



概 况

Summary

KZ32型气动捆扎机系由上海冶金设计研究院在消化引进国外先进捆扎设备的基础上，并根据我国冶金工业产品在捆扎机具体情况设计而成。

本机特点：重量轻、操作简便、安全可靠。捆扎迅速、牢固、劳动强度低且捆扎效率高。只需一名操作人员便能完成捆扎钢带的抽紧、锁扣、剪断等全部动作。因此该设备能广泛适用于各种钢材及有色金属材料的捆扎包装。

Model KZ32 pneumatic bundling tool—desinged by Shanghai Metallurgy Design and Research Institute, is a tool based onthe experience of other countries in bundling machinces and on the specific application in metallurgical industry in China.

Characteristics: Lightweight, Simple operation, Safty and reliability, Fast and firm bundling, Lower intensity and efficiency. Only one operator, therefor this type of tool can be applied in bundling up many kinds of materials such as steel and nonferrous metal.

一、技术规范

Technical Specifications

1.使用空气压力 Air pressure:	0.4~0.6MPa
2.捆扎钢带规格 Steel strap type:	32×(0.8~1.2) mm
3.钢带抽紧速度: Tensioning speed:	4.2m/min
4.抽紧力 Tension:	≥9807N
5.夹口承受拉力 Pulling to the notch	≥1685N
6.设备重量 Weight of tool:	14kg
7.捆扎全过程平均耗气 Average air consumption during bundling:	1m³

二、安装要求

Installation

1.捆扎机通过平衡器吊挂在可旋转或可移动的横梁或悬臂上,使捆扎机能自由移动至被捆扎物体上方,操作高度可通过平衡器调节获得。

By the balance, this tool can be hung on the turning or moving overarm and can be removed over the top of the package freely. The operating height can be received from the balance.

2.使用该捆扎机时,车间内应具有0.4-0.6MPa的压缩空气气源,压缩空气需通过过滤器、压力调节阀、注油器(简称气源三联件)进入捆扎机。分支管路必须从总管上方分出,进气管内径为12.7mm。详见图一。

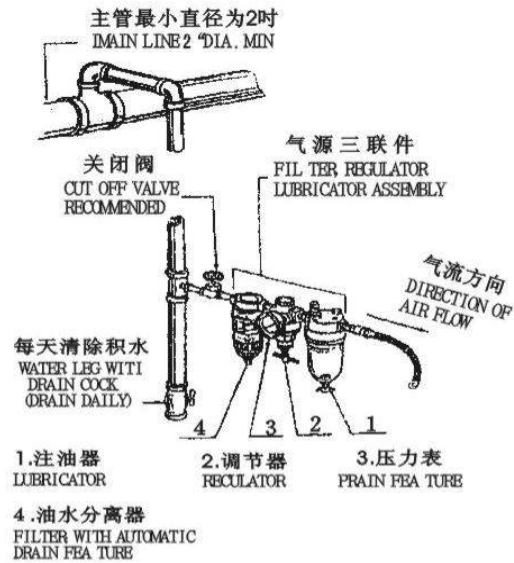


图1 (Fig1)

There should be a 0.4 to 0.6MPa compressed air source in the workshop. The compressed air should go into the tool through the filter. The regulator and the lubricator (called three-union in short) respectively. Branch lines are taken from the top of main. The air hose is 12.7mm I.D. See Fig. 1.

三、捆扎机使用方法及步骤

Operating Instructions

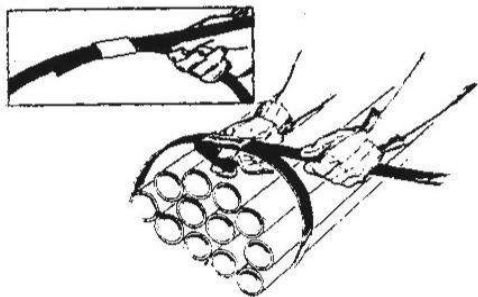


图2 (Fig2)

1.将锁扣套在捆扎机用的钢带上并将钢带绕物体一周后再插入锁扣,以形成上层和下层钢带,最后将下层钢带在离锁扣大约50mm处折过来。

见图二。

Pass the strap around the package then thread the lead end around and up and result it into the seal. This will result in creating a TOP STRAP and a BOTTOM STRAP. Bend about 50mm of the lead end of the BOTTOM STRAP back beneath the seal. see Fig. 2.

