



MHHD SERIES HIGH EFFICIENCY HOPPER DRYER OPERATION MANUAL

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To all consumers:
You should read through the specification carefully before you install and operate the machine.

1.Summarization

In the installation and use of the machine carefully before reading this instruction manual, lest cause accidents or damaged by the machine.

 Note:The appearance of the high temperature dryer, easy scald, when using, should be careful.

The MHHD series dryer apply to drying all kinds of plastic materials.This dryer by direct installed in molding hosts primarily,with compact structure, convenient operation,sirocco straight blow type design more easily drying raw materials,hot air from down to up through the whole barrel rear out raw material,Let the energy loss to the minimum extent.

2.Characteristic

- (1) With the high-performance spread equably dispersed hot air drying, keep plastic device uniform, enhance the dry efficiency.
- (2) BaiTels and bottom can open, clean material is convenient, quickly replace material.Ensure raw material to prevent contamination.
- (3) Can be connected directly with the plastic machine design, avoid the second damp.
- (4) After drying of raw materials to fall into the injection molding machine thermal state can shorten the dissolution time and improve injection efficiency.

3.The main parameters

By choose molding machine specifications size selection dryer specifica-tion is extremely important, choose excessive waste energy and capital, conversely drying effect is bad, To reach to efficient drying effect, ensure material dry completely, can according to molding injection quantity computation time, its selection method

$$\text{Every hour launch dosage} = \frac{\text{Dryer amount of material loaded}}{2.5}$$

Eg: Every hour lunch dosage bits of 20kg into type, should choose which kind of specification drying.

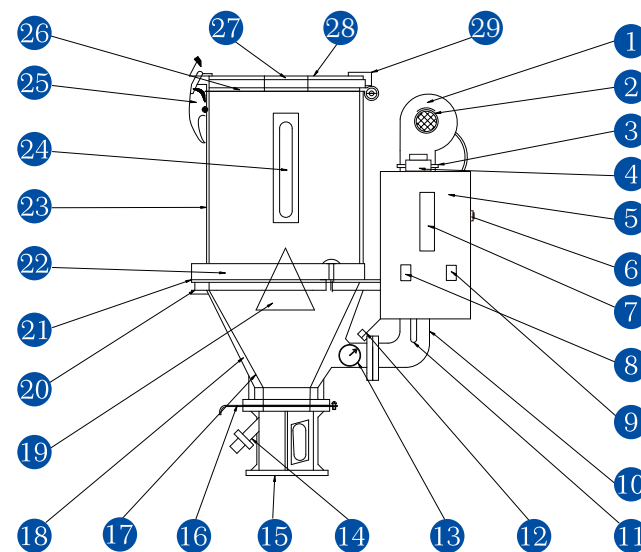
Should choose MHHD-50 or more model of machine.

Model	Capacity	Power		External size	Weight	
	(KG)	(KW)	(W)	(MM)	(KG)	(LB)
MHHD-12E	12	1.8	50	620×400×820	22	48
MHHD-25E	25	3	120	760×500×1040	34	75
MHHD-50E	50	4.5	180	870×540×1210	45	99
MHHD-75E	75	5.5	180	940×600×1310	56	123
MHHD-100E	100	6	220	1020×730×1410	68	150
MHHD-150E	150	7.5	300	1100×770×1760	90	198
MHHD-200E	200	10	350	1200×850×1830	110	242
MHHD-300E	300	15	550	1420×1000×1880	150	330
MHHD-400E	400	15	750	1480×1060×2000	170	374
MHHD-600E	600	20	1100	1580×1160×2380	280	616
MHHD-800E	800	30	2200	1800×1280×2480	360	792
MHHD-1000E	1000	40	2200	2000×1400×2480	500	1100

The above parameters are subject to change without notice.

