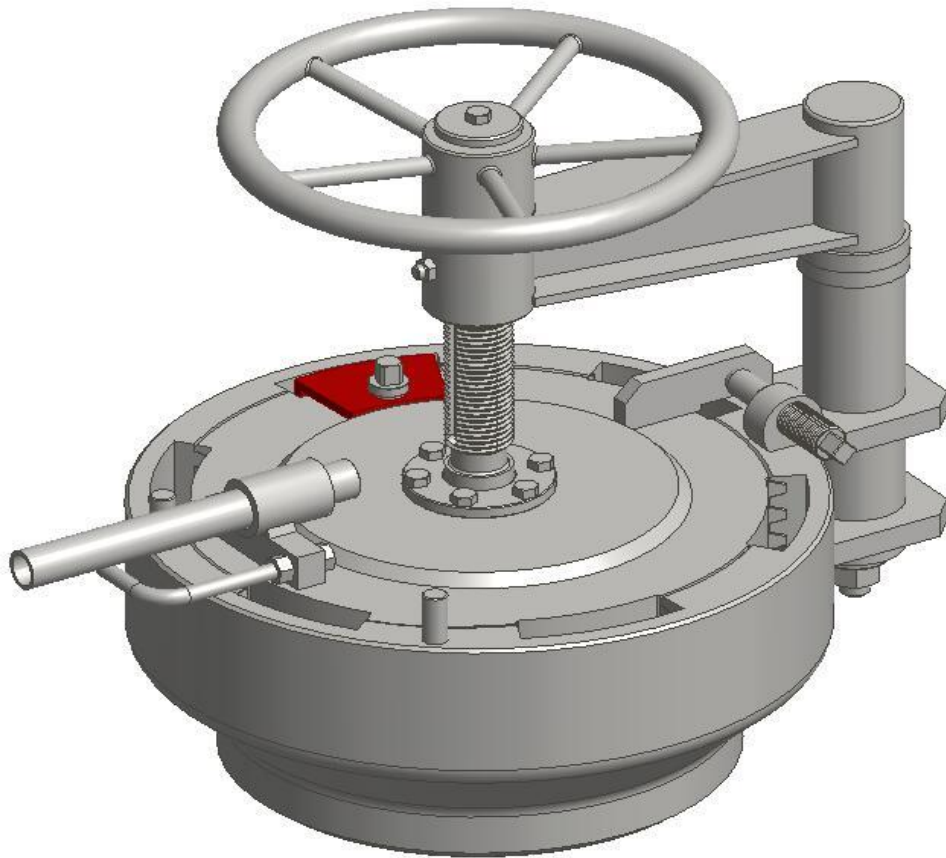


插扣型快开盲板（立式）安装、使用、维护手册

Inserted type QOC (vertical type) Installation, use and maintenance manuals

提示：在使用快开盲板之前请认真阅读本手册

Kind reminder: Please read this manual carefully before
using the Quick opening closure.



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1. 快开盲板介绍 **Introduction of QOC**

1.1 产品特点 **Product feature**

本产品结构简单合理,操作方便快捷,安全可靠性高,维护方便, 性价比高, 非常适用于公称直径 800mm 以下设备上安装使用。带有安全联锁机构, 充分确保安全可靠。

该产品主要由盲板盖、筒体、安全联锁机构、转臂机构及开闭机构组成。使用随机配备的开关杠顺时针或逆时针转动盲板盖至限位销, 即可达到快速开启和关闭的目的。

This product has a simple and reasonable structure, easy and fast operation, high safety and reliability, easy maintenance, high cost performance, and is very suitable for installation on equipment with a nominal diameter of 800mm or less. With safety interlocking mechanism, fully ensure safety and reliability.

The product mainly consists of end closure, barrel flange, safety interlocking mechanism, arm mechanism and opening and closing mechanism. The end closure can be quickly opened and closed by turning it clockwise or counterclockwise to the limit pin using the switching lever supplied with the product.

