









SA41542



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綠盆/ROTATE

失 開
ON

電源开关/POWER

失 開
OFF ON













TO ALL STAFF

ANYONE FOUND USING
STEEL IMPLEMENTS OR A
SCREW DRIVER INSTEAD OF
A BRASS ROD WILL BE
DISMISSED IMMEDIATELY.

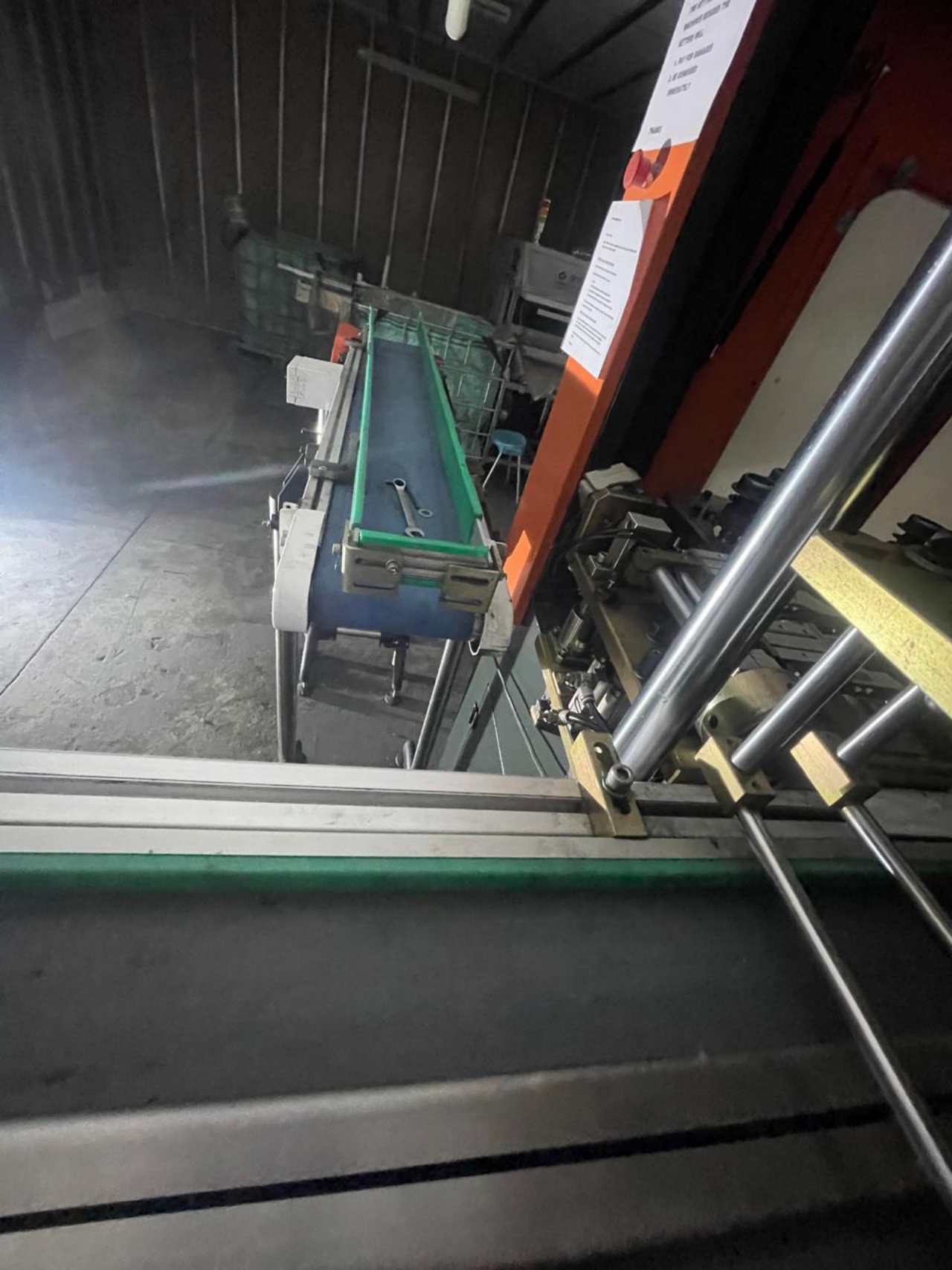


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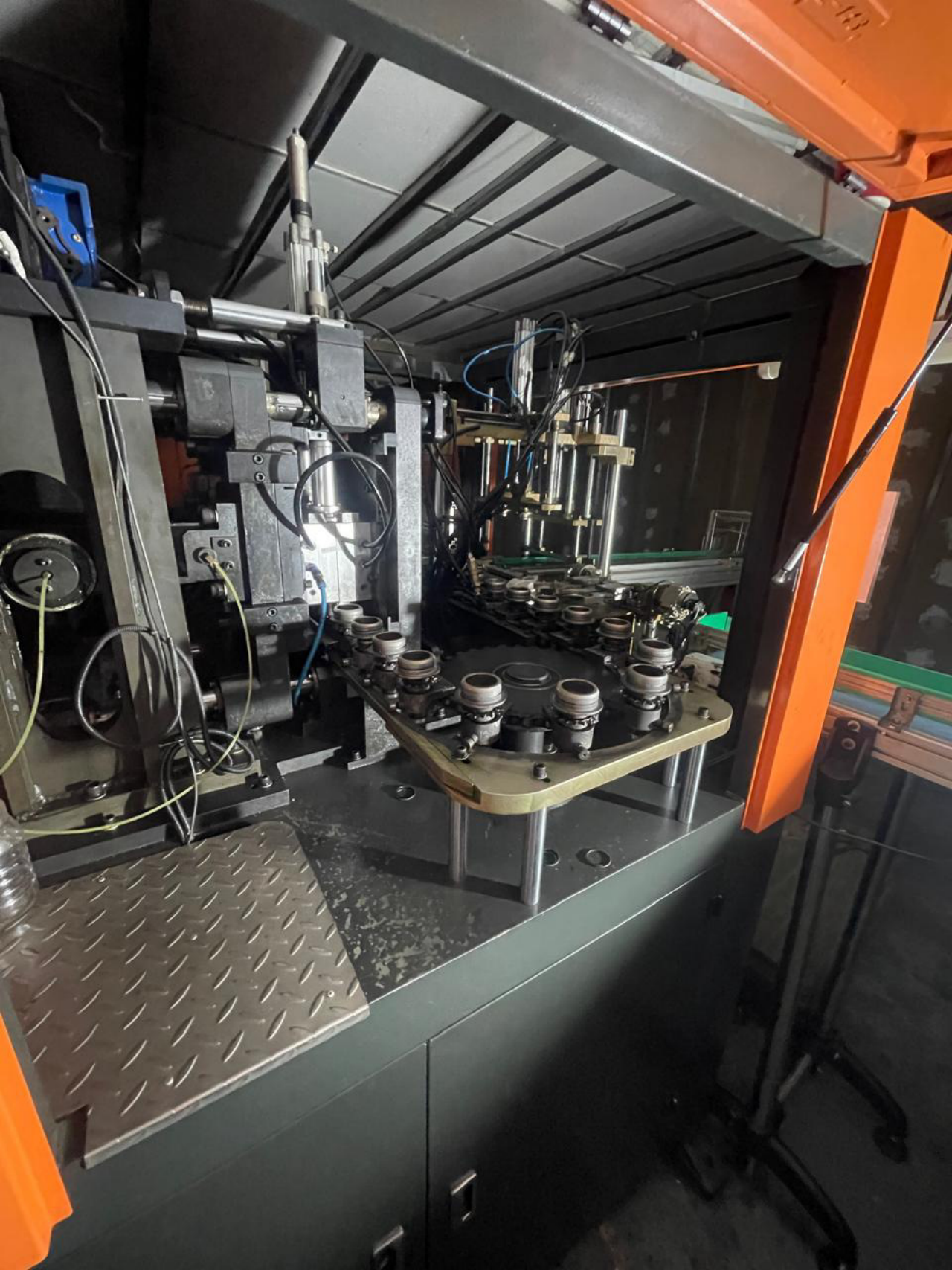
TO ALL

