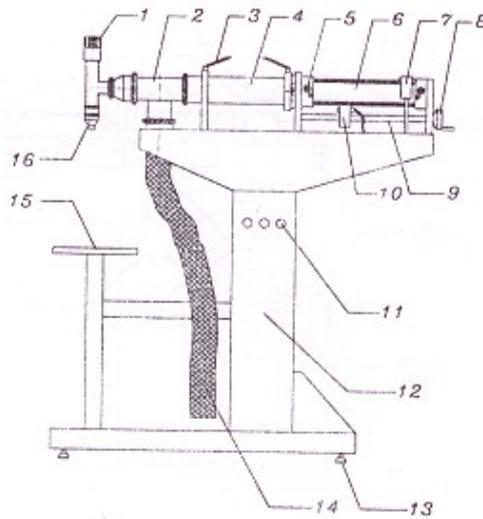
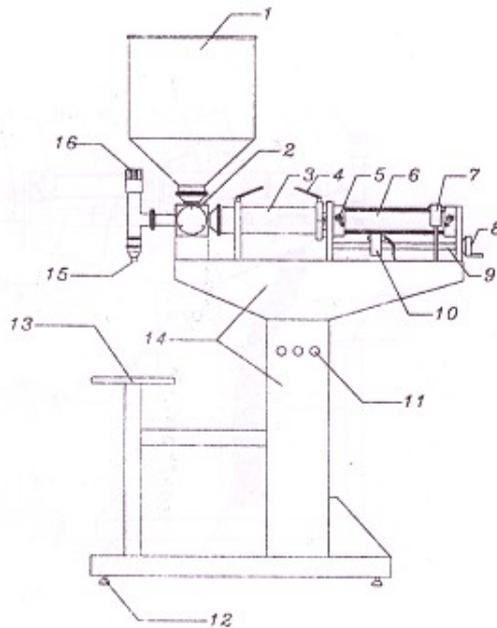


Filling machine manual



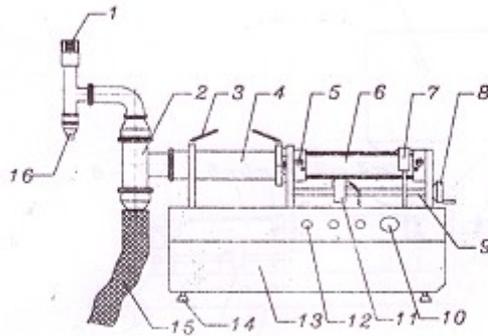
LPF-stand style for liquid

- 1.leakage proof cylinder 2. check valve 3. fixing handle 4.piston cylinder 5.throttle valve 6.main cylinder 7.fixed inductive 8.adjustable hand wheel 9.adjustable screw 10.adjustable inductive switch 11.control button 12.stand 13.foot 14.inlet pipe 15.working table 16.discharge nozzle



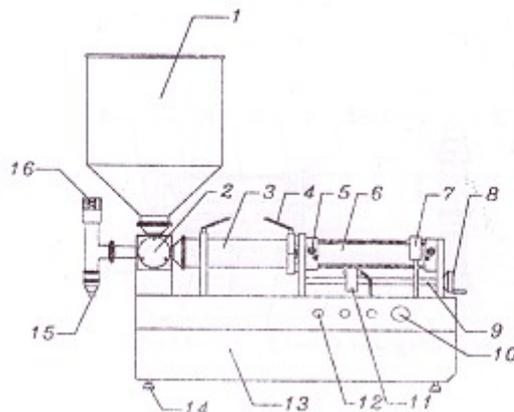
PPF-stand style for pasten

- 1.charging barrel 2.change valve 3.piston-cylinder 4.fixing handle 5.throttle valve 6.main cylinder 7.fixed inductive 8.adjustable hand wheel 9.adjustable screw 10.adjustable inductive switch 11.control button 12.foot 13.working table 14.inlet pipe 15.discharge nozzle 16.leakage proof cylinder



LPF-table style for liquid

- 1.leakage proof cylinder 2. check valve 3. fixing handle 4.piston cylinder 5.throttle valve 6.main cylinder 7.fixed inductive switch 8.adjustable hand wheel 9.adjustable screw 10.manometer 11.adjustable inductive switch 12.control button 13.stand 14.foot 15.inlet pipe 16.discharge nozzle.



