UV24 Operator's Manual

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SAFETY INFORMATION

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Ⅰ. Shipping, handling, and installing the equipment.

1. The equipment is packed in a wooden crate. The crate and packing are water and vibration proof and suitable for land, air or sea transportation.

When crate is transported, it can be moved by forklift or crane (1 ton capacity). Use the bottom planks of the box as the support area to unload the box. If the equipment is exposed, please do not use crane, hanger, or round iron pipe to move it.

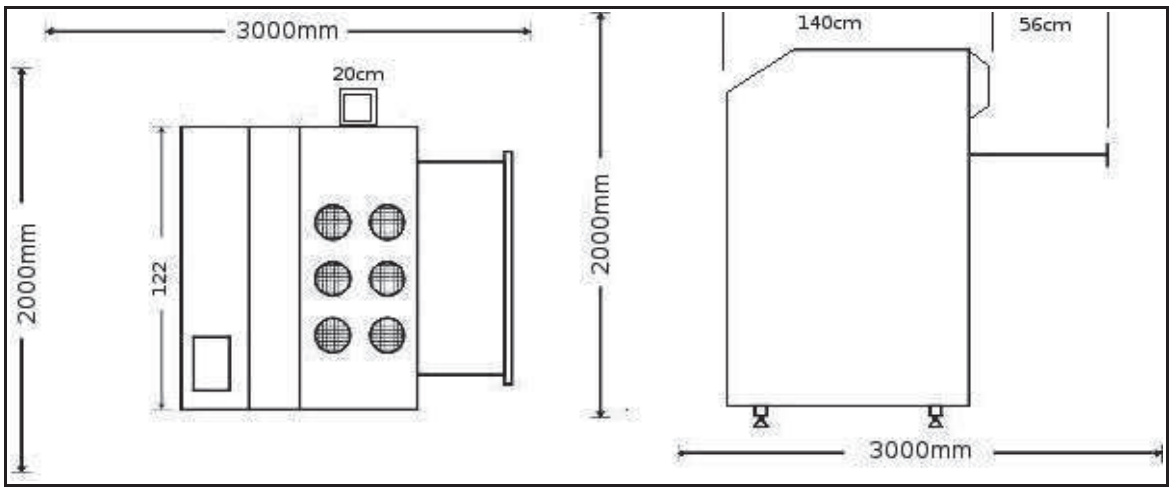
There are 4 wheels installed on the equipment for easy movement. Storage temperature: -20 to 60℃ during short term transportation period. Ambient humidity: 20 to 95% RH (non-condensing).

2. Size and weight

Models UV24 UV24-HA	Crated dimensions and weight		Equipment	
	Weight	Length×width×height	Weight	Length×width×height
	640Kg	147(L)x133(W)x148(H)	540Kg	140(L)x122(W)x132(H)
	1400Lb	58”(L)x52”(W)x79”(H)	1180Lb	55”(L)x48”(W)x52”(H)

3. Space required for operation

Space required for UV24 and UV24-HA length x width x height	3000mm×2000mm×2000mm
	120in×80in×80in



4、 Operating Environment

The equipment should be located in a clean (low dust) environment with good ventilation and no direct sunlight. Room temperature: 5-40℃. Humidity: under 95%.

5、Power source for UV24 and UV24-HA

1φ220V AC 50/60Hz 3.5 to 5.5KW (SEE NAMEPLATE)

Ⅱ. Noise, UV radiation, and danger warnings

★After the machine is started, the fan will emit a blowing noise within the normal limit. If the operator feels uncomfortable, please wear earplugs.

★UV radiation will be emitted by the UV curing lamp. All direct UV radiation has been shielded, but repeated exposure to reflected UV light can still cause eye damage.

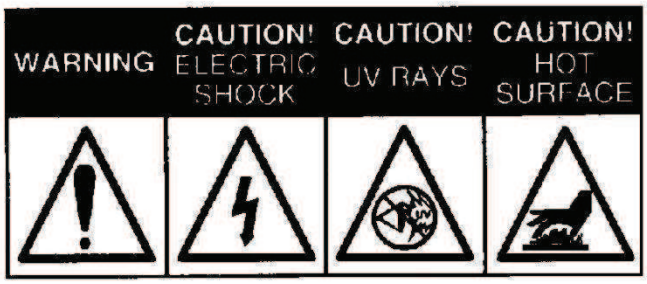
Warning: when the UV lamp is lit, always wear UV blocking glasses to avoid eye damage. Never open the rear cover of the machine when the UV light is lit. Never look directly at the lit UV lamp. UV Glasses have been provided with the machine.

★Before you replace the UV lamp, please read the replacement instructions. Then follow the instructions to avoid exposure to high voltages and possible damage to the new UV lamp.

Ⅲ. Environmental considerations when dismantling or scrapping the equipment

★ Do not burn, crush, or puncture the high voltage capacitor.
★ Do not burn any component made with rubber or plastics.
★ Before you dispose of any components covered with uncured UV lacquer, expose the components to sunlight for 1-2 days to solidify the UV lacquer.
★ Metal components can be recycled normally.
★ The UV lamp contains mercury. Follow local laws when disposing.
★ It is suggested that you use the services of a professional environmental recycling company when dismantling and scrapping the equipment.

Ⅳ. Explanation of safety and warning symbols



Location:

Mounted on rear cover.

Explanation:

- Warning symbol
- Caution electric shock
- Caution UV radiation
- Caution hot! Burn hazard!

Location:

Mounted on the front cover.

Explanation:

Wear rubber gloves when handling UV liquid. Avoid skin contact with UV liquid. Use soap and water to remove UV liquid from the skin. Never use solvent to clean UV liquid from the skin.
Wear eye protection when handling UV liquids!

Location:

Mounted on the control panel door.

Explanation:

- Electrical hazard!
- Danger: Lethal voltage! Do not touch components inside. Access restricted to qualified electrical technicians.

Location:

Mounted on the high voltage compartment door.

Explanation:

- High voltage warning
- Danger: Lethal voltage! Do not touch components inside. Access restricted to qualified electrical technicians.

Ⅴ. Safety measures

Location:

Mounted on dryer motor access door.

Explanation:

Caution: Pinch hazard. Keep hands away from moving parts. Stop dryer transport before opening door.

Location:

Mounted on front and rear covers.

Explanation:

Danger: UV radiation. Wear UV blocking glasses when operating machine. Wear UV blocking glasses when working near the machine.

Note: Read and understand the MSDS that is included in the shipment of your coating products. The MSDS contains more complete and specific information than is provided here.

1. ***The properties of UV liquids and the effects of bodily contact.***

Endangering effects:

★Repeated skin contact will result in skin rash. Wear gloves. In the event of contact, wash *immediately* with soap and water. Never use solvents to clean skin. Solvents will drive the irritating chemicals into the skin making matters worse.

Cured UV lacquer is safe to handle and has no endangering effects.

★If it is inhaled, it will irritate the upper-respiratory tract and make you feel unwell. Use proper ventilation, when working with UV chemicals.

2、First-aid measures

First-aid measures for different exposures：

★Skin contact： Wash immediately with soap and water. Remove contaminated clothing. If irritation persists, seek medical attention.

★Inhalation： Move to fresh air. Consult physician / medical help if respiration is not relieved by fresh air.

★Eye contact： Rinse eyes immediately with large amount of water for at least 15 minutes, and contact physician as needed.

★Ingestion: Wash out mouth with water, do not induce vomiting, contact physician.

3、Fire fighting measures and cleaning up accidental spills：

Extinguishing fire:

★Suitable extinguisher preparation: Chemical dry powder, foam, sand, CO2, halon.

★Water spray can be used, never use direct water-jet.

Cleaning up spills:

Personal protection requirements:

★Rubber gloves, eye protection, ventilation.

Cleaning method:

★Use absorbent materials.

★Dispose materials in accordance with local regulations.

★Use detergents and water or solvents to remove last vestiges of spilled material.

★Direct sunlight will cause liquid to cure and harden.

Operating Instruction Contents

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Main Technical Specifications:

Model: UV24

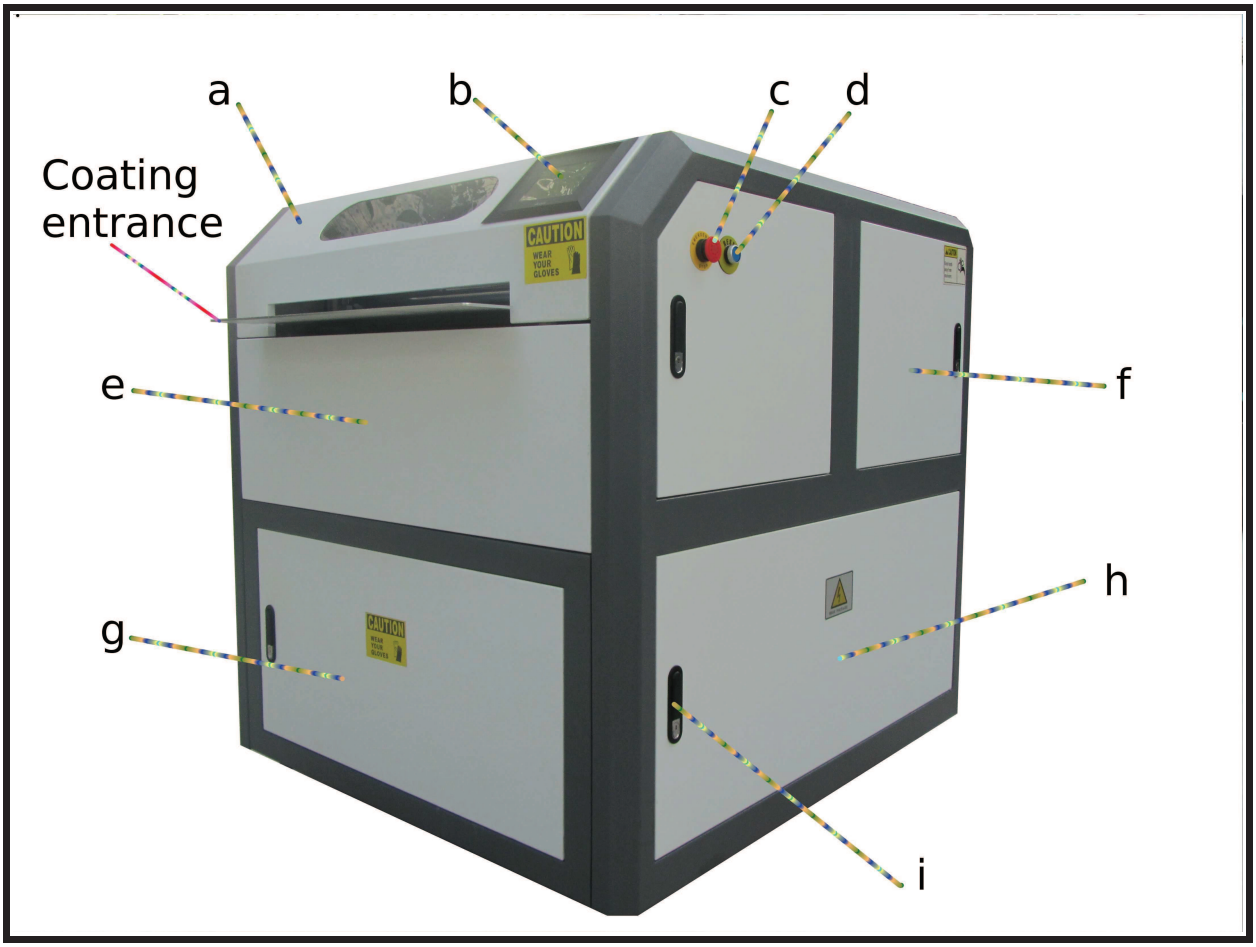
·Max. Coating width: 620mm (24”)
·Max. Coating speed: 30m/min (100 fpm)
·Max coating material thickness: 3mm
·Max coating thickness: 20 microns
·Power :1φ220V 3.5 to 5.5KW (see nameplate)

Model: UV24-HA

·Max. Coating width: 620mm (24”)
·Max. Coating speed: 30m/min (100 fpm)
·Max coating material thickness: 25mm
·Max coating thickness: 20 microns
·Power :1φ220V 3.5 to 5.5KW (see nameplate)

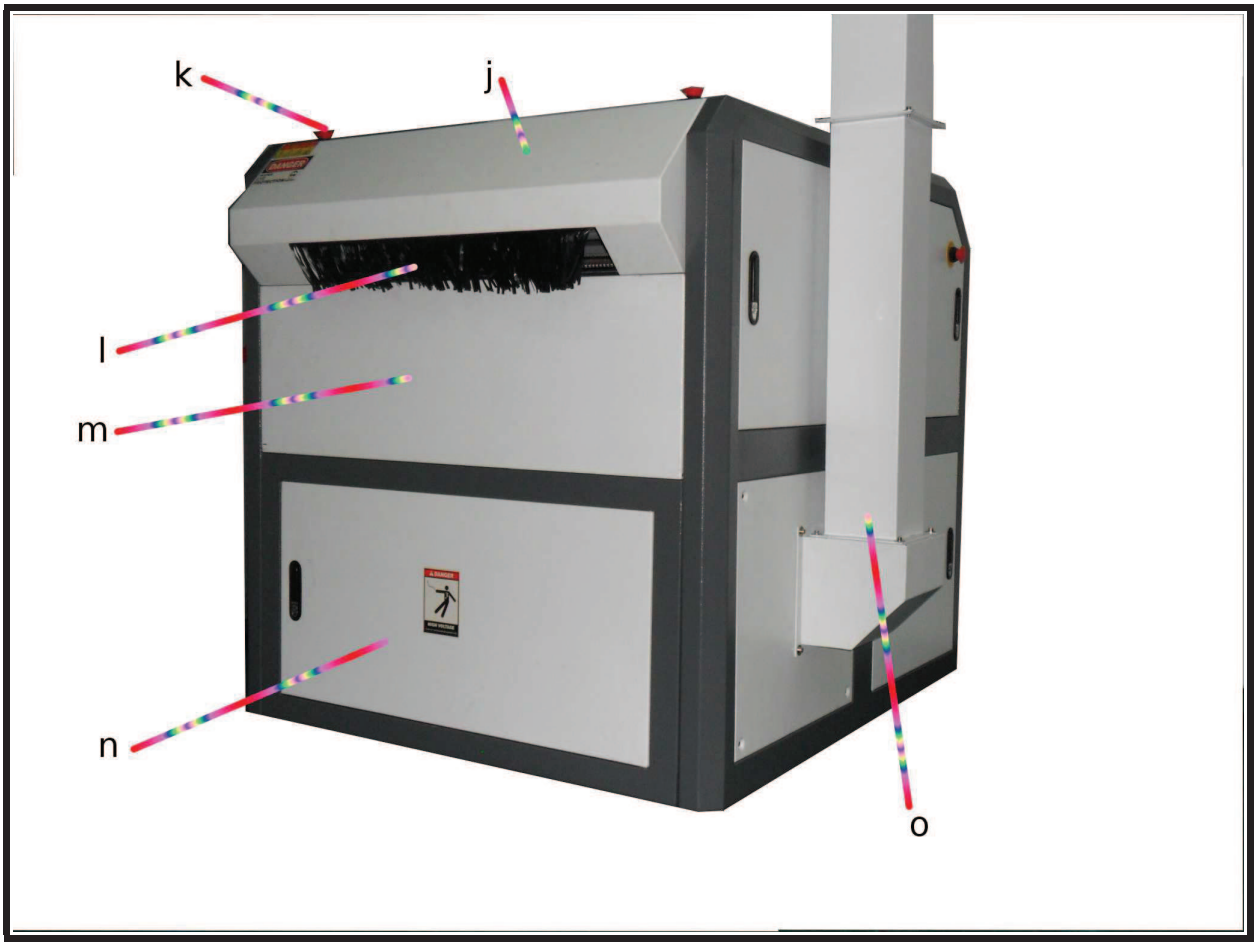
Overview

Front View:



