

MODEL JH01 STRAW MAKING MACHINE

JH make aircrew to make beverage form a complete set in the aircrew by suction by 01 series of beverage suction, adopt the polypropylene (P.P) for the raw material, can produce colourless, monochromatic, double-colored, three beverage suction, it is a comparatively advanced beverage suction.

This aircrew is pushed is pushed out of machine, vacuum and finalize the design and cool the device, draw and cut device, switch board of circuit, air compressor, etc, to form partly mainly.

The main performance parameter is the following;

MODEL	JH01-250		
Feature	Material		P.P
	Color		2
	Product dia	(mm)	4—6
	Product length	(mm)	10--500
Extruder	Motor	Kw	VS7.5
	Heater caucity	Kw	13
	Speed control		Inverter
	Automatic	Set	
	Heating zones		8
Cooling set			3.5m cold water tank
Take up & cutting unit	Motor	Kw	VS0.75*2
Other	Air compressortotal electric	Kw	VS1.5
	Use power	Kw	25
	Machine weight	Ton	1.5
	Dimension	W*L(m)	2*10
	power		380V 50Hz

Composition

1. The structure is simple, it is convenient to operate it, the automatic degree is high, it is reliable to run steadily, production efficiency is high.
2. Pushed out of machine main one and adopted 38 CrMoLu hight quality alloy and made and carried on nitrogen ization to deal with.
3. Water troughs, hopper all adopt 1Cr18Ni9Ti stainless steel board to make, the hygiene is beautiful.
4. Adopt high to integrate warm to accuse of components and parts to finding machine control steadily by temperature.
5. Have output to count functions, can report to the police in batches.

I Push out of the machine and electric switch board

1. Push out of the machine

Push out of the sketch of machine as picture 2 shows, main organic body, urge equipment, transmission and change speed systematic pushing system, mouthfuls of mould, automatic to accuse of, atmospheric pressure regulate system, machine section of thick bamboo move and regulate system system, etc, form partly while being warm, push and adopt the pole structure of three spiral shells systematically, the middle is a main spiral shell's pole, both sides are a pair of spiral shells' poles.

2. The structure of the whole part of electric heat of machine

The structure of the whole part of electric heat of machine consists of ten districts, it is as picture 3 shows distributed. Among them:

- A: the first part of machine section of thick bamboo A (A1)
- B: the second part of machine section of thick bamboo A (A2)
- C: the first part of machine section of thick bamboo B (B1)
- D: the first part of the elbow of machine section of thick bamboo B (B2)
- E: the second part of the elbow of machine section of thick bamboo B (B3)
- F: the first part of machine section of thick bamboo C (C1)
- G: the first part of the elbow of machine section of thick bamboo C (C2)
- H: the second part of the elbow of machine section of thick bamboo (C3)
- I: the host computer head (a the first 1 moulds)
- J: the moulds head (the first 2 of mould)

3. Electric switch board

The electric switched board is systematic by the energy supply mainly, adjust several parts, such as systematic and automatic temperature control system of the speed, etc, to form.

Its automaticallies control the work of pushing the machine out of mainly, it is in steady job temperature throughout to enable pushing out of the machine; stepless speed regulation, make and find material can stabilized, even; control the vacuum at the same time and finalize the design and cool the operation of the vacuum pump of the device, and is drawn and cut the device and offer the power.

