



Quanzhou Famous Trademark

Tea strip shaping carding machine

6CLZ-60/8、11

User's manual

Anxi Yongxing Machinery Co., Ltd.

I, use and characteristics

This product is suitable for high-grade strip-shaped tea strips and plastic surgery. The finished tea bar is tight, the tooth leaves are intact, the peak seedlings are exposed, and the color is green.

II, safety precautions

1. For your safety, please make sure to connect a ground wire to the machine casing. The ground wire can be fixed to any screw in the machine base.

At the joint of the grain, the contact must be good.

2. When the machine is running, do not approach, and do not touch the machine with your hands. Pay special attention to the moving parts, which will wrap your arms and clothes, which is very dangerous.

3. During the operation of the machine, jamming, collision and abnormal sounds occur. If it is impossible to judge the fault source or the fault that cannot be easily handled, the electric heat pipe should be turned off first, and then the temperature should be checked before the temperature is lowered. Never operate the machine and handle the high temperature with a high temperature to avoid personal safety.

4. When the machine is shut down normally, the electric heating tube switch should be cut off first, and then the temperature should be lowered to room temperature and then shut down, or the pot body should be turned up in time to avoid deformation of the pot body under the action of residual heat.

5. Regularly check whether the fasteners are reliable, tighten the loose fasteners, tighten the belt or tighten the fasteners, and replace the sliding sleeves or guide rails when they are worn.

6. Gas-fired liquefied petroleum gas (usually referred to as gas), if using pipeline gas or natural gas, gas furnace

The stove must be changed accordingly. In addition, the burner should be equipped with the corresponding pressure reducing valve. Connect the gas inlet hose to the air inlet port of the unit to check whether the air hose is damaged. If it is damaged, replace it immediately to ensure safety.

7. For the gas multi-purpose machine, after opening the air valve for two seconds, press the ignition button to ignite the entire burner. After the ignition is delayed, if the burner is not ignited (or not fully ignited), the ball valve should be closed. Switch and re-ignite.

8. The firewood or coal-fired products of our factory are all closed furnaces and flue. The height of the chimney has been carefully studied. Bring

Do not arbitrarily cut or stack the chimney, and do not arbitrarily match the length of the chimney to avoid poor burning or excessive heat escape, which affects the quality of the tea.

III, the main technical parameters

Item		Unit of Measure	6CLZ60/11	6CLZ60/8
width of pot body		Mm	600	
Number of pot body grooves		/	11	8
Pot body Length		Mm	1000	
Pot Body Depth		Mm	85	
Number of reciprocating movements		Times /min	170-240	
Amplitude (eccentricity)		Mm	80 (40)	
Hours processing capacity		kg two green leaf /h	≥ 6	
Output at kilowatt-table		kg two green leaf /kw. h	≥ 1	
Water content of the strip leaves		%	\leq	
Water content of hair and fire leaves		%	\leq	
Dry tea Stripe Rate		%	\geq	
Heat Source Energy	Electric heating Type	KW. h	8	
	Combustion type	kg/h (Chai)	10	

Consumption capacity	Gas-type	kg/h	0.8 (liquefied petroleum gas)	
Drive motor	Voltage	V	380/220	
	Power	KW	0.55	
Wind Machine	Voltage	V	220	
	Power	KW	0.15	
Weight of the whole machine	Electric heating Type	Kg	222	214
	Combustion type	Kg	272	270
	Gas-type	Kg	190	216
Dimensions (length × width × height)		Mm	1765 x780x775	

Note: The shape height of the combustion heat source does not include the chimney.

IV, working principle and structure

1, working principle

Each pot of fried tea leaves has original static and dynamic differences. The original static difference has the difference of quality, size, shape and old tenderness; when the tea leaves move in the pot, the dynamic difference of each piece of tea leaves is different in the pot, the windward side is different, and there is no collision between the tea leaves. The water speed is different and so on.

