垫板 welding board for pressure beam guide tray	1	AISI201
5	压梁导柱 pressure beam guide pin	2	45#

2.9.5 压梁过渡轮组件及明细表

Pressure beam transition wheel components & details

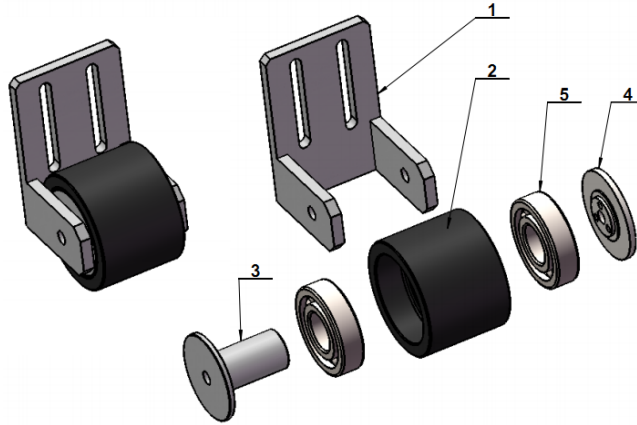


表17 压梁过渡轮组件明细表

Sheet 17 Pressure beam transition wheel components & details

No.	Component	Qty	Material
1	压梁过渡轮调节座 pressure beam transition wheel adjusting base	1	A3
2	过渡轮（光身） transition wheel	1	HT200
3	过渡轮轴 transition wheel axis	1	45#
4	定位盖 $\Phi 80 \times 10$ positioning cover $\Phi 80 \times 10$	1	45#
5	深沟球轴承 6307 deep groove ball bearing 6307	2	

2.10 压砖轮组件及明细表

Tile pressing wheel components & details

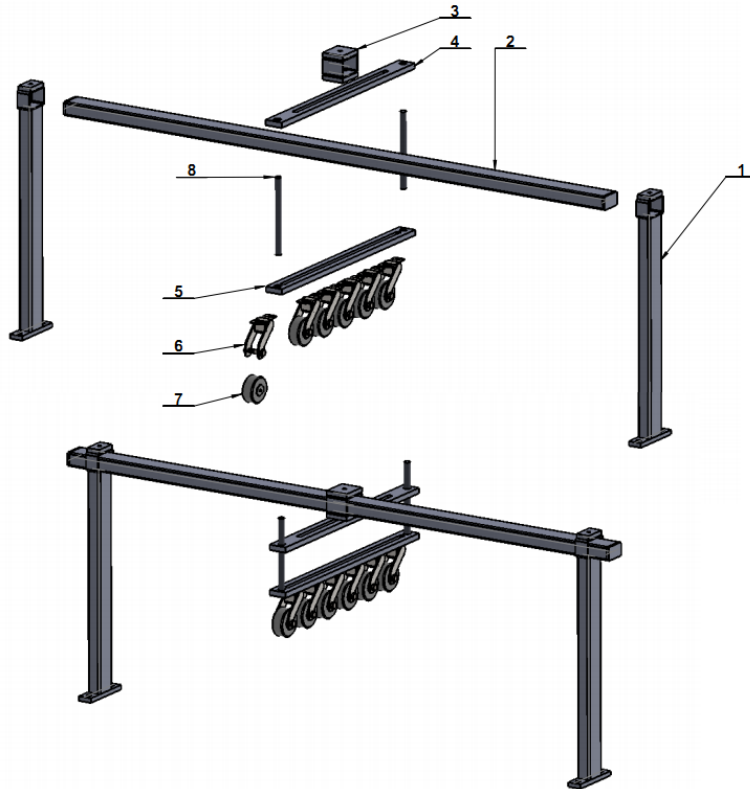


表18 压砖轮组件明细表

Sheet 18 Tile pressing wheel components & details

No.	Component	Qty	Material
1	压轮焊接支撑架 bracket for pressing wheel welding	2	A3
2	压轮横梁（方管）30x50xL pressing wheel beam (square pipe) 30x50xL	1	A3
3	活动调节座 moveable adjusting base	1	A3
4	压轮固定板 pressing wheel fixing board	1	A3
5	压轮调节板 pressing wheel adjusting board	1	A3
6	压轮支架 pressing wheel bracket	6	compound
7	压轮 pressing wheel	6	compound
8	压轮调节螺杆 M14x170 pressing wheel adjusting screw M14x170	2	45#

