


Maintenance and Inspection

⚠ High Temperature Attention:

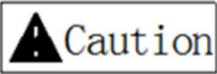
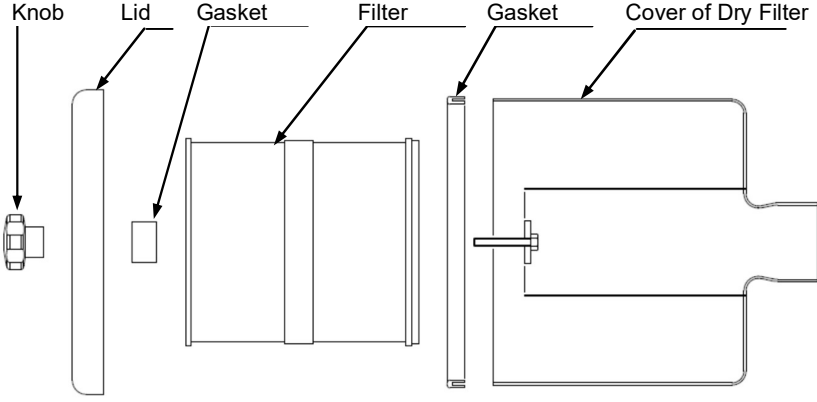
Please perform maintenance and item-by-item checking after the device completely cools down (natural cooling normally takes five hours), for the device may continue to keep high temperature after it has stopped operating for some time. Furthermore, pay attention that even though the exterior part of the device has cooled down, the inner part of it and some dry stuff may still keep high temperature.

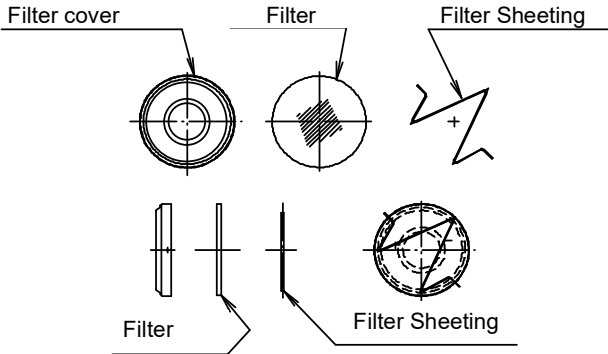
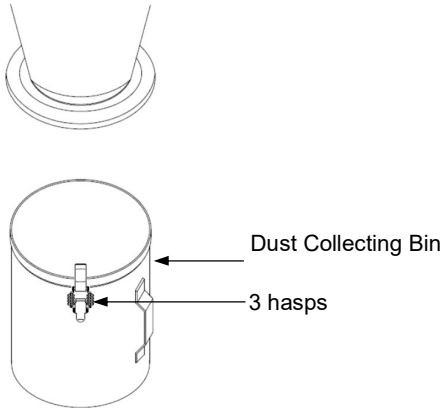
1. Daily maintenance and inspection

Maintenance and Item-by-Item checking item	Operation Content
Temperature confirmation	<p>Please confirm if drying temperature and regeneration temperature are controlled by the setting temperature of the touch screen.</p> <p>【Drying temperature confirm】</p> <p>Please refer to the present value and setting value on the main menu. Normal drying temperature is among setting value $\pm 2 \sim 3^{\circ}\text{C}$ ($\pm 3.6 \sim 5.4^{\circ}\text{F}$)</p> <div style="display: flex; justify-content: space-around;"> <div data-bbox="646 951 998 1207"> <p>Present Value: 80°C Set up Value: 80°C</p> </div> <div data-bbox="1044 961 1396 1207"> <p>When [i plas] flickers</p> </div> </div> <p>※ When [i plas] is flickering, this machine is in lasting drying working condition. The present value is switched to [i plas].</p> <p>【regeneration temperature confirmation】</p> <p>Please refer to 「temperature monitor」 for confirming. Normal regeneration temperature is between $210^{\circ}\text{C} \sim 220^{\circ}\text{C}$ ($410 \sim 428^{\circ}\text{F}$). (It is normal that regeneration temperature changes with the ambient temperature.)</p> <div style="display: flex; justify-content: space-around;"> <div data-bbox="646 1564 1010 1774"> </div> <div data-bbox="1036 1564 1399 1774"> </div> </div> <p>※ When [i plas] is flickering, this machine is in lasting drying working condition. The present value is switched to [i plas].</p>

