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Yihui Casting® 艺辉

17盅/40盅旋转电炉

17/40 PCS flasks rotary burnout oven

专注于首饰铸造
Specializing In Jewelry Casting

专业 · 敬业 · 合作 · 共赢
Profession, Devotion, Cooperation, Double-win

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九、系统出现故障时会出错报警并提示
When the system fails, it will alarm and prompt.

故障现象 Fault phenomenon	处理方法 Handling method
上层温度出现红色字体 The upper temperature appears in red	上层热电偶故障 The upper thermocouple is faulty
中层温度出现红色字体 The middle temperature appears in red	中层热电偶故障 The middle thermocouple is faulty
下层温度出现红色字体 The lower temperature appears in red	下层热电偶故障 The lower thermocouple is faulty
炉温不加热 Theoven temperature is not heated	1、超温保护 2、门未感应关闭 1. Overtemperature protection 2. The door is not induction closed
工作灯闪烁、报警灯亮 The working light is blinking and the alarm is on	门未关好 The door was not closed properly

十、配件清单 Parts list

名称 Name	数量 Number
接蜡盒 Wax box	1个 1 pcs
二次燃烧 Secondary combustion	1台 1 set

提示：如果炉膛需要延时工作，第1步设置0°C对应延时时间
炉膛恒温设置：例如第5步需要恒温720°C烘焙时间最少4小时方法：
将第5步设置720°C 时间设置240min，再将第6步设置720°C 时间设置9999min

Tip: If the oven needs to delay working, step 1 set 0°C corresponding to the delay time.
Interiro constant temperature setting: For example, step 5 requires constant temperature of 720°C and burn time of at least 4 hours. Method:
Set step 5 to 720°C and time to 240min, then set step 6 to 720°C and time to 9999min.

二次燃烧设置：第一次燃烧时间需要计算炉膛300°C之前的累计时间，需要提前30分钟打开二次燃烧。温度设置在800-900°C，第二段为燃烧时间设置120分钟。

2nd burn: The first brun time needs to calculate the cumulative time before the interiro reaches 300°C, and the 2nd burn needs to be turned on 30 minutes in advance. The temperature is set at 800-900°C, and the second stage is set for the burning time of 120 minutes.

八、用户操作 User operation

1、选择<放盅模式>：填写放盅位置，放入钢盅。
2、旋转<炉温设置>：选择对应的程序，或者修改炉膛加热温度与时间，并根据需求按照参数设置中的提示，设置好二次燃烧参数，检查钢盅是否放好，长按加热按键，启动加热。
3、面板检查：旋转开关在自动档。
4、取盅：在取盅模式下，并将三档开关选择在取盅档位，输入钢盅编号，等待转盘动画停止，打开门取盅，第一次取盅完成，关门后，钢盅自动停止在下一钢盅的位置。
提示：每次开门后必须关好门。
提示：取盅时若发现钢盅偏移：可以将三档开关选择在手动档，长按真转或者反转，停留在需要的位置取盅。

1. Select <flask in mode>: fill in the flask placement position and place the flask.
2. Rotate <oven temperature setting>: select the corresponding program, or modify the interiro heating temperature and time, and follow the prompts in the parameter setting to set the 2nd burn parameters as needed, check whether the flask is placed, and long press the heating button to start heating.
3. Panel inspection: Rotary switch is in automatic gear.
4. Flask out: In the flask out mode, select the three-speed switch to the flask in position, enter the flask number, wait for the turntable animation to stop, open the door to take the flask, the first flask out is completed, after closing the door, the flask automatically stops At the position of the next flask.
5. Tip: You must close the door every time you open the door.

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。
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版本： V2.0 2023.10.20

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 propperty 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 inccurs.
- 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 permittion, 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 mistake or omission in this manual, please inform the supplier you bought the machine from. We will be very grateful for this.

