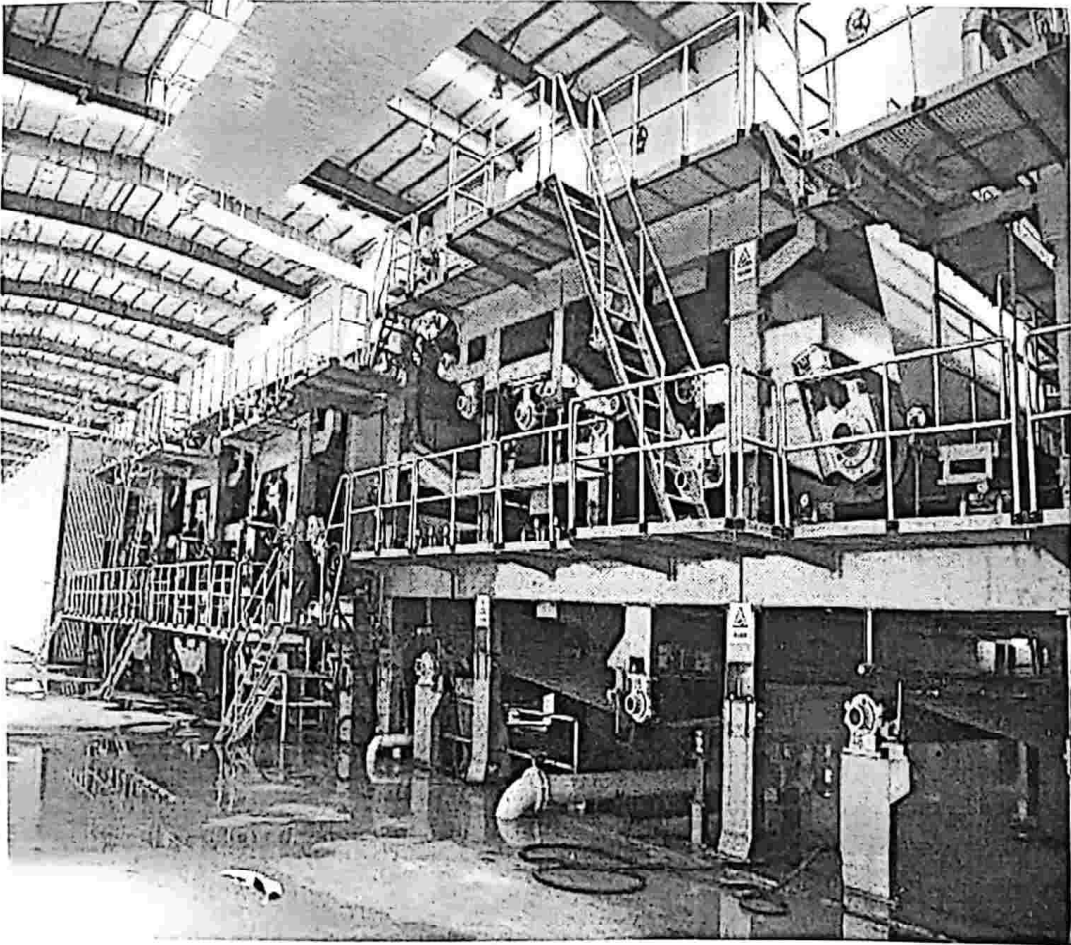


2680/100m 烘缸 + 施胶机

2680/100 8Dryers+sizing machine

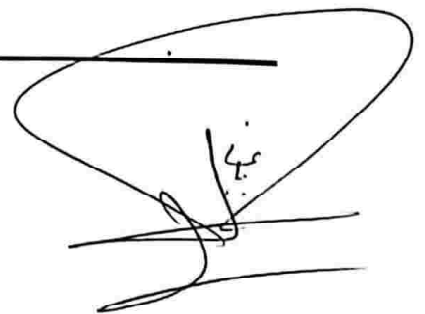
技术方案

Technical schema



沁阳市晟瑞机械厂

地址：沁阳市里村工业区



根据贵公司要求的基本条件, 我对项目的主要参数进行计算和平衡, 为此向贵公司推荐结合国内外先进技术的、成熟可靠的、经济合理的方案。

According to your request, our company calculated and balanced the main parameters of the project and recommended to your company for that purpose, combined with advanced technology, mature and reliable, economically reasonable solution.