PPF-table style for pasten

- 1.charging barrel 2.change valve 3.piston-cylinder 4.fixing handle 5.throttle valve 6.main cylinder 7.fixed inductive 8.adjustable hand wheel 9.adjustable screw 10.manometer 11.adjustable inductive switch 12.control button 13.stand 14.foot 15.discharge nozzle 16.leakage proof cylinder

2.General information and application

PF series semi-automatic pneumatic filling machine is the latest machine designed on the basic of many advanced equipment used at home and abroad and our customer requirement as well. 95% of the machine is made of quality stainless steel, which has good performance on acid/alkali resistance and corrosion resistance. The machine has nice and elegant appearance, which is precisely made with stable operation, reliable performance, easy operation and maintenance. It can be used to fill many liquid or paste with fixed quantity such as sweet chili sauce, cooking oil, mineral water, juice, injection, shampoo, detergent and so on, in which its filling quantity and speed can be adjusted freely and precisely. Adopting vacuum returning or instant cut-off, it avoids drawing and efficiency as well. The machine can be used in single or equipped in an assembly line, which is really an ideal mechanical equipments for pharmacy, food, chemical industry and other industries.

Note our factory offers made to order automatic filling machines with double outlets, 6outlets, 8outlets, etc, and assembly lines. Welcome to hold business talk with us!

3.Main technical data and specification, filling capacity

Produce code	Filling capacity	Maxairconsumption	Overall size	Machine weight
PPF-100T	20g-100g	0.6m ³ /hour		
LPF-100T	20ml-100ml	0.55m ³ /hour		
PPF-250T	50g-250g	0.6m ³ /hour		
LPF-250T	50ml-250ml	0.55m ³ /hour		
PPF-500T	100g-500g	0.9m ³ /hour		
LPF-500T	100ml-500ml	0.88m ³ /hour		
PPF-1000T	200g-1000g	1.1m ³ /hour		
LPF-1000T	200ml-1000ml	1.05m ³ /hour		
PPF-100	20g-100g	0.6m ³ /hour		
LPF-100	20ml-100ml	0.55m ³ /hour		
PPF-250	50g-250g	0.6m ³ /hour		
LPF-250	50ml-250ml	0.55m ³ /hour		
PPF-500	100g-500g	0.9m ³ /hour		
LPF-500	100ml-500ml	0.88m ³ /hour		
PPF-1000	200g-1000g	1.1m ³ /hour		
LPF-1000	200ml-1000ml	1.05m ³ /hour		

Voltage: 220V/50HZ

Power: 20W

Air supply pressure: 0.4-0.6Mpa

Operation Efficiency: 10-18/min

Filling precision: $\leq \pm 1\%$

Note: for filling capacity over 1000g (or ml) or less than 100g(or ml), our factory offers made-to-order product to customers.

4. Debug and instruction

4.1. Preparation before running the machine

A. Check accessories and attached parts according to components list when you first unpack the machine after receipt. Put power line in relevant socket.

B. Connect and install attached parts with the machine. Plug pedal switch and power line into relevant socket, then connect the charging barrel and change valve and clamp it.

C. Put the machine on a stable working table. (Put it on a flat floor if it is a floor type)

D. Check to see if there is any fastening component loosened and flexible parts component clamped.

E. Check if the ground line is well connected.

F. Put through air supply (customer should prepare an air compressor with 35L capacity and over 1.5KW). Remove any dusts, impurities, etc. in the pipeline so as to avoid any possible damage to pneumatic components caused by this.

G. Connect to power supply.

4.2. Debug in idle running

A. Adjust the pressure adjusting filter to reach air pressure 0.4-0.6 Mpa.

B. Switch the optional button to manual operation and fill one or more times.

Note: Put a bucket or other container under the feeding nozzle during filling.

C. User can adjust the filling speed according to its discharging speed and impact force in order to get the satisfactory filling quality and higher operation efficiency. Usually, it's recommended to accelerate the filling speed when it feeds and slow down when it fills. For detailed methods please refer to (fig.2).

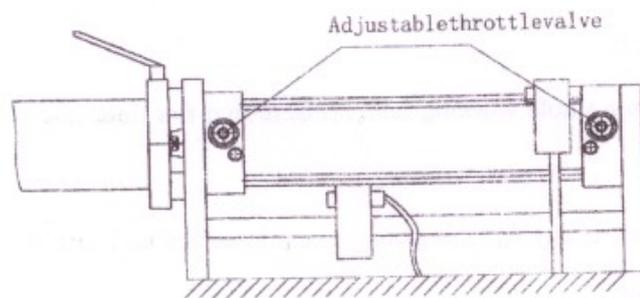


Fig2

D Adjustments steps

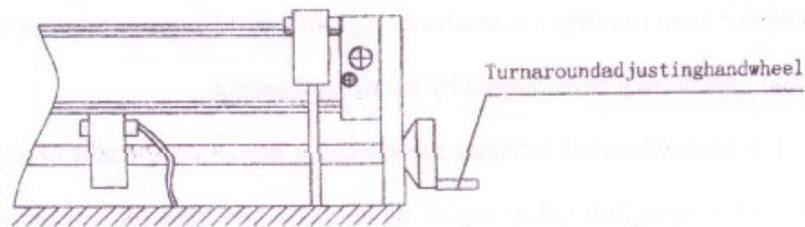
a. Loosen the locking nut in the one-way shut-off valve on the main cylinder.