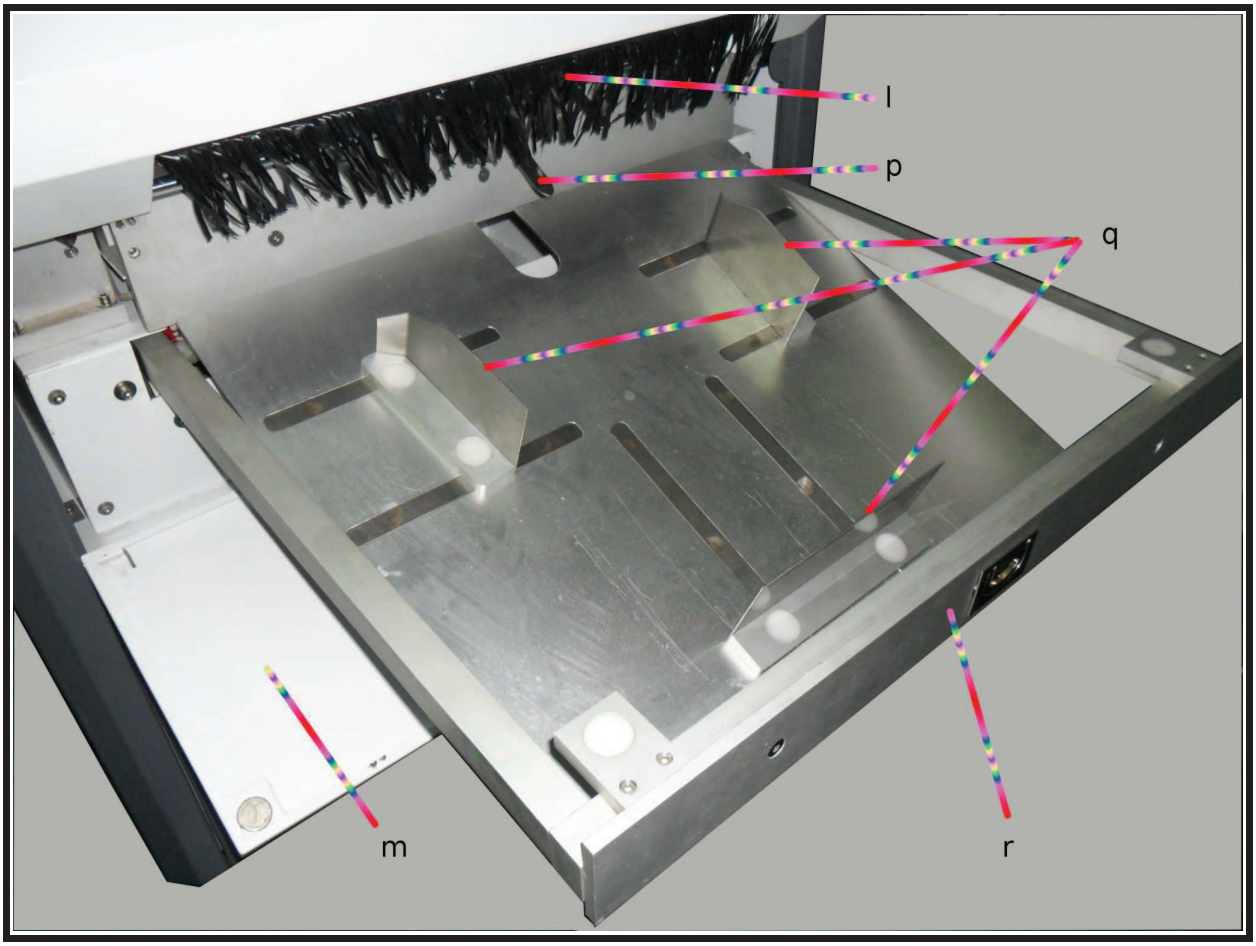
a) Front top cover
b) Touch screen
c) Emergency stop
d) Reset push button
e) Drain tank cover
f) Dryer motor cover
g) Coating liquid cabinet
h) Electric control cabinet
i)Lock

Rear View:



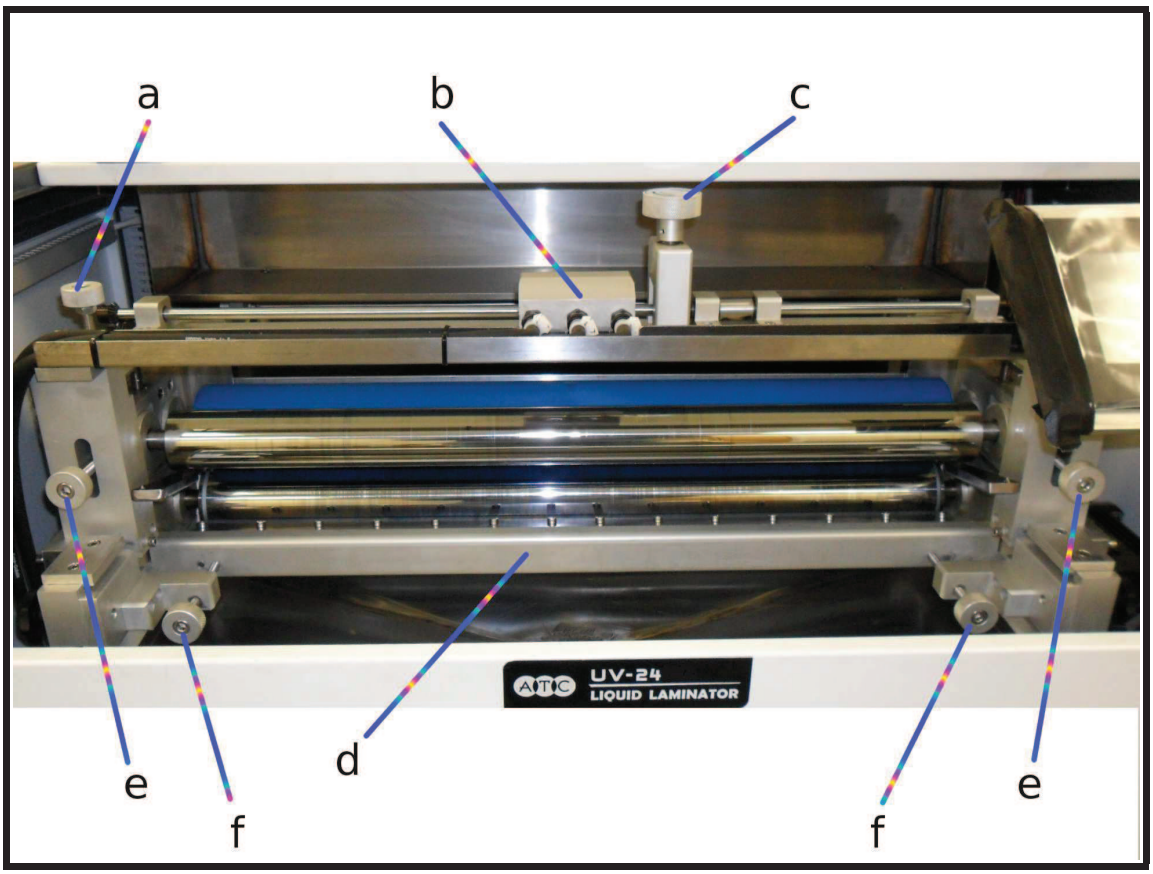
j) Rear top cover
k) Emergency stops
l) Dryer exit
m) Catch tray cover
n) High voltage compartment
o) Ventilation stack

Catch tray:



l) Dryer exit
m) Catch tray cover
p) Exit guide finger
q) Magnetic stacking guides
r) Pull out catch tray frame

Coating rack adjustments.

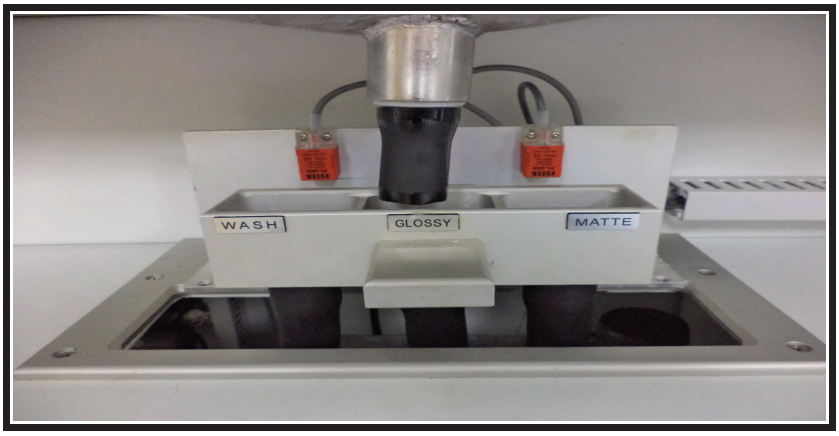


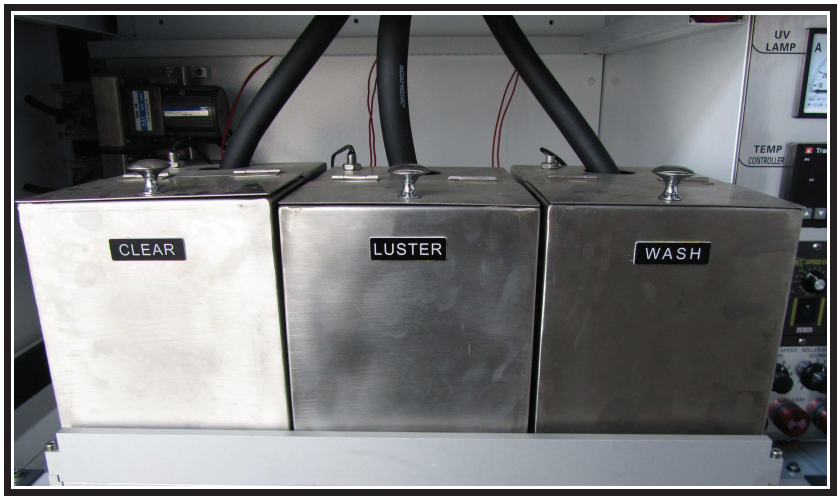
a) Rack locking screw, fastens rack in position.
b) Lacquer feed tubes.
c) Coating roller nip manual adjustment.
d) Bottom roller scraper (keeps back of print clean).
e) Left and right pinch roller adjusting screws.
f) Left and right scraper adjusting screws.

Note: When shutting down the machine loosen "e" and "f" adjusting screws. Raise the rubber roller to a position off of the bottom roller using by programming height at power off (second screen under Roller Settings).

Always remove pressure from the coating roller when the rollers are not turning.

Coating liquid, pump and drain settings.





Electronic drain interlock:

★To avoid cross contamination of the liquids, the drain position must match the pump selection on the touch screen.

★ The pump will not run until the positions match.

★Allow sufficient drain time (10-15 minutes) before switching to another coating to avoid the mess of flowing lacquer at the tank drain when you switch connections.

★You will need to wash the rack when you change from matte or luster to clear coating to avoid introducing matting agent into your glossy lacquer.

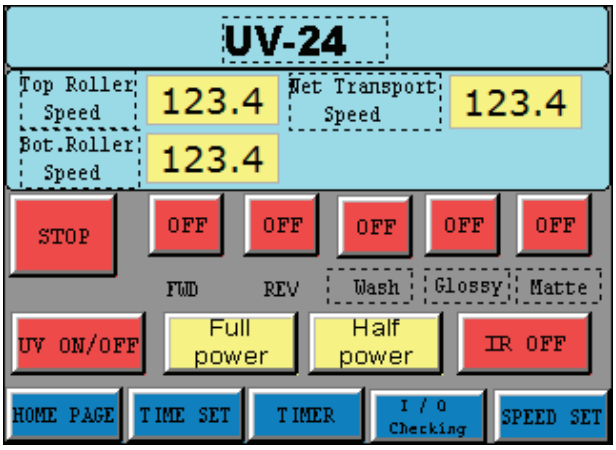
Draining the rack, scraper and tank:

★Turn pump off.

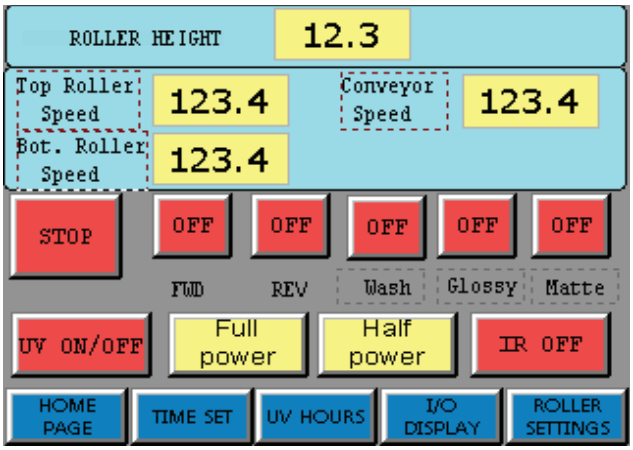
★ Allow the rack to run, with rollers touching (same speed) and scraper engaged for 10-15 minutes.

