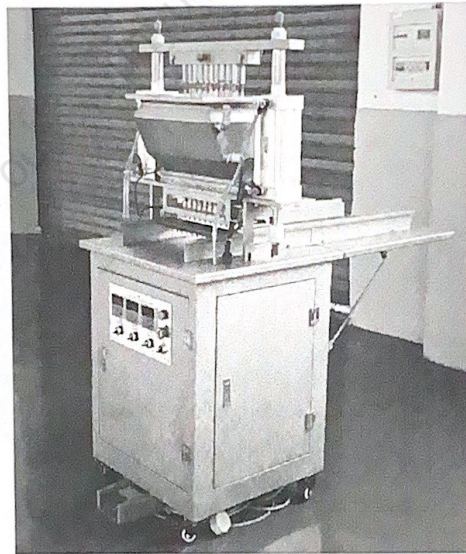


说明书 Manual

型号 Model

J-30

配图 Pictures



描述 (Description)

This candy depositing machine is a multi-functional ideal equipment to make various candies, such as gummy candy, hard candy, lollipop candy. As it is small size, it is widely used in the lab or home.

参数 Specification

Production capacity: 10-30kg/hour

Candy weight: 2-8g or customized

Power: 5kw

Machine packaging size: 950*930*1630mm

Machine weight: 120KG(估)

联系方式 Contact

Shanghai Junyu Food Machine Co., Ltd

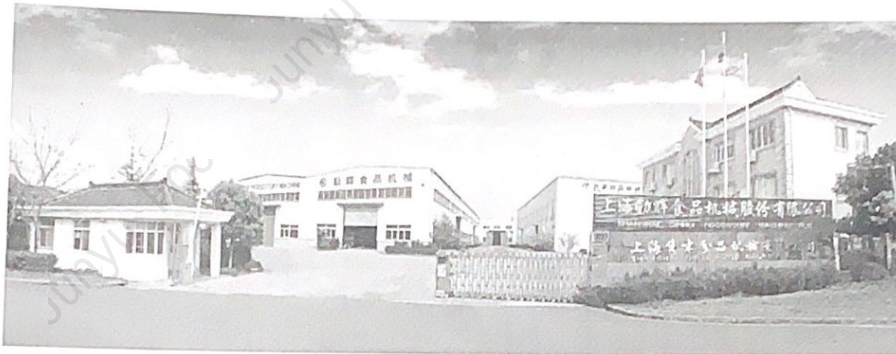
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Tel: 8621-57450859

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 - 2.3 操作面板以及介绍 Operation panel and introduction
 - 2.4 配件清单 Spare parts list
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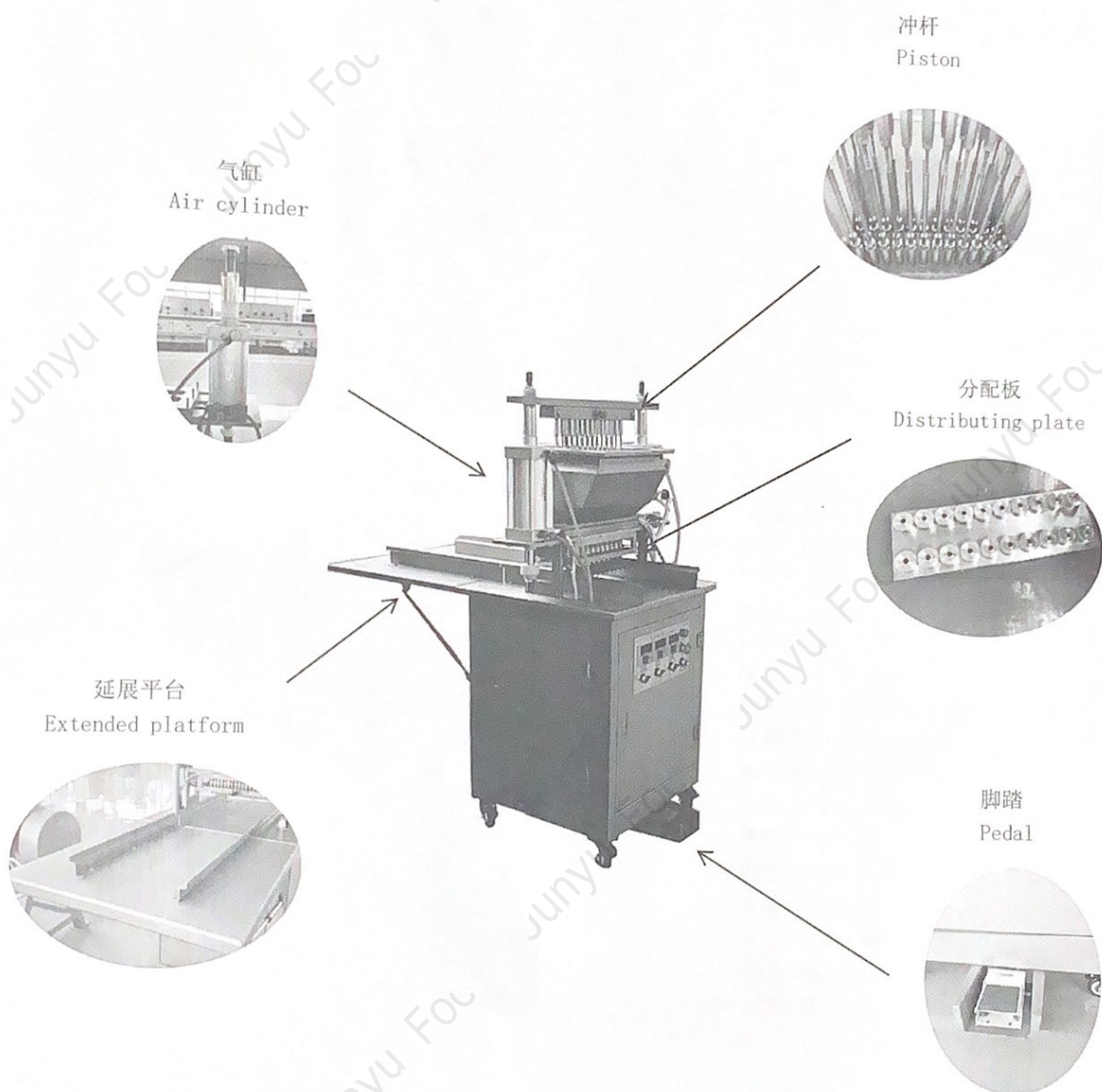
1. 公司介绍 Company introduction



