

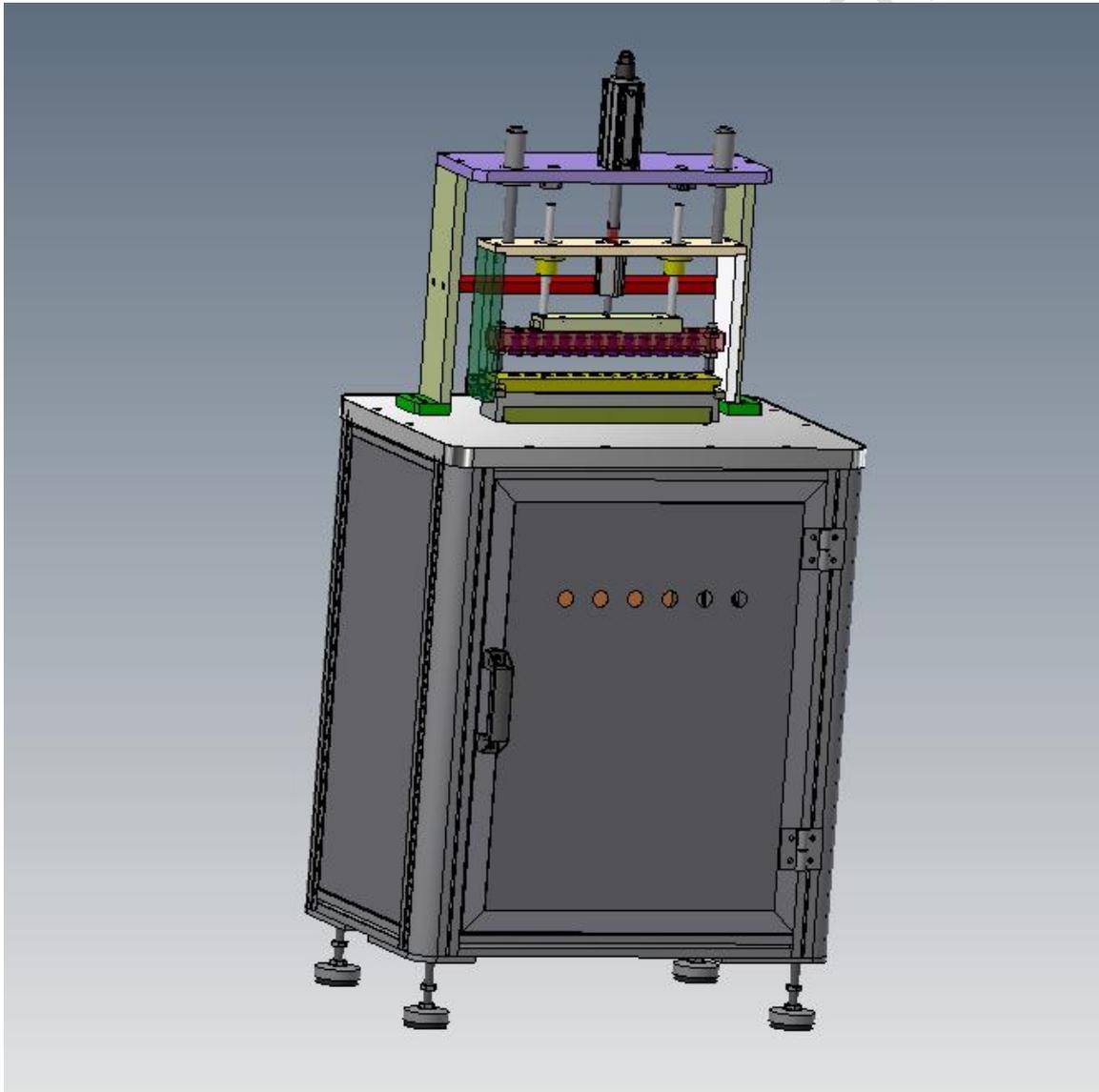


Vacuum Stripping Machine

Operation Instructions

Preface

We are very grateful to your trust and care! For you to know more about the characteristics and functions of the operation, repair, maintenance and consumables, we issued this Operation Instructions to help you to operate the machine smoothly in the future work. If any words failed to express the meaning or did not read smoothly, we hope you will not stint your criticism, we will sincerely accept and improve it.