ANYONE
STEEL IM
SCREW DR
A BRASS R
DISMISSED



THESE TESTS
SHOULD BE DONE FOR
1. 100% OF THE
2. 100% OF THE
3. 100% OF THE
4. 100% OF THE

TESTING
PROCEDURE
1. 100% OF THE
2. 100% OF THE
3. 100% OF THE
4. 100% OF THE





107 NOVEMBER 2011

ARTICLE THAT CHARGES
THE SETTING ON THE
REARWARD BRIMMED THE
DEVELOP WILL

1. PAY FOR REARWARD
2. BE CHARGED
REARWARDING 1

THANKS

TO ALL STAFF

ATTENDING PHOTOS DURING
STREET DEMONSTRATIONS OR A
SCENE DRIVEN INCIDENT OR
A SCENE WITH VIOLENCE OR
DISORDERLY BEHAVIOR





Warning
Do not touch the work area
during operation

PLEASE KEEP
YOUR WORK
STATIONS AND
FACTORY
CLEAN BEFORE
YOU LEAVE
YOUR SHIFT



烘道温度
OVEN TEMP



A 温度调节
TEMP. ADJUSTOR A



B 温度调节
TEMP. ADJUSTOR B



C 温度调节
TEMP. ADJUSTOR C



D 温度调节
TEMP. ADJUSTOR D



E 温度调节
TEMP. ADJUSTOR E



F 温度调节
TEMP. ADJUSTOR F



G 温度调节
TEMP. ADJUSTOR G



H 温度调节
TEMP. ADJUSTOR H

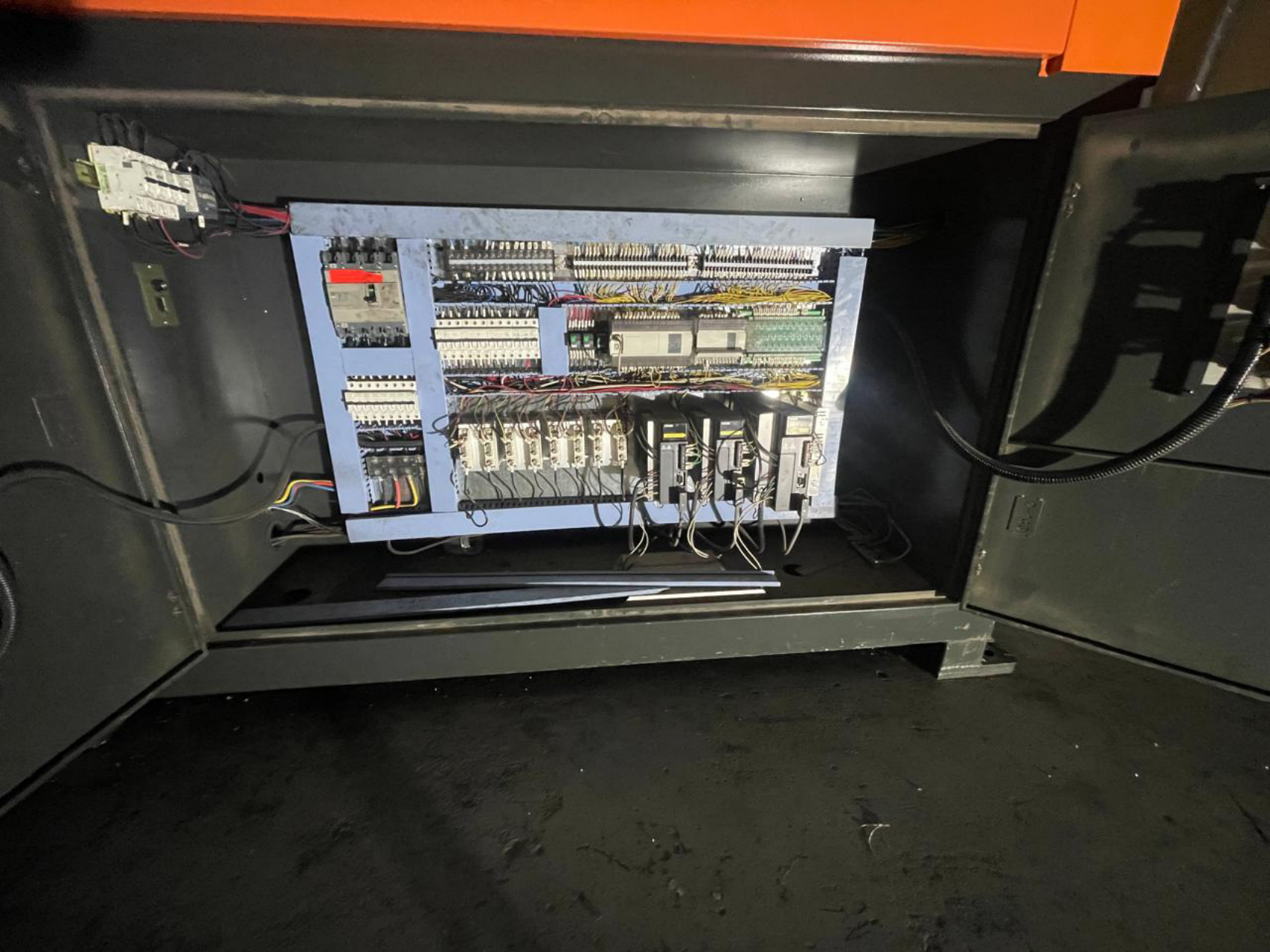


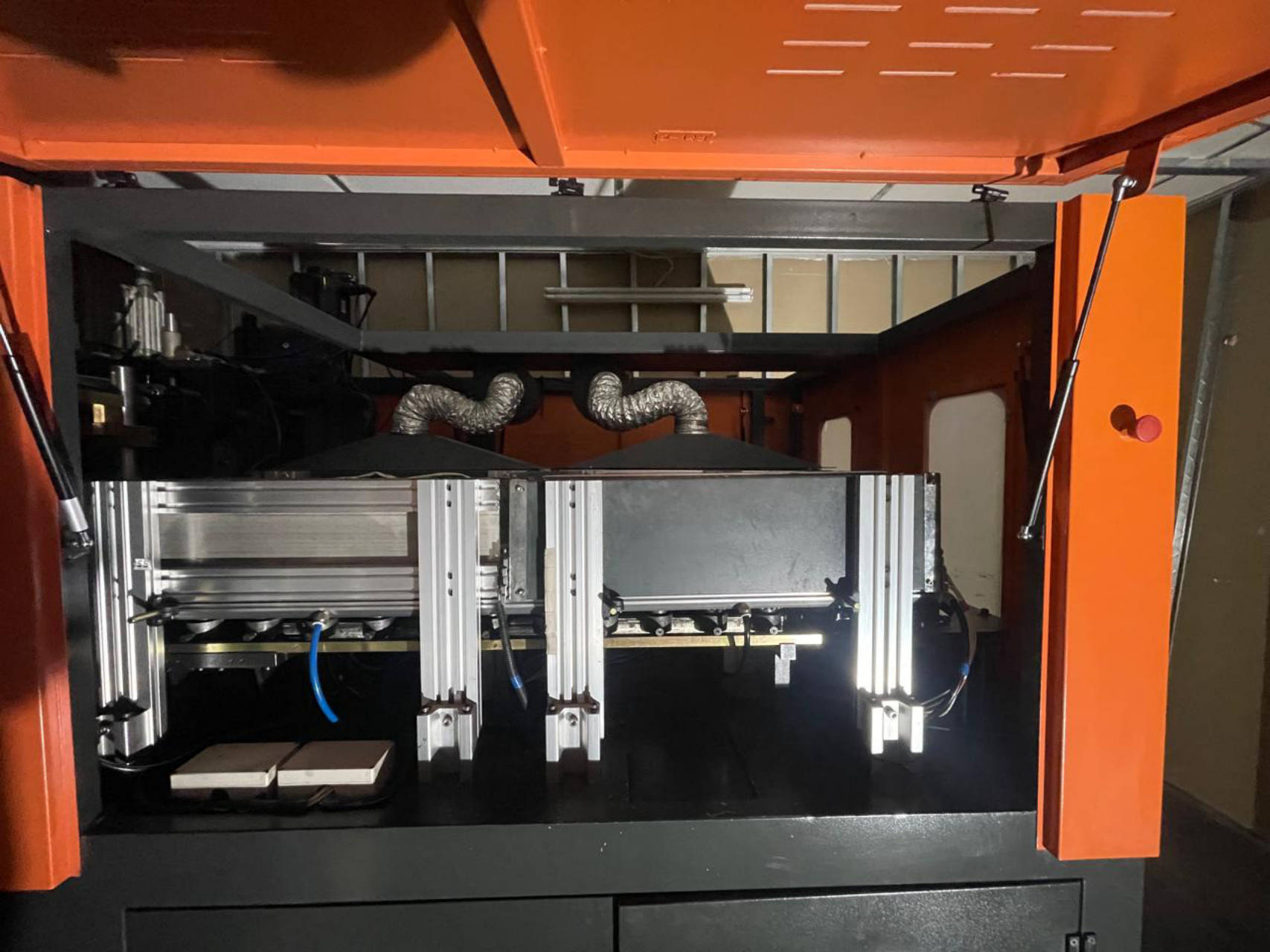


DO NOT OPERATE
THIS MACHINE WITHOUT
PROPER TRAINING AND
SAFETY EQUIPMENT. SEE
MANUAL FOR DETAILS.

