

贵金属焊接退火隧道炉说明书

Precious metal welding annealing tunnel furnace instructions

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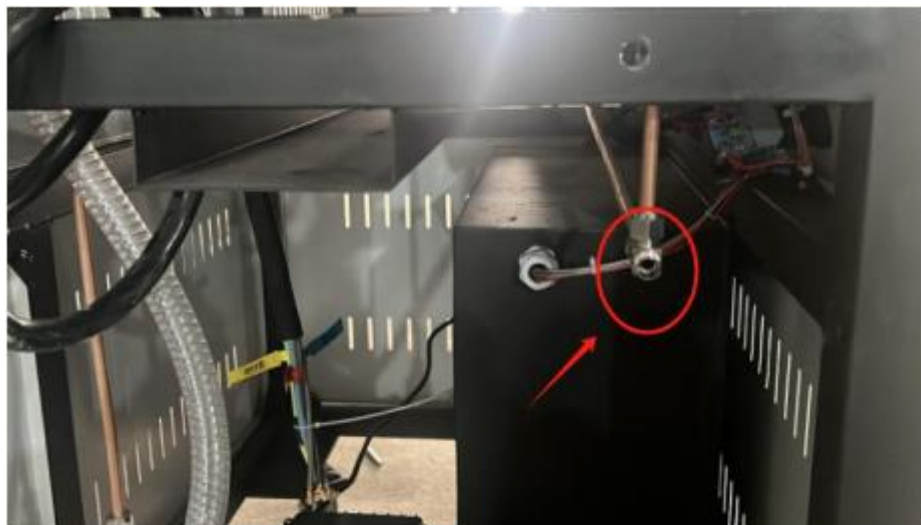
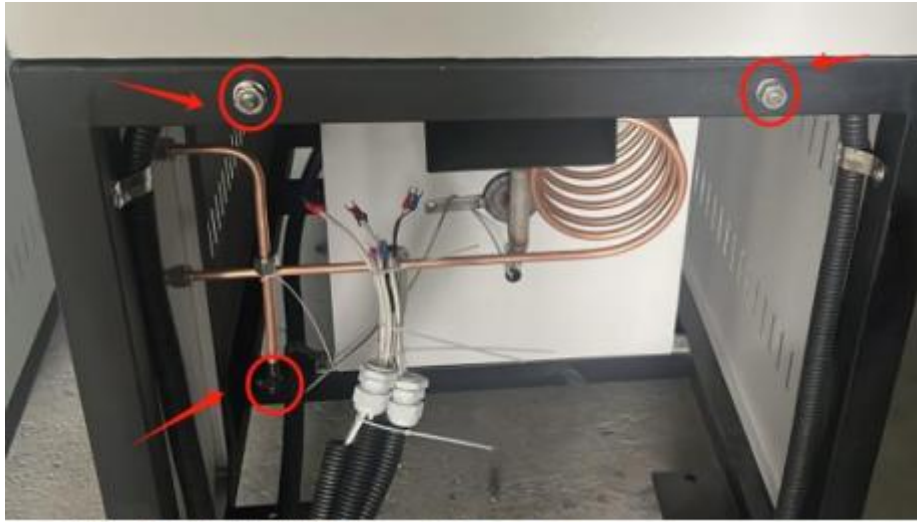
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1.**开机前准备材料**	**Materials Preparation Before Startup**
- 氨气	
Ammonia gas	
- 接氨气管	
Ammonia gas hose	
- 钢丝软管	
Steel wire hose	
- 卡口抱箍	
Hose clamps	
- 循环水	
Circulating water	
- 对应尺寸网带	
Mesh belt of corresponding size	

2. **开机前检查准备工作** **Pre-Startup Inspection and Preparation**2. 1 将两节隧道炉连接

为一个整体，拧好螺丝，接上气体管道

Connect the two sections of the tunnel furnace into one unit, tighten the screws, and attach the gas pipelines.



2.2 安装探温针，注意：探温针贴到底后，稍微提上来一点点后，再锁紧螺丝。

Install the temperature probe: Insert it to the bottom, slightly lift it up, then tighten the screw.



2.3 根据背面标签, “出水口” “进水口” 连接上循环水设施。

Connect the circulating water system to the "Water Outlet" and "Water Inlet" ports based on the labels on the back.



2.4 检查主线, 分别标记有“火线、零线、地线”, 一一对应接空开开关。

Check the main power cables labeled "Live wire, Neutral wire, Ground wire" and connect them correctly to the circuit breaker.



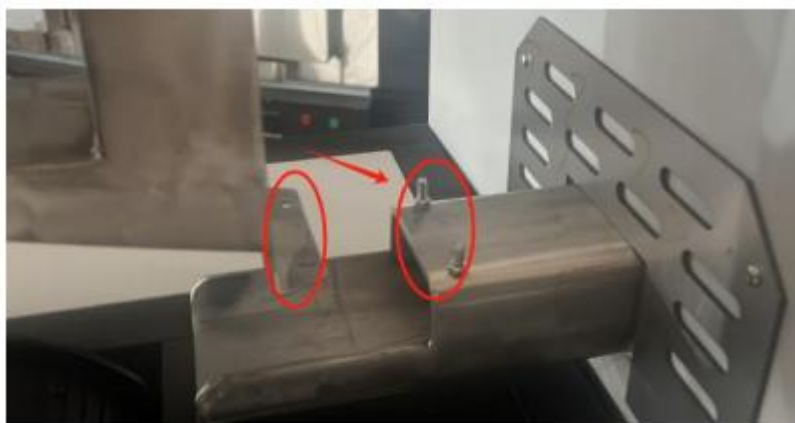
2.5 根据所需长度，选择合适长度的网带，连接放置在黑色滚轮上，并将网带首尾相连。

Select a mesh belt of appropriate length, place it on the black rollers, and connect the ends of the belt.



