



Automatic soap cutting machine

Operation Instructions



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Important warning and risk considerations

- Note and pay attention to the technical parameters of the machine, especially the environmental conditions must meet the requirements.
- The machine operator must undergo strict training.
- Installation and fault inspection must be conducted by professionals.
- Before installation, check whether the various components of the machine complete.
- The machine safety instructions must be strictly observed.
- Before power connection, must carefully check the installation and connection is correct, the system must be reliably grounded.
- While the machine is running, please do not put hand on the machine belt and conveyor belt to avoid fingers injured.
- Prohibit to disassemble the machine without stop the machine, must turn off the power supply before open control box and the driving part.
- Please do not put the flammable material on the machine, lest cause an accident
- Must carefully read this manual before start the machine, please post a copy to the using site in order to safe operation
- The operators who use this machine must ensure that all work and electrical components won't cause any danger of accident or personal injury!!

I. The equipment Introductions

Usage:

Automatic Soap cutting machine is the dedicated handmade soap(Square soap) cutting equipment,after the poured handmade soap cooling in the box, placed this large pieces handmade soap on the machine, you can cut into thin slices (thickness of the handmade soap can be set accurate to 0.01 mm).

Equipment advantages:

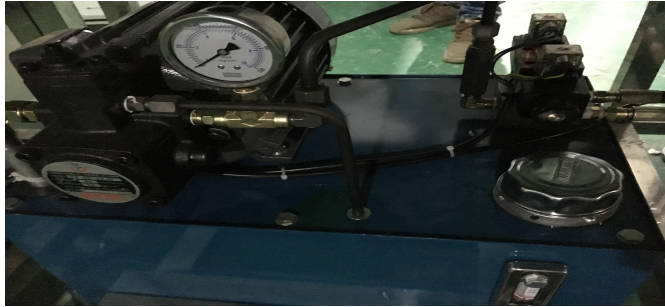
It is suitable for cutting a variety of square and rectangular soap. Its length, width and height are adjustable according to the size of the product. It is fast in production speed, PLC control, adjust parameters on touch screen,easy to adjust cutting thickness, accurate soap cutting size.Soap weight inaccurate $\leq \pm 2$ grams.

Technical parameters:

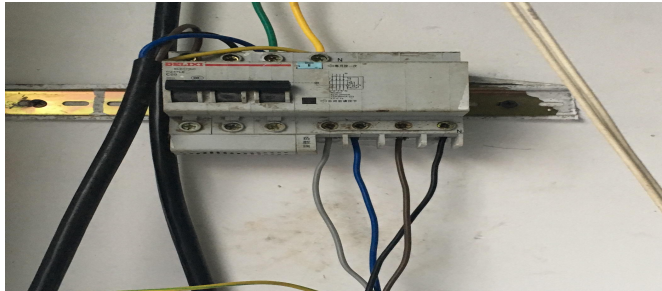
Automatic Soap cutting machine	
Production Speed	180-300/min
Weight	450kg
Power	3.7KW
Voltage	380V50Hz
Size	3400mm*800mm*1380mm

II. Installation & Operation

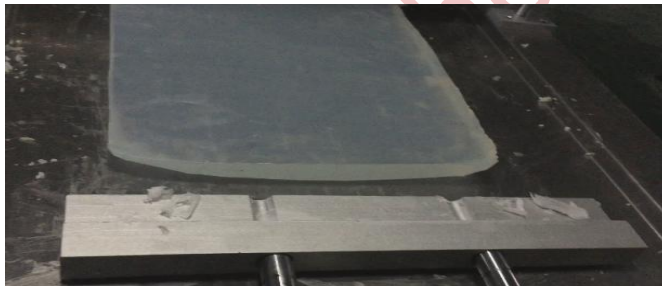
2.1 Add 30L #46 Hydraulic oil to Hydraulic oil tank



2.2 Connect Power and Switch on the Power (380 V)



2.3 Place the soap on the work table (in the middle)



2.4 Turn on the power switch in the power box



2.5 Check hydraulic oil pump

Run the hydraulic oil pump, check the running direction of motor (it is correct if the running direction the same with red arrow, if the running direction the different with red arrow then the three-phase power connection is wrong)

Turn off the hydraulic oil pump after check.

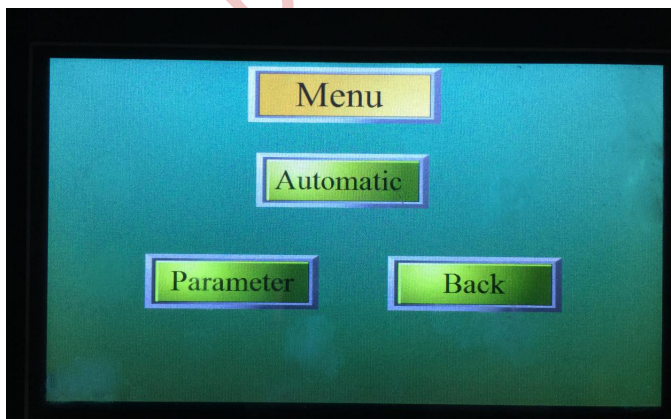


2.6 Adjust Parameter

Open Screen, Choose “English” version



Go to “Automatic” page

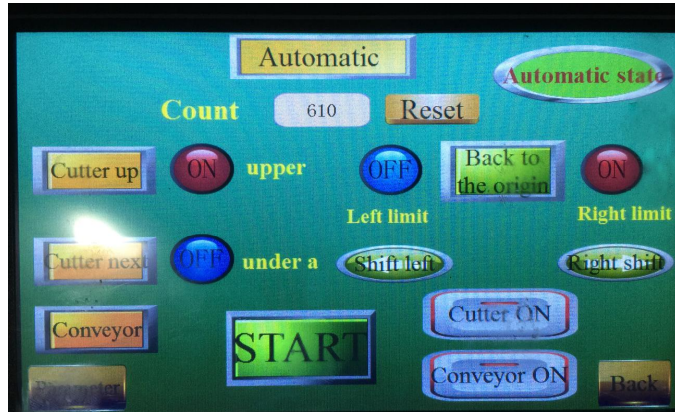


Right upper Conner of the page switch between “Automatic state” and “Manual State”

