

Yihui Casting® 艺辉

四盅不锈钢电炉

4PCS flask oven



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

致用户：

- 感谢您对瑞辉自动化系统（广东）有限公司的信赖和支持，选购艺辉牌系列产品，为安全操作并最大限度发挥本机性能，请在操作前仔细阅读说明书，并严格遵守安全规则，以防发生意外事故，造成不必要的损失。
- 在机器使用的过程中，如遇到问题可以随时联系本公司销售人员，我们将会竭诚为您服务。
- 在保修期间，如果未经本公司允许，用户不得擅自拆开机器进行错误的检修，如擅自拆开机器，保修期将自动失效，不再享受本公司保修服务。
- 机器使用时所产生损失、利益损失和各种违规操作造成的各种间接损害，概与本公司无关。
- 未经本公司许可，产品说明书的所有内容，不得以任何形式翻版、传播、转载。
- 说明书因修改而进行的变更，恕不另行通知。如果您发现任何错误或遗漏，请您向所购买的供应商反映，对此，我们深表感谢。

STATEMENT

To users:

- Thanks for choosing Yihui brand products of Yihui Casting Technology Co.,Ltd. We are greatly appreciated for the support and trust you give to us. To ensure safe operation and play the property of this machine in full, please read the user manual in advance and observe the safety rules in case that accidents happen and unnecessary loss incurs.
- 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.

一、注意事项 Precautions

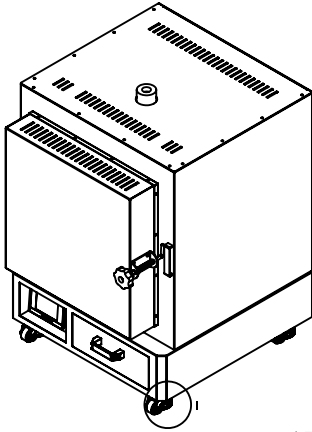
1. 电源使用注意事项 Precautions for using the powder

- 工厂供电为AC220V，在特殊场合中有的电压高于220V时，使用此机器会造成机器损坏。
- The power supply of this machine is AC 220V. The machine will be damaged if it is used in special occasions where the voltage is higher than 220V.

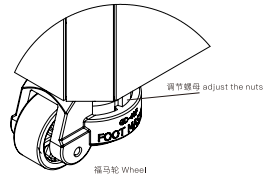


- 由于这台机器内部可加热至很高的温度，请禁止未经训练人士来操作。
- 切勿在安装此机器的房间使用或储存易燃物体、易挥发液体。
- 使用此机器前请先检查门锁是否正常，防止炉内高温的情况下门突然打开对人造成伤害。
- 设置时必须有足够的脱蜡时间，防止蜡在炉膛内燃烧。
- The temperature inside this machine can be very high when heating, untrained personels are not allowed to operate this machine.
- Do not use or store flammable objects or volatile liquids in the room where this machine is installed.
- Please check whether the door is locked normally or not in case that the door opens suddenly at a high temperature, which could hurt.
- When setting parameters, there must be enough time for dewaxing to prevent the wax from burning in the chamber.

2. 安装说明 Installation



调节螺母 adjust the nuts



福马轮 Wheel

水平调节：将机器移动至安装使用的位置，通过调整福马轮来调节机器的平衡，顺时针旋转“调节螺母（红色）”，福马轮相应的部分会被顶起，反之则是降低。
Level adjustment: Move the machine to the position where it is installed and used, and adjust the balance of the machine by adjusting the Fuma wheel. Turn the "adjusting the nuts" clockwise, the corresponding parts of Fuma wheels will be lifted up, otherwise it will be lowered.

二、机器的配置 The machine configuration

1. 电源使用注意事项 Precautions for using the powder

- 本电炉可应用于金属工艺品、珠宝首饰铸造的失蜡铸造和烧结工序。通过炉膛内部合理的布局，使炉膛内部温度均匀。微电脑控制温度，开放式加热工艺设置。
- This oven is applicable to loss-wax casting and burning of metal artifacts and jewelry. Through proper layout of the chamber, the temperature will be even throughout the chamber. Microcomputer-based temperature control and settings for open heating process.

