MacWac

杰出版真空注蜡机

OUTST Vacuum Wax Injector

专业　敬业　合作　共赢
profession Dedication Cooperation Double-win

目录
CATALOGUE

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一、设备参数介绍　Equipment parameter introduction

1.注蜡机技术参数　Technical parameters of wax injector

❶电源：单相 AC 220V±10%　50 / 60Hz
❷功率：500W
❸保险丝规格：5A/250V
❹蜡缸加热温度范围：55-85℃(±1℃)
❺蜡嘴加热温度范围：55-85℃(±1℃)

❻真空定时范围:0-12S(±0.1s)
❼注蜡定时范围:0-12S(±0.1s)
❽蜡缸容量:3Kg
❾外型尺寸：L438× W312 × D506(mm)
❿重量:19kg

❶Power supply：
　single-phase AC 220V±10% 50/60Hz
❷Power:500W
❸Fuse specifications:5A/250V
❹Temperature range for wax chamber：
　55-85℃(±1℃)
❺Temperature range for wax nozzle：
　55-85℃(±1℃)

❻Vacuum timing range:0 – 12 S (±0.1s)
❼Timing range for injection:
　0 – 12 S (±0.1s)
❽Wax tank capacity:3kg
❾Machine dimensions:
　L438× W312 × D506(mm)
❿Weight:19kg

2.控制箱技术参数　Control box technical parameters

❶外部气压:0.4-0.7MPa
❷调压阀设定气压:0.4MPa
❸第一次注蜡压力:< 256KPa
❹第二次注蜡压力:< 256KPa
❺再次启动时间: 建议<0.5S,不需要二次加压，设置为0

❻夹具压模气力: < 256KPa
❼夹具推模气力: < 256KPa
❽压模延时: < 256S
❾最大工件数:999999
❿存储参数组:一键模式10组+非一键模式1组

❶External air pressure:0.4-0.7MPa
　Setting air pressure of pressure
❷regulating valve :0.4MPa
❸First injection pressure (1):< 256KPa
❹Second injection pressure(2):
　< 256KPa
❺Timing for P.2 :It is recommended to
　< 0.5 S , no need to pressurize twice ,
　set to 0

❻Compress pressure: < 256KPa
❼Forward pressure： < 256KPa
❽Hold time: < 256S
❾Maximum number of work pieces：
　999999
❿Storage parameter group:10 groups
　of one - key mode ＋ 1 group of non-
　one-key mode

3.机械手技术参数　Manipulator technical parameters

标准夹具胶模尺寸：L135 × W105 × D45(mm)
加宽型大夹具胶模尺寸：L135 × W135 × D60(mm)

Standard clamp film size：L135 × W105 × D45(mm)
Widened large clamp film size：L135 × W135 × D60(mm)

4.真空泵技术参数　Technical parameters of vacuum pump

- 电源：AC 220V±10%　50 / 60Hz
- 功率：120W
- 最大真空压力: -100KPa
- 抽气速率: 1.2L/S
- 加油量:160mL

- power supply：AC 220V±10%　50 / 60Hz
- power：120W
- Maximum vacuum pressure: -100KPa
- Pumping rate: 1.2L/S
- The amount of oil:160mL

二、安装指导　Installation guide

1.使用条件　Conditions of Use

- 电压　AC220V±10%
- 使用开关必须为带漏电保护的空气开关，电源供电必须接地
- 压缩空气必须进行干燥、除尘、除油处理并且稳定
- 设备周围不能放置易燃易爆物品
- 不能在有粉尘有害气体环境下使用此机器

- Voltage AC220V±10%
- The switch used must be an air switch with leakage protection , and the power supply must be grounded
- The compressed air must be dried, dust-removed, oil-removed and stable
- No flammable and explosive materials should be placed around the equipment
- This machine cannot be used in an environment with dust and harmful gases

