

# **NJP-C Series**



## **全自動膠囊充填機說明書**

**MANUAL BOOK**

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## **Operation Instruction**

Before using this machine, be sure to read this manual, detailed knowledge of every aspect of the equipment used, and pay special attention to the following "Safe Practices" and "Emergency Disposal plan" to ensure the safety of the operator and avoid the machine damaging.

1.1 Arrange professional full-time staff to operate and maintain. The operator must have the appropriate quality, the use of methods and strict compliance with safety regulations after a basic understanding of the operating instructions, and do routine maintenance work.

1.2 Please read the operating instructions carefully before using the device and pay attention to warning signs affixed to the machine.

1.3 Do not install the equipment in the heat, humidity, vibration, strong, easy to make a collision or flammable place.

1.4 Before using the device according to the machine ground signs indicating access to the ground.

1.5 To confirm the voltage of power supply must meet the specifications of the machine and kept within safe limits.

1.6 Keep the device electrical box door closed to prevent moisture or dust particles flying into the cause short circuit, and the timing of the electrical box in the dust to clean up (Must be powered off before cleaning).

1.7 If there is an abnormal state of electrical equipment, it must be handled by a professional electrical engineer.

1.8 In any state of the device during the warranty period, without our authorization, non-professional mechanical engineers do not mobilize any machine components, otherwise the company will not be free warranty.

1.9 While the machine is running, if any abnormal condition or unusual sounds, immediately press the emergency stop button. Without professional maintenance staff, please call our service telephone **0086 25 5621 6295** or **service@hanyoo-china.com** for assistance.

1.10 When the machine daily cleaning, maintenance, repair or replacement of the mold parts, make sure the power is off.

1.11 Follow this specification, "Routine Maintenance" section of the machine for maintenance, if not in accordance with these instructions to perform routine maintenance on equipment and cause damage to parts of the warranty period, the company will not be free warranty.

## General Description

NJP-C series of fully automatic hard capsule filling machine are a new generation machine, featuring human-machine interface, PLC, sound sealing, variable-frequency stepless speed adjustment, easy operation, high ratio of capsule mount, precise dosage, low energy consumption, high yield, product standardization and serialization. The main technical parameters lead the trade in China. With different specifications of mould, No. 00 to No. 5 hard capsules and safety capsules A, B, C, D, E can be filled. Both slow-released pellets fill and mixed fill with powder and pellets can be realized.

## Technical Parameter

Model	200C	400C	800C	1200C
Output (pcs/min)	200	400	800	1200
Bore Number	2	3	6	9
Capsule Size	#00-#4	#00-#4	#00-#4	#00-#4
Power (KW)	3	3	4	5
Weight (KG)	600	700	800	900
Size (mm)	610×670×1600	730×950×1700	700×900×1800	800×1000×1800

### 3.1 Water Requirement

Adopting liquid ring vacuum pump and recycled water tank, exterior water supply may also be used. Vacuum: -0.02~-0.06 MPa, flow rate: 250 L/h, water pressure: 0.0012~0.0015 MPa, inner diameter of incoming pipe: 15 mm, inner diameter of drainpipe: 20 mm.

### 3.2 Working Environment

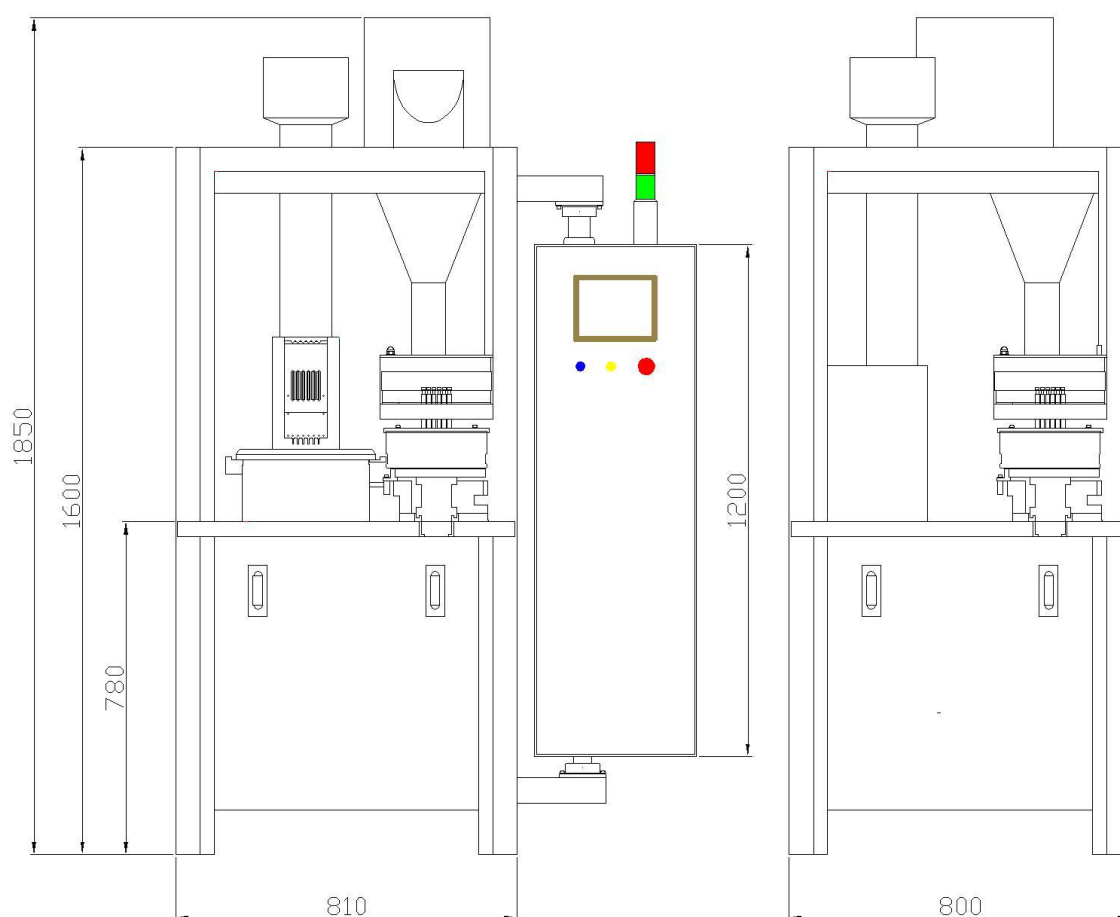
Temperature:  $21^{\circ}\text{C} \pm 3^{\circ}\text{C}$     Relative humidity: 40~55%

### 3.3 Air Requirement

Industrial suction machine with  $160\text{ m}^3/\text{h}$  exhaust capacity is needed to collect defect capsule and residual medicine powder.

In order to make your work environment better, we recommend that your suction machine and recycled water tank should be installed in a work-isolated room.

### 3.4 Machine Size



Fig(1) Machine Size

## **Installation & Ground Requirement**

The machine shall be installed on level ground of adequate bearing capacity. Should the machine be installed upstairs, the bearing ability of the floor shall not be lower than 800 kg/m<sup>2</sup>. Rubber cushion shall be installed to resist shock. The bench of the machine shall be adjusted to horizontal level with level instrument.

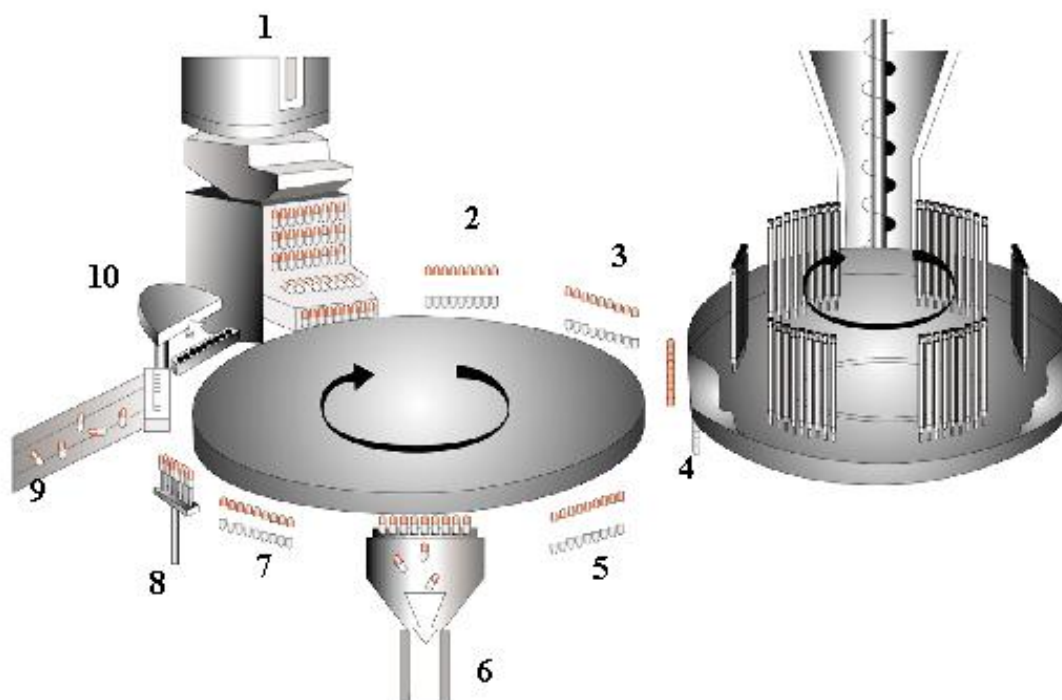
Further check: manually rotate the machine for some rotations and lubricate every part in accordance with relevant stipulation.

To prevent contamination, carefully clean all parts that directly contact the medicine with alcohol.

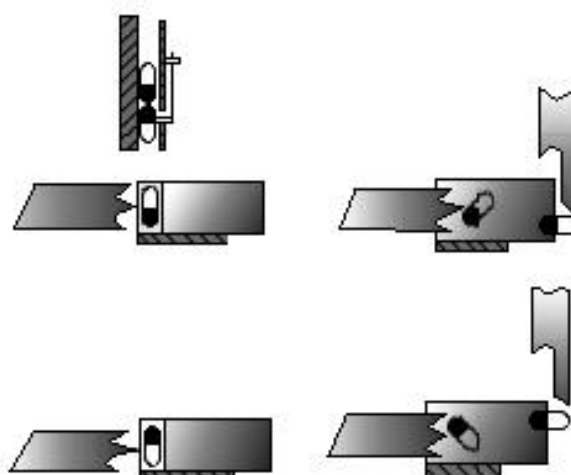
Do not turn on the power switch unless you make sure the voltage and frequency are suitable for this machine. Since frequency converter controls motor of machine, the Revolving Platform is always rotating clockwise. Check whether the rotational direction of dust collector is identical to the mark, if the direction is wrong, exchange the two wires of power supply. The vacuum pump, dust collector and mix motor are identical in the inner line.

## Working Principle

NJP-C fully automatic hard capsule filling machine varies its output by varying die assembly (quantity of die hole).

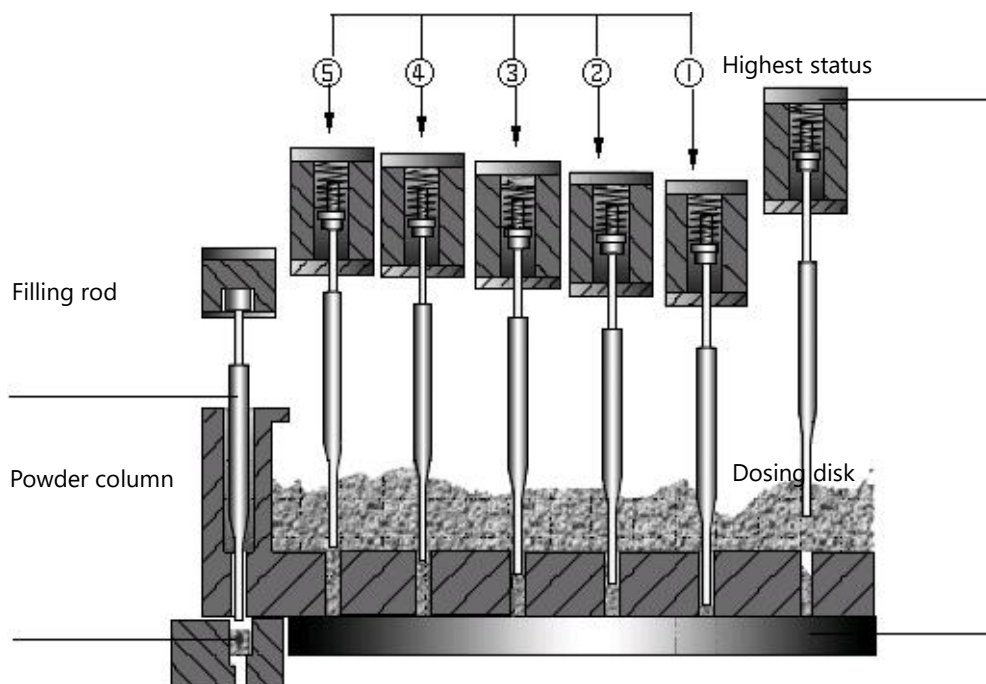


Fig(2) Operation Route



Fig(3) Capsule Turning Course





Fig(4) Powder Filling Station

Station 1: cap and body splitting

Station 4: powder column filling

Station 5: pellet and tablet filling

Station 6: defect capsule cleaning

Station 8: joining

Station 9: lead-out of joined capsules

Station 10: die hole cleaning

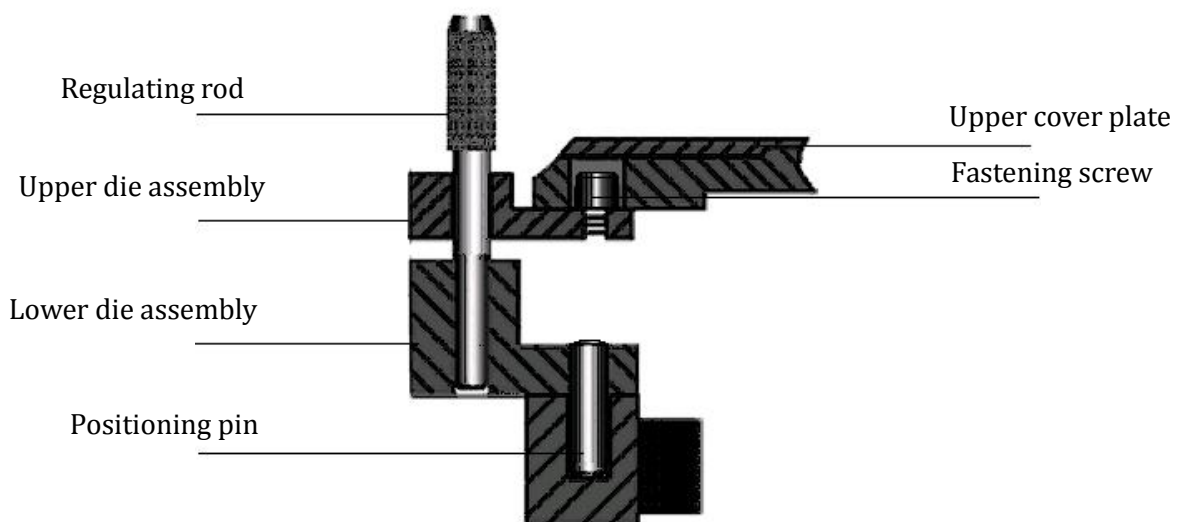
## Operation Instruction

### 6.1 Mold Changing

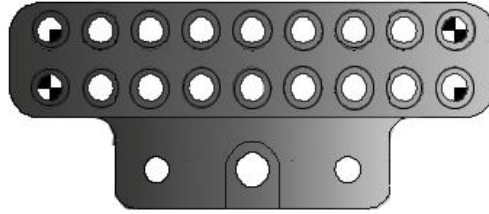
To change the size of capsule, replace corresponding upper and lower die assemblies, capsule feeding plate, horizontal fork, vertical fork, straightener, filling rod and dosing disk.