Version number: V2.0 2023.10.20

一、注意事项 Notice

警告

1、电源按照标识接线，必须接地线，供电功率大于设备额定功率；
2、设备安装场地，要求有通风，禁止有易燃易爆物体；
3、设备有高温，必须经过专业的培训合格后才可操作；
4、设备高温工作，必须穿防护服，戴高温手套，以免造成伤害；
5、转盘上的石膏模具应摆倒放，快速排蜡，并整齐摆放，防止模具掉落损坏炉壁及发热丝短路、漏电；
6、当产生升温排蜡时切勿开门，此时开门可能导致炉内燃烧；
7、每次启动前检查是否放排蜡箱，并定期清理，防止火灾；
8、炉内应保持清洁，转盘与排腊口上的残渣或灰尘会造成堵塞。大量的可燃混合气会积累在炉内，具有很大的安全隐患；
9、断电后再次启动电源需等待10秒以上。

Warning

1. Please refer to the label to connect the power cable.The machine must be connected to the ground wire. The power supply is greater than the rated power of the device.
2. The equipment installation site must be well ventilated, and flammable and explosive objects are prohibited.
3. The equipment has high temperature, the operator must be qualified after professional training before operation.
4. The equipment works at high temperature. The operator must wear protective clothing and high-temperature gloves to avoid injury.
5. The plaster mold on the turntable should be placed upside down, quickly drained of wax, and neatly placed. Prevent mold fall damage oven walls and heating coils short circuit, leakage.
6. When generating incomplete-combustion wax gas, do not open the door, which maycauses burning in the interior of the oven.
7. Before each start of the machine, check whether the wax box is discharged, and clean it regularly to prevent fire.
8. The inside of the machine should be kept clean, the residue or dust on the turntable and the wax outlet will cause blockage. A large amount of combustible mixture will accumulate in the oven,which poses a great safety hazard.
9. After the machine is powered off, wait more than 10 seconds to start the power again.

名称 Name	功能 Function	说明 Instructions
中英文图标 Language	中英文语言切换 Chinese and English language switching	
电机速度 Motor RPM	调整旋转速度 Adjust rotation speed	0-100%
炉温上限 Max Temp.	炉温最大温度 Maximum temperature of oven	建议800°C Recommended 800°C

3、面板功能 Panel function
①三档选择开关：自动、取盅、手动
②正转按键
③反转按键
以上开关和按键仅仅控制转盘工作

①Three speed selection switch: automatic, flask out, manual
②Forward key
③Reverse key
The switches and buttons above only control the operation of the turntable

七、参数设置 Parameter setting

1、选择烘焙程序 1-1000
2、炉膛温度设置：炉温设置/炉膛/每步温度设置
3、炉膛加热时间设置：炉温设置/炉膛/每步加热时间设置
4、二次燃烧温度设置：炉温设置/二次燃烧/每步温度设置
5、二次燃烧加热时间设置：炉温设置/二次燃烧/每步加热时间设置

1. Select burn program 1-1000 sets
2. Interiro temperature setting: oven temperature setting/Interiro/Temperature setting at each step
3. Interiro heating time setting: oven temperature setting/2nd burn/each step heating time setting
4. 2nd burn temperature setting: oven temperature setting/2nd burn/each step temperature setting
5. 2nd burn heating time setting: oven temperature setting/2nd burn/each step heating time setting

名称 Name	功能 Function	说明 Instructions
转动图标 Rotating image	动作代表转动 静止代表停止 The image state in motion means that the turntable is rotating, and the image state in static means that the turntable has stopped rotating.	仅显示 Show only
上层温度 Top tempe	炉膛上层温度 TopInteriro temperature	仅显示 Show only
中层温度 Middle tempe	炉膛中层温度 Middle Interiro temperature	仅显示 Show only
下层温度 Bottom temp	炉膛下层温度 Bottom Interiro temperature	仅显示 Show only
二次燃烧 2nd burn	二次燃烧温度 Secondary burn temperature	仅显示 Show only

⑤系统设置 Parameters

二、产品介绍 Product introduction

旋转炉应用于失蜡铸造工艺中的钢盅脱蜡烘焙工艺。

旋转炉优点：炉膛圆形发热丝热辐射均匀对钢盅加热，三组独立的炉丝控制，进行差温补偿，加之内部有旋转机构充分搅拌，做到上下层温度一致。操作系统含有1000组程序，多段加热曲线，满足不同工艺的铸造需求。

二次燃烧装置，充分燃烧烘焙脱蜡产生的有害废气体，降低对空气污染。

系统操作：亲和的人机界面，按照铸造工艺去进行的专业系统设计，参数设置、入炉、取盅复杂的操作简化。

系统安全：超温保护、开门加热保护、炉丝短路保护。

Rotary oven is applied to dewaxing baking process of flask in lost wax casting process.

