

Operation Manual

1 Step Before Fitting the Machine

- Look for suitable place to set the Machine.
- It's good to place wooden planks on the ground before Machine move in.
- Earth wire of the Main Machine must connected (to prevent accident occurs).
- Check power supply is it in good supply.
(if its low, it will damage motor :- suggest to measure by volt meter)
* ensure the voltage is not less then 400V oor minimum ampere of 25A.
- Make sure the Mixer Knife is turning in normal condition speed
(if mixer knife turning at abnormal, mean voltage too low and this will burn the Motor).
- Pour some tapioca starch on the Extrusion Rolling compress Roller to ensure smooth compress processing.
(do not pour water on roller during the processing to escape from bearing and Extruding Tube damaging)
* If Mixer Knife turning slow and at abnormal sound, mean voltage too low or inconsistent, this will burn the Motor. Immediate inform Electrical Mechanical to check the main current supply.

2 Starting Operation Guide

- Standby mixing sand, water and packet of cement evenly in Blender Mixer first
(suggest 15 scoops of sand for the first mixture to get running smooth).
- Make sure the Blender Mixer and Hopper Mixer are turning in a clockwise direction.
- Pour plaster lime 10kg/bag or 8liters of water into Hopper Mixer.
Start delivery the water then stop delivery immediately before water empty to prevent air suck in.
- Pour plaster lime 10kg/bag or 8liters of concentrated Cement with water mixture into Hopper Mixer and delivery until empty.
- Stop the delivery first by switch off the Main Machine.
Flow down the first Mixture to Hopper Mixer and do not start delivery first.
- Turn on the vibrating motor of the Hopper Mixer. Allow ready Mixed plaster to flow down until full, Don't start delivery first, standby one more mixture of Cement on Blender Mixer then start deliver
(Make sure the Hopper Mixer is always filled up with plaster to prevent air to suck in. If air suck in, this may causes a Choke).
- Increase the speed if the delivery process is smooth.

3 Stopage During Long Breaks or Power Supply Break Down Guide

- Disconnect the Iron Tube and the Extruding Tube.
- Clean all the Cement inside of the Iron Tube and Extruding Tube.
- Repeat the cleaning procedure (If long break not more than 30mins, turn Main Machine switch to reverse and countdown to 10second then switch back forward and start delivery again).

4 Jamming Guide

- Stop the delivery, (extract the plaster back by turn Main Machine switch to reverse and countdown to 10 second then switch back forward and start delivery again).
- **Check what is the cause of the jamming. Normally, its happen on below issues :-**
 - Choking cause by the jammed at 10m Delivery Tube.
(use Hammer to knock on the harden Plaster in the Tube before digging it out).
 - Chocking cause by Iron Tube, it could be the Rubber Ring of the retaining ring has been torn(replace it with a new one).
 - Chocking cause by Hopper Tube. It could be the inconsistent delivery or uneven mixing (turn main Machine switch to anti-clockwise to return all the Cement several times until smooth delivery again).

5 Cleaning Procedures

- Disconnect power supply of Blender Mixer and push all the remaining Mixture to Hopper Mixer until empty.
- Take out the Blender Mixer knife and wash thoroughly.
- Let all the Mixture flow through the Hopper Mixer.
- Stop the delivery and disconnect the Hopper Mixer, take out the Hopper Mixer Knife and wash it.
- Dig out all the extra mixture from Hopper Mixer then start machine again to pump up all the remaining Cement.
After that stop Machine again.
- Pour one pack of Plaster Lime and start Machine to pump up follow by block the Hopper output with Sponge while Plaster lime almost finish (to prevent air suck in).
- Stop the Main Machine again, clean off all the Blender and Hopper Mixer accessories. Clean thoroughly to prevent the leftover Mixture from causing rust in the long term.
- Standby 5 pieces of Sponge will be pump up follow one by one internal between 10 second each).
- Make sure all the Sponges flow out from the end of the Iron Tube (this is to clean all the remaining Mixture along the Iron Tube)
- If the Sponges never flow out. It must be stuck either one of the Iron Tube that rust start remained.
(disconnect few Iron Tube to check where the Sponges stuck).
- Everyday after work must practice to clean all the items throughly to maintain Machine in good condition and run smoothly.

6 Fixing the Extruding Tube

- Apply some powder onto the external surface of the Extruding Tube.
- Fix the tube from the bottom to top into the Extruding Rolling.
- Gauze the Extruding Tube by manually controlling the speed.
- Tighten the upper connection first then to lower connection.
- Make sure the groove is fully filed and control the Extruding Tube direction on the positioning.
- Check the compressing Roller weekly (off power supply before checking).
- Turn the Extruding Tube upside down surface twice a week to get longer life of the Extruding Tube for cost saving purpose.

7 Basic Defects Rectifying

- **Main Machine**
 - Compressing Roller not moving/ unable to deliver/ bearing defective/ protective wheel not moving or difficult to rotate/ control panel shortage of Oil/ Gear defective and centre shaft bent.
- **Blender Mixer**
 - Motor defective/ Blender Mixer's Knife/ heavy knock on Mixer's Knife/ Gear Box Oil leakage/ Main Switch short circuit or Wire torn causing leakage.
- **Hopper Mixer**
 - Motor defective/ light vibrating cause by loose screws or heavy knock on Hopper Mixer's Knife.