#### 6.11 Filling Die Replacement

Loosen the fastening screws of upper cover plate of revolving platform and remove the upper cover plate, loosen and remove fastening screws on the upper and lower die assemblies and take out the two die assemblies. Then install the lower die assembly of another specification; align two positioning holes with two column pins of T-type axle and tighten screws. Then install the upper die assembly; insert the regulating rod of each pair of upper and lower die assemblies in the two holes at the outside respectively at Station 8 to regulate their concentricity; then tighten the screws. Make sure the regulating rod rotates freely in the holes of upper and lower die assemblies. Caution: Move the arbor wheel of the main motor with hand shrank in replacing the die assembly and rotate the revolving platform. Remove the regulating rod before rotating!



Fig(5) Centering the Die Assembly

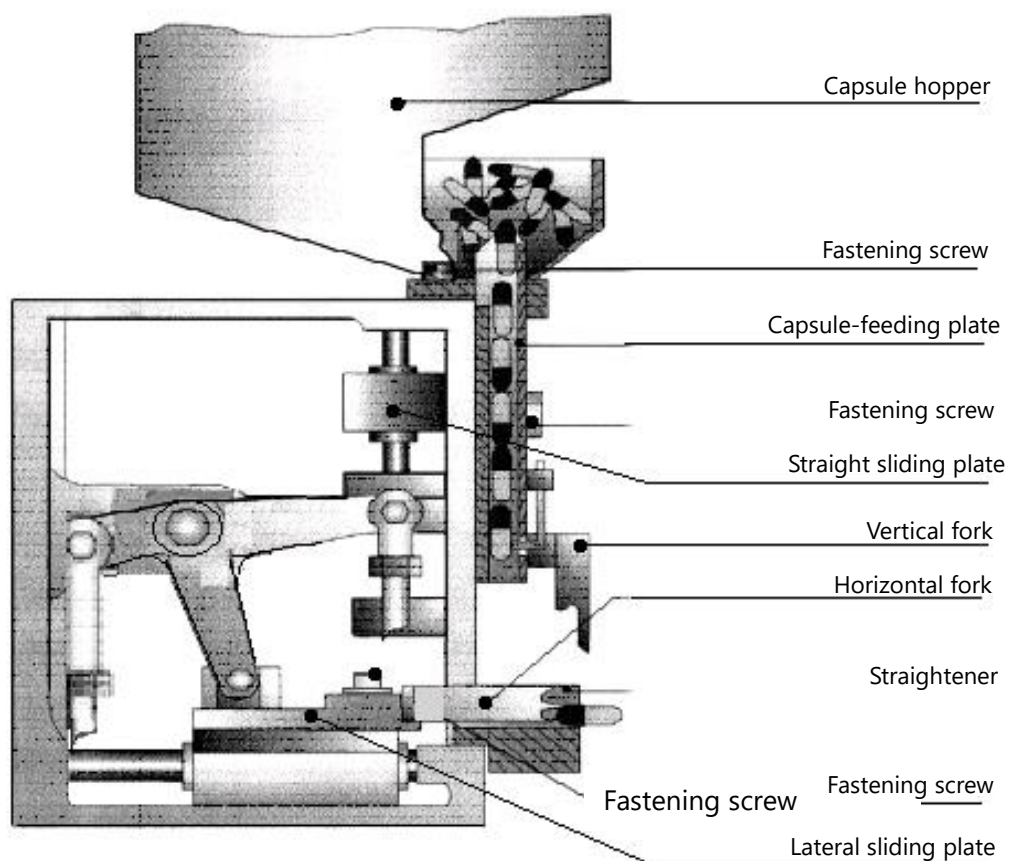


“” and “” means regulating rod insert adjustment

Fig(6) Regulating Rod Adjustment

## 6.12 Capsule Loading Installation & Replacement

- (1) Align two positioning holes of straightener with the pins of casing, and tighten the screw;
- (2) Align two grooves of horizontal fork with the pin of lateral sliding plate and install on the sliding plate; adjust to feeding capsule to the optimum position and tighten screw (generally feed the body of capsule to the outer end surface of straightener);
- (3) Align two positioning holes of capsule-feeding plate and rear plate with the pin of straight sliding plate, and tighten screw;
- (4) Install capsule hopper and tighten screw (make sure the clearance around square groove and capsule-feeding plate should be uniform);
- (5) After replacing capsule feeding parts, put some empty capsules in the hopper and start vacuum pump, open capsule release unit, rotate the machine with hand crank to ensure normal capsule splitting.



