

STL 移动带输送机 产品使用说明书

STL Mobile Belt conveyor

Product construction

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一、用途

Use

STL 移动带式输送机(以下简称输送机)是一种工效高，使用方便，机动性好的连续输送装卸设备。主要用于装卸地点经常变换的场合，如：港口、码头、车站、煤场、仓库、建筑工地、砂石料场、农场等，用来短途运输及装卸散状物料或成件物品。

STL Mobile Belt conveyor(hereinafter called conveyor) is the Continuous conveyor handling equipment with high efficiency, Easy to use and good mobility. It is mainly used when the loading and unloading locations change frequently, For example: Port, Pier, Station, Coal yard, Warehouse, Construction site, Sand and stone yard, farm and so on. Used for short distance transportation and Loading and unloading of bulk materials or piece items.

二、外形图 (见图1 图2)

Outside view (View 1 View 2)

三、结构特征

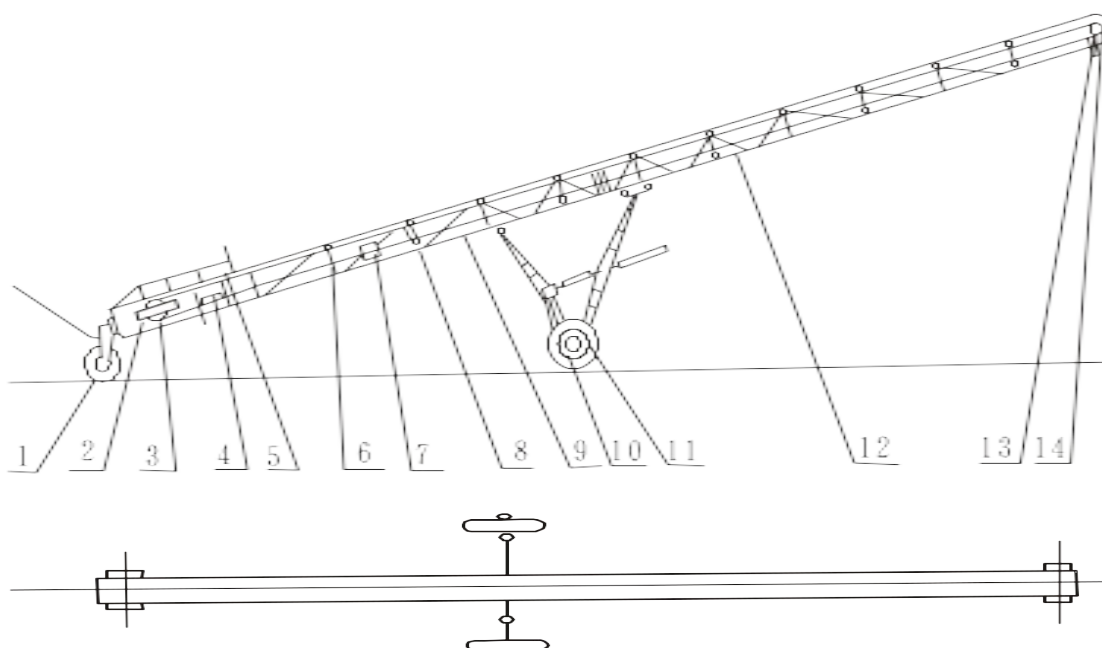
Architectural feature

输送机分为可升降型及不可升降型两大类。输送带的运行靠电动滚筒驱动。整机的升降与运行均为非机动。其主要组成部分如下：

The conveyor can be divided into the adjustable lifting type and unadjustable lifting type. The conveyor belt is driven by electric roller. The lifting and running of the whole machine are non-motorized. The main components are as follows:

- 1、 机架：是整机的主体，系由钢管焊接成的等断面桁架结构。机长在10米以下者，为单节机架，机长10米及10米以上者，机架分成前后两节，以螺栓联接成一整体。

1. Frame: is the main body of the machine, an equal section bracket structure welded by steel pipe, If the machine length is less than 10 meters, it is a single frame, If the machine length is 10 meter and more than 10 meters, the frame has front and back parts, connect as a whole by bolts.



