

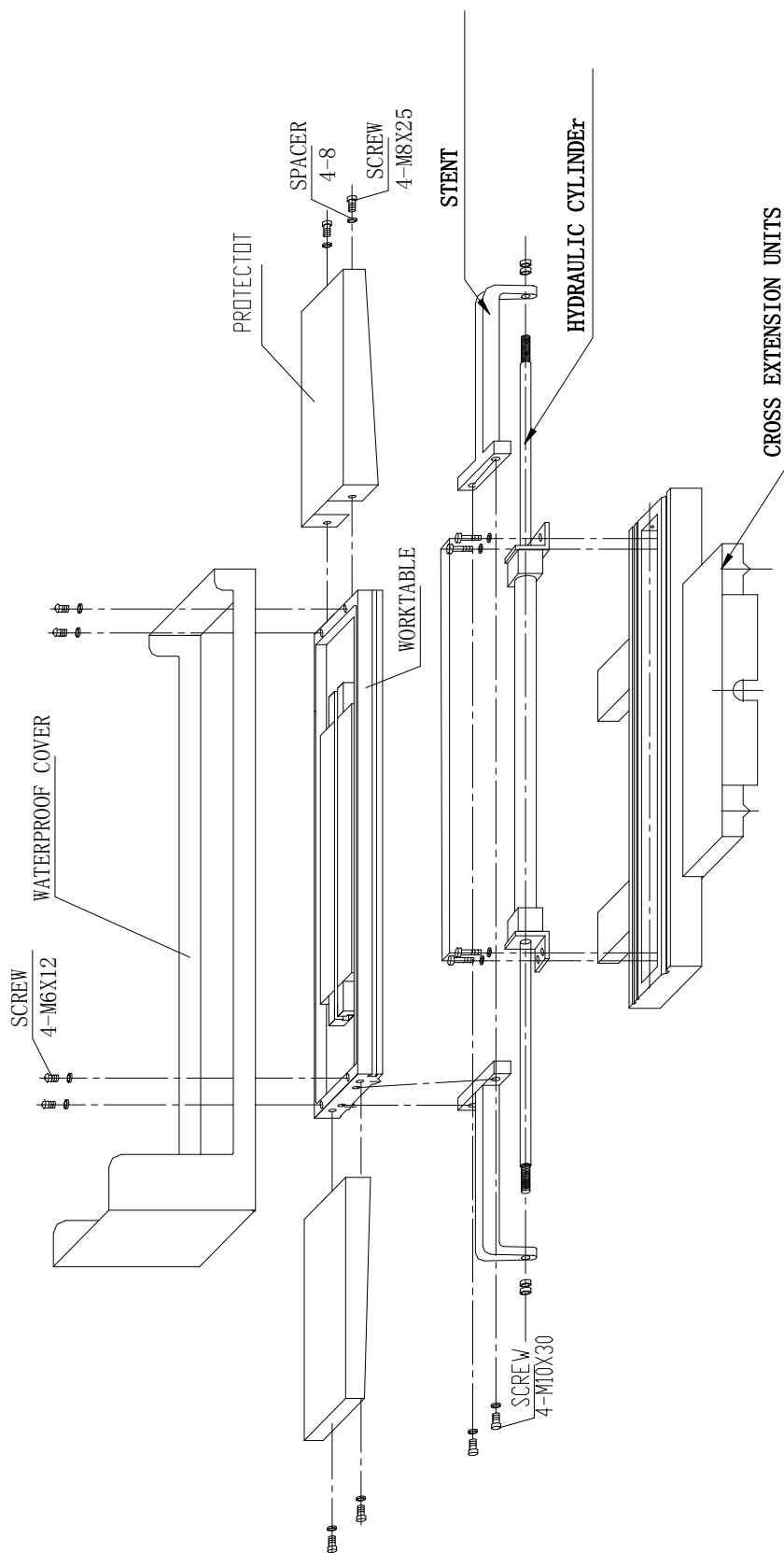
OPERATOR MANUAL FOR HYDRAULIC SURFACE GRINDER

**PLEASE READ THIS MANUAL
CAREFULLY
BEFORE OPERATION**

It is essential to give the serial number of your machine in any order of repair parts to assure prompt and accurate service Order repair parts by part S/N, Part numbers, description and machine serial number

