

KZ19/16 型气动联动捆扎机

Model KZ19/16 Combination pneumatic strapping tool

使用说明书

OPERATING SPECIFICATION



扫描全能王 创建

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扫描全能王 创建

一、特点和用途

Application and character

KZ19/16型气动联动捆扎机是属于钢带有扣型捆扎机。它适用于一般抗拉强度和高抗拉强度的钢带。本机单人操作将拉紧、锁扣、切断一次性完成，捆扎时间短，打包效率高，捆扎规范、牢固，操作轻松简便。

Model KZ19/16 Combination pneumatic strapping tool belong to buckled strapping tool. Applicable to strips with general strapping strength and high strapping strength. The machine operate tensioning, buckling and cutting in one go, shorten the packing time, making the packing more efficient and standard, firm. function, more convenient to operate.

广泛适用于钢铁和有色金属等行业的板材、型材、管材、钢筋及不规则面的捆扎和包装。

Wildly used in the strapping and packing of plate materials, proximate matter, pipe materials, steel bar and irregular face materials in metal and non-ferrous metal Industry ect.

在零件中更换七种零件可以分别使用19, 16毫米钢带, 或在订货时指明是购买19毫米钢带还是16毫米钢带机器。

Replacement of seven parts in the parts can be used in 19, 16mm steel strip, or in the order specified, the purchase of 19mm or 16mm steel strip machine.

二、主要技术性能

Main technical property

使用空气压力	Air pressures	0.49-0.63MPa
捆扎钢带规格	Steel strip to be used	19×(0.6-0.8)mmmm 16×(0.6-0.8)mmmm
拉紧力	Strap force	≥4.5KN
夹口承受拉力	Clip endurance	≥6.3KN
捆扎平均耗气量	Average air consumption	0.6m ³
重量	Weight	4.2Kg

三、附属设备及管路配备

Auxiliary equipment and pipeline equipment

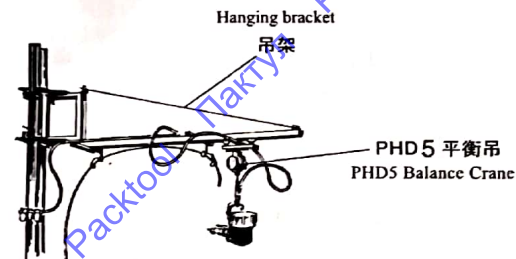
1、压缩空气 Air compression

一台KZ19/16型气动捆扎机大约需要排量13.3升/秒(0.8米³/分)以上的气量。随压力上升拉紧力上升。工作气压在0.49~0.63MPa(5~6.5kg/cm²)之间。

One KZ19/16 Combination pneumatic strapping tool need at least 13.3L/S(0.8m³/min) displacement capacity, and the strapping force raise with the the pressure. working pressure among 0.49~0.63MPa(5~6.5kg/cm²)

2、平衡吊与吊架

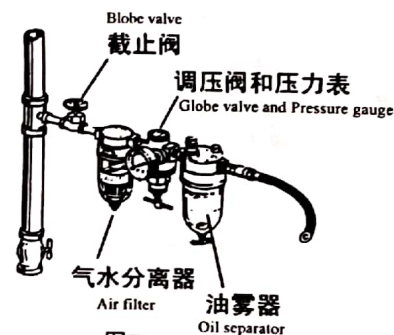
Balance crane and hanging bracket



图一
(Fig 1)

3、压缩空气必须通过截止阀、气水分离器、调压阀和油雾分离器(气动三大件)进入捆扎机。

Compressed air should entry the strapping tool through globe valve, air filter and oil separator



图二
(Fig 2)

4、管路 Pipeline

与捆扎机相连的胶管内径应是 10 毫米, 其理想长度应在5米以内。从气源主管分出的支管内径必须在 15 毫米以上。

The inner diameter of rubber tube witch linked to the strapping tool should be 10mm, ideal length within 5m. the inner diameter of side tube separated from the main pipe of the air resource.



