

# **The Instruction of QH Horizontal Automatic and Continuous Foaming Machine**

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# **Brife Instruction**

## **1. Preface**

This manual is mainly used for users to install、 set parameter、 diagnose fault、 get rid of and normal maintain the continuous foaming machine. In order to use this machine properly, please read this instruction before starting up.

## **2. Main technical specifications and parameters**

This equipment is on trail of 6-100KG/M3 hard/ soft PU foaming production. It's applicable to furniture、 bra、 shoes、 garment and so on. PLC operation system、 automatic program、 low production cost are large-scale manufacturer's ideal equipment .

Length: 8M

Adjust width: between 1 M-2.4M

Power of mixing head: 37KW

Total power: 2 KW

Foaming height: between 0.5-1.3 M

Foaming width: between 1-2.3M

Outside size [L\*W\*H] : 34000\*4550\*3100

Dynamo and reduction gear please find out in contract configuration

### **3. Construction and principle**

1. QH 2011 foaming line is made up of material tank, foaming rack, electric controller, mixing head organization, cut-off machine, conveyor device and so on.
2. Material tank is made according to the quantity of customers' contract. Definite setting is on customers location standard.
3. Foaming rack includes oven, side link plate transmission, blanking plate, foaming box transmit system.
4. Electric controller includes controller electric box, cut-off box, stirring electric box and above equipment Electra-mechanical transmissions.
5. Mixing head includes loading material square system and TDI loading blanking plate and so on.
6. Cut-off machine is made up of drive mechanism, roller rack mechanism, transmit mechanism, foaming box belt, fast deliver foam mechanism and back transmit mechanism.

#### 4. Installation and notes

Install condition

Ambient temperature : -10--+40

Relative humidity : 60%-95%

Atmosphere pressure : 86-406KPA

Install order: platform——mixed erection fixture——foaming box  
——transmit belt ——cut-off machine——back  
transmission and material tank

Steps and notes:

1. This machine's installation is more complex and more strict. Customers area must solid. Use screw to fasten feet after make sure the machine leg is level, and then fixed by concrete.
2. Maximum error of total transmit belt is 5mm.
3. Transmit belt installation requires neat and unify, manual debug when finished installation, in order to keep no noise and trouble.
4. Pipe installation requires neat in sure to keep pipe smooth 、 guarantee air pressure test and ensure that install electric box and electrician do not exposure the wire, keep horizontal and vertical effect.
5. When operation, no skilled electrician please don't open the control box's door in sure to keep safety.

6. Machine's operation power supply is triphase and four-wire of 380VAC-50HZ, control power supply is 220VAC. Remember not connect wrong, otherwise will burn up dynamo.

## **5. Operation and notes of cut-off machine**

Operation [ reference on operation panel]

1. When the light turns red, press main power supply button to start power supply.
2. Start knife belt power supply and then start sharpen engine.
3. Make sure there is no trouble after move the manual controller front and back, left and right. Manual adjust cylinder according to foaming width. According to the specification of foam to choose automatic or manual cut. The length of knife belt is 6270.

## **6. Notice of safety precaution**

1. Machinery electrical equipment must be maintained well.
2. No professional cannot open the electric box arbitrarily, otherwise maybe cause personal injury. Repair mechanical electricity must be professional. When repair, machine must be off position, turn off all the operations. For example, in case of turn on the air pressure or hydraulic device inattention, attaching yellow warning“ Please keep off the switch when repair”. Make sure the power supply be cut off before open the electric box. If it must be repair with power on,you should take corresponding safety precaution in order to avoid risk of shock.
3. Adjust fuse wire, keep the same current value as original, No allow increase arbitrarily.
4. NO allow supply voltage exceed 10% of engine electrical equipment voltage to avoid insulation and burn-in of electrical equipment.
5. Keep abrasion wheel shield、 belt shield、 knife belt shield and so on in good shape when operation, No allow dismantle arbitrarily.
6. Keep people off the machine when operation in case of risk.
7. Make sure keep hands and other things off the belt,chain and knife belt when operation.

## **7. Cleaning and maintain**

1. Keep clean electrical equipment frequently against grease and dust.
2. When short out, change by same volume fuse, tin or silver, suggest no substitute by copper wire.
3. Use kerosene or diesel clean the rolling bearing every one month and change cleaning grease. Clean greasy dirt after everyday's work then add grease.
4. Check the insulation of electricity when stop working in moist season (especially exceed a month), it should be dehumidification which use reduce voltage to 1/3 rated voltage and idle the engine for 48 hours avoid moisture, then rework to rated voltage.
5. Attention that machine landing in good shape, it should be clean if there are greasy dirt or rusting in landing screw's face.
6. Attention that if there are broken roll, snap or damage phenomenon in exposure tube or wire.
7. Check the sensitivity of contact and locking device.
8. Use the machinery equipment according to the instruction.

## **8. Using and cleaning of mixing head**

In order to keep long-term and stable working, the key point is cleaning and maintain mixing head. Please do as follows:

1. As soon as the machine ending work, use MC clean the TDI air-valve and back loading material main tube manually.
2. Turn off the disk valve, then turn on MC pump manually, stop it when pressure gags shift to 1.5KG..
3. Keep the speed of mixing head engine at 1000 per 5 minutes, then open all disk valves and clean them with a MC bucket, draw MC into the tank.