

HYDRALOK 扣压机用户使用手册

型号: H50C4



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1. 所购机器在装运前均经过严格检测。

2. 自购买之日起，所购机器享有 **12** 个月的质保期。

3. 对于确实存在缺陷的零部件/机器，用户预先支付运费后，可将存在问题的零部件/机器退回本公司。我们将附有“运费已付”的零部件/机器运换给客户。只有在运费已付的情况下，我们才接受退货。

4. 该质保声明包括在质保期内享有维修和/或更换任何确实存在缺陷的零部件的权益。

5. 该质保声明下的维修和更换在 12 个月质保期满后不再延续。

6. 该质保声明不包括正常的机器损耗。

7. 该质保声明不包括由于使用不当或未能按照机器使用说明进行操作而引起的损坏。

8. 该质保声明不包括用户私自改装以后的机器。

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NOI
WF

(nome del fabbricante o del suo mandatario stabilito nella comunità - *supplier's name*)

(indirizzo completo - *address*)

DICHIARIAMO SOTTO LA NOSTRA ESCLUSIVA RESPONSABILITA' CHE IL PRODOTTO:
DECLARE UNDER OUR SOLE RESPONSIBILITY THAT THE PRODUCT:

serial number:

(nome - *name*, tipo- *type*, modello - *model*, n° di serie - *serial number*)

AL QUALE QUESTA DICHIARAZIONE SI RIFERISCE E' CONFORME ALLE SEGUENTI
NORME O AD ALTRI DOCUMENTI NORMATIVI:
*TO WHICH THIS DECLARATION RELATES IS IN CONFORMITY WITH THE FOLLOWING
STANDARDS:*

Machinery Directive (Technical File) E.M.C. Directive. (Certificate No. 1560/96)

(luogo e data)
(*place and date*)

(nome e firma o timbratura della persona autorizzata)
(name and signature or equivalent marking of authorised person)

毛 重(Kgs)	175
电压 Voltage	220/240-1-50HZ or 220/240 - 380/440-3-50 Hz 225/280 – 440/480 60 Hz
扣压力 Swaging force	2509 Kn
扣压范围 Swaging range	0.6 mm – 76 mm
标准模具 Standard dies	16 19 22 26 30 34 40 46 52 58 64 70

装卸/搬运注意事项 HANDLING/TRANSPORT

机器通常封装在木箱之中。将机器的封定装置拆除后应当使用合适的起重设备将机器置于工作平台之上。The machine will normally be shipped bolted to a wooden pallet . The bolts should be removed and the machine lifted onto the work place using suitable lifting equipment.

预备检测 PRELIMINARY CHECKS

将机器置于平稳的工作平台之上。Place the machine on a stable surface.

如有可能，确保有一个与电源线路适配的自动保险电门，在电流超载时能自动切断电路。
Where applicable, ensure that the power supply line is fitted with a differential safety breaker and overload cut-out.

照明 LIGHTING

机器本身并不带照明装置，因此应当在适宜的照明条件下进行操作。The equipment does not have its own lighting and so it must be used in a suitably illuminated area.

日常维护 ROUTINE MAINTENANCE

保证经常给活动部件上润滑油。Ensure that moving parts are always lightly greased.

如有可能，定期检查限定开关与紧急按钮，确保其运行正常。Where applicable check periodically that the limit switches and emergency controls are in good working order.

去除机器背后的油箱盖，根据“浸测杆”检查油位是否正常，添加 ISO 32 液压油。At the rear of the machine remove the oil filler cap and check that the oil level is correct when measured against the mark on the “dip stick”. Where necessary add oil (ISO 32 Hydraulic oil)

- The finished swage size should be checked and calibration settings adjusted where necessary as “spring back” (energy trapped and released by the rubber and metal after swaging) make occur especially with very large hose and fitting assemblies.

- Switch off machine when not in use, using the latching emergency stop button. To unlatch the stop button twist the red knob clockwise and release.

