

安全檢查和機械設定

Safety Check and Machine Condition Setting

1. 確認安全裝置是否可以正常運作。

Check safety device is working.



捏合機標準混練條件 – A 混練

Standard compounding Conditions in Kneader- A Compound

1. 打開集塵機。Turn on the dust collector.
2. 素練 Plasticate the raw rubber. [30 sec.]
讓生膠卷在轉子上，讓生膠進入可塑狀態。

Make the raw rubber curl on the rotors and transfer the raw rubber into plastic state.

Step1: 將生膠放入混合腔中。Put the raw rubber into the mixing chamber.



Step2: 讓重捶完全降下，確保所有生膠均在混合腔中，並將及塵罩蓋下。

Let the pressure lid completely go down and make sure all raw rubber is curling in the mixing chamber. Press the button to pull down the dust cover.



Step3: 開啟主馬達，確認轉速達到 180RPM 後，開啓計時器。

Turn on the main motor and make sure the main motor RPM reach 180.0, then turn on the mixing timer.



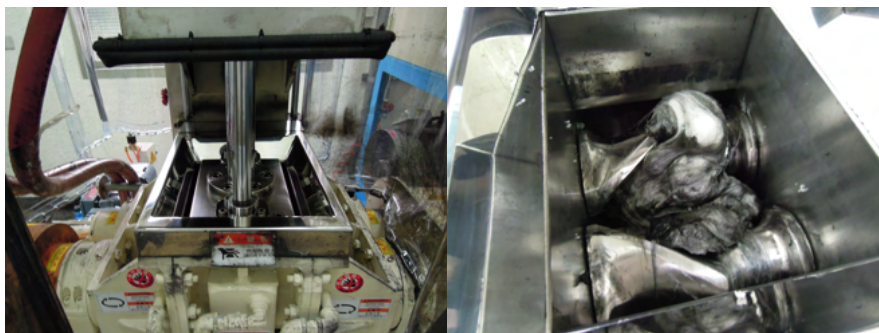
Step4: 每 10 秒紀錄溫度和電流值。

Record the temperature and the electric current every 10 second.



Step5: 30 秒後，停止主馬達後升起防塵罩，確認轉子完全停止，讓重錘升起。

After 30 seconds, stop the main motor and press the button to lift the dust cover. Make sure the rotors have completely stopped, then let the pressure lid go up.



Step6: 測量並紀錄混煉膠溫度。 Measure and record the temperature of the compound.



3. 加入抗氧化劑、潤滑劑和 1/2 量的碳黑。

Add the antioxidants, lubricants and 1/2 amount of carbon black. [120 sec.]

Step1: 加入抗氧化劑、潤滑劑和 1/2 量的碳黑到混合腔中。

Add antioxidants, lubricants and 1/2 amount of carbon black into the mixing chamber.



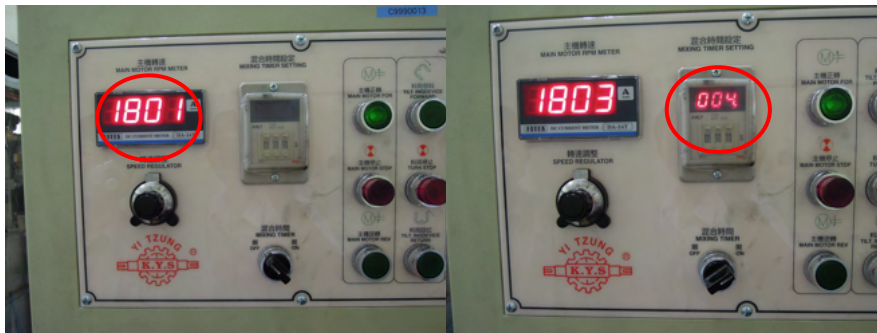
Step2: 讓重錘下降和混合腔開口平行，蓋下防塵罩。

Let the pressure lid go down to parallel with the opening at the top of the mixing chamber and press the button to pull down the dust cover.