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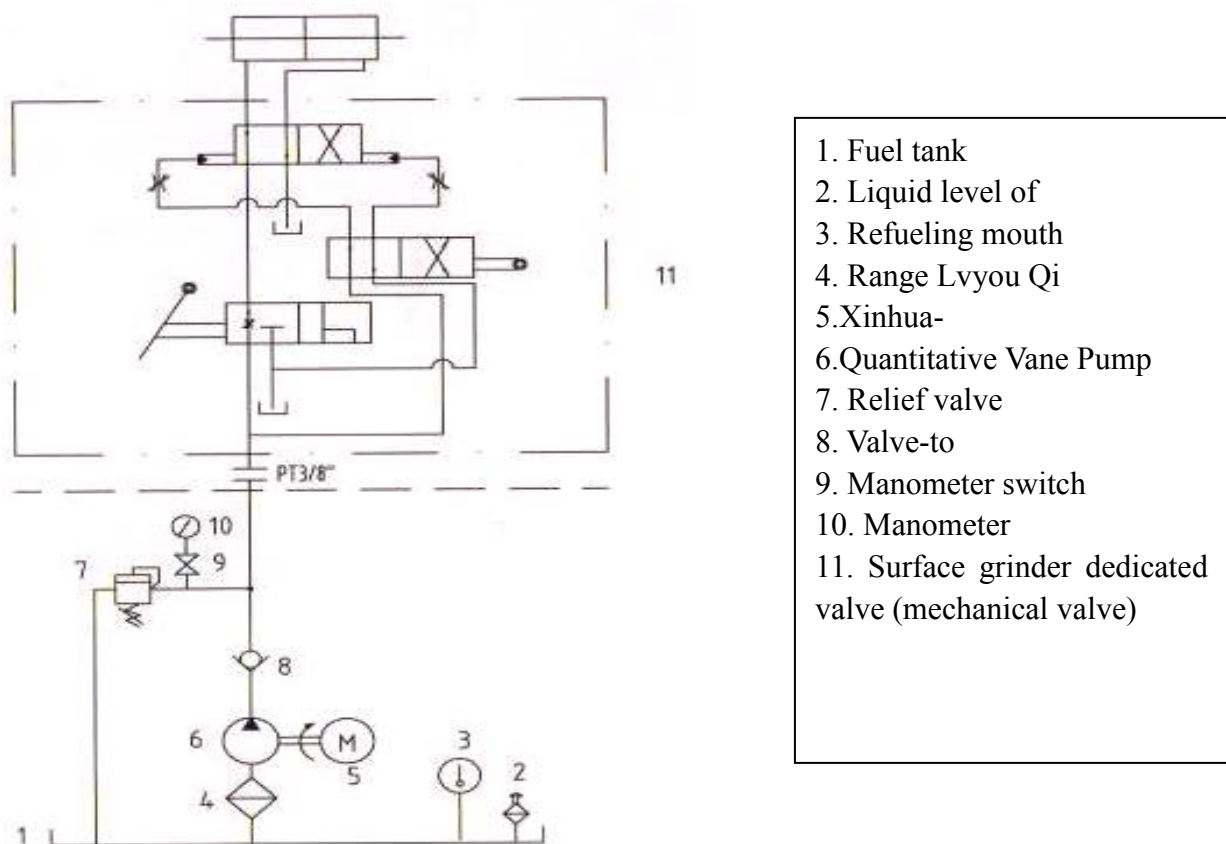
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1. surface grinder hydraulic system works:

The table of longitudinal movement is changed from manual movement into the hydraulic system. The return of their table by the longitudinal movement is installed on board the trailer hydraulic cylinder hydraulic rod back and forth movement and a traction table back and forth movement. Movement and direction of its conversion programme is installed on the table from the itinerary of block and installed in the trailers board dedicated to the control valve machinery for the decision.