2.打开气源开关,按图3所示,移动捆扎机,使其接近被捆扎物体上方,将上层钢带置于送进压轮下,并将捆扎机向前推动,使锁紧扣与锁扣机构位置对正,此时捆扎机准备工作完毕。

Switch on the air source, move the tool (Fig.3) to the top of the package. Insert the TOP STRAP under the feedwheel, Push the tool forward until the front of the seal stop contacts the end of the seal. The Preparation is ended.

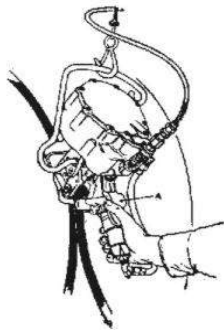


图4 (Fig4)

4.如想中途停机,应按下阀芯B(如图5所示),捆扎机便自行恢复原始状态。

If it is necessary to shut off the tool for a while during the tensioning portion of the cycle, push down the pawl pin B as indicated in Fig. 5, the tool can resume the previous state automatically.

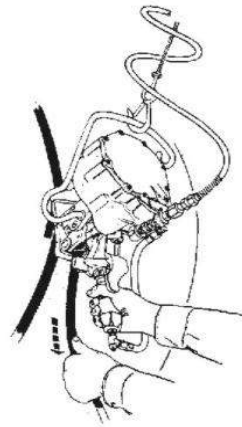


图3 (Fig3)

3.如图4所示,将手柄A往下压一下,此时,送进压轮压住钢带开始工作。当钢带抽紧时,再压一下手柄A,机器将会自动进行锁扣、剪断,此时,操作过程便告完成。

Press the operating lever A once while the strap pressed by the feedwheel is working. Press down the operating lever A one time again when the strap being tensioned. The tool will notch the seal/strap, cut off the TOP STRAP, after that, the operating is completed.

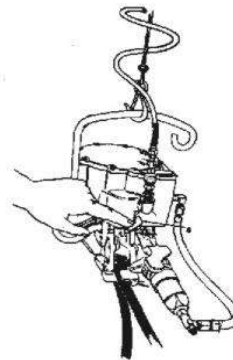


图5 (Fig5)



5.如需立式捆扎物体，可按图6所示操作。

If bundle the package vertically, operate the tool according to Fig.6.

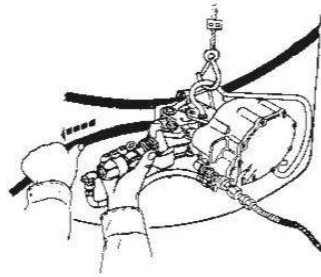


图6 (Fig6)

四、维护与保养 Maintenance

1.在发动机和缸体内必须经常保持适量的润滑油，为此，应在注油器中注满22#气轮机油，才能保持固定的供油量，当发动机运转时，从注油中下滴的润滑为40-60滴/min,此外，如果每班操作前，能有若干滴润滑油直接进入机器内，那将使操作更为顺利。注油器和过滤器每使用六个月应用煤油清洗一次。

