

ANHUI KOYO BEVERAGE MACHINERY .CO.,LTD
安徽蓬源饮料机械有限公司

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KYQ Type Full Auto PET Bottle Blowing Machine

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1,Operation panel





,Touch screen,all the operation dialogues are all completed by this.



,Stop button. Use method: Press down to work, turn automatically pop-up for the reset state.



,Automatic run button.



,Preform rotary switch,turn right for work ,turn left for stop.



,Temperature control panel,tubes from down to up A to H.



,Oven temperature control table,often set below the light box actual temperature,let the exhaust fan work continuously. Special bottle type control according to the light box temperature.



,High pressure gauge,general control at around 2.8,except special bottle type.



,Low pressure gauge,general at around 1.

2,Touch screen Instruction

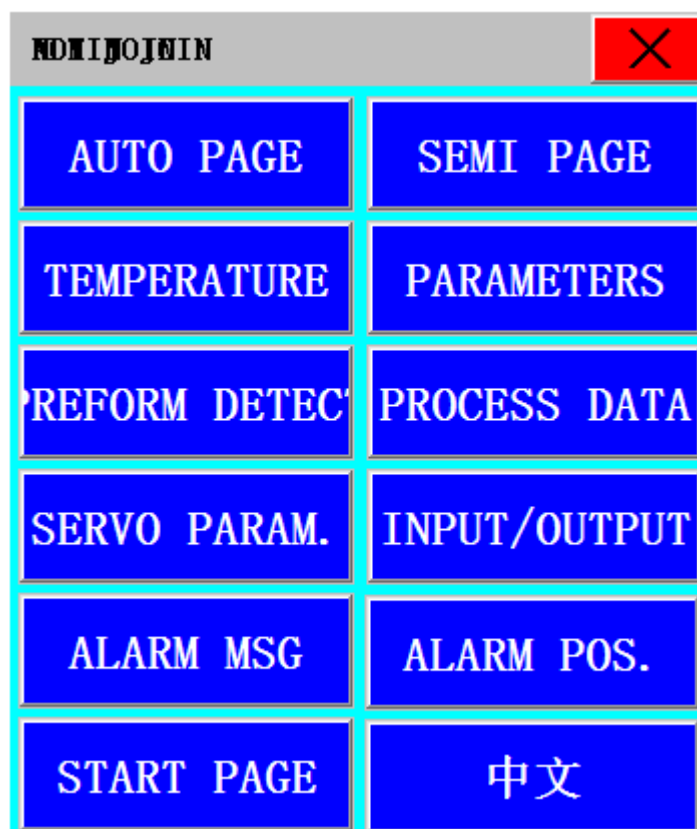
When this machine after electrify, this touch screen appears,if the picture is not shown the word V2.0 or V3.0,the default operating system is V1.0 version,please use this manual.

This is the main screen,also the language selection screen meanwhile.

Warning:When choosing the language,please note:once you choose a language,the operation system can not be returned,need to turn off the power to restart and choose again.



Click on button, selection screen will appears:



This is selection screen, click the corresponding button, automatically jump to the corresponding operation window, complete the action, the corresponding functions are:



This button is corresponding to the monitoring window of automatic running.



This button is corresponding to the operation screen of equipment action. You can do all the manual operation by this, it is useful to the recondition of equipment.



This screen is choose Screen, you can adjust the temperature by this.



When you click this button, it will jump to the screen of Time Setting, you can set the time by this.



The button corresponding to bottle blowing bottles embryo entrance test parameters, by setting this parameter to determine whether the

bottle embryo into the cavity, whether into the bottle blowing process.

PROCESS DATA

, This button is corresponding to choosing the saved parameter, pur machine comes with the setting parameter of different type of bottle. You can adjust the parameter rather than re-enter.

SERVO PARAM.

, This button is corresponding to the servo parameter setting screen. Generally ,please don't alter it, just default the factory default settings.

INPUT/OUTPUT

This button is corresponding to the monitoring window of the output and input. It is convenient for you to find the problem.

ALARM MSG

This button is corresponding to the position of breakdown to help you solve the problem.

ALARM POS.