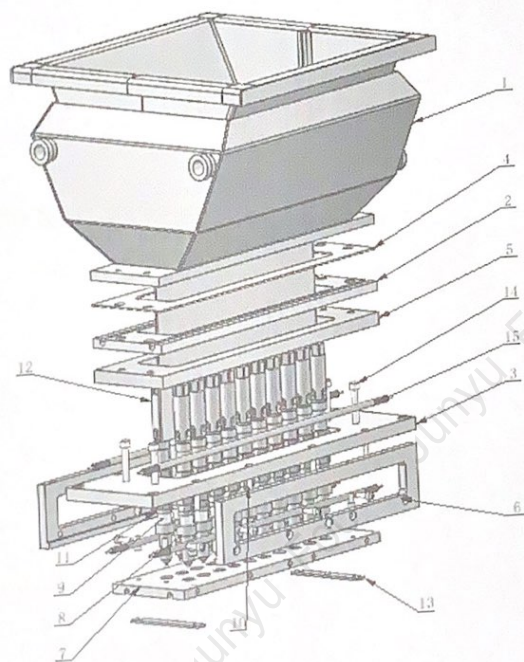
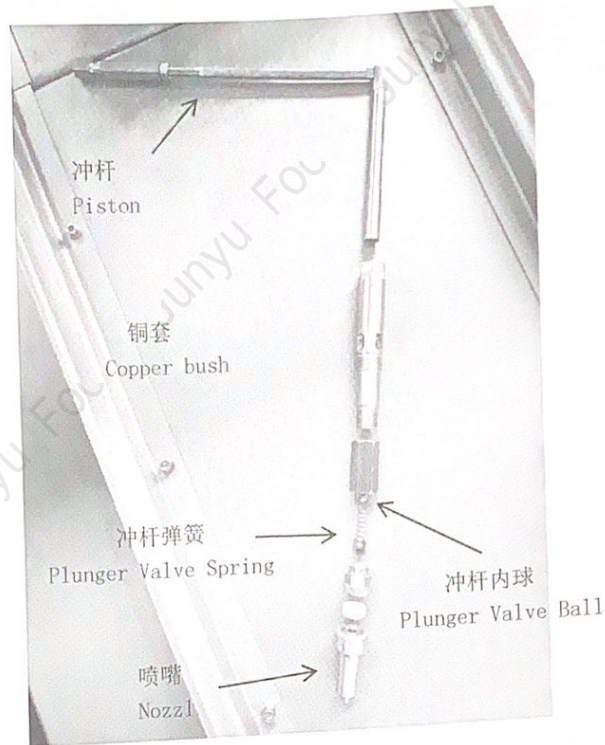
Shanghai Junyu Food Machine Co., Ltd. is a private enterprise with more than 40 years of manufacturing experience, specializing in the production of various types of food machine. It is a fast-growing enterprise with slightly global equipment. The company mainly specializes in the production of biscuit machine complete sets of equipment, candy machine complete sets of equipment, yolk pie complete sets of equipment, chocolate complete sets of equipment, automatic wafer production line and other types of food machine. On the basis of technological innovation, the company attaches great importance to quality management and continuously improves its service level, realizes the sound development of its business, increases its sales performance year by year, and accounts for about 90% of the total annual sales. Excellent employees, advanced technology, sophisticated equipment, strict management is the company can continue to grow, products can win user dependence on the fundamental. The company is committed to the business philosophy of honesty, trust-based, quality-based. "To win customer satisfaction with high-quality products, to continue to improve to ensure technological development & quality policy. Shanghai Junyu Food Machine Co., Ltd. has won the trust and praise of customers at home and abroad in pre-sale, mid-sale and after-sale service. We actively participate in the promotion and industry exchange activities. In the long-term development process, the company has established long-term good cooperative partnership with excellent product quality, good product performance, leading technical advantages and many large enterprises at home and abroad. We also warmly welcome customers from home and abroad to visit our company and exchange technology.