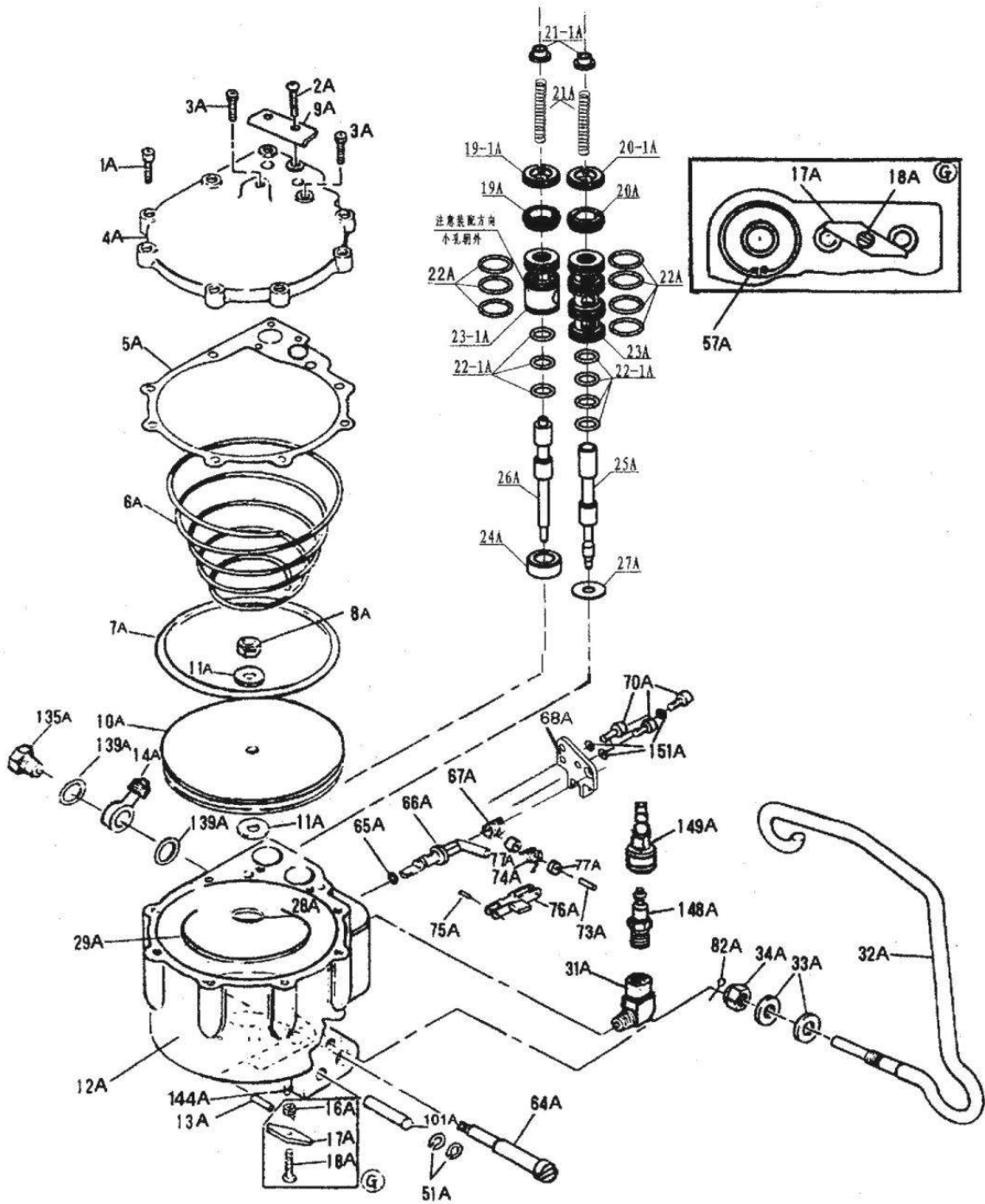
Fill the lubricator with 22# steam turbine oil to keep a quantity of lubricating oil in the motor and the cylinder when the motor is running. The oil must drop through the lubricator at a rate of 40 drops to 60 drops per minute, if some drops can be filled into the tool directly before daily operation, the operation will be successful. Clean the lubricator and the filter with Kerosene at least one time in six months during operation.

2.必须将压缩空气的压力调整在0.4-0.6MPa范围内，否则将造成气压不足，影响打包质量。
Adjusting the air pressure within the range of 0.4MPa to 0.6MPa to obtain enough air pressure, otherwise, the bundling quality will be affected.

