

RUBBEX

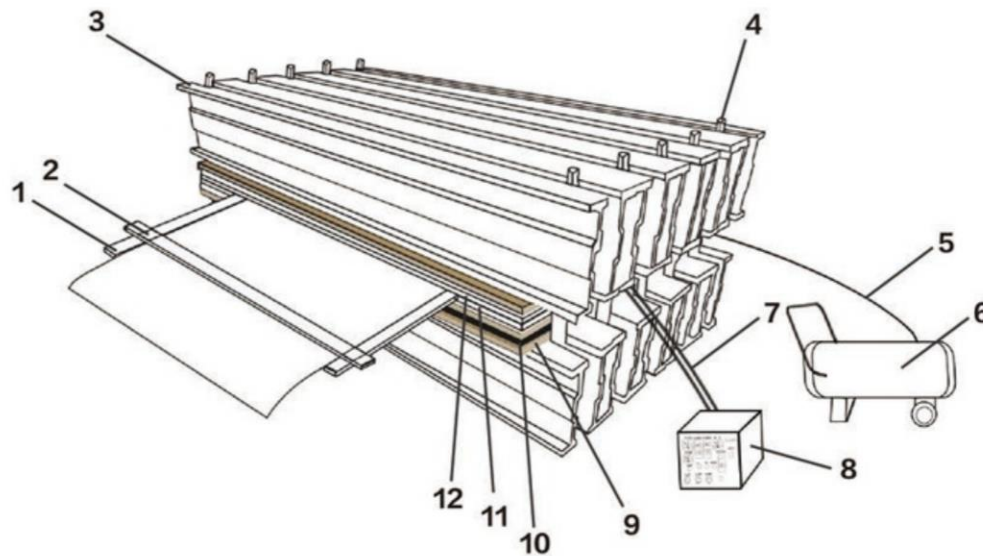
VULCANIZER PRESS



TECHNICAL DATA

Vulcanizer press is an indispensable auxiliary equipment in conveyor belt machinery.

Cooperate with hot vulcanizing cement, tie gum and cover rubber for hot vulcanization joint processing of conveyor belt.



Main Structures

- | | |
|-------------------------------|---------------------------|
| 1. Frame | 7. Water pipe |
| 2. Clamps | 8. Control box |
| 3. Aluminum beam | 9. Insulation plate. |
| 4. Bolts. | 10. Water pressure bag |
| 5. High-pressure soft pipe. | 11. Bottom heating plate. |
| 6. Electric air pressure pump | 12. Top heating plate. |

Technical data

- | | |
|--|--|
| 1. Pressure: 0-2Mpa. | 6. Voltage: normal 380V, others can be customized. |
| 2. Temperature: 145℃. | 7. Temp. adjusting range: 0~200℃. |
| 3. Surface temp. diff. : ±3℃. | 8. Time. adjusting range: 0~99 min. |
| 4. Heating time: >30min. | |
| 5. After pressure the top and down heating Plates in 0.8 MPa, the gap between the Plate: >0.5mm. | |

Components:



A. Water pressure plate



High-pressure soft pipe
Connect **A** to **B**



B. Electric air pressure pump



C. Electric hydraulic pump



Water pipe
Connect **C** to **D**



D. Heating plate



D. Heating plate



Primary cable and secondary cable
Connect **D** to **E**



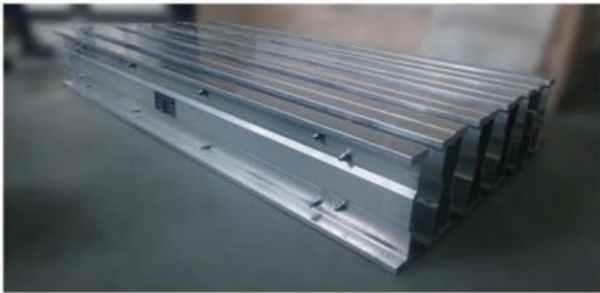
E. Control box

INSTRUCTION OF VULCANIZER

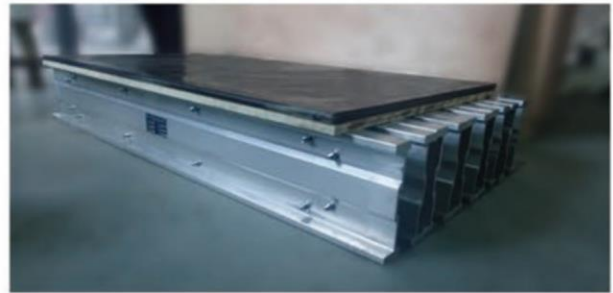
The structural parts of vulcanizer are light and portable. The operation space and convenient electricity should be considered before installation. Before construction on the conveyer, a platform should be first put on the sleepers, which dimension is according to the position of the belt to be vulcanized and the numbers of vulcanizer to be used at the same time. Splicing repair tools, materials and a 200℃ mercurial thermometer should be prepared in advance.