2.注蜡机箱与机械手连接 Connect the wax injector case to the clamp

前限位块
Front limit block

固定块
Fixed block

气缸连接块
Cylinder
connecting block

螺丝
Screw

橡胶垫
rubber gasket
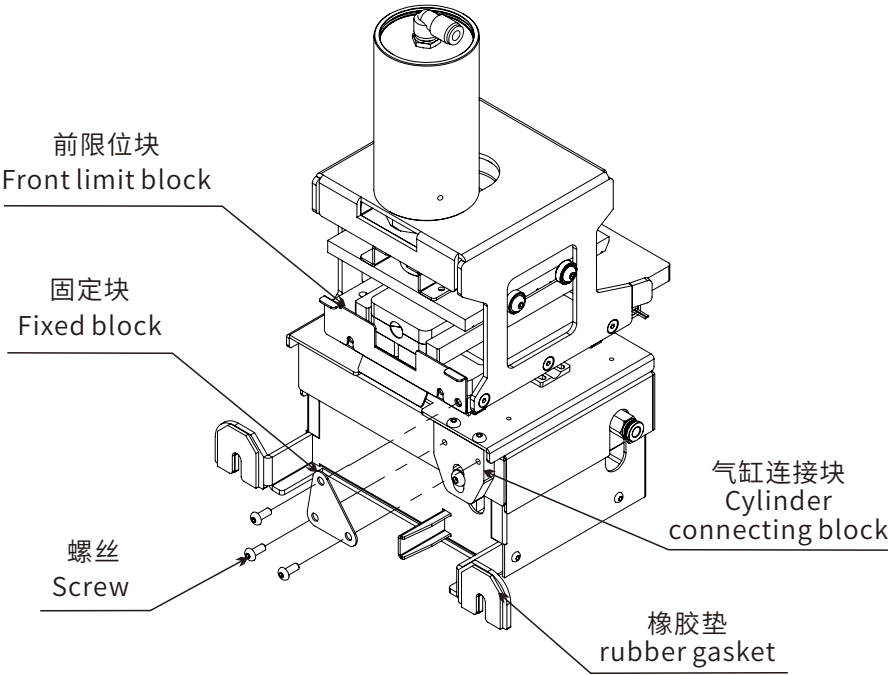
拆卸运输专用"固定块"示意图
Schematic diagram of
disassembling and transporting "fixed block"

❶卸下"固定块"的3颗螺丝，将"固定块"保存好。(如需要打包运输时，将"固定板"固定回原位，防止机械手在运输过程中因摆动造成的二次损坏)；

❷将注蜡机箱和控制箱放着在同一水平的工作台面上；

❸将注蜡机箱上的两个"胶头螺丝"旋转松动，旋转出一定的距离；

❹将"机械手"挂靠在注蜡机箱的两个"胶头螺丝"上，"气缸挂扣"与机械手的气缸连接块固定，后将"胶头螺丝"拧紧；

❺转动机械手底部的"调节螺丝"，使"机械手"水平放置；

❻将"接蜡杯"放置于"机械手"相应的卡位上，完成安装。

注蜡机箱
wax injector case

胶头螺丝
Plastic head screw

机械手
clamp

托模板
Acrylic

调节螺母
adjustable nut

升降调节转盘
lift-down plate

接蜡杯
Wax cup

控制箱
control box
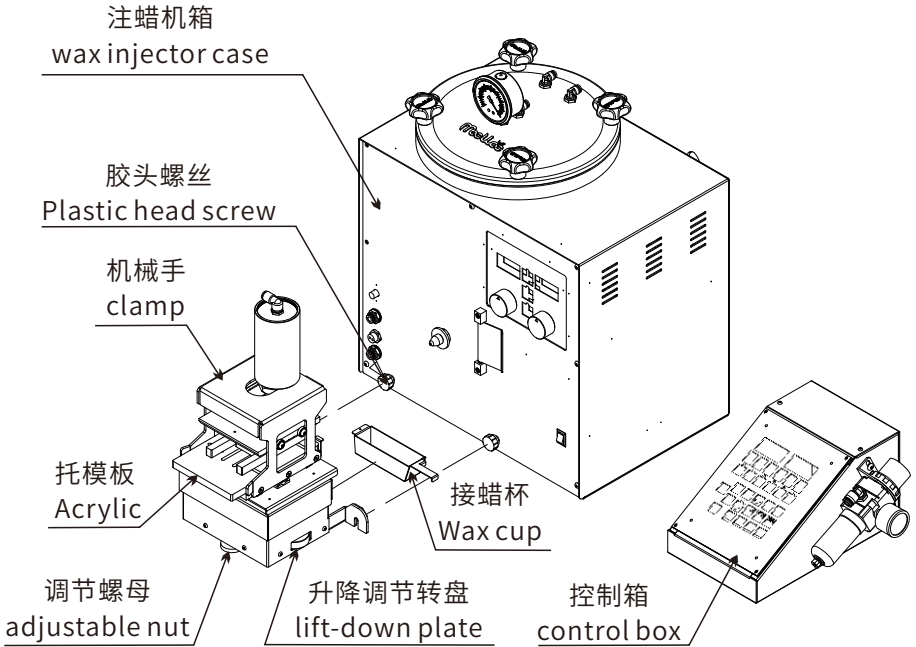
注蜡机箱与机械手连接示意图
Schematic diagram of connection
between wax injector case and clamp

