

喷砂房 安装说明手册

Sandblasting room Installation instruction manual

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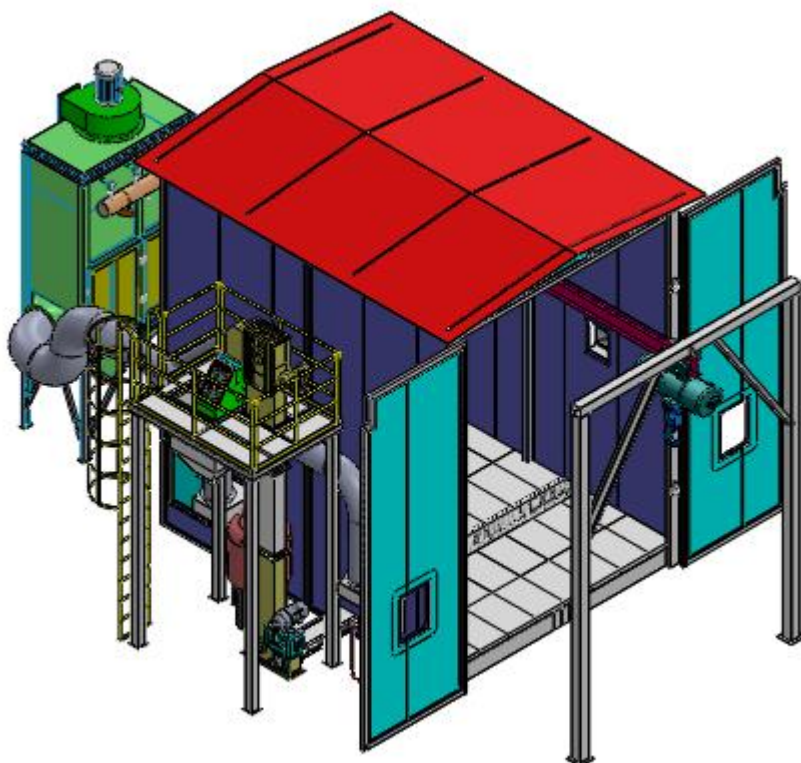
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设备组成

喷砂房体、喷丸罐、斗式提升机、丸砂分离器、螺旋输送机、操作地坪、除尘系统、吊装系统、电控系统以及辅助钢结构等组成。

Equipment composition

Sandblasting room body, shot blasting tank, bucket elevator, sand separator, screw conveyor, operating floor, dust removal system, lifting system, electronic control system and auxiliary steel structure.