- | | | |
|---------------------------|----------------------------------|-------------------------------|
| 1——尾轮组 | 2——拉紧装置 | 3——电动滚筒组 |
| 1——Tail wheel set | 2——Tensioning device | 3——Electric roller set |
| 4——空段清扫器 | 5——导料槽 | 6——上托辊组 |
| 4——Empty section cleaner | 5——Feed guide groove | 6——Upper supporting idler set |
| 7——电器控制箱 | 8——平行托辊组 | 9——后部机架 |
| 7——Electrical control box | 8——parallel supporting idler set | 9——Behind part machine frame |
| 10——升降装置 | 11——行轮组 | 12——前部机架 |
| 10——Lifting device | 11——Running wheel set | 12——Front part machine frame |
| 13——弹簧清扫器 | 14——改向滚筒组 | |
| 13——Spring cleaner | 14——Change direction roller set | |

注：1.上托辊有平行托辊及槽形托辊两种，输送成件物品时为平行托辊（V = 0.8 米/秒）
 输送散状物料时为槽形托辊（V = 1.6 米/秒）

2.输送成件物品时没有序号 4.5.13 部分。

3.也可使用不转向的行轮组，此时在型号后面增加一个“A”字。

Note: 1. Upper supporting idler set include parallel supporting idler set and Groove supporting idler set, parallel supporting idler set for one piece items (V = 0.8 M/S)

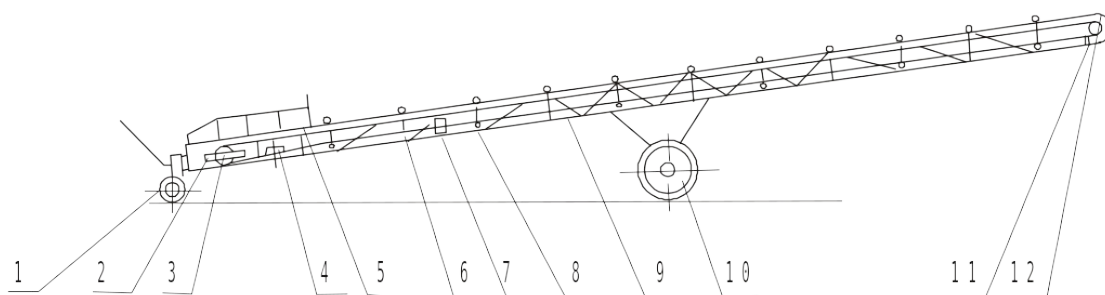
Groove supporting idler set for Loose materials (V = 1.6 M/S)

2. There is no part 4.5.13 of number when transport one piece items

3. non - steering running wheel set can also be used, and add "A" behind the model

图 1.可升降型移动带式输送机外形图

View 1. the outside view of adjustable lifting type Mobile Belt conveyor



1——尾轮组 2——拉紧装置 3——电动滚筒组 4——空段清扫器
1—Tail wheel set 2—Tensioning device 3—Electric roller set 4—Empty section cleaner

5——导料槽 6——上托轮组 7——电器控制箱
5—Feed guide groove 6—Upper supporting idler set 7—Electrical control box

8——平形托轮组 9——机架 10——行轮组
8—parallel supporting idler set 9—frame 10—Running wheel set

11——弹簧清扫器 12——改向滚筒组
11—Spring cleaner 12—Change direction roller set

注：1) 上托辊组有平形托辊及槽形托辊两种。输送成件物品时为平形托辊（V = 0.8 米/秒）。

输送散状物料时为槽形托辊（V = 1.6 米/秒）

2) 输送成件物品时无序号 4.5.11 三部件

3) 带宽 500 及 650 毫米，机长为 10 米及 15 米时才有尾轮组

Note: 1. Upper supporting idler set include parallel supporting idler set and Groove supporting idler set, parallel supporting idler set for one piece items (V = 0.8 M/S)

Groove supporting idler set for Loose materials (V = 1.6 M/S)

2. There is no part 4.5.11 of number when transport one piece items

3. The Tail wheel set is available when belt width is 500 to 650mm, machine length is 10meters to 15 meters

图 2、不可升降型移动带式输送机外形图

View 2. the outside view of unadjustable lifting type Mobile Belt conveyor

2. 驱动装置：采用油冷式电动滚筒，它安装在机架的尾部。详见“电动滚筒使用说明书”。

2. Driving device: adopt oil-cooled electric roller, installs on back of frame. Please refer to "Electric roller Operation Manual" for details.

3. 托辊：用于支承输送带和带上物料，使其稳定运行。它有上托辊和下托辊两种，上托辊又分槽形和平形。槽形上托辊用于输送散状物料。平形上托辊用于输送成件物品。下托辊内为平形托辊。槽形上托辊由三个辊子呈槽形布置。侧辊与水平线成 30° 交角。所有辊子的直径均为 76 毫米。图 3 为辊子的结构图。

3. Supporting roller: It is used to support the conveyor belt and the material to make it run stably. Its has Upper supporting idler set and lower supporting idler set, Upper supporting idler set include parallel supporting idler set and Groove supporting idler set. Groove supporting idler set for Loose materials, parallel supporting idler set for one piece items. The inside of lower supporting idler set is the parallel supporting idler. The groove roller is arranged by three idlers in groove shape. The side roll intersects the horizontal line at an Angle of 30°. All rollers are 76 mm in diameter. The View 3 is the structure of the rollers

