

AMC

AMC INDUSTRIAL DEVELOPMENT COMPANY LIMITED

OPERATION MANUAL

Semi-Automatic Pre-Feeder

Model: **DX-1226B**



REV 09/21

Serial: **AMC210210DXB**

US

English



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Chapter 1: SAFETY

This document is aimed for the people, who, for different reasons, directly or indirectly are responsible of the machine handling. The people who interact with the machine, have different levels of training and expertise. Thus, in order to ensure a high level of security, it's necessary that the people that directly interacting with the machine, are well trained and with experienced.

The customer has to make sure that the operator is adequately qualified and trained for the tasks he performs. This manual is intended for anyone involved in the usage of the machine. As far as general safety standards are concerned, this document is directed to the machine operator and user, who are most prone to accidents, as well as people who interact directly with the machine.

A) General

1. Users are advised to carefully read this manual and follow general instructions.
2. This document is a tool necessary for the previous understanding of the **Semi-Automatic Pre-Feeder DX-1226B** that will be used.
3. Its reading and understanding are mandatory before using the machine, as it is necessary to know all its operation, maintenance and safety aspects.
4. Correct operation shall be determined by its appropriate installation and use.
5. Any modification performed on this mechanical or electrical parts can compromise the safety parameters arranged by **AMC Industrial Development Company Limited**. **AMC Industrial Development Company Limited** declines all responsibilities such as accidents or damages caused by safety systems tampering attempts concerns.
6. It is advised to only utilize replacement parts recommended by the manufacturer. In case of detecting any shortcoming, the manufacturer must be informed to mend it.
7. Repairs for this unit as well as its periodical maintenance, should be performed by qualified professionals.
8. Before commissioning, cleaning or making any adjustments to the machine, be sure all moving parts are in standby.
9. In case of detecting any deficiency, the manufacturer must be informed in order to solve it.
10. Necessary information shall be provided to workers using the machine, as well as a specific training for its use.
11. This instruction manual shall be made available imperatively to the workers.
12. Appropriate individual protective equipments recommended by the manufacturer shall be provided to each worker. A documental record of maintenance, revisions and malfunctions of the machine shall be carried out.

B) Safety Warning Labels

It is important to know that in this document **AMC Industrial Development Company Limited** gathers all the information necessary to use the machine in safety conditions, it cannot however obviate them in the whole.

As a complete and capillary test on every machine always shows residual dangers, that is to say those dangers that can not be avoided or sufficiently reduced through planning and against which protections are not completely effective, **the operator must take the safety warning labels applied on the machine and the following advice into serious considerations:**

1. The Operators must memorize the exact position of control devices able to stop the machine in case of emergency.
2. The Operators must control their workmates in case they are operating in dangerous area.
3. It is forbidden to perform maintenance work on the machine before interrupting voltage, or before the starting up device of the part to be inspected or on which maintenance has to be carried out is deactivated.
4. Each foreign object placed on parts in movement such as keys, screw drivers and bolts, must be removed before machine is started up.
5. The machine's working signaling must be kept cleaned and easily legible, in particularly the warning one.
6. It is widely recommended not to remove barriers and protection devices restricting the access to the machine components.
7. Examine the efficiency of safety device periodically in order to keep the unit's reliability if required.
8. Do not use the machine until all security devices have been restored.
9. Guards and panels opened or removed in order to carry out repairs must be always closed and replaced.
10. Do not execute repairs or adjusting operations on operation parts. Whenever it is necessary to perform such operations, safety precautions must be taken in order to protect workers.
11. When an emergency occurs, press the "emergency stop switch" to cut off electrical power boxes and stop the machine action.
12. 12. Wear proper working garments, such as clothing, protective helmets and gloves.
13. Wear rubber shoes to avoid electrical shock.
14. Always follow the instructions on the warning labels attached to the equipment.