2.11 主传动组件及明细表

Main drive component & details

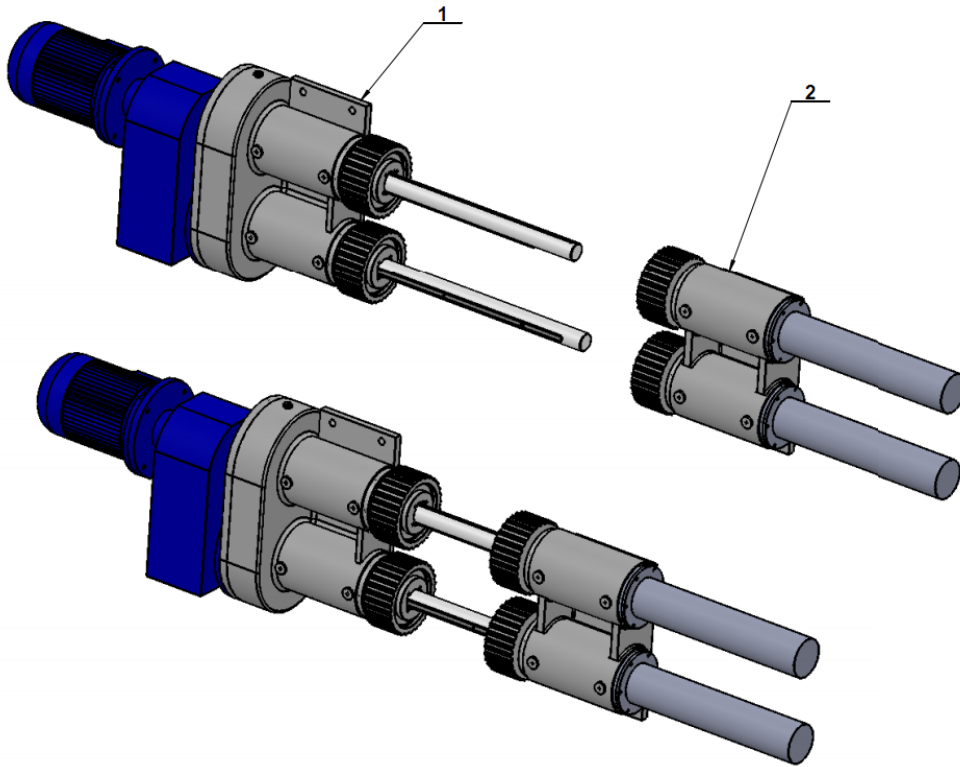


表19 主传动组件明细表
Sheet 19 Main drive component & details

No.	Component	Qty	Material
1	主传动传动套件 main drive driving component	1	
2	主传动副动套件 main drive driven component	1	

