

陆威机械
LUWEI MACHINERY

Outside Flange Bolted Silo

(Abbreviation: Bolted silos)

General Installation Manual

Edited: Xiamen Luwei Construction Equipment Co., Ltd

Sales: +86 592 7072928

Mobile phone: +86 13559257519

Wechat and Whatsapp: +86 13559257519

Skype: tina.yexiamen

E-mail: tina.ye@xmlwjx.com

<http://xmlwjx.en.alibaba.com>

<Http://www.xmlwjx.com>

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Company Profile

Xiamen LuWei Construction Equipment Co., Ltd is a professional company dealing with all kinds of material treatment equipments and concreting machinery, which integrates research & development, manufacture and sales into a whole. The main products of the company include: powder material silo, dry powder & mortar storage tank, various non-standard steel-frame building and associated equipments. Our company has the particular patent in 'Bolted-type Powder Silo' (Patent NO: 201020649684.5). These kinds of powder silos enjoy high reputation for easy transportation, installation and dismantlement. Our products mainly used in the areas such as construction material, chemical engineering, energy resources, environmental protection and foodstuff.

Under the management principle of 'Getting the client trust by providing high quality product' and the management policy of 'Innovate for development, Honesty to client', our company aims to provide sound pre-sale service, in-sale service and after-sale service for our customers. Up until now our company has supplied high-quality products and considerate services to high-speed railway construction projects such as Beijing-Shanghai Railway and Shijiazhuang-Wuhan Railway as well as many city commercial concrete enterprises, cement companies and new industries like dry powder & mortar. Meanwhile, our business has expanded to various oversea markets with broad good customer evaluation and feedbacks.

Xiamen LuWei Construction Equipment Co., Ltd is set up by the investment of Xiamen Xianghao Industry and trade Co., Ltd which takes a controlling stake of it. Relies on Xianghao Company's economic strength, corporate brands and carries out the modern management mode of XiangHao, LuWei strides forward toward engineering machine specialization and product series. For the strategic objective of developing Xianghao Industry and trade Co., Ltd into a group company, the development of LuWei will lay a solid foundation.

Chapter two Preparation before installation

One unloading

Van parked in the pile of goods, untie the goods. Staff should pay attention to whether the component is stable in the process of unloading. If the component is not stable, you should first smoothly pull the component with hook, prevent component injury somebody. Crane goes items according to the location of the goods by the top down order. After the component is bound by shackle, all the staff should back to a safe place then elevate the pothook smoothly. At the first, the command crew members outside in security lines observe whether the component is stable, then Command crane to hang the component to goods area. After the component is totally steady, remove the shackle.

The unloading process should be equipped with two experienced lifting workers, one security officer and one commander; all personnel should strictly follow the command crew guidance. In the process of hoisting, within 2 meters area, the arm rotation radius is strictly prohibited area within stand.

The relevant personnel must wear safety protective equipment; related personnel must posts (all of the following operation processes are required to comply with).

According to the site conditions and the installation process discharge of orderly, pay attention to the following:

1. Can't take up installation site, consider the crane parking position.
2. Consider the area that the crane can cover, had better not remove the crane as far as possible.
3. All objects should be discharged base on the principle of the first used in front.
4. All objects should Place neatly and compact as far as possible. Take up the less space as far as possible.
5. The same or similar components should be put together. It is easy to find or remove when using.
6. Please according to the characteristics and convenient way to put objects in case that the components deformation or difficult to use.
7. Should avoid collision to any other object parts, so as not to scratch or deformation. It is placed on the ground smoothly.

Two Installed base acceptance

According to equipment layout diagram, foundation drawing, silos diagram inspection installation base whether accord with installation requirements, the following key inspection:

1. The Leg distance and standard in the silo figure are in accord?
2. Whether they are qualified based sclerosis?
3. Foundation board elevation (Level height) is consistent?
4. Silo is assembled properly with other objects?
5. The deviation in foundation center will affect the need of security?

Three Best installation site selections

1. Based less distance from the installation, the crane can reach the distance directly.
2. The ground should level off, hard, dry.
3. The size of the space should consider the requirement of handstand of the cans.

4. The electric control cabinet should be placed in the convenient and safe position.
5. without the high tension wires and other barriers above the place.

Four the preparation of installation personnel and equipment

1. Staffing (According to a single tank consideration, if there are more than two cans, all kinds of personnel can increase)

- (1) One person in charge of the installation procedures and installation personnel deployment.
- (2) two to five assembly workers, grasp the basic mechanical assembly knowledge, can direct the crane, and have a strong sense of security.
- (3) One crane worker, have high altitude work operation experience, safety consciousness is extremely strong with the aloft working license;
- (4) one to two welding workers have outdoor experience with welding license.
- (5) two to five ordinary workers, responsible for wear and installation bolt, with the experience in the construction site, have strong sense of security.

2. Tools and equipment:

A number of crane hoisting, according to the site conditions; two to five electric/air wrench; six Manual wrench; two sets of electric welder; 1 set of gas cutting; a number of iron bars; one safety rope ladder; four Safety rope; one ladders and other necessary tools.

Five Check goods

1. Verify the number and size of bolt and other accessories.
2. Check the number and size of the product components.
3. Verify tools whether are complete.

Six the preparation of Common parts

1. Prepare the number of bolt which will be used on that day (prepare the sub plate).
2. Prepare the number of sealing parts which will be used on that day (cut according to the need).