Whether the speed of the pan is greater than the speed of the tea, or the speed of the tea is greater than the speed of the pan, the collision of the tea with the wall of the pot occurs. Especially when the pan is suddenly reversed, the probability of the tea colliding with the wall is the greatest. When the tea leaves are hit by the wall of the pot, they move according to their own inertial motion until they collide again. Due to the original static and dynamic differences of each piece of tea, the pan constantly collides

with the tea leaves in the reciprocating vibration, and the effect is that all the tea leaves continuously collide in the pot. The semi-cylindrical pot causes the tea to collide with the horizontal level of the pot, generating an upward throwing force. During the process of dropping the tea leaves, it slides and flips along the surface of the pot.

In order to increase the pressing force, measures such as pressing rods and tea leaves are often used. The pressurizing rod is composed of a wooden stick outsourcing cloth or a plastic tube containing sand, and the basic requirement is that the weight is heavy and the surface is soft. The tea leaves collide and flip, and slides along the surface of the pot to produce friction. The tea leaves are squeezed and rubbed against each other, and the pressed rods are pressed and rubbed against the tea leaves. Under the combined effect of the above factors, the tea leaves are dried, striped and polished. After the tea leaves with the orientation and chaos are put into the pot, the blades automatically turn to the most stable orientation - the direction of the main vein of the blade is perpendicular to the direction of reciprocation. Therefore, after the reciprocating vibration of the strip, the tea leaves are centered on the main vein of the leaf, resulting in tightening and curling. Because of the original difference, some of the blades collide more seriously, and some of the blades collide with lighter. The tea leaves of the same pot should be as large as possible, so as to ensure uniform collision force, uniform strips and less broken tea.

2, mechanical structure

1 is a schematic diagram of a mechanical structure, the slide bar is fixed on the frame, and the pot body is connected to the pot rack by a hinge, and the pot rack is supported by the sliding sleeve sliding rod. The eccentric wheel 5, the connecting rod 4, the pot body 2, and the frame 9 constitute a crank slider mechanism. When the eccentric wheel rotates, the pot body and the pan frame are integrally connected for reciprocating horizontal movement.

The reciprocating frequency adjusting mechanism is controlled by the frequency converter to adjust the vibration speed, and the adjustment is convenient; the other is

Speed control handwheel, speed control lever, turntable base, motor pulley. When the speed control handwheel is turned, the speed control lever only rotates without moving up and down. There is a thread under the speed regulating rod, which is driven by the screw to drive the base to rotate. The effect is that the speed adjusting nut moves up and down, and the adjustable base rotates up and down to make the motor belt elastically change. When the belt is tightened, the effective diameter of the belt becomes smaller, the transmission reduction ratio becomes larger, and the reciprocating frequency becomes lower. Conversely, when the pulley is relaxed, the reciprocating frequency becomes higher. It should be noted that when the belt is excessively relaxed and the belt slip increases, the vibration frequency becomes lower.

When the tea is out, the tea handle is lifted up, the pot body rotates around the rotation axis, and the tea door is automatically opened, and the tea leaves are discharged.

V. Operation and use

1. Preparation before use

(1) The ground is required to be leveled, and the anchor bolts are installed after the machine is in place.

(2) Please be sure to check whether the power supply voltage used is the same as the voltage selected for this product, and the ground wire and electric shock protector should be connected to ensure the safety of personnel and equipment.

(3) Check that the fasteners are reliable and tighten the loose fasteners.

(4) Remove debris from the pot and the surface of the machine and wipe it off with a cloth.

(5) Add a proper amount of lubricating oil to the moving parts such as connecting rods and sliding sleeves to ensure that the machine can run at the best condition.

(6) Turn on the power to start the machine for 0.5 hours of empty operation, no jamming, collision and abnormal sound.

2, operation and use

(1) After the machine is running normally after idling, the electric heating tube button can be activated to heat and adjust the vibration frequency for slow operation. When the temperature of the pot reaches 80-100 ° C, the running speed of the pot is adjusted fast, and the water content of the tea to be fried is 35%-40%, and the tea leaves are uniformly put into each tank. The total amount of leaves is about 1.2kg, each pot The amount of leaf should be even.