UV24 and UV24-HA Screens

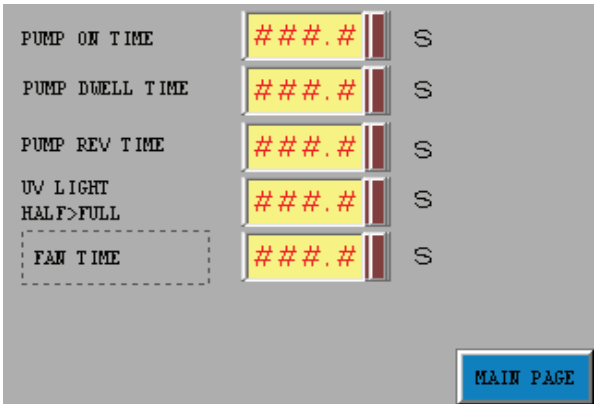
Opening screen. “Home Page”. Press “English” to go to Main Page.



Main UV24 screen. “Main Page”. Readouts for roller and conveyor speeds. Push buttons for rollers, UV conveyor and lamp, IR, and pumps. Drain setting must match intended pump selection for pump to turn on. Along the bottom are “Go to” push buttons for screens with adjustments.



Main UV24-HA screen. “Main Page”. Readouts for coating roller gap, roller and conveyor speeds. Push buttons for rollers, UV conveyor and lamp, IR, and pumps. Drain setting must match pump selection. Along the bottom are “Go To” push buttons for screens with adjustments.

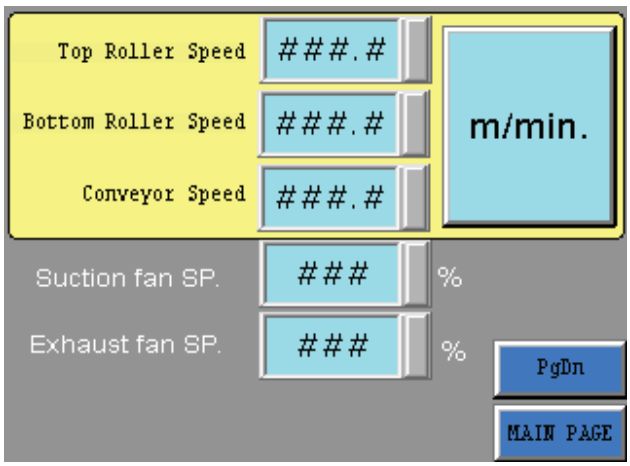


“Time Set” screen.

Pump cycle time determined by ratio of On to Dwell time. Pump reverse (3-5 seconds) eliminates drips from nozzle.

UV light Half>Full and fan time are technical settings for the UV lamp warm up cycle. It is recommended not to change these without first consulting factory.

Roller screens:



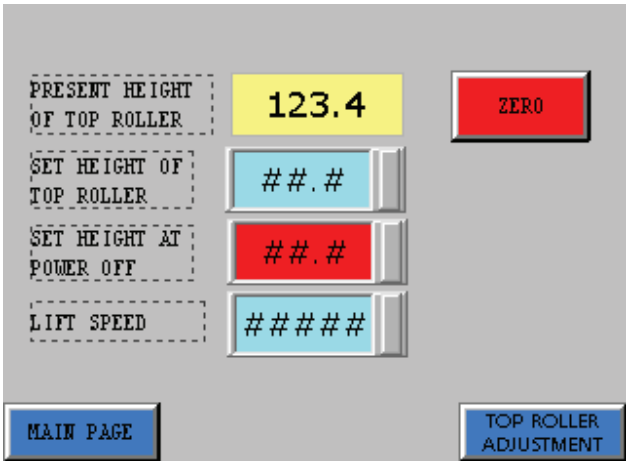
Roller Settings screen.

Set roller and conveyor speeds.

Change readout from m/min to ft/min.

For extremely thin materials the fans under the conveyor mat can be set to have reduced suction.

Exhaust fan setting is a technical setting, call factory before changing.



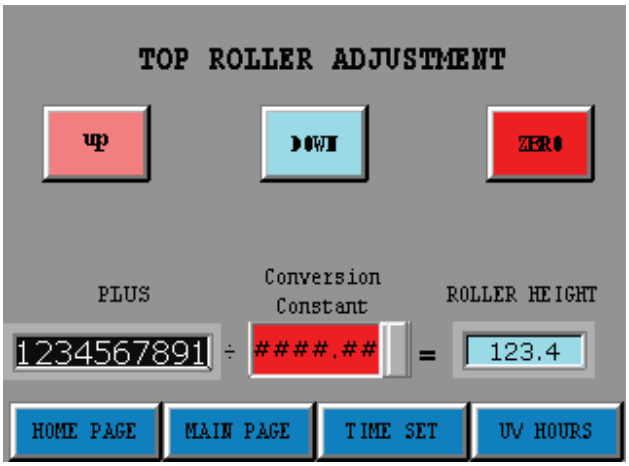
UV24-HA only:

"PgDn" from "Roller Settings"

Roller height readout.

Set roller height (roller gap). This is where you set the rollers for your material thickness.

Set height after power off.
Lift Speed is a technical setting: step motor stepping speed.



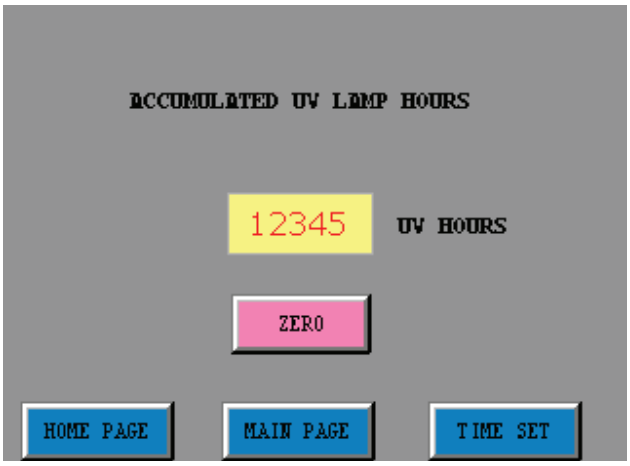
UV24-HA only:

Top Roller Adjustment from screen above.

Conversion constant is a technical setting,
Changing this setting will change accuracy of the roller height readout.

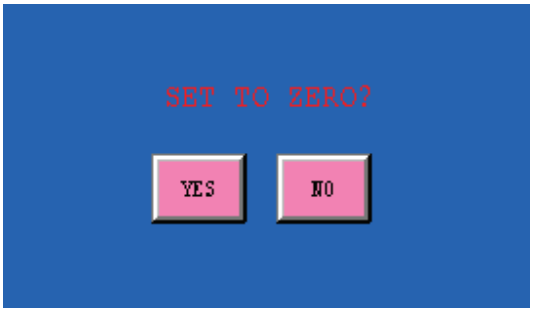
UV Lamp screens:

Accumulated hours. Reset to zero when replacing old lamp with new lamp. UV lamps have a lifespan of 750 to 1000 hours (depending on the number of starts—more starts will shorten the life span of the lamp). Knowing the hours will help troubleshoot curing problems.

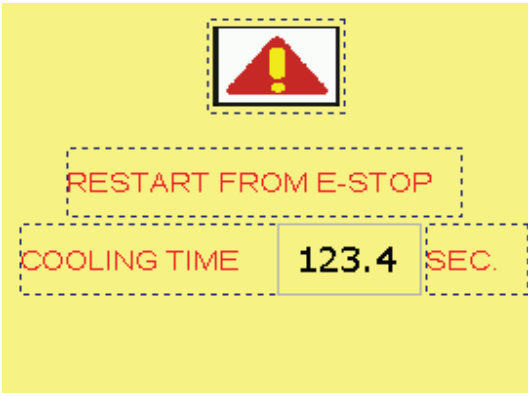


"UV Hours" from Main Page

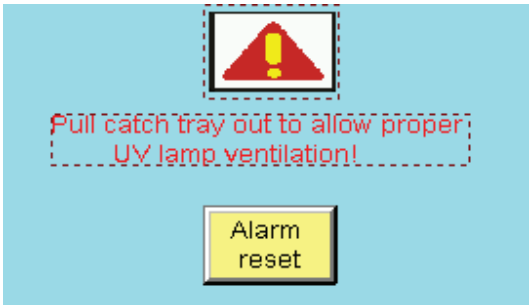
The code to access this screen is "22222222".

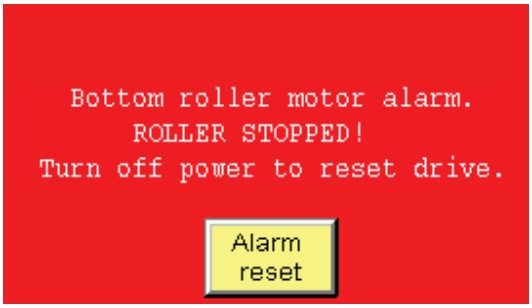


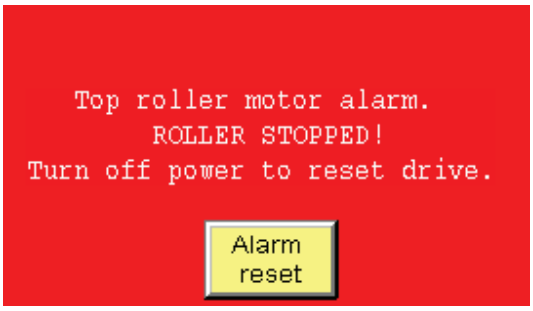
Restart from E-stop. The UV lamp must be cool to restart. This screen ensures that the lamp is cool.

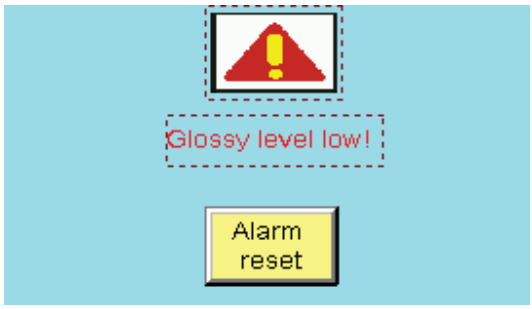


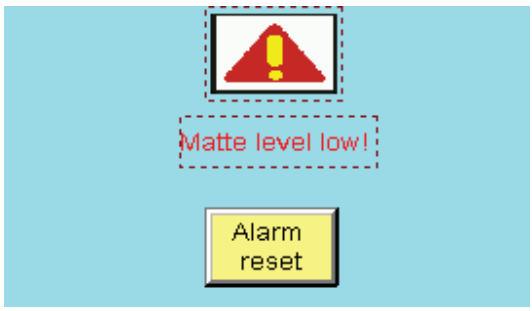
Pop up warning screens:











Technical Screens:

PLC inputs and outputs. “I / O Display” from Main Page

X0	Phase A		X7	Wash drain
X1	Phase B		X10	Glossy level
X2	Photoeye		X11	Matte level
X3	Lacquer rack upper limit		X12	Wash level
X4	Lacquer rack lower limit		X13	Coating roller motor alarm
X5	Glossy drain		X14	Bottom roller motor alarm
X6	Matte drain		X15	Rear top door safety switch.

MAIN PAGE PgDn

X16	Temperature protection				
X17	Blower overload				
X20	Drain pan out of position.				
X21	Catch tray not pulled out.				

MAIN PAGE PgUp PgDn

Y0	Step pulse		Y7	UV Full
Y1	Step direction		Y10	IR light
Y2	Suction fan		Y11	Glossy FWD
			Y12	Glossy REV
Y4	Exhaust fan		Y13	Matte FWD
Y5	Alarm		Y14	Matte REV
Y6	UV Half		Y15	Wash

MAIN PAGE PgUp PgDn

Y23	Conveyor belt drive	
Y25	Forward	
Y26	Reverse	

PgUp

MAIN PAGE

Start up check list.

1) Lacquer coating rack.

a) ***Adjust the scraper.*** Turn right and left scraper knobs until the scraper blades touch the bottom roller on both sides. Then turn ½ turn more. Do not over tighten. You will need to check this adjustment later when you are running lacquer in the rack. The scraper prevents lacquer from being transferred to the backs of the prints.

b) ***Adjust the pinch roller.*** Turn the right and left pinch roller knobs until the pinch roller just touches the coating roller. Then turn ¼ turn more. Look at the evenness of the lacquer across the roller. Adjust the knobs for an even application of lacquer across the top face of the coating roller.

c) ***Adjust roller speeds.*** It is possible to (minimally) control coating thickness with the pinch roller setting. More pressure less coating. A more productive technique uses roller speeds. Higher speeds for the coating roller relative to the bottom roller will result in thicker coatings. Lower speeds of the coating roller relative to the bottom roller will result in thinner coatings.

2) Pump and drain.

a) ***Select the drain setting*** to match the pump and liquid you will be using.

b) ***Check the liquid level*** in the tank.

c) You may have to adjust the pump cycle time in the touch screen control "Time Set" section. Adjust the pump setting so that lacquer travels to the ends of the rollers in the top nip. At higher roller speeds you will need to pump more lacquer.

d) ***Start the pump.*** Let the machine run for a few minutes. Then check that the lacquer in top nip has spread to both ends. Double check the scraper to make sure the bottom roller is scraped clean.

Start up check list (cont.)

3) UV section.

a) ***Lamp clearance.*** The height of the lamp is adjustable. The lower the lamp the more power delivered to the coating and substrate. However when running materials with thick substrates, check to make sure the lamp is high enough for the items to pass under.

Caution: High voltage in lamp section! Turn off machine and wait five minutes for capacitors to discharge. Caution: Hot! Allow lamp to cool to room temperature before adjusting

b) ***Catch tray.*** The catch tray stores inside the machine for shipping.

Warning: Before starting the machine the first time, pull out the catch tray to allow the UV lamp to cool.

Shutting down.

1) Drain the rack. See “Coating liquid, pump and drain settings." for details.

2) Separate the rollers. See "Coating rack adjustments." for details.

Cleaning the Machine.

1) Follow the start up check list.

2) Choose the Wash pump, set the drain, reduce the pump time. Thin wash liquids pump more easily and in greater volumes. Reducing the pump cycle time adjusts the liquid flow to better match the rack speed and prevents excessive overflow at the ends of the top nip.

3) The machine is cleaned by cycling the coating rack. Run the rollers at the same speed and touching, with the scraper engaged, for 15-20 minutes. Then follow the shut down procedure.

How to replace UV tube.