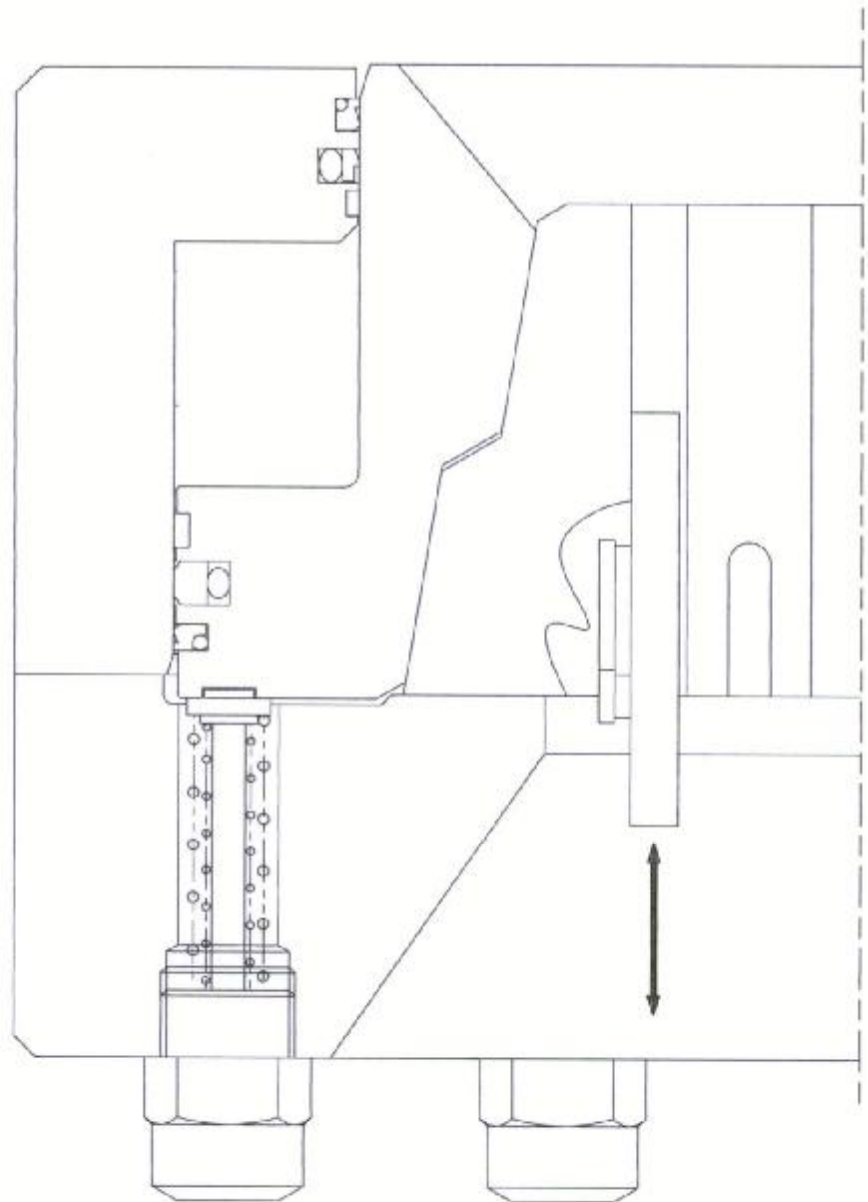
To stop the machine in an emergency press the RED emergency STOP BUTTON.

DO NOT START THE MACHINE UNDER LOAD.

ALWAYS RELEASE PRESSURE BEFORE RESTARTING.

ISOLATE THE MACHINE FROM THE ELECTRICAL SUPPLY WHEN NOT IN USE.

DIE FITTING INSTRUCTIONS





模具号	扣压范围 (mm)	扣压长度	装上模具后最大开口直径
*06	06.0 -7.9	40.00	18.00
*08	08.0 -09.9	40.00	20.00
*10	10.0012.9	40.00	22.00
*13	13.0-15.9	40.00	25.00
16	16.0-18.9	40.00	28.00
19	19.0-21.9	40.00	31.00
22	22.0-25.9	50.00	34.00
26	26.0-29.9	50.00	38.00
*28	28.0-33.9	50.00	40.00
30	30.0-33.9	60.00	42.00
34	34.0-39.9	70.00	46.00
40	40.0-45.9	70.00	52.00
46	46.0-51.9	80.00	58.00
52	52.0-57.9	80.00	64.00
58	58.0-63.9	80.00	70.00
64	64.0-69.9	80.00	76.00
70	70.0-76.0	95.00	82.00