Maintenance and Item-by-Item checking item	Operating Content
Confirming rotation of blower	<p data-bbox="576 354 862 386">【For the drying blower】</p> <p data-bbox="576 392 1421 457">Remove the hose from the exhaust port of the drying hopper and confirm that air flows swiftly.</p> <p data-bbox="576 497 946 529">【For the Regeneration blower】</p> <p data-bbox="576 535 1312 567">Confirm that air swiftly comes out from the recycle exhaust port.</p> <div data-bbox="850 604 1029 659" style="text-align: center;"> WARNING</div> <p data-bbox="576 680 1398 781">As powder and fragments of material may scatter at this time, please exercise caution and wear protective glasses and gloves when making confirmation.</p>

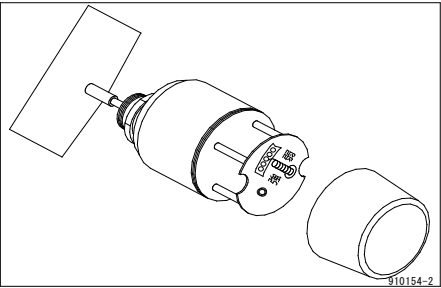
2. Weekly maintenance and inspection

Maintenance and Item-by-Item checking item	Operation Content
Clearing of the Filter	<div style="text-align: center; margin-bottom: 10px;">  </div> <ol style="list-style-type: none"> 1. Please wear respirator to prevent dust when clearing the dry filter, for the impurity attached on the filter may fly in the air. 2. Pay attention that the jamming of the filter may make its operation temperature and air rate unstable, and then cause fire hazard. <ul style="list-style-type: none"> * If the filter is jammed, take it off and use clean dry air to blow off the attachment. * Different surrounding may cause different polluted condition, be sure to carefully check regularly and clear the pollutant carefully. * After complete checking, put the filter back and fix it. <p>* If the mesh is badly jammed, or surface attached with oil film, filter undergoing severe color change and component quality deteriorating or shape distorting, please replace it with a new one.</p>
Clearing of Feeding Filter Clearing of Dry Filter	<p>Please take off the filter and check if it is jammed and clean it up.</p> <div style="text-align: center; margin-bottom: 10px;"> <p>[Disassembling and Clearing of the Filter]</p>  </div>

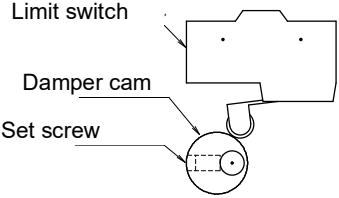
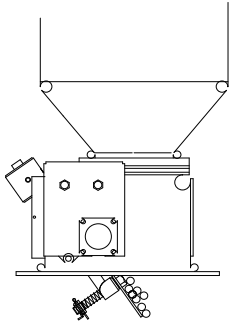
Maintenance and Item-by-item checking item	Operation Content
<p>Clearing of the Regeneration Filter</p>	<p>Please take off filter and check if it is got jammed or not and clear it up.</p>  <p>The diagrams illustrate the components and assembly of the regeneration filter. The top row shows a 'Filter cover' (a circular frame with a central hub), a 'Filter' (a circular disc with a central hub and a shaded area), and 'Filter Sheeting' (a jagged, irregular shape with a '+' sign). The bottom row shows a 'Filter' (a rectangular strip) and 'Filter Sheeting' (a circular disc with a central hub and a shaded area).</p>
<p>Dust Collecting Bin of air source unit</p>	<p>Please take off dust collecting bin and remove the fine particles that is stagnant inside.</p>  <p>The diagrams illustrate the dust collecting bin. The top diagram shows a cross-section of the bin, which is a cylindrical container with a lid. The bottom diagram shows the bin with three hasps (labeled '3 hasps') attached to the lid. The bin is labeled 'Dust Collecting Bin'.</p> <p>* Please replace gaskets with new ones when being degraded, transformed, discolored or become hardened.</p>