2.11.1 主传动主动套件及明细表

Main drive driving suite component & details

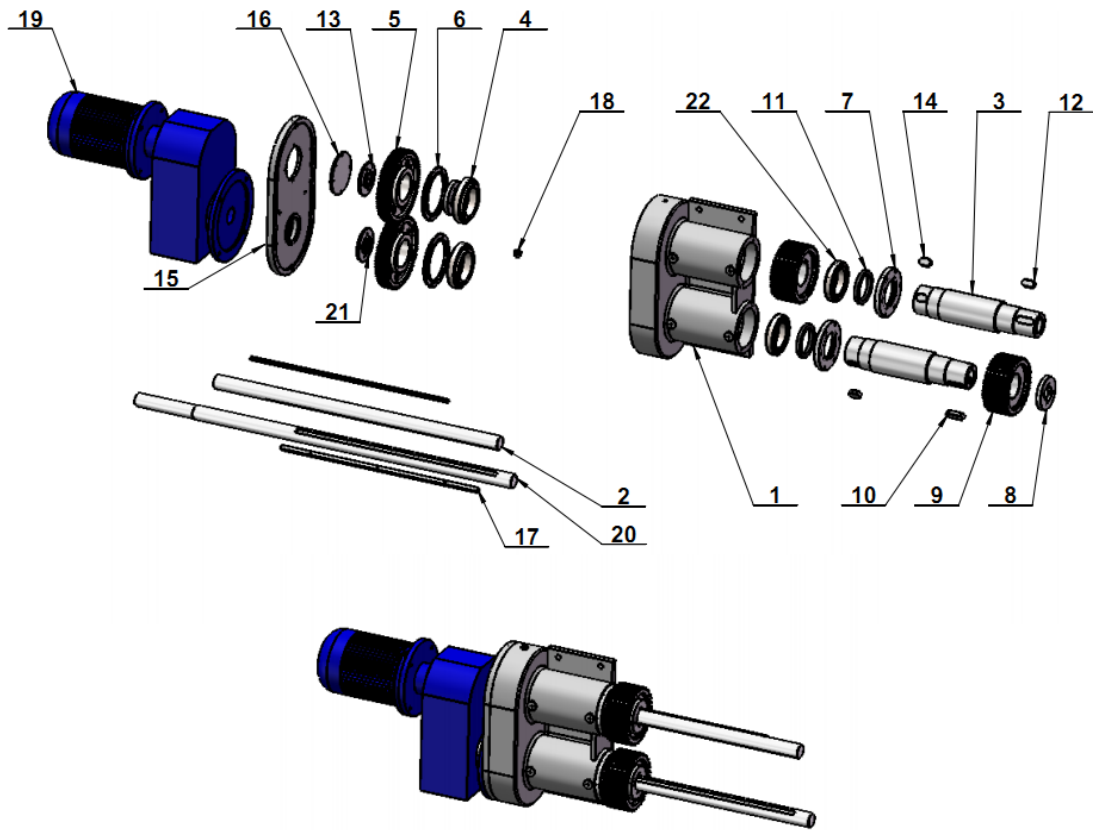


表20 主传动主动套件明细表

Sheet 20 Main drive driving suite component & details

No.	Component	Qty	Material
1	齿轮箱 gear wheel box	1	HT200
2	主传动被动轴 main drive passive axis	1	45#
3	空心轴 428 hollow shaft 428	2	45#
4	圆锥滚子轴承 32019 tapered roller bearing 32019	2	
5	77 齿轮 (钢件) 90 孔 77 gear wheel(steel) 90 holes	2	HT200
6	大轴承端盖 (主传动) big bearing end cover(main drive)	2	HT200
7	小轴承端盖 (主传动) small bearing end cover (main drive)	2	HT200
8	同步轮压盖 synchronous wheel pressing cover	2	HT200
9	同步轮 (主传动) synchronous wheel (main drive)	2	HT200
10	平键 22x14xl=63 flat key 22x14xl=63	1	
11	骨架油封 $\phi 85 \times \phi 110 \times 12$ framework oil seal $\phi 85 \times \phi 110 \times 12$	2	
12	平键 22x14xl=47 flat key 22x14xl=47	1	
13	被动齿轮端盖 driven gear wheel end cover	1	HT200
14	平键 25x14xl=40 flat key 25x14xl=40	2	
15	齿轮箱 (齿轮箱盖) gear wheel box (box cover)	1	HT200

16	齿轮箱盖板 gear wheel box cover	1	HT200
17	导向平键 14-N-1084 guide flat key 14-N-1084	2	
18	透气塞 (M16) porous plug (M16)	1	
19	齿轮减速机 (380V) gear wheel reducer	1	
20	主传动主动轴 main drive active axis	1	45#
21	主动齿轮端盖 active gear wheel end cover	1	HT200
22	圆锥滚子轴承 32017 tapered roller bearing 32017	2	

