

Caution!

<p>When making operations of conveying and setting etc, pay attention to the stability of the device to avoid accidents caused by dropping or slipping</p>	<p>Injury or failure can be caused with the instructions ignored.</p>
<p>Do not drag the wires and the rotation parts of the device when making the conveying.</p>	
<p>Restarting can probably happen when the power supply is resumed after the power failure, therefore settings of the device shall be properly made to avoid accidents of the restarting and ensure the personal safety.</p>	<p>Accident of injury can be caused with the instructions ignored.</p>
<p>Make sure that the device is operated stably. Keep the device away from strong impacts; avoid connecting and disconnecting the power supply too frequently.</p>	<p>Accident of electric shock, injury, damage and fire accident can be caused with the instructions ignored.</p>



1 Foreword

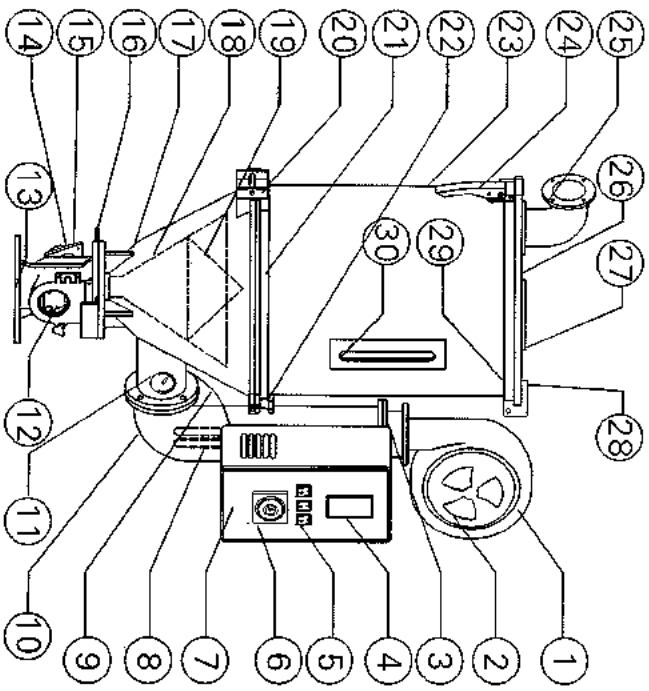
1.1 User Precautions

1. Please read the technical manual carefully before the installation and application of the device.
2. The performances, operations and maintenances of the device will be detailed in the following characters.
3. The documentations must be provided to the managerial personnel and the onsite operation and maintenance personnel.
4. The device has been made various testing before making the delivery to ensure that the device is complied with ex-factory standards. Proper application, careful maintenance of the device is the greatest guarantees to ensure the reliability, stability and effective operation of the device.
5. The documentation is permanent file for the device, please make proper keeping of the documents.

1.2 Application environments

1. The device is required to be applied in the indoor environments of clean and neat, ensure that there's ample light and ventilations.
2. The environmental temperatures for the operation of the device shall be controlled within the range of 5°C to 45°C, the surrounding temperature where operation is made for more than 24 hours shall be no more than 40°C.
3. The air humidity shall be controlled within the range of 20% to 95%, certain space shall be left surrounding the device.
4. Irrelevant personnel are not allowed to enter the working area when the device is under operation.
5. Make proper use of the device, do not operate the device beyond the application ranges.

2. Structural drawings and names



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|-------------------------------|------------------------------|
| 1. Blower | 16. Big draw plate |
| 2. Air regulation cover | 17. Aliu hopper |
| 3. over temperature protector | 18. Screen Separator |
| 4. Temperature control | 19. Shade Separator |
| 5. Boat-type switch | 20. Barrel hopper loose-leaf |
| 6. 24h Timer | 21. Under bucket flange |
| 7. Control box | 22. Quincunx screw |
| 8. Heater | 23. Drying Barrel |
| 9. Thermocouple | 24. Handle |
| 10. Heating cylinder | 25. Exhaust Pipe |
| 11. Thermo-meter | 26. Cover |
| 12. Hopper Magnet | 27. Tetragonal plate |
| 13. Base | 28. Barrelhead loose-leaf |
| 14. Feeding Port | 29. Above bucket flange |
| 15. Small draw plate | 30. Sight case |

