



溧阳市众星环保机械有限公司
LiYang ZhongXing Environmental Protection Machinery Co., Ltd.



公司简介 Foreword

溧阳市众星环保机械有限公司位于江苏省AAAA级国家旅游度假区（天目湖），紧靠104国道，宁杭高速，座落在溧阳市天目湖工业园区。本公司开创以来，一直专业从事各类除尘器的研究、设计和制造。公司拥有先进的设备，完善的电脑管理系统，技术力量雄厚，产品质量可靠。

Liyang Zhongxing Environmental Protection Machinery Corporation Limited is situated in National AAAA Class Tourist Holiday Resort (Tianmu Lake) of Jiangsu Province, adjoined 104 State Highway & Nanjing - Hangzhou Express Way, located in Tianmu Lake Industrial Park. Since the foundation of the company, we have been specializing in research, design and manufacture all kinds of dust collectors.

企业先后通过了ISO9001:2008质量体系认证、欧盟CE产品认证，并获得江苏省环保推荐产品、全国质量信得过企业、中国信用企业认证等荣誉，产品同时申请了专利保护。

The enterprise has passed ISO9001:2008 Quality Management System Certification, the European CE Product Certification, and obtained Jiangsu Province Environmental Protection Products Recommended, the National Quality Trustworthy Enterprise and Chinese Credit Enterprise Certification etc., and also applied for patent protection.

公司本着“诚信于员工，诚信于客户，诚信于社会”的诚信的服务理念，与北方热设计院、国家装备总公司等十多家设计单位建立了合作开发横向联合，致力于产品的开发与提高，目前产品应用于电力、冶金、化工、建材（水泥）、建筑工程、铸造、矿山等行业。

Company follows the principles of "Integrity to Staffs; Integrity to Customer; Integrity to Society", established cooperation to develop horizontal integration with North Thermoelectricity Design Institute and National Equipment Corporation etc. in recent years. Products are widely used in electricity, metallurgy, chemical, building materials (cement), architectural engineering, cast and mining industries.

目前，我公司形成了产品系列化，设计规划化，技术创新化，服务优质化的良好局面。公司恪守以人为本的理念，发扬开拓创新的企业精神，树立实事求是的科学态度。将以“认真”两字作为工作的标尺。用“服务无止境”为座右铭，服务客户、回报社会。

At present, our company has formed product serration, design planification, technology innovation and service quality of a good situation. Company adheres to the concept of people-oriented, promotes the pioneering and innovative spirit of enterprise and establishes a scientific attitude of being practical and realistic. We will view "Earnestness" as the working benchmark and "Endless Service" as motto, serve customers and reward society.



Characteristics of products 特色产品

为了积极贯彻国家环境保护法的实施，适应全国各地厂矿企业对治理三废、改善劳动条件、保护环境卫生、促进文明生产和综合利用的迫切需要，公司针对采石矿具有粉尘浓度大、污染面积广的特点，新设计了集脉冲和旋风为一体的复合型电子脉冲袋式除尘器，并申请了国家专利，该除尘器改变了以往旋风除尘器为负压式、布袋除尘为正压式的缺陷。

Due to high dust concentration and mass contamination area while quarrying and mining, the company newly designed an electronic pulse bag filter and applied national patent. This dust collector integrates pulse with cyclones and overcomes the former disadvantages of negative pressure condition for cyclone dust collector and positive pressure condition for bag filter. The products meet the requirements of the National Environmental Protection Act.

我们在不断提高产品质量的同时，与客户密切配合，不断增加新品种，新设备以满足用户需求，如客户有特殊要求，我公司在现有标准化产品的基础上可为客户专门设计、制造、安装。

While constantly improving the product quality, we cooperate closely with clients, and add new varieties and latest equipments to meet their needs. According to the clients' requirements, we can specially design, manufacture and install for them on the basis of the existing standardized products.

我公司目前生产的ZXMC系列复合型电子脉冲袋式除尘器可广泛应用于矿山采掘、电炉冶炼、机械铸造、化工制品、建材、水泥（水泥磨）、垃圾焚烧、粮食加工等工矿企业。

Our present ZXMC series electronic pulse bag filter is widely applicable in the many fields, such as mine mining, electric furnace smelting, machinery manufacturing, chemical products, building materials, cement (cement grinding mill), waste incineration and food processing etc.

