Sponge-Jet®海绵喷砂系统

介质回收器
用户手册

型号:

35-P

50-P

Sponge-Jet, Inc.

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1-603-610-7950 / www.spongejet.com

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1.0 前言

基本组件

1. 料斗
2. 主筒缘
3. 振动部分
4. 安全罩
5. 大颗粒出料管
6. 盘卡箍钩
7. 盘卡箍
8. 再利用介质出料管
9. 细颗粒出料管
10. 压力表
11. 进气阀
12. 润滑器
13. 调压器
14. 空气过滤器
15. 供气管路接头
16. 支架
17. 消声器
18. 马达

2.0 安全检查清单

- Sponge-Jet 公司的回收器(Recycler)为高压系统。只允许经过培训的操作工对本设备进行调节、维护和修理。
- 回送压力不得超过 8.6 bar (125 psi)。
- 为防止静电的累积和可能的放电，本装置必须正确接地/连接。
- 视清除涂层或污染物的具体类型，操作人员和喷砂场所附近的人员必须始终佩戴眼部和耳部防护装备以及相应的呼吸装备和防护服。
- 应检查所有气动管路有无孔洞、磨损，是否正确接合。
- 在所有供气软管接头上均应配备安全销和限流器，以防止连接意外断开。
- 严禁振动部件接触静态或静止部件。
- 确认本装置安装稳定、牢固且坐落在平面上。
- 未配备安全罩时，严禁进行操作。
- 在开始任何作业（除正常操作）之前，确保整个系统已泄压。

重要事项：在**任何**情况下，设备正在运行或与供气装置连接时，严禁进行任何检查、调节或润滑。

3.0 要求

3.1 供气/压缩机

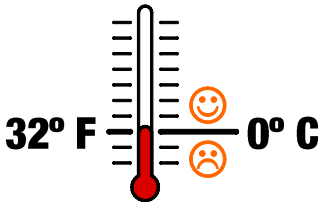
必须供应清洁干燥的压缩空气。本装置要求 **2.8 bar (40 psi)** 下的最小供气流量为 **2 m³ /min (70 cfm)**。

3.2 供气连接

本装置采用一个 12.7 mm (.5 in) 标准管路，通常可与 12.7 mm (.5 in) 通用 2 耳接头匹配。供气软管应配备一个匹配的接头，或根据需要对两个接头一起进行更换。

将至少为 12.7 mm (.5 in) 的供气软管连接到**供气管路接头**上。
注：在高湿度环境中，需要安装更多的除湿器。

3.3 环境温度



环境温度应高于 0° 摄氏度（32° 华氏度）。否则：

a) 在润滑器中使用冬用气动工具润滑油。

b) 最大限度减少供气中的水份。

c) 轴承润滑脂在严寒环境中会稠化，因而需要使用低温润滑脂。在操作之前，可能需要对本装置进行预热。

3.4 介质废料与收集

在每个出料管下方均需放置一个容器，用于收集和运送 Sponge Media™ 和废料。

4.0 操作

在回收器(Recycler)加压和操作之前：

- 严禁振动部件接触静态或静止部件。
- 确认本装置安装稳定、牢固且坐落在平面上。
- 应检查所有气动管路有无孔洞、磨损，是否正确接合。
- 在所有供气软管接头上均应配备安全销和限流器，以防止连接意外断开。
- 在开始任何作业（除正常操作）之前，确保整个系统已泄压。

确保本装置不受约束。刚性连接会降低效率并导致损坏。

请检查**盘卡箍**是否扣紧。每个盘卡箍杠杆手柄端部均不得超过 14 kg (30 lbs.)。通过转动**盘卡箍钩**进行调节。

将供气软管连接到**供气管路接头**上，并用安全销和限流器固定。
注：调压器出厂设置为 2.5-2.8 bar (35-40 psi)，应该不需要调节。

请确认在**润滑器**中能看见气动工具润滑油（见第 5.0 节）。

在每个**颗粒出料管**下方放置料桶/料袋。

通过打开**进气阀**进行启动。

从**料斗**添加喷砂 Sponge Media。

尺寸过大的颗粒将从**大颗粒出料管**中排出。

废料：请妥善处置。

可循环使用的 Sponge Media 从**再利用介质出料管**中排出。

可循环使用介质：要制备喷砂混合磨料，请添加 5% 至 10% 的新 Sponge Media；这种混合磨料即可用于喷砂了。

更小的污染物和用过的 Sponge Media 从**细颗粒出料管**中排出。

废料：请妥善处置。

重要事项：需要根据工程环境确定可接受的粉尘含量。如果要求低粉尘含量，则让循环的 Sponge Media 再次或多次通过**料斗**。

5.0 维护

重要事项：在**任何**情况下，装置正在运行或与供气装置连接时，严禁进行任何检查、调节或润滑。

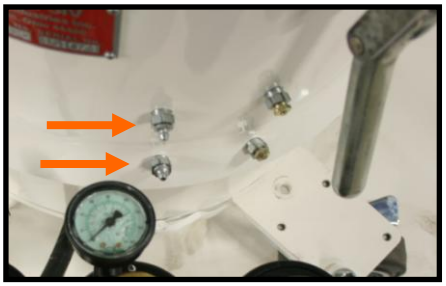
5.1 轴承润滑脂

本装置出厂前已加注过润滑脂。每工作 500 小时，加半筒（或少量）润滑脂。如果本装置一年未使用，加 1 至 2 筒润滑脂。请使用 NLGI #2 品质的润滑脂，如：

