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灌装机培训确认单

Training Confirmation Listing of Automatic Insulating Glass Desiccant Filling Machine

由于不同设备所需要安装条件和工具不同，为提高工作效率，节省双方时间，特附《机器安装要求清单》一份。希望客户能给予配合，在我方技术人员到场之前准备好清单上所列条目，以便人员到位后可以立刻开展工作.谢谢您的合作！

Due to the different installation conditions and tools required by different equipment, in order to improve work efficiency and save time on both sides, a copy of the 《Machine Installation Requirements List》 is attached as below. We hope that the customer can cooperate and prepare the items listed on the list before the technicians arrive. So that the technicians can start working immediately after the arrival. Thank you for your cooperation!

请提供如下 Please provide as below:

1. 可以安装设备的场地,灌装机须视生产适当安排位置 Proper place where equipment can be installed,as the filling machine will be placed accordingly.
2. 提前将气源安装到位,气源要求: 需要 2-3 个接口 (气流量不低于 2000L/MIN。需要客户提供气管直径 12mm、10mm (气管长度是气源到机器的距离) Install the air source in place in advance, the air source requirements: 2-3 interfaces are required (the air flow is not less than 2000L/MIN. The customer needs to provide the tracheal diameter 12mm, 10mm (the length of the gas pipe is the distance from the gas source to the machine).
3. 提前安装电源, 要求 220V。 Install the power supply in advance, which requires 220V of voltage.
4. 调试机器用的铝框及丁基胶 Aluminum frame and butyl rubber for machine debugging.

第一部分：Section 1: 安装与调试 Installation&Debugging

目录 Content:

- 1.开关机的操作 Operation of the switch
- 2.触摸屏各个功能键的使用 Button on the touch screen
- 3.密封胶温度的设定 Sealing temperature setting
- 4.气钻位置的调节 Air drill position adjustment
- 5.钻头的更换方式 How to replace the drill bit
- 6.灌装挡板与封料刀片的配合方式 How to match the filling baffle with the sealing blade
- 7.灌装块的安装方式 How to install the filling block
- 8.灌装时间的调节 Filling time adjustment
- 9.密封胶位置的调整 Adjustment of sealing position
- 10.胶缸换胶的方式 Method of changing glue for glue cylinder
- 11.密封胶时间的调整 Adjustment of sealing time
- 12.灌装机的上升下降的使用 Use of filling machine's up and down
- 13.料桶上料的原理 The principle of feeding the barrel
- 14.料桶感应器的作用 The function of barrel sensor
- 15.电器元件的作用 The function electrical components
- 16.加热棒和热电偶的用途与检测 Application and Detection of heating rods and Thermocouples
- 17.每个感应器的作用 The role of each sensor
- 18.气缸和电磁阀的用途 Use of individual cylinders and solenoid valves

<p>培训内容 Training content: 安装与调试 Installation&Debugging</p>	<p>操作员签字 Signature of operator</p>	<p>主管签字 Signature of supervisor</p>
<p>1. 开关机的操作 operation of the switch: 打开电源 Turns on the power supply of the machine 打开急停开关—按下启动按钮 Turns on the emergency switch 检查文本控制器里的参数设定是否正确，等待胶缸温度达到设定值即可工作 Presses the start button to check that the parameters in the text controller are set correctly, and waits for the cylinder temperature to reach the set value</p>		
<p>2. 触摸屏功能键的使用 Buttons in touch screen: 返回按钮 Return button 报警按钮 Alarm button 向下翻页按钮 Page down button 向上翻页按钮 Page up button 向左翻页按钮 Page to the left 向右翻页按钮 Page to the right 设置按钮 Setting button 确定返回按钮 Confirm return button 数字输入区 Digital input area</p> <p>3. 密封胶温度的设定 Sealant temperature setting: 测量的实际温度显示区 measured actual temperature display area 温度设定值显示区 temperature setting display area 温度设置区 temperature setting area 向上调整按钮 rise up button 向下调整按钮 downward button</p>		

