

### Semi-automatic brake shoe roll welding machine

# OPERATION INSTRUCTIONS



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### —、Preface

Thank you for purchasing and using the semi-automatic brake shoe roller welder. This manual is the use and maintenance data of this equipment. The products we supply to customers are not only our design results, but also how to give full play to the equipment (operation technology) and maintain the best state (safety maintenance).

In order to ensure the safety of the operator and maintain the excellent performance of the equipment for a long time, please read this manual carefully and save it for subsequent use before using the equipment, so as to avoid danger or damage to the machine during operation.

All parts of our products ensure their safety and rationality. If the equipment is operated incorrectly or violates the operating procedures, it will directly cause equipment damage or injury to operators. Now some precautions are described as follows:

1 . operators can operate the equipment only after passing relevant skill training.

② When replacing the equipment fixture or repairing, the equipment is in the "emergency stop" state.

Before operation, be sure to safely understand the matters described in the operation manual, and please operate the equipment in accordance with the contents of the operation manual. According to the characteristics of the equipment, we can get a long service life, but we must pay attention to faults and troubleshooting. We sincerely hope that the operator will fully understand the contents described in the operation manual before operation, so as to maintain the best use state of the equipment at any time and ensure the service life.

This machine is subject to upgrade or update at any time without notice. Please understand! If you have further technical or use problems, please contact us in time.

### 二、Summary

The B-ZT series semi-automatic automobile brake shoe intermediate frequency roll welding machine adopts pressure welding method to directly make the panel round and the hoof tendon welded. Change the traditional single point welding process. It has the advantages of high efficiency, high quality, high energy saving, low cost, simple and convenient operation, and wide application range. It is an ideal welding equipment for the brake production industry. Below, we will elaborate on its operating principles, conditions of use, functions of each part, and daily maintenance.





5 ~40°C

### $\Xi$ 、Product working conditions

### 3.1 Working conditions

·Ambient air range

Working hours	

During transportation and storage  $0^{\circ}$ C  $\sim$ 40°C

·Air relative humidity

At 35℃ ≤50%

**At 20**°C **≤90%** 

•The content of dust, acid, corrosive gas and other substances in the surrounding air does not exceed the normal content.

The altitude does not exceed 1000 meters

·Grid voltage fluctuation: ≤±10% (when the grid frequency is the rated value)

·Grid frequency fluctuation: ≤±1% (when the grid voltage is the rated value)

### 3.2 Working environment

The product should be placed in a dry, ventilated and dust-free environment away from direct sunlight, rain, gas vapor, chemical deposition and corrosive media that seriously affect the use of the equipment, and avoid violent vibration and turbulence.

### 四、Safety Precautions

### 4.1 Electricity safety

The basic principle of preventing electric shock is not to touch the two poles of voltage electrical equipment at the same time. The specific precautions are as follows:

1 Sefore operation, you must wear qualified protective equipment, such as safety gloves, insulating shoes, and all labor protection equipment must be dry and undamaged;

2 Sefore servicing and testing the equipment, cut off the power supply to prevent electric shock.





#### 4.2 Mechanical equipment hurts

When the equipment is working, be sure to keep hands, hair, clothing and tools away from mechanical movement, pneumatic actuators and other operating mechanisms. Pay attention to pneumatic and mechanical pressure components that hurt people. Operators are not allowed to wear loose clothing and accessories.

#### 4.3 Comprehensive preventive measures

1. Ensure equipment power safety measures;

2. Only skilled electricians can work on high-voltage equipment;

3、The equipment safety warning signs must have clear signs and be readily available;

4. During the operation of the equipment, the lubrication and maintenance of the equipment cannot be carried out.

#### 4.4 Precautions for installation and debugging

1.After opening the package, confirm whether it is the model you ordered.

2.Check whether the equipment is damaged during transportation. If there is any damage, please contact our after-sales service.

3.Our company will not bear any responsibility for equipment damage or other losses caused by not strictly complying with the operating requirements specified in this manual.

4.After 7 days of installation and commissioning, our company cannot return the goods without reason.

5.Before installation and commissioning, please prepare 5 square meters of three-phase five-wire wires (the number of meters required according to your company's operating site), one 40A power switch, one bucket of purified water, about 20L, and several 10 mm air pipes. Compressed air less than 0.6MPa, steel strip materials, etc.

6.After installation and commissioning, our after-sales personnel will teach your company how to operate. Please be sure to send someone to study carefully.