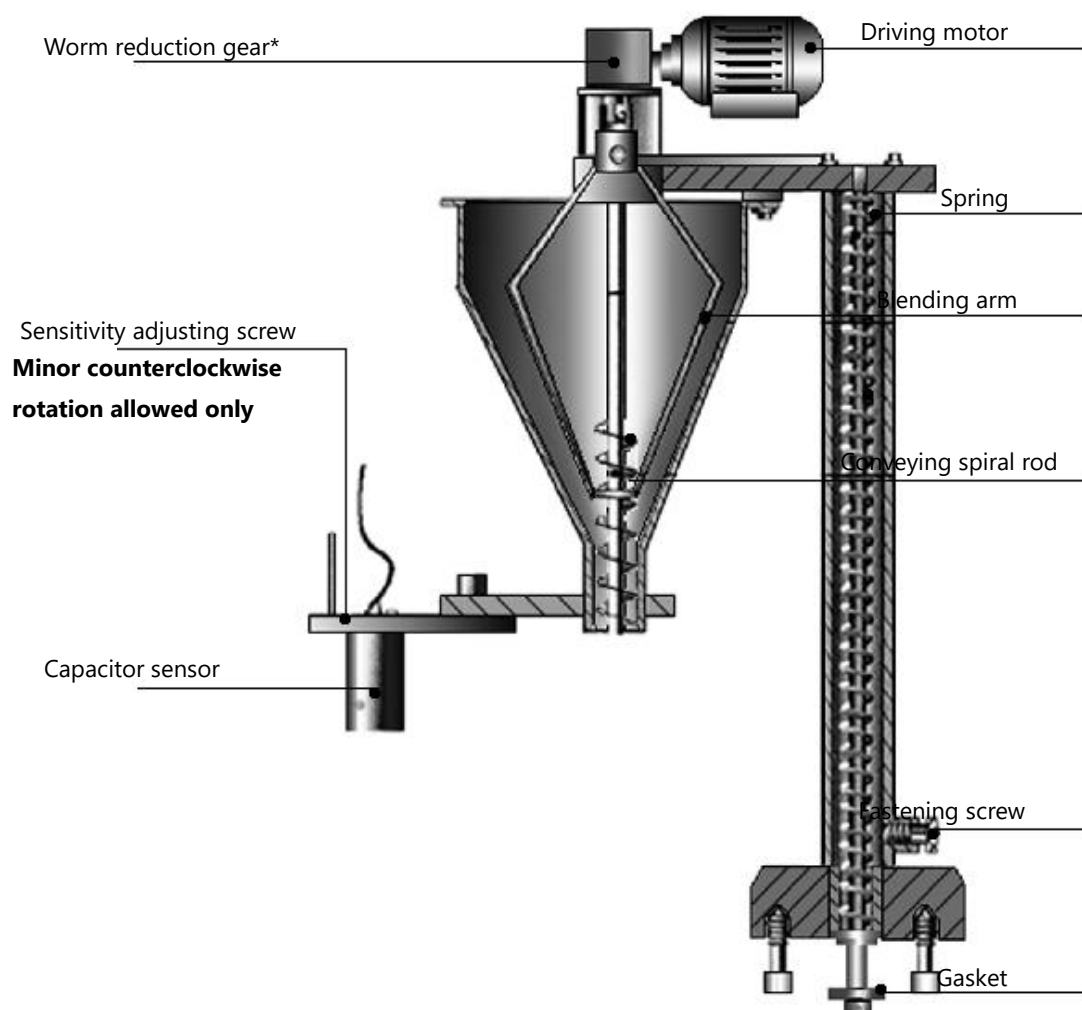
Fig(6) Capsule Loading Mechanism



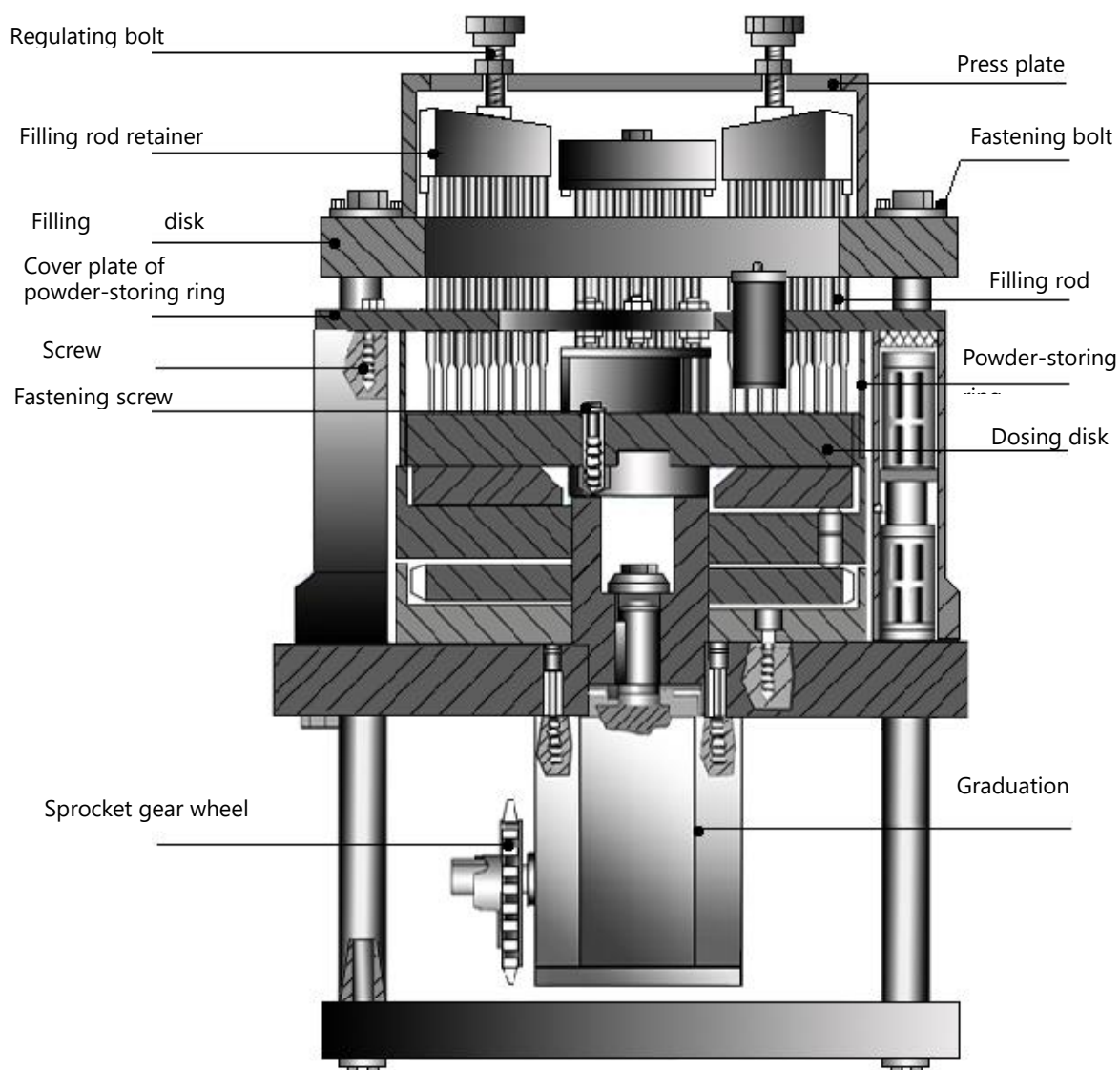
Fig(7) Straightener

### 6.13 Dosing Disk & Filling Rod Replacement

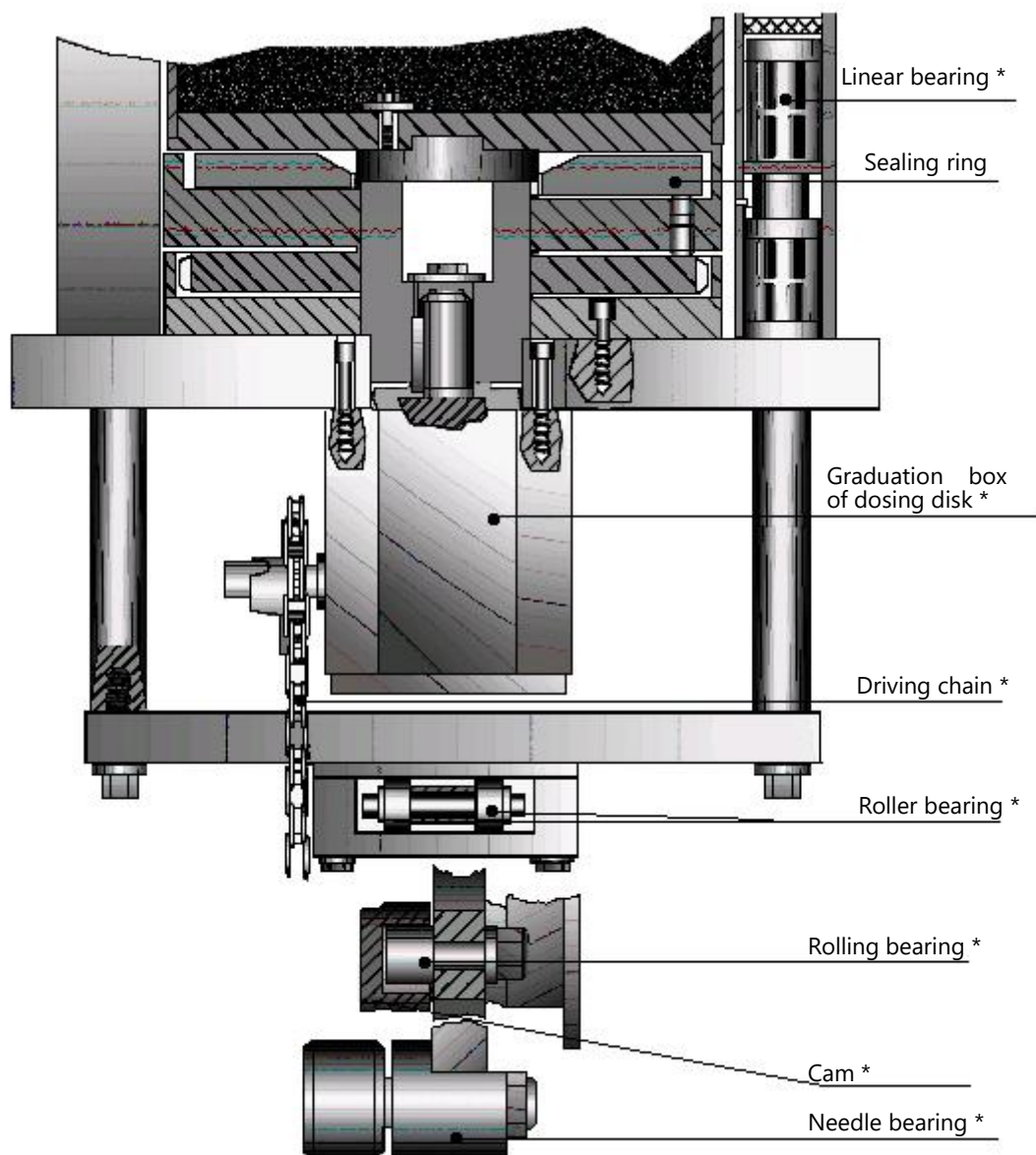
- (1) Loosen fastening screws and raise powder hopper by the resilience of spring; (refer to Fig. 9)
- (2) Absorb residual power in power-store ring with dust collector;
- (3) Rotate the arbor wheel of main motor with hand crank until the holder of filling assembly reaches the highest position;
- (4) Loosen and remove acorn nut, rotate knob clockwise (refer to Fig. 21) to uplift and remove press plate and filling retainer;
- (5) Loosen the screws on the small press plate with square hole under the retainer and remove the filling rod. After replacing the filling rod, replace the small press plate and fasten the screw;
- (6) Draw out baffle upwards, loosen two screws on both sides of powder-storing ring cover and remove baffle outside powder-storing ring, loosen four fastening screws of power-storing ring and remove the ring and cover plate from dosing disk gently from the side without removing filling rod holder;
- (7) Loosen three fastening screws of dosing disk with special wrench, remove dosing disk and powder-storing ring.
- (8) Clean the powder in the tray and replace alternate dosing disk of another specification. Do not tighten three fastening screws for the time being;
- (9) Insert two dosing disk regulating rods separately into multiple holes of filling rod holder at different positions. Gently rotate dosing disk so as to insert the regulating rod easily, carefully tighten three screws in turn. Should the regulating rod be unable to insert in dosing disk hole easily, you must re-adjust until the rod can be inserted easily;
- (10) Insert powder-storing ring and cover plate to the precise position from the side, rotate the machine with hand crank and fasten four screws of powder-storing ring. If newly-replaced dosing disk is thicker than the former one, lift the powder wiper correspondingly.
- (11) Fasten screws of cover plate. Carefully examine the clearance (0.05~0.1mm) between powder wiper and dosing disk with feeler gauge, then tighten fastening screws;
- (12) Install filling rod and retainer in their original positions and tighten acorn nut.



Fig(8) Feeding Mechanism



Fig(9) Dosing Station



Fig(10) Driving Mechanism of Dosing Unit



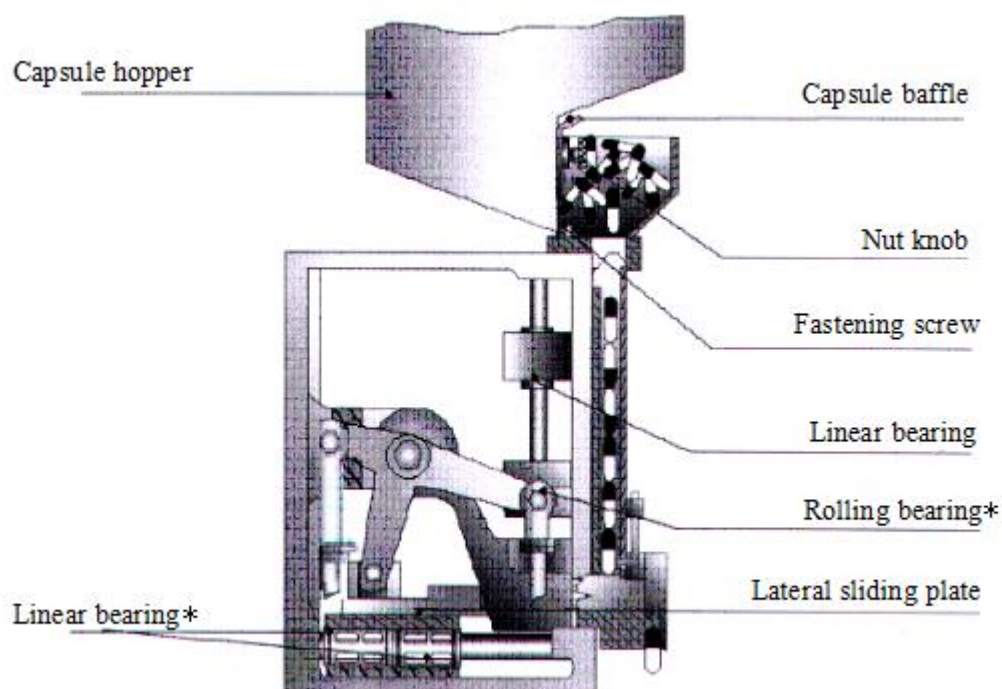
## 6.14 After Assembling Die

Whenever having replaced die assembly, make proper adjustment of the machine. First rotate arbor wheel of motor for 1~2 rotations with hand shrank. If anything abnormal happens, stop the rotation immediately and eliminate the trouble.

## 6.2 Machine Adjustment

### 6.21 Capsule Hopper Exit Adjustment

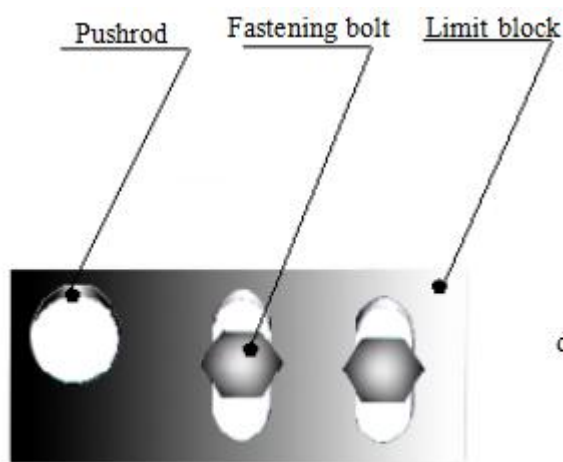
The capsule baffle installed on the hopper can control the height of capsule at the exit by loosening the fastening knob and pulling the baffle. According to the experience, the height of exit should be preferably the half of capsule height at exit.



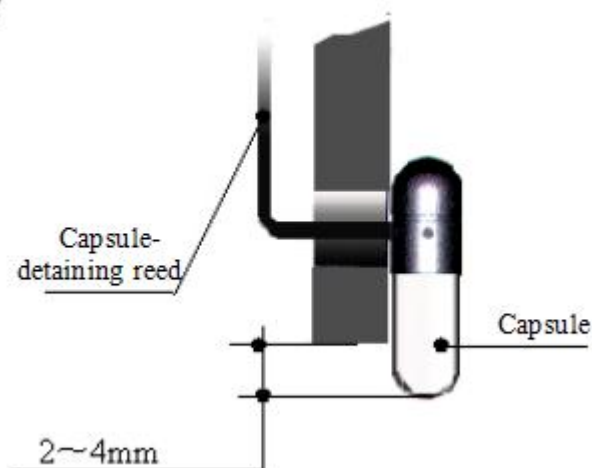
Fig(11) Capsule Loading Station

## 6.22 Capsule-Detaining Reed Adjustment

The time of opening and closing capsule-detaining reed ensures that only single capsule should be discharged out of capsule-feeding plate each time. To adjust the time, loosen the fastening bolt of limit block and move the limit block to allow only single capsule to be discharged each time. Then detain the capsule to be discharged at the position as illustrated below:



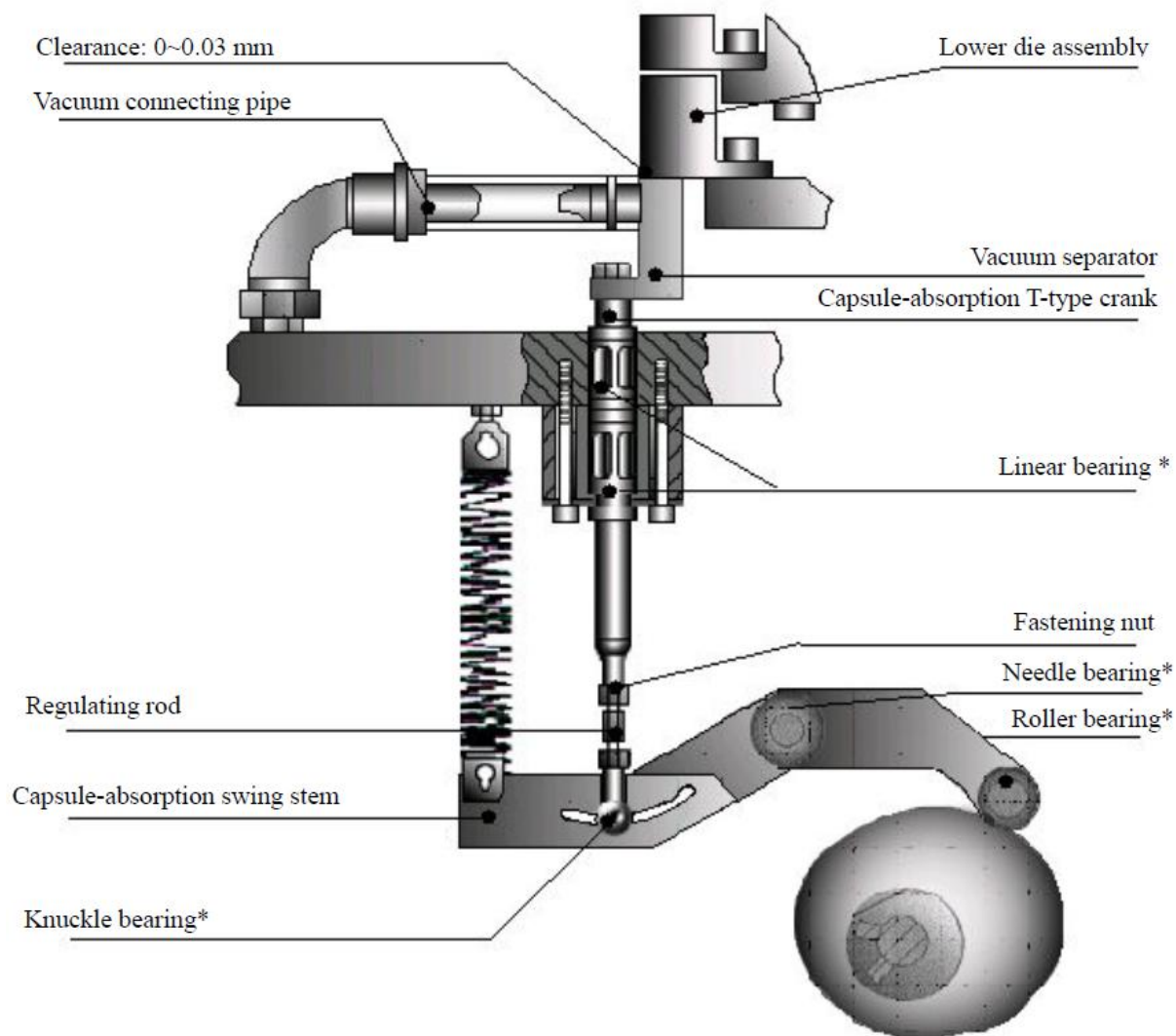
Fig(11) Limit Block



Fig(12) Capsule Detaining Reed

## 6.23 Vacuum Separator Adjustment

Whenever the machine runs by a station, vacuum separator goes upwards and downwards once. The position of vacuum separator is well regulated at factory's delivery; no adjustment is needed in most common case. Should any adjustment is needed, rotate arbor wheel of main motor with hand crank until the vacuum separator reaches the highest position, loosen fastening nuts (left and right thread) on both sides of regulating rod under machine bench, rotate regulating rod to adjust vacuum separator height (clearance between upper surface of separator and the lower surface of lower die assembly), and then fasten the nuts. Recheck for several times until proper status is met. Place empty capsules in the capsule-feeding unit and start vacuum pump, rotate machine with hand crank to verify normal capsule splitting.



