



MDJ-23S Small Double Jacket Machine

Operation Manual

Company brief

Suzhou Industrial Park Mate Automation Technology Co., Ltd. is a metallic gasket and equipment manufacturing and selling company. We are located in Suzhou - a city well known for its Chinese classic garden, south of Jiangsu Province, China. With our technology, we offer our customers very wide variety of metallic gasket equipments, such as

Spiral wound gasket winding machine;

Kammprofile machine;

Guide rings grooving machine;

Inner ring beveling machine;

Bend & weld machine;

Stamp marking machine;

as well as computer controlled compression tester.

Our concept is to provide our customers with one-stop service for all metallic gasket related products, parts, and equipment. We have successfully sold our products and equipment to customers in the Asia India USA Europe and South America.

We welcome all customers from abroad and home.

SUZHOU INDUSTRIAL PARK MATE AUTOMATION TECHNOLOGY CO.,LTD

www.suzhoumate.com

Thanks for using our products. Before use, please read this menu carefully and keep it for future reference. Thanks for your understanding if there's any discrepancies between the manual and practical operation process due to technical update ceaselessly.



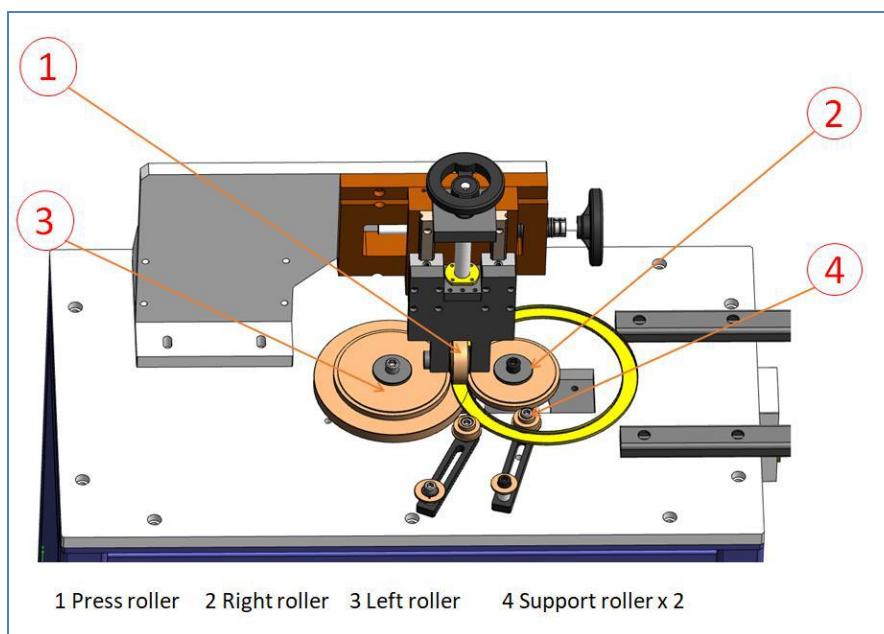
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MDJ-23S Double Jacket Machine (Pic1)



Machine Structure

1. This machine mainly consist of press roller, left support roller and right roller, left one is fixed, right one is moveable, which allows adjust to different flange width of gasket. See below detailed pic,





Machine Main features

2. Small Double Jacket Machine is special designed for making small sizes of gasket
3. Small size normally can not be bended due to softness, so small sizes are made from ring cut off by laser or plasma cut machine, then make U shape, then fill in graphite strips, and close both edges.
4. This machine can do such job, make U shape, and close the both edges by two steps

Machine set up and operation

1. Connect cable to power.
2. Turn on power.
3. Load all necessary down side stainless steel strips for forming the U shape.
4. After formed U shape, then manually put the graphite or PTFE tape into the U formed strip, and put the upside strip on top of it.
5. Move the two edge closing rollers to the U shaped strip from both sides, turn around the ring until the both edges bended 45 degree;
6. Change right and left rollers to the final closing rollers, and make the both edge rollers to support the ring firmly, then turn around the ring until both edges closed properly.

Material Specifications

Metal Jacketed Gasket - Raw Material Dimension VS Finshed Gasket Flange Width Recommended (mm)						
Item	Gasket Flange Width	Steel Strip Thickness	Graphite Filler Thickness	Graphite Filler width	Up Steel Strip Width	Down Steel Strip width
1	8.00	0.50	2.00	7.00	NIL	18.00
2	10.00	0.50	2.00	9.00	9.00	21.00
3	13.00	0.50	2.00	12.00	12.00	23.00
4	16.00	0.50	2.00	15.00	15.00	26.00
5	18.00	0.50	2.00	17.00	17.50	30.00
6	19.00	0.50	2.00	18.00	18.50	32.00
7	20.00	0.50	2.00	19.00	19.00	33.00
8	22.00	0.50	2.00	21.00	22.00	35.00
9	24.00	0.50	2.00	23.00	24.00	36.00
10	25.00	0.50	2.00	24.00	24.00	38.00
11	28.00	0.50	2.00	27.00	28.00	42.00
12	30.00	0.50	2.00	29.00	28.00	48.00

Note,

- 1) Final width of metal jacketed gasket is 3.2 mm or 3.5 mm
- 2) When Final Thickness of metal jacketed gasket is 4.00 mm graphite with 3 mm thickness is used.
- 3) Graphite filler width normally 1 mm less than the final gasket flange width.
- 4) Raw material advised use 304L and 316L, to make small sizes, better use 316L.

Machine specification



Type	MDJ-23S
Machine profile (L*W*H)	860*660*1300
Net weight	320KG
Power supply	1.1 KW
Drive motor	1.1KW
Voltage	380V
Work mode	Semi-automatic
Ring Size	10"-3500 mm
Max Thickness	0.8 mm
Line Speed	0-200 mm/s
Material suited	SS & Alloy

Safe Instruction

1. Operator must wear glove to protect hands from steel strip sharp edges and steel flash.
2. Use necessary tools to guide the strips go through each roller sets, and keep hands away from rollers.
3. Don't open electronic box when electrician is absence.

END