2. 设备介绍 Equipment Introduction

2.1 设备各部件名称以及介绍 Name and introduction of each component of the equipment

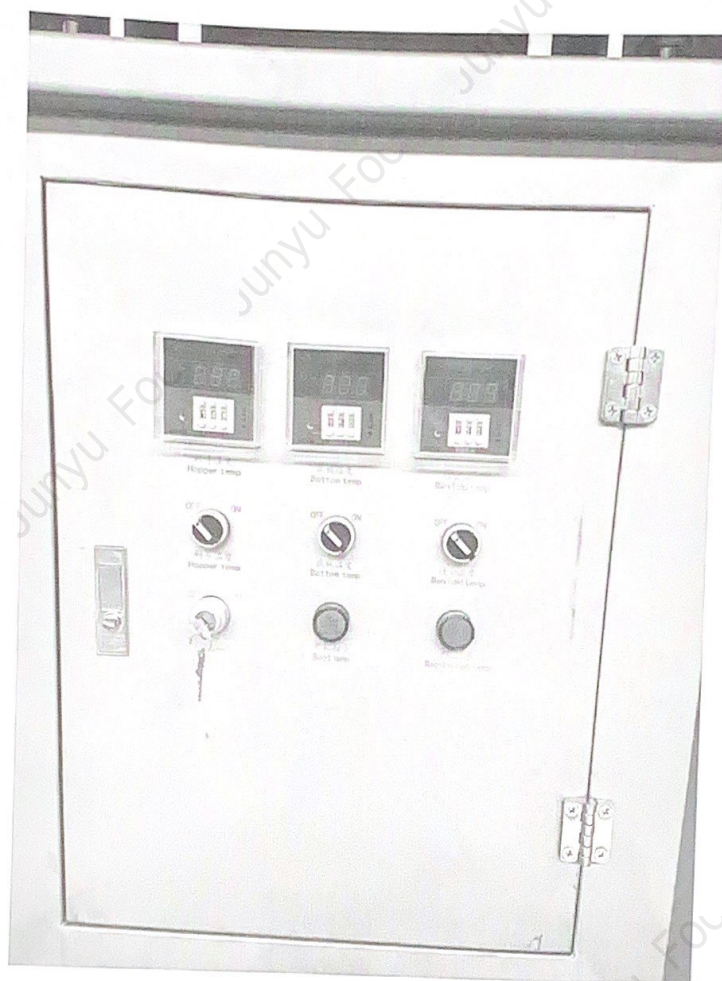


2.2 料斗各部件介绍及示意 Hopper components and schematic



- 1- 料斗 hopper
- 2- 上加热板 heating plate
- 3- 底板 baseboard
- 4- 加热板盖板 cover plate for heating plate
- 5- 保温板 insulation board
- 6- 侧板 side plate
- 7- 分配板 distributing plate
- 8- 浇铸嘴 casting mouth
- 9- 密封圈 seal ring
- 10- 阀腔 body cavity
- 11- 弹簧座 spring seat
- 12- 铜套 copper bush
- 13- 压板 pressing plate
- 14- 内六角螺栓 inside hexagonal bolt
- 15- 电热管 tubular electric heating element

2.3 操作面板以及介绍 Operation panel and introduction



1) 料斗温度 Hopper temperature

控制料斗的温度，可在显示屏下手动按钮调节；

The hopper temperature can be adjusted by manual button under the display screen;

2) 底板温度 Bottom temperature

控制底板的温度，可在显示屏下手动按钮调节；

The bottom temperature can be adjusted by manual button under the display screen;

3) 歧管温度 Manifold temperature

控制歧管的温度，可在显示屏下手动按钮调节：

Manifold temperature control can be adjusted by manual button under the display screen;

4) 电源 Power

钥匙启动电源；

Turn key to start machine power;

5) 开机指示 Boot lamp

开机启动按钮；

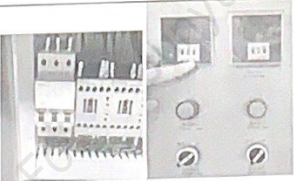
Turn on the machine start button;

6) 停机指示 Machine halt lamp

关闭机器启动按钮。

Turn off the machine start button.

2.4 配件清单 Spare part list

N/M	Item 名称	Picture 图片	Application 应用	Quantity 数量
1	plunger 冲杆		Use for candy depositing. Consist of plunger, brass sleeve, valve ball, spring, Teflon seals, nozzle 用于糖果浇筑。 由冲杆、铜套、内球、弹簧、密封圈、喷嘴组成	1set 1套
2	Temperature detector 温度探头		for temperature detection 用于温度探测	1set 1套
3	Air pipe connector 气管接头		for air access 用于气管接入	1set 1套
4	Air pipe 气管		For air go through 用于气管运输	1set 1套
5	Electrical parts 电器部分		for Electric control 用于电器控制	1set 1套

3. 设备准备 Equipment preparation

- 特别提示 Special Note

作为一种有高温，及金属传动的设备，必须要时刻防止人身事故的发生，保护生产和机器。为了操作者和维修人员的安全，检修时关闭所有气源和电源，请您仔细阅读本说明书并严格遵照安全标准执行。

As it is a metal drive equipment with high temperature, you need to pay more attention to avoid any accident and protect the machine production. To keep the safety for the operators and maintenance engineers, we need to turn off the power and air supply before the maintenance. Meanwhile, pls kindly read this manual and strictly comply with safety standards.

3.1 安全准则 Safety rules

浇注机械传动机构有夹伤身体及手指的危险；运行中身体不要接触机械的可移部分以及气缸。

The drive mechanism in the depositing machine has the risk that can pinch the fingers or a part of the body; When running the machine, don't touch any movable part of the machine.

料斗高温烫伤身体的危险；运行中身体不要接触机械的可移部分及高温部分。

High temperature of the hopper is easy to burn the body; Do not touch the removable body of the machine and the high-temperature part.

检查、修理时必须关闭电源以及气源，如肢体进入机器运动部件中间，应立即切断电源。

If bodies are in the moving parts of the machine during the inspection and repairment, you should turn off the power and air supply immediately.

无论什么场合，整个身体进入危险部位时都应先切断电源。

Whatever the occasion, the whole body entering into the dangerous parts should be cut off the power first.