4. 拉紧装置：采用装在机尾的螺旋拉紧型式。通过螺杆的旋转来调整输送带的松紧。

4. Tensioning device: Adopt the screw tension type mounted on the tail. The tightness of the conveyor belt is adjusted by rotating the screw

5. 输送带：起传递牵引力及承载物料的作用。采用三层棉芯织物的普通橡胶运输带。上胶厚 3 毫米。下胶厚 1.5 毫米。

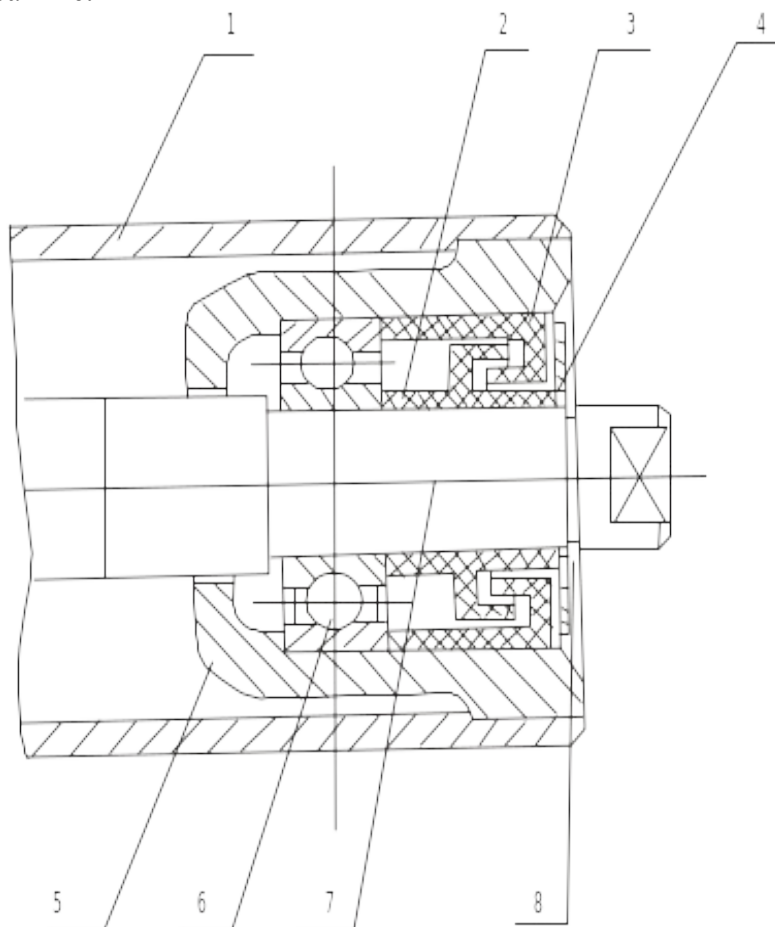
5. Conveyor belt: the role of transferring traction and carrying material. Plain rubber conveyor belt with three layers of cotton core fabric. Upper Gluing thickness 3 mm. Lower glue thickness 1.5mm.

6. 升降装置：安装在输送机中部，由人力转动手柄带动伞齿轮付及螺杆旋转，从而改变前、后支架间的夹角，使整机升降。也可采用电动形式带动伞齿轮付及螺杆旋转。仅可升降型有此部份。

6. Lifting device: Installs in the middle of the conveyor, turn the handle manually to drive the bevel gear pair and screw to rotate, to change the included angle between the front and rear supports, for lifting the whole machine. The bevel gear pair and screw can also be driven electrically to rotate. Only the adjustable lifting type has this part.

7. 行走结构：有行轮与尾轮两部份。可升降型的行轮采用型充气轮胎，尾轮采用直径 300 毫米的铸胶实心轮胎，尾轮可绕铅垂线转动，从而输送机在纵向、横向、斜向移动较为方便。不可升降型的尾轮不能绕铅垂线转动。

7. Operating structure: There are two parts: running wheel and tail wheel. Running wheel of the adjustable lifting type use the type pneumatic tire, The tail wheel is made of 300 mm diameter cast rubber solid tire, The tail wheel can rotate around the plumb line, Therefore, it is convenient for the conveyor to move longitudinally, transversely and diagonally. The tail wheel of unadjustable lifting type cannot rotate around the vertical line.



