喷水织机使用故障检修及排除方法
Troubleshooting and solution of water jet loom

①开口部分 Opening part

- ①油封透水损坏轴承
  The oil seal to damage the bearing.
- ②螺栓螺母松动磨损配件
  The bolt and nut loosen and wear the fitting.
  - 解决办法：加油周期严格遵守，了机时清洗要彻底，全面检查螺栓螺母的紧固，避免织造过程中坏机
    Solution: Strictly abide by the refueling cycle. When a roll of pan head is woven, it should be thoroughly cleaned, and the tightening of bolts and nuts should be fully checked to avoid machine damage during weaving.
    - **日常保养：使用中织机清洗周期为20-25天/次，锂基润滑脂加注周期20-25/次，并确保挤出旧油。龙头机皮带30天/次检查并校正平棕度数。**
      Daily maintenance:The cleaning cycle of the loom in use is 20-25 days each time, and the lithium grease filling cycle is 20-25 days each time, and ensure that the old oil can be extruded.Dobby and cam belt is checked every 30 days and Corrected flat flame degree.

②引纬部分 The weft insertion part

- ①09AA-06泵簧断和工作不良
  Pump spring breaks and works badly.
  - 解决办法：避免频繁调整压缩泵簧并确保泵簧的'PH值'不要太小。
    Solution:Avoid frequent adjustments to the compression pump spring frequently and ensure that the 'PH' of the pump spring is not too small.
- ②09AA-15Y-16Y,单向阀磨损和破损
  Valve is worn and damaged.
  - 解决办法：要求客户改善水质，并注意拆装时操作要整洁规范。
    Solution: Customers need to improve water quality, and pay attention to clean and standard operation when disassembling and installing.
- ③09GC-17(凸轮转子）经常失油磨损
  Cam rotor often lose oil and wear.
  - 解决办法：严格遵守加油周期。
    Solution：Strictly abide by the refueling cycle.
- **日常保养：09BC-01S蓄水槽（桶）确保使用中不漏水、不溢水，7天/次清洁。**
  Water storage tank (barrel) ensures that there is no leakage or overflow during use, and it is cleaned for 7 days / time.

③打纬部分 Beating part

- ①30CA-31-32摇摆轴防水护罩处容易堆积废纱造成6212轴承损坏，从而使得打纬不良产生停机档、打纬异响
  It is easy to accumulate waste yarn at the waterproof shield of the swing shaft causing damage to the 6212 bearing, which results in poor beating with abnormal noises.
  - 解决办法：需参照喷水织机保养手册。
    Solution：Please refer to the loom maintenance manual.
- ②30CA-6铊座固定螺栓用电动扳手紧固存在隐患容易松动
  The fixed bolt reed seat is fastened by electric wrench, which is easy to loosen.

④送经部分 Let-off part

- ①纬向档疵(weft defect)
  - 轻薄织物(Light fabric)
    - 解决办法A：轻薄织物18FB-60后梁滚筒'倾斜角度'要变小、张力适度减小。
      Solution A:The 'tilt angle' of the light fabric back beam roller should be smaller and the tension should be reduced appropriately.
    - 解决办法B：18FB-27自在弹簧压缩圈数调整到5圈或者减少重锤铁块。
      Solution B:Free spring compression turns to 5 turns or reduce weight iron block.
  - 厚重织物(Heavy fabric)
    - 解决办法：加多重锤铁块、加大18FB-60后梁滚筒倾斜角度、加大张力，如果调整有效果可以继续加大调整力度，如果调整织物档疵没有变化需要仔细检查齿轮、经纱导筒轴承、经轴轴承、送经齿轮箱有没有配件磨损。
      Solutions:Increase the weight of the iron block, increase the tilt angle of the rear beam roller and increase the tension, if the adjustment is effective, you can continue to increase the adjustment intensity. If there is no change in the adjustment of fabric defects, it is necessary to carefully check the gears, warp guide bearings, warp beam bearings, and let-off gear box for accessories wear.
- ②经轴轴承在经纱大张力下容易磨损
  Warp beam bearings are prone to wear under high warp tension.
  - 解决办法：尽量减小织物经向张力、厚重张力大的特殊织物需要加大经轴轴承（6210改6212）
    Solution: Try to reduce the warp tension of the fabric and the special fabric with large heavy tension needs to increase the warp beam bearing.
- ③经纱断裂(Warp breakage)
  - 解决办法：改变经纱张力大小、控制好现场温湿度、经纱挂浆均匀、调整18FB-27自在弹簧压缩圈数、改变18FB-60后梁倾斜角度，如果没有改善效果需检查器材：综丝、钢筘、导筒的光洁度。
    Solutions:Change the warp tension, control the temperature and humidity on the spot, and warp hanging slurry Uniform, adjust the number of 18FB-27 free spring compression turns, and change the tilt angle of the 18FB-60 rear beam. If there is no improvement, you need to check the equipment: heald wire, steel reeds, finish of guide tube.