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I、 Operation and Safety Precautions

Safety Precautions

1. Before operating the machine, the operator must read to understand the operation instructions and safety precautions.
2. Only the professionals who know the machine and familiarize with the risk and rule of the machine can repair it.
3. When the machine is running, prohibit change or adjust the components and related units.
4. Only professional engineering staff can carry out maintenance and service
5. Prohibit collide the electrical equipment in the control area to prevent damage.
6. Prohibit remove the safety warning symbol from the machine.
7. Prohibit damage the safety switch on the machine or change its functions.
8. The safety door must be closed at any time.
9. The main switch must be shut off if the machine is not operating.
10. All persons not install or repair the machine must move 1.5m away when installing or repairing the machine.
11. Prohibit non-professional electric control person to randomly adjust the equipment in the control cabinet.
12. Make sure to connect the correct voltage (1PH, AC220V, 55A, 50 / 60HZ), and confirm the machine is grounding, then connect to the air pressure source and adjust the pressure to 5~6kg/cm²

Operation Precautions

1. Only to operate the machine after completely knew the equipment safety protection rules.
2. Must guarantee that no danger to all people around the machine before starting up the machine.
3. Prohibit operate the machine in case the operator's body or tools were wet.
4. Please do not touch any action parts to avoid danger.

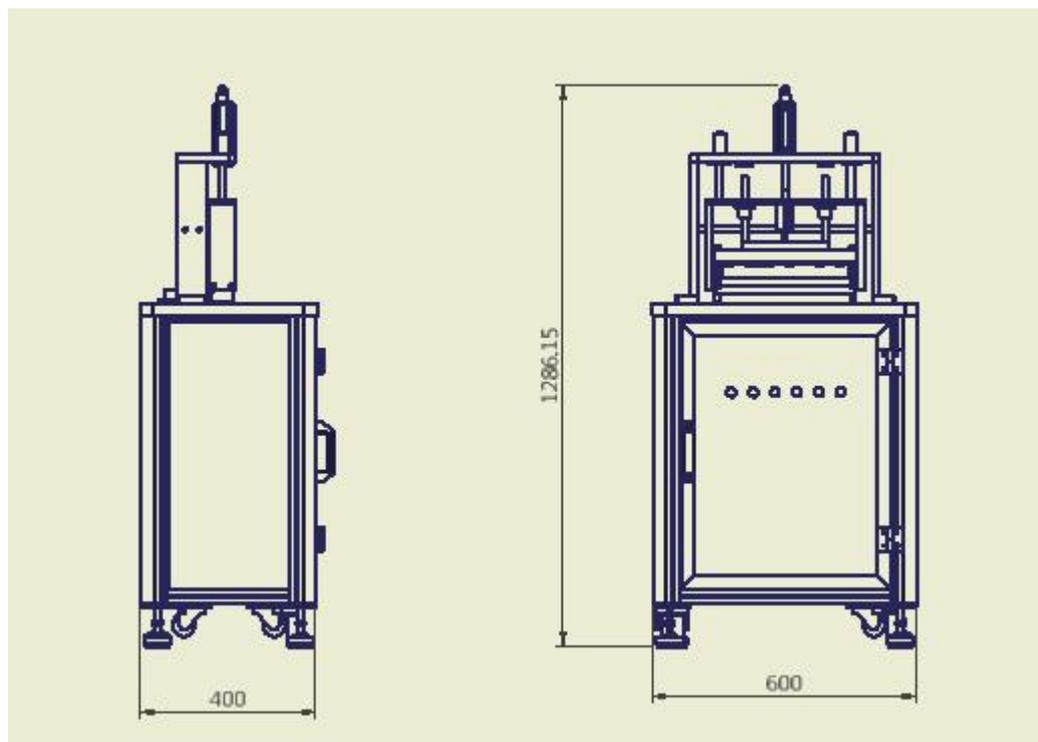
II、 Applications

Vacuum stripping machine is mainly used for silicone lipstick mold.