### $\Xi$ 、 Equipment appearance description

### 5.1、 Cooling water circuit diagram:



Inlet valve
 Filter
 Vent valve
 Water flow regulating valve
 Water meter
 Outlet valve
 IF controller drainage

(\$) (1) (1) IF transformer drainage

① Upper conductive box drainage ① Lower conductive box drainage





#### 5.2、Water circuit description:

1. The user connects the inlet and outlet water strictly in accordance with the signs.

2. Each flow of water is greater than 20 liters.

3. The user must monitor it every 4 hours when using it (if any of the water flow is too low or blocked, it must be ruled out before it can be used).

4. The inlet water temperature is controlled between  $5\sim15^{\circ}$ C.

5. Disassemble the filter 2 every week for cleaning. Workers should empty the cooling water in the equipment when they stop production to prevent the waterway from freezing and cracking. The method of draining water is to close valve 1 first; then open the bleed valve 3, and close the drain valve 6 after one minute; finally, close the bleed valve 3.

6. Open the water inlet valve 1 and drain valve 6 when going to work



5.3、Gas circuit diagram:









② Air storage tank
 ③ Welding solenoid valve
 ③ Air pressure switch
 ③ Upper welding wheel stroke valve
 ③ Down pressure speed control valve
 ③ Upper welding wheel stop position adjustment nut

### 5.4、 Description of gas circuit:

1. The installed air inlet is entered by 18 (the customer installs the quick plug on the  $\phi$  10PU pipe and inserts it in 18)

2. Sliding valve 19 is a switch that controls the general gas circuit. Sliding upwards is open; when sliding downwards is closed, it is sliding upwards in the working state. Automatic drainage action and reduce the fatigue degree of the sealing ring, improve the service life of the air circuit components)

3. White oil should be filled in the oil cup 16, and the oil level should be kept between the upper limit and the lower limit

4. The oil volume adjustment screw 15 is used to control the number of times of oil dripping in the gas circuit, usually 10-15 products drip oil once

5. The welding pressure regulating valve 21 is used to adjust the pressure





generated by the upper welding wheel and the mold when the upper welding wheel is pressed down, and finally the welding point is instantaneously melted and cooled to achieve the welding effect. Its pressure depends on the thickness of the shoe panel.

6. The welding solenoid valve 23 controls the upper welding wheel to press down and lift up (if the upper welding wheel fails to work normally during operation, the valve is stuck or the coil is burned out)

7. The air pressure switch 25 detects the pressure of the main air circuit. If the pressure is too low, the built-in switch device will not be turned on and will not work normally. The red word of air pressure alarm will be displayed on the top of the touch screen.

8. The downward pressure speed regulating valve 27 is used to adjust the downward pressure speed of the upper welding wheel, and reduce the speed and impact of the downward pressure of the upper welding wheel.

9. The upper welding wheel stop position adjustment nut 28 is used to adjust the return position of the welding wheel, and to control the gap between the upper welding wheel and the mold to achieve an ideal position. When adjusting, open the stroke control valve first, see Figure 5







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Figure 6

#### 5.5 Description of equipment access line

a. The inlet position is at the lower part of the intermediate frequency control box

b.Water, gas and electricity parameter table (1) Intermediate frequency power supply

设备型号	设备功率	入线平方	空开容量	进气压力	进水压力	进水流量	进水温度
B-ZT160	160KVA	$3 \times 25^{2}$	150A	0.5-0.8MPA	0.1-0.2MPA	>=50L/min	<mark>5−15°</mark> C
B-ZT250	250KVA	$3 \times 50^{2}$	200A	0. 5-0. 8MPA	0.1-0.2MPA	>=50L/min	<mark>5−15</mark> ℃
B-ZT350	350KVA	$3 \times 95^{2}$	250A	0. 5-0. 8MPA	0.1-0.2MPA	>=60L/min	<mark>5−15℃</mark>
B-ZT500	500KVA	$3 \times 120^{2}$	300A	0.5-0.8MPA	0.1-0.2MPA	>=80L/min	5-15℃

### Notice!!!

The connected wire connector must be firm and reliable, the wire nose and the copper bar must be in flat contact; the equipment must be placed horizontally and installed with anchor screws; fix 10 square ground wires at the anchor screws

### 六、Man-machine interface description

### Boot interface.





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SW <u>Artw 9134 (1661) 当前后使</u> 用的语言)
中文 ····································

### 6.1 Boot page description

After the machine is powered on, the initial state of the touch screen displays the startup screen, which displays the device name, company address, contact number, three-language buttons and the "Enter Operation" button.

