

Upsetting Mill for Gold Coin



Voltage and frequency: AC220V, 50/60HZ

Power: 0.4kw

Air source: 0.4-0.6Mpa

Roller diameter: Φ 40mm

Product size: Φ 38.1X2.6 (customizable)

Forming speed: 12 pieces/min (frequency regulation)

Feeding method: manual feeding

Discharge method: automatic unloading

Weight: about 50kg

Dimensions: L600mm \times W560mm \times H450 (mm)

1. On-site environmental requirements

Ambient temperature:0~45°C

Relative humidity:20~90%RH

Power: 220V AC

Voltage fluctuation range:±10%

Frequency:50Hz

2. Parameter

Equipment size: length 560 X width 600 X height 440MM

Weight: 50KG

Equipment color: Lacquered silver, base plate anodized blue.

Power: 220V AC/50HZ

Main motor: YE3-110L1-4-370W

Reducer: RV90, reduction ratio 15

Wheel size: Diameter 40MM

Wheel handling: surface polishing

Mold processing finished product size: Diameter 38.2

Thickness 2.6MM

Control method:time relay + button

3. Installation and debugging

3.1、 The machine is placed on a solid foundation, the location should be far away from the source of the shock, avoid sunlight and heat radiation, and place it in a dry place to avoid the influence of humidity and airflow.

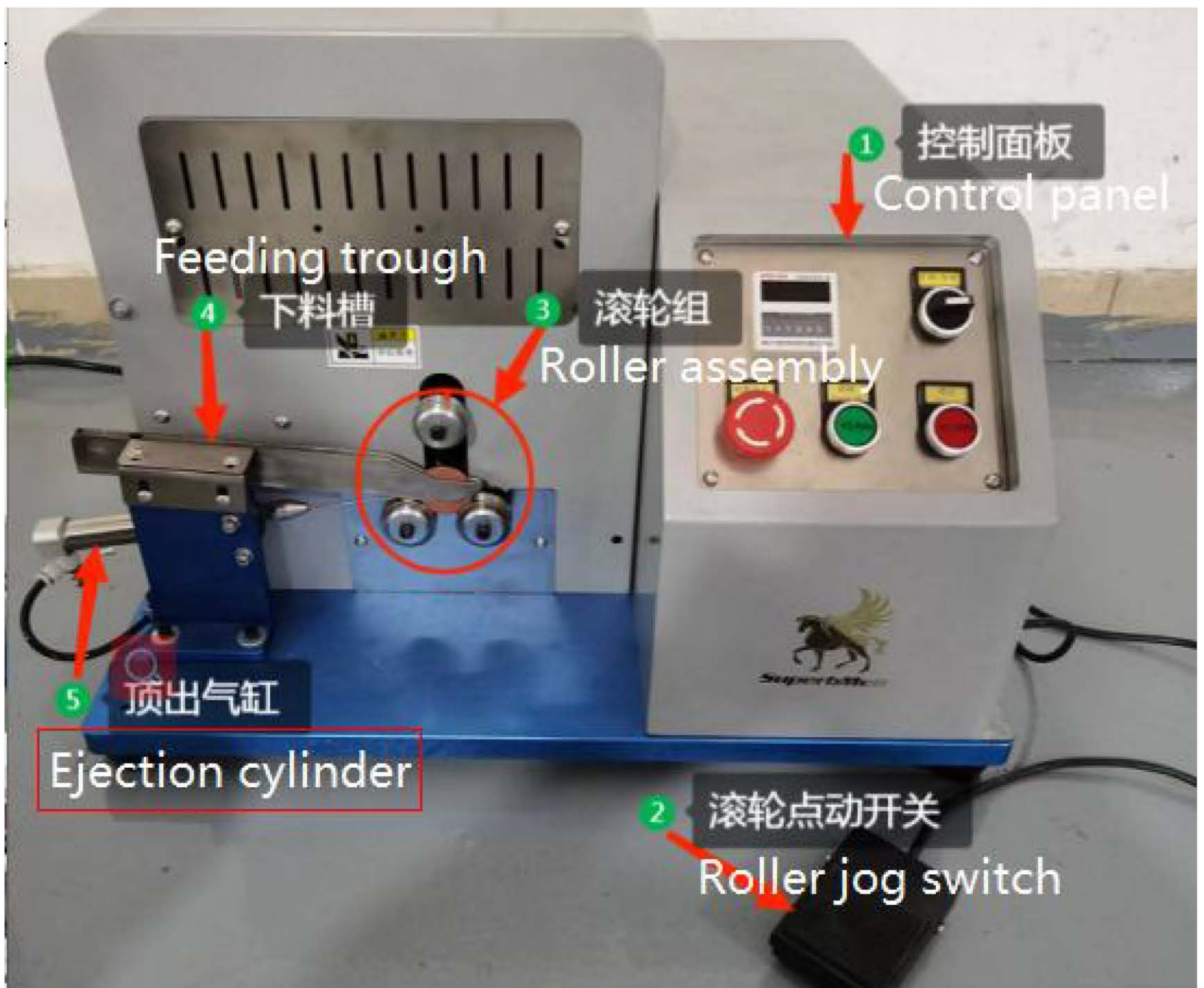
3.2 、 Check whether the switches and components in the

