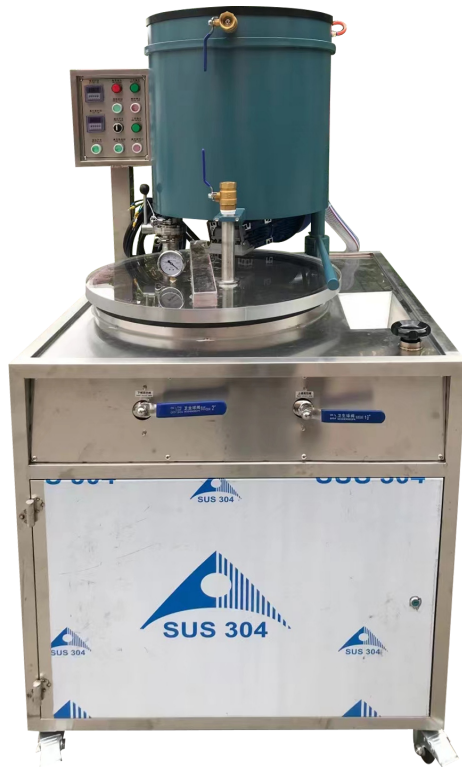


Yihui Casting® 艺辉

真空搅粉机

Vacuum Mixer Manual



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声明

致用户：

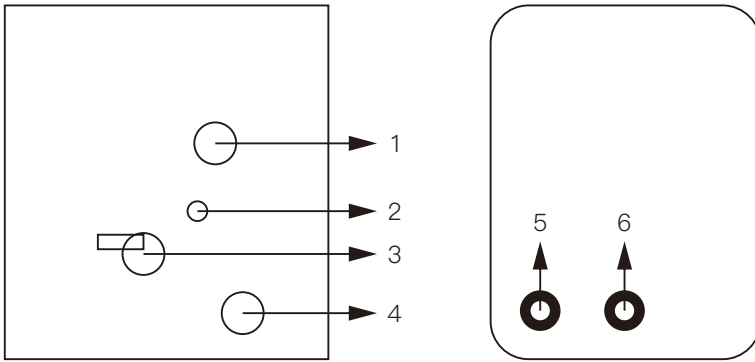
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STATEMENT

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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.

一、机器背面说明图 Back of machine



1、排水口：机面漏斗出水口，用1.5寸胶管接入，并用1.5寸管箍锁紧。

Water out: funnel water out, connect to 1.5inch hose, fix with 1.5 inch pipe hoop.

2、入水口：用4分管接入水源，并用4分管箍锁紧。

Water in: connect to 4inch hose, fix with 20mm pipe hoop

3、下桶排水口：下桶废水出口处。

Down bucket: down bucket wastewater out.

4、真空接入口：用1寸胶管与真空泵相连，并用1寸管箍锁紧。

Vacuum in: connect to vacuum pump by 1 inch hose, fix with 1 inch pipe hoop

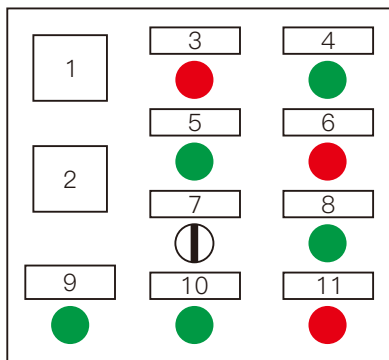
5、电源线：五芯电缆分为三条火线一条零线与一条地线，其中三条带“Y”线头的为火线，蓝色的为零线，黄蓝相间的为地线，此电缆与电源连接，五线都需连上。

Power cable: The five-core cable is divided into three live wires, a neutral wire and a ground wire. Three of them with "Y" wire are live wires, the blue wire is the neutral wire, and the yellow and blue wire is the ground wire. This cable is connected to the power supply. All five wires must be connected.

