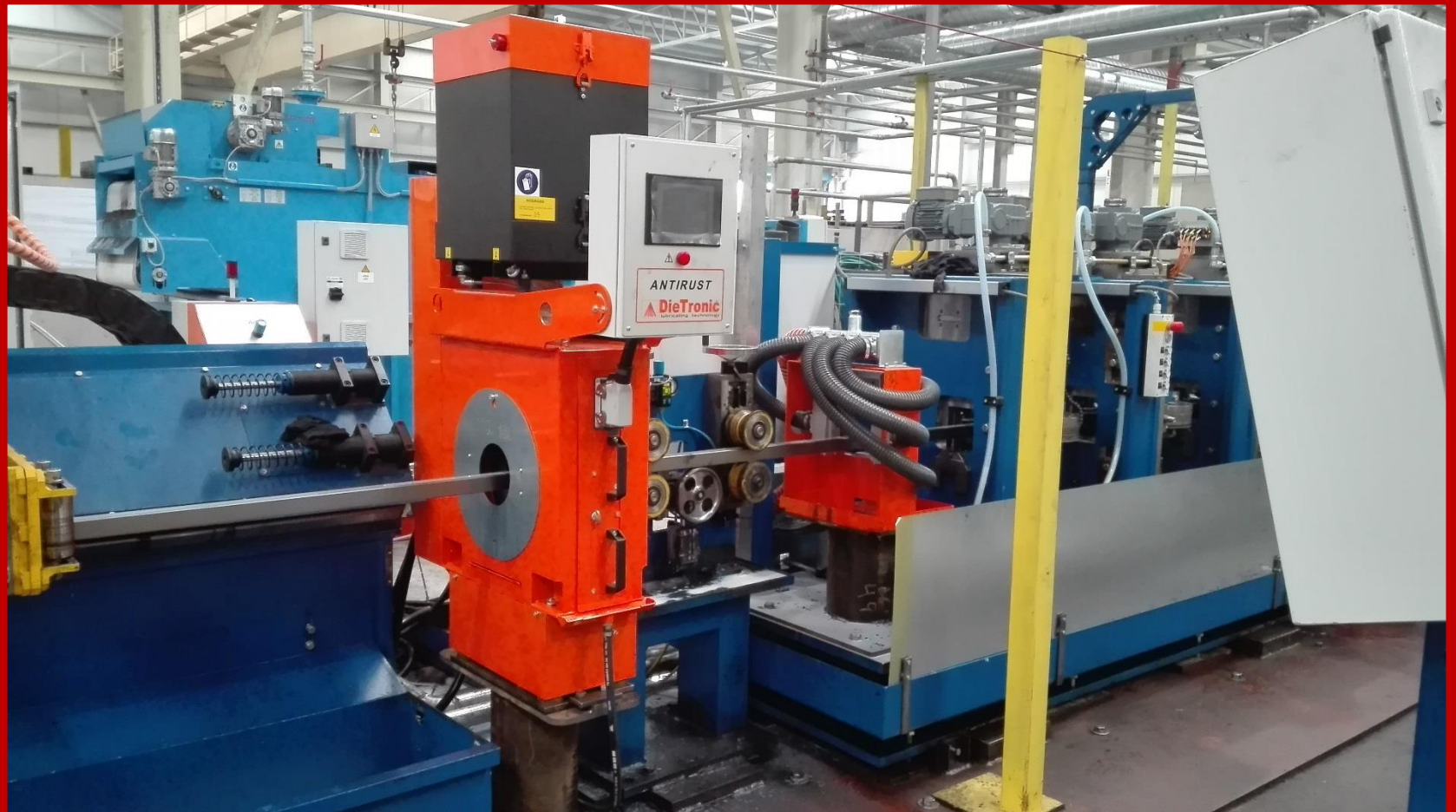


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Commissioning



INDEX

IN THE FOLLOWING PAGES YOU WILL FIND ALL THE INFORMATION TO INSTALL THE MACHINE STEP BY STEP:

- STEP 0: POSITIONING OF THE MACHINE
- STEP 1: ELECTRIC AND PNEUMATIC CONNECTION
- STEP 2: EXTERNAL SIGNAL CONNECTION (ENCODER AND ALARM RELAY)
- STEP 3: ELECTRIC CONNECTION MACHINE-TANK
- STEP 4: PNEUMATIC AND HYDRAULIC CONNECTION MACHINE-TANK
- STEP 5: FILLING THE TANK
- STEP 6: RECOVERY FILTER UNIT
- STEP 7: TURNING ON THE MACHINE
- STEP 8: INITIAL PAGE
- STEP 9: NOZZLES MANAGEMENT PAGE
- STEP 10: OIL MANAGEMENT PAGE
- STEP 11: INFORMATION ON CONSUMPTION OF OIL
- STEP 12: FLOW CONTROL PAGE
- STEP 13: OPERATION IN MANUAL MODE
- STEP 14: PULVERIZATION AIR CONTROL
- STEP 15: POSITIONING OF THE NOZZLES
- STEP 16: CHOOSE THE CORRECT COVERS

POSITIONING OF THE MACHINE

STEP 0



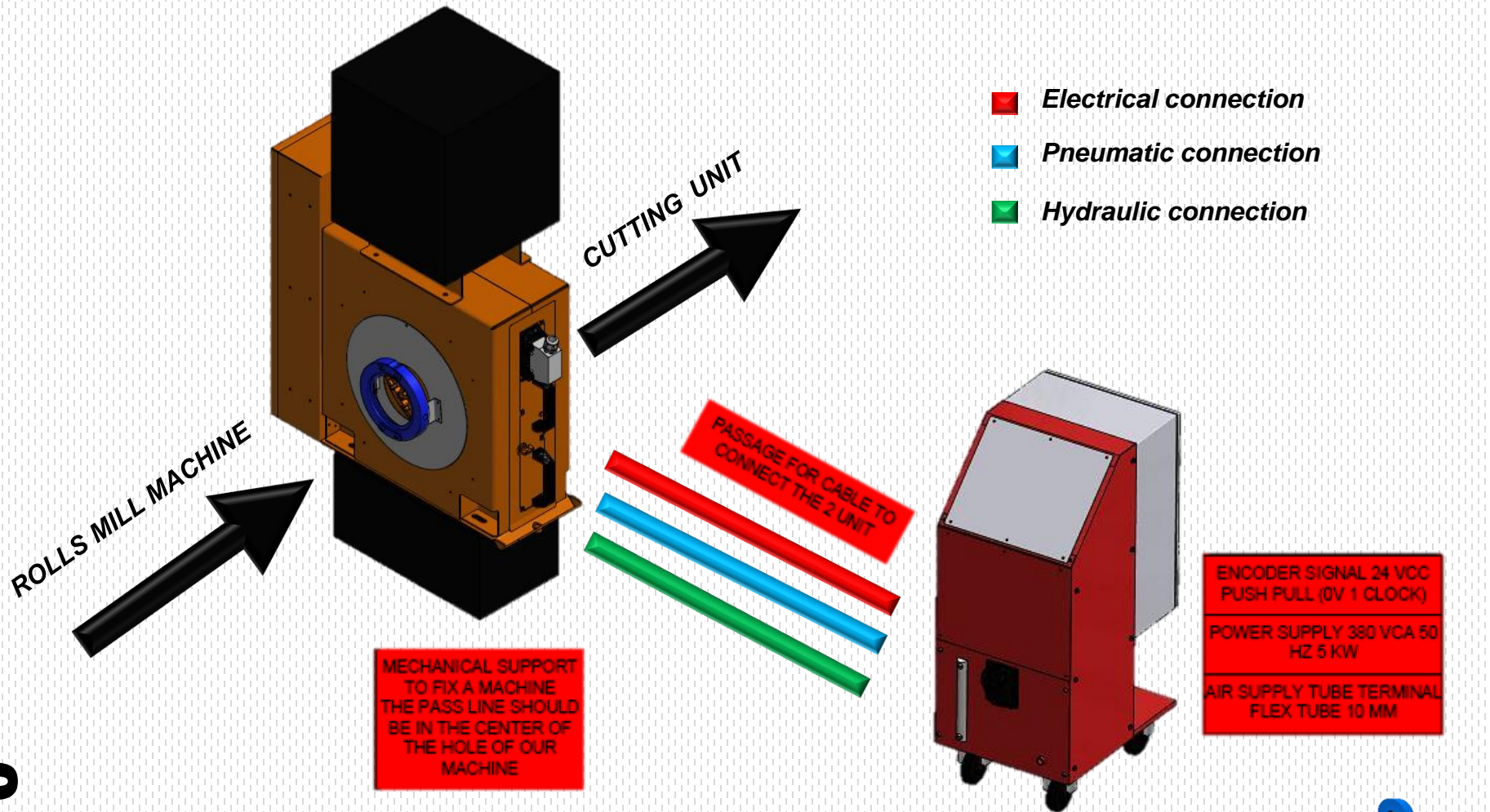
- PLACE THE MACHINE AND THE ELECTRICAL PANEL.
- IT'S IMPORTANT THAT THE CENTRAL HOLE OF THE MACHINE IS IN CORRESPONDENCE WITH THE PASSAGE OF THE TUBE (CHECK THE CORRECT PASS LINE).
- THE MACHINE WILL BE POSITIONED BEFORE THE TUBE CUTTING STATION.



