

Yihui Casting® 艺辉

# 一盅搅粉机

1 pc flask vacuum mixer



专注于首饰铸造  
Specializing In Jewelry Casting

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profession Dedication Cooperation Double-win

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## 声明

致用户：

- 感谢您对瑞辉自动化系统（广东）有限公司的信赖和支持，选购艺辉牌系列产品，为安全操作并最大限度发挥本机性能，请在操作前仔细阅读说明书，并严格遵守安全规则，以防发生意外事故，造成不必要的损失。
- 在机器使用的过程中，如遇到问题可以随时联系本公司销售人员，我们将会竭诚为您服务。
- 在保修期间，如果未经本公司允许，用户不得擅自拆开机器进行错误的检修，如擅自拆开机器，保修期将自动失效，不再享受本公司保修服务。
- 机器使用时所产生损失、利益损失和各种违规操作造成的各种间接损害，概与本公司无关。
- 未经本公司许可，产品说明书的所有内容，不得以任何形式翻版、传播、转载。
- 说明书因修改而进行的变更，恕不另行通知。如果您发现任何错误或遗漏，请您向您所购买的供应商反映，对此，我们深表感谢。

## STATEMENT

To users:

- Thanks for choosing Yihui brand products of Yihui Casting Technology Co.,Ltd. We are greatly appreciated for the support and trust you give to us. To ensure safe operation and play the property of this machine in full, please read the user manual in advance and observe the safty rules in case that accidents happen and unnecessary loss incurs.
- If you meet any problem when using this machine, please feel free to contact our salespersons. We will try our best to give you service.
- We are not responsible for the loss including loss in interest and all indirect damages caused by operations due to rule-breaking operations.
- Without our permission, it is prohibited to copy,disseminate or reprint the whole content of this user manual in any form.
- This manual is subject to alterations without prior notice. If you find any mistake or omission in this manual, please inform the supplier you bought the machine from. We will be very grateful for this.

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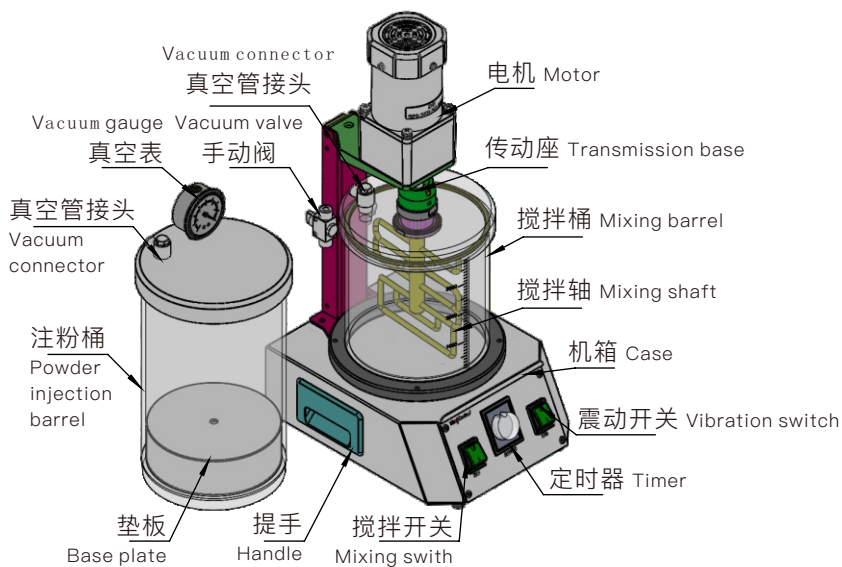
## 一、概述 Summary

本机主要功能为石膏粉搅拌及钢盅注粉。其体积小，一次最大放置4"×10"钢盅一个，更适应于工作室使用，其操作灵活，集搅拌、震动、抽真空等功能，便捷可靠。为了防止由于不熟练而造成的人身伤害、机器损坏及材料浪费等，因此，在使用本机器前，操作人员必须经过培训并充分理解机器的构成及注意事项，且仔细阅读使用说明书。

The main function of the machine is for mixing gypsum and injecting powder to flasks. The volume is small and it support max 1PC Φ4"x H 10" flasks at a time, and more suitable for studio. The operation is flexible, integrating functions such as stirring, vibration, and vacuuming which is convenient and reliable. In order to avoid personal injury, machine damage and material waste caused by unskillful person, the operator must be trained and well know the composition and precautions of machine before operate machine, and read the instruction carefully.

