



概述

Summary

GSC32 气动捆扎拉紧机和DYA32 气动捆扎锁扣机是一种优质新颖的机械化程度较高的打包工具，二机必须联合使用才能完成全部捆扎动作（拉紧，锁扣，折断）

Pneumatic bundling tensioner GSC32 and pneumatic bundling sealer DYA32 are novel bundling tools which have high level of mechanization. Those two tools should be united that all actions of tensioning, sealing and breaking can be finished.

本机是一种气动式捆扎工具，具有重量轻，操作简便，安全可靠，捆扎迅速牢固等特点，而且劳动强度较低，适用于对钢材，管材，板材等物件的捆扎。

Those combined tools are pneumatic powered tools, which have many characteristics such as light weight, easy operation, safety and good performance. They can be applied for bundling steel, tube, plate and etc.

一、技术参数

Technical Specification

GSC-32 型气动捆扎拉紧机

pneumatic bundling tensioner GSC-32

使用空气压力:	
Air pressure:	0.4 - 0.6 Mpa
钢带规格:	
Tape size :	(19-32)x(0.8-1.2)mm
拉紧力:	
Tension:	≥10kN/0.6Mpa
整机重量:	
N.W. :	4.8kgs

DYA32 型气动捆扎锁扣机

pneumatic bundling sealer DYA32

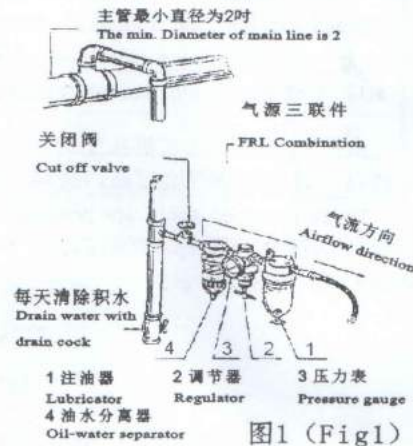
使用空气压力:	
Air pressure:	0.4 - 0.6 Mpa
钢带规格:	
Tape size :	32x(0.8-1.2)mm
锁扣部分抗拉强度:	
Tension stress of the seal:	≥16.8kN
整机重量:	
N.W. :	3.1KGS

二、安装要求

Installation

使用该捆扎机时, 车间内应具有 $0.8\text{m}^3/\text{min}$ 气流量和 $0.4\text{--}0.6\text{Mpa}$ 的压缩空气源, 捆扎全过程平均耗气约为 1m^3 。压缩空气需通过油水分离器, 压力调节阀, 注油器(简称气源三联件)进入捆扎机。每条分支管路, 应从总管上部引出, 分支管路的内径大致为 14mm 。详见图 1。

There should have $0.8\text{m}^3/\text{min}$ air flow and $0.4\text{--}0.6\text{Mpa}$ compressed air source in the workshop. The average air consumption during bundling is 1m^3 . The compressed air should go into the tool through the filter, regulator and lubricator (called air units in short) respectively. Each branch line are taken from the top of mainline. Its inner diameter is about 14mm . See Fig.1



三、使用方法及步骤

Using methods and procedures

1.如图 2 所示, 先将锁扣套在捆扎用的钢带上, 并将钢带绕物体一周再插入锁扣, 在离锁扣外大约 50mm 处翻折。

1.As indicated in Fig. 2, put a buckle thread the strap, encircle the bundle and rethread the strap end through the seal. Bend the strap back under the seal about 50mm .

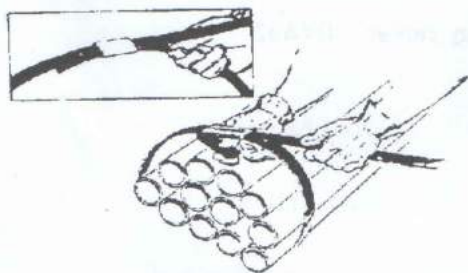


图2 (Fig2)

2.如图 3 所示, 握住减速箱体, 并用大拇指按下松带手柄 A, 将穿过扣子的上层钢带插入收紧滚轮和滚动板齿之间, 然后松开手柄。

2.Hold the deceleration box, press ungird handler A with the thumb. Place the top strap into the interval between feed wheel and rolling plate teeth, then loose ungird handler A as shown in Fig. 3