AT CUSTOMER'S CHARGE



POSITIONING OF THE MACHINE



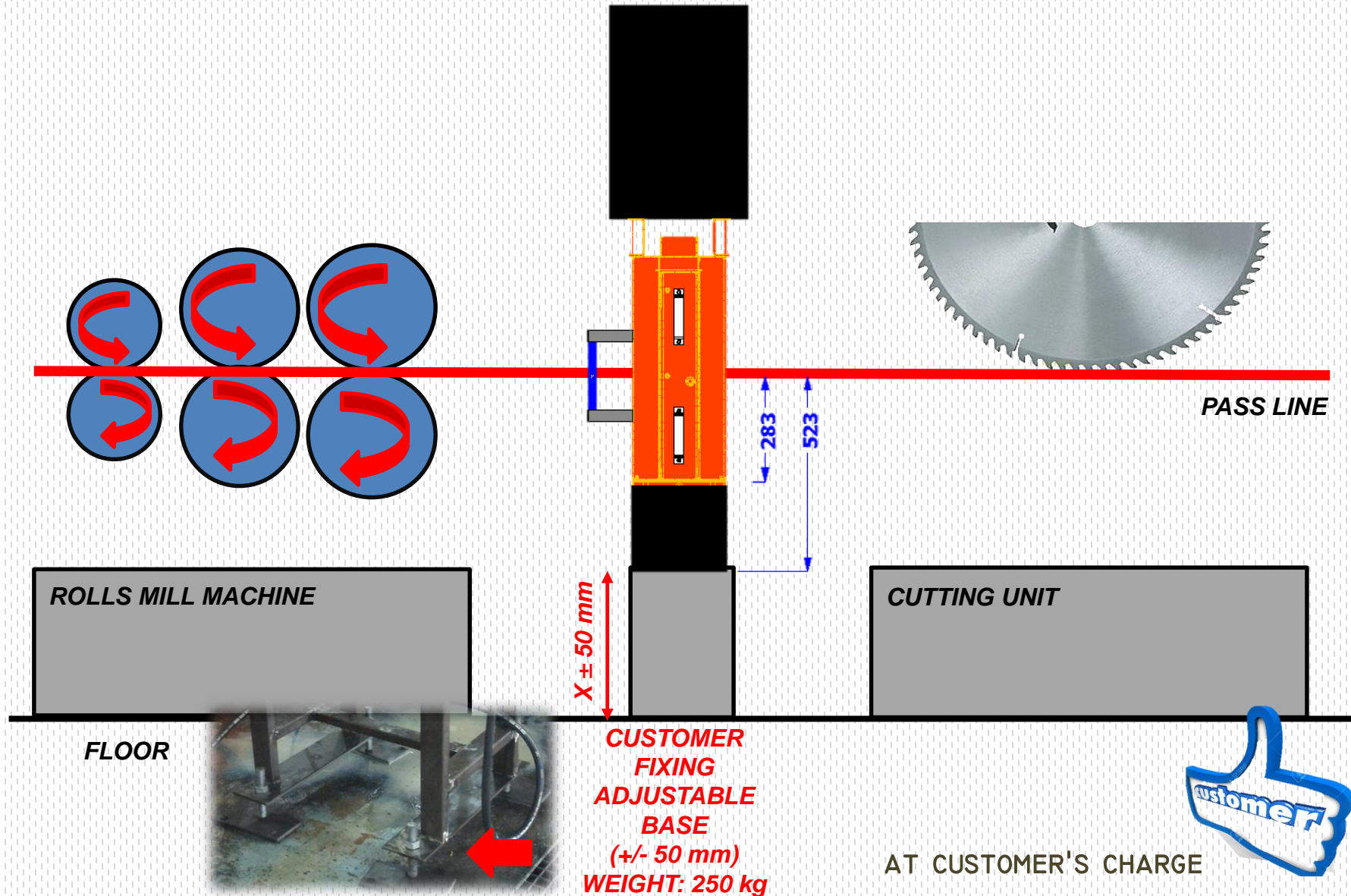
STEP 0

AT CUSTOMER'S CHARGE



POSITIONING OF THE MACHINE WITH VERTICAL ADJUSTMENT

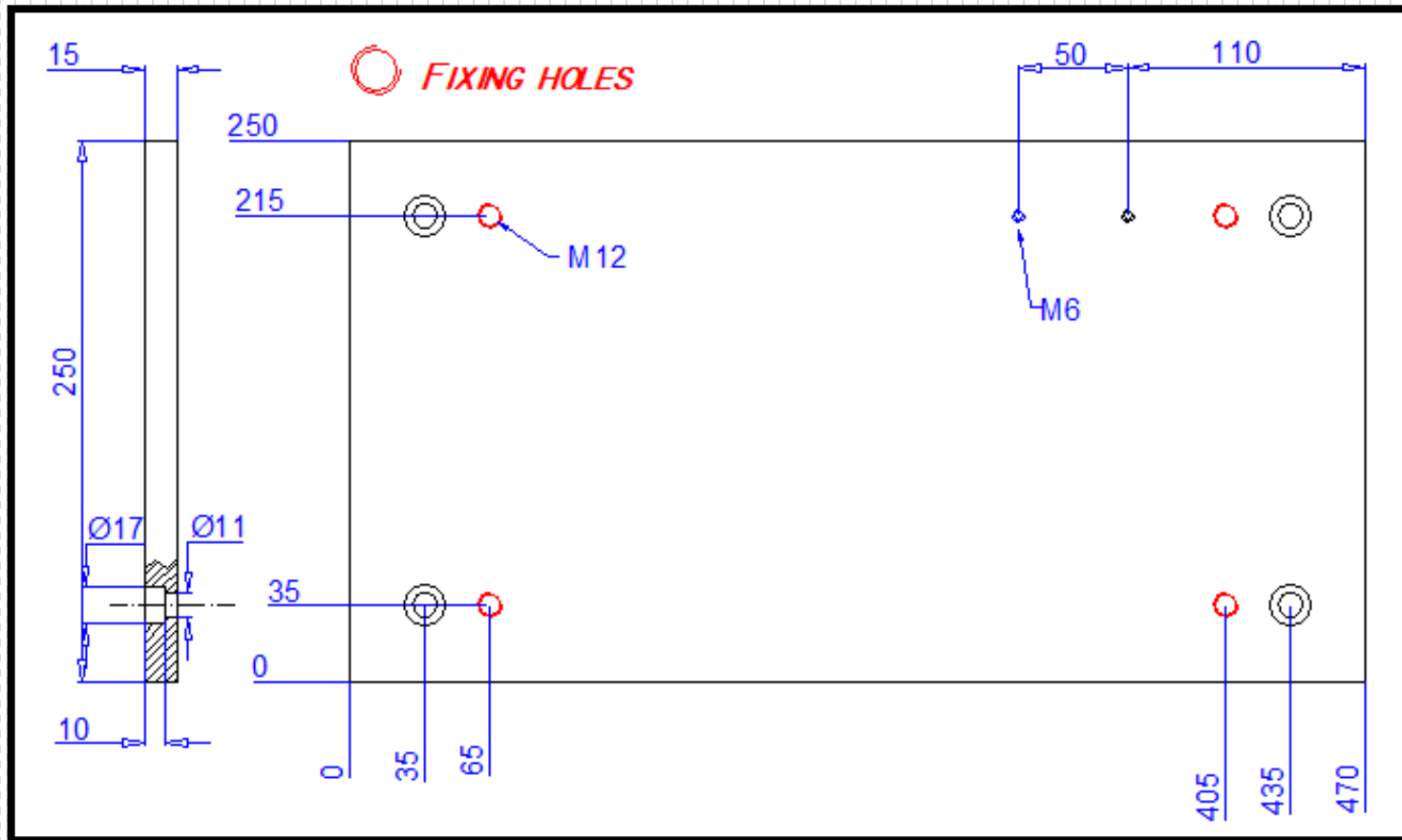
STEP 0



AT CUSTOMER'S CHARGE



POSITIONING OF THE MACHINE WITH VERTICAL ADJUSTMENT



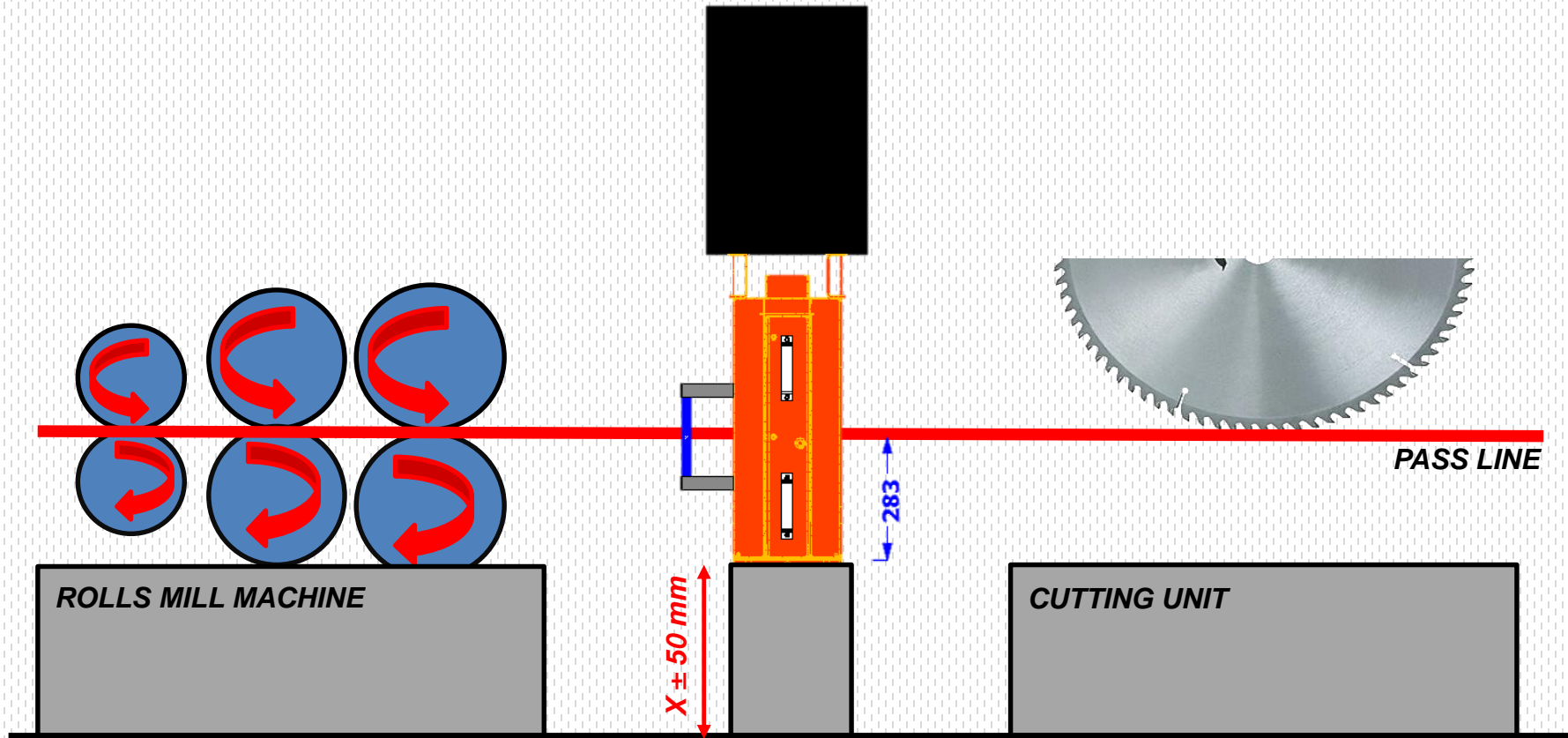
FIXING HOLES WITH VERTICAL ADJUSTMENT

AT CUSTOMER'S CHARGE



STEP 0

POSITIONING OF THE MACHINE WITHOUT VERTICAL ADJUSTMENT



FLOOR



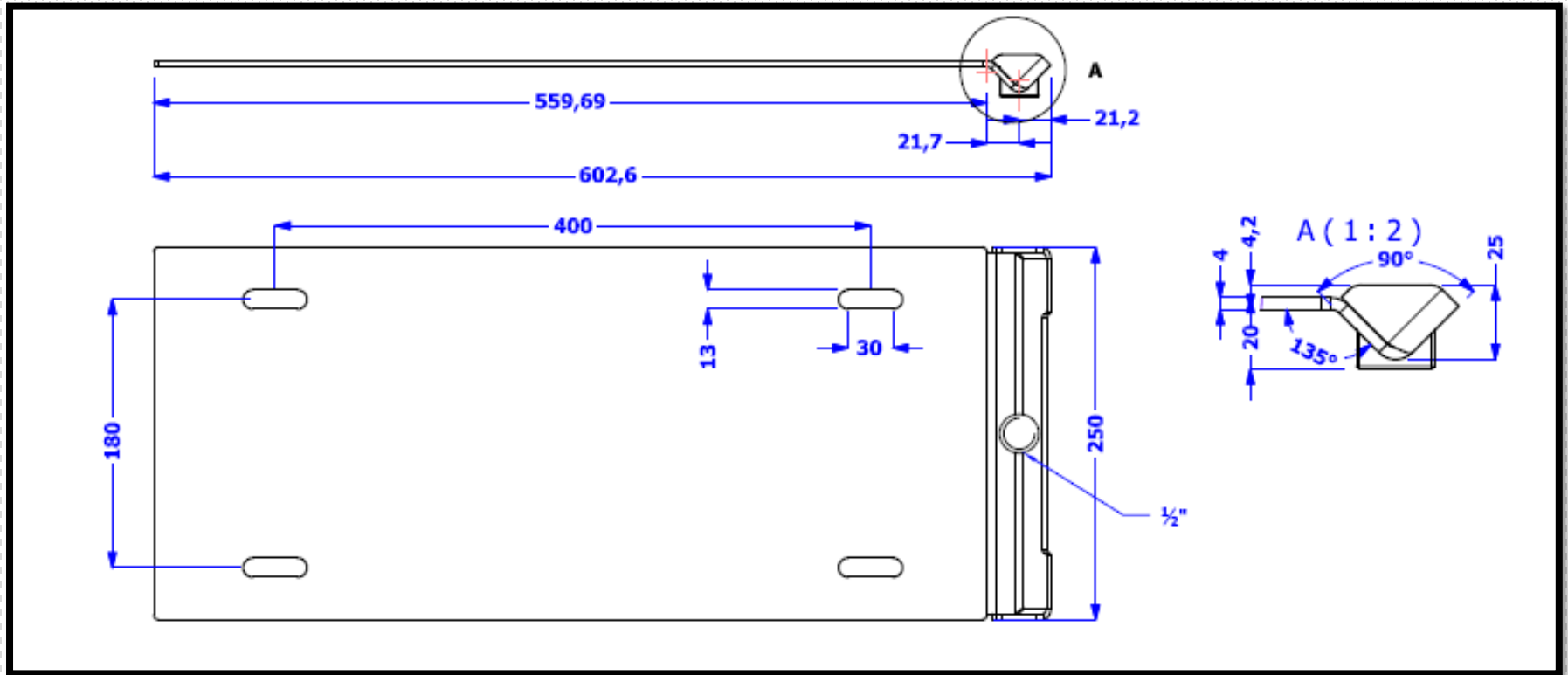
**CUSTOMER
FIXING
ADJUSTABLE
BASE
(+/- 50 mm)
WEIGHT: 200 kg**