施胶机—8 只 $\phi 1500$ 烘缸

size press-8 of $\phi 1500$ cylinder

本机布置形式为一层楼布置, 左手机 (可按用户要求设计)

This paper machine layout in the form of single-layer arrangement,
The left hand machine (from dryer to headbox, drive in left hand) (can change based on the customer's requirement).

本机所有辊类的动平衡等级设定为 G2.5。

The dynamic balance level of the rolls of the paper machine is G2.5

本机烘缸的动平衡等级设定为 G4。

The dynamic balance level of the paper machine is G4

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2680/100m 烘缸+施胶机 技术说明

2680/100 8Dryers+sizing machine technical instructions

一、 总则 General Provisions

1、主要技术参数

主要产品: T 纸

The main products: test liner paper

定量范围 Weight range: 100-200g/m²

净纸宽度 Trim paper width: 2680mm

工作车速 Working speed: 100m/min

设计车速 Design speed: 130m/min

爬行车速 Crawling speed: 25m/min

动平衡车速 Balancing speed: 130m/min

烘缸宽 Dryer body width: 3050mm

轨 距 Rail distance: 3700mm (以最终设计为准)

传动方式: 交流电机变频调速分部传动

Transmission method: AC Motor Division drive

布置形式: 单层

Arrangement model: single-layer arrangement

最大单件重量 the largest single piece weight: ~10t

2、主要性能要求和保证

本纸机设备配置能达到预定的生产能力，并首先重点考虑纸机的内在和外观性能要求。

轴承要求: 采用瓦房店轴承厂或洛阳轴承厂产品。

2. The main performance requirements and guarantee

This paper machine can achieve the desired production capacity, and the first key consideration of the paper machine is the internal and external performance requirements of the

machine.

The bearing requirement: the bearings provided by the Wafangdian Bearing Factory or Luoyang Bearing Factory.

二、各部主要特征 The main features

本纸机主要由烘干部、施胶机、基础部、机械传动及其电气控制等组成。

The main components of the paper machine include the dry section, size press, the base section, mechanical transmission

1、烘干部

烘干部配有 $\phi 1500$ 烘缸 8 只。

采用大齿轮传动。

干网设计张力: 6KN/m。

1. The dry section

The dry section is equipped with the 8 sets of $\phi 1500$ cylinder, mother cited paper cylinder use the big gear drive

Dry wires design tension: 8KN / m.

1.1 烘缸

数 量:	8 套
直径/缸面长度:	$\phi 1500/3050$
缸体材料:	HT250
硬 度:	HB190-220
缸面粗糙度:	≤ 0.8 微米
最高工作压力:	0.3Mpa
水压试验压力:	0.6Mpa
配备旋转蒸汽接头。	

1.1 cylinders

Quantity: 8 sets

Diameter / length of the cylinder surface: $\phi 1500/3050$ mm,

Cylinder body material: The cylinder body and head are HT250

Hardness: HB190-220

Cylinder surface roughness: ≤ 0.8 microns

Maximum working pressure: 0.3Mpa

Hydrostatic test pressure: 0.6M pa

Equipped with a rotary steam joints.

1.2 校网器

数 量: 2 套

主要结构: 气动自动校网。

1.2 wire-adjusting device

Quantity: 2 sets

The main structure: Pneumatic Automatic school wire.

1.3 紧网器

数 量: 2 套

主要结构: 电动张紧, 兼可手动调节, 双向限位。

1.3 The tight wire device

Quantity: 2 sets

The main Structure: the electric tension can be adjusted manually, two-way limit.