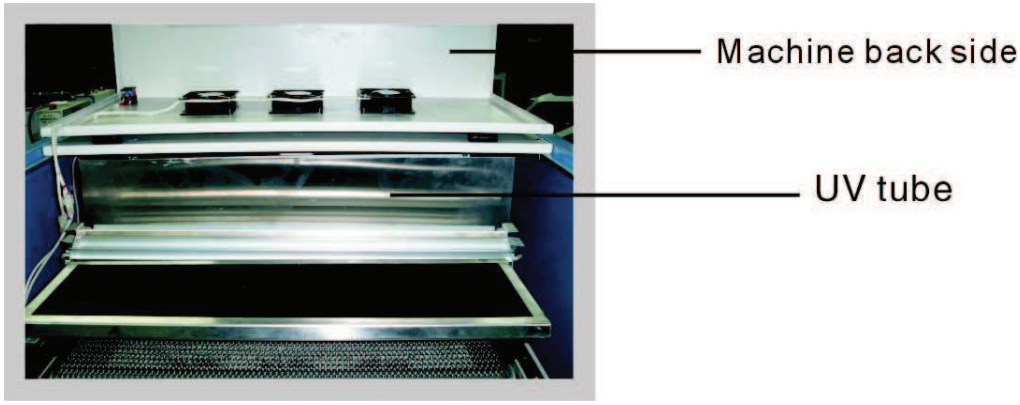
★UV tube life 800-1000 hours.

★The reflector and UV tube should be at room temperature.

★***Danger high voltage!*** Disconnect all power to the machine.

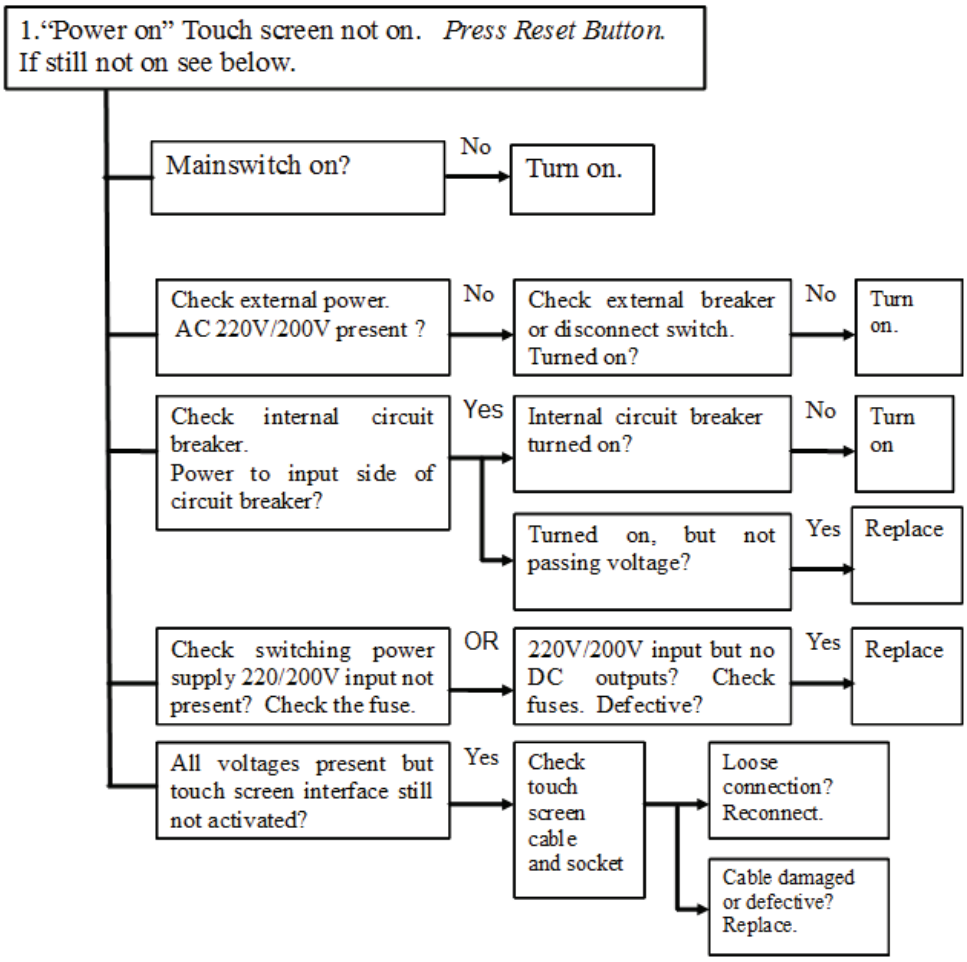
1) Open the rear top cover of the machine.
2) Loosen 2 reflector screws.
3) Loosen the lamp wire screws.
4) Remove the UV tube and install new one.

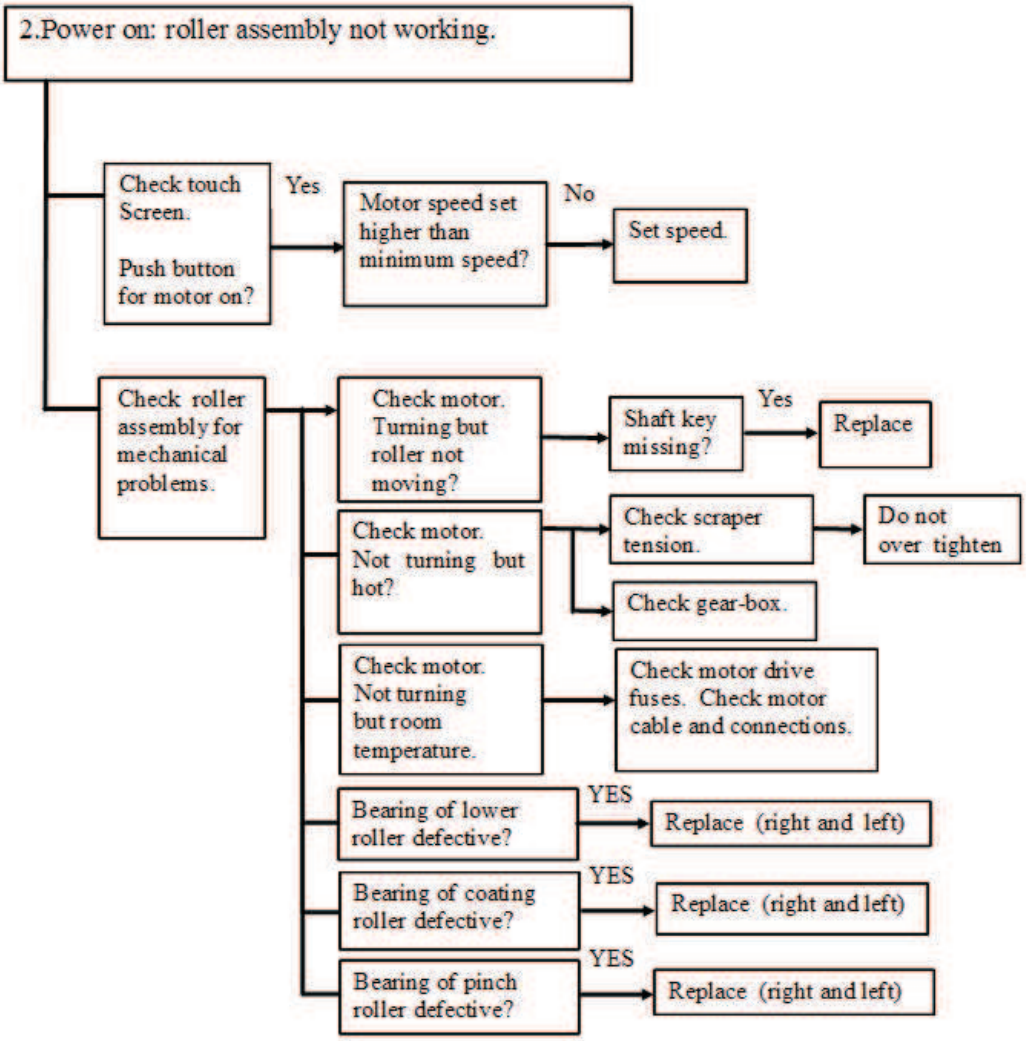
Warning: Never touch the UV tube surface with your fingers. Wear cotton gloves or handle with clean paper towels. Wipe the surface clean with alcohol. Oil from your fingers left on the lamp can cause the quartz envelope to fail at high heat.

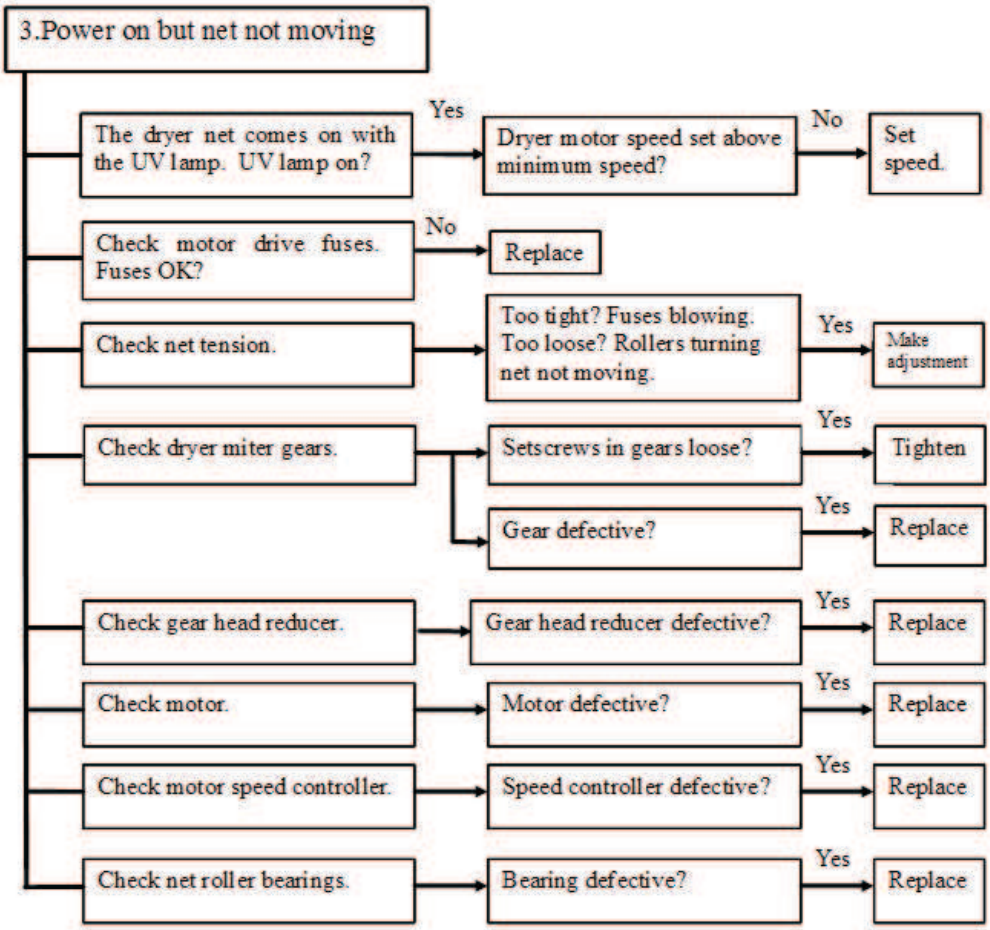


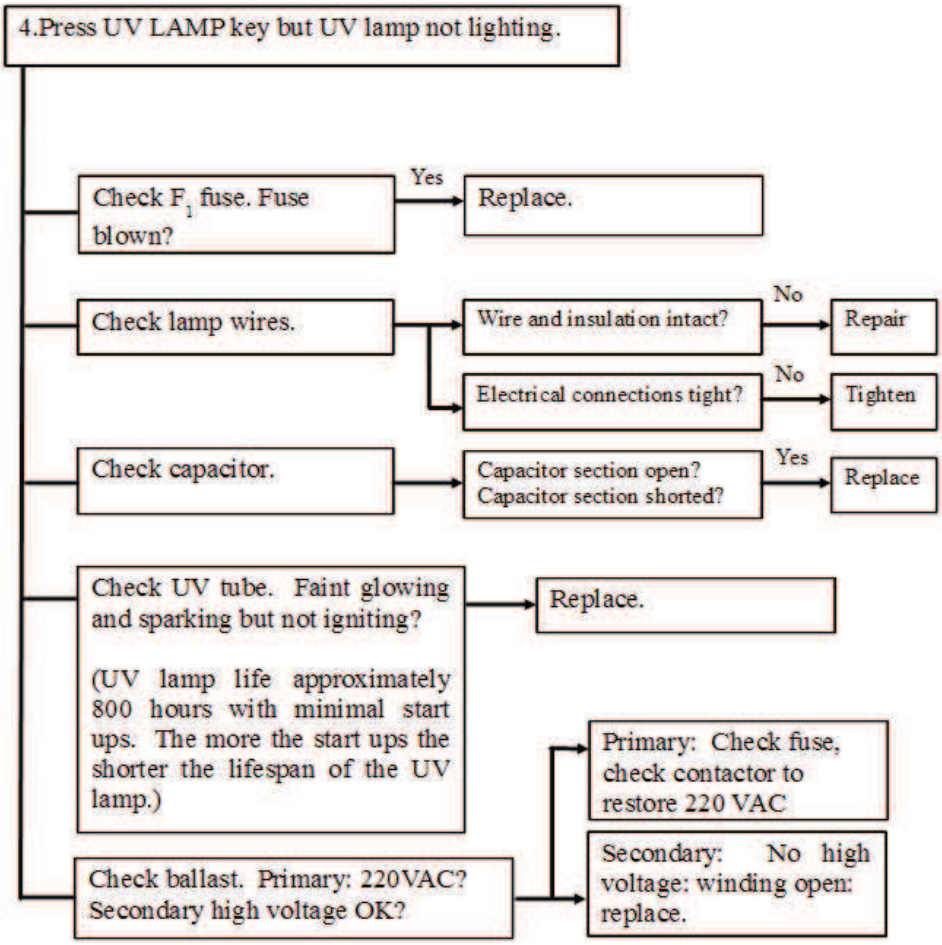
Trouble shooting

1. Touch screen not coming on.....23
2. Roller assembly not turning.....24
3. Dryer net not moving.....25
4. UV lamp not lighting.....26
5. UV lamp output diminished.....27
6. Pump not supplying liquid.....28


1.“Power on” Touch screen not on. Press Reset Button.
If still not on see below.
Mainswitch on?
No
Turn on.
Check external power.
AC 220V/200V present ?
No
Check external breaker or disconnect switch.
Turned on?
No
Turn on.
Check internal circuit breaker.
Power to input side of circuit breaker?
Yes
Internal circuit breaker turned on?
No
Turn on
Turned on, but not passing voltage?
Yes
Replace
Check switching power supply 220/200V input not present? Check the fuse.
OR
220V/200V input but no DC outputs? Check fuses. Defective?
Yes
Replace
All voltages present but touch screen interface still not activated?
Yes
Check touch screen cable and socket
Loose connection? Reconnect.
Cable damaged or defective? Replace.