AT CUSTOMER'S CHARGE

STEP 0

POSITIONING OF THE MACHINE WITHOUT VERTICAL ADJUSTMENT



STEP 0

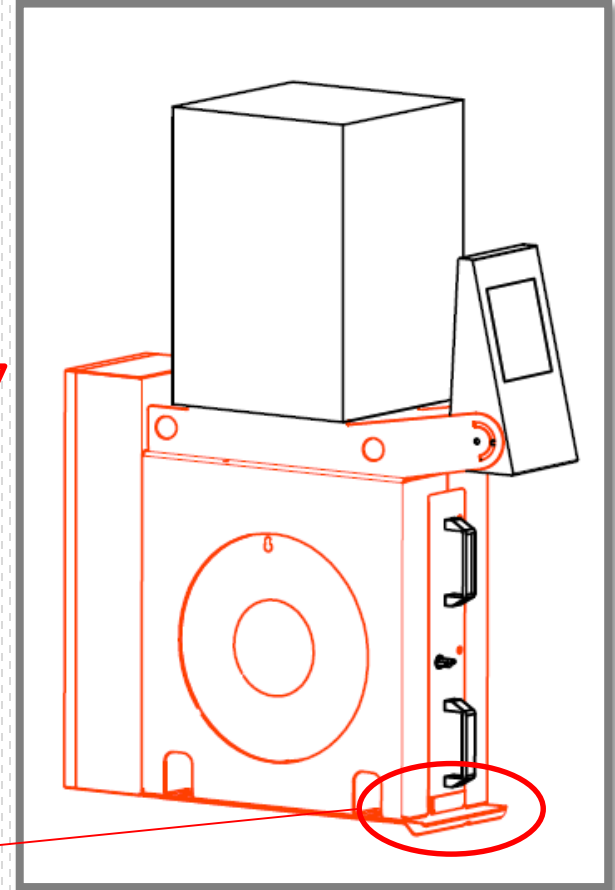
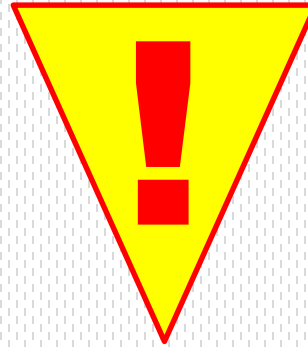
FIXING HOLES WITHOUT VERTICAL ADJUSTMENT

AT CUSTOMER'S CHARGE



BASE FOR THE MACHINE

STEP 0

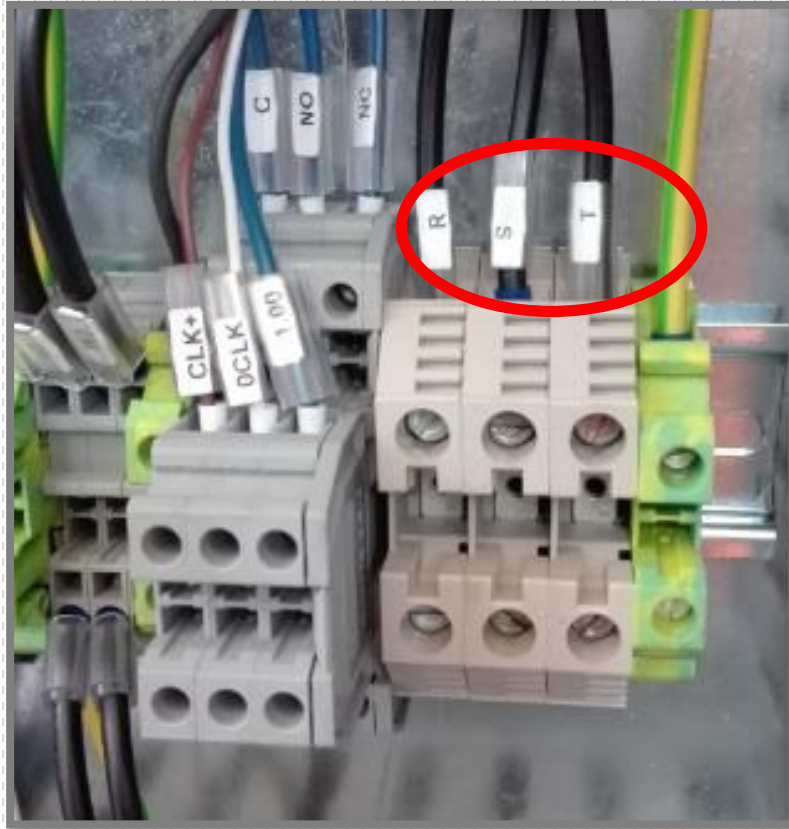


See Details A - page 8



AT CUSTOMER'S CHARGE

ELECTRIC AND PNEUMATIC CONNECTION



- CHECK THAT THE SUPPLY VOLTAGE INDICATED ON THE NAMEPLATE IS THE SAME NETWORK.
- CONNECT THE POWER CABLE TO THE TERMINAL BLOCK INSIDE THE ELECTRICAL CABINET.
- CONNECT THE COMPRESSED AIR TUBE TO THE BALL VALVE ON THE SIDE OF THE TANK (MAX 6 BAR).



AT CUSTOMER'S CHARGE

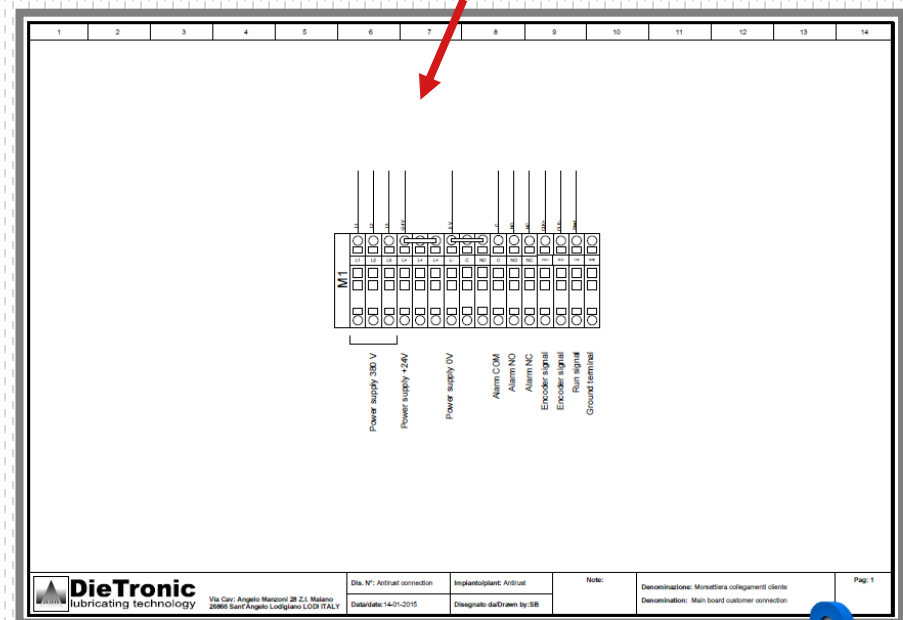
STEP 1

EXTERNAL SIGNAL CONNECTION

CONNECT THE EXTERNAL SIGNALS TO THE CUSTOMER MAIN TERMINAL BOARD FOR THE AUTOMATIC OPERATION OF THE MACHINE.



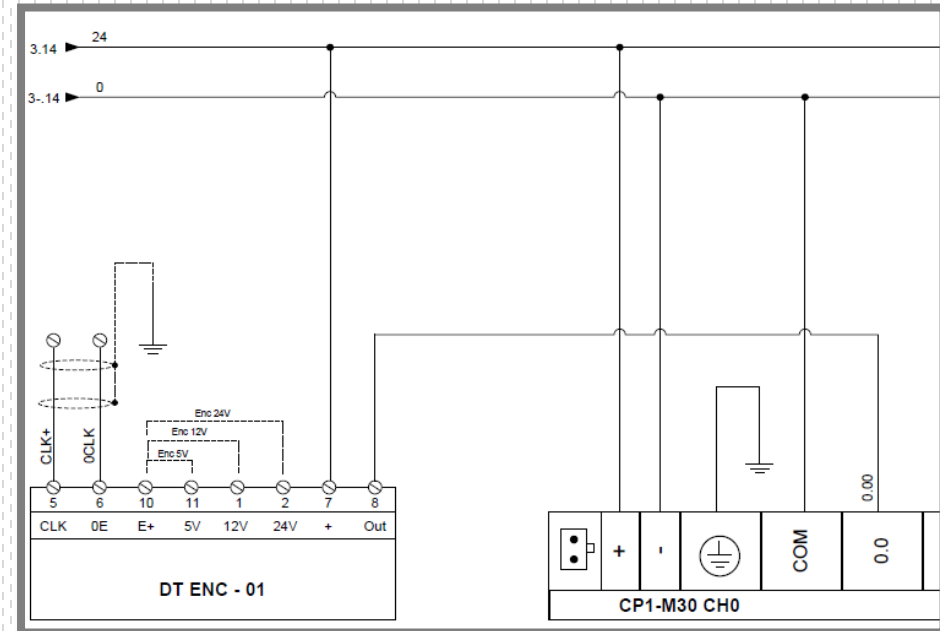
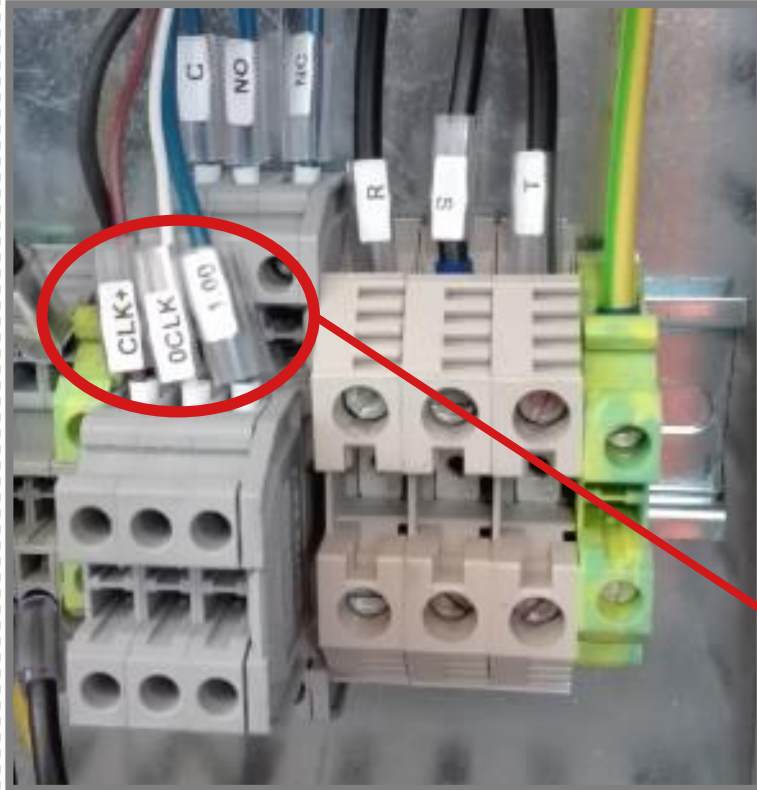
SEE THE DOCUMENTATION
MAIN BOARD CUSTOMER CONNECTION