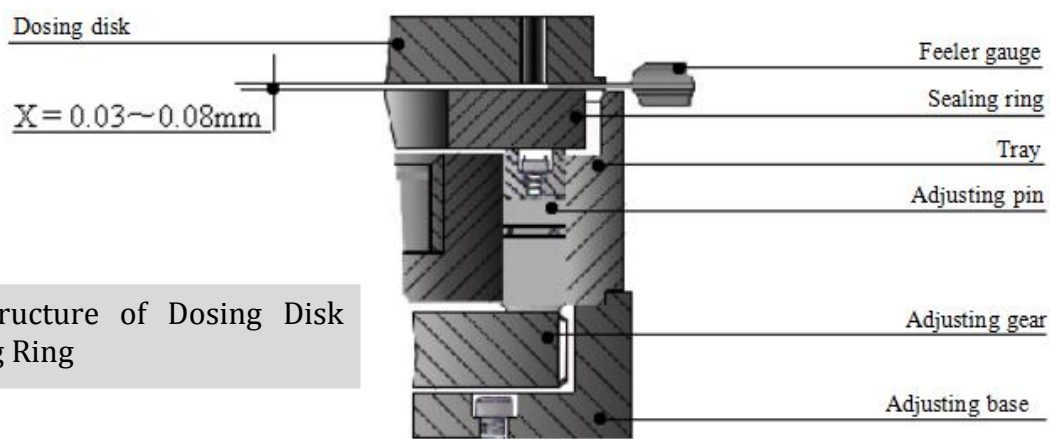
Fig(13) Vacuum Separator Height Adjustment

## 6.24 Upper & Down Die Alignment

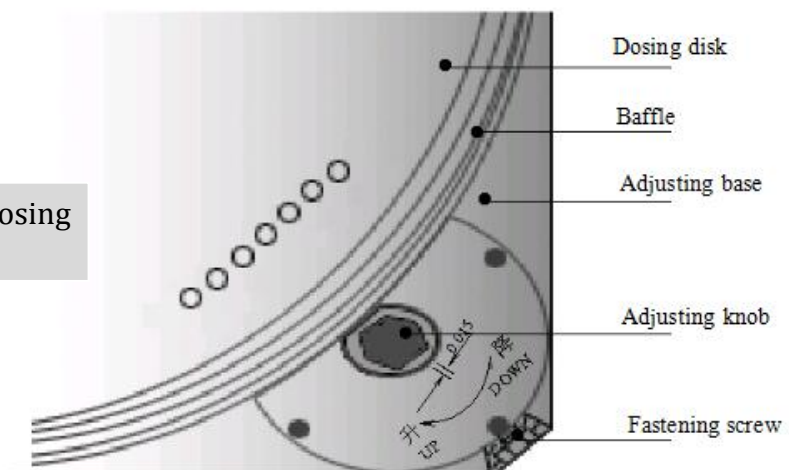
After replacing die assembly or finding the frequent occurrence of unsplit or joined caps and bodies, make sure the alignment of die assembly is adjusted as illustrated in 5.1.1.

## 6.25 Dosing Disk and Sealing Ring Adjustment

The clearance between dosing disk and sealing ring should be preferably 0.03~0.08 mm. With larger particles, the clearance may be adjusted wider. Too narrow clearance may increase the resistance between dosing disk and sealing ring. Should too much powder leakage or resistance occur in the operation, adjustment of the clearance shall be made. To adjust the clearance, draw out baffle and loosen fastening screw on adjusting base, first rotate adjusting knob counterclockwise to lower sealing ring, then rotate adjusting knob clockwise to raise sealing ring. After deciding the clearance between sealing ring and dosing disk with feeler gauge, lock the fastening screw. If sealing ring is adjusted too high, just rotate the adjusting knob counterclockwise to lower sealing ring and then rotate clockwise to raise it. Adjust from high to low shall not be allowed. The knob has a scale. Whenever you rotate one degree, sealing ring will rise by 0.015mm. After adjusting the clearance between dosing disk and sealing ring, install baffle on the tray.



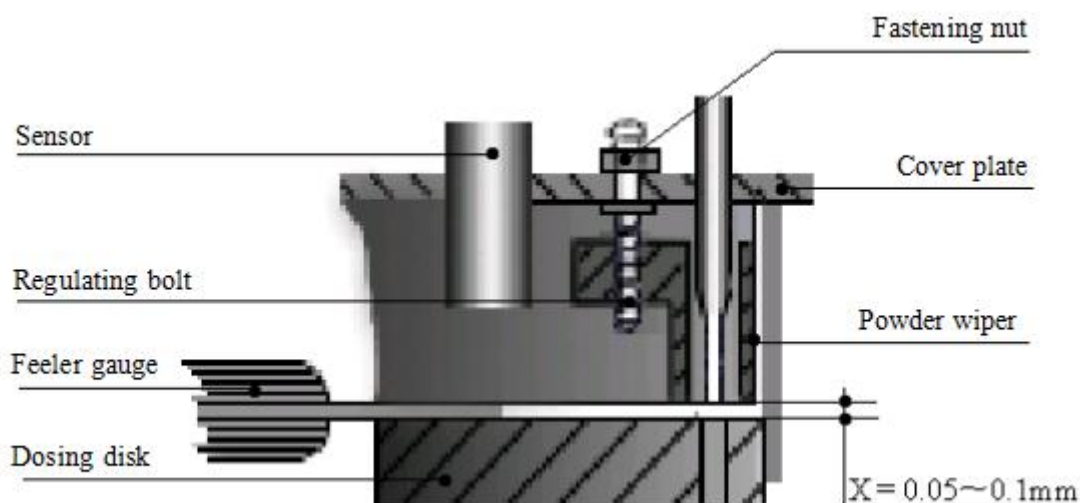
Fig(14) Structure of Dosing Disk and Sealing Ring



Fig(15) Adjusting Unit of Dosing Disk

## 6.26 Powder Wiper Clearance Adjustment

Adjust the clearance after replacing dosing disk each time. The clearance should be preferably 0.05~0.1 mm. To adjust the clearance, loosen the fastening nut and rotate adjusting screw to raise or lower the powder wiper. Measure the clearance with feeler gauge and tighten the fastening nut.

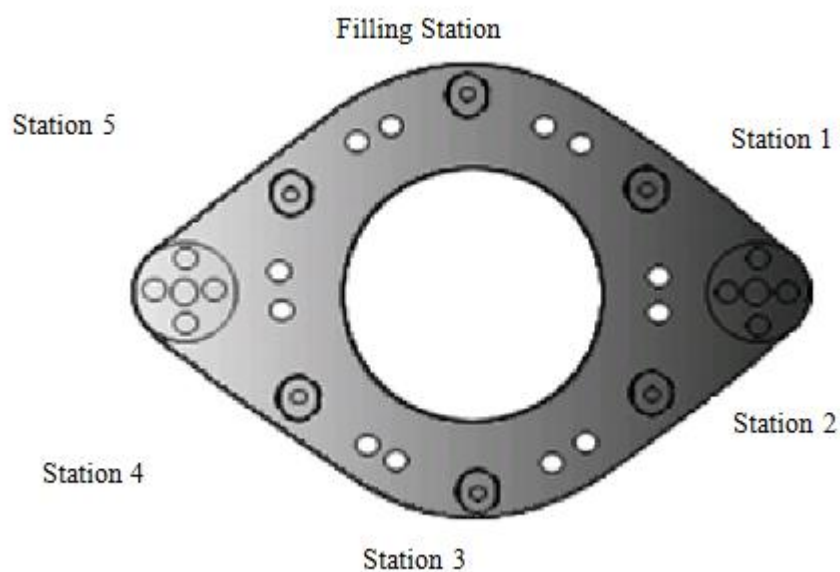


Fig(16) Clearance between Powder Wiper and Dosing Disk

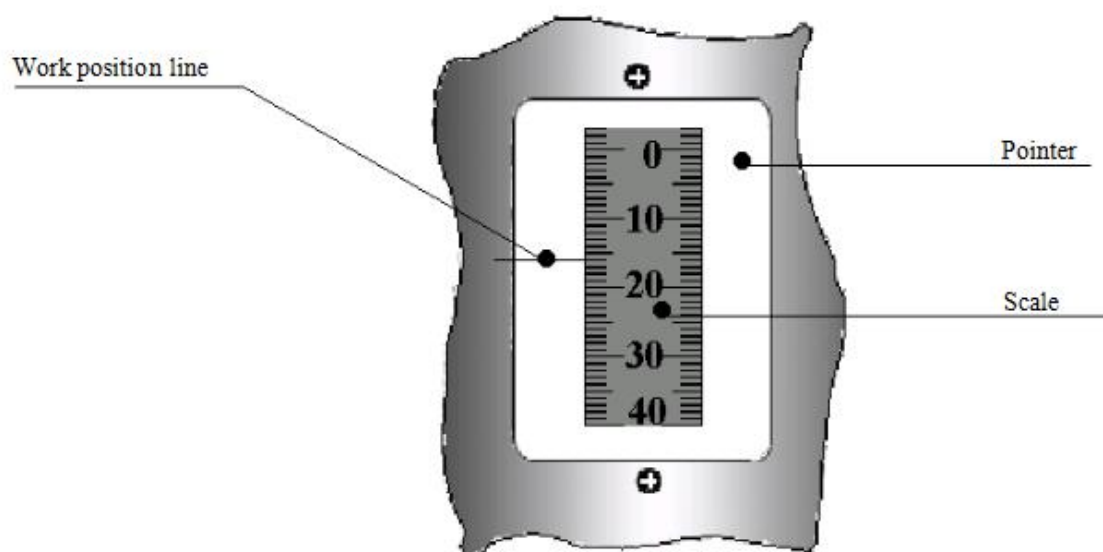
## 6.27 Filling Rod Height Adjustment

The density and volume of powder column change with the height of the filling rod. Appropriate adjustment of filling rod height leads to precise volume of powder filling. The depth that filling rod enters dosing disk may be decided upon the reference table and not be too deep. When filling rod disk holder is at the lowest position, the “0” scale line of retainer represents that the lower surface of filling rod is at the same level as the lower surface of dosing disk, i.e., the numerical reading aligned with the work position line of sight glass is the very height of the lower end surface of filling rod from sealing ring. To adjust the height, loosen the fastening screw on adjusting rod, rotate the knob on the screw stem counterclockwise so as to raise the filling rod, and then rotate the knob clockwise to lower it to desired height, finally tighten the fastening nut. That is to say, adjustment shall be made in the order from high to low. (When the thickness of dosing disk is 18mm)

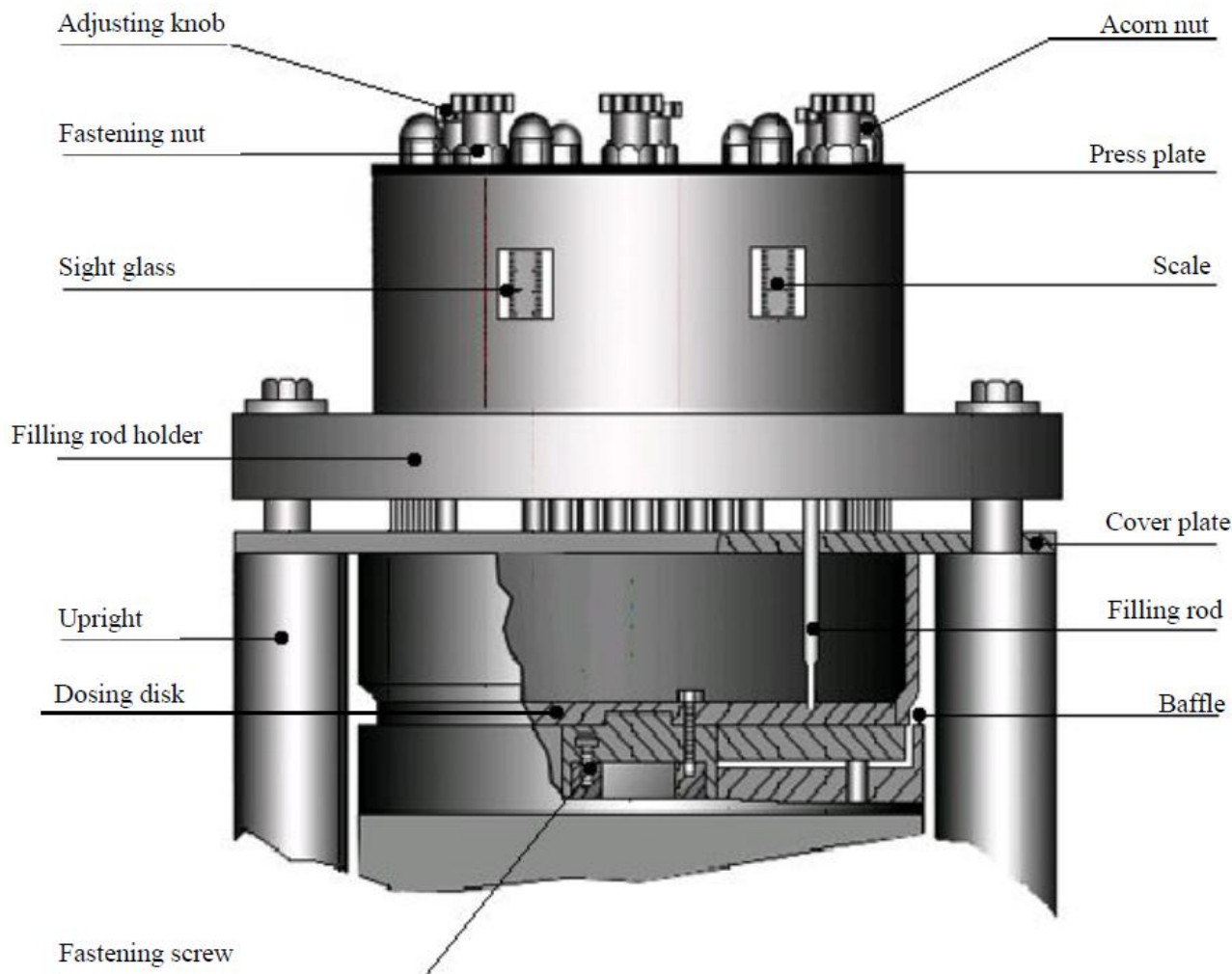
Station	1	2	3	4	5
Depth in Dosing Disk	9	- 5 - 21 -	3	2	0.5