1. 管子 2.内密封圈 3.外密封圈 4. 垫圈 5.轴承座 6.轴承 7.轴

8.挡圈

1. Pipe 2. Inside sealing ring 3. outside sealing ring 4. Washer 5. Bearing pedestal
6. Bearing 7 axis 8 Retaining ring

图 3、辊子结构图
The View 3 is the structure of the rollers

四、安装、调整与试运转

Installation, adjustment and test

1. 根据拆散发运的情况，在使用单位的安装顺序如下：
According to the conditions of disassembly and shipment, the installation sequence in the user unit is as follows
 - 1) 前、后机架联接成一个整体；
The front and rear frames are connected as a whole
 - 2) 安装电动滚筒与电气控制箱；
Installation of electric roller set and electric control box
 - 3) 安装尾轮；
Install the tail wheel
 - 4) 先组装行轮组与升降装置，再将该组件与机架装配一体；
Assemble the running wheel set and lifting device, and then assemble the assembly with the frame
 - 5) 安装各组托辊；
Install each group of supporting idler
 - 6) 放置输运带并进行接头；
Place conveyor belt and make joints
 - 7) 安装弹簧清扫器与空段清扫器；
Install spring cleaner and empty section cleaner
 - 8) 安装导料槽。

Install feed guide groove

2. 安装技术要求与注意事项：

Technical requirements and precautions for installation

- 1)前、后机架拼装时，纵向中心线应保持同心，对准后再紧固法兰上的螺栓。机架主弦杆的直线度误差不得大于 1/2000, 全长范围内的直线度误差
不

得大于 1/1000。

1) When assembling the front and rear frames, the longitudinal centerline shall be concentric, and the bolts on the flange shall be tightened after alignment bolt. The straightness error of the main chord of the rack shall not be greater than 1/2000, and the straightness error within the full length range shall not be greater than greater than 1/1000.

2) 托辊安装中心应与机架中心重合，托辊轴心线应与机架纵向中心线垂直。托辊安装后用手转动各辊子就轻便灵活。

2) The installation center of the supporting rollers shall coincide with the center of the rack, and the axis line of the supporting rollers shall coincide with the longitudinal center line of the rack Vertical. After the idler is installed, it is light and flexible to rotate each roller by hand.

3) 改向滚筒轴心线与电动滚筒轴心线应平行，并垂直于机架纵向中心线。

3). The axis line of the Change direction roller set shall be parallel to the axis line of the Electric roller and perpendicular to the longitudinal center line of the rack.

4) 弹簧清扫器及空段清扫器的刮板应与输送带贴合良好，其接触长度不得小于带宽的 85%。（注：运送湿性或粘性散料设置弹簧清扫器，固体或袋装物不必设置弹簧清扫器）

4). The scraper of spring cleaner and empty section cleaner shall be well fitted with the conveyor belt

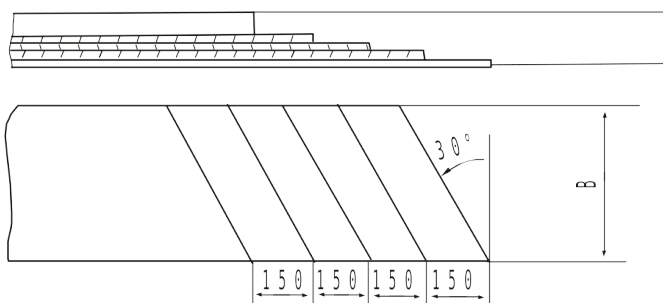


图 4

5) 安装输送带时：

5). When installing the conveyor belt

① 将拉紧装置调整至电动滚筒最靠近改向滚筒的位置。

Adjust the tensioning device to the nearest position of the electric drum to the turning drum

② 分清输送带的上、下胶面，将输送带卷中心插入一芯轴，用架子托起在尾

部平坦处，以便输送带自由拉出。

Distinguish the upper and lower rubber surfaces of the conveyor belt, insert a mandrel into the center of the conveyor belt roll, and lift it at the end with a shelf Part flat, so that the conveyor belt can be pulled out freely

③ 输送带的接头推荐用冷粘接头。若无条件，亦可用皮带扣机械联接。

Cold adhesive joint is recommended for the joint of conveyor belt. If there is no condition, the belt buckle can also be used for mechanical connection

④ 冷粘接头的工艺过程为：

The process of cold bonding joint is：

拉紧--划线--裁剥 打毛--烘干--涂胶--贴合--压实。

Tensioning -- scribing Roughen -- peeling -- drying -- gluing -- fitting -- compaction

操作时先将输送带两端分别拉紧，按图 4 尺寸划线后用刀裁剥掉多余的部份。(注意：裁剥阶梯时切勿将下层帆布切伤)用钢丝刷打去帆布层上的残余橡胶，且将帆布层打毛，清洗带上脏物。

During operation, tighten both ends of the conveyor belt respectively, according to View 4, cut off the surplus after the size is marked (Note: Do not cut the lower canvas when peeling the ladder) Remove the residual rubber on the canvas layer with a wire brush, and canvas layer is roughened and dirt on the belt is cleaned.

