

Yihui Casting® 艺辉

三盅搅粉机

3 pcs Vacuum Mixer



专注于首饰铸造
Specializing In Jewelry Casting

专业 敬业 合作 共赢
profession Dedication Cooperation Double-win

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声明

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STATEMENT

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- If you meet any problem when using this machine, please feel free to contact our salespersons. We will try our best to give you service.
- We are not responsible for the loss including loss in interest and all indirect damages caused by operations due to rule-breaking operations.
- Without our permission, it is prohibited to copy,disseminate or reprint the whole content of this user manual in any form.
- This manual is subject to alterations without prior notice. If you find any mistake or omission in this manual, please inform the supplier you bought the machine from. We will be very grateful for this.

版本号：V1.0 2020.07.27

一、技术参数 Technical parameter



型号:	M.VM.SAS03
电源:	三相 380V/50HZ 三相 220V/60HZ
功率:	2KW
抽气速度:	15L/s
极限压力:	6x10 pa
外形尺寸:	890x580x1330mm
Model:	M.VM.SAS03
Volt:	three phase 380V/50HZ three phase 380V/60HZ
Power:	2KW
Exhaust speed:	15L/s
Max pressure:	6x10 pa
Outer size:	890x580x1330mm

二、产品特点 Product features

三盅搅粉机是一款专门为精密铸造研发的石膏搅拌设备。一次可搅拌3个4”x10”钢盅量的石膏粉，搅拌和抽真空同时进行，使搅拌、注粉、整个过程在真空状态一次完成，能够彻底抽除石膏浆里的空气，杜绝铸件表面的小圆珠出现，使铸件的表面更加光洁，是高要求精密铸造的必须设备。

The 3 flasks investment powder mixer is specially made for high precision cast ing process. It can hold 3pcs of 4”x10” flask one time. It provide vacuum and mixing at the same time which means the whole investing process can be done in vacuum circumstance. Therefore, without air in the investment, the casting piece surface will be smoother and nicer. This equipment is a good choice for high precision casting.

三、操作说明 Operation Instruction

- 1.将钢盅放入下桶并摆好位置，使每一盅都能对准放粉口，关闭所有注入阀。
- 2.分别转动MIXING TIME SWITCH（搅粉时间）旋钮及VACUUM TIME SWTICH（抽真空时间）旋钮，设定搅粉时间3min及抽真空时间5min。
- 3.依次将水和石膏粉倒入搅粉机上桶并盖上盖子，并保证搅粉叶片上无石膏粉残留。（1kg粉兑380-400ml的水）

- 4.依次按下VACUUM（抽真空）开关、UPPER VACUUM BARREL（上桶真空）开关、MIXING(搅拌)开关、MIXING TIME SWITCH（搅拌时间）开关及VACUUM TIME SWITCH（抽真空时间）开关，启动搅粉机进行真空搅粉，待蜂鸣器响起，检查石膏粉浆的均匀程度，若未搅拌均匀，则延长搅拌时间继续搅拌。
- 5.打开注入阀将搅好的石膏粉浆注入各个钢盅，待石膏粉浆灌满钢盅后，关闭注入阀。
- 6.关闭MIXING TIME SWITCH（搅拌时间）开关并打开VIBRATION（震动）开关，待蜂鸣器响起，关闭VAVUUM（抽真空）开关、VACUUM TIME SWITCH（抽真空时间）开关及VIBRATION（震动）开关，打开EXHAUST(排气)按钮释放真空。
- 7.将注入盖移动至右侧清洗槽，将注满石膏粉浆的钢盅取出在干燥的地方平放静置自然烘干待石膏凝固后，将胶带及橡胶底座逐一去除，用刮刀清除高于钢盅的石膏，并在石膏底部刻下模具编号。
- 8.打开注入阀及MIXING开关，清理搅粉机上桶内的石膏粉浆残留，保证搅粉叶片及注入孔的洁净。

- 1.Put the flasks into the down chamber and set the position to make sure each flask can be aligned with the powder discharge port. Close all the pouring valves.
- 2.Turn the “MIXING TIME SWITCH” knob and the “VACUUM TIME SWITCH” knob respectively to set the powder mixing time 3mins and the vacuuming time 5mins.
- 3.Pour water and investment powder into the upper chamber in order and close the lid, and ensure that there is no investment powder remaining on the blender blade. (proportion for investment powder and water is 1kg power : 400ml water)
- 4.Press the “VACUUM” switch, the “UPPER VACUUM BARREL” switch, the “MIXING” switch, the “MIXING TIME SWITCH” and the “VACUUM TIME SWITCH” in order to start the machine. Mixing the powder in vacuum, wait for the buzzer to sound, check the uniformity of the investment powder slurry,extend the mixing time if it is not stirred evenly.
- 5.Open the injection valves to injecting the mixed investment powder slurry into each flask. Close the injection vlaves after all flasks have been filled.
- 6.Turn off the “MIXING TIME SWITCH”, turn on the” VIBRATION” . After the buzzer sounds, turn off the “VAVUUM” , “VACUUM TIME SWITCH” and the “VIBRATION” , and turn on the “EXHAUST”to releases vacuum.
- 7.Move the injection cap to the right washing tank, take out the filled flasks, place it in a dry place and let it dry naturally (about 60 ~ 120min). After the slurry solidated, remove the tape and rubber base one by one , Use a spatula to remove the powder above the flask, and engraved the mold number on the bottom of the mould.
- 8.Open the injection valve and the “MIXING” switch to clean up the remaining slurry in the bucket on the mixer to ensure the cleanness of the blade and the injection hole.