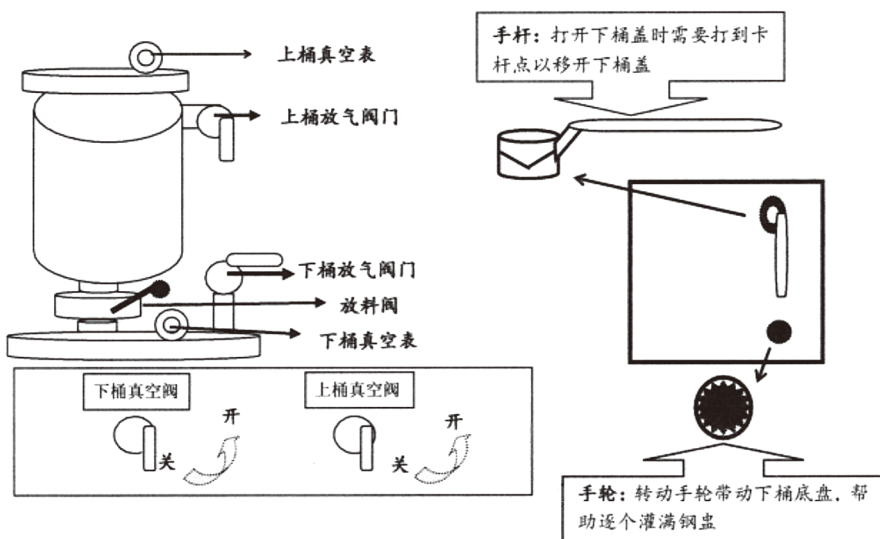
6、真空泵连接线：四芯电缆分为三条火线一条地线，其中三条带“0”线头的为火线，黄蓝相间的为地线，此电缆与真空泵连接，连接时注意真空泵转向，若连接后真空泵反向工作，则把已连接到真空泵的其中两条火线调换连接到真空泵即可。

Vacuum pump connection line: The four-core cable is divided into three live wires and one earth wire. Three of them with "0" wire are live wires, the yellow and blue wires are earth wires. This cable is connected to the vacuum pump. When connecting, pay attention to the direction of the vacuum pump. If connected, the vacuum pump works in reverse, Then the two live wires that have been connected to the vacuum pump can be exchanged and connected to the vacuum pump.

二、控制说明图 Control illustration



- 1、搅拌时间制 Mixing time model
- 2、真空泵时间制 Vacuum pump time model
- 3、电源指示灯 Power Indicator
- 4、上桶指示灯 Upper barrel indicator
- 5、搅拌启动 Start mixing
- 6、搅拌停止 Stop mixing
- 7、振动开关 Vibration switch
- 8、下桶指示灯 Lower barrel indicator
- 9、加水开关 Adding water button
- 10、真空泵启动 Vacuum pump start
- 11、真空泵停止 Vacuum pum stop



电源指示打: 电源指示灯亮起时表示本机器电源已接通。

Power Indicator: the power indicator light is on, means that the power of the machine is turned on

上桶指示打: 搅拌工作开启时亮起, 搅拌停止时熄灭。

Upper barrel indicator: Lights up only during mixing

搅拌启动按钮: 即搅拌启动按钮, 按此开关, 上桶搅拌工作启动。

Start mixing button: press the start mixing button, upper barrel starts mixing.

搅拌停止按钮：即搅拌停止按钮，按此开关，上桶搅拌工作停止。

Stop mixing: press the stop mixing button, upper barrel stops mixing.

下桶指示灯：真空泵启动时亮起，真空泵停止工作时熄灭

Lower barrel indicator: it light up when Vacuum pump working.

真空泵启动按钮：即真空泵开关按钮，按此开关，真空泵启动。

Vacuum pump start: press the vacuum pump start button, vacuum pump starts.

真空泵停止按钮：即真空泵停止按钮，按此开关，真空泵停止工作。

Vacuum pump stop button: press the vacuum pump stop button, vacuum pump stops

搅拌时间制：设置上桶搅拌工作时间，所设时间到后搅拌工作自动停止。如：设置5M22，则搅拌工作5分22秒钟后自动停止。（单位：H为小时，M为分钟，S为秒）

Mixing time model: Set upper barrel mixing time, when the set time is up, the mixing work will stop automatically.

真空时间制：设置真空泵工作时间，所设时间到后真空泵自动停止工作。如：设置8M22，则抽真空工作8分22秒后自动停止。（单位：H为小时，M为分钟，S为秒）

Vacuum pump time model: Set the vacuum pump time, and the vacuum pump will automatically stop working when the set time is up. For example, if set 8M22, the vacuum will stop automatically after 8 minutes and 22 seconds.

加水开关按钮：按此开关，上桶有水加入，再按一下，加水停止。

Adding water button: press adding water button, water adding into upper barrel, press again, adding water stops.

下桶真空阀：真空泵工作启动后，往上打开球阀，下桶进入抽真空状态，往下关闭球阀则下桶停止抽真空状态。

Lower barrel vacuum valve: After the vacuum pump started, open the ball valve upward, the lower barrel starts vacuuming, if close the ball valve downward, the lower barrel stops vacuuming

上桶真空阀：真空泵工作启动后，往上打开球阀，上桶进入抽真空状态，往下关闭球阀则上桶停止抽真空状态。

Upper barrel vacuum valve: After the vacuum pump started, open the ball valve upward, the upper barrel starts vacuuming, if close the ball valve downward, the upper barrel stops vacuuming

上桶放气阀门：上桶停止抽真空状态后，打开此球阀，上桶进入空气。

Upper barrel exhaust valve: upper barrel stop vacuuming, open, upper barrel exhaust valve, air enter upper barrel.

放料阀：上桶石膏粉搅拌好后，打开球阀对准钢盅注入石膏。

Release valve: after upper barrel finished mixing, aim to flask and open release valve to inject gypsum to flask.

下桶放气阀门：下桶停止抽真空状态后，打开此球阀，下桶进入空气。

Lower barrel exhaust valve:after lower barrel stoped vacuuming,open Lower barrel exhaust valve,air enter lower barrel.

上桶真空表：显示上桶真空度以及检测上桶气密性。

Upper barrel vacuum gauge:show the vacuum pressure of upper barrel and check the air tightness of the upper barrel

下桶真空表：显示下桶真空度以及检测下桶气密性。

Lower barrel vacuum gauge:show the vacuum pressure of lower barrel and check the air tightness of the lower barrel.

振动开关：打开下桶振动，关闭振动停止。

Vibration Button:turn on vibration button,lower barrel vibrating,turn off vibration button,lower barrel stop vibrating.

随机配件 Spare parts

1.5米长1.5寸钢丝胶管一条（接到机身后排水口）

One 1.5m*1.5inch hose pipe (connect to the water out back of machine)

两米长1寸钢丝胶管一条（连接机身后的真空接口与真空泵）

One 2m* 1 inch hose (connect the vacuum in and vacuum pump)

两米长4分塑胶水管一条（连接机身右侧接水口与水龙头）

One 2m* 20mm hose (connect the water in and faucet)

1.5寸管箍一个、1寸管箍两个、4分管箱两个

1.5 inch pipe hoop × 1pcs, 1 inch pipe hoop × 2pcs, 20mm pipe × 2pcs

三、控制说明图 Control illustration

1、操作前务必检查所有球阀（包括：放料阀、上桶放气阀门、下桶放气阀门、上桶真空阀、下桶真空阀和在机身后的下桶排水口球阀）处于关闭状态。

Before operation, please check all ball valve (including: Release valve、Upper barrel exhaust valve、Lower barrel exhaust valve、Upper barrel vacuum valve、Lower barrel vacuum valve and lower barrel water out ball valve) and make sure all ball valve closed.

2、把手杆拉到卡杆位置，把上桶移开，放好钢盅（本机最多放入5个4寸钢盅），再把上桶移回原位，盖好下桶（注：桶盖要覆盖下桶的延边），然后把手杆拉回固定位置。

Pull the handle, remove the upper barrel, place flask (at most 5 4-inch flasks) , pull back to original position, cover lower barrel (The lid should cover the edge of lower barrel) , the pull handle back.

3、打开上桶桶盖，按比例倒入所需清水和铸造粉（首次使用本机请先只倒入清水操作，以熟悉本机操作流程），盖好上桶（注：桶盖要覆盖上桶的延边）。

Open the lid of the upper barrel, pour in water and casting powder in proportion (please pour only water for the first time to familiarize the operation process), then cover the upper barrel (The lid should cover the edge of upper barrel).

4、设置“搅拌时间制”和“真空泵时间制”时间

Set “Mixing time model” and “Vacuum pump time model” time.

5、按“搅拌启动”按钮，启动搅拌工作。

Press Start mixing button, start mixing.

6、按“真空泵启动”按钮，真空泵启动。

Press the vacuum pump start button, vacuum pump starts

7、打开“上桶真空阀”和“下桶真空阀”，使上桶和下桶都处在抽真空状态。

Open the upper barrel vacuum valve and lower barrel vacuum valve, keep upper barrel and power barrel in vacuuming.

8、若铸造粉搅拌在“搅拌时间制”所设时间前已到达所要求，可按一下“搅拌停止”按钮，提前搅拌停止（搅拌时间到达“搅拌时间制”所设时间后，搅拌会自动停止，若打算手动控制上桶搅拌，请在“搅拌时间制”上把时间值设定大于预期所需时间，否则搅拌停止后需要再次按“搅拌启动”按钮启动搅拌，计时重新）。

In “Mixing time model”, if the casting powder mixing has reached the required requirements before set time is up, press stop mixing button to stop mixing in advance. (upon the mixing time reaches the time set in the “mixing time

model”，the mixing will automatically stop,if you want to manually control the upper barrel mixing, please set the time in the "mixing time model" to be more than the expected time, otherwise you need press the "mixing start" button again to start mixing after the mixing stops, and the timing will restart).

9、铸造粉搅拌完成后，然后缓慢打开“放料阀”（此球阀需提起才能打开），通过转动黑色手轮，把钢盅逐个注满铸造浆，最后关闭“放料阀”，并关闭“上桶真空阀”。

Casting powder finished mixing, open release valve slowly (This ball valve needs to be lifted to open) , fill the flask one by one By turning the black hand wheel, finally close release valve and close the upper barrel vacuum valve.

10、关闭“上桶真空阀”后，打开“振动开关”此时全机只剩下桶处于抽真空状态，此时可 对上桶进行前期清洗工作。

上桶前期清洗步骤：按“注水开关”往上桶注入适量清水然后再按一下“注水开关”停止注水，进行短时间搅拌，以免上桶剩余石膏浆硬化（此步骤中的 注水与搅拌可同时进行），下桶此时依然处于抽真空状态。

After closing the upper barrel vacuum valve,turn on vibration button,now only lower barrel is vacuuming. You can clean the upper barrel.

Upper barrel clean step:press water in switch to stop water in,mix for a short time to avoid hardening of the remaining gypsum slurry in the upper barrel.(Water injection and mixing can be carried at the same time)lower barrel is still vacuuming.

11、观察下桶，若钢盅内注浆在“下桶时间制”所设时间前已达到所要求后，可关闭“下桶真空阀”，关闭“振动开关”，然后按一下“真空泵停止”按钮停止真空泵工作并关闭，此时全机各工作停止，然后缓慢打开“下桶放气阀门”（注：切勿快速打开，一定要缓慢打开，否则气压会冲起钢盅内铸造浆破坏石膏模），缓慢打开“下桶放气阀门”后，使空气充分进入真空表归零后关闭“下桶放气阀门”。

Observe the lower barrel,if the injection to flask has reached the requirements before the time set in the "barrel time model", you can close the lower barrel vacuum valve.Then press the vacuum pump stop button to stop the vacuum pump and turn it off, now the machine stop working,open the Lower barrel exhaust valve slowly(do not open it quickly, it must be opened slowly, otherwise the air pressure will rush up the casting slurry in the flask and quickly break the mold.)

12、把手杆拉到卡杆位置，把上桶移开，拿走所有钢盅，用水枪对下桶稍作清洗，亦可完成 本机器该工作日使用后再清洗，“下桶排水球阀”在机身 后，打开排走下桶废水，再关上即可。

Pull the handle and remove the upper barrel, take away all flasks, Clean the lower barrel with a water gun, lower barrel water out valve is back of the machine open it, and discharge wastewater then close it.

13、把上桶移到机面漏斗位置，使放料口对准漏斗，打开”上桶放气阀门“至真空表归零后关上，打开“放料阀”，排走上桶多余废水后再按一下“搅拌停止”按钮停止搅拌，若 上桶清洗不足，应用清水作进一步清洗至干净程度（对上桶进一步清洗时，必须在搅 拌工作停止后进行，以免搅拌对人体造成误伤）。

Move the upper barrel to the funnel position,align the discharge port with the funnel, open

upper barrel exhaust valve until the vacuum gauge bacome zero, then close it. Open the release

Valve,after draining the excess waste water from the upper barrel, press the stop mixing button to stop mixing,If the upper barrel is not cleaned enough, do further cleaning.(to avoid accidental injury to the human body caused by the mixing,before cleaning the upper barrel, it must make sure stoped mixing)

14、把上桶移回原位，拉回手杆，盖回桶盖，使机器恢复到使用前状态，重复步骤1-13进行下一次操作。

Move the upper barrel back to its original position, pull back the handle, and close the lid to restore the machine to the state before use. Repeat steps 1-13 for the next operation.

四、真空搅拌机基本参数 Vacuum mixer parameters

尺寸(mm) Dimention	规格 Specifcation	电源 Power Supply	电机功率 Motor Power
720x850x1270	4x11 & 5盅	AC380V	550W
880x950x1350	4x11 & 8盅	AC380V	550W

为了机器生产效果更理想，本公司建议本机器搭配30升每秒以上真空泵使用。

In order to achieve a better production effect, we recommends that this machine be used with a vacuum pump of more than 30 liters per second.

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