1.2 基本结构 Basic structure

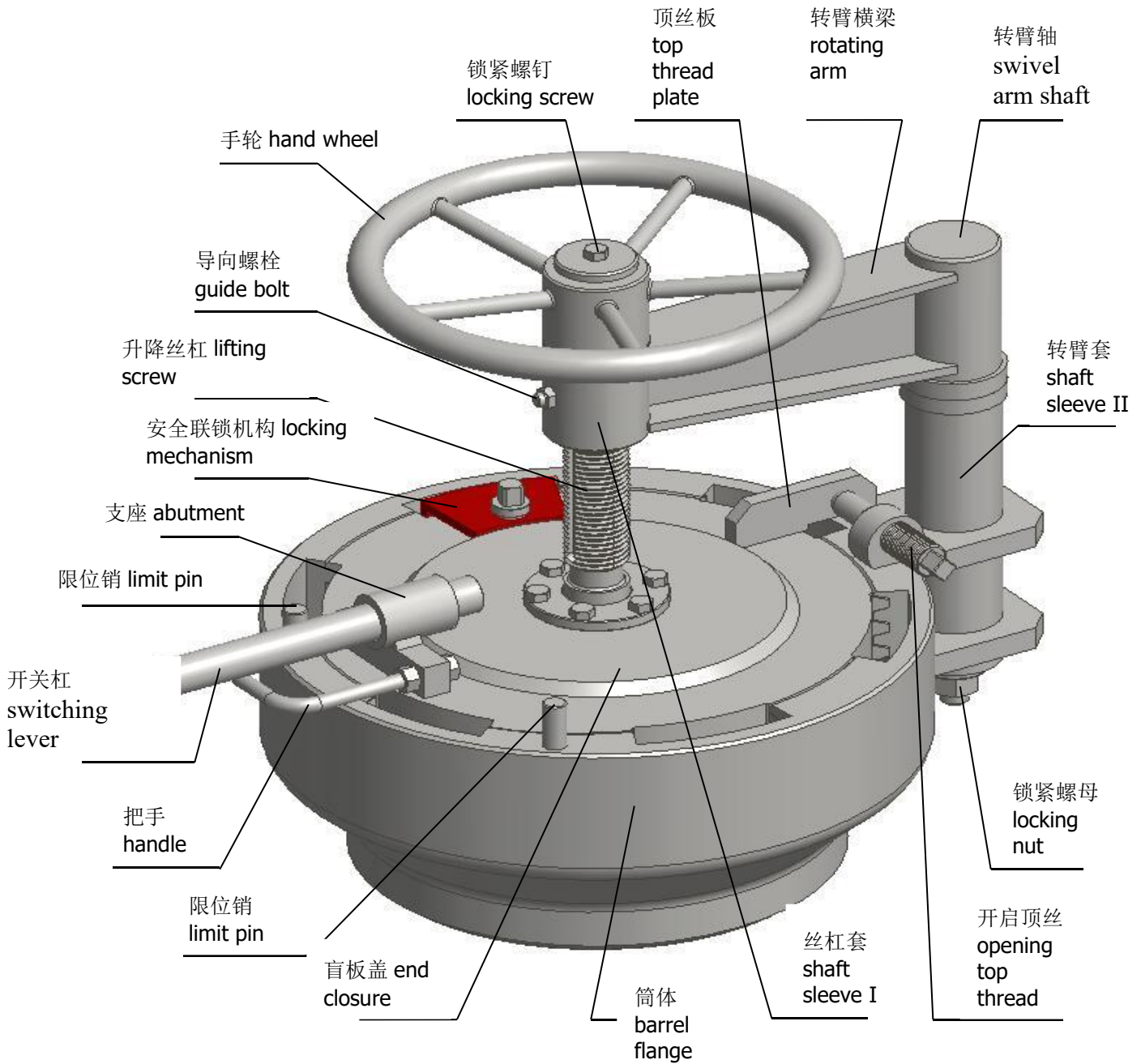


图 1 (picture 1)

1.3 应用范围 Application range

该型式快开盲板广泛应用于天然气管线、化工、医药、冶金等各个领域中的如收发球筒、槽罐、增压釜、过滤分离器、换热器等需要不定期开闭的容器设备上。

This type of quick opening closure is widely used in natural gas pipeline, chemical industry, medicine, metallurgy and other fields, such as receiving and sending ball cylinder, tank, pressurized k

ettle, filtration separator, heat exchanger and other containers and equipments that need to be opened and closed from time to time.

