

MAINTENANCE INSTRUCTION

保养手册

真正的拥有 · 是别人没有
CHANGE YOUR MIND

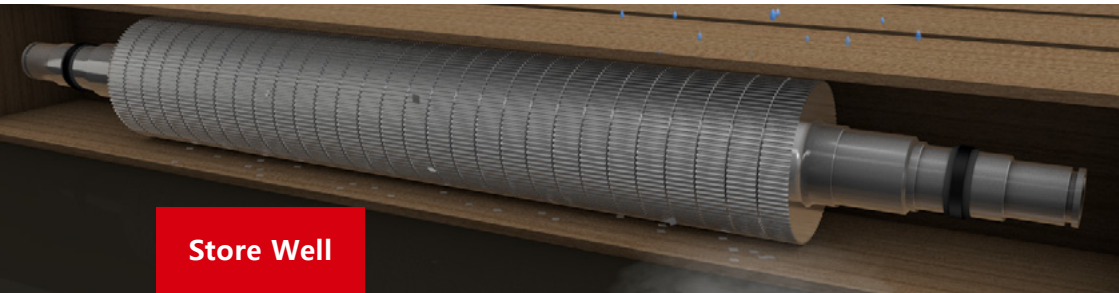


上海大松瓦楞辊
DASONG

TO REACH 100 MILLION LINEAR METERS

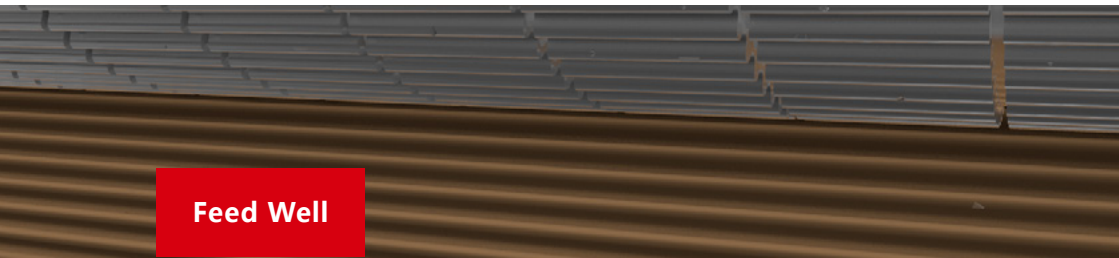


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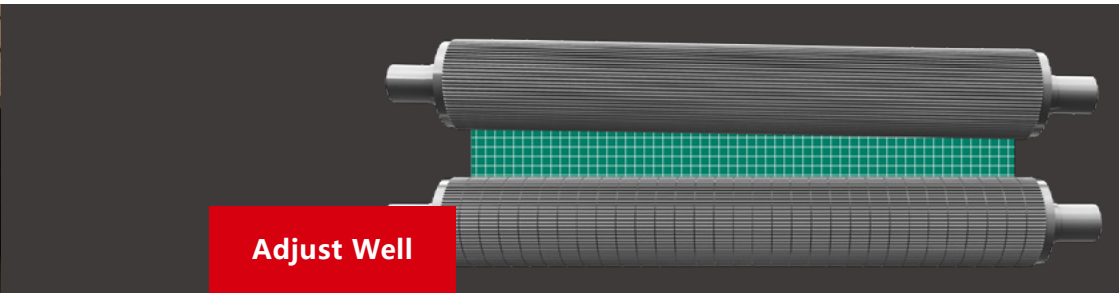
Store Well

- a. The surface of corrugating roll is not compact structure. The permeation and corrosion of water and steam will cause unusual falling off of coatings. So the corrugating rolls should be stored in dry places.
- b. The surface of corrugating roll is not compact structure. Before corrugating roll leaves factory, it has been applied silicon oil, which is valid for 3 months. If customer doesn't use corrugating rolls for a long time, silicon oil must be applied to the rolls regularly to avoid unusual falling off of coatings caused by the permeation and corrosion of water and steam.
- c. If customer doesn't use corrugating rolls and puts the rolls in the warehouse, the surface of corrugating rolls should be cleaned and applied on silicon oil for later use.



