Desiccant Filling Machine

FAQ

LIGZ2020-08 Others

LIGZ2020-07 Electrical control system

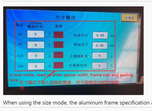
01The machine does not work after startup

Check whether the working mode is correctly selected. Select one of the working modes and set the parameters correctly LIGZ2020-07-QT

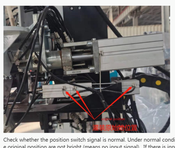
Time mode:

When using the time mode,only need to input the filling time and sealing time LIGZ2020-07-QT

尺寸模式:



When using the size mode, the aluminum frame specification and sealing time must be entered LIGZ2020-07-QT



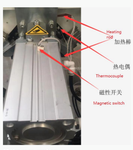
Check whether the position switch signal is normal. Under normal conditions, when it is not working, the three proximity switch indicators in the original position are not bright (means no input signal) , If there is input signal, then it is abnormal. Check whether the proximity switch is incorrectly positioned or damaged LIGZ2020-07-DL

Check whether there is molecular sieve in the small barrel and whether the signal of the two proximity switches in the barrel is normal. no material, no signal LIGZ2020-07-DL

Check whether the pedal switch signal is normal. Under normal conditions, stepping on the pedal switch has input signal, not stepping on it has no signal LIGZ2020-07-DL

Check whether the rubber cylinder has butyl glue, no glue alarm magnetic switch has a signal or the magnetic switch is damaged, the machine will not work, check whether the temperature is normal.LIGZ2020-07-QT

Check whether the filling time setting is correct, the filling time should not be less than 3 seconds LIGZ2020-07-QT



Check whether the heating solid state relay is normal. Under normal conditions, when the temperature does not reach the set value, the solid-state relay indicator lights up, and the measured output point has 220V output voltage LIGZ2020-07-DL

Check whether the heating rod is damaged. Measure the resistance value of the heating rod with a multimeter after the power is cut off. If it is short-circuited or disconnected, means burned out. Normally, it has a resistance value of several hundred ohms. LIGZ2020-07-DL

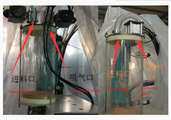
Check that the thermocouple is measuring properly. Check whether the measurement display value changes normally. Abnormal or display "***" means that the thermocouple is broken or the connection wire is disconnected. Replace the thermocouple or connect the disconnected wire. LIGZ2020-07-DL

02 Heater not working

03 Air cylinder solenoid valve maintenance

Often check whether there is lubricating oil in the triplet oil atomizer of the air intake, and cut off the air and release water every day. LIGZ2020-07-QT

If the solenoid valve and cylinder have stuck phenomenon, can be opened to clean the stain. Solenoid valve can be disassembled to clean the spool, cylinder can be disassembled to clean the piston and cylinder wall.LIGZ2020-07-QT



Check whether the exhaust port is smooth, whether the size of the air source is appropriate (small barrel), check whether there is air leakage in the suction port, whether the vacuum pump is working (answeed barrel). LIGZ2020-07-JZ

04 The barrel cannot be fed or the feeding is slow

LIGZ2020-06 Sealing

The position of the glue hole can be adjusted by adjusting the position of the connecting plate between the sealing system and the machine frame. LIGZ2020-06-JZ

01 Adjustment of sealing position

02 Can not seal glue or glue amount is small

Check whether the temperature of the glue is normal, generally in 70-100 degrees Celsius. LIGZ2020-06-QT

Check the pressure of glue pushing, generally 0.5-0.6mpa. LIGZ2020-06-QT

Check whether the piston rod is moving backward when the sealing cylinder is working, and check whether the solenoid valve is leaking. LIGZ2020-06-DL

Check whether the glue hole of the glue block is blocked. Manually press and hold the open button of the left and right glue sealing solenoid valve, and the glue pushing electromagnetic in the state of pushing the glue, you can check whether the glue hole of the glue block is blocked. If it is blocked, it needs to be removed to clean up.. LIGZ2020-06-JZ

Check if the sealing cylinder piston rod action is normal while working. LIGZ2020-06-JZ

Check whether there is glue in the cylinder, whether there is no glue alarm, if not alarm, adjust the magnetic switch LIGZ2020-06-QT

Check whether the glue pushing piston and seal ring are worn out. If so, remove the cylinder and replace the seal ring. LIGZ2020-06-JL

03Glue cylinder leaking

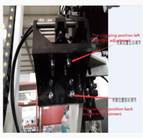
Check whether the inner wall of the cylinder is scratched. If scratched, replace it. LIGZ2020-06-JL

04The cleaning method of glue block and glue barrel

Take apart the glue block and clean it with kerosene. LIGZ2020-06-JZ

Increase the push pressure to squeeze the rubber barrel clean after cleaning, and then remove the air cylinder and piston, and then clean the glue cylinder with kerosene. LIGZ2020-06-JZ

LIGZ2020-05 Filling



The clamping seat can be adjusted around, adjust the aluminum bar in the middle of the pressing, to prevent uneven left and right sides. LIGZ2020-05-JZ

01Adjustment of filling position

Check whether the switch board works properly. The switch plate can move flexibly between the filling block and the baffle and the gap is less than 0.2 mm. LIGZ2020-05-JZ

Check whether the filling hole has molecular sieve agglomeration and blockage. If yes, needs to be disassembled and cleaned. LIGZ2020-05-QT