3-2-1 操作人员安全 The Operator safety

1) 防止漏电及电击 Prevent electric leakage and electric shock

2) 机器必须接地良好，保证电源接地线的正确；

The machine must be grounded, and make sure correct power ground wire

3) 机器接通电源时，所有的操作面板及外罩均应处于正确位置，开机后，不允许接触电器；

When the machine is power on, the operation panel and machine's cover should be in the

correct position, no allow to contact with electrical power;

4) 保持身体与地面绝缘: 戴防护手套, 穿安全鞋以及安全服;
Keep the body insulated from the ground: Wear protective gloves, safety shoes and safety clothing;

5) 应配置与电源相适应的可快速断开电源的装置;
Should configure quick outage (cutting power) device;

6) 经常检查主导线的外壳是否损坏或破裂, 否则须立即更换;
Regularly checks the shell of the leading line, if damaged or broken, it should be replaced immediately;

7) 在维护保养时, 必须首先断开电源开关或取下电源插头, 等待 5 分钟后 (电容器放电完成), 才可以进行后面的工作, 防止电击。

During the maintenance, the first thing is to close off the power, wait for 5 minutes (capacitor discharge), and then start to work, to prevent electric shock.

8) 防止火灾及烧伤事故 Prevent fires and burns accident

9) 操作者应穿戴合适的安全防护用品;

The operator should wear appropriate safety outfit;

10) 保持机器及其四周环境卫生, 安全处理废水;

Keeping the machine and its environment clean, safety treatment of wastewater;

3-2-2. 对车间的要求 Workshop requirements

1) 建议车间采用全封闭结构, 防止外部环境中的灰尘进入车间;

Suggest using totally-enclosed workshop to prevent dust outside to enter the workshop.

2) 车间要有通风排风扇, 排风扇应用隔离网, 以使车间与外部隔离, 防止外部环境中的灰尘进入车间。

Workshop should have ventilation fan with isolation network, in order to prevent dust outside entering workshop.

3) 板墙面应由易清洁的卫生材料做成, 且应有卫生的天花板, 防止灰尘积聚跌落到机器及产品上, 影响产品的卫生

The wall boards need to be made of easy-to-clean material and setting with clean ceiling to prevent dust on the wall falling into the machine. That will affect the hygiene of the product.

4) 车间温度要求为室温。

The workshop is room temperature.

5) 建议车间安装空调, 以保证本设备对生产车间的温度要求(1-40C, 30-55%),

Suggest install air condition in the workshop, which can ensure the equipment requirements of the production workshop(1-40C, 30-55%);

3.3 机器固定以及润滑 Machine fixed and lubrication

运动部件的润滑 The lubrication of the moving parts

本设备有减速机，链条等运动部件，为了这些部件的正常运行，请按规定对它们进行润滑。
This equipment has many moving parts, like reducer, chain and etc., for their normal operation, lubricate them in accordance with the regulations.

汽缸：请使用 N320—N469#润滑油，第一次机器使用 100 小时后更换第一次润滑油，以后每 2500 小时更换一次。

Reducer: N320-N469 # lubricant, please replaces the lubricant after the first 100 hour, and then replaced once after each 2,500 hours.

轴承：请使用 3#钙基润滑油脂，每年更换一次。

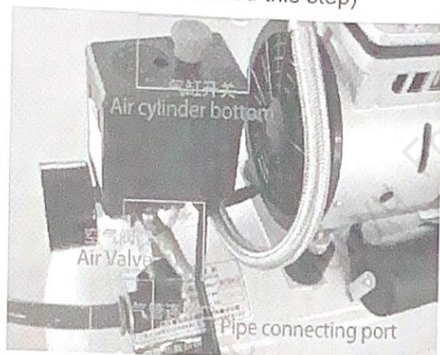
Bearings: please use the # 3 calcium base grease, replaced once a year.

注意：禁止使用其它不符合食品卫生要求的润滑油，以免污染食品。

Notice: about Conveyor chain and templates conveyor chain, prohibit using other lubricants that do not meet the requirements of food hygiene, to avoid contamination of food.

3.4 接线接气标准指示 Guide for air and wire connection

- 1) 接气(如伺服电钢的型号则不需要这个步骤)Air connection (such as servo electric steel models do not need this step)



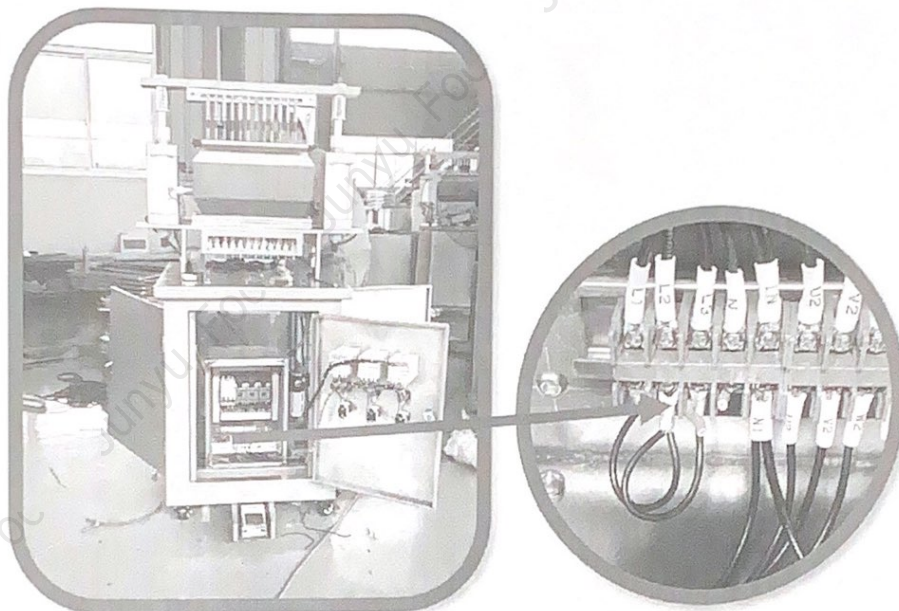
- 2) 接线(如航空插头的型号则不需要这个步骤)Wiring (this step is not required for models with airline plugs)



