

(3) 必须保证钢丝经过导向辊送料架后, 牵引到成型盘上为一条直线; (4) 根据所使用的钢丝直径, 选择对应配套的送料架小料夹和排线轮规格; (5) 开机前检查排线轮沟槽边部是否有卷边、毛刺等, 一经发现及时更换。

6 结语

六角形钢丝圈覆胶不良主要受到胎圈钢丝、覆胶胶料、挤出机温度控制及钢丝预热效果、钢丝圈缠绕机口型、机台送料架及排线轮等因素的影响, 生产过程控制中需要从以上几个方面入手, 降低该缺陷的发生率。本文只针对我公司六角形钢丝圈缠绕工艺运行过程中遇到的钢丝圈覆胶不良

问题进行了初步研究探讨, 在今后的工作中还需进一步探索更优化的问题解决方案。

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Analysis on Influencing Factors of Compound Coating Defect of Hexagonal Bead Ring

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Abstract: The effects of bead wire, coating compound, extruder temperature control, wire preheating, the mouth shape, head feeding frame and winding wheel of the bead winding machine on the compound coating defect of hexagonal bead ring were analyzed. It was found that the compound coating defect of the hexagonal bead ring could be effectively controlled by implementing the following improvement solutions: strictly control the plating thickness and breaking force of the bead wire, appropriately increase the coating weight, control the Mooney viscosity, Mooney scorch time and physical properties of the coating compound within the standard range, strictly monitor the preheating process and control the extruder temperature, control the preheating temperature of the wire inductance at $40\sim 60\text{ }^{\circ}\text{C}$, add a chamfer in the direction of the wire inlet of the wire guide plate, and moderate the gaps between the clamps of the feeding frame and the width of the groove on the winding wheel.

Key words: radial tire; hexagonal bead ring; compound coating defect; bead wire; extrusion; winding; feeding

高耐久低生热的矿用工程轮胎带束层胶及其制备方法

由泰凯英(青岛)专用轮胎技术研究开发有限公司申请的专利(公布号 CN 114163698A, 公布日期 2022-03-11)“高耐久低生热的矿用工程轮胎带束层胶及其制备方法”, 公开了一种高耐久低生热的矿用工程机械轮胎带束层胶及其制备方法, 其矿用工程机械轮胎带束层配方为天然

橡胶 100, 炭黑 45~60, 氧化锌 6~8, 硬脂酸 0.4~0.55, 防老剂 2~2.5, 粘合剂 6~8, 间-甲-白增硬体系 2~5, 钴盐 0.3~0.5, 高耐久改性剂DC-01T 0.5~1.2, 塑解剂 0.1~0.2, 炭黑分散剂 1~2, 不溶性硫黄 5~8, 促进剂 0.7~1, 防焦剂 0.15~0.3。本发明解决了现有技术带束层胶料耐久性能不足、生热较高的缺点。

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