In the open position, check whether the filling hole is aligned with the hole of the switch plate. If not, adjust the Angle of the filling block or the position of the switch plate to make it aligned. LIGZ2020-05-JZ

Check whether the clamping mechanism of the aluminum strip is not parallel, resulting in the offset of the drilling hole, and the filling hole cannot be aligned with the drilling hole. If so, adjust the clamping mechanism to clamp flexibly. LIGZ2020-06-J-L

02 The desiccant does not enter or one side does not enter

03Desiccant leakage

When not pressed down, check whether the gap on both sides of the aluminum strip is uniform, whether one side is loose and the other side is tight. If not uniform, adjust the left and right positions of the seat plate to make the two sides of the aluminum strip consistent and there is no gap after pressing down. LIGZ2020-05-JZ

Check the gap between the switch plate and the filling block. The gap should be less than 0.2 mm. LIGZ2020-05-JZ

Check whether the hole position is consistent with the filling hole when the aluminum strip is drilled. If not, the molecular sieve will be leaked , LIGZ2020-05-JZ

When the gas drill moves up and down, the speed can not be too fast. If the speed is too fast, a pit will be generated in the wide aluminum strip when drilling, and the molecular sieve will be leaked when filling.LIGZ2020-05-QT

Use thin iron wire to clean the filling hole. If it solidifies too hard, remove the filling block and baffle to clean it up. LIGZ2020-05-QT

04 Filling hole and filling block desiccant solidification treatment method

Check whether the switch plate (inserting plate) is deformed, bent and stuck, correct flatness, or replace it with a new one. LIGZ2020-05-JL

Check whether the air cylinder solenoid valve reversing is normal, remove the spool and clean it, or see if the coil is burned out. If damaged, a new solenoid valve is needed. LIGZ2020-05-DL

子主题

Loosen the fixing screw of the air cylinder to adjust its Angle. Remove the air pipe and pull the piston of the cylinder by hand. When the cylinder can be flexibly telescoped, fix the cylinder. After the cylinder is fixed, the piston of the cylinder can be flexibly jerked by hand.LIGZ2020-05-JZ。。

Check the gap between the filling switch plate and filling block. If it is larger than 0.2mm, repair the filling block to make the gap smaller than 0.2mm or replace the filling switch plate and filling block. LIGZ2020-05-JL

05 The treatment method of filling switch/inserting plate is not inserted

LIGZ2020-04 The hole drilling

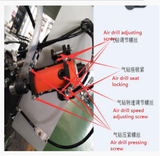
The tightening seat can be adjusted back and forth, can adjust through this position if the drilling position is not in the middle of the aluminum bar. LIGZ2020-04-JZ

The left and right positions can be adjusted by loosening the vertical setting screws of the tightening seat. LIGZ2020-04-JZ

Loosen the horizontal setting screws of the seat to adjust the front and rear positions. LIGZ2020-04-JZ

The clamping block guide shaft wandering clearance is large, resulting in the front and rear clamping block is not synchronized. Need to adjust the guide shaft synchronization or replace the guide shaft sleeve. LIGZ2020-04-JZ

01The drilling hole is not in the correct position



The air drill does not move: check whether the moving cylinder is working normally, whether there is a stuck situation. Check whether the air source of the two cylinders is normal.Press the manual button of the solenoid valve to check whether it can change direction normally, pull off the two air pipes of the air drill moving cylinder, and push the cylinder seat by hand to check whether it is stuck. If it is stuck, check the mechanical device, whether it is caused by the cylinder or the guide, and try to move after exclusion. LIGZ2020-04-JZ

The air drill does not rotate: check whether the air source is normal, check the air drill speed adjustment screw, and whether the air drill filter is blocked. LIGZ2020-04-JZ

Check the main triplet. It may be that the flow rate is too small because the triplet is used for a long time and the air drill is not flexible. LIGZ2020-04-JZ

02The air drill does not move or rotate

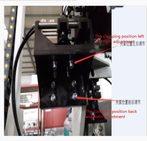
The air drill has insufficient rotational power

Air drill speed can be adjusted by adjusting the air drill source adjustment screw. LIGZ2020-04-QT

Remove the filter screw to clean the stain and prevent air source blockage. LIGZ2020-04-QT

03Air drill maintenance

LIGZ2020-03 Working lifting



Aluminum bar clamping

Maintenance of clamp parts

Check whether the clamp tube is moving flexibly and not stuck, can adjust the clamp tube pressure appropriately. LIGZ2020-02-JZ

Check whether the positions of the two pins are a line. Loosen the fixing screws properly and tighten the screws after they are naturally straighted. LIGZ2020-02-JZ

LIGZ2020-01Filling lifting

01Filling lifting does not move

Check whether the air source pressure is too small, should be greater than 0.65MP

Check whether the direction reversing of the solenoid valve of the lifting cylinder is normal, and check whether the solenoid valve coil is burned out. If so, replace the coil with a new one.

Check whether lifting mechanism has any stuck, check and repair stuck areas

02The treatment of the nose falling down after the filling has risen

Check whether there is air leakage at the connector of the solenoid valve, or whether the solenoid valve spool can't be sealed , LIGZ2020-01-JL

Check whether there is a slight air colluding in the cylinder, remove the upper air pipe, and then press "up" to check the exhaust of the upper air outlet. If the exhaust volume is large, it indicates that the cylinder is colluding.LIGZ2020-01-JL