Advantages of rotary oven: the circular heating coils of the oven heats the flask evenly with heat radiation, three sets of independent heating coils control, differential temperature compensation, and the internal rotating mechanism is fully stirred, so that the top and bottom temperatures are consistent. The operating system contains 1000 groups of programs, multi-stage heating curves to meet the casting needs of different processes.

The secondary burn device fully burns the harmful waste gas generated by baking and dewaxing, reducing air pollution.

System operation: Friendly human-machine interface, professional system design based on the casting process, simplifying complex operations of parameter setting, flask in, and flask out.

System safety: over-temperature protection, door-opening heating protection, heating coil short-circuit protection.

三、技术参数 Tehnical parameters

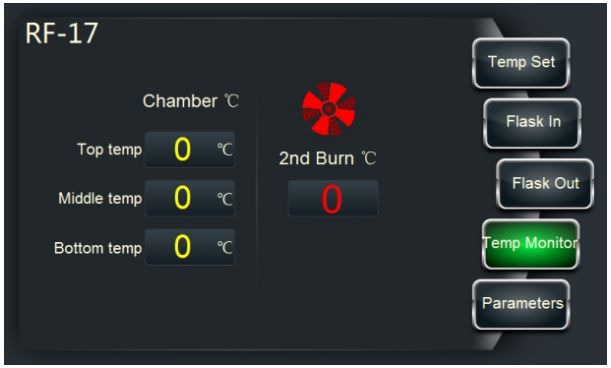
型号 Model	RF-17	RF-40
电压 Voltage	400V AC 3faz +N 50/60Hz	
功率 Power	≤10KW	≤15KW
温度设置范围 Temperature setting range	0-950°C	
探温 Temperature detection	3组炉膛 3 sets of interiro 1组二次加热 1 set of secondary heating	
控温精度 Temp. control accuracy	±5°C	
炉膛步骤 Interiro step	10步骤 10 Steps	
二次燃烧步骤 Secondary burn step	10步骤 10 Steps	
程序组 Program suite	1000组 1000 Sets	
每段时间 Every time	≤9999分钟 ≤9999minutes	
炉膛数量 Interiro number	4×10"无法兰 Without flange (17Pcs)	4×10"无法兰 Without flange (37Pcs)
转盘直径 Turntable diameter	Φ400mm	Φ560mm
整机尺寸 Machine size (L×W×H)	1020×971×2065mm	1210×1090×2285mm
重量 Weight	约 About: 700Kg	约 About: 800Kg

中层温度 Middle temperature	炉膛中层温度 Middle Interiro temperature	仅显示 Show only
下层温度 Bottom temperature	炉膛下层温度 Bottom Interiro temperature	仅显示 Show only
加热步骤 Heating Step	当前加热步骤 Current heating step	仅显示 Show only
加热时间 Heating time	当前加热步骤升温时间 Current heating step Heating time	仅显示 Show only

提示：在升温过程中，每层温度不一致属于正常现象，恒温阶段会恒温

Tip: During the heating process, it is normal for the temperature of each layer to be inconsistent, and the temperature will be constant during the constant temperature stage.