AT CUSTOMER'S CHARGE

EXTERNAL SIGNAL CONNECTION - ENCODER

CONNECTING AN INCREMENTAL ENCODER PUSH PULL



PAGE 4 OF THE ELECTRICAL DRAWING

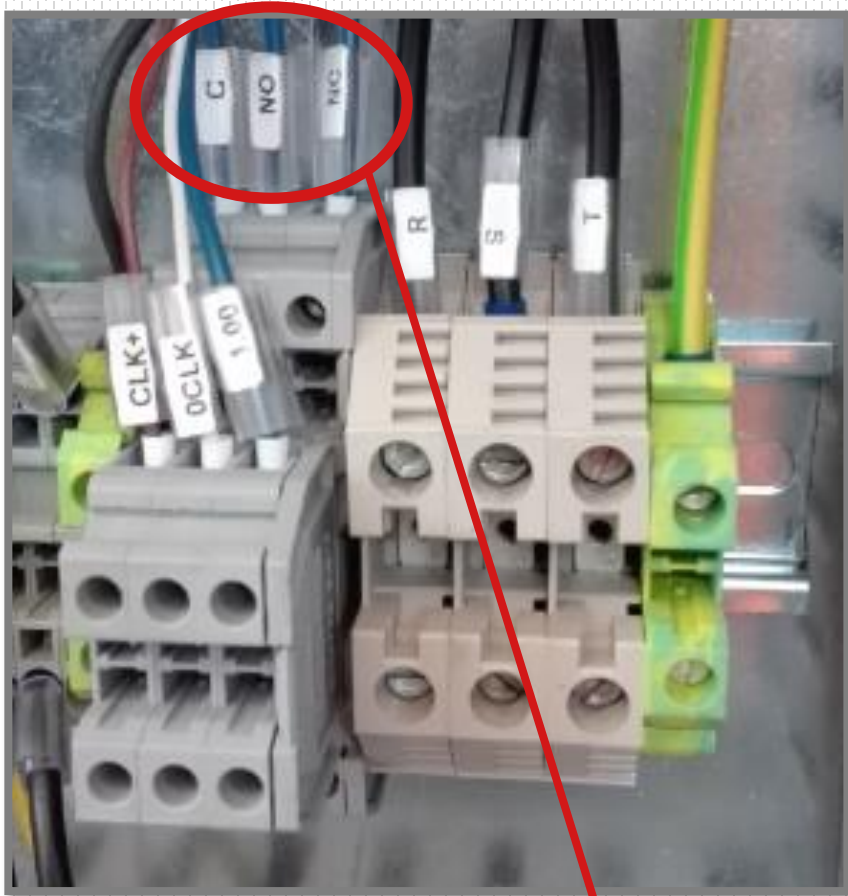


IT'S POSSIBLE USE THREE
DIFFERENT TYPES OF ENCODERS
5 VOLT / 12 VOLT / 24 VOLT

AT CUSTOMER'S CHARGE



EXTERNAL SIGNAL CONNECTION - ALARM



IT'S IMPORTANT TO CONNECT THE ALARM SIGNAL (SEE WIRING DIAGRAMS AND MANUAL), TO AVOID FURTHER PROBLEMS TO THE FLOW SENSORS.

IF THE ALARM SIGNAL IS CONNECTED TO THE MAIN PANEL, THE MACHINE STOPS IN CASE OF THE FAILURE OF THE SENSOR FLOW.

THIS WAY IS POSSIBLE TO AVOID TO BREAK THE SENSOR BECAUSE IF THE NOZZLE IS DIRTY AND CLOGGED AND THE MACHINE CONTINUES TO WORK, CAUSE THE BREAKING OF THE SENSOR.

STEP 2



AT CUSTOMER'S CHARGE

ELECTRIC CONNECTION MACHINE-TANK



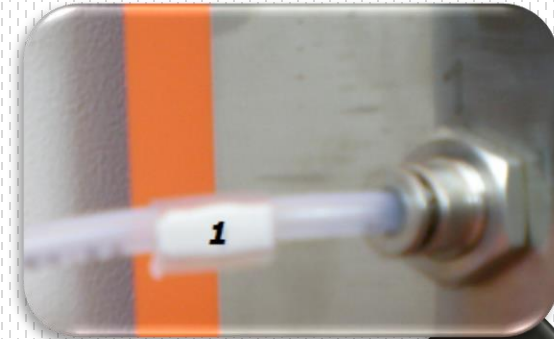
CONNECT THE XI CONNECTOR AT THE
BASE INSIDE THE ELECTRIC CABINET

STEP 3

AT CUSTOMER'S CHARGE



PNEUMATIC AND HYDRAULIC CONNECTION MACHINE-TANK



CONNECT THE OIL AND AIR TUBES FROM THE MACHINE TO THE TANK.
SEE LABELS ON THE TUBES AND THE PLATE ON THE TANK



AT CUSTOMER'S CHARGE

STEP 4

PNEUMATIC AND HYDRAULIC CONNECTION MACHINE-TANK

ANTIRUST 04

CHANNEL 1 (1)

CHANNEL 2 (2)

CHANNEL 3 (3)

CHANNEL 4 (4)

CHANNEL 5 (5)

CHANNEL 6 (6)

CHANNEL 7 (7)

CHANNEL 8 (8)

ANTIRUST 08

PULVERIZATION AIR (A)

OIL RETURN (B)



AT CUSTOMER'S CHARGE

STEP 4

FILLING THE TANK



STEP 5

AT CUSTOMER'S CHARGE



RECOVERY FILTER UNIT - OPTIONAL



DIRTY OIL



FILTERED OIL

STEP 6

AT CUSTOMER'S CHARGE



TURNING ON THE MACHINE



TURN ON THE ELECTRICAL CABINET.

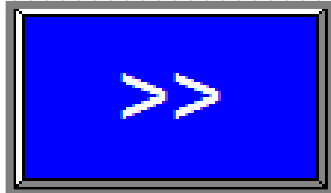
THE HOME PAGE WILL APPEAR ON THE TOUCH SCREEN PANEL.



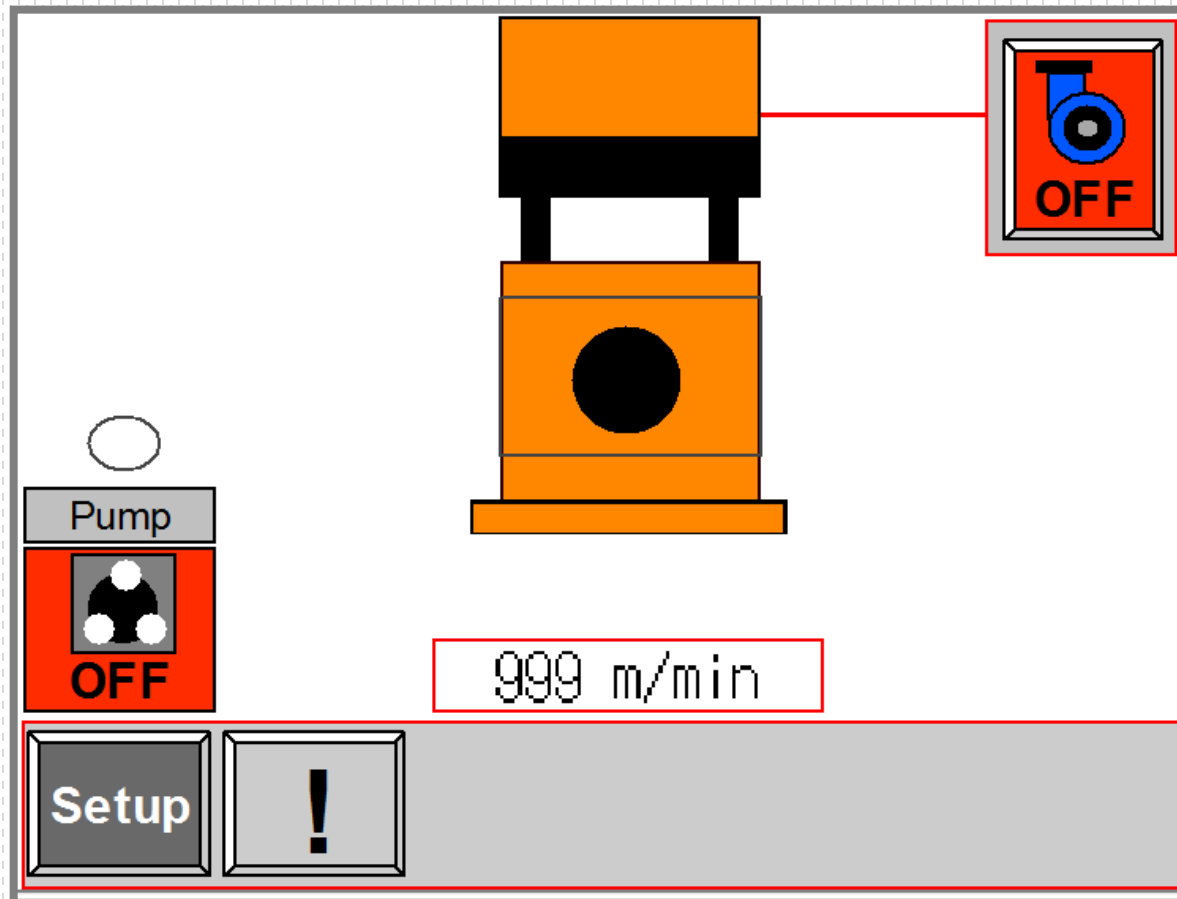
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TURNING ON THE MACHINE