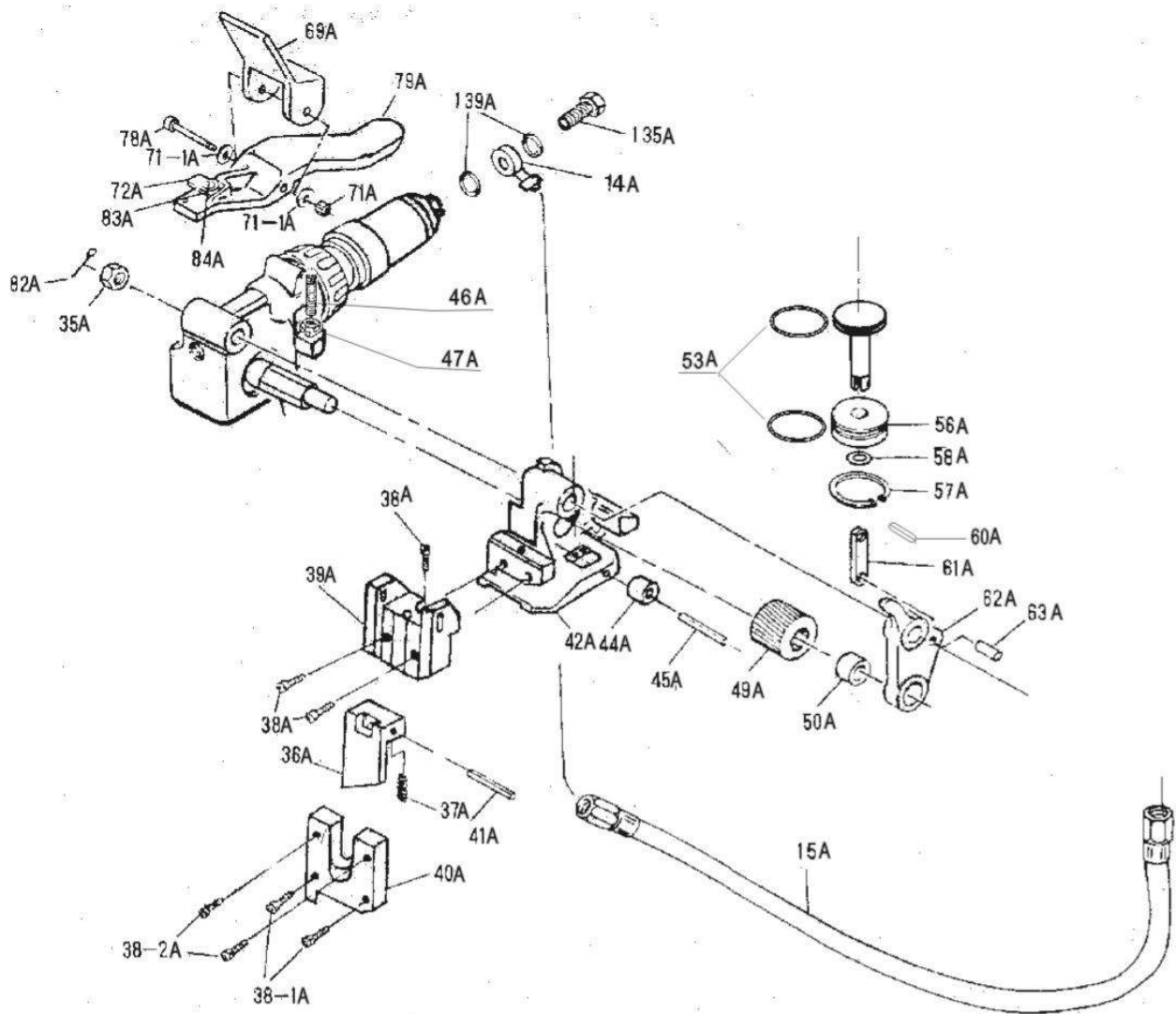
3.必须定期检查过滤器和压力调节阀，并定期排除过滤器中的积水。
Check the filter and the regulating valve regularly. Drain the water from the filter daily.

4.应注意送进压轮与滚轮之间的间隙是在0.5-0.7mm范围内，否则应予调整。
Be careful of the interval which is from 0.5mm to 0.7mm between the feedwheel and the gyrowheel, otherwise, it should be adjusted.

5.在使用期间应经常使滑动或转动部件保持适量的润滑油，并及时消除送进压轮上的铁屑。
During the operation, keep a quantity of lubricating oil in turning or rolling parts. Eliminate the iron filings on the feedwheel in time.