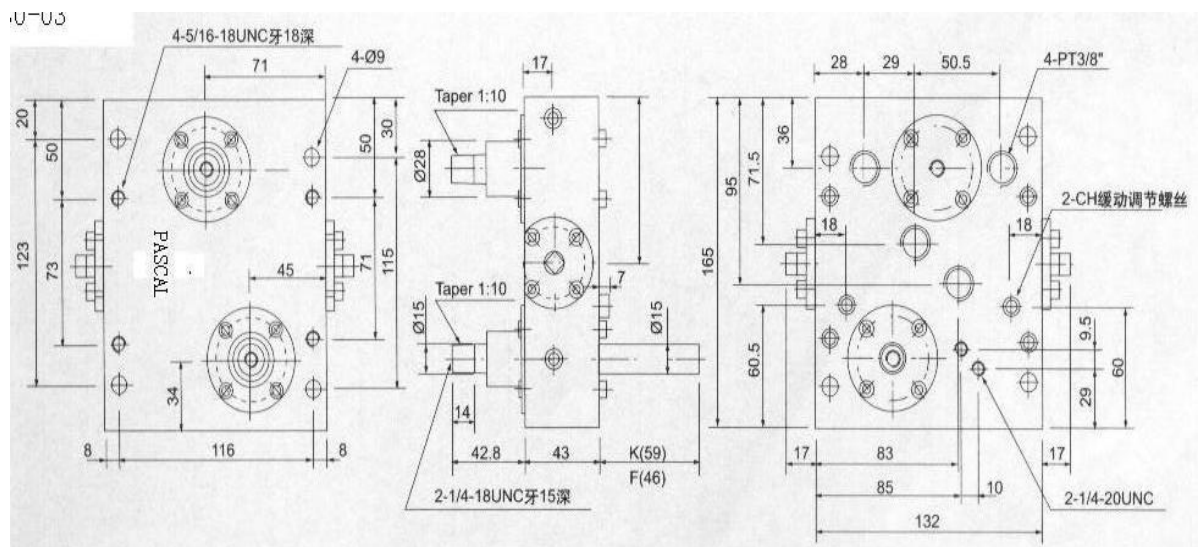
The working principle of the hydraulic system (see Figure 1)



(Figure 1) The hydraulic system schematics

2. hydraulic surface grinder technical parameters:

The hydraulic system is composed of a motor quantitative pumping systems, the system pressure regulating valve from the oil spill. Systems for the main mechanical valve grinder dedicated valve, in two parts, machinery for control and throttle control to control. Throttle control are part of unloading capabilities that can achieve the Commitment table. The valve also has a buffer regulation. For the specific valve grinder. See attached map (Figure 2).



(Figure 2): The mechanical valve

Hydraulic automatic surface grinder main technical parameters: (see Table 1)

(Table 1) **hydraulic surface grinder main technical parameters**

Model		MY820	MY1022	MY1224	MY1230	MY4080	MY4100
Table size (mm)		480×200	540×250	600×300	750×300	800x400	1000x400
Max. table travel (mm)		530×220	560×260	650×310	780×310	850*480	1050*480
Max. distance from table to spindle center (mm)		450	450	530	530	600	600
Table slide-way		Double V-type rail	Double-V rail	Double-V rail	Double-V rail	Double-V rail	Double-V rail
Feed of Cross Handwheel	per revolution (mm)	2. 5	2. 5	2. 5	2. 5	5.0	5.0
	per graduation (mm)	0. 02	0. 02	0. 02	0. 02	0.02	0.02
Feed of Vertical handwheel	per revolution (mm)	1. 25	1. 25	2. 0	2. 0	0.8	0.8
	per graduation (mm)	0. 01	0. 01	0. 01	0. 01	0.01	0.01
Wheel speed (60HZ)		3440	3440	1680	1680	1680	1680
Wheel size (WA46K5V)		200x31.75x20		300x75x30		355x127x40	355x127x40
Power of Spindle motor(W)		1100	1500	2200	2200	4000	4000
Hydraulic station motor (W)		1500	1500	2200	2200	2200	2200
Working Pressure (Mpa)		3	3	4	4	4	4
Max. runoff (L/min)		18	18	20	20	30	30
Fuel tank capacity (L)		80	80	100	100	100	100
Coolant pump (W)		40	40	40	40	125	125
Machine net weight (Kg)		750	900	1300	1400	2600	2600
Packing gross weight (Kg)		850	1000	1400	1530	2800	2800
Machine size (M)		1.68×1.14×1.80	1.80×1.40×1.80	1.80×1.40×1.80	1.89×1.50×1.83	2.35x2.10x2.00	2.35x2.10x2.00
Packing size (M)		1.63×1.14×1.96	1.63×1.25×1.89	2.00×1.60×2.02	2.00×1.60×2.03	2.4x2.12x2.15	2.55x2.12x2.15

3. The functioning of the hydraulic system

3.1 hydraulic system pre-boot:

1) and fuel tanks are required to use mainframe-level adjustment, and fixed properly.

