



Quanzhou Famous Trademark

**Tea Rolling Machine**

# **User's manual**

**Anxi Yongxing Machinery Co., Ltd.**

- Overview

The products mentioned in this instruction manual are used only to tea fixation, twist strips and destroying cells in order to roast and dry work, and to apply to the twisting operation of strip black tea.

The products mentioned in this instruction manual can only be operated, maintained and repaired by personnel who are familiar with the characteristics of the machine and have relevant knowledge of safe operation.

Rules and other safety regulations to prevent accidents must be observed at all times.

The manufacturer is not responsible for the reduced reliability of the machine, damage to the machine or injury to the personnel as a result of the unauthorized restructuring of the products mentioned in this instruction manual.

Chapter I For the safety of you and others, please note the following  
security considerations

1. Users in the purchase, installation, use of the enterprise products, please be sure to read this manual in detail, so as to avoid errors.
2. Conscientiously implement the regulations and requirements for the use and maintenance of this machine. For the new operator to carry out special training, unqualified operator may not operate the machine.
3. Check that the power cord is intact and the power cord must not be damaged. The power supply used for the product is three-phase four-wire system, voltage 380V , the wire diameter of the installation wiring should be  $\geq 2.5 \text{ mm}^2$  , directly from the knife switch to pick up. Wiring should be operated by a professional electrician, pay attention to the rotation direction of the twisting machine.
4. Before powering up, you must first pick up the electric shock protection device and grounding wire, and the grounding line is firm and reliable, to ensure the safety of electricity.
5. Before turning on to ensure that there is no debris in the box, flexible and reliable, no abnormal sound, to ensure that the fan is running normally. Near the machine ban flammable and explosive items and odorous items.
6. Do not wear loose clothing operations that are easy to be involved in rotating parts, and long hair holders are required to wear helmets. When using the operator must not leave the machine, do not touch the rotating parts, do not continue to operate the machine under fatigue, drink conditions, non-operators are not allowed to use the machine.
7. When the machine rotates, it is strictly forbidden to put hands and other utensils into the machine; non-operators and children are not allowed to approach the machine.
8. When using the machine, there should be someone responsible for operation, inspection and maintenance. When checking and maintaining, be sure to cut off the power supply in time: When working, encounter power outage, be sure to immediately cut off the power supply.
9. Do not use in the event of a thunderstorm. The power supply must be cut off to prevent lightning damage to electrical parts and personal accidents.
10. After the end of the work to cut off the power supply (knife switch), every time after working tea, to clean the tea foam inside the machine, to prevent the long-term accumulation of tea foam led to ignition to avoid accidents such as fires.
11. The joints of the machine and the machine's inlet line should be checked frequently for any charred conditions. The feeder line should use a special Line table. Electrical system to often maintain, found that wire damage, aging to be replaced immediately.
12. Except for repairs, do not remove the safety shield shell at will so as not to injure people.

Chapter II Product main technology and performance

<b>Serial number</b>	<b>Item</b>	<b>Units</b>	<b>Parameter values</b>	
<b>1</b>	<b>Dimensions (length × width × height)</b>	Mm	1.75*1.4*1.58	
<b>2</b>	<b>Weight of the whole machine</b>	Kg	680	
<b>3</b>	<b>Rub bucket inner diameter</b>	Mm	650	
<b>4</b>	<b>Motor</b>	<b>Power</b>	kw	3
		<b>Speed</b>	R/min	1400
		<b>Operating voltage</b>	V	380
<b>5</b>	<b>Productivity</b>	kg/h	90-100	
<b>6</b>	<b>Pressurized device</b>		Pneumatic automatic control pressurization	

## 1, use and operation

### 1.1 Preparation before use:

- a) Remove the debris and tools left over from the rubbing plate, rolling bucket and machine;
- b) Be sure to check that the supply voltage used is the same as the motor voltage of this product, and connect the ground line and electric shock protector to ensure the safety of the person and machine;
- c) Carefully check whether the fastener is reliable, especially if the fastening screws on the curvature arm are loose and shedding.
- d) Check the amount of mechanical oil in the gearbox, if not enough, please add a number of mechanical oil to the box.
- e) Outside the warning area, the empty car commissioning for 10 minutes, to observe whether the direction of operation is correct, gear rotation is normal, if there is blocking, collision phenomenon should be immediately shut down to check.