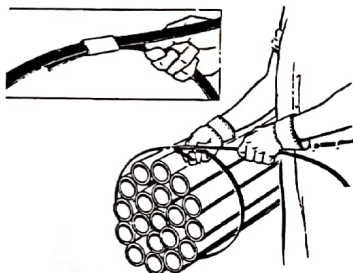
四、操作方法

Operation method

1、钢带穿入 Penetration of the strap

先把钢带穿过钢扣，然后将钢带绕捆扎件一周后，再穿过钢扣并用手将钢带初端朝下方向折叠（见图三）。折叠长度约50mm。用手拉紧松弛的钢带，将钢扣放置在靠近捆扎的位置。

Thread strap through a seal, Then encircle bundle and thread strap through seal and fold the initial end upside down by hand (see Fig 3). the fold length about 50mm. strain the strap by hand and place the seal near the pagking position

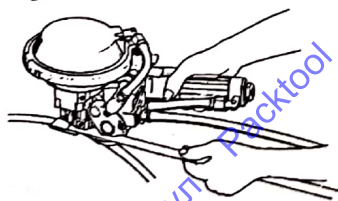


图三
(Fig 3)

2、钢带插入 Insertion of the strap

如图4所示，握住发动机箱体，并用大拇指按下手把（46#）让已穿过钢扣上层的钢带插入进给轮（32#）和防磨滑板（27#）之间，并将捆扎机向前推动，使钢扣与锁扣机构的位置对正，然后松开手把（见图四）。

Hold the moter-box, Press the handl ebars(46#) with the thumb place the tlp strap into the interval between the feedwheel(32#) and the anti friction slide(27#) Push the tool forward until the front of the seal stop contacts the end of theseal. Then loose the handl edars. As shown in Fig4

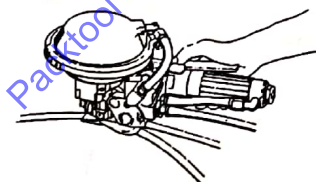


图四
(Fig 4)

3、钢带拉紧 Strap tensioning

如图5所示，按下拉紧开关臂(42#)，阀芯被推动，气马达转动，进给轮压住钢带开始工作。拉紧开关臂按到位后，松开手，进给轮自动拉紧钢带，直至钢带呈紧绷状态，气马达停止收紧。

Press the tighter the switch arm(42#), Valve core pushed, pneumatic motor rotate, feedwheel start working. Hands off after the tighter the switch arm pushed in place, and the feedwheel tension the strap automatic until the strap stained, then the pneumatic motor stop, As shown in Fig5



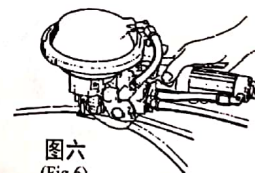
图五
(Fig 5)

4、封锁钢扣和切断钢带 Block the seal and cut off the strap

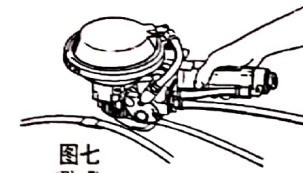
如图6所示，按下锁紧开关臂(43#)，阀芯被推动，完成封锁钢扣和切断钢带。此时，操作过程便告结束。抬起发动机，可将钢带从机中取出，迎接下次的捆扎运作，如图7所示。

As shown in Fig6

Press the locking arm(43#), valve core pushed, complete blocking the seal and cutting off the strap. After that, the operation is ended. Lift up the engine, the strap can be fetched from the tool See Fig7.



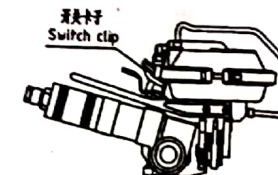
图六
(Fig 6)



图七
(Fig 7)