3.Product specifications

Model	Applicable injector	Power of drying electric thermal	Power of the Drying Blower
15KG	30~60g	2.7kw	0.12kw
25KG	60~125g	3.3kw	0.12kw
50KG	125~500g	4.2kw	0.18kw
75KG	300~500g	5.1kw	0.18kw
100KG	600~1000g	7kw	0.25kw
150KG	1000~2000g	9kw	0.25kw
200KG	2000~2500g	12kw	0.4kw
250KG	2500~3000g	15kw	0.4kw
300KG	3kg~4kg	15kw	0.4kw
400KG	4kg~6kg	18kw	0.45kw
500KG	6kg~7kg	21kw	0.96kw
600KG	7kg~8kg	24kw	1.1kw
800KG	8kg~10kg	30kw	1.5kw
1000KG	10kg~12kg	36kw	2.2kw
1200KG	12kg~15kg	42kw	2.2kw
1500KG	15kg~20kg	48kw	2.2kw
2000KG	20kg~30kg	54kw	3kw
2500KG	30kg~40kg	57kw	3kw

4.Function description

4.1 Operational principles

The dryer makes drying on the raw materials in the barrel by blowing air onto the electric heating tube in the heating cylinder, and then controlling the air supply temperature by thermostat to make it flow evenly in the drying barrel.

4.2 Product features

- 1.Parts of the device contacting with raw materials are made of stainless steel to keep the raw materials away from contamination; bending pipe type is applied in the heating cylinder to make effective protection from the stacking of dusts.
- 2.The device is featured by even hot blast blowing and high drying efficiency. The thermostat is proportion error type and the temperature error is controlled by 3 °C
- 3.The device can be made combined application with dehumidifier to meet high drying requirements.

5.Installation instruction

5.1 Preparation before installation

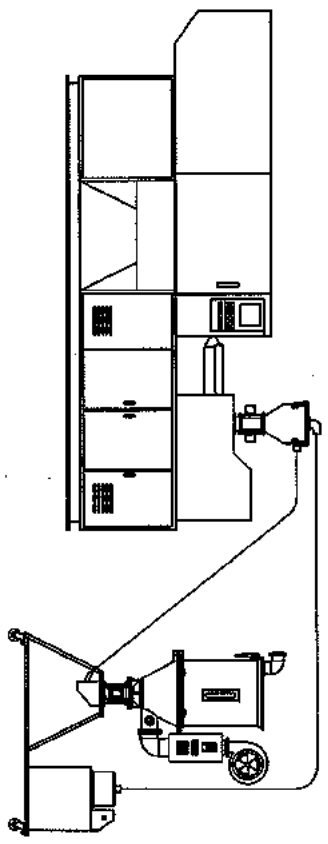
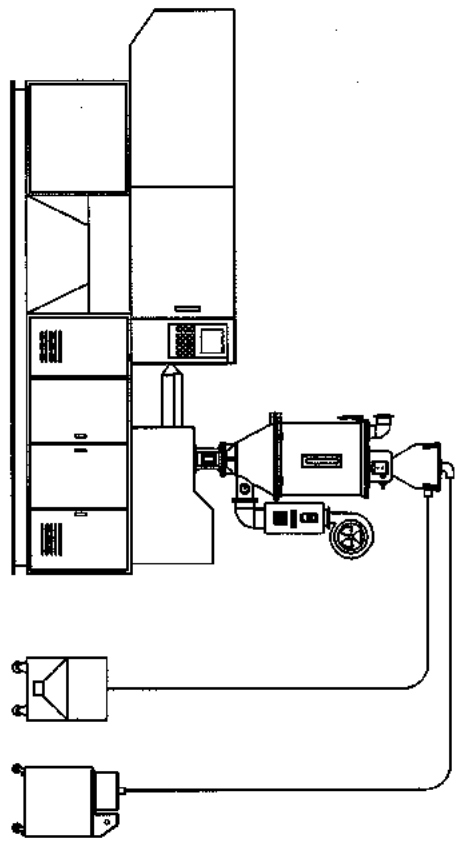
- 1.Other devices, stacking of materials and maintenance space must be taken into consideration before determining the installation position of the device. At least a distant of 1m is required to be kept surrounding the device.
- 2.The arrangements of power supply must be made before the installation, the load power of the power source wires shall be over the total power of the device.