Fig(17)Layout of Powder Filling Station



Fig(18) Scare

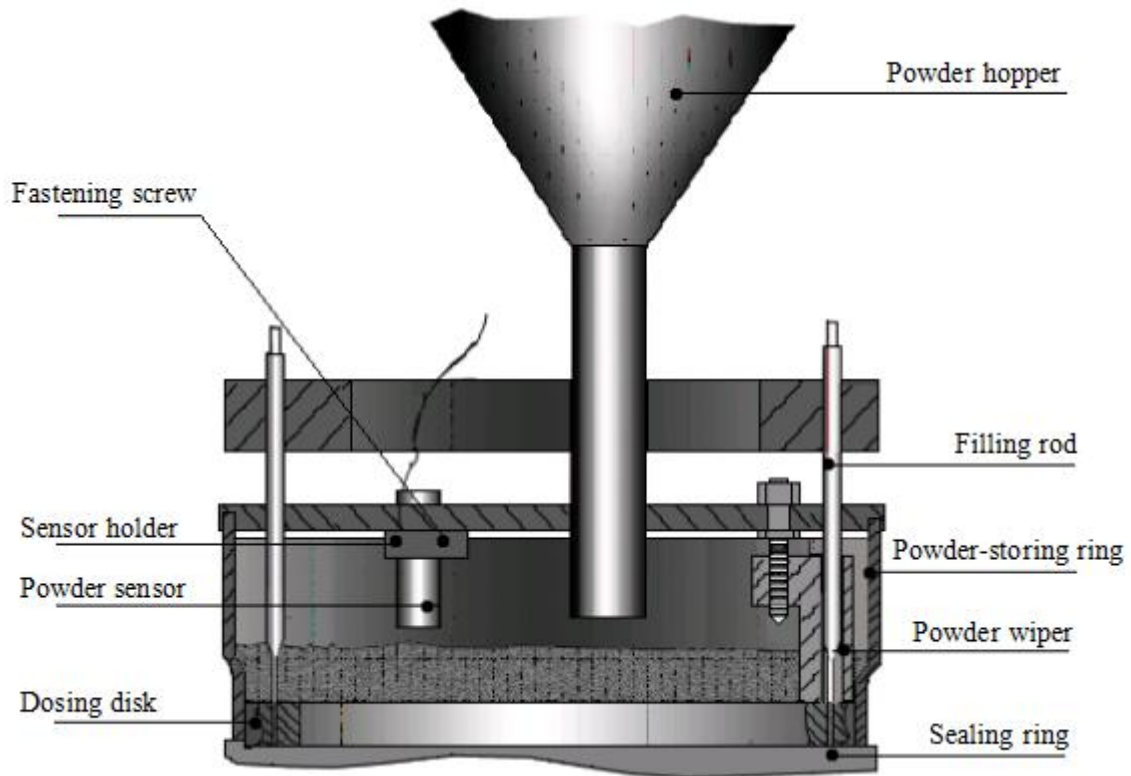


Fig(19) Filling Rod Height Adjustment

## 6.28 Powder Height Sensor Adjustment

Capacitor sensor is applied to control the height of powder in the powder-storing ring. The signal emitted by sensor controls the start and stop of feeding motor. Therefore, the height of sensor decides the height of powder in powder tank. Appropriately adjust the height of sensor according to powder specification and its flow ability to obtain precise filling volume. To adjust the height of sensor, loosen the screw on the sensor and raise or lower the sensor. After adjustment, fasten the screw. The screw in the upper part of sensor may control sensitivity. The distance between sensor and powder is 2~8mm.



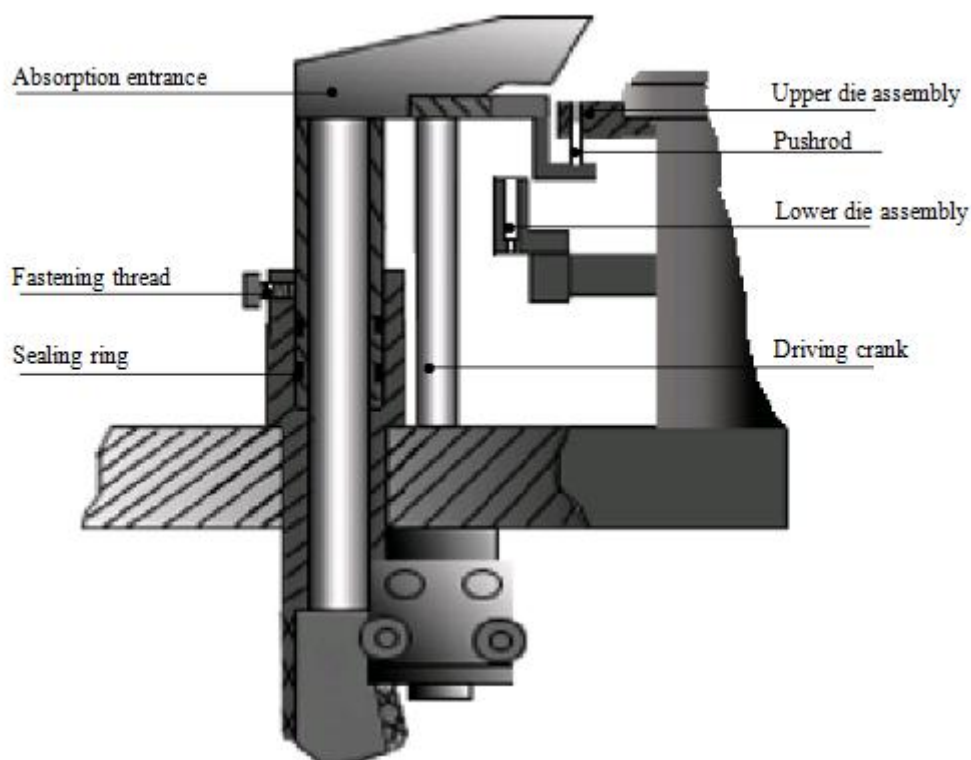


Fig(20) Powder Sensor Adjustment

## 6.29 Waste Capsule Rejection Adjustment

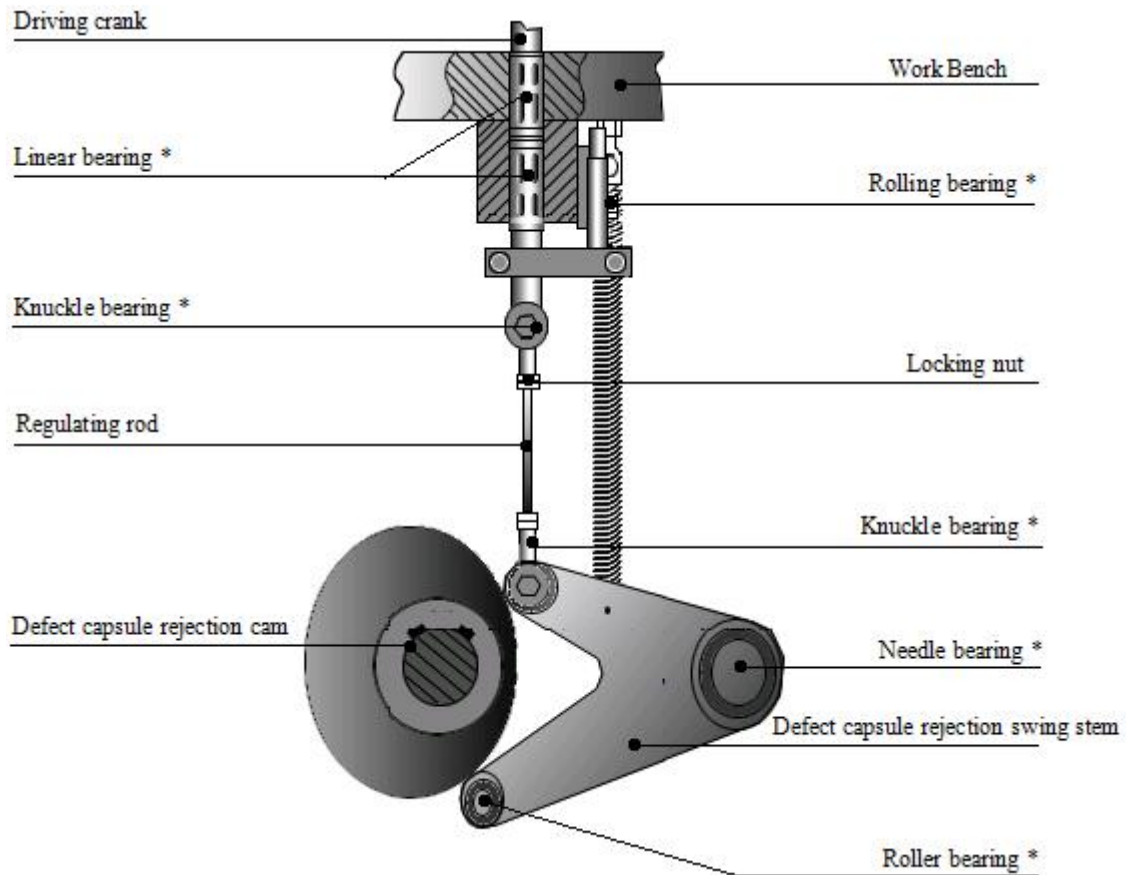
At station 6, the push rod reciprocating vertically can reject unseparated capsules in the upper die assembly. By adjusting the bolt on the cam connecting rod, the push rod reciprocating vertically can avoid bump with the upper and lower die assembly and simultaneously reject the Defect Capsules. The column pin after the adjustment should be in the center of die assembly hole. The clearance between the guider on the Defect Capsule box and the die assembly can be adjusted by adjusting the fastening screw to such a position that the die assembly will not bump into the capsule while the capsules may be smoothly led out.





Fig(21) Capsule Rejection Station

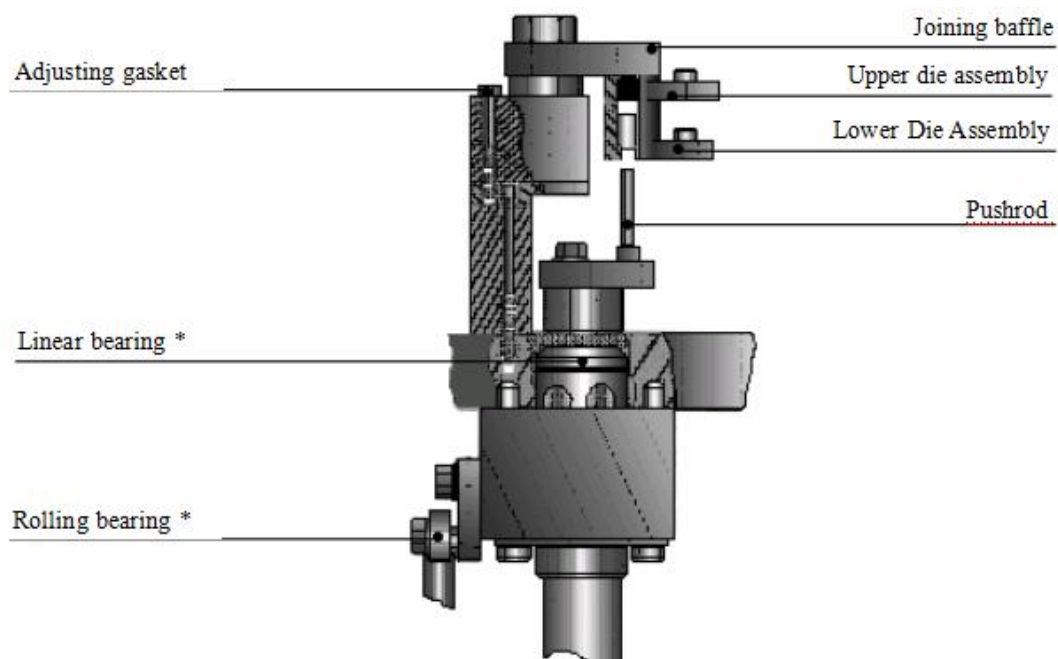
To adjust regulating rod height, loosen fastening screws on knuckle bearings on both ends of regulating rod, rotate regulating rod to adjust push rod height. Put unsplit capsule in the hole of upper die assembly at Station 6, move main motor shaft with hand crank to raise and lower the regulating rod, see to it that defect capsules are successfully absorbed, finally tighten nut. The adjustment of push rod must be careful to avoid collision between upper and lower die assemblies when push rod runs vertically.