PLEASE KEEP
YOUR WORK
STATIONS AND
FACTORY
CLEAN BEFORE
YOU LEAVE
YOUR SHIFT





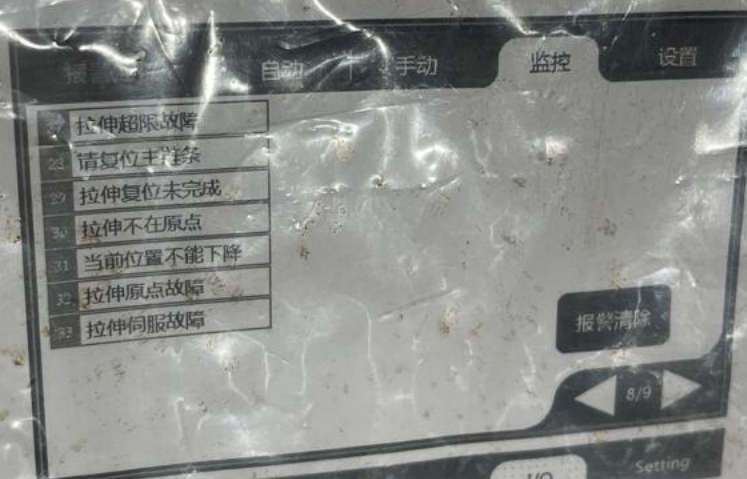




Picture 4-6 Alarm monitor

报警监控 Alarm monitor 自动 Automatic 手动 Manual 监控 Monitor 设置 Setting

1	Failure at front/back air cylinder of feeding preform	11	Oper. mould can't sealing	21	Adjust material motor overtime
2	Failure at rotating air cylinder of feeding preform rotating	12	Open mould can't blowing	22	Error at close mould parameter
3	Failure at air cylinder of hoist of feeding preform	13	Feeding preform not at the position	23	Error at main chain parameter
4	Failure at air cylinder of feeding preform	14	Discharge bottle group not at the position	24	Servo alarm at open/close mould
5	Failure at front/back air cylinder of discharge bottle	15	Close mould not at the position	25	Servo alarm of main chain
6	Failure at hoist air cylinder of discharge bottle	16	Manual can't startup	26	Adjust material motor alarm
7	Failure at rotating air cylinder of discharge bottle	17	Emergency stop status can't running		
8	Failure at cover wind air cylinder	18	Not reset for alarm		
9	Failure at drawing motor	19	Only remaining open/close mould		
10	Failure at main chain	20	Close mould motor error line		



ECENE



吹瓶机维护保养

1. 每日在开合处各活动部件加润滑油一次(40#机油)。(机械手、机械臂等)
2. 维护一次。加温机大链条、小链条可一个月一次。
3. 开合时检查各部件能否结实,螺丝是否松动脱落,特别是冲击力较强的地方。
4. 检查气压,低气压,电源,水源能否正常。
5. 检查灯,断,要及时更换。
6. 检查二气,是否堵塞,水杯储水量能否太满。
7. 模具必须做防锈处理。
8. 开合时必须缓慢举升,以防气流速度太快杂物吹进电磁阀,同时开合,确保空气洁净。
9. 吹瓶机必须确保机械局部良好,机器内部无人,无异物。
10. 启动机先启动电动机,延迟30秒启动加温机,以防电压波动,启动加温。
11. 吹瓶机必须密切注意机器能否有异常响声,要做到早发现,及时停机早解决。
12. 遇有紧急情况,可按急停按钮,紧急刹车。而后根据现场状态分析原因,找到问题。
13. 正常吹瓶时,本任何部位不要靠近机器内免得机械伤人。如机器有异响可减速后。
14. 正常吹瓶时,必须注意观察瓶子的质量,免得电压的波动影响吹瓶质量。
15. 遇有紧急情况,可按急停按钮,紧急刹车。而后根据现场状态分析原因,找到问题。

Maintenance of PET blowing machine

1. Before start, lubricate very moving parts (30# engine oil) (manipulator, etc.)
2. Lubricate the chain once 3 to 4 days (Lubricate chains once a month)
3. Before start, check all moving parts strong enough, especially high pressure, low pressure or not and hot drive part work well or not
4. Check the gas pressure, low pressure, power supply, air supply, etc.
5. Check the light, replace it in time.
6. Check the gas, whether it is blocked or not, and the water storage tank full or not
7. The mold must be rust treated when not use for long time
8. Before start, the machine must be slow down, and then open the valve, to ensure the air is clean
9. Before start, the machine must be slow down, and then open the valve, to ensure the air is clean
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15. Before start, the machine must be slow down, and then open the valve, to ensure the air is clean

[illegible][illegible]

2. 每星期2~4次至一生, 如患过工役者, 个别的又一个另一次。

1. 平谷县属河北省北部平谷县，属北京市平谷县，特别是平谷县较强的地方。

1. 1990年1月1日起，凡在境内从事生产经营活动的纳税人，其应纳税额，除另有规定外，均按本规定执行。

1. 1990年12月1日以前

● 中国书画函授大学肇庆分校建校二十周年纪念册

9. 中區電力局之電力供應

[illegible]

② 启动时，应先将电动机转速调至最低，然后逐渐增加，以防电压波动，启动电流过大。

... 及时发现, 及时等机早解决。

...找到问题...

Membrane PET blowing machine





