



Guide Ring Assembly Machine MGA-20

Operation Manual

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.



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 equipment, such as: Spiral wound gasket winding machine; Kammprofile machine; Double jacket machine as well as Guide rings grooving machine;

Inner ring beveling machine;

Bend & weld machine;

Laser marking machine;

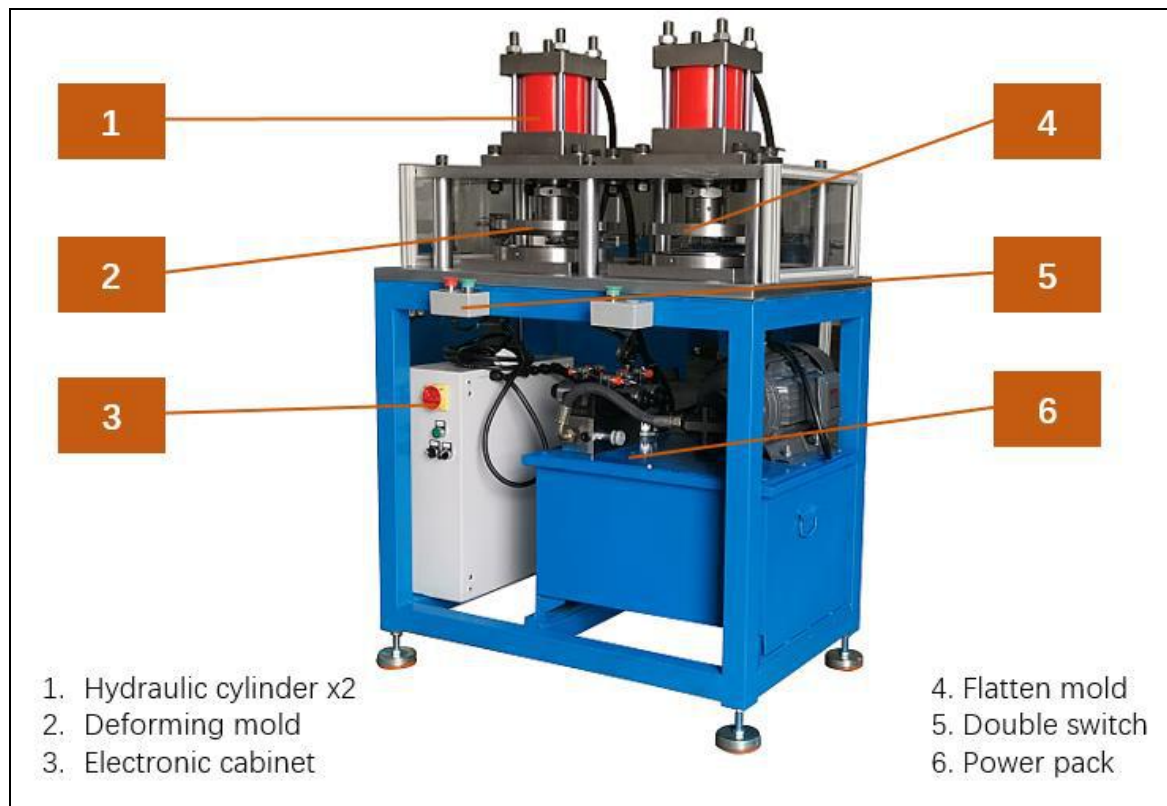
as well as computer controlled compression tester.

We to provide our customers one-stop service for all metallic gasket related products, parts, and equipment, and we provide our customers free consultant on gasket processes. We have successfully sold our products and equipment to customers from over 30 countries of world.

We welcome all customers from abroad and home.



MGA-20 Guide Ring Assembly Machine (Pic1)



Machine Main Features

1. Deform the guide ring to cone shape, let winding element fit in, then press guide ring back to flat, guide ring assembled.
2. 2-step process, very simple to operate, it needs no skills for operators.
3. With double safe protection, double switch and guard light (optional as per customer's request, well protect operator).
4. Special designed quick changing mold, reduce set up time and change over time.
5. Hydraulic power pack provide maximum pressure up to 50 tons, can assembly sizes from 1/2" up to 8", cover all big volume items.
6. Durable machine with simply and easy maintenance requirements.
7. Build in digital counter, record production volume.