15. Never handle the switches with wet hands.
16. Before operating any switch, always confirm its position and function.
17. Before running the machine, always tidy up your work area to ensure safe working conditions.
18. Make sure there are not other people or obstacles on the protective covers or rotating parts.
19. Always enter the machine after it has completely stopped.
20. In order to protect the operator, all the driving parts of the machine are equipped with protective cover.
21. If you have noticed any unusual noise, vibration and/or electronic control system's failure, immediately stop the machine.
22. The electric part must have a good grounding protection when the machine is to be installed.
23. If the machine is not working, please check whether the power is working properly or whether the fuse has blown
24. The working voltage must be consistent with specification.
25. In the event of the machine being used after a transfer or a long period of inactivity, it is advisable to ask for the assistance of **AMC Industrial Development Company Limited**.
26. In case you are not able to solve a malfunction by yourself or find yourself in difficulties, do not make risky repair attempts, please call an agent of AMC Industrial Development Company Limited of your district.

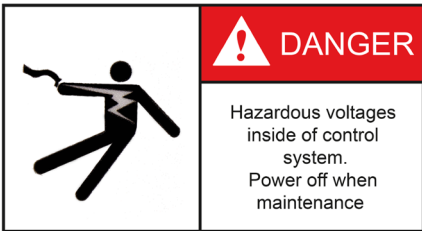
The following safety warning labels are attached to this machine. The operators and maintenance personnel must follow the safety warnings. If any of the safety warnings has come off or become unreadable, always attach a new warning label.

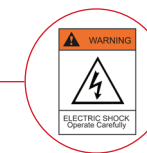
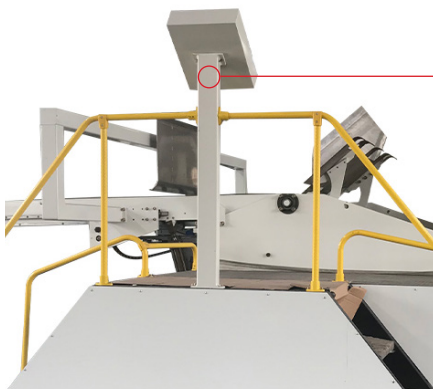
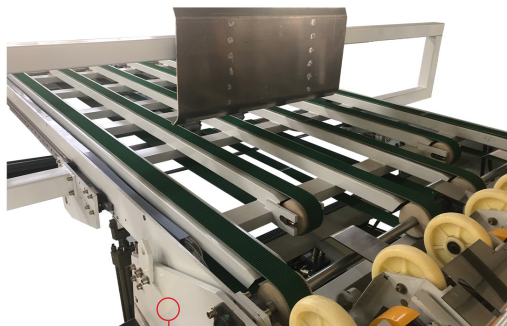
Safety Warning Labels are used on the machine and procedures on this manual, they alert the user of its existence and relative degree of hazards, it contains important information about personal safety during operation or near the machine. Understanding safety alert symbols guarantee operator safety, review carefully following symbols.

Safety Alert Symbols

	Potentially destructive situation which if not avoided, may result in damage or reduce the longevity of the equipment.
	Potentially hazardous situation, which if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.
	Potentially hazardous situation, which if not avoided, could result in death or serious injury.

Review the safety warning labels that are applied on the machine, which shows the warning positions:

	ALWAYS, keep hands away from machine when running.
	ALWAYS, turn off all power before starting maintenance or do inspection.
	ALWAYS, turn off all power before starting maintenance or do inspection.



Chapter 2:

MACHINE IDENTIFICATION

A) Identification Plate



Here, after taking note of the name plate attached to our machines. Which is generally placed on the top, on the left or right side, it can be consulted by customers each time it is necessary.