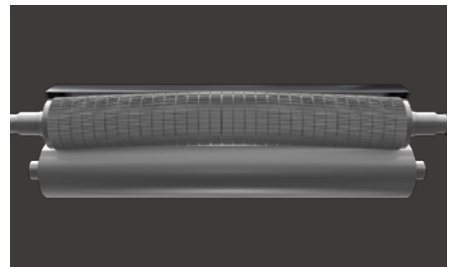
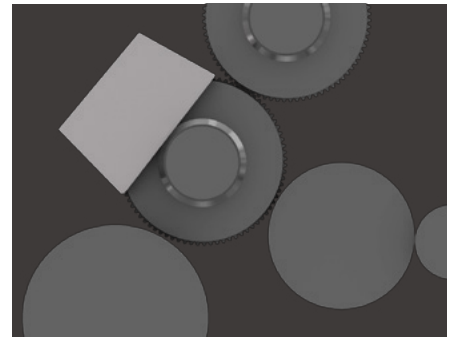
Feed Well

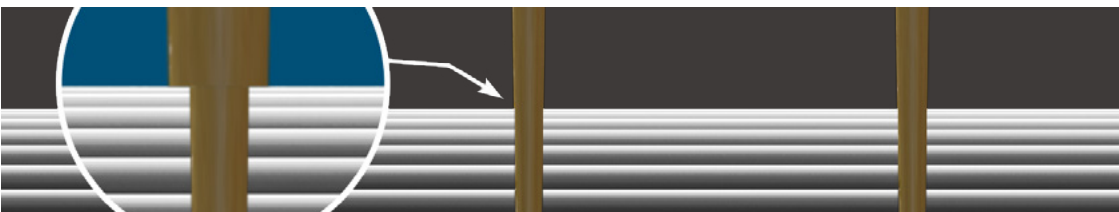
- a. Ash content in corrugated paper is one of the most important factors which directly influence the lifetime of corrugating rolls. The sand in corrugated paper will squeeze corrugating roll and form pits which will cause falling off of coatings. It will severely affect the lifetime of corrugating rolls.
- b. Please use corrugated paper which the ash content is lower than 4%.



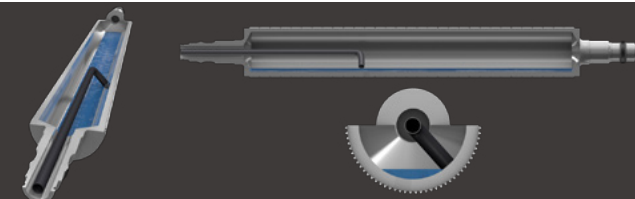
Adjust Well

- a. Inspect the balance of corrugating roll regularly, at least once a month as suggested.
- b. When installing corrugating rolls, mind the small gap between corrugating rolls and suction hood which will cause abrasion of corrugating rolls and aluminum plate from suction hood.
- c. The suction hood will loosen with the movement of machine. Inspect the gap between corrugating rolls and suction hood to avoid abnormal abrasion.
- d. "Banana shape" appears in normal symphonic corrugating roll. If stop the machine for a long time, too small gap between corrugating rolls and suction hood will cause abrasion in the middle of rolls and suction hood.
- e. Inspect the gap among corrugating roll, glue roll and pressure roll to avoid abrasion.
- f. The copper knives will loosen with the movement of machine. The knife in "T" position will scratch the coating on two sides of grooves. So fix the copper knives regularly.

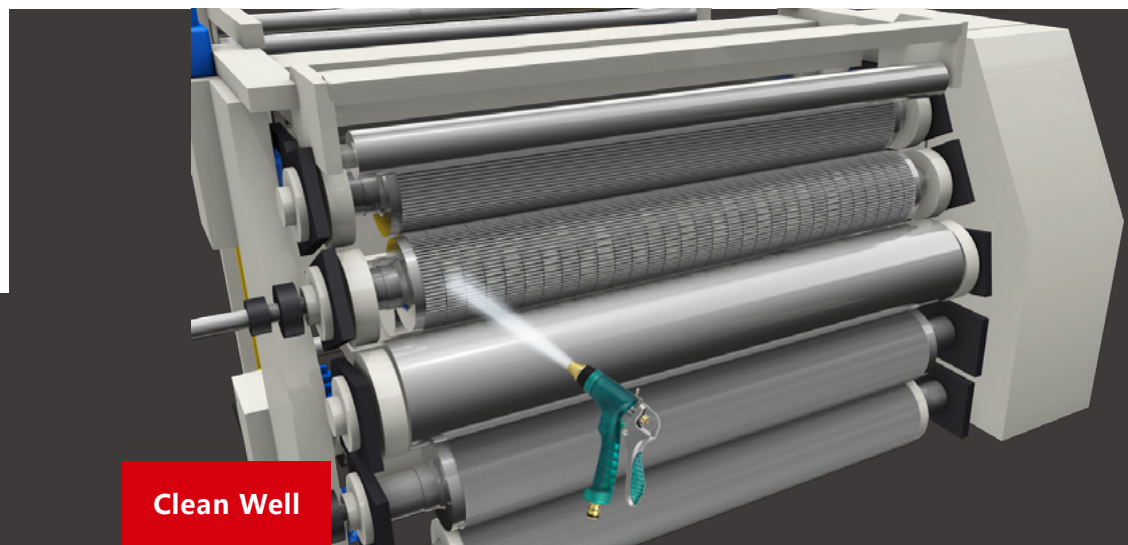
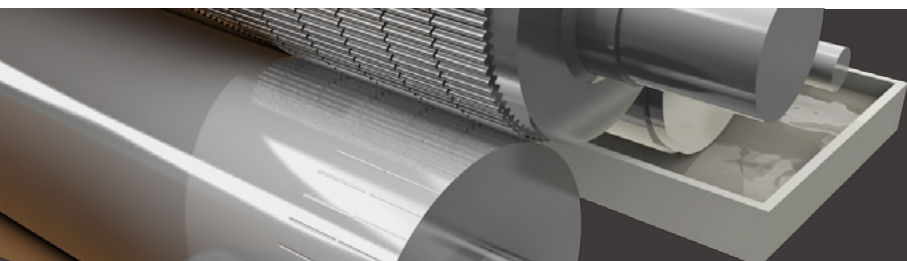