### 1.2 the operations order:

- a) shutdown, open the pressurized cover, close the tea exit door, to the bucket to add sufficient amount of fixing leaves or withering leaves.
- b) Close the pressurized cover, make the formation barrel about 30 millimeters, start the operation (called Air pressure driving), and then gradually pressurized, to the foot until the filling (that is, until tea is rolling well). Then go to the pressure to rub a minute, up the loose group, strips, adsorption of tea juice and other functions, you can open the tea door out of the tea, stop to clean machine left behind the leaves, close the tea exit door, you can carry out a second rolling operation.
- c) when used by pneumatic tea rolling machine, the pressure timing 2 minutes, loose pressure timing \$ seconds, pressure gauges 0.1 lattice =7.85 kg

## **2 , Transport, installation and adjustment**

**2.1 When transporting, it is required to place a smooth, fixed and no relative sliding to prevent the impact from damaging the machine.**

### **2.2 Installation & commissioning**

Tea rolling machine installation is simple, in the selected position, will be installed in the tea rolling machine bracket suspended (pre-dug The pouring hole), three feet to the positive three pouring holes, put on the screw ,then correct rubbing plate level, and then poured cement mortar, when the cement mortar is strong, remove the support, and then gradually tighten the foot nut, can also be used M12 expansion bolts fixed, and at any time on the edge of the rubbing plate with a horizontal meter to measure the positive level, until the nut tightening, the installation is complete.

## **Chapter Fourth Maintenance**

- 1, when working, the temperature rise of each bearing of the rolling machine must not exceed 25 degrees Celsius, transmission box temperature must not exceed 40 degrees Celsius.
- 2, the operation should pay attention to the gears in the gearbox, the teeth joints operation is smooth and normal, must not have abnormal impact, vibration and noise.
- 3, check the deceleration box shaft end to confirm there is no oil leakage phenomenon.
- 4, regular refueling of each lubrication point, pay special attention to the lubrication state of the arm part, in order to ensure normal operation. The oil must be cleaned, some parts such as lifting screw, etc., in the maintenance of a certain lubrication conditions, grease should not be added too much, to prevent driving refueling, in order to policy safety.
- 5, in general normal conditions, each tea period should check whether the lubrication pipe is smooth, the amount of oil is appropriate.
- 6, after the machine has been on hold for a long time, it is necessary to carry out all the inspection before the start, replace the lubricating oil in each bearing and gearbox, and carry out the commissioning, think that the operation is normal before working.
- 7, must strictly abide by the maintenance and repair system and safety procedures, check motor and electrical circuit switch. Machines on schedule for maintenance, every year to remove a check, wipe the dust on the machine, tea, tea juice and other dirt, in the operation and use should pay attention to safety procedures, to prevent the occurrence of accidents.

## Chapter Fifth Common faults and troubleshooting

### 1, rubbing the bucket to reverse or not turn (cause analysis)

- ① The three-phase motor wiring is wrong;
- ② The active curvature arm and the active shaft tightening screw fall off and loosen.

**Exclude method:** 1, the two-phase wiring position on the arbitrary switching motor; 2, check and tighten the screws tightly.

### 2, the noise of machine operation is high (cause analysis):

Insufficient lubricant or gear wear in gear reducer.

**Exclude method:** loosen the oil injection Plug and add - oil or replacement gear.

### 3, a cover shaking too much impact rubbing bucket (cause analysis):

- ① loosening of fastening bolts at the lower end of the column;
- ② the pressurized arm is loose with the guide nut joint bolt.

**Exclude method:** tighten the loosening of the relevant bolts.

## Chapter Six Single machine set and spare parts delivery catalog

S/N	Part Name	Unit	Quantity	Remarks
1	Machine	Set	1	
2	user's manual	Copy	1	
3	Quality Certificate	Copy	1	Sticked on the machine
4	Warranty certificate	Copy	1	
5	Quality Certificate	Copy	1	

● Chapter Seven Warranty Card

### Warranty Card

S/N	Content				
1	Product	Name	Trademark	Model	Serial code
2	Supporting Info.	Brand	Type	Serial number	Production unit
3	Sales unit	Name	Address	Telephone	Warranty certificate
4	Maintenance staff	Name	Address	Telephone	Warranty item
5	Sales record	Purchase unit	Purchase address	Purchase date	Purchase invoice number
6	The whole machine warranty period (months)		12		
7	Main component warranty period (months)		Motor		6
8	Wearing parts, other parts warranty period (months)			transmission belt	3

### Maintenance Records

Repair time	Failure situation	Repaired situation	Exchange delivery time	Return certificate

The warranty is not implemented in the following cases

- A. The agricultural machinery user cannot prove that the agricultural machinery product is within the validity period;
- B. The product exceeds the validity period;
- C. Damage caused by failure to use the maintenance as required by the instructions;
- D, The user's manual shall not be modified or disassembled, the modification or disassembly of the machine change the performance of the machine or cause damage;
- E, After the failure, the agricultural machinery user cannot make a technical appraisal for the cause of the failure due to improper disposal;
- F, Other man-made damage due to non-product quality;
- G, Causing damage as a result of force majeure;

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