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# DHCE10B CAPPING MACHINE

## Instruction





## Contents

### 【Foreword】

Thank you for choosing our products. We provide you with high quality products and reliable after-sales service. In order to ensure the personal safety of users and the integrity of the machine, please read this manual fully before using the machine and pay attention to the precautions in use. This operation manual describes the design principle of the equipment in detail according to the standards, construction, operation specifications and maintenance. Possible fault situation and troubleshooting method, electrical diagram, etc. References to "test specifications" in this manual are for reference only. If you find any objection, please review the relevant standards or materials by yourself.

Special instructions

- ◆ This operation manual shall not be used as a basis for making any request to the company
- ◆ The company reserves the right to interpret the operation manual



## Brief Introduction

The desktop capping machine relates to an electronic cigarette device that can quickly, conveniently and accurately cap a variety of electronic cigarettes at the same time.

## Main Structure and Working Principle:

### 1.Main Structure

It mainly consists of a rack, press fixture, and electric cylinder device. (the equipment is assembled and shipped as a whole, no need customer self-installation)

### 2.Working Principle

This device is used for electronic fumigators to press atomizer cigarette holders. The equipment is composed of a rack, a press fixture, and an electric cylinder device. The mechanical devices of the equipment include: rack components, press components, and the coordinated operation of each component enables the electronic smoker to simply, conveniently, and accurately press the cigarette holder.

## Main Specification:

Item Name	DHCE10B ELECTRICAL CAPPING MACHINE
Input voltage (V)	AC110VAC 60Hz
Power	2.5KW
The Length Range Of The Atomizer	20-160mm
Size	650x500x1500mm
Weight	250kg
Using Condition	Temperature 10~40°C
Working Pressure (T)	0.5~10T
Control	Electric control pressure control
Pressed Area	240x320mm



## Setting Up

### Setting up circumstance

- 1.To get the best performance of the equipment, should choose the sites temperature of 15 ~ 120 °C, relative humidity is no more than 85%;
- 2.Please no rapid temperature change for the working site;
- 3.Should install on horizontal ground, do not have direct sunshine, ventilated good, dust is little;

### Move Around and Loading & Unloading

- 1.Please use lifter lift the equipment wooden box and keep it horizontal when take it into the facility;
- 2.Follow the mark on the wooden box to stand up the wooden box then separate the wooden box and get the equipment;
- 3.Check if there is any damage on the equipment surface;

## Safety Precaution

### Mechanical Part

- 1.You should reading the operation manual when operating the equipment;
- 2.Wear appropriate work clothes. Persons operating or maintaining equipment shall not wear ties, necklaces or loose clothing and shall wear necessary protective equipment
- 3.Do not touch the heating part of the equipment by hand to avoid scald;
- 4.Please consider the operation steps Before operate the device;
- 5.Do not block secure interlocks unless you are a qualified person.

### Electric Part

- 1.Electrical hazards exist in the power supply and wiring terminals of the equipment. In order to avoid any electric shock and injury accidents, the main power supply must be cut off before maintenance. And only qualified or trained maintenance person were allowed to maintain and repair equipment.
- 2.Please turn off the main power supply before any maintenance in the electrical cabinet. Live operation is strictly prohibited. Live maintenance or adjustment is allowed only by trained persons.

3.Understand and remember the location of all safety devices and strictly follow standard safety rules.

## Operation Note Points

1.Before operation, please carefully check whether the power supply conforms to the specified voltage, whether the power supply has grounding wire, whether the power supply wire is properly connected according to the specifications, and whether the electrical components have short circuit. Carefully check whether there is leakage in the pipeline system and whether there is looseness in the pipeline interface; If all is well, the operation can be carried out.