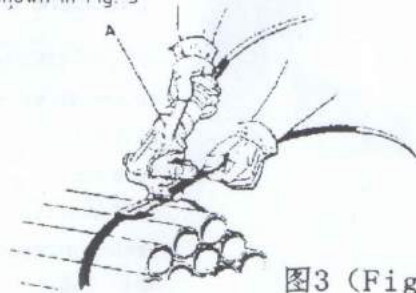


图3 (Fig3)

3.减速箱体尾部的调速阀具有停止,半开,全开三档位置,如图4所示,顺时针方向旋转调速阀,收紧滚轮转动并将穿过扣子的钢带拉紧到饱和状态时,收紧滚轮便停止转动,但调速阀仍固定在“全开”位置上。

3.At the end of deceleration box, as per Fig. 4, there are three grades of speed control valve: stop,semi-operate,operate. Move speed control valve clockwise, feed wheel start turn and tension the steel strap to saturation state until feed wheel stop turning, but speed control valve is still fixed on“operate”

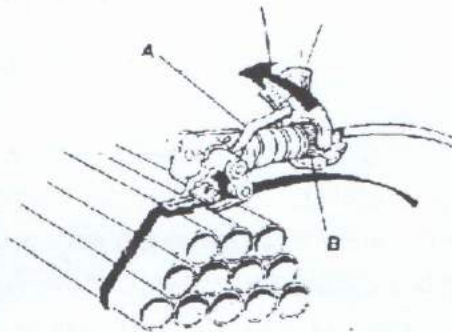


图4 (Fig4)

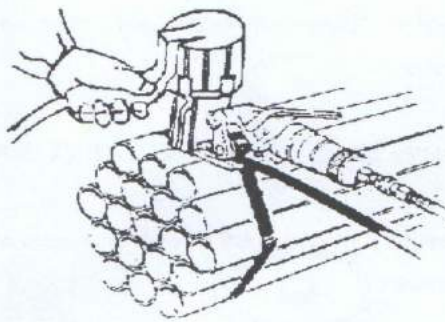


图5 (Fig5)

4.如图5所示,将锁扣机的活动钳口放在扣子上,按下主阀杆使锁紧机进行锁紧动作,作业完毕,松开主阀杆,锁扣机工作结束。

4.Place the moving jaw of sealer on the buckle, press main valve stem to lock the seal. After that, loose the main valve stem. Refer to Fig.5.

5.如图6所示,将拉紧机做向上垂直位置的倾斜动作,以折断钢带。钢带折断后即将调速阀做逆时针方向旋转到“停止”位置上。

5.Break the steel strap by sloping the tensioner vertically.Then move speed control valve anticlockwise to the position of “stop” See Fig. 6.

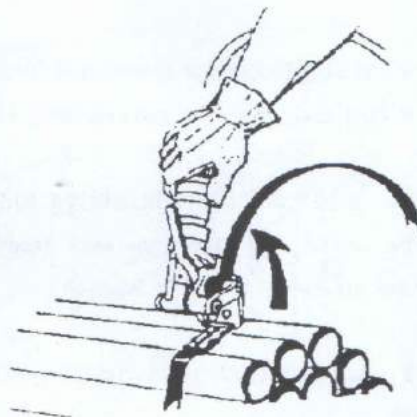


图6 (Fig6)



四、维护和保养

Maintenance

1、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#汽轮机油，才能保持固定的供油量，当发动机运转时，从注油器中下滴的润滑油为 40-60 滴/分钟，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 6 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 cylinder. The oil must be dropped through the lubricator at a rate of 40 drops to 60 drops per minute when the motor is running. Anyhow, if some drops will be filled into the tool directly before daily operation, that will be more better for operation. Clean the lubricator and filter with kerosene at least one time in 6 months during operation.

2、必须将压缩空气的压力调整在 0.4MPa- 0.6MPa 范围内，否则将造成气压不足，影响打包质量。

It must adjust the air pressure within the range of 0.4MPa to 0.6MPa to obtain enough air pressure, otherwise, it will effect the working performance.