- Citco 公司的 Citco AP
- Ore-Lube 公司的 K2
- Mobil Oil 公司的 Mobilux
- Mobil Oil 公司的 Socony
- Valvoline 公司的 Val-Lith #IP。
- MM Industries 公司的 VS SGA。
- Texaco 公司的 Multifak #2。
- Shell Oil 公司的 Alvanie R#。

5.2 接触润滑管件

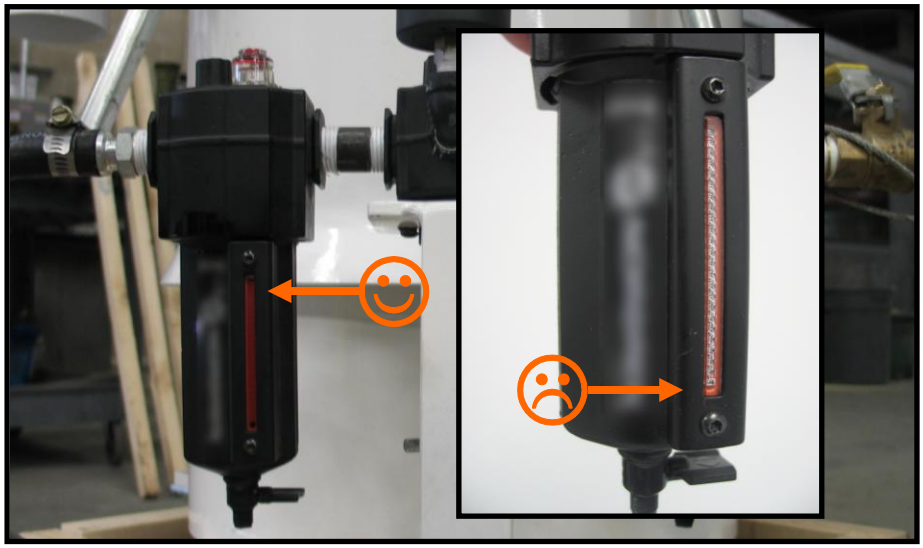
两个轴承应该通过机器侧面的管接头进行润滑。



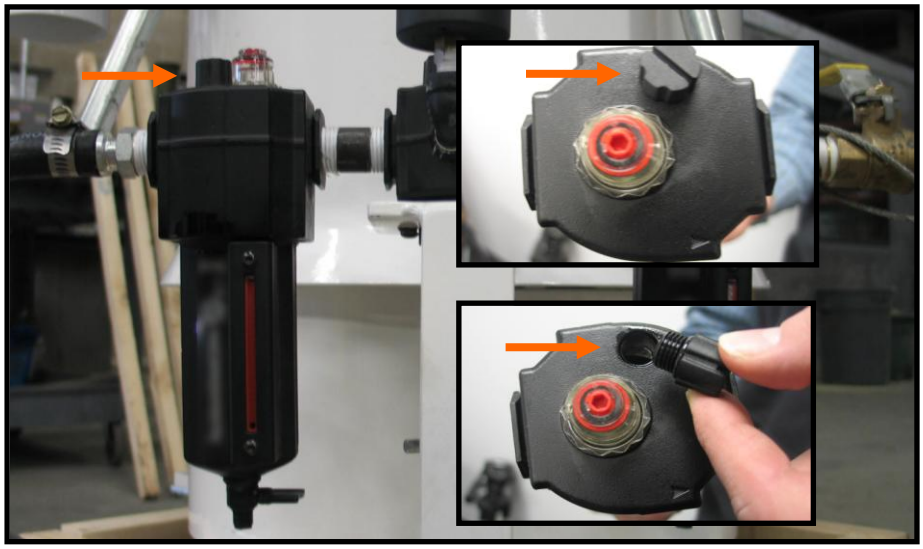
请勿加注过多润滑脂。

5.3 润滑器

检查**润滑器**中的气动油位。



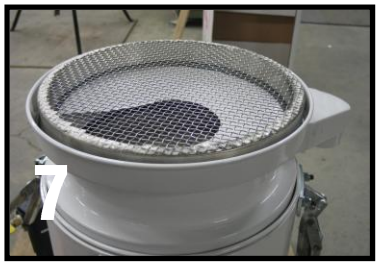
根据需要从顶部的加油口重新加注气动工具润滑油。



网筛组件

注：未正确组装和固定**网筛组件**，将大幅缩短其工作寿命。

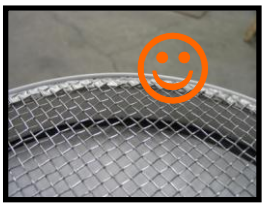
请按以下步骤进行组装：



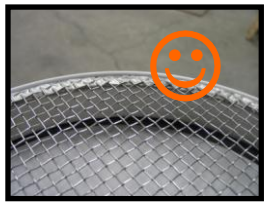
1. 将**细颗粒出料管**插入**振动部分**的孔中。**注：**务必使出料管对中。
2. 将一个**平垫圈**放入**浅漏斗**中。
3. 将**底筛**（#16* 目）放在**平垫圈**上。**重要事项：将网筛一侧朝上放置**。**
4. 将一个**平垫圈**放在**底筛**的筛网上。
5. 将**主筒缘**放在**平垫圈**上。
6. 将一个**平垫圈**放入**主筒缘**上方。
7. **将顶筛**（#3* 目）放入**主筒缘**的**平垫圈**上。**重要事项：将网筛一侧朝上放置**。**
8. 将一个**平垫圈**放在**顶筛**上，请务必使**平垫圈**对中。
9. 将**料斗**放在**平垫圈**上。
10. 装好所有**盘卡箍**。必须对这些盘卡箍进行正确调整，以确保**网筛**装置牢固固定（请参见 4.0 操作）。

