LABORATORY PADDING MANGLE

Vertical Type

OPERATION MANUAL

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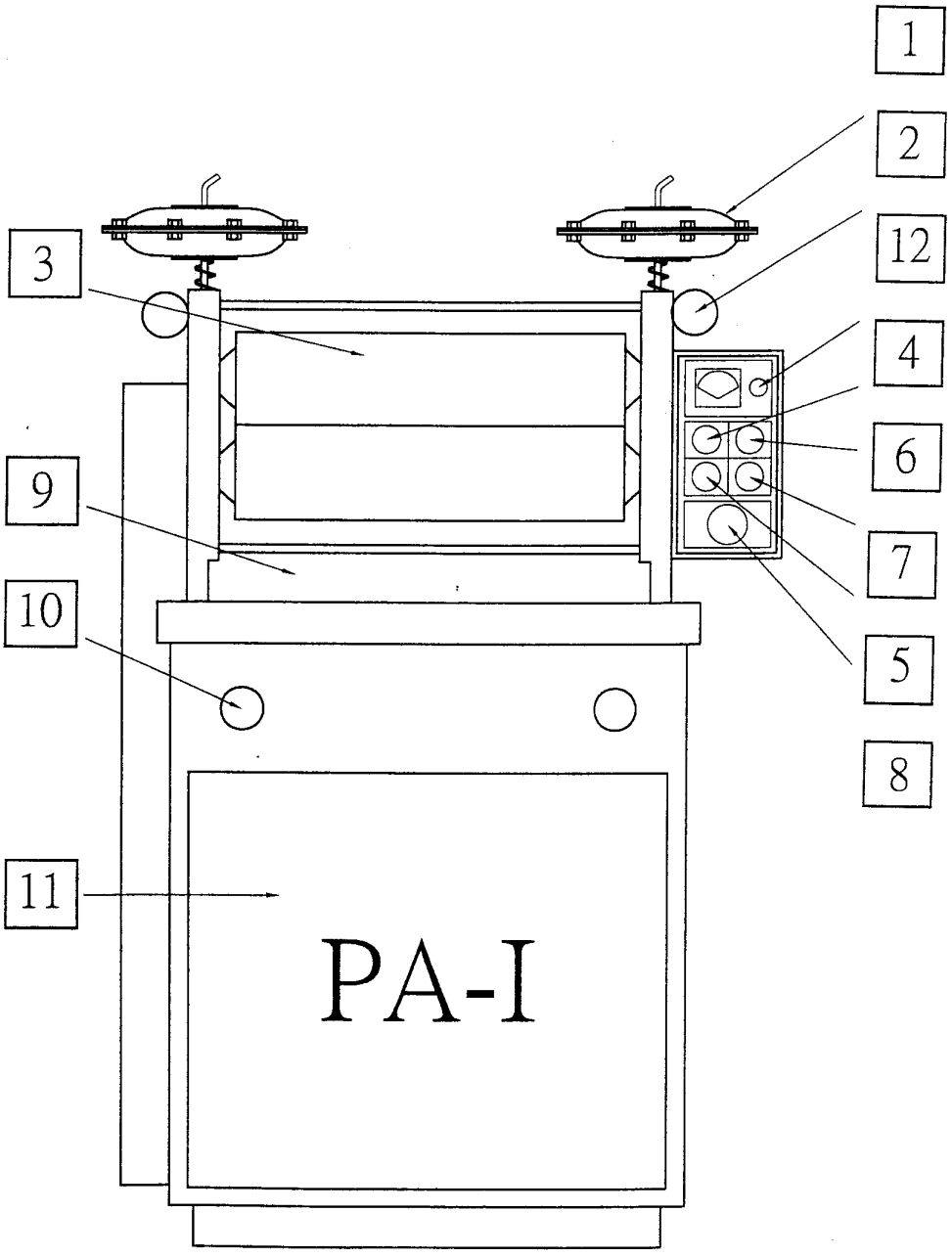
P-AO / P-AI