electrical control box are normal.

3.3、 Preparation before trial operation, check whether there are tools and other items on the machine, and whether all guards and protective devices are effective.

3.4、 The machine needs to connect compressed air: 6kgf/cm² (need to filter out water, oil, etc.) to the air pipe interface.

4. Machine function introduction



4.1 Control panel



4.1.1 Power switch: Control the power of the whole machine to cut off. Turn on.

4.1.2 Start switch :When the manual/automatic knob is switched to (automatic), the start switch is valid, press the whole machine to start the automatic cycle operation.

4.1.3 Stop switch. Press the switch to stop automatic operation.

4.1.4 Auto/Manual switch. Switch manual debugging mode. Switch automatic operation mode.

4.1.5 Time Relay



4.2 Roller jog switch: keep pressing the switch, the roller rotates, the automatic/manual switch is switched to (manual), and the cylinder starts to press down. Automatic/manual switch to (automatic) cylinder lift.

4.3 Roller assembly: 3 roller assemblies can be replaced according to different products.

(optional)

4.4 Feeding trough: The feeding trough can be replaced according to different products

(optional)

4.5 Ejection cylinder: The cylinder pushes out the product when unloading.

4.6 Roller speed adjustment panel (inverter panel)



5. Operation and Precautions

5.1、 Non-specified operators are not allowed to start the machine casually.

5.2 、 When the machine is not in use, turn off the power of the machine.

5.3 、 The operator must be familiar with the structure, performance and transmission system of the machine tool, lubrication parts, electrical and other basic knowledge and use and maintenance methods. The operator must pass the examination before operating.

5.4 、 When the machine tool is abnormal, such as abnormal noise, smoke, vibration, odor, etc.,

It should be stopped immediately, and the relevant personnel should be checked and dealt with.

5.5 、 Do not leave the post when the machine is running. When it is necessary to leave the post, it must be stopped and the power supply must be cut off.

6. Daily maintenance and maintenance

6.1 、 Tools, cutting tools and work objects cannot be placed directly on the machine tool.

6.2 、 The environment must be kept clean and tidy, avoid too dry and wet, avoid too much dust, especially avoid corrosive gas, which will reduce the wear and corrosion of the surface of

the roller, prevent the damage of electrical components, and prolong the trouble-free running time of the machine tool.

effect.

6.3、 Check all parts of the machine regularly. The parts related to the safety of the equipment, such as the lubrication system and emergency stop button switch, need to be checked frequently to find problems in time and eliminate hidden dangers.

6.4、 Prevent the machine tool from running with faults. Once the equipment fails, especially the mechanical part, the processing should be stopped immediately, and the operation should be continued after analyzing the cause of the failure and solving it. It is forbidden to run the machine in a fault condition, otherwise it may cause serious damage to the equipment.