*除非规定或提供了其他规格，否则顶筛标准规格为 #3；底筛标准规格为 #16。

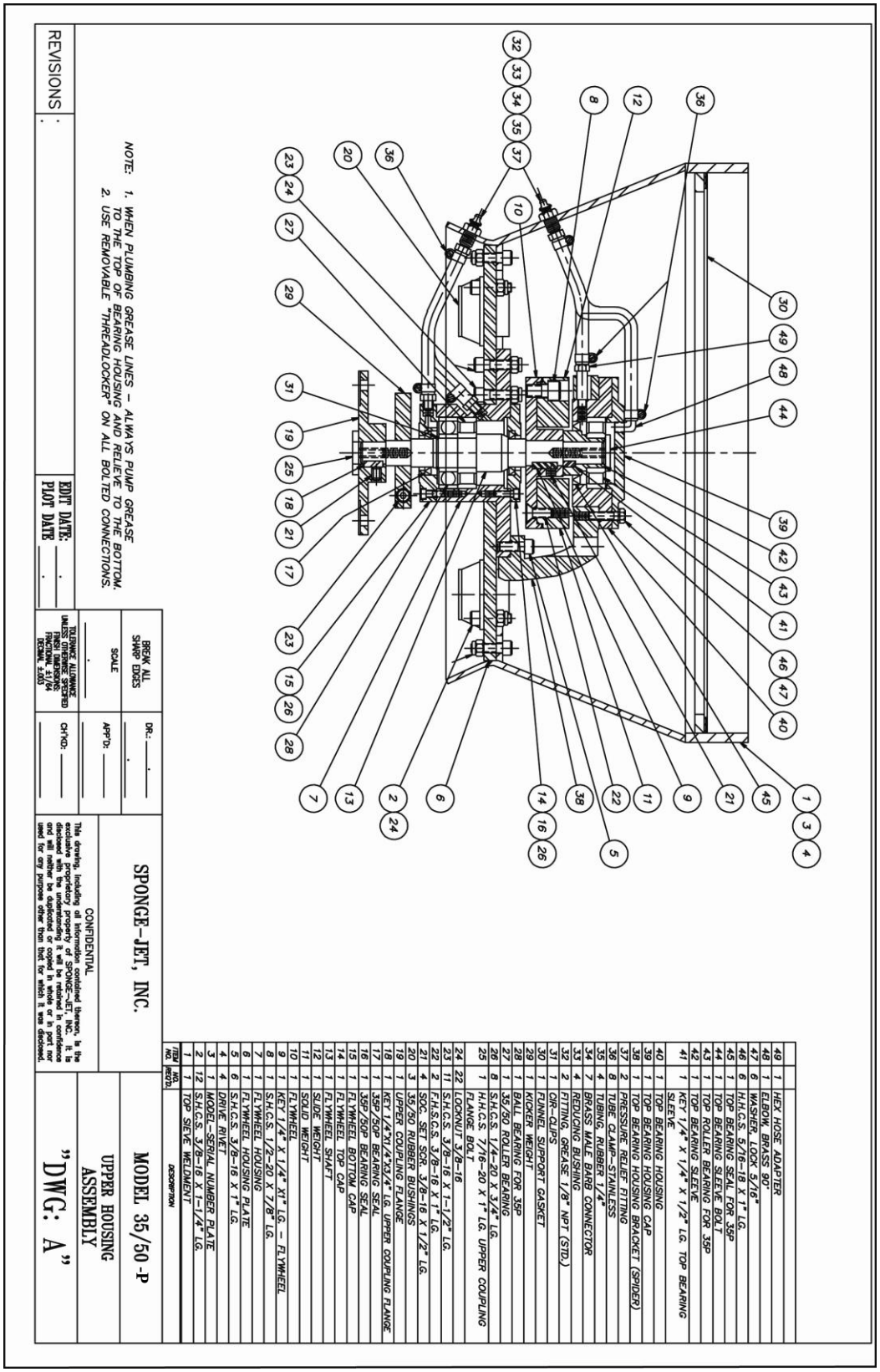
**网筛必须网面一侧朝上。组装不正确可导致工作异常。



6.0 故障排除

装置不启动或振动太慢	请确认**压力表**读数是否在 2.5-2.8 bar(35-40 psi) 之间。 **如果装置温度接近或低于冰点，** a) 操作之前可能需要对本装置进行预热。 b) 在润滑器中使用冬用气动工具润滑油。 c) 最大限度减少供气中的水份。 **如果振动慢，但装置仍在工作**，则在不添加 Sponge Media 的情况下进行空转，直到振动正常为止。
大颗粒出料管中排出 **Sponge Media**	请确认**顶筛**安装正确且无任何碎屑。 
喷砂时，发现粉尘量过多	请确认**底筛**安装是否正确。 可通过以下方法进一步减少粉尘： 1. 让 Sponge Media 再次通过本装置。 2. 使用更大开口率的**底筛**。

7.0 图纸


NOTE: 1. WHEN PLUMBING GREASE LINES – ALWAYS PUMP GREASE TO THE TOP OF BEARING HOUSING AND RELIEVE TO THE BOTTOM.
2. USE REMOVABLE "THREADLOCKER" ON ALL BOLTED CONNECTIONS.
REVISIONS
EDIT DATE:
PLOT DATE
BREAK ALL SHARP EDGES
SCALE
TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED FINISH DIMENSIONS FRACTIONAL ±1/64 DECIMAL ±.005
DR.:
APP'D:
CH'KD:
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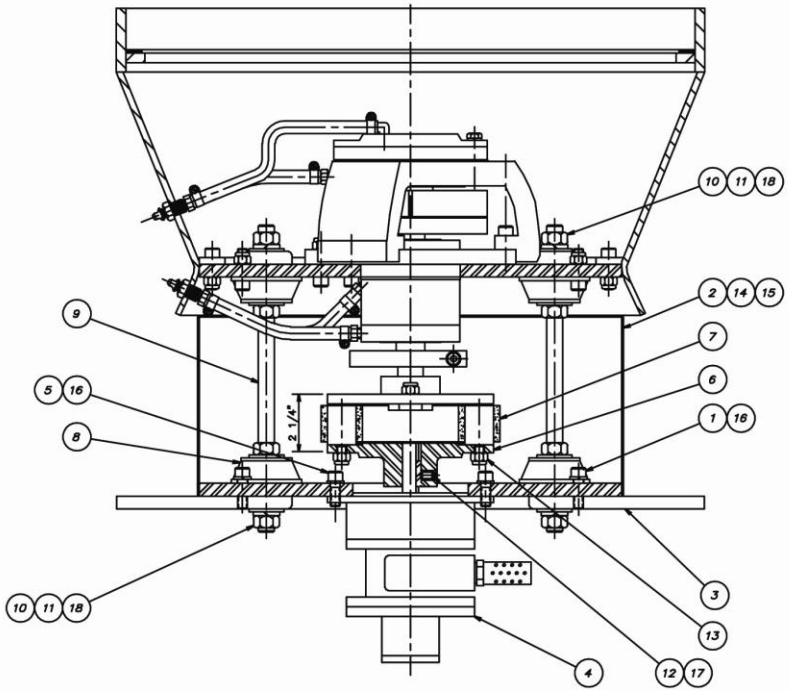
MODEL 35/50 -P
UPPER HOUSING ASSEMBLY
"DWG: A"
ITEM NO. | NO. REQ'D. | DESCRIPTION
49 1 HEX HOSE ADAPTER
48 1 ELBOW, BRASS 90°
47 6 WASHER, LOCK 5/16"
46 6 H.H.C.S. 5/16-18 X 1" LG.
45 1 TOP BEARING SEAL FOR 35P
44 1 TOP BEARING SLEEVE BOLT
43 1 TOP ROLLER BEARING FOR 35P
