



KHL-60T

操作説明書

油壓壓床機

September 2019

目錄:

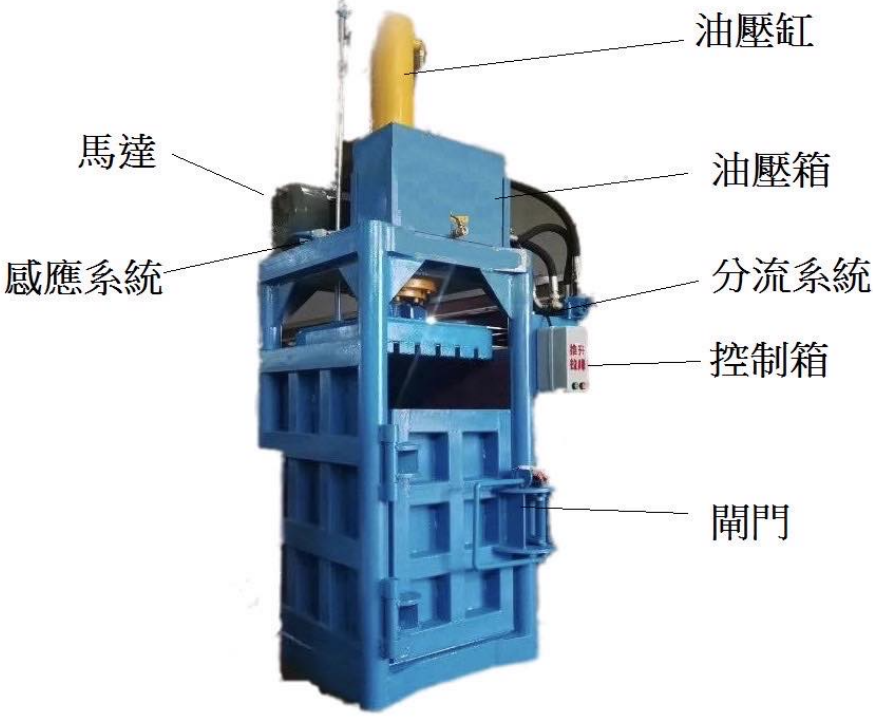

1. 規格
2. 結構
3. 操作程序
4. 異常排除



1. 規格

油桶尺寸	53GL 油桶 600*900*1.6 mm
油壓系統	3 相 220V 60HZ 安全增防爆
油壓缸行程:	1030 mm
油壓缸直徑	190 mm
壓力	60 Ton
每桶壓縮時間	1 分鐘以內
壓床內部使用空間:	650*650*1000 mm
壓桶操作:	分手動/自動選項按鈕開關 (需防爆) 每次衝壓後需復歸裝置
安全保護裝置	設計安全保護/柵門連動、門開斷電無作動 油壓箱配置圍籬外, 電磁閥為安全增防爆等級 柵門附鎖
壓床結構	四周護欄柱, 採用無縫鋼管 圍籬: 50 (H) x 100 (W) x 3 (T) mm 及 鍍鋅鋼板 3mm 102(W)*170(H)*8MM 柱底鋼板 16mm (T) 鑽孔以 M16 x 100 mm (H)擴張螺栓固定(SUS304)
內箱尺寸	650*650*1000 mm
外箱尺寸	1250*1100*2750 mm
電源電壓	AC 380V, 3 Phase, 四線, 7.5 KW

2. 結構

#	說明
1.	 <p>油壓缸</p> <p>油壓箱</p> <p>分流系統</p> <p>控制箱</p> <p>閘門</p> <p>馬達</p> <p>感應系統</p> <p>Detailed description: A blue industrial machine, possibly a hydraulic press or compactor. It features a vertical frame with a central opening. At the top, there is a yellow hydraulic cylinder. To the left, a motor is mounted. To the right, there is a control box and a valve. The machine is labeled with various components in Chinese: 油壓缸 (Hydraulic cylinder), 油壓箱 (Hydraulic tank), 分流系統 (Flow control system), 控制箱 (Control box), 閘門 (Gate/Valve), 馬達 (Motor), and 感應系統 (Sensing system).</p>
2	<p>防爆保護</p>  <p>Detailed description: A close-up view of the control box of the machine. The box is white and has a handle. It is labeled with 'Ex' in red, indicating it is an explosion-proof enclosure. The box is mounted on the blue frame of the machine.</p>