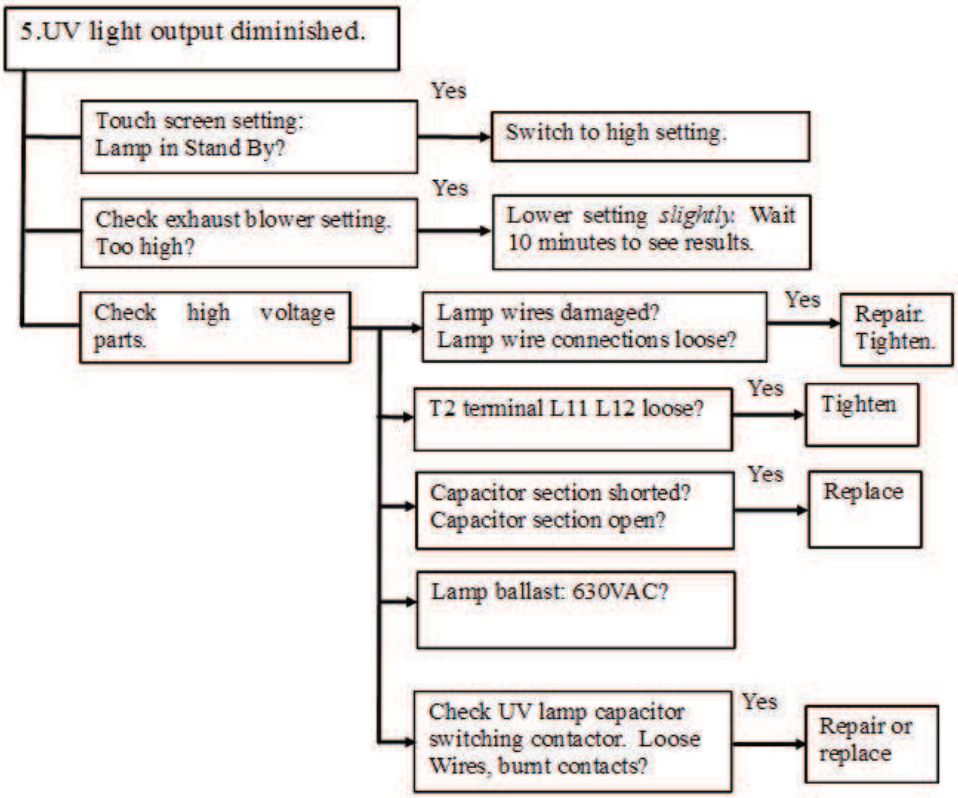

2.Power on: roller assembly not working.
Check touch Screen.
Push button for motor on?
Yes
Motor speed set higher than minimum speed?
No
Set speed.
Check roller assembly for mechanical problems.
Check motor. Turning but roller not moving?
Shaft key missing?
Yes
Replace
Check motor. Not turning but hot?
Check scraper tension.
Do not over tighten
Check gear-box.
Check motor. Not turning but room temperature.
Check motor drive fuses. Check motor cable and connections.
Bearing of lower roller defective?
YES
Replace (right and left)
Bearing of coating roller defective?
YES
Replace (right and left)
Bearing of pinch roller defective?
YES
Replace (right and left)


3.Power on but net not moving
The dryer net comes on with the UV lamp. UV lamp on?
Yes
Dryer motor speed set above minimum speed?
No
Set speed.
Check motor drive fuses. Fuses OK?
No
Replace
Check net tension.
Too tight? Fuses blowing. Too loose? Rollers turning net not moving.
Yes
Make adjustment
Check dryer miter gears.
Setscrews in gears loose?
Yes
Tighten
Gear defective?
Yes
Replace
Check gear head reducer.
Gear head reducer defective?
Yes
Replace
Check motor.
Motor defective?
Yes
Replace
Check motor speed controller.
Speed controller defective?
Yes
Replace
Check net roller bearings.
Bearing defective?
Yes
Replace



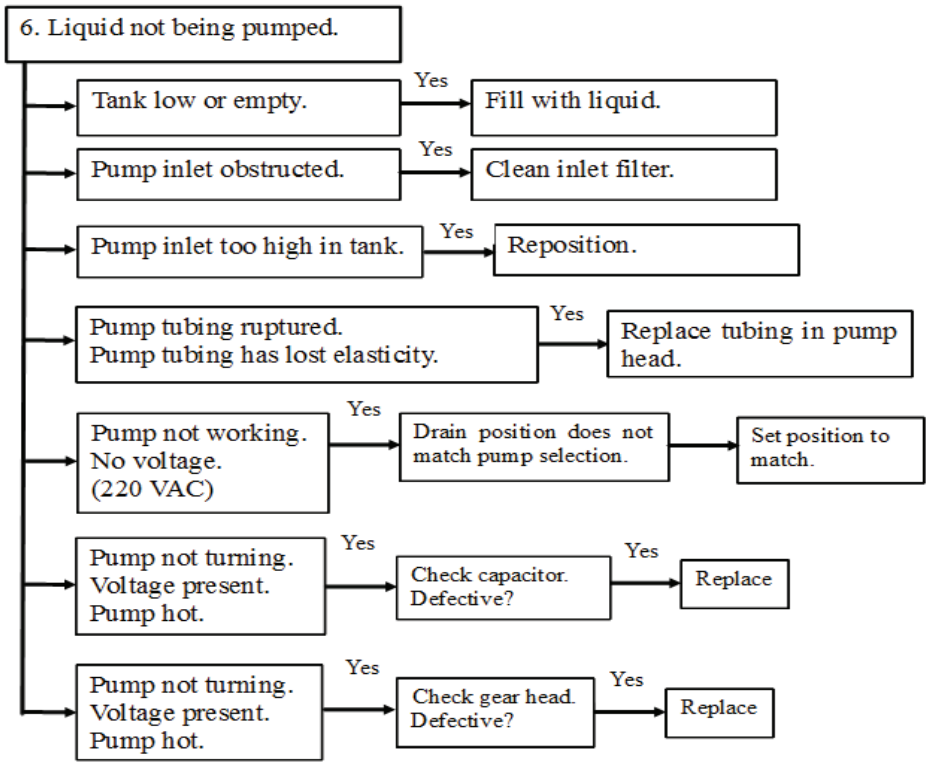
Caution: High voltage lethal. Troubleshooting requires a qualified electrical technician with a voltmeter rated for 1000VAC. Allow 5 minutes for capacitors to discharge.

Reference :UV light circuit diagram



Caution: High voltage lethal. Troubleshooting requires a qualified electrical technician with a voltmeter rated for 1000VAC. Allow 5 minutes for capacitors to discharge.

Reference :UV light circuit diagram



Reference :Liquid supply control circuit diagram

List of the parts and components

Part number	Part name	Part number	Part name
ATC-24001	Cover, front upper	ATC-24040	Scraper holder
ATC-24002	Cover, front middle	ATC-24041	Tension block, left
ATC-24003	Cover, front lower	ATC-24042	Tension block, right
ATC-24004	Frame, touch screen	ATC-24043	Gear
ATC-24005	Touch screen	ATC-24044	Gear
ATC-24006	Window	ATC-24045	Bottom roller
ATC-24007	Hinge	ATC-24046	Reducer 1:15
ATC-24008	Lock	ATC-24047	Motor 120W
ATC-24009	Leveling foot	ATC-24048	Threaded rod, up/down
ATC-24010	Table, entrance	ATC-24049	IR tube
ATC-24011	Door, rear right	ATC-24050	Reflector
ATC-24012	Door, front right	ATC-24051	Bracket, IR unit
ATC-24013	Restart switch	ATC-24052	Stepping motor (option)
ATC-24014	Emergency switch	ATC-24053	Ceramic terminal block
ATC-24015	Door, lower right	ATC-24054	Sensor, limit
ATC-24016	Body side frame, right	ATC-24055	Air cylinder (option)
ATC-24017	Body side frame, left	ATC-24056	Bracket (option)
ATC-24018	Filter set	ATC-24057	Holder, tubing (option)
ATC-24019	Cover, rear middle	ATC-24058	Tubing high temp. (option)
ATC-24020	Door, rear lower	ATC-24059	Tubing, air
ATC-24021	Chamber, exhaust	ATC-24060	Channel for tubing
ATC-24022	Adapter, chamber	ATC-24061	Tubing, liquid
ATC-24023	Door, lower left	ATC-24062	Cylinder (option)
ATC-24024	Door, upper left front	ATC-24063	Bracket, cylinder(option)
ATC-24025	Door, upper left rear	ATC-24064	Bracket
ATC-24026	Cover, lower left	ATC-24065	Shutter, upper
ATC-24027	Light shield fabric	ATC-24066	Holder, air tubing(option)
ATC-24028	Rotary knob	ATC-24067	Transport net
ATC-24029	Bracket	ATC-24068	Air tubing (option)
ATC-24030	Bearing set	ATC-24069	Needle valves (option)
ATC-24031	Lacquer supply head	ATC-24070	Sensor (option)
ATC-24032	Elbow	ATC-24071	Holder, sensor (option)
ATC-24033	Top plate, roller unit	ATC-24072	Light tight shutter
ATC-24034	Side plate, left	ATC-24073	Reflector, UV lamp house
ATC-24035	Side plate, right	ATC-24074	Honeycomb plate
ATC-24036	Coating roller	ATC-24075	Air distributor
ATC-24037	Pinch roller	ATC-24076	Tray, liquid
ATC-24038	Bearing set	ATC-24077	Scraper tension screws
ATC-24039	Bearing set	ATC-24078	Side plate, liquid tray

Part number	Part name	Part number	Part name
ATC-24079	Name plate	ATC-24116	Inverter 0.4kw
ATC-24080	Indicator	ATC-24117	Speed controller, blower
ATC-24081	Motor	ATC-24118	Holder (option)
ATC-24082	Reducer 1:18	ATC-24119-01	Light tight plate(option)
ATC-24083	Capacitor	ATC-24119	Line protection
ATC-24084	Bracket, motor	ATC-24120	Plate, cooling fan
ATC-24085	Sensor	ATC-24121	Cooling fan
ATC-24086	Bearing set	ATC-24122	Connecter
ATC-24087	Threaded rod	ATC-24123	UV lamp
ATC-24088	Drain tray, 3 compartment	ATC-24124	Holder, lamp house
ATC-24089	Holder, air tubing (option)	ATC-24125	Motor
ATC-24090	Mounting plate	ATC-24126	Reducer
ATC-24091	Control panel	ATC-24127	Gear
ATC-24092	Meter, current	ATC-24128	Gear
ATC-24093	Temp. Controller	ATC-24129	Holder, motor
ATC-24094	Speed controller	ATC-24130	Frame, paper tray
ATC-24095	Var. Resistor with knob	ATC-24131	Encoder
ATC-24096	Buzzer	ATC-24132	Connecter
ATC-24097	Tank	ATC-24133	Holder, encoder
ATC-24098	Ball valve	ATC-24134	Contactor
ATC-24099	Holder, tank	ATC-24135	Terminal
ATC-24100	Linear guide rail	ATC-24136	Cable
ATC-24101	Drain tube	ATC-24137	Bar, exit fin
ATC-24102	Level sensor	ATC-24138	Fin, exit
ATC-24103	Moving block	ATC-24139	Fin, exit
ATC-24104	Liquid pump	ATC-24140	Plate, suction fan
ATC-24105	Holder plate	ATC-24141	Roller, net
ATC-24106	Holder	ATC-24142	Paper tray
ATC-24107	Head	ATC-24143	Magnet guide, right
ATC-24108	Connecter	ATC-24144	Magnet guide, left
ATC-24109	Capacitor	ATC-24145	Magnet guide, lower
ATC-24110	Blower	ATC-24146	Roller, net front
ATC-24111	Blower, hi-speed	ATC-24147	Castor
ATC-24112	Pipe	ATC-24148	Plate, suction fan
ATC-24113	Chamber, exhaust	ATC-24149	Fan
ATC-24114	Transformer 6.5kw	ATC-24150	Scarper
ATC-24115	Capacitor 10+5uf 2000V	ATC-24151	Scraper tension plate