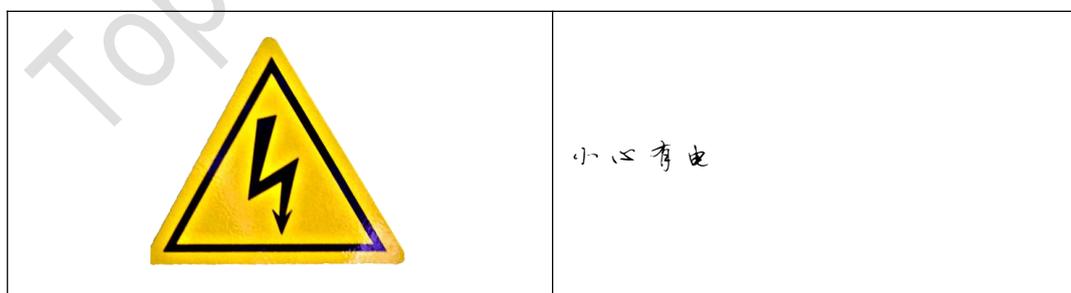
III、 Specification

	Specification	Value
1	Dimension	40×60×128cm(L×W×H)
2	Power Supply	1PH .220Vac. 10A.50/60HZ
3	Peripheral Equipment	1 PH. 220Vac
4	Power Consumption	300W
5	Air Pressure	5~6 kg/cm ²
6	Noise Level	Below 65db(A)

Mechanical Dimension



IV、 Safety Warning Symbol



V、 Environmental Conditions

1. Mechanical environmental temperature should be 0~40°C.
2. The machine should be avoided from dusty polluted environment.
3. The machine should be avoided in a corrosive space.
4. Please do not install the machine in a place with an explosive hazard.
5. The machine should be placed in a well ventilated place.

VI、 Delivery Method

In order to avoiding the machine damaged during the delivery, the machine is packed in wooden box before leaving the manufacturer's factory. After the machine is arrived, please unload and transfer it as below:

Unload the machine from the wooden box to the ground by forklift. If the machine has no wheels, transfer it by forklift.

VII、 Installation Method

1. Confirmation before Installation (Please accompany the engineering staff)

1-1 To check and confirm whether the installation place meets the requirements of Environmental Conditions.

1-2 To check and confirm from the machine specifications. Confirm the power supply, air source supply is in appropriate place(The air source supply may be too far, but the power line is not long enough or the power line might be trampled and tripped by people because the power line goes through the aisle space)

	Specification	Supply by Customer
Power Supply	1PH 220Vac 55A	◎Use 2P 55A breaker ◎Use quick connector ◎Use voltage changer
Air Pressure	5~6 kg/cm ²	Air compressor or pipe valve

2.Installation Steps

2-1 Start to install the machine after above confirmation. Firstly lock the machine's shock feet(4).Please place the machine horizontally.

2-2 check the machine and turn shock feet down, and place the machine horizontally.Use the level instrument to measure the level, to adjust the shock feet to place the machine horizontally,then lock the nut of shock feet(4).

3. Installation Precautions

3-1 Please pay attention to the length of power line when installing the power supply.

3-2 Use standard power supply breaker which mentioned in machine specifications, avoid to loss the protection function of power supply breaker.

3-3 If use quick connector for the power supply, It is necessary to lock the screws

when making the plug. And confirm again that its shunt power supply of quick socket overload protector capacity is enough.

3-4 If the power supply is from a voltage changer, then please make sure that the capacity of the voltage changer is sufficient, especially when it connected with other equipment(s).

3-5 If the power supplied by a generator(s), please measure the power supply situation when the machine is running and record the number of the generator(s)(which supply power to the machine).

3-6 Please get to know and record the power consumption of the machine and the stability of the power supply. It is not recommended to run the machine if the voltage exceeds $\pm 10\%$, in order to avoid burning the device components. Suggest that to install the voltage stabilizer and inform our company.

3-7 Turn the power breaker OFF when connect to the connection of wires and pay attention to their own safety. Do not operate the machine when your body is wet or your mental state is poor. The terminal screws on the power breaker must be locked well.

3-8 Note that the grounding wire must be connected to the factory grounding system and the ground terminal screws are locked.

3-9 Power supply switch of the machine must be turned OFF before the power supplied, to avoid unpredictable danger.

3-10 Pull down the Sliding relief valve to relief pressure before air pressure supplied, to avoid unpredictable danger.