3

内箱



3. 操作程序

#	說明
1.	機台定位後, 先加入 60 升液壓油。 於活塞桿左右兩側導桿上塗上黃油, 以減少噪音。
2.	接上 AC 380V 電源
3.	按下控制器上綠色按鍵, 留意馬達旋轉方向是否與機器右邊黃色箭頭方向一致。 如果轉向不同, 請更換任意兩條電源線, 確保馬達轉向與箭頭方向一致。
4.	機台操作閥桿有三個檔位; 往內推為油壓缸上升狀態, 回到中間為油壓缸持平狀態, 往外拉為油壓缸下降狀態。 *首次使用時請長按開關盒上面綠色按鍵 2 秒, 為切換閥桿, 讓壓板上下跑動 30 次。
5.	操作時, 將油桶放置入內
6.	將閥桿向外拉
7.	按下綠色鍵, 啟動, 下降
8.	完成後, 將閥桿向內推
9.	按下綠色鍵, 啟動, 上升
10.	將壓扁的桶子拿出

4. 異常排除說明

#	異常	原因	排除方法
1.	電機運作正常, 系統無壓力	<ol style="list-style-type: none"> 1. 電機轉向錯誤 2. 油壓缸密封圈受損 3. 油壓箱液壓油不足 4. 連軸器鍵槽受損 5. 齒輪泵壓力不足 	<ol style="list-style-type: none"> 1. 更換線路, 改變電機轉向 2. 更換密封圈 3. 添加液壓油至油箱 4/5 4. 更換連軸器 5. 更換齒輪泵及相關零件
2.	系統突然無壓力, 活塞桿無法上下	<ol style="list-style-type: none"> 1 <input type="checkbox"/> 滑閥或閥芯卡住或油壓孔阻塞 2 <input type="checkbox"/> 油液污染嚴重 3. 齒輪泵損壞 	<ol style="list-style-type: none"> 1. 清除孔內堵塞物 2. 過濾或更換液壓油 3. 修復或更換齒輪泵
3.	油壓桿上升, 下降緩慢	<ol style="list-style-type: none"> 1. 液壓油不足 2. 閥桿軸承阻油孔堵塞 3. 油液黏稠污染嚴重 4. 密封圈損壞, 內部洩漏嚴重 	<ol style="list-style-type: none"> 1. 補充液壓油 2. 清洗閥桿軸承阻塞物 3. 過濾或更換液壓油 4. 更換密封圈
4.	油壓桿、管接頭漏油	<ol style="list-style-type: none"> 1. 檢查油缸活塞與缸蓋接觸面是否有刮傷 2. 檢查接頭是否鬆動 3. 檢查接頭密封是否密合 4. 檢查接頭是否損壞 	<ol style="list-style-type: none"> 1. 輕刮傷用油石磨光, 重刮傷用更換活塞桿; 無刮傷更換密封或缸蓋 2. 鎖緊接頭 3. 更換密封墊圈或 O 型圈 4. 更換接頭
5.	大小門關不牢或系統無壓力	<ol style="list-style-type: none"> 1. 溢流閥軸承阻油孔堵塞 2. 液壓油污染嚴重 	<ol style="list-style-type: none"> 1. 拆檢清洗溢流閥, 疏通軸承小孔 2. 更換過濾液壓油
**	注意	<p>主機配置的各種閥的安全壓力已調好, 已進行鉛封或用背母鎖緊, 拆檢時如誤鬆動高壓手柄的鎖緊背母, 請先將高壓手柄逆時針方向後退數圈, 然後按順時針方向每次旋轉四分之一圈, 主閥壓力調至打包重量符合要求, 開關門溢流壓力調整到壓包時小門不後退, 又不造成機架不變形、彎曲為止, 然後將背母鎖緊。切記! 不要調壓過高, 以免破壞門子或造成其他機件損壞。</p>	

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