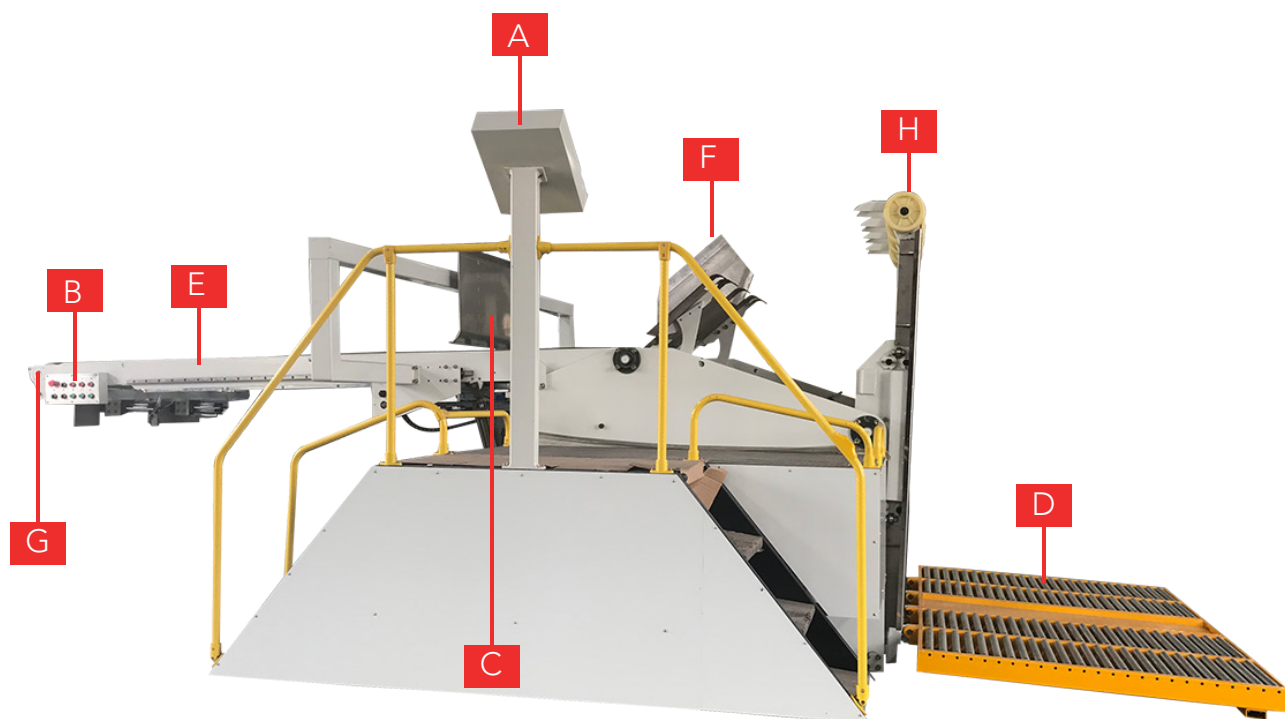
The following data is reported on the name plate:

Code	Description
A	Machine Model
B	Serial Number
C	Manufacturer Address
D	Production Date
E	Voltage

Chapter 3:

MACHINE DESCRIPTION

MACHINE DESCRIPTION

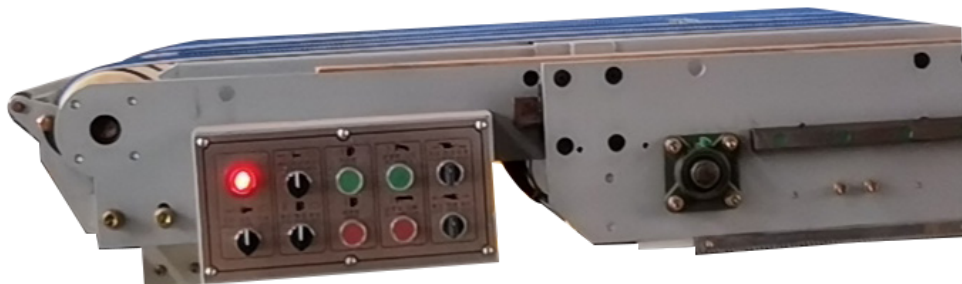


Code	Description
A	Main Control Button
B	Front Button Panel
C	Front Deflector
D	Fork Tine Raising and Lowering
E	Lower Conveyor Bed
F	Side Deflector
G	Front Flapping
H	Automatic Hook