自动 ON	▲ 主操作正 ▲ 一	<mark>前面</mark> #.##] <u>度</u>	
	731.0(1)-2020 复位		™10/1-30) 报警复位
	反馈次数: 群	支馈次数: 詳	
JAJ	<sup>™_2</sup> 运行状态:	准备完成	
FK_9 手动操作	月 焊接参数 焊接	位置	管理

### Main control operation page-

### 6.2 Master control instructions





The host operating the man-machine interface is shown in the figure above. The device is not in the starting position. Switch to manual. Press the "Reset" button, and the device will automatically return to the starting position. If there are red Chinese characters displayed in the fault column on the upper part of the screen, the first step is to press the alarm reset button in the figure. If there is still a display, the user should check and eliminate the fault according to the displayed content until there is no display fault.

•On the main operation interface of the touch screen, press the "Manual Operation" button, the screen jumps to the manual screen



### Manual page.

### 6.3、 Manual operation instructions

1. In the first step of operation, you need to place the manual automatic red button in the manual position by tapping the word OFF with your finger.

2. The forward and reverse buttons are used to control the clockwise and counterclockwise rotation of the mold. When the finger touches it, it starts to rotate and then it stops (the welding direction is forward rotation)

3. Clamping cylinder release, clamping cylinder clamping button is to control the clamping and release of the mold. Its operation method is to first touch the hydraulic station button to open the hydraulic station before touching the clamping and releasing buttons

4. The push material returns, that is, when the push material is extended, the





automatic feeding cylinder is controlled to move forward and backward.

5. The "press cylinder" button is used to control the pressing and lifting of the "up welding wheel"

6. The "Welding Mode" button is to control manual discharge (note: the working condition of this button is that the "upper welding wheel" is lifted up and it can be used when it is not in contact with the "lower electrode"; it can also be used when the "upper welding wheel" is pressed down. And it can be used only after pressing the product)

7. The adjustable-stroke cylinder is used to adjust the adjusting nut of the stop position of the welding wheel on Figure 3-28. When the gap between the upper welding wheel and the shoe surface needs to be adjusted each time the mold is changed, the first step is to touch the manual operation screen of the man-machine interface to the cylinder button, and set the upper welding wheel stop position adjustment nut in Figure 3-28. Adjustable at top dead center.

### 6.4、 Manual screen mold change steps

 $1 \ {\rm \ }$  The manual automatic red button is in the manual position by gently touching the word off with your fingers

2、Touch the "hydraulic station" button to start the "hydraulic station"

3 Touch the "push cylinder return" button to move the push claw back to the dead center, as shown in Figure 11



Upper welding wheel
Panel to be welded
Welding die
Rib plate to be welded
M20X1.5Oil pressure buffer
M10Set screw
Pushing claw
Push cylinder
Material rack
Panel Overlay style
Panel positioning guide





4、 Touch the "clamping cylinder release" button (see Figure 10) to make the chuck in the released state



S Clamping arm Pressure plate assembly Panel positioning guide

5、 Loosen the handles at both ends of the "clamping arm" in Figure 12 and put the "clamping arm" in the style in Figure 12.

- $6_{\smallsetminus}$  Pull out the "pressure plate assembly" as shown in Figure 12
- $7\,{\scriptstyle \smallsetminus}\,$  After pulling out, see Figure 13





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Figure13 (3) Pressure plate (5) M10Locking screw (6) Guide bush 8、 Remove the M10 locking screw to replace the pressure plate of the welded product



(a) electrode (b) Support plate (c) Locking screw (c) Release spring 9. Remove the "locking screw" in Figure 14 to replace the electrode assembly of the required product