2) electrical line of control as required to connect to the main control box, check whether the loose electrical wiring components, Xu Han.

3) 32, a mechanical hydraulic oil from the reserve tank by adding words to the fuel tank on the level of the ceiling only. After the tank Jiaman You can not start up immediately, such as the fuel tank to be in the bubble disappear naturally. Will handle the oil spill valve counter-clockwise relax.

3.2 functioning before the confirmation of

1) confirmed the oil tank of liquid level

2) check the connections of the main switch control board

3) Check the filter cleanliness, if necessary, can be replaced

4) Check whether there is a control device alarm signals, if necessary, reset the signal

3.3 hydraulic station and the functioning of the attention that matters

Preparatory work is completed, please follow the procedures of operation

1) on a main power switch

2) Press the power button

3) the need to open the pump work

4) No surveillance system in the state, we must downtime.

3.4 start-up operation:

To move the motor launch Motor Show me the direction of rotation, and then officially launched Motors, unloading state, ruled out running 10 minutes in the air, targeting the fuel tank, oil spill valve regulator knob slowly and observe the pressure gauge to regulate the use of pressure . Reciprocating several times in normal operation.

3.5 filter

80% of the hydraulic system for impaired because of the dirty oil, the oil should be changed regularly, and timely replacement of filters. The system has 80 μ oil-absorbing filter in order to ensure the cleanliness of oil.

3.6 cooling

The hydraulic station cooling system uses natural cooling system can meet the cooling requirements.

4. Machine electrical panel plans and schematics

4.1-map of the electrical machine and button function map (Figure III, IV)

4.2 machine circuit (see Figure 6, Figure 7, Chart 8)

4.3 Electric operations (to do this in order to operate five of the electrical panel to explain)

4.3.1 using the machine before me on the first electrical cable access to the corresponding AC power, water pumps to pump electrical cable access,

cable access to the hydraulic motor oil

4.3.2 rotating emergency switch button SB5, SB5 switch in a closed state.

4.3.3 press the point switch SB2, contact with a suction KM1, wheel motor, wheel spin

4.3.4 press the switch SB1, disconnect the contactor KM1, Wheel motor stopped working.

4.3.5 in the wheel motor work Bandong SA1 switch to "ON" position, the pump motor work. Bandong SA1 switch to "OFF" position, the pump motor stopped working.

4.3.6 took to move the switch SB3, contact with a suction KM2, hydraulic motors, will table the itinerary block transferred to the appropriate location, rotating fuel switching to table the appropriate speed, and from the table to return Campaign, press switch SB4, disconnect the contactor KM2, hydraulic motor stopped working, working platforms stop working.

4.3.7 SB5 for exigency stop button, KM1, KM2 disconnect in the state.

Note: pre-wheel motor must first move the switch SB2, grinding head to see the direction of rotation, found that reverse rotation, we must stop immediately, transfer of power lines to avoid damage to grinding head loose.

5. The hydraulic system of Attention

5.1 The use of hydraulic oil to reach the accuracy NAS9-class, if pollution must be immediately replaced. Oil must not be lower than the level displayed.

5.2 in the hydraulic pipe fittings, bolt, twisting tight to prevent the earthquake-song.

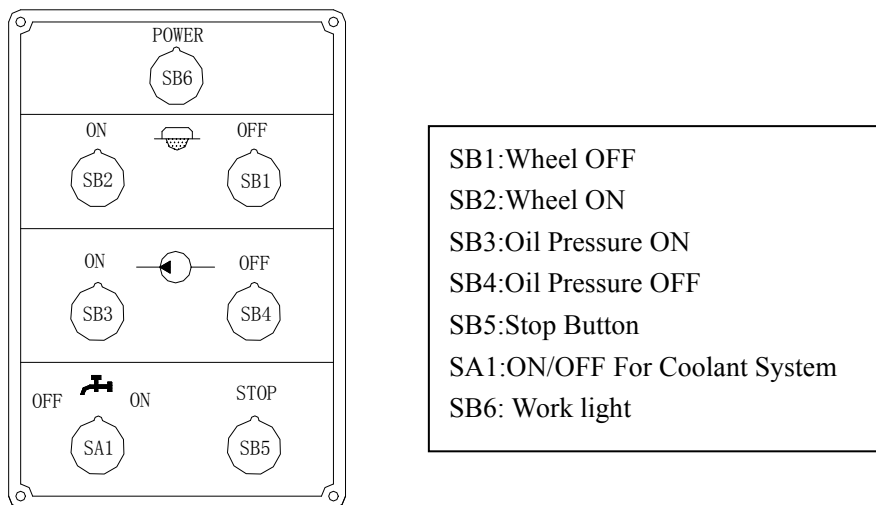
5.3 Where strange noise generated must immediately stands inspection