Step3: 開啟主馬達，確認轉速達到 180RPM 後，開啟計時器。

Turn on the main motor and make sure the main motor RPM reach 180.0, then turn on the mixing timer.



Step4: 每 10 秒紀錄溫度和電流值。

Record the temperature and the electric current every 10 seconds.



Step5: 30 秒後讓重錘完全降下。

Let the pressure lid completely go down at 30 seconds.



Step6: 每 10 秒紀錄溫度和電流值。

Keep recording the temperature and the electric current every 10 seconds.



Step7: 120 秒後，停止主馬達，升起防塵罩，將重錘上的碳黑掃入混合腔中。

After 120 seconds, stop the main motor and lift the dust cover. Sweep the left over carbon black on the top of pressure lid into the mixing chamber.



Step8: 讓重錘升高，將重錘側邊黏附的碳黑掃入混合腔中。

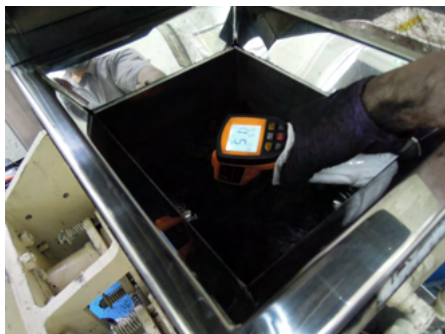
Let the pressure lid over the mixing chamber. Sweep the left over carbon black on the side of the pressure lid into the mixing chamber.



Step9: 讓重錘完全升起。
Let the pressure lid completely go up.



Step10: 測量並紀錄混練膠溫度。
Measure and record the temperature of the compound.



Step11: 將混合腔口的碳黑掃入混合腔。
Sweep the left over carbon black on the sidewall into the mixing chamber.

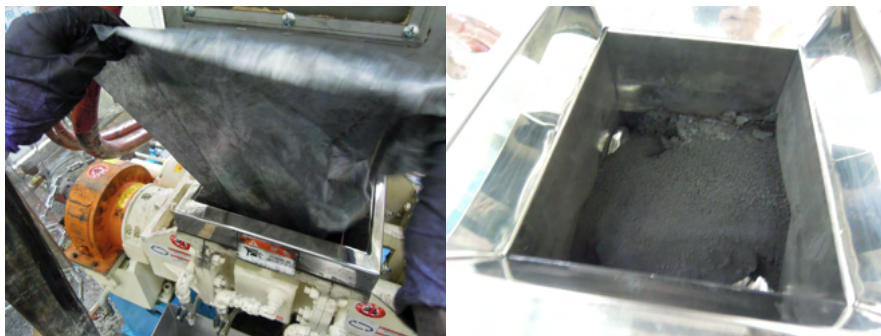


4. 加入剩下的 1/2 碳黑到混練膠中。

Add the rest amount of 1/2 carbon black into the rubber. [210 sec.]

Step1: 加入剩下的 1/2 碳黑到混合腔中。

Add the rest amount of 1/2 carbon black into the mixing chamber.



Step2: 讓重錘下降和混合腔開口平行，蓋下防塵罩。

Let the pressure lid go down to parallel with the opening at the top of the mixing chamber and press the button to pull down the dust cover.



Step3: 開啟主馬達，確認轉速達到 180RPM 後，開啓計時器。

Turn on the main motor and make sure the main motor RPM reach 180.0, then turn on the mixing timer.



Step4: 每 10 秒紀錄溫度和電流值。

Record the temperature and the electric current every 10 second.



Step5: 30 秒後讓重錘完全降下。

Let the pressure lid completely go down at 30 seconds.