Showing and operate symbols to see picture 4 of electric switch board

Picture 4 the electric switch board operates a panel of sketch

- 1) Switch
- 2) Power indicator lamp

- 3) Air compressor switch
- 4) Indicator lamp of air compressor
- 5) Pump switch of vacuum
- 6) Indicator lamp of vacuum
- 7) Motor of main spiral shell pole A is started
- 8) Motor of main spiral shell pole A stops
- 9) Governor switch of main spiral shell pole A
- 10) Speed is set up (A)
- 11) Rotational speed form (A)
- 16) The arrival of pole B of a pair of spiral shells and C
- 17) The stopping of pole B and C of a pair of spiral shells
- 18) Speed is set up
- 19) Rotational speed form (B, C)
- 20) The switch of the temperature controller of the first part of main spiral shell pole A
- 21) The job instruction of heating the loop of the first part of main spiral shell pole A
- 22) The temperature controller of the loop of the first part of main spiral shell pole A
- 23) The switch of the temperature controller of the second part of main spiral shell pole A
- 24) The job instruction of heating the loop of the second part of main spiral shell pole A
- 25) The temperature controller of the loop of the second part of main spiral shell pole A
- 26) The switch of the temperature controller of the first part of pole B of spiral shell
- 27) The job instruction of heating the loop of the first part of pole B of spiral shell
- 28) The temperature controller of the loop of the first part of pole B of spiral shell
- 29) The switch of the temperature controller of the second part of pole B of spiral shell
- 30) The job instruction of heating the loop of the second part of pole B of spiral shell
- 31) The temperature controller of the loop of the second part of pole B of spiral shell
- 32) The switch of the temperature controller of the third part of pole B of spiral shell
- 33) The job instruction of heating the loop of the third part of pole B of spiral shell
- 34) The temperature controller of the loop of the third part of pole B of spiral shell
- 35) The switch of the temperature controller of the first part of pole C of spiral shell
- 36) The job instruction of heating the loop of the first part of pole C of spiral shell
- 37) The temperature controller of the loop of the first part of pole C of spiral shell
- 38) The switch of the temperature controller of the second part of pole C of spiral shell
- 39) The job instruction of heating the loop of the second part of pole C of spiral shell
- 40) The temperature controller of the loop of the second part of pole C of spiral shell
- 41) The switch of the temperature controller of the third part of pole C of spiral shell
- 42) The job instruction of heating the loop of the third part of pole C of spiral shell
- 43) The temperature controller of the loop of the third part of pole C of spiral shell
- 44) The switch of the temperature controller of the first part of the mould head (a the first moulds)
- 45) The job instruction of heating the loop of the first part of the mould head
- 46) The temperature controller of the loop of the mould head
- 47) The switch of the temperature controller of the second part of the mould head (the second moulds)
- 48) The job instruction of heating the loop of the second part of the mould head
- 49) The temperature controller of the loop of the second part of the mould head

II The vacuum finalizes the design and the device

The vacuum finalizes the design and cooled the device to finalize the design by seat shelf, vacuum mainly device, cooling water trough and vacuum pump form, see picture 5.

Picture 5 the vacuum finalizes the design and cool the sketch of the device

While pursueing:

- A: Take shaped moulds ----- make the material take shape
- B: The vacuum finalizes the design to manage
- C: In charge of steadily ----- make tubes transmit steady
- D: The water level is automatic
- E: Produce water valve
- F: Regular nut ----- the box is covered to finalize the design regularly
- G: Vacuum form
- H: Regulate the valve ----- control the vacuum pressure

III The device drawn and cut

Draw, device that cut mainly at seat shelf, unit of drawing cut, transmission change speed systematic unit operating and finish standing see picture 6.

1. Drawing the unit, like picture 6. Among them:

- A: The handwheel ----- regulate the glue roller interval
- B: The interval ----- it makes tube regulate through handwheel in normal cases, glue should insert the urgent tube by roller.
- C: Blow the angry switch ----- in tube dry up the waters of tube in front of glue roller.

2. Cutting the unit, like picture 6. among them;
D: The length regulates the handwheel ---- if the clockwise rotation, the length of the tube is strengthened; opposite on the contrary. (Be careful: regulate when only start shooting).
E: Cover the shell. F: Back to knife one. G: Cut the knife. H: Support set
Be careful: 1) picture I means that the head of the suction is cut into an inclined plane.
2) picture II means that the head of the suction is cut into perpendicular one.
3. Operating the station, like picture 6, among them;
I: Switch. J: Power indicator lamp. R: Arrival. L: Stop. M: Adjust the speed knob
N: Rotational speed form. O: Counter. P: Buzzer. Q: Insurance

IV Installation

Please read one and does not install until after the content of four chapters care fully.

1. Installation
 - 1) Show according to 1 picture, put rig up in place. Usually situation find and intervals between the mould 100mm shaping the mouthfuls of moulds of machine, it is 2000mm that the device and vacuum drawn and cut finalize the design and cool the interval between the device.
 - 2) Installation require the ground to be levelled and firm at the equipment. Should not be moved after rig up and vibration.
 - 3) Find and vacuum finalize the design device and draw and show installing with device that cut according to 1 picture that cool the machines of material.
2. Join (join according to 1 interface grade shown of picture)
 - 1) Circuit
 - a) Receive the cable of the electric switch board in the switching box of the tricolor staw machine in proper order according to the electric wire grade.
 - b) Lead the power into the electric switch board according to the electric principle picture (1 of figure). The power is 380V, 50Hz.
 - c) The thread inserts the electric switch board to draw the power of the air compressor and vacuum pump.
 - d) The power that the electricity that will draw and cut the device accuses of the box draws threads and insert in the switch.
 - 2) Waterway
Find to cool as can have been as entering water mouth or produce ink mouth machine.
Device and water Bonce C, D of the device drawn and cut that the vacuum finalizes the design and cools are joined on request.
Be careful: the pressure of entering water totally >2P
 - 3) Angry way
 - a) At to give vent to anger F once link with air inlet E of the relief pressure valve air compressor.
 - b) At to give to anger mouthfuls of G with blowing angry to connect H link to each other air compressor.
3. Measuring

- 1) Circuit. Checks the wiring position and cable and keeps in touch well according to the principle picture of the electric apparatus.
- 2) Check temperature control system (temperature the detailed the detailed working techniques of controller see temperature the manual of controller)
 - a) Open the switch, and turn on the switch of the temperature controller one by one.
 - b) The settling of temperature in order to rise sparingly.
 - c) Temperature control measure begin form machine section of thick bamboo A, test progressively.
 - d) After beginning to heat, watch the instruction of indicator lamp.