42 1 TOP BEARING SLEEVE
41 1 KEY 1/4" X 1/4" X 1/2" LG. TOP BEARING SLEEVE
40 1 TOP BEARING HOUSING
39 1 TOP BEARING HOUSING CAP
38 1 TOP BEARING HOUSING BRACKET (SPIDER)
37 2 PRESSURE RELIEF FITTING
36 8 TUBE CLAMP-STAINLESS
35 4 TUBING, RUBBER 1/4"
34 7 BRASS MALE BARB CONNECTOR
33 4 REDUCING BUSHING
32 2 FITTING, GREASE 1/8" NPT (STD.)
31 1 CIR-CLIPS
30 1 FUNNEL SUPPORT GASKET
29 1 KICKER WEIGHT
28 1 BALL BEARING FOR 35P
27 1 35/50 ROLLER BEARING
26 8 S.H.C.S. 1/4-20 X 3/4" LG.
25 1 H.H.C.S. 7/16-20 X 1" LG. UPPER COUPLING FLANGE BOLT
24 22 LOCKNUT 3/8-16
23 11 S.H.C.S. 3/8-16 X 1-1/2" LG.
22 2 F.H.S.C.S. 3/8-16 X 1" LG.
21 4 SOC. SET SCR. 3/8-16 X 1/2" LG.
20 3 35/50 RUBBER BUSHINGS
19 1 UPPER COUPLING FLANGE
18 1 KEY 1/4"X1/4"X3/4" LG. UPPER COUPLING FLANGE
17 1 35P/50P BEARING SEAL
16 1 35P/50P BEARING SEAL
15 1 FLYWHEEL BOTTOM CAP
14 1 FLYWHEEL TOP CAP
13 1 FLYWHEEL SHAFT
12 1 SLIDE WEIGHT
11 1 SOLID WEIGHT
10 1 FLYWHEEL
9 1 KEY 1/4" X 1/4" X1" LG. – FLYWHEEL
8 1 S.H.C.S. 1/2-20 X 7/8" LG.
7 1 FLYWHEEL HOUSING
6 1 FLYWHEEL HOUSING PLATE
5 6 S.H.C.S. 3/8-16 X 1" LG.
4 4 DRIVE RIVET
3 1 MODEL-SERIAL NUMBER PLATE
2 12 S.H.C.S. 3/8-16 X 1-1/4" LG.
1 1 TOP SIEVE WELDMENT