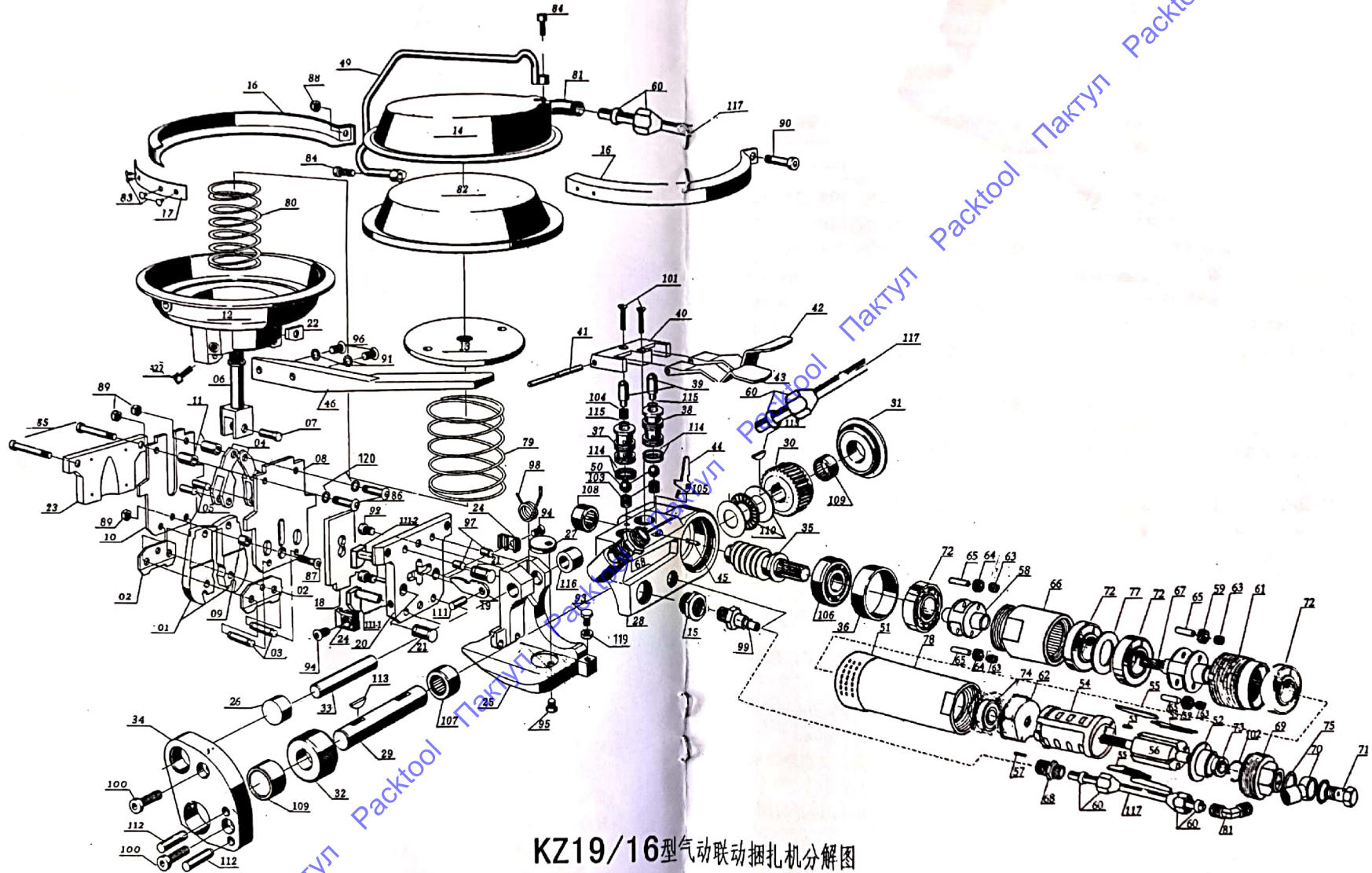
5、如果在拉紧钢带过程中，需要停止作业，可用手转动开关卡子(44#)，机器即恢复到原始状态。如图8所示

If stop operation is needed during tensioning the strap, turn the switch clip(44#), then the machine back to original condition. See Fig8



图八
(Fig 8)





五、使用注意事项

Attention

正常合理地使用工具,能使捆扎机发挥最大的功能和延长使用寿命。在使用中应注意下列事项:

Using the tool correctly and reasonably can make the strapping tool function well and extend the life span. Noticing the following matters during operation:

1、压缩空气 compress air

含有水分和杂质的压缩空气进入机子将会产生腐蚀和咬死现象,因此通气管路中必须装有分水过滤器。机子使用的工作压力在0.49-0.63MPa的范围内,拉紧力的大小随气压的高低而变化。当需要的捆扎拉力被确定就用调压阀固定气压。

Compressed air with water and impurities enter the machine may cause corrosion and anfrassen. so the air pipeline should equip with air filter. the working pressure is among 0.49~0.63MPa. the tension force changes with the pressure. using pressure regulating valve to fix the pressure when the tension force needed been confirmed.

2、润滑 lubrication

本机拉紧部分是由风马达和行星减速齿轮等组成,因此机子必须保持润滑。在油雾器内加入22#机油,注油量在每分钟40-60滴。如果每班操作前,能有若干滴油直接进入机器内,那将是操作更为顺利。注油机和分水过滤器半年至少用煤油清洗一次。

The tension part of the machine consist of pneumatic motor and idle gear. so the machine need to lubricating regularly. so fill the lubricator with 22# steam and the drop rate is 40-60 drop/min. if several lube can be filled into the machine before operation, the machine will running smoothly. the oiling machine and air filter should be cleaned every 6 month by kerosene.