3. The application of the device shall be made indoors where the surroundings are clean and neat. Space for ventilation system installation shall be reserved when drying raw materials that may generate toxic gases.
4. Please check whether the machine appearance has been damaged during the transportation. If there is the obvious damage of the appearance, please don't hesitate to contact with the factory or seller.

5.2 Installation methods

1. Install the vacuum hoppers on the material storage barrel and injector, connect the material suction hose; connect the heat resisting air pipe from the air outlet of the material storage barrel to the dehumidifying return air inlet.
2. Connect the main power supply wires to the main power supply. Make sure the voltage of the power supply circuit is same as that of the device. Open the power switch and the main switch in the control box of the device and then cut in the auto running switch. If revise phase is indicated on the panel, first disconnect the power supply, then shift any two of the wires of the main power supply wires.
3. After the pipeline and the power source are correctly connected, open the power supply and the system operation switch. The dehumidifier will be started automatically. The rotation direction of the blower needs not to be inspected because that reverse phase detector is installed in the device. Inspection on whether all the rotation directions of the air blowers and air pumps are complied with the arrows shall be made if the power supply wires of the blower have been disassembled.
4. After installation, clean up the device with soft cloth, especial the inner barrel. Thorough cleaning shall be made on parts directly contacted with raw materials to avoid the raw materials from being contaminated.

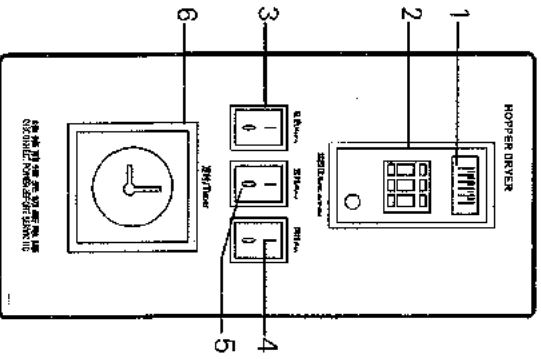
5.3 Diagram of installation



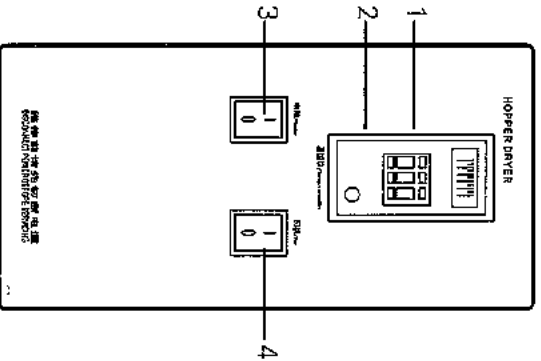
6. Operation instruction

6.1 Operation panel introductions

With timer



Without timer



1. Temperature deviation indication
2. Temperature setting button
3. Heater switch
4. Blower switch
5. timer switch
6. 24 hours timer