<p>4.气钻位置的调节:Adjustment of air drilling position 松开气钻座螺丝，调节螺丝调整气钻，可以调节气钻钻头里外位置，松开气钻压紧螺丝可以调节气钻上下位置。Loosen the air drill seat screw, adjust the screw to adjust the air drill, adjust the position inside and outside the air drill bit, and loosen the pneumatic drill compression screw to adjust the upper and lower positions of the air drill. 调节气钻转速调节螺丝可以调整气钻转速 Adjust the air drill speed adjustment screw to adjust the air drill speed</p>		
<p>5.钻头的更换方式 Replacement of drilling part: 用气钻钥匙松开，锁紧螺丝更换钻头，气钻移动气缸伸出时钻头伸出灌装挡板三四毫米左右即可 Loosen with the air drill key. Lock the screw to replace the drill bit. When the pneumatic drill moves the cylinder, the drill bit extends out of the filling baffle for about three or four millimeters.</p>		
<p>6. 灌装挡板与封料刀片的配合方式 How to match the filling baffle with the sealing blade: The filling board is connected to the filling block. The center is controlled by the pore molecular sieve on the filling switch board</p>		
<p>7. 灌装块的安装方式 Installation of filling blocks: 灌装块用两个螺丝连接到后座上，上面连接下料管，下面连接灌装板 The filling block is connected to the back seat by two screws, connected to the lower tube above and the filling board connected below</p>		
<p>8. 灌装时间的调节 Adjustment of the filling time: 用翻页键找到此页按 SET 选择需要调节的边长。通过数值设置键调节需要设置的时间 Find this page with the page turning key, press SET to select the length of the side that needs to be adjusted, and adjust the time to be set by setting the key numerically.</p>		
<p>9. 封胶位置的调整 Adjustment of sealing position: 前后调节螺丝可以调节封胶孔前后位置 Loose opening glue position before and after adjusting screw can adjust the front and rear position of the sealing hole. 上下调节螺丝可以调节上下封胶孔位置 Loose opening glue position up and down adjustment screw can adjust the position of upper and lower sealing holes</p>		

<p>左右调节螺丝可以调节左右密封胶孔位置 Loose opening glue position left and right adjustment screws can adjust the position of left and right sealing holes</p>		
<p>10. 胶缸换胶的方式 How to change the glue: 在文本显示器里有控制气缸伸缩的按键。丁基胶使用完毕后，操作箱上启动按钮的指示灯会熄灭，在文本显示器里点击推胶缸，将准备好的丁基胶放进胶缸预留孔里，点击推胶。 In the text display, there are keys to control the expansion and expansion of the cylinder. After the use of Ding Ji glue in the rubber cylinder, the indicator light of the start button on the operating box will go out. Click on the rubber cylinder in the text display. Put the prepared Ding Ji glue into the reserved hole in the rubber cylinder and click push glue.</p>		
<p>11. 密封胶时间的调整 Adjustment of sealing time: 用翻页键找到此页按 SET 选择需要调节的边长通过数值设置键调节需要设置的时间 Find this page with the page turning key, press SET to select the length of the side that needs to be adjusted, and adjust the time to be set by setting the key numerically</p>		
<p>12. 灌装机的上升和下降的使用 Use of the filling machine's up and down: 0 是手动上料 0 for manual loading 1 是上升 1 for up. 2 是下降 2 for down</p>		
<p>13.料桶上料的原理 The principle of feeding the desiccant: 工作前将小颗粒分子筛加入下料桶后将桶盖拧紧，需要加料时下料桶进气口的电磁阀工作气源进入下料桶，用气源压力将分子筛通过出料口吹进上料桶 Before work, the small particle molecular sieve was added to the feeding barrel, the lid of the barrel was tightened, and the solenoid valve working gas source of the inlet of the feeding barrel needed to be fed into the feeding drum, and the molecular sieve was blown into the barrel through the outlet with the pressure of the gas source.</p>		

<p>14.料桶感应器的作用 The use of drum's sensors: 上料桶的感应器，控制上料启动和停止。下限位感应器没有信号后开始上料，加满后上限位感应器有信号后停止加料 Feeding bucket of sensors, control the feeding starting and stopping. Lower limit sensor no signal after feeding, after a full cap of a sensor signal after stop charging</p>		
<p>15. 电器元件的作用 The uses of various electric elements: 直流 24V 开关电源 24 v dc switching power supply: 将交流 220V 电源转换成直流 24V 电源 ac 220 v power supply is converted into dc 24 v power supply 电源开关 Power switch:机器总电源开关 the total power switch machine 交流接触器 Ac contactor: 用于接通、分断线路、或频繁的控制电动机等设备运行 Used for breaking lines, or frequent switching control equipment such as motor running 固态继电器 Solid state relay:控制加热棒电源的通断 Control the heating power on and off PLC:程序控制器用于储存控制设备的程序 PLC controller is used to store control program of the equipment. 继电器 Relay:通过 PLC 的信号控制通断 Use the PLC signal control on and off</p>		
<p>16. 加热棒和热电偶的用途与检测 The use and testing of heating rods and thermocouple :</p>		
<p>17. 每个感应器的作用 The use of each sensor: 位置感应器 Position sensors:分别感应钻孔位置，灌筛位置，密封胶位置 induction drilling position respectively, screen location, sealant. 料桶感应器 Tank sensors: 检测分子筛的上下线 detecting molecular sieve from top to bottom line 磁性开关 Magnetic switches:检测胶缸里的胶量 detecting rubber cylinder in the rubber content</p>		
<p>18.各个气缸和电磁阀的用途 Use of individual cylinders and solenoid valves 详见说明书 See the instructions for details</p>		