❶Remove the 3 screws of the "fixed block" and save the "fixed block". (If you need to pack and transport, fix the "fixed plate" back to the original position to prevent secondary damage caused by the swing of the manipulator during transportation) ;
❷Place the "wax injection box" and "control box" on the same level work surface ;
❸Loosen the two "plastic head screws" on the wax injection case to a certain distance ;
❹Put the clamp on Plastic head screw of wax injector main box,after stable them, switch the Plastic head screw to fasten them;
❺Turn the "adjustment screw" at the bottom of the manipulator to place the "manipulator" horizontally;
❻Place the "wax receiving cup" on the corresponding card position of the "manipulator" to complete the installation.

3.气管、信号线、电源线的连接　Connection of pipe, signal wire and power wire

注蜡机箱前面气管、信号电缆连线示意图
Schematic diagram for the pipe and signal wire connection on the front of the wax injector

:气管　Pipe
:信号线 Signal wire

信号线
signal wire
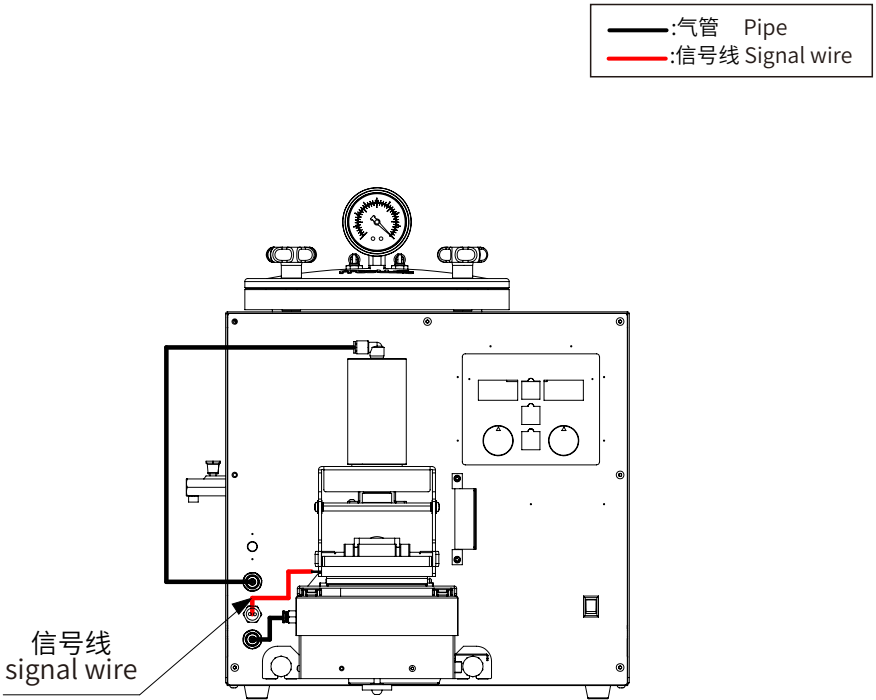
注蜡机箱背面气管、电源线连线示意图

Schematic diagram for the pipe and power wire connection on the back of the wax injector

——	气管 Air pipe
——	信号电缆 Signal cable
——	电缆线 Cable
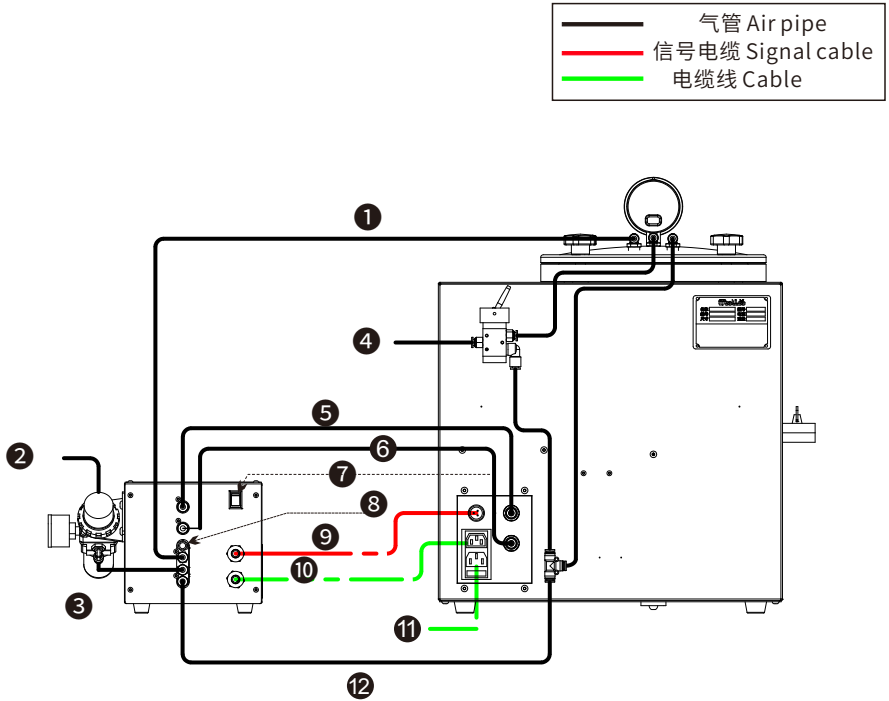
❶注蜡压力Wax injection pressure
❷压缩空气供给0.4-0.7MPa
　Compressed air supply0.4-0.7MPa
❸调压阀输出0.3MPa
　Pressure regulator output 0.3MPa
❹至真空泵To vacuum pump
❺压模Compression film
❻进模Into the film