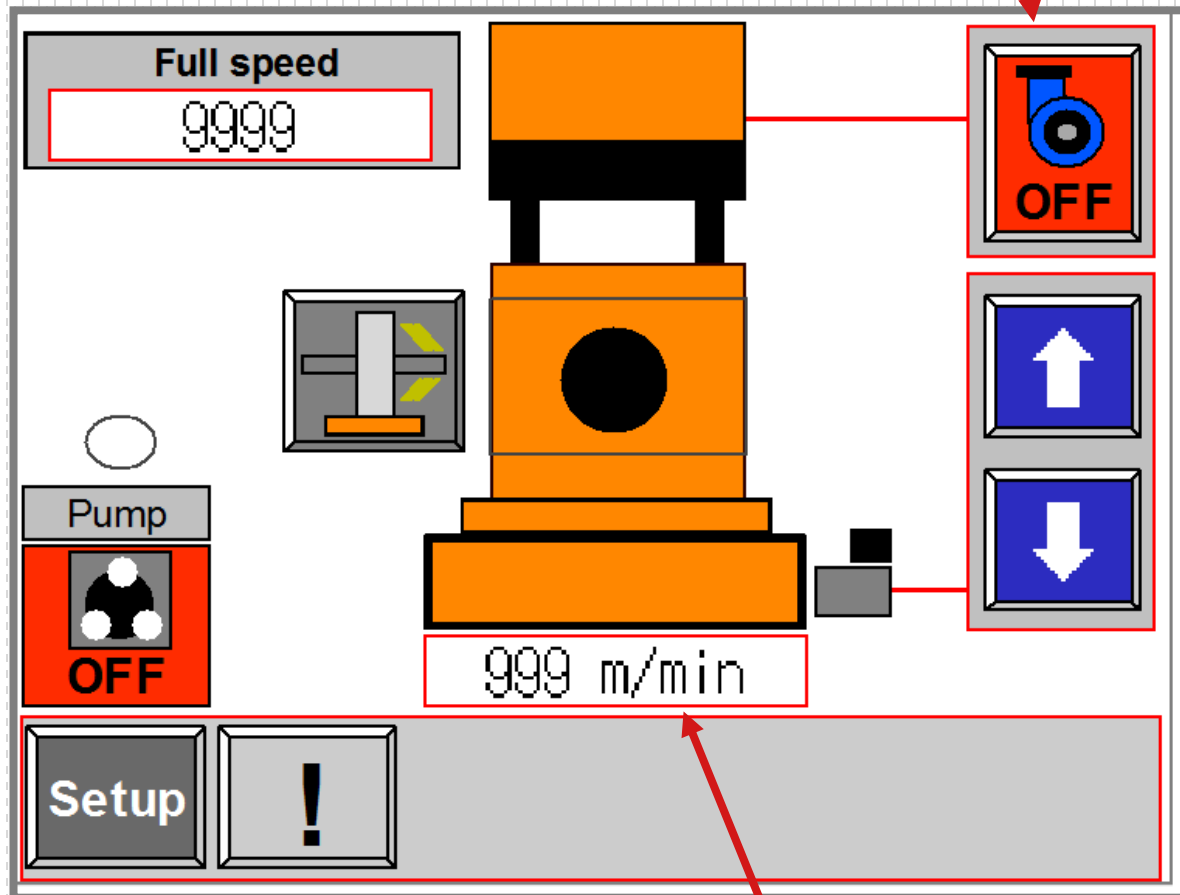
PRESS THE BUTTON TO ENTER IN THE INITIAL PAGE OF THE SYSTEM



STEP 7

START PAGE

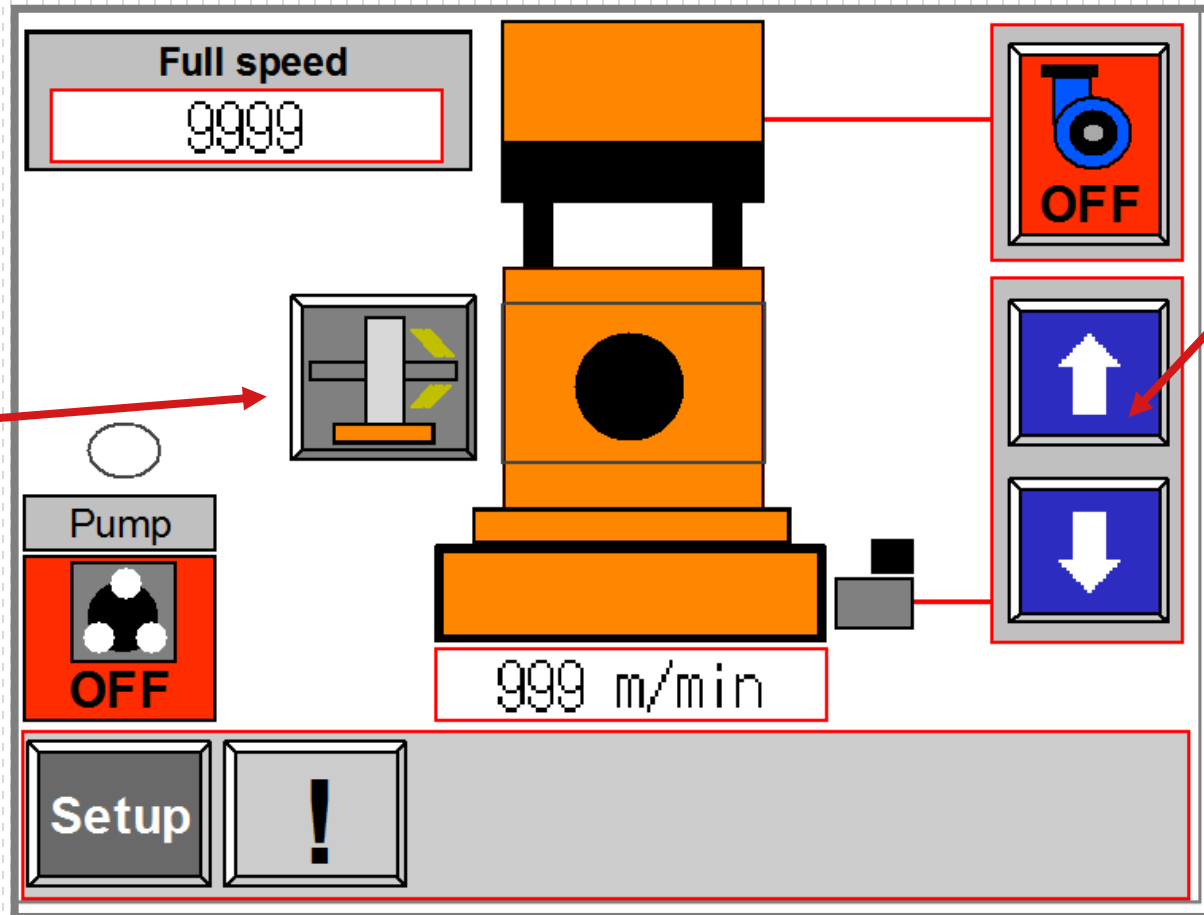
PRESS FOR 3 SEC, THE SUCTION SYSTEM WILL START IN MANUAL MODE
PRESS FOR 1 SEC TO SET THE AUTOMATIC MODE



SPEED OF THE LINE

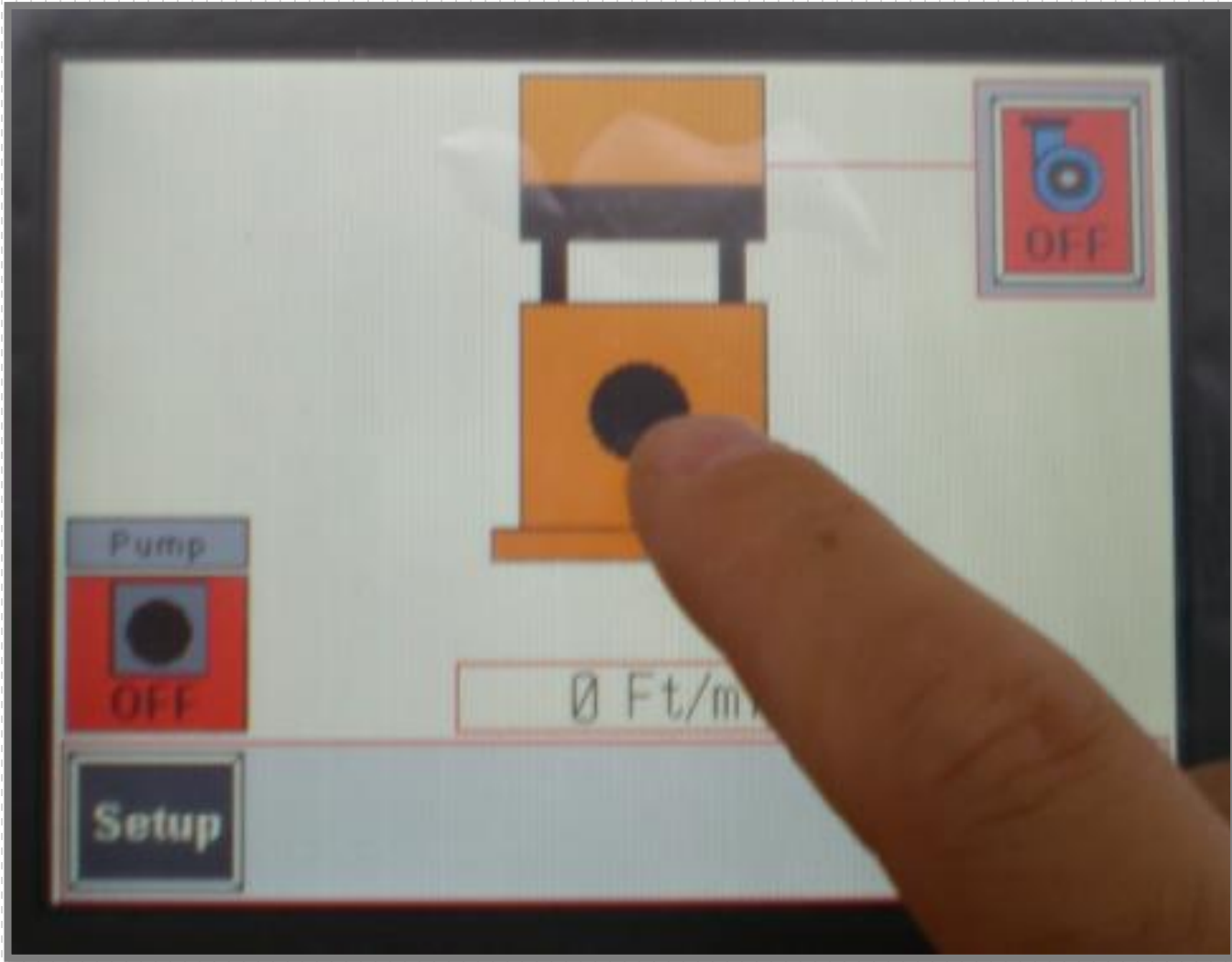
START PAGE

OPTIONAL: UP/DOWN SYSTEM- PUSH THE BUTTONS TO CHOOSE THE CORRECT HIGH OF THE MACHINE ON THE BASIS OF THE PASS LINE



OPTIONAL: ON/OFF AIR KNIFE

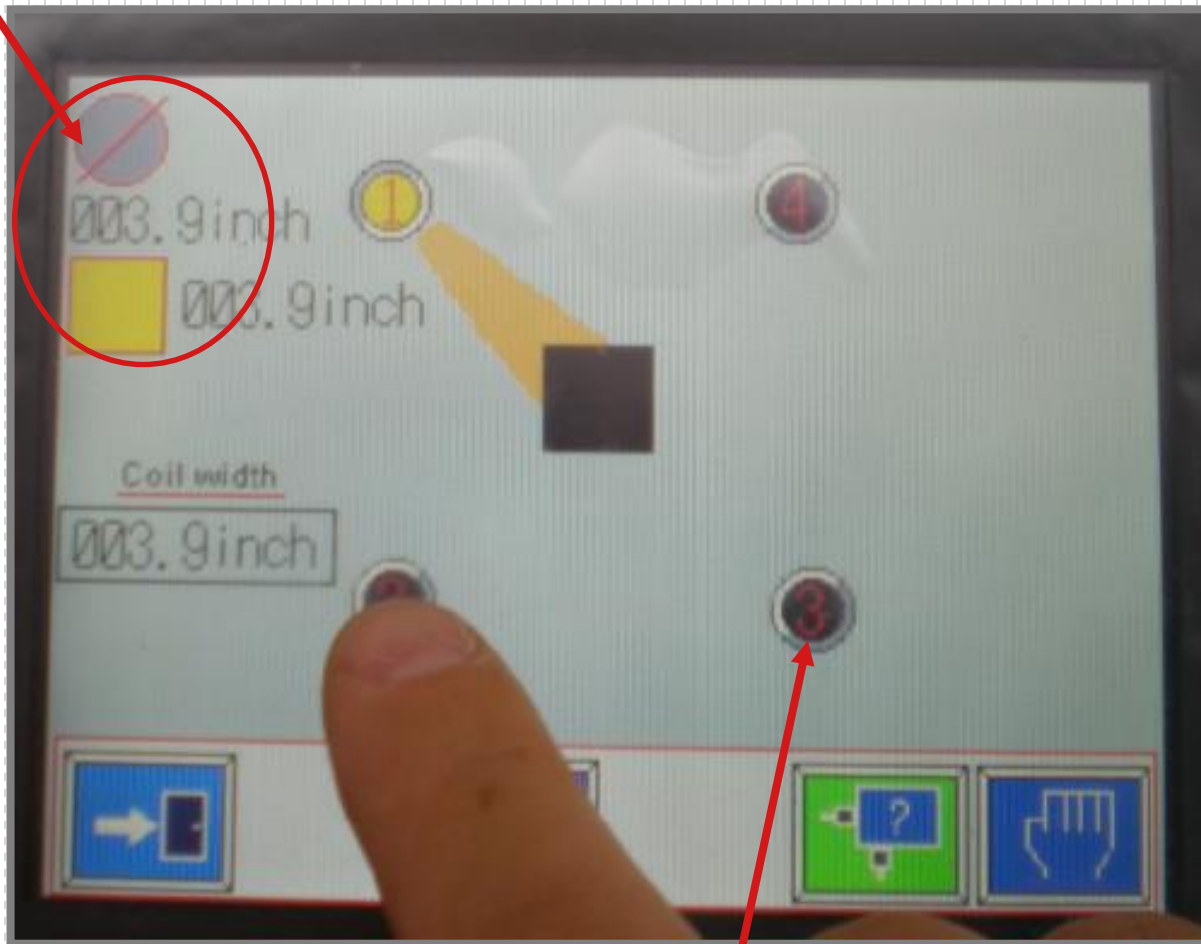
START PAGE



TYPE THE BLACK HOLE AND ENTER IN THE PAGE
OF THE NOZZLES MANAGEMENT

NOZZLES MANAGEMENT PAGE

BUTTON TO SELECT THE PROFILE AND THE DIMENSION OF THE TUBE
(ROUND OR SQUARE OR RECTANGULAR)