Maintenance and Item-by-Item checking item	Operation Content
<p>Method of discharging drain of air kit</p>	<p>Discharge drain that is stagnant in the bowl.</p> <p>If pressing drain valve on lower part of the bowl, air and drain will be discharged at the same time under the condition of compressed air being supplied (slick valve switched [on] side) .</p> <p>Receive the drain with the can.</p> <div data-bbox="738 604 1339 1029" data-label="Diagram"> </div>

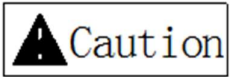
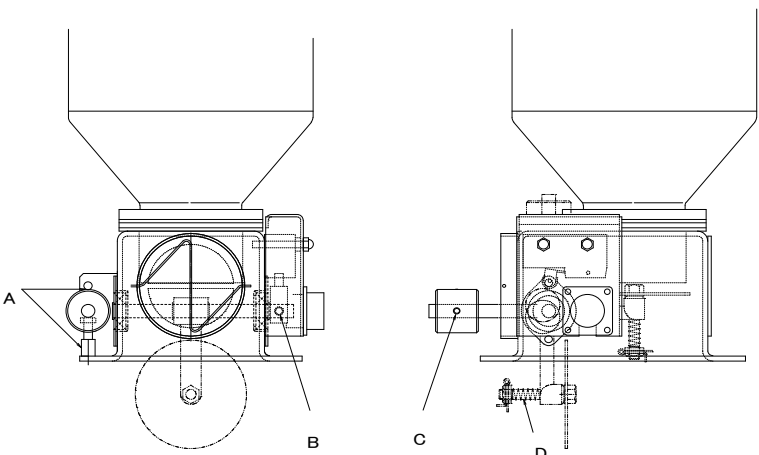
Maintenance and Item-by-Item checking item	Operation Content
Filter cleaning Jet Clone Receiving hopper on molding machine	<p data-bbox="581 317 1425 394">Please open the top cover of the sucking hopper and then remove the filter to check clogging up or not.</p> <p data-bbox="581 401 1425 478">If clogging up, puff it away with dry and clean air. Get rid of the adhering material.</p> <div data-bbox="738 535 1258 919" style="text-align: center;"> </div> <p data-bbox="581 961 1425 1039">* If the adhering material can't be puffed away with dry air, get rid of it with spiky head of iron wire, etc.</p> <p data-bbox="581 1045 1425 1123">* Please replace a new gasket when the old one is seriously aging, distorted, color changed or hardened.</p> <div data-bbox="889 1138 1107 1207" style="text-align: center;"> </div> <ul data-bbox="581 1228 1425 1690" style="list-style-type: none"> ○ Air leakage will occur if the filter is distorted, which will result in feeding can't continue; therefore, please pay more attention to the using manner. Once the filter is distorted, hammer it to stretch with soft objects such as wood hammer or rubber hammer, etc. If it can't be repaired in any way, please replace a new one. ○ The dirt adhering on the filter will fly in the atmosphere while cleaning the drying filter. Please wear a respirator to prevent the dust. ○ The conveying blower running with overload or with low conveying efficiency is always resulted from the clogging up to the meshes of the filter. Therefore, you should pay enough attention to it.

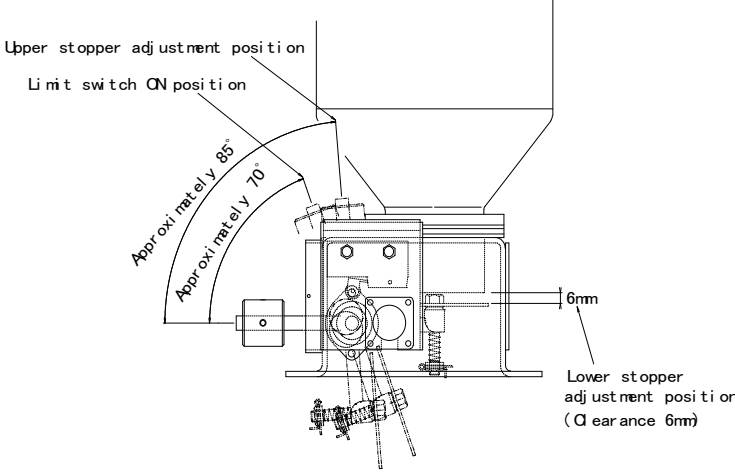
Maintenance and Item-by-Item Checking Item	Operation Content
Sensitivity adjustment of the paddle type level switch (Using the paddle type level switch)	<p>When the level switch doesn't sense correctly by the kind of material, the sensitivity adjustment is necessary.</p> <p>[Adjusting method]</p> <p>Adjust sensitivity at the specific gravity of convey material.</p> <ol style="list-style-type: none">① Turn the lid of the level switch to remove.② Change the position of spring installation hole. <p>When moving a spring to the low position, the sensitivity up. And, when moving a spring to the high position the sensitivity down.</p>  <p>610154-2</p>