2.11.2 主传动副动套件及明细表

Main drive passive suite component & details

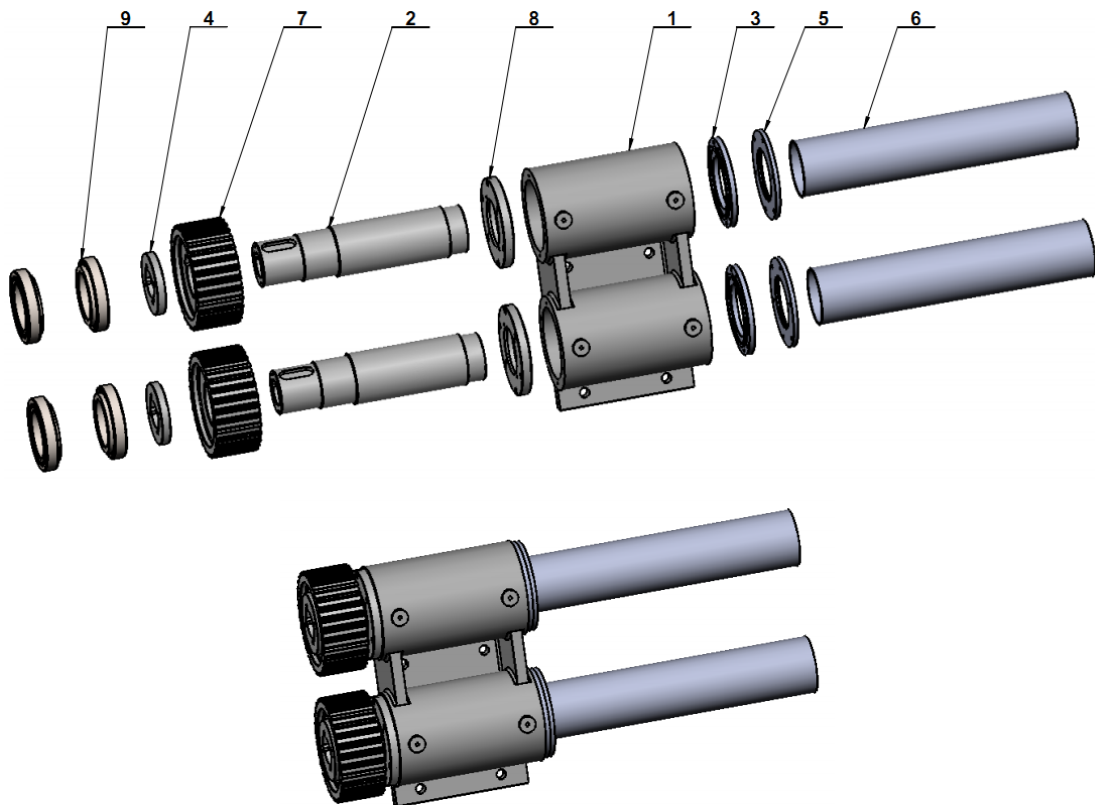


表21 主传动副动套件明细表

Sheet 21 Main drive driven suite component & details

No.	Component	Qty	Material
1	主传动副箱座 main drive sub-box	1	HT200
2	空心轴 374 hollow axis 374	2	45#
3	1000 新轴套 1000 new sleeve for axis	2	
4	同步轮压盖 synchronous wheel cover	2	HT200
5	新轴套法兰 new flange for axis sleeve	2	
6	1000 型端盖罩 1000 type end cover	2	A3
7	同步轮 (主传动) synchronous wheel (main drive)	2	HT200
8	小轴承端盖 (主传动) small bearing end cover (main drive)	2	HT200

9	圆锥滚子轴承 32017 tapered roller bearing 32017	4	
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2.12 推砖组件及明细表