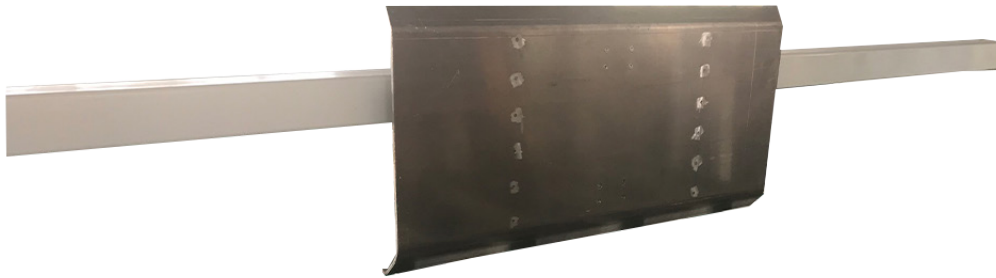
A) Main Control Button



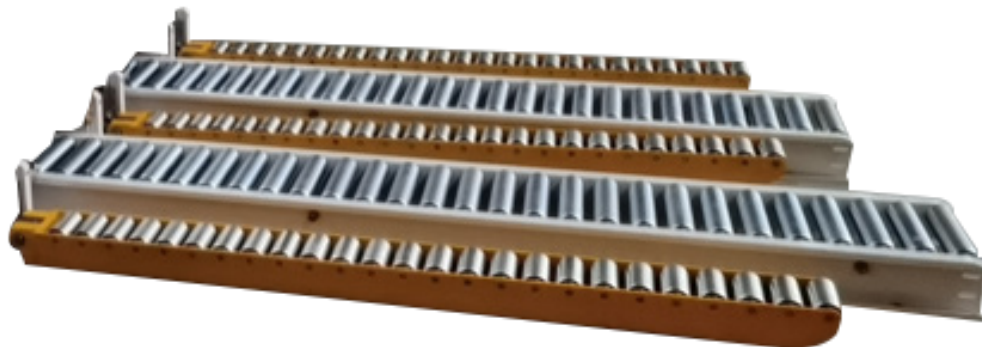
B) Front Button Panel



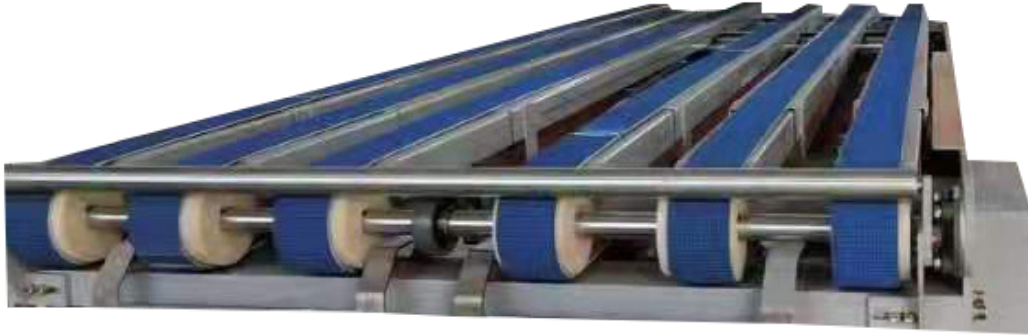
C) Front Deflector



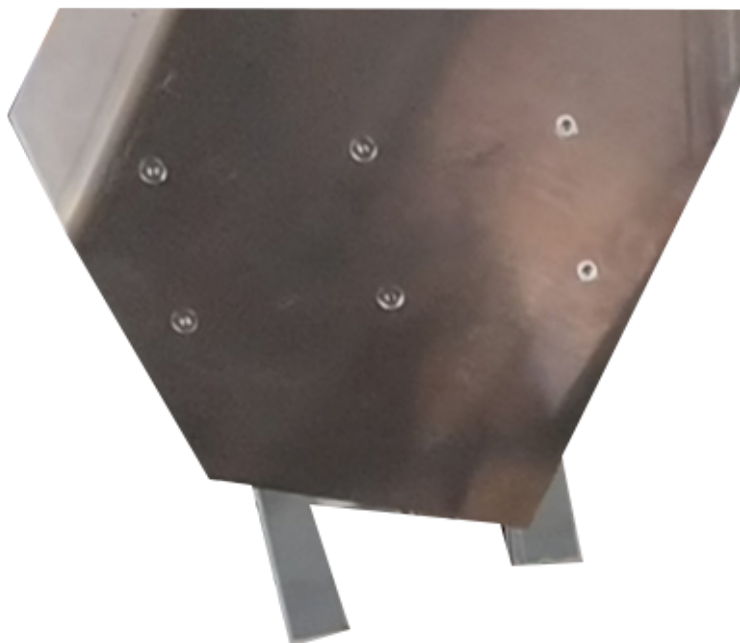
D) Fork Tine Raising and Lowering



E) Lower Conveyor Bed



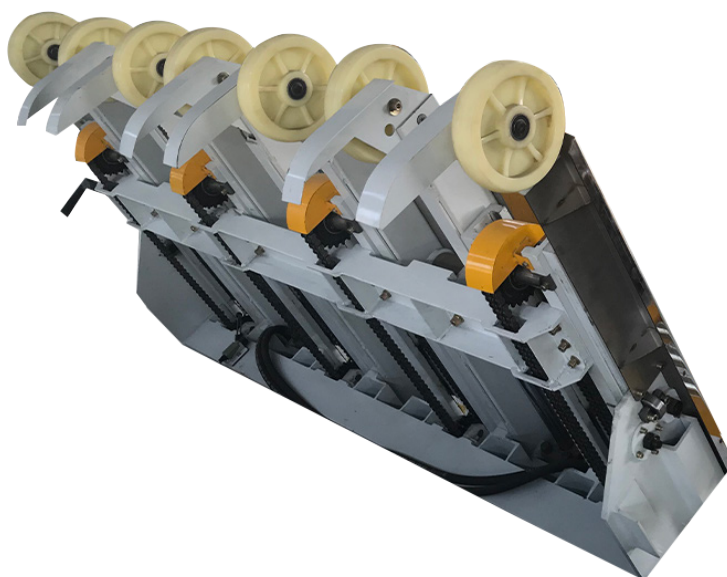
F) Side Deflector



G) Front Flapping



H) Automatic Hook



Chapter 4:

TECHNICAL PARAMETER



AMC INDUSTRIAL DEVELOPMENT COMPANY LIMITED

SEMI-AUTOMATIC PRE-FEEDER MODEL DX-1226B			
Electrical Requirements		Product	Semi-Automatic Pre-Feeder
Voltage	440V	Brand	AMC
Phase	3 Ph	Model	DX-1226B
Frequency	60 Hz	Origin	China
		Application	Ensure the precise and careful feeding materials into lead edge equipment.
Operation Conditions		Overall Dimensions	
Operating Temperature (°C)	15°C - 29°C	Length	4500 mm
Maximum Operating Temperature (°C)	15°C - 29°C	Wide	4500 mm
Installation Place Room Temperature (°C)	29°C	High	1800 mm
Relative Humidity (%)	No more than 70%	Weight	3000 Kg.
Elevation (m)	161m Above Sea Level	Floor Area Requirement	
Installation Place	Lima, Perú	5000 mm x 5000 mm x 2000 mm	
Technical Specifications			
Max. Machine Speed	300 Sheet / Min		
Suitable Working Speed	180-250 Sheet / Min		
Max. Sheet Size	2200 x 2800 mm		
Max. Sheet Stack Height	1800 mm		
Max. Stacking Load Weight	1500 kg		
Feed Out Type	Auto Hook Mode or Without Guide Plate for Sheets Over 600 mm Manual Mode or With Guide Plate for Sheets Under 600 mm		
Feed In Type	Roller Conveyors, Manual Punch-In		
Sheet Lifting Drive	Hydraulic		
Sheet Stacker Turning Drive	Hydraulic		