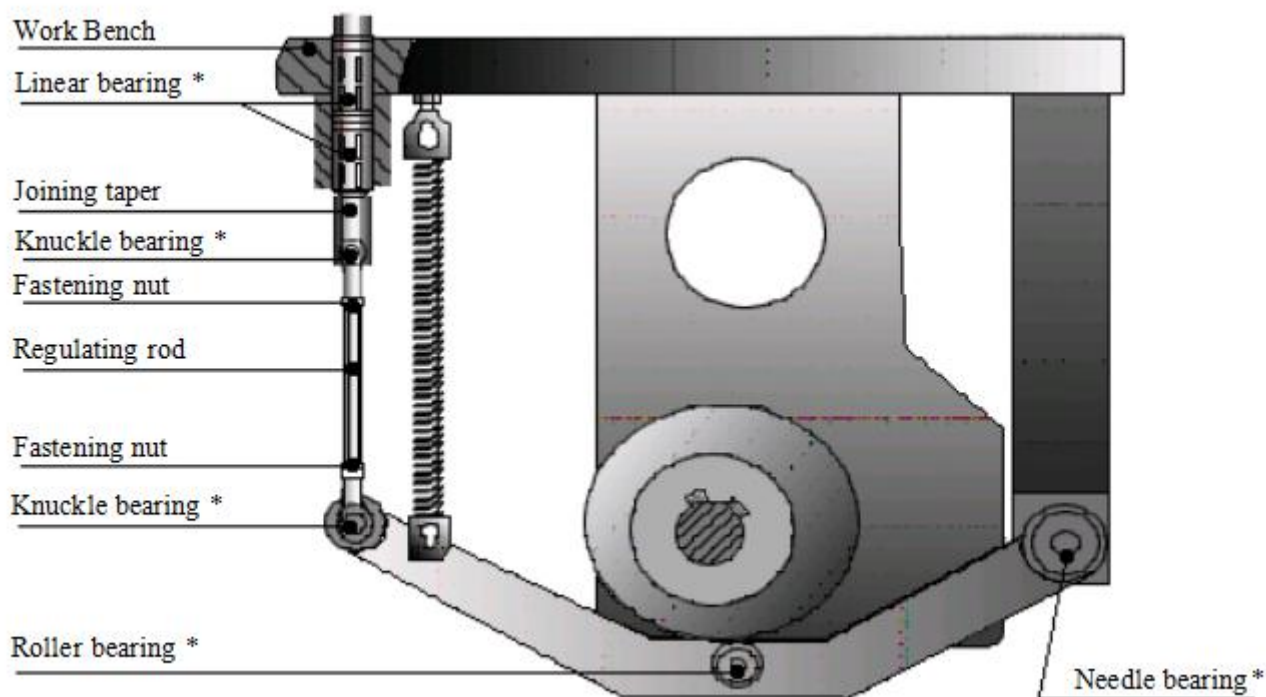
Fig(22) Capsule Rejection Driving Station

### 6.30 Capsule Locking Adjustment

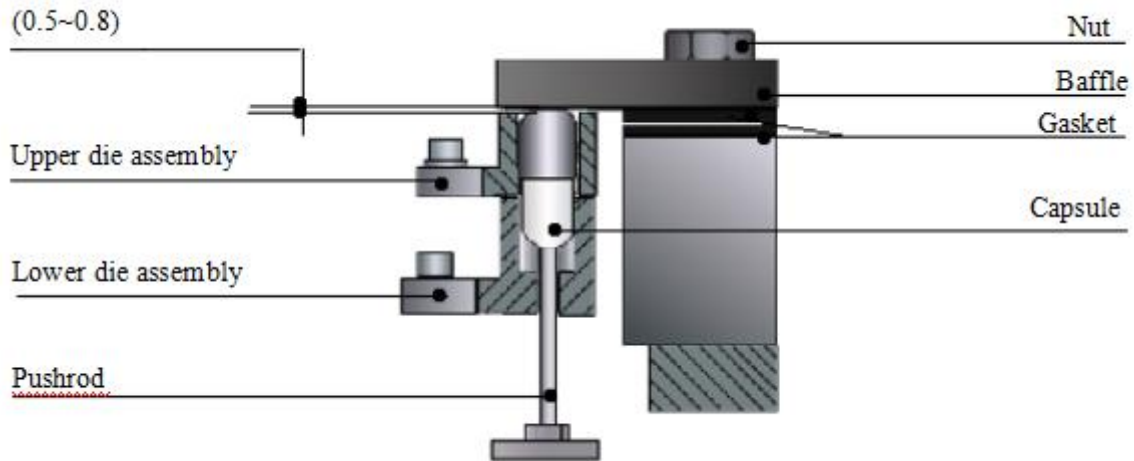
Adjustment of length of capsule joined shall be made according to the different sizes and lengths or when replacing capsule. The clearance between joining baffle and the capsule in the die assembly should be preferably 0.5~0.8 mm. The clearance can be adjusted by replacing the gaskets of different thickness. To adjust the height of push rod, place the joined capsule in the die assembly, adjust the length of bolt on the joining taper to such a position that when the push rod is at the highest position, the column pin can just contact the lower part of capsule. If joining capsule seems not normal in the course of filling, e.g., the capsule is too long to join or too short to maintain regular shape, re-adjustment shall be made carefully. After the adjustment, fasten the nut.



Fig(23) Capsule Locking Station



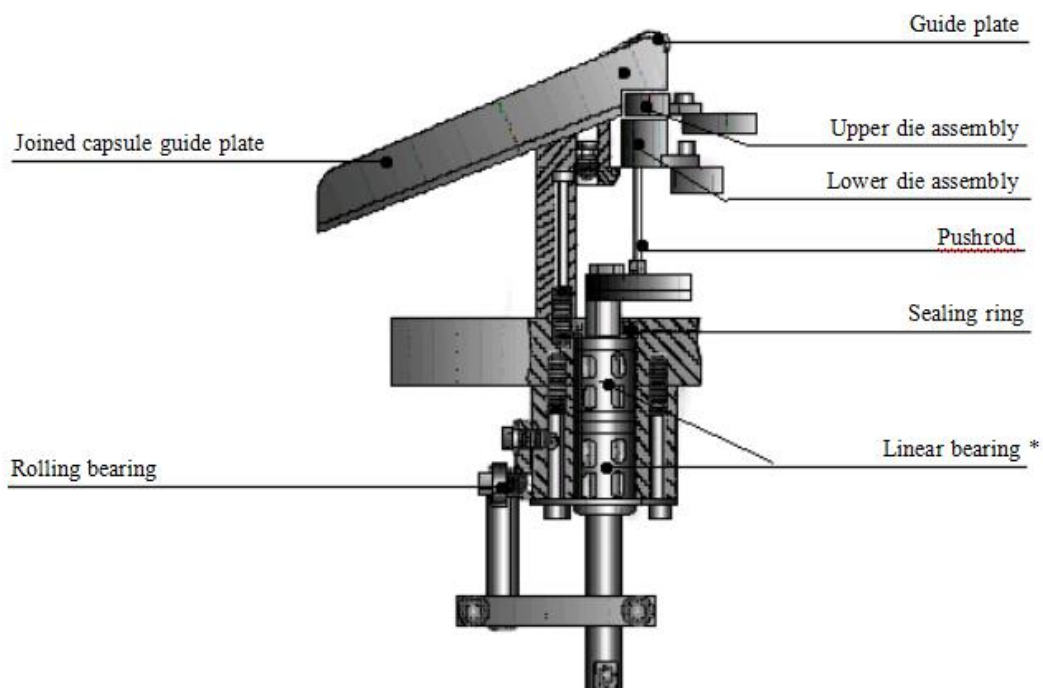
Fig(24) Locking Mechanism



Fig(25) Clearance Between Baffle and Capsule

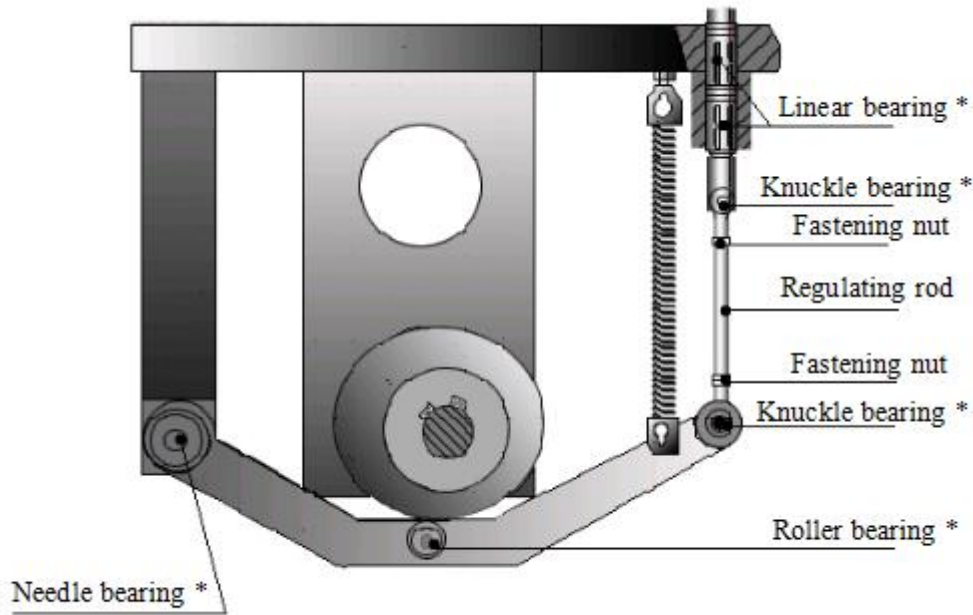
### 6.31 Output of Finished Capsules

Adjustment of lead-out unit for finished product consists of joined capsule guide plate and push rod adjustment. Joined capsule guide plate has guide grooves with the same distance as die assembly holes. Loosen fastening nut on guide plate on both sides; adjust the angle and height of guide plate so that guide grooves can align with the joined capsule that is driven out. The standard is to lead out joined capsules smoothly. Finally fasten the nut.



Fig(26) Output of Finished Capsules Station

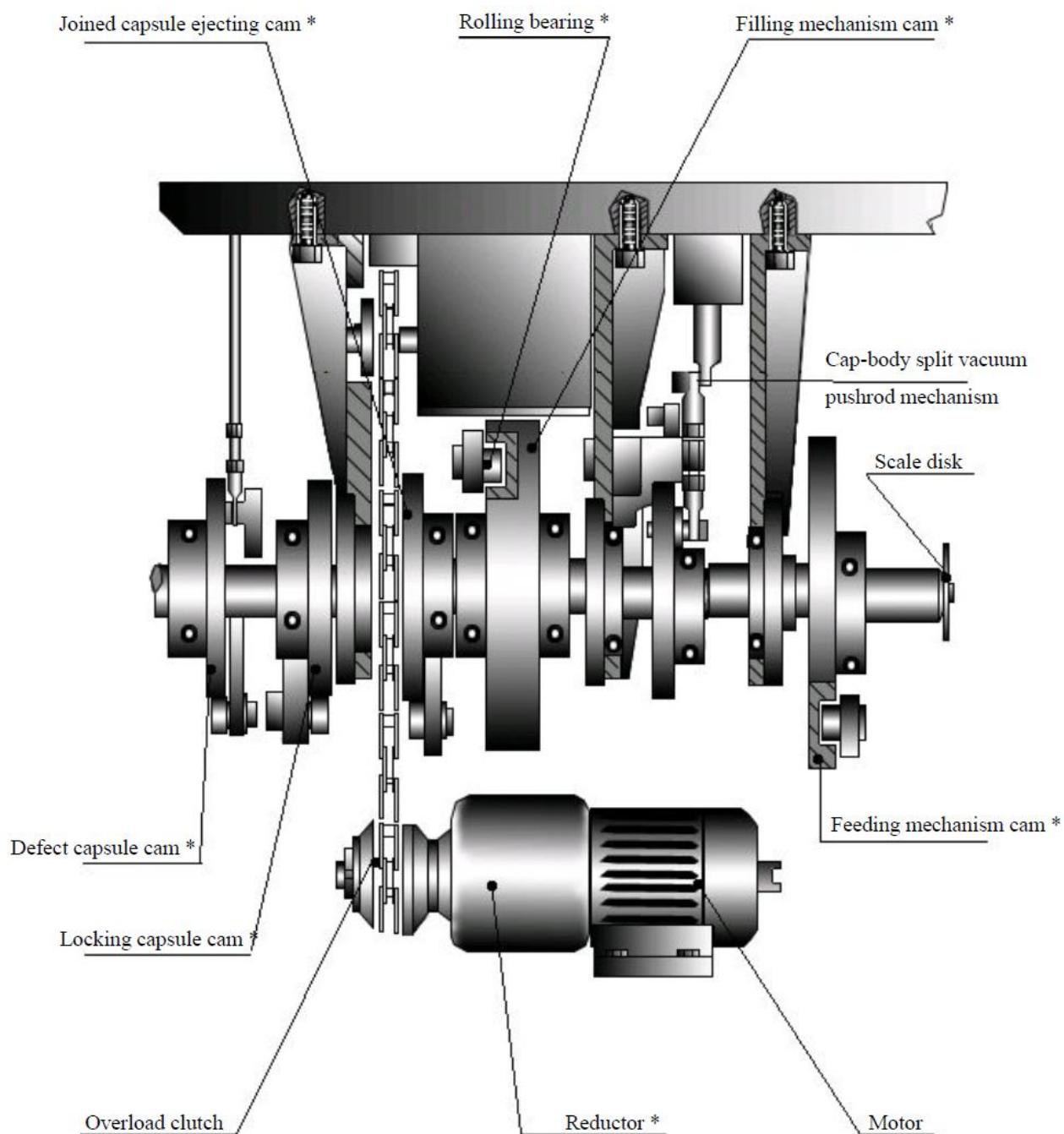
The method of adjusting joined capsule crown rod is the same as adjusting joining crown rod. As illustrated in Fig. 26 and explained in Section 5.2.10, you may adjust push rod to decide push rod height so as to eject capsules when push rod arrives at the highest position. When push rod arrives at the lowest position, the upper surface shall be lower than the lower surface of lower die assembly.



Fig(27) Output of Finished Capsules Mechanism

### 6.32 Overload Adjustment

Overload clutch is a device installed in the output end of main motor reductor. Overload clutch can protect the machine in case of overload. Overload clutch should not slip under normal load. Since slippery may occur in long-term operation, the round nut of overload clutch should be tightened to guarantee both the normal operation and protective function.



