Semi-auto Pneumatic Filling Machine

Operation Instruction

Preface

Please operator read carefully this instruction before using the machine, in order to performance efficiently of the machine.Hope you operate and use according the instruction show, as be careful of the safety below:

1. Keep the environment cleanness of the machine, it can not be too wet environment.

2. Pull the plug out before maintenance machine in case of electric shock.

3. Keep the cleanest state of the filling part, machine should be wiped by timing, clean the pump, then using and maintain the filling machine according the operation manual.

Catalogue

Note: Machine with heating type, avoid to heat without water in it, that makes easily to damage machine, and influence the life of machine.

⑴ Brief introduction

①. Machine principle & performance & model introduction & technical parameters

1. **Machine principle:** This series of filling machine for the semi-automatic piston filling machine, through the cylinder to drive a piston to absorb and hit the material, by an one-way valve to control the flow of materials, with a magnetic switch control cylinder travel, then can adjust the filling volume.

2. **Performance:** Our company's semi-automatic piston filling machine is based on the product of filling machine, The introduction of foreign advanced filling machine technology, and carried out a series of transformation and innovation, which structure is more simple and reasonable, filling precision is more higher, as well as wash and operation is more simple. The material contact parts are made of 304 stainless steel (accept 316L stainless steel customized), sealing parts are made of PTFE materials and silicone materials, with corrosion resistance, aging resistance, high temperature, good sealing and so on. Is the food, pharmaceutical, chemical, cosmetic, oil, pesticide and other industries ideal filling equipment.

3. **Model introduction:** This series of filling machine according to the type of material is divided into liquid filling machine and paste filling machine, according to the ffiller type is divided into single head filling machine, double filling machine and without power all pneumatic explosion-proof filling machine And other models. Liquid filling machine for the hose self-priming, paste filling machine for the hopper self-priming

4. Technical parameters

<table>
<tr><td rowspan="8">Technical parameters</td><td>Content</td><td colspan="3">parameters</td></tr>
<tr><td>Voltage</td><td colspan="3">220V±5V 110V±5V(not included explosion-proof type)</td></tr>
<tr><td>Current</td><td colspan="3">1A(not included explosion-proof type)</td></tr>
<tr><td>Power</td><td colspan="3">10W(not included explosion-proof type)</td></tr>
<tr><td>Air pressure</td><td colspan="3">0.4-0.6Mpa</td></tr>
<tr><td>Filling speed</td><td colspan="3">Single head: 10-30 bottles/min
double heads: 20-60bottles/min</td></tr>
<tr><td>Filling precision</td><td colspan="3">±0.5%-±0.1%</td></tr>
<tr><td rowspan="7"></td><td>Model</td><td>Capacity</td><td>Extra Function</td><td>Filling range (ml)</td></tr>
<tr><td>G1WTD-( )</td><td>100( )</td><td rowspan="6">H( )
M( )
HM( )
None( )</td><td>5-100</td></tr>
<tr><td>G2WTD- ( )</td><td>300( )</td><td>30-300</td></tr>
<tr><td>Y1WTD-( )</td><td>500( )</td><td>50-500</td></tr>
<tr><td>Y2WTD-( )</td><td>1000( )</td><td>100-1000</td></tr>
<tr><td></td><td>2500( )</td><td>500-2500</td></tr>
<tr><td></td><td>5000( )</td><td>1000-5000</td></tr>
</table>

5. Model name explanation

G1WTD---Filling capacity (single head table-top paste filling machine)

G2WTD---Filling capacity (double nozzles table-top paste filling machine)
Y1WTD---Filling capacity (single head table-top liquid filling machine)
Y2WTD---Filling capacity (double nozzle table-top liquid filling machine)
Note: If there is H or M or HM signal after filling volume, it means the machine has additional function:

H-------Hopper heating function
M------Hopper mixing function
HM----Hopper heating and mixing function

②. Precautions and factors affected in working

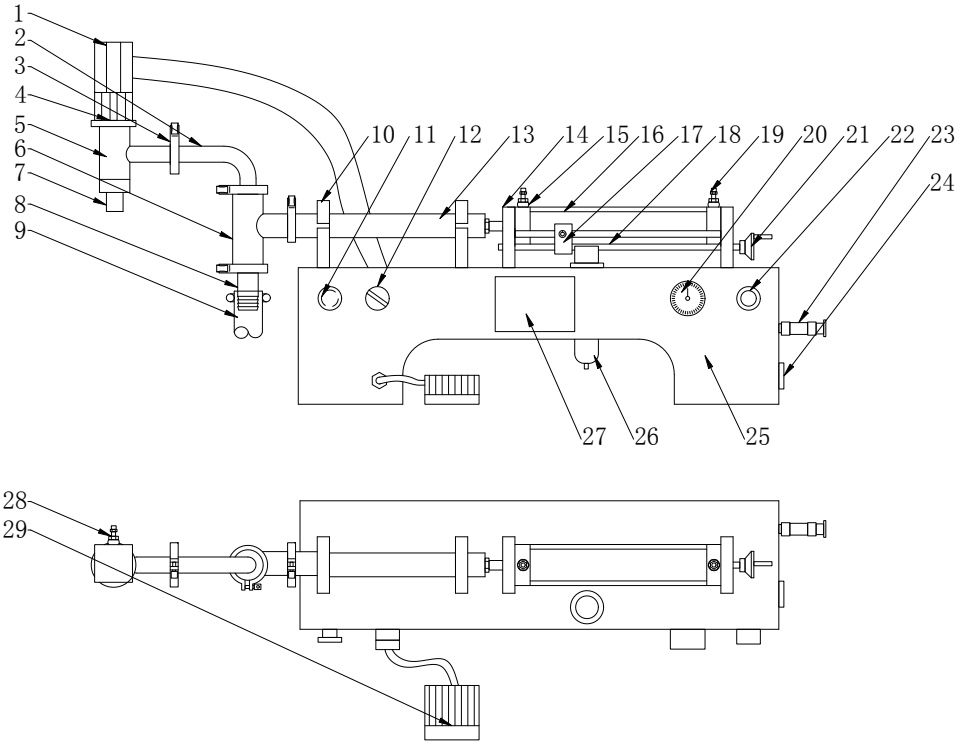
Remark: This type of filling machine is only suitable for filling liquid, low precision paste, or like sauce objects, can not be used for other purposes.
To ensure safe production, please read carefully as blow:
1. Use the machine in line with the provisions of the power and gas (see the technical parameters), in a continuous working state must maintain the stability of the gas source can not be high when low. All pneumatic explosion-proof filling machine is without power.
2. Before washing or servicing this machine before(去掉）, Be sure to turn off the power and gas.
3. The second half of the machine (near the control button) and the lower part of the rack with electrical control components, no matter under what conditions can not be directly washed body with water, otherwise there will be risk of electric shake, damage to electrical control components.
4. To prevent electric shock, the machine should have a good grounding device, please use the machine with a ground power outlet or directly on the body of the grounding device.
5. After turn off the power switch, the electrical control part of the circuit there is still with voltage, Please be sure to unplug the power when repair the line of control.
6. Please do not close to the filling head when working, pay attention to safety!
7. Please do not put your hand on cylinder when working, pay attention to you hand!
8. Before using the material filling(filling materials), it is best to use the cleaning detergent wash the machine first, then clean with water to avoid oil or foreign matter and material mixture, resulting in waste of material and damage to the machine.
9. The hopper should be covered to avoid dust or other debris into the hopper when doesn't work, resulting in waste of material and damage to the machine.