2.Demonstrate the operation steps before operating the device

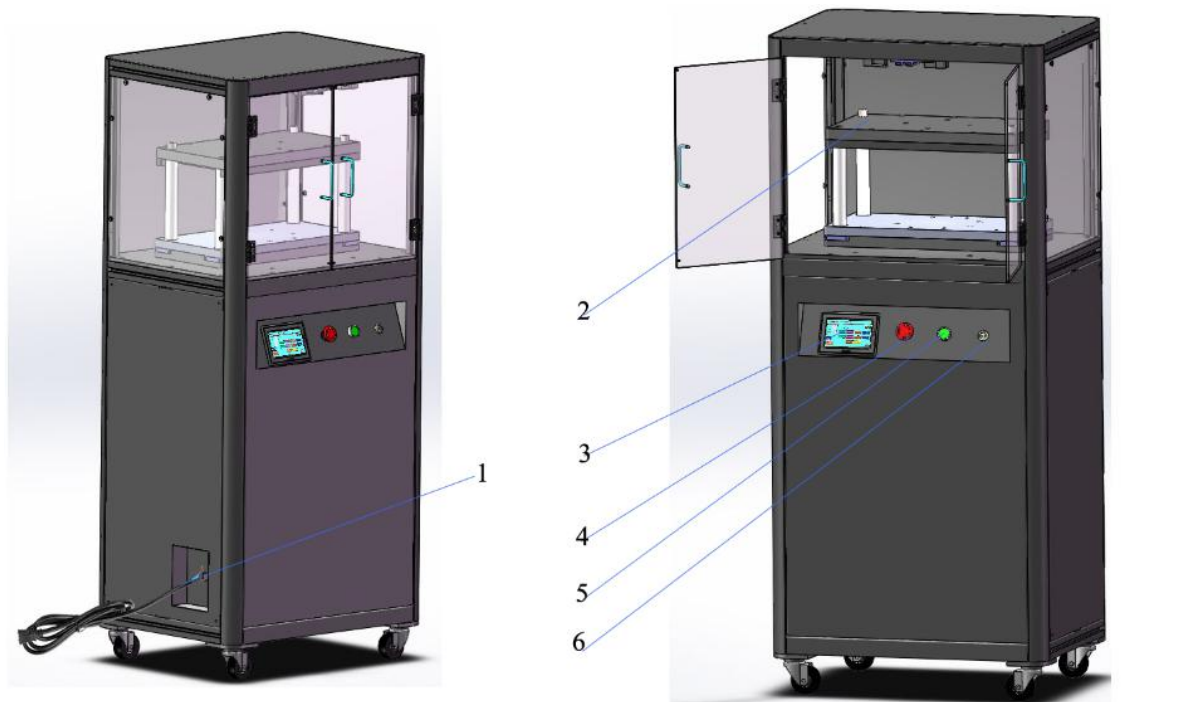
3.Please make sure cut off the power before move the equipment.

## Operation Theory

### Contents

Understand the position and function of the major parts of the equipment

### General Survey





1	Power Socket
2	Fixture
3	Touch Screen
4	Emergency Stop Button
5	Start Button
6	Power Switch

## Function

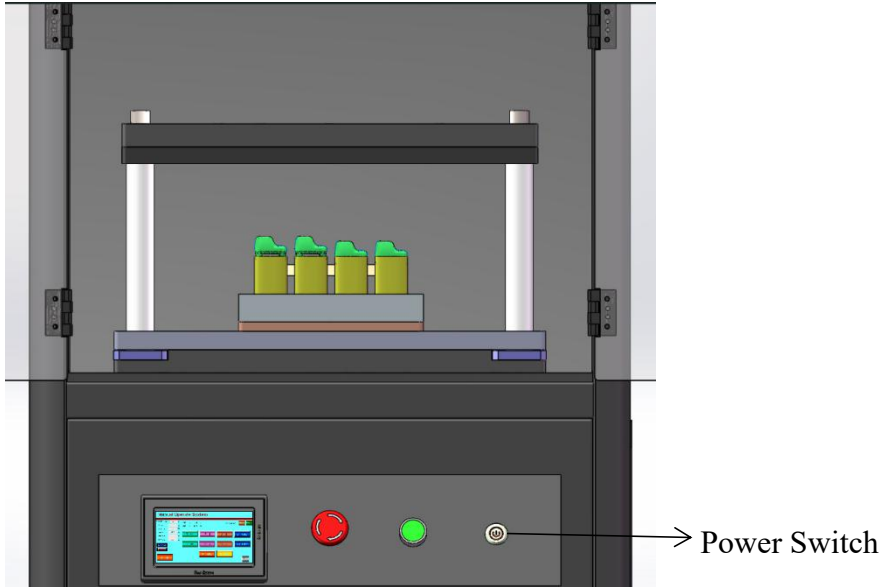
- 1.Power socket: insert the supporting power cord (with accessories), the voltage is AC110V
- 2.Fixture: This fixture is a press fit fixture used for pressing products
- 3.Touch Screen: The touch screen is used for controlling the device system
- 4.Emergency stop button: in case of emergency, you can press this button and rotate it to reset
- 5.Start button: Start press button.
- 6.Power switch: self-locking power switch with indicator light

