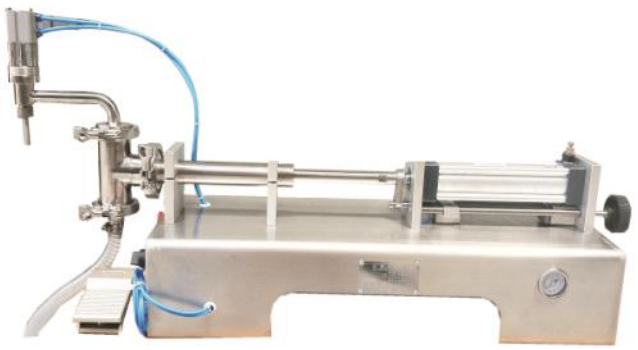
Model: G1WYD

Operational Manual for Single-Head Liquid Filling Machine

Operational Manual



SEMI-AUTOMATIC PISTON FILLING MACHINE

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Principle and Property

1. Principle: The G1WYD series filling machine is semi-automatic and of piston type. The material is pumped by a piston driven by a cylinder. The material flow is controlled by a one-way valve and the cylinder stroke controlled by a reed switch to adjust the filling dosage.
2. Performance: The G1WYD series single-headed liquid filling machine is produced on the basis of further transformation and innovation of other type filling machines by introducing advanced foreign technology. Thus its construction is made more simple and more reasonable, accuracy higher, and operation easier. The machine is an ideal selection for your purchasing filling equipment.

Specifications

	Items	Parameters
Technical Parameters	Voltage	220V±5V
	Current	1A
	Power	10W
	Rated air pressure	4-6kg
	Filling Speed	0-50Bottle/Min.
	Filling Accuracy	±1 % - ±2 %

	Model	Filling Range (ml)	Preferred Filling Range (ml)	The model of your machine (√)
Filling Results	100	5~130	10~100	
	280	10~330	20~280	
	500	30~550	50~500	
	1000	80~1100	100~1000	
	2800	350~3100	500~2800	
	5000	800~5300	1000~5000	

Directions to Safe Operation

The machine is only suitable for filling low concentration materials such as liquid and cannot be used for other purposes. In order to ensure safe production, please read the following attentions carefully.

1 Use air source and power source complying to this machine (Referring to the specifications of this manual).
2. Do cut off air source and power source before disassembling and washing this machine.
3. Electrical control elements are built in the rear part (close to the control button) of the machine. Do not wash the machine with water at any circs. Otherwise there is a danger of electric shock and damage to control elements.
4. A reliable earthing should be ensured by providing a socket with a earthing line.
5. Disconnect power from the machine upon repairing the circuit as voltage may exist in the circuit of power control when power is off.

Instruction to machine

The machine is an ideal filling machine for the trades of foodstuffs, daily-used chemicals, pesticide, medicine as well as special trades. In the process of operation, the machine is affected by the following factors:

1. The filling accuracy: Compressed air stability, material uniformity and filling speed
2. The filling speed: material viscosity, cylinder stroke, material tank size, filling nozzle size and operational skill
3. The machine is filled by the two methods of pedaling and continuous filling, which can be switched as desired. To keep the workshop neat and avoid the waste of materials, it is suggested to make filling operation by pedaling at the initial stage of your operation if you are not skilled enough.

Installation and Adjustments

1. First install the three-way slide valve (11) (See Fig.1) and then material-filling nozzle (14)." (Care should be taken to tighten the clamping band and anchor ear).
2. Confirm the reed switch position (The rear reel switch position is fixed.)
3. Insert the feed pipe (14) into the charging basket or connect it with

the material tank.

4. Connect the power source (17) with the machine.
5. Connect the air source (19) with the machine.
6. Turn on the power supply (22).
7. Open the air source (19)(the sliding valve).
8. Change the working mode of the switch (04) into "pedaling"
9. Tread the pedal switch till a material flows out of the material-filling nozzle(20)
10. Turn throttle valve (01) and (06) to adjust the pumping and filling speed properly. To raise working efficiency, adjust the material pumping speed (01)to a higher level and filling speed(06) to a lower level but no material or bubbles coming out of a bottle.
11. Measure the filling amount and adjust it to the set value by shifting the reed switch.
12. Lock tightly the front reel switch to begin formal filling.
13. When your operation becomes skillful, turn your working mode to "Auto" .

Maintenance

1. In order to protect the machine cleaning, do not scrape its surface with a sharp and hard object and wipe its dirt with alcohol.

2. The Cylinder has been lubricated before the product leaves the factory. Do not disassemble the cylinder to append any other lubricant.