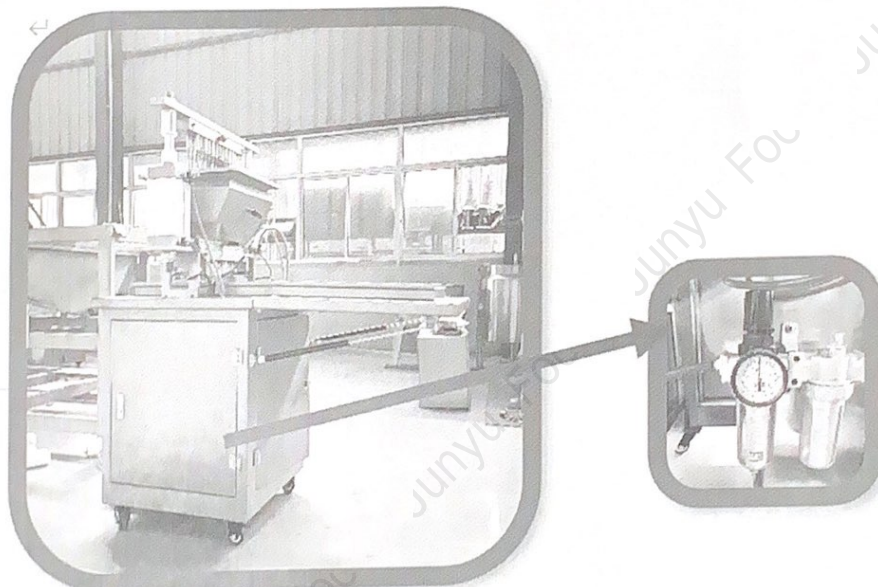
Three phase five wire

4. 操作指南 Operation guide

- 1) 打开控制面板和电控箱并找到左下角电源线接口。按照对应的接线标准接线
Open the electric box to find out the power and wiring.



- 2) 打开侧面的柜门，找到油水分离器（No.1 气管接入阀）
Open the side door to find out the oil water separator and connect the air.



- 3) 按照箭头接入气管
Connect the air pipe.

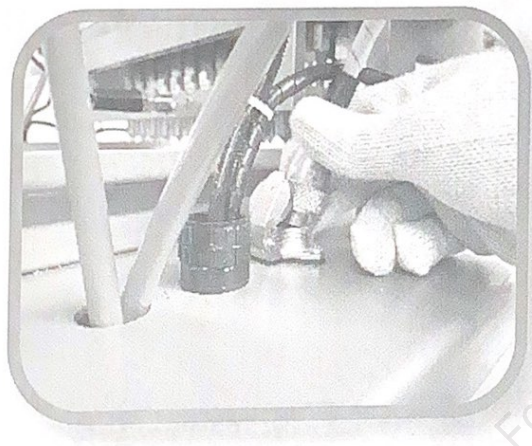


4) 将气泵气压调整到 0.4 - 0.5

Adjust the pressure to 0.4-0.5

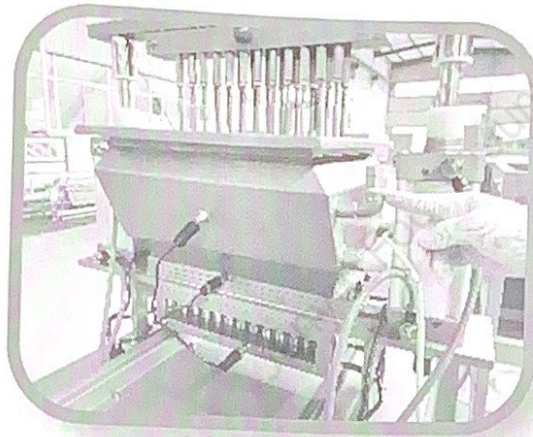
5) 关闭所有柜门，插入航空插头并旋转至锁定

Close the doors, connect the plug and turn to the lock.

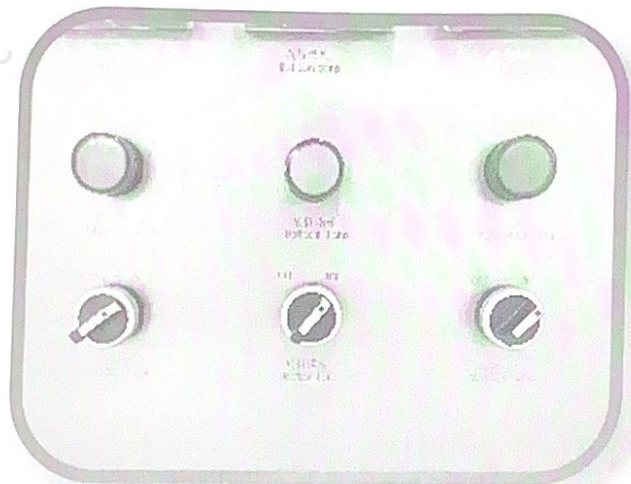


6) 倒入导热油

Fill in the heating transfer oil



7) 打开三个独立温度控制开关
Open three separate temperature control switch

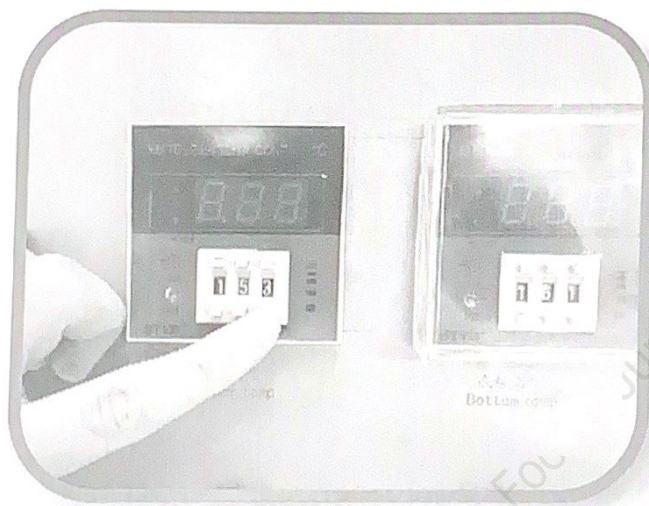


8) 按照配方要求设定温
Set up the temperature according to the formula condition



9) 上面的按钮降低温度；下面的按钮增加温度。

Upper button to reduce the temperature; below button to increase the temperature



10) 糖浆倒入料斗

Syrup fill into the hopper

11) 踩住踏板气缸上升，放开踏板气缸下降完成浇注。

Step the pedal, the cylinder will go up. Release the pedal, the cylinder drops, then finish the depositing.