NOTE:
1. THE FLEXIBLE COUPLING MUST BE ADJUSTED TO 2 1/4" FROM THE TOP OF THE UPPER FLANGE TO THE BOTTOM OF THE MOTER FLANGE
2. DO NOT ATTEMPT TO OPERATE THE MOTOR WITHOUT THE FLEXIBLE COUPLING BOLTED TO THE UPPER FLANGE AND MOTOR FLANGE.
3. USE REMOVABLE "THREADLOCKER" ON ALL BOLTED CONNECTIONS.

ITEM NO.	NO. REQ'D.	DESCRIPTION
18	12	5/8" DIA FLAT WASHERS
17	1	KEY, MOTOR SHAFT 3/16" SQ. X 1" LG.
16	10	WASHER, SPLIT 3/8"
15	1	OVER CENTER LATCH STRAP
14	1	TRUNION, NUT AND BOLT STRAP
13	4	LOCKNUT 3/8-16
12	2	SOC. SET SCR. 3/8-16 X 1/2" LG.
11	6	WASHER, SPLIT 5/8"
10	12	NUT, HEX 5/8-11
9	3	35/50 RECYCLER SUSPENSION RODS
8	3	BUSHING, RUBBER
7	1	35/50 RECYCLER FLEXIBLE COUPLING
6	1	MOTOR FLANGE
5	4	S.H.C.S. 3/8-16 X 1" LG.
4	1	35/50 AIR MOTOR
3	1	MOTOR PLATE
2	2	35/50 SIDE COVERS
1	6	S.H.C.S. 3/8-16 X 1-1/4" LG.

BREAK ALL SHARP EDGES

SCALE

TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED
FINISH DIMENSIONS:
FRACTIONAL ±1/64
DECIMAL ±.005

DR.:

APP'D:

CH'KD:

MODEL 35/50

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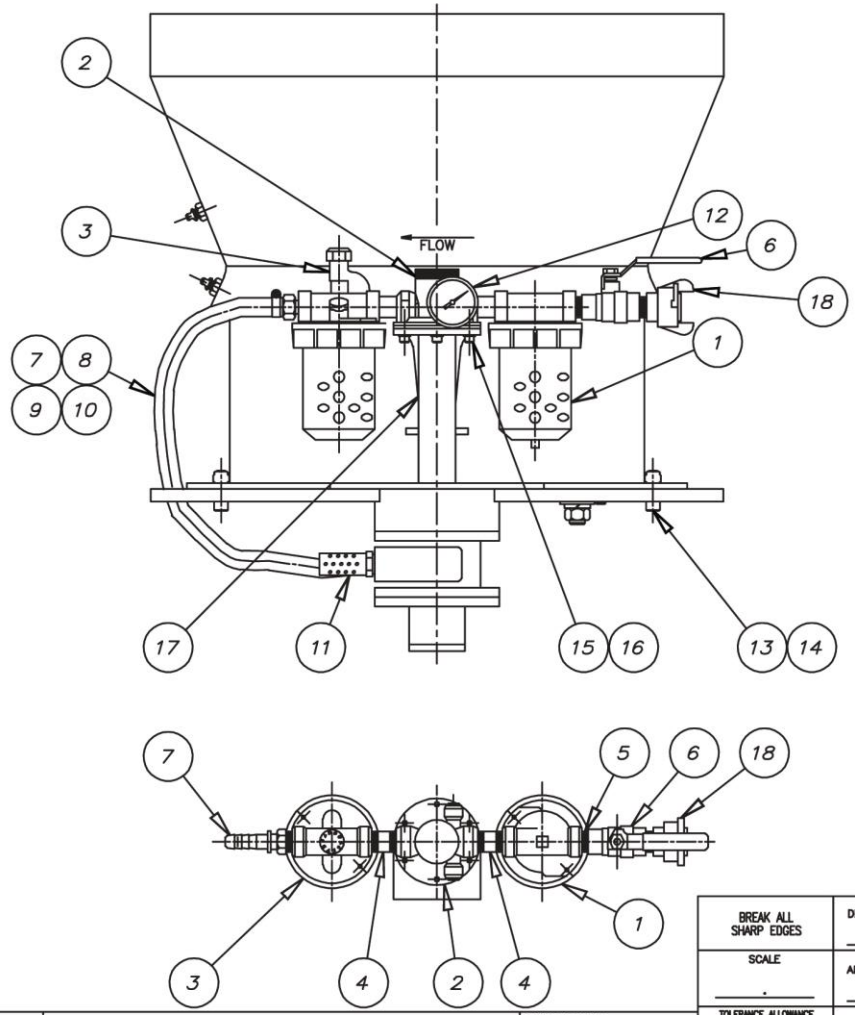
MODEL RBF-15/22