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

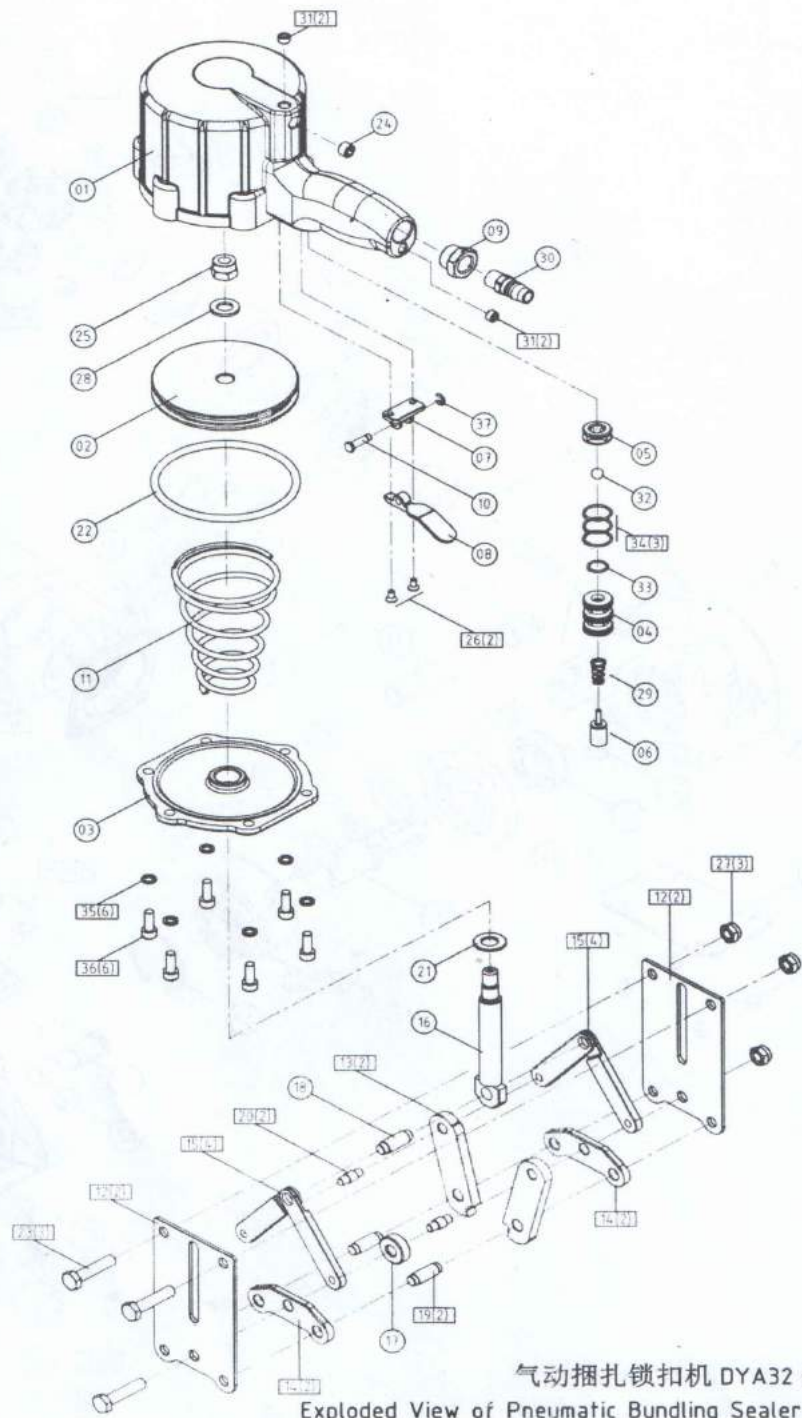
It must check the filter and regulating valve regularly and drain the water from filter daily.