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ATC-24006
ATC-24014
ATC-24004
ATC-24001
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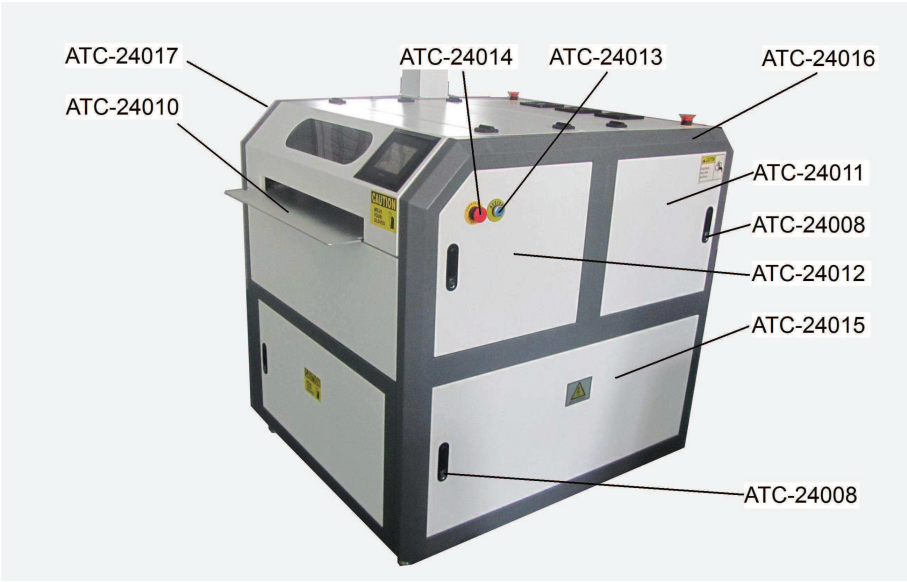
ATC-24002
ATC-24008
ATC-24003
ATC-24009
CAUTION
CAUTION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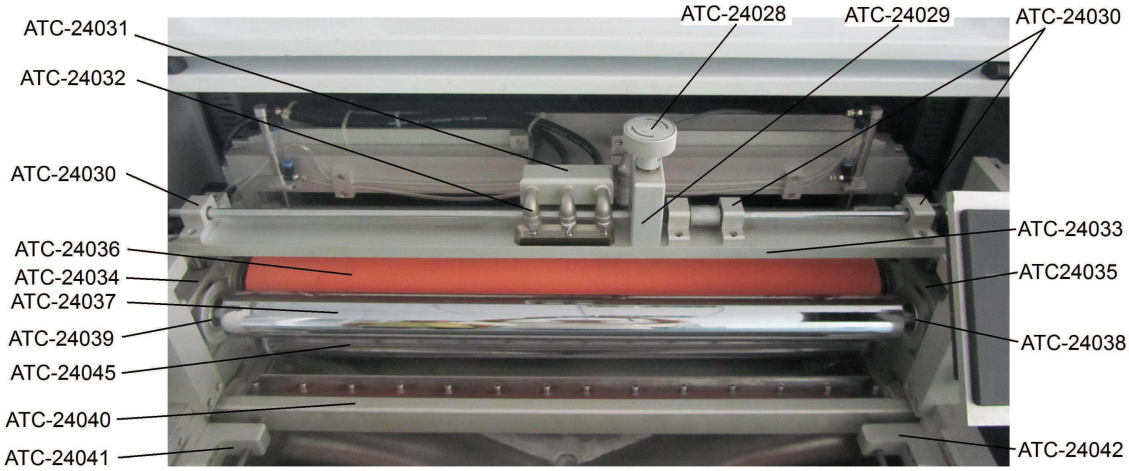
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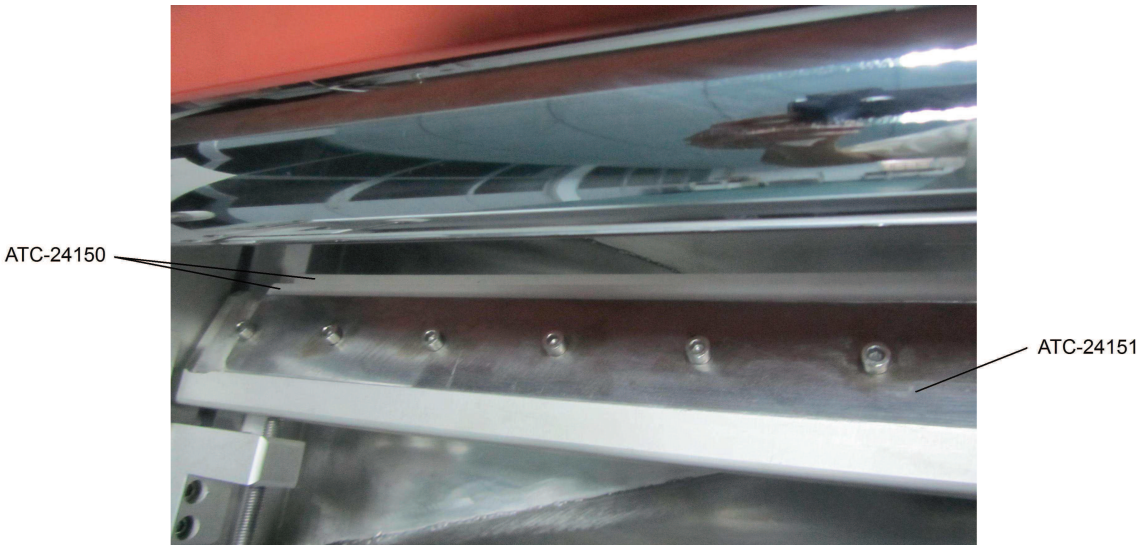
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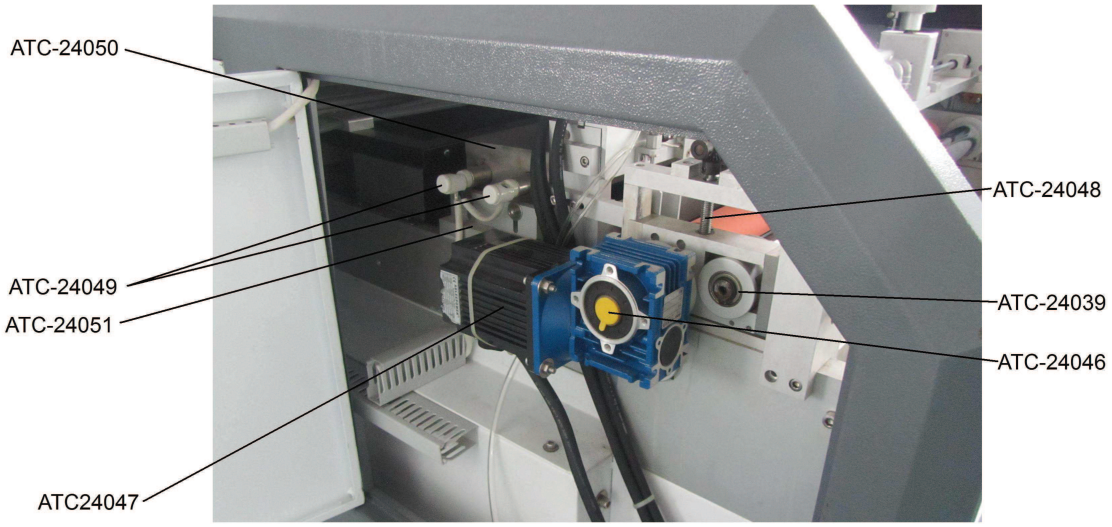
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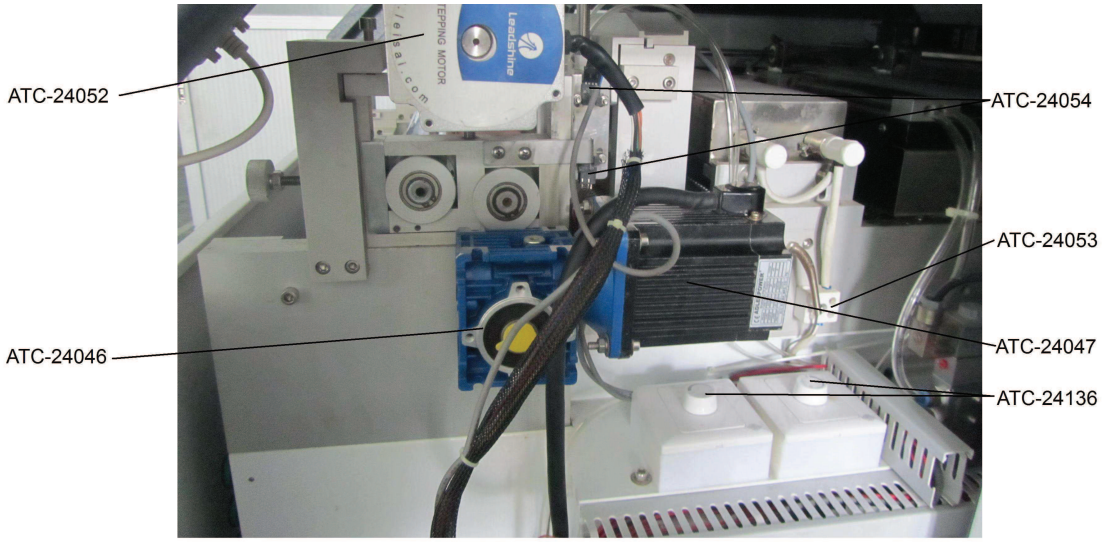
ATC24047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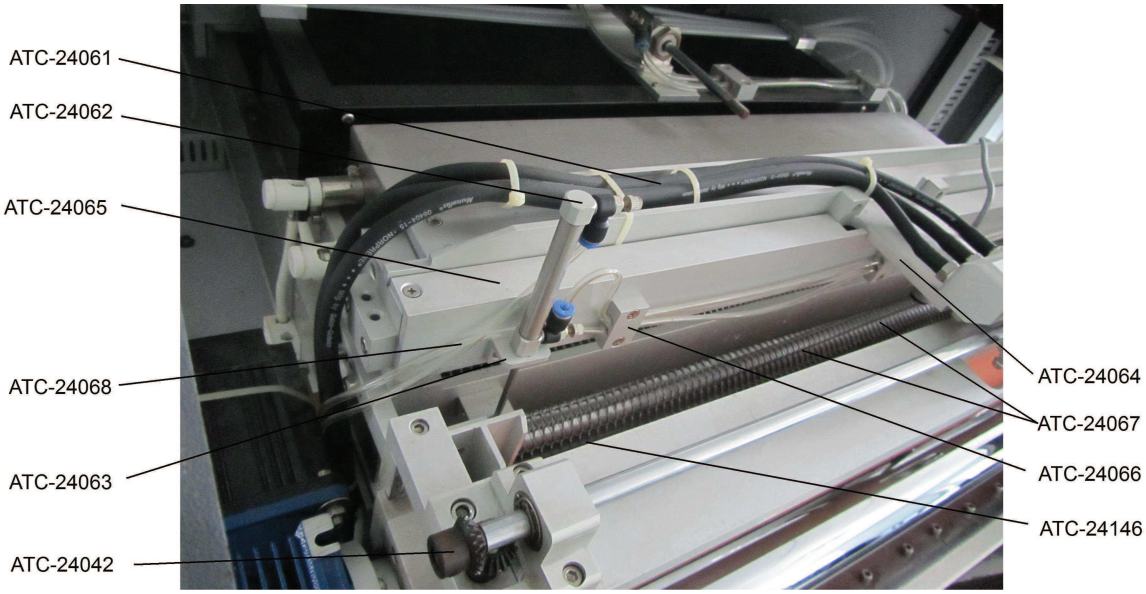
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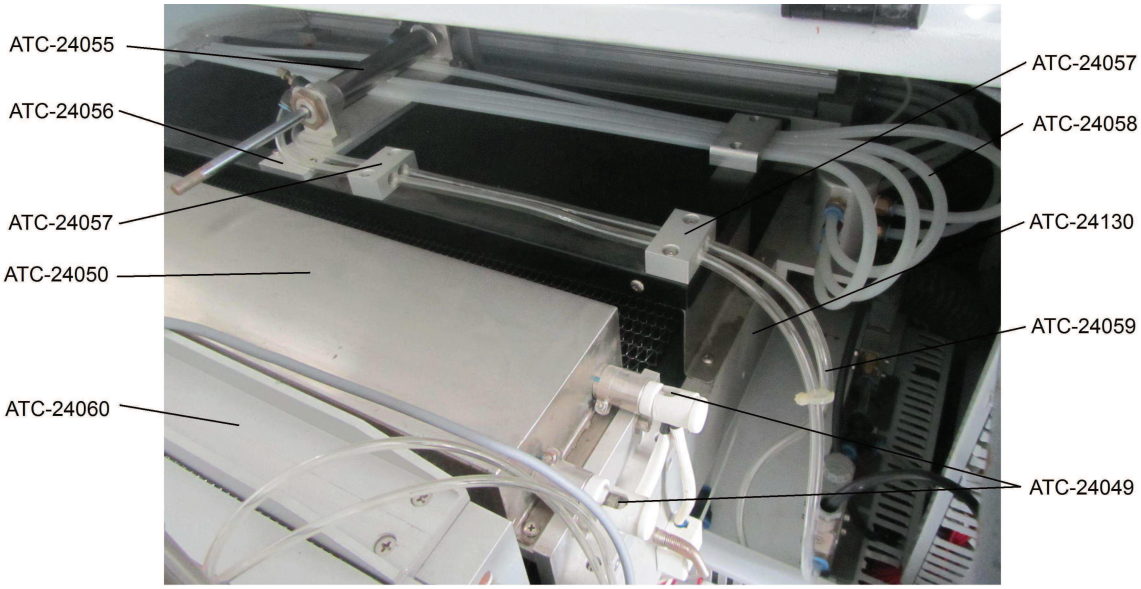
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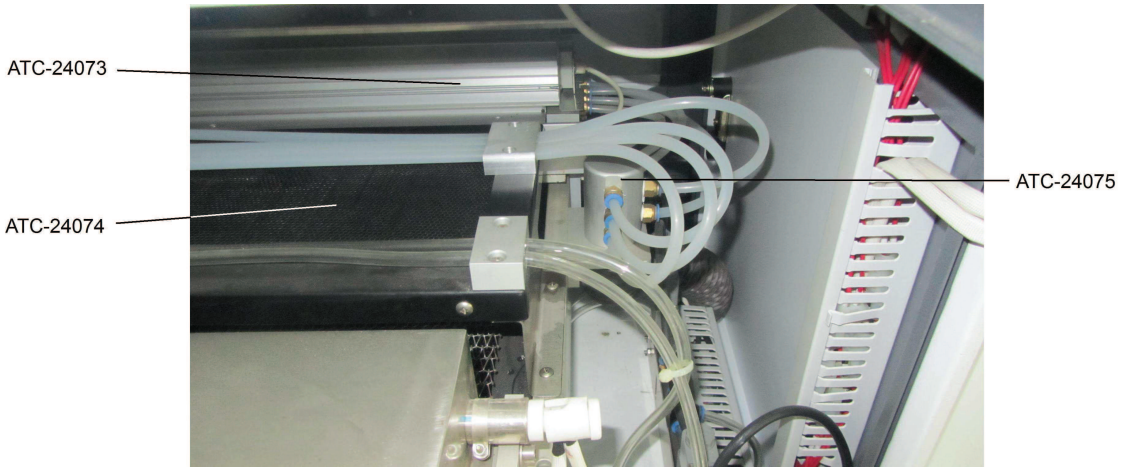
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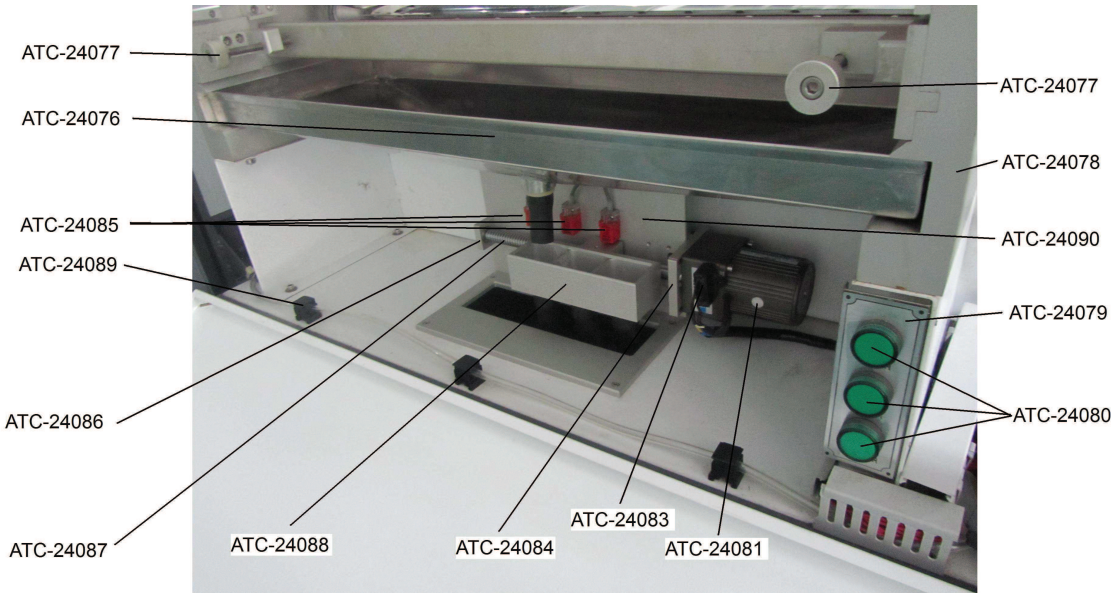
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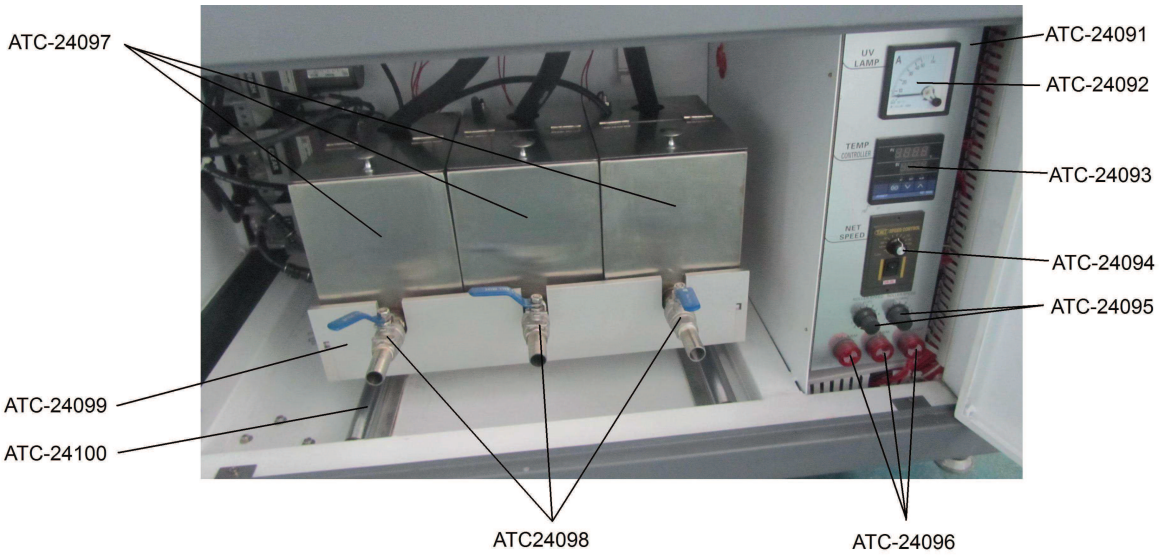
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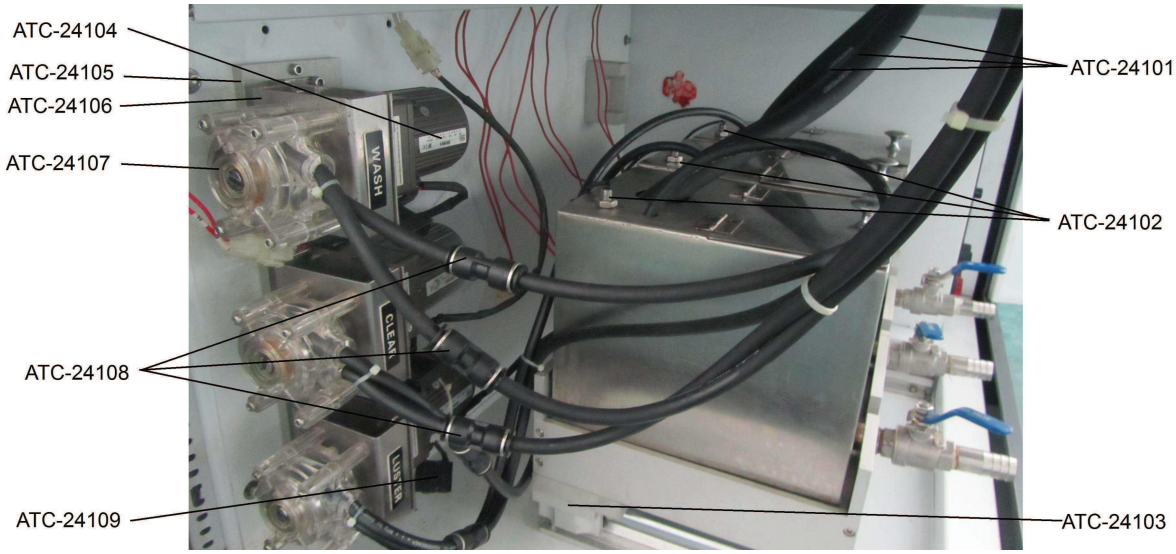
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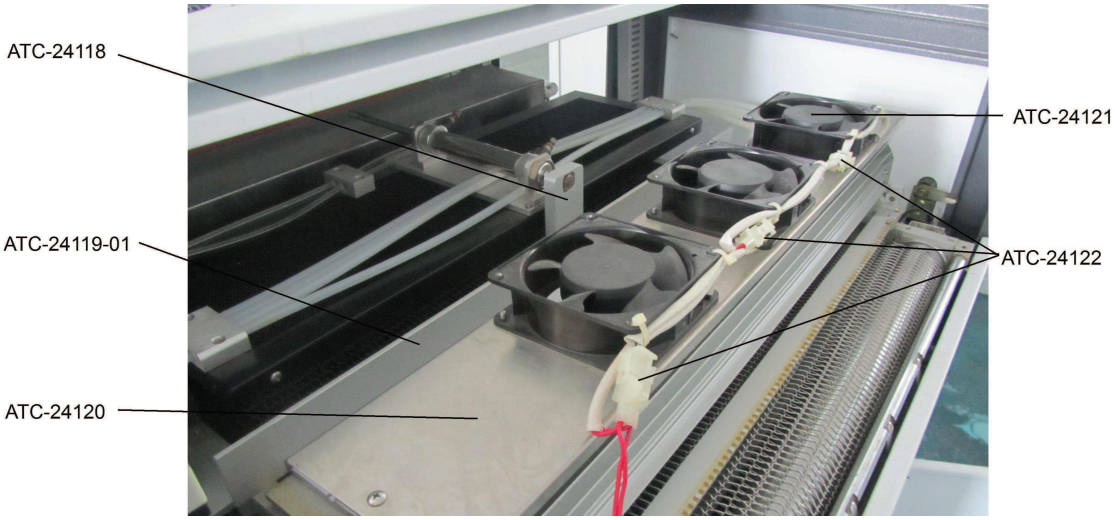
WASH
CLEAN
LUBER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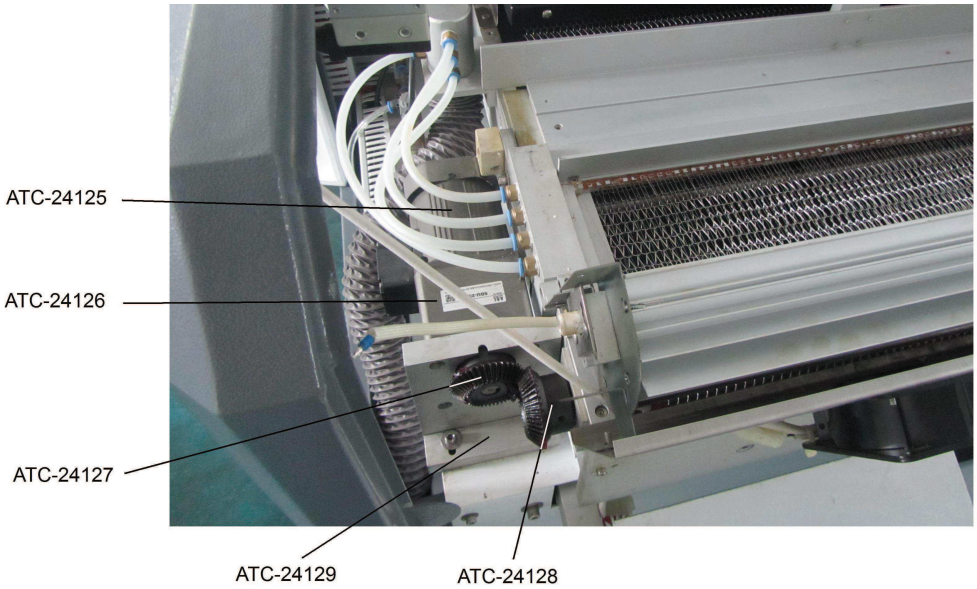
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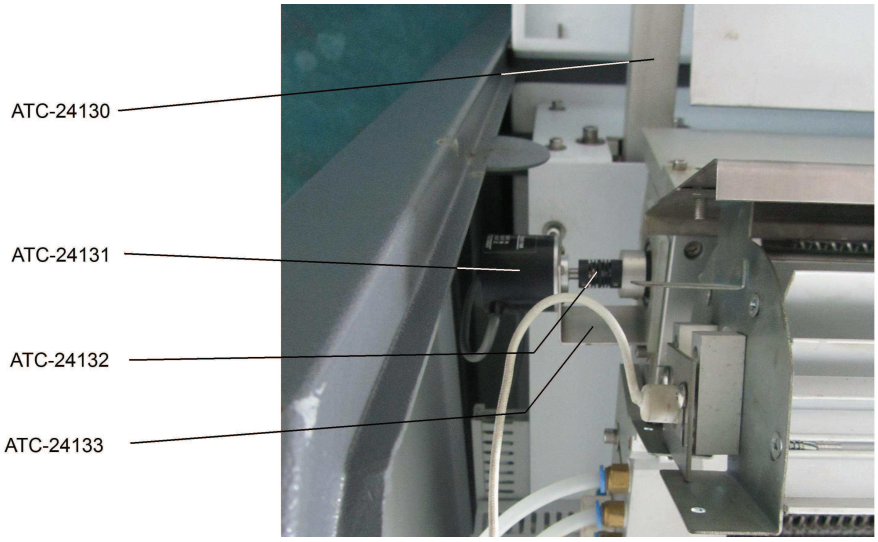
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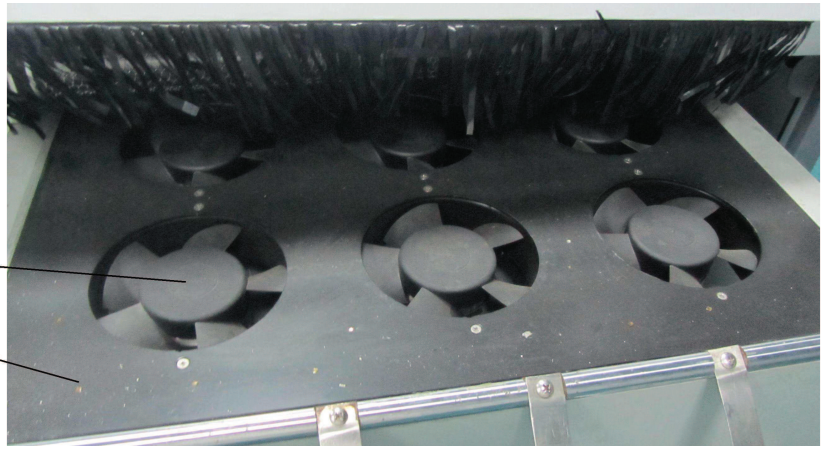
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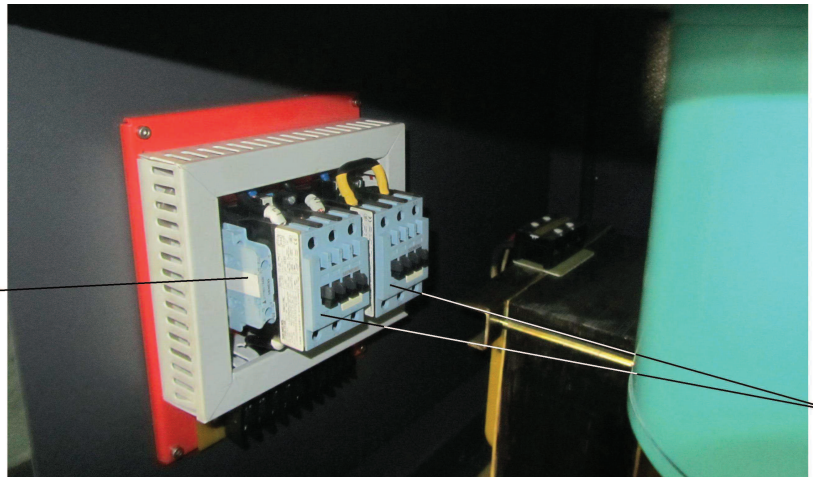
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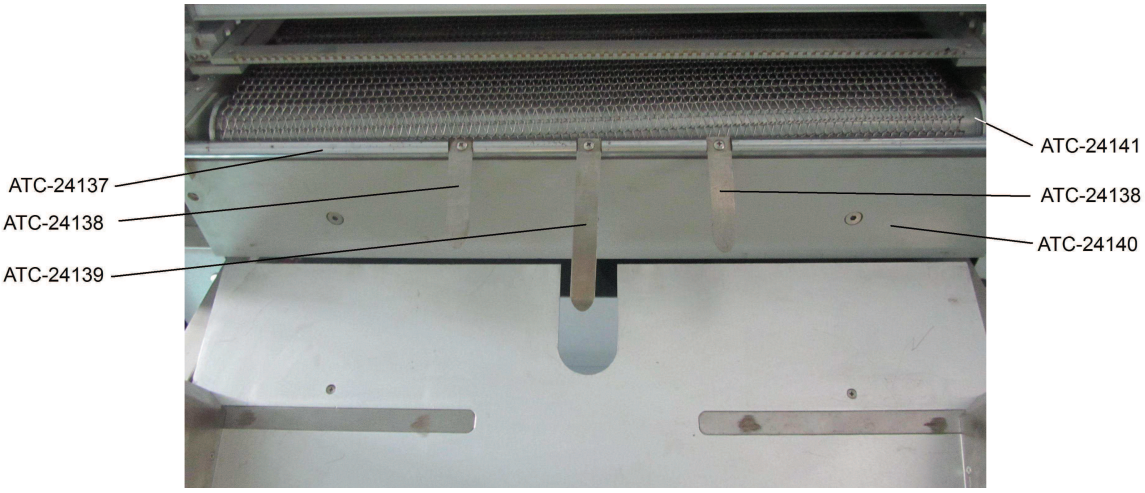
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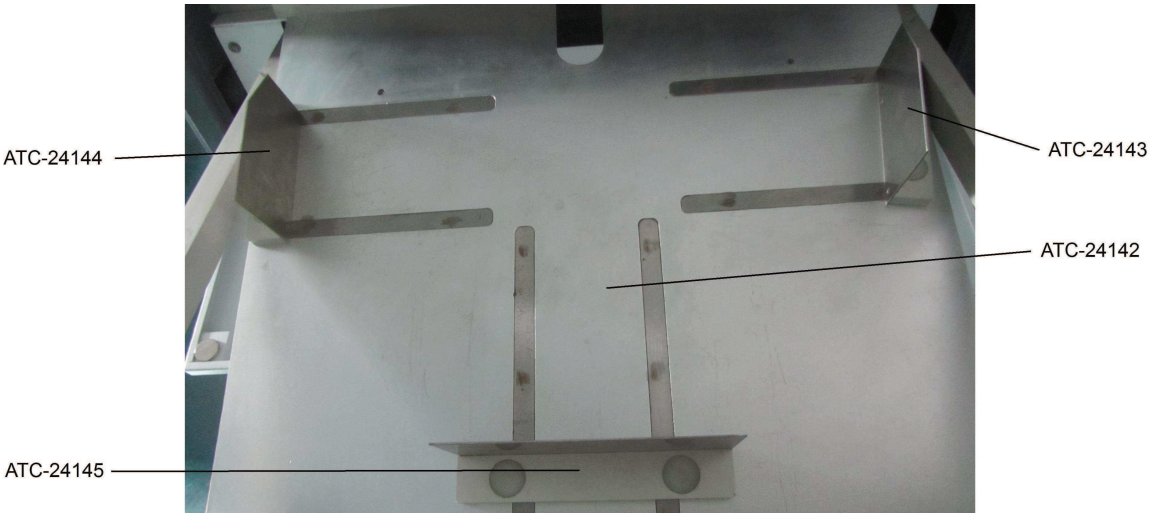
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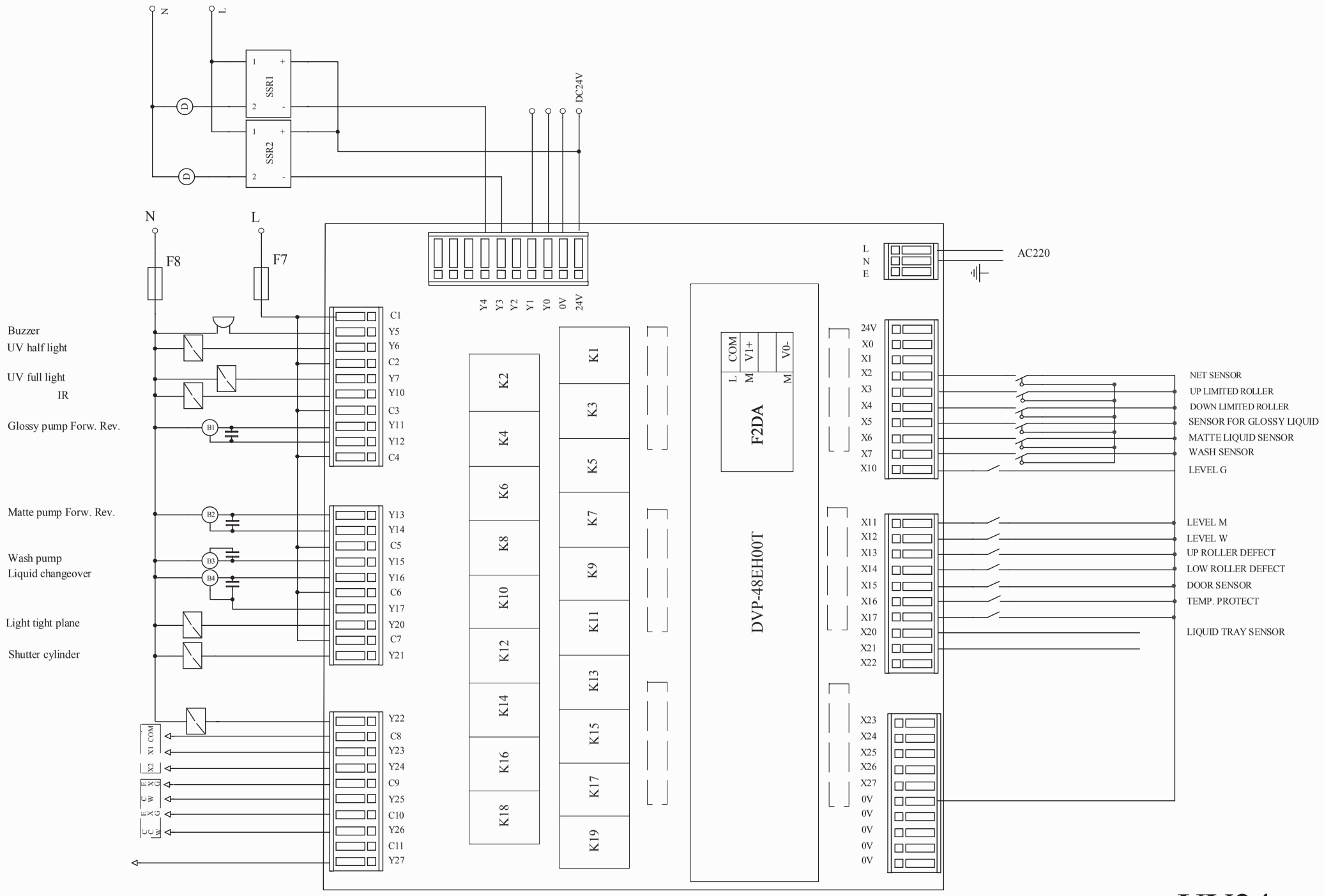
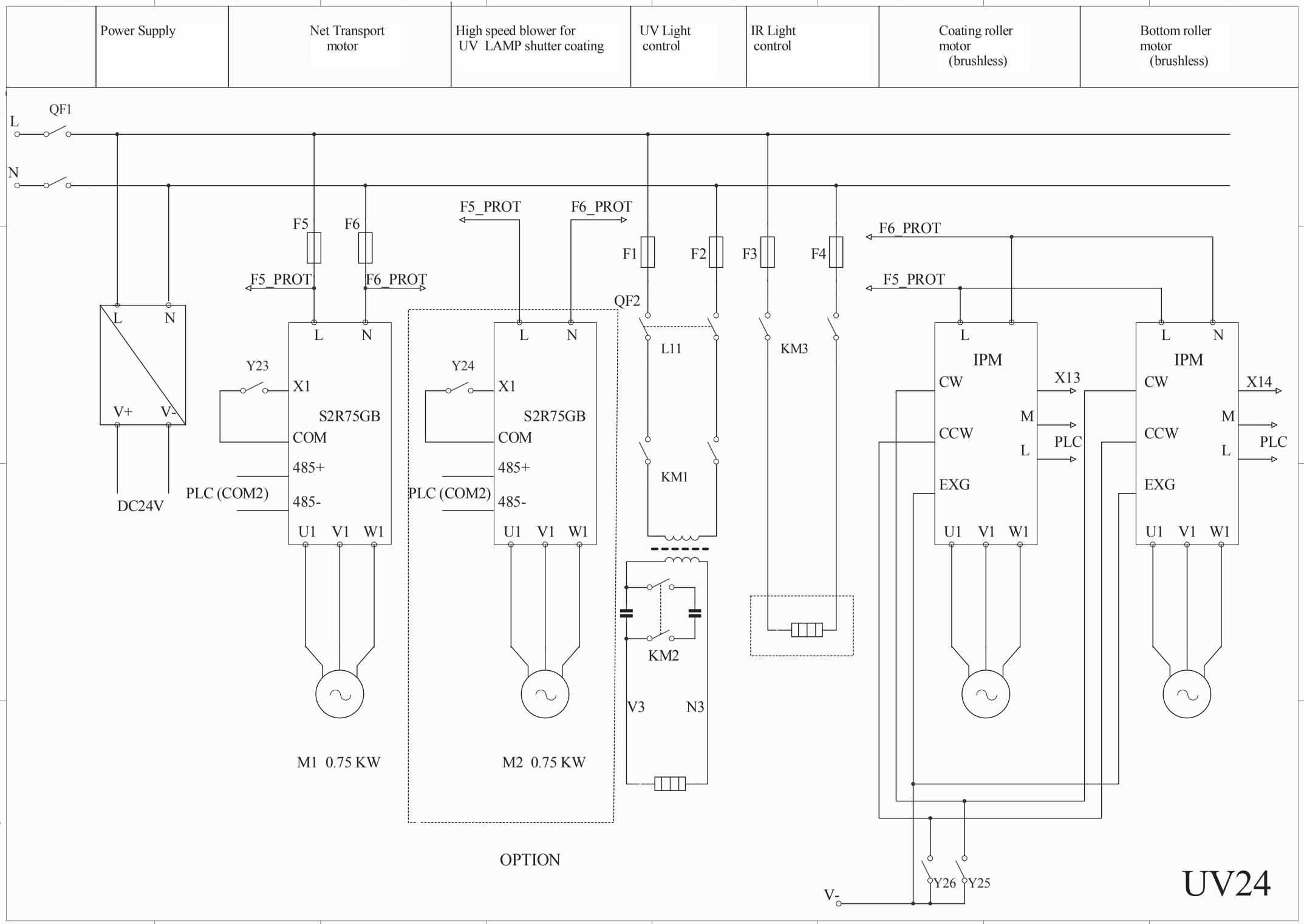