Fig(28) Transmission Gear

### 6.33 Driving Cam Adjustment

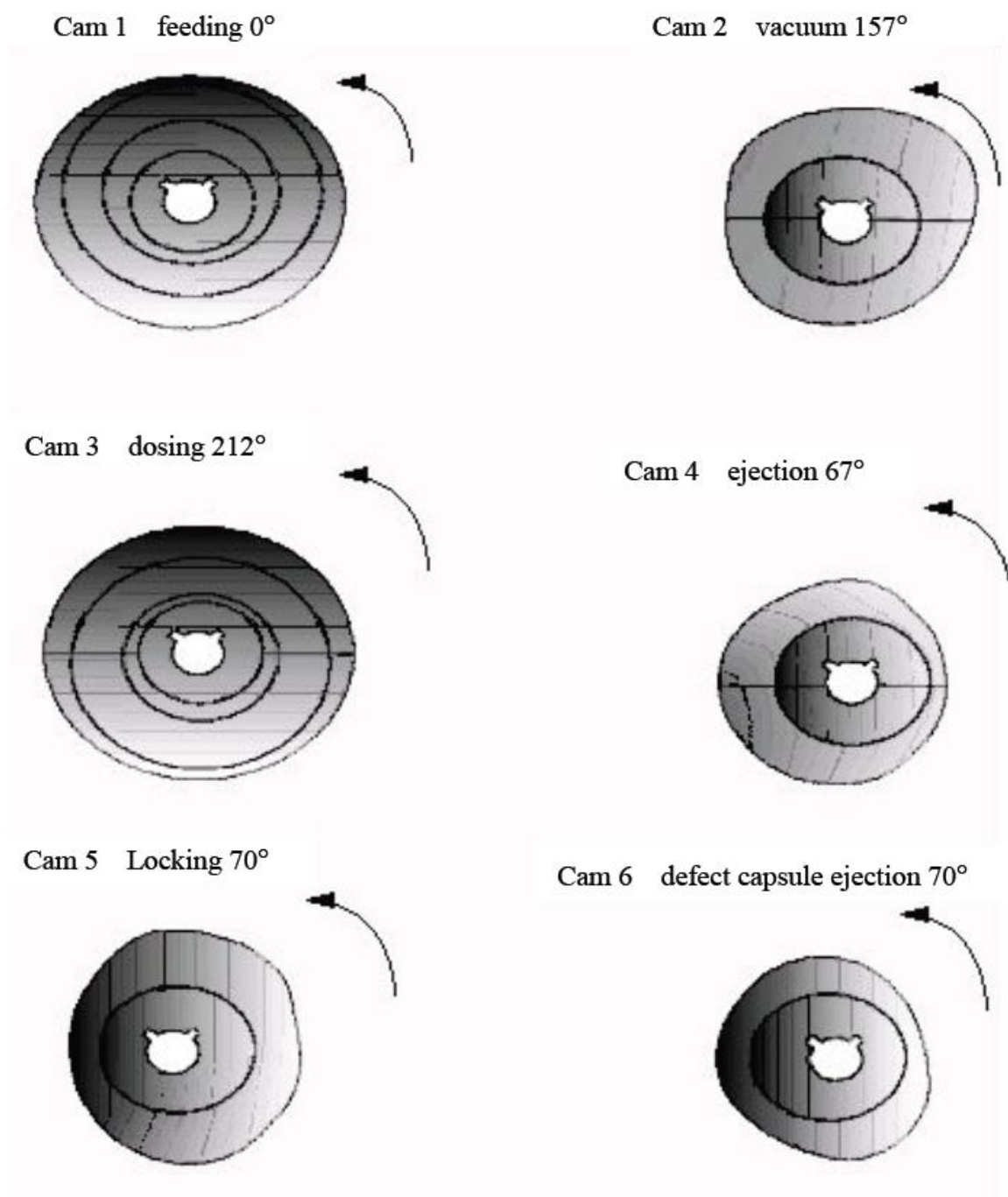
The positions of driving cam are regulated at factory before the delivery. Do not adjust these



positions in normal condition. Should adjustment be made, carefully adjust in accordance with the angle given by the Fig. 29.

### Front View of Scale Disk

When cam position is as illustrated in the following figures, the indicating angle of scale disk of main arbor is as follows:

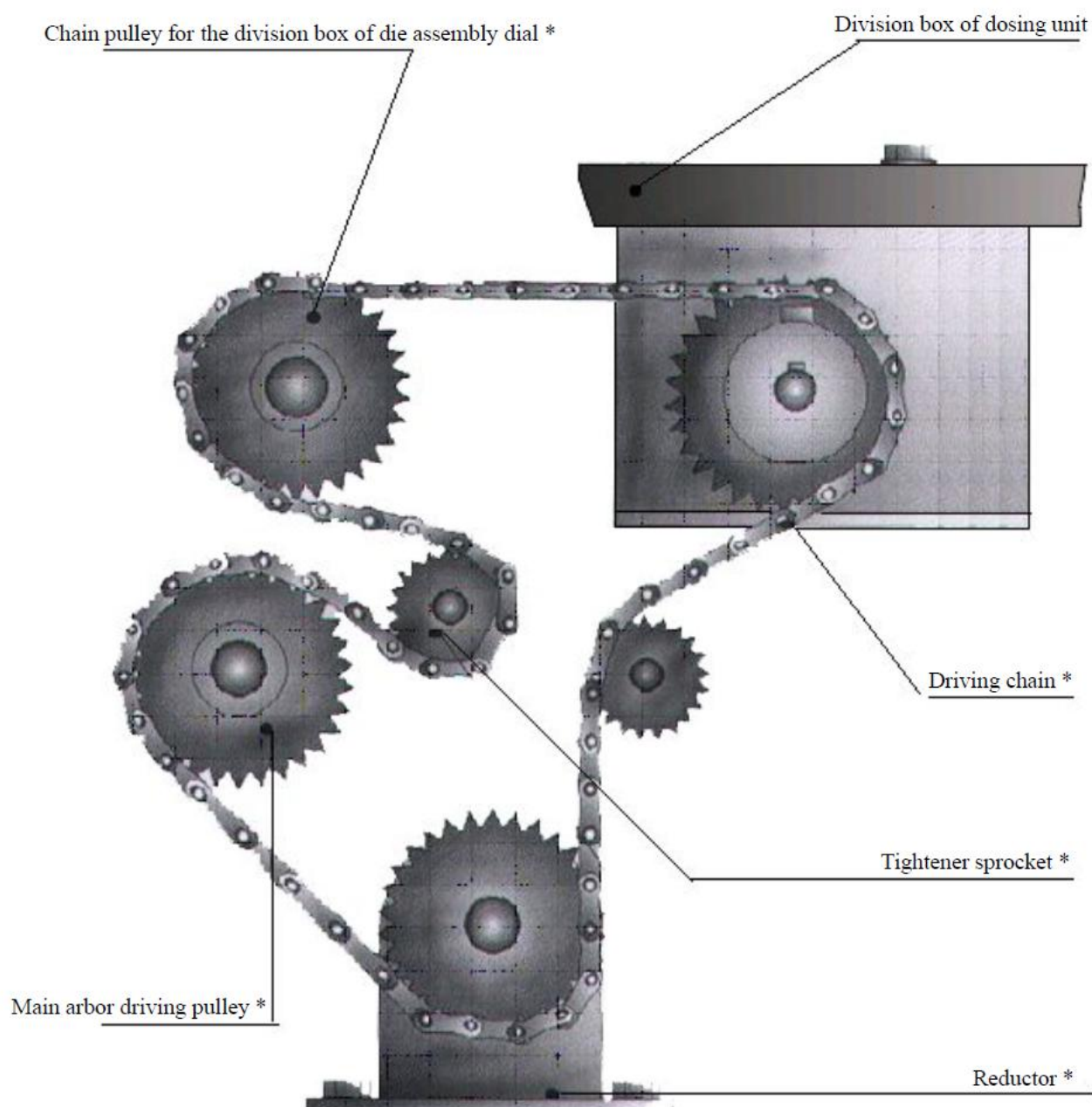


Fig(29) Cam Angle

### 6.34 Driving Chain Adjustment

If you find the chain is too loose, you can adjust the chain by moving jockey pulley but neither let the chain go off any chain pulley nor unlock the chain, otherwise the movement order of the whole mechanism will be disturbed.

Check the chain once a week. Tighten and lubricate the chain if necessary.



**Fig30 Chain Diagram**



### 6.35 Vacuum Adjustment

Clean water is used in water-ring vacuum pump with a low water flow. Vacuum degree can be controlled with a shutoff valve connecting to a vacuum gauge. Generally, -0.02~-0.06 MPa is advisable to guarantee the split of capsule without damage. With too high vacuum degree, open vacuum regulating valve to a larger extent. With too low vacuum degree, close vacuum regulating valve to a less extent or turn it off.

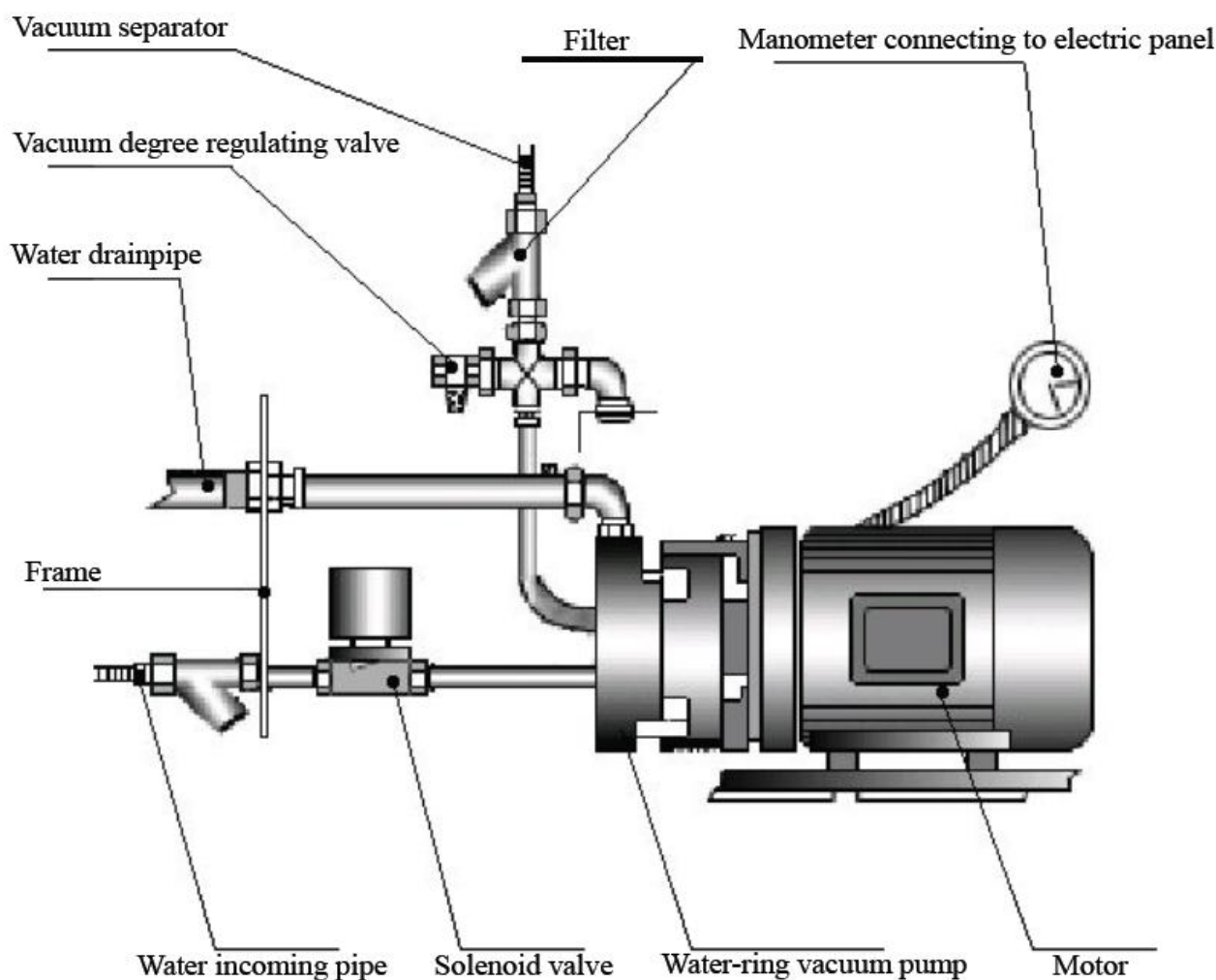


Fig31 Vacuum System

## Touch Screen Operation

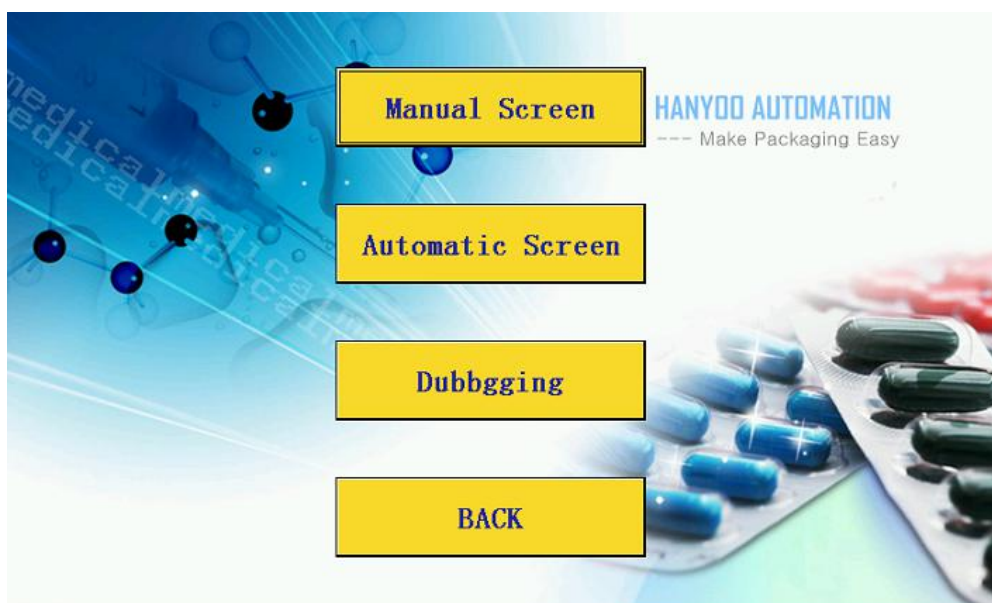
7. 1. Turn on the power switch, enter the home screen as shown in FIG 1 to choose the language



(Fig 1)

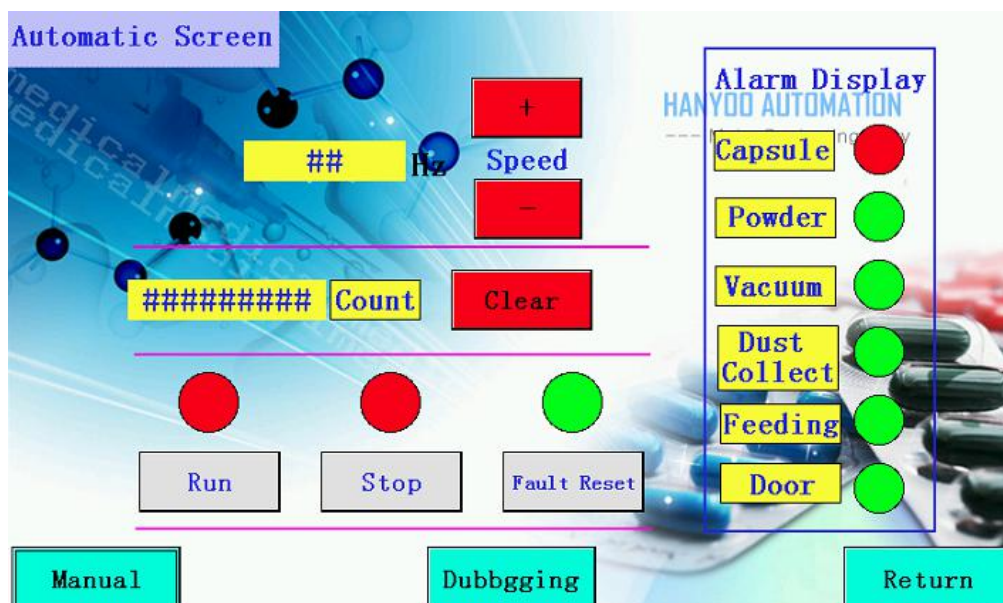
7. 2. Press **ENGLISH** to enter operation menu as shown in Fig 2.