公司产品特别为满足高速公路联合碎石筛分机组而配套的大流量、高浓度（含尘量 $\geq 1000\text{g}/\text{m}^3$ ）无规则排放粉尘的工况特点而开发复合型袋式净化设备，净化后的气体排放可达到GB16297—1996对二三类地区颗粒物矿物的排放标准 $\leq 30\text{mg}/\text{m}^3$ ，经过科研单位和使用单位鉴定，一致认为该产品各项技术指标均达到设计要求，现已批量生产。该除尘器还具有除尘效率高，维修量小，处理能量大，性能良好，美观大方等优点，并有净化和分选二大功能，尤其是对成品料（0~4.75mm）中的200目（0.075mm）粉尘可进行调节控制，使200目（0.075mm）以下的粉料含量不超过10%，从而提高成品石料的品位，（比传统选粉机节约能耗50%）。

And it is designed with high dedusting efficiency for joint gravel screening machines with the characteristics of large flow, high concentration (Dust Volume more than $1000\text{g}/\text{m}^3$) and irregular dust emission. According to the requirements of Two-Three class areas under GB16297-1996, purified dust emission concentration can achieve standard of less than $30\text{mg}/\text{m}^3$. Both scientific institutes and users identify that the technical specifications of the product meet the design requirements. Now it has already entered into mass production, which has the advantages of high efficiency, less maintenance, long service life and elegant appearance etc. Moreover, it is functional with purification and separation. Especially, it can control the dust content of the finished 4th stone and ensure the powder content which is under 0.075mm no more than 10%, thereby it raises the grade of the finished stone, 50% lower than Powder Concentrator on energy consumption.





ZXMC系列除尘器技术说明

脉冲袋式除尘器基本构造及工作原理

Fundamental construction and work principle of Pulse Bag Dust collector

用途:

ZXMC系列袋式除尘器是本公司自主研发的新型矿山除尘机组专利产品,具有技术性能高,净化效率高,处理气体能力大,性能稳定,使用寿命长,应用范围广的特点,该设备广泛应用于冶金、化工、建材、粮食加工、机械铸造、轻工、橡胶等工矿企业的通风除尘,对于改善环境,防止大气污染收到良好效果。

Purpose described:

ZXMC series bag-type Dust Collector, national patent product is new type dedusting unit, R&D on our own. It has high technical function, high purification, powerful air processing capacity, stable performance, long service life and application range though continuous improvement and modification. It can be widely used in many fields covering metallurgy, chemical, building material, food processing, machinery casting, light industry, rubber etc. To improve the environment, and prevent atmospheric pollution it has a good effect.

基本结构图见图1,它由以下五个部分组成:

1. 上箱体 (2): 装有可掀起的顶部检修门 (1) 和出气口 (16)、多孔板 (7)、进气口 (8)、滤袋 (14)、弹簧龙骨 (15) 和文氏管 (6)
2. 下箱体: 灰斗 (12) 及检查门 (13)
3. 排灰系统: 包括减速装置和排尘阀 (10)
4. 喷吹系统: 包括控制仪 (9) 脉冲阀 (3) 常压连接器 (4) 喷吹管 (17) 分气箱 (5)

The basic structure is shown in picture 1. It is made up of 5 parts as follows.

1. The upper box (2): equipped with top inspection gate (1) and air outlet (16), perforated plate (7), gas inlet (8), filter bag (14), spring (15) and venturi tube (6).
2. The under box: ash hopper (12) and inspection door (13).
3. Ash removing system: including speed reducer and dust remove valve (10).
4. Spray system: including controller (9), control valve (3), ordinary pressure connector (4), spurt and blow pipe (17) and gas bag (5).

脉冲除尘器的工作原理, 尘气进入沉降室后由于速度急剧降低粗灰尘随即落下, 细灰尘被气流带上升, 净空气通过滤袋经文氏管, 从净气室出口排出。

The working principle of pulse dust collector: After getting into sedimentation chamber, thick dust fall because of sudden decreasing speed, and fine one is raised by the air flow. Clean air passes through filter bags, gets into venturi pipes and expelled from the clean air chamber.

初始粉尘沉积在滤布表面形成灰尘层即提高除尘效率也使阻力增长。为保持工作稳定, 必须控制除尘阻力在一定范围内 (一般为120-150毫米水银柱), 为此要有规律地清灰—清除灰尘层, 脉冲除尘器以压缩空气为清灰动力, 每排滤袋上敷设一根1"的喷气管, 连接成一个脉冲网, 由控制仪按给定程序触发每个脉冲阀喷吹, 此时, 高压空气经喷吹管上φ6.4mm的小孔对准滤袋中心口喷出, 通过文氏管诱导数倍于一次风的周围空气进入滤袋, 在一瞬间滤袋急剧膨胀, 抖落灰尘层, 由此可见, 这种清灰方法效果较好。

Dust accumulates on surface of filter bags and forms dust layer, which is to increase resistance for the sake of improving dedusting efficiency. To keep the working condition steady, the resistance of dust collector must be limited in an area (generally 1200-1500Pa), so dust layer should be cleaned regularly. Pulse dust collector adopts the compressed air as the clean power. Each row of filter bag is equipped with a 1" jet pipe which forms a pulse net. According to the definite program, the controller urges the pulse valve to spray. At that time, compressed air through 6.4mm nozzles on blow pipes, and induce ambient air, which is several times stronger than primary air, goes into filter bags through venturi pipe. In a instantaneous time, filter bags inflate rapidly and shakes off the dust layer. Meanwhile, the air current reversed and some dust in the filter bag is blown out.