OPERATION MANUAL

SEQ **PAGE**

FRONT VIEW【FIG-1】



ELEMENTS DESCRIPTION OF 【FIG-1】

ITEM	DESCRIPTION	REMARK
1	Diaphragm Complete	膠閥
2	Pressure Gauge	壓力表
3	Roller	橡膠滾輪
4	Pad ON Button	加壓按鈕
5	Pad OFF Button	洩壓按鈕
6	Motor ON Button	馬達啟動按鈕
7	Motor OFF Button	馬達停止按鈕
8	Emergency OFF	緊急停止開關
9	Fluid Bed	藥槽
10	Air-Regulator	壓力調整閥
11	Emergency Touch	緊急觸摸開關
12	Panel Meter Adjuster （Speed Control）	調速旋鈕

INSTALLATION

1. Check the machine to see if there is any damage of transport.
   If there is any damage, please inform us the details by
   Tel:886-2-26945880 or by FAX:886-2-26943928/26935793
2. Please check packing list to make sure if it is complete, otherwise please inform our company.
3. Place machine at desired position and keep proper space for machine maintenance.
4. Please connect water outlet pipe to proper drainage channel.
5. Make sure the power supplied by factory meets the power data written on control panel of machine of it is ok then please connect the power wire to non-fuse breaker.
6. Connect the air outlet pipe of air compressor with the inlet of air.

OPERATION

1. **Check supplied air pressure is adequate** at least 1kg/cm^2 higher than the needed one max need 6 kg/cm^2
2. **Make sure the Roller Rotating direction** is from the back toward the front. The tested sample fabric is supposed to come out toward the operator.

   Put the wetted (impregnated) sample on the surface of the top roller then start the padder the sample will be guided and squeezed by the mangles and come out toward the operator. This is correct and safe way.
3. **Regulating the pick-up rate**
   A. Individually regulate the pressure gauges left or right.
   B. Pressure regulator turn clockwise for more pressure anti-clockwise for less pressure.
   C. 1). Press button of pad on FIG1-4 then regulate it by turning clockwise to reach desired pressure.
      2). Press pad off button FIG1-5 to release pressure.
      3). Repeat 1st and 2nd steps 2-3 times to make sure to reach the desired pressure.
   D. After repeating and confirm the both side of Roller pressure could reach required pressures then slightly pull the regulators to “lock” position.
   E. Conduct the padding with sample fabric to measure the pick-up, adjust the pressure to reach the desired pick-up rate.
4. **Prepare the resin or chemical solution for the application**

START APPLICATION

1. Clean rollers and dry them.
2. Press motor on button FIG1-6 and pad on button FIG1-4.
3. Wetting (impregnating) tested fabrics.
4. Padding the tested fabric.
5. Forward the padded fabric to next step like drying、curing.
6. Clean rollers for another recipe.
7. When work finished press pad off button FIG1-5 and motor off button FIG1-7.

REMARK:

Each time you change the setting of pressure, please repeat pad on → pressure regulating → pad off a couple of times to assure the pressure gauge is reacting properly.