### Operation Menu



(Fig 2)

7. 3. Press **AUTOMATIC SCREEN** to enter Fig 3



(Fig 3)

The operation steps are as following;

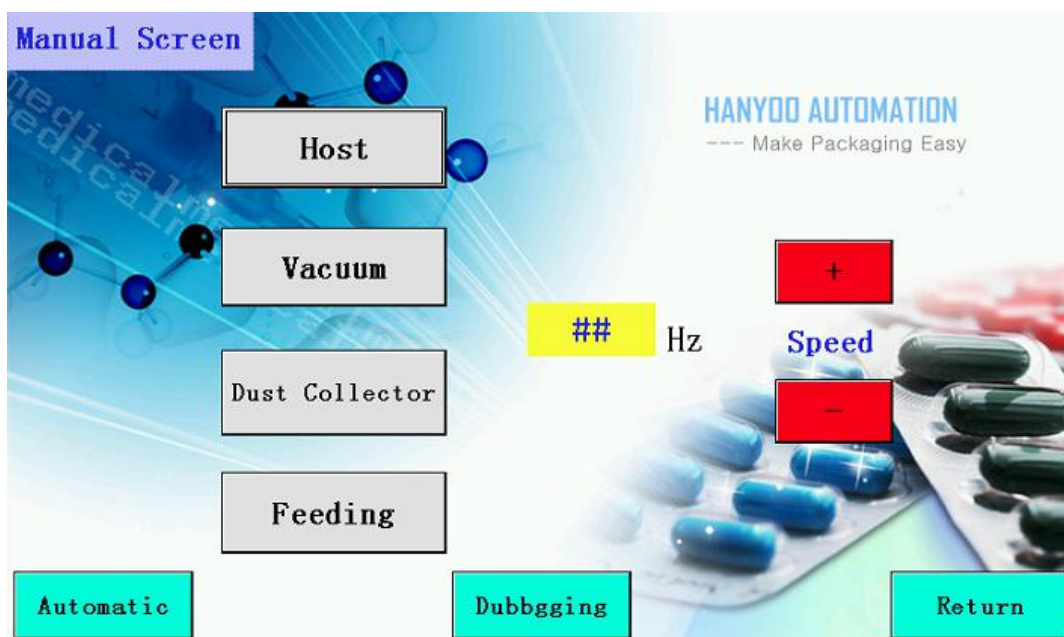
A-Press **RUN STOP** button in FIG 3 to realize the whole machine operation.

B-The **+** is to adjust frequency to control the machine speed.

C-In Fig 3, when there is any failure, or the door is not well closed, there would be alarming.

Check the failure and solve it, then press **RETURN** to come back to FIG 2 to start new operation.

7. 4. Press **MANUAL SCREEN** in FIG 2 to jump to this following display.



(Fig 5)

A- **+-** in FIG 5 is to adjust the main motor speed.

B-Press **VACUUM** for once, the vacuum pump is turned on, press it again, vacuum pump is turned off.

C-Press **DUST COLLECTOR** for once, the dust collector is turned on, press it again, the dust collector is turned off.

D-Press **HOST** for once, the main motor will start, press it again, the main motor is turned off.

F-Keep pressing on **FEEDING**, the feeding motor start to rotate, loose it the feeding motor stops rotating.

7. 5. Press **DEBUGGING** in FIG 2 to jump to this following display



(Fig 6)

NOTE:

1. CAPSULE DELAY, POWDER DELAY, FEEDING DELAY is for AUTOMATIC model running.
2. TIMED FEEDING, FEEDING TIME is for MANUAL model working.

**AUTOMATIC RUNNING MODEL**

A- The **POWDER DELAY** shown in Fig 6 is to control the feeding motor. Normally, the powder delay time is about 5-10 seconds based on different powder fluidity. For example, when you set 5 seconds, when the sensor can not detect powder, the machine will stop automatically after running 5 seconds. And sensor level position is movable.

B- The **CAPSULE DELAY** shown in Fig 6 is to detecting the capsules in capsule hopper, when the sensor can not detect capsules in capsule hopper, the machine will stop automatically after you set the time. It is same function as powder delay. Normally, the capsule delay time is about 20-40 seconds based on your machine running speed.

C- The **FEEDING DELAY** shown in Fig 6 is to set the feeding time after the powder sensor can not detect the powder. Normally, NJP-200/400C model set FEEDING DELAY time 6 seconds. NJP-800C model set time to 12 seconds. NJP-1200C model set time to 15 seconds. NJP-2000C model set time to 25 seconds. NJP-3500C model set to 40 seconds. The time could be a little different due to the powder property.

**MANUAL RUNNING MODEL**

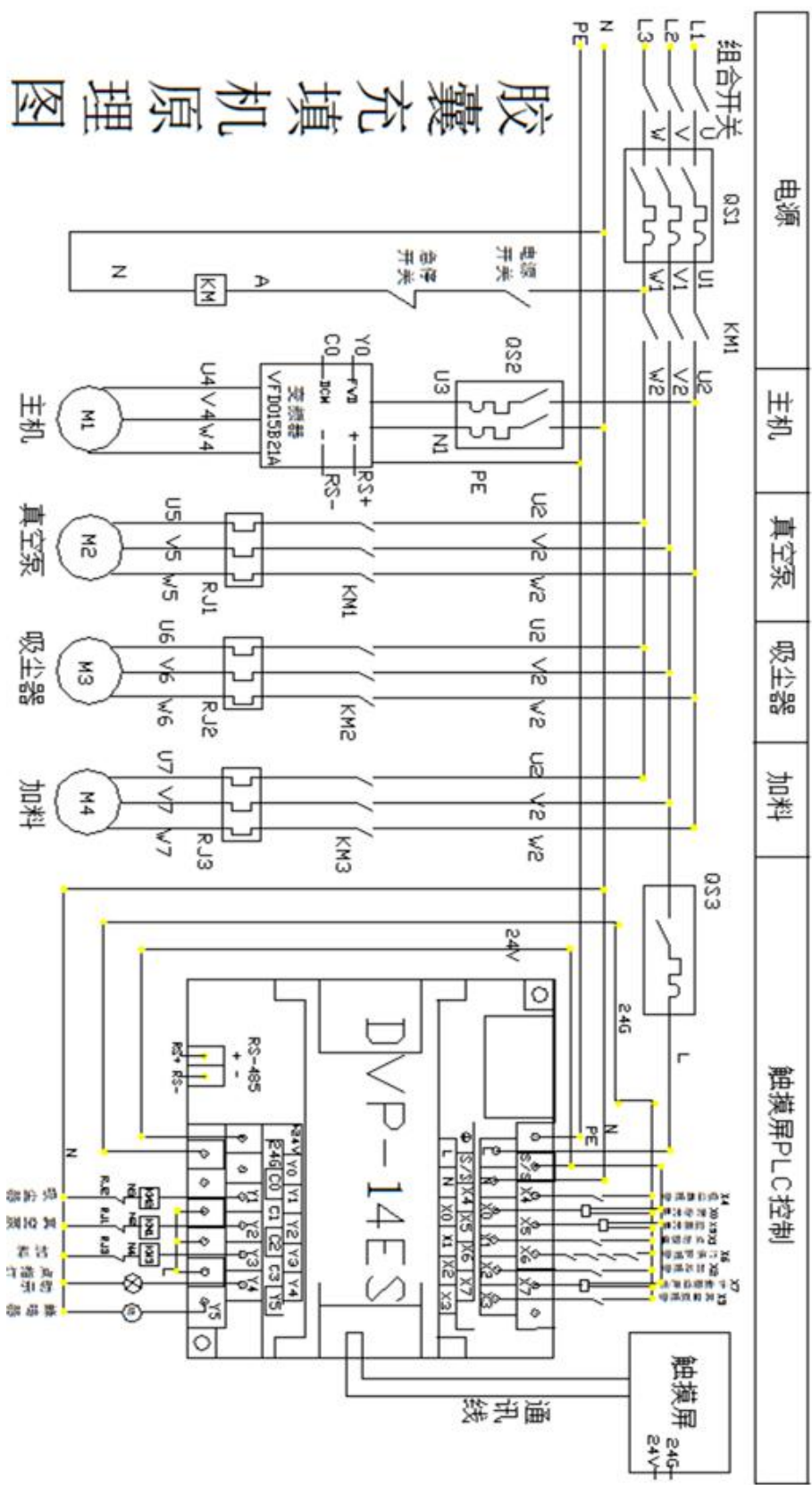
A- The **TIMED FEEDING** shown in Fig 6 is to set the time feeding in manual running model. For example, when set 5 seconds, the filling interval time is 5 seconds.

B- The **FEEDING TIME** shown in Fig 6 is to set the powder filling time in manual running model. For example, when set 5 seconds, the powder filling time is 5 seconds.



Electronic Diagram

图 (35) 电气图



## Machine Maintenance

9.1 In long operation of the machine, regularly clean the parts that contact powder directly. Also clean these parts when replacing another kind of medicine powder or shutdown for a long time.

9.2 Often wipe greasy dirt at driving parts in the lower part of the machine to view the running state more clearly.

9.3 Regularly open and clean the filter of vacuum system. (refer to Fig. 33)

9.4 Lubrication of machine

9.4.1 Coating the working surface of roller of all cams with grease weekly.

9.4.2 Drip lubrication in the joint bearings of all connecting rod under the working bench weekly.

Clean and lubricate all kinds of bearings regularly or according to operation situation. Drip lubrication in sealed bearings.

9.5 Check and lubricate the driving chain for tightness weekly.

9.6 Check the main driving reducer and powder-feeding reducer for oil volume monthly. Fill oil in time. Replace lubrication every half year.

9.7 Station division box under the revolving platform and dosing disk shall be disassembled and maintained under the guidance of professional technicians.

9.8 After running for 1000 hours, two division boxes shall have the first replacement of lubrication oil, and later after every 3000 hours of running, a replacement of lubrication oil shall be made once; (90# engine oil is recommended here, viscosity 680~460)

9.9 Remove cover plate of revolving platform every week and lubricate T-type shaft and brass sleeve and bearing of moving points in guide rod. Every 1000 work hours, uninstall T-type shaft and sealing ring for complete cleaning, replacement and lubrication once.

Table of Lubricating Oil

Lubricating Oil	Grade No.	Part to lubricate
Machine oil	N4B GB443-84	Chain, guiding part
No. 2 lithium base grease	ZL2 SY1412-75	Cam, rolling bearing, chain
No. 0 lithium base grease	ZLD SY1412-75	Division box, speed reducer

## Familiar Malfunction Obviating

Malfunction state	Malfunction cause	Obviating method
Capsule can't be conveyed	Intake of capsule convey plate is jammed by defect capsules	Remove defect capsules from capsule tank by long pin.
	The switch of conveying capsule is too big or too small.	Adjust the position of convey capsule.
	The immobility of capsule piece is damaged or position is not accurate.	Replace the immobility of capsule piece or adjust its angles.
Low ratio of capsule mount	The horizontal fork of the correct position is before or behind.	Adjust the position of horizontal fork.
Capsule caps can't enter upper mold block to split.	Vacuum pressure is too big.	Adjust vacuum valves to change vacuum pressure.
Capsules can't be split normally	Vacuum is too low.	Adjust vacuum valves to change vacuum.
	The holes of mold block are too dirty.	Cleaning the hole of upper mold block and the hole of lower mold block.
	The concentricity of mold block holes is not accurate.	Regulate their concentricity with regulating rod.
	Capsule fragments is jammed by air vent of sucker capsule	Cleaning capsule fragments with a pin hook.
	Mold block is damaged.	Replace mold block.
	Vacuum pipeline is jammed.	Cleaning vacuum pipeline.
Capsules locked in position and crack as well as pit phenomenon appears.	The concentricity of mold block holes is not accurate.	Regulate their concentricity with regulating rod.
	Point pin of locking capsule is torched.	Adjust or replace point pin of locking capsule.
	End surface of point pin is dirty.	Cleaning the end surface of point pin.
	The position of point pin is too high.	Adjust height of point pin.
	The holes of mold block are damaged or wear.	Replace mold block.
The position of capsule locking is incorrect.	The position of point pin is too low.	Adjust height of point pin.
	Dosage is excessive.	Adjust by manufacturer



## **Warranty Terms**

1. The machine warranty period is 12 months
2. During the warranty period, the problem appeared in accordance with normal use and service instructions, we provide free fixing.
3. During the warranty period, such as one of the following conditions occur, it will be charged:

- (1) Can not provide a valid warranty card or purchasing documents.
- (2) Misuse and damage caused by improper repairs.
- (3) Transporting or damage caused by fall.
- (4) Failure and other damage caused by force majeure.
- (5) Use the power voltage caused damage other than those specified.

4. The appearance of the product, the vulnerability of consumables and accessories are not covered by the warranty.

The accessories included Spring, Water Tank , Filter , Rubber Gasket and tooling in the tooling box,

5. Only for the above guarantee, does not make any express or other guarantee, either in the contract, on tort or otherwise, the Company liable for any special, incidental or consequential damages in charge.

**Service Tel: 0086 25 5621 6295**

**Warranty Card**

Machine Name	
Model	
Series No.	
Manufacturing Date	
Company Stamp	(Available After Stamp)
Client Name	
Client Address	
Contact Number	
Record (1)	
Record (2)	
Record (3)	
Record (4)	



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