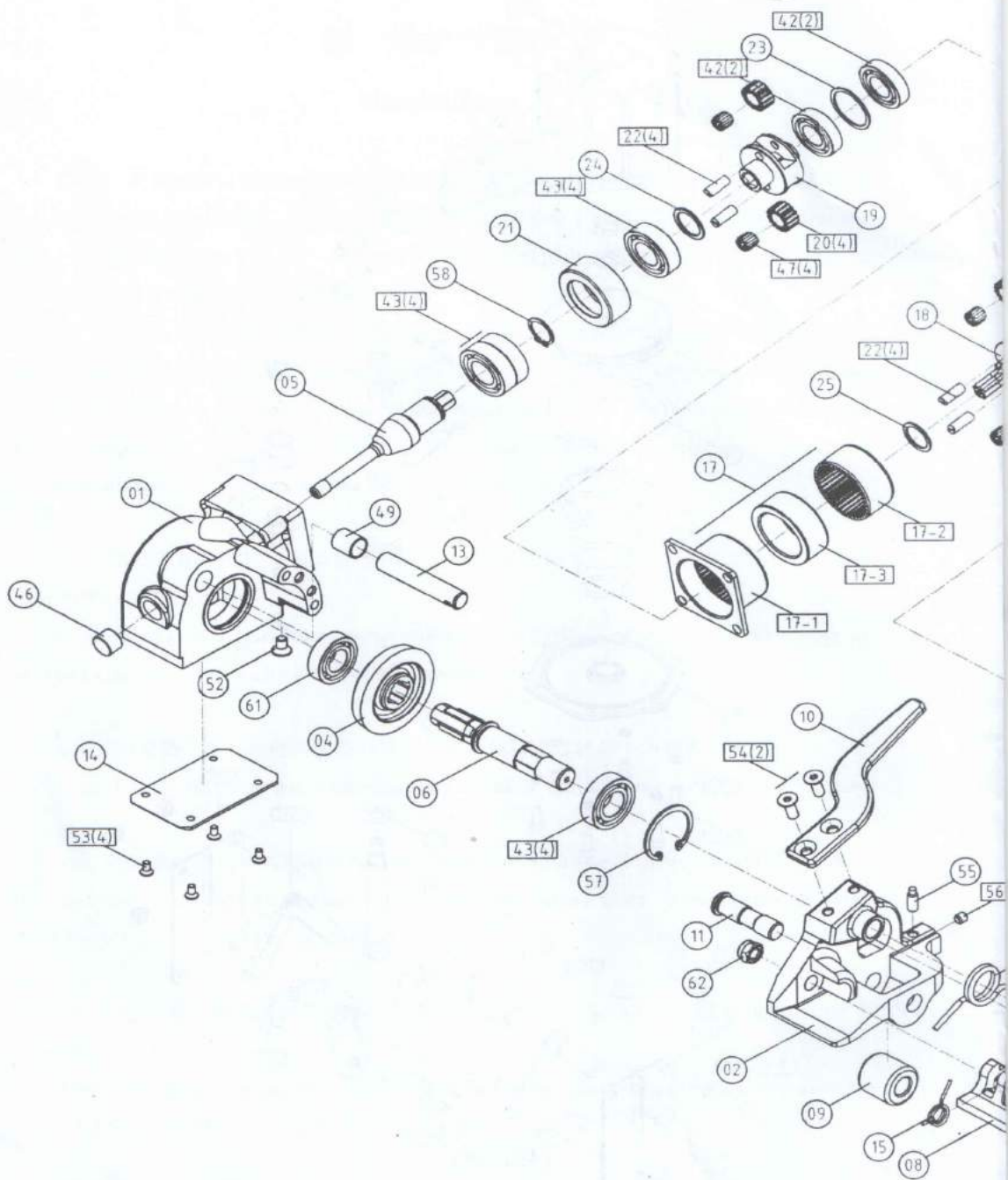
4、应注意收紧滚轮和滚动板齿之间的间隙是在 0.1-0.3mm 范围内，否则应予以调整

