



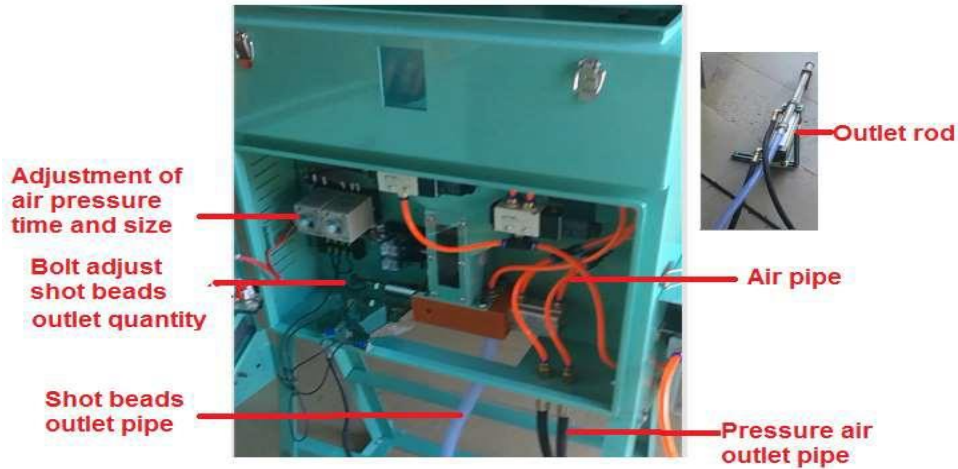
Shot Beads Dispenser Manual

Shot Beads Dispenser is used widely in die casting industries, it works automatically, Simple to operation, increase the speed of shot beads injection, so it could help you save time and labor costs; use very little Electric, save manufacture cost; no oil and gas pollution, free from dirty process, keep plants work environment clean, and also increase plant safety,

Part One:

Parts-Details of Shot beads dispenser SBD-T





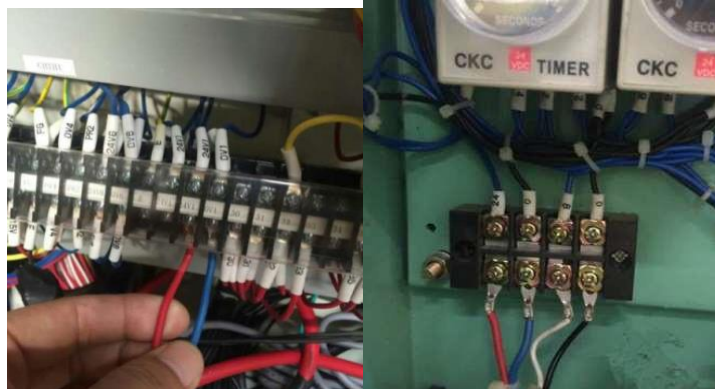
Part Two:

Installation

1. Put the dispenser on the suitable place beside die casting machine.
2. Connect the Power--Joint the wire write 24V with the right connection which marks 24V on die casting machine.