Sheet Transmitting Part Lifting Drive	Hydraulic
Transmitting Belt Driving Motor	Hydraulic Motor
Belt Frame Telescope	1350 mm
(3) Roller Conveyors Sections	(3) Sections 1580 mm x 100 mm (LxW) Each One
Squaring Device	Included
Total Power	10 Kw
Electrical Parts	
Main Motor	Siemens
Gearbox Motor	Schneider, Siemens, Omron or ABB
PLC	Schneider, Siemens, Omron or ABB
Contactor	Schneider, Siemens, Omron or ABB
Relay	Schneider, Siemens, Omron or ABB
Sensor	Schneider, Siemens, Omron or ABB
Position Limit Switch	Schneider, Siemens, Omron or ABB
Touch screen	Schneider, Siemens, Omron or ABB
Button	Schneider, Siemens, Omron or ABB
Encoder	Schneider, Siemens, Omron or ABB
Pressure Pump	7ocean or Qunce
Hydraulic Station Motor	Siemens
Hydraulic Valve Package	7ocean or Qunce
Hydraulic Cylinder and Pipe	7ocean or Qunce
Pneumatic Cylinder	7ocean or Qunce

Chapter 5:

INSTALLATION INSTRUCTIONS

A) General

The machine is usually installed by **AMC Industrial Development Company Limited** technicians. In case it must be removed, the operation must be performed by skilled and authorized personnel. Once they have reached the customer, our technicians begin the machine/plant loading/unloading operations. Afterwards, they must control packings are undamaged, which means, the machine has not suffered any damages caused by shocks, wrong handling or atmospheric elements.

The technician will check the integrity of the equipment also during the phases subsequent to the packing's first opening. The technician also must control the foundation's conditions and relative pre-arrangements necessary for installation; which means: the accuracy of foundations, cement quality and drilling testing on the area where the rails are going to be installed. **When apply.**

Prearrangements must be provided by: water supply distribution, compressed-air distribution, the presence of a power supply cable, and the installation of a line side isolate. The installation starts, with the installation of main tracks, using the suitable tools for subsequent levelling. When apply.

The technician concludes the mechanical assembling and checks that each part is closed down, adjusted and tightened so it can perform its final functions.

Now there is nothing left but, to supply of power to the main control panel, so it's required the customer provides an adequately electric infrastructure.

Each group of functionality at this point, is tested and it is advisable that from now on and for on, your maintenance personnel and your production manager or operator, support our technician, because, it is very useful for them, to follow functional test operations in order to know the functions of each operation, mechanisms and even the ones that in the future the operator will never have to adjust or repair.

The technician, makes sure each button of the control panel correlates to the suitable function: Start, stop, acoustic signal, pressure raising or lowering, movements, etc.

These operating mechanisms, responsible for the safety of workers assigned to the machine or plant are very carefully controlled: Stop button and alarms to signalize that photocells limiting the access are working.

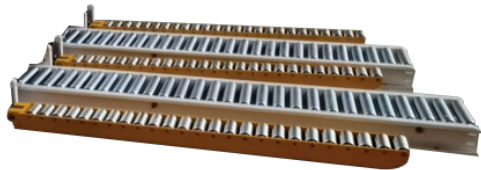
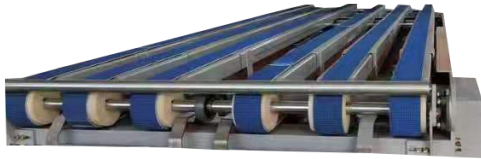
According to us, the operations above mentioned must be performed with the assistance of your personnel, thereby, will become acquainted with troubleshooting problems that often occur during this phase. In order to achieve a correct professional personnel training, the technician, will perform adjusting, inspecting and working operations.

