



**FMPJJ---FENGMI Spraying Machine for leather**

**PJQ—B---FENGMI Spraying Machine computer**

## Manual

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Advise to users : Thanks to use our company's machines! To enable you to better grasp the machine performance, please read the manual carefully ,before you use the machine !

### **Notices:**

1. The configuration and technical parameters just for basic operation not for all kinds of machines .The machine configuration based on our contract !

2. Plant configuration and technology will change according to customer needs. If the products different from the manual, to the final product as the standard.

**Security Warning :** When the Spraying Machine is working , the operator prohibited to checking in to the spraying room by head , Otherwise, most likely to cause significant physical security incidents, and even life-threatening!

## Preface

FMPJJ-FengMi Spraying Machine Collection Fengmi high control technology and hardware manufacturing advantage. Products based on high-end customers at home and abroad.

### Product Configuration

**GUNS:** Italian Import for usual, can choose A10, All guns from Germany

**PUMP:** Italian Import for usual, can choose Taiwan or Germany's pump

**Spray Chamber:** Interior usual is 1.5mm stainless, exterior is 1.5-2.0mm cold plate , 3mm hot plate overall column, stainless water cycle retaining plate , High-strength steel windows, 1.5mm cold plate punching roof , Channel turntable Holder. Can choose stainless exterior or stainless whole machine .

**Dust:** Three 2-3mm hot plate box , two spray , two water curtain , one filter, dedicated recycling sewage pump , Vertical dust blower. Can choose stainless exterior or stainless whole machine .

**Wash Lines :** Single line for usual , single brush high washing machine . Can choose double lines and stainless wash line slot ;

**Drying :** Steam heating for usual, with filter hot wind sustainable cycle. Can choose heat with infrared or oil .

**Insulation Plate :** 50mm environmentally friendly insulation board.

**Solenoid :** Routine use of German imports , can choose Taiwan or Italy ;

**Axis :** Imitation Italian technology double Seal built-in

automation axis for usual. Can choose two spraying ways .

**Slip Ring** : 10 rings for usual , with turntable track , can choose two ways .

**Computer** : The 8<sup>th</sup> computer of Fengmi , can use 2-24 guns and two ways .

**Master Chip** : Imports from American .

**Others**: Control of electric parts and motors from China .

**Products Advantages:**

**Use turntable with no interstitial technology** : This technology can adjust the displacement with auto , improve the accuracy of spraying

**High-density optical scanning technology** : The usual scanning density is 4 cm , FengMi use 2.5 cm , average saving can reach 10%-15%.

**Leather Measuring Function** : The measuring accuracy can reach leather measuring machine .

**Environmentally friendly insulation board**: Up the thermal efficiency to 5%-10% .

**Software technology development can unlimited upgrades.**

**Technology Parameter**

**Working width** : Usual 1800mm; 2200mm; 2600mm; 3000mm; 3400mm

**(PS: Special specifications can be customized )**

**Machine Length** : 22m-23m for usual

**GUNS** : 4-24 handles , Specific according to customer needs

**The high from Conveyor Line to land** : 900mm-950mm for usual (Specific according to customer needs)

**Transmission speed (Stepless)** : 0m/min—20m/min

**Transmission lines Density**:2cm/root—2.5cm/root

**Guns Rotation speed (Stepless)**: 0r/min—30r/min

**Air compressed** : Pressure 0.5Mpa-0.7Mpa

Air volume 1.5m<sup>3</sup>/min

Enter the compressed air path:  $\phi$ 20min

**Serous compressed in case** : 0Mpa-0.3Mpa

**Whole machine power:** 17-22kw

**Oven :** 5 \* 2m for usual

**Steam Compressed :** 0.2Mpa-0.4Mpa

**Oven temperature :** 70-95°C

**Input heat pipe diameter:**  $\phi$ 40min for usual

**Environmental purification :** Water Ring Type

**Whole machine Weight :** 6T-10T

**Spraying choose for leather**

- (1)Whole spraying
- (2)Front spraying and after spraying
- (3)Single gun or double guns
- (4)Point spraying time set
- (5)Auto guns washing control
- (6)Front and behind , left and right extension for leather edge
- (7)Guns correction
- (8) Detection fault for auto
- (9)Measuring auto
- (10)Leather shape show on monitor

**Machine Installation :**

Installation follow the technicians of Fengmi , about 7-10days to finish the work .