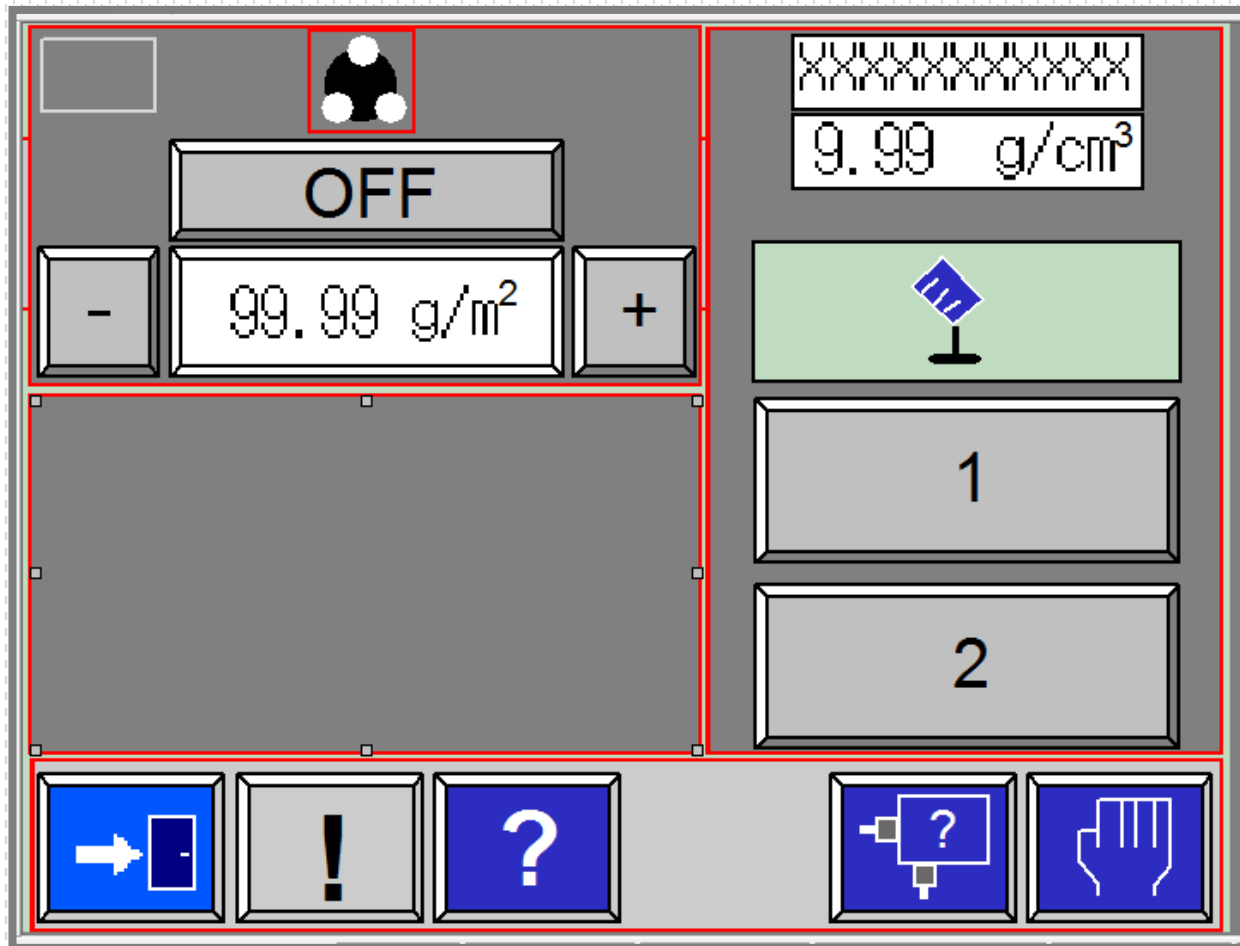


BUTTON TO TURN ON / TURN OFF THE NOZZLES

OIL MANAGEMENT PAGE



PRESS THE BUTTON TO ENTER IN THE OIL MANAGEMENT PAGE



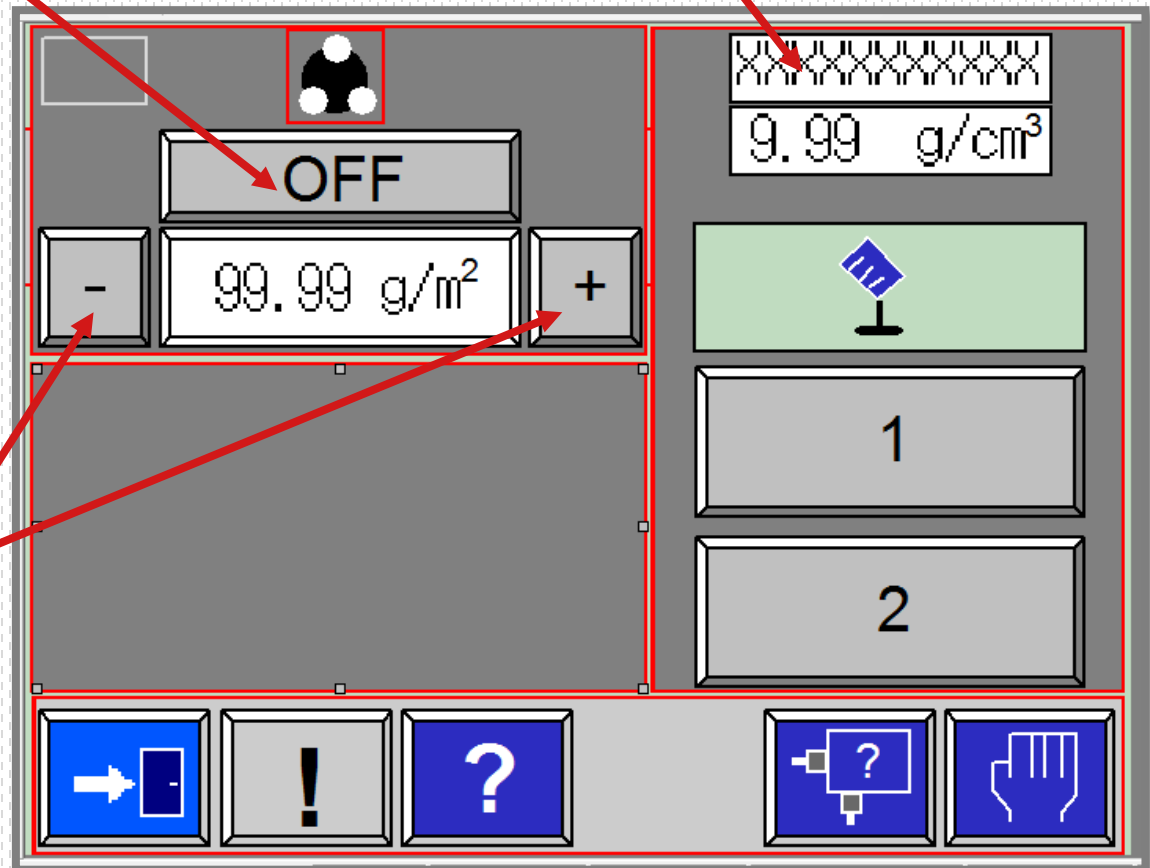
STEP 10

OIL MANAGEMENT PAGE

BUTTON TO TURN
ON / TURN OFF
THE GEAR PUMP

BUTTON TO
CHANGE THE
VISCOSITY OF OIL

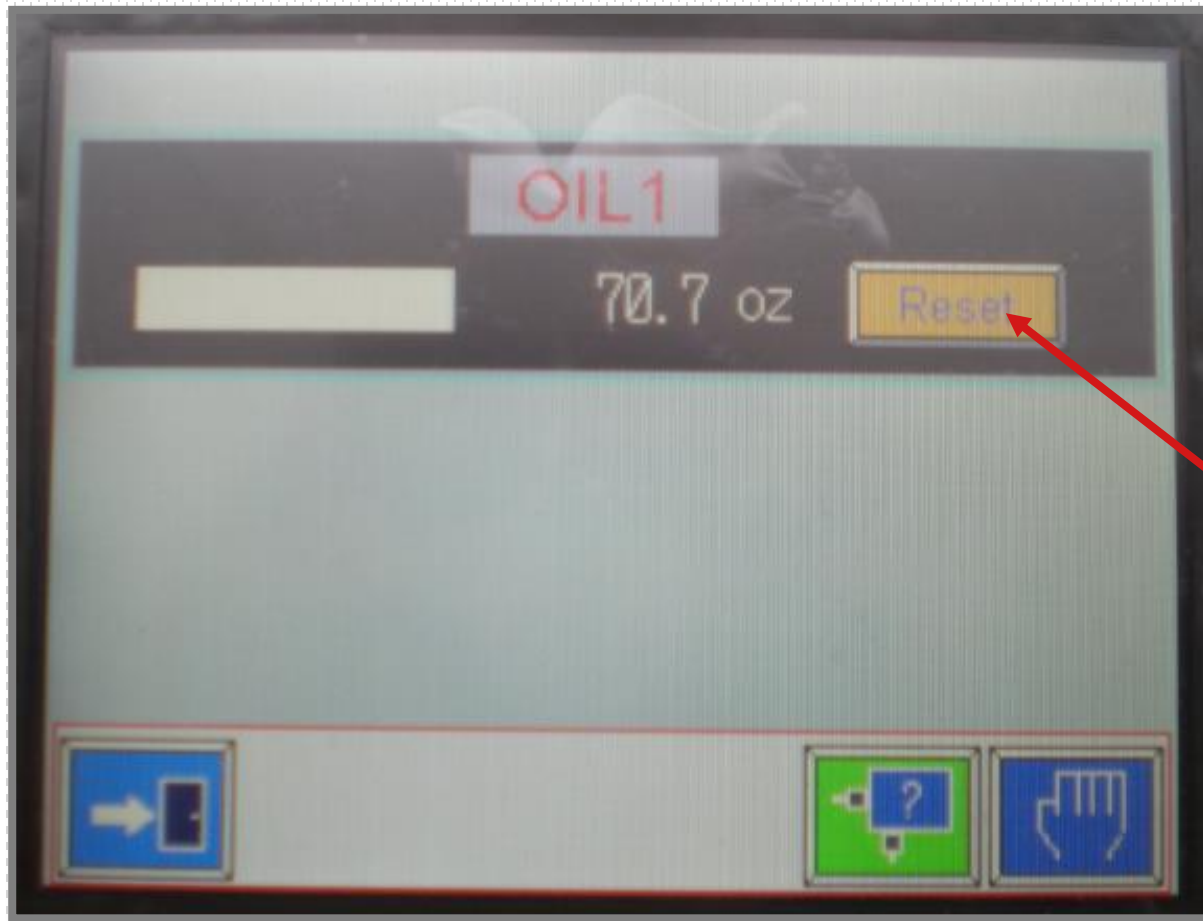
BUTTON TO
INCREASE $[+]$ OR
DECREASE $[-]$ THE
QUANTITY OF OIL