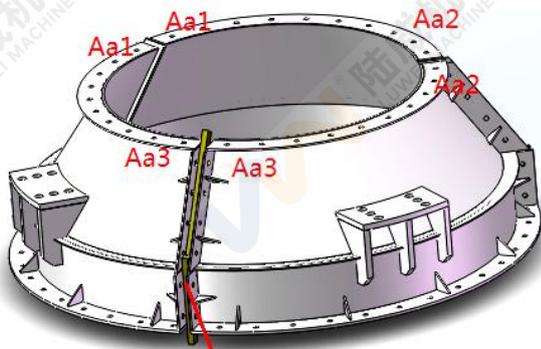
Seven Particular attention

After the silo is install, the external sprinkler inspection should be carried out, the water should be sprayed on the outside of the silo, and the leaking point should be checked and glued on the inside of the silo

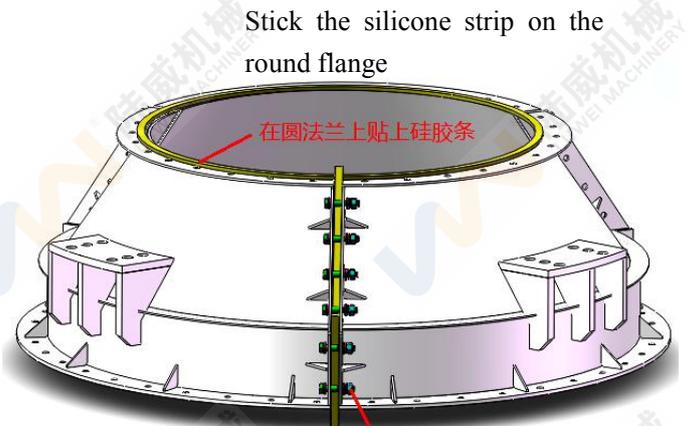
Chapter Three Installation Steps and Notes

I Cone assembly

- 1.Circle large cones, such as Aa1-Aa1,Aa2-Aa2,Aa3-Aa3, according to the graphic number.
- 2.The straight flange and the circular flange are affixed with silicone strips, and strips of the two ends of the straight flange are 100 mm longer than the straight flange. Tear the release paper on the silicone strip and stick the silicone strip directly to the inside of the bolt hole of the straight flange.



在直法兰上贴上硅胶条
Stick the silicone strip on the straight flange



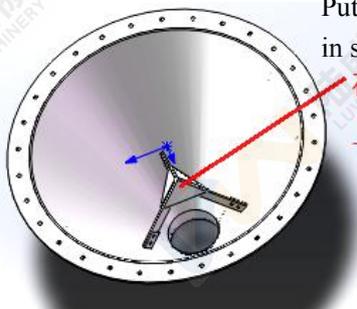
Stick the silicone strip on the round flange

在圆法兰上贴上硅胶条

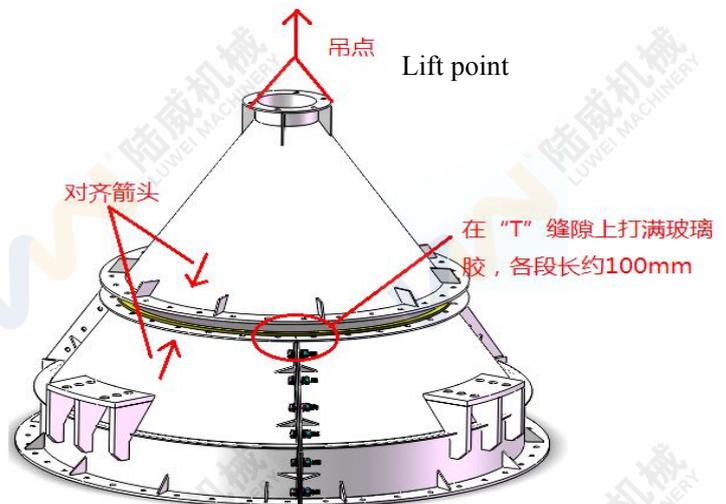
穿好螺栓拧紧

Screw bolt

3. lock the bolt tightly against the big cone, if the bolt hole is not good alignment can use crowbar to pry the cone level.
- 4.if there is a middle cone according to the above method to assemble the middle cone.
- 5.Put the small cone down and lock the decompression device.



Put relief device in small cone
在小锥上装上减压装置



吊点

Lift point

对齐箭头

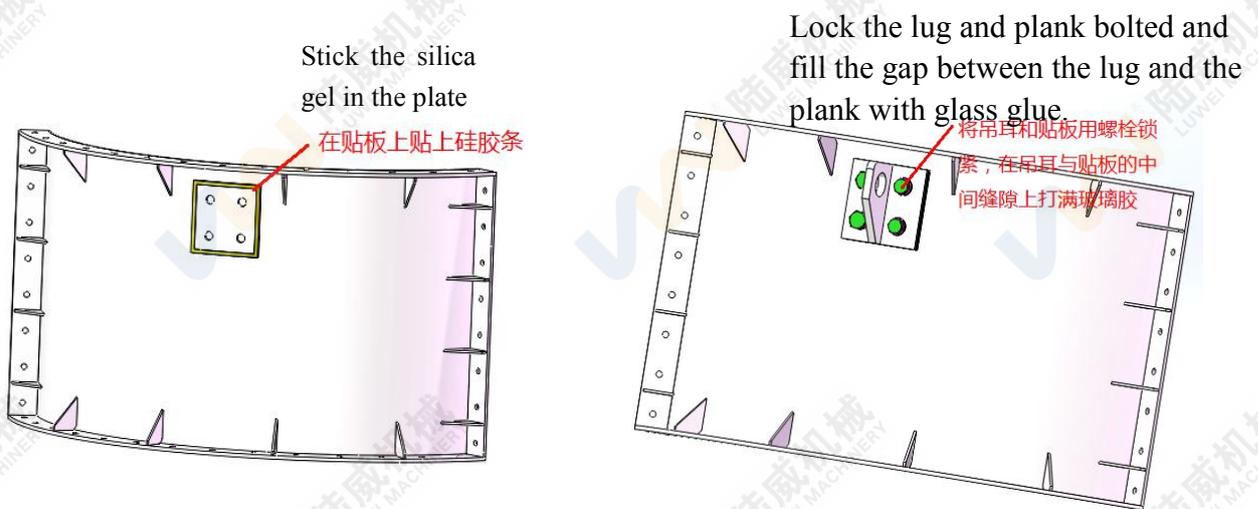
在“T”缝隙上打满玻璃胶，各段长约100mm

The T gap is covered with glass glue, and the length of each section is about 100mm.