- 在机器使用的过程中，如遇到问题可随时联系本公司销售人员，我们将会竭诚为您服务。
- 在保修期间，未经本公司许可，用户不得擅自拆开机器进行错误的检修，如擅自拆开机器，保修期将自动失效，不再享受本公司保修服务。
- 说明书因修改而进行的变更，恕不另行通知。如果您发现任何错误或遗漏，请向您所购买的供应商反映，对此，我们深表感谢。
- In the process for using the machine, if you have any problems, please feel free to contact our sales staff, we will be pleased to serve you.
- During the warranty period, if without the permission of our company, the user is not allow to disassemble the machine for wrong maintenance. If the machine is disassembled without authorization, the warranty period will be automatically invalidated and the company's warranty service will be terminated.
- The instructions are subject to change without prior notice. If you find any errors or omissions, please report it to the supplier you purchased, and we appreciate it.

## 二、机器构成 Instruction of machine



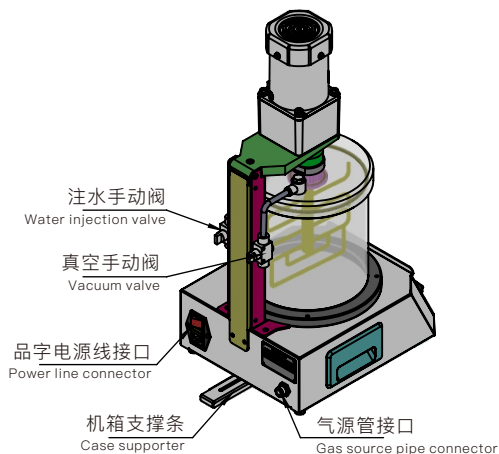
注：“垫板”为选配件，若放置4”×10”钢盅，则不需要垫板；若放置尺寸小的钢盅，可选用垫板垫高。

Remark: "Base plate" is an optional part. If it is a 4"×10" flask, you don't need a base plate; if it is a smaller size flask, you can choose a base plate.

### 三、产品参数 Parameters

产品型号 Item No	Z.M.VM.SAS01
电压 Voltage	220V
功率 Power	80W
气压 Air pressure	0.5MPa
抽气速率 Pumping rate	4L/S
搅拌速度 Mixing speed	145rpm
重量 Weight	17kg
外形尺寸 Size	260*331*583 mm

### 四、操作说明 Operating instruction



## 机器管、线连接

- 将机器摆放在工作台上，抽出机箱支撑条稳固机器。
- 连接气源管及真空管（真空管路可由手动阀控制通、断）。
- 将电源线插入接口，拨动开关进行通电。
- （注：注水手动阀在需要加水的情况下使用）

## Connection for pipes and lines

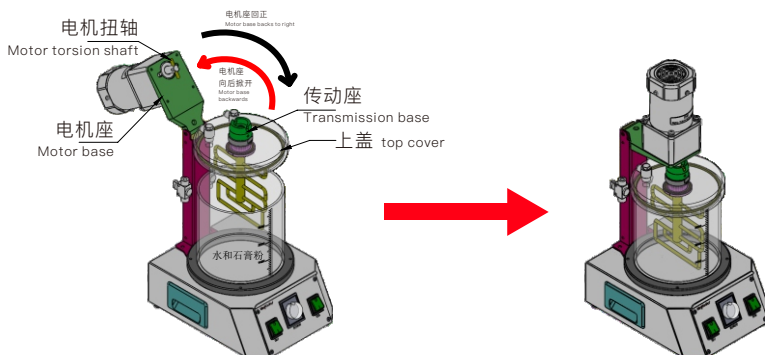
- Place the machine on the working table and pull out the case supporter to stabilize the machine.
  - Connect the gas source pipe and the vacuum pipe (the vacuum pipe can be switched on / off by a manual valve).
  - Connect the power wire and switch it on.
- (Note: The water injection valve is used in adding water require situation)