(2) After 4-5 minutes, when the moisture content of the leaf is reduced to about 20%, when the tight peak of the strip is exposed and the aroma overflows, the pot handle is lifted and the tea leaves are quickly discharged out of the pot.

(3) After the cold and the pot is put into the pot again, it is generally done three times. Every time it should be cooled down, so that the water loss is balanced. As for the temperature, it should be "high first and then low". The actual situation of making tea "see tea for tea."

(4) When using this unit, please carefully grasp the temperature change of the pot to prevent other phenomena that affect the quality of the tea, such as yellowing, darkening, or sizzling.

VI, maintenance

1, in use

a. Clean the machine regularly;

b. Check the temperature rise of the motor and other components to hear if there is any abnormal sound;

c. Observe the oil quantity of the chute oil tank, add lubricating oil in time, and regularly add lubricating oil (fat) to other moving parts such as connecting rods;

d. Regularly check that the fasteners are reliable and tighten the loose fasteners.

2, after use (end of each tea season)

a. Thoroughly cleaned up;

b. Cleaning and replacement of lubricating oil (fat);

c. Cover the machine with a cloth or other dust cover to keep the storage area dry and ventilated.

Vii. common faults and troubleshooting methods

Common faults	Troubleshooting & repair methods
Out of the tea door leaking tea	1, check whether the spring loses elasticity or lack of elasticity, if the spring is replaced; 2, check whether the tea door deformation, if it is used to knock flat with a wooden hammer; 3, check out whether the tea door piled up tea dust, clear tea dust;
The pot body beats badly	1, check whether the sliding sleeve or guide rail wear, if the wear is obvious should be replaced; 2, check whether the connecting rod or PIN shaft wear, if the wear is obvious should be replaced;
Abnormal sound	1, check whether the oil tank is insufficient oil quantity; 2, check whether the sliding sleeve or guide rail wear, if the wear is obvious should be replaced; 3, check whether the connecting rod or PIN shaft wear, if the wear is obvious should be replaced; 4, check whether there is collision or friction between the pot body and the rack or heating source parts;

	5, check the transmission parts, whether the fasteners are loose, the position of the belt wheel is correct;
The electric furnace temperature doesn't go.	1, disassemble the mask board, check whether the line is intact; 2, check whether the heat pipe is heated, replace the electric heating tube without heat;
Gas spots don't catch fire.	1, check whether the gas source is airborne, no should replace the gas source; 2, check the electrical part, adjust the position of the firing needle and replace the battery, after the adjustment does not anger should be repaired and replaced; 3, check whether the switch part or nozzle has foreign body; 4, check whether the pressure relief valve ventilation;
Gas appears Huang	1, check whether the gas source is airborne, no should replace the gas source; 2, check the burner, clean the combustion hole; 3, check the nozzle, clean the nozzle blockage;
Gas flames are not uniform.	1, check the burner, clean the combustion hole;
Gas combustion has noise	1, check the burner, clean the combustion hole; 2, check the nozzle, clean the nozzle blockage; 3, check the air tightness of the pipeline;

Viii. Other

1, List of Consumables

S/N	Part name	Number	Graphic No.
1	Connecting rod	1	6CLZ60/11-5000/13 (A)
2	Connecting rod pin Sleeve	1	6CLZ60/11-5000/14
3	PIN Shaft	1	6CLZ60/11-5000/15
4	Connecting Rod seat	1	6CLZ60/11-5000/16 (A)
5	Sliding sleeve Components	4	6CLZ60/11-4000
6	U type electric Heat pipe	2, 1	2. 5kW, 3kW/220V
7	Triangle Belt	1, 2	B1041, B1168
8	Rolling bearing 6204	1	GB276-82
9	Rolling bearing 6205	4	GB276-82

Note: 1. The wearing parts are provided by the customer; 2. The quantity is the number of each.

2, The delivery list

S/N	Graphic No.	Item name	Number	Remarks
1	6CLZ60/8、11	Tea strip shaping carding machine	1	
2		Jumping stick L=585	8	
3		Expansion screw M10×100	4 pairs	
4		User' s manual	1	
5		Product warranty voucher	1	
6		Product Certification	1	
7		Packing List	1	