Installment Procedures:

1. Put the bottom frame on the platform.

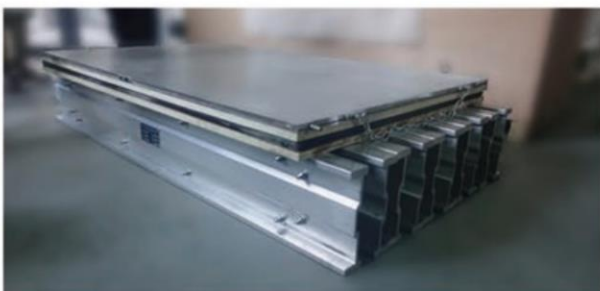


2. Put the Water pressure bag on the bottom frame.



3. Put the bottom heating plate on the Water pressure bag with its working side upwards.

Note:The smooth surface of the heating plate (no screw surface) is the working surface, which is in contact with the joint.

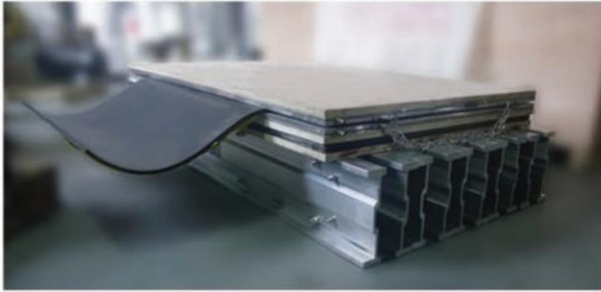


4. Put the joint which has been processed according to the vulcanized technology on the bottom heating plate. After alignment of the center line, the two sides of the belt are fixed by the clamping plate and the tightening device.

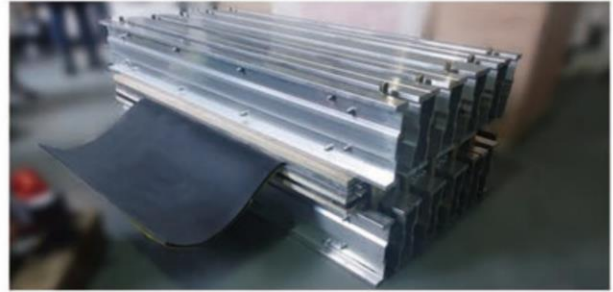


5. Put the top heating plate on the joint.

If several vulcanizers are united working for a long joint, placing a metal plate of 0.2mm thickness on the gap of every 2 vulcanizers.



6. Put the frame on the insulation plate. Mount the bolts and washes and screw the nuts in evenly.



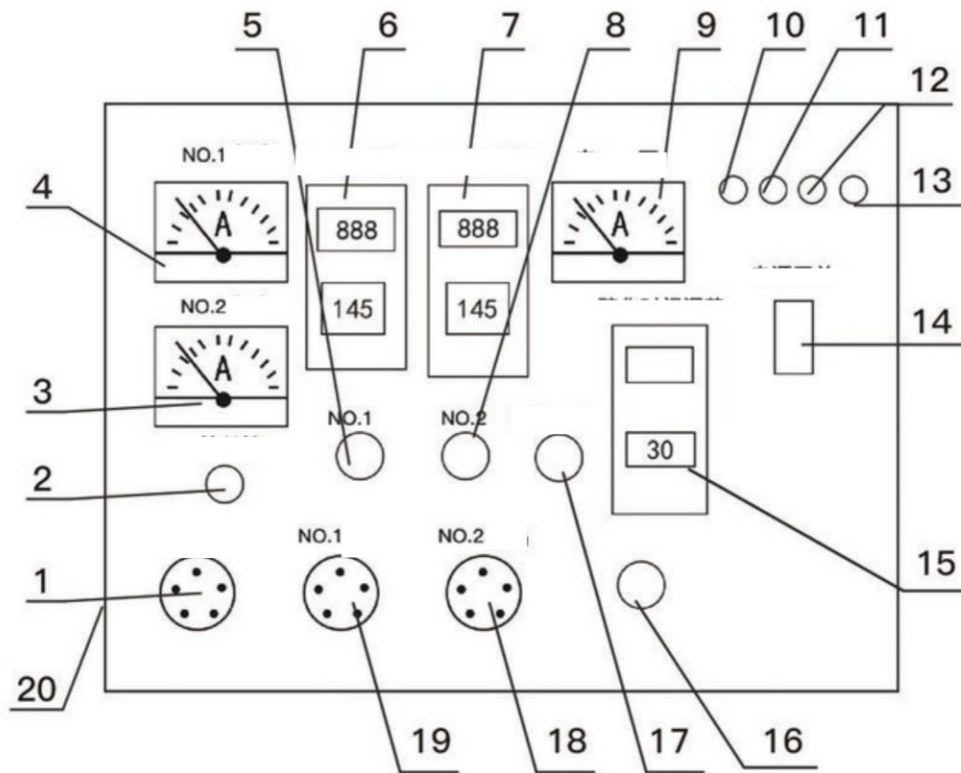
7. Connect the control box and the heating plates with the secondary cables, and connect the power supply with the primary cable.