## Inspection Before Operation

1. Check whether the position of the lower pressure plate is at the upper position. Please do not put the atomizer under the lower pressure plate before the demonstration to avoid damage to the atomizer by mistake.
2. Check whether the power plug is loose.
3. Check whether the equipment power supply voltage meets the requirements.
4. Check whether there are oil pipe leaks in the pipelines of the equipment. After checking, connect the power cord.

## Operation guide

- 1.After the equipment is checked, when everything is normal, connect the equipment to the power supply, press the main power switch, and the power switch indicator lights up
- 2.As the picture shows below



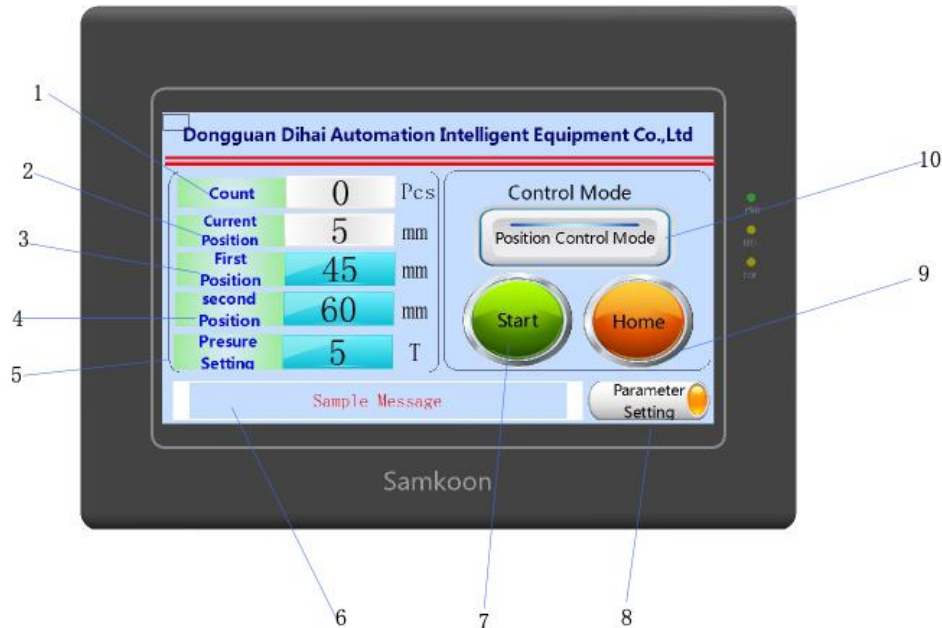
3. Enter system: There are two languages for you, which are English and Chinese options.



Choose the language and then click on the Icon of “Enter The System” to set parameters. We need to reset it firstly before we start to proceed.