### Welding position setting page

*永压打	及警! ▼	∽ 焊	接位置	设定		
1#	₩ <u>=</u> º (0-500) #### <b>.</b> #	₩E_\$(P-600) ###	9#	₩E_13/(0-516) ####.#	NE_18 (D-608) ###	κ_• 手动操作
2#	₩E_1 (P-592) ####.#	WE_G (P-601)	10#	₩ <u>=</u> 14,( <u>1</u> -518) ####.#	₩E_19(D-609) ###	
3#	<sup>NE_2</sup> (P-594) ### <b>#</b> . #	INE_7 (D-602)	11#	₩E_20/(9-520) ####.#	NE_26 (D-610)	焊接参数
4#	₩ <u>E_3 (P-596)</u> #### <b>.</b> #	WE_8(D-603) ###	12#	₩ <u>=_21/(9-522)</u> #### <b>.</b> #	NE_27 (D-611) ###	FK.3 牛产管理
5#	₩E_4 (P-598) ####.#	NE_9(D-604) ###	13#	₩ <u>222/0-524)</u> #### <b>.</b> #	NE_28 (D-612)	
6#	₩E_10/(9-510) ####.#	HE_15(0-605)	14#	₩E_23,(Q-526) ####.#	₩E_29,(D-613) ####	FK.2返回
7#	₩E_11 (0-512) ####.#	NE_16 (D-606)	15#	₩ <u>24/0-528)</u> ####.#	WE_30 (D-614)	
8#	₩Ĕ_12/Q-514) ####.#	INE_17.(D-607)) ###	16#	₩ <u>_</u> 25/0-530) ### <b>#</b> .#	NE_31 (0-615)	

图 16

### 6.5、Commissioning steps

1. Find the drawing of the welded product, as shown in Figure 15





2, Input the 9 measured dimensions in Figure 15 into the "position parameters" in Figure 16 "man-machine interface" (Note: the 1# parameter in Figure 15 is always 0, and the measured data in Figure 15 are input into 2#, 3# to 10#) in Figure 16 at one time)

3、Find the drawing of the welded product, as shown in Figure 18







4、Enter the "welding parameters" setting in the "man-machine interface", as shown in Figure 19

 $5_{\smallsetminus}$  Count the number of panel welds in Figure 15, for example, 10, and set the number of welds in Figure 19 to 10

Welding parameters page-





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6. Check the radius size of the product (see the style in Figure 18), and enter the data to be viewed in the "product radius" position in Figure 19. For example, if it is 134.7, then enter 134.7.

7、 "Welding speed" in Figure 19 is the rotation speed of the solder joints during discharge; "idling speed" is the rotation of the distance between the panel solder joints and the solder joints, usually fast walking: "Reset speed" is when the machine is turned on or pressed The speed of mold rotation after pressing the reset button after an emergency stop; "advance distance" means that the welding spot needs to be welded in advance, because the PLC sends a welding command to the intermediate frequency controller when the mold is rotating, and then the intermediate frequency controller sends out the set current After the RGPT is turned on, the intermediate frequency transformer outputs the current to the welding spot to perform welding. The time required in the discharge process must be compensated by the "advance distance", and the advance value is determined by the actual operation; the "A side use" display indicates that the user needs to place the ribs according to Figure 20, and the "A side use" display When not in use, place the ribs according to Figure 21. "A side offset" is the position setting of the first welding point of the rib. The parameter is set according to the actual situation on site; "B side offset" is welding at two positions, that is to say, the A side and the B side are welded together. When using different products, first make sure that the product on side A is qualified, and then adjust the value on side B to the qualified value (side B can enter a positive value or a negative value, depending on the actual situation. Certainly). The rest of the function parts in the welding parameters are in accordance with the factory values.











图 21





## Production management page-



Figure 22

### 6、 Description of production management page

When entering the screen in Figure 22, the production output and cumulative production output can be displayed. The production output can be cleared, but the cumulative output cannot be cleared. Horseshoe is stored in hoof iron. It means that you have produced a hoof iron program, which can store up to 10 models of shoes.





### 七、IF controller description

### 7.1Basic page introduction

#### Password setting page: password input and modification



Welding sequence page: basic welding parameter settings



Select the specification number to be used, modify the welding method to 1, and set the appropriate welding current and welding time.





规范号 当前规范 为起动规	编程状态	####-##-## ##:##:##	故障
####	编程 焊接 测试 加压	设备正常	复位
	₩ <u>-0(禁止起动</u> LW4 <u>1000</u> )	NE_1(颜:中起动 LW-1001)	其 <sup>8</sup> 它参数
	禁止起动 #### 脉冲起动	#### 测纸终了 #####	缝焊控制
	单2点/连续 <sup>₩E_2 達錄/ 点</sup> <sup>LW-1025</sup> 發程 愛压器圈比	NE_3 (变压器圈¥::LW-1024) 井井井.井	电流监控
	₩开时间 ₩开时间	NE_5 (休止时间 LW-1023) 井井井井	步增控制 FK_2
	补焊控制 <sup>₩ € 6 付焊控制</sup> <sup>₩ 4 1030)</sup> 進补焊点数	NE_7 (连补煤点数:LW-1031) 井井井井	可编程输出
	测量延时 ##### 拖尾检测	NE_9 (視尾松列) 井井井井	设备调试
主页面焊接	时序 焊接设置 系统设置 系统	统参数 监视页面 密码设置	帮助