Oil Spill valve

5.4 factory has been set, do not random adjustment. Must adjust to the spin-song, gradually increase the pressure after the boot. The maximum pressure should not exceed 3 Mpa. (Note MY3060/MY3075, the maximum pressure should not exceed 4 MPa)

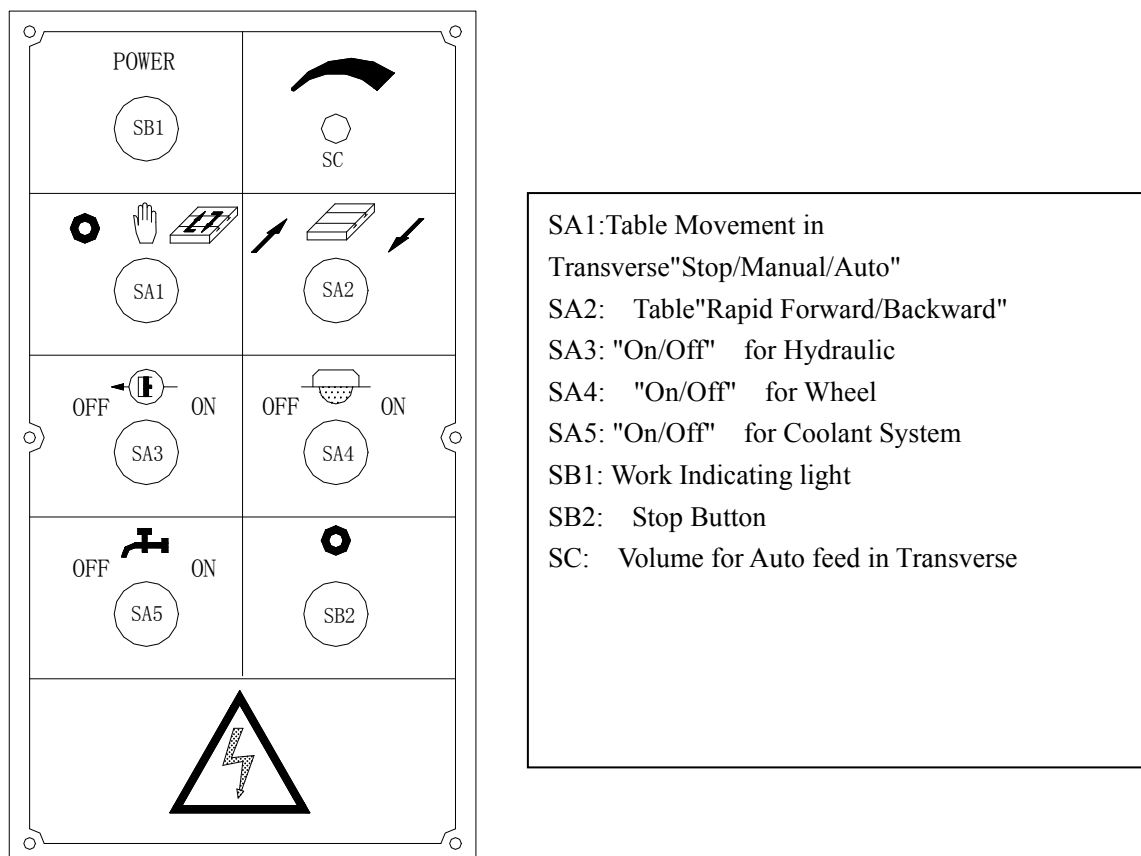
5.5 Circuit event of pipeline leakage should immediately stop operation, to repair.

5.6 in winter when the hydraulic system to idling (no load) five minutes and then start working platforms.