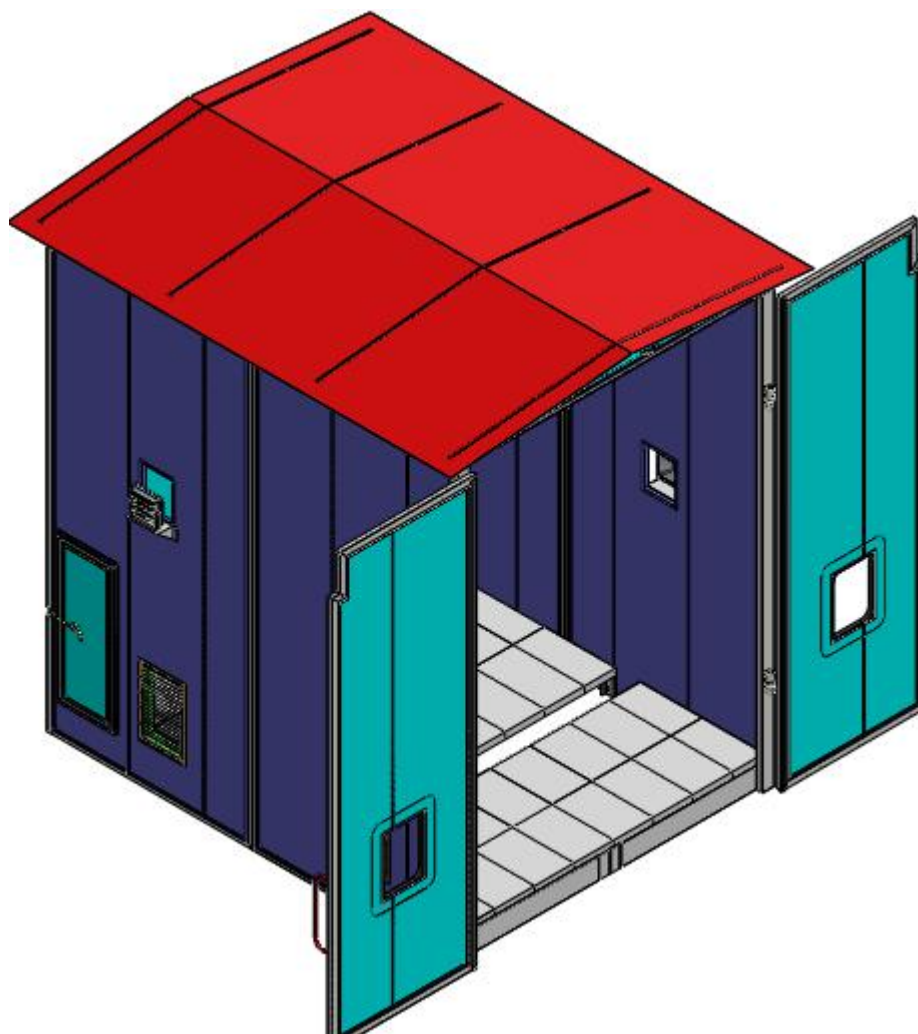


1、喷砂房体

喷砂房体主要由8瓣室体和两扇大门组成，包括必要的附件（8只照明灯和除尘口）和顶部的简易防雨棚

1、 Sandblasting room

The sandblasting chamber body mainly consists of 8 blocks for enclosure body and two large doors, including the necessary accessories (8 lights and dust removal ports) and a simple rainproof shed at the top.



A 、安装时需要把室体块依次拼装，在相邻的室体中间焊接保证牢固，同时与地面的预埋件焊接，保证不会发生过倾倒。注意：焊接时一定要防止室内壁的橡胶板燃烧

B 、依次把橡胶板悬挂在室内壁，使橡胶板之间相互搭接。

C 、把8只照明灯固定在室体的四周

D 、把三角桁架梁依次焊接固定在室体的顶部

E 、把单层彩板依次用自攻螺丝固定在三角桁架梁上。

F 、把两个除尘口固定在室体固有的位置上

G 、把螺旋输送机按照位置穿入固定

H 、把操作地坪依次摆好固定

A 、 When installing, it is necessary to assemble the chamber body blocks in turn, and the welding in the middle of the adjacent chamber body is ensured to be firm, and at the same time, it is welded with the embedded parts of the ground to ensure that no overturning occurs.

B 、 The rubber sheets are suspended from the inner wall of the chamber in turn so that the rubber sheets overlap each other.

C 、 Fix 8 lights around the chamber

D 、 The triangular truss beam is welded and fixed to the top of the chamber body in turn.

E 、 Fix the single-layer color plate on the triangular truss beam with self-tapping screws.

F 、 Fix the two dust removal ports in the position inherently in the chamber

G 、 The screw conveyor is fixed in position according to the position

H 、 The operating floor is placed in order

2、提升机

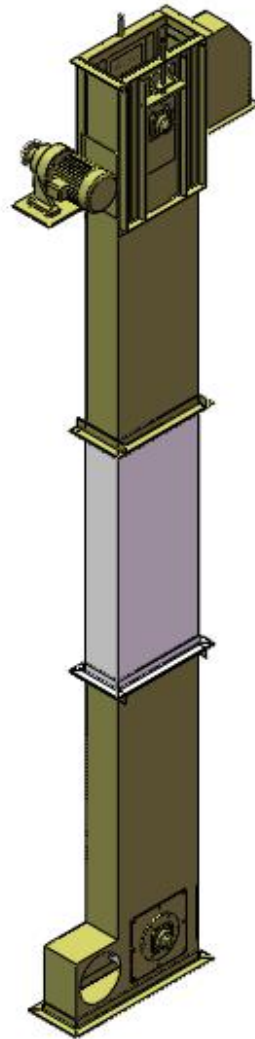
提升机主要由提升机上罩、中罩下罩和皮带总成组成

- A 、 安装提升机下罩,使下轴与螺旋输送机相衔接。
- B 、 安装提升机中罩
- C 、 安装维修平台支腿和平台体
- D 、 安装提升机上罩
- E 、 安装皮带总成

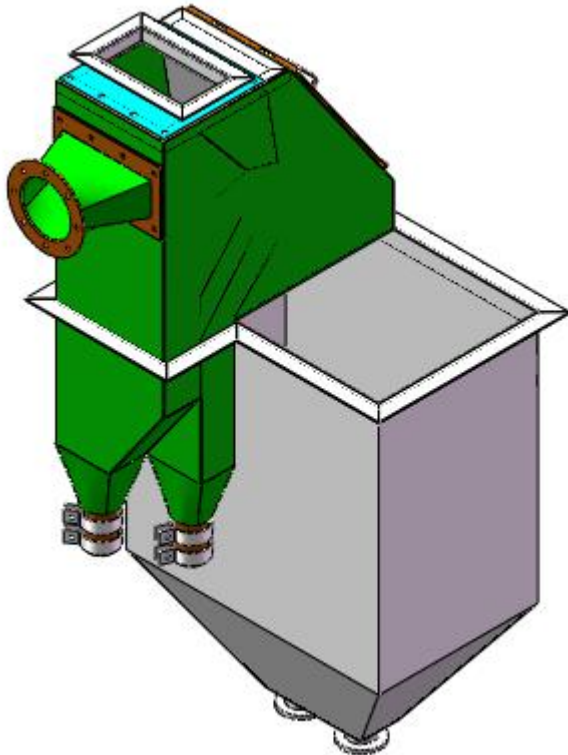
2、 Elevator

The elevator are composed of upper cover, middle cover and lower cover and belt assembly

- A 、 Install the lower cover of the elevator, and connect the lower shaft of elevator with the screw conveyor.
- B 、 Install the middle cover of the elevator.
- C 、 Install the maintenance platform legs and platform body.
- D 、 Install the hood cover on the elevator.
- E 、 installation belt assembly.