烘干，用帆布搭一个棚，将带的接头部份封在棚内，棚内安装六个 300~500 瓦灯泡(最好用红外线灯泡)烘烤，使带机上的温度计指示到 33℃，保温一小时，(若在干燥及高温季节接头，可不必烘干)。

Drying, Build a shed with canvas, seal the joint part of the belt in the shed, and install six 300~500 watt bulbs for baking in the shed(infrared bulb is the best). Keep the thermometer on the belt machine at 33 °C for one hour. (It is unnecessary to dry the joint in dry and high temperature seasons)

涂胶：分两次在棚内进行，每次涂完后，应待温度达到 33℃且不粘手时再涂第二遍或进行贴合。

Gluing: carried out in the shed in two times, After each coating, the second coating or fitting shall be carried out when the temperature reaches 33 °C and it is not sticky

贴合，要对准位置，保证输送带成一直线。用 8 磅大锤均匀地由一端向另一端敲打 3-4 遍，以去除中间的空气，使之全面贴合。

Fitting, align the position to ensure that the conveyor belt is in a straight line, Use an 8-pound sledgehammer to strike evenly from one end to the other 3-4 times, for removing the air in the middle, and make it fit.

压实：在输送带两面各垫一块厚 2 毫米的钢板，用重物(或用压板及螺栓)压紧，保持 0.5 公斤力/厘米 的压力一小时后拆除。

Compaction: place a 2mm thick steel plate on both sides of the conveyor belt, Press with weight (or press plate and bolt), Remove after maintaining the pressure of 0.5 kgf/cm for one hour.

3. 调整

Adjustment

1) 调整输送带位置，使其上、下中心与机架纵向中心线基本重合，调整拉紧装置，使输送带松紧适宜。

Adjust the position of the conveyor belt to make its upper and lower centers basically coincide with the longitudinal centerline of the rack, and adjust the tensioning device to make the conveyor belt appropriately loose.

2) 使各组槽形上托辊处于前倾位置。

Make the upper idler of each group of grooves in the forward inclined position

3) 使各清扫器的刮板与输送带接触良好。

Keep the scraper of each cleaner in good contact with the conveyor belt

4) 使导料槽的橡胶析与输送带接触均匀。

Make the rubber of the Feed guide groove contact the conveyor belt evenly

4. 试运转：

Test

1) 试运转前的准备与检查，

Preparation and inspection before Test

① 全部紧固件要紧固，不得松动。

All fasteners shall be fastened without looseness.

② 电动滚筒内电机定子绕组与机架的绝缘电阻应大于 5 兆欧，接地线应可靠地接地，润滑油达到油面线指示的高度。

The insulation resistance between the motor stator winding and the frame in the electric drum shall be greater than 5 megohm, the grounding wire shall be reliably grounded, and the lubricating oil shall reach the height indicated by the oil level line

③ 改向滚筒，托辊，升降装置，行轮，尾轮等处不得无润滑运转。

Change direction roller, idler, lifting device, running wheel, tail wheel and other places shall not operate without lubrication

④ 用手拉动输送带就无明显的障碍。

There is no obvious obstacle when the conveyor belt is pulled by hand

2) 接通电源空载试运转，时间不得少于二小时。

Turn on the power supply for no-load test run, and the time shall not be less than two hours

3) 空载试运转时，应作如下检查：

During no-load test run, the following inspections shall be made

① 点动各按钮，控制应有效。

运行方向应正确。

Each button, and the control shall be effective

The running direction shall be correct

② 轴承温升不大于 40°C，且最高温度不超过 80°C。

The bearing temperature rise shall not exceed 40 °C, and the maximum temperature shall not exceed 80 °C

③ 托辊应与输送带接触，转动灵活。如有不转动者，可用手锤轻敲辊子（轴向）。若仍不能排除，应拆检。

The idler shall contact the conveyor belt and rotate flexibly. In case of non rotation, gently tap the roller (axially) with a hammer. If it cannot be eliminated, it shall be disassembled for inspection

④ 清扫器刮板，导料槽橡胶板与输送带贴合良好。

Sweeper scraper, The rubber plate of the material guide groove is well fitted with the conveyor belt

⑤ 输送带松紧适宜，无跑偏现象，若输送带跑偏，应按表 2 及图 5、图 6 所示方法纠正。

The conveyor belt is properly tightened without deviation. If the conveyor belt deviates, it should be corrected according to the methods shown in Table 2, View 5 and View 6

⑥ 整机运行平稳，无明显冲击声或过大噪音。

The whole machine runs smoothly without obvious impact sound or excessive noise

4) 空载运转后进行如下检查：

Carry out the following inspections after no-load operation

① 各润滑处应无漏油现象。

There shall be no oil leakage at all lubrication points

② 各紧固件不得松动。

All fasteners shall not be loose

③ 整个结构应无明显变形，各部件性能应良好。

The whole structure shall be free of obvious deformation, and the performance of each component shall be good

5) 空载试运转合格后方可进行满载试运转，其程序及检查项目同上。

The full load test run can be carried out only after the no-load test run is qualified. The procedures and inspection items are the same as above

五、操作规程

Operating instruction

本机的操作人员都必须熟悉与遵守操作规程，负有对本机操作，维护与保管之责。

The operator of this machine must be familiar with and abide by the operating procedures, and be responsible for the operation, maintenance and custody of this machine.