6. with the flange of the outlet of the small cone as the hanging point, the small cone is lifted to the large cone in a good direction (align with the arrow), and the locking bolt (if there is a middle cone, the small cone and the middle cone pair are locked in the whole small cone, the middle cone is suspended to the large cone and locked with the large cone).
7. the gap between the word "T" is filled with glass glue, and the length of each segment is about 100 mm.

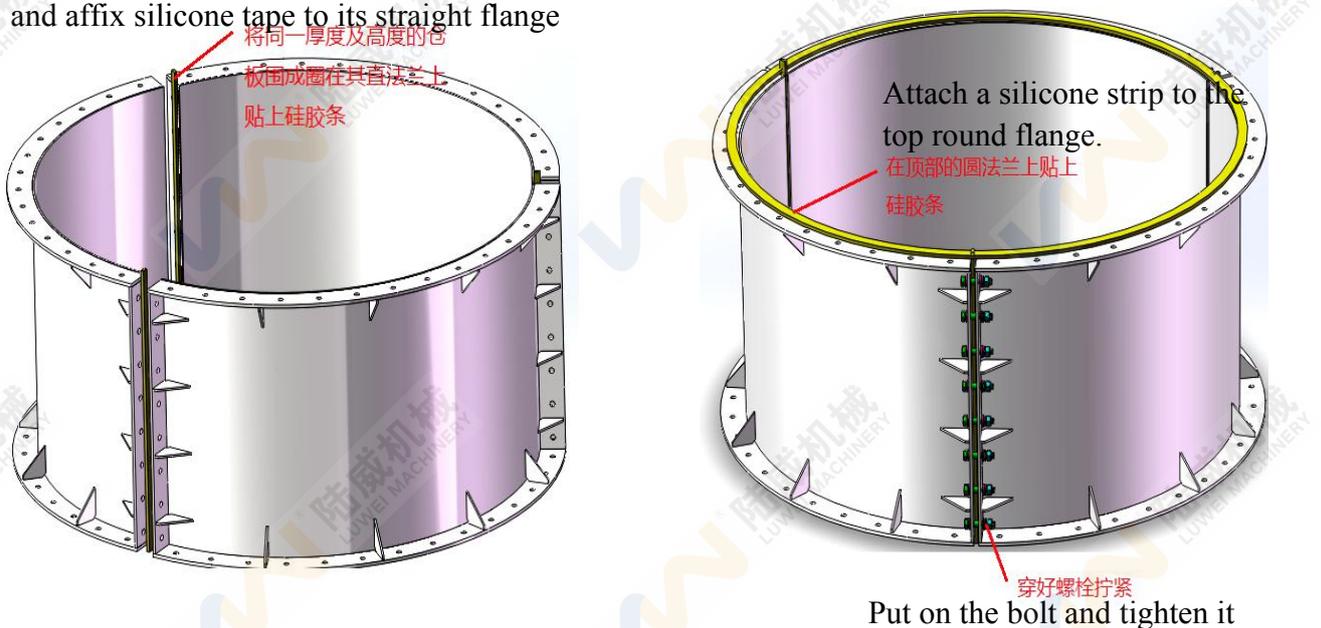
II Silo plate assembly

1. level out a site large enough to place all the warehouse panels together.



2. Find out the warehouse plate with the welding plate, affix the silicone strip on the board, and then lock the lifting lug and fill the glass glue around the bolt hole and the plate.
3. Circle the silo plate of the same thickness and height (the silo plate with hanging ear is in the same circle) and affix the silicone strip on the straight flange (the length of the silicone strip is longer than that of each end of the straight flange).

Circle the silo plate of the same thickness and height and affix silicone tape to its straight flange

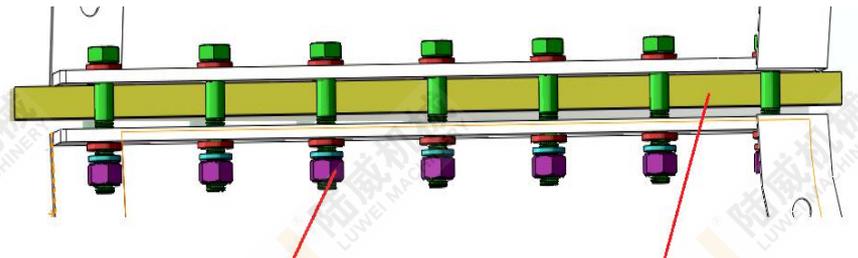
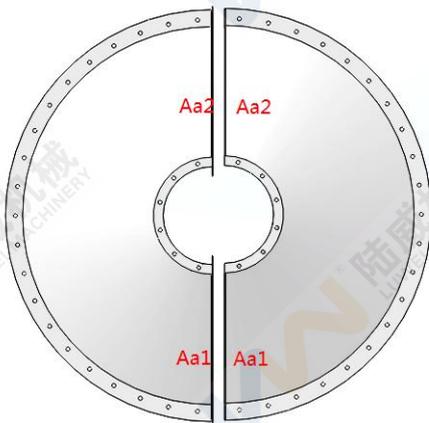


Put on the bolt and tighten it

3. Close the warehouse plate and lock the straight flange. After locking, affix the silicone strip to the upper round flange (all silicone strips are inside the bolt hole).

III Silo cover assembly

1. Circle the cover of the warehouse in a circle as shown.



穿好螺栓后拧紧

Tighten when you put on the bolts

在其中一片直法兰上贴上硅胶条，在硅胶条上打上玻璃胶

Put a silicone strip on one of the enforcement blue pieces and put glass glue on the silicone strip.

