

中空玻璃生产线注意事项

Precautions for insulating glass production line

一、玻璃清洗机

Glass washing machine

1. 设备应安装在干燥、无粉尘、无腐蚀性气体、温度在 10-40℃ 的室内。

The equipment should be installed in a dry room without dust or corrosive gas, and the temperature should be 10-40℃.

2. 设备必须安装地线，应选用规格 4 平方毫米的软铜芯绝缘线，接地电阻不大于 4Ω。

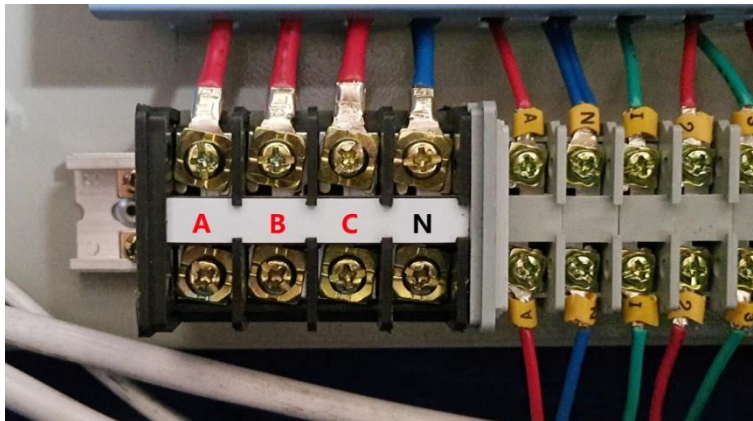
A ground cable must be installed with a soft copper core insulated wire of 4 mm square and with a ground resistance of no more than 4Ω.

3. 请使用纯净水清洗玻璃，当水中出现杂质时更换（约制作 400 平方中空玻璃）。

Please clean the glass with pure water. When impurities appear in the water, the water should be replaced (about 400 square insulating glass production).

4. 传动辊转动方向是否与玻璃行进方向一致，如果不一致，请调整电源的接电顺序。（A、B、C 三根电源线中的任意两根。）

Check whether the rotation direction of the drive roller is the same as that of the glass. If not, adjust the power connection sequence. (Any two of the three power cords A, B, and C.)



5. 运行状态下调整清洗机的运行速度。停止时不能进行调速。

The running speed of the glass washing machine can be adjusted under the running state; The speed of the machine cannot be adjusted when it is stopped.



6. 设备第一次使用前，需泡开吸水辊。吸水辊的海绵处于完全蓬松状态时，关闭水阀。

If the machine is used for the first time, the suction roller needs to absorb enough water. When the sponge of the suction roll is in a completely fluffy state, close the water valve.

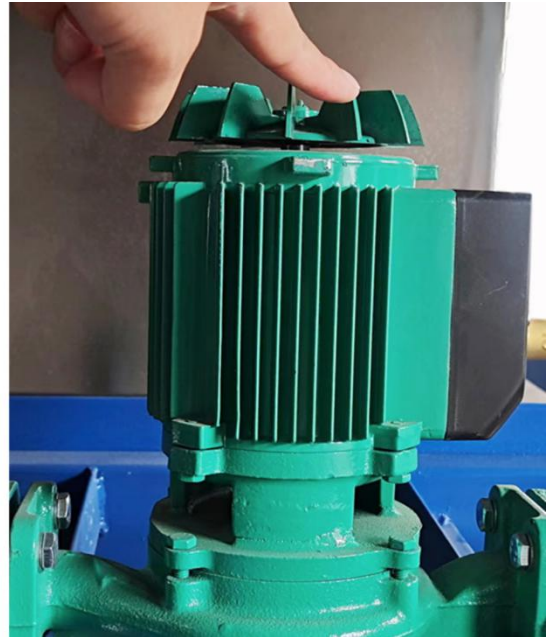


7. 吸水海绵辊严禁与油接触。

Absorbent sponge roller is strictly prohibited from contacting with oil.