1. 操作前的准备工作。

Preparation before operation

1) 所有紧固件应可靠紧固。

All fasteners shall be fastened reliably

2) 检查各部位润滑情况。

Check the lubrication of all parts

3) 清理输送机上遗留物及杂物。

Clean up the leftovers and sundries on the conveyor

4) 输送机悬臂端下不得有人或放置其它设备。

No person or other equipment shall be placed under the cantilever end of the conveyor

5) 发现行轮组轮胎的气压不足时，应及时充气。

If the tire pressure of the wheel set is insufficient, inflate it in time

6) 若地面较软而使尾轮下陷，应在轮下垫钢板或木板。

If the ground is soft and makes the tail wheel sink, steel plate or plank shall be placed under the wheel

7) 可升降输送机行轮组的定位销应插好。

The locating pin of the traveling wheel group of the lifting conveyor shall be inserted properly

2. 开车后的操作与检查。

Operation and inspection after start-up

1) 按空载试运转时的各项要求检查。

Check according to various requirements during no-load test run

2)合格后可开始输送作业，应按给定的输送能力均匀加料。料流应对准导料槽与输送带的中心，物料的块度不可太大，且落料高度不得超过 2 米，应尽量保持连续输送，不得有大量物料倾卸堆积和其它影响输送机工作的情况。

The conveying operation can be started after the products are qualified, and the materials shall be fed evenly according to the given conveying capacity. The material flow should be aligned to the center of the guide chute and the conveyor belt. The size of the material should not be too large, and the blanking height should not exceed 2 meters. The continuous conveying should be maintained as far as possible. There should be no dumping and accumulation of large amounts of materials and other conditions that affect the operation of the conveyor

3.先停止供料，待机上物料卸空后停车，进行清洁及收尾工作。

Stop feeding first, and stop the machine after loading and unloading materials for cleaning and finishing

3. 操作中发生的主要故障及其排除方法见表 2。

See Table 2 for main faults and troubleshooting methods during operation

故障 Fault	产生原因 Cause	排除方法 Removing Metho	备注 Remark
输送带打滑 Belt slipping	1. 输送带张力小 Low conveyor belt tension 2. 天冷滚筒表面结冰。 Ice on the surface of the cold roller 3. 电动滚筒表面粘有物料或月份太大。 Materials on the surface of the electric roller or the month is too large	1. 转动张紧螺杆认大张力。 Turn the tensioning screw to increase the tension 2. 消除冰层。 Clear ice 3. 加强空段清扫器的清扫效果。 Strengthen the cleaning effect of the empty section cleaner	如胶带过长应截短。 If the tape is too long, cut it short
输送带在两端跑偏 The conveyor belt deviates at both ends	1. 滚筒装配位置不正。 Incorrect assembly position of roller 2. 滚筒表面积物太多。 Too many objects on the surface of	1. 调整滚筒位置。 Adjust roller position 2. 清除积物。 Removal of deposits	图 5 View 5

	the roller		
输送带在中段跑偏 Belt deviation in the middle section	<ol style="list-style-type: none"> 托辊组安装位置不当。 Improper installation position of idler 带子接头不正。 Belt connector is not correct 加料时未对准带子中心。 Misalignment of belt sub center during feeding 	<ol style="list-style-type: none"> 调整托辊位置。 Adjust idler position 重新接头。 Reconnect 改变加料情况。 Change the feeding condition 	图 6 View 6
输送带开始运转位置正常以后向一侧跑偏 Conveyor belt starts to run at a normal position and then deviates to one side	<ol style="list-style-type: none"> 加料时未对准带子中心。 Misalignment of belt sub center during feeding 托辊、滚筒位置改变。 Position change of idler and roller 	<ol style="list-style-type: none"> 改变加料情况。 Change the feeding condition 紧固各部件。 Fasten all parts 	
输送带撕裂与破口 Belt tear and tear	<ol style="list-style-type: none"> 接头质刃不符合要求。 The quality of the joint blade does not meet the requirements 滚筒与带间夹有坚硬物。 Hard objects are sandwiched between roller and belt 清扫器刮板未贴合带子。 Scraper of the cleaner is not attached to the belt 	<ol style="list-style-type: none"> 重新接头。 Reconnect 清除夹物。 Removal of deposits 调整刮板。 Adjusting the scraper 	