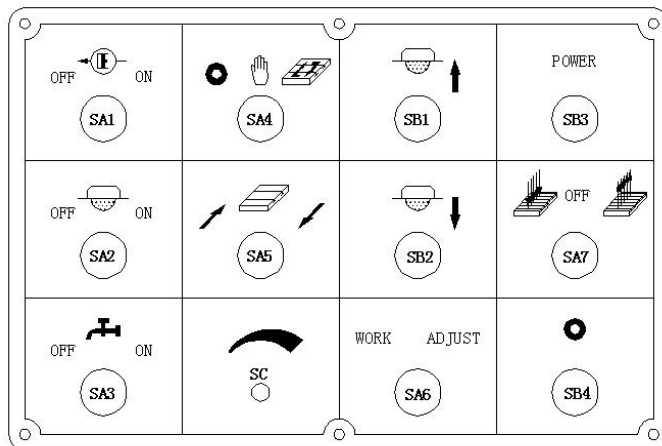
(Figure 3: MY820)

The electrical hydraulic grinder plate plans and functional plans button



(Figure 4: MY1022)

Instruction for Auto feed of MY1022

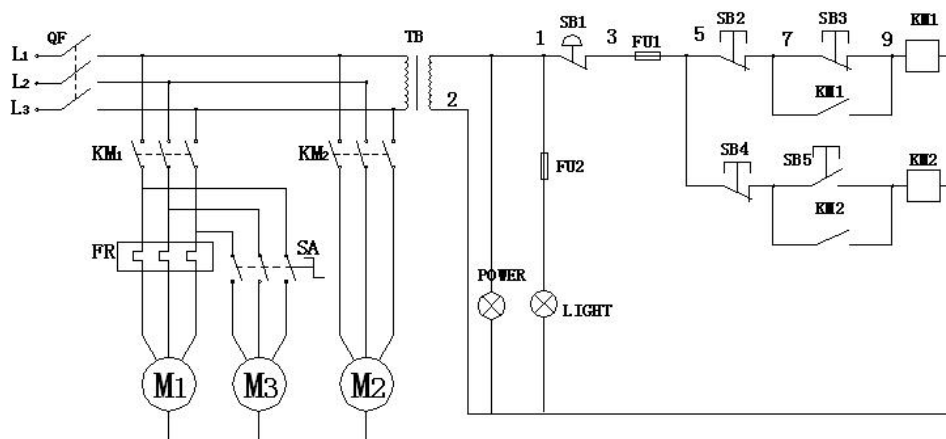


- SA1: hydraulic system of "start / stop"
- SA2: Wheel "start / stop"
- SA3: cooling system of "start / stop"
- SA4:: moving the table before and after the move to "stop/ manual / automatic"
- SA5 : SA2:Table"Rapid Forward/Backward"
- SC : Stage Speed button
- SB1:Wheel's "rapid rise"
- SB2:: Wheel's "rapid decline"
- SB3: "Work / debug" button
- SA7: electromagnetic sucker's "absorption magnetic / to magnetic"
- SB4: exigency stop button

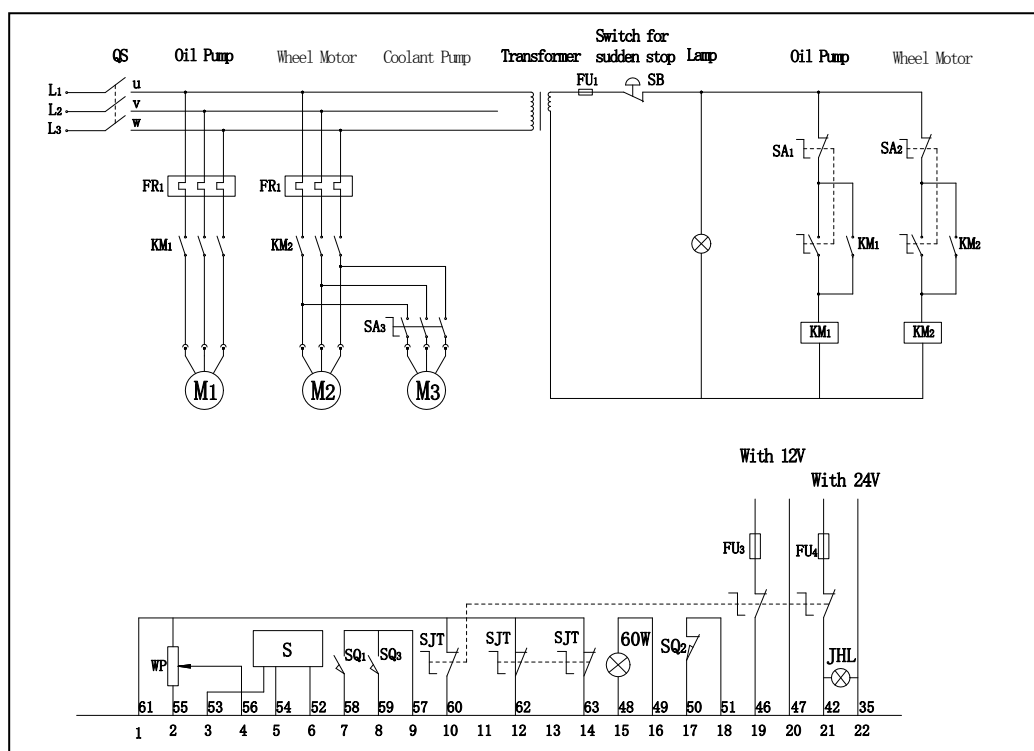
(Figure 5: MY1224/MY1230/MY4080 MY4100)