2. Put a silicone strip on one of the enforcement blue pieces and put glass glue on the silicone strip.

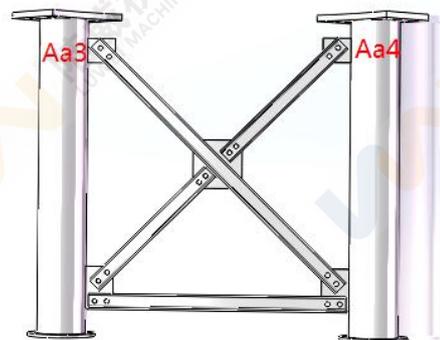
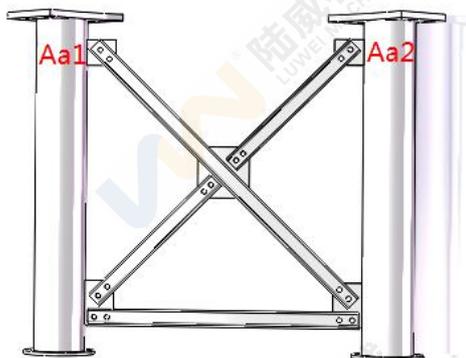
3. tighten when you put on the bolts

IV Leg assembly

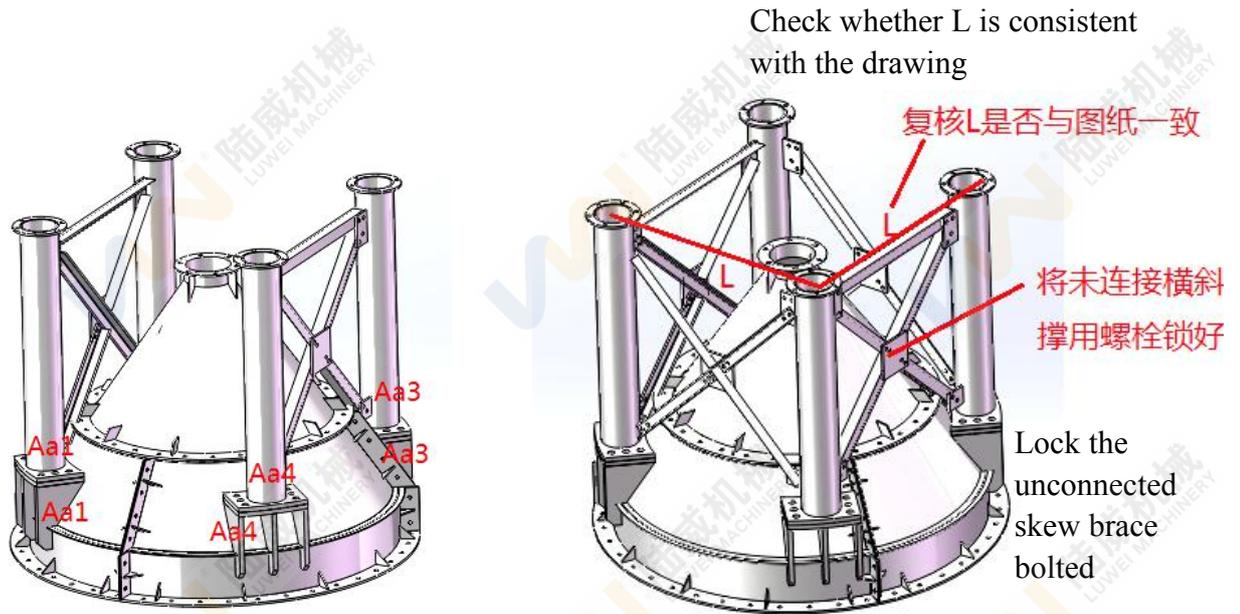
1. Short leg assembly (welded with leg cover)

1.1. Check the distribution of leg package numbers on the assembled cone, as shown below.

1.2. According to the distribution of leg bag number, the leg is divided into two pieces.



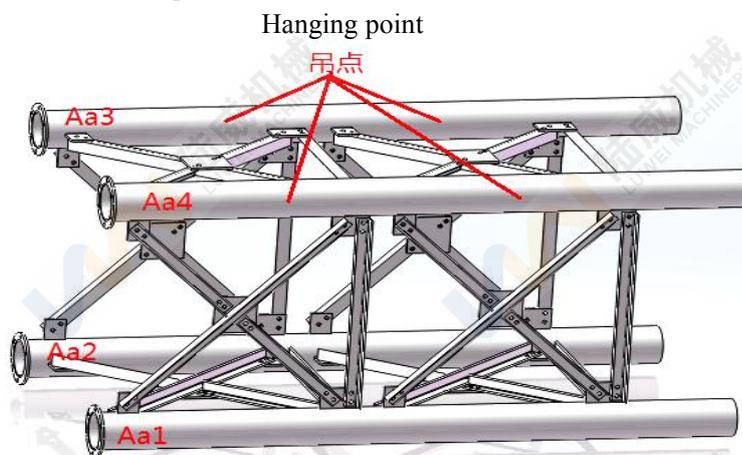
1.3. Lock the matched two-piece supporting leg according to the number and the supporting leg of the large cone, as shown in the following figure.



- 1.4. connect the short leg without connecting the transverse brace.
- 1.5. check whether the distance between the short legs is consistent with the drawing.
- 1.6. flip the cone and bracket.