3. The one-way valve, three-way stainless steel valve and material tank can be easily disassembled and washed.

Filling Speed

The filling speed is decided by the following five factors:

1. The sucking speed is decided by the viscosity of the material and the sucking pipe length.

2. The filling speed depends on the caliber of the filling head, the larger caliber will result in faster filling.

3.Foaming speed: Fill a high sudsing product should be at a slower speed.

4.Filling amount: Fill a large amount at a slower speed.

5.Filling accuracy: Fill an accurate amount at a slower speed.

Adjustment operation:

Loose the front and rear speed regulation valves (01)and (06)to adjust the nut.

1. Turn the front unidirectional throttle valve (06) handle clockwise to slow down the cylinder front travel speed and charging speed.
2. Turn the front unidirectional throttle valve (06) handle counterclockwise to accelerate the cylinder front travel speed and charging speed.
3. Turn the rear unidirectional throttle valve (01) handle clockwise to slow down the cylinder withdrawal speed and material-sucking speed.
4. Turn the rear unidirectional throttle valve (01) handle counterclockwise to accelcrate the cylinder withdrawal speed and material-sucking speed.

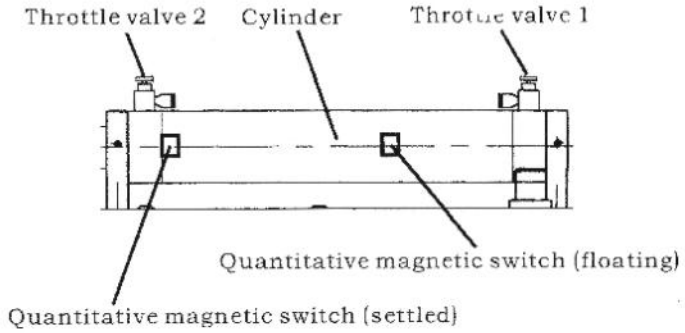
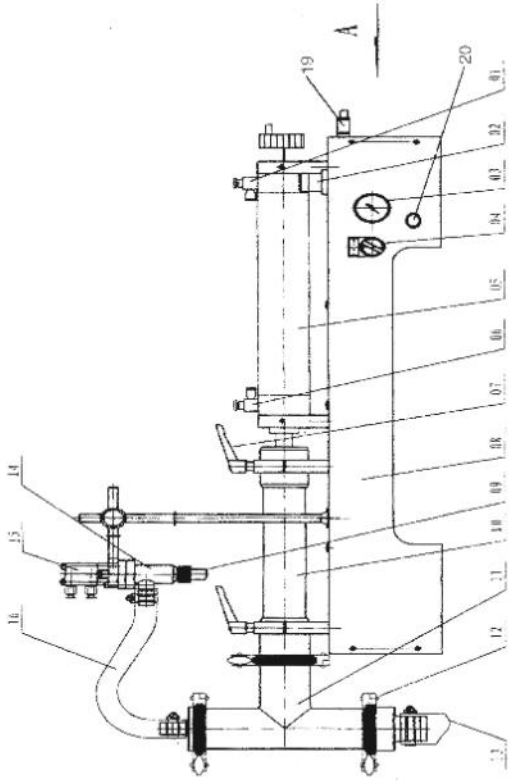


Diagram 1



01. Throttle valve 02. Filter 03. Manometer 04. Selection switch

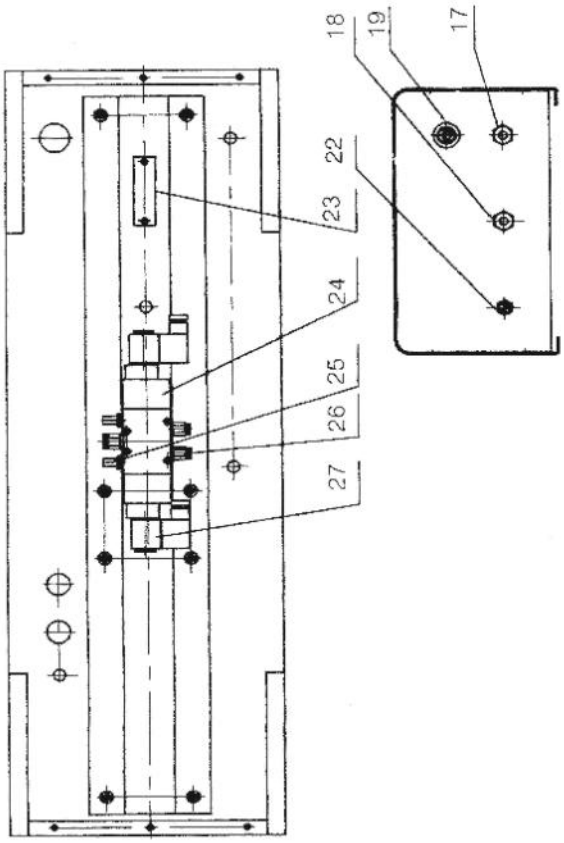
05. Cylinder 06. Throttle valve 07. Adjustable handle