③The work is affected by following factors

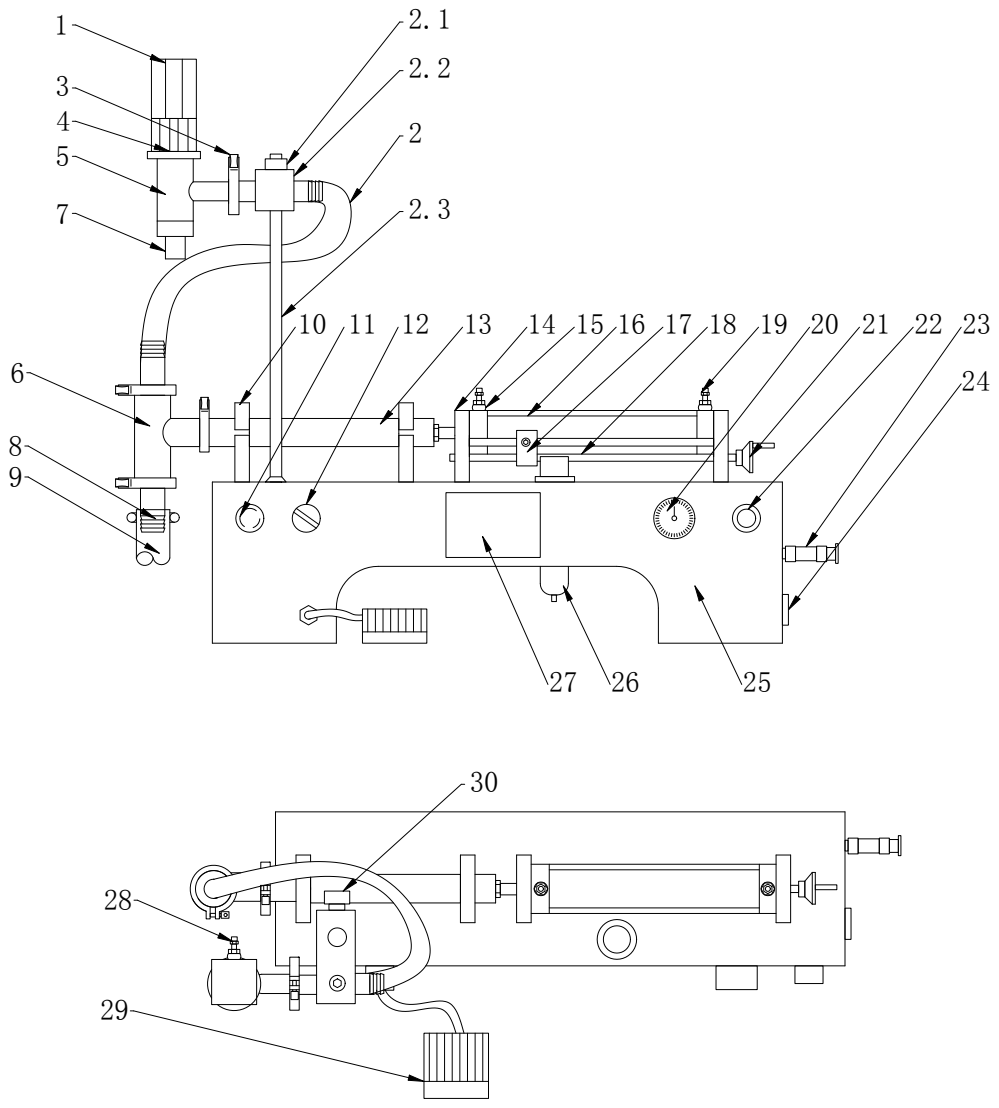
1. Filling precision: the stability of air pressure, the material uniformity, filling speed and so on.
2. Filling speed: the sticky of material, the travel of cylinder, the size of cylinder, the size of outlet, the mastery of the operation master.
3. The machine has two ways operation, with foot pedal switch filling and continuous automatic filling; two filling methods can be switched free. It is recommended first to use foot pedal switch filling.

⑵ Operation and adjustment

①Liquid filling machine

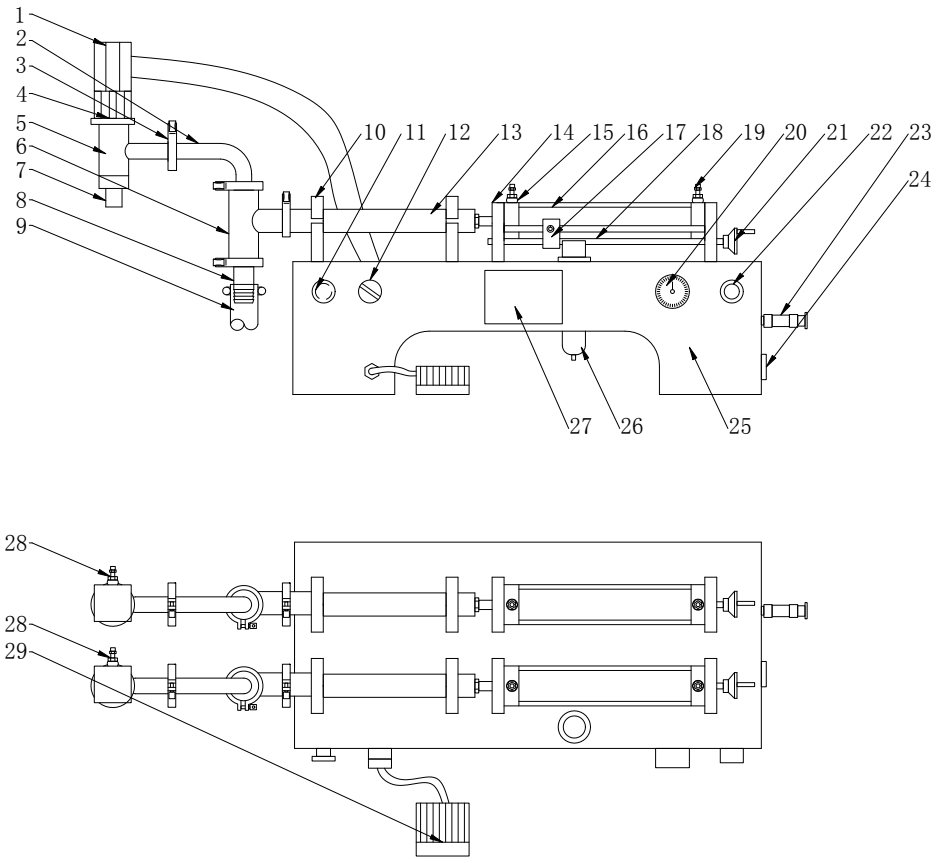


(**Figure 1.** Single head liquid filing machine)



(**Figure 2.**Single head liquid filing machine)

filling nozzle can move



(**Figure 3**. Doube heads liquid illing machine)