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6.2 Operation cautions

1. The transportation and installation of the machine must be completed by the professional peoples who know the technical parameters of the machine very well.
2. After finishing the machine's installation but before use, the machine must be cleaned and inspected to see if there is any tools and sundries forgotten in the machine.
3. After installation, it needs to check the machine's parts, electric elements and electric wires to see if they have loosened or broken off during the transportation. If they have, please fasten them again, then the machine can be put into operation.
4. When installation, the machine must be placed vertically and be placed on the flat ground.
5. Please make sure that the earth wire connects the ground correctly in order to avoid the electric shock accident.
6. The use of three-phase five-line system, according to the head of the line marking the correct connection, L1, L2, L3 next phase, N to zero line, PE earthing grounding resistance requirements of less than 0.1 ohm.
7. The main power supply should be rated at 10 percent, the frequency should be rated frequency of less than 2 percent, if the power fluctuations may not exceed the scope of this boot, if the damage caused by forced reboot, the Company will not within the scope of the warranty.
8. Before starting the device, inspect whether there's something abnormal on the device, whether the power supply is correct connect and the voltage is complied with requirements.
9. If warming is made on the reserved phase, please shift the positions of the connection wires L1 and L2 of the power supply.

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10. The operators shall be made essential trainings before operation including: Possible dangers when operating the device; The working principle of the machine and the correct application methods; The regulation of the device parameters and the possible results; Safety apparatuses of the device and safety knowledge. Stop any unsafe activities that can damage the device.
11. The managerial personnel have the obligation to inform to the operators knowledge relevant to safety, operations and performances; and possible dangers during operation and how to make safety protection on operators themselves and the device.
12. This machine is with 3phase voltage and has the pump overloading device. When there is any overloading occurs, the machine will stop its operation. At that time, please check the overloading reason to eliminate the faults, then to reposit the overload protector and can start to operate normally.

6.3 Operation methods

Opening the equipment

1. Open the blower switch on the control box of the device. The Ac contactors of the blower are connected and the blower is started.
2. Turn on the electric heating control switch to contact the temperature controller. When the actual temperature is detected lower than the set temperature, the AC contactors of the electric heating units are connected and the heater starts heating.

Operation of the temperature controller

1. Press the "+" "-" button to regulate the values indicated on the temperature controller to increase or reduce the set temperature.
 2. The indication lamp will turn red when heating is being made and the indication lamp will turn green if no heating is being made.
 3. When deviations are detected between the set temperature and the actual temperature, Use temperature deviation fine adjustment button to make fine adjustments.
- Application method of the 24h timing
1. Turn on the "Timing" switch if needed (keep it of when not needed). Calibrate the time to the current actual time by turning the knob of the timer. Turn the "Function switch" on the timer to "G" ("1" when the timing is not required).
 2. Set the switch gear of the timer according to the requirements. Pressing outwards means open and inwards means close. Each space of the gear means 15 minutes.
 3. When the small triangle on the panel of the time is pointing the outwards pressing, the device will be started and when it's pointing to the inwards pressing, the device will be stopped. The device will work according to the set time intervals until new settings are made on the device.

Operation requirement

1. Set the temperature values on the temperature controller according to the drying temperature of the raw materials. It shall be noted that the raw materials can be caked with the set temperature over high. Proper adjustment shall be made according to the practical experience when making the settings.
2. The air regulation can affect the efficiency of the drying. Generally the air regulation cover is suggested to turn clockwise to full open position. The air flow shall be reduced appropriately if the raw materials in the barrel are not many or a higher temperature is required.
3. Keep the raw materials full in the barrel to achieve a better drying effectiveness. The collocation with automatic feeding machine can provide a better effectiveness.
4. Install air filter in the air inlet when drying transparent raw materials to prevent dusts from entering the materials.
5. The raw materials shall be dried fully before the injection molding, generally the drying time shall be at least two hours.

Stopping

When stopping the device, the blower shall be stopped after 5 to 10 minutes of the stoppage of electric heater in case that the residual temperature of the heater is over high to damage the heating cylinder.

