

Hand-Type Thermal Deposition Machine Operation Manual



Tokai Metal Industry Co., Ltd.
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◆ Parts Name ◆

● Drill Stand

Handle

Head

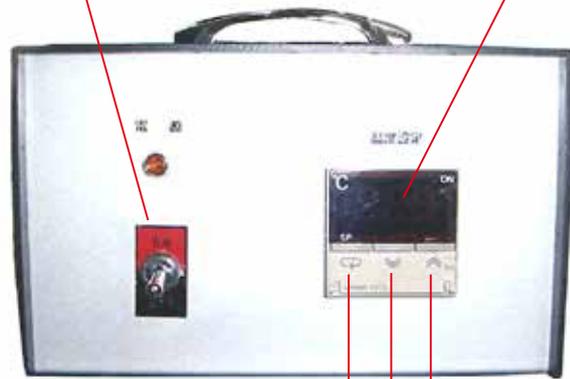
Punch



● Temperature Controller

Main Power Switch

Temperature Display



Temp-Display Switch Key

Temp Down Key

Temp UP Key

Specifications

AC100V 300W

Fuse 5A

How to connect the wiring between drill stand and temp controller.

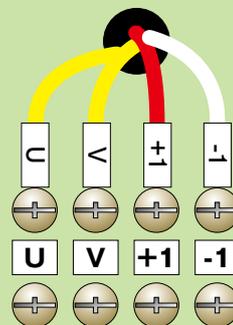
Drill Stand Head



A code Connect with the heater port at the rear of temp controller

B code Connect with the **thermocouple port** at the rear of temp controller

Temp Controller Rear Port



Connect U (A code) with U (rear of temp controller)

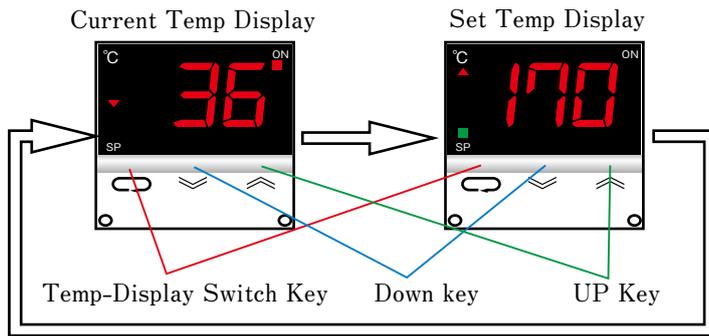
Connect V (A code) with V (rear of temp controller)

Connect "+ 1" (B code) with "+ 1" (rear of temp controller)

Connect "- 1" (B code) with "- 1" (rear of temp controller)

◆ Preparation for Inserting ◆

● Temp Set Panel



While power is on, current temp is displayed.

To see the set temp, press one time the temp-display switch key.

The display that ■ is lighting is set temp display.

Press one more time the temp-display switch key, and the current temp is shown.

Set temperature

Since set temp varies with the resin characteristics, determine the set temp by testing.

250°C is the target temperature.

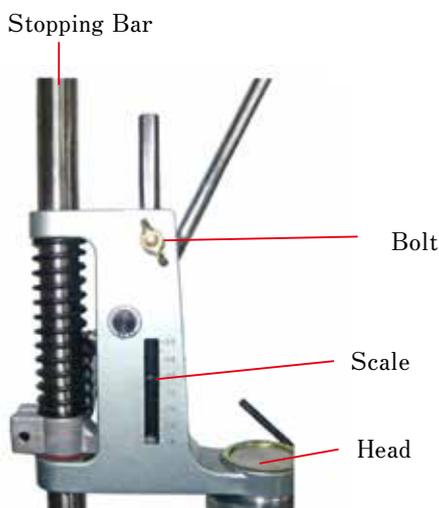
(400°C is the max set temp, but control the temp at most 350°C .)

How to change set temperature.

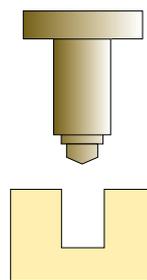
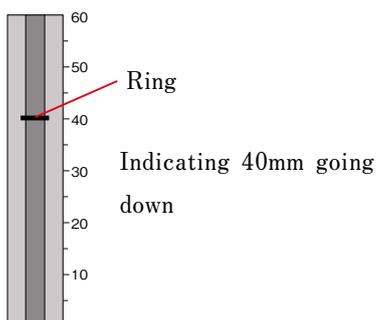
Change the set temp display by pressing up key or down key.

After setting, press the temp-display switch key and show the current temp display.

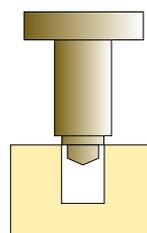
● Drill Stand How to Adjust the Stroke



Scale Enlargement



① Unfasten the bolt and put down the punch until the position of inserting.



② While the punch is getting down, fasten the bolt, and fix the inserting stroke.

★ In order to exchange the punch part, please do it after its complete cool down.

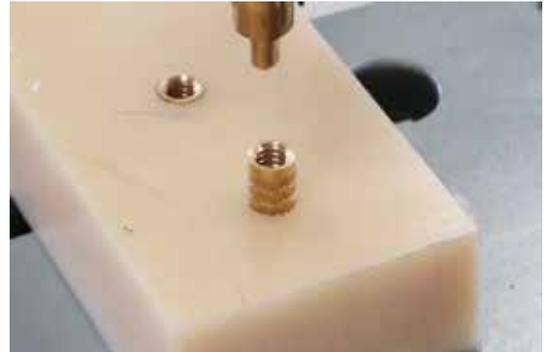
Thread is reverse torision.(Thread comes loose by clockwise rotation)

◆ Press In ◆

1 Prepare the Nutter, and warm it after the setting of punch temperature.



2 Place the insert nut at the opponent resin.



3 Start press in by lowering the handle.



4 Press in till the predetermined position, and raise the handle slowly.



5 Complete.