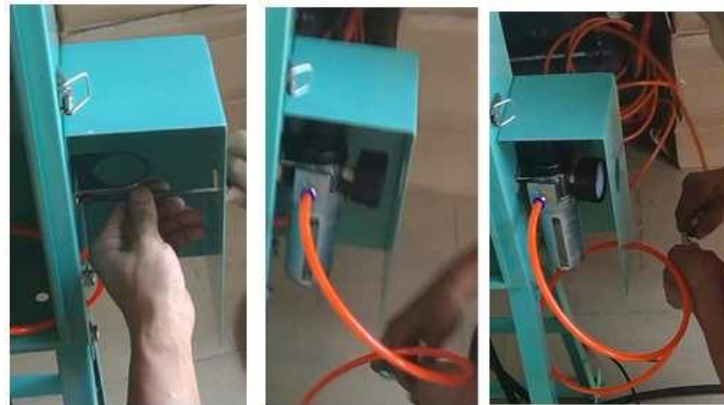
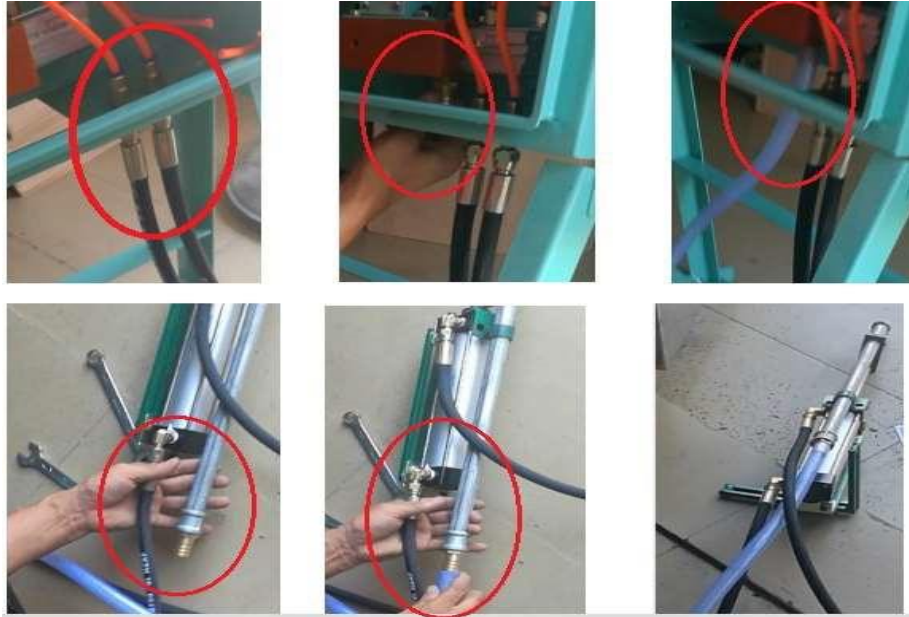
3. Connect the signal wire-connect wire #8 to the signal line of die casting machine.
If old style machine, it connected to the back valve.
It related to the outlet rod extend and shrink, so that the dispenser could put shot beads into die casting machine properly.



4. Install the outlet rod and gas pipes, shot beads delivery pipe, gas filter pump.

It should adjust according to the position of die casting machine.

Remark: please Push the material gas cylinder rod to the top, the material outlet rod pot should higher than injection port about 2cm, it must not too high, or the shot beads will drop out; then put the soup feeding pot put at the side of outlet rod pot, make sure the two parts not hit or against each other. When the outlet rod adjust well, should block/fix it with rack.



Part Three

Test the dispenser machine

- First switch on the power, make sure the power is on.
- Open the Valve of gas adjustment, adjust the gas pressure to 4-6kgs. (It should adjust

to the most suitable size, not too bigger or smaller, or the shot beads will shot out of machine.)

c. Adjust the number of shot beads quantity. When adjust the bolt left or right, when the bolt will go ahead, the shot beads outlet number will be less, when the bolt turn back, the shot beads number will be more, when adjust the most suitable site, please keep control nut tight.



d. Adjust the time control.

TIME 1 : Control the time of Outlet rod stop at filling port.

TIME 2: Control the time of gas pressure blow the shot beads.

e. Adjust the gas pressure size, it controlled by the relief valve, normally the pressure 1KG is ok.

Part Four

Sort and fix all the wires and pipes, keep the floor clean, and the machine is ready for work.

Part Five Maintenance and problem solution

A . The shot beads don't shoot out.

1. First check if the dispenser is working, confirm the power is on; if the power light not bright, check the power fuse is OK or not.
2. Check if the signal light bright, make sure the Electrical relay is working.
3. Check the electric valve is working or not.
4. Check if the pipe is broken.
5. Please check all the nozzles are jam or not; if jam, please pull out the pipe, press the electric valve test button, Push the sliding block to check if shot beads out; if shot beads out, please adjust the pressure bigger; if shot beads not come out or the block could not slide, please check if the gas too wet so the slide become bigger cannot work well, please

loose the screw of the slide, at last, please check the gas cylinder is ok or not, off let the water in gas cylinder in time.

B. Shot beads drop out the die casting machine

- a. Adjust the time click to control the rod stop time.
- b. Adjust the time click of gas come out time.
- c. Adjust the gas pressure size.

C. Check the machine every day, put the lubricant oil of die casting machine and off let water out of gas cylinder in time; should keep the air dry, if air too wet, it will let the shot beads wet, and influence the electric valve and sliding block working.