Please check carefully, take care of electric shock!

- 1) The rotation direction of the motor
 - a) Main motor

Fasten the switch to ON's position, push 7 arrival switch of the motor of the main spiral shell's pole more (pay attention to not opening to adjust the speed switch). Check the rotation direction of the motor, should be unanimous with the direction of the arrow point that is labelled on the motor, if inconsistent, please change to connect the power thread of the main motor, make its rotatory direction keep the same with direction of the arrow point.

- b) The motor of the vacuum pump

Fasten the switch to ON's position, push 5 of arrival switch of the vacuum pump more, check the rotation direction of the motor of the vacuum pump, should be unanimous with the direction of the arrow point that is labelled on the motor, if inconsistent, the power that please change to connect the vacuum pump draws threads.

V Production operational procedure

1. Open the switch, settle temperature of heating
 - 1) A1 (The first part of machine section of thick bamboo A). Temperature 200°C.
 - 2) A2 (The second part of machine section of thick bamboo A). Temperature 215°C.
 - 3) B1 (The first part of machine section of thick bamboo B). Temperature 200°C.
 - 4) B2 (The second part of machine section of thick bamboo B). Temperature 210°C.
 - 5) B3 (The third part of machine section of thick bamboo B). Temperature 215°C.
 - 6) C1 (The first part of machine section of thick bamboo C). Temperature 200°C.
 - 7) C2 (The second part of machine section of thick bamboo C). Temperature 210°C.
 - 8) C3 (The third part of machine section of thick bamboo C). Temperature 215°C.
 - 9) M1 (The first part of the mould head)
 - 10) M2 (The second part of the mould head)

Be careful: the settling value of above –mentioned temperature is only for reference, some factors will influence and change temperature, such as weather, material, etc.

Please find out the rational value that settles temperature in the real work.

(Usually the time above-mentioned temperature that will be settled. If heat for a long time and has not still reached and settle temperature value, please check the system of heating normally, such as heat and enclose and damage, the temperature sensor keeps in touch bad or damages ly.)

2. Start the equipment

In temperature reach person who settle, at air compressor and machine of finding and draw and start with device that cut at the same time, it maintains 300~450rpm to cut the speed that is in charge of, adjust the main spiral shell's rotational speed of pole in 350~450rpm, adjust the vice spiral shell's rotational speed of pole in 300~350rpm, open the valve of the hopper at the same time.

Be careful: temperature has not reached the settling value, sure not to start spiral shell's pole!

3. Manufacture and guide managing

- 1) Make and guide and in charge of and take away steadily and at vacuum tube before innning charge of and close and enter water and enter angry.
- 2) Consulting picture 7, push out of material F and join through D, C, B, A hole with a tick of fine rule material. Then draw through A, B, C, D hole slowly, it finishes drawing detailed pieces of form relatively it is affective for conduct to guide, cut and bring up the rear, in charge of putting well steadily.

Be careful: after producing as a trial, manufacture and guide innning charge of this measure and needn't be done.

4. Manufacture the tube

- 1) By guiding and manage through D, C, B, A hole and push out of material F joining, then draw though A, B, C, D hole slowly.

It manufactures tube stage of beginning this important steps very, fail repeated to make odd times more, until it is skilled.

- 2) After finishing the work of 1): according to pursuing 8 main forces draw and arrive device that cut of drawing by tube, reach and cut and cut off partly by gyro wheel. (The black line part shows while pursuing that it is a suction).
- 3) Regulating the rotational speed of main spiral shell pole A, angry and enter water to regulate into at the same time, pays attention to flooding the suction, and can overflow.
- 4) Such as needing and make suction draw round, offer vacuum service pump and build urgent vacuums finalize the design the covers of device.

Be careful: it operates course challenge and cut and in charge of the speeds of device its in conformity with main spiral shell's pole tempo.

Picture 7 guide is in charge of the sketch map
Picture 8 manufacture the sketch map of the tube

5. Shut-down

- 1) Close spiral shell's pole at first, turn off temperature controller, the air compressor, vacuum pump again.
- 2) Cut off and draw and cut the power of the device.
- 3) Cut off the power of the electric switch board.