8. 清洗机长时间未用，启动前，手动旋转水泵叶轮，顺畅后方可启动。

If the cleaning has not been used for a long time, manually rotate the pump impeller before starting again, and it can be started after running smoothly.



9. 清洗玻璃尺寸不得小于 $400 \times 400\text{mm}$ 。

The size of the cleaned glass shall not be less than $400 \times 400\text{mm}$.

10. 连续清洗时，两块玻璃之间的距离不能太近，最小不得少于 100mm 。

Continuous cleaning, the distance between the two pieces of glass can not be too close, the minimum should not be less than 100mm .

11. 传送辊两端轴承每周注油一次。

Oil the bearings at both ends of the transfer roller once a week.



二、中空玻璃气浮台

Air float table

1. 设备应安装在干燥、无粉尘、无腐蚀性气体、温度在 10-40℃ 的室内。

The equipment should be installed in a dry room without dust or corrosive gas, and the temperature should be 10-40℃.

2. 设备必须安装地线，其规格应选用 2 平方毫米的软铜芯绝缘线，接地电阻不大于 4Ω。

A ground cable must be installed with a soft copper core insulated wire of 2 mm square and with a ground resistance of no more than 4Ω.

3. 设备接电后，如发现气浮台吹风和吸风能力小，请重新调换任意两根电源线位置。

After the machine is connected to power, if it is found that the blowing and suction capacity of the air floating platform is weak, please replace the position of any two power cables.

三、中空玻璃翻转合片台

Air Float Tilting Table

1. 设备应安装在干燥、无粉尘、无腐蚀性气体、温度在 10-40℃ 的室内。

The equipment should be installed in a dry room without dust or corrosive gas, and the temperature should be 10-40℃.

四、中空玻璃热压机

Hot press machine

1. 设备应安装在干燥、无粉尘、无腐蚀性气体、温度在 10-40℃ 的室内。

The equipment should be installed in a dry room without dust or corrosive gas, and the temperature should be 10-40℃.

2. 设备必须安装地线，其规格应选用 6 平方毫米的软铜芯绝缘线，接地电阻不大于 4Ω。

A ground cable must be installed with a soft copper core insulated wire of 6 mm square and with a ground resistance of no more than 4Ω.

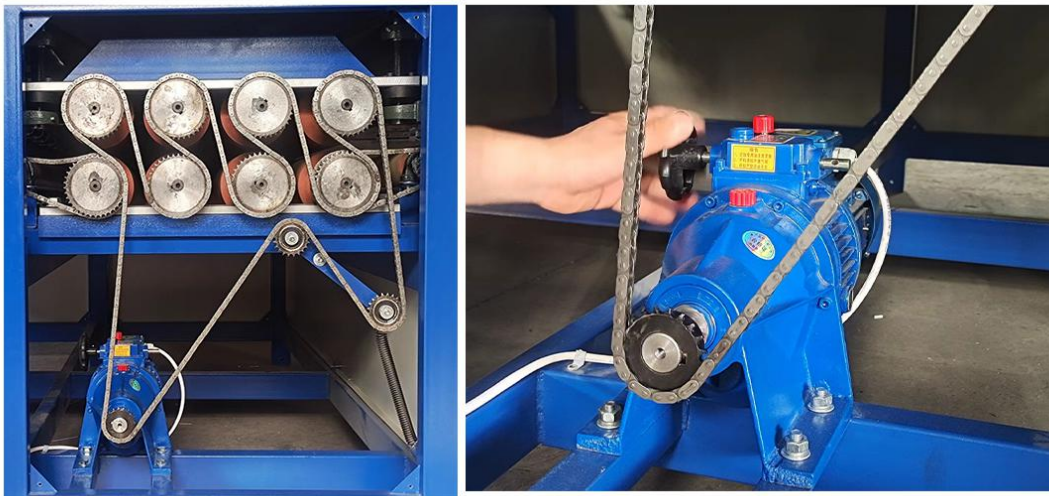
3. 传动辊转动方向是否与玻璃行进方向一致，如果不一致，请调整电源的接电顺序。(A、B、C 三根电源线中的任意两根。)

Check whether the rotation direction of the drive roller is consistent with that of the glass. If not, adjust the power connection sequence. (Any two of the three power cables A, B and C.)