Heat Well



- g. In the premise of assuring corrugated board quality in real production, it's better to use smallest oil/air cylinder pressure both of corrugating roll and pressure roll.
- h. When changing wide width to small width in real production, reduce oil/air cylinder pressure both of corrugating roll and pressure roll accordingly to avoid abnormal abrasion caused by excessive pressure. Especially the direct abrasion between corrugating rolls and pressure roll in paperless areas will cause falling off of coatings.



Clean Well

- a. Start the corrugating rolls before filling in steam to avoid abnormal deformation.
- b. Check the temperature of corrugating roll and pressure roll regularly to avoid temperature decrease caused by accumulation of condensate water.
- c. If the temperature is abnormal, please check and keep the correct position of siphon to let condensate water out successfully.

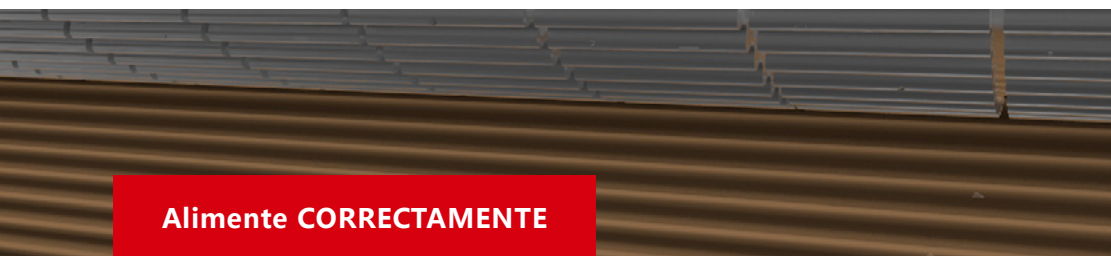
- a. Clean the glue and paper scraps on corrugating rolls after production to avoid scratches of coatings.
- b. Don't wash the corrugating rolls directly when the rolls are hot.
- c. After the corrugating rolls cool down, wash the rolls by water or gas.
- d. After cleaning, apply silicon oil on corrugating rolls.

MÉTODO PARA ALCANZAR 100.000.000 DE METROS LINEALES DE VIDA ÚTIL



Almacene CORRECTAMENTE

- La superficie del rodillo corrugador no es una estructura compacta. La permeabilidad y capacidad corrosiva del agua y del vapor pueden hacer que se desprendan partículas del recubrimiento exterior. Es muy importante almacenar los rodillos en espacios secos.
- Antes de proceder al envío de los rodillos corrugadores nuestro departamento de expedición les aplica aceite de silicona como protector de los núcleos y recubrimientos para un periodo de 3 meses. Si Usted no va a usar los rodillos durante un periodo superior o los quiere mantener como rodillos de reserva, deberá controlar los rodillos regularmente y reemplazar si fuera necesario el aceite de silicona.

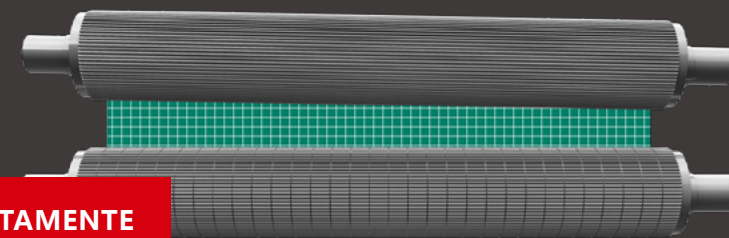


Alimente CORRECTAMENTE

- Empleamos la más avanzada tecnología para aplicar nuestros recubrimientos (Carburo de Tungsteno). Gracias a la composición del recubrimiento podemos garantizar una muy larga vida útil si el fluting no es abrasivo.
- El contenido de ceniza en los papeles intermedios es uno de los factores más importantes que influye en la vida útil de los rodillos