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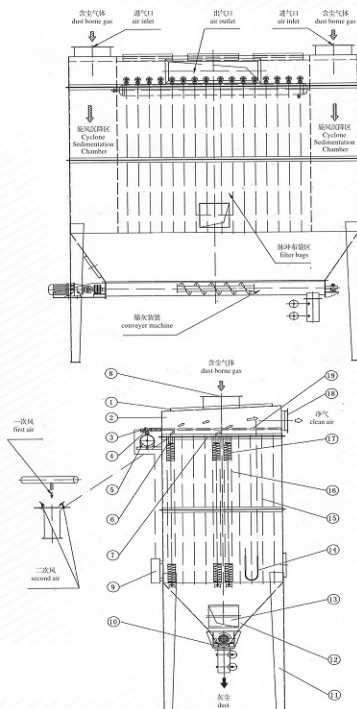


图1 除尘器的基本结构

Fig.1 basic configuration dust remover

1. 顶部检修门 top inspection gate
2. 上箱体 upper box body
3. 脉冲阀 pulse valve
4. 常压联接器 ordinary pressure connector
5. 分气箱 gas bag
6. 文氏管 venturi tube
7. 多孔板 perforated plate
8. 进风口 air inlet
9. 脉冲控制仪 pulse control device
10. 螺旋机 screw conveyor
11. 支腿 landing leg
12. 灰斗 ash hopper
13. 检查门 inspection gate
14. 布袋 filter bag
15. 弹簧笼骨 spring
16. 出风口 air outlet
17. 喷吹管 spurt and blow pipe

ZXMC系列除尘器技术说明

脉冲袋式除尘器基本构造及工作原理

Fundamental construction and work principle of Pulse Bag Dust collector

图2是一个清灰周期的分解。(A) (C)是过滤状态袋角抽成多角星状,气流由外及里(B)是喷吹清灰状态,袋子鼓足,气流反向,由里及外,将滤布表面沉积的灰尘层成片状剥离脱落。清灰周期一般在一分钟以上,而一次喷吹清灰的时间仅0.1秒,每次只有一排滤袋受到鼓吹,因此,适用于连续工作,而且负荷均匀,工况稳定,除落的灰尘经灰斗中的螺旋机和回转阀排出机体。

Picture 2 is a decomposition of the dust clean cycle. (A) and (C) pictures reflect a process, when in the filter condition the bag corner turned into polygonal form. Gas flow spray the dust from outside to inside, and picture (B) reflect the phase of gas flow spray. The bag will screw up, flow reverse from inside to the outside and the dust layer which deposit outside the cloth filter will be peeled or flaked. The dust cleaning cycle should over 1 minute and the spray of dust cleaning just 0.1s. Every time, only spray one row of filter. So it is suitable for continuous working, the load is even and working condition is steady. The dust removed is sent to the screw conveyor of ash hopper and revolving valve, then exhaust out of machine.

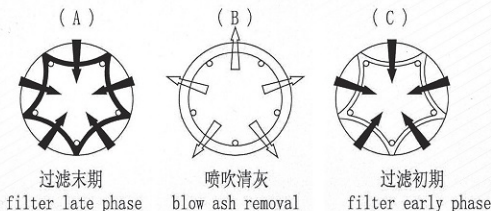


图2、清灰周期分解图

Fig.2 ash removal cycle decompose chart

喷吹系统的构造及工作原理

喷吹系统的构造及工作原理

Fundamental construction and work principle of spurt and blow system

喷吹系统的组成如图3，脉冲阀A端接压缩空气分气箱，B端接喷气管，脉冲阀背压室接控制阀。控制阀的工作由控制仪完成，在控制仪无信号输出时，控制阀的活动铁芯封住排气口，脉冲阀处于关闭状态，当控制仪发出信号时，控制阀将脉冲阀背压室与大气压相通（泄压），脉冲阀开启，压缩空气由分气箱通过脉冲阀经喷吹管小孔喷进文氏管，造成滤袋内瞬时正压，实现清灰。

The construction of the spray system can be seen in Picture 3. A side of the pulse valve connects with compressed air package and B side connects with the gas ejector pipe. The backpressure chamber of pulse valve connects with the control valve. The work of control valve is completed by the controller. If there is no signal with controller, the moving core of the controller block the air vent, the pulse valve is closed. If there is signal, the control valve will prompt the backpressure chamber of pulse valve to connect with the atmospheric pressure (releasing pressure) and the pulse valve is turned on. The compressed air in the air bag goes into the Venturi pipe through pulse valve and the small hole of spray and blow pipe, which makes the filter bag full of positive pressure instantaneously and so that the dust cleaning is finished.

