

自动加压大宽度测厚计把柄设置成宽矩形,使把柄底端距离测量头达30~50 cm,沿胶帘布两边可分别测量30~50 cm宽度范围的厚度。

(3) 采用轻便材料。普通测厚仪采用金属把柄和金属底座,轻便数显自动加压大宽度测厚仪则采用橡胶把柄和橡胶底座。

(4) 安装可供测厚计自由移动的不锈钢管。在压延机主机左机架与压延机烘干辊左机架间和压延机主机右机架和压延机烘干辊右机架间分别设置两根金属不锈钢管,钢管直径为3~5 cm。在两根钢管上均分别悬挂一个轻便数显自动加压大宽度测厚计,保证测厚计随帘布运动而在金属杆上自由移动。

2.3 使用效果

压延胶帘布自动测厚装置的使用效果如下:

- (1) 实现连续测厚,对胶帘布质量实时监控;
- (2) 实现自动测厚,避免测厚操作造成的胶帘

布浪费和不安全因素;

(3) 具有数据存储功能,实现胶帘布的质量追溯;

(4) 实现自动加压和数显读数,减少人为读数产生的胶帘布厚度测量误差;

(5) 实现全方位测厚,提高胶帘布质量控制。

3 结语

本设计压延胶帘布自动测厚装置已在轮胎生产企业实际应用,并获得实用新型专利授权(CN 204831231U)。

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Design of Automatic Thickness Measuring Device for Calendering Process

MIAO Fei¹, XU Yunhui^{1,2}, SUN Peng¹, WANG Hu³

(1. Xuzhou College of Industrial Technology, Xuzhou 221140, China; 2. China University of Mining and Technology, Xuzhou 221116, China; 3. Xuzhou Xugong Tyres Co., Ltd, Xuzhou 221005, China)

Abstract: This paper introduced the design of automatic thickness measuring device of calendared rubber cord fabric which could measure both the thickness in the middle part and the thickness at the edge. The device was composed of X-ray emission source with its storage rack, X-ray receiver and its storage rack, control cabinet, user operation terminal, calender frame, calender cooling frame, cross beam, weight adjustment device and a portable digital thickness measurement device with automatic pressing control and large width capability. With this device, the thickness of calendared rubber cord fabric could be automatically, continuously and accurately measured, it improved the production efficiency.

Key words: calendared rubber cord fabric; automatic thickness gauging device; portable mechanical thickness gage

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2016年第3季度,米其林轮胎公司净销售额为51.8亿欧元,同比下降2.5%,其中卡车轮胎净销售额为15.3亿欧元,同比下降4.6%;卡车轮胎销量同比下

降3%,乘用车轮胎销量同比增长2%(不包括俄罗斯和巴西市场);两轮轮胎与飞机轮胎市场发展势头较好,工程机械轮胎和农业轮胎销售不理想,但米其林没有公布相关数据。

(中 联)