The technician will mention the dangerous maneuvering for the safety of workers. The operator must maintain a safe distance from the machine and not to stand under the fastening bands or under the machine.

The personnel have to learn all production cycles in order to become familiar with the machine's main functions and its operating mechanism until it is self-sufficient, always under technician's control.

The technician will also simulate with personnel possible emergency conditions, in order to control that operators perfectly remember the position of stop and emergency buttons at the plant.

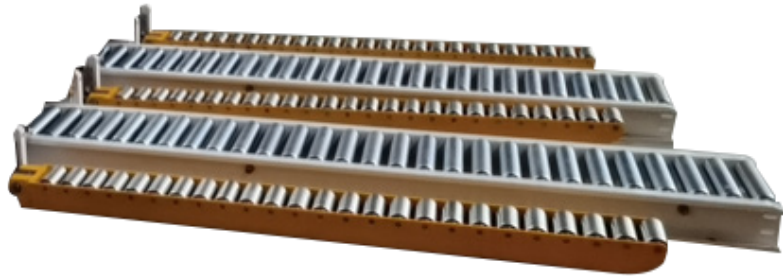
The machine arrives to customer's facilities, unassembled in 4 pieces, each one, must be unloaded separately, according to the following **Unloading Equipment Requirements**, the operator must keep a safe distance from the machine and not to stand under the fastening bands or under the machine.

Photo	Description	Unloading Equipment Requirements
	Conveyors	Cart Dolly
	Main Control Platform	Forklift 5 Ton. or Crane 5 Ton.
	Lower Conveyor Bed	Forklift 3 Ton. or Crane 3 Ton.

	Main Module	Forklift 5 Ton. or Crane 5 Ton.
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Make sure to do the unloading of the Conveyors, Main Control Platform, Main Module and Conveyor Bed, from the unloading points already determined, which are located in each unit, please see the photos below.

