

Qingdao Hongshenghong Machinery Co.,Ltd

R-RP-R-RP1000

Double Side Wide Belt Sanding Machine

User Manual

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1. Usage and Main Structure

This machine is used to do surface sanding on multiply wood, block board, fiber board, shaving board, veneer, wood panel, frame and marble etc..

The machine is mainly composed of the frame, input device, elevating device, electrical and auto control device, dust suction device.

2. Basic data

Model	R-RP-R-RP1000
Max .working width	100cm
Min. Working length	50cm
Max .working thickness	0.3-11cm
Speed of conveyor belt	6-30m/min
Total motor power	55.74kw
No.1 upper abrasive belt power	15kw
No.2 upper abrasive belt power	11kw
Power of upper conveyor belt	1.5kw
Power of upper lifting	0.37kw
No.1 lower abrasive belt power	15kw
No.2 lower abrasive belt power	11kw
Power of lower conveyor belt	1.5kw
Power of lower lifting	0.37kw
Diameter of rollers	19cm
Size of abrasive belt	102*200cm
Working pressure	0.6Mpa
Consumption of Compressed air	8000m ³ /h
Overall dimensions	380*190*210cm
Net weight	4000KG

3. Installation

Open the package and check damage during transportation, then clean the machine. The machine shall be put in large space.

Note: Large space shall be reserved on the right side of the machine to install sand belt.

Put about 200*200mm steel sheets on floor and the four corner adjusting bolts, the sheets shall be at least 12mm, adjust the bolts to get absolute level. Put an accurate frame level on the left and right surface of the base to check the leveling.

4. Dust Suction Device

To maintain good and smooth operation, dust suction device shall be installed, the air velocity of each dust suction vent shall be over 25 m/s.

5. Circuit connection

The electrical part of this machine is installed and adjusted by the manufacturer, client doesn't have to readjust it in most cases. Use $\geq 25\text{mm}^2$ copper core to input power to the machine (the general auto breaker input end R,S,T in the Electrical Box). Connect the neutral line to the grounding end (N) with $\geq 6.25\text{mm}^2$ copper core wire to protect. Install a disconnecter in the power source to cut off power when the machine is stopped to guarantee

the safety.

6. Connection the compressed air

Connect compressed air to the inlet hose, the internal diameter is $\geq 4\text{mm}$, the pressure is $\geq 0.55\text{MPa}$, water in moisture trap shall be discharged frequently, the oil level of the grease device shall be in line with the requirement.

7. Trial Cycle

The machine is adjusted well in factory, to make sure the machine can work safely and stably, after the machine is installed, make an overall checking.

8. Installation procedure of the sand belt

Operate the tension valve to decrease the tension roll

Loose the lock handler to draw the support frame

Carefully install the sand belt, take note that the arrowhead direction must be exact same with the actual operational direction.

Insert the support frame, fasten the lock handler, operate the tension valve to tense the sand belt.

9. Pressure relay

When there is no compressed air or the air pressure is less than 0.25Mpa , the machine cannot start.

10. Start-up

Operate the master switch to connect power, the indicator is on, open the emergency stop switch, press one time the start button "1", the light of start-up button is on.

After the power is on, operate the transferring belt button "--" first, the moving direction of the transferring belt shall be on the contrary. If it is not, swap the inlet wires to confirm the circuit phase sequence.

Note: before start the machine, all buttons must be in stop or off position (turning to left).

The front/back sand belt motors adopt "Y/" start-up, the swap time is adjusted and set by kt_1 , kt_2 in the electric box, clients can make adjustment as per different cases.

11. Processing thickness adjustment

The elevating controller controls the up and down of the work platform (see the attached usage description), adjusting the spindle handler on the elevating motor shaft could realize fine adjustment.

To diminish the difference, when manually adjust to lower position, adjust about 1mm more as per the desired thickness, then raise to the desired value.

Tow position limit switches realize the upper and lower spacing.

12. The sand belt alignment

Opt-electrical auto control is used on the front and back sand belts of the machine.

To adopt to various opening parallelism of different sand belts, there is manual adjustment handler, loose the adjustment handler to the desired direction and then fasten, adjustment method is to see the diagram above the handler.

The alignment speed of oscillation is adjusted by a choke valve. The chock valve is inside the lower door on the right side.

13. Transporting and feeding part

The feeding part is composed of the rubber conveyer belt on the work platform and stepless gearbox, tense and auto alignment system.

The feeding speed could be adjusted through the transmission handler on the stepless gear box.

Note: this adjustment can only be carried out when the machine is running. It is prohibited to turn the adjustment handler when the machine stops.

14. Adjustment of the front thickness roll

Turbo worm adjusting mechanism is employed, turn clockwise the thickness roll rise, and vice versa. Adjust the work method according to the process requirement.