3、机子的保养 maintenance of the machine

(1) 应注意防磨滑板(#27)与进给轮(#32)之间的间隙为0.1-0.3毫米,以确保拉力。可用调整螺丝钉调整间隙。

Be careful of the interval witch is from 0.1~0.3mm between the feed wheel and the anti friction slide to ensure the tension force, adjust the space by screw spike.

(2) 在使用期间应该经常使滑动或转动部件保持适量的润滑,并经常用钢丝刷清除进给轮上的铁屑。

During the operation, keep a quantity of lubricating oil in turning or rolling parts. eliminate the iron filings on the feed wheel in time.

六、KZ19/16型气动联动捆扎机零件明细表

KZ19/16 Combination pneumatic strapping tool components sheet

订货号 Order Number	名称 Description	规格 Specification	数量 Qty
1	轧紧刀 Jan		2
1	轧紧刀(B) Jan(B) 用于16mm钢带		2
2	砧座 Notcher		2
2	砧座B NotcherB 用于16mm钢带		2
3	侧板销 Rear Pin		2
4	链板 Janlink		2
5	链销 Link Pin		2
6	活塞杆 Piston rod		1
7	活塞杆销 Piston rod Pin		1
8	内侧板 Rear Plate		1
9	砧座垫 Notcher Spacer		1
10	外侧板 Front Plate		1
11	侧板隔套筒 Bulkhead Sleeve		2
12	下缸体 Lower Block		1
13	活塞杆盘 Piston rod disc		1
14	上缸盖 Upper cylinder head		1
15	补心 Thread reduction		1
16	夹紧箍 Spring band		2
17	弹簧箍带 Spring band		1
18	刀片 Blade		1
18	刀片B BladeB 用于16mm钢带		1
19	刀片压杆 Blade pressure bar		1
20	刀盘连接板 Cutter head connecting		1
21	起动销 Starting Pin		2
22	拐板 Crutch		1
23	防护侧板 Protective side panel		1
24	导向块 Guide block		2
25	夹紧座 Clamping seat		1
25	夹紧座B Clamping seat B 用于16mm钢带		1
26	托架套筒 Bracket sleeve		1
27	防磨滑板 Anti friction slide		1
28	蜗轮箱 Worm gear box		1



订货号 Order Number	名称 Description	规格 Specification	数量 Qty
29	主轴 Main shaft		1
30	蜗轮 Worm gear		1
31	蜗轮箱盖 Worm case cover		1
32	进给轮 Feed wheel		1
33	托架销 Bracket Pin		1
34	托架 Bracket		1
35	蜗杆 Worm		1
36	轴承衬套 Bearing Bush		1
37	锁紧阀套 Locking sleeve		1
38	拉紧阀套 Tighten the valve sleeve		1
39	阀芯 Valve core		2
40	开关座 Switch seat		1
41	开关座轴 Switch base shaft		1
42	拉紧开关臂 Tighten the switch arm		1
43	锁紧开关臂 Locking arm		1
44	开关卡子 Switch clip		1
45	开关卡子轴 Switch clamp spindle		1
46	手把 Handle bars		1
47	销 Cylindrical Pin(本机不用)(No need for this paragraph)	$\phi 5 \times 12$	2
48	螺母 Nut (本机不用)(No need for this paragraph)	M8	1
49	吊钩 Lifting Hook		1
50	钢球 Steel Ball	10	2
51	排气阀 Exhaust Coil		1
52	气马达后盖 Air Motor back cover		1
53	弹性圆柱销 Elastic Pin	$\phi 2 \times 6$	1
54	气马达气缸 Air cylinder		1
55	滑片 Slip piece		5
56	气马达转子 Air Motor Rotor		1
57	弹性圆柱销 Elastic Pin	$\phi 2 \times 10$	1
58	第二空转体 Second idling idling		1
59	一空转行星轮 An idling planetary gear		2
60	气管接头(二零件组成) Tracheal dogma(2 components)		4
61	一空转内齿轮 Idling internal gear		1

