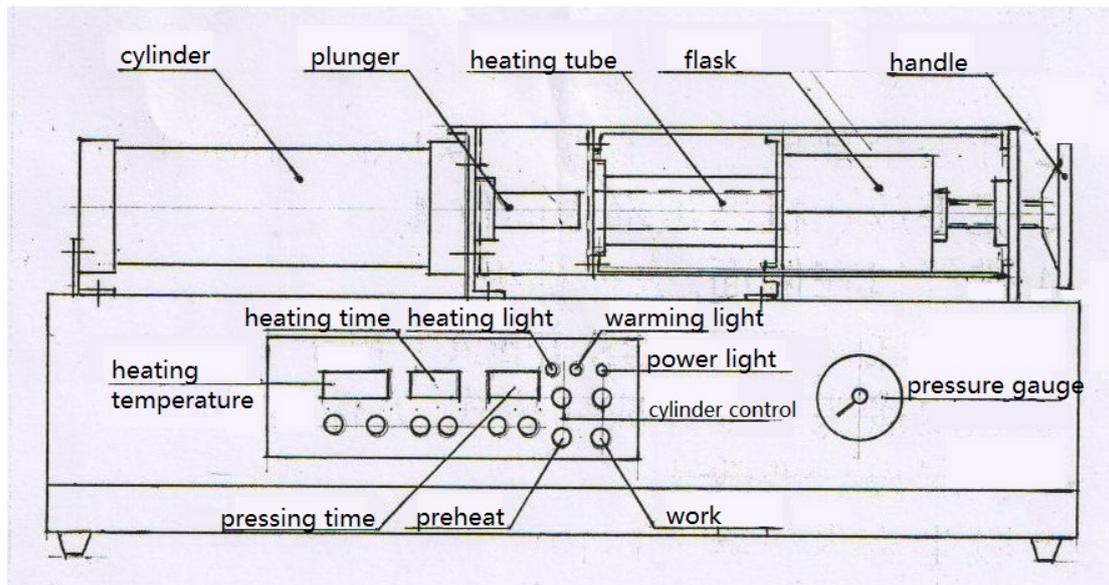


# **USER MANUAL**

*AX-YDA*

*Injection System*

## I. Diagram



## II. Specifications

Voltage: AC 220V 50Hz (AC 110V 60Hz)

Power: 450W

Temperature: 260°C~310°C

Working pressure: 0.6 Mp

Dimension: 800mm(length) x 220mm(width) x 320mm(height)

Weight: 36 kg

## III. Before use

Check the machine after unpacking. The machine should have no damage on it.

Place the machine steadily on a working surface. No inflammable object or object vulnerable to heat should be placed within 400mm to the back of the machine.

The supply power should be AC 215V~230V (AC 105V~120V), **a well-connected ground wire is ABSOLUTELY NECESSARY.**

The pressure of the gas source should be able to reach and stay steady between 0.8Mp~1.0Mp.

Read this instruction carefully before using the machine.

## IV. Usage and maintenance

1. Plug in the power cord, switch on the power switch on the side of the machine, the green indicator light on the upper right corner of the control panel is on.

The default settings are displayed:

Preheating temperature--287°C; heating time--12m; pressing time--15s.

The user can adjust the settings by pressing ⊕ ⊖ buttons under each display window. Adjusting ranges are:

Preheating temperature: 260°C~310°C

Heating time: 10min~20min

Pressing time: 5s~25s

Connect the gas pipe of the gas source to the gas inlet at the back of the machine.

Adjust the gas source pressure to 0.6 Mp.

2. Press the preheating button. The temperature display switch from preheating temperature to room temperature. The heater begin to work. The red indicator light for heating on the upper right corner of the control panel is on. The temperature display goes up as the temperature rises.

When the temperature reaches the pre-set value, the beeper beeps 5~8 seconds, indicating the user to proceed. The red heating indicator is off, and the green indicator for warming is on. **(Note: for better warming up of the machine, each time you use the machine when it has completely cooled down, wait for 5 minutes after preheating is finished before proceeding with cartridge heating and pressing)**

3. Put the copper gasket and cartridge (apply silicon oil to both of them beforehand) into the heating tube.

**★Attention: To avoid burning, do not touch the heating tube directly with hand.**

**Put in the copper gasket first, then the cartridge, with the curling end heading right.**

Put the flask on the platform in proper position. Turn the handle clockwise to make to flask closely pressed against the heating tube.

4. Press the work button. The countdown of heating time begins. During the heating process, heating indicator and warming indicator will be on alternatively according to

the instant temperature.

When the heating is finished, the beeper will beep 2~4 seconds. The heater stops working. The heating and warming indicator both goes off.

Pressing begins automatically, as well as the countdown of the pressing time. The cylinder presses the melted resin in the cartridge into the flask, at the pressure of 0.6 Mp.

When the pressing is finished, the beeper beeps 5~8 seconds. The cylinder plunger withdraws automatically.

5. Turn the handle anti-clockwise to take the flask out. Press ⊖ button controlling the cylinder to push the copper gasket and cartridge out of the heating tube. Then press ⊖ button so that the cylinder plunger is back to its place. The whole working process is finished.

Clean the heating tube and the platform to get ready for the next working procedure.

6. When the working hour of each day is over, turn off the machine as well as the gas source.

If the machine is not to be used in a period of time, unplug the power cord and disconnect the gas pipe.