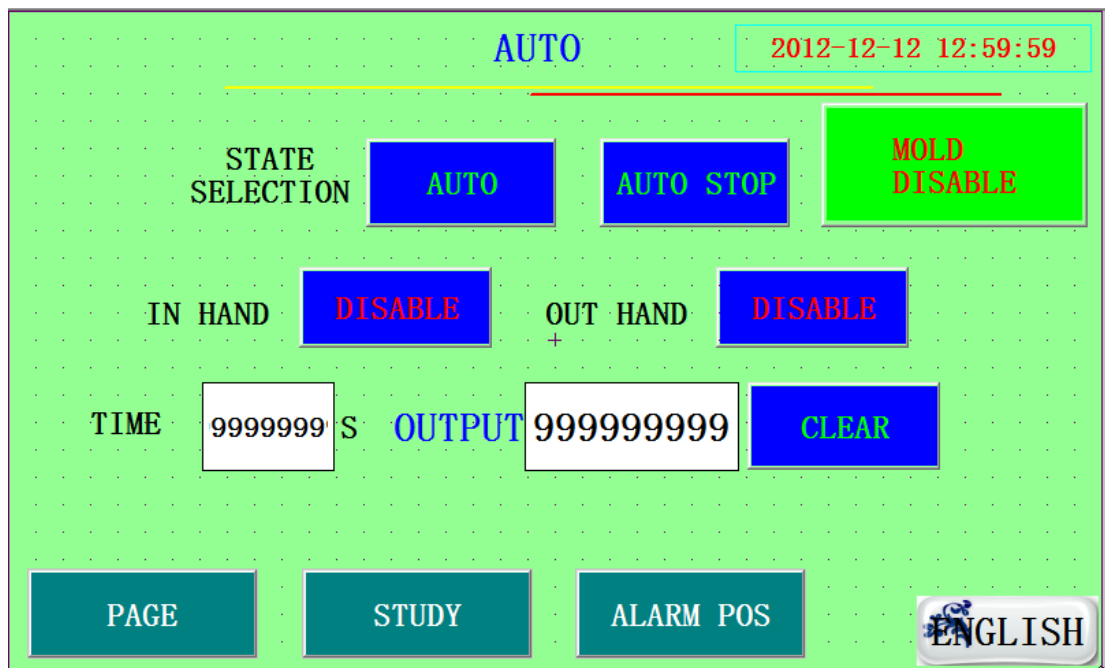
This button is corresponding to the operation screen of Fully authorized users. The system will default the user as the operator, when you click the User Login, you can alter all the parameter including the servo parameter.

2.1, Automatic operation screen

When click on auto button, appears the following pictures:

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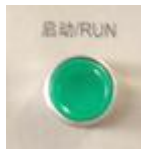
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Corresponding button shown as follows:



This button is acknowledgement , you should check it before automatic run. When you press the button ,the pathway will look for the origin automatically, and enter the standby condition automatically. When you press the

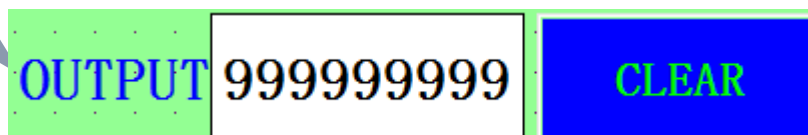


,the machine will turn to Automatic running state.

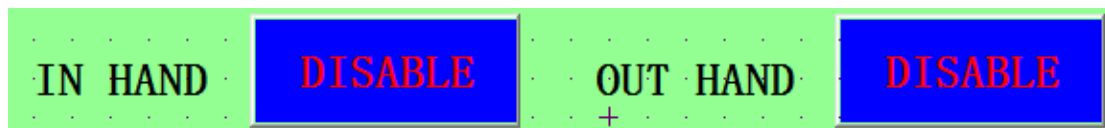


This button is critical, automatically run when light up this button, clamping state is prohibited, means, clamping frame does not work.

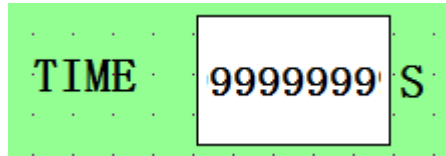
Warning: Under run automatically, no matter whether the button work, arm cannot stretch into the internal machine (especially the clamping frame), or cause any consequences.



,count box, used to display the output.



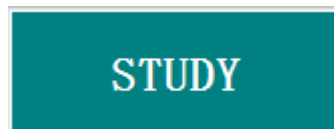
This button is used to control the manipulator.



