

機器運作時注意事項 SOP

Warning Standard Operating Procedures for Machine When Working

(一) 紅色緊急停止 Red - Emergency stop

1.若有機器異常狀況發生，緊急狀況下無法即時處理，此時先按下射座控制面板上的紅色圓形緊急停止開關，機台電源斷電，馬達及設備停止運轉，機台將無法操作。所以進行射出機操作前，必須先測試此開關是否有效，如無效，必須找出原因並修理，保持安全。

1. If there is abnormal emergency happened to the machine and couldn't be fixed immediately, then please press the red circle emergency stop button on the injection seat panel; the power of machine will be cut off and the motor and other equipments will stop working. Before operate the machine, please test this switch to see if it works; if it's not working, please find out the reason and fix it to keep safe.

2.待狀況排除再旋轉放鬆，依照正常開機程序啟動。

Rotate the button to loosen it after eliminated the problem and turn on the machine with regular procedure.

(二) 黃色圓盤轉暫時停止 Yellow Disc Pause

1.各站操作時，如有突發狀況，經判斷可即時處理，立即按下射座控制面板上的黃色圓形圓盤轉暫停開關→待狀況排除，旋轉放鬆黃色暫停開關→繼續設備操作。

Please press the yellow circle disc pause button on the control panel of the injection seat if there's emergency happened and determine as a fixable problem which could be deal properly during operating. Rotate the button to loosen it after eliminated the problem and continue to operate the machine.

(三) 不可有異物 Without any foreign objects.

1.射出座位移移動區域內、兩側滑桿上及射料嘴不可有異物與吊掛物品。

There can't be foreign objects or hanging things inside the displacement area of injection seat, both side of the slider and injection nozzle.

2.料管內螺桿在旋轉入料時，切勿將長形物品或異物置入原料槽，因此將原料在放入原料槽前，務必檢查原料槽內是否有異物。

Do not put rectangles or foreign objects into the material tank when the screw in the barrel is rotating to feed, therefore, it is necessary to check if there are foreign objects in the material tank before putting the material in it.

3. 注意螺桿不可任其空轉，以避免螺桿磨耗，所以在目視原料槽內原料剩餘 1/4 時，應確認自動吸料機是否有確時補充原料。

Do not let the screw idling to prevent from worn out the screw. Therefore, confirm the auto vacuum to see if it fills the material properly if there is 1/4 of the material left in the tank.

4. 模具在各站關模前時，均需檢查無異物及膠料在模具內，這樣可避免關模射出時，產生間隙使模具無法密合，造成膠料溢出。

Check and make sure there are no foreign objects and rubber left in the mold before mold closing. This action is to prevent the mold from closing with gap and can't close tightly and lead to the rubber overflowing.

(四) 不可有異聲 Can't have abnormal sound

1. 射出機馬達運轉時，若發出刺耳聲響或異於平時聲響時，需立即找出原因並修理，以避免馬達燒毀與泵浦損壞。

If there are discordant sound or abnormal sound when the motor of injection machine is working, please find out the reason and fix immediately to prevent from burning the motor or breaking the pump.

2. 射出機運作時，活動機件作動時，若有摩擦出現時，均需暫停操作，立即找出原因並修理。

Pause operating to find out the reason and fix immediately when there is attrition happened during the machine and accessories working.

3. 適時添加少許黃油於邊模處，可降低磨耗增加壽命。

Decrease the abrasion by adding some grease oil properly to the side mold and prolong the life

(五) 其它應注意事項 Other Notice.

1. 在射出機運作時，須隨時注意，油壓管接頭、油路板、油壓馬達及泵浦等附近，不可有不異常漏油現象，如有需立即找出原因並檢修或更換完成，以保持安全，增加設備壽命，不影響機台正常運作。

In order to keep safe, prolong the life of equipment and not to affect the machine working, please always pay attention to the connection of hydraulic pipe, manifold block, hydraulic motor and pump and other equipments nearby when machine is working to see if they have abnormal leaking situation; if yes, please find out the reason and fix or replace immediately.

2.切換自動模式前須將各模站兩個切換開關轉到槓頭升、邊模開位置，以確保操作過程中若有緊急狀況時，只要將各模站自動轉成手動，模座即到常開位置，以確保設備操作人員安全。

It's necessary to switch every station to last-rising and side mold open before turning to auto mode to make sure the safety of the operators; once there is emergency happened, turn every station from auto to manual and the mold seat will back to the regular position.

※ 詳細參考手冊及設備手冊，以維持順利運轉及增加 設備壽命。

Please refer to the manual and equipment manual for machinery to keep the machine working successfully and prolong the life of equipment.

★本公司保留修改此文件之權利

★We reserve the right to modify this document.