**The main interface functions are as follows**

## Main interface functions



### Interface Description:

1. Count: Record the number of pressed pieces
2. Current position: Display the current position of the pressing plate
3. First position: Start pre pressing position
4. Second position: End position for pressing installation
5. Pressure setting: Set the pressure for the press installation, with a pressure range of 0.5-10T tons (500Kg~10000Kg)
6. Alarm information: When a system error occurs, the current alarm information is displayed
7. Start button: Start switch
8. Parameter key: This key enters the parameter interface.
9. Reset key: Reset the pressed pressing plate
10. Pressing mode: click to switch

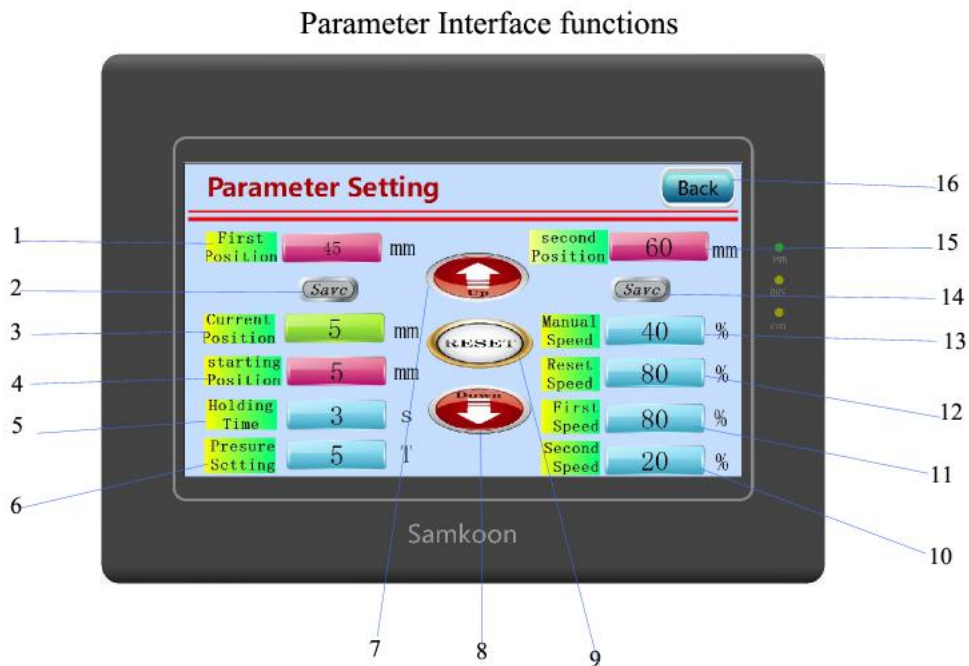
### Three modes:

- ① Position control mode: After the pressing reaches the set position, the pressing plate stops
- ② Torque control mode: After reaching the set pressure, the pressing plate stops
- ③ Position and Torque Control mode: The pressing plate stops when reach one of the set value. Which means, The pressing plate first reaches the set position, but if the pressure does not reach the set value, the pressing plate stops; Alternatively, if the pressure of the pressing plate reaches the set pressure first and the position does not reach the set value, the pressing plate will stop.



#### 4.Parameter Setting:

Click on the parameter setting icon, interface shows as below.



Interface Description:

- 1.First position setting: Set H1 height position
2. Save button: When setting the height, click this button directly to save the height position
3. Current position: Display the current height position
4. Start position: The height position at which the operation begins
5. Holding time: Holding time upon completion of pressing
6. Pressure setting: Set the pressure for the press installation
7. Up button: Press the button to run the board up
8. Down button: Press the button to run down the mounting plate
9. Reset button: The button for pressing the mounting plate back to the original point
10. Second speed setting: Set the speed for running H2
11. First speed setting: Set the speed for running H1
12. Reset speed setting: Set the reset running speed
13. Manual speed setting: Set the manual operating speed
14. Save button: When setting the height, click this button directly to save the height position
15. Second position setting: Set H2 height position
16. Return button: Return to the main interface button