The thickness roll must be in parallel with work platform, if it is not, loose the fasten nut of the slide bearing connecting copper adjustment nut, adjust to correct direction and then fasten the nut.

15. Adjustment of sanding cushion

The sanding cushion must be in parallel with the work platform (through adjusting the adjustment stand of the riser), the cushion movement is realized by adjusting the spindle handle, the movement can be shown by the position indicator. (one turn is 0.1mm)

One measure of the position indicator is 0.1mm. "0" indicates that the sanding cushion and thickness roll is at the same height compared with the work platform. Turn clockwise, the sanding cushion decrease, vice versa.

The thickness roll and sanding cushion can work simultaneously.

The thickness roll works independently (the sanding cushion rises or is drawn out of the machine)

The sanding cushion works independently (decrease 0.5 – 1mm).

Note: the graphite cloth covering the cushion will get worn after some time, when the backing fabric is shown, please change with new one. When the sanding doesn't need cushion, the cushion shall be drawn to avoid

unnecessary wearing.

16. Sanding work

The sanding quantity is determined by the grinding degree of the sand belt, board materials and work platform position, if the sanding result is not good, i.e. sanding cushion grinding quantity is not enough to wear the sanding sign left by thickness sanding, then adjust lower then cushion (turn the spindle handle clockwise) to increase the grinding quantity.

Glue left on glued board will paste to sand belt surface to shorten its service life. Thus no board shall have residue glue to extend the sand belt usage cycle.

17. Safety Devices

To safeguard the normal operation, emergency stop button (autolock) is on the control panel, four limit switches are on the two side of the front and back sanding frames, in case the sanding belt is darted out of place, they can stop the machine.

The pressure relay is activated when the air system pressure is not enough.

Plate brake is on motor and belt wheel to stop the machine quickly when there is emergency. All the above devices could stop the machine once they are activated.

The breakdown indicator on the panel could indicate air deficiency, sanding belt breaking, sanding belt left and right excess of stroke etc..

Every day after the work, all the machine shall be cleaned carefully, blow all dust and residues off with the air nuzzle, check all bearing lubricating to determine whether oil is needed, especially the work part such as thickness roll, cushion, convey belt and the opt-electric switch of the sand belt alignment, and the reflecting board shall be cleaned often as well.

The lubrication of the machine shall be carried out as per the lubrication sheet.

The oil level of the stepless gear box must be at least half of each oil scale, if it is not, please add oil. The first change oil of the gear box shall be carried out when the machine operates 500 hours, change oil every 2000 hours after that. In any case, the oil surface must be seen through each oil window.

