

USER MANUAL

Dental Injection System



The Machine designed and Manufactured by our factory ,and The machine is made of 2 parts . one is the pressure casting frame , and the other is automatic temperature controller . The machine have 3 advantaged functions : automatic temperature control , automatic keep temperature and notice on setting time . this machine is improved by old style ,so cooperate more easily . which is the basic necessary equipment both for dental laboratory and clinics .

一. The Main Technical parameter:

power	AC110/60HZ
Rated power	350W

二. SETTING UP:

1.The combined injection machine : first fixed the pressure casting frame on the top of the working station , and the 3 pieces of strength bars tight accordingly . Put the flasks on the bottom base plate of the frame , then the heating furnace will installed up of the flasks (just in the middle of the Columns . the feeder bar should dig into the under hole of heating furnace . Put the heating tube into heating furnace and above of the the feeder bar. and put the cartridge into The heating tube (it is better if you scribble some high temperature oil around the cartridge ,so that can convenient to take off from the heating tube)

2.The part injection machine: please first fixed the pressure casting frame on the top of the working station , and the 3 pieces of stain steal strips tight accordingly . Put the flasks on the bottom flats of the frame . Put the heating barrel into heating furnace which on top of temperature controller , and

put the cartridge into The heating tube (it is better if you scribble some high temperature oil around the cartridge ,so that can convenient to take off from the heating barrel)

3.The Pneumatic injection :Please contact the machine with the air Compressor completely .the air compressor to be adjusted to 0.35mpa-0.4mpa. Put the flask on the base plates of the pressure frame .Put heating furnace Just according to the flask hole ,and equipped on the top of the the two side of columns . please put the feeder bar into the bottom hole of the heating furnace ,Put the heating barrel into the heating furnace ,but must up the feeder the bar (its very important) , Put the cartridge into the heating barrel (it is better if you scribble some high temperature oil around the cartridge ,so that can convenient to take off from the heating barrel)

4. please contact the different wires accordingly.

The combined injection including the power wire ,the ceramic head heating wire ,and the thermocouple wire .

The part injection including : the power wire ,the ceramic head heating wire ,and the thermocouple wire .The pneumatic injection including : the power wire

三. Operation and use

Please open the power swift after equipped completely. The left of temperature controller display meaning the actual temperature of the furnace ,The temperature also can be adopted .first please press the key.  It will set the temperature and will showing shining .meanwhile ,you press “ $\wedge$ ” or “ $\vee$ ” key to adopt to be planed temperature (the factory setting 287degree).after adopting the temperature ,please press key  ,the temperature setting work over .

The right of temperature controller display the times for keeping temperature (factory setting is 480 second) , the time can be adjusted .press the “” . The time data will shine and meanwhile please press “ $\hat{=}$ ” or “ $\hat{=}$ ” key to adjust , after that to confirm , the time setting over

The machine can not increasing temperature constantly when the machine work, until you set the temperature .when reach the setting temperature, time will countdown, the warning sound will happen after countdown. The machine will always do the same working procedure when working time ,after working ,the machine must close .it should open the power again when use the machine again .

During the working procedure ,when heating , the display light is on , when in keeping temperature, the display light is off .

The combined injection : As soon as listening to the warning music ,please take out the feeder bar from the heating furnace, then put into the steel Jacking block, and revolve the 3 piece of hard stick,until the whole pressure casting procedures finish.

The pneumatic injection: As soon as listening to the warning music ,please take out the feeder bar from the heating furnace, then put into the steel Jacking block, and revolve the 3 piece of strength bar,until the whole pressure casting procedures finish

The part injection:As soon as listening to the warning music,please take take out the heating barrel and the cartridge to the top of the flasks , then put into the steel jacking block ,remove the 3 pieces of strength bar ,until whole pressure casting procedure finish .

after the pressure casting ,please bow out the empty cartridge ,if the temperature cold down ,its hard to bow out

it .

Remark : Different Altitudes of different place ,different seasons all will influence the heating temperatures of heating and times of keeping temperature . If the casting material color much darker, you should set the temperature higher and keep long time for temperature . if the casting material color much lighter ,you should down set the temperature lower and keep short time for temperature.

四: The FAQ and Solutions :

If the indicator light on but furnace not heat , The reason maybe be caused by the the heating coil of furnace broken. Suggest you change new hearing coil just OK

If the indicator light off ,and the furnace not heat ,please check the setting temperature lower than the furnace temperature or not , suggest set the temperature again

If the temperature showing :” — ”, caused by the thermocouple broken or connecting in wrong location . suggest change the new thermocouple or connect again

If the cartridge always explosion, caused by the the inaccurate temperature sensing, pls check the thermocouple if loose contact or not