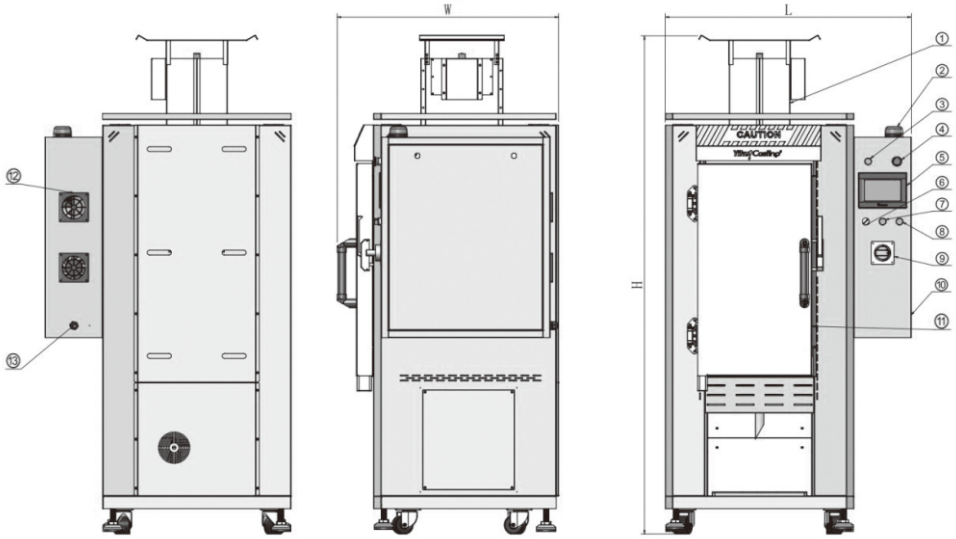
④炉温监视 Temp. monitor



③取盅界面 Flask out interface

名称 Name	功能 Function	说明 Instructions
当前钢盅位置 Current Place	显示钢盅位置 Show current the position of the flask	需要旋转一圈后开始计数 It takes one turn to start counting
设置放入钢盅位置 Flask out set	设置钢盅位置 Set the flask position	最大10组 Max 10 sets
转动图标 Rotating image	动作代表转动 静止代表停止 The image state in motion means that the turntable is rotating, and the image state in static means that the turntable has stopped rotating.	
上层温度 Top temperature	炉膛上层温度 Top Interiro temperature	仅显示 Show only

四、结构介绍 Structureomtroduction



①二次燃烧 ②报警灯 ③运行灯 ④急停开关 ⑤触控屏 ⑥模式选择开关 ⑦正转 ⑧反转
⑨总开关 ⑩电箱 ⑪炉门 ⑫散热风扇 ⑬电源线

①2nd burn ②Alarm light ③Working light ④Emergency stop switch
⑤Touch screen ⑥Mode selector switch ⑦Forword ⑧Reversal
⑨Main switch ⑩Electric box ⑪Oven door ⑫Cooling fan ⑬Power cord

五、设备连接 Equipment connection

1、电源接线按照标签接，必须接地
2、排蜡口必须放接蜡箱

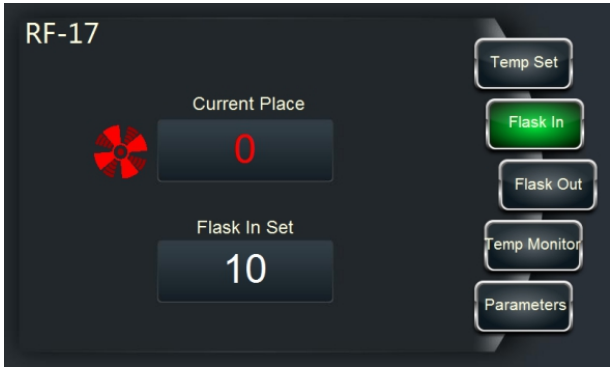
1. Connect power cables according to the label and must be grounded
2. The wax outlet must be connected to the wax box

六、操作界面 Operation interface

1、触控屏界面Touch screen interface
①炉温设置界面Temp. Set interface

名称 Name	功能 Function	说明 Instructions
程序 Program	0-1000组 0-1000sets	焙烧工艺程序 Roasting process program
加热步骤 Heating step	炉膛加热步骤 Oven heating steps	最大10组 Max 10 sets
温度 Temp	每步炉膛的加热温度 Heating temperature of the Interiro at each step	最大10组 Max 10 sets
时间 Time	每步炉膛加热时间 Interiro heating time per step	最大10组 Max 10 sets
二次燃烧温度 2nd Heat temperature	每步炉膛的加热温度 Heating temperature of the interiro at each step	最大2组 Max 2 sets
二次燃烧时间 2nd heat time	每步二次燃烧加热时间 Secondary burn heating time per step	最大2组 Max 2 sets

②放盅界面 Flask in interface



名称 Name	功能 Function	说明 Instructions
当前钢盅位置 Current place	显示钢盅位置 Show Current the position of the flask	需要旋转一圈后开始计数 It takes one turn to start counting
设置放入钢盅位置 Flask in set	设置钢盅位置 Set the flask position	最大10组 Max 10 sets
转动图标 Rotating image	动作代表转动 静止代表停止 The image state in motion means that the turntable is rotating, and the image state in static means that the turntable has stopped rotating.	