**Ready to Installation**

**Before installation , users need to get ready :**

1. Compressed air source (Reference to Technical Specifications)
2. Steam Gas, power, water (Reference to Technical Specifications)
3. The duct except dust blower , should installation by users.
4. The water tubes installation by users.

**USE Description**

### **1. Operational Readiness**

Check the transfer: the need to be adjusted to work to the best speed;

Check the spray chamber: Focus on the transmission speed and spray turntable effects of the best match;

Spray room environment: to ensure that there is sufficient water cycle, water and normal operation;

The transfer efficiency spray gun: (require an experienced master operation)

Check Drying: At 30 minutes before the boot to open sources of heat;

Check the cold wind: as the business process may be spraying. Generally normal open state;

Check washing line: washing line pool water clean, washing-line device normal operation.

Check electrical appliances: no fault state

Check Safety: rotating spray room spray in the working state room windows should be closed, or open the windows on both sides of spray chamber.

Strictly prohibited in the spray head probe into the central room.

**(Warning: shotcrete machine machine operations must run on all these sites became operational in normal circumstances, or is likely to cause significant quality-related accidents!)**

## Handling Precautions

### Spraying Precautions:

① Gun away from the transmission-line Distance: the distance between the factory will be regular distance, the actual operation by the

Customer factory leather craftsmen leather craft based on the enterprises to adjust requirements

② Slurry filling of the pressure: conventional storage grouting fluid pressure in the range of 0-3 bar, the requirement

Thick coating, it can put pressure transferred to a larger.

③ the remaining slurry disposal: Each completed its work schedule to be let go the remaining slurry to 40 °C warm water instead of slurry spraying continued for 20 minutes (set your computer to clean state), wash, slurry pipeline and the spray gun.

④ spray room environment clean: spray chamber of the circulating water should be replaced once per flight per week, cleaning .A spray room, spray room should not open the windows in general, so as not to affect the ventilation effect, but if the pumping power is too large (if spray a small

hides), have a choice to open the windows can adjust the size of the pumping power.

⑤ adjust the size of spray volume: spray gun to achieve the cover knob, clockwise pulp decreased, Counter-clockwise increases the amount of pulp

⑥ slurry atomization fan adjustment: adjustment gun at the bottom and side cover knob to achieve.

### Dust Units Note:

① spray chamber to start the same time, dust to simultaneously start. At this point, the door should be open, Sheung Shui, dust to dust body water spray to prevent dirt, dust removal machines, burning and polluting the environment.

② After the cessation of shotcrete, dust motor should continue to work for 30 minutes after the stop, to ensure clear indoor residual spraying slurry.

③ easy to keep dirt, dust removal device, must be cleared once a day. Hairdryer method is to open the door to eradicate the dirt.

**Washing line maintenance:** wash trough of water should be replaced once a day, money-laundering brush cleaned once a week (available 40 °C warm water washing). In addition, depending on the slurry, and some need warm water line, you can join the steam pipes in the wash trough.

Measure of the standard washing line is clean is: to see whether the thicker lines are washed, if not thicker washing line that is normal.

**Oven temperature control:** oven temperature control is driven by the temperature sensor switch steam valve achieved. The user to set the required temperature on the thermometer can be automatic thermostat.

**Lubrication:** bearings parts of each machine, reducer should be once a week, plus oil.

## 2. The operation of the computer

① various parts of computer

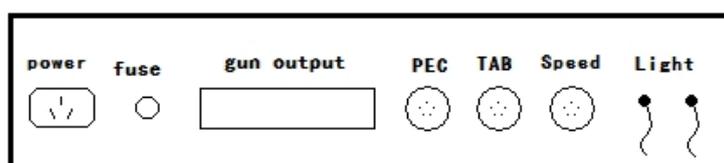
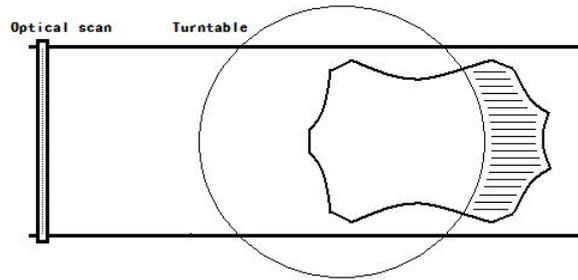


Figure 1



(Figure 3a):Pre-spray PIC



(图三 b) :后喷图

(Figure 3b):After spraying PIC

**ODD:** According to the singular key to odd-numbered light lit, when gun 1.3.5. The gun every odd job.

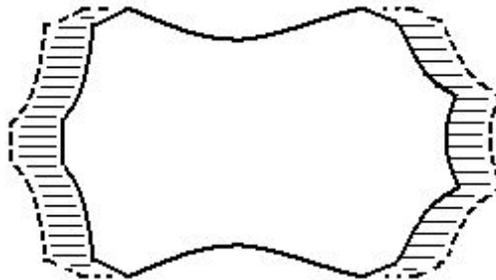
**Nos:** According to two the number of keys, the double the number of lights lit, which is every gun .. 2.4.6 the number of pairs of .Gun industry.