2. 安装 Install

2.1 初始安装 Initial installation

快开盲板初始安装，需符合以下要求：

Quick opening closure initial installation, need to meet the following requirements:

1)快开盲板内径应与设备内径一致，焊缝对口间隙应均匀一致，其最大与最小对口间隙之差 ≤ 1.0 毫米，对口错边量应符合 GB150.4-2011 标准中表 1 规定；

1) The inner diameter of the quick opening closure should be consistent with the inner diameter of the equipment, the weld counter gap should be uniform, the difference between the maximum and minimum counter gap ≤ 1.0 mm, the amount of misalignment of the counter should be consistent with the provisions of GB150.4-2011 standards in Table 1;

2)快开盲板与设备筒体组对之前，应先确定焊接型式：a.如采用双面焊，需拆下盲板盖（具体操作按本手册 2.2 盲板盖的拆卸）；b.如果采用单面焊，只需拿下密封圈即可，无需拆卸盲板盖；

2) Before the quick opening closure and the equipment barrel flange are grouped, the welding type should be determined: a. If double-sided welding is used, the end closure needs to be removed (specific operation according to the manual 2.2 Removal of end closure); b. If single-sided welding is used, just take down the sealing ring, no need to dismantle the end closure;

3)快开盲板与设备筒体焊接之前，请仔细阅读本手册 2.3 焊接及焊后热处理。

3) Before welding the quick opening closure with the equipment barrel flange, please read carefully 2.3 Welding and post-welding heat treatment of this manual.

2.2 盲板盖的拆卸 removal the end closure

在快开盲板组装及维护需要拆卸盲板盖时，请按以下步骤进行：

When the assembly and maintenance of the quick opening closure requires disassembly of the end closure, follow the steps below:

1)将快开盲板合适放置，按本手册 3.1 开门操作，将盲板盖打开；

1) With the quick opening closure suitably positioned, open the end closure by opening the door as per 3.1 of this manual;

2)按图 1 所示，a.卸下手轮中心锁紧螺钉 b. 卸下手轮 c. 卸下转臂轴下端锁紧螺母 d.拧松导向螺栓；

2) Remove the hand wheel center locking screw as shown in Figure 1. a. Remove the hand wheel center locking screw b. Remove the handwheel c. Remove the locking nut at the lower end of the swivel arm shaft d. Loosen the guide bolt;

3) 将转臂轴、转臂横梁、丝杠套从转臂套中卸下；

3) Remove the swivel arm shaft, rotating arm, and rotating arm from rotating arm;

4) 卸下盲板盖并妥善放置。

4) Remove the end closure and place it properly.

2.3 焊接及焊后热处理 Welding and post-welding heat treatment

由于焊接过程中的焊接应力及焊接操作不当等原因，都可能导致焊接变形的产生，为防止和减小焊接变形，快开盲板与设备筒体组对及焊接时，应遵守以下规定：

Due to welding stress during the welding process and improper welding operation, etc., may lead to welding deformation, in order to prevent and minimize welding deformation, quick opening closure and equipment barrel flange pairing and welding, should comply with the following provisions:

1) 对口间隙应均匀一致，最大与最小对口间隙之差 ≤ 1.0 毫米，对口错边量应符合 GB150.4-2011 标准中表 1 规定；

1) Counter gap should be uniform, the difference between the maximum and minimum counter gap ≤ 1.0 mm, the amount of counter misalignment should be in accordance with the GB150.4-2011 standard in Table 1;

2) 施焊前，需进行坡口预热或按焊接工艺规定执行；

2) Before applying welding, bevel preheating is required or according to the provisions of the welding process;

3) 施焊时，应采用小直径焊条、小电流、对称焊、多层焊的焊接方法来控制焊接变形。

3) When applying welding, small-diameter electrode, small current, symmetrical welding and multi-layer welding should be used to control welding deformation.