PNEUMATIC MOTOR
DRIVE ASSEMBLY

"DWG: B"

REVISIONS

EDIT DATE:
PLOT DATE



ITEM NO.	NO. REQ'D.	DESCRIPTION
1	1	35–P MOISTURE SEPARATOR
2	1	35–P REGULATOR
3	1	35–P AUTOMATIC LUBRICATOR
4	1	1/2" NPT X 2" LG NIPPLES
5	2	1/2" NPT CLOSE NIPPLES
6	1	1/2" BALL VALVE
7	1	1/2" NPT HOSE BARB FITTING WITH ORIFICE
8	1	1/2" NPT HOSE BARB FITTING
9	2	HOSE CLAMPS
10	1	1/2" I.D. AIR HOSE
11	1	MUFFLER FOR 35P RECYCLER
12	1	2 1/2" GAUGE; 0–160 PSI W/CLIP
13	2	LOCKNUT 3/8–16 (SHIPPING ONLY)
14	2	S.H.C.S. 3/8–16 X 1–1/2" LG. (SHIPPING ONLY)
15	3	1/4" – 20 UNC SHCS X 1" LG
16	3	1/4" LOCKWASHER
17	1	FRL MOUNT
18	1	1/2" 2 PRONG COUPLING

NOTE:
1. ALL FITTINGS SEALED WTIH TEFLON TAPE.
2. AIR SYSTEM IS FACTORY SET TO RUN AT 3000 RPM MAXIMUM.
3. FILTER, REGULATOR, AND LUBRICATOR ARE CURRENTLY SUPPLIED BY THE CUSTOMER FOR ASSEMBLY.
4. SAFETY TIE BARB FITTING WITH ORIFICE TO LUBRICATOR.

REVISIONS

EDIT DATE:
PLOT DATE

BREAK ALL SHARP EDGES

SCALE

TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED
FINISH DIMENSIONS:
FRACTIONAL ±1/64
DECIMAL ±.003

DR.:
APP'D:
CH'KD:

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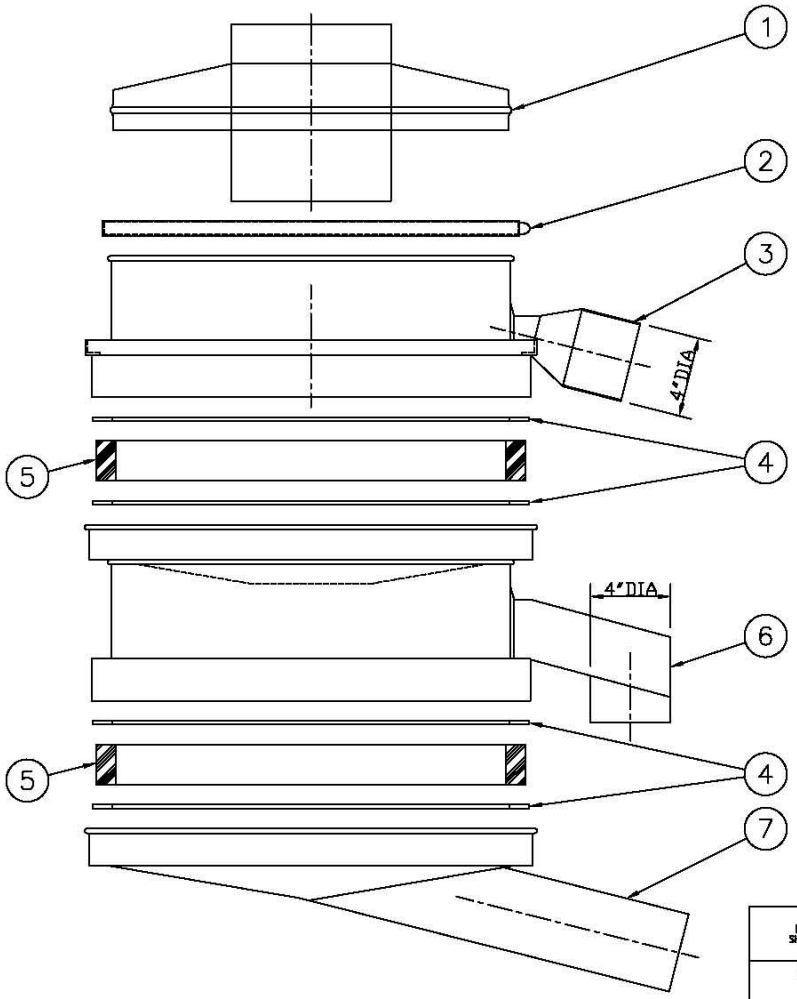
MODEL 35/50-P