**Point spray:** spray button press point to point spray indicator light, in the set point when the spray gun time Switches Parameters, then it will emit fancy leather;

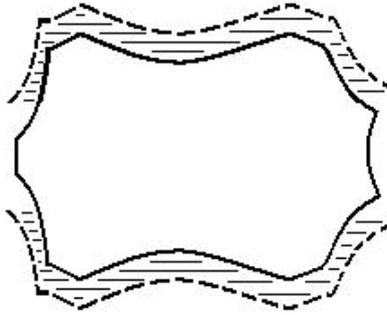
**Wash Gun:** According to wash gun key: to wash gun indicator light on the gun into the wash process

**Before and after the increase:** According to Mode Select button to align the arrows before and after the increase, according to set key to modify the parameters, you can .In order to spray on skin before and after the expansion of Canadian gun operation (Figure 4 a)

**Left and Right increase:** Press mode select button to align the arrows around Canada, by setting key to modify the parameters, you can Sprayed on the skin so as to extend the Canadian gun operation ( Figure 4 b)



(Figure 4a)



(Figure 4b)

**Center:** for the spray gun offset settings, sub-A group and B group, the alignment arrows A or B, Modify the parameters of the spray gun can just spray on skin;

**Area:** display the number of skin spray

(Special Note: the area is cleared, the alignment area of the arrow, press Stop / spray button for more than three seconds on the zero; area of a standard board Correction: According to set the plus or minus, with standard board alignment can)

② The keyboard functions:

**Debug keys:** Click here to enter debug state, debugging lamp lit,

**Sync B:** said rotary switch close to the working status

**Sync A:** close to the switch that sent the work of the state

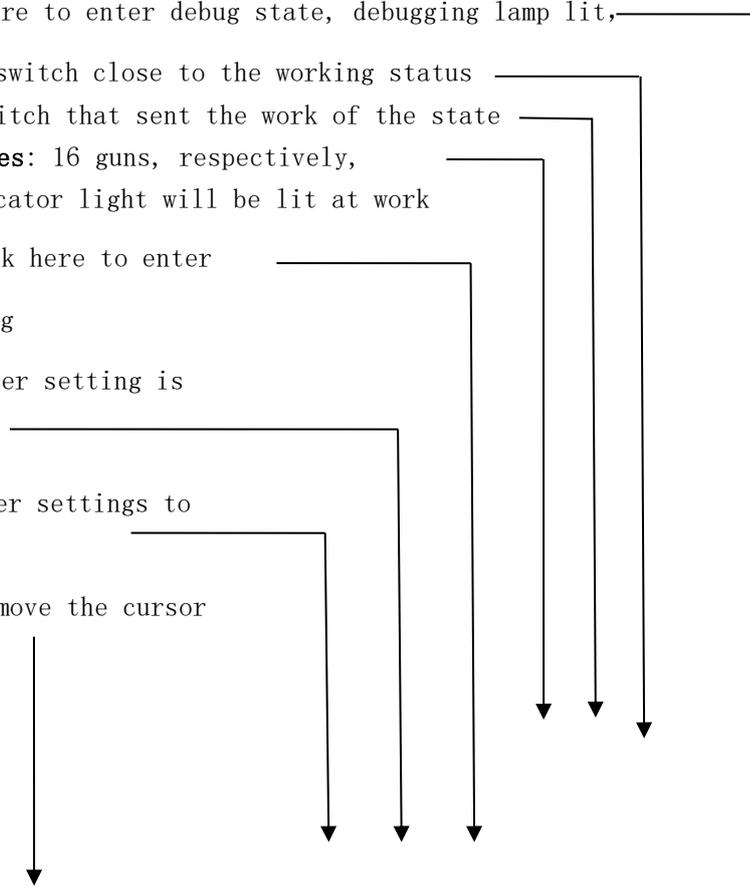
**1-16 first row of figures:** 16 guns, respectively, the working state. Indicator light will be lit at work