4.The mechanical structure and working principle

4.1 Structure schematic



- | | |
|--|---------------------------------|
| 1. Blowers | 16. Material sluice |
| 2. Wineregulator | 17. Protection screen separator |
| 3. Flange | 18. Dust collector |
| 4. Alarm light | 19. Export screen separator |
| 5. Control box | 20. Under close blade |
| 6. Overtem perature controller | 21. Rubber MATS |
| 7. Automatic temperature regulator | 22. Lower ring |
| 8. Electric switch and indicator light | 23. The dry room |
| 9. Blowers switch and indicator light | 24. Visual material box |
| 10. Duct | 25. Handle |
| 11. Electric heating tube | 26. Annulus on |
| 12. Feeling temperature | 27. Vent |
| 13. Metal temperature form | 28. Lid |
| 14. Check materials export | 29. Sco blade |
| 15. Assembling base | |

4.1 Drying principle

Wind machine blower blew out of wind, through high temperature electric heat pipe become hot air temperature control instrument, then after electronic control, in the proper temperature into special structure of hot air chamber, forming an average of pressures uniform particles in the air drilling raw materials by under all the way along the way for heat roll, promote dry, take away the moisture, then the vent to discharge. Resin, namely accept input from dry, in by go up and down slowly drop process, continuously for drying, water gradually decrease, repass screen and protect screen separator separation, separate after drying, raw material with thermal state into molding machine inside, so complete efficient continual drying effect, shading screen and holes will directly influence the stand or fall of drying effect.

5. The drying time and temperature

5.1 The drying time

In began to take shape before work, must make raw materials drying, to ensure sufficient and dry 100% molding rate. Appropriate selection of drying temperature and can adjust the fan flow, the material in about 2.5 hours to reach the required amount into forming a dry work, as long as timing molding supplement materials can continual drying need not discontinuous.

Note: In dry process, must keep always bucketful, in order to ensure the machine life, reduce energy consumption and drying effects.

5.2 The drying temperature

All kinds of raw materials of the drying temperature, please refer to the table and raw material factory of data, and must consider sirocco cannot make material dissolves agglomerate, cooperate grain practical experience, the discretion to determine the right temperature. This dryer in materials due to the bottom of drier by raw material itself flows into machine, when the temperature is high, the raw material flows through protect screen separator nearby easily agglomerate, blocking the whereabouts of hot air passage and raw materials, so that the failure. Therefore the drying temperature the choosing principle is guaranteed to particles don't happen agglomerate phenomenon under the premise of get good drying effect.

Plastic raw material drying temperature reference table

Material name	Centigrade	Fahrenheit degree
PE、PP、PS	80°C	176°F
NYLON	80°C	176°F
CELLULOSE、SERIES	75°C	167°F
ACRYLIC、ABB、AS	82°C	180°F
POLYCARBONATE	120°C	248°F
PVC	70°C	158°F
PET	180°C	356°F

6. Installation And Use

6.1 Installation

Will this dryer base bored after, erect in plastic injection moulding machine feeding port, tightening bolt connection with fixed, and set good grounding wires.

6.2 Connect the power

Three-phase four wire 3 80/220/460v.60Hz. Will distribution box open, reference wiring diagrams, connected to the power source, and power, voltage should pay attention to whether conform to, the power switch specifications and load protect rated whether recognition, and start blowers check rotation direction correctly.

6.3 Adjust wind

Reference plastic raw materials of the drying temperature reference table, according to practical experience in electronic temperature control instrument regulating discretion. The first use of process, contrast temperature control instrument and metal pointer table, such as whether index inconsistent with different temperature control instrument must be adjusted to the instructions of electronic scale, make correspond.

6.4 Conditioning wind

Conditioning wind, directly affecting drying effect, general with full open when the best effect, if encounter inside bucket material is not much, or need to high temperature, can according to need to reduce a little air volume reduce energy losses, otherwise cannot achieve the desired drying effect.

6.5 Add Raw material

Must ensure that "bucketful" dry, namely inside bucket materials should be not less than 70% of the container, in order to ensure the machine life, reduce energy consumption and drying effects.