❼机械手电源开关Clamp power switch
❽排气Exhaust
❾信号检测Signal Detection
❿机械手电源线Clamp power wire
⓫至外部供电电源AC 220V ±10%; 50/60Hz
　To external power supply
　AC 220V ±10%; 50/60Hz
⓬蜡缸压力检测 Wax pot pressure detection

三、真空注蜡机 IW-VWI 操作面板介绍
Introduction of IW-VWI Operation Panel of Vacuum Wax Injection Machine

1.面板说明　Panel introduction
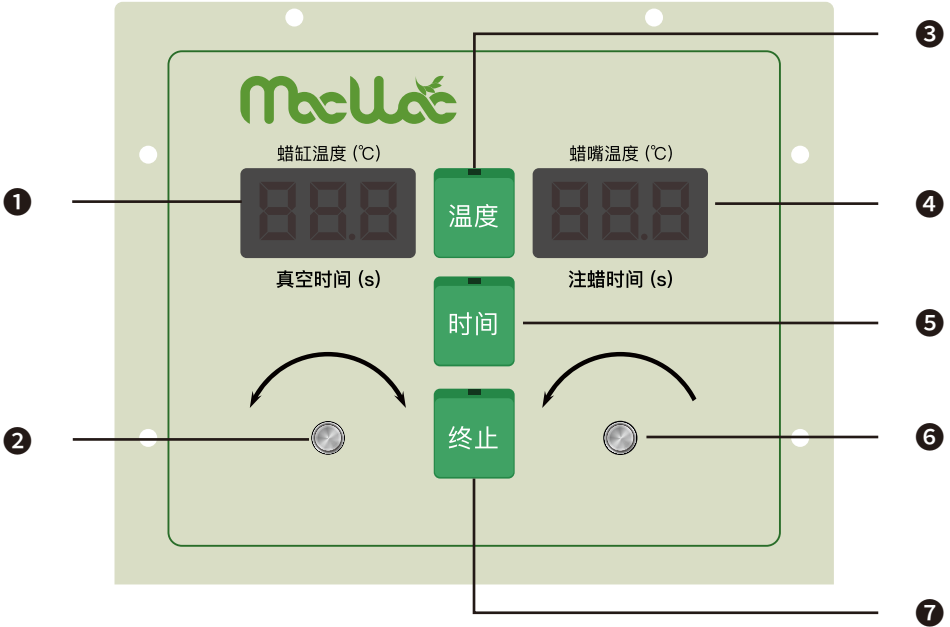
❶蜡缸温度,真空时间数值显示窗口
❷蜡缸温度,真空时间调节旋钮
❸温度按键+指示灯

❹蜡嘴温度,注蜡时间数值显示窗口
❺时间按键+指示灯
❻蜡嘴温度,注蜡时间调节旋钮
❼终止按键+指示灯

❶Display for wax chamber temperature and vacuum time
❷Wax chamber temperature, vacuum time adjustment button
❸Temperature button + indicator
❹Wax nozzle temperature, wax injection time display
❺Time button + indicator
❻Wax nozzle temperature, wax injection time adjustment button
❼Stop button + indicator

