

Manual book for Wood Briquette machine

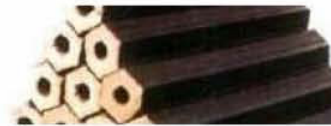
Made in China



ZBJ-I
capacity: 150-200kg/h
power: 7.5-11kw



ZBJ-II
capacity: 200-300kg/h
power: 13-15kw



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SHENYANG C&A MACHINERY

FOREWORD

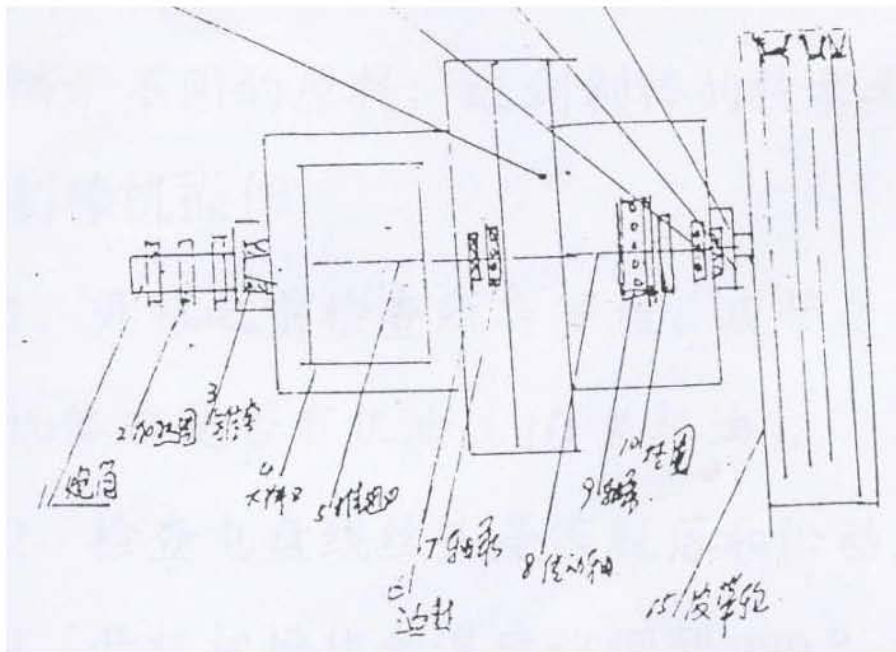
1. INTRODUCING FOR THE MACHINE
2. MAIN PARTS
3. OPERATION
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1. INTRODUCING FOR THE MACHINE

The machine mainly use the sawdust,branch,rice hull,peanut hull,dregs of coffee,grain straw etc ,which they are grinded , through higher temperature and pressure to heat them, make them stick for the fuel .

The raw materials should be less than 5mm,the moisture is 8 % orso.

2.Main parts



1. Forming Cylinder 2.Heating Collar 3.Mounting Inner-Sleeve 4. feeder 5.Propeller
6.oil seal 7.216 #Bearings 8.shaft 9. 8315#bearings 10 gasket 11. 211# bearings
12. Oil seal 13. cover of bearings 14. Bearings seat 15. belt wheel

3. OPERATION

A. check all screw belt for guantee them normal not loosen ,check if lubricate into the gears ,etc.

B. check the electrical broad for contacting right .

c. adjust the temperature meter to 280 degrees, to heat ,till it automatically stop ,then put the materials into hopper ,slowly the

stick briquette would be out .

Only working normally for 30 mins or so, which shows the operating successfully .

D. the length of stick could be adjusted by hand according to the requires at the local market .

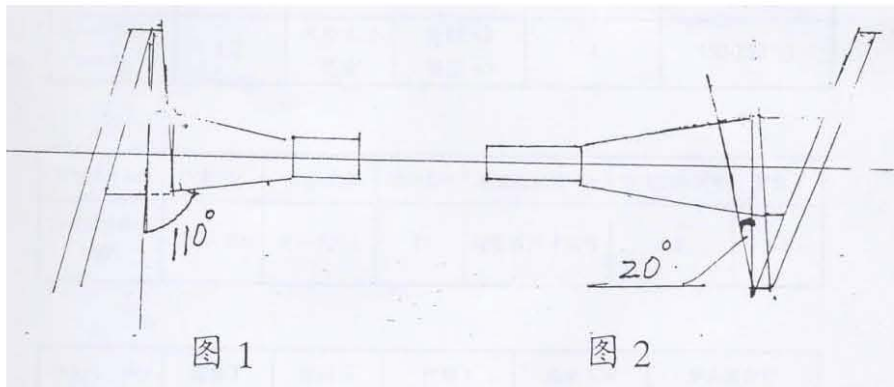
E. make not any materials inner hopper before stopping the machine, and to reversing for one min ,let the materials out from the propeller .