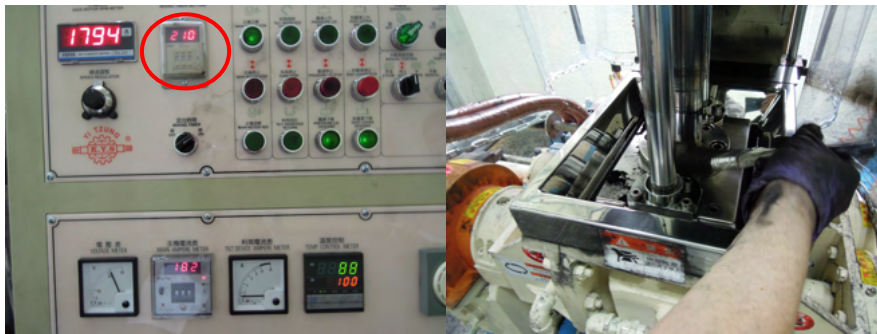
Step6: 每 10 秒紀錄溫度和電流值。

Keep recording the temperature and the electric current every 10 seconds



Step7: 210 秒後，停止主馬達，升起防塵罩，將重錘上的碳黑掃入混合腔中。

After 210 seconds, stop the main motor and press the button to lift the dust cover. Sweep the left over carbon black on the top of pressure lid into the mixing chamber.



Step8: 讓重錘升高，將重錘側邊黏附的碳黑掃入混合腔中。

Let the pressure lid over the mixing chamber. Sweep the left over carbon black on the side of the pressure lid into the mixing chamber.

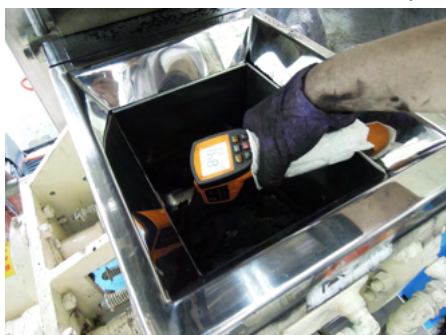


Step9: 讓重錘完全升起。 Let the pressure lid completely go up.



Step10: 測量並紀錄混練膠溫度。

Measure and record the temperature of the the compound.



Step11: 將混合腔口的碳黑掃入混合腔。

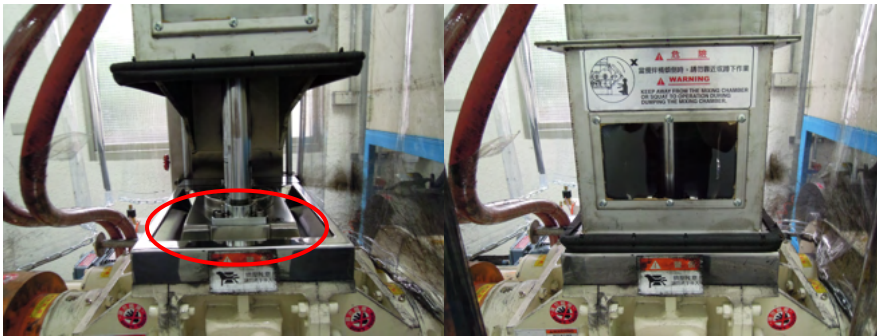
Sweep the left over carbon black on the sidewall into the mixing chamber.



5. 混練膠再次混合 Remix the compound. [60 sec.]

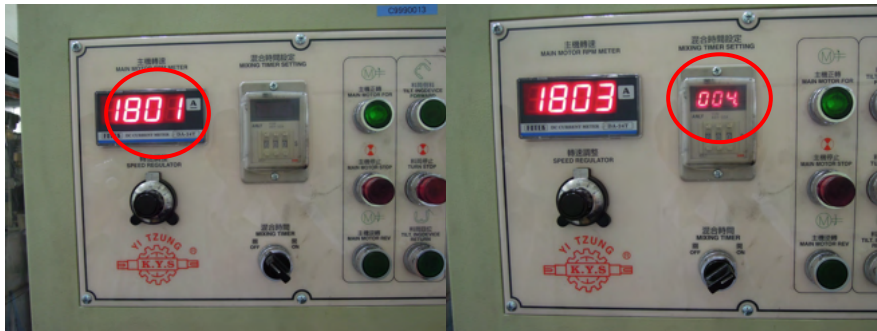
Step1: 讓重錘下降和混合腔開口平行，蓋下防塵罩。

Let the pressure lid go down to parallel with the opening at the top of the mixing chamber and press the button to pull down the dust cover.