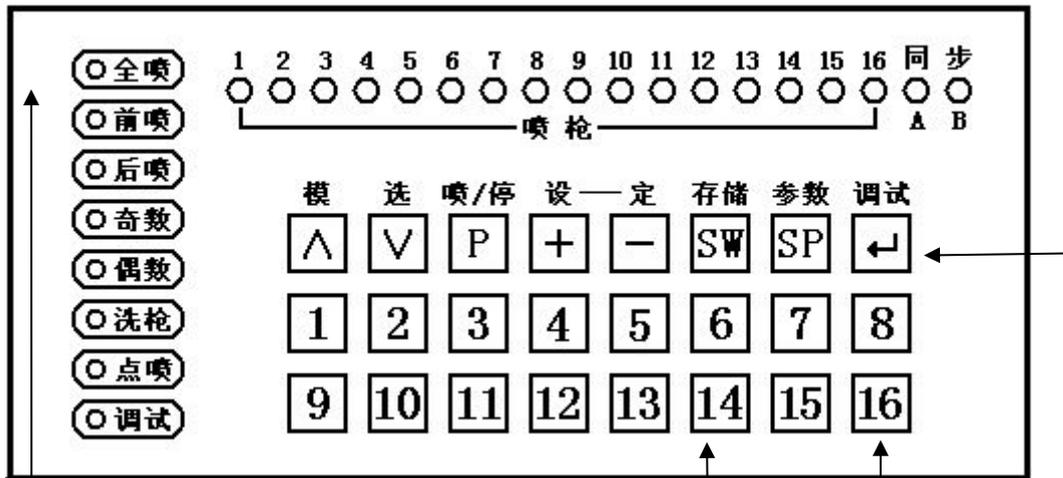
**Parameters key:** Click here to enter the parameter setting

**Storage key:** parameter setting is completed to save

**Set the key:** parameter settings to increase or decrease

**Mode selection key:** to move the cursor up and down arrows





Before spraying and after spraying, single number, double the number of points, spray,

Washing gun, spray the

whole key operations: (see Figure 2 below),

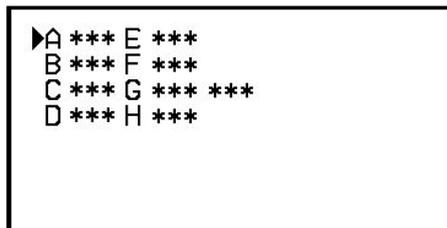
Control panel 1-16 digit keys: You can individually control the corresponding spray gun)

This feature can be used to clean or debugging a single gun

Optical scan self-test failures: 16 keys

### ③ parameter setting interface description

According to parameters of key, the screen is set to enter the following states:



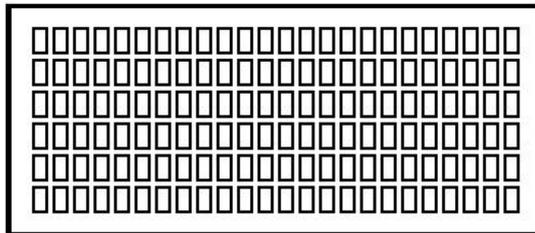
Code	Parameters	Function
A	021	Set-ray scanning to the distance from the front wheel
B	043	Set dial back-end location tracking
C	000	Not work
D	050	Set to send the incremental sampling
E	210	Wheel radius
F	128	Set phototube number(2.5 cm for each)

<b>G</b>	074 000	Set tone round, after the three-digit adjusted to zero for the correct (limited to between 50-85)
<b>H</b>	001	Phototube about adjustment (from the installer when debugging use)

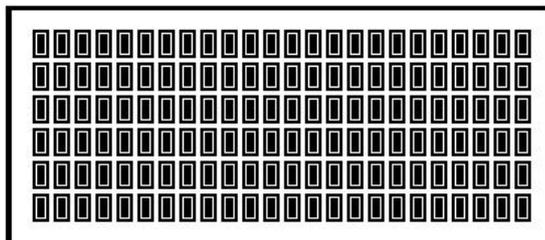
**Note:** The above setting is usually in the new machine (or computer) must be first used before the operation, set up is completed, the computer will automatically remember. The next boot without the need for repeat settings.