4. Air pressure source and power supply installation



(VII-4-1)

1PH 220VAC 55A



(VII-4-2)

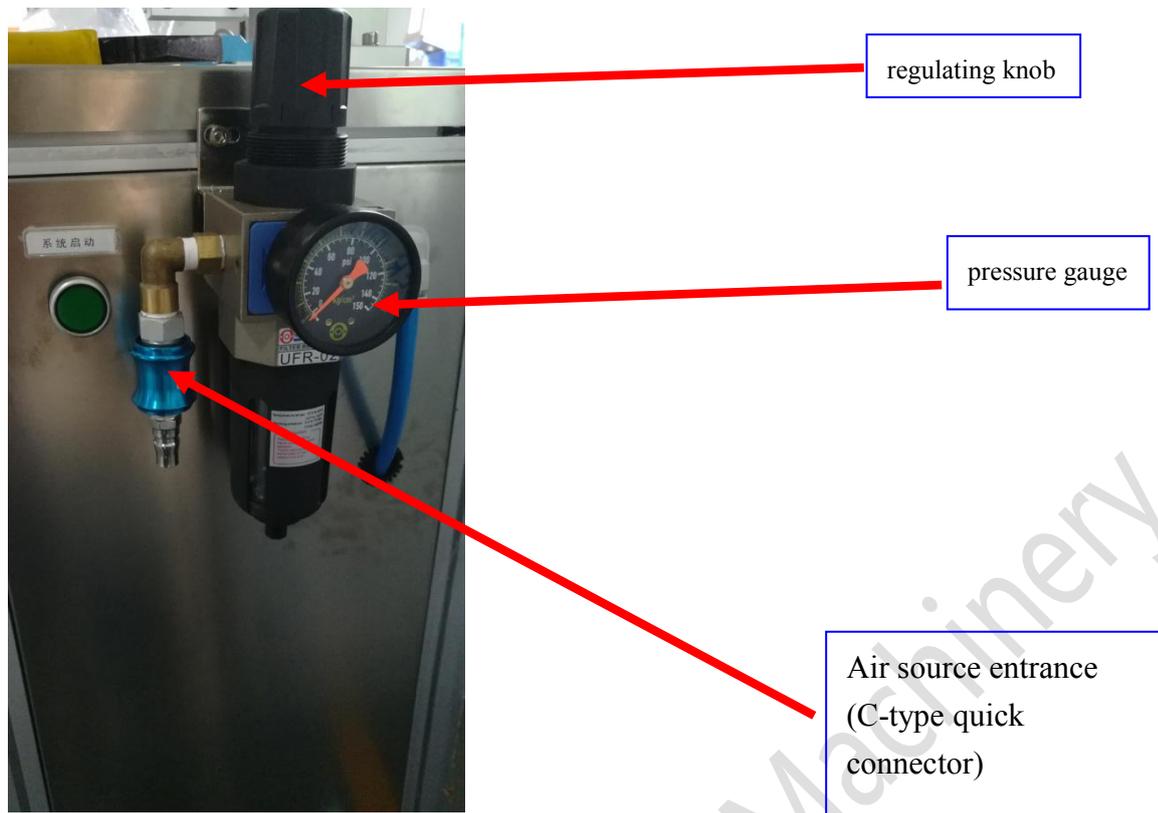
4-1 Adjust aire pressure

4-1-1 Air pressure source of this machine, such as the green line marked in the picture (VII-4-1).

4-1-2 Connect the air pressure source to the C-type quick connector located on the left side of the machine (VII-4-3).

4-1-3 Adjust the pressure regulating knob. Adjust the needle to 5~6kg/cm² on the pressure gauge. ;Pressure regulating knob must be pulled up to rotate, increase pressure by clockwise rotation or decrease pressure by anticlockwise rotation.

4-1-4 After adjusted the pressure, please press down the pressure regulating knob.



(VII-4-3)

4-2 Power supply installation

4-2-1 The power connection of the machine as shown in the diagram(VII-4-X).Red is power supply;green is air pressure source supply.

4-2-2 Bring the power line of the machine to the power supply place and be ready to install power supply.Turn OFF the power from the power supply breaker before install power supply.

4-2-3 Turn ON the power from the power supply breaker after power supply installed.

4-2-4 Turn ON the main power switch of the machine, pay attention to the safety of personnel before give the air pressure. Check all emergency stop switches to be unlocked.