1.4 辊子 roll

1.4.1 导 辊

数 量: 数量设计时定

直径/辊面长度: $\phi 191/3050$

材 料: 20#无缝钢管, 壁厚 14mm。

1.4.1 Guide roll

Quantity: the number are given based on the design

Diameter / length of the roll surface: $\phi 191/3050$ mm

Roll material: 20# seamless stainless Pipe, thickness: 14mm

1.4.2 引纸辊

数 量: 2 套

直径/辊面长度: $\phi 159/3050$

材 料: 20 无缝钢管, 壁厚 12mm。

辊面镀铬，铬层厚 0.08-0.1mm

1.4.2 Initiative cited paper roll

Quantity: 2 sets

Diameter / length of the roll surface: $\phi 159/3050$ mm

Material: 20 seamless steel pipe.thickness:12mm

The roll surface is chrome-plated; chrome thickness is 0.08-0.1mm

1.5 烘缸刮刀

数量: 8套

刮刀材料: EP板

主要结构: 刮刀体钢板焊接结构，固定式刮刀。刮刀片为抽插更换

1.5 The cylinder scraper

Quantity: 8 sets

Scraper materials: EP board

The main structure: the scraper body is steel plate welded structure, fixed scraper.

The scraper knife are changed randomly

1.6 引纸绳系统 1套

1.6 Paper leading rope system 1 set

整个系统为二绳轮引纸。在每组引纸系统中均含各种绳轮、轴、支架、张紧器等。引纸绳张紧为气动张紧，按绳的张力 150 ~ 200N 设计，气缸外购，绳轮、机架及底座等自制。引纸绳系统的轴承润滑为油脂润滑，设有防尘装置。

The whole system is two rope wheel paper leading. In each group of paper leading system, there are rope wheel, shaft, support, tensioner and so on. Paper

leading rope is pneumatic tension and designed according to rope tension 150~200N. Gas cylinders are outsourcing. Rope wheel, rack and housing are self made. Bearing lubrication of paper leading rope system is grease with anti-dust device.

1.6 机架及走台

机 架: 机架为箱形结构, 材质铸铁或为焊接件, 时效处理。
走 台: 烘干部操作与传动两侧均配有纵向走台及必要的横走台, 走台板和栏杆均为 Q235 型材。

1.6 racks and the walking board

The rack: rack is box structure, the materials is welded material with the aging treatment.

Walking board: the dry section operation and the two side of the drive are all have the vertical walking board and the necessary horizontal walking board .the walking board plate and the railing are Q235 material.

2、施胶机

1 台

主要结构: 双辊斜列式, 两辊均带传动
最高线压: 50KN/m
中高设计线压: 40KN/m
加压方式: 采用波纹气胎加压

2. Size press 1 set

Main structure: double roll inclined column type, use two roll to belt drive

The maximum line pressure: 50KN / m

Medium High design line pressure: 40KN / m

Pressure method: the corrugated gas tire pressure

2.1 施胶辊

数 量: 1 套
 直径/辊面长度: ϕ 700/3050
 材 料: 天然大理石辊

2.1 Sizing top roll

Quantity: 1 set
 Diameter / length of the roll surface: ϕ 700/3050mm
 Material: natural marble roll

2.2 施胶辊

数 量: 1 套
 直径/辊面长度: ϕ 705/3050
 材 料: HT250 铸铁包丁晴橡胶, 胶层厚 20mm
 包覆材料: 包胶硬度邵尔 A95 \pm 2°

2.2 Sizing bottom roll

Quantity: 1 set
 Diameter / length of the roll surface: ϕ 705/3050mm
 Material: HT250 cast iron with rubber (NBR) , rubber thickness 20mm
 Coated material: rubber covered hardness ShoreA95 \pm 2°

2.3 供胶装置

配有 1Cr18Ni9Ti 不锈钢 2 根喷胶管和挡胶板, 喷嘴间距 300mm, 喷嘴直径 1/2 寸不锈钢管, 挡板厚度不小于 30mm, 保证不漏胶。

2.3 rubber supply devices

With two 1Cr18Ni9Ti stainless steel, spray adhesive pipe and block rubber sheet, the nozzle spacing is 300mm; 1/2 inch diameter of stainless steel nozzle, the baffle thickness is not less than 30mm, in order to avoid rubber leakage.