INFORMATION ON CONSUMPTION OF OIL

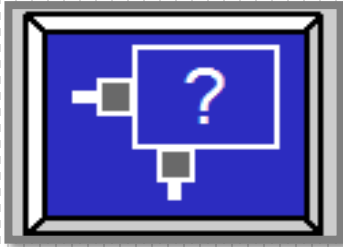


PRESS THE BUTTON TO ENTER IN THE OIL MANAGEMENT PAGE

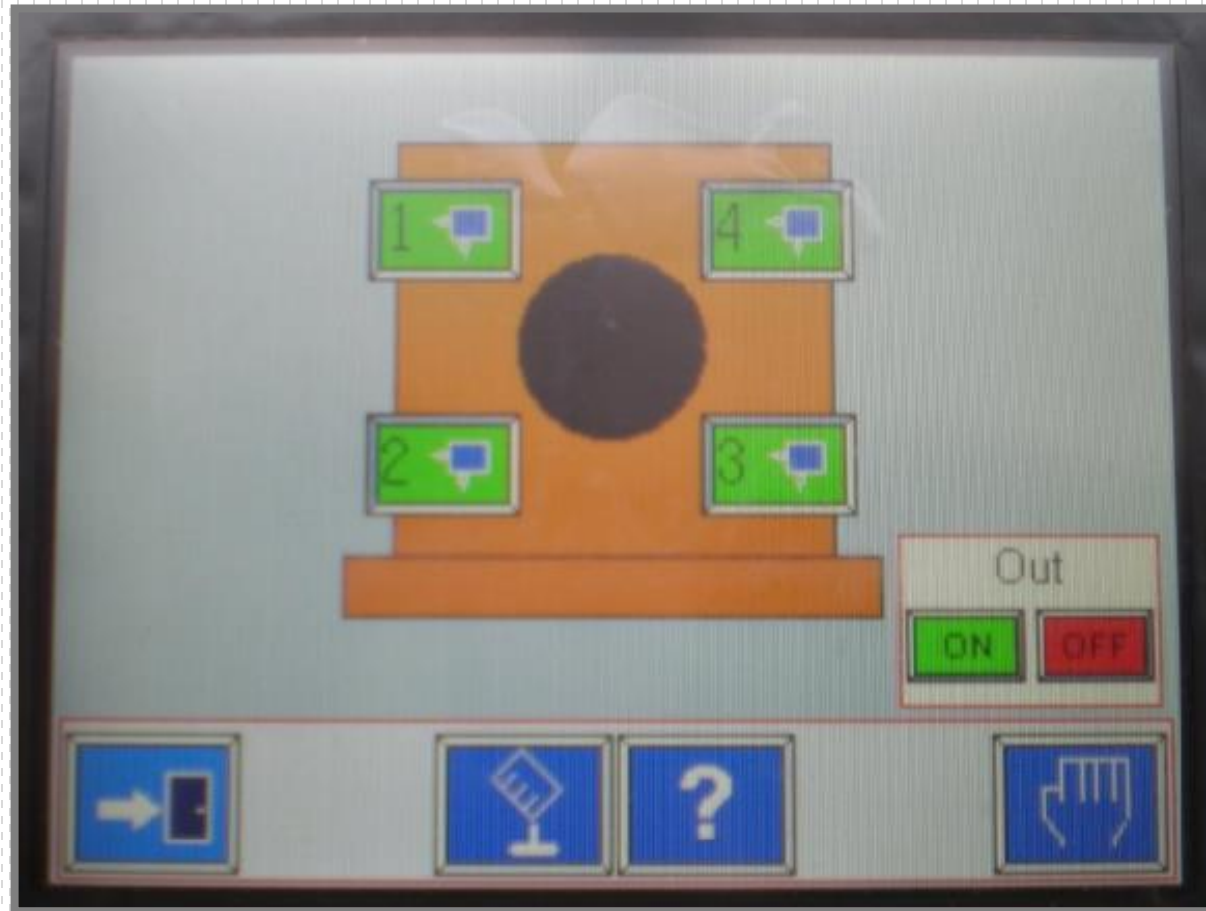


PRESS THE
BUTTON TO
RESET THE
COUNTER

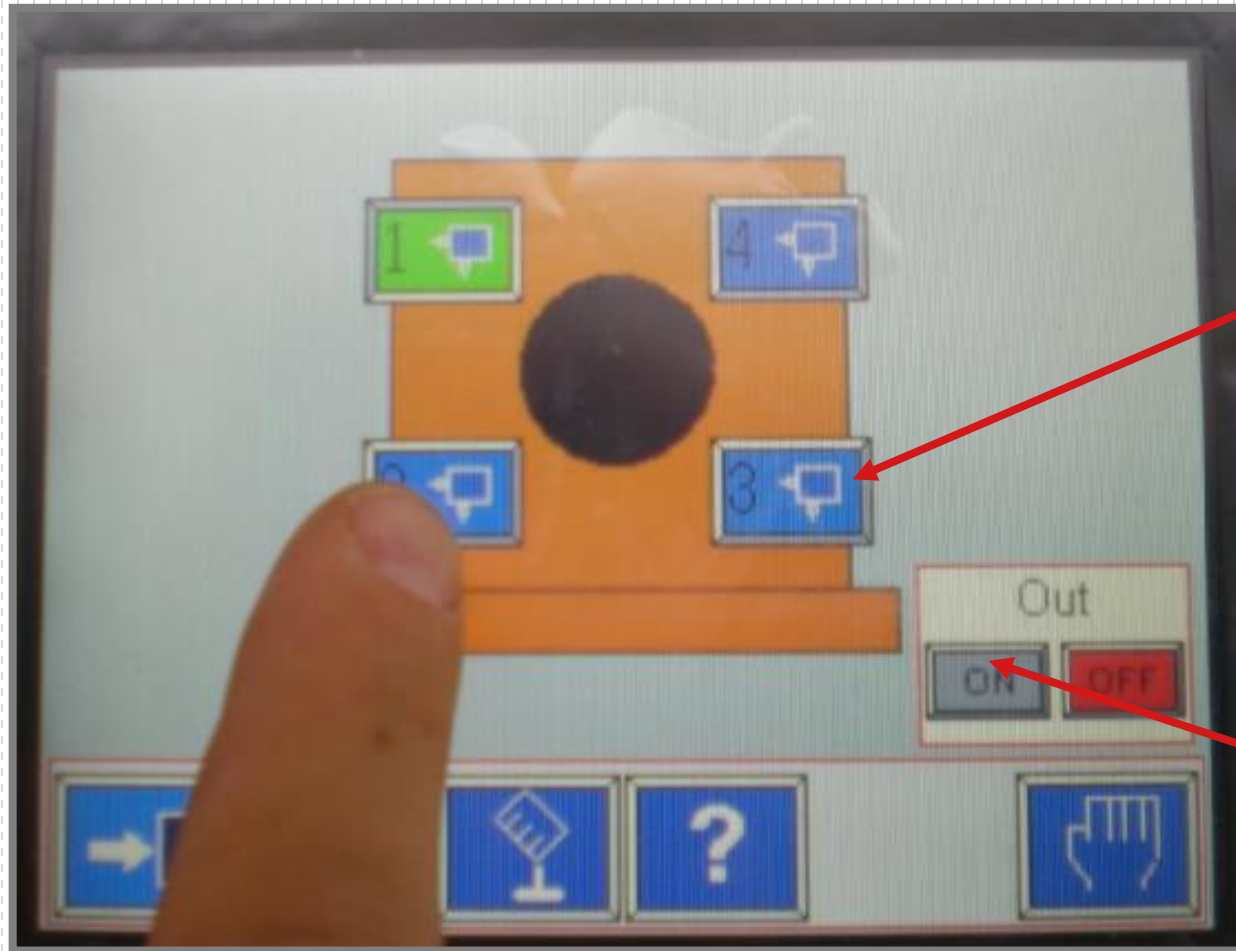
FLOW CONTROL PAGE



PRESS THE BUTTON TO ENTER IN THE FOLLOWING PAGE AND TURN ON / TURN OFF THE SENSOR FLOW



FLOW CONTROL PAGE



BUTTON TO TURN
ON OR TURN OFF
THE SENSOR FLOW

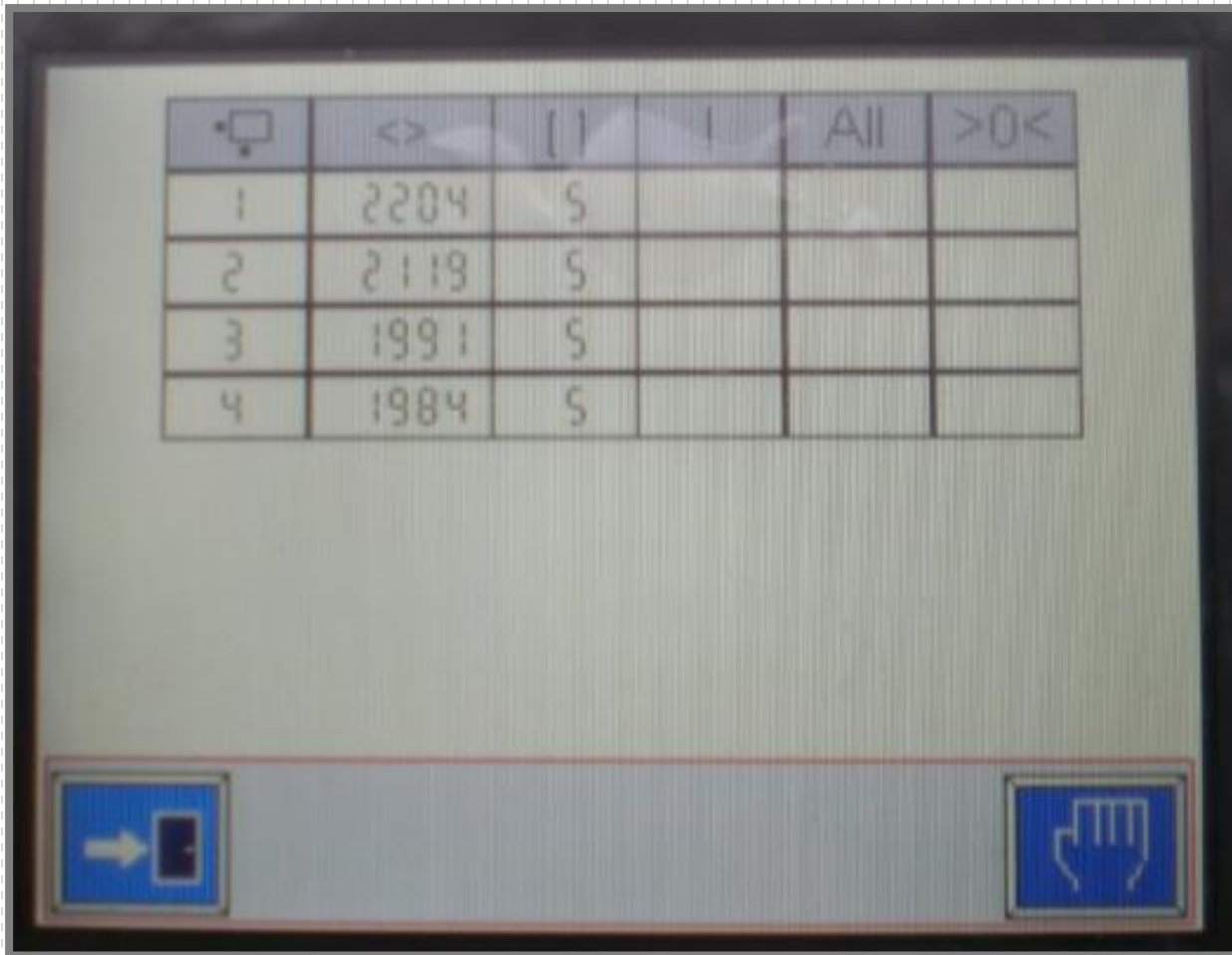
BUTTON TO REMOVE
THE ALARM SIGNAL

STEP 12

FLOW CONTROL PAGE



PRESS THE BUTTON TO ENTER IN THE PAGE OF THE
CONTROL THE PARAMETERS OF THE SENSORS FLOW



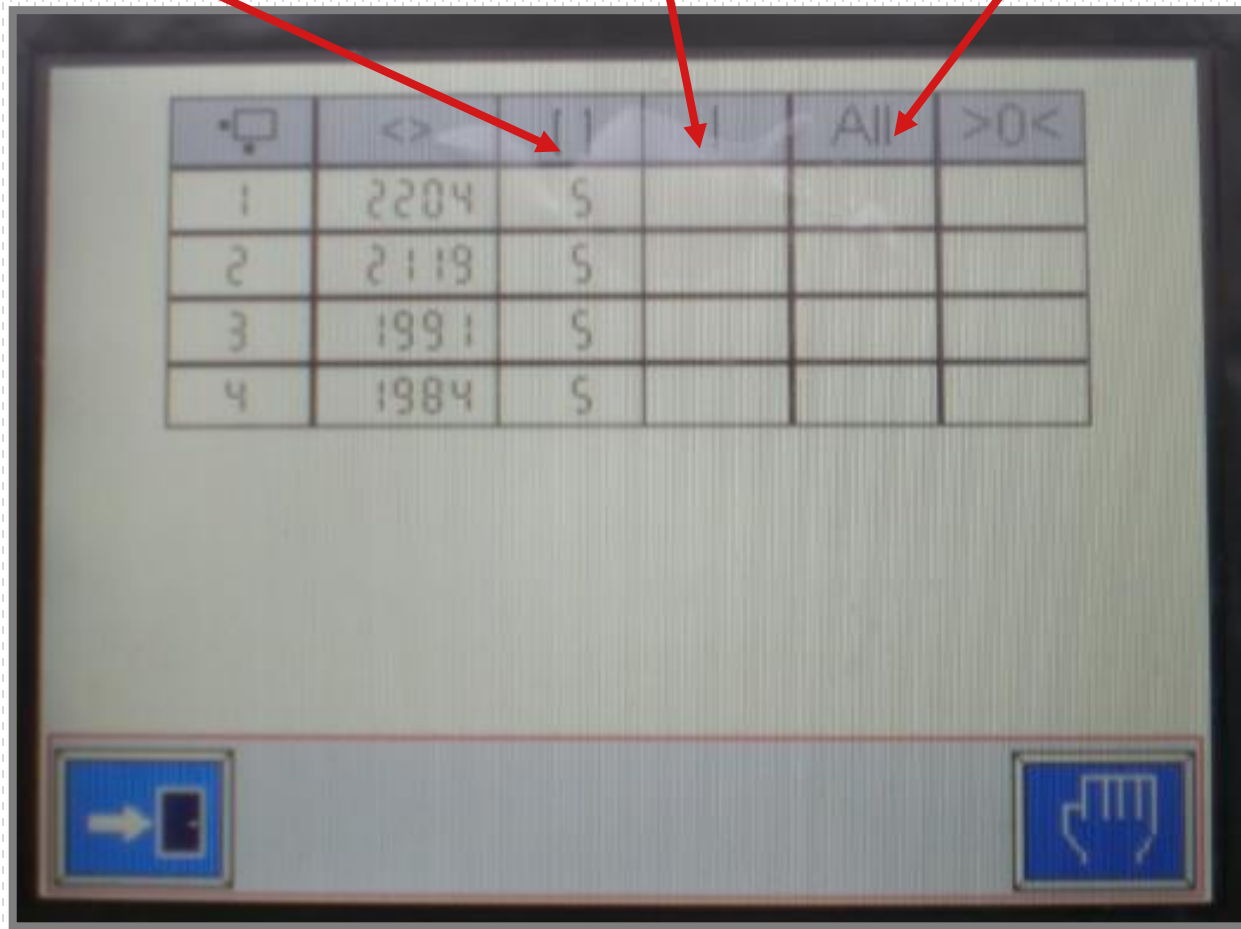
STEP 12

FLOW CONTROL PAGE

SELECT THE RANGE OF 5
[LOW VISCOSITY] TO 20
[HIGH VISCOSITY]

PRE-ALARM SENSOR FLOW

ALARM SENSOR FLOW



STEP 12

OPERATION IN MANUAL MODE



PRESS THE BUTTON TO
OPERATE IN MANUAL
MODE AND CONTROL
THE CORRECT
OPERATION OF THE
SINGLE NOZZLE

AT THE FIRST START OF THE MACHINE, TURN ON ALL
NOZZLES AND PRESS THE MANUAL MODE BUTTON.
WAIT THAT THE HYDRAULIC CIRCUIT IS FULL AND THE
NOZZLES BEGIN TO SPRAY OIL.

PULVERIZATION AIR CONTROL



TURN THE PRESSURE