1.Lock valve 2 feed corners 2.1 filling the left and right position adjustment screw
2.2 Filling mouth adjustment block 2.3 filling head pillars 3. Clamps 4. Lock core
5. lock three links 6. Feed three links 7. Can change the diameter of the mouth
8. Feed pipe 9. Feed to take over 10. Pump body mount 11. Emergency stop switch
12. Automatically switch the button manually 13. Pump body
14. Filling cylinder mounting seat 15. Filling speed control valve
16. Filling the cylinder 17. Filling the dose of the magnetic switch
18. Dose adjustment screw 19. Automatic mode filling interval adjustment valve
20. Barometer 21. Dosage adjustment hand wheel 22. Power switch
23. Intake pipe connector 24. Power outlet 25. Fuselage 26. Two pieces (pressure regulating valve) 27. Machine nameplate 28. Lock cylinder control valve 29. Foot switch 30. Fill head height adjustment screw

Machine operation steps

1. Place the machine in a ventilated place and place it horizontally on the workbench
2. Check all the accessories are complete and all the fasteners are fastened
3. Inspection （17. The magnetic control switch of filling range） should be in the middle position to avoid the occurrence of debugging dose is not expected or excessive dose caused

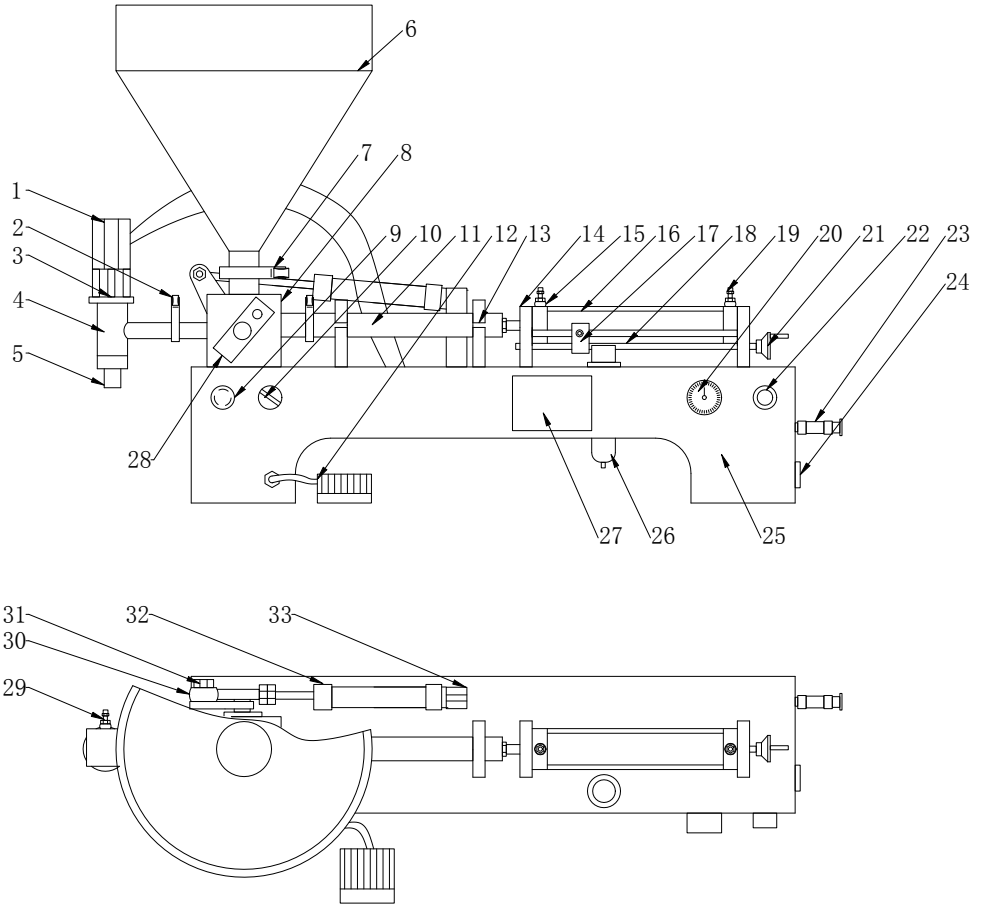
by material waste
4.Filling head is adjusted according to the level of filling containers and shape adjustment. (2.1 filling the left and right position to adjust the drop screw) to adjust the filling head left and right position, adjust the lock after the fixed screw and then release the two (30. filling head height adjustment screw) to adjust the height of the filling head position, adjust the high and low position after locking the fixing screw
5.Power outlet should be well grounded, plug in the power cord, turn on the power switch (explosion-proof filling machine without this step)
6.Connect the air intake pipe to (23. Intake pipe terminal) to open the air supply switch. Pull out the air supply should check whether the air supply switch is off. The air pressure can be adjusted in the upper part of the Two pieces (26. pressure adjustment valve) to adjust, the factory has been adjusted without adjustment.
7.Switch (12. Manual toggle push button)to manual (foot pedal switch) mode
8.Electric(Driven electrical) foot switch until there is material out of the filling head
9.Rotate （15.The adjustable valve of filling speeding）（19.Gas pressure meter） tune out the appropriate pumping speed slow a little (do not make the filling process with the material or bubbles out of the bottle）
10.According to your filling needs through(by) the filling machine on the right side of the dose adjustment hand wheel to adjust the position on the cylinder （17.The filling range of adjustment screw）so as to determine the amount of filling required. To determine the amount of filling the cylinder after the （17.The filling range of adjustment screw） lock, the official start filling（17. The filling range of adjustment screw）position close to the pump is the dose is reduced inversely
11. After working, you can switch the operating mode to "Auto"

