



Ring Flatten Machine

MRF-24

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 equipments, such as

Spiral wound gasket winding machine;

Kammrofile machine;

Guide rings grooving machine;

Inner ring beveling machine;

Bend & weld machine;

Stamp marking machine;

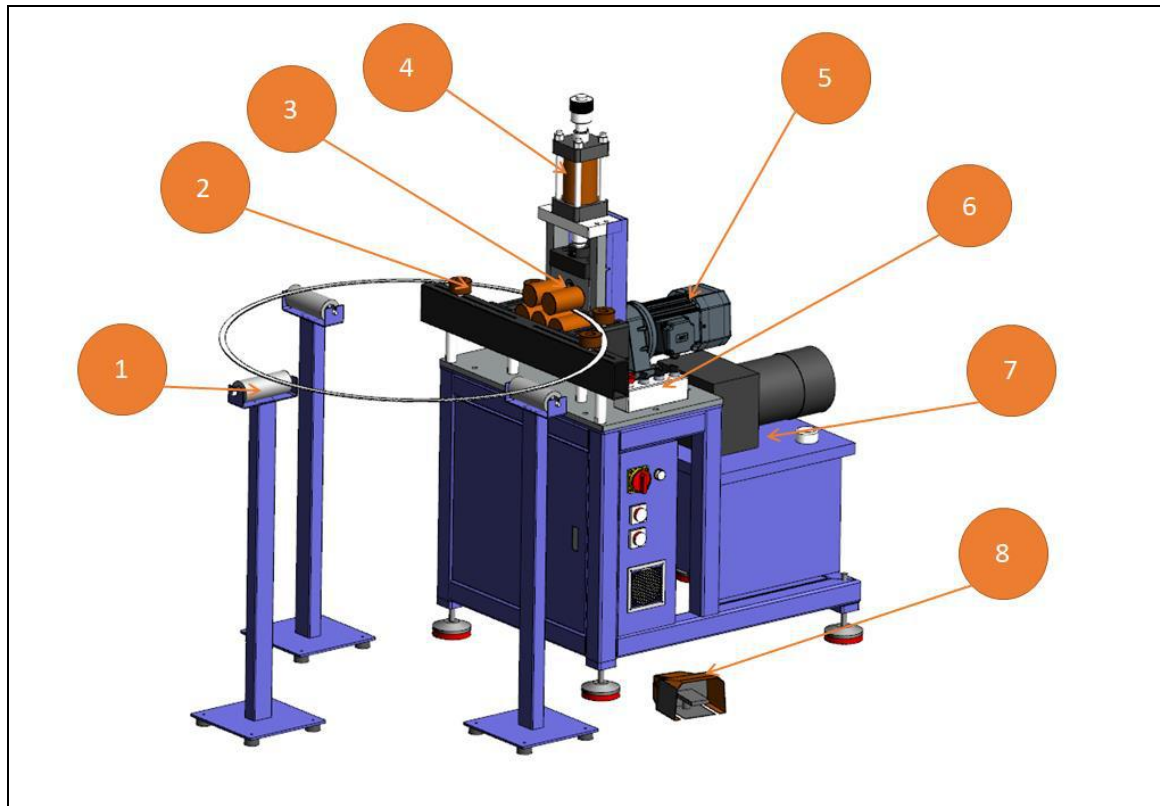
as well as computer controlled compression tester.

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.



MRF-24 Ring Flatten Machine



1. Support roller (x3)
2. Ring Holding roller (x4)
3. Flatten roller set (x5)
4. Hydraulic cylinder
5. Driven motor
6. Hydraulic power pack
7. Control panel
8. Foot switch

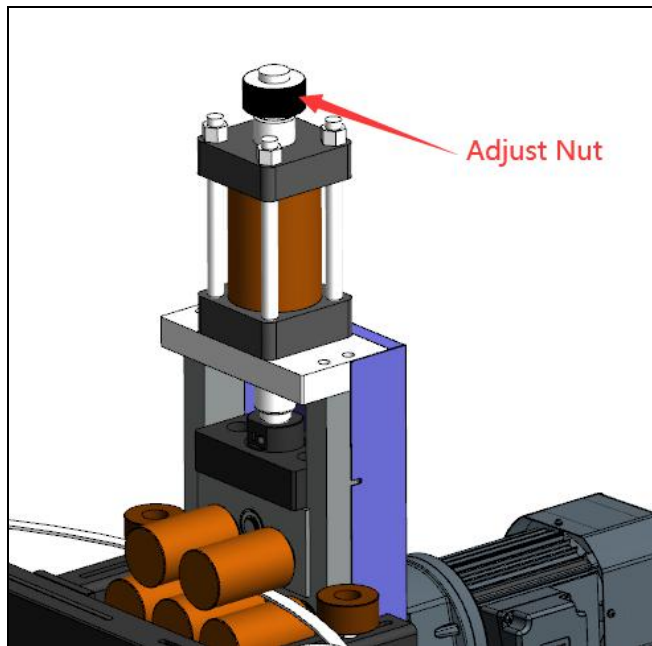
Machine main features

1. Machine is specially designed for flattening the inner ring or guide ring, especially for those bended and welded rings. Normally those rings will be more or less deformed after bending and welding, and contain internal stress, this machine can help flattening the ring's deformation and release the internal stress crated by bending and welding process or any other reasons, those rings will stay flat after processing by this machine;
2. Very simple to operate, Use hydraulic power pack as press to flatten the rings, very simple machine, easy to operate all need operator to do is load ring press "Start" and unload the ring after process;
3. Easy maintenance, all need to do change the pressure oil periodically.

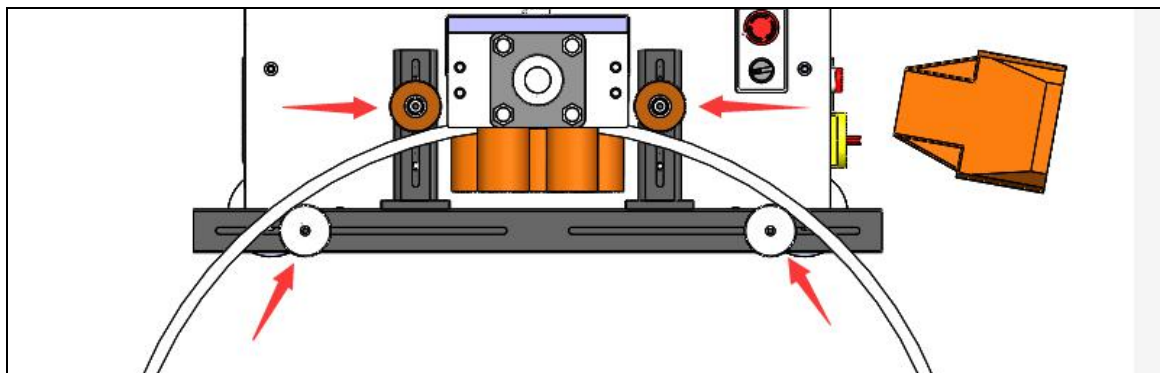


Machine set up

1. Connect cable to power. 220V single phase or 380V 3 phase as per customers' requirement.
2. Turn on power.
3. Set up height of press rollers, adjust the nut on the cylinder top to get the right height of press roller, the default height set is as per 3 mm thickness ring, if you change ring thickness, you will need to re-set the height. See below pic,



4. Turn on hydraulic pump, now machine is ready for processing.
5. Set horizontal holding rollers' position for certain sizes of ring, See below pic, the back two rollers hold from outside of ring, while the front two hold from inside.



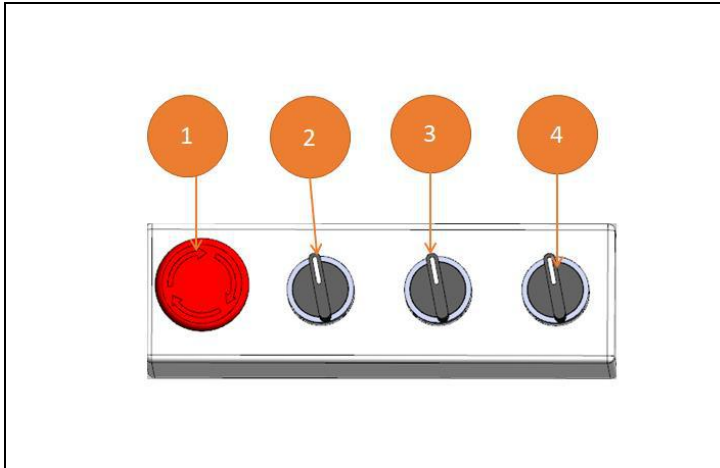
Standard process map

- 1) Load the ring, right way is hold the ring by both hands place on top of the flatten rollers at down side and support rollers if large size.
- 2) Press green "Start" button or foot swith
- 3) Press rollers come down touch and press the ring, driven motor driver ring turn around



several rounds, then rollers go up automatically.

- 4) Take off ring and put another one to repeat process above. Normally the slight deformed ring need to be flattened by only one side, but you can press both sides if the ring deformation is serious. Large sizes of ring,; while small size ring use switch No 3., No 4 switch is for changing turnig direction.



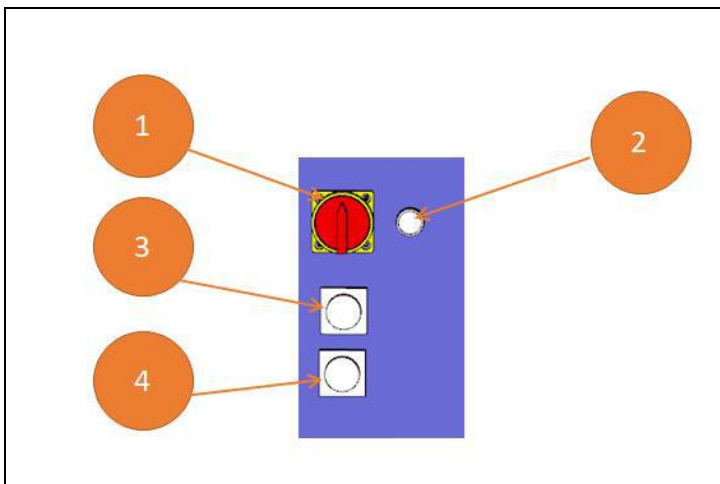
No 1 emergency switch, emergency stop

No 2 Pump on / off, hydraulic pump switch on or off

No 3 CW/CCW Driven motor turn clock wise or counter clock wise

No 4 LT/ST LT means long circle time, which is for wide flange ring or serious deformed ring, ST means short circle time, which is for narrow one.

- 5) And you can change flatten processing cycle time by adjust the timers, the default setting is good enough, but you can change setting if you think neccesary, see below pic,



1. Main switch

2. Power on signal light

3. LT Timer for large size of ring, which is adjustable

4. ST Timer for small size of ring, which is adjustable



Machine specification

Type	MRF-24
Profile(L*W*H)	1200*600*1280mm
Net weight	340KG
Driven motor	1.5 kw
Hydraulic pump	3.5KW
Voltage	380V
Size scale	200– 3000mm
Thickness	2 – 5 mm
Flange width	5 - 60 mm
Line speed	0-200 mm/s
Material suited	CS/SS

Safe Instruction

1. Always leave both hands away from the press rollers during process.
2. Don't open electronic box when electrician is absence.
3. Always use ISO VG32 or VG46 hydraulic oil or equivalence, maintain proper level.
4. Change hydraulic oil periodically will helpful for life of all hydraulic parts.

END