4. Maintenance for the Propeller

If show the following question ,the propeller should be repaired.

- 1.the speed of producing the stick
- 2.the raw materials is normal, but the shaft is jammed now and then.
- 3.the stick is ok, but it could not contact one good length.
- 4.the speed of producing, but it is loosen, lower density
- 5.the face part is less then 4mm for the frower of propeller
6. the dia of inner of final stick is less then 15mm
- 7.the screw parts is wore out or destroyed

Repairing the propeller



1. pre-heating the part welded for 350 degrees .
2. use the direct current welding machine, with casting, cineration, tungstenic alloy welding rod (hardness HRA77) (melting point 1600 – 1700 degree).
3. one lay by one layer weld on the part wore ,after welding one layer, to remove the welding dregs, then weld the second layer. The thickness welding is more 1-2mm than the normal requires, the

propeller welding not permit dregs ,air hole etc.

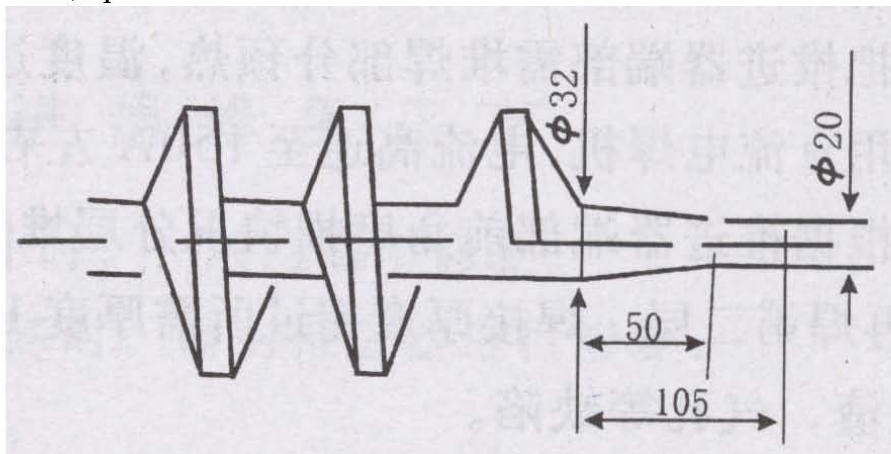
4.cool the propeller

After welding,put the part welded into the dry calces or plant ash for cooling.

5.when cooling to under 50 degrees take out .Polish it on the grinding wheel slowly ,probid to use the water or the other liquid .

6.when polishing it ,the forward of screw part ,at 360 degree periodic angle ,its forward angle slowly add from 2 degree to 22degree +_ 1.5 degree at the tip part . Note,it should smoothly .

Accoding to the following map ,if the shaft wore is more than 6mm,repair it as it .



A. When pre-heating to 350 degrees ,at the length 105mm ,steady welding lay by lay with carbal welding rods, which is more 1-2mm then the size of the map .

B. cooling it as the before .

Note:

1. tighten the screw of heating collar,and the 3 pcs thimble inner of mounting sleeve.

2. after stoping ,then to before opeing again ,the temperature of heating collar should be 350 degrees .

3. the volvage is 360 v orso.

4. if propeller could not run, stop quickly the machine and conversely the running to let the materials be out from the hopper, add 20 degrees than the before confirmed ,then open it again .

5. Forbid standing any person before the outer .

6.forbid any stone and iron into the hopper ,or quickly stop it to

remove it .

7. keep the dry for the electrical parts, before stopping the machine ,pls cut the power in advance.

8. lunnicate all parts each month.

9. the machine is contacted to the ground normally .