Filing precision adjustment

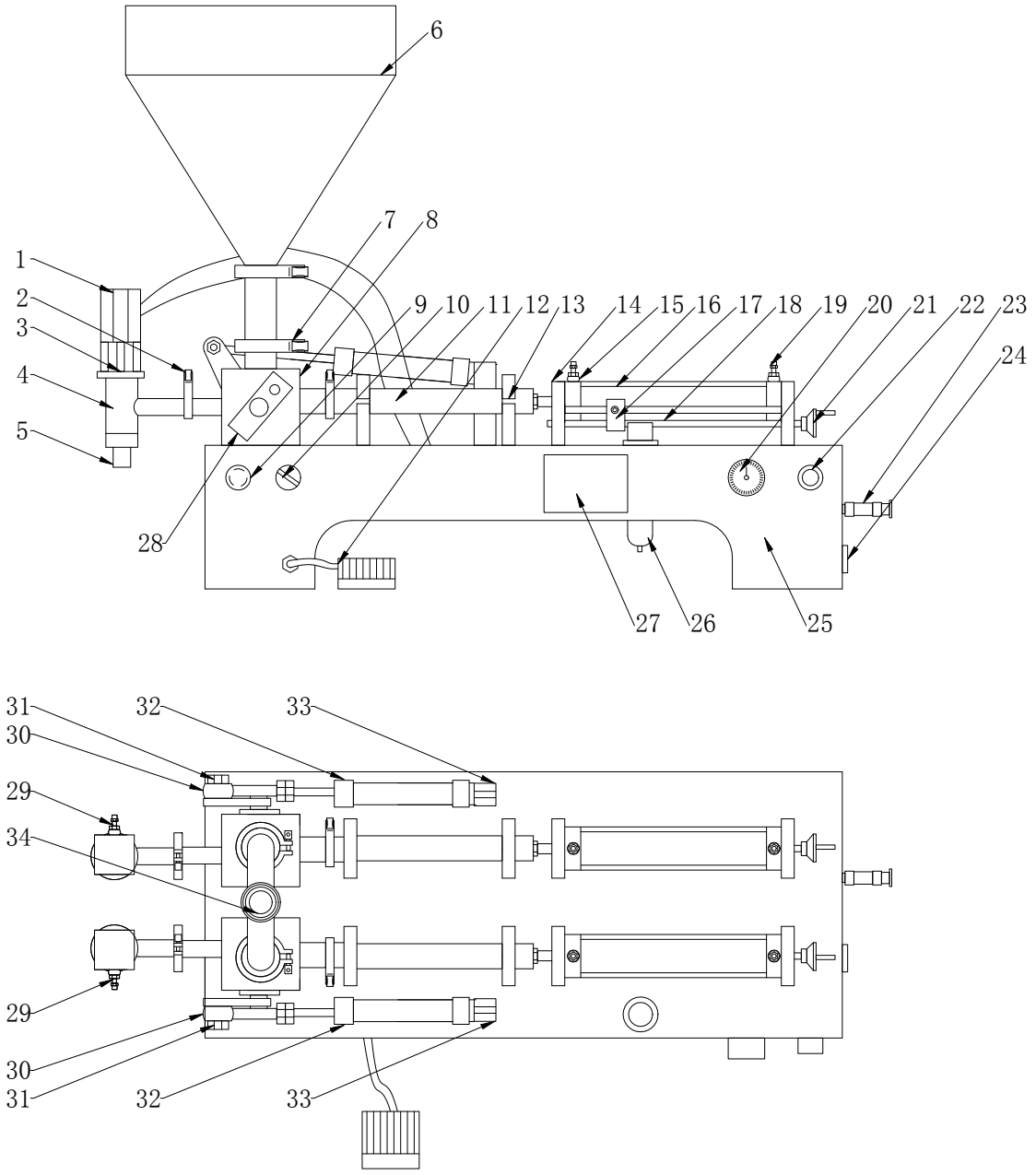
1.The filling error of the liquid filling machine is mainly the filling capacity, the filling speed, the switching speed of the upper and lower valves of the feed three-way control valve, the speed of the valve on and off the valve, the inside of the pump or the silica Type ring, the air inside the feed hose to determine
2.Feed three-way valve and lock three-way valve valve up and down the valve speed and the viscosity of the product. The greater the viscosity, the slower the valve switch
3.Feed the three-way valve switching speed to adjust the valve spring pressure. Spring pressure increases, the valve switching spee is faster. Adjust the spring pressure inside the valve size to have the operator's experience to determine
4.The speed of the two feed three-way valves of the double-headed liquid filling machine is not necessarily the same, depending on the experience of the site production and the operator
5.Double-head liquid filling machine lock-type three-way valve up and down the valve switch the main adjustment (28. Foot pedal switch) two control valve.
6.The filling accuracy depends primarily on the degree of wear of the silicone O-ring on the

pump or piston, as well as the degree of wear on all O-rings and all flat seals
7.Minimize the air in the feed hose, no air condition is the best

②Single head Paste filling machine



(**Figure 4.** Single head paste filling machine)



(**Figure 5.** Double heads pate filling machine)

1.Lock valve 2.Lock clamp 3.Lock core 4.Lock three links 5.Can change the diameter of the mouth 6. Barrel 7. Barrel clamp 8.Paste body 9. emergency switch 10.Automatically switch the button manually(Automatically & Manually switch buttom) 11. Pump body 12. Foot switch 13. Pump body mount 14.Filling cylinder mounting seat 15. Filling speed control valve 16. Filling cylinder 17. Filling dosages 18. Dose adjustment screw 19. Automatic mode filling interval control valve 20. Barometer 21. Dose adjustment handwheel 22. Power switch 23.Intake pipe terminal 24.power outlet 25. Body 26. Two pieces (pressure regulating valve) 27. Machine nameplate 28. Paste pump to the valve 29. Lock cylinder control valve 30. Joint bearing 31. Fixing screws 32. Paste opening and closing valve cylinder 33. Cylinder seat 34. U type tee

