

QWISE-FM-SBJSGC-2019-QLFS

Company Standard

Hunan WISE New Material Technology Co., Ltd.

Powder sub-factory

Powder product

production process equipment

safety technical regulations

Safety technical specification for airflow crushing classifier

Approved by : Zhaohui LIU

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Checked by Sub-Factory: Zhengchen Xu and Zhengdao Xiao

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- 1、Wear overalls, work shoes, gloves, and dust masks before operation.
- 2 、Before starting the machine, carefully check that the host, attached machine, pipeline, valve, etc. must be in good condition, set the frequency of the pulse controller, so that the filter resistance is controlled within a certain range.
- 3、Starting up:
 - 3.1 Open the inlet and outlet cooling water valve first to ensure the normal flow of cooling water;
 - 3.2 Start the air compressor according to the instructions for use of the air compressor;
 - 3.3 The pressure of the air tank is adjusted to be higher than the crushing pressure by 0.1 Mpa by the pressure regulator of the air compressor;
 - 3.4 Turn on the freeze dryer to ensure that the pressure meets the requirements;
 - 3.5 Open the cleaning valve and sealing valve, adjust the cleaning pressure to 0.2~0.4Mpa, seal the pressure to 0.05~0.1 Mpa, then start the grading wheel, gradually adjust the required frequency from the zero start by the inverter;
 - 3.6 First close the inlet fan of the induced draft fan, then open the induced draft fan, and then gradually open the inlet fan of the large induced draft fan to the required air volume.
 - 3.7 Open the air ring inlet valve, adjust the pressure before the crushing nozzle to 0.7~0.85Mpa; turn on the trap backflush valve and adjust to 0.6Mpa; then turn the cyclone and trap discharge valve one by one.
- 4、Feeding:
 - 4.1 When feeding, the material should be inspected to remove coarse aggregates and other hard materials, and if necessary, first screened to prevent jamming of the feed spiral;
 - 4.2 The grading wheel current should be checked frequently during the feeding process. If the current is too large, the feeding should be stopped.
 - 4.3 During the operation, the suction port should be inspected for suction and adjusted by the suction valve of the exhaust fan to ensure that the feed is in a negative pressure state;

4.4 Frequently check the condition of the material in the plastic pipe discharged from the grading wheel, and use a wooden hammer to strike properly to prevent the material from being deposited too much to affect the grading effect;

4.5 Check the discharge condition of the cyclone separator and the trap (dust collector), adjust the classification frequency and the amount of exhaust air according to the process requirements, and control the amount of tailings.

5、 Downtime:

5.1 Stop the screw feeder feed, stop the compressor, and close the air ring inlet valve;

5.2 Close the inlet fan inlet valve, stop the fan, stop the staged impeller motor, close the purge valve and seal valve;

5.3 Stop the cyclone separator and close the trap discharge valve;

5.4 Stop and lock the important switch after stopping.

6、 Do not reach into the discharger outlet when the unloader is running to avoid injury to your hands.

7、 The graded impeller speed cannot exceed the specified value to avoid damage to the stepped wheel motor.

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