Automatic hydraulic grinder map of the electrical panels and buttons Figure

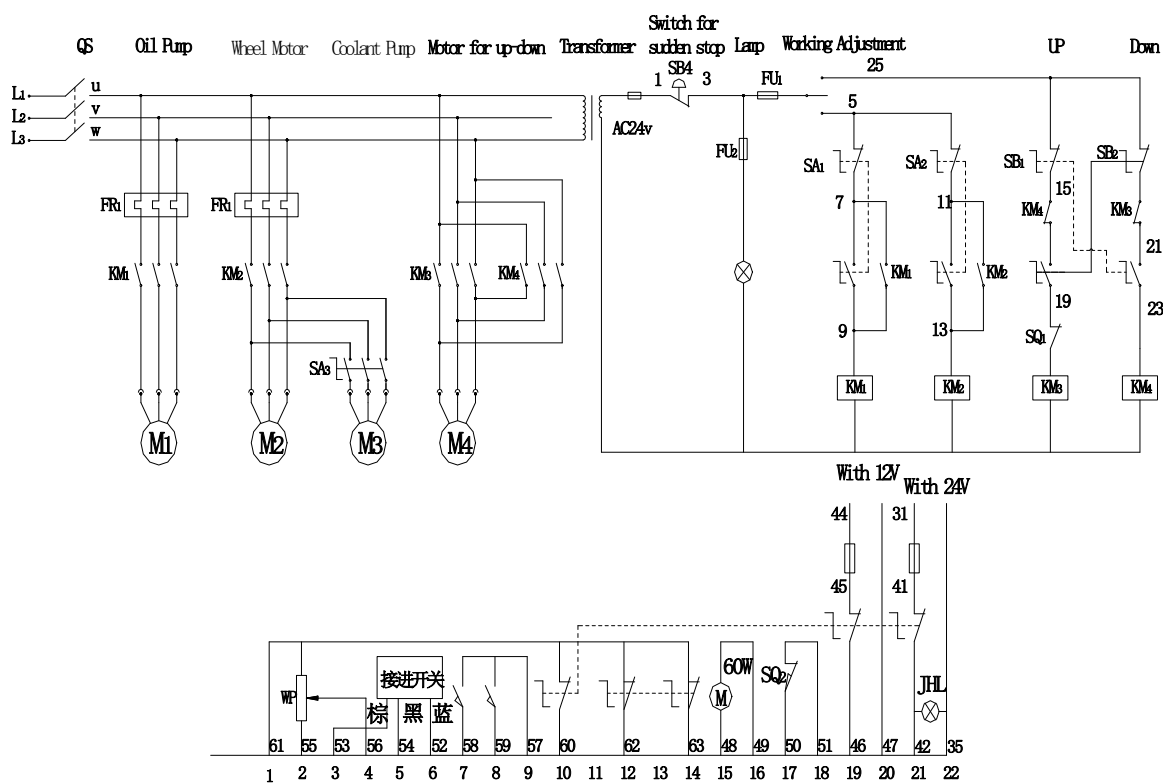
Permanent m hydraulic Circuit DiagramGrinder



