SANYI

Sanyi Technology

SY-ZP4A Rotary disc precision sand

National free service

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Dongguan Sanyi Machinery Technology Co., LTD

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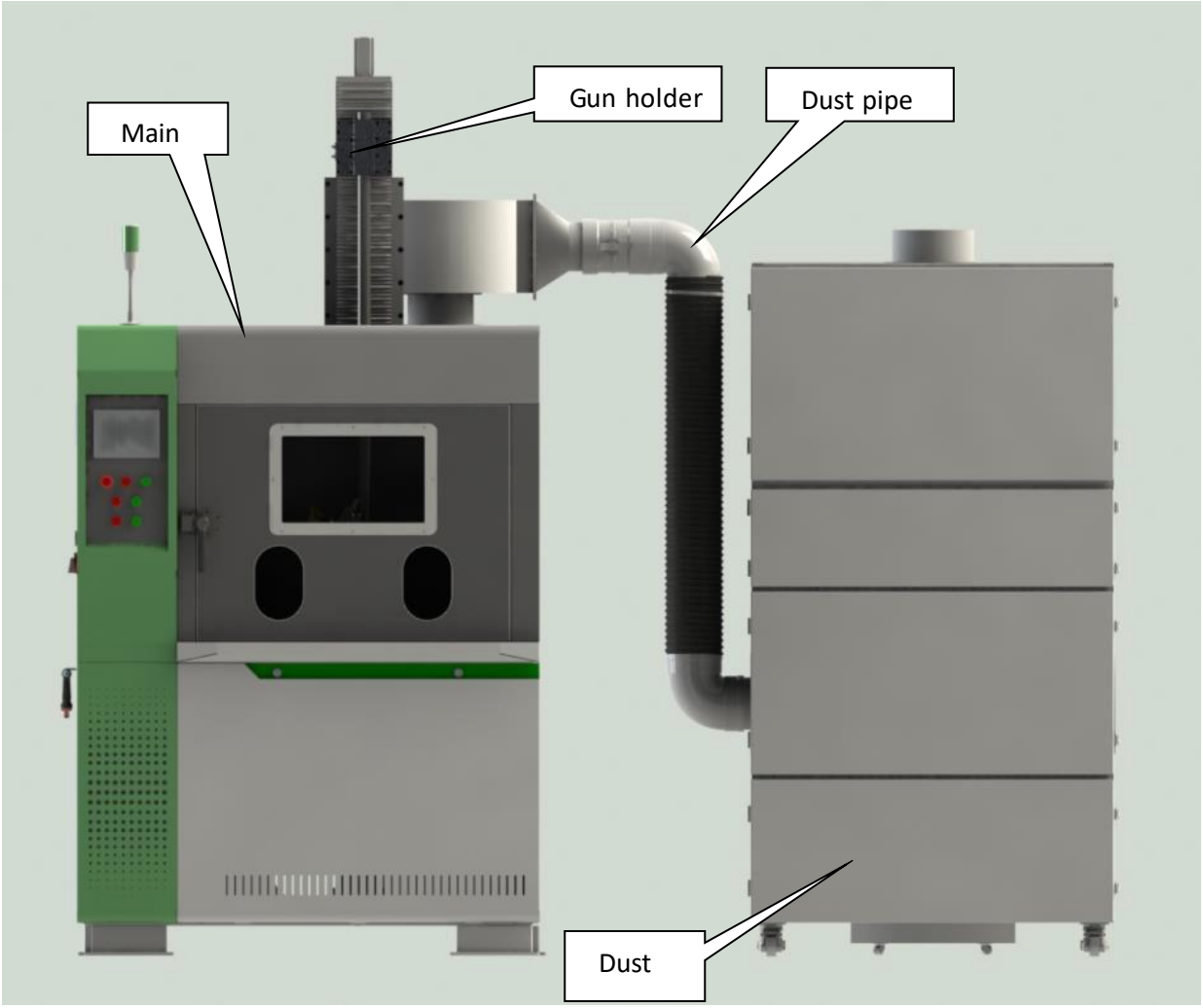