	灯亮Light on	灯灭Light off
温度按键及指示灯 Temperature Button and LED light	正在对蜡缸温度或蜡嘴温度进行设置或查看。 Checking and Setting Wax bath and Nozzle temperature. (当按下温度按键时,灯亮:左窗口显示值为蜡缸温度,右窗口显示值为蜡嘴温度) (Pressing temperature button , light on :left version is wax bath temperature,right version is Nozzle temperature.	不在温度设置状态,也不显示温度数值。 Out off Temperature setting and value present status.
时间按键及指示灯 Time button and LED light	正在对真空时间或注蜡时间进行设置或查看。 Checking and Setting Vacuum and Injection time. (当按下时间按键时,灯亮:左窗口显示值为真空时间,右窗口显示值为注蜡时间) Pressing time button,light on:left version is Vacuum time,right version is Injection time.	不在时间设置状态,也不显示时间数值。 Out off time setting and value present status.
终止按键及指示灯 Stop Button and LED light	按下终止按键,指示灯亮,操作状态停止。 Pressing stop button,light on,operation status is stop.	再按一下终止按键,指示灯灭,操作状态继续。 Pressing stop button,light off, operation is continuous.

2.刻度旋钮说明　Description of scale knob

①蜡缸温度旋钮：温度调节范围55-85℃

　Wax bath temperature knob : The temperature adjustment range is 55-85℃

②蜡嘴温度旋钮：温度调节范围55-85℃

　Wax nozzle temperature knob:The temperature adjustment range is 55-85℃

　●当数字显示窗口显示末位为" . "时, 表示正在加热 (如73.3.), 若末位不显示".", 则表示加热结束 (如77.7) 。
　●当数字显示窗口显示"LL.L"时, 则表示当前温度比设置温度低, 低温提示。
　●当数字显示窗口显示"HH.H"时, 则表示当前温度比设置温度高, 超温提示。

　●When the last digit of the digital display is ".", it means heating (as 73.3.) , if the last digit doesn' t display ".", it means finish the heating(such as 77.7).
　●When the digital display shows "LL.L", it means that the current temperature is lower than the setting temperature, the low-temperature hint.
　●When the digital display shows "HH.H", it means that the current temperature is higher than the setting temperature, and the over-temperature hint.

③真空时间旋钮：真空时间调节范围0-12秒

　Wax injection time knob: Wax injection time adjustment range 0-12 seconds

④注蜡时间旋钮：注蜡时间调节范围0-12秒

　Wax injection time knob: Wax injection time adjustment range 0-12 seconds

四、主机控制盒IW-DCB介绍Introduction of host control box IW-DCB
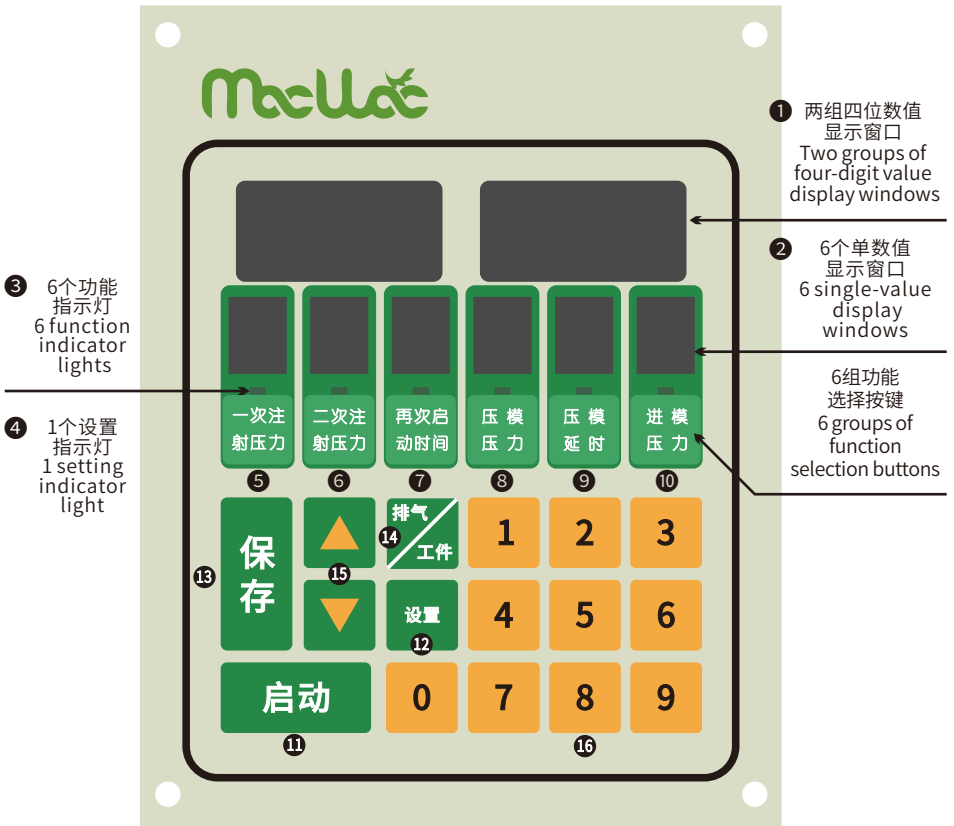
❶ 两组四位数值显示窗口
Two groups of four-digit value display windows