N
L
SSR1
SSR2
DC24V
F8
F7
Buzzer
UV half light
UV full light
IR
Glossy pump Forw. Rev.
Matte pump Forw. Rev.
Wash pump
Liquid changeover
Light tight plane
Shutter cylinder
Y4 Y3 Y2 Y1 Y0 0V 24V
C1 Y5 Y6 C2 Y7 Y10 C3 Y11 Y12 C4
Y13 Y14 C5 Y15 Y16 C6 Y17 Y20 C7 Y21
Y22 C8 Y23 Y24 C9 Y25 C10 Y26 C11 Y27
K1 K2 K3 K4 K5 K6 K7 K8 K9 K10 K11 K12 K13 K14 K15 K16 K17 K18 K19
F2DA
DVP-48EH00T
COM V1+ V0-
L M M
L N E
AC220
24V X0 X1 X2 X3 X4 X5 X6 X7 X10
X11 X12 X13 X14 X15 X16 X17 X20 X21 X22
X23 X24 X25 X26 X27 0V 0V 0V 0V 0V
NET SENSOR
UP LIMITED ROLLER
DOWN LIMITED ROLLER
SENSOR FOR GLOSSY LIQUID
MATTE LIQUID SENSOR
WASH SENSOR
LEVEL G
LEVEL M
LEVEL W
UP ROLLER DEFECT
LOW ROLLER DEFECT
DOOR SENSOR
TEMP. PROTECT
LIQUID TRAY SENSOR
UV24


