ErreBi SHOP | Soluzioni Custom in tempi record

Manual RBEW1940

Product Introduction

Our company specializes in manufacturing far-infrared double-sided heating ovens, tunnel ovens, and other series of intelligent mechanical products. These products are mainly used for heat shrinking of wire harnesses and heat shrink tubing, heat shrink film packaging, and heat shrinking and baking of products such as circuit boards, transformer copper busbars, and inductor coils.

Several key advantages of far-infrared (double-sided heating) heat shrink ovens:

1. Mechanical double-sided heating ensures that the product being baked is heated from both the top and bottom simultaneously, with a small temperature difference between the top and bottom. This prevents the product from shrinking or deforming during the baking process, maintaining stable quality.
2. The assembly line feeding mode ensures fast baking speed and high efficiency, significantly improving production efficiency;
3. The open structure allows for localized heating of the product, preventing damage to components in other parts of the product;
4. The mechanical structure is compact, the design is exquisite, the size is small, it

does not take up much space, and it can be selected as floor-standing or desktop type, and can also be connected to the production line for synchronous control;

5. The heating temperature is adjustable and can be adapted to the temperature requirements of different products;

6. The chassis features a double-layer shell design with high-temperature resistant insulation cotton sandwiched in between, preventing the outer surface temperature of the chassis from overheating. This not only creates a comfortable working environment but also reduces energy waste.

Operating Instructions

(a) Instructions for the operation panel

Power supply: Displays the device's power status; the indicator light remains on when the leakage protection switch is turned on.

Temperature controller: controls and displays the temperature inside the tunnel furnace.

Power switches: The upper power switch and the lower power switch control the upper and lower heating elements respectively.

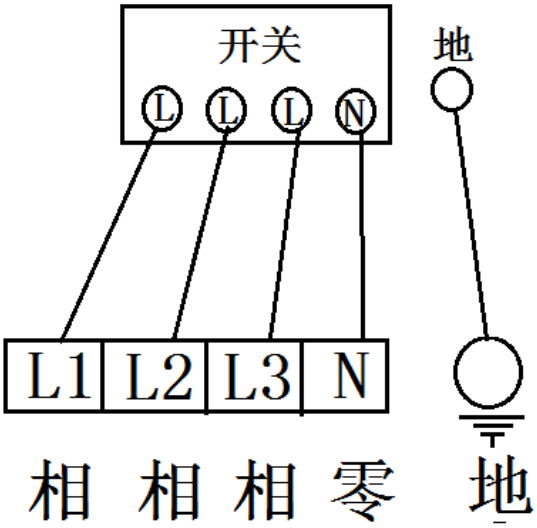
Fan switch: controls the high-temperature motor, and the high-speed rotation of the high-temperature motor ensures that the temperature inside the chamber is uniform and stable.

Conveyor belt switch: A switch that controls the conveyor belt motor.

(II) Debugging Steps

1. Connect to power

This oven is a three-phase five- wire system (three-phase 220V) (one black wire is the neutral wire , two-color wires are the ground wire, and the other three phases are connected to 380V); after connecting the power supply, turn on the power switch (the red power indicator light will illuminate). If it cannot start, the phase wires are reversed (e.g., the motor is rotating in reverse). Please adjust the phases in time to enable the oven to start normally .



2. Operating Procedures

(1) Turn the leakage protection switch handle to the "ON" position, turn on the main power supply, and the power indicator light will light up.

(2) After powering on, turn on each control switch (if not needed, you can leave it off). The indicator lights will illuminate, and the equipment will enter the working state.

3. Adjust the conveyor belt speed

Adjusting the knob on the speed controller allows you to adjust the speed of the

conveyor belt.

4. Temperature setting

Press the SET function key on the temperature controller, then press the ▲ OR ▼ key to display the desired setting value in the lower green numbers. Press the SET function key again to return the controller to standard mode.

Common Faults

Phenomenon	reason	Handling method
3.1 The hot air blower does not rotate counterclockwise.	1. The phase of the power supply to the machine does not match the phase required by the motor.	1. After shutdown, swap the positions of two of the three live wires on the incoming line to change the phase.
3.2 Abnormal Conveyor Belt Movement	1. The sprocket and Teflon belt are loose and lean to one side. 2. Non-parallel linkage, skipped chain teeth.	1. Readjust the positions of the sprockets and rollers, and tighten them.
3.3 The conveyor belt remains stationary.	1. Loose wiring 2. Damaged conveyor motor 3. The speed controller is damaged.	1. Check the wiring and measure whether the motor's operating voltage is normal. 2. Check if the motor or speed controller is damaged. If damaged, please send it back to the factory for repair.
3.4 The light tube is not working.	1. Damaged light bulb 2. Power phase loss (usually several lamps are not working at the same time) 3. Poor wiring contact 4. Solid-state relay or thermostat is damaged.	1. Replace the light bulb 2. Measure whether the input three-phase voltage is normal, or check the lamp circuit. 3. Inspect the lamp wiring. 4. Replace or send back to the factory for repair.
3.5 Abnormal temperature, fluctuating between high and low.	1. Temperature sensor damaged 2. Poor contact of the temperature sensing wire	1. Replace the temperature sensor 2. Retighten the temperature sensing wire connector.

3.6 Temperature not displayed or temperature gauge display is abnormal	1. Thermostat malfunction 2. The temperature sensor is damaged or the temperature sensing wire has come loose.	1. Replace the thermostat 2. Replace the temperature sensing wire 3. Connect the temperature sensing wire.
3.7 The displayed temperature does not match the actual temperature.	There is a systematic error.	1. Modify SC parameters. See the Temperature Correction section under Temperature Control for detailed debugging instructions.

Maintenance Precautions

1. Regularly check if the lamps are not working. The method is to check if the lamps inside the oven are working during the heating process.

2. The side panel of the machine is tightly fitted to prevent unauthorized personnel from storing debris inside the machine. When opening, one hand must lift the machine from the bottom upwards, while the other hand grips the inner latch and pulls upwards together.

3. When moving the machine, the correct operating procedure is as follows: Adjust the feet so that they are more than 50mm off the ground before moving the machine. After positioning, adjust the feet again to keep the equipment level, so that the wheels are about 10mm off the ground.

4. When it is necessary to open part of the furnace body for machine maintenance, the correct operating procedure is as follows:

(1) At least three people are required, and two sturdy support rods are needed.

(2) Open all the relevant locking nuts before and after.

(3) Open the handle, two people lift the furnace body up, and a third person supports the support rod, with one end supporting the furnace body and the other end supporting the conveyor support.

(4) Carry out relevant maintenance and repair, and clean up debris and dust after completion.

(5) When lowering, two people support the furnace body, one person removes the support rod, and then slowly lowers the furnace body.

(6) Wipe the lamp tube with alcohol every six months to ensure the baking effect.