1、脉冲阀：脉冲是电动脉冲，气动脉冲或机动脉冲控制系统的执行机构，如图4，当控制仪无信号时，气包内压缩空气通过节流孔进入脉冲阀背压室C，波纹膜片两侧压力相等，加弹簧压力作用，使喷吹口膜片封闭，当控制仪发出信号时，控制阀接到信号立即放气，使脉冲阀C室气压突然泄气，A室气压将波纹膜片压开，喷吹压缩空气从气包经A室进入B室喷吹，控制信号消失后，C室气压迅速回升，加弹簧压力作用，喷吹即停止。

1. Pulse valve: Pulse is the implementing agencies of electric pulse, pneumatic pulse or motor pulse system (Picture 4). When there is no signal with controller, the compressed air in the air bag goes into backpressure chamber of pulse valve C through the throttle orifice, corrugated diaphragm has the same pressure on both sides, the diaphragm of spray is closed with the spring pressure. When the controller sends out signal, the control valve receives the signal and release gas immediately, the pressure of pulse valve C deflated suddenly and pressures of A prompt the corrugated diaphragm to open. The compressed air in the gas bag spray into B through A, when the signal disappeared, Pressure of C rises again rapidly, the spray stopped with the spring pressure.

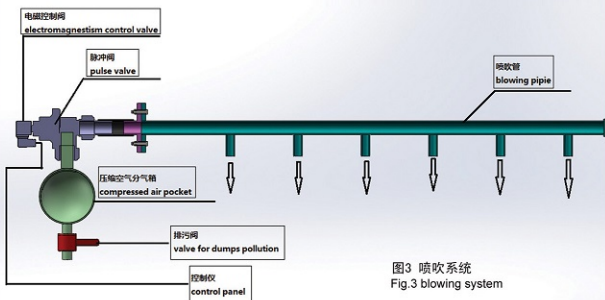


图3 喷吹系统
Fig.3 blowing system

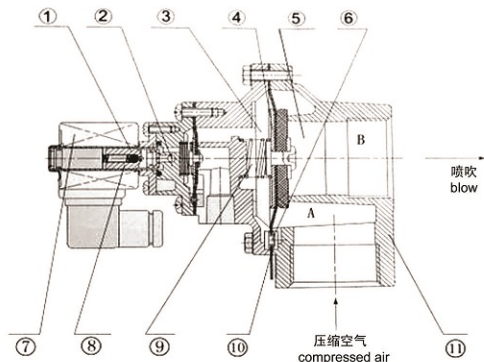


图4 电磁阀示意图
Fig.4 diagram of pulse valve

1-铁芯或挡板 Iron core or apron; 2-排气孔 Exhaust hole; 3-阀盖 Valve cover; 4-脉冲阀 Pulse valve; 5-喷吹口 Spray exit; 6-节流孔 Orifice; 7-控制阀 Control valve; 8-排气阀 Exhaust valve; 9-弹簧 Spring; 10-波纹膜片 Corrugated diaphragm; 11-阀体 Valve body

使用条件:

- 1、环境温度: $-20^{\circ}\text{C}\sim+50^{\circ}\text{C}$
- 2、相对湿度: 85% (温度在 $16^{\circ}\text{C}\sim 32^{\circ}\text{C}$)
- 3、电源电压: $220\pm 15\%$ 伏, 频率 50Hz
- 4、安装特点:
 - (1) 直接安装在除尘器主体上
 - (2) 安装在主控制室内, 通过 300M 以内的馈线, 实现远距离控制

技术特性:

- 1、输入脉冲宽度调节范围: 0.03秒~0.2秒
最大宽度 $t_{\text{mdx}} \geq 0.2\text{s}$
最小宽度 $t_{\text{min}} \leq 0.03\text{s}$
- 2、输出脉冲间隔时间调节范围: 1秒~30秒
最大间隔 $t_{\text{mdx}} \geq 30\text{s}$
最小间隔 $t_{\text{min}} \leq 1\text{s}$
- 3、能带动 4~30 个电磁阀正常工作

Working condition:

- 1.Environmental temperature: $-20^{\circ}\text{C}\sim 50^{\circ}\text{C}$
- 2.Relative temperature: 85% ($16^{\circ}\text{C}\sim 32^{\circ}\text{C}$)
- 3.Supply voltage: $220\pm 15\%$ V, Frequency 50Hz
- 4.Installation:
 - (1) Install in the main body of dust collector directly.
 - (2) Install in the main control room, feeder line which is less than 300 meter-long can be used to achieve remote control.