焊后热处理建议：

Post-weld heat treatment recommendations:

1) 对快开盲板与设备筒体之间的环焊缝进行热处理时，应尽量采用局部热处理；

1) When heat treatment is applied to the annular weld between the quick opening closure and the equipment barrel flange, local heat treatment should be applied as far as possible;

2) 如果设备制造总图的技术要求中规定设备必须进行整体热处理时，必须用岩棉、硅酸铝或其它保温材料将密封面保护起来，防止过度氧化而影响密封；

2) If the technical requirements of the general drawing of equipment manufacturing stipulate that the equipment must be subjected to overall heat treatment, the sealing surface must be protected by rock wool, aluminum silicate or other insulating materials to prevent excessive oxidation from affecting the sealing;

3) 热处理工艺严格按 GB150.4 第 8.2 条或 ASME 标准进行，或按热处理厂家成熟的热处理工艺进行；

3) The heat treatment process is carried out strictly in accordance with clause 8.2 of GB150.4 or ASME standards, or in accordance with the heat treatment process matured by the heat treatment manufacturer;

4) 请注意：a. 如果热处理前盲板盖已经拆下来，请在热处理之后进行盲板盖安装；b. 如果热处理前盲板盖未拆卸，请务必将所有密封圈拿下来；c. 热处理之后应使用细砂布将密封面轻微擦拭干净，并均匀涂抹润滑脂、甘油或防锈油。

4) Please note: a. If the end closure has been removed before heat treatment, please install the end closure after heat treatment; b. If the end closure has not been removed before heat treatment, please make sure to take down all the seals; c. The sealing surfaces should be lightly wiped clean with a fine emery cloth and evenly coated with grease, glycerin or antirust oil after the heat treatment.

2.4 涂敷 coating

快开盲板喷漆之前，必须将安全联锁机构卸下，将所有密封面、内外螺纹、紧固件、焊接坡口、不锈钢零部件、铜质件、电镀处理件等不需要喷漆的部分仔细包覆，以避免影响装配精度、使用性能、外形美观以及防止喷砂和油漆进入。

Before painting the quick opening closure, the safety interlocking mechanism must be removed, and all sealing surfaces, internal and external threads, fasteners, welded bevels, stainless steel parts, copper parts, plating treatment parts, and other parts that do not need to be painted must be carefully wrapped, in order to avoid affecting the assembly accuracy, performance, appearance, as well as preventing the ingress of sandblasted sand and paint.

2.5 盲板盖的重装 reset of the end closure

重新安装盲板盖时，请按以下要求进行：

When reinstalling the end closure, proceed as follows:

1) 首先对所有密封面进行保护；

1) Protect all sealing surfaces first;

2)将转臂轴插入转臂套中，同时将升降丝杠插入丝杠套中并进行调整，调整后先锁紧转臂轴下端锁紧螺母，再将手轮装入升降丝杠，并拧入锁紧螺钉。装配时应注意升降丝杠的导向槽与导向螺栓对正；

2)Insert the swivel arm shaft into the shaft sleeve II, meanwhile, insert the lifting screw into the shaft sleeve I and adjust it, after adjustment, first lock the lock nut at the lower end of the swivel arm shaft, then install the hand wheel into the lifting screw and screw in the locking screw. When assembling, it should be noted that the guide groove of the lifting screw is aligned with the guide bolt;

3)全部装配完毕后，将密封面与密封槽彻底清理干净并均匀涂上防锈油脂，检查密封圈有无损坏后将密封圈装入密封槽；

3) After all the assembling is finished, clean the sealing surface and sealing groove thoroughly and apply anti-rust grease evenly, check the sealing ring for any damage and then install the sealing ring into the sealing groove;

4)推动转臂，将盲板盖与筒体中心对正，旋转手轮使盲板盖下落至筒体；

4)Push the swivel arm to align the end closure with the center of the barrel flange, and rotate the hand wheel to make the end closure drop down to the barrel flange;

5)将开关杠插入支座，按顺时针方向（关闭方向）旋转开关杠至限位销；

5)Insert the switching lever into the abutment, rotate the switching lever in clockwise direction (closing direction) to the limit pin;

6)安装安全联锁机构。

6) Install the safety interlocking mechanism.

3. 开关门操作 opening and closing operation

3.1 开门操作 opening operation

注意：严格按以下要求和步骤进行！

Notice: Strictly follow the following requirements and steps.

1)开门前必须保证设备内压力为零，并严格遵守安全操作规程；

1) before opening the door, the pressure inside the equipment must be ensured to be zero, and safe operating procedures must be strictly followed.

2)拧出安全联锁机构上的安全螺栓，此时，若设备内有残压，应立即停止拧出安全螺栓动作，重新检查设备压力，确认设备内部已完全卸压后（设备上压力表指针回零），方可拧出安全螺栓并卸下安全联锁机构；

2) unscrew the safety bolts on the Locking mechanism. If there is residual pressure in the equipment, should stop removing the safety bolt immediately and recheck the equipment pressure again. Ensure that the inside pressure relief is complete (the pressure gauge pointer on the equipment returns to zero) before unscrew the safety bolt and locking mechanism.