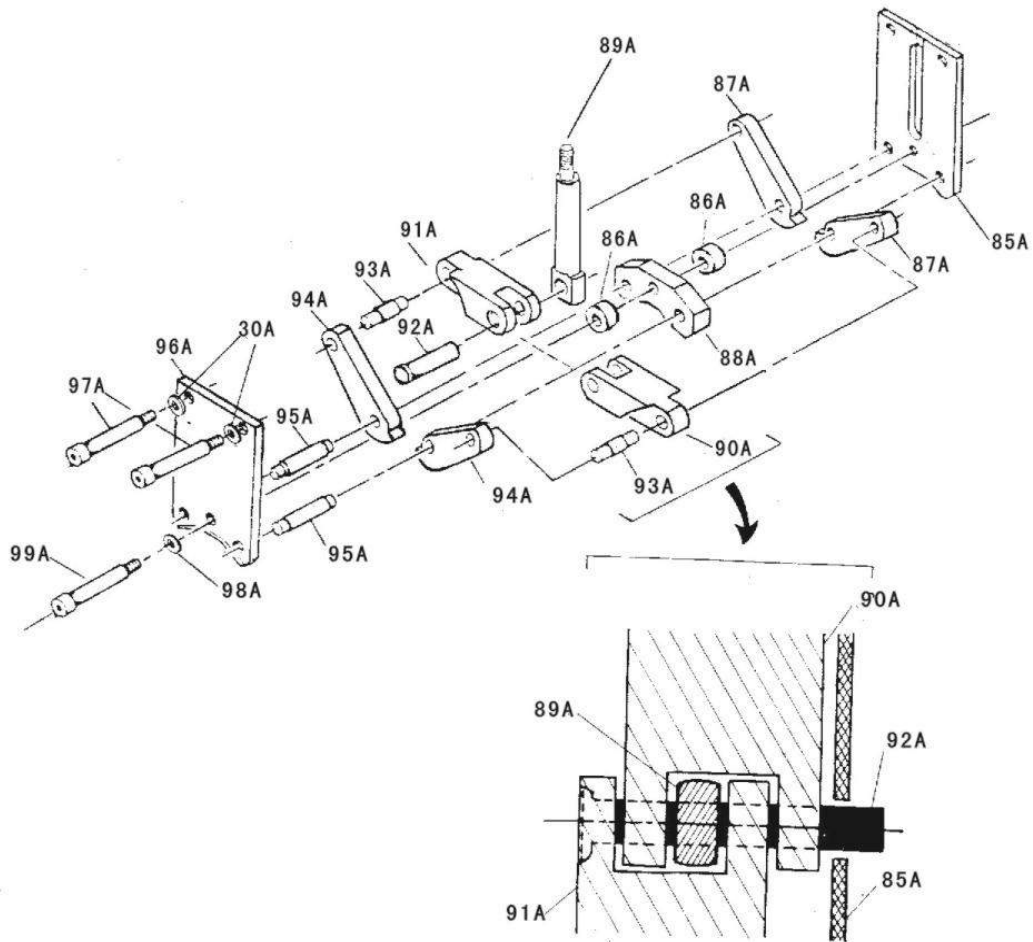


缸体总成解体图
General Disintegration F igure of the Cylinder



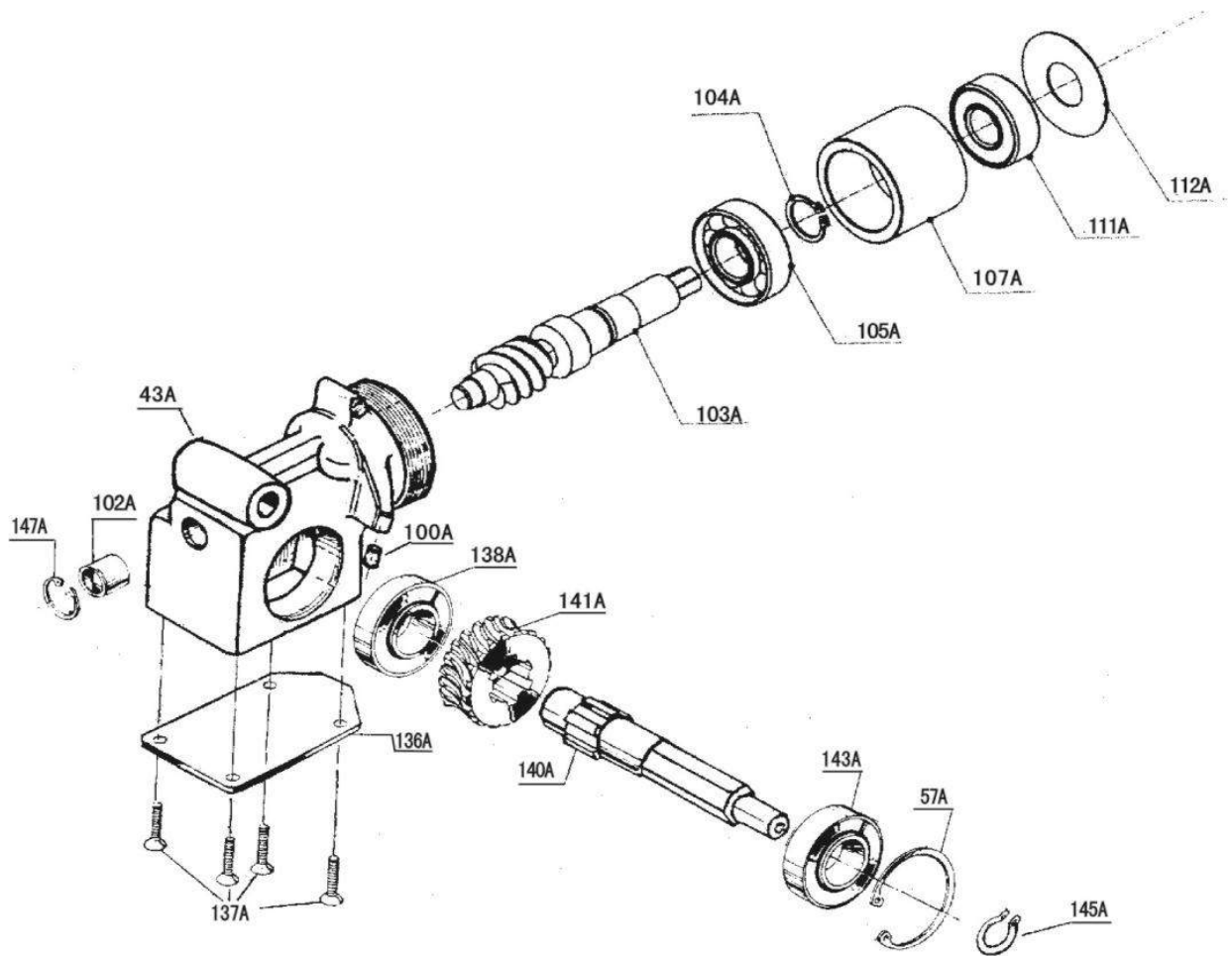
刀架总成解体图

General Disintegration Figure of the Rest



夹爪总成解体图

General Disintegration Figure of the jaw



蜗轮箱总成解体图

General Disintegration Figure of the Wormwheelbox





零件明细表

Parts List

序号 NO	名称 DESCRIPTION	规格 SPECIFICATION	数量 QTY.
1 A	内六角螺钉 A Socket head cap screw- A	M6×25	7
2 A	内六角螺钉 A Socket head cap screw- A	M5×30	2
3 A	内六角螺钉 A Socket head cap screw- A	M5×25	2
4 A	缸 盖 A Cylinder head-A		1
5 A	缸 盖 垫 A Cylinder gasket-A		1
6 A	截 锥 弹 簧 A Conical compression spring-A		1
7 A	大活塞密封环 A Piston 0-ring-A	φ5.7×157	1
8 A	螺 母 A Nut-A	M14	1
9 A	挡 风 板 A Guard-A		1
10 A	大 活 塞 A Piston-A		1
11 A	大活塞垫圈 A Piston washer-A		2
12 A	气 缸 体 A Cylinder-A		1
13 A	摆杆限位销 A Out link stop pin-A	φ6×20	1
14 A	软管接头 A Hose elbow-A		2
15 A	金属软管 A Metal hose-A		1
16 A	棱形片回位弹簧 A Prism returning spring-A		1
17 A	棱 形 片 A Prism-A		1
18 A	棱形片螺钉 A Prism shoulder screw-A		1
19 A	压 紧 螺 母 A Tight-Nut-A		1
19-1A	保 险 螺 母 A Insurance-Nut-A		1
20 A	压 紧 螺 母 A Tight-Nut-A		1
20-1A	保 险 螺 母 A Insurance-Nut-A		1
21 A	工作活塞弹簧 A Oper rating piston spring-A		2
21-1A	弹 簧 座 A Spring stand-A		2