❷ 6个单数值显示窗口
6 single-value display windows

❸ 6个功能指示灯
6 function indicator lights

❹ 1个设置指示灯
1 setting indicator light

6组功能选择按键
6 groups of function selection buttons

一次注射压力　二次注射压力　再次启动时间　压模压力　压模延时　进模压力

保存　▲　排气/工件　1 2 3
启动　▼　设置　4 5 6　7 8 9 0

❺ 一次注射压力:PRESS 1　　　　　❽ 压模压力:CLAMP PRESSURE
❻ 二次注射压力:PRESS 2　　　　　❾ 压模延时:HOLD TIME
❼ 再次启动时间:TIMING FOR P.2　❿ 进模压力:FORWARD PRESSURE

⓫ 启动按键:START　　　　　　　　⓮ 排气/工件按键:EXHAUST/WORK-PIECE
⓬ 设置按键:SET　　　　　　　　　⓯ 上下按键:Up and down buttons
⓭ 保存按键:ENTER　　　　　　　　⓰ 0-9数字按键:0-9 numeric keys

1.操作面板介绍　Operation panel introduction

1.1 . 窗口显示介绍

❶两组四位数值显示窗口：前功能按键对应左侧参数显示窗口数值，后功能按键对应右侧参数显示窗口；

❷6个单数值显示窗口：一键代码模式显示代码值，非一键模式显示123456，当再次启动时候和压模延时的设置值>0时，该窗口会有代码值显示，便于提示已经开启此功能；

❸6个功能指示灯：灯亮代表显示窗口处于的状态；

❹1个设置指示灯：灯亮代表设置状态

1.1 . Window display introduction

❶ Two groups of four - digit value display windows：pre - function button match with left version value,after-function button match with right version；

❷ 6 single - value display windows：one - key code mode displays the code value, non - one - key mode displays 123456, when restarting and the compression mold delay setting value >0, the window will display the code value, which is convenient to indicate that it has been opened this function；

❸ 6 function indicator lights: light on means version working on；

❹ 1 setting indicator light: light on means setting status

1.2. 按键功能介绍

● 6组功能选择按键：一次注射压力、二次注射压力、再次启动时间、压模压力、压模延时，进模压力；

⑪ 启动按键：启动注蜡程序；

⑫ 设置按键：灯亮进入设置模式，再按灯灭退出设置模式；

⑬ 保存按键：修改参数，数值闪动，按下保存按键，数值停止调动，参数已保存；

⑭ 排气/工件按键： 排气功能（按下设置灯亮后按排气）；工件查看功能（长按时显示工件数量）；

⑮ 上下按键：翻页/上下功能；

⑯ 0-9数字按键：在设置功能可以进行参数输入，在非设置时可一键代码选择代码号（注蜡程序过程，按键无效）。

1.2. Introduction to key functions

● 6 groups of function selection buttons : PRESS 1, PRESS 2 , TIMING FOR P.2, CLAMP , HOLD TIME,FORWARD PRESSURE;

⑪ START : Start injection process;

⑫ SET : the light is on to enter the setting mode, and then the light is off to exit the setting mode;

⑬ ENTER : modify the parameter, the value flashes, press the ENTER button, the value stops transferring, the parameter has been saved;

⑭ EXHAUST/WORK-PIECE : Exhaust function (press to set the light and then press to exhaust）; Work piece viewing function (long press to display the number of work pieces）;

⑮ Up and down buttons: page turning/up and down functions;

⑯ 0 - 9 numeric keys : parameter input can be performed in the setting function, and the code number can be selected by one key code when it is not set (the wax injection program process, the key is invalid).

2.系统参数设置与软件版本查看
System parameter setting and software version view

2.1. 运行模式选择：一键代码 / 非一键代码：

● 一键代码：按"设置"按键，设置灯亮，系统进入设置模式，通过上下按键选择P1 项，输入数值"1"并按保存按键。
● 非一键代码：按设置按键，设置灯亮，系统进入设置模式，通过上下按键选择P1 项，输入参数"0"并按保存按键。

[一键代码说明：有十组一键代码参数，通过数字按键0-9快速选择调用（用户可自由修改，有保存功能）。非一键代码说明：一组参数（用户可自由修改，有保存功能）键值参数显示1-6]

2.1. Operation mode selection: One-key code / non-one-key code:

● One-key code: Press the " Settings " button, the setting light is on, and the system enters the setting mode. Use the up and down buttons to select P1, enter the value "1" and press the save button.
● Non-one-key code: Press the setting button, the setting light is on, and the system enters the setting mode. Use the up and down buttons to select item P1, enter the parameter "0" and press the save button.