REGULATOR CLOCKWISE TO
INCREASE THE
PULVERIZATION AIR AND
COUNTERCLOCKWISE TO
DECREASE THE
PULVERIZATION AIR

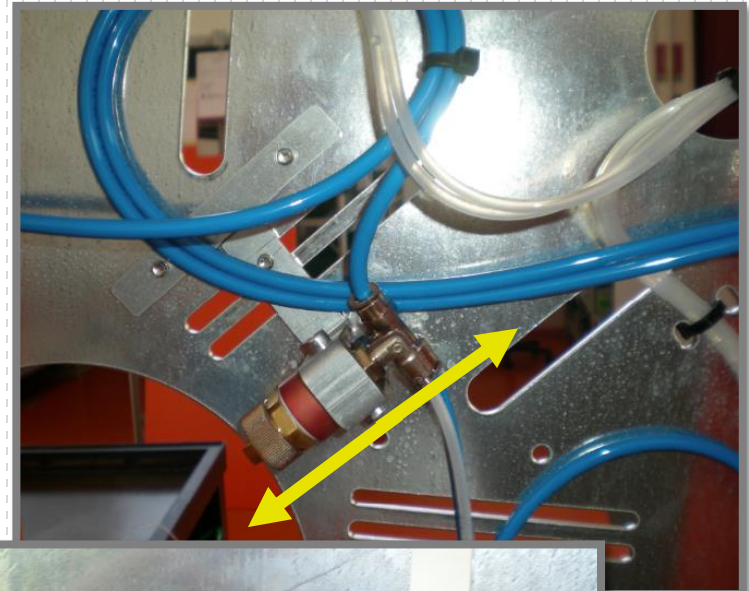
STEP 14

POSITIONING OF THE NOZZLES

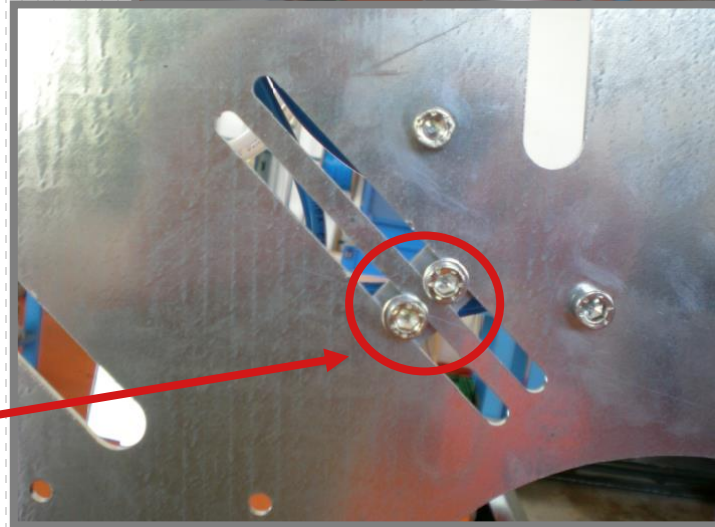
MOVE AWAY OR APPROACH
THE NOZZLES ACCORDING TO
THE PROFILE OF THE TUBE



TAKE OUT THE SPRAY BOX



UNSCREW THE TWO
SCREWS TO MOVE THE
NOZZLE



CHOOSE THE CORRECT COVERS



CHOOSE COVER MOST
APPROPRIATE BASED ON
THE SIZE OF THE PIPE



DOCUMENTATION

IT IS POSSIBLE TO FIND ALL THE
DOCUMENTATION REGARDING THE MACHINE
INSIDE THE ELECTRICAL CABINET:

- OPERATING INSTRUCTION AND
MAINTENANCE
- SPARE PARTS LIST
- ELECTRICAL DRAWING
- EXTERNAL SIGNAL
- HYDRAULIC AND PNEUMATIC CIRCUIT



OPERATION IN AUTOMATIC MODE

NOW THE MACHINE IS READY FOR
WORK IN AUTOMATIC MODE

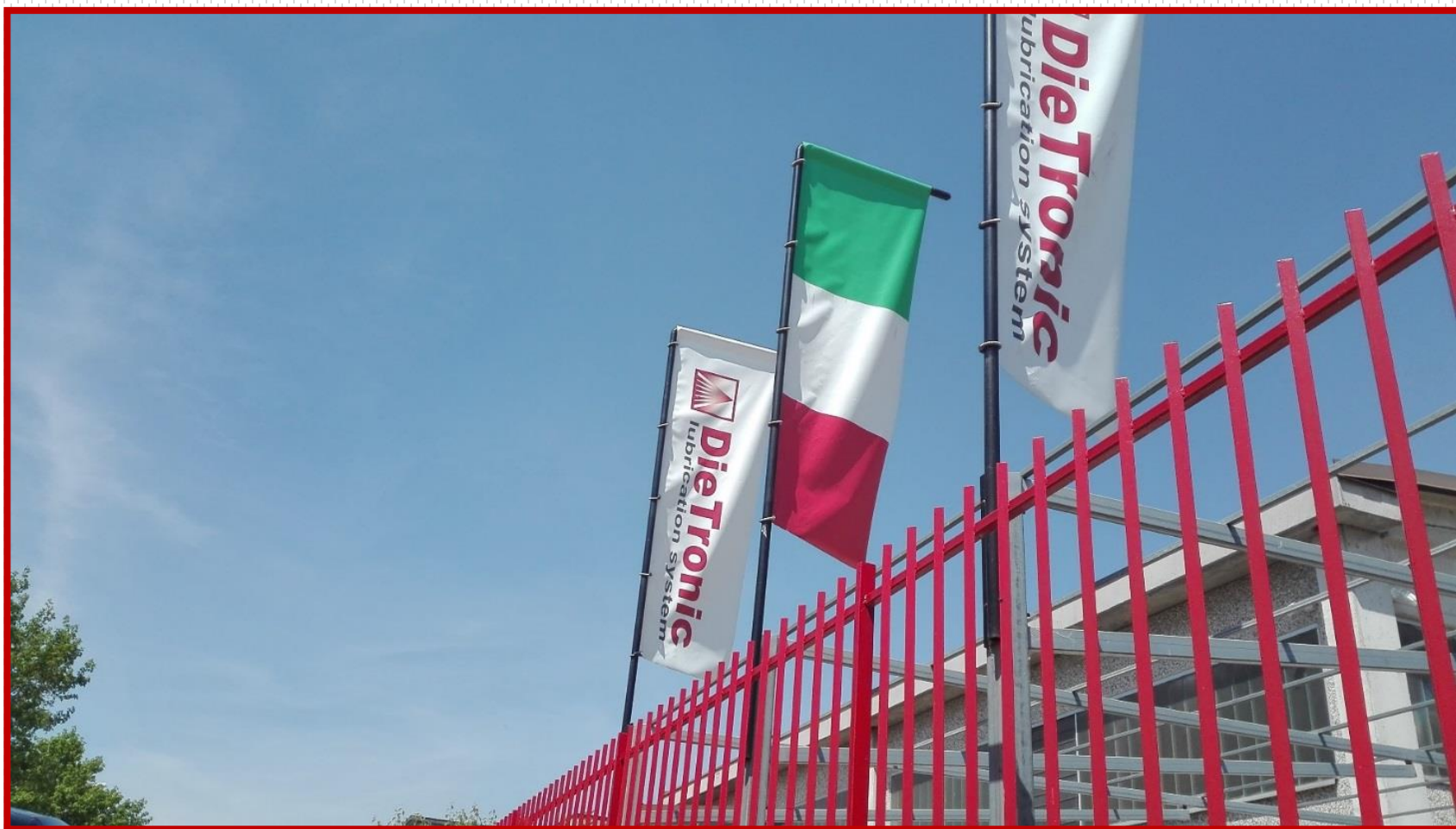


HAVE A GOOD WORK

*FOR ANY TECHNICAL SUPPORT REGARDING THE PRE-COMMISSIONING OR
FURTHER ASSISTANCE YOU CAN ALWAYS CONTACT OUR TECHNICAL TEAM:*

+39 0371 210 129

INFO@DIETRONIC.EU



THANK YOU FOR YOUR ATTENTION



DIETRONIC S.R.L

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WWW.DIETRONIC.EU*