8. Connect the water pressure pag and the electric air pressuer pump with a high-pressure soft pipe.



OPERATION OF VULCANIZER



1. Primary Power	11. Indicator for bottom plate
2. Fuse	12. Indicator for vulcanization end
3. Current indicator for bottom heating plate	13. Primary power indicator
4. Current indicator for top heating plate	14. Automatic switch for air leakance
5. Control switch for top plate	15. Time-meter
6. Temperature indicator for top plate	16. Manual/automatic switch
7. Temperature indicator for bottom plate	17. Switch for vulcanization time
8. Control switch for bottom plate	18. Power for top heating plate
9. Voltage indicator	19. Power for bottom heating plate
10. Indicator for top plate	20. Grounding screw

Operating steps:

1. Turn the knobs of 6 and 7 to set vulcanizing temp($145\pm 5^{\circ}\text{C}$);
If used for PVC/PVG conveyor belt, it is adjusted to $155\pm 5^{\circ}\text{C}$.
2. Adjust No.15 to set the heat preservation time for vulcanizing. Make sure No.17 switch in "off" position;
3. Connect the power the 13 lamp will light. Switch on 14. dial No.9 will show pressure number.
4. Turn the switches of 5 & 8, the lamps of 10 & 11 will light and the green lamp of 6 & 7 also will light.
Before press up to 145°C , press the water pressure bag to 1.2Mpa to 2Mpa (show in No.9) as different belt types and keep it by electric or manual press pump.
When the temperature goes up to the set value, the lamps of 10 & 11 will dim, meanwhile, the green lamps of 6 & 7 will become red. Then turn the switch of 17 to "ON" position, (from now on, the constant temperature will be kept until the end of vulcanizing), tighten them evenly.
5. When the preset time of No. 15 is completed, the secondary power supply will be automatically cut off.
And the 12 indicator will light, which represents the end of the vulcanizing.
6. When the temperature drops below 70°C , the heating plate can be filled with water by hydraulic pump to cool down. When the temperature drops to 0°C , the vulcanizing machine can be removed.

If any meter damaged, turn the 6 switch to "manual" position and the entire meters stop working, The temperature of heating plates can be read out from the mercury thermometer. (you prepared by self in advance). The constant temperature could be kept on 145°C by manual controlling for switches of 5 & 8 to fulfill the vulcanizing process. When keeping the manual position, the protection of leakance stop working, so the ground connection must be reliable.

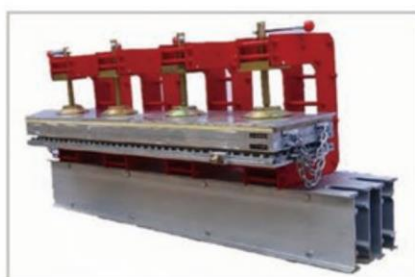
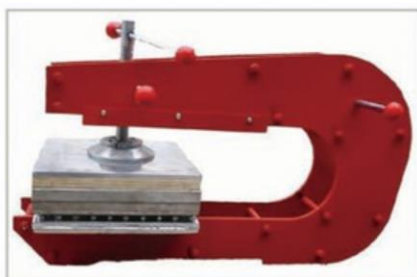
Specifications:

Order No.	Belt width (mm)	Item (mm)	Heating plate (mm)	Power (kw)	Size (mm)	Weight (kg)
XS/DGLJL-650	650	650X830	830X820	9.8	1140X830X585	495
		650X1000	1000X820	11.8	1140X1000X585	560
XS/DGLJL-800	800	800X830	830X995	11.97	1320X830X585	650
		800X1000	1000X995	14.4	1320X1000X585	750
XS/DGLJL-1000	1000	1000X830	830X1228	14.7	1450X830X585	890
		1000X1000	1000X1228	17.8	1450X1000X585	1000
XS/DGLJL-1200	1200	1200X830	830X1431	17.2	1700X830X750	980
		1200X1000	1000X1431	20.7	1700X1000X750	1180
XS/DGLJL-1400	1400	1400X830	830X1653	19.8	1950X830X750	1200
		1400X1000	1000X1653	23.8	1950X1000X750	1500
XS/DGLJL-1600	1600	1600X1000	830X1867	22.3	2150X830X795	1350
		1400X1000	1000X1867	27	2150X1000X795	1600
XS/DGLJL-1800	1800	1800X830	830X2079	24.9	2380X830X900	1500
		1800X1000	1000X2079	30	2380X1000X900	1850
XS/DGLJL-2000	2000	2000X830	830X2303	27.6	2620X830X900	1546
		2000X1000	1000X2303	33.2	2620X1000X900	1900
XS/DGLJL-2200	2200	2200X830	830X2478	29.7	2830X830X900	1734
		2200X1000	1000X2478	35.8	2830X1000X900	2014