7. Repair and maintenance

7.1 Common faults and solutions

Phenomenon	Cause	Elimination
No power supply.	The switch of the power supply is turned off or the fuse is burnt	Open the switch of the power supply or replace the fuse
The machine without heating	The over temperature protector, the electric heating contactor or the heater is broken.	Inspect the above components by multimeter, please replace them if broken.
The heating temperature can not be met.	One of the heaters is broken or the set temperature is over high.	Inspect and replace the heater or set the temperature no more than 140°C.
The heating temperature is always higher than the set temperature	The blower blades rotate reversely, or the air inlet of the blower is closed.	Shift the rotation direction of the blades or open the air inlet.
The raw materials are caked	The heating temperature is over high, the temperature controller can't control the temperature accurately.	Regulate the heating temperature, inspect whether the temperature

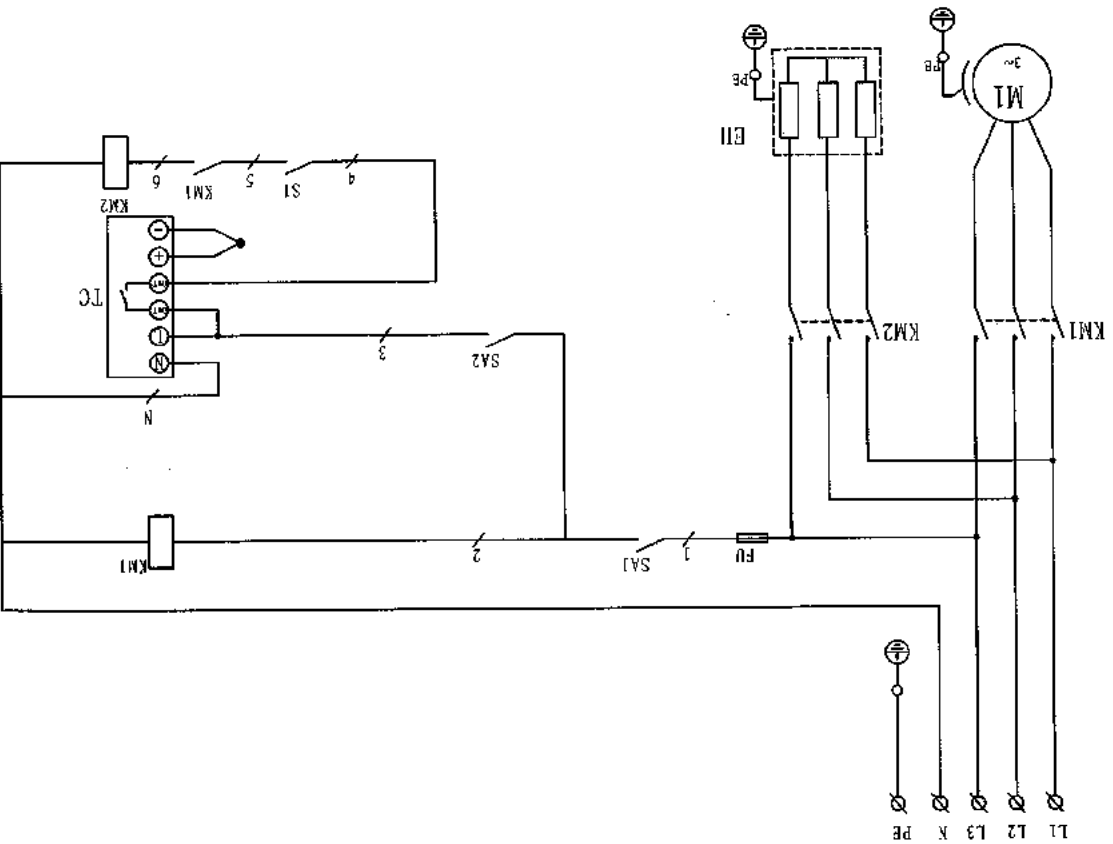
7.2 Cautions for maintenance

1. When the device's work and the temperature is very high, please don't process servicing to avoid the danger of scald. If necessary, please shut down the electric heater until the machine is cooling, then can do it.
2. All the repairs and maintenances must be made with the main power supply off. Lock the disconnected switches if necessary.
3. All the repair and maintenance must be made by assigned qualified person. The repair and maintenance personnel must know clearly the performances and parameters of the machine.
4. Careful inspections shall be made after the repair or maintenance. The device can only be handed to the operators after all are confirmed to be in order. Records shall be kept.