Technical Characteristics:

- 1.Limits of input pulse width: 0.03s~0.2s
Maximum width (t_{mdx}) $\geq 0.2\text{s}$
Minimum width (t_{min}) $\leq 0.03\text{s}$
- 2.Limits of output pulse width: 1s~30s
Maximum interval (t_{mdx}) $\geq 30\text{s}$
Minimum interval (t_{min}) $\leq 1\text{s}$
- 3.It can make 4-30 electromagnetic valve work normally.

Technical parameters list(type of overseas) 技术参数一览表(国外型)

规格 Type	处理风量 Flow rate m ³ /h	过滤 面积 Filter area m ²	过滤 风速 Filter speed m/min	吸尘 效率 Cleaning efficiency	净化 排放 Purification emissions mg/m ³	配套电机 (kw) Matching Motor	
						主机 Mainframe	螺旋输送机 Helix conveyer machine
ZXMC-60-2.5	4320~7560	60	1.2~2.1	95%	≤30-50	5.5~7.5	
ZXMC-80-2.5	5760~10080	80	1.2~2.1	95%	≤30-50	11~15	
ZXMC-100-2.5	7200~12600	100	1.2~2.1	95%	≤30-50	15~18.5	
ZXMC-120-2.5	8640~15120	120	1.2~2.1	95%	≤30-50	15~18.5	2.2
ZXMC-140-2.5	10080~17640	140	1.2~2.1	95%	≤30-50	18.5~22	2.2
ZXMC-160-2.5	11520~20160	160	1.2~2.1	95%	≤30-50	18.5~22	3
ZXMC-180-2.5	12960~22680	180	1.2~2.1	95%	≤30-50	18.5~22	3
ZXMC-200-2.5	14400~25200	200	1.2~2.1	95%	≤30-50	22~30	3
ZXMC-220-2.5	15840~27720	220	1.2~2.1	95%	≤30-50	22~30	3
ZXMC-240-2.5	17280~30240	240	1.2~2.1	95%	≤30-50	22~37	4
ZXMC-260-2.5	18720~32760	260	1.2~2.1	95%	≤30-50	22~37	4
ZXMC-280-2.5	20160~35280	280	1.2~2.1	95%	≤30-50	22~37	4
ZXMC-300-2.5	21600~37800	300	1.2~2.1	95%	≤30-50	30~37	4
ZXMC-320-2.5	23040~40320	320	1.2~2.1	95%	≤30-50	30~45	4
ZXMC-340-2.5	24480~42840	340	1.2~2.1	95%	≤30-50	30~45	4
ZXMC-360-2.5	25920~45360	360	1.2~2.1	95%	≤30-50	30~55	4
ZXMC-380-2.5	27360~47880	380	1.2~2.1	95%	≤30-50	30~55	4
ZXMC-400-2.5	28800~50400	400	1.2~2.1	95%	≤30-50	37~75	3*2
ZXMC-420-2.5	30240~52920	420	1.2~2.1	95%	≤30-50	37~75	3*2
ZXMC-460-2.5	33120~57960	460	1.2~2.1	95%	≤30-50	37~75	3*2
ZXMC-480-2.5	34560~60480	480	1.2~2.1	95%	≤30-50	37~75	3*2



Technical parameters list(domestic)

技术参数一览表(国内型)

规格 Type	处理风量 Flow rate m³/h	过滤面积 Filter area m²	过滤风速 Filter speed m/min	吸尘效率 Cleaning efficiency	净化排放 Purification emissions mg/m³	配套电机 (kw) Matching Motor	
						主机 Mainframe	螺旋输送机 Helix conveyor machine
ZXMC-60-3	5184~9072	72	1.2~2.1	95%	≤30-50	7.5~11	
ZXMC-80-3	6912~12096	96	1.2~2.1	95%	≤30-50	15~18.5	
ZXMC-100-3	8640~15120	120	1.2~2.1	95%	≤30-50	15~22	
ZXMC-120-3	10368~18144	144	1.2~2.1	95%	≤30-50	18.5~22	2.2
ZXMC-140-3	12096~21168	168	1.2~2.1	95%	≤30-50	18.5~22	2.2
ZXMC-160-3	13824~24192	192	1.2~2.1	95%	≤30-50	18.5~30	3
ZXMC-180-3	15552~27216	216	1.2~2.1	95%	≤30-50	22~30	3
ZXMC-200-3	17280~30240	240	1.2~2.1	95%	≤30-50	22~37	3
ZXMC-220-3	19008~33264	264	1.2~2.1	95%	≤30-50	22~37	3
ZXMC-240-3	20736~36288	288	1.2~2.1	95%	≤30-50	22~45	4
ZXMC-260-3	22464~39312	312	1.2~2.1	95%	≤30-50	30~45	4
ZXMC-280-3	24192~42336	336	1.2~2.1	95%	≤30-50	30~45	4
ZXMC-300-3	25920~45360	360	1.2~2.1	95%	≤30-50	30~55	4
ZXMC-320-3	27648~48384	384	1.2~2.1	95%	≤30-50	30~55	4
ZXMC-340-3	29376~51408	408	1.2~2.1	95%	≤30-50	30~55	4
ZXMC-360-3	31104~54432	432	1.2~2.1	95%	≤30-50	37~75	4
ZXMC-380-3	32832~57456	456	1.2~2.1	95%	≤30-50	37~75	4
ZXMC-400-3	34560~60480	480	1.2~2.1	95%	≤30-50	37~75	3*2
ZXMC-420-3	36288~63504	504	1.2~2.1	95%	≤30-50	37~75	3*2
ZXMC-460-3	39744~69552	552	1.2~2.1	95%	≤30-50	45~90	3*2
ZXMC-480-3	41472~72576	576	1.2~2.1	95%	≤30-50	45~90	3*2

1、安装前准备

按照除尘器基础图（见图样），做好地基，用于固定除尘器箱体及风机

2、除尘器安装步骤

- (1) 先检查基础，按常规清理，找平、放线
- (2) 吊装箱体，上、下箱体拼合，固定
- (3) 安装气体处理器（脉冲阀等）和风机
- (4) 按照图纸安装管道、阀门、管道支架和附属设施
- (5) 安装脉冲阀气路、空压机气路
- (6) 安装滤袋（设备发运时，预先将袋笼装入袋室内，安装时进行整理即可）

3、要求事项

(1) 安装前必须仔细阅读说明书及随设备提供的图纸资料，并按装箱发运清单检查全部零件的数量和质量，如发现有问
题应及时与供方联系

(2) 上、下箱体安装时，全部联接处应保证密封不漏气，要求焊接密封的应密焊，用紧固件联接的，必须加密封垫

(3) 组装气路部分时，主气管（接电磁脉冲阀）在厂内已分别装配制作好，现场只要组对，控制气管（接气缸）现场下
料、套口、安装。要求气管内无杂质、铁屑，经试压不漏气

1. Before installation

According to the foundation drawing of dust collector (see drawing), complete the foundation, to fix filter body and fan.

2. Installation Steps

- (1) Check the foundation, do conventional cleaning, make level, pay-off.
- (2) Lift upper and lower box body, fix them together.
- (3) Install gas processor (pulse valve) and fan.
- (4) Install pipe, valve, pipe support and subsidiary facilities by drawing.
- (5) Install pulse valve gas circuit, air compressor gas circuit.
- (6) Install filter bag (in box body when shipped, just clear up when installation).

3. Requirements

(1) Before installation you should read instruction book and drawing with equipment, check the quality and quantity of the machinery by packing list. If you have any questions please contact with supplier.

(2) During installation of upper and lower box body, all connection places should be guaranteed no leaking of full welding. Gasket must be added for connecting with fasteners.

(3) During assembly of gas circuit parts, main air pipes (connect with electromagnet pulse valve) has completely manufactured in our company, you just fit it up. The quantity, connector and installation of control air pipe (connect cylinder) will be finished on site. To ensure there is no impurities, scrap iron in air pipe, and no leakage after testing.



操作维护规程 Operation and maintenance

为确保除尘系统安全、稳定、可靠运行，严格按如下规程操作：

1、操作程序

①. 除尘设备调试步骤

- 所有设备通电
- 检查风机、螺杆机转向
- 控制仪调节（建议脉冲间隔6-8秒，脉冲宽度150ms），调节参考控制仪说明书。
- 检查脉冲阀工作是否正常

②. 开机步骤

- 启动空压机，待空压机压力上升到0.8mpa
- 接通控制仪电源
- 启动排灰系统电机（螺旋输送机）
- 待脉冲阀喷吹三分钟后启动风机电机

③. 停机步骤

- 关停风机
- 风机停机后，待螺旋输送机无灰尘清出，关停螺旋输送机。
- 关停脉冲控制仪
- 关停排灰系统（空压机）电源
- 切断总电源

To ensure the dust removing system is safe, stable and reliable in operation, the following rules should be strictly obeyed.

1. Operating debugging procedures

①. Commission steps of dust collecting equipment

- Turn on the power of all the equipments.
- Check the direction of the fan and screw compressor.
- Adjust the controller (suggest the pulse interval 6-8s, pulse width 150ms), please adjust according to the controller instruction.
- Check the pulse valve to make sure that it is working properly.

②. Starting procedures

- Start air compressor motor, and then wait for the pressure increasing to 0.8mpa.
- Turn on the power supply of controller.
- Switch on the screw conveyor.
- Operate the fan motor until the pulse valve working for three minutes.

③. Stopping procedures

- Shut off the fan.
- After the fan stopped, do not turn off the screw conveyor until no dust discharged from it.
- Shut down pulse controller.
- Turn off air compressor.
- Switch off main power.

2、维护检视规程：

- 定期检查，翻板排灰阀是否灵活，管道、风机、除尘器密封是否良好，气泡内积水及时排除（每天不少于1次）。
- 定期检查，喷气管是否偏移，喷吹管要正对文氏管中间。
- 系统运行时，应经常巡视系统工作情况，尤其是下雨天和石料含水量过大时，请不要打开除尘系统，防止湿粉尘在布袋上，难以清除。如果卸灰阀不出灰，应及时停机检查，查明原因并排除故障后，方可再投入运行。
- 运行时经常检查风机运行状况，发现有振动现象，应停机检查，叶轮是否积灰，或叶轮是否磨损，如严重磨损应及时更换。
- 空压机应放置在空气洁净处并定时检查油位，低于油位应及时补充。发现异常情况应及时停机检查。

2. Maintenance rules

- Ash valve should be inspected regularly for flexibility, and make sure that pipe, fan and dust remover are in good condition, moreover, water inside the bubble should be removed at once (at least once daily).
- Jet tube should be inspected regularly to make sure whether it is offset or not, and the jet tube should be directly face to the middle of the venturi tube.
- When the system is operating, it should be regularly inspected. In order to prevent dust gather in the wet bag and inhalation of ash, please do not open the dust remover system especially when it is rainy or the stone materials containing too much water, because it's difficult to clean up the dust remover system. If there is no dust from discharging valve, please stop and check it.
- The fan operation should be checked regularly. If appear vibration phenomenon, the fans should be stopped and checked to make sure whether the impeller is full of dust or damaged. If the impeller damaged severe, please change it in time.
- Air compressor should be stored in the place where the air is clean, oil level should be checked regularly, when the oil is lower than its level, add it timely. If the machine is exceptional, please stop and check it in time.

Attention 注意事项

- A. 雨天及石料含水量过大时，严禁开机。
- B. 运行时严禁接触运动旋转部件。
- C. 运行时严禁用手塞入排灰阀下口检查运行状况，防止粉尘到顶而阻塞排灰阀出灰，引发螺旋电机烧毁。
- D. 空压机及电磁脉冲未运行前，不得启动风机运转。
- E. 如电磁脉冲频率太快或者太慢和喷气时间间隔太长，而影响布袋除尘效果，请参照脉冲仪说明书进行调整。
- F. 脉冲控制仪应防潮，防晒，防灰，防剧烈震动，不用时取下电源和控制插头，专人收管。
- G. 布袋要定时更换（一般为一年一次），及时清洗，清洗需用高压水枪或高压气枪对准布袋的口子向内压水或喷气。使布袋内的堵塞物受水压或气压后被强制排，然后晾干备用。
- H. 除尘系统的高性能和长寿命是靠平时的正确使用、维护和保养来保证的。

Attention

- A. Do not start the machine when it is rainy or the stone materials containing too much water.
- B. Do not touch rotating components when running.
- C. The dust might up to the ceiling and block the ash valve, which leads to the burning down of the spiral electric machinery, and thus the ash valve should be checked while do not insert fingers into the ash valve.
- D. Do not start the fan before running the air compressor and the electromagnetic pulse.
- E. If the electromagnetic pulse frequency is too fast or too slow or jet time interval being too long, the dust removing effect of cloth bags will be impacted, please refer to the specification of pulse instrument and adjust accordingly.
- F. Pulse controller should be protected from moisture, sunscreen, dust, and violent vibration, when it is not used, the power supply should be cut off and the plugs should be took off and kept safely.
- G. The cloth bag should be replaced regularly (usually once a year) and cleaned in time. The high pressure squirt gun or pneumatic gun should be opposite to the cloth bag. Pressurized water or air forces to discharge the obstacles in the cloth bag and then dry the cloth bag for its next using.
- H. The high performance and longevity of dust remover system is relying on proper use and maintenance.



常见故障原因及排除方法

Common cause of the malfunction and remove methods

序号 No.	故障 Malfunction	故障原因 Reason	排除方法 Methods
1	风机口排灰尘 Dust discharged from Blower	滤袋破损 Broken Bag	修复或更换滤袋 Repair or replace Bag
2	脉冲阀无力 Unable pulse valve	空气压力小 Small air pressure	空气机压力调至5~7kg Air compressor pressure changes to 5-7kg
		气管漏气 Tracheal leaks	修复漏气管道 Repair pipeline leak
3	风量减小 Air flow comes down	脉冲阀不全部工作 Not all pulse valves work	更换不工作阀 Replace valves that not work
		滤袋严重堵塞 Bag seriously blocked	更换或清洗滤袋 Replace or clean the filter bag
4	风机异常声 Abnormal sound of the blower	叶轮与其它摩擦 Friction with other impeller	调整到无摩擦 Adjust to no friction
		轴承损坏 Bearing damages	更换轴承 Replace the bearing
		地脚螺丝松动 Foot screws Loose	调整到位拧紧 Adjust and Tighten
5	空压机供气不足 Gas shortage from air compressor	进气过滤器堵塞 Inlet Filters plugs	清洗或更换过滤器 Clean or replace filters
		空压机缸套磨损 Air compressor cylinder liner breaks	修理空压机 Repair Air compressors
6	卸灰阀不出灰 No dust from dust valve	除尘器内部堵塞 Precipitator internal plugs	清理 Clean
		卸灰阀出口结料 Material blocked at outlet	清理出口口，严禁堆料 Clean the outlet, Prohibited Stocker

Project 工程实例



南非矿业公司 South Africa



沙特 Saudi Arabia



圣戈班建材（上海）有限公司 Saint-Gobain Shanghai, China





蒙古阿尔泰矿业 Mongolia



常州上黄 Changzhou, China

工程实例 Project



宣州象山建材厂 Anhui, China



埃塞俄比亚 Ethiopia



巴基斯坦卡拉奇核电站石骨料生产线
Stone Crushing Line Nuclear Power Station Karachi Pakistan



滁州市全椒县除尘工程 Chuzhou, Anhui, China

工程实例 Project



南阳镇平县建源石材有限公司 Nanyang, Henan, China



舞阳中加矿业 Wuyang, Henan, China

Project 工程实例



常铝股份熔铸线除尘器 Casting Dust Collector, Fujian, China



隆翠汽车木工区域除尘
Longtree Automobile Woodworking Dedusting Plant, Zhejiang, China

工程实例 Project



湖州泰玛仕生产线 Tiimax Huzhou China

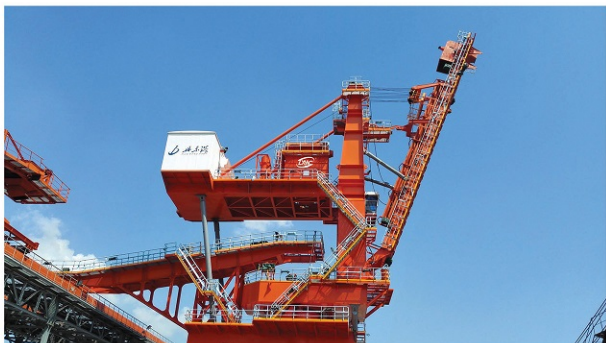


江苏中韵木业实木生产线 Zhongyun Woodworking Jiangsu China

Project 工程实例



景德镇新越沥青除尘项目 Asphalt dust collector, Jingdezhen, China



三一丹东港装船机除尘项目
Ship Loader Dedusting Project in Sanyi Dandong Port



工程实例 Project



绍兴福膜车间除尘项目 Hangzhou Foremost Shaoxing China



徐工集团巴西抛丸线滤筒除尘项目
XCMG Blasting Line Cartridge Dust Collector in Brazil

Project 工程实例



斯里兰卡生产线2016年9月 Sri Lanka



中水九局惠水公司重力惯性分级机干法制砂线

Huishui Company of Sinohydro Bureau 9 Gravitational-inertia Classifier Dry Sand Making Line



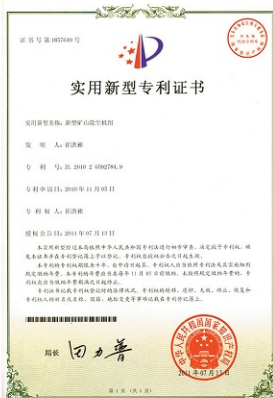
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