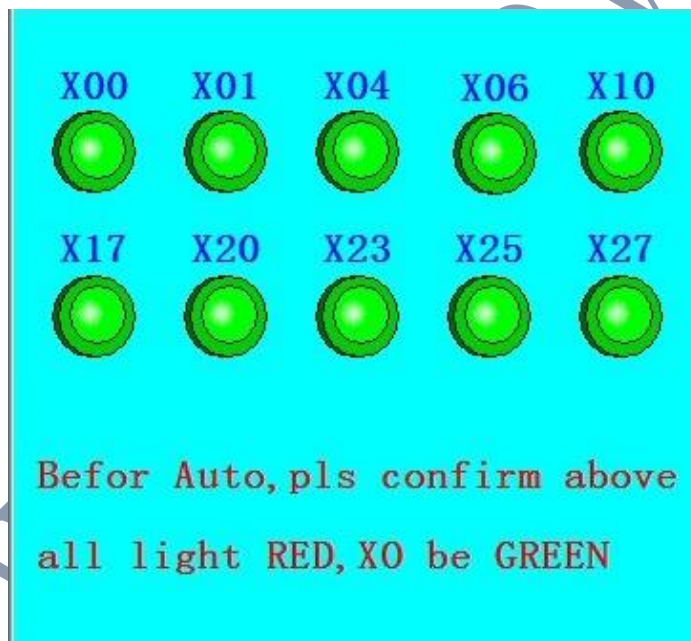
This button is used to show Single circulating time.



All the screen have this button, it is used to switch the screen



This button is used to auxiliary examination before automatic start, to check which position go wrong, when you press this button, the screen will be like this :



Follow the prompting, check the corresponding position, to ensure all the indicator light works like Mentioned in the article, if indicator light doesn't work well, it means you can't start it.

2.1.1 Automatically boot process:



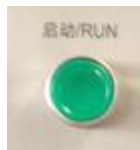
Closed abrupt stop switch ----gyration abrupt stop switch and reset



---click

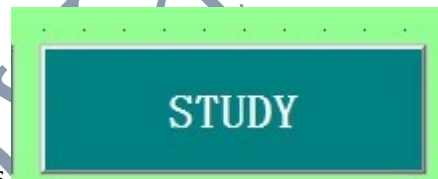


,make it

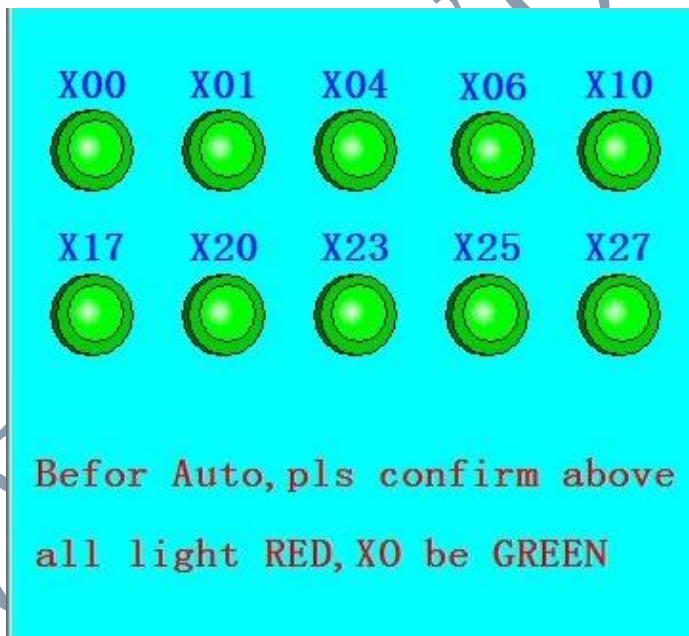


yellow color-----press run ,it run in full automatic mode。

2.1.2,Troubleshooting of automatic mode could not work:



Automatic mode could not work, press ,shows



,check the corresponding position, make sure that all indicator work according to the text prompts,