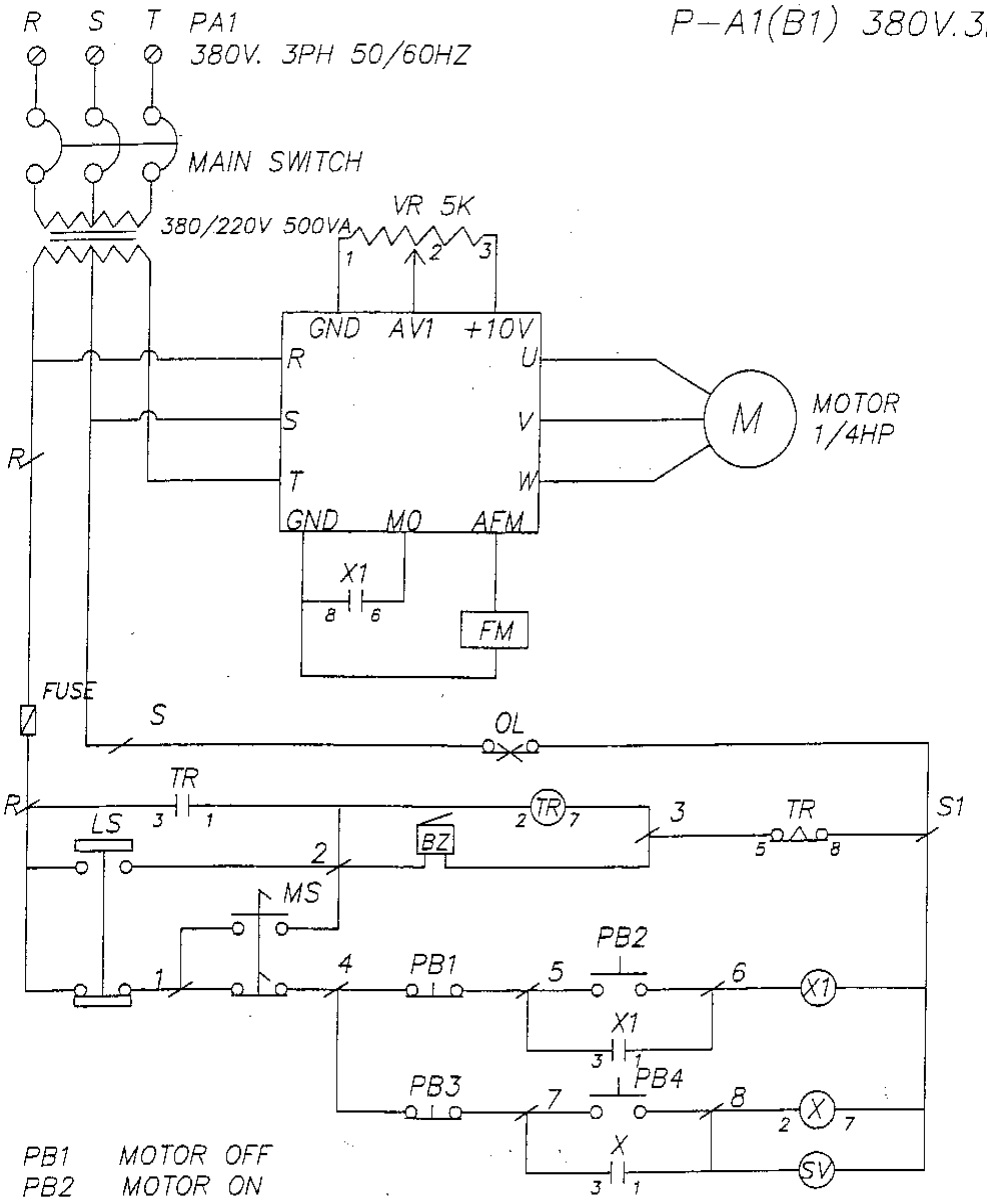
ADJUSTMENT OF PICK-UP RATE

Under the same condition of pressure, different fabrics will gain different pick-up the best way is gradually testing from 0.8/1/2/3/4/5 kg/cm^2 to get each pick-up value at different pressures and draw a pick-up curve for obtaining a better result on individual fabric.

MAINTENANCE

1. Clean Rollers with clean water at end of test.
2. Replace lubricant of gear reducer every 1000 hour working time.
3. Regulate the tension of connecting chain and lubricate it at every 1000 hour.
4. Bearing to be greased every 4-6 months.

ELECTRICAL DIAGRAM



PB1 MOTOR OFF
PB2 MOTOR ON
PB3 PAD OFF
PB4 PAD ON
LS,MS EMERGENCY
TR TIMER
BZ BUZZER
C MAGNETIC CONTACTOR FOR MOTOR
X RELAY
SV SOLENOID VALVE
FM SPEED METER