Machine Specification

Type	MGA-20	Compress	Hydraulic power pack
Profile (L*W*H)	1060*700*1630	Maximum	50 T
Net weight	740KG	Circle time	5-10 Seconds
Motor power	4.5KW	Safe protection	Double switch
Voltage	380V	Guide light	Optional
Size scale	1/2"– 8"	Material suited	CS/SS
Volum count	Yes	Hydraulic oil	ISO VG32 or above

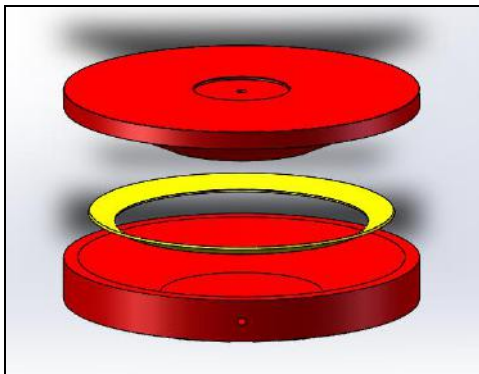


**Important notification: Miss operating could cause serious injury,
please do not operate before reading through this guide.**

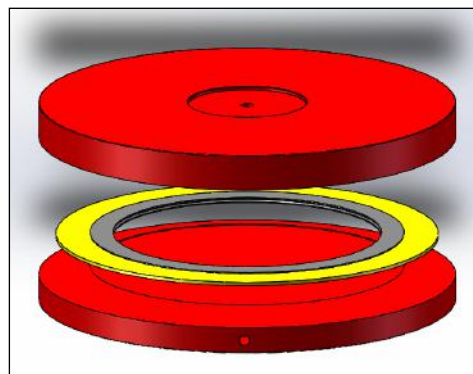
Machine set up

1. Connect cable to power. 380V 3 phase.
2. Infuse proper volume of hydraulic oil up to indicated level. Old grade must be ISO 32 or above.
3. Turn on main switch.
4. Pick up right size deforming mold (Pic 2) and flatten mold (Pic 3), and put them on each position.

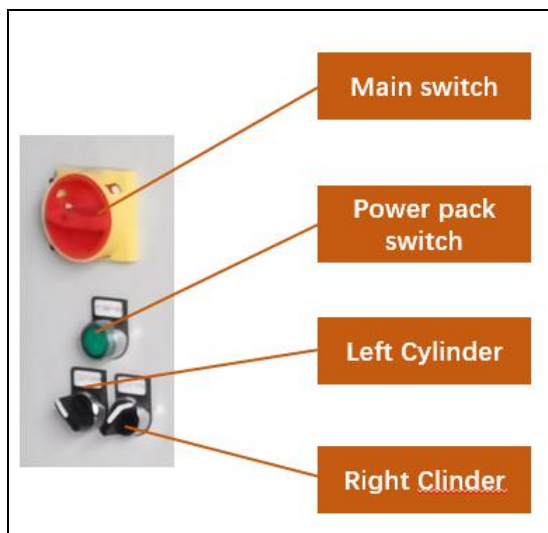
Pic 2



Pic 3



5. This machine can do deforming and flattening process simultaneously, or each single process separately. There two switches, left switch and right switch, control each cylinder's motion. Normally we recommend user to use one cylinder only, switch off another.



6. Switch on left cylinder, but switch off the right cylinder, now the machine is ready to



work, put guide ring on the deforming mold, locate the ring as central as possible, then use two hands press the green buttons at the two sides, the up mold will come down make the ring deformed, pick it up and load another ring, then repeat the process.

7. After finishing the deforming process, switch off the left cylinder, and switch on the right cylinder, now the machine is ready to do flattening process. Put the winding element on the center of the flatten mold, and put the deformed ring on top it, make sure the ring locate as centrally as possible, use both hands press the green switches, the flatten mold come down, flatten the guide ring back, job done.

One important tip, as you can see that our flatten die is designed not perfect flat, it actually is a little more over than flat, that is for overcome resilience, if you find that the guide ring over or not enough after flatten process (it may happen due to the guide ring material slight different), you can rotate the flatten up die a little up or down.

END