6. Change

1) The adjustment of a mould

Main spiral shells slow to find PP material pole, see instantaneous frank form that finds is if not frank, need to regulate A, B bolt. Show like 9 of picture and unclamp a bit and at the opposite bolt urgent to be careless bolt A, whether look straight again, have bolts with bolt A, B in four directions, suit well straight repeatedly.

2) Enter the adjustment of the tolerance.

a) The relief pressure valve is adjusted in the proper pressure. (0.2mp)

b) Base on the premise that the speed of production is not turned into, dam size and quality that the keeping in touch with amount of the valve (10 of the C pictures) will influence of the tube one-wayly, regulate carefully when operating.

3) The adjustment of the speed

Base on the premise that keeping in touch with amount and the speed drawn is not turned into, the rotation speed of spiral shell's pole will influence the wall of the suction thick.

Such as improving the speed of production, then the rotational speed of spiral shell's pole and speed drawn should be improved correspondingly, want to keep the diameter of the suction, the one-way keeping in touch with amount of damming the valve must increase.

4) Diameter of the tube, adjustment of the length, slang.

a) The diameter of the tube

The normal range is $\Phi 3 \sim \phi 6\text{mm}$; $< \phi 3\text{mm}, > \phi 6\text{mm}$ can be processed too, only need to change the mould head.

b) The length of the tube

The length of the tube has no grade to adjust, it is $2\text{mm} \sim \infty$

c) The slang of the tube

The slang of the tube is adjusted and sees the introduction in chapter four 2, have flat mouths and oblique mouths.

Picture 10 the sketh of the part of mould head

5) Unload the mould

Please unload the mould according to following measures. (Picture 10)

1. Unload the bolt here. 2. Unclamp the bolt of the seat of bearing remove a pair of spiral shell's pole device. 3. Unload and dam valve C. 4. Bolt D of panasonic. 5. Take away mould E once and mould body F. 6. Fetch and put interior mould G.

Be careful:

- a) Please unload the mould according to above-mentioned measures.
- b) It closes machine section of thick bamboo A1 and A2 of the temperature controllers the others are closed. If the core of the mould in not can'ting unload, can start main spiral shell pole A, the core of the mould withdraw in using forcing.
- c) The shut-down after the mould inclusive and other mould are unloaded.
- d) Clear up the mould at once, if the mould inclusive and other mould are unloaded the other mould, it is difficult too to remove the material at the same time.

These there is ranges of product ϕ 2~ ϕ 12mm, among them ϕ 2~ ϕ 4mm, ϕ 4~ ϕ 6mm, ϕ 6~ ϕ 9mm, the less separately adopt at ϕ 9~ ϕ 12mm, in , heavy, an enormous these the mould heads of the specification s, this machine usually disposes model's head of number in each, if there are special requirements, can consult with our factory.

VI Safeguard

1. Check various kinds of belts to put well in bringing the wheel.
2. Check the oil which moderates the case to mark, see the lubricating oil in the middle of the scales, generally change lubricating oil once in three months.
3. Drawing and cut the bearing of the device, the bearing in the vice machine seat of bearing should often check and the calcium base lubricating grease of note.
4. Pay attention to and ignore daily to maintain and maintain.
Please consult controller, counter.

V Installation, training, after-sale service guarantee

1. Installation, training
The request about the chapter go on when please consult the manual to install.
Can generally choose following schemes to train:

- 1) The user is sent staff to come to our factory to accept to train, after the equipment is transported, installation is taken care of oneself by the user.
- 2) Send someone from our factory to on-the-spot installation, and train the attendant. Last to send personnel travel charge at external users with, board and lodging expenses and try on expenses machine.

The domestic user can choose one of the above-mentioned two kinds of training schemes. Choose scheme one, the acceptances of user train whether and board and lodging expenses take care of oneself the travel charges of personnel, Our factory trains free. It chooses schemes our factory send whether and board and lodging expenses bear the travel charges of personnel by the user.

Choose the regulation in the purchase contract of any schemes.

2. The after-sale service in guarantee period of one year

The user please keep the connection with our factory after the equipment, reflect the operating position the equipment in time. Our factory will be responsible for maintaining maintain and change the spare part free according to guaranteeing the range following with in one year delivering;

- 1) On the damage that has already existed before unpacking, not including the damage caused by transport in the course. Be careful: confirm goods equipment, and when find by equipment it have issue of.
- 2) Operate according to the operational procedure, but the equipment turns round badly.
- 3) Influence and run well through own factor of the equipment, please reflect the detailed situation the sales department of our factory. Our factory will look the situation according to being guaranteed and be dealt with.

To the maintenance outside above range, our factory will charge as one sees fit.

3. Sell the service over one year of later stage

Equipment sell it exceeds to be paid services in one year, look situation collect certain fitting cost fee, maintenance personal travel charge and fee in man-hour.

The ones that bore to the products in our factory maintained the paid service all the life, by responsibility for the user.