

Magnetic strip laying machine

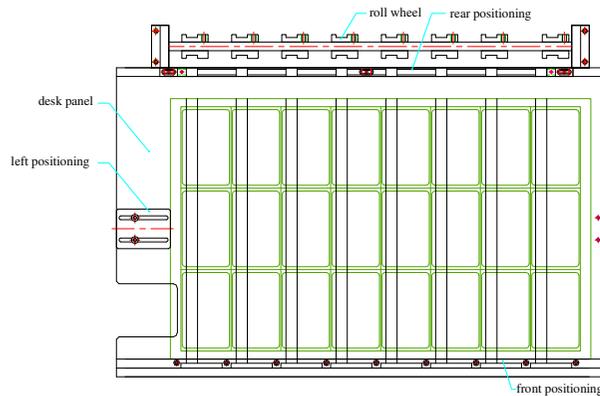
operation instruction

A Setting

- Air pressure setting:** commonly as 0.2 – 0.3Mpa (turn pressure-reducing valve, the pressure meter point at 0.2 – 0.3Mpa. To increase pressure, turn it clockwise, contrarily turn counterclockwise to reduce pressure).
- Time setting:** commonly as 3 – 4 second, details to modify time, please consult an instruction of time relay.
- Temperature setting:** commonly as 150 – 160 degree, details to modify temperature, please consult an instruction of temperature controller.

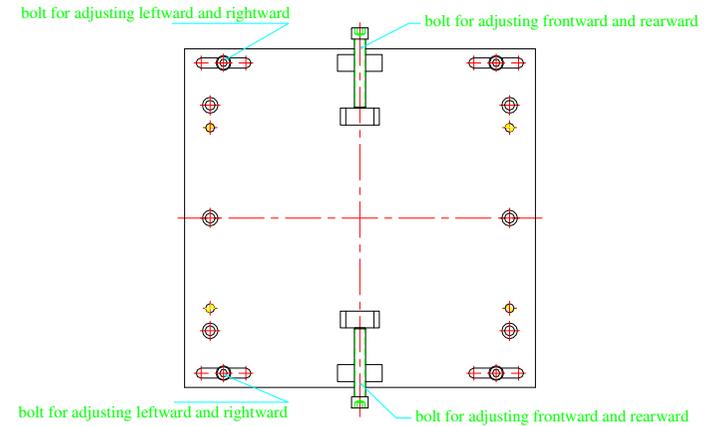
B Adjusting

- Adjusting position of magnetic strip:** put sample sheet on the desk, take a front positioning (close up operation side) as benchmark, and adjust rear positioning strip and positioning block of magnetic strip so that making 3 benchmarks are on the same line as well as superposing with a magnetic strip position line.



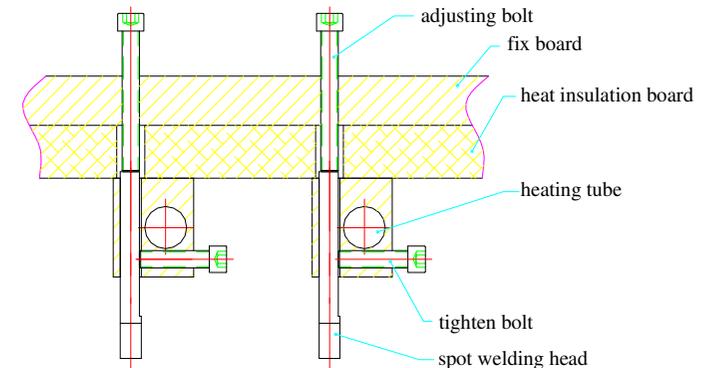
b. Adjusting position of welding points:

- a warp at front and rear of welding point: adjust a bolt at bottom of desk (there is one bolt each at front and rear, if adjusting forward, turn the front bolt counterclockwise to a certain distance, then turning the rear bolt clockwise to exact position, last turn the front bolt clockwise to tight condition. If adjusting backward, turn the other way.)
- a warp at left and right of welding point: loose 4-M8 bolt between the desk and base, then turning desk left and right.



c. Magnetic strip's welding point not reliable:

- temperature and time are not proper: adjust temperature and time.
- if a few welding points are not reliable: weld head not plane, adjust an upper bolt of weld head bit.



- Adjusting motion speed of cylinder:** there are 2 throttle valves between a directional valve and cylinder, they are used for adjusting motion speed of both up and down directions of cylinder, normally up-speed more fast, down-speed is slow; turn throttle valve clockwise to slow down speed, turn counterclockwise to speed.

C Operation

- put material that will be laid magnetic strips on the desk in positioning direction;
- strain magnetic strips (turn hand wheel counterclockwise with left hand), push a work button with right hand so that a cylinder press down and go back automatically when time up.
- raise material that already laid strips with right hand, meanwhile putting material that will be laid magnetic strips on the desk with left hand, drag finished material with both hands to an assistance desk.
- start laying next sheet.

D Main specification

Applicable material	PVC or other plastic materials
Size of material	295×480
Heat temperature	≤200°C
Temp. control	±1.0°C
Compress air	0.6 MPa
Power supply	AC220V 50/60Hz 1-phase 3-line
Power	2.4kW
Productivity (cards)	7200 cards per hour
Dimension	L700×W1000×H1550mm
Weight	appr. 220kg

E Circuit diagram and Pneumatic principle diagram