22 A	密 封 环 A 0-ring-A	φ25× φ2.4	7
22-1A	密 封 环 A 0-ring-A	φ12.5× φ2.65	7
23 A	活 塞 套 A Piston sleeve-A		1



续 Continued

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY.
23-1A	活 塞 套 A Piston sleeve-A		1
24 A	下 套 筒 A Lower sleeve-A		1
25 A	长工作活塞 A Long operating piston-A		1
26 A	短工作活塞 A Short operating piston-A		1
27 A	长工作活塞垫圈 A Long operating piston washer-A		1
28 A	活塞杆密封环 A Piston shaft O-ring-A	$\phi 2.4 \times \phi 22$	1
29 A	缓 冲 环 A Cushion ring-A	$\phi 6 \times \phi 100$	1
30 A	弹 性 垫 圈 A Elastic washer-A	$\phi 10$	2
31 A	90度管接头 A 90 Degree elbow-A		1
32 A	攀 钩 A Hanger-A		1
33 A	垫 圈 A Washer-A	$\phi 12$	1
34 A	螺 母 A Nut-A	M12 \times 1.25	1
35 A	螺 母 A Nut-A	M10	1
36 A	刀 片 A Cutter-A		1
37 A	刀 片 弹 簧 A Cutter spring-A		1
38 A	内六角螺钉 A Socket head cap srew-A	M6 \times 12	3
38-1A	内六角螺钉 A Socket head cap srew-A	M5 \times 12	2
38-2A	内六角螺钉 A Socket head cap srew-A	M5 \times 10	2
39 A	刀 架 A Rest-A		1
40 A	刀 架 盖 板 A Rest cover-A		1
41 A	刀 片 销 A Cutter pin-A	$\phi 5 \times 55$	1
42 A	断 闭 座 A Seal stop stand-A		1
43 A	蜗 轮 箱 A Wormwheelbox-A		1
44 A	滚 轮 A Gyrowheel-A		1
45 A	滚 轮 轴 A Gyrowheel shaft-A		1
46 A	平 端 螺 钉 A Flat screw-A	M10 \times 15	1
47 A	圆 柱 头 螺 钉 A Cheese-head screw-A	M4 \times 30	1