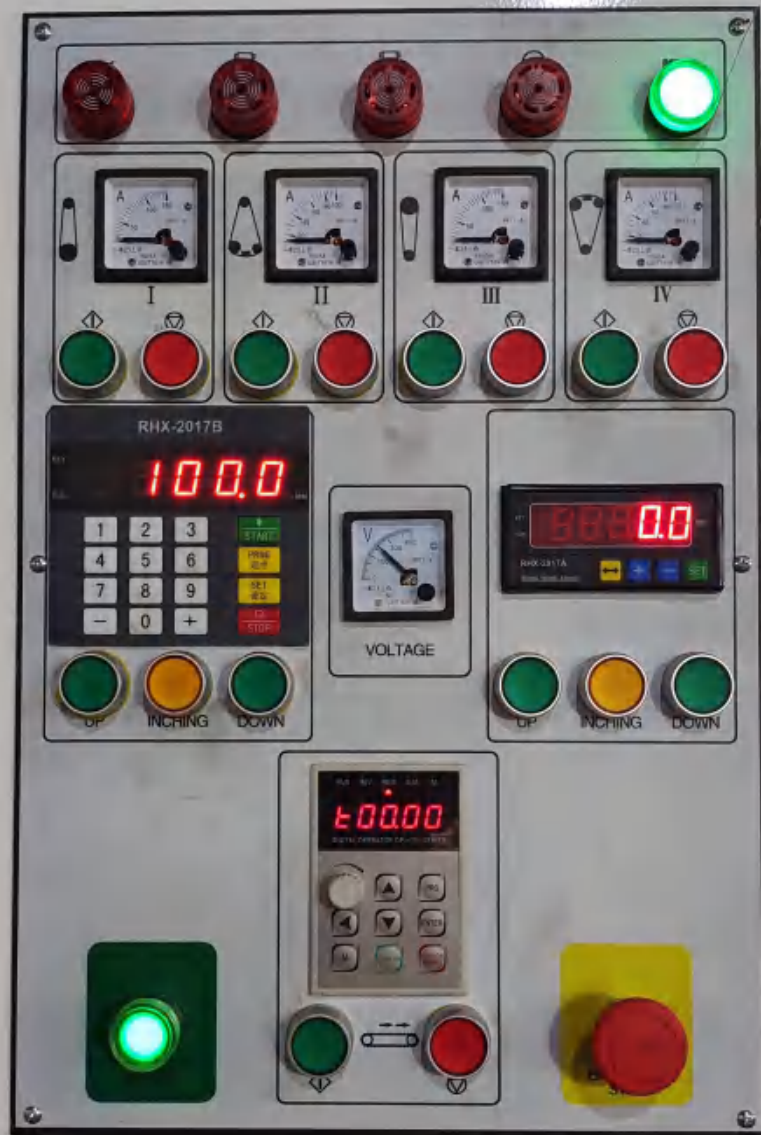
Lubricating Sheet

No.	Part	Period	Oil
1	oil atomizer	As per case	20# lubricant
2	chain	month	lime grease
3	front and middle thickness roll Left and right bearings	week	lime grease
4	Back sanding frame roll left and right bearings	Week	lime grease
5	Front and back tense roll left and right bearings	As per case	lime grease
6	Convey belt stepless gear box	As per case	UB-1

Worn parts sheet

1.	Sand belt convey vee belt model(15N/15J) 5v800	3
	5v810	3
2.	Brush roll convey vee belt model: 0 500 mm	1
3.	Front steel thickness roll bearing: UCT207	2
4.	Sanding frame thickness roll bearing: UCF207	1
	UCFL207	1
5.	Sand frame tense roll bearing UCFC206	1
	UCFL206	1
6.	Support roll bearing: UCPA207	4
7.	Solenoid valve: Two position five way, thread (in 1/4), AC220V	3

Actual data may differ.

