

3 硫化模具改进结构功能

3.1 内压介质循环

改进硫化模具外水嘴座孔与内密封圈底座孔的相交长度以不影响内压介质流量为宜,两套并联的内循环管路可独立使用且互不影响,从而使模具达到既可用于硫化罐又可用于四柱硫化机硫化的目的。

3.2 在机台上的安装

在硫化罐内,改进硫化模具直接重叠放置,模具外的凸台槽口用于模具吊装;在四柱硫化机内,改进硫化模具外壁增设的环形凹槽用于安装压板槽。

3.3 在运模台上的运行

改进硫化模具凸台吊装槽口与四柱硫化机安装槽周向方向一致,避免四柱硫化机安装时螺栓与模具裙边干涉。

4 硫化模具改进效果

硫化模具改进前,硫化罐和四柱硫化机使用各自的硫化模具;硫化罐硫化模具外水嘴座孔中

心距与内密封圈底座孔中心距一致,受外水嘴座孔中心距大的限制,模具硫化的最小规格轮胎胎圈直径为15英寸(381.0 mm),如要硫化更小规格轮胎需在模具间增加过渡板。

硫化罐硫化模具改进后,模具外水嘴座孔中心距与内密封圈底座孔中心距不同,且外水嘴座孔与内密封圈底座孔相交,硫化的轮胎胎圈直径最小减至13英寸(330.2 mm),同时未增加内压介质泄漏点,模具相关操作与改进前一致。改进后的硫化模具可用于硫化罐和四柱硫化机硫化,能同时满足两机型的使用要求。改进模具结构简单,易加工,改造费用较低。

5 结语

改进的用于双机型的小规格轮胎硫化模具对轮胎硫化操作和硫化质量控制无影响。该模具已成熟地运用于我公司硫化罐和四柱硫化机生产线,对降低固定资产投资、减少操作人员调配以及合理安排生产成效显著。

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Improved Design of Curing Molds for Small Size Tire

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Abstract: In this study, autoclave curing mold was improved, and the curing molds for small size tire with bead diameter from 13 to 16 in (330.2~406.4 mm) which were suitable for two models for autoclave and four post curing press were designed. In the improved design, the distance between the outside outlet centers was larger than the distance between the base centers of inner sealing ring, and the outside outlet intersected with the inner ring base. The mold had two circulation lines which could function separately. On the outside of mold, additional outer mold plate skirt and pressure plate groove were added. Mold support plate could also be added with less mold plate skirt. The improved mold structure was simple and easy to be processed.

Key words: curing mold; small size tire; autoclave; four-post curing press

巴西拟延长对华农机轮胎反倾销调查期

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据商务部报道,巴西决定自2016年10月14日,延长对原产自中国的农机轮胎反倾销调查期限最长至8个月。

巴西近期发布了对中国农机轮胎反倾销初裁结果,初步认定中国农机轮胎生产企业对巴西存在倾销行为,对巴西国内农机轮胎生产造成损害。

(本刊编辑部)