续 Continued

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY.
47-1A	螺 母 A Nut-A	M4	1
48 A	卡 圈 A Block-A		1
49 A	送 进 压 轮 A Feedwheel-A		1
50 A	6941/12 滚针轴承 A 6941/12 Needle bearing-A		1
51 A	开 口 挡 圈 A Split hamper-A	$\phi 7 \times 1$	2
52 A	内六角螺钉 A Socket head cap screw-A	M8 \times 20	1
53 A	密 封 圈 A O-ring-A	$\phi 3.5 \times \phi 41$	2
54 A	提 升 活 塞 A Position piston-A		1
56 A	端 盖 A Cover-A		1
57 A	孔用弹性挡圈 A Hole-usage elastic hamper-A	$\phi 42 \times 1.5$	2
58 A	提升活塞杆密封环 A Position ram O-ring-A	$\phi 25 \times \phi 18.5$	1
59 A	提升活塞杆 A Position ram-A		1
60 A	销 A Roll pin-A	$\phi 5 \times 20$	1
61 A	连 杆 A Position link-A		1
62 A	摆 杆 A Out link-A		1
63 A	摆 杆 销 A Out link pin-A	$\phi 6 \times 30$	1
64 A	连接螺杆 A Pivot shaft-A		1
65 A	气门密封环 A Valve O-ring-A	$\phi 1.7 \times \phi 9.6$	1
66 A	阀芯(气门开关) A Valve switch-A		1
67 A	气 门 弹 簧 A Valve spring-A		1
68 A	固 定 板 A Cover plate-A		1
69 A	橡 胶 挡 板 A Rubber guard-A		1
70 A	内六角螺钉 A Socket head cap screw-A	M4 \times 12	3
71 A	螺 母 A Nut-A	M5	1
71-1A	垫 圈 A Washer-A	$\phi 5$	2
72 A	跳 板 A Gang plank-A		1
73 A	销 A Roll pin-A	$\phi 3 \times 20$	1



续 Continued

序号 NO	名称 DESCRIPTION	规格 SPECIFICATION	数量 QTY.
74 A	撞板回位弹簧 A Bump returning spring-A		1
75 A	销 A Roll pin-A	φ3×11	1
76 A	撞板 A Bump-A		1
77 A	辊子 A Roller-A		2
78 A	内六角螺钉 A Socket head cap screw-A	M5×55	1
79 A	开关板(手柄) A Lever assembly-A		1
80 A	螺钉 A screw-A		1
81 A	垫圈 A Washer-A		1
82 A	开口销 A Split pin-A	φ2×35	2
83 A	跳板弹簧 A Gang plank screw-A		1
84 A	弹簧固定销 A Spring shoulder pin-A		1
85 A	内侧板(有槽) A Rear side plate(slot in it)-A		1
86 A	前后垫块 A Spacer-A		2
87 A	R夹爪 A R-jaw-A		2
88 A	支架 A Notcher-A		1
89 A	活塞杆 A Ram-A		1
90 A	内叉头 A Rear sealer link-A		1
91 A	外叉头 A Front sealer link-A		1
92 A	传动销 A Ram pin-A		1
93 A	短销 A Short pin-A		2
94 A	F夹爪 A F-jaw-A		2
95 A	长销 A Long pin-A		2
96 A	外侧板 A Front side plate-A		1
97 A	固定螺钉 A Shoulder screw-A		2
98 A	垫圈 A Washer-A	φ8	1
99 A	内六角螺钉 A Socket head cap screw-A	M8×60	1
100A	碰块销 A Pin-A	φ8×12	1