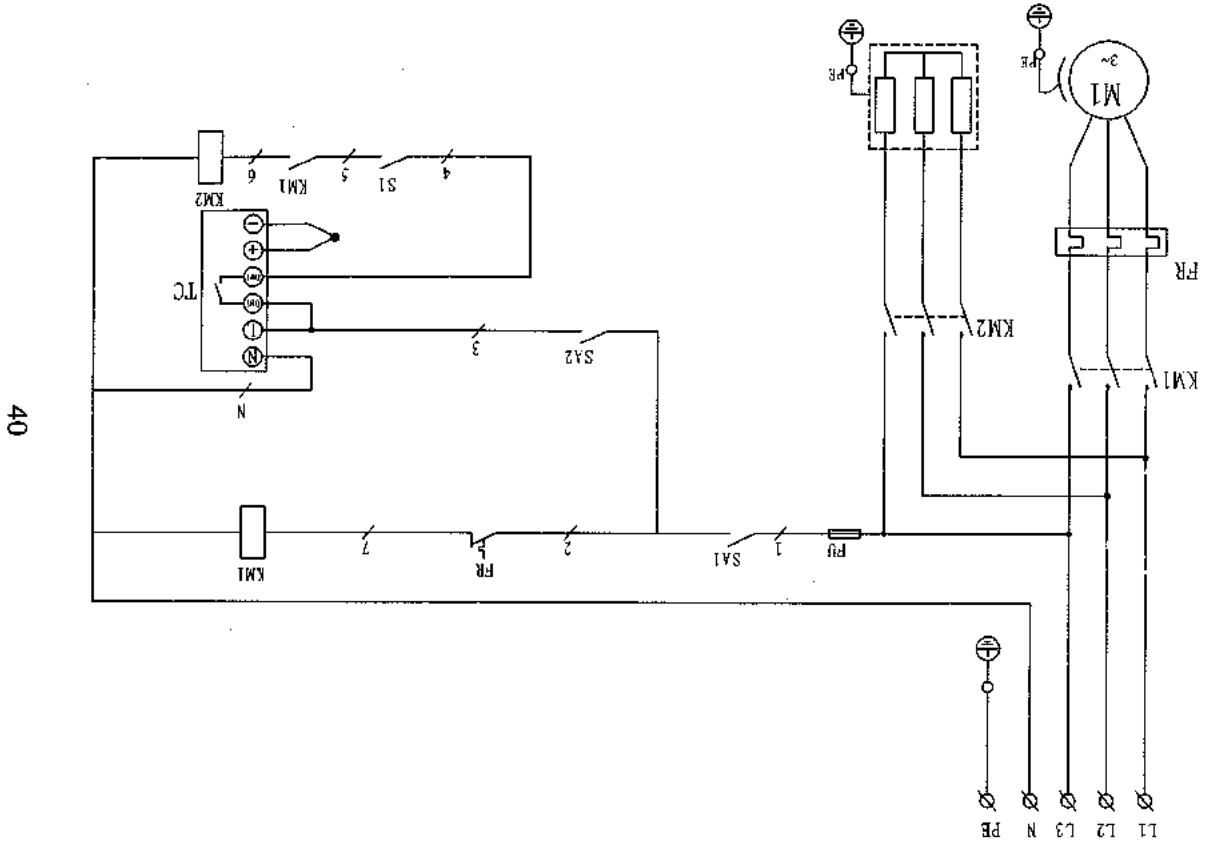
7.3 Maintenences

1. The filter screen of the air inlet shall be cleaned often to avoid blocks that may affect the drying effects.
2. Make periodical cleaning the dust cham ber. Cleaning shall be made often because that the powders of the raw materials can silted in the dust chamber during the operation of the device.
3. When changing the raw materials, make thorough cleaning on the big and small mesh hoppers, the material barrel, and the heating cylinder to prevent the afterwards raw materials from being contaminated.

15-300KG 电路图 Circuit diagram



400-800KG 电路图 Circuit diagram



定时器型 电路图 Circuit diagram