- b. Adjust the one-way shut-off valve in order to reach an ideal filling speed.
- c. Fasten the locking nut.
- d. Usually, user only needs to adjust the shut-off valve that controls filling speed, i.e. the one nears the charging barrel.

4.3. Adjusting filling capacity

A. Coarse adjustment. Loosen the locking nut on the adjusting brace and turn around the hand wheel to get the adjustable inductive switch to needed position that allows required filling capacity. Fill one or more times on this position.

B. Fine adjustment. Carry out adjustment according to errors found between required filling capacity and the actual filling capacity. Fix the adjusting brace after the actual filling capacity equals the required value. For detailed method, please refer to (fig.3)



C Do not move the inductive switch while debugging since it may result in failure operation of the machine. If it is moved, you need to adjust its position again until the machine works normally before you look and fasten the inductive switch.

4.4. Operation

After debugging, it can be put to use.

5. Service and maintenance

5.1. Clean the air circuit thoroughly to keep any dust or other impurity away the pipeline and cause any possible pneumatic components.

5.2. Keep any hard or sharp material away the charging barrel and cylinder gasket from being scratched, which may further cause mistaken measurement or other mechanical damage that stops machine from running. It's recommended to filter the material before get into the charging barrel.

5.3. As the machine uses compressed air, it is recommended to get the air supply through air cleaner and dryer before getting to the pneumatic parts so as to prolong the operation life of the pneumatic parts so as to prolong the operation life of the pneumatic parts.

5.4. Never keep running the machine idly without filling material, or else, the piston gasket

may be damaged by frictional heating.

5.5. It is recommended to clean the charging barrel with water or liquid medicine after operation every day so as to avoid any possible corrosion to the precise parts as charging barrel and piston. The machine should be wiped with a towel.

5.6 Keep the high precision parts such as charging barrel and cylinder from being crashed by hard material, or else, the machine may be unusable. Please transport the machine as gently as possible.

5.7 If the machine is not operated for a long time, it should be put in a dry place without possible crash. Remove and clean the remained material in the charging barrel thoroughly and cover the machine.

6. Failure and recovery

Failure	Recovery
Pilot lamp doesn't shine and machine cannot start running.	1. Check the power supply
	2. Check the protective tube
Cylinder moves slowly and reciprocating motion shows tiredness	1. Low air pressure. Please adjust the adjusting filter.
	2. Damaged cylinder
	3. Mechanical chucking
	4. Damaged electromagnetic valve, change one
Normal power supply and air supply, but the machine cannot start running.	1. Adjust the position of inductive switch
	2. Damaged coil of electromagnetic valve, change the valve.
Irregular filling measurement	1. Damaged piston or charging barrel, change it.
	2. Filling speed is too fast, slow filling speed.
	3. Dull electromagnetic valve or inductive switch
Blocked filling nozzle	1. Mechanical chucking
	2. Damaged leakage proof cylinder, change the cylinder
	3. Air pipeline is wrong connected
Leaking	1. Damaged leakage proof cylinder
	2. Damaged gasket, change the leakage proof piston gasket.

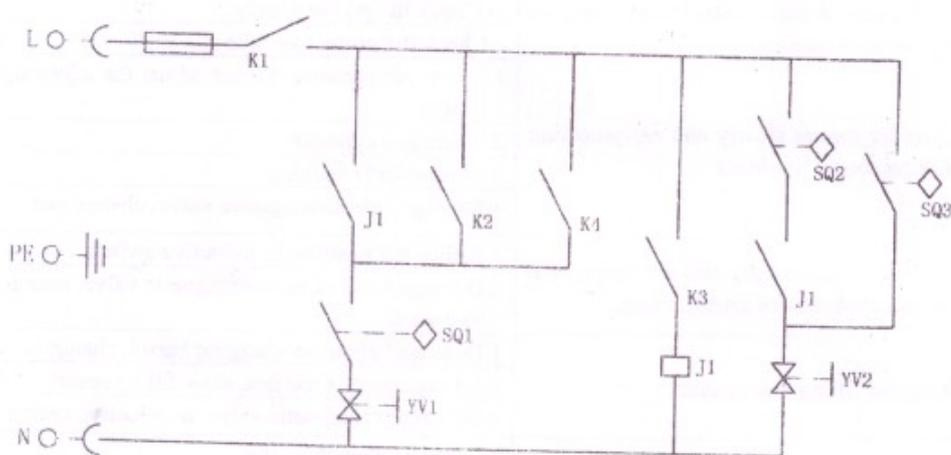
Noter

1. please go to professional maintenance technicians or contact the manufacture to maintain the machine. Non-professionals should never take the machine apart.