Maintenance and Item-by-Item Checking Item	Operation Content
Sensitivity Adjustment of the Level Sensor	<p>Receiving hopper on molding machine install the level sensor. Sensitivity adjustment is done before goods shipped out of factory; However, if malfunction occurred, please follow below steps to adjust.</p> <div data-bbox="584 483 1412 808" style="text-align: center;"> </div> <p>Adjust sensitivity when material is empty(Function lamp turns off)</p> <ol style="list-style-type: none"> 1) Please set receiving hopper material empty. 2) Prepare round stick with flat or round head at both ends, diameter $\phi 3$. 3) Please observe function lamp while hold pressing OUT OFF program design button (for standard 4 seconds). When function lamp become slow flickering, please move your finger away and make sure the function lamp is turned off. 4) Please set receiving hopper level state full (with material), and when the function lamp becomes lit, adjustment finishes. <div data-bbox="876 1281 998 1354" style="text-align: center; border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;"> <p>NOTE</p> </div> <p>Please never touch the program design button with sharp or keen kit to avoid damage.</p>

Maintenance and Item-by-Item Checking Item	Operation Content									
<p>Adjustment of Jet Clone damper cam on upper part of the drying hopper</p>	<p>When the damper doesn't open until the full signal appears on, adjust a damper cam by following procedures.</p>	 <table border="1" data-bbox="581 554 1416 800"> <thead> <tr> <th data-bbox="581 554 667 600">Steps</th> <th data-bbox="667 554 1416 600">Operation Content</th> </tr> </thead> <tbody> <tr> <td data-bbox="581 600 667 646">1</td> <td data-bbox="667 600 1416 646">Loosen the set screw with a hexagon rod spanner (2.5mm)</td> </tr> <tr> <td data-bbox="581 646 667 722">2</td> <td data-bbox="667 646 1416 722">Adjust the cam so that limit switch may turn "ON" when damper declined to 45°~50° from the level line.</td> </tr> <tr> <td data-bbox="581 722 667 800">3</td> <td data-bbox="667 722 1416 800">After adjusting the daper cam, secure it by tightening the set-screw.</td> </tr> </tbody> </table>	Steps	Operation Content	1	Loosen the set screw with a hexagon rod spanner (2.5mm)	2	Adjust the cam so that limit switch may turn "ON" when damper declined to 45°~50° from the level line.	3	After adjusting the daper cam, secure it by tightening the set-screw.
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2	Adjust the cam so that limit switch may turn "ON" when damper declined to 45°~50° from the level line.									
3	After adjusting the daper cam, secure it by tightening the set-screw.									
<p>Adjustment of Jet Clone balancer on upper part of the drying hopper</p>	<p>Due to static electricity, occasionally, material will attached to the damper as it is shown in the photo besides, when this happens, please loosen the 2 set screws on the balancer and move backward at 5mm each time until the damper finally reach level line. When adjustment is over, please fix the set screws.</p>									