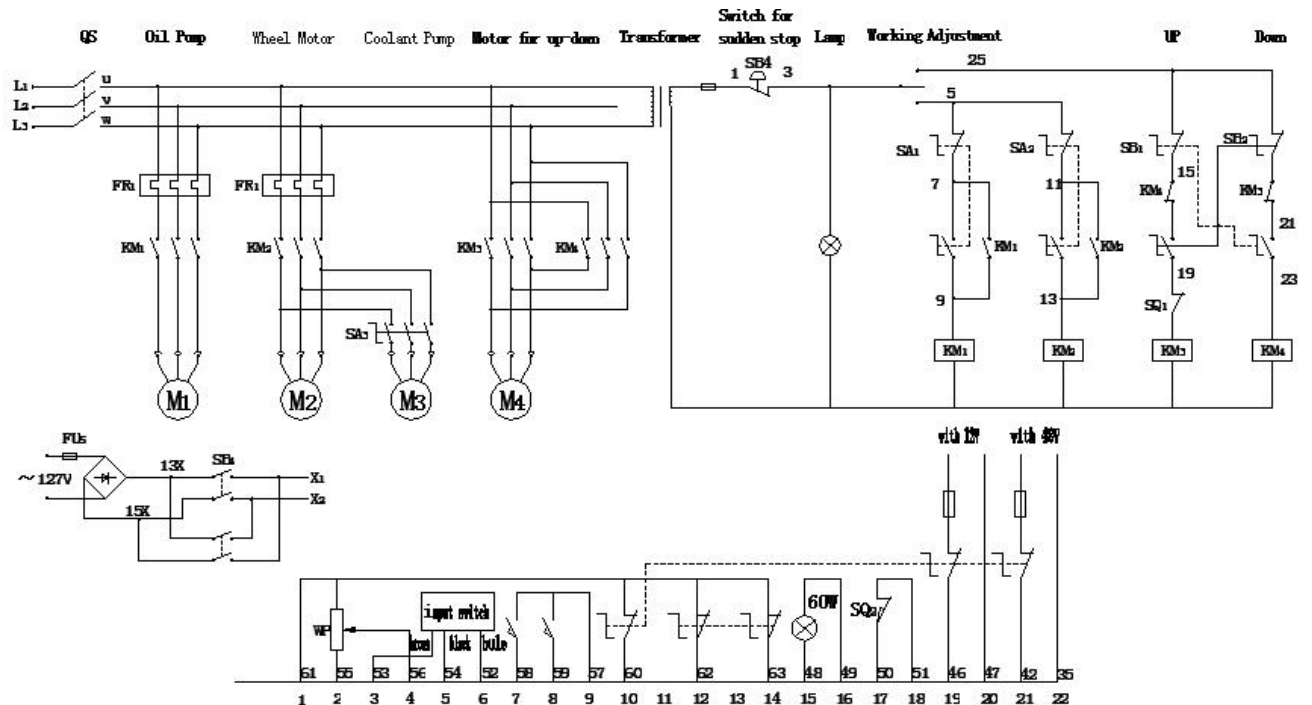
(Figure (6) MY820 CIRCUIT DIAGRAM



(Figure 7)MY1022 CIRCUIT DIAGRAM



(Figure 8) MY1224/MY1230 CIRCUIT DIAGRAM



(Figure 9) MY4080/MY4100 CIRCUIT DIAGRAM

6. Hydraulic equipment maintenance and fault corrected method

6.1 hydraulic equipment maintenance

6.1.1 hydraulic oil change once every six months, or under the circumstances, oil pollution-free, can be extended to replace the appropriate time.

6.1.2 filters cleaned regularly (3-6 months cleaning time)

6.1.3 Inspection System Circuit availability of oil spills, the Circuit tubing

connector tighten anti-pine.

6.2 The failure of hydraulic equipment exclusion method

Machine reasons for the failure of hydraulic equipment, and the elimination of methods

Failure inspection methods and countermeasures

1. Hydraulic system under pressure, lack of traffic

check whether fluing hydraulic pump oil.

Check whether the oil-normal, normal pump oil absorption

Check whether the normal electrical

Check relief valve, the valves are normal

Check whether there is a system of leakage

Check whether the Motor is correct

Check whether the normal flow valve adjustment

2. The implementation of components action check valve is not normal for it to normal

Inspection System pressure is normal

Check the implementation of the normal components

Mixed with air in the system

Related to the mechanical failure

Flow valves, pressure valve settings and adjustments

3. High oil temperature too much noise excessive pressure adjustment

The large flow of high-pressure relief valve uninstalls

Viscosity of the oil pump.

Within the fuel tank less than

4. Too much oil absorption system noise filter plug, cleaning can be removed.

Oil, mixed with air, generally for the first time start-up occurred, more than run for a period of time, you can return to normal.