[One-key code description: There are ten groups of one-key code parameters, which can be quickly selected and called by the number buttons 0-9 (the user can freely modify, and there is a save function).Description of non-one-key code: a set of parameters (users can freely modify, with save function) key value parameter display 1-6].

2.2. 软件版本查看：

● 按设置按键，设置灯亮，系统进入设置模式，通过上下按键选择P0 项，右侧"数值显示窗口"显示程序版本。

2.2. Viewing the software version:

● press the setting button, the setting light is on, the system enters the setting mode, and the P0 item is selected by the up and down buttons, and the program version is displayed on the "value display window" on the right.

2.3. 工件数量查看：

● 长按"排气/工件"按键显示工件数量。

2.3. View the number of work pieces：

● long press the "exhaust/work piece" button to display the number of work pieces.

五、操作说明 Instructions

1.总气压调节 Total air pressure adjustment

调压阀位于控制箱右侧，拔起后再调节 建议值400Kpa。

The pressure regulating valve is located on the right side of the control box. After pulling it up, adjust the recommended value 400Kpa.

2.给蜡缸添加蜡步骤 Feeding wax into wax bath

❶排气：选择功能按键"第一次注射压力"，按"设置"按键灯亮进入设置模式，再按"排气"按键，出现"OUT---"字样，等待压力值为0；
❷打开上盖，添加蜡；
❸再确定盖好上盖；
❹按"设置"按键，按键灯灭，退出排气模式，加蜡完成。

❶Exhaust: press " Press 1 ",press " SET "button ,light on into setting status,press "Exhaust" button,present "OUT--"till pressure become 0;
❷Open the cover and add wax;
❸Make sure cover in good condition;
❹Press "SET" button,light off,out off exhaust status,finish feeding wax.

3.排蜡步骤 Wax discharge steps

每天注蜡工作结束需要进行排蜡。

❶设置好熔炼室压力为50KPa，打开排蜡开关，此时真空室压力等于蜡缸压力。
❷将接蜡盒放置排蜡口下方（注意眼睛请勿水平直视排蜡口，以免蜡排放伤害）缓慢打开侧面的排蜡阀门，将真空室的蜡向外排。

Wax removal is required at the end of daily wax injection work.

❶Set the pressure of the melting chamber to 50KPa and turn on the wax discharge switch . At this time, the pressure of the vacuum chamber is equal to the pressure of the wax tank.
❷Place the wax box under the wax discharge port (be careful not to look directly at the wax discharge port horizontally to avoid wax discharge damage) slowly open the wax discharge valve on the side to drain the wax in the vacuum chamber.

4.工件清零 Zero the work piece

长按"排气/工件"按键显示工件数量,按键不释放,此时输入"0",系统将工件清零。

Long press the "Exhaust/Work piece" button to display the number of work pieces. If the button is not released, input "0" at this time, and the system will reset the work piece.

5.参数设置 Parameter setting

（气压单位KPa , 时间单位秒, 输入最大数255）
（Air pressure unit KPa, time unit second, enter the maximum number 255)

一次注射压力	Press 1
二次注射压力	Press2
再次启动时间	Timing for P.2
压模压力	Clamp Pressure
压模延时进模压力	Hold time

举例说明:设置一键代码值0的一次注射压力 70KPa 、二次注射压力80KPa、再次启动时间0.5S、压模压力90KPa、压模延时5S , 进模压力100KPa。

For example : set the one-key code value 0 for the first injection pressure of 70KPa, the second injection pressure of 80 Kpa , the restart time of 0.5S, the compression mold pressure of 90KPa, the compression mold delay 5S, and the injection pressure of 100KPa.