Tile pushing component & details

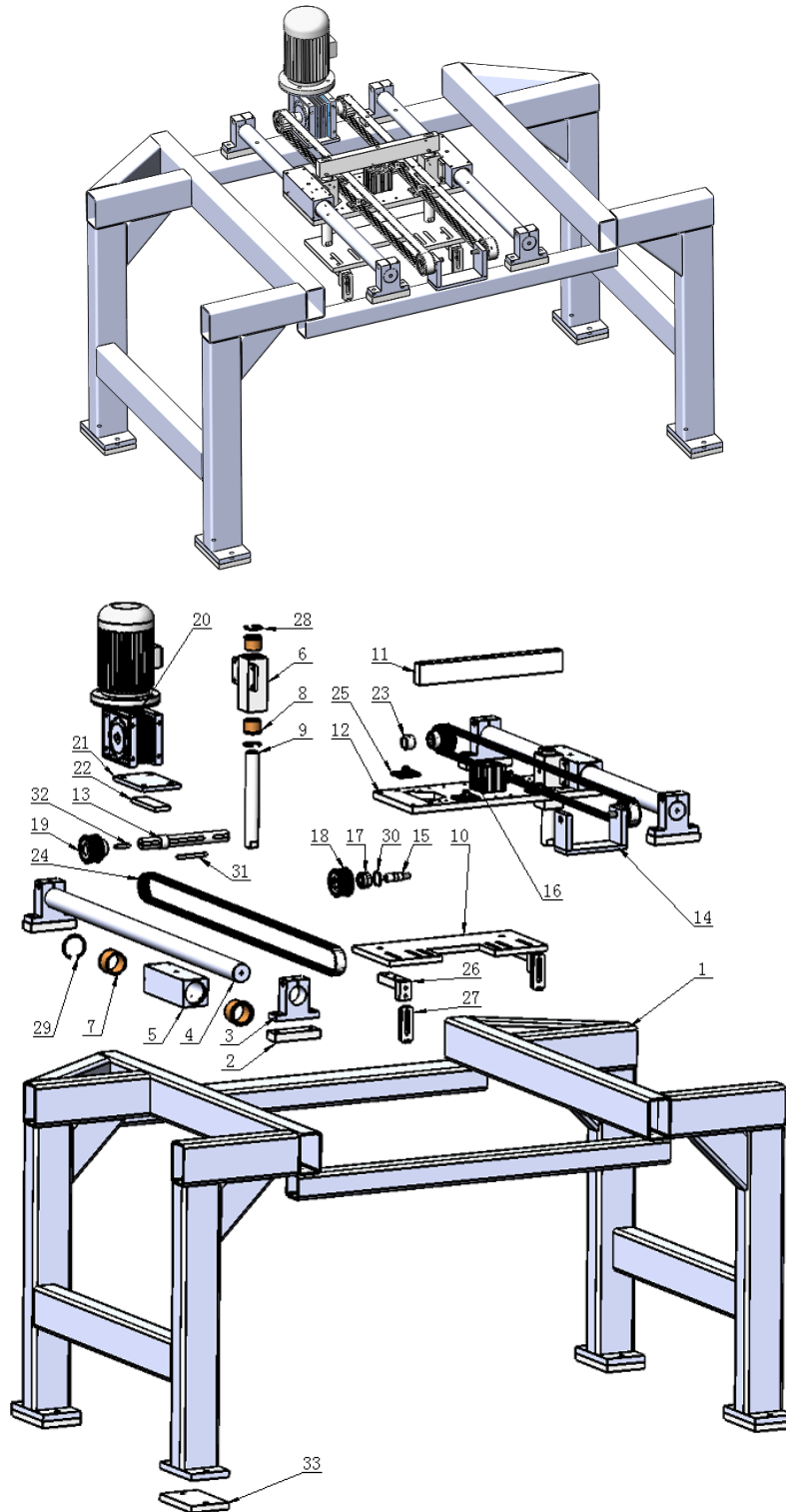


表22 推砖组件明细表

Sheet 22 Tile pushing component & details

双压带干式磨边机 Double belt dry type squaring machinery

No.	Component	Specification	Unit	Qty	Note
1	1000 推砖架 1000 tile pushing framework	1000 type	pc	1	Q235A
2	固定座垫板 fixing base plate	120*40*20	pc	4	Q235A
3	固定座 Φ45 fixing base Φ45	114*36*95, Ø45 inner hole	pc	4	aluminum
4	推砖导轴(导向杠 A) Tile pushing guide axis (guide pole A)	Ø45*1000	bar	2	45# (chromed)
5	导向块 a guide block a	200*65*65, with Ø45 guide axis	pc	2	Q235A
6	导向块 B Guide block B	128*110*50, with Ø30 guide axis	pc	2	Q235A
7	推砖铜套 Tile pushing sleeve	55x45x37	pc	4	brass
8	推砖铜套 Tile pushing sleeve	40x30x30	pc	4	brass
9	导向轴(导向杠 B) Guide axis(guide pole B)	Ø30*228	bar	2	45# (chromed)
10	1000 型推砖座板 A 1000 type tile pushing base A	580*190*14	pc	1	Q235A
11	导向连接板 guide connection board	380*50*25	pc	1	Q235A
12	推砖连接板 tile pushing connection board	505*200*16	pc	1	Q235A
13	推砖小轴 tile pushing small axis	Ø30*229	bar	1	45#
14	同步轮支架 (矮) synchronous wheel bracket (short)	160*60*95	pc	1	Q235A
15	被动同步轮轴 passive synchronous wheel axis	Ø20*63	bar	2	45#
16	推砖气缸 tile pushing cylinder	QGY50X25	pc	1	
17	深沟球轴承 deep groove ball bearing	6003	pc	4	
18	小同步带轮 (从动) small synchronous belt wheel(driven)	AT10, 20 segments, inner holes 35	pc	2	HT150
19	小同步带轮 (主动) small synchronous belt wheel (driving)	AT10, 20 segments, inner hole 25	pc	2	HT150

双压带干式磨边机 Double belt dry type squaring machinery

20	电机+方箱 motor + box	0.75KW-RV50-i	set	1	
21	推砖方箱安装板 assembly board for tile pushing box	150*100*10	pc	1	Q235A
22	推砖方箱垫板（10厚） plate for tile pushing box(10mm thickness)	120*40*10	pc	1	Q235A
23	推砖小轴隔套 spacer sleeve for tile pushing small axis	Ø32*Ø25*20	pc	1	45#
24	推砖同步带 tile pushing synchronous belt	25AT10-2100	bar	2	
25	皮带扣 buckle		pc	4	
26	推刀座 blade pushing base	110*45*30	pc	2	Q235A
27	推砖爪 tile pushing paw	85*30*10	pc	2	Q235A
28	内卡 inner clip	Ø40	pc	4	
29	内卡 inner clip	Ø55	pc	4	
30	内卡 inner clip	Ø35	pc	2	
31	圆头平键 round head flat key	8x80	grain	1	
32	圆头平键 round head flat key	8x40	grain	2	
33	推砖架垫板 plate for tile pushing framework	160*100*16	pc	4	Q235A