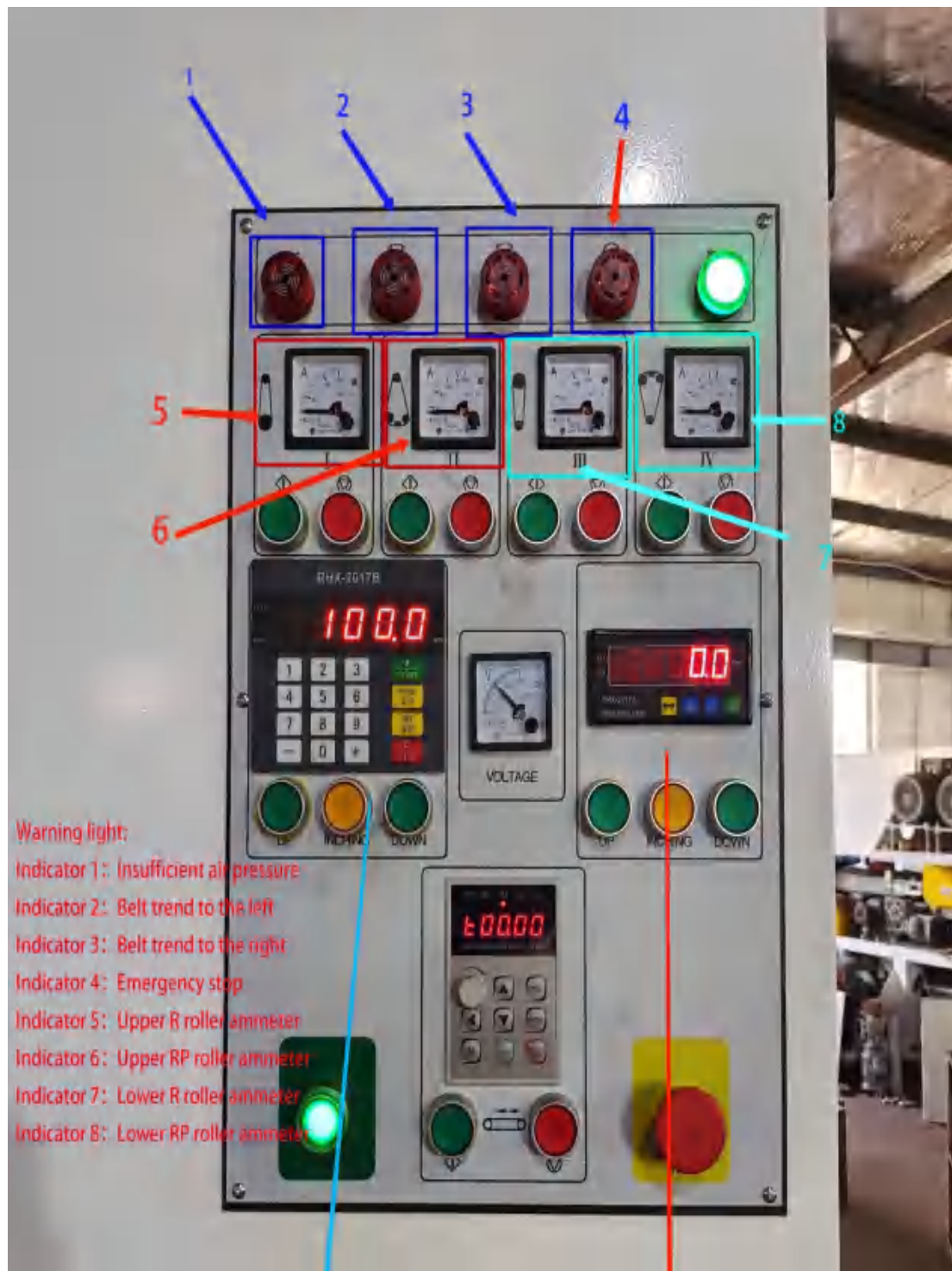


Start:

- 1, Turn "EMERGENCY STOP" clockwise
- 2, Turn on the "POWER"

Comienzo:

- 1, gire "EMERGENCY STOP" en el sentido de las agujas del reloj
- 2, encienda el "POWER"



Adjustment for this digital display:

Input the thickness of wood that will be sanded. Then press" START"

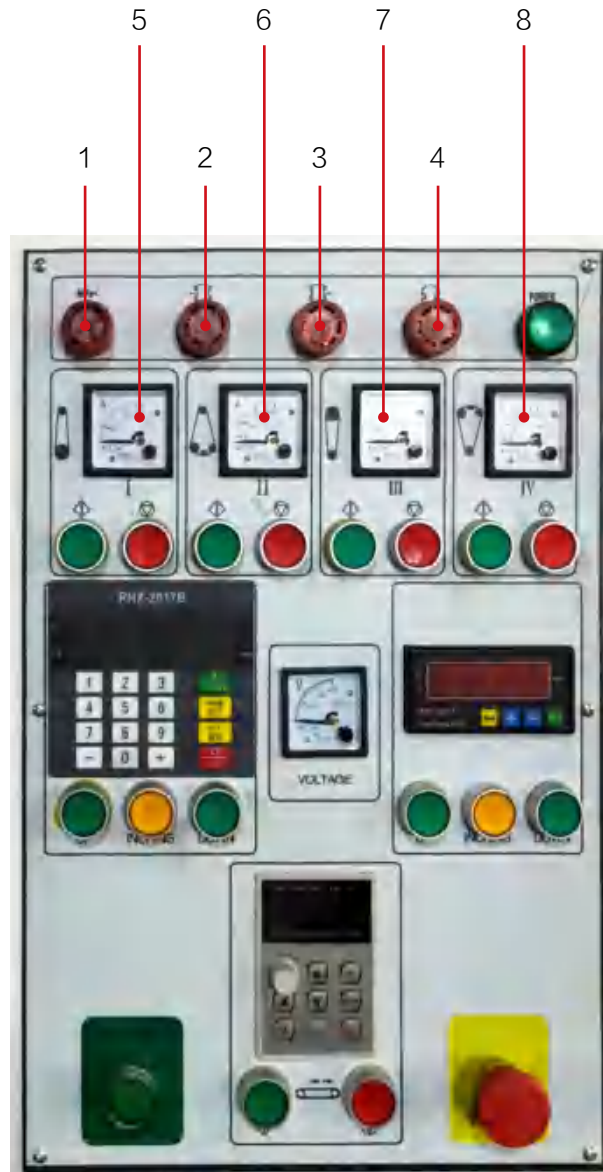
If the thickness after sanding, the data on screen is not same as the real thickness of wood:

For example, the data on screen is 22mm, but after sanding, the thickness of wood is 20mm.

Press"SET" button for 3-5 seconds, then loose the button, input the real thickness 20mm of wood. Then press"SET" button for 3-5 seconds.

This digital display is for balance of two working tables. Don't adjust it all the time.

If the two tables can not be same height, Please contact us for adjustment and solutions.



警示灯 Warning light

Indicator 1: 气压不足报警灯 Insufficient air pressure

Indicator 2: 砂带左偏报警灯 Belt trend to the left

Indicator 3: 砂带右偏报警灯 Belt trend to the right

Indicator 4: 急停开关报警灯 Emergency stop

Indicator 5: 上钢辊 R 电流表 Upper R roller ammeter

Indicator 6: 上钢辊 RP 电流表 Upper RP roller ammeter

Indicator 7: 下钢辊 R 电流表 Lower R roller ammeter

Indicator 8: 下钢辊 RP 电流表 Lower RP roller ammeter