VIII、 Electrical control & Operation Instructions

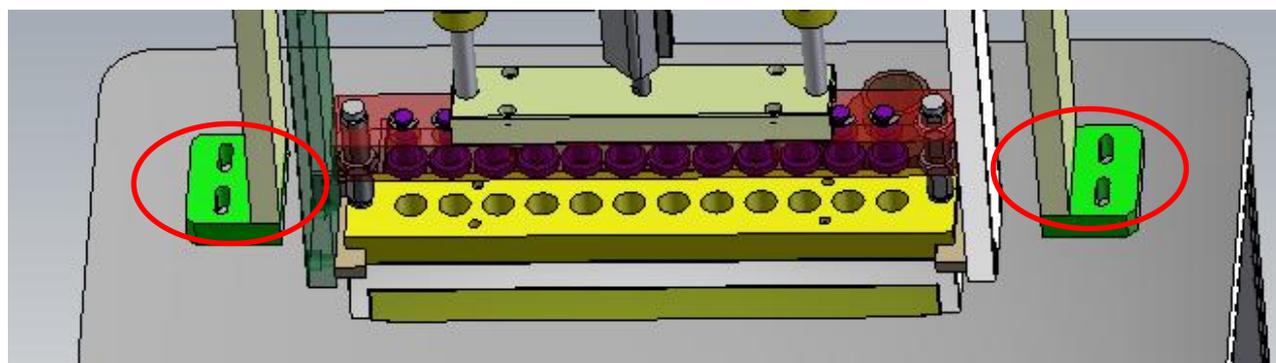
Before operating the machine, please read the Electrical control & operation instructions as below:

After turn on the **Power Switch**, the green Power indicator lights up, the machine is on start state.



A1	Power Switch	To turn the Power on or off
A2	Power Indicator	Indicates whether the machine is powered on
A3	Auto/Manual	Set the system to automatic mode, when the vacuum nozzles and mold in place, the Pressing, Vacuum and Lifting will be a coherent. Set the system to manual mode, the Pressing, Vacuum and Lifting will be controlled by the manual switches, use these A4,A6,A5 switches to control the machine step by step.
A4	Manual Pressing	Auto/Manual compression moulding switch
A5	Manual Lifting	Auto/Manual lifting switch
A6	Manual Vacuum	Auto/Manual vacuum switch

IX、 Mechanical Adjustment



Loosen the parts in the circle shown above, move the mechanism back and forth to adjust until the gland needle pusher is aligned with the vacuum mold holder.

X、 Simple troubleshooting of the machine

(Supply for 1PH 220V 60HZ power, 5~6kg/cm² air pressure)

Issue	Possible Cause	Fixes
1. No power supply	<ol style="list-style-type: none"> 1. Check if the main switch was OFF. 2.If the fuse of the major loop good or not. 	<ol style="list-style-type: none"> 1. Check the main switch. 2. Change a new one if burned out.
2. After selected AUTO, but no action, or stop at an action.	<ol style="list-style-type: none"> 1. Fuse burned 2. Relay is not working 3. Solenoid valve coil faulted. 4. Air Pressue source not connected 	<ol style="list-style-type: none"> 1. Replace 2. Replace 3. Replace 4. Connect Air Pressue source
3. No action for cylinder	<ol style="list-style-type: none"> 1.Air Pressue source not connected 2.Solenoid valve faulted. 3.the pressure regulating valve turned to the minimum 4.The cylinder leaks 	<ol style="list-style-type: none"> 1.Connect Air Pressue source 2. Fix or Replace 3.Adjust to the requied standard air pressure 4.Fix or replace cylinder

XI、 Maintenance and Clean

To make the machine run smoothly and extend its life, maintenance must be done as below requirements. Before the maintenance and clean, please shut off the power supply and exhaust air pressure:

Daily Maintenance:

1. Keep the machine clean.
2. Keep the bucket and the nozzle clean at all times

Weekly Maintenance:

1. Regularly check if the screws loosed or not, tighten it if yes.
2. Check the connecting control wire, broken/bare wire is prohibited.

****Attention****

Please make dry treatment for air source to avoid influencing the machine's life.

Enclosure 1 : Fragile Parts

Name	Numbers	Model
O-Ring	12	OP-18

Notice: The life of the O-ring is determined by the frequency use of the O-ring, it should be taken to prevent from scratching or damaging when installing the O-ring.

Enclosure 2 - Photo of Pneumatic system