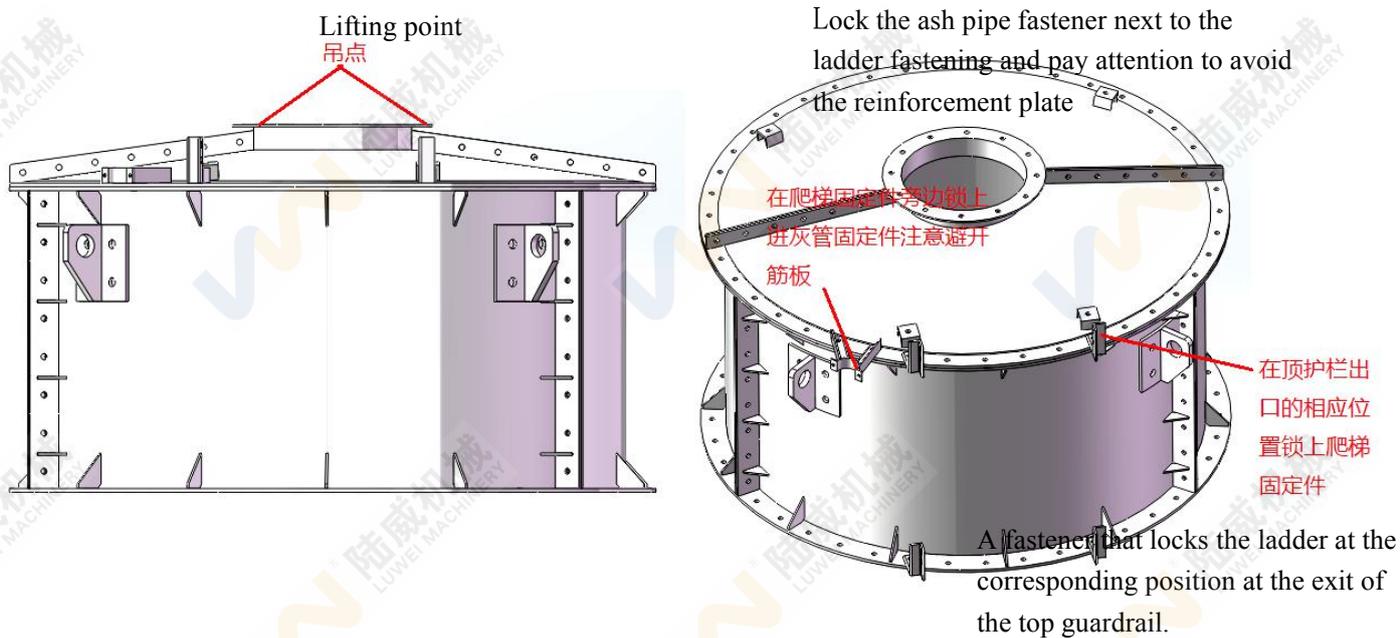
2. Long leg assembly

- 2.1. Split the remaining legs into two pieces.
- 2.2. place one piece on the floor and the other with a crane above the previous one, the distance equal to the leg distance on the general drawing to connect the remaining diagonal brace to a bracket.
- 2.3. check whether the leg spacing is consistent with the drawing (to be consistent with the short leg).
- 2.4. after hoisting the leg frame to the foundation and adjusting the level and the distance between the legs, the leg is welded with the foundation plate (full welding).
- 2.5. weld the leg reinforcement plate.



V Silo body unit assembly

1. Hoist the spliced bin cover above the spliced bin plate (lock lugs on the bin plate docked with the bin cover).
2. The position locking bolt of the warehouse cover and the hole position of the warehouse plate is tightened, and the exit of the top guardrail of the warehouse cover is found to climb the ladder fixing part on the corresponding hole position lock, and the ash pipe fixing part is locked next to the climbing plate fixing part as shown below.



3. 4 lugs as hanging points according to the thickness of the warehouse plate given in the drawing, all the warehouse plates are docked in order of height, and all the ladder fixtures are locked according to the drawings (make sure that all the fixtures are in the same straight line).
4. lock the corresponding ladder and ladder fixtures.
5. when splicing warehouse board, all straight flange should be staggered, which is that the round flange of straight flange butt should be filled with glass glue.
6. hang the whole cylinder body above the cone according to the appeal method and the cone lock.

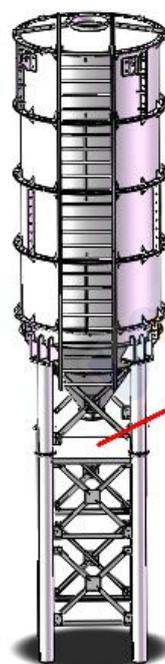


Fill all the T-word seams with glass glue

After the tube body is assembled, and then connect to the assembled cone.

VI Whole silo assembly

- 1.The whole silo is hung on the base and is connected with the lower supporting leg frame.
2. Install the ladder of the lower bracket.



The operator completes the assembly of the whole silo and the lower leg frame on the maintenance platform.

操作人员在检修平台上完成整个筒仓与下支腿架的拼接

VII Silo accessories assembly

1. Installation of top guardrail

- 1.1. circle the top guardrail according to the number and lock it with bolts.
- 1.2. lift the top guardrail to the top of the silo and lock the support on the lid of the silo, and the opening should correspond to the climbing ladder.

2. The ash pipe is installed

- 2.1.the end of the ash pipe is welded on the cover according to the actual length of the top section of the ash pipe.
- 2.2.connect the ash pipe along the ladder and lock the fixtures.

3. Installation of dust collector

- 3.1. Weld the dust collector and the flange of the dust collector in an annular full weld, and do not have leakage welding, and the air hole shall be provided with leakage leakage.
- 3.2. Remove the bolts of the dust collector flange of the dust collector and the bin cover, and then apply the glass glue to the flange of the bin cover dust collector before the connection.

4.High and low material level meter installation

- 4.1.About 300mm on the other side of the ladder, about 600mm at the bottom of the warehouse cover, cutting the hole with a slightly larger screw diameter than the material level meter.
- 4.2. About 300mm on the other side of the ladder and about 600mm on the top of the cone to cut holes slightly larger than the screw of the material level meter.
- 4.3. insert the material level meter threaded pipe into the hole and weld it with the silo plate ring, pay attention to the direction of the thread pipe to ensure that the material level meter can be rotated from the outside of the cylinder body.

5. Safety valve installation

- 5.1. Place on the bin cover a hole with a diameter slightly larger than the relief valve approximately 500 mm away from the edge of the bin cover.
- 5.2. Insert the safety valve into the hole and weld with the cover ring.