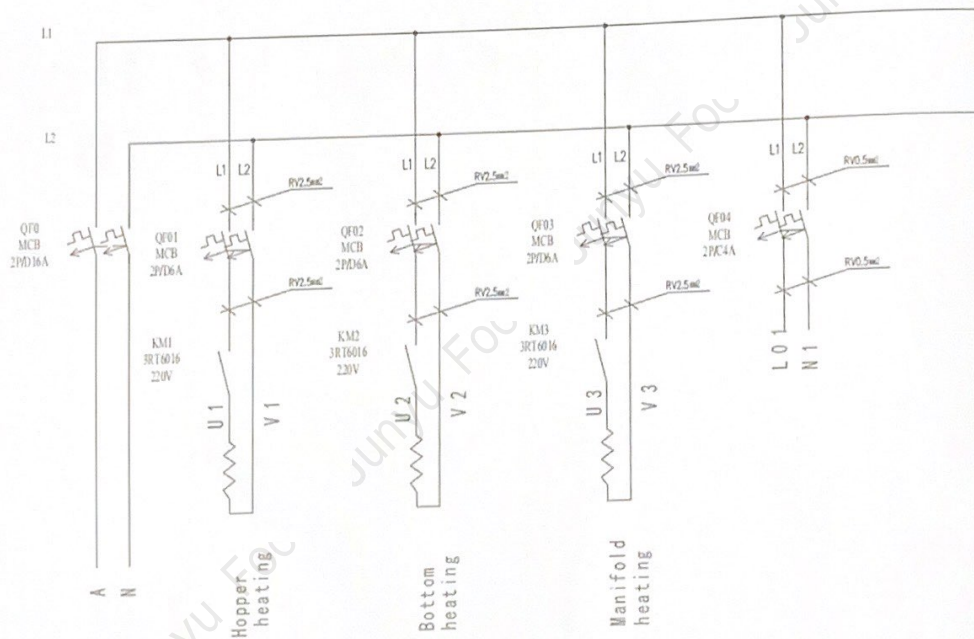


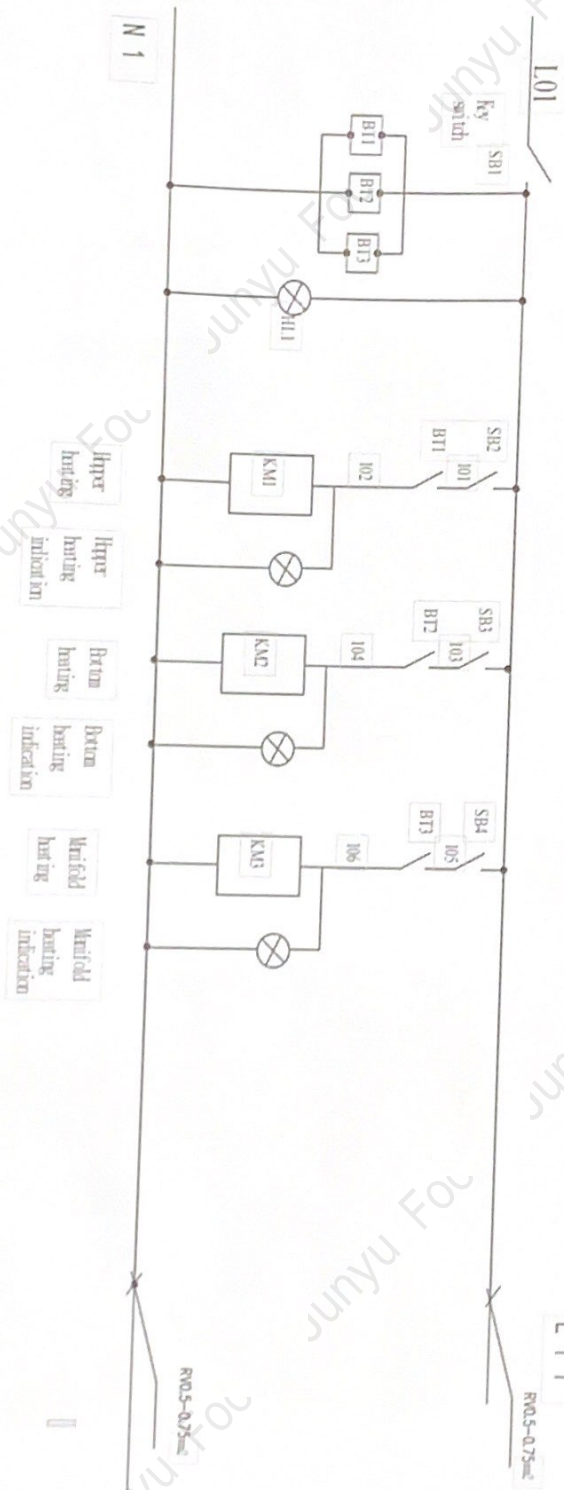
Tip: 为了美观气管请从机箱底部接入。

Tip: To be tidy, the air pipe can connect from the machine bottom.