2. Never change the connecting way of each air pipe, or else, the machine will unable to work.

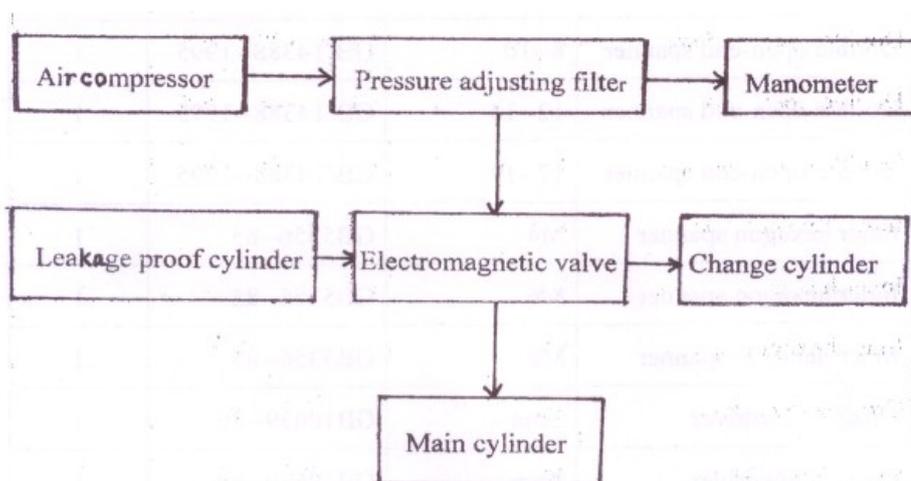
3. Stop the machine while maintaining it; its better to cut of power supply and air supply.

4. Schematic diagram of electric parts.

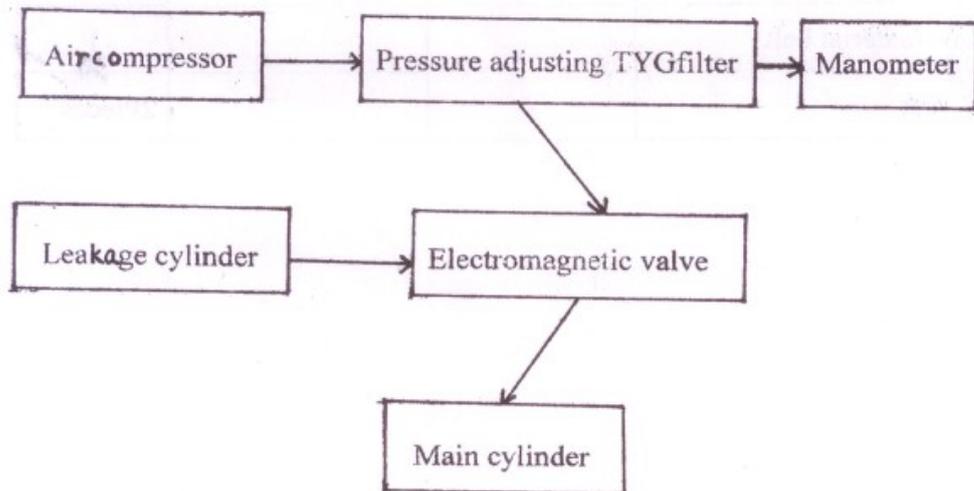


8. Schematic plan of air circuit

8.1 PPF series air circuit schematic plan



LPF series air circuit schematic plan



9.Attached parts

Name	Specification	Standard	Quantity
Double open-end spanner	8-10	GB/T4388-1995	1
Double open-end spanner	12-14	GB/T4388-1995	1
Double open-end spanner	17-19	GB/T4388-1995	1
Inner hexagon spanner	M4	GB5356-85	1
Inner hexagon spanner	M6	GB5356-85	1
Inner hexagon spanner	M8	GB5356-85	1
Cross screwdriver	2cun	GB10639-89	1
Cross screwdriver	3cun	GB10639-89	1
Cross screwdriver	3cun	GB1064-89	1
Raw material belt			1
Gasket			2Pieces