3、分离器 Separator



A 、先安装分离器料仓在维修平台上，固定焊接

B 、安装分离器本体与料仓连接，并与提升机上罩相连接

A 、 First install the separator silo on the maintenance platform, fixed by welding

B 、 Install the separator body to connect with the silo and connect with the upper cover of the hoist

4、喷丸罐

A 、放置喷丸罐在分离器下部

B 、连接分离器下部的流丸管与喷丸罐的进料口上部

C 、连接压缩空气管路与喷砂罐

D 、连接喷枪，并引入喷丸室体

注意、接入的压缩空气要求 无水无油 压力为：0.6-0.8MPa 流量为7m³/min

4、Shotblasting tank

A 、Placing the shot blasting tank at bottom of separator

B 、Connect the abrasive dosing unit under the separator and the feed port of the shot blasting tank

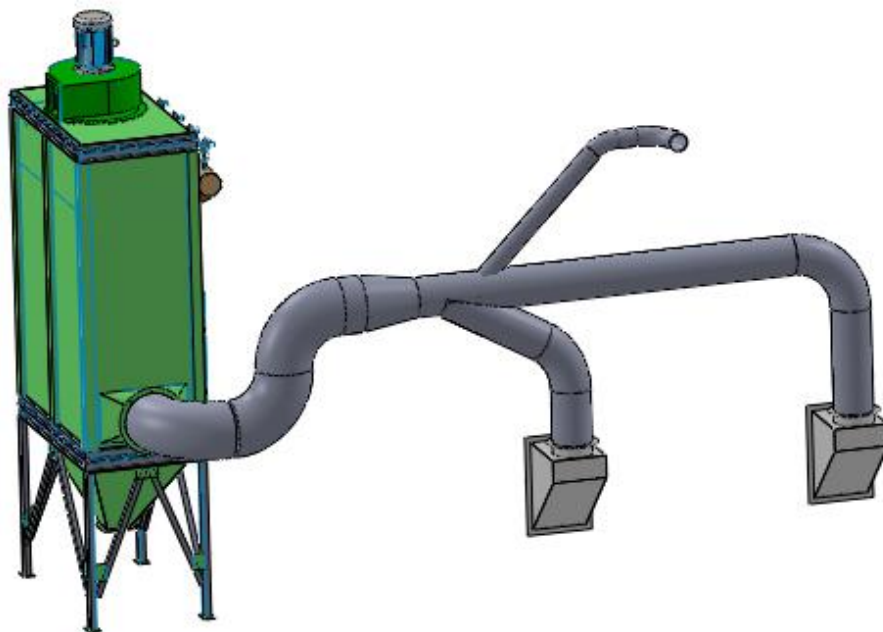
C 、Connect compressed air line with sand blasting tank

D 、Connect the blasting gun and introduce it to the blasting room.

Note: that the compressed air require water-free and oil-free. Pressure is: 0.6-0.8MPa Flow rate is 7m³/min

5、除尘系统

5 、Dust collector system



A 、 组装除尘器 （由料斗和主体组成）

B 、 依次安装除尘管道 如图

A 、 Assembling the dust collector (consisting of the hopper and the body)

B 、 Install dust collecting ducts in turn.

6、 吊装系统

6、 Overhead lifting system



A 、依次固定导轨支架

B 、安装5T 电动葫芦

注意：室体内部的支腿需要与室体的侧壁焊接牢固。

A 、 Fixed frame in proper sequence

B 、 Install 5T electric hoist

Note: The legs inside the chamber body need to be welded firmly to the side walls of the chamber body.

7、电气部分

主要由电控柜和气控部分组成

A 、电控柜就位

B 、连接各部分的线缆、 详见电器原理图和气控原理图

C 、依次调试旋向 如 风机电机的旋向、提升机的旋转方向 、螺旋输送器的旋转方向等。

7、The electrical part

Mainly composed of electric control cabinet and pneumatic control part

A 、 The electric control cabinet is in place

B 、 Connect the cables of each part. For details, see the electrical schematic and the air control schematic.

C 、 Debug the rotation direction for dust collector fan, elevator motor and screw conveyor in sequence.

注意：为给喷砂房加丸料，启动螺旋给料机、和斗提机，将丸料输送到丸料储存斗，加入喷砂罐。

Note: In order to add the blasting media to the blasting room, start the screw conveyor and the bucket elevator in sequence, add the blasting media into the screw conveyor system, and then through screw conveyor and lifting by elevator, it will get into the storage bin, via the abrasive dosing unit to get into the blasting tank.