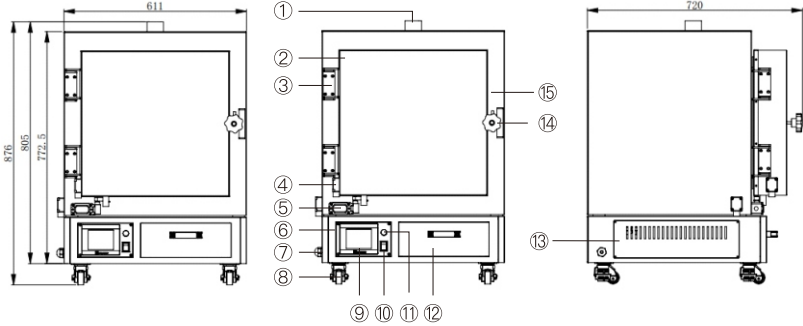
2. 机器参数 parameters of the machine

型号 model	S004
电压 voltage	AC220V 50HZ
总功率 power	3KW
炉膛功率 power of the chamber	3KW
温度设置范围 temperature setting range	0~900°C
控温精度 temperature measurement accuracy	±1°C
加热方式 heating method	斜率均匀加热 uniform heating
程序控制 program control	多段定时控制 multi-stage timing control
钢盅规格 (数量) flask specification(quantity)	4个4×8钢盅或8个4×5钢盅 (两层) 4 4'×8' flasks or 8 4'×5' flasks (stacked together)
整机尺寸 (宽*深*高) machine size(Width*depth*height)	611×720×876mm
重量weight	160kg

3. 保护系统 Protection system

- 采用双温控系统实现超温保护功能，一温控系统控制加热温控作用，另一温控限制炉膛最高温度，超温断开炉丝供电，起到过温保护的作用。炉门设有安全装置，当炉门打开时，电炉自动断电，确保操作者的安全。
- Double control systems are applied to add a protective function for controlling over-high temperature. One temperature control system controls heating, the other limits the maximum temperature of the chamber, stopping the coil from supplying power when the temperature is over high. A safety device is set on the door of the oven. When it is opened, the power will be cut out automatically to ensure the safety of operators.

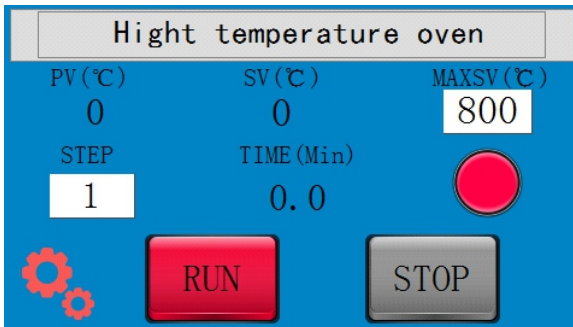
三、机器外型 The appearance of the machine



- | | | |
|-----------------------|------------------------|-----------------------|
| ① 陶瓷隔套 Ceramic sleeve | ⑥ 控制箱 Control box | ⑪ 指示灯 Indicator light |
| ② 炉门 Door | ⑦ 电缆锁头 Cable lock | ⑫ 排蜡抽屉 Drawer |
| ③ 旋转铰座 Rotary base | ⑧ 福马轮 Wheel | ⑬ 电气盖板 Front cover |
| ④ 过线器 Wire thread | ⑨ 操作面板 Operation panel | ⑭ 压紧把手 Handle |
| ⑤ 行程开关 Limit switch | ⑩ 船型开关 Switch | ⑮ 电炉箱 Cabinet |


