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FM214-1 chalk machine operation process

- 1, after the mold is installed according to the installation drawing, before operation, the mold mouth up, and then brush oil, the new mold should be more oil, oil to be even is very important! Dip oil with a wide brush, brush on the mold mouth first oblique then straight back and forth. The top rod bottom plate moves up and down a few lower to the end, 4 top screw contact shall be subject to, each mold to put to the end is also very important, can not put to the end of the short chalk, leakage phenomenon. (Diesel oil, peanut oil ratio of 8:2) after a period of use. The ratio of diesel oil to peanut oil can be reduced to 9:1. Also can add stearic acid inside diesel oil, 100 catties of diesel oil add 2 catties of stearic acid, put stearic acid in a small amount of diesel oil first in the heating, and then stir well in diesel oil.
2. Mix the slurry evenly. The ratio of gypsum powder and water is 3.5kg of powder: 4.15kg of water, the first mold to 4.15kg of powder than 3.5kg of water, first put the water into the bucket, then add gypsum powder, stir well with wooden stick, and then into the mold, with a scraper with smooth. The hard and soft chalk can adjust the ratio of water to gypsum powder. If the chalk is soft, reduce the water. If the chalk is hard, add the water.
- 3, die: the first die of the new mold should not be too late. After 2-8 minutes of grouting, press the chalk by hand, it is a little hard, turn the mold to 180°, then put it into the feeding tray, rotate the eccentric ejecting mechanism of the mold, you can eject 2-5 mm first, after 1 ~ 2 minutes to make all the chalk ejecting at one time. An operation is completed. And then you do it again. Circulation flow operation.
4. The same as the white chalk, but the chalk paste should be 0.1-0.2kg per mold, and the water should be reduced 0.1-0.2kg when the color paste is added. If the color is too thick, add less color paste, if the color is light, add more color paste.
- 5, do color chalk should add antifoaming agent, tributylene phosphate, grouting spray.
6. Before chalk production, make a chalk tray with an inside diameter of 290 mm long, 350 mm wide and 60 mm high. The surface of the tray is covered with floor leather.
7. Fault handling: the ejector bar cannot fall to the bottom during operation. Is caused by two reasons, one is the top plate before oil did not fall to the end, slurry leakage to the top rod down, two is the top out of the chalk too early, this situation can be added to the mold bubble on 2-3 hours, and then move the bottom plate up and down activity, until the end of the top plate.
8. Random accessories are ejector rod and glue. When changing the ejector rod, remove the bottom plate, put the ejector rod into the mold mouth, screw the nut onto the ejector rod, then point glue, and then use it after setting.