2.2,Stop Operation

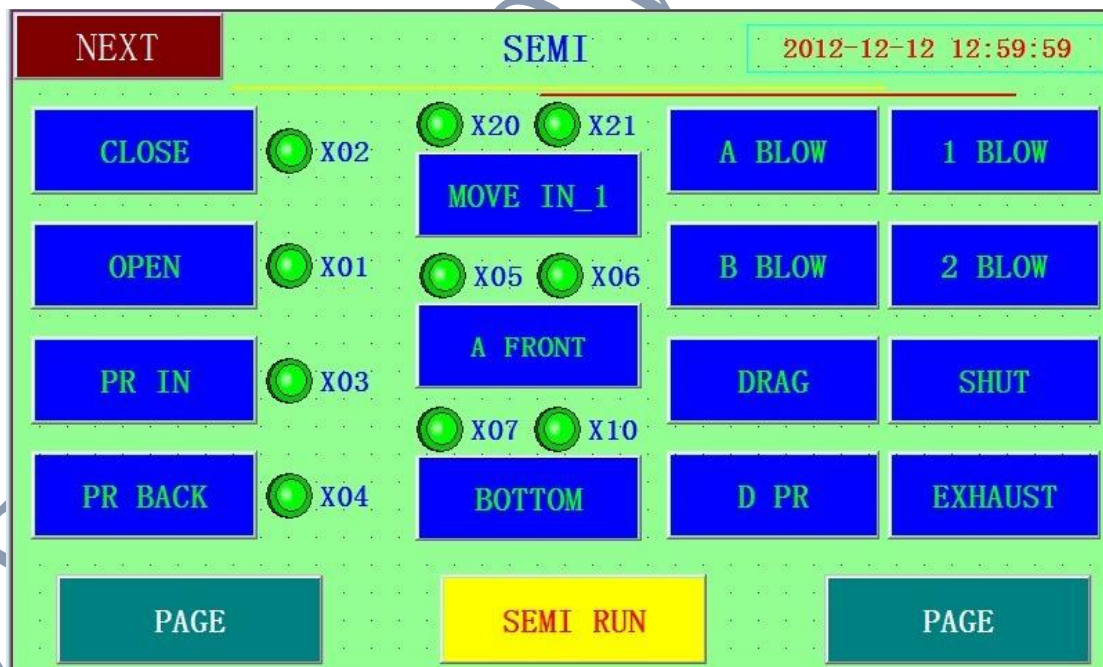


Machine in operation, if find faults need to stop, press ,machine would stop.

2.2.1,fault shut-down and manual troubleshooting

When machine in operation, fault shut-down, press stop button, but the machine is not stopped at the position of the normal power on reset,2 steps as below:

A, press ,click  choose ,turn to semi automatic mode ,see below:



Reset the stop button,click ,when it turns yellow machine would make a reset command automatically, machine could be in

automatically boot state.

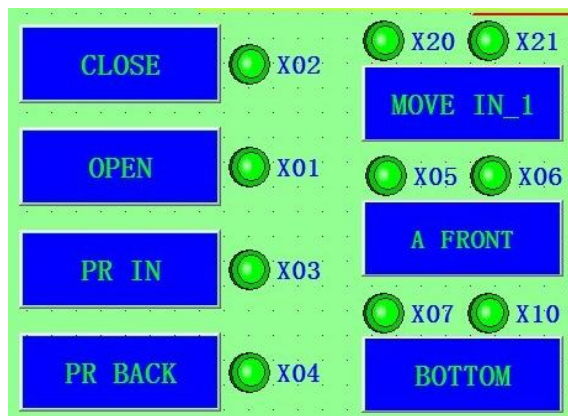
B, This operation is an extension of the A operation, after execute the A operation, if machine is still not return to the automatically activated state, continue to operate this procedure, select relevant operation button, to make the machine reset under manual mode.



direction: ,go to the mechanical hand work screen.



,manual mode button, could press with ,to change manual mode to full automatic mode. When need to rest, press stop button again. Start to work when it turn to yellow, stop when it turn to green.



action button patten,



means corresponding switch working condition. In red color, means it is working,in green, off work. The same as mechanical hand screen.