Exterior pictures

Chapter 1 Instructions for Using

First, precautions

1. Preparation and inspection before use

1) Select the suitable abrasive to be added into the engine room, and the abrasive will fall into the lower sand collection box after being filtered through the filter screen of the separator;
2) Connect to the air source and power supply of the machine, and open the power switch on the electric contro box;
3) Adjust the pressure of the compressed air entering the pressure tank through the reducing valve between 0.4~0.5MPa as required;

2. Safety protection before and during use

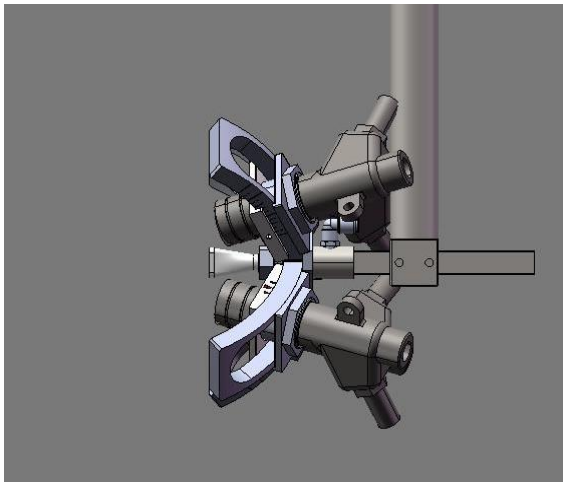
1) Should often check whether the pipe connection is sealed well and firmly, and make it often in good condition
2) Should often check the threshold switch and electrical switch and button is good, and make it in good condition;
3) shall not drop other items except the specified abrasive into the work cabin, so as not to affect the circulation of abrasive;
4) The surface of the workpiece to be processed must be dry;
5) After stopping use, the power and air source into the machine must be cut off.

Note: It is strictly prohibited to start the

Two, basic

1、Loading of abrasive:

The sand is added directly from the studio, and should be poured slowly when adding, and the fan should be started when adding the abrasive.The abrasive loading capacity of the machine is about 25kg at a time.



Cylindrical parts are suitable for moving up and down the side of the spray gun group, according to the size of the workpiece, may need to adjust the spray gun and the workpiece The distance, Angle and other parameters.

3, manual airbrush operation

[foot switch]

Non-standard parts processing, or individual parts processing please use manual sandblasting mode, simple and quick.

Operation mode:

A: Switch to manual mode on the operation panel.

B: Open the hatch and put in the parts to be handled, large parts can be placed on the turntable and close the hatch.

C: Reach into the operating hand hole with both hands, hold the parts in the left hand, hold the airbrush in the right hand, and Angle back the inner wall.

D: Gently step on the sand blasting pedal switch to test whether the sand blasting pressure is appropriate and whether the sand flow is stable.

F: After adjusting the required parameters, manual sand blasting can be started.

During manual sandblasting operation, attention should be paid to

Do not step on the foot switch when you do not hold the spray gun,

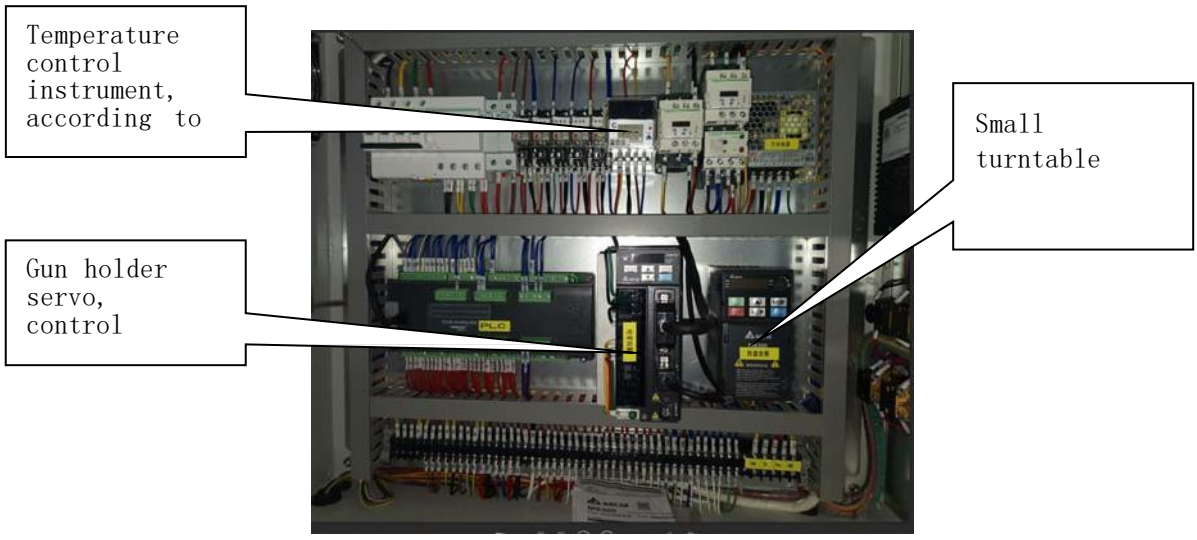
3. Adjustment of compressed air pressure:

Pressure regulating valve is located in the rear side of the equipment host air inlet pipe interface position; Adjust the pressure regulating valve control according to the needs of processing workpiece The compressed air pressure of the spray gun can be adjusted in the range of 1.0-7bar, and the working pressure can be adjusted appropriately according to the material of the workpiece to be sprayed. When the working pressure is adjusted properly, the adjusting knob of the pressure regulating valve should be pressed down and locked before sandblasting can be carried out.

4. Control panel operation

The device is set up with a touch screen control system, basic operations can be completed intuitively here. The interface is as follows:

The debugger will inform the user of the password at the site installation and keep it in mind.You can follow the prompts when entering the screen. 4. Frequency conversion speed adjustment in the electrical box (can also be completed on the touch screen)



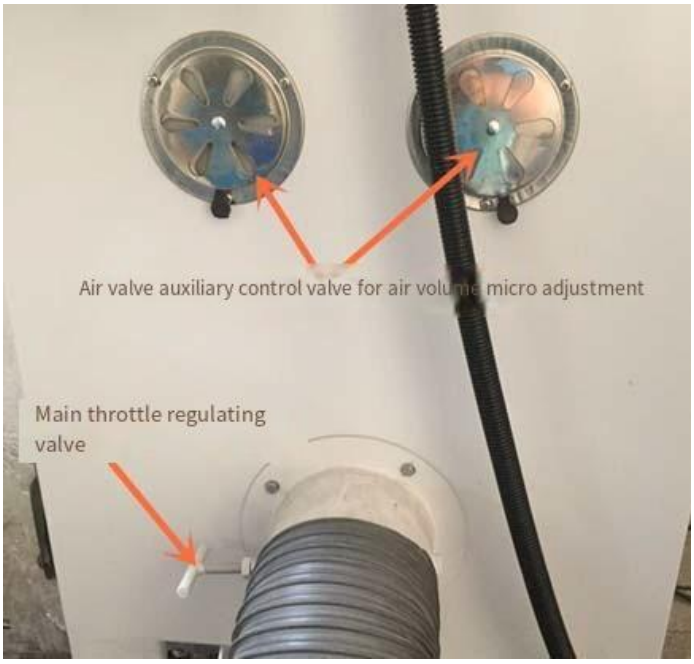
5. Dust removal system:

This machine is equipped with pneumatic automatic reverse blowing dust removal system, in order to achieve better dust removal effect need to be cleaned every 6-8 hours by human dust, specific operation mode: Turn off the power switch, open the door of the dust box, shake the dust filter core manually (see the diagram), open the dust bucket at the bottom of the dust box at the end of the day, and clean up the dust after the container.Every three months, the dust filter element should be removed with manual air gun cleaning (can alsobe adjusted according to the actual situation), clean and dry after installation.

A new filter cartridge should be replaced every 6 months according to the effect of use.

【 Schematic diagram of filter element cleaning 】

6. Adjustment of dust removal box damper:



Adjusting the damper of the dust removal box can adjust the size of the wind volume of the cyclone separator, and realize dust separation from the dust, in order to ensure the effect of sandblasting; When the damper is completely closed, the maximum air volume is suitable for abrasive with large proportion of particles. When the damper is opened, the air volume gradually decreases, which can be used for the lighter abrasive. In the process of use, the damper of the dust removal box should be adjusted according to the specific proportion of abrasive to the opening degree, so as to achieve the best effect of dust separation.