2.4 导辊

数 量: 1 套

直径/辊面长度: $\phi 270/3050$
辊体材料: 20 无缝钢管, 镀铬, 厚 0.08-0.1mm, 壁厚 14mm。

2.4 guide roll

Quantity: 1 set

Diameter / length of the roll surface: $\phi 270/3050\text{mm}$

Roll body material: 20 # seamless steel pipe, chrome coated , thickness is 0.08-0.1mm, pipe thickness 14mm.

2.5 施胶辊刮刀

数 量: 1 套
刮刀材料: EP 板
主要结构: 刮刀体钢板焊接结构, 采用气动控件操作。

2.5 size scraper

Quality: 1sets

Scrape material: EP board

Main structure: the Scraper body is steel plate welded structure, the use of pneumatic control operation.

2.6 喷水管

数 量: 1 套
材 料: 304 不锈钢
主要结构: 用于辊面的清洁。

2.6 spray pipe

Quality: 1 set

Material: 304 stainless steel

Main structure: use for cleaning the roll surface

2.7 机架及走台

机 架: 机架为箱形结构, 材质为焊接件。
走 台: 施胶部操作侧配有纵向走台及必要的横走台, 走台板和栏杆均为 Q235 型材。

2.7 racks and waling board

Rack: the rack is box structure, the material is welded

Walking board: the operation side of the size press has the vertical and horizontal walking board and the walking board and rails are all Q235 material

2.8 活动弧型辊

数量: 1 套
 直径/面宽: $\phi 159/3050\text{mm}$
 材料: 辊体 20#无缝钢管, 轴 45#钢调质。
 表面处理: 表面镀铬, 铬层厚 0.05-0.08mm。

2.8 Multi section curved roller

Quantity: 1 SET
 Diameter / length of the roll surface: $\phi 191/3050\text{mm}$
 Roll material: 20# seamless stainless Pipe
 Surface: chromate treatment, thickness 0.05~0.08mm

2.9 圆形震动筛

数量: 1 套
 性能另文约定。

2.9 Cylinder vibrating screen

Quantity: 1 SET

Technical parameter due to other documents.

3、基础部

包括基础板、地脚螺栓。本机全部基础板均经过两次热处理, 即铸造后进行首次热处理, 粗加工后再进行一次热处理, 之后才进行最后一次精加工, 从而保证基础板的平直和不产生内应力变形。

3. The base section

Including the base plate, foundation bolts. The base plate of this paper machine is going through twice heat treatment. Which means did the heat process after the casting, then after the roughing and did the first heat treatment, then did the final treatment, in

电话: 13703893386

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order to ensure the straightness of the base plate and avoid the internal stress deformation.

4、机械传动

4.1 采用全数字交流变频分部传动。

4.2 各分部均由专用交流变频电机和高精度硬齿面减速机、联轴器或万向联轴器等传动。

4.3 各分部测速装置均采用高精度的光电脉冲式编码器。

4. The mechanical transmission

4.1 The mechanical transmission part adopt the full -digital AC frequency segment transmission

4.2 Each segment adopts the dedicated AC variable frequency motors and high precision hardened gear box, coupling or universal joint couplings, etc

4.3 The speed measuring device of each section uses the high-precision optical pulse encoder.

4.4 各分部主传动点功率如下：（按最终设计为准）

4.4 The motor power in each main transmission point is as follows: (in the final design to date)

传动点	电机 (KW) × 数量
Transmission point	motor (kW) × number
8 缸组 8 sets of cylinders	22X1=22
施胶机 Size press	15×2=30
	合计 Total: 52kw