PNEUMATIC SYSTEM ASSEMBLY

"DWG: C"



ITEM	QTY.	DESCRIPTION
1	1	DOME LID WITH 8" DIA. INLET
2	1	22" RIM LOCKING BAND
3	1	UPPER MAIN RIM
4	4	22" FLAT GASKET
5	2	50P SCREEN
6	1	LOWER MAIN RIM
7	1	22" SHALLOW FUNNEL

REVISIONS

EDIT DATE:
PLOT DATE

BREAK ALL SHARP EDGES

SCALE

TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED
FINISH DIMENSIONS:
FRACTIONAL ±1/64
DECIMAL ±.003

DR.:
APP'D:
CH'KD:

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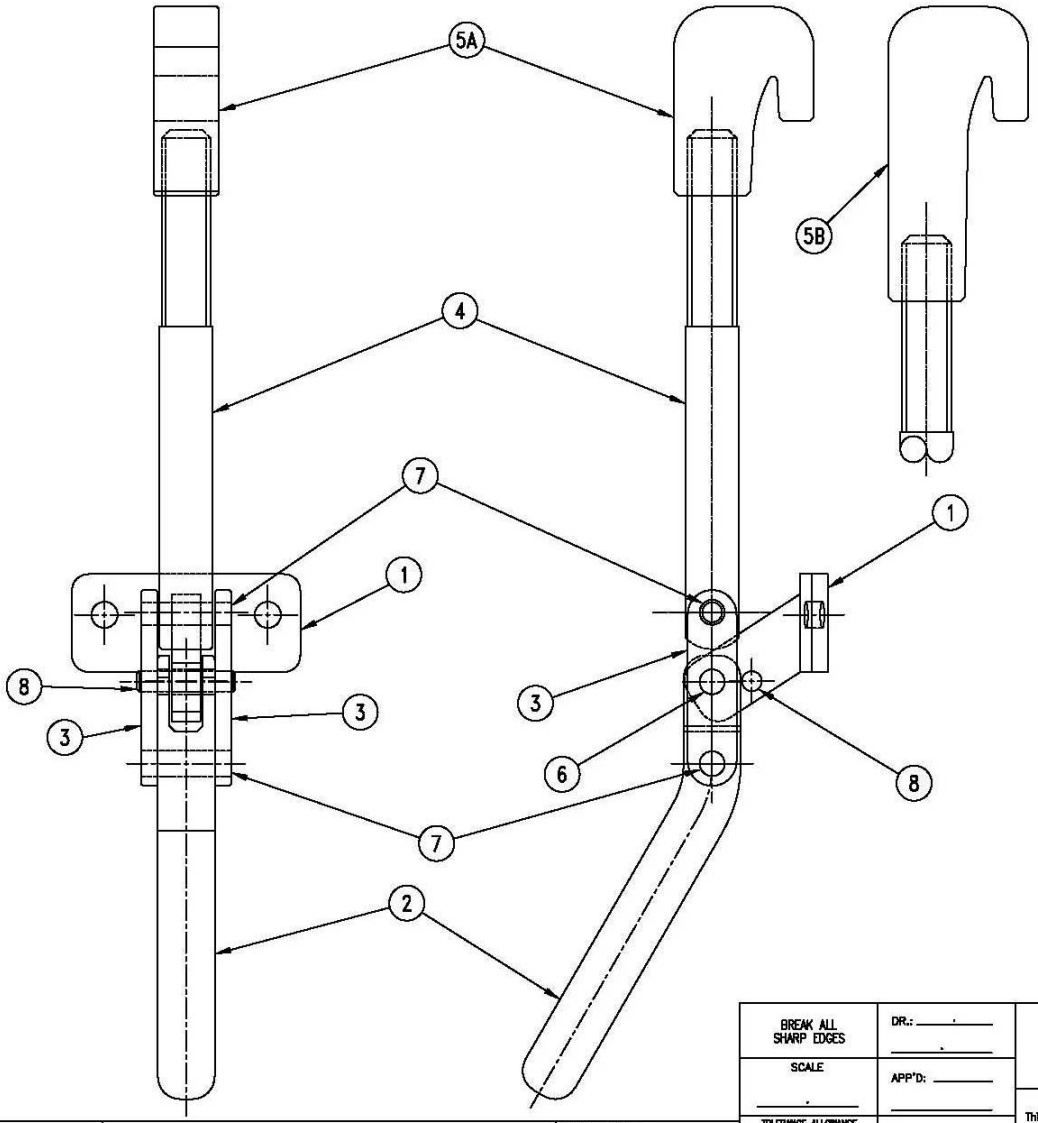
MODEL 50-P