3. Monthly maintenance and inspection

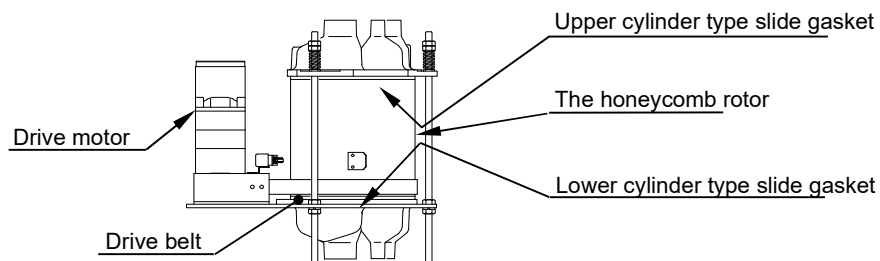
Maintenance and Item-by-Item Checking Item	Operation Content
Screwing Down of Terminal	<p>Please confirm if the wiring connection of the electrical apparatuses inside the electric-controlled box and the device is loose, screw down if it is loose.</p> <div style="text-align: center;">  </div> <p>Be sure to perform item-by-item checking after stopping the device and cutting off the power supply.</p>
Jet Clone inspecting	<p>A: Please check upper and lower brake (M6) for its firmness. * If any loose be found, please refer to “Brake Adjustment Photo” on next page for re-fasten.</p> <p>B: Please take off blind flange and check socket head cap screw of damper cam for its firmness. Meanwhile, shut up damper and check limit switch condition. * If any loose be found, please refer to “Brake Adjustment Photo “on next page for re-fasten.</p> <p>C: Please check socket head cap screw that set the balancer for its firmness. * If any loose be found, please tighten it up.</p> <p>D: Please check spring, bolt, nut and split pin condition. * If any abnormalities found, please replace them with a new one.</p> <div style="text-align: center;">  </div>

Maintenance and Item-by-Item checking Item	Operation Content
Jet Clone Inspecting	 <p style="text-align: center;">Brake Adjustment Photo</p>
Dropping and air-leaking of hose	<p>Please check if hose removes or leaks or not.</p> <p>* In case of the air-leak, replace them with a new.</p> <p style="text-align: center;">[Example of the checking method of the air leak]</p> <p>In the checking method, hang a string or a thread near the hose. In the shaking condition of a string or a thread, the air leak can be confirmed.</p>

4. Every six months maintenance and inspection

Maintenance and Item-by-Item Checking Item	Operation Content
Bolts and Screw Caps of Each Part of the Device	Please check if each bolt or screw cap is loose or not, screw down it if it is loose.
The Honeycomb Rotor	If remove destructive and non-regenerated adhering matters of high boiling point and improper object by outside force, the honeycomb rotor shall not undergo chronicle worsening in function due to use, so long as dehumidifying air dew point keeps stable and works properly, there is no need for replacing.

Maintenance and Item-By-Item Checking Item	Operation Content
The honeycomb rotor air gasket	<p>Air gasket on both upper and lower part of the honeycomb rotor are cylindrical type slide gasket. Please check both side sides of the honeycomb rotor. If any air leak or abnormities occurred, we recommend that you replace the cylindrical type slide gasket.</p> <p style="text-align: center;"> Warning</p> <p>The honeycomb ususly rotates at a low speed, therefore, situation is likely to happen when it reaches to seemed stopping, please pay sufficient attention to this.</p> <p>Carry on inspection while honeycomb rotor is operating, please paysufficient attention, do not draw clothing and finger, etc. into drive belt and belt pulley as well as into clearance between the honeycomb rotor and other parts.</p>
Drive motor	<p>Check driving motor, if any abnormities such as heat, noise, vibration, etc. occurred, please make sure to replace it with a new one.</p> <p style="text-align: center;"> Warning</p> <p>The honeycomb ususly rotate at a low speed in ON/OFF. Situation is likely to happen when it reaches to seemed stopping; therefore, please pay sufficient attention to this.</p> <p>Carry on inspection while the honeycomb rotor is operating, please pay enough attention, do not draw clothing and finger into belt and belt pulleyas well as clearance between honeycomb rotor and other parts.</p>
Drive belt	<p>Check drive belt, if any crack or gear wear, please make sure to replace It.</p> <p style="text-align: center;"> Warning</p> <p>Before approaching drive belt, please make sure to stop operaion and cut off power supply.</p>



Note: Only personnels with professional knowledge and skill can perform replacement and repairing work. If inspecting result shows abnormities, please contact Matsui's after-sales department.

This chapter mainly explains alarm function and its cause as well as how to