08. Machine body 09. Changeable nozzle 10. Material cylinder

11. Three-way valve 12. Control valve 13. Bar clasp

14. Material filling nozzle 15. Thin cylinder 16. Transparent steel wire tube

Diagram2



17. Cable connector 18. Fuse holder 19. Air source switch

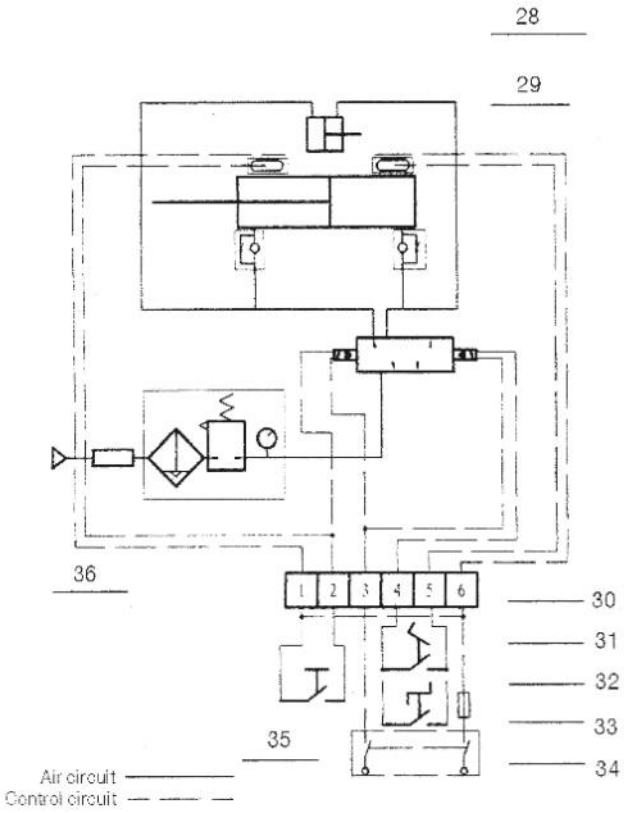
20. Cable connector (connected to pedal switch)

21. Crawl switch (choose) 22. Power switch 23. Terminals

24. Solenoid (two-position five- way) 25. Silencer

26. Straight way valve 27. coil

AIR CIRCUIT CONTROL DIAGRAM



28. Cylinder for material filling nozzle 29. Cylinder for material pushing

30. Terminal 31. pedal switch 32. Selection switch

33. Fuse 34. Master switch 35. Air source switch 36. Reset switch

Troubleshooting:

Failures	Elimination
Cylinder piston refuses to move.	1. Confirm the power switch(22) is on.
	2. Confirm the air source switch(19) is on.
	3. Confirm the fixed reed switch is on.
	4. Confirm the air pressure shown on the manometer (03) has reached requirements
	5. Confirm the piston is not jammed.
	6. Confirm the material viscosity is proper (The product is used for liquid filling) .
Piston dose not return after it comes to the top.	Press the relocation button (21)to adjust fixed reel switch.
Filling amount is not accurate or no material feeding.	1. Confirm that the reed switch position is moved or not.
	2. Reduce the material-sucking speed of the cylinder (Only for high viscosity material).
	3. Confirm the one-way valve is not clogged.
	4. Confirm there is enough material in the charging basket.
	5. Confirm the joints of the pipes are well sealed.
Material leaks from the rear of the material tank.	1. Check whether the piston ring is broken. If so, make replacement.
	2. Confirm the piston and the piston rod are firm.

Packing List

Model of product: G1WYD

Name of product: Semi-automatic piston type single head liquid filling machine

Serial No.	Category	Descriptions	Unit	Quan.	Specifica-Tions	Remarks
1	Technical Document	Main Machine	Set	1		
2		Instructions	Copy	1		
3		Packing List	Copy	1		
4		Receiving Apron	Copy	1		
5		Product Certificate	Copy	1		
8	Accessory	Ring	Set	1	Model O or XY	Depending on size
9		3-way valve ring	Set	1	Depending on size	
10		Inner Hexagonal Spanner	Set	1	1.5、2、2.5、3、4、5	
11		Screw Driver "+"	Piece	1	Ordinary	
12		Screw Driver "-"	Piece	1	Ordinary	