CONTACT PARTS

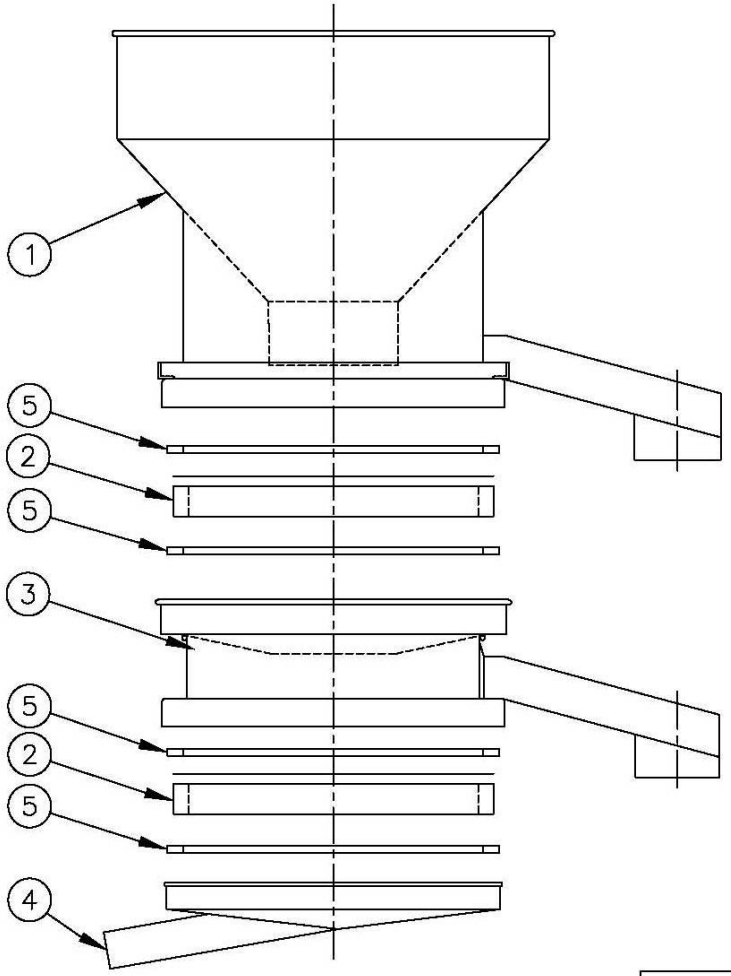
"DWG: D"



ITEM	DESCRIPTION	REQ'D.
1	35 & 50P/E CLAMP BODY ONLY	1
2	HANDLE FOR #050PW-8	1
3	35/50 LINK FOR CLAMP (2 REQUIRED PER CLAMP)	2
4	THREADED ROD FOR 35P/E & 50P CLAMP 050PW-8	1
5A	35P CLAMP ARM HOOK	1
5B	50P CLAMP ARM HOOK	1
6	35/50 SHORT PIN FOR CLAMP	1
7	35/50 LONG PIN FOR CLAMP	2
8	35/50 STOP PIN FOR CLAMP BODY FOR 050PW-8	1
	50P RECYCLER COMPLETE CLAMP	4
	35/50 LOCKNUTS 3/8-16	8
	35P RECYCLER COMPLETE CLAMP	4

NOTE: 1. USE REMOVABLE "THREADLOCKER" WHEN BOLTING TO THE TOP HOUSING.

REVISIONS	EDIT DATE: PLOT DATE:	BREAK ALL SHARP EDGES	DR.:	SPONGE-JET, INC.	MODEL 35-P/50-P
		SCALE	APP'D:	CONFIDENTIAL	CLAMP ASSEMBLY
		TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED FINISH DIMENSIONS: FRACTIONAL ±1/64 DECIMAL ±.005	CH'KD:	This drawing, including all information contained thereon, is the exclusive proprietary property of SPONGE-JET, INC. It is disclosed with the understanding it will be retained in confidence and will neither be duplicated or copied in whole or in part nor used for any purpose other than that for which it was disclosed.	"DWG: E"



ITEM	QTY.	DESCRIPTION
1	1	HOPPER
2	2	35-P SCREEN
3	1	MAIN RIM WITH 2" X 9" OVERSIZE CHUTE
4	1	SHALLOW FUNNEL
5	4	FLAT GASKETS

BREAK ALL SHARP EDGES	DR.:	SPONGE-JET, INC.	MODEL 35-P	
SCALE	APP'D:	CONFIDENTIAL	CONTACT PARTS	
TOLERANCE ALLOWANCE UNLESS OTHERWISE SPECIFIED FINISH DIMENSIONS: FRACTIONAL ±1/64 DECIMAL ±.005	CH'KD:	This drawing, including all information contained thereon, is the exclusive proprietary property of SPONGE-JET, INC. It is disclosed with the understanding it will be retained in confidence and will neither be duplicated or copied in whole or in part nor used for any purpose other than that for which it was disclosed.	"DWG: F"	

REVISIONS

EDIT DATE:

PLOT DATE:

说明: _____

型号: _____

序列号: _____