❶择一键代码"0";
❷进入设置模式:按下"设置"按键,灯亮进入设置模式;
❸选择功能按键:按下"一次注射压力",此时右侧数值显卡值调动,输入"70"并按确定按键,数值不闪烁代表数值保存完成;
❹选择功能按键:按下"二次注射压力",此时右侧数值显卡值调动,输入"80"并按确定按键,数值不闪烁代表数值保存完成;
❺选择功能按键:按下"再次启动时间",此时右侧数值显卡值调动,输入" 5 "并按确定按键,数值不闪烁代表数值保存完成;
❻依次类推完成所有操作,再次按"设置"按键,灯灭,退出设置模式。

❶Choose a key code "0";
❷Enter the setting mode : press the " SET " button , the light is on to enter the setting mode;
❸Select the function button: Press "PRESS 1", and the value of the numerical display on the right side will be adjusted at this time. Enter "70" and press the OK button. The value does not flash, indicating that the value is saved;
❹Select the function button: Press "PRESS 2", and the value of the numerical display on the right side will be adjusted at this time. Enter "80" and press the OK button. The value does not flash, indicating that the value is saved;
❺Select the function button: Press "Timing for P.2", the value of the right-side numerical display card will be adjusted at this time, enter "5" and press the OK button, the value does not flash, indicating that the value is saved;
❻Complete all operations by analogy, press the "SET" button again, the light is off, and exit the setting mode.

6.自动/手动模式选择　Automatic/manual mode selection

● 自动模式选择：将主机红色自动开关至按下状态
先将胶模放在亚克力工装上，推进机械手，亚克力工装到位磁铁触发设备启动；

● 手动模式：将主机红色自动开关至抬起状态
先将胶模放在亚克力工装上，推进机械手，再按控制面板的启动按键触发设备启动。

● Automatic mode selection: turn the red automatic switch of the host to the pressed state.
Put the film on the acrylic tooling first, push the manipulator, the acrylic tooling is in place and the magnet triggers the device to start;

● Manual mode : turn the red automatic switch of the host to the raised state.
Put the film on the acrylic tooling first, push the manipulator, and then press the start button on the control panel to trigger the device to start.

7. 夹具上下调节　Up and down adjustment for auto clamp

● 机械手右下角逆时针拨动转盘，机械手上升；
● 机械手右下角顺时针拨动转盘，机械手下降；

（注：通过镜子可观察注蜡嘴与模具口是否对齐，通过拨动转盘调节合适的高度。）

● Turn the turntable counterclockwise at the lower right side of the clamp to make the clamp rises;
● Turn the turntable clockwise at the lower right side of the clamp to make clamp down;

(Note : You can observe whether the injection nozzle is aligned with the mold nozzle through the mirror , and adjust the appropriate height by turning the turntable.)

8. 压模位置调节　Adjust position of mould

抓住压模气缸逆时针拧松，移动位置，顺时针拧紧即可

Hold the cylinder to loosen it counterclockwise, move the position and tighten it clockwise.

六、设备报错代码说明 Device error code description

当设备出现错误时，若显示提示"E 1 1 1"字样。其代表意思如下：

❶第一个"1"代表蜡缸加压漏气，检查接管，或者上盖是否锁紧。
❷第二个"1"代表夹具压动漏气，检查气管是否漏气。
❸第三个"1"代表夹具推动漏气，检查气管是否漏气。

When the device has an error, if it displays the prompt "E 1 1 1". Its representative meaning is as follows:

❶The first " 1 " means that the wax bath is pressurized and leaks. Check whether the connecting pipe or the upper cover is locked.
❷The second "1" means that the clamp is compressed and leaked. Check whether the air pipe is leaking.
❸The third " 1 " represents air leakage when the fixture is pushed. Check whether the air pipe is leaking.

七、包装清单 Packing list

打开包装时，请检查一下配件是否齐全。
When opening the package, please check whether the accessories are complete.

配件清单 Parts list			
序号 No.	配件名称 Parts name	数量 Quantity	单 位 Unit
1	注蜡机Vacuum wax injector	1	台SET
2	控制盒control box	1	台SET
3	机械手Clamp	1	台SET
4	真空泵Vacuum pump	1	台SET
5	配件盒Accessory box	1	盒BOX
6	托模板套装Acrylic plate	1	盒BOX

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艺 辉 铸 造 科 技 有 限 公 司

Yihui Casting Technology Co ., Ltd.

地址: 广东省广州市番禺区沙头街沙南路50号
Add.: No.50, Shanan Road, Shatou Street, Panyu District, Guangzhou City,
　　　Guangdong Province, China
电话/ Tel : +86-20-34734999/34734666　　传真/Fax: +86-20-84872122
邮箱/ Email：info@yihuicasting.com
网址/ Web：www.yihuicasting.com　　　　www.yihuicasting.cn

制造商　Agency ■────────────────────────────────

瑞 辉 自 动 化 系 统 (广 东) 有 限 公 司

Ruihui Auto System (Guangdong) Co . Ltd .

地址: 广东省广州市番禺区沙湾镇福涌牛眠岗工业区一街10号
Add.: No.10, First Street, Niumiangang Industrial Park, Fuchong, Shawan
　　　Town, Panyu District, Guangzhou City, Guangdong province, China.