

Hammer mill malfunction and troubleshooting

Trouble	Cause/s	Solution/s
Machine is started with difficulty.	<p>Too low voltage</p> <p>The lead wire section area is very small.</p> <p>Fuse burns off easily.</p>	<p>Avoid turning up the machine at peak hours of power consumption. Restart the machine.</p> <p>Replace the old lead wire with a new one.</p> <p>Use a bigger compensator.</p> <p>Use a new fuse in accordance with the motor load.</p>
Motor overhead; The power is cut off	<p>The motor runs in two phases.</p> <p>The motor coil has a short circuit.</p> <p>There is overload in the long-term.</p>	<p>Connect the other phase and continue to run in three-phase.</p> <p>Repair the motor.</p> <p>Run the machine under the rated load.</p>
Severe vibration in the hammer mill	<p>There is an error in the hammers array.</p> <p>Every two opposite hammers are of different weights.</p> <p>Some hammers are locked, they are not free.</p> <p>Imbalance of other parts on the rotor;</p> <p>The main shaft is bent.</p> <p>The bearing is worn.</p> <p>The pin shaft of the hammer is worn.</p> <p>There is no distance between the coupling two halves.</p> <p>Couplings are misaligned.</p> <p>Insufficient strength of anchor bolts.</p>	<p>Install hammers in accordance with their arraying diagram.</p> <p>Keep a 5-gram weight difference between two opposite hammers on radial when replacing the old hammers with new ones.</p> <p>The hammers should be freed.</p> <p>Check the rotor in terms of imbalance.</p> <p>Align the shaft or replace the old shaft with the new one.</p> <p>Replace the old bearing with the new one.</p>
Abnormal voice is heard from hammer mill.	<p>A metal part or stone has entered the machine.</p> <p>Some inner parts have been dismantled or broken.</p> <p>There is a small distance between the screen and hammers.</p> <p>Rotor has been displaced.</p>	<p>Turn off the machine to remove hard materials.</p> <p>Turn off the machine to check and replace spare parts.</p> <p>Keep the distance between the hammer and screen in accordance with the instruction.</p> <p>Check and do the required adjustments.</p>
Low efficiency	<p>The motor is of a lower power.</p> <p>Sever wearing of hammers;</p> <p>Uneven feeding;</p> <p>The raw materials' moisture content is very high.</p> <p>Using inappropriate screen;</p> <p>Dust filter is blocked.</p> <p>Low percentage of open area of the screen.</p>	<p>Check the motor and repair it.</p> <p>Change the hammers or replace the old hammers with the new ones.</p> <p>Feed materials evenly.</p> <p>Dry the raw materials.</p> <p>Replace the inappropriate screen with an appropriate one.</p> <p>Clean filter bags, or replace the old filter bags with the new ones.</p>

		Choose a high open area screen.
Feeding inlet has been removed.	Conveying pipe is blocked. Screen holes are blocked The grinding plate position does not match the rotor rotation.	Remove the blockage. Clean the holes of the screen or replace the old screen with a new one. Change the position of the guiding plate or running direction of the motor.
Coarse mesh of the product	Severely worn or damaged screen; The screen and its frame do not touch in a proper way, or there is a large side gap.	Repair the screen or replace the old screen with a new one. Turn off the machine and repair or tighten the screen and frame.
Bearing has been overheated.	Misalignment of the main shaft and motor; Too much or less volume of lubricating oil has been used. The bearing is damaged. The main shaft is bent, or the rotor is imbalanced. The motor has run overloaded for a prolonged period. Inappropriate lubricating oil has been used.	Adjust the motor; it should be concentric with the main shaft. Change the oil. Add oil in accordance with the instruction. Replace the damaged bearing with a new one. Balance the rotor after aligning the main shaft. Reduce the volume of the feeding. Use suitable lubricating oil.