Step2: 開啟主馬達，確認轉速達到 180RPM 後，開啓計時器。

Turn on the main motor and make sure the main motor RPM reach 180.0, then turn on the mixing timer and let the pressure lid completely go down.



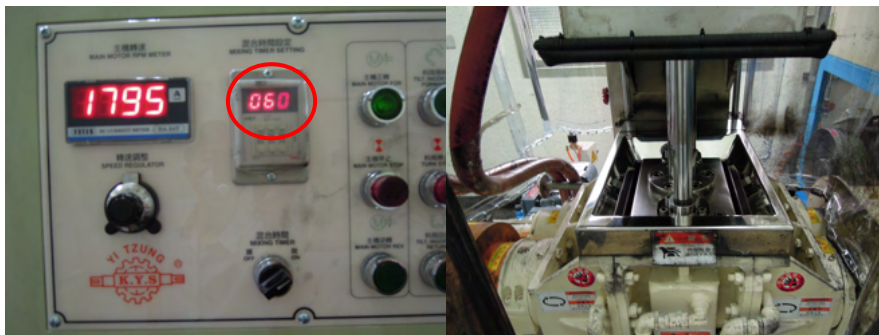
Step3: 每 10 秒紀錄溫度和電流值。

Record the temperature and the electric current every 10 second.



Step4: 60 秒後，停止主馬達，生起防塵罩。

After 60 seconds, stop the main motor and press the button to lift the dust cover.



Step5: 讓重錘完全升起。

Let the pressure lid completely go up.



Step6: 測量並紀錄混練膠溫度。

Measure and record the temperature of the compound.



6.將混練膠取出。 Take out the compound.

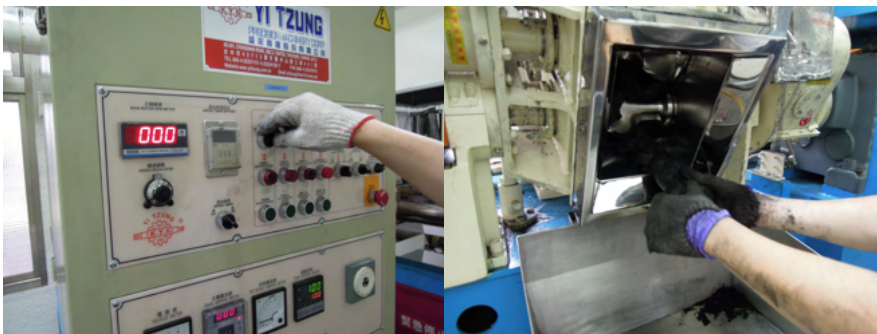
Step1: 將混合腔倒放。

Tilt the mixing chamber forward.



Step2: 控制主馬達正轉，取出混練膠。

Turn on the main motor forward and take out the compound.



Step3: 控制主馬達倒轉，取出混練膠。

Turn on the main motor backward and take out the compound.



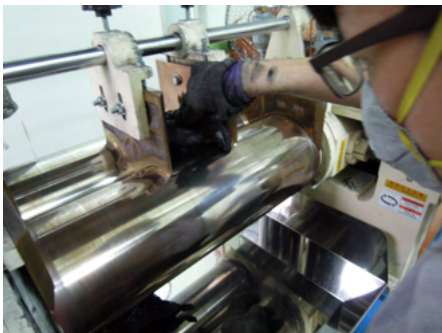
Step4: 重複正轉與倒轉馬達，取出混練膠。

Repeat step2 to step3 until take out all compounds.



7. 壓成薄片 Sheeting.

Step1:將混練膠放到開練機內。Put the compound onto the rollers.



Step2:抽出混練膠。Draw out all of compound.



Step3:壓成薄片 Sheeting