⑤卷取部分 Take-up part

- ①卷取链条断
  The take-up chain is broken
  - 解决办法A：调整24CA-71链条张力连杆压力大小
    SolutionA:.Adjust the pressure of 24CA-71 chain and tension link.
  - 解决办法B：检查24CA-27Y自转轮是否正反转正常
    SolutionB:Check if the 24CA-27Y auto-rotating wheel is normal or reverse.
- ②胶刺皮脱落(The stripper off)
  - 解决办法：保证吸水风机工作良好，保持胶刺皮干爽，经常检修胶刺皮开头跟结尾是否密封良好、了机用细毛刷刷洗干净胶刺皮上的浆料，上机时经纱绑接头避免太大，以防碾压脱离胶刺皮
    Solution: Ensure that the water suction fan works well and keep the stripper dry. Regularly check whether the beginning and end of the stripper are well sealed. The machine uses a fine brush to clean the slurry on the stripper. Too big to prevent the rollers from peeling off the rubber prickles;The warp yarn binding joint should not be too large when it is on the machine, so as to prevent the roller from peeling off the rubber burr.
- ③24EA-02轴承壳处6209轴承失油磨损，造成织物档疵
  Bearing oil loss and wear at the bearing shell , causing fabric defects
  - 解决办法：油嘴严格遵守保养手册要求周期，每月加注锂基脂
    Solution: The grease nipple strictly abides by the period required by the maintenance manual, and the lithium base grease is added every month.
- ④卷取离合器故障
  Winding clutch failure
  - 解决办法A：定期检修离合踏板踩踏运行并润滑良好。
    SolutionA:Regularly overhaul the clutch pedal and run it well with good lubrication.
  - 解决办法B：定期加注齿轮油润滑离合器咬合齿轮、离合器踏板连杆。
    SolutionB:Periodically add gear oil to lubricate the clutch gear and clutch pedal connecting rod.

⑥电控部分 Electric control system

- ①电控柜受潮，电路板烧焦
  The electric control cabinet is damp and the circuit board is scorched.
  - 解决办法：电控柜定期更换足额的干燥剂、避免长时间断电、清洗机器时注意遮挡、避免带电拔插插头、如需操作，断电2min后进行。
    Solution: The electric control cabinet regularly replaces the full amount of desiccant, avoids long-term power failure, pays attention to shielding when cleaning the machine, and avoids plugging and plugging with electricity. If you need to operate the machine, you need to do it after 2 minutes of power off.
- ②电缆线断路、通讯故障问题
  The cable is broken and the communication is faulty.
  - 解决办法：电缆线固定位置要合理、通讯线路插头端子固定牢固。
    Solution: The fixed position of the cable should be reasonable, and the plug terminal of the communication line should be firmly fixed.
- ③电动机及机械式吸水风机出现问题
  The motor and mechanical suction fan have problems.
  - A.检修皮带松紧度
    A:Repair the tightness of the belt.
  - B.1年/次检修保养转子轴承
    B:1 year / time overhaul and maintenance of rotor bearings.
  - C.吸水风机叶轮确保1月/次冲洗干净，确保叶轮轴轴承不超负荷运行
    C:The impeller of the water suction fan is ensured to be cleaned once a month, to ensure that the bearings of the impeller shaft are not overloaded.
  - D.1天/次巡回机器区域有无异响、有无丢落螺丝、有无烧焦异味、机台周围有无异常漏水
    D:Check whether there is any abnormal noise in the area of the machine for 1 day / time tour, whether there are screws dropped, whether there is burnt smell, and whether there is any abnormal water leakage around the machine.