第二部分 Section2:故障的排除与保养 Troubleshooting&Maintenance

目录 Content:

- 1.打孔位置偏的调节 Solution for the deviation of the drill hole
- 2.气钻不移动和不转动的调节.Solution for air drill's not moving and not spinning
- 3.气钻的保养 Maintenance of the air drill
- 4.灌装位置的调节.Adjustment of filling position
- 5.干燥剂灌不进或一边不进的的处理 Solution for desiccant not being filled either one side or both sides
- 6.漏干燥剂的处理 Solution for the leakage of desiccant
- 7.灌装孔和灌装块干燥剂凝固的处理 Solution for solidification of desiccant and filling block desiccant
- 8.灌装插板不抽动的处理 Solution for filling board not moving
- 9.封胶位置的调节 Adjustment of the sealing position
- 10.无法封胶或出胶量少的处理 Sealing without or too little of glue
- 11.胶缸漏胶的处理 Solution for glue leakage of glue cylinder

12.出胶块和胶桶的清理方式 Cleaning method of glue block and glue barrel

13.灌装上升不动作的处理 Filling up and not moving

14.料桶不上料和上料慢的处理 Solution for not or too slow of loading the desiccant

15.设备启动不工作的处理 Solution for equipment not working

16.温度不加热的处理 Solution for not heating

17.气缸电磁阀的保养 Maintenance of cylinder solenoid valve

18.机头部分保养 Machine head maintenance

<p style="text-align: center;">培训内容 Training content: 故障的排除与保养 Troubleshooting、Maintenance</p>	<p style="text-align: center;">操作员签字 Operator's signature</p>	<p style="text-align: center;">主管签字 Signature of supervisor</p>
<p>1. 打孔位置偏移的调节 Solution for the deviation of the drill hole: 钻孔位置不在铝条中间时可以通过铝条夹紧座调节 When the drilling position is not in the middle of the aluminum strip, it can be adjusted by the aluminum strip clamping seat.</p>		
<p>2. 气钻不移动和不转动的调节 Solution for air drill's not moving and not spinning:</p> <p>① 气钻不移动: 检查移动气缸是否动作正常, 是否有卡住的情况 For not moving ,check if the cylinder is stuck</p> <p>② 气钻不转动: 检查气源是否正常, 检查气钻转速调节螺丝 For not spinning,check the air drill speed adjustment screw</p> <p>③ 气钻过滤网是否堵塞 Check if the air drill filter is blocked</p>		
<p>3.气钻的保养 Maintenance of the air drill:</p> <p>转动时动力不足 Insufficient power when the air drill turns</p> <p>① 气源调整螺丝可以调整气钻转速 Adjust the air drill air supply adjustment screw to adjust the air drill speed.</p> <p>② 拆开过滤网螺丝可以清理污渍, 防止气源堵塞 Disassemble the filter screw to clean the stain and prevent the air source from being blocked.</p>		
<p>4.灌装位置的调节 Adjustment of filling position: 夹紧座可以左右调节, 调节铝条处在压紧的中间位置 防止左右两侧不均匀 The clamping seat can be adjusted left and right to adjust the aluminum strip in the middle of the compression to prevent unevenness on the left and right sides.</p>		