5. FAILURE AND SOLVEING

No	phenomenon	reason	solve
1	Lamp is not light	a. not contact to the power b. fuse blowout c. the lamp is destroyed	a. contact to the power b. change the fuse c. change one
2	The motor not work	a. the volvage is lower b. 2 phases work c. voltage and hz is not accord	a. change the button b. contact the electrical wire c. check it
3.	The temperature is slow and not up to 350 degrees	a. voltage is low b. heating collar is destoried c. type of hearing collar is not correct	a. check the voltage b. change the heating collar c. choose the right type
4	The motor is heat	a. load is big b. 2 phases work c. Bearings is destroyed d. Wind funnel is jam e. High temperature near it f. The volvage is not jarless g. short circuit	a. check it according to No 5 b. check the fuse ,button, knife switch c. change the bearings d. clear the impurity e. reduce the temperature f. adjust the volvage g. check and solve the matter
5	The stick is not out	a. wet materials b. the temperature is low c. screw groove nip the materials d. the stagger for the groove of inner sleeve and heating collar e. low volvage f. groove of the inner sleeve is wore out g. sleeve of heating collar is destroyed h. propeller is wore out	a. dry the materials b. add the temperature c. repair the propeller, clear the impurity d. assamble the inner sleeve of heating collar e. check the volvage f. change the inner sleeve g. change the inner sleeve h. repair the propeller

6	The stick is not complete	<ul style="list-style-type: none"> a. wet materials b. the stagger for the groove of inner sleeve and heating collar c. high temperature d. the angle of propeller is less than 20 degrees e. thermocouple is not assembled well or wrong place f. short circuit of heating collar g. oil is more of the materials h. the belts is loosen 	<ul style="list-style-type: none"> a. dry the raw materials b. assamble the inner sleeve c. reduce the temperature d. repair the angle e. assamble the thermocouple f. check the circuit of heating collar g. repair the angle of propeller for the No 4 h. tighten the belts
7	Stears is out from the hopper and bumping	<ul style="list-style-type: none"> a. wetter raw materials b. inner sleeve of bracket is wore out c. inner sleeve of heating collar is wore out d. the angle of propeller is not cccord 	<ul style="list-style-type: none"> a. dry the materials b. repair the inner sleeve c. same as b d. same as b e. repair the propeller

6. Main data

Model	ZBJ-III	ZBJ-II	ZBJ-I
Output kg/h	750-1000	200-300	150-200
Motor Power (kw)	30	15	11kw
Electric heater (kw)	3*1.5	3*1.5	3*1.5
Size of products (mm)	Ø50-100, length > 50mm	Ø45-55, length > 50mm	Ø45-55,length > 50mm
Size (mm)		1680*550*1280	1650*530*1250
Weight (kg)	910	780	720
Consumptation	< 100kwh/t		
Density of product	1.1-1.3t/m3		
Heating quantity	4400-5000kcal/kg		

● Note: spare parts

1. Mounting Inner-Sleeve
 2. Propeller
 - 2 Forming Cylinder
 - 3.Heating Collar
-

The others' machine matched

● Wood crusher



- 9FH- Branch Crusher



BG- Straw Crusher

Introduce

9FH system crusher could crush the small diameter tree branch, less than 30mm, and BG system could crush the big diameter.

Mata

Item	BG-10	BG-20	9FH-36	9FH-40	9FH-60
Capacity (kg/h)	350-650	750-1000	100	150-200	200-250
Diameter of feeding material (mm)	$\leq \phi 10$	$\leq \phi 20$	$\leq \phi 30$	$\leq \phi 40$	$\leq \phi 60$
Max. size of	$\phi 5 \times 5$	$\phi 5 \times 5$	$\phi 1 \times 3$	$\phi 1 \times 3$	$\phi 1 \times 3$

crush (mm)					
Motor(kw)	7.5 - 11kw	15-18.5kw	3-4	7.5-11	11-15
Overall dimension (cm)	180*70*80	230*100*140	70*48*95	75*55*115	

● Pipe Dryer for sawdust

It is necessary for man-made briquetting line ,even the peanut shell and rice hull dried normally said, which is also required to dry them , only this they could meet the needs for making the briquette stick .

It produce the high temperature funnel-air inner of the furnace of dryer ,with the waste materials or gas born ,then make the raw materials (sawdust ,etc) contact to the funnel-air directly, to rid off the moisture of raw materials to less than 12% .so it could meet the requires of making the briquette stick .

The requires of raw materials : length <5 mm,dia <3mm, water > 12%



HGJ Flash Dryer

Model	Capacity (Moisture:40%) (kg /hour)	materials Size of feeding (Diameter)	Temperature of Hot Air	Power (kw)	Installing size (m)	Dia. of main pipe
HGJ-I	300-500	< 20mm	180~250℃	4	20*0.85*2.2	300 mm
HGJ-II	600-800	< 20mm	180~250℃	5.5	30*0.85*2.5	350 mm
HGJ-III	1000-1500	< 20mm	180~250℃	7.5-11		400 mm