

**Well-Qualified
And Confirmed By**



Screw Feeder User Manual



This manual was written on August 1, 2020.

6th Edition

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First of all, thank you for your company using the screw feed produced by Qingyuan Yongheng Intelligent Technology Co., Ltd.

We will serve you wholeheartedly! All parameters of the screw machine have been adjusted to the best effect before leaving the factory.

It can be used directly after the mains and gas supply are connected. Please do not adjust it without permission!

Follow the instructions below! If you have any questions, please call us directly!

1. Usage:

1. First plug in the 220V power supply and 3-6KG gas source;
2. Add the screws to the tray. The tray screws should not exceed the track of the conveying screws.
3. Insert the signal cable plug into the signal interface of the control box;
4. Insert the screw delivery tube into the screw outlet of the control box (the screw delivery tube needs to be inserted to the bottom of the screw outlet);
5. Turn on the power switch of the screw machine (the power indicator light is on and the signal light is on);

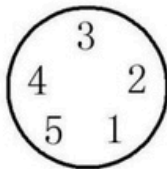


H

(Figure 1)

C

6. Signal interface (E) terminal description:



1. 0V

2. Alarm output 3.

Screw delivery completion signal

4. +24V

5. Free signal import

The start signal is rising. The start signal is rising edge trigger (trigger pulse

is valid for

more than 0.2 seconds). The maximum load of the alarm

output terminal is 500mA. When pins 1 and 5 are connected for 0.2 seconds,

the feeder starts feeding

(no external voltage can be connected); when the machine alarms, pin 2 outputs

0V, and pins 2 and

4 can drive the intermediate relay. When the machine completes feeding

screws, pin 3 outputs 0V, and pins 3 and 4 can drive the intermediate relay.

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(Figure 2)

- A. Push cylinder
- B. Material distribution sensor switch
- C. Air source interface
- D. Screw pipe
- E. Signal interface
- F. Screw detection switch

- G. Power switch
- H. Pressure regulating valve
- L. Digital tube
- R. Horizontal feeding speed adjustment
- V. Parameter setting panel
- Q. Barometer

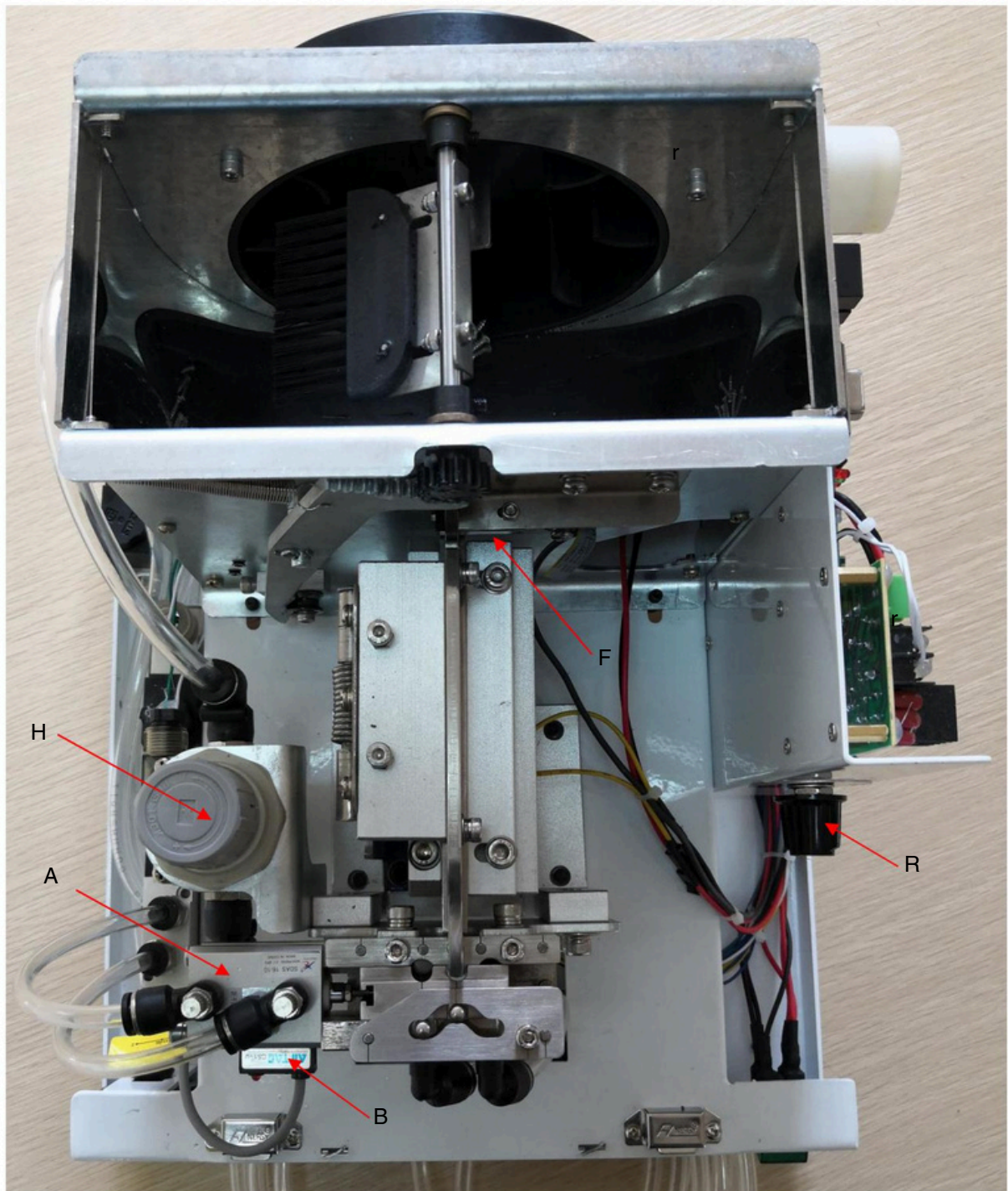
2. Performance adjustment:

1. Adjust the vibration intensity according to the screw transmission situation (clockwise increase, counterclockwise increase

direction decrease);

2. Vibration delay adjustment, adjust appropriately according to the transmission of the screw (clockwise increase, counterclockwise

needle direction decreases);



(Figure 3)

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3. The screw sweeping time of the material tray is automatically controlled by the induction switch, and it stops automatically when the guide rail is full of screws;

4. According to the different screw specifications, lift the regulating valve H(clockwise to increase air pressure, counterclockwise to increase air pressure).

Turn the regulating valve in the right direction to reduce the air pressure). Press the regulating valve after adjusting to the desired level.

3. Parameter setting panel (V) description:

1. Button 1 is the minus 1 key: when not in the function setting state, press it once to become the push key;

2. Button 3 is the plus 1 button: when not in the function setting state, press it once to activate the blow 1 button;

3. Button 4 is the confirmation button: when the machine is a one-out-two feeder, press it before entering the function setting state to blow 2

When the machine is a one-outlet four-feeder machine, press it once before entering the function setting state to push the material down.

4. Button 5 is the exit button:

4.1. When not in the function setting state, press the machine to eliminate the alarm as the reset button;

4.2. Press and hold the 5 key for 5seconds to restore the factory settings. The display will be 8888, and the parameter values will automatically change to 0.3 for item 1 and 0.3 for item 2.

The value of item 0 is 0.3, the value of item 3 is 9.0, press the 5 key again to return to the count display;

5. Button 6 is a single-action button: press it once to complete one feeding action;

6. Button 2 is a function key: when not in the function setting state, press it for 0.5 seconds to reset the counter;

6.1. When not in the function setting state, press 0.5 seconds to reset the counter;

6.2. Press this key for 5 seconds to enter the function setting state, the digital tube setting display, 100.3, (this parameter is the blowing time)

Press the 1 or 3 key to add or subtract 0.1 accordingly, and press the 4 key to enter the next item. Set the display to 200.3 (this parameter is

Press the 1 or 3 key to increase or decrease 0.1 accordingly, and press the 4 key to enter the next setting display.

The display shows 309.0 (this parameter is the material shortage delay alarm time). Then press the 1 or 3 key to increase or decrease 0.1 accordingly. Then press the 4

Press the key to return to the count display. During the setting process, press the 5 key to directly return to the count display.

7. The digital tube is a counter when it is not in the function setting state. It automatically increases by 1 when the screw is sent once.

It will automatically reset to zero at 9999;

4. Troubleshooting:

1. The loading tray does not rotate:

1.1. First check whether the screws on the guide rail are full. If they are full, the F indicator of the screw detection switch will light up and the loading tray will be turned on.

It is normal that it does not rotate. If the guide rail is not fully loaded with screws and the indicator light Fof of the screw detection switch is on,

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To adjust the height of the switch, make sure that the indicator light is on when there is a screw passing through the bottom of the sensor switch, and the indicator light is off when there is no screw.

It cannot be lit when passing by;

1.2. Check if the motor cable driving the loading tray is loose, or if the small gear driving the loading tray is loose.

fall down;

2. The sweeper does not swing:

2.1. First check whether the motor driving the sweeper to swing is rotating;

2.2. Check if the motor cable driving the sweeper is loose or if the small gear driving the sweeper is loose.

It didn't fall off;

5. Notes:

1. The machine cannot be inverted for extrusion. It is best to use a magnet to clean the hopper screws. Do not use an air source with water.

Do not adjust the machine performance at will, or disassemble non-standard parts and machine casing at will (with permission from our company).

or professional and technical personnel);

2. Do not connect any accessories at will. Please turn off the power and power supply before maintenance;