续 Continued

序号 NO	名 称 DESCRIPTION	规 格 SPECIFICATION	数 量 QTY.
101A	缸体长销 A Cylinder pin-A		1
102A	滚针轴承(6941/10) A Needle bearing(6941/10)-A	$\phi 10 \times \phi 16 \times 10$	1
103A	蜗 杆 A Worm-A		1
104A	轴用弹性挡圈 A Shaft-usage elastic hamper-A	$\phi 17 \times 1$	1
105A	轴承(36203) A Bearing(36203)-A	$\phi 17 \times \phi 40 \times 12$	1
106 A	行星轮座 A Planetarywheel stand-A		1
107 A	隔 套 A Sleeve-A		1
108 A	轴 承 A Bearing-A	$\phi 17 \times \phi 35 \times 10$	1
109 A	行星齿轮 A Epicyclic gear-A		4
110 A	内 齿 圈 A Internal teeth-A		1
111 A	轴 承 A Bearing-A	$\phi 15 \times \phi 35 \times 11$	1
112 A	垫 圈 A Washer-A		1
113 A	内 齿 圈 A Gear washer-A		1
114 A	行星轮座垫圈 A Planetarywheel stand washe-A		1
115 A	太阳轮垫圈 A Sunwheel washer-A		1
116 A	轴 承 A Bearing-A	$\phi 12 \times \phi 28 \times 8$	1
117 A	齿 轮 轴 A Gear shaft-A		4
118 A	轴 承 座(-) A Bearing-A		1
119 A	滚 针 轴 承 A Needle bearing-A	$\phi 6 \times \phi 10 \times 10$	4
120 A	太 阳 轮 A Sunwheel-A		1
121 A	轴 承 A Bearing stand-A	$\phi 15 \times \phi 32 \times 8$	1
122 A	前 支 承 圈 A Front shoulder ring-A		1
123 A	轴 承 A Bearing-A	$\phi 10 \times \phi 30 \times 9$	1
124 A	转 子 轴 套 A Front shoulder ring-A		1
125 A	轴 承 座 (二) A Bearing Stand-A		1
126 A	转 子 A Rotator-A		1
127 A	后 支 承 圈 A Rear shoulder ring-A		1





续 Continued

序号 NO	名称 DESCRIPTION	规格 SPECIFICATION	数量 QTY.
127-1A	后支承圈垫片 A Rear shoulder ring spacer-A		1
128 A	轴 承 A Bearing-A	$\phi 9 \times \phi 26 \times 8$	1
129 A	缓 气 圈 A Cushion ring-A		1
130 A	偏 心 套 A Eccentric sleeve-A		1
131 A	叶 片 A Vane-A		5
132 A	叶 片 腔 A Vane cavity-A		1
133 A	轴 承 A Bearing-A	$\phi 15 \times \phi 32 \times 9$	1
134 A	叶片腔盖 A Vance cavity head-A		1
135 A	进 气 螺 钉 A Air entrance screw-A		1
136 A	底 板 A Base-A		1
137 A	沉 头 螺 钉 A Raised-head screw-A	M5×10	4
138 A	轴 承 (104) A Bearing(104)-A	$\phi 20 \times \phi 42 \times 12$	1
139 A	垫 圈 A Washer-A	$\phi 12 \times \phi 18 \times 1$	2
140 A	蜗 轮 轴 A Wormwheel shaft-A		1
141 A	蜗 轮 A Wormwheel-A		1
142 A	内六角螺钉 A Socket head cap screw-A	M5×16	1
143 A	轴承 (60104) A Bearing(60104)A	$\phi 20 \times \phi 42 \times 12$	1
144 A	平 端 螺 钉 A Flat screw-A	M5×5	1
145 A	轴用弹性挡圈 A Shaft-usage elastic hamper-A	$\phi 20 \times 1$	1
146 A	定 位 销 A Position pin-A		2
147 A	孔用弹性挡圈 A Hole-usage elastic hamper-A	$\phi 16 \times 1$	1
148 A	进 气 接 头 A Air entrance joint-A		1
149 A	快速连接接头 A Quick connection joint-A		1
151 A	弹 性 垫 圈 A Elastic washer-A	$\phi 4$	3



KZ-32气动捆扎机装箱单 KZ-32 Pneumatic Bundling TOOL Shipment		共1页 Total:One page	
		第1页 NO.1	
出厂编号 Number of production	箱号 Box number	箱体尺寸 Volume of box 500×300×320	
		毛重 Gross weight 15Kg	净重 Net weight 14Kg
附件 Appendix	数量 QTY	密封圈 Total seals	数量 QTY
送进压轮 Feedwheel	1	φ1.7× φ9.6	1
		φ6× φ100	1
塑料防尘罩 Plastic dust cover	1	φ2.4× φ22	1
		φ5.7× φ157	1
合格证 Quality certificate	1	φ12.5× φ2.65	7
		φ25× φ2.4	7
产品使用说明书 Operation manual	1	φ3.5× φ41	2
		φ2.5× φ18.5	1
装箱日期 Date of shipment		装箱检验员 Inspector	
公司地址 Address		邮政编码 Post code	
		电话 Tel.	
		传真 Fax	