表 2 Table 2

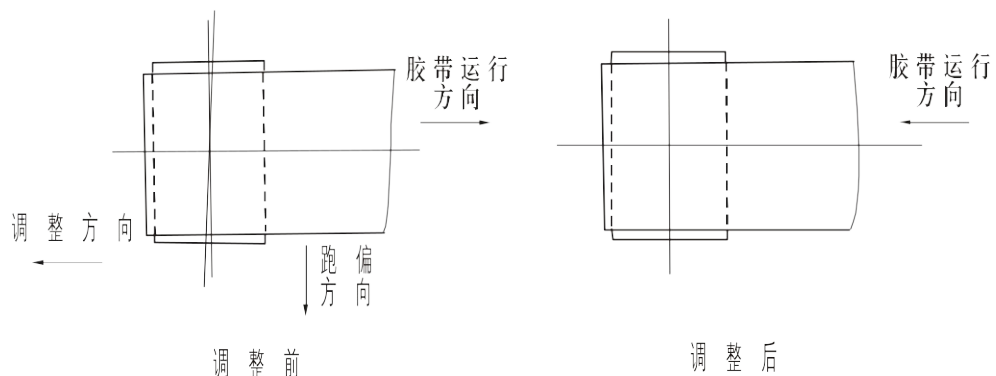
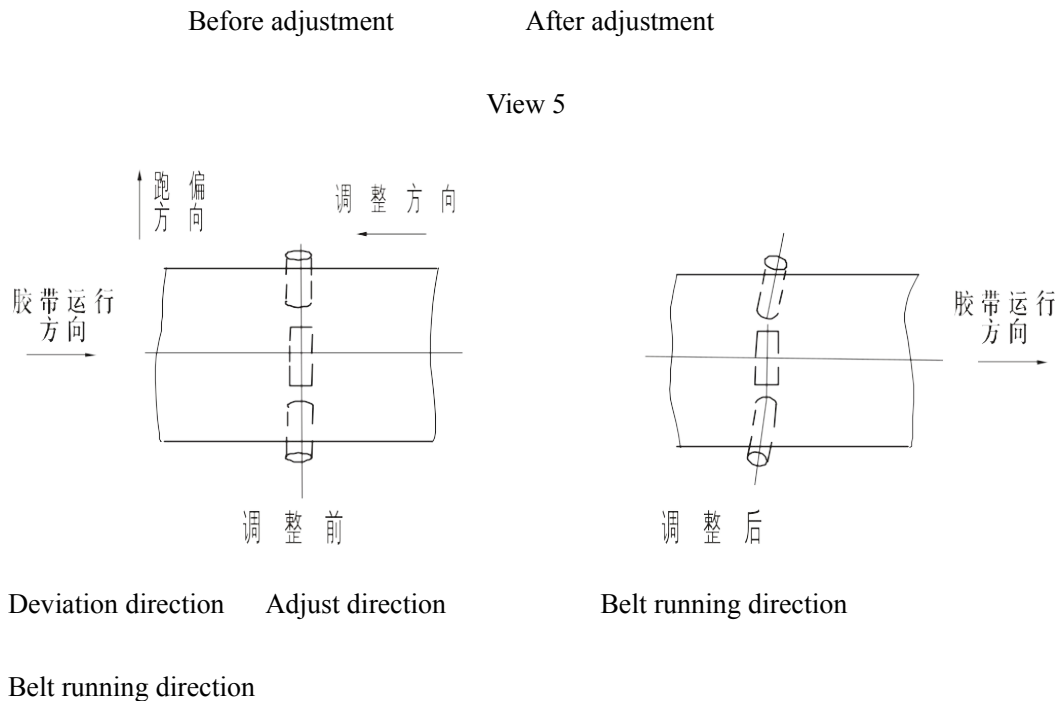


图 5

Adjust direction Belt running direction Belt running direction
Deviation direction



Before adjustment After adjustment
注：下分支胶带跑偏时，托辊的调整方法与此相同。
图 6

Note: When the lower branch belt deviates, the adjustment method of the idler is the same as this

View 6

六、安全和维护 Safety and Maintenance

掌握保养知识及安全技术，能使输送机经常保持良好的技术状态。这对保证输送机正常运行，延长使用寿命，保障人身安全都有着重要的意义。Master maintenance knowledge and safety technology can keep the conveyor in good technical condition. It is great significance to ensure the normal operation of the conveyor, extend its service life and ensure personal safety.

1. 安全： Safety

1) 输送机应有专人操作，输送机下方严禁站人或放置其它设备。
The conveyor shall be operated by a specially assigned person. It is strictly forbidden to stand under the conveyor or place other equipment.

2) 调整改向滚筒或上部找辊位置时，只许一人在前机架上面操作，而机长小于 10 米的输送机不得在前机架上站人。

When adjusting the position of the turning drum or the upper locating roller, only one person is allowed to operate on the front frame, and the conveyor with a length of less than 10 meters shall not stand on the front frame.