6. Installation of broken arches

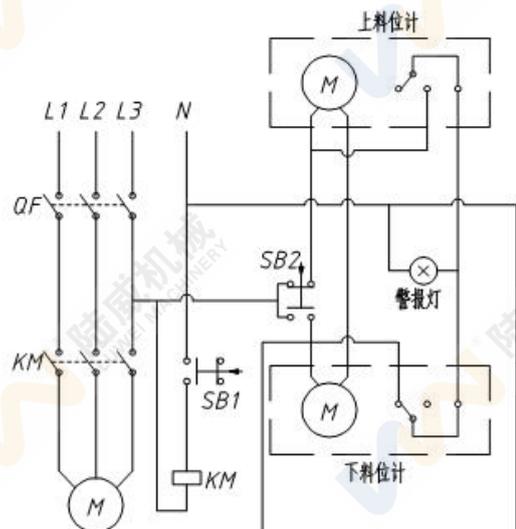
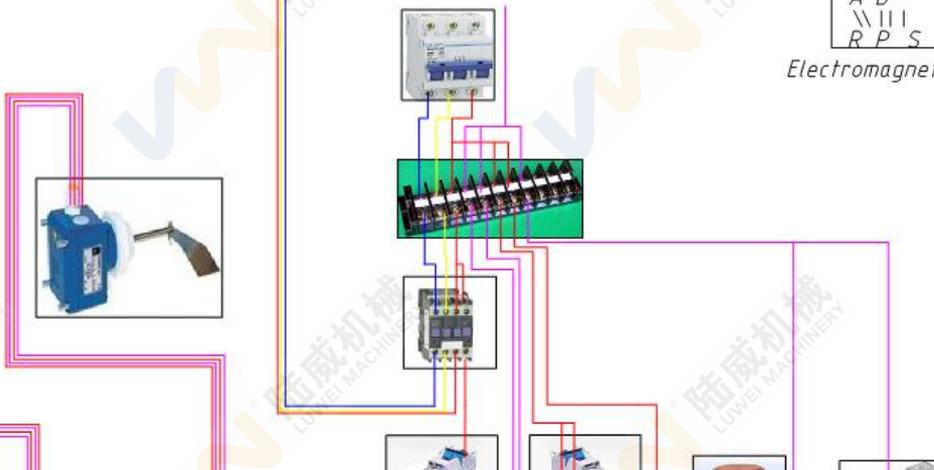
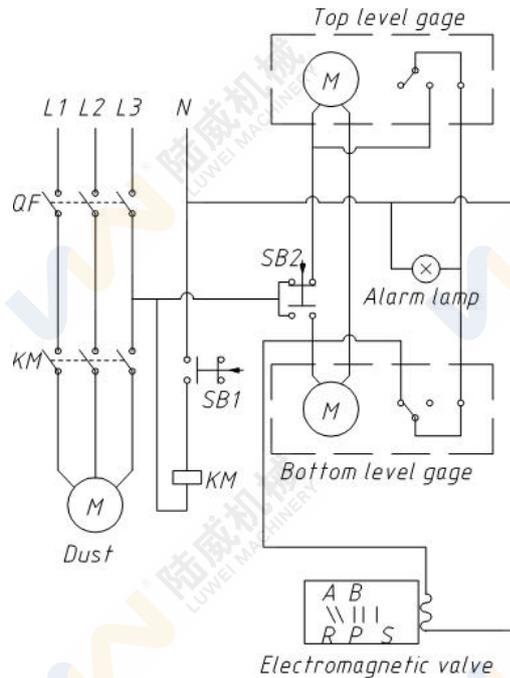
Screw the broken arch into the tube thread on the cone.

VIII Circuit

This illustration shows the recommended circuit, but because our customers on the silos of monitoring and control requirements are difference, it can also be made by customers professional electrician to design according to the

self demand circuit; In the following, that is the only simple introduction for several loop circuit.

1. When the process for remove ash in the silo, people regularly turn on the SB1, switch off the A.C. contactor and start the vibration motor of ash separator.
2. When the process for remove ash in the silo, keep the switch to the normally off, turn on the motor of level gage, the material is in the place, the level gage will automatically turn off because the blade is blocked, connect the circle of alarm, remind stop playing gray.
3. When the material is discharged from the silo, turn the normally open interlock off, start the motor of level gage while connect the solenoid valve and the return circuit of arch breaking airflow. When the descended material is in the place, start the motor of level gage, turn the normally closed interlock off, connect the circle to the alarm, and remind that it is lack of material.



Appendix one Site management requirements

1.1, the "ban", "no" clause in the silos construction site:

- 1.1.1, it is strictly prohibited to spread of speech which is damage the image of the company;
- 1.1.2, no dispute or clashes with user;
- 1.1.3, it is prohibited for behave which is not connection with the job in the work place.
- 1.1.4, it is prohibited any material rewards from users;
- 1.1.5, it is strictly prohibited to the project manager or outsourcing unit staff fight each other;
- 1.1.6, it is strictly prohibited to bribery, bribery, sacked;
- 1.1.7, it is prohibited to take family members or close friends into the construction site;
- 1.1.8, it is prohibited to smoke and make fire in the construction site or controlling room;
- 1.1.9, it is prohibited to propose the unreasonable demands or excessive demands for users, do not complain to the users about the site conditions;
- 1.1.10, it must wear a helmet into the construction field work;
- 1.1.11, it must wear seat belts when do the aerial work;
- 1.1.12, not in the construction site casting from high above any item;

1.2, the provisions for the spare parts and tools:

- 1.2.1, the project manager or silos installation personnel must set up the good guidance of safety consciousness, leave after arranging the loading bay and the inspection about all the components and parts everyday;
- 1.2.2, the project manager or silos installation guidance personnel need check whether there is unusual before going to work every day; If find out something is stolen, large amount of more than 1000 Yuan (should) the first time tell the police and protect the alibi, waiting for the police, and assist investigation with police and reported to the company;
- 1.2.3 All parts should be put in the order according to the condition, put the similar material together for the convenient search;
- 1.2.4 the whole installation site must be kept clean and tidy and may not throw the packing paper and wood anywhere, but should be placed together, it is disposal after install the unity;
- 1.2.5, tools, such as electric welding machine, electric grinding machine need waterproof processing; everyday should make the rain proof measures before going;
- 1.2.6, should clean up the installation site after the whole project finishing, ensure make the construction site clean and tidy.