Welding setting page: basic welding parameter setting

Only in the programming mode, it is allowed to modify the parameters

System setting page: basic welding parameter setting

规范号当前规范	编程状态	####-##-## ##:##	故障
####	编程 焊接 测试 加压	设备正常	复位
	系统密码 <sup>™</sup>	? [系绕密码   ####	
编程初始化 ##	?∰醒珈m≰: LW-1140) <b>究</b> 许通信 <sup>₩</sup> ####	運[]:L₩41162)	
₽.ºI最大值 <sup>™</sup> #	### ** A* 控制器型号 ####	7 0/400A 控制器地址	NE_10(控制器地址:LW-1 井井井井
StI最大值 #	₽. <sup>-</sup> ₩ 面板选规范 ###	<sup>4,0</sup> ,0000/端子选规范 <sup>1</sup> 1111/面板选规范	
起动-规范 📲	####20 1₩-1154) 4/15规范 ■#####	₩8 LW-1155) 7	
茨级安装	[#### <sup>₩</sup> -1156) 原边反馈 <sup>₩</sup> -9.原始	5.胰 LVL-1157) 井	
主页面焊接印	时序 焊接设置 系统设置 系约	充参数 监视页面 密码设置	帮助





#### 与前规范 内起动规 规范号 ####-##-## 编程状态 ##:##:## 复位 编程 焊接 测试 加压 设备正常 LW-1141) E\_0(系統密码 井井井井 聚统密码 W-1159 W-1150) E\_8(步增方式 开开开开 V-1153) E.7 (加压切排 井井井井 年9(6]式UIII 日日日日 步增方式 方式切换 加压切换 LW-1149) W-1158) E\_5 (计数不报 井井井井 井井井井 E\_9(中断报警 开开开开 计数不报警 LW-115 中断报警 ■E\_10(报警输) 井井井井 报警输出 W-1145) LW-1146) 焊点数监控 E.3、煤点监控 井井井井 最大焊点数 に1 (蔵木県県 井井井井 LW-1147) 最大生产数 生产数监控 E\_2(生产监控 井井井井 LW-1148) IE\_4(最大生) 井井井井 焊接时序 焊接设置 系统设置 系统参数 监视页面 密码设置 主页面 帮助

### System parameter page: basic welding parameter setting

### Monitoring page: monitor welding results







### 7.2Preparation before startup

Turn the "welding/adjustment" button on the controller door to the welding state, click the "welding" button on the screen to enter the welding state, and the touch screen will display the controller state.

### 7.3Precautions for use of IF controller

1. When controlling and using, the chassis shell must be firmly grounded

2. The control box must be connected to the cooling water before it can be used, and the cooling water must have sufficient flow and pressure. Check the working condition of the water cooling system regularly (once a month)

3. When the power is on, it is not allowed to open the controller box, let alone touch the electrical components of the box with your hands, so as to avoid electric shock (the box has 600V high voltage)

4. Note that after the power supply is disconnected and the internal circuit board indicator light is off, the internal energy storage capacitor of the controller still has a voltage close to 80V, and attention needs to be paid to the control and maintenance.

5. When checking the circuit, please be sure to disconnect the power

6. It is not allowed to touch the components on the control board by hand to prevent static electricity from damaging the components

### 7.4Faults and Countermeasures of IF controller

1. Inverter drive failure: whether the IGBT device overcurrent or the corresponding drive circuit is normal during the inverter process

2. The heat sink is overheated: first check whether the temperature of the water flowing through the radiator is too high, and secondly, if the temperature relay on the heat sink is damaged, the contacts are closed under normal conditions

3. The primary circuit is abnormal: (1) The inverter output current is too large (2) The transformer pair is short-circuited (3) The main control board detects abnormalities

4. Abnormal capacitor voltage: (1) Check whether the capacitor is energized normally (2) Check whether the power supply grid is stable and welding

5. Excessive current: It prompts that the actual current in the welding process exceeds the setting range of the monitoring current, check whether the parameter setting is correct and whether the welding process is appropriate

6. Current too small: It prompts that the actual current in the welding process exceeds the setting range of the monitoring current. Check whether the parameter settings are correct, whether the welding process is appropriate, and whether there is a problem with the welding secondary circuit.