Machine operation steps

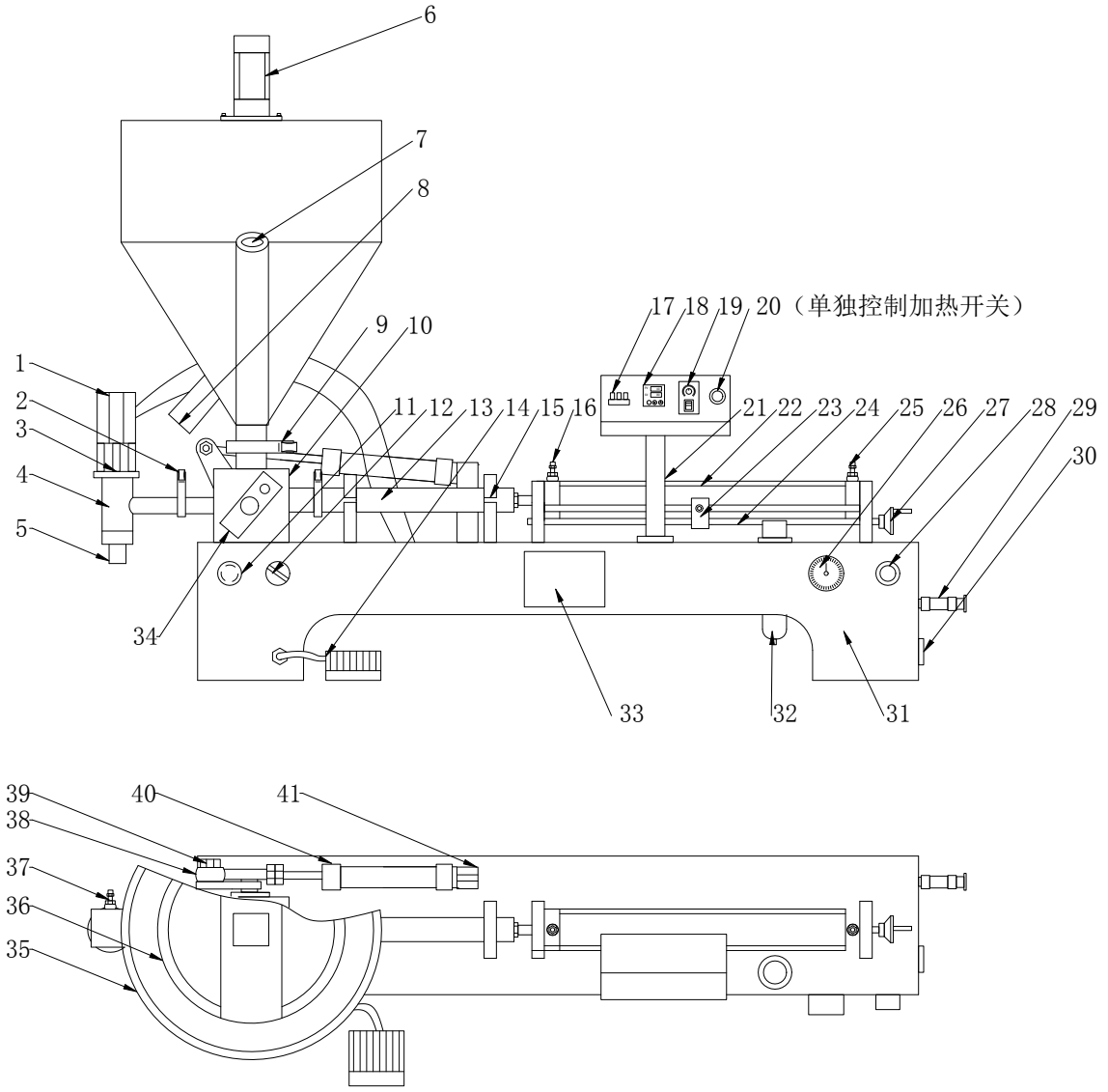
1.The U-type three-head were installed in the top of the (two)paste pump, and locking the clamp, the barrel installed in the U-type three-way above(top), and lock the clamp (single-head models without this step)
2. Install the cartridge above the paste pump and lock the clamp. (Double-headed models without this step)
3.Check (17. Filling dosages) should be in the middle of the position to avoid the occurrence of debugging dose is not expected or excessive dose caused by waste material
4.Power outlet should be well grounded, plug in the power cord, turn on the power switch (explosion-proof filling machine without this step)
5.Place the air intake pipe on (23.Intake pipe terminal) to open the air supply switch. Pull out the air supply should check whether the air supply switch is off. The air pressure can be adjusted in the upper part of the (26. Two pieces (pressure regulating valve) to adjust, the factory has been adjusted without adjustment.
6. Switch (10.Automatically switch the button manually) to the manual mode(foot pedal switch mode)
7. Electric foot switch until the machine is correct(When confirm the electrical foot switch is correct), the material(then put the material)) into the hopper. (In the use of materials before filling(Before filling material), it is best to use the first(detergent) cleaning before cleaning(to) the machine, in the clean with water to avoid oil or foreign matter and material mixing, resulting in waste of materials and damage to the machine)
8. Rotate （15. Filling speed control valve 19. Automatic mode filling interval control valve） tune out the appropriate pumping speed slow a little (do not make the filling process with the material or bubbles out of the bottle(the material or bubbles out of the bottle when it is in filling)）
9. According to your filling needs through the filling machine on the right side of the dose adjustment hand wheel to adjust the position on the cylinder （17. Filling dosages） to determine the filling volume. To determine the amount of filling the cylinder after the （17. Filling dosages） lock, the start filling, （17. Filling dosages） position close to the pump is the dose of the inverse of the large。
10. After working, you can switch the working mode to the automatic file

Filing precision adjustment

1. The filling error of the dispensing machine is mainly determined by the filling speed(capacity), the filling speed, the rotary valve,(flowing feed), the lock valve three-way valve up and down the valve switch speed, the pump body or the piston on the silicone O-ring(the silicone O-ring on pump body or the piston) to determine.
2. Check the position of the adjustment valve, you must keep the two-headed model of the two valve alignment position consistent and consistent action
3. Lock three-way valve valve up and down the valve speed and(concerns to) the viscosity of the product. The greater the viscosity, the slower the valve switch。
4. Double-head model of the two lock three-way valve switching speed is not necessarily the same, depending on the field production and operational experience to determine
5. Double-head model of the lock three-way valve up and down the valve switch speed adjustment of the main（29. Lock cylinder control valve）two control valve
6. The filling accuracy depends primarily on the degree of wear of the silicone O-ring of the pump or piston, as well as the degree of wear on all O-rings and all of the flat seals

7. Can be adjusted by (15. Filling speed control valve) (19. Automatic mode filling interval control valve) to improve the filling accuracy

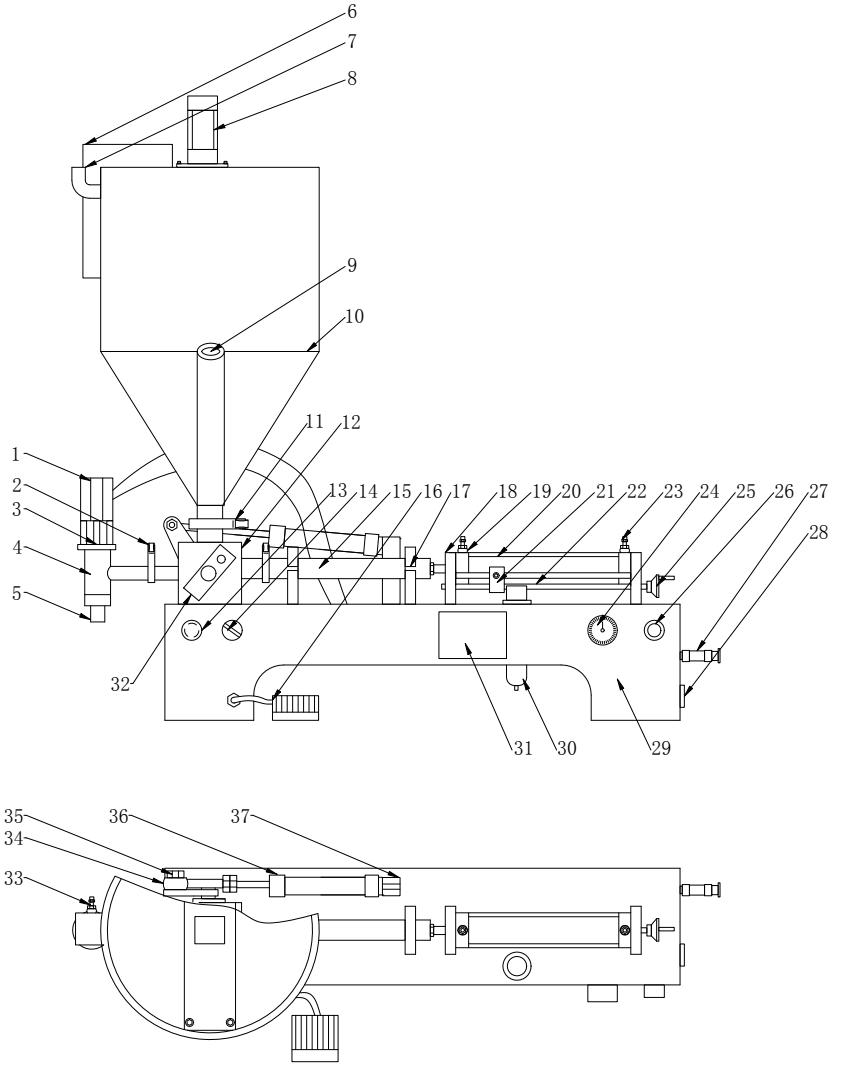
③Machine with heating and mixing

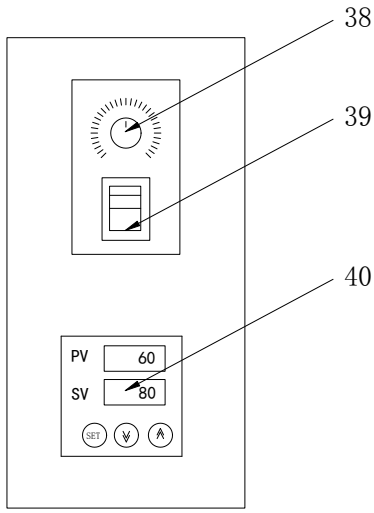


(**Figure 6.** Hopper none closed type)