Appendix two Security management request

According to the country laws, regulations as " Production Safety Law" "Construction Engineering Safety Production Management Regulations" and "The Production Safety Accident Report, Investigation And Handling Regulations", considering the actual installation situation and past experience and lessons, then work out this production safety request to guide the installation and construction in order to prevent accident to assure production safety.

2.1 Basic rules for installing and constructing silos

- 2.1.1, Installation principals (captain), part-time security officer must have the safety training and have the level of safety management.
- 2.1.2, Construction workers in site such as electrician, welder (cutting), lifting driver, cable workers must have the card mount guard, forbid any personnel unlicensed operating;
- 2.1.3, Banned any dangerous operation contraindication engaged in dangerous operations;
- 2.1.4, Construction site shall be equipped with completely and have effective protective appliances such as safety helmet, safety belt and safety glasses, etc;
- 2.1.5, Installation principals (captain), part-time security officer should talk about the safety technique with workers before constructing everyday and do safety inspection the appliances and equipments.
- 2.1.6, According to the local weather, like wind (including the typhoon), ray (electrical) rain, snow, high temperature (above 35 °C), frozen and so on, decide to suspend or stop the construction.

2.2 The ban for safety management in site

- Ban to appearing any behaviors violated construction site disciplines;
- Ban to putting forward any unreasonable request to customers.
- Ban to threatening subordinates and outsource construction works.
- Ban to going to construction site without safety helmet.
- Ban to doing aerial work without safety belt.
- Ban to throwing any items form aerial work site.

2.3 Major hazard installation--- identification and safeguard procedures for high operation, air drop.

- 2.3.1 All height of fall high than 2 meters include 2 meters are called high operation, its main accident harm are fall, serious injury and even die.
- 2.3.2, Must abide by the following safety technology requests when involving the high operation in installation.
 - 1, before high operation, should wear the antiskid shoes and correctly wear seat belt
 - 2, before high operation, should hung the safety belt in fixed reliable location
 - 3, Safety belt should hang high, but low use.
 - 4 Forbid to hang safety pothook on safety belt directly but on link ring.

2.4 major hazards installations--hot welding, fire and explosion danger and protective measures

2.4.1, hot welding, cutting, use gas cylinders, etc may cause fire, explosion on construction site, its main accident harm are: fire, explosion.

2.4.2, During the installation process, involving to hot welding, cutting, use the cylinders, be sure to keep the following safety technical requirements:

- 1, Keep a safety distance more than 10 meters between gas cylinder and fire when do hot welding or cutting on site.
- 2, Keep a safety distance more than 5 meters between gas cylinders when do hot welding or cutting on site.
- 3, At least equip with one powder fire extinguisher on site when hot welding or cutting.
- 4, Gas cylinder on site should vertically put or put on the shelf, rather than lie down, roll, crash or expose in hot sun.
- 5 Forbid to smoking and firing on construction site, dormitory and somewhere stack fuel.

2.5 major hazards installations--electric equipment, electric dangerous and protective measures

2.5.1, On construction site, using electrical equipments will happen electric shock as short circuit overload, insulation damage, electric leakage and so on. Its main harm is electric shock, electric wound, fire, etc.

2.5.2, During installing, be sure to keep the following safety technical requirements when involve using electric equipments.

- 1, Paste safety alarm mark on electricity box shell on construction site, makes sure who the principal is. Equip with fireproof and waterproof appliances.
- 2, the cable draw from the electricity cabinet on site should be built on stilts in order to avoid damaging the insulation.
- 3, Temporary using electricity require "three-phase five line system, level 3 distribution level 3 protection, just one brake one machine one leakage protection"

2.6 Major hazards installations-- other dangerous and protective measures on construction site

2.6.1, There are lots cross work and the environment is bad on construction site, beside the dangerous above, there are some other dangerous elements. If haven't control these elements on site, they also will cause serious accidents on site. The main harm is injury by trip, high falling, vehicle hurting, collapsing, and machine hurting, ECT.

2.6.2, During the installation process, must obey the following safety technology requests in order to avoid the other main dangerous elements:

- 1, At least 2 people for limited space work, one work one guard, if any unusual, timely deal with.
- 2, At least 2 people if there are bamboo flexible ladder on site, one work one guard and fix ladder.
- 3 Forbid to throwing down items when operating.
- 4, for lifting operation area, shall set up warning belt, banned the irrelevant personnel go into the lifting work on site
- 5, Person in charge of the construction site, should regularly do workers security education training, strengthening their safety consciousness.

Appendix three the emergency and first-aid treatment

3.1 Basic treatment process for industrial injury and accident

3.1.1 Treatment process for minor injury and accident

Treatment in site, near- treatment---report to the company leadership or projects leadership.

3.1.2 Treatment process for serious accident

Call 120 emergency calls for help---the first aid in site and keep--- report to the company leadership or projects leadership ---assign a special people to attend the wounded--- report new situation at any time

3.2 Basic treatment process for fire

3.2.1 Treatment process for slight fire accident

Put out the fire with near extinguisher - - -restore the site--- report to the company leadership or projects leadership

3.2.2 Treatment process for serious accident treatment process

Call 119 emergency calls for help---isolate combustibile, evacuate the crowd--- report to the company leadership or projects leadership

3.3 Common sense for all kinds of accidents emergency aid

3.3.1 Electric shock emergency aid

Quickly cut off power supply, if the switch is far away, pick to open wire by dry sticks, rope, board, pliers, dry towel, insulated sticks and so on, also can try to cut off the wire by some tools with insulated handle, if none of the above conditions but with the hand, the rescuer must pull the dry clothes which not near the people's skin who contact with the electric wire by stand on a dry board to separate him from the power supply.