订货号 Order Number	名称 Description	规格 Specification	数量 Qty
62	气马达前盖 Front cover of air motor		1
63	滑动轴承 Linear-motion bearing		4
64	二空转行星轮 Two-idling planetary gear		2
65	齿轮轴 Gear shaft		4
66	二空转内齿轮 Double idling internal gear		1
67	第一空转体 First idling		1
68	卡套 Card holder		2
69	夹紧螺母 Clamping nut		1
70	三通接头 Tee Joint		1
71	进气螺栓 Intake Bolt		1
72	深沟球轴承(102) Deep groove ball bearing	15×32×9	4
73	深沟球轴承(80026)双面带防尘盖 Deep groove ball bearing	6×19×6	1
74	深沟球轴承(18)双面带防尘盖 Deep groove ball bearing	8×22×7	1
75	密封垫圈 Sealing Washer		2
76	轴承环 Bearing replacement (本机不用)(No need for this paragraph)		1
77	轴承隔垫 Bearing spacer		1
78	发动机箱 Motor case		1
79	返回弹簧 Return spring		1
80	内顶弹簧 Internal top spring		1
81	直角卡套 Right Angle holder		2
82	皮碗 Leather bowl		1
83	圆头铆钉 Round head rivet	3×6	4
84	内六角圆柱头螺钉 Hexagon socket caphead screws	M6×12	2
85	内六角圆柱头螺钉 Hexagon socket caphead screws	M6×35	2
86	内六角圆柱头螺钉 Hexagon socket caphead screws	M5×25	2
87	内六角沉头螺钉 Hexagon socket caphead screws	M5×25	1
88	六角尼龙锁紧螺母 Hexagon nylon lock nut	M6	1
89	六角尼龙锁紧螺母 Hexagon nylon lock nut	M5	3
90	内六角圆柱头螺钉 Hexagon socket caphead screws	M6×30	1
91	弹簧垫圈 Spring washer	5	2
92	内六角圆柱头螺钉 Hexagon socket caphead screws	M5×10	2
93	六角头螺栓 Hexagon head bolt	M5×15	1
94	内六角沉头螺钉 Hexagon socket counter sunk head screw	M5×12	2



订货号 Order Number	名称 Description	规格 Specification	数量 Qty
95	内六角沉头螺钉 Hexagon socket counter sunk head screw	M4×8	1
96	内六角圆柱头螺钉 Hexagon socket caphead screws	M5×16	2
97	导向销 Guide pin		2
97	导向销B Guide pinB 用于16mm钢带		2
98	扭簧 Torsion spring		1
99	气嘴 Gas nozzle		1
100	内六角圆柱头螺钉 Hexagon socket caphead screws	M5×20	2
101	内六角圆柱头螺钉 Hexagon socket caphead screws	M4×18	2
102	孔用弹性挡圈 Circlip for hole	19	1
103	钢球下弹簧 Steel ball lower spring		2
104	阀芯弹簧 Spool lower spring		2
105	开关卡子弹簧 Switch clip safety		1
106	角接触球轴承(36201) Radial push up bearing	12×32×10	1
107	滚针轴承(941/15) Needle bearing	15×20×12(两头通)	1
108	滚针轴承(6941/12) Needle bearing	12×17×12(一头通)	1
109	滚针轴承(6941/15) Needle bearing	15×20×12(一头通)	2
110	止推轴承(8102) Thrust bearing	15×28×9改为15×28×8-0.035	1
111- $\frac{1}{2}$	刀片导向销 Blade Guide Pin		2
111-1B	顶块(1) Top block (1) 用于16mm钢带		1
111-2B	顶块(2) Top block (2) 用于16mm钢带		1
111	刀片压杆销 Blade Pin 半圆头滚针5×15.8-5-10 GB/T309-2000		
112	销 Pin	B5×20公差h8	2
113	半圆键 Half circle key	4×6.5×16	2
114	外密封圈 Outer seal ring		4
115	内密封圈 Inner sealing ring		2
116	齿轮箱套筒 Gearbox sleeve		1
117	气管 Tracher		2
118	调压螺钉 Pressure adjusting screw(本机不用)(No need for this paragraph)	M8×25	1
119	螺母 Nut	M5	1
120	平垫圈 Flat washer	5	2
121	内六角平端紧定螺钉 Hexagon socket set screw with flat end (闷堵用)	M6×5	2
122	内六角圆柱头螺钉 Hexagon socket caphead screws	M6×25	1