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一般每月检查油位，对于使用较频繁的机器，应当经常检查油位。

机头的滑槽应当定期用含二硫化钼的喷洒剂进行润滑上油。

建议每年重新校验扣压机头。以下提供校验指南。

生产商或经授权的销售商能提供整套校验服务。

校验指南 CALIBRATION INSTRUCTIONS

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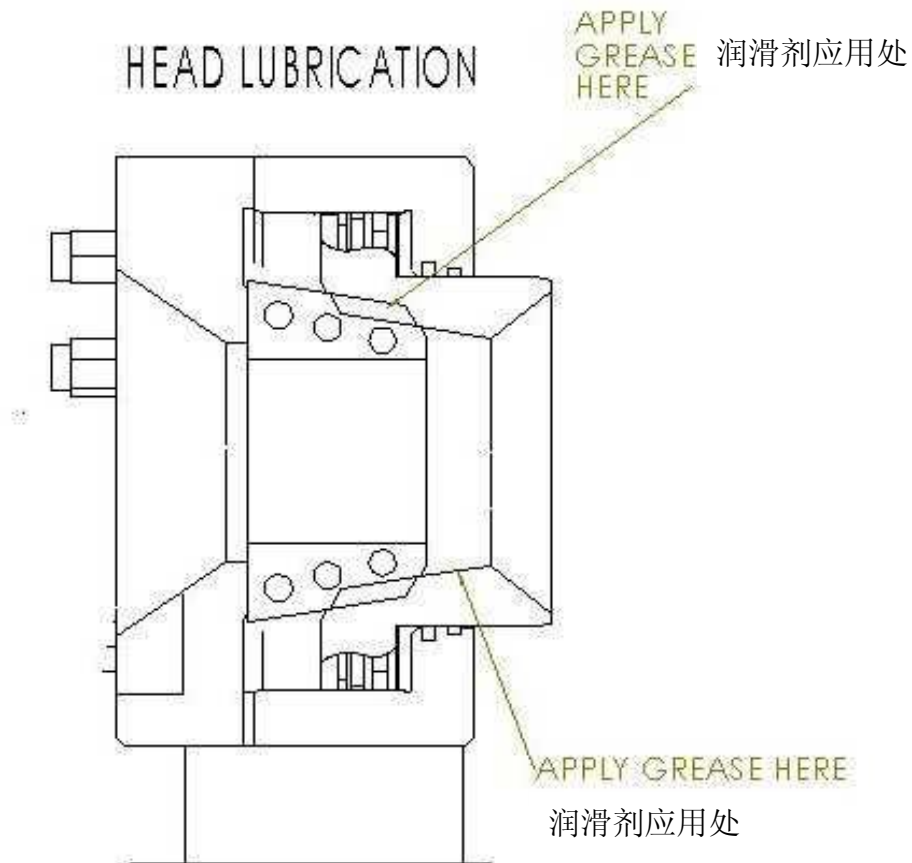
SPARE PARTS

部件 Item	编号 Part Number	描述 Description
10,11,12,13,14,15	300-072	密封套件 seal kit
18,19,20,21	300-031	弹簧套件 spring kit
9	SH5001	校准器组件 calibrator assembly
4,6,18,19,25,26	300-032	模具架组件 die holder assembly
5,7,20,21	300-033	返弹组件 return spring assembly





SECTION 4



2. It is important to lubricate at least once per day;
每天至少润滑一次，以在每次需大批量扣压之前润滑最佳。

如图所示，润滑时机头必须张开一些；然后按照图示位置涂抹润滑脂，即 8 个模具底座之间以及银白色的缸套内部。只要涂上适量的润滑剂，机头常摩擦，易磨损的部位表面就会马上形成一层薄薄的保护膜，这时应当启动机器，使机头做“开-合-开-合”的空载运动 10-15 分钟，使得润滑剂得以充分接触表面。

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如果使用非本公司提供的不恰当的润滑剂，或润滑时没有按照上述的正确方法，都会引起机器损坏，严重影响扣压。