四、功能说明 Function description

1.主要界面 the main panel

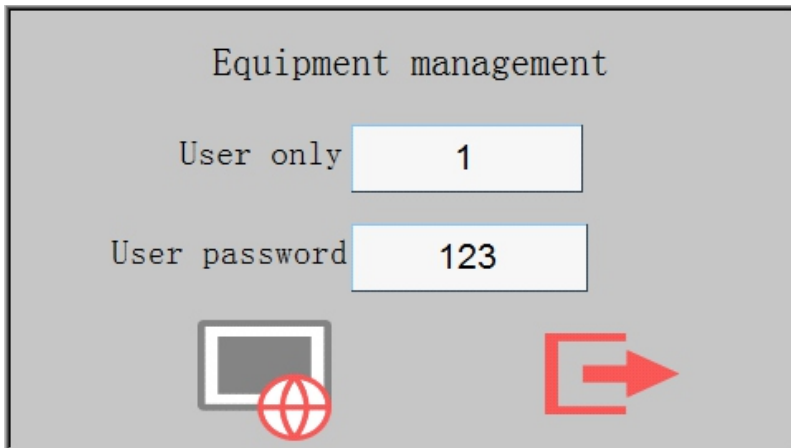




提示：所有操作需要在管理界面输入密码123才能获取权限操作设备，设备5分钟未操作，自动注销操作权限。

Tips: the password 123 must be input on the management interface to obtain the permission to operate this equipment before all the operations are conducted. If the equipment is not operated for 5 minutes, the permission will be canceled automatically.

- ① PV 炉膛显示温度
PV the temperature shown on the chamber.
- ② SV 当前程序设置温度
SV the temperature set in the current program.
- ③ MAXSV 超限保护温度
MAXSV over-limit protection temperature.
- ④ STEP 加热步骤 (操作时候可以插入跳变到其他步骤)
STEP heating steps (In the process of the operation, the current step can be transferred to other steps.)
- ⑤ TIME (Min) 当前步骤已运行时间(每1.6分钟增加一次)
TIME(Min) the time for which the current step has been running(it increase every 1.6 minutes)
- ⑥ LED红色程序启动，灰色程序未启动
LED the red program has started , gray program has not started.
- ⑦  进入管理界面
Enter the management interface.
- ⑧ RUN 启动程序
RUN run the program
- ⑨ STOP 终止程序
STOP stop the program

2.操作管理界面 Operate the management interface



- ① User password 输入正确密码123，获取系统操作权限
User password input password 123 to obtain permission of operation
- ②  返回主页
back to home
- ③  进入参数设置界面
enter the interface to set parameters

3.系统参数设置 Set the parameters in the system

Parameters. 1					
STEP	SV	TIME	STEP	SV	TIME
1	100	200	6	650	999
2	200	100	7	650	999
3	300	100	8	0	0
4	400	100	9	0	0
5	550	200	10	0	0

Parameters. 2					
STEP	SV	TIME	STEP	SV	TIME
11	0	0	16	0	0
12	0	0	17	0	0
13	0	0	18	0	0
14	0	0	19	0	0
15	0	0	20	0	0

- ① Parameters.1 界面1参数
Parameters 1 interface 1 parameters
- ② Parameters.1 界面2参数
Parameters 1 interface 2 parameters
- ③ Step 步骤
- ④ SV[°C] 设置温度
SV[°C] set temperature
- ⑤ TIME[Min] 设置时间
TIME[Min] set time

4.内部加热模式 Internal heating model

默认斜率模式，系统根据按设定温度，自动计算每分钟升温多少℃，进行升温控制。如有特需要求需阶梯加热模式请联系我厂技术支持；

Default slope mode.the system will automatically calculate how many degrees the temperature rises to control the temperature according to set temperature. If, due to the specail requirements, you need a step-by-step heating mode, please kindly contact our technical sopport team.

5.加热参数设置 Set parameters for heating

按加热步骤设置加热温度与加热时间，程序最大20步，若只前5步加热，在第五步加热时间设置为999；

Set the heating temperature and heating time according to heating steps. 20 steps are set in the program. If heating is set only for the first 5 steps, when heating is going on for the 5th step, you can set the heating time 999.

6.加热启动 Start heating.

按下屏幕“启动”按键，系统按照设置参数进行加热；

Press “start”button on the screen, the system will heat according to the parameters set.