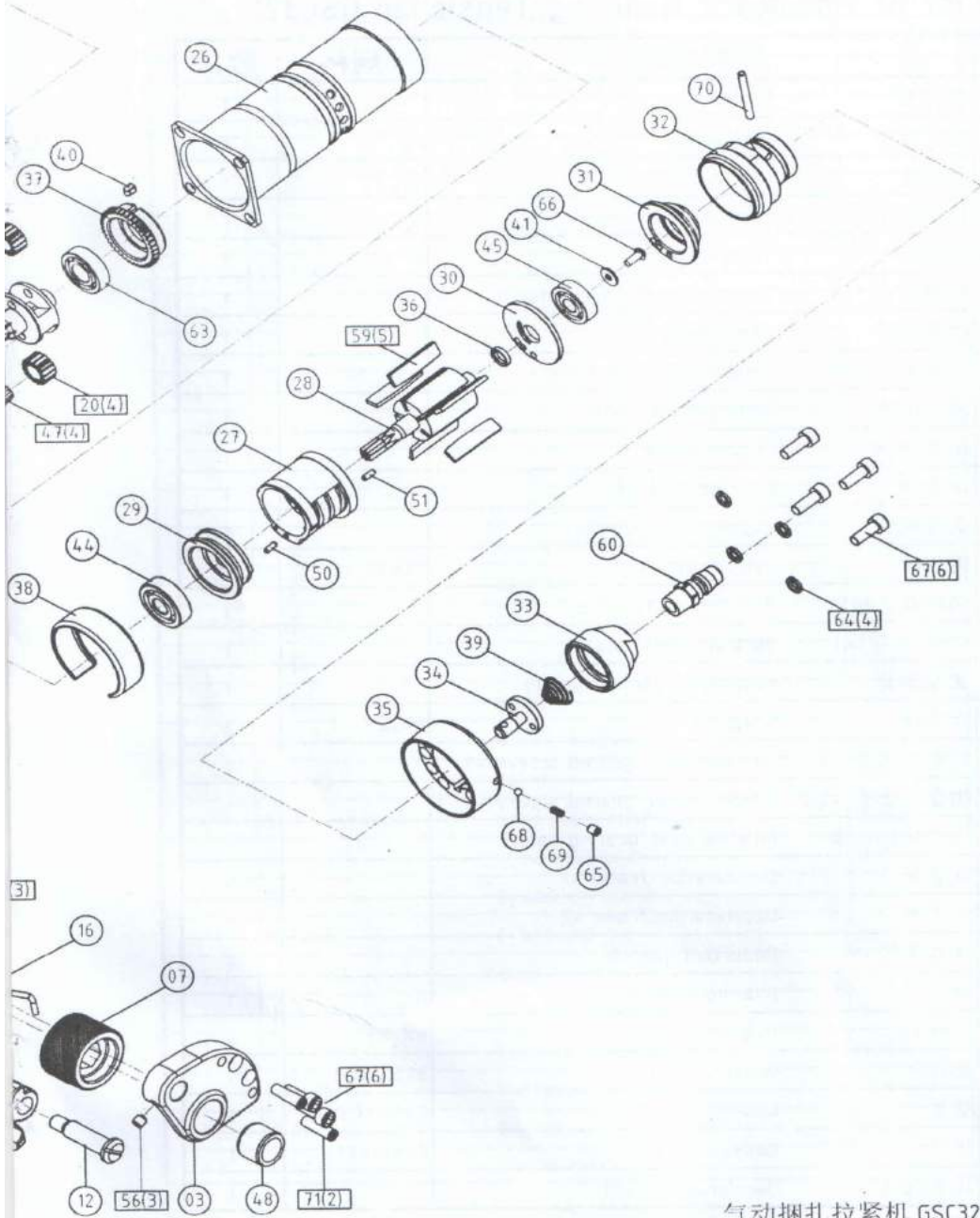
Be careful the interval between feed wheel and rolling plate teeth should be within 0.1-0.3mm, otherwise, it need be adjusted.

5、在使用期间,滑动或转动部件保持有适量的润滑油，并及时消除收紧滚轮上的铁屑及杂物。

During the operation, please keep a quantity of lubricating oil in turning or rolling parts. Eliminate the iron filing and others on the feed wheel in time.







气动捆扎拉紧机 GSC32 分解图
Exploded View of Pneumatic Bundling Tensioner GSC32



GSC32气动拉紧机零部件清单

Part List of Pneumatic Bundling Tensioner GSC32

序号	零件名称		规格	数量
1	蜗轮箱	Gearbox		1
2	收紧底座	String base		1
3	左箱盖	Left case cover		1
4	锥蜗轮	Tapered worm wheel		1
5	锥蜗杆	Tapered worm		1
6	锥蜗轮轴	Tapered worm wheel shaft		1
7	收紧滚轮	Feed wheel		1
8	收紧支撑板	Tensioning support plate		1
9	滚动板齿	Rolling plate teeth		1
10	松带手柄	Ungird handle		1
11	滚齿轴	Gear hobbing axis		1
12	支撑板销	Support boarded pin		1
13	圆柱销	Cylindrical pin	12X63	1
14	涡轮箱底板	Turbine volute base		1
15	弹簧[支撑板]	Spring(support plate)		1
16	底座扭簧	Foundation torsion spring		1
71	台阶销	Step pin	6X22	2
17-1	组合内齿套 -1	Combine inner geared sleeve -1		1
17-2	组合内齿套 -2	Combine inner geared sleeve -2		1
17-3	内齿轮轴承套	Internal gear bearing holder		1
18	减速架-1	Deceleration frame -1		1
19	减速架-2	Deceleration frame -2		1
20	减数齿轮-16	Reduction gear-16		4
21	轴承衬套	Bearing liner		1
22	圆柱销	Cylindrical pin	6X16.5	4
23	垫片	Gasket	31.5X26X1	1
24	垫片	Gasket	23.5X17.5X1.2	1
25	垫片	Gasket	21.5X16X1.2	1
26	减速机壳	Deceleration shell		1