1. Lock valve 2.Lock clamp 3.Lock core 4.Lock three links 5.Can change the diameter of the mouth 6.control box 7.Heating bucket inlet hole 8.Stirring motor 9.Barrel heating tube 10.Heating cylinder 11.Barrel clamp 12.Paste body 13.Emergency switch 14.Automatically switch the button manually 15.Pump body 16.Foot pedal switch 17.Pump body mount 18.Filling cylinder mounting seat 19.Filling speed control valve 20.Filling cylinder 21.Filling dosages 22.Dose adjustment screw 23.Automatic mode filling interval control valve 24.Barometer 25.Dose adjustment hand wheel 26.Power switch 27.Intake pipe terminal

28.Power outlet 29.Machine body 30.Two pieces (pressure regulating valve) 31.Machine nameplate 32.Paste pump to the valve 33.Lock cylinder control valve 34.Joint bearing 35.Fixing screws 36.Paste opening and closing valve cylinder 37.Cylinder seat 38.Mix the speed control knob 39.Mixing switch 40.Heating barrel temperature controller 41. Cylinder seat





(**Figure 7.** Hopper Full sealed type)

1. Lock valve 2. Locking clamps 3. Lock core 4. lock three links
5. Fill nozzle with changeable diameter 6. Control box 7. Heater bucket 8. Stir the motor 9. Tubing heating pipe 10. Heat the barrel 11. Cartridge clamp
12. Paste body 13. Emergency stop switch 14. Automatically/manually switch the button 15. Pump body 16. Foot switch 17. Pump body set 18. Filling cylinder mounting seat 19. Filling speed control valve 20. Filling cylinder 21. Dose filling of magnetic control switch 22. Dosage adjustment screw 23. Automatic mode filling interval adjustment valve 24. Pressure gauge 25. dose adjustment hand wheel 26. Power switch 27. Intake pipe connector 28. Power outlet 29. Fuselage 30. Two pieces (air pressure regulating valve) 31. Machine nameplate 32. Paste pump to the valve 33. Lock cylinder control valve 34. Spherical plain bearings 35. Fixing screws 36. Paste opening and closing valve cylinder 37. Cylinder seat 38. Stir the speed control knob 39. Stirring switch 40. Heating barrel temperature controller

Machine operation

1. Check （21. Filling dosages）should be in the middle section to avoid the occurrence of debugging dose is not expected or excessive dose caused by material waste
2. Power outlet should be well grounded, plug in the power cord, turn on the power switch (explosion-proof filling machine without this step)
3. Place the air intake pipe on (27.Intake pipe terminal) to open the air supply switch. Pull out the air supply should check whether the air supply switch is off. The air pressure can be adjusted in the upper part of the (30. Two pieces (pressure regulating valve) to adjust, the factory has been adjusted without adjustment.
4. Switch (14. .Automatically switch the button manually) to the manual mode(foot pedal

switch mode)
5. Electric foot switch until the machine is correct, the material into the hopper. (In the use of materials before filling(before filling the materials), it is best to use the first cleaning before(after) cleaning the machine, in the clean with water to avoid oil or foreign matter and material mixing, resulting in waste of materials and damage to the machine)
6. According to the material to set the temperature controller Press the SET button SV window number is flashing, that is, go to set the temperature mode through the button △▽to adjust the temperature. Set and then（then） press the SET button that is the leg temperature setting mode for barrel heating state.
7. Use the knob on the panel to adjust the speed of the stirrer
8. Rotate （19. Filling speed control valve 22.(23.) Automatic mode filling interval control valve）
tune out the appropriate pumping speed slow a little(slower) (do not make the filling process with the material or bubbles out of the bottle）
9. According to your filling needs through the filling machine on the right side of the dose adjustment hand wheel to adjust the position on the cylinder （21. Filling dosages） to determine the required filling volume. To determine the amount of filling the cylinder after (before)the（21. Filling dosages）lock, the start filling,（21. Filling dosages）position close to the pump is the dose of the inverse of the large
10. After working, you can switch the working mode to the automatic mode

Filing precision adjustment

1. The filling error of the dispensing machine is mainly determined by the filling speed, the filling speed, the rotary valve, the lock valve three-way valve up and down the valve switch speed, the pump body or the piston on the silicone O-ring to determine.
2. Depending on the situation of the material to set the mixing speed and heating temperature so that poor mobility of the material flow easy to fill
3. Lock three-way valve valve up and down the valve speed and the viscosity of the product, the greater the viscosity, the valve switch speed slower. Is the field production and operation of the staff to determine the experience
4. Lock three-way valve up and down the valve switch speed adjustment of the two （33.Lock cylinder control valve）main control valve
5. The filling accuracy depends primarily on the degree of wear of the silicone O-ring of the pump or piston, as well as the degree of wear on all O-rings and all of the flat seals
6. Can be adjusted by (19. Filling speed control valve) (23. Automatic mode filling interval control valve) to improve the filling accuracy

④ Speed, Precision and Adjustment

Filling speed is determined by the following five factors

1. Suction speed: depending on the viscosity of the product, the length of the liquid feed nozzle, the capacity of the material in the paste hopper
2. Filling speed: depending on the filling head can change(changeable) the size of the mouth diameter, caliber large filling speed

3. Product bubble speed: high bubble product filling speed should be slow down
4. How much is the amount(Amount) of filling: the amount of filling is much slower
5. Filling accuracy: the higher the accuracy requirements, the filling speed should be slower

The adjustment operation is as follows: Loosen the filling speed control valve and the automatic mode Filling interval The nut on the control valve

1. Clockwise twist the filling speed control valve, the cylinder forward speed slows down, charging speed also slows down
2. Counterclockwise twist filling speed control valve, cylinder forward speed, filling speed is also accelerated
3. Clockwise twist automatic mode filling interval control valve, cylinder back speed slows down, suction speed also slows down
4. Counterclockwise twist automatic mode filling interval control valve, cylinder back speed widened, suction speed is also accelerating

⑶Operation for Manual mode and Automatic mode

Manual and automatic selection switch, mainly for debugging or measurement and set up. When the new machine debugging(debugging the new machine), or product change, or filling the amount of change(changing of the filling capacity), or equipment after cleaning(after cleaning the equipment), it is recommended to use point moving file debugging(debug point moving gear). When the end of debugging(finish debugging), product filling normal(the capacity becomes normal), with automatic file(AUTO) work. Jog and automatic between the free to switch(It can switch anytime between job and AUTO), no need to shut down