3) 输送机运转时，不得升降有移动。

When the conveyor is running, it shall not be lifted or moved

4) 整机移动时应将机架放至最低位置，移动速度不得超过 10 公里/小时。

When moving the whole machine, the rack shall be placed at the lowest position, and the moving speed shall not exceed 10km/h

5) 可升降型输送机的行轮转向后，应及时插入定位销。应使尾轮的方向与行轮方向垂直。如尾轮手柄妨碍加料，可卸下。

After the running wheel of the elevating conveyor turns, the locating pin shall be inserted in time. The direction of the tail wheel shall be perpendicular to the direction of the running wheel. If the tail wheel handle interferes with feeding, it can be removed

6) 几台输送机联合成线运输时，应注意起动及停车顺序，保持空载时起动与停车。

When several conveyors are combined to form a line for transportation, Pay attention to the starting and stopping sequence, and it shall be kept at no-load.

7) 电动滚筒拆下检修时应将输送机降至最低位置并在机架尾部加上足够的压重。

When the electric roller is disassembled for maintenance, the conveyor shall be lowered to the lowest position and enough weight shall be added at the end of the rack

2. 维护：

Maintenance

1) 输送带适合的环境温度在-10℃~+40℃之间。当运输具有酸性、碱性、油类或有机溶剂等成份的物料时，需采用耐酸碱或耐油的特种输送带。The suitable ambient temperature of the conveyor belt is - 10 °C~+40 °C. When transporting materials with acidic, alkaline, oil or organic solvent components, special acid and alkali resistant or oil resistant conveyor belts shall be used.

2) 每班使用后应进行日常保养工作，其内容如下：

Daily maintenance shall be carried out after each shift of use, and the contents are as follows:

<1>切断电源，清洁输送带及各部件。

Cut off the power supply and clean the conveyor belt and all parts

<2>检查各部份紧固件，不得有松动或脱落现象。

Check all fasteners to ensure they are free from looseness or falling off

<3>检查托辊辊子传动情况，遇有不转动者及时换下。

Check the driving condition of the idler roller, and replace it if it does not rotate

<4>检查导料槽，弹簧清扫器，空段清扫器的橡胶板磨损情况。
及时调整或更换。

Check the wear of rubber plates of guide chute, spring cleaner and empty section cleaner.

Adjust or replace in time

<5>检查机械接头的搭扣磨损情况或冷粘接头情况。

Check the buckle wear of the mechanical joint or the cold bonded joint

<6>检查充气轮胎的气压，并注意气伐芯的保养，如较长时间不移动时应设法将轮轴支起，使轮胎悬空。

Check the air pressure of the pneumatic tire, and pay attention to the maintenance of the air valve core. If it does not move for a long time, try to support the axle to make the tire hang in the air

3. 根据实际情况情况，每左右对输送机进行一次全面检修。主要工作内容有：

According to the actual situation, the conveyor shall be overhauled during a period of time, Main work contents include:

<1>清洗整台输送机。

Clean the whole conveyor

<2>按电动滚筒使用说明书拆检电动滚筒。

Dismantle and inspect the electric roller according to the operation manual of the electric roller

<3>拆检及改向滚筒并加油。

Dismantle, inspect and change the direction of the roller and add oil

<4>拆检各托辊辊子并清洗加油。

Disassemble and inspect each idler roller, clean and add oil

<5>在拉紧螺杆，升降螺杆、行轮、尾轮等处加油。

Oil the tension screw, lifting screw, running wheel, tail wheel, etc

<6>平整或更换导料槽。

Level or replace the Feed guide groove

<7>调整清扫器刮板与导料槽橡胶板。

Adjust the scraper of the sweeper and the rubber plate of the Feed guide

groove

<8>整机油漆。

Paint the whole machine

七、润滑 Lubrication

按表 3 规定进行

表 3

润滑部位	润滑剂牌号	润滑周期	备注
托辊组 尾轮组 运行轮组 改向滚筒	锂基润滑脂ZL-2 (SY1508-65)	三年左右	清洗后重新加注
的轴承及油室的密封槽内			
拉紧装置 升降减速机 装置箱 螺杆菌 变表 表面 轴承 轮内	锂基润滑脂ZL-2 (SY1058-65)	3-6个月	

Operation according to Table 3

Lubrication position	Lubricant brand	Lubrication cycle	Remark
Idler roller Tail wheel group Running group Change direction roller	(bear and oil chamber sealing groove) Lithium Grease ZL-2 (SY1508-65)	About 3 years	Refill after cleaning
Screw surface of tensioning device Screw surface of lifting device Reduction gearbox Inside variable bearing shaft	Lithium Grease ZL-2 (SY1058-65)	3-6 months	