四、机器的保养注意事项 Operation Instruction

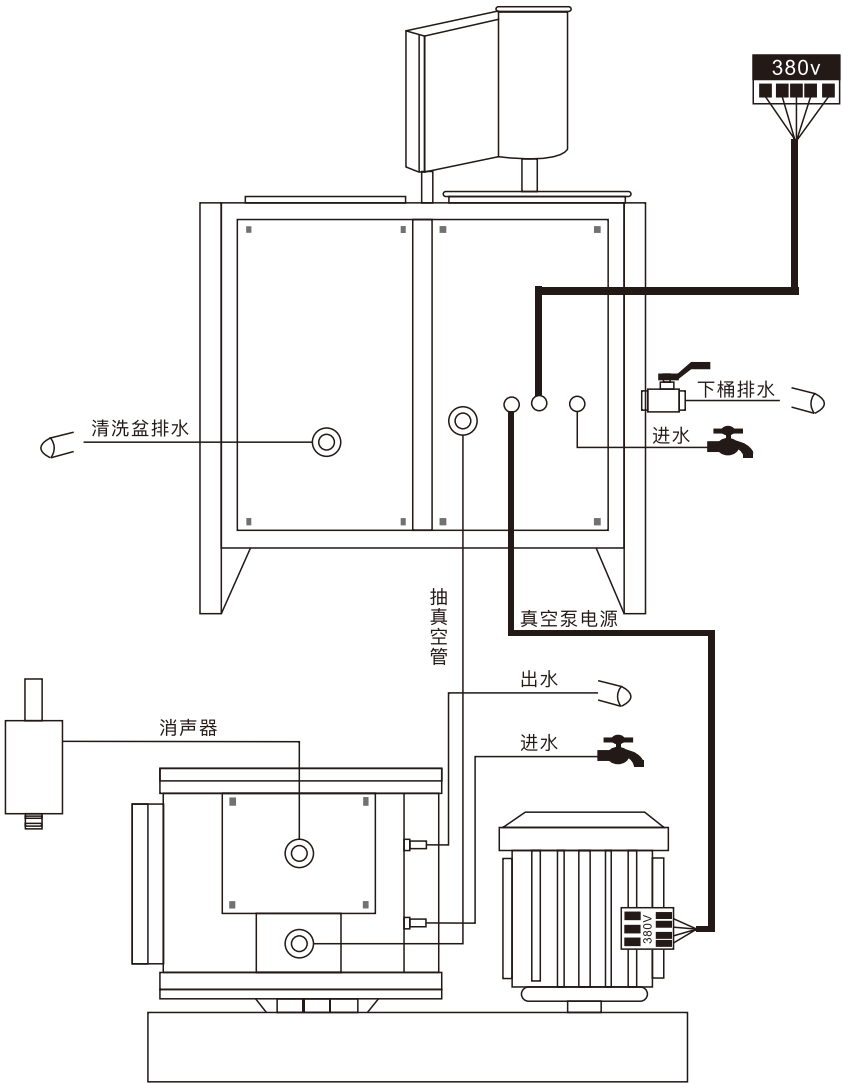
1. 来回移动上下桶时，请先用上升杠顶起上桶，避免密封圈损坏
 2. 每日真空泵开启前，先打开排油口，将上一次抽入泵体中的水分排除
 3. 定期清理搅粉机内部的过滤器
 4. 上升杠顶位置需加黄油润滑
 5. 每次搅粉完要立即清洗避免石膏长期累积堵塞
-
1. Before move the up down mixing chamber, please rise up the chamber with long handle to avoid damage of sealing rings.
 2. Before start vacuum pump every day, open oil drainage hole to drain out the water first.
 3. Regularly clean the filter inside of the mixer
 4. The top of the rising bar needs to be lubricated with butter
 5. Wash immediately after each mixing to avoid blockage caused by long-term cumulative of powde

五、选配功能 Function for option

1. 可调速搅拌
2. 下桶震动功能

1. Adjustable speed for mixing
2. Vibration for down chamber





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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, Shan'an Road, Sha Tou 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, Niutang Industrial Park, Fuchong, Shawan
Town, Panyu District, Guangzhou City, Guangdong province, China