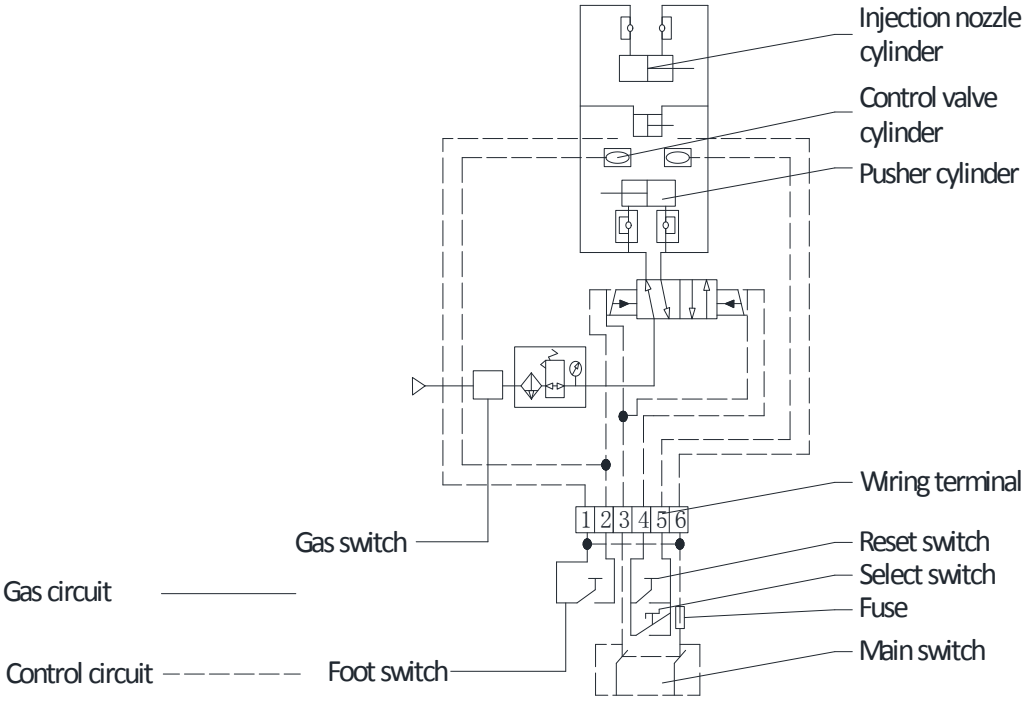
⑷The usage of safety switch

Safety switch, also known as emergency stop switch, in the normal work, the safety switch is disconnected, improper operation of the material loss(when losing material with incorrect operation), you can press the safety switch to avoid waste of material to ensure that the workshop clean

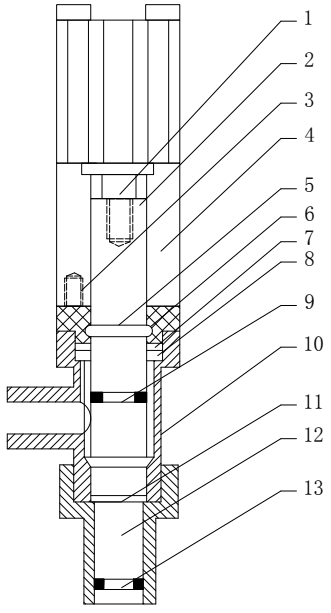
⑸Daily maintenance

1. In order to keep the fuse tube clean, do not use a sharp, hard weapon to scrap the surface, if any stains, please use alcohol to wipe
2. Cylinder in the factory plus a good lubricant, do not open the cylinder or add any lubricants
3. The machine's rotary valve, stainless steel tee, cylinder, filling head, hopper, O-ring, seals and so can easily wash
4. When cleaning is required(When preparing to wash), open the machine and let the machine work automatically until it is clean. It is best to use hot water to clean(wash)
5. If you do not apply the machine for a long time, you can turn the valve, stainless steel tee, cylinder, filling head, hopper, O-ring, seals and other parts of the contact with the material can be removed and cleaned to prevent dry material and Corrosion for next use
6. To always check the pump piston or piston on the O-type silicone ring, filling the head of the O-type silicone ring, control the valve in the O-type silicone ring, three-way control valve in the O-type silicone ring all the clamp surface Seals, etc. are so good, if the wear and tear to replace timely

⑹Electricity diagram and Filling nozzle diagram

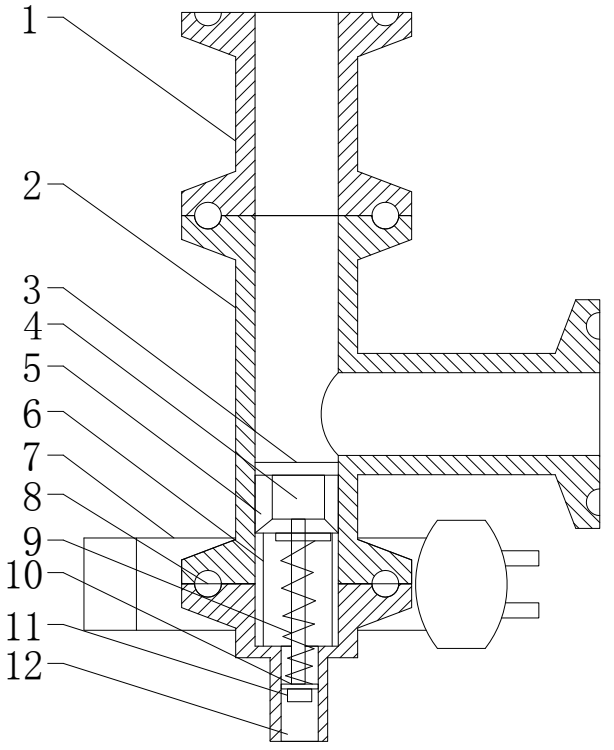


(Figure 8. Electricity diagram)



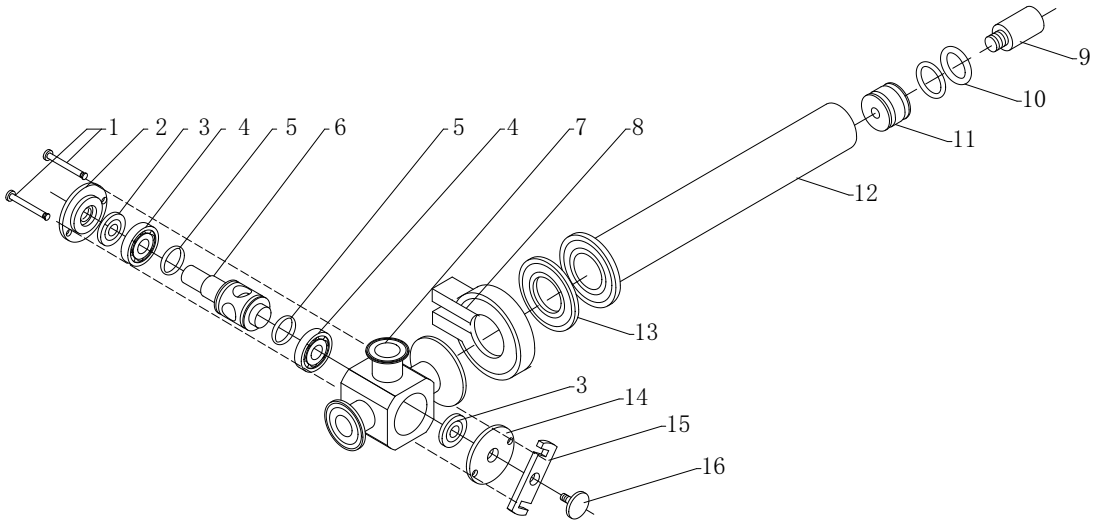
(Figure 9. Three-way valve diagram)