Replacement of abrasives

Abrasives generally use a cumulative 16-20 working hours to check, according to the stock to replace or appropriate add some new abrasives, replace abrasives according to the following procedures:

1) Open the sand blasting machine, and then use the air gun to thoroughly clean the working table, the inner wall of the main engine room of the sand blasting machine and the abrasive attached to the mesh plate, so that it flows back to the hopper;

2) At this time, the abrasive basically enters the collector behind the equipment, prepare the appropriate material bag, unload the discharge port of the bucket plate, and release the abrasive.

3) Buckle the baffle, repeat 1-2 procedures 1 times, so that the abrasive is completely collected and released.
4) Add appropriate amount of new abrasive to the machine hopper as needed.

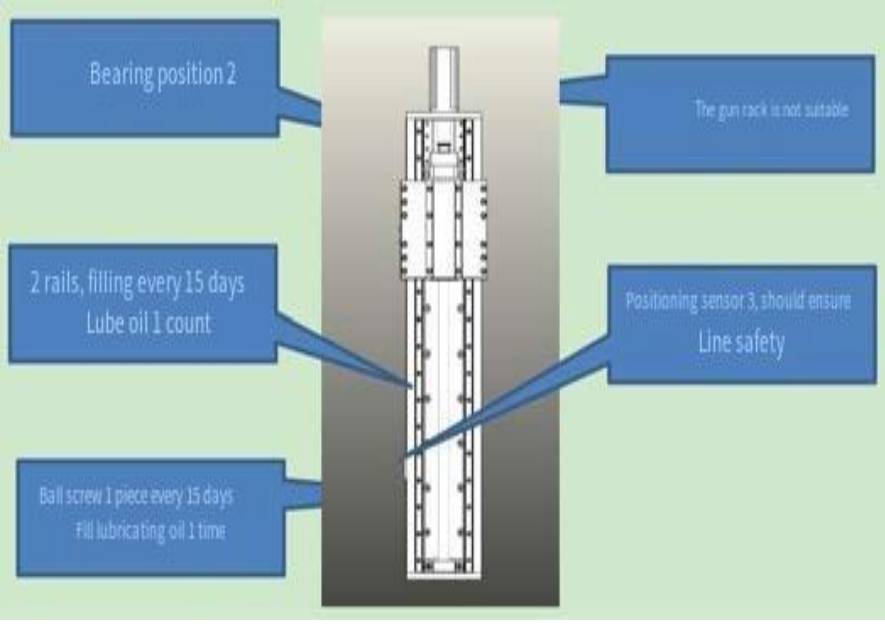
Note: Waste abrasive should be treated in

Instructions for

If the abrasive is fine, the auxiliary heating device is needed to heat and dry the abrasive in the humid air environment (if the abrasive is too damp, it needs to be manually dried or dried). The drying device is located under the main engine bucket, and the air conditioning port can adjust the size of the sand output of the spray gun.

Maintenance and

The lead screw slider is a precision part that needs regular maintenance and inspection, so as to clean the dust and oil the lead screw slider every 30 days (add lead screw guide oil), and increase the service life of the lead screw slider.



Three automatic

3-1. Connect the power supply and air source, place the parts, and manually adjust the position of the spray gun.
3-2. Switch the control panel to automatic mode and adjust the relevant parameter Settings.
3-3, set the automatic processing time, close all doors and Windows.
3-4. Start the automatic switch and start the automatic sandblasting operation.
3-5. Once the sandblasting time is up, the spray gun will stop, the turntable will stop, and the studio door will be opened when the indoor dust is observed to decrease.
3-6. Clean the parts with manual air gun and take them out manually.
3-7, continue to put in new parts, directly start the automatic sandblasting switch, enter the next cycle.

Chapter 2 Daily maintenance

1. Daily maintenance and maintenance

Daily maintenance and maintenance shall be conducted in accordance with the following table:

Schedule of routine (per shift) maintenance and maintenance work

Project	Maintenance content
Gas road,	Check whether the pipeline is damaged or leaking, if there
Protective	Check for breakage and replace if necessary;
nozzle	Check the nozzle wear condition, if the wear is serious or found that the efficiency of sand blasting processing is significantly reduced, should be erected
abrasive	Check if the abrasives have been damaged and replace them with
Dust	Check the ash collection situation in the ash hopper, and
Window	Check whether the window glass is ground, whether the wear
Filter	Check the filter cup for standing water, if too much standing
Seal	Check all sealing parts, especially the door seal is good and effective, if found to be ineffective, please stand
Electrical	Check whether the operation control of all electrical
Lead screw slide block	Often check whether there is dust on the lead screw slider, if found, please clean up in time;Make the weekly