7、Abnormal programming parameters: check whether the parameters in the starting welding specification are out of range

8、Abnormal correction coefficient: there is a problem with the main control board

9. Abnormal water pressure detection and abnormal air pressure detection: check whether the water pressure and air pressure are normal; check whether the 24V power supply of the air valve power supply is normal

10、 Starting prohibition: the current specification has been set to prohibit starting mode

11、Transformer temperature is too high: check whether the water temperature of the transformer is too high; check whether the temperature relay in the transformer is damaged

### 八、Daily maintenance

1. Power, water, and gas should be connected before starting up (check whether the water is unblocked, whether there is water leakage, electricity leakage, or air leakage, if any, it should be eliminated in time before normal production)

2. Check whether the liquid level of the hydraulic station and automatic pressure pump is between the upper limit and the lower limit every week. If there is oil shortage, it should be refilled in time before production

3. Check whether the pressure screw of the conductive sheet in the picture below is loose every week. The check method is to use the thumb and index finger of the right hand to turn the screw until it stops.







### Fault project

### Cause: the material return cylinder does not return the material

1. Turn on the power of the welder

2. Open to manual state

3. Touch the "hydraulic station" with your finger to start the hydraulic motor (operator)

4. The inspector goes to the back of the machine and opens the back door to confirm whether the oil pump motor is started

5. Whether the hydraulic motor is started

6. The operator touches the clamping and unclamping, and sees whether the mold is clamped, unclamped, and whether the speed is fast or slow

7. The inspector looks at the pointer of the fuel gauge, where it is pointing, (normally 4Mpa)

8. When the operator is performing "clamping" or "releasing", the operator checks to see if there are two red indicator lights on the gas station that will light up, if both are on or off at the same time, it means the circuit is normal Yes, if it is not, it means the circuit is faulty. The cause of the fault may be that the coil of the intermediate relay is damaged. The user replaces all the intermediate relays of the electric box (the equipment is used for one year)

9. If the clamping, unclamping, and the circuit are all normal, proceed to the next step 10. The operator, touch "Pushing out" and "Pushing back" to see if the cylinder is moving

11. The inspector sees if there are two red indicator lights on the top of the petrol station that light up or off with the work touched by the front staff. If they light up or off, it means that the circuit is not faulty. The oil pressure gauge shows that there is no abnormal sound from the  $3\sim$ 4Mpa oil pump, which means that the front oil circuit is normal. Then check the pressure regulating valve under the solenoid valve, turn it clockwise, and see if the material is pushed forward or back. If there is a change, it means that the oil pressure of the pushing material is too low. If there is no change, proceed to the next test

12. The inspector goes to the side of the pusher cylinder, and when the operator touches "Pushing out" and "Pushing back", the hand mold tubing feels without pulsation. If there is pulsation, it means there is oil pressure, and if there is no pulsation, it needs to be removed. Push down the two oil pipes of the material cylinder and put the two oil pipes into a container that can hold oil. The operator continues to touch the "push material cylinder" to move forward and backward to see if there is any oil out of the oil pipes. There is no indication of solenoid valve or pressure regulation. The valve is damaged and needs to be replaced, and a lot of oil





rushes out, indicating that the oil cylinder is broken and needs to be repaired or replaced (note: the operator must stop the machine when the inspector removes the oil pipe)

#### Display air pressure alarm, welding spot frying, non-pressure welding spot

1. If this happens at the same time, it means that the air pressure is too low. The solution is to increase the pressure and flow of the compressed air.

2. When the air pressure does not alarm, the solder joints will be blown up, and the solder joints will not be pressed. There are two situations that can cause this to happen:

a. Circuit failure, put the welding machine in manual state, display "continuous welding" and touch the "cylinder press down" button. At this time, whether the upper welding wheel is pressed down, if it is pressed down, and it is smooth, it means that there is no fault. The preload time of one solder joint can solve the fault.

b. The gas circuit is faulty. If the welding wheel does not press down, the staff should check whether the two solenoid valve indicator lights on the top of the machine are on. If they are on, the solenoid valve should be replaced if it is damaged. It means that the circuit is blocked and the circuit needs to be checked. The voltage is DC24V.