4. 设备在出厂前已调制好速度，请不要随意更改速度，如需更改，请在运行状态下调整热压速度，设备停止时不能进行调速。

The speed of the machine has been modulated before leaving the factory. Please do not change the speed at will. If you need to change the speed, please adjust the hot pressing speed under the running state, you shouldn't speed the machine when it stops.



5. 热压机的尺寸=单片玻璃+胶条尺寸+单片玻璃

Size of hot press machine = glass size + spacer size + glass size



6. 中空玻璃菱形进入热压机，确保热压更均匀。并且封口处后进入，防止中空玻璃内部高温，压强变大，中空玻璃炸裂。

To ensure more uniform hot pressing, insulating glass should be diamond shaped into the hot press. And the sealing interface is finally entered, to prevent the internal high temperature of the insulating glass, when the pressure is increased, the insulating glass will be cracked.



(操作不当，导致中空玻璃炸裂)
(Improper operation, resulting in the explosion of the insulating glass)

7. 通常情况下，春夏秋三季热压机加热温度大约在 160℃-170℃。冬季热压机加热温度大约在 200℃。但实际加热温度要以中空玻璃出热压机后胶条表面温度为准，该温度为 43℃-50℃。如低于该温度，请调高加热温度。如高于该温度，请调低加热温度。

Under normal circumstances, spring, summer and autumn hot press heating temperature is about 160 °C -170 °C . The heating temperature of hot press machine in winter is about 200 °C . However, the actual heating temperature shall be subject to the surface temperature of the sealing spacer after the insulating glass leaves the hot press, which is 43°C -50°C . If the temperature is lower than this, please increase the heating temperature. If the temperature is higher than that, lower the heating temperature.

Spring, summer, autumn (160-170℃)

Winter (200℃)

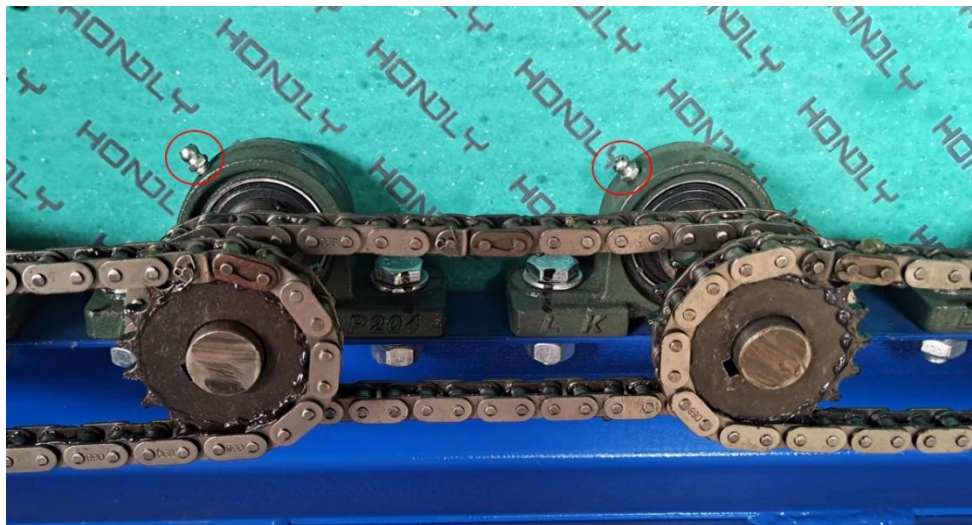
春夏秋 (160-170℃)

冬季 (200℃)



8. 传送辊两端轴承每周注油一次。

Oil the bearings at both ends of the transfer roller once a week.



结束

THE END