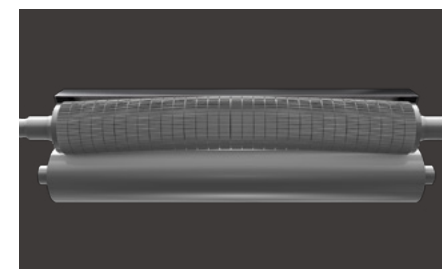
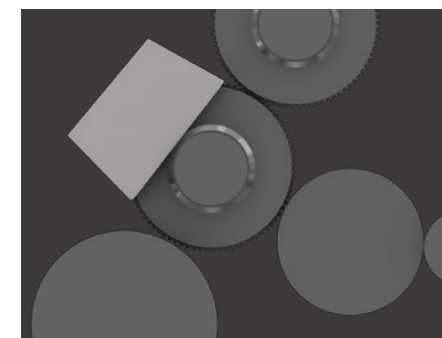
corrugadores. Sus partículas producen esquirlas en el rodillo corrugador provocando la pérdida de recubrimiento. Esto afecta de manera vital a la vida útil de los rodillos corrugadores.

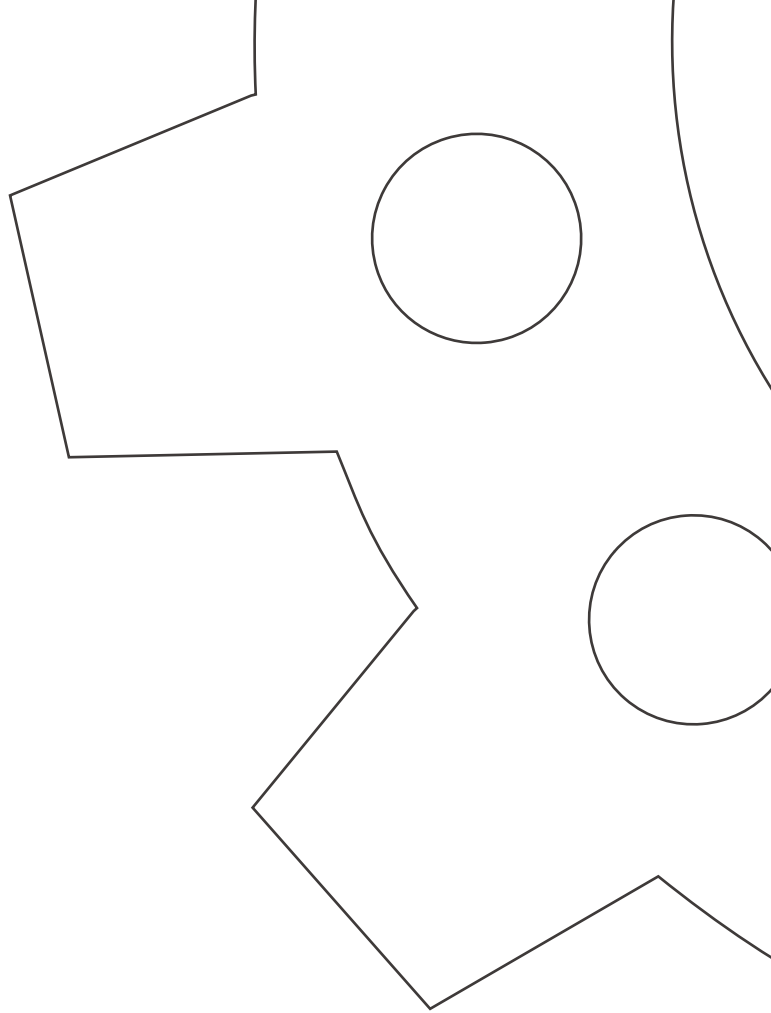
- Por favor intente seleccionar papeles fluting con un contenido de ceniza inferior al 4%.



Ajuste CORRECTAMENTE

- Inspeccione el equilibrado de sus rodillos corrugadores regularmente, recomendamos al menos una vez al mes.
- Cuando instale los rodillos corrugadores tenga en cuenta la separación entre estos y el cabezal aspirador. Puede provocar fricción entre los rodillos corrugadores y la placa de aluminio del cabezal.
- El cabezal puede soltarse por las vibraciones de máquina. Inspeccione la separación entre los rodillos corrugadores y el cabezal de aspiración para evitar un desgaste anormal.
- El efecto Banana se produce en rodillos corrugadores con





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