7.停止加热 Stop heating

按下屏幕“停止”按键，系统停止加热，加热步骤为0；

Press “STOP”button on the screen, the system stops heating, the step for heating is 0

五、操作前准备Preparation before operation

1.接通电源前的检查 Check before the power is connected

- 将电源连接到外部供电电源（AC220V 50HZ）。
- 漏腊口无堵塞，炉内无异物。
- 禁止有金属与发热丝触碰，防止短路、漏电。
- Connect the power with outside power supply
- The hole for emititng wax is not blocked, there is no other object in the oven.
- Metals can not touch the heating wires to avoid short circuit and power leakage.

2.接通电源后的检查 Check after connecting the power

- 检查温度传感器检测数据是否正常。
- 使用手动操作检查加热时发热丝的电流数据，是否有发热丝断路等情况。
- Check if the data of temperature sensor is normal or not.
- Please check manually the current of heating coils when heating is going on, whether the problems including short circuit happens.

六、操作流程 Casting process

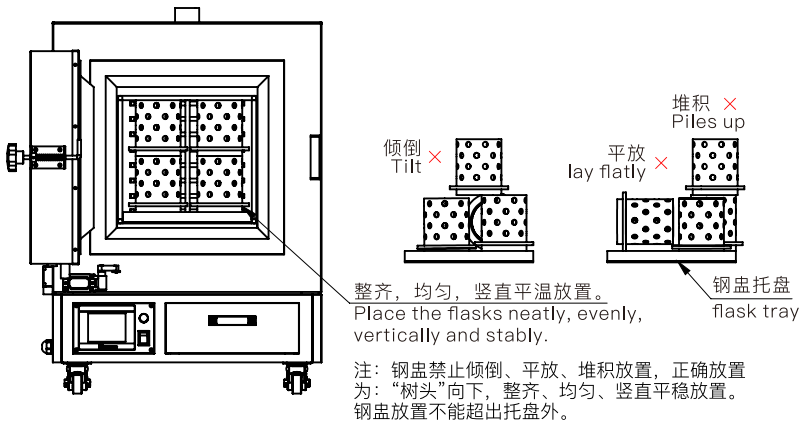
1.开启电源 Start power

- 按下船型开关 Press the switch

2.放入钢盅 Put the flasks into the oven

- 将钢盅正确放置于炉膛钢盅托盘上，钢盅不得超出托盘外。放置完后关上炉门，炉门行程柱触碰行程开关后，加热指示灯亮
- Place the flasks on the pallet in the chamber completely and correctly. Then close the door of the oven.

3.钢盅摆放方式 Ways of placing the flasks:



- 注：机器运行时，严禁移动、撞击机器。如机器运行过程中发现有钢盅倒伏或者存在倒伏的可能时请立即停止机器，将倒伏钢盅取出。
- 注：钢盅禁止倾倒，平放，堆积放置，正确放置为：“树头”向下，整齐，均匀，竖直平稳放置。钢盅放置不能超出托盘外。
- 注：钢盅禁止倾倒，平放，堆积放置，正确放置为：“树头”向下，整齐，均匀，竖直平稳放置。钢盅放置不能超出托盘外。
- **注意：此过程必须关闭机器电源进行操作。**
- It is prohibited to move the machine and hit the machine when it is working. If you find that the flasks have fallen or may fall down when it is working, please stop the machine from working, then take out the corresponding flasks.
- Note: the flasks can not be dumped, lain flatly or stacked. The right method of placing the flasks: The bottom of the fasks must be upside down,all fasks must be placed neatly,evenly,vertically and stably. Flasks can not be placed beyond the tray.
- Note: the flasks can not be dumped, lain flatly or stacked. The right method of placing the flasks: The bottom of the fasks must be upside down,all fasks must be placed neatly,evenly,vertically and stably. Flasks can not be placed beyond the tray.
- **Please note that this process must be done when the power of the machine is turned off.**

七、日常保养Daily maintenance

- 定期清理炉内托盘与排腊口上的残渣或灰尘，防止造成排蜡管堵塞。
- Please clean up the residue and dust on the tray and to prevent the pipe from being blocked.

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艺辉铸造科技有限公司

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