5. 电器图 (设备检修时用)

Electrical diagram (for equipment maintenance)





L 1 1

L 1 1

RV0.5-0.75A

RV0.5-0.75A

N 1

L 0 1

KV switch

SB1

BF1

BF2

BF3

HL1

SB2

BT1

101

102

KM1

SB3

BT2

103

104

KM2

SB4

BT3

105

106

KM3

Hyper
hasting
indicator

Hyper
hasting
indicator

Forward
hasting

Forward
hasting
indicator

Forward
hasting

Forward
hasting
indicator

RV0.5-0.75A

RV0.5-0.75A

6. 常见问题指南 FAQ Guide

6-1 如何调节产品重量 (说明气缸各部分) How to adjust the weight of the product
(description of each part of the cylinder)

每个气缸分上下两个进气口。下进气向上移动，上进气向下移动。

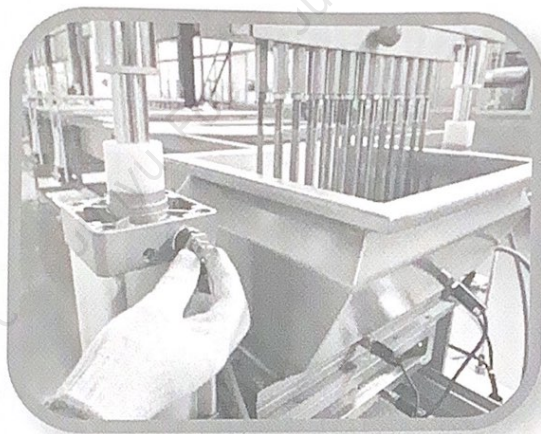
Each cylinder has two air inlets. The below one can move up, the above one can move down.

控制进气速度的方法:

The method to control the air filling speed:

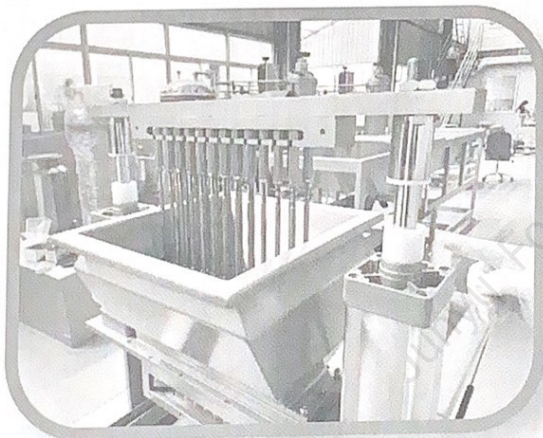
向左旋转增加上升或下降的速度，向右旋转减小上升或下降的速度

Turn left to increase the speed for up-down. Vice versa.



特氟龙垫圈可按照产品需求增加或减少。

Teflon seals can reduce the quantity or increase according to the product requirements.



踩住脚踏板后保持，气缸上升

Step on the pedal and keep it until the cylinder goes up.

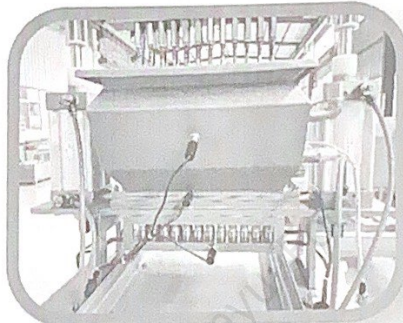
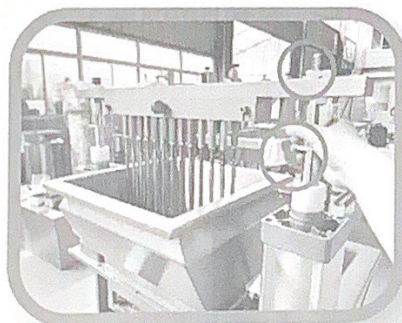


如果你想增加糖浆量，先松动上面的螺丝，然后同时向上拧动下面的螺丝，并调节直到左右相同。

If you want to increase the syrup volume, release the upper and below screw, then adjust them into the same position for the both sides.

如果你想减少糖浆量，先松动下面的螺丝，然后同时向下拧动上面的螺丝，并调节直到左右相同。

If you want to reduce the syrup volume, reduce the below screw firstly and the upper screw, then adjust them into the same position for the both sides.



6-2 个别误差如何微调 How to fine tune individual errors

Step 1 取下固定螺丝和垫片

Take off the fixed screw and gasket

Step 2 选择需要调节的冲杆，松开冲杆的固定螺丝

Pick up the plunger need to adjust, release the fixed screw

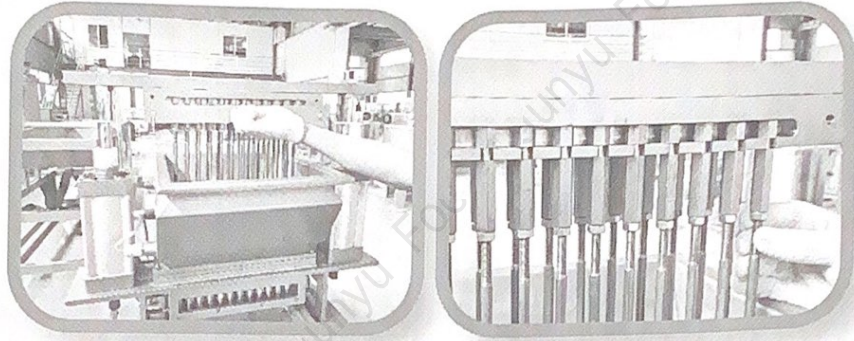
Step 3 向上旋转冲杆如果要增加糖浆量，直到相同。

If you need to increase the syrup volume, just rotate up the plunger until the same position for the both sides.