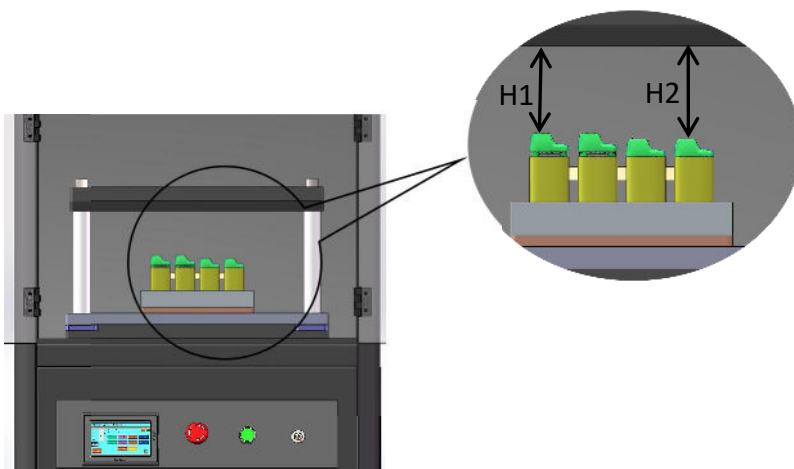
5. Place the atomizer tray into the machine and set the height of H1 and H2:

**Height setting method:**

H1: First position: The distance from the top of the atomizer nozzle to the bottom of the pressure plate, which has not been pressed yet

H2: Second position: The distance from the top of the atomizer nozzle to the bottom of the pressure plate after being pressed and installed

$$H1 \leq H2$$



Height setting method: Click on the parameter interface (down button) to move the press mounting plate to position H1,

Then click on the "save" button below the "first position" and save the first position,

Continue to move the pressing plate down to the H2 position, click on the (save button) below the (second position) to complete the height setting, and click on the (reset button) to return the pressing plate to its original position.

6. After the test machine is completed, it can be produced

Click the return button to enter the main interface, select the pressing method: (position mode, torque mode, position+torque mode), take out the atomizer tray, press the start button to start, test run, and observe whether the pressing height meets the set height value. After the test run is completed, the machine can start production.



## Maintenance

1. After each use of the equipment, please keep the inside and outside of the machine clean, no stains;
2. The equipment is very precise, according to the specified ways to move around, please no crash or other damage.
3. The on-off interval of the equipment must be guaranteed to be more than 1 minute;
4. The equipment should be electrified every other week if out of use for a long time;
5. Do not remove electrical components and equipment parts at will, so as not to damage the equipment and affect the performance;
6. Maintenance and repair of the equipment shall be carried out by professionals or trained persons



## Common Fault Analysis

1.Contents:Provide any possible failures; Operation manual, tools and other tools, troubleshooting according to the trouble list

### 2.Trouble List Analysis

Trouble	Part	Analysis	Solution
The touch screen is not displaying or the machine lighting does not light up	Power supply terminal in the chassis	Power cord terminal is off	Correspondingly plug in the terminal
	Switch Mode Power Supply	Main Power Indicator not light up	The terminal is off, connect the wire, or replace the main power button
	Touch Screen	Touch screen power cord detached	Connect the power cord properly
	LED Light	LED lights burned out	Replace LED light
Unable to reset action	Origin sensor/lower limit switch	Unable to sense the origin or damaged sensor/limit switch	Open the cover plate of the lower chassis and observe whether the sensor is sensing properly, or if the lower limit switch triggers sensing, or replace the damaged sensor.
Machine not moving	Unable to start machine	Not returning to the origin position	Check if it returns to the origin and the position parameter changes to 180mm
	Select mode	Check if the pressing mode selected on the touch screen is correct	Switch appropriate pressing mode
	Servo alarm	Check if the position and torque parameters are correct	Adjust the position/torque parameters to increase/decrease torque.
Touch screen no communication	Touch screen communication cable	Cable is loose	Check the communication line connector, tighten the communication line connector screws, and restart the machine

**Note: If other not known fault occurs, let professional person to maintain**