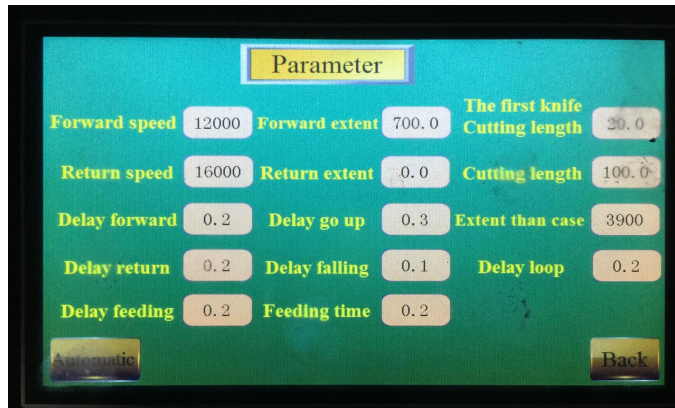
Back to the origin: move the pusher to the original place

Cutter ON/OFF: turn on or off the cutter during automatic mode

Conveyor ON/OFF: turn on or off the conveyor during automatic mode



Go to “Parameter” page



The first knife Cutting Length: First cutting length

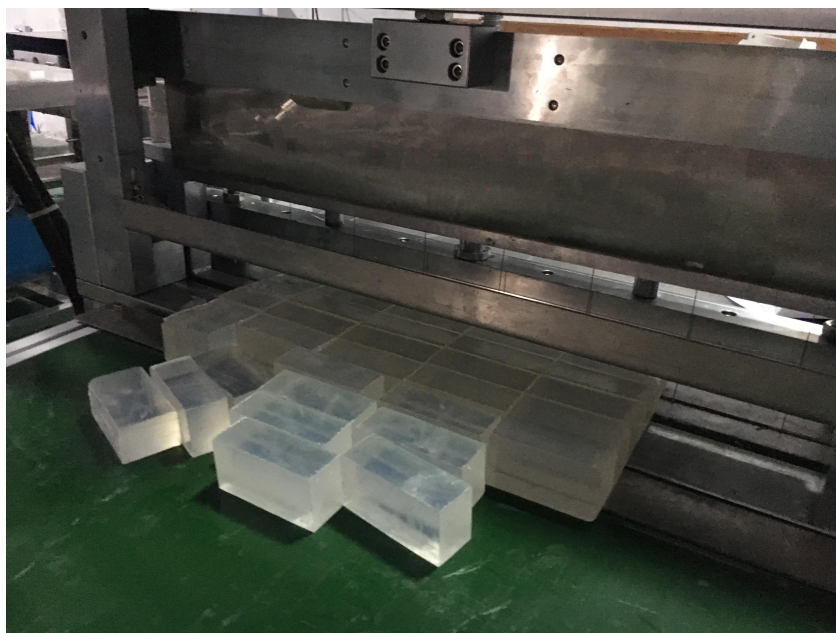
Cutting Length: Cutting length starting from second cut

****Please keep the rest parameter set as default, to be advised from engineer before change them****

2.7 Adjust the hand wheel position for flat knife



2.8 Restart hydraulic oil pump, then click “START” on Automatic Page to run the machine automatically.



2.9 Turn off the power if no production work

III. Maintenance

The machine operator must go through training before operate the machine. In order to make the best use of this machine, the operator must pay close attention to the operation of the machine during the machine is running and must have regular maintenance to the machine.

Maintenance on the following guidance:

1. Daily maintenance

Daily before start the machine

- 1) Before daily power-on, should check to see whether there is sundry, such as: wrench, screwdriver, etc
- 2) Observe the power supply, the power cord to see if there is any breakage.
- 3) Regularly Check and fix immediately if air path blocked or air leak on air path system connector

4) Check whether the Hydraulic oil is enough

Daily before get off work

Every day before get off work should shut off power supply, after confirmed the power has been disconnected then must to do the following work:

- 1) To clean the machine, use wet soft cloth to clean the soap then use the dry soft cloth to wipe the machine.
- 2) When wiping the machine, pay attention if there is a loose screw. The loose screw should be screwed tightly immediately.

2. Regular maintenance

Every year should do the maintenance for the machine, the transmission gear, and guide, clean-up dirty oil, coated with new oil.

IV. Transport considerations

1. Pay attention to the center of gravity of the machine while hoisting, to prevent the damage of machine caused by the wooden box tipping over.
2. The machine should be fixed by ropes during transportation, and rain proofing measures should be taken.

V. Common problem analysis

Phenomenon	Reason	Solution
Steel wire snapped	Used for long time	Change to new Steel wire