序号	零件名称	规格	数量	
27	气缸	Cylinder	1	
28	转子	Rotor	1	
29	气缸前盖	Cylinder front cover	1	
30	气缸后盖	Cylinder rear cover	1	
31	气缸轴承盖	Cylinder bearing cover	1	
32	气腔	Air cavity	1	
33	气腔盖	Air cavity cover	1	
34	节流阀	Throttling valve	1	
35	调速阀	Speed control valve	1	
36	转子环	Rotor ring	1	
37	隔圈	Space ring	1	
38	节流套	Orifice sleeve	1	
39	螺旋弹簧	Helical spring	1	
40	平行键	parallel key	4X8	1
41	平垫片	Flat gasket	5.2X14X1.5	1
42	轴承	Bearing	16002	2
43	轴承	Bearing	6003	4
44	轴承	Bearing	6200	1
45	轴承	Bearing	629	1
46	滚针轴承	Needle bearing	BKH0810	1
47	保持架	Retainer	K6X10X9	4
48	固体润滑轴承	Solid lubrication bearing	152116	1
49	复合轴承	Composite bearing	1215	1
50	圆柱销	Cylindrical pin	3X8	1
51	圆柱销	Cylindrical pin	3X10	1
52	沉头铆钉	Sunk head rivet	6X10	1
53	十字槽沉头螺钉	Cross head screw	M4X8	4
54	内六角沉头螺钉	Countersunk head screw	M6X16	2
55	内六角紧定螺钉	Fastening screw	M6X16	1
56	内六角紧定螺钉	Fastening screw	M6X6	3
57	孔用弹性挡圈	Circlip for hole	35	1



序号	零件名称	规格	数量	
58	轴用弹性挡圈	Circlip for shaft	17	1
59	叶片	Blade		5
60	进气接头	Inlet connection		1
61	轴承	Bearing	6002	1
62	六角锁紧螺母	Hexagonal locknut	M8	1
63	轴承	Bearing	6001	1
64	弹性垫圈	Elastic washer	6	4
65	紧定螺钉	Set screw	M5X6	1
66	内六角半圆头螺钉	Hexagon socket button head screw	M5X12	1
67	内六角圆柱头螺钉	Hexagon socket head cap screw	M6X16	6
68	钢珠	Steel ball	4	1
69	棘爪弹簧	Clickspring		1
70	圆柱销	Cylindrical pin	4X35	1



DYA32气动锁扣机零件清单

Part List of Pneumatic Bundling Sealer DY A32

序号	零件名称	规格	数量
1	主缸 Cylinder		1
2	活塞 Piston		1
3	主缸盖 Master cylinder cover		1
4	主阀 Main valve		1
5	阀门盖 Valve caps		1
6	主阀杆 Main valve stem		1
7	主阀按钮座 Main valve button seat		1
8	主阀按钮 Main valve button		1
9	接头座 Plinth		1
10	销[按钮] Pin(button)		1
11	活塞弹簧 Piston spring		1
12	钳口盖板 Jaw cover plate		2
13	活动钳口 Moving jaw		2
14	固定钳口 Regular jaw		2
15	连杆 Connecting rod		4
16	活塞杆 Piston rod		1
17	钳口垫 Jaw gasket		1
18	销-活塞杆 Pin-piston rod		1
19	销-钳口 Pin-jaw		2
20	销-连杆 Pin-connecting rod		2
21	垫片 Gasket	22X11.5X2	1
22	O型圈 O-ring	90x5.3	1
23	六角头螺栓 Hexagon headed bolt	M8X35	3
24	紧定螺钉 Set screw	M10X8	1
25	防松螺母 Locknut	M10	1
26	内六角沉头螺钉 Countersunk head screw	M4X8	2
27	防松螺母 Locknut	M8	3
28	平垫片 Flat gasket	10	1
29	主阀杆[弹簧] Main valve stem(spring)		1



序号	零件名称		规格	数量
30	进气接头	Inlet connection		1
31	紧定螺钉	Set screw	M8X6	2
32	尼龙球	Nylon ball	8	1
33	O型圈	O-ring	11.5×1.5	1
34	O型圈	O-ring	17X1.5	3
35	弹性垫圈	Elastic washer	6	6
36	内六角圆柱头螺钉	Hexagon cap screw	M6X16	6
37	E型挡圈	E-retainer ring	4	1