Power off	Before leaving, you must turn off the power and air to the

2 Maintenance standards

2-1, check the gun body cavity of the flow surface wear, such as visible wear traces should be replaced;
2-2, check the wear of the inner hole of the nozzle core inside the nozzle assembly, if the maximum diameter of the inner hole exceeds 30% of the original diameter, it should be replaced;
2-3. Check the wear of the rubber layer on the outer surface of the nozzle assembly. If the metal matrix has been exposed, it should be replaced.

Chapter 3 General Troubleshooting

1, For general common faults, you first refer to the following table, and according to the method provided in the table to troubleshoot.

Common faults and troubleshooting methods

Symptom	Possible causes	Methods of elimination
Dust spill during sandbla sting	The filter cartridge is blocked; Too much powder in the abrasive; The air nozzle hole is too large; The compressed air There is too much sand and the hopper return port is blocked	Clean or replace the filter Replace the abrasive, adjust the Aperture must not be greater than 5.6mm; Lower the Remove all abrasive, run empty Add qualified abrasives
Processi low	Compressed air pressure is too The nozzle and air nozzle are too Abrasives used have exceeded their And too much dust)	Turn up the pressure; Replace larger nozzles and air Empty out the old abrasive before loading in the new
	Too little abrasive; Low compressed air pressure;	Adding abrasive; High pressure;
Uneven or pulsatin g spray of	Nozzle blockage; Wet abrasive; Out. Solenoid valve plugged	Eliminate the blockage; Empty the abrasives in the storage box, load the dry abrasives, check whether there is water in Check and clean up
Job Uneven	Too low rotary speed Rotary belt slip Insufficient abrasive	Adjust the frequency of the To fit Adjust the belt tension or Add the appropriate amount of

2. Note: If the fault beyond the above table cannot be solved, please consult Technical support

3.Wearingpas

Sand blasting machine wearing parts table

Seria l	Name of the wearing part	Specifications/m odels	The number	To prepare note
1	Small	6007	2	
2	Sandblasting	200 standard	1 pair	
3	Airbrush	Custom type	5 sets	
4	Boron carbide	Φ 8 x Φ 22 x 50	5 pieces	
5	Sandblast pipe	19 x 32 (2 m) Φ	5 strips	
6	Dust filter	Φ 220 x 500	6	
7	B triangle belt	Type B L=1505mm	1	
8	Window glass	375 mm * 225 mm * 4	1	
9	Protective	2mm,3mm,5mm,10mm	1 set	All rubber
10	Ball screw	SFE25	1 strip	Ball screw
11	Linear guide	BCH30A /L=800	2 strips	Linear guide
Please consult a professional before purchasing accessories and abrasives, contact Mr				

Note:
1. Principle of wearing parts: Natural wear caused by sand flow and component transmission is not covered by warranty.
2. The service life of pneumatic components is closely related to the cleanliness of air source. The products are guaranteed to be used for half a year in the

Chapter4 Warranty and Terms of Service

1. clothing service

1.1Our products are subject to one-year warranty from the date of purchase, except for wearing parts;

1.2The company for sale of products to provide long-term spare parts and maintenance guidance;

1.3The company is always welcome users to make suggestions for improvement of our products;

1.4The company can design and manufacture all kinds of sandblasting machines according to the needs of users and undertake upgrading;

1.5The company is ready to provide users with sandblasting machine products and sand blasting processing process consultation.

2. Descriptionof

During the warranty period, the supplier agrees to maintain the service free of charge. In any of the following cases, the Supplier will charge the material cost or maintenance fee at its discretion.

- Wearing parts, parts and articles due to natural wear and tear, human damage and damage caused by force majeure.

- damage caused by modification, extension or movement without the consent of the supplier. After the expiration of the warranty period, if the Customer needs to continue the service, the customer will be charged for the materials and maintenance at the Supplier's maintenance rate.

SANYI
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Professional manufacturer of automatic sand blasting machine!

Call 0769-2233 6646 for service
Technical support: 18027560576