## 操作方法

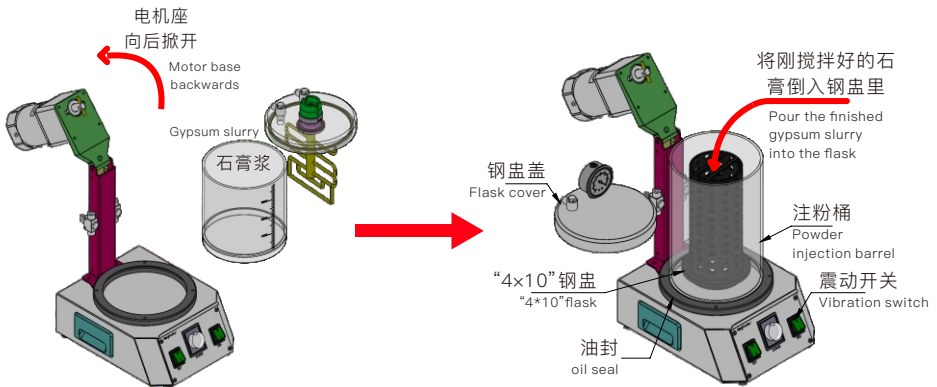
- 根据水粉比例，称好石膏粉和所需要的水（1kg粉兑380-400ml水）；
- 将电机座向后掀开，按比例将水与石膏粉倒入搅拌桶中，盖上上盖（图一）；  
电机座回正，电机扭轴卡入传动座槽中（图二）；

## Operational approach

- According to the ratio of water and powder, weigh the investment powder and the required water (380-400ml water for 1kg powder)
- Open the motor base, pour water and investment powder into the mixing barrel according to the ratio, and close the top cover (Picture 1); the motor base back to right, and the motor torsion shaft will be clamped into the transmission base slot (Picture 2) .



- 开启搅拌按钮，设置搅拌时间，开启真空手动阀，抽真空，待搅拌均匀后，搅拌完成并关闭搅拌开关。
- 将电机座向后掀开，搅拌桶移出油封；
- 将注粉桶放置在油封中，把 4"×10"寸钢盅竖直放入注粉桶内。后将搅拌桶的石膏浆倒入注粉桶钢盅中，盖上钢盅盖；开启震动开关，气动振压力阀调整至 0.5MPa(根据实际情况适当调整，正常情况下无需调整)，同时抽真空；
- Turn on the mixing button, set the mixing time, turn on the vacuum valve and vacuuming. After finish mixing, turn off the mixing.
- Open the motor seat and remove the mixing barrel from the oil seal .
- Place the powder injection barrel in the oil seal, and put the 4"×10" flask vertically into the powder injection barrel. Then pour the gypsum slurry into the flask in powder injection barrel, and cover the flask; turn on the vibration switch, and adjust the pneumatic vibration pressure valve to 0.5MPa (It's normally no need to adjust it, or according to the actual situation to adjust it), and pump vacuum at the same time.



- 完成后将注满石膏粉浆的钢盅取出，放在干燥的地方自然烘干，最后清洗搅粉机。
- After finish, take out the flask which filled with gypsum slurry, and place it in dry place to dry naturally, and finally clean the vacuum mixer.

## 五、维护及保养 Maintenance

- 注粉桶内如有溅、漏石膏水，使用结束后清理干净。
- If there is any splash or leakage in the powder injection barrel, clean it up after finish.



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