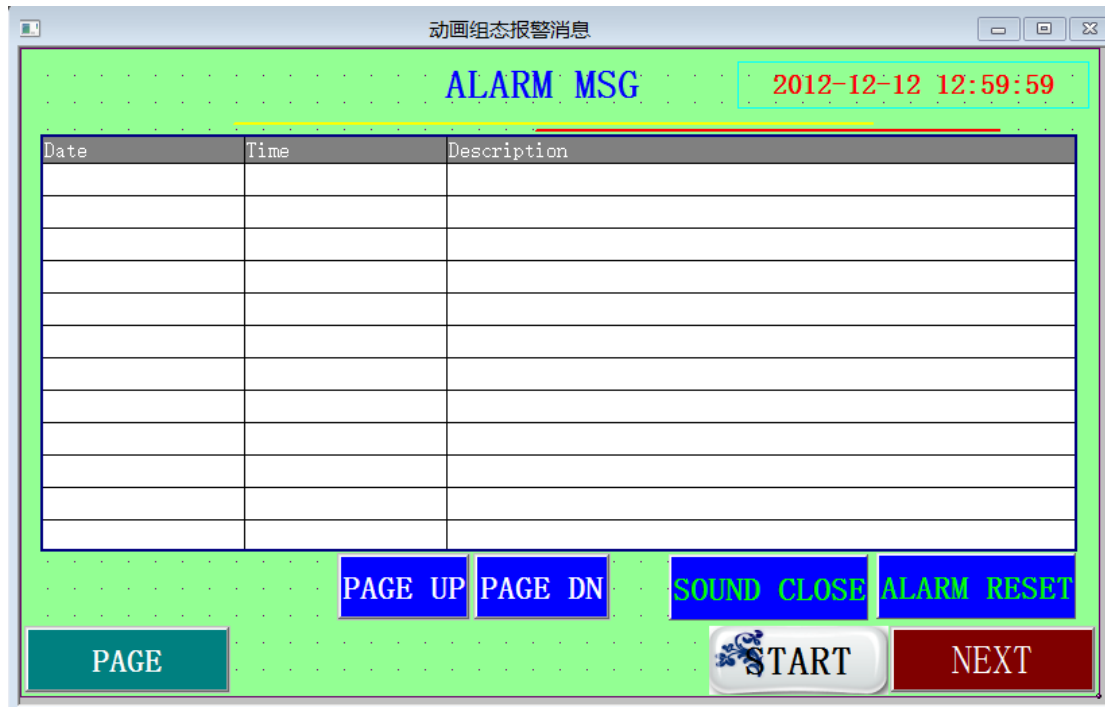
2.2.2,Detection swith's check and troubleshooting:

When could not start the full automatic mode,indicate the inspect switch is not in right position,toubleshooting as follow:

the corresponding picture, in respect to find points, work status switch to manual work mode. Corresponding button manually, in respect to find points, manual repair.

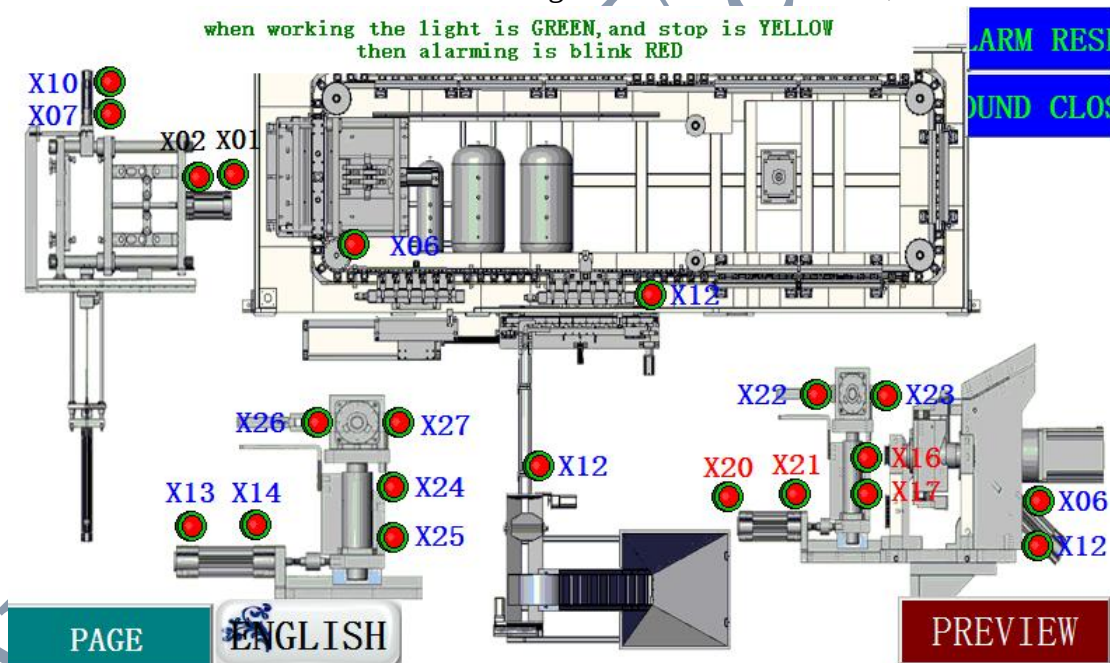
2.3 ,Alarm and elimination of alarm status:

When in automatical mode, a position fails,machine will automatically alarm, alarm screen pops up:



If the exact fault location can not be distinguished in the literal sense,

when working the light is GREEN, and stop is YELLOW
then alarming is blink RED



find the fault point in accordance with the flashing position, eliminating one by one. Tip: when the alarm appears, it means execute emergency stop instruction manually. All the parts of the machine stop running. The elimination of the alarm: when the alarm screen appears, click in eliminate the alarm. Shift to manual or automatic operation as shown in 2.2.

3,Time-setting screen

Time setting screen, as below :

TIME		2012-12-12 12:59:59	
Pre-blow Delay	输入框	High pressure delay	输入框
High pressure time 1	输入框	Compact time delay 1	输入框
	输入框		
Center top	输入框	Timeout	输入框
PAGE		NEXT	

Explain as follows:

Pre-blow Delay, low-pressure blow, also is pre-blow, this time for this action, it means low pressure blow delay. Time format is 0.00, the unit is in seconds.

High pressure delay, the low-pressure blowing time, Time format is 0.00, the unit is in seconds.

High pressure time 1, 2 blow is high-pressure blowing, which is total time of high-pressure blowing. Time format is 0.00, the unit is in seconds.

Compact time delay 1, once 2 blow finished, the machine will exhaust high-pressure air according to set time, depressurization, then to next operate. Time format is 0.00, the unit is in seconds.

, This time is the core of the machine operation, the design thought is balancing machine in no preform state and blowing bottles state the perform

heating in equal time, this time is an experience, the timing start is based on the material feeding in place, time to go to the next cycle.

Set way is observe the normal bottle blowing time, and empty cycle time, conventional the normal blowing bottle time is longer than empty cycle time, the two time subtract, which is the technical time. But slightly different in the actual operation, please watch carefully and take into consideration the setting.

Remark, normal blowing and compound die working process:

Below the center of top---compound die---seal---stretch---1 blow delay---low-pressure blow---low-pressure blowing time---shut low-pressure and open high-pressure---high-pressure blowing---2 blow---shut low-pressure and start to exhaust---exhaust time---shut exhaust---seal below---stretch below---open mould---the center of top time---the center of top

Center top

, the center of delay, that is, open mould movement began to start the time, time to the center line on the top, to prevent the bottle stuck on the mold bottom. Time format is 0.0, the unit is in seconds, conventional is 0.2-0.6, bottle different time difference.

Timeout

, Meaning is one action that persists for more than the set time, i.e. the action does not reach to designated position, the machine automatically alarm, stop operation, the general time setting for the 10. Time format for 0.0, the unit is in seconds, regular set is 10.0.

NEXT

: This picture says jump to the manipulator time setting page.

Feeding manipulator time setting page:

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TIME		2012-12-12 12:59:59	
OVER TIME	输入框	Compact time	输入框
Clip time delay	输入框	Whole slab delay	输入框
		Timeout	输入框

PAGE EXIT NEXT

OVER TIME,pressed shape action delay, used to wait for feeding manipulator lay the preform into the bottle seat, stay work again after steadier, auxiliary positioning.

Compact time, pressed shape total working time, when the time out, pressed shape reset is complete.

Clip time delay,Feeding manipulator clamping the preform waiting time, used to wait for the preform rock in the process of neaten, lest appear misoperation.

Timeout, Equivalent to previous picture.

EXIT, Here is back to the main time set screen.

NEXT, here is **laying-off** manipulator time set screen.

Laying-off manipulator time set screen:

TIME		2012-12-12 12:59:59	
Under time	输入框		
Clip time	输入框	Blow time	输入框
		Timeout	输入框

PAGE EXIT

Under time, Refer to the manipulator clamp and open clamp required time, feeding manipulator clamp need same time. Time format is 0.0, the unit is in seconds.

Clip time	输入框	Blow time	输入框
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, This two time is automatic discharge bottle system time set. If yes, please set up corresponding time, if not, please set to 0.

Clip time, Time for strengthening of conveyor belt, time to the action that is terminated.

Blow time, When folded belt, blowing duration time, time to blowing stop.