1. Mandrel fixing screw 2. Filling the spool 3. Hexagon socket screws 4. Cylinder support seat 5.O type silicone seal ring 6. Seal the cover 7. Seal the next seat 8.O type silicone seal ring 9.O type silicone seal ring 10. Filling head 11.O type silicone seal ring 12. Changeable filling mouth 13.O type silicone seal ring



(Figure 10. Three-way valve**)**

1. Exit connector 2. Express three-way control valve 3.O type silicone seal ring 4. Check the spool 5. Entrance and exit seat 6. Center frame 7. Clamps 8.O type silicone seal ring 9. Compress the coil spring 10. Compression spring locating seat 11. Hex nuts 12.Entrance connector



(**Figure 11**. Paste Rotary valve diagram)

1. Connecting rod 2. The left flange 3. Seal rod 4. Bearing 5. O style ring 6. Pump spindle 7. Pump 8. Clamp 9. Connecting 10. Piston 11. O style ring 12. Pump spindle 13. Seal rod of pump 14. The right flange 15. Tumbler 16. Locking screw

⑺Troubles and shooting

Troubles	Trouble phenomenon	Troubleshooting
Air cylinder does not work	1.Confirm air pressure(pic one 20)shows if pressure reach the demand and if there is air into machine	This machine can be used by pressure, be reference with the spec of this machine then pull the air in
	2. Confirm power switch(pic one22)open or not	Open the power switch(explosion-proof is no this one)
	3.Confirm air source switch(pic one23)open or not	Open air switch
	4. Confirm magnetic switch(pic one17)open or not	The behind magnetic switch must load the behind of cylinder so the location of cylinder can not remove
	5. Confirm EMS(pic one11)press or not	Rotary witch so return to original location
	6.Confirm the insurance tube	Change new fuse if it break(explosion-proof is no fuse)

	7. Check and confirm the pump piston on the paste controller valve retator chart	Repack the location of piston
	8.Confirm if the pump piston O style rubber stickness to jam the piston	Change O style silicone loop
	9. Confirm(pic nine 2 filler center)jam or not	Repack the location of valve element
	10. Confirm magnetic switch(pic one 17)if the location beyond the biggest capacity	Recall the activity magnetic switch(electrical machine is no this one)
	11. Confirm if the magnetic switch good	Change to new one if damaged
	12. Confirm control rotary valve(pic eleven 15)and pump(pic eleven 12) the location is right or not	Repack if location is wrong(liquid filling machine is no this one)

Troubles	Trouble phenomenon	Troubleshooting
Filling capacity is not exactly or non-dischargeable	1.Confirm if magnetic switch(pic one 17)loose	Lock the front magnetic switch when adjust the capacity in every time
	2. Confirm pic one(15.adjust valve of filling speed)(19.auto mode time of filling adjust valve)close or not	Keep the throttle
	3. Confirm the fill speed is fast or not	Adjust pit one(15.filling speed adjust valve),lower the filling speed
	4. Confirm(pic one6 three-pass valve)or(pic one 15 ratary) is other things or not	Clean it if there are
	5. Confirm(pic nine 2 filling valve element)if jam or later open	If there jam with piston, pack the location of valve element again. If there is later, adjust(pic one 28. Clock cylinder adjust valve)
	6. Confirm the elasticity of the compression coil spring (pic ten 2 fast three-pass controller valve)	Adjust the elasticity of compressed coiled spring, the elasticity does not too large, or non-return valve element can not open(paste filling machine is no this one)

	7. Confirm(pic ten 2 fast three-pass controller valve)in (pic nine 11 six angle screw)if loose or not	Lock if there is(paste filling machine is no this one)
	8. Confirm piston.piston O style silicone.filler's O style silicone.controller O style silicone.fast three-pass controller O style silicone.all of the sealing if they are damaged. Be changed if damaged	
	9. Confirm all of clamp,pickup buckle, tube sealed or not	All should lock and seal, can not air leakage. If the seal seat of silicone is damaged, need change
	10. Confirm pressure is stead or not	Air can not be high and low, must keep same
	11. Confirm if there is enough feed in storage or hopper	Feed can not be much or little, must keep same
	12. Confirm if is air into on tube of the connecting fast three-pass control valve and filler	Reduce the air or pull air out ASAP(filling machine is no this one)

Troubles	Trouble phenomenon	Troubleshooting
It can nor return when stuff jar pull the uppest	Confirm the activity magnetic switch location	Press the EMS, and adjust activity magnetic switch again
The feed leaks from the behind of feed cylinder	1. Confirm the piston of feed cylinder and O style silicone loop is damaged or not	If loop, please lock it
	2. Confirm the piston of feed cylinder and piston rod is solid or not	If loop, please lock it
	3. Confirm if the feed cylinder is on the center of feed cylinder support	If there is transaction of feed cylinder, please install location again
	4. Rare feed too much	Please contact with us
Charging barrel is not heating	1. Confirm if settle the heat temperature	Settle heat temperature according the methods of pic seven
	2. Confirm the heat tube is damaged or not	Cancel or change heat tube
	3. Charging barrel is empty burning without water	Water on heat charging barrel
	1. Check if it is on zero position with	Adjust mixer speed

Without mixing	adjust rotary button	
	2. Check if the mixer motor is damaged or not	Exclude or change motor
	3. Exclude the badness of mixer motor	Check exclude electricity trouble

(8).Packing List

NO.	Category	Name	Unit	PCS	Specification	Remark
1	Technical library	Main	Set	1		
2		Machine Instruction	Part	1		
3		Packing list	Part	1		
4	Spare parts	Seal ring	Case	1	O style,planar	Depending on size
5		“+” screwdriver	Piece	1	Normal	

(9)Warranty Card and Warranty instruction

Warranty Card

Product Name：_____ Customer Name：_____

Item/Specif：_____ Contact address：_____

Factory model：_____ Salesman：_____

Production date：_____ Date of buying：_____

Note: Card is available when salesman Stamps.

Warranty Instruction

According Regulation on National, goods from our factory are guaranteed with repairs and compensations after the date of buying, there are contents below:

1. Buyer must read manual to operate when buy machine.
2. During the guarantee time, it is not in our scope of repair if buyer can not operate exactly, using,maintenance according the instruction, or replace the spare parts by yourselves. Our company still repair but buyer pay the cost.
3. Term of service: The time is one year with the accessories.Electrical components is six months.

After buying machine, buyers need confirm the machine model and the item no. carefully according the invoice and warranty card. If not, contact with us in time and we will replace.

Buyer should keep the buying invoice and warranty card, no replacement if lost, invalid if unilateral amendment. Please show the valid card and buying invoice when repairing.

⑽Certification

Certification

Product Name:_____

Product model:_____

Inspector:_____

Date of production:_____

Allowed factory with qualified product