#### ④ self Interface Description

If machine to run exception, may use this feature to quickly check for problems. Press 16 key to enter the self-test ,Interface (Press any key to return to the main interface).



**Note:** The above diagram each box represents a scan point, when the scanning point is working properly and no objects blocking the scanning point of light when the box is hollow.



**Note:** When an object is scanned point is damaged or blocked, when the scanning point light box is solid.

#### ⑤ computer operation note

To keep the keyboard clean: tanneries shotcrete machine operatives will often operate with gloves or with oil paint stick to leather on the keyboard, resulting in ambiguous keyboards.

Do not arbitrarily change the settings: Unless you are sure to learn how to set up and vice versa should not arbitrarily adjust the settings, leading to equipment failure or inability to run;

Optical scan should always clean: optical scan, if dirty, covered with dust will affect the sensitivity of the computer;

Cleaning spray room, beware of the water spills in the optical-scan;

## ⑥ Computer Installation Notes

If you're just Fengmi users, your computer should be installed Note:

Optical scanning Do not pay too close to the spray chamber: the ideal distance of 80cm or more. Spray too close to the pulp chamber is very likely to spill light on the board or the scan, leading to mechanical failures.

Computers and optical scanning as far as possible away from the converter: the impact of the computer inverter is fatal. Swept the computer using strong anti-interference and shielding the circuit, but the proximity transducer over the computer's influence always present.

The correct use of inverter: Inverter's non-standard wiring and use of the interference will increase the frequency converter, experienced electrical engineers can rule out this point.

### Usual Troubleshooting

Failure	Reason and exclusion program
Indiscriminate spraying	Optical Scan been cover; Inverter interference; Setting error; turntable switch error
monitor too dark	Change the monitor
Do not spraying	Sensors error
Just one gun work	Cable has been Disturb
Some guns does not stop spraying	Transistor broken , Flat wire loose
Sometimes do not spraying	Flat wire loose
Sometimes indiscriminate spraying	Lighting too dark; Parameter setting error
Transmission synchronization's light keep turn on	Proximity Switches Bad
Sometimes can not spraying on to the leather	Proximity Switches Bad
Bead on spraying room's top	Dust box filter plugging
Leakage	Add water too fast, too overflow outlet
Oven's temperature Non-compliance	Less than the amount of steam; thermometer failure
Washing lines dirty	Change brush

### Domestic service:

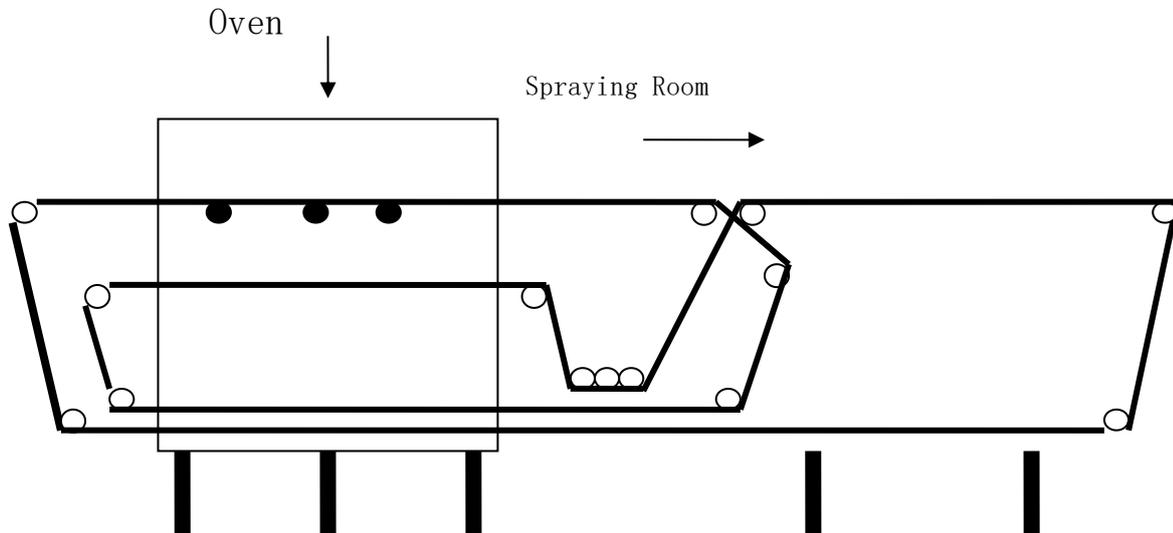
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PS: Picture of walking line



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