Power Supply
Net Transport motor
High speed blower for UV LAMP shutter coating
UV Light control
IR Light control
Coating roller motor (brushless)
Bottom roller motor (brushless)
QF1
L
N
F5
F6
F5_PROT
F6_PROT
F1
F2
F3
F4
QF2
L11
KM1
KM2
KM3
V3
N3
V+
V-
DC24V
Y23
Y24
X1
S2R75GB
COM
485+
485-
PLC (COM2)
U1
V1
W1
M1 0.75 KW
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OPTION
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CCW
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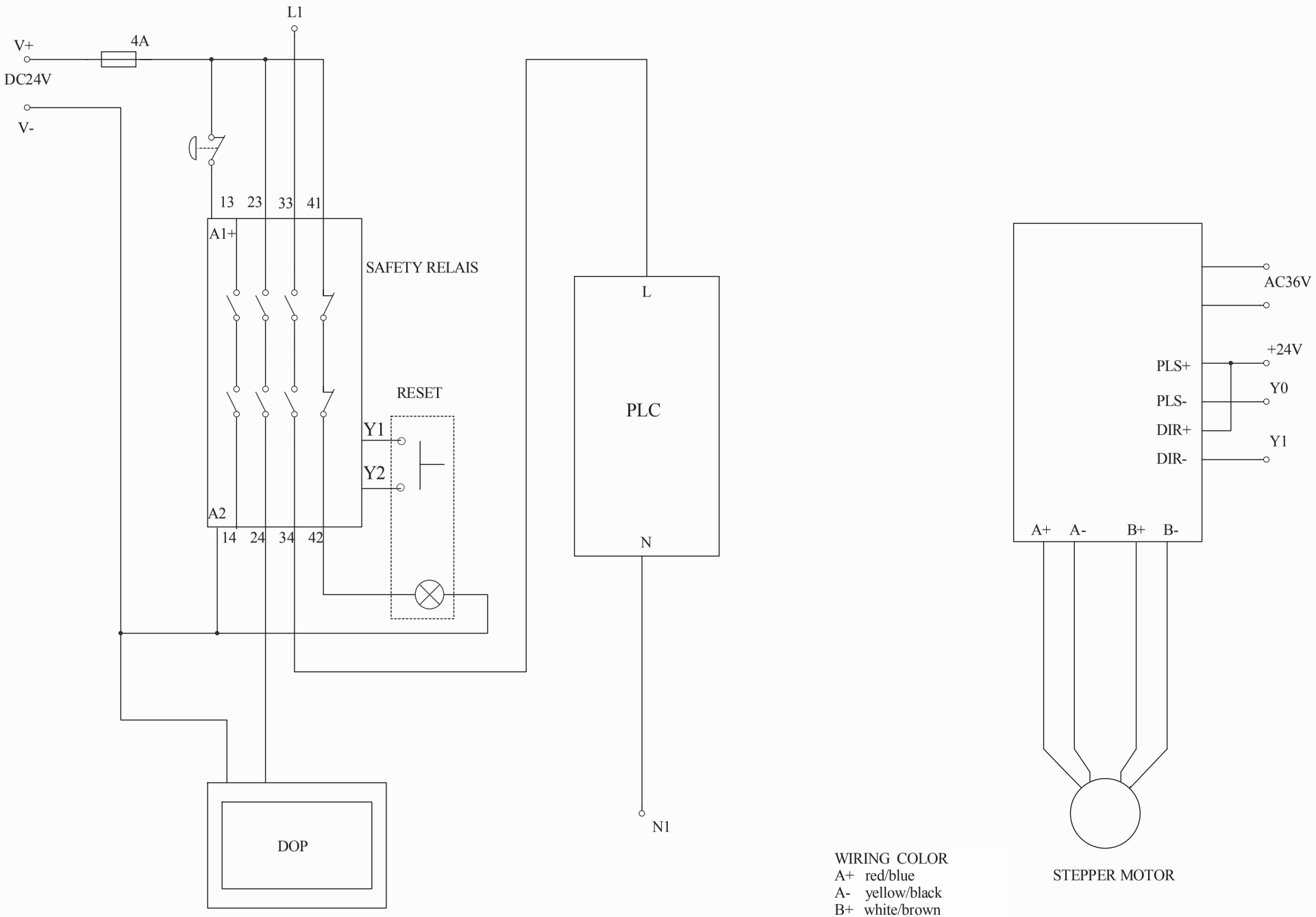
UV24



WIRING COLOR
A+ red/blue
A- yellow/black
B+ white/brown
B- orange/green

UV24