6.6 Transparent material drying

Must in wind path device air filter "sponge" etc, prevent dust into the air.

6.7 Preheat barrels

Adding material, before barrels of heat, the internal moisture drying. Preheat 10 to 20 minutes.

7. Repair And Maintenance

1). Cleaning mesh

Import nets regularly inspecting, regular cleaning, when filter blocked, into the air volume decrease, influence drying effect.

2). Cleaning separator

Replace raw material, separator should brush clear after add new material.

3). Clean the hopper

In dry process, powder material into hopper, time deposit, therefore, need regularly cleared. A. The first remove the filter when clear; B. Cleaning the hopper within particle; C. Pack screen.

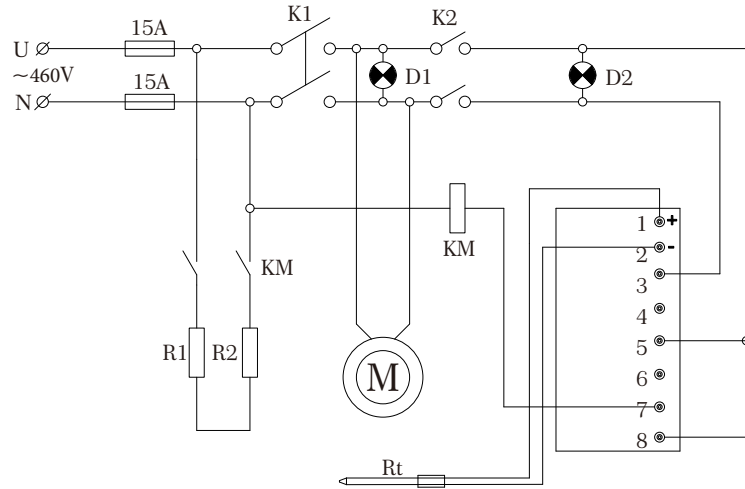
4). Protect screen cleaning raw material caking

For example, the temperature is exorbitant, raw material to be protecting screen, raw material caking cannot fall, right now prohibits the use of iron stick the content such as chipped to defend screen separator is impaired, should be removed. Feeding barrel decomposition

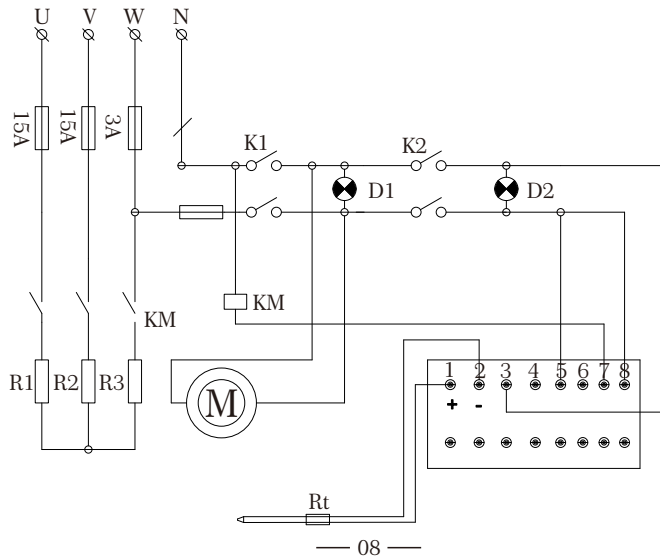
5). Shutdown, the heating should be turned off after ten minutes, then shut down the wind, so as not to shorten the life of the machine. Reduce energy consumption and drying effect.

8.Circuit

MHHD-12 to 25 model plastic dryer circuit



MHHD-50 to 1000 model plastic dryer circuit



WARRANTY CARD		
Inspection Date:		
Inspector Code:		
MAINTENANCE RECORDS		
Fault	Maintenance	Recovery Time

(Be valid by means of the official seal)