<p>5.干燥剂灌不进或一边不进的的处理 Solution for desiccant not being filled either one side or both sides:</p> <p>① 检查开关板是否动作正常 Check if the switch board works well</p> <p>② 检查灌装孔是否有分子筛结块, 是否堵塞 Check if the filling hole is blocked by molecular sieve agglomeration</p> <p>③ 检查灌装孔与灌装开关板的孔是否对正 Check if the holes in the filling hole and the filling switch board are aligned</p>		
<p>6. 漏干燥剂的处理 Solution for the leakage of desiccant: 检查铝条两侧间隙是否均匀, 是否有一边松一边紧的情况 Check if the gap between the two sides of the aluminum strip is even, and if there is a loose side</p>		
<p>7. 灌装孔和灌装块干燥剂凝固的处理 Solution for solidification of desiccant and filling block desiccant: 用细铁丝清理灌装孔, 如果凝固的太硬就需要将灌装块拆卸下来清理干净 Clean the filling hole with a thin wire. If the solidification is too hard, the filling block needs to be removed and cleaned</p>		
<p>8. 灌装插板不抽动的处理 Treatment for Filling board without twitching: 将气缸固定螺丝松开, 手动控制气缸伸缩, 等到气缸灵活伸缩时固定住气缸 Loosen the cylinder fixing screw and manually control the cylinder to expand and contract, and wait until the cylinder flexes and retracts to fix the cylinder</p>		
<p>9. 封胶位置的调节 Adjustment of the sealing position: 封胶位置前后左右上下分别由螺丝控制 sealing position controlled by screws</p>		
<p>10.无法封胶或封胶出胶量少的处理 Sealing without or too little of glue</p> <p>① 检查胶的温度是否正常 Check if the temperature of the glue is normal</p> <p>② 检查推胶压力大小 Check the pressure of the push glue</p> <p>③ 检查出胶孔是否有堵塞的现象 Check if the rubber hole is clogged</p> <p>④ 检查封胶气缸动作是否正常 Check if the sealing cylinder is working properly</p>		

<p>11.胶缸漏胶的处理 Rubber cylinder leakage treatment: 检查推胶活塞及密封圈是否磨损 Check if the pusher piston and seal are worn 检查胶缸内壁是否划伤 Check if the inner wall of the cylinder is scratched</p>		
<p>12.出胶块和胶桶的清理 Solution for Cleaning method of glue block and glue barrel: 将出胶块拆开用煤油清理干净 Disassemble the rubber block and clean it with kerosene 加热后加大推胶压力将胶桶内挤干净, 用煤油清理干净 After heating, increase the pushing pressure and squeeze the inside of the plastic barrel to clean it with kerosene.</p>		
<p>13.灌装上升不动作的处理 Solution for Filling up and not moving: 检查气源压力是否过小 Check if the air supply pressure is too small 检查升降气缸电磁阀换向是否正常 Check if the reversing cylinder solenoid valve is normal 检查升降机构是否有卡住现象 Check if the lifting mechanism is stuck</p>		
<p>14.料桶不上料和上料慢的处理 What to do when the barrel is not loaded and the feeding is slow: 检查进料口是否阻塞 Check if the inlet is blocked 检查排口是否通畅, 气源大小是否合适 (小料桶) Check if the discharge port is unobstructed, and whether the gas source is small (small barrel) 吸气口是否有漏气,真空泵是否工作 (大料桶) If any leak in the suction port? Does the vacuum pump work (large barrel)</p>		
<p>15. 设备正常启动但不工作的处理 What to do when starting up but not working: 检查工作方式是否选择正确 Check if the work mode is correct 检查位置开关信号是否正常 Check if the position switch signal is normal 检查脚踏开关信号是否正常 Check if the foot switch signal is normal 检查灌装时间设定是否正确 Check if the filling time setting is correct</p>		
<p>16.不加热的处理 Solution for not heating: 检查温控器是否正常工作 Check if the thermostat is working properly 检查加热固态继电器是否正常工作 Check if the heated solid state relay is working properly 检查加热棒是否损坏 Check if the heater is damaged</p>		

<p>检查热电偶是否测量正常 Check that the thermocouple is measured properly</p>		
<p>17.气缸电磁阀的保养 Maintenance of cylinder solenoid valve: 在进气的三联体的油雾器经常检查是否有润滑油， 过水器每天断气放水 The oil mist of the triplet in the intake air is often checked for oil, and the gas and water is released every day 电磁阀与气缸有卡滞现象时可以拆开清理污渍 When the solenoid valve and the cylinder are stuck, the stain can be removed</p>		
<p>18 机头部分保养 Machine head maintenance: 每天下班清理卫生杂物，滑动部件上润滑油。检查螺丝是否松动 Clean up the sundries and the lubricating parts on the sliding parts every day after work. Check if the screws are loose</p>		