SPOT VULCANIZING REPAIR MACHINE

Spot vulcanizing repair machine, also known as C-clamp spot vulcanizing repair machine ,is an electric heating repair equipment for conveyor belt.

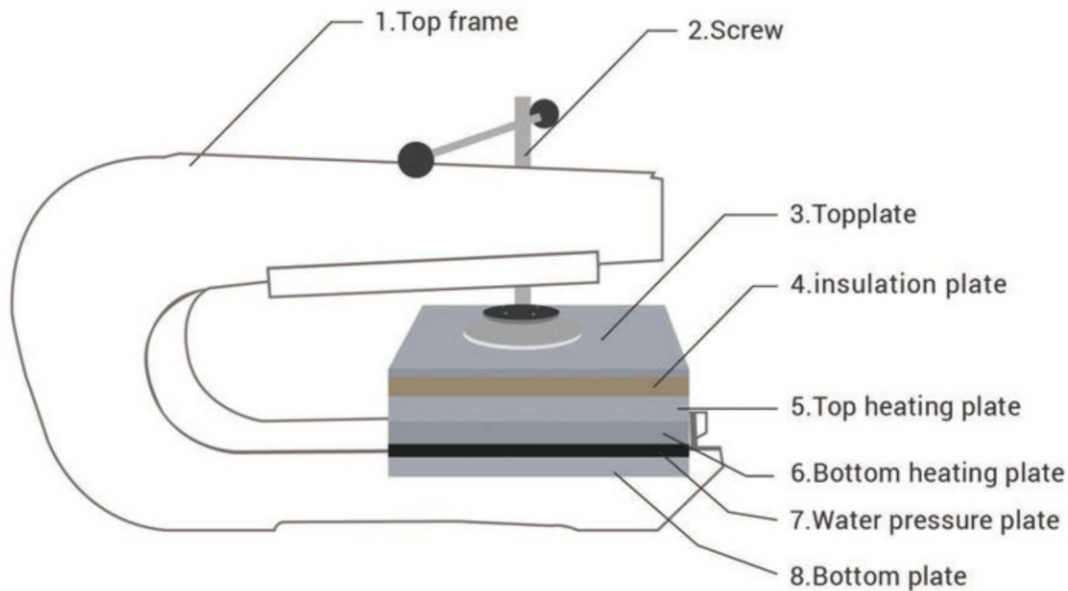
Mainly used for small area of the conveyor belt damage repair, such as the conveyor belt scratch, longitudinal tear, puncture after the core layer damage repair and conveyor belt edge damage repair.



Specifications:

Model	XS/PXBG-01	XS/PXBG-02	XS/PXBG-03
Conveyor Belt type	Canvas, nylon, steel cord belt	Canvas, nylon, steel cord belt	Canvas, nylon, steel cord belt
Repair Belt width (mm)	650-2200	650-2200	650-2200
Max rips size (mm)	250x250	250*600	250x900
Heating plate size (mm)	350x350	350*700	350*1000
Temperature range(°C)	0~200	0~200	0~200
Power(kw)	1.91	3.5	5.5
Voltage(V)	380	380	380
Temperature difference(°C)	±3	±3	±3
Pressure(Mpa)	0.8	0.8	0.8
Heating up time(Min)	30	30	30

Main structures:



Operating steps:

1. Transfer machine to the repair site.
2. Fill glue in the damaged areas that need to be repaired (see the adhesive part in the vulcanization process of the belt joints, or the demonstration by our staff when the equipment is being tested).
3. Place the bottom frame under the belt to align with the damaged part, then place the bottom plate, water pressure plate and the bottom heating plate.
4. Place the top heating plate directly above the damaged area, then place the insulation plate, top plate and the top frame.
5. Install the screw and tighten it.
6. Press the pressure pump until it reaches enough pressure level.
7. Get the first power wire well connected to the control box and the power supply. Connect the second wire with the control box and the top and bottom heating plates. Note that it corresponds to the sign on the electric control box.
8. Use a high pressure soft pipe to connect the water pressure plate and the pressure pump, then turn on the electric control box and fill water into the water pressure plate to the vulcanization pressure and start the vulcanizing repair process.