Step 4 向下旋转冲杆如果要减少糖浆量，直到相同。

If you need to reduce the syrup volume, just rotate down the plunger until the same

position for the both sides.



Tip: 可使用水代替糖浆在调试时

Tip: The water is acceptable when testing the machine.

6-2 如何设定温度 How to set the temperature



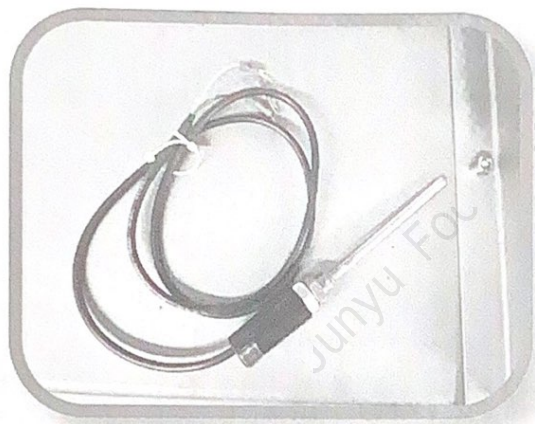
6-4 温度显示乱跳 / 闪动的原因 The reason for the temperature display jumping/flashing

Poor contact of thermostat/damaged thermostat/water immersion of thermostat

6-5 电控柜内温度模块自动关闭的原因 Reasons for automatic shutdown of the temperature module in the electronic control cabinet

Poor contact of thermostat/damaged thermostat/water immersion of thermostat

6-6 温度探头的更换接线 Temperature probe replacement wiring



6-7 当有漏气的声音, 请检查气管, 如有接触不良或者气管已经损坏, 及时拧紧或更换。
When there is a sound of air leakage, check inadequate or damaged pipe contact, then tighten the connector or replace the pipe.

6-8 气管如何插拔? How to insert and remove pipe?

插入: 气管对准接口用力插入

拔出: 向里按压然后向外拔出

Insert: the pipe is inserted forcefully into the pipe interface

Remove: first press in pipe and then pull out

6-9 气管漏气的解决办法 Solutions for air pipe leaks

更换气管。

Replace the air pipe

7. 设备日常维护 Equipment daily maintenance

清洗 clean out

气动部分，二联件需要润滑油维护，其它部分只需保持整洁即可。

For pneumatic parts, such as two connection pieces need to be maintained by the lubricating oil, other parts should be kept clean only.

使用中应定期检查气缸各部分有无异常现象，发现问题及时处理。

You need to check each part of cylinder regularly. If there is any problem, pls solve it in time.

检查各连接部分有无松动等，轴销式安装的汽缸活动部位应定期加润滑油。

Check whether each connection parts are loose or not. Add lubricating oil regularly to flexible parts of cylinder.

汽缸正常工作条件：工作压力应在 0.4~0.6Mpa 之间，普通气缸运动速度范围是 50~500mm/s，环境温度控制在常温。在低温情况下，需采取防冻措施，防止系统内的水分被冻结。

Normal operating conditions of cylinder: working pressure should in the range from 0.4 MPa to 0.6 MPa, common working speed of cylinder should between 50mm/s to 500mm/s. The ambient temperature is controlled at room temperature. Under circumstance of low temperature, take anti-freezing measures to prevent water from being frozen in the system.

当气缸检查需要重新装配时，应清理元件，确保没有将脏物带入汽缸内。特别注意防止密封圈被剪切、损害和注意动密封圈的安装方向。

When cylinder needs to be reassembled, you should clean up element, and make sure that no dirty brought into cylinder. Pay special attention to prevent the sealing ring from shearing and damage and pay attention to the installation direction of the sealing ring.

气缸拆下的零部件长时间不使用时，所有加工表面涂防锈油，进排气口应加防尘堵塞。

When the parts removed by the cylinder are not used for a long time, all the processed surfaces should be coated with rustproof grease, and the inlet and exhaust ports should be added with dust-proof plugging.

制定出气缸的月、季、年的维护保养制度。

Specify the cylinder maintenance system by month, season and year.

运动部件的润滑 The lubrication of the moving parts

本设备有减速机，链条等运动部件，为了这些部件的正常运行，请按规定对它们进行润滑。

This equipment has speed reducer, chain and other moving parts. For the normal operation of these parts, please lubricate them according to the regulations.

备注 NOTE: (确认下各自情况)

1. 本机器总耗能约为 18kW, 连接方式为三相五线制。

The machine total power is about 18kW, connected for a three-phase five-wire system.

2. 三相电缆要求: 大于 10mm² 铜芯或大于 16 mm² 铝芯线。

Three-phase cable requirements: greater than 10mm² Cu or greater than 16 mm² aluminum wire.

罐体系统可直接打膨胀螺丝于地面上固定。由于本身较重可直接置于地面, 但要求地面平整, 如果地面水平面不平, 则需用三角形垫铁对机器垫平。

The tank devices can be directly fixed in the ground by expansion screws. Because it is heavy, it can be placed directly on the ground, it has a good stability. But the ground requires smooth. If not, you need to use something to level up.

浇注机可直接置于地面, 由于本机器较重, 采用直接放置。要求地面平整, 如果地面不能保证平整度则需要采用三角形的垫铁垫平。另外要求电机座及机座底部与地面接触部分采用 10mm 橡胶垫起, 防止冲洗地板的水会腐蚀机座以延长机器的寿命。

Depositing machine can be directly fixed in the ground But the ground requires smooth. If not, you need to use something to level up. The best is use 10mm rubber blanket under the motor and machine base, that can prevent water corrosion the machines, and prolong the life of the machines.

9. 售后电话以及信息 After-sales contacts

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