3)将开关杠插入支座中，按逆时针方向（开启方向）旋转开关杠至限位销（如果盲板盖长期不开启，导致开关杠旋转困难时，可用扳手旋转开启顶丝，使盲板盖出现松动，然后再旋转开关杠进行开启）；

3) Insert the switching lever into the abutment, rotate the switching lever counterclockwise (opening direction) to the limit pin (if the end closure is not opened for a long period of time, resulting in difficulties in rotating the switching lever, a wrench can be used to rotate the opening top thread, so that the end closure appears to loosen, and then rotate the switching lever to open)

4)旋转手轮，将盲板盖提升后，推动转臂至盲板盖不影响操作的位置，即完成开启。

4) Rotate the hand wheel, lift the end closure, push the rotating shaft to the proper place, that is complete the opening.

3.2 关门操作 closing operation

1)关门之前应仔细检查密封面、密封槽以及密封圈。密封面应擦拭干净，不允许有一切影响密封的杂物存在。检查密封圈是否有损坏，橡胶是否老化，如有缺陷，必须更换；

1) Before closing the door, should carefully check the sealing surface, sealing groove and sealing ring. The sealing surface should be wiped clean, and no debris affecting the sealing is allowed. Check whether the seal ring is damaged, whether the rubber is aging, if there are defects, it must be replaced;

2)在密封槽和密封面上均匀涂抹润滑油脂，然后将密封圈装入密封槽内（先装入12、6点钟方向，再装入3、9点钟方向）；

2) Evenly apply lubricating grease to the sealing groove and sealing surface, and then put the sealing ring into the sealing groove (first into the 12, 6 o'clock direction, then into the 3, 9 o'clock direction)

3)推动转臂，使盲板盖置于筒体上方正确位置，旋转手轮将盲板盖落下，将开关杠插入支座中，按顺时针方向（关闭方向）旋转至限位销；

3) Push the rotating arm, Place the end closure over the barrel flange and rotate the hand wheel put down end closure, Insert the switching lever into the abutment, turn clockwise (closing direction) to limit pin

4)装入安全联锁机构并缓慢拧紧安全螺栓。

4) Install the locking mechanism and slowly tighten the safety bolt

4. 维护保养 Maintenance

4.1 存放 storage

如快开盲板需要储存，需将密封圈卸下，并将密封面、密封槽彻底清理干净，在表面均匀涂抹防锈油，然后将密封圈重新装入，用塑料布或其它包覆材料将快开盲板整体包裹好，放入包装箱储存于室内。

If the quick opening closure needs to be stored, the sealing ring should be removed and the sealing surface and sealing groove should be thoroughly cleaned, anti-rust oil should be evenly applied to the surface, then the sealing ring should be re-installed, and the quick opening closure should be wrapped up with a plastic sheet or other wrapping materials as a whole, and then put into a packing box for storing indoors.

4.2 检查 inspection

1)定期或不定期检查密封圈情况，观察密封圈是否有损坏或橡胶老化，如有缺陷必须更换；

1)Regularly or irregularly check the condition of seals, observe whether the seals are damaged or rubber aging, if defective must be replaced;

2)定期或不定期检查安全联锁机构是否完好，安全螺栓是否有断裂，密封圈是否有损坏或老化，如有缺陷必须更换；

2)Regularly or irregularly check whether the safety interlocking mechanism is intact, whether the safety bolt is broken, whether the sealing ring is damaged or aging, if defective must be replaced;

3)定期或不定期检查快开盲板是否开关灵活、可靠。

3) Regularly or irregularly check whether the quick opening closure is flexible and reliable.

4.3 润滑 lubrication

定期在快开盲板各转动件、筒体与盲板盖的梯形螺纹以及升降丝杠加注润滑油脂以保证快开盲板开关灵活。

Regularly add lubricating grease to the rotating parts of the quick opening closure, the trapezoidal threads of the barrel flange and the end closure, and the lifting screw to ensure that the quick opening closure is opened and closed flexibly.

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(实施后请打 ✓) Tick after implementation

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