2.6 安装“烟囱”，机器两头各有一个，对应两个螺丝孔，安装扭紧即可。

Install the "chimney". Each end of the machine has one chimney. Align them with the two screw holes and tighten securely.

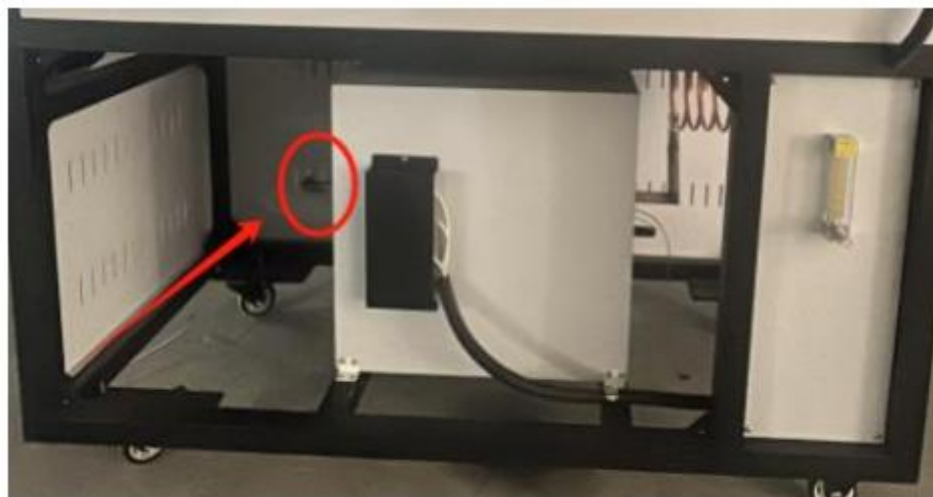


2.7 连接“氨气”，打开“流量计”左侧面板，用氨气管连接上“氨分解”接头，用卡箍箍紧，

防

止氨气外泄。

Connect the "ammonia gas": Open the left panel of the "flow meter", connect the ammonia gas hose to the "ammonia decomposition" port, and secure it with a hose clamp to prevent gas leakage.



3. **开机流程** **Startup Procedure**

3.1 开启红色主开关，绿色指示灯亮起，开机成功 Turn on the red main switch. The green indicator will light up, indicating successful startup.



3.2 打开“炉膛开关”，指示灯亮起后，设定“炉膛温控表”，调整到目标加热温度。

Turn on the "Furnace Switch." After the indicator lights up, set the target heating



3.3 打开“水泵开关”升温时，一定要打开“水泵”开关。

During heating, the "Water Pump Switch" must be turned on.



3.4 打开“氨分解开关”，指示灯亮起后，保护气体则成功开启。 - 注意：炉膛温度达到 850 度，才能开启氨气开关。

Turn on the "Ammonia Decomposition Switch." The protective gas system is activated once the indicator lights up.

Precautions : The ammonia gas switch can only be turned on when the furnace temperature reaches 850°C



3.5 根据产品需要，设定“变频调速器”的速度，以此控制滚轮和网带的传动速度。
Adjust the speed of the "Frequency Converter" based on product requirements to control the rotation of rollers and the movement of the mesh belt.



3.6 “定时器”可以提前调节时间，转动定时器指针，可设定规定时间开机或关机。
The "Timer" can be preset by rotating the timer pointer to set automatic startup or shutdown at specified times.



4. 过货流程 Material Processing Procedure

4.1 根据产品特性，选择“退火”或“焊接”工艺，将物料放置于链条上，打开开关，根据工艺需求进行参数调整。

Based on product characteristics, select the "annealing" or "welding" process, place the material on the conveyor chain, turn on the switch, and adjust parameters according to process requirements.

5. 注意事项 Precautions

-**氨气管路**Ammonia Gas Hose: 必须使用钢丝软管连接至氨气表，防止腐蚀漏气引发事故。

Must be connected to the ammonia gas meter using imported steel wire hoses to prevent corrosion and gas leaks.

- **操作安全**Operational Safety:

- 操作人员应佩戴防护装备，如手套、护目镜等。

Operators must wear protective equipment such as gloves and goggles.

- **气体调节**Gas Adjustment: 氨气出气量需缓慢调节，避免过量。

Adjust the ammonia gas output slowly to avoid excessive flow.

6. 关机流程 Shutdown Procedure

6.1. 关闭氨气总开关。 Turn off the ammonia gas main valve.

6.2. 关闭水泵。 Turn off the water pump..

6.3. 关闭机器总电源。 Turn off the main power switch.**附录**Appendix

- ****技术参数****Technical Parameters::

- 功率 Power: 12 KW

- 最高温度范围 Maximum Temperature Range: 850 °C

- ****维护建议****Maintenance Recommendations*:

- 定期检查气体管路和电源线。

Regularly inspect gas lines and power cables.

- 清洁设备内部，确保测温针和加热元件正常工作。

Clean the interior of the equipment to ensure the temperature probe and heating elements function properly.

****温馨提示****Friendly Reminder*: 操作前请仔细阅读说明书，确保熟悉设备操作流程和安

全注意事项。如有疑问，请联系技术支持。

Please read the manual carefully before operation to ensure familiarity with the equipment's procedures and safety precautions. For any questions, please contact technical suppo