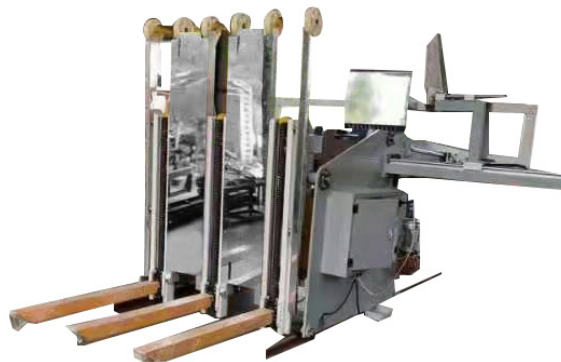
Conveyors



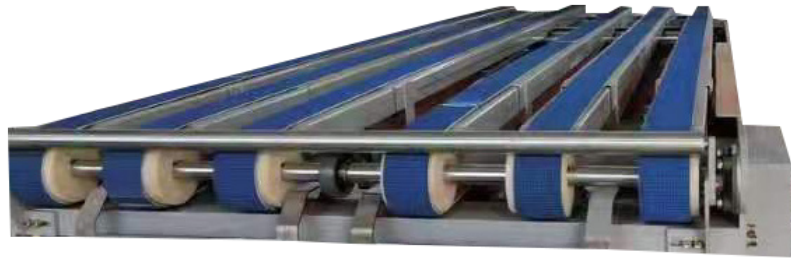
Main Control Platform



Main Module



Conveyor Bed



B) Pre-Installation

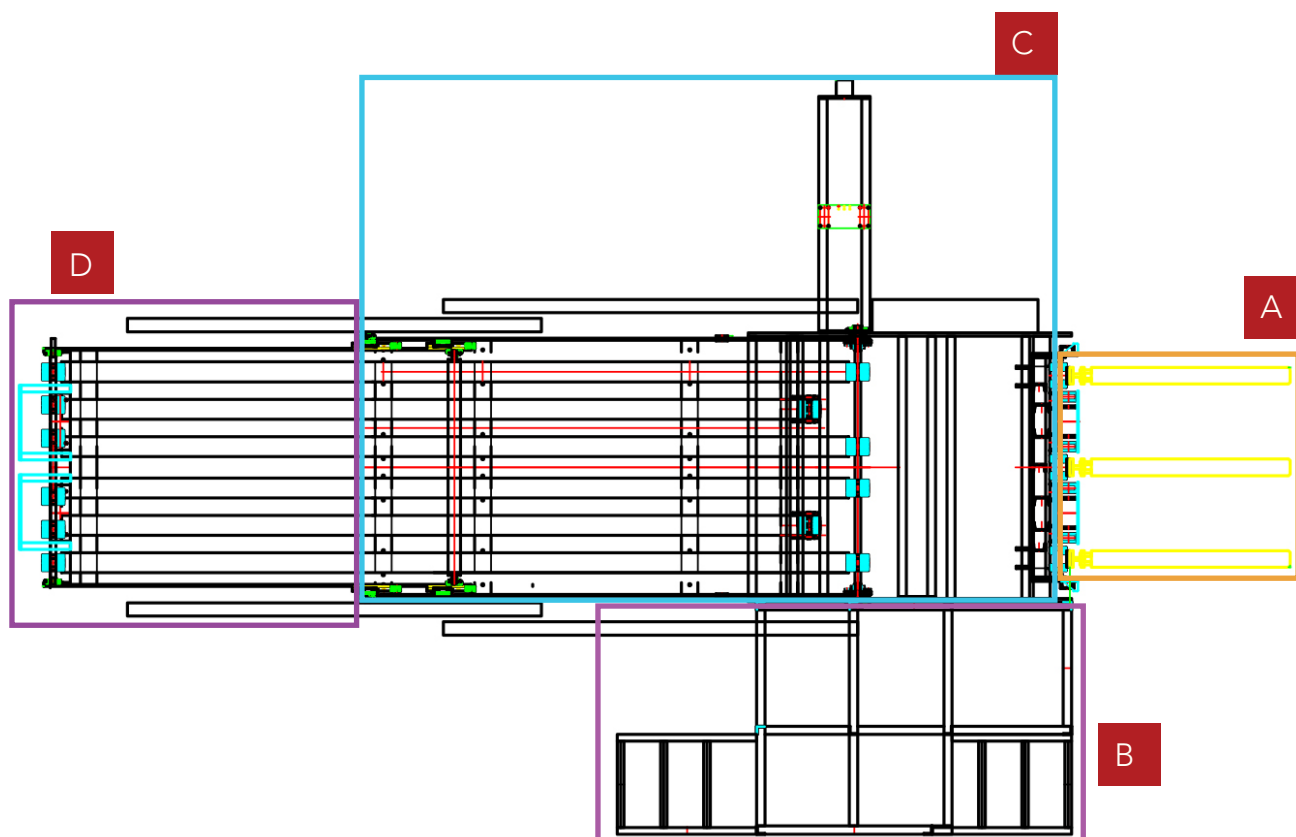
- 1) Remove the plastic film.
- 2) Check each unit of the machine and in case of finding any unit damaged, take some pictures and get in touch with an agent from **AMC Industrial Development Company Limited**.

C) Installation

In order to install the **AMC Semi-Automatic Pre-Feeder DX-1226B**, it is not required any type of special equipment, it should be installed on a flat concrete ground.

I.- Steps for installation

- 1) Determine the area on the floor according with the Layout.



Code	Description
A	Conveyors
B	Main Control Platform
C	Main Module
D	Conveyor Bed



A



B



C



D

Chapter 6:

OPERATION INSTRUCTIONS

WARