

Yihui Casting® 艺辉

5盅搅粉机

5 pcs Vacuum Mixer



专注于首饰铸造
Specializing In Jewelry Casting

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profession Dedication Cooperation Double-win

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声明

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- 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。
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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 safty 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.

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一、技术参数 Technical parameter

型号 Model	Z.M.VM.SAS05-1
电压 Voltage	220/380V, 50/60HZ, 3phases; 220V/50HZ
功率 Power input	2kw
抽气速度 Exhaust speed	15/L,30/L
极限压力 Max pressure	$6 \times 10^{-2} \text{Pa}$
外形尺寸 Size(mm)	L650xW780xH1400
重量 Weight	130kg

二、产品特点 Product features

五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5个4" x 10" 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 5 flasks investment powder mixer is specially made for high precision casting process. It can hold 5 pcs of 4"*10" flask at one time. It provides vacuumizing and mixing at the same time which means the whole investing process can be done in vacuum circumstance. Therefore, without air in the investment powder, the casting piece surface will be smooth and nice. This equipment is a good choice for high precision casitng.

三、操作说明 Operation Instruction

接好搅粉机电源及真空泵（三根相线，一根零线，一根地线），点动观察搅粉电机及真空泵的正反转，如反转请调转任意两根相线。

Connect the power supply and also vacuum pump for the mixer (three phase lines, one neutral line,one ground wire).And observe the rotation of the mixer and the vacuum pump. If reverse to the indication, please turn any two phase lines.

- 1.将钢盅放入下桶并摆好位置，使每一盅都能对准放粉口，关闭放粉阀门，打开抽真空控制阀门。设定搅粉时间3-4min，抽真空1-2mins。
- 2.称好石膏粉，和所需要的水（1kg粉兑380-400ml的水）。
- 3.将三分之一的水先倒入上桶，再将石膏粉倒入，最后倒完剩下的水盖好上盖，打开搅粉开关，接着打开抽真空开关，再打开搅粉定时开关。
- 4.待搅粉时间到峰鸣提醒关闭搅粉定时开关，打开放粉阀门逐个将钢盅注满石膏浆，然后关闭放粉阀和抽真空控制阀门，立即打开抽真空定时开关，并打开进水开关清洗上桶。
- 5.待抽真空时间到峰鸣提醒(-760mmHg)，关闭抽真空定时开关和抽真空开关，打开排气开关和抽真空控制阀门，排完真空至大气压，双手托住钢盅的胶底座拿出钢盅，最后清洗搅粉机。
- 6.石膏粉静止1小时左右完全凝固后铲干净法兰边多余的石膏，去掉胶底座，胶纸按铸造温度次序放进电炉焙烧。

- 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 the pouring valve, and open vacuum control valve, Set the mixing time as 3mins -4 mins and vacuumizing 1mins-2 mins.
- 2.weigh the gypsum powder, and the required water(1 kg powder against 380-400ml of water).
- 3.Pour one-third of the water into the upper chamber first, then pour the powder into it. Finally,pour the remaining water and cover the lid. Open the mixing switch, then the vacuumizing switch, lastly the mixing timer switch.
- 4.Turn off the mixing timer switch when there is beep reminder for mixing time up, open the powder discharging valve and fill the flasks slurry one by one. Then close the powder discharging valve and the vacuumizing control valve and immediately open the vacuumizing timer switch, vibration switch and water inlet switch to clean uppder chamber.
- 5.When vacuumizing time up (value around -760mmHg), buzzer will remind you to turn off the Vacuumizing timer switch and also the vacuumizing switch. Open the exhausting switch and vacuum control switch, and exhaust the down chamber to atmospheric pressure.Take out the flasks as hold the rubber bases, and then clean the machine.
- 6.The powder is completely solidified for about 1 hour, then clean the powder from flask flange.Remove rubber base and also the tape and placed flask into an burnout oven for firing in the order of casting temperature.

四. 机器的保养注意事项 Machine maintenance precautions

- 1.来回移动上桶时，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搅粉机上下桶以及上桶真空管道避免石膏长期累积堵塞

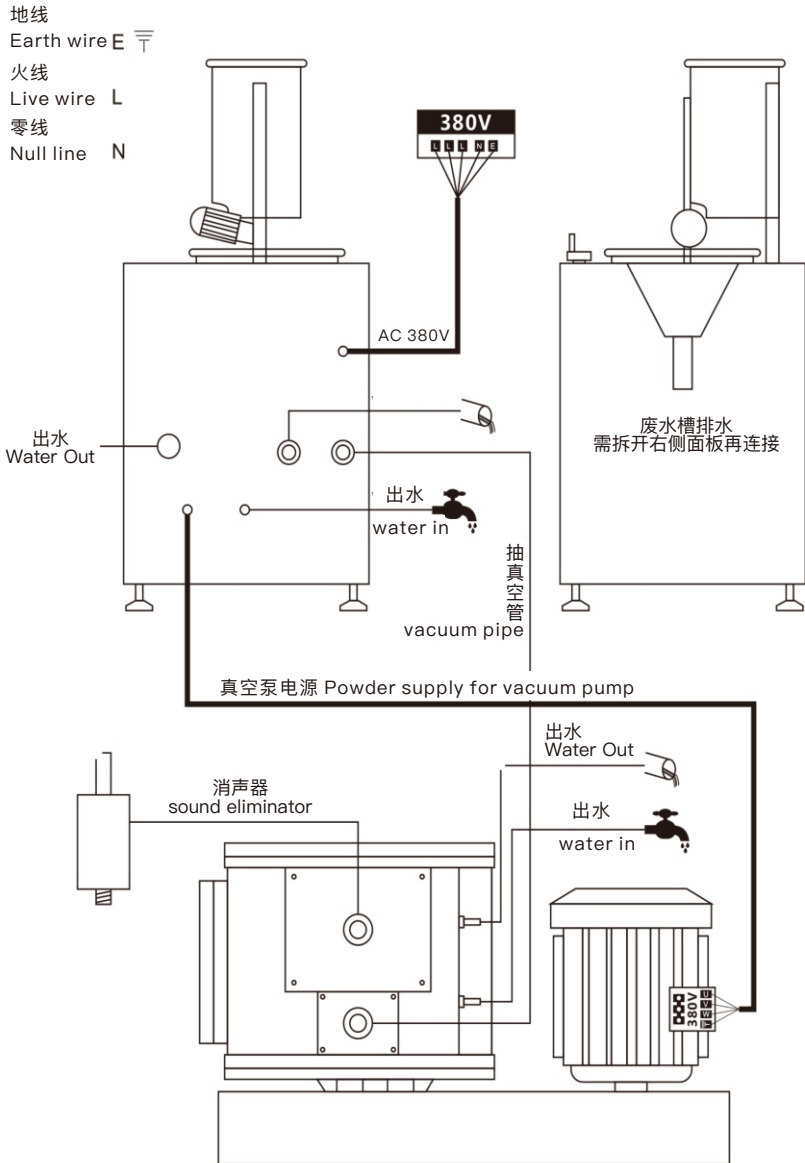
- 1.Before move the up mixing chamber, please ruse up the chamber with long handle to avoid damage of sealing rings.
- 2.Before start vacuum pump every day, open oil drainage hole to drain out the water first.
- 3.Regularly clean the filter inside of the mixer
- 4.The top of the rising bar needs to be lubricated with butter
- 5.Wash immediatly after each mixing to avoid blockage caused by long-term cumulative of powder.

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 underside barrel





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