Let the people lie flat, untie the belt and collar, pat the shoulder, call his name, observe whether appearing reaction, ban to shake his head, if just slight injury, let him rest for 1 hour or so, then send to hospital to inspect;

If the people is serious injury, unconscious, try to find ice bag then put it under the head, armpit, and belly to slow down the body metabolism to promote brain recovery;

If no breathing , let him lie flat, clear the mouth ,give mouth to mouth artificial respiration, give a mouth to nose artificial respiration when his mouth injury. If no heartbeat, should make continuous outside chest press when send to hospital.

3.3.2 Fracture emergency aid

Preliminary ex-animate the explosion wound. If the wound is bleeding, first stop bleeding, and then bind up. Properly fix. Fixed can use the board, magazines, cartons or wood umbrella as upholder. Don't try to twist or reset by yourself. Splinting should support the whole wounded limb.

Make quickly and steady transfer. If fracture the key part as spinal column ,must keep the patient's body horizontal move, can not bend or twist waist, keep the patient lie flat on a hard board then send to hospital by a large ambulance rather than the canvas, ropes or soft stretcher. If mishandled, can cause spinal cord nerve damage, lead to paraplegic, then consequence is unimaginable.

3.3.3 Trauma emergency aid

1 Cutting injury

If a few bleeding, can bind up by band-aid or sterilized gauze.

If the wound is deep, the bleed is bright red and flow fast or even spray, it's maybe the arteriorrhagia, so we should press the vessel means press the artery which is closer to heart than wound to stop bleeding.

If cutting instrument is not clean, it would be best to hospital to take the tetanus shot and antibiotic to prevent wound infection.

If a finger or toe was cut off, should press the injury to stop bleeding. Bind up the wound with sterile gauze or clean cotton cloth. The fracture of the fingers, toes also should be bind up, and then send to hospital for immediately surgery. The amputation should be put in ice barrel to escort in summer; amputation shouldn't contact the ice directly to prevent to frostbite. The amputation is banned to be soaked in any water or soup in order to avoid replanting.

2 Hemostasis

Transfer to the quiet place, then inspect, make sure which type it is, arteriorrhagia phleborrhagia or capillary hemorrhage.

Can adopt press the bleeding wound or arterial blood-supply by finger to stop bleeding. For limbs bleeding, should bind up the 1/3 part of arm or the middle leg to stop bleeding by belt, tie, ribbon, wide cloth strip, scarves or strip tore by your clothes.

3 Penetrating

After penetrated by iron nails or sharp, it will be infected, even cause sepsis or tetanus with improper handle. So no matter how small penetrating should be handling with the sterilized pincer rather than hastily pull out by nail.

Stabbed deep, May injury nerve or viscera, the penetrated can't be pulling out at will. If the viscera such as intestinal tube prolepses, reset in site is not permitted. Send to hospital immediately after bonded up by clean bowl or basin covered.

3.3.4 Fire accident emergency aid

Timely dial the call box after find the fire .Tell clearly what is on fire, where fire, your name and telephone number when call the police. Assign a people to the door or crossing to wait the fire trunk after called the police.

Fire just happens, first time extinguish while the fire is small meanwhile call the police rather than follow the crowd blindly. Run toward the bright and open place when evacuating. Evacuate back on to the firework when the passageway were blocked.

When clothes catch on fire, it would be best to take off or lie down, cover face by hand and roll or jump to the near pool to extinguish the flam.

If hazy, use a wet towel to cover mouth and nose to breath, reduce posture, and crawl along the wall to escape.

Appendix Four Common Faults and Maintenance

1. Filter

1.1 Clean the filter cartridge in every three month

1.2 Start the filter on the procedure of inputting material.

1.3 Still start the filter after inputting material for three to five minutes to counter blowing or shake off the floating dust from the filter cartridge.

1.4 Overhaul the motor of filter and electric circuit in every six month.

2. Relief Valve

The reasons for spraying dust from relief valve: 1. the filter cartridge is blocked by floating dust, you should check whether the filter is working or not; you should check vibrator's motor of filter and electric circuit. 2. the valve plate of relief valve is blocked so that the valve plate can not automatically close and seal on the normal pressure; open the head cover of relief valve to check that: whether there is unusual stuff on the valve plate; whether the valve plate can open and close with freedom; whether the screw nuts on the pressure spring of valve plate are loose.

3. Level Gage

3.1 The high level gage is open all the time when inputting material. Stop inputting material when the warning light alarms to prevent too much material on the silos.

3.2 The low level gage is open all the time when inputting material. Start to input the material when the warning light alarms to prevent there is no material on the silos.

3.3 Check the eclectic circle of level gage and rotating motor in every six month.

4. Arch Breaker

4.1 Open the gas path's electromagnetic valve of arch breaker when output the material to prevent the bulging of powder in the silos.

4.2 When start the arch breaker, the procedure of outputting the material is influent, you should check whether the electromagnetic valve is working and the gas path is damage or not.

5. Butterfly Valve

5.1 Rotate the driving handle after installing the butterfly valve to make sure the fluency of opening it.

5.2 The reasons that the butterfly valve can not be opened: 1. the unclean welding slag, welding tumor and other unusual convex stuff block the opening of silos and the opening of spiral machine. On that case, you can adjust the direction of butterfly valve to avoid or remove the unusual stuff. 2. Some part of powder is agglomerate and it blocks the valve plate, you should scatter the piece of powder in time.

6. Sealing Silos

6.1 After installing the silos, you should re-check at least 20% of bolts on the warehouse cover and cone to make sure all the bolts have been screwed tightly. It prevents the accident that bolts and nuts aren't screwed.

6.2 After the silo is install, the external sprinkler inspection should be carried out, the water should be sprayed on the outside of the silo, and the leaking point should be

checked and glued on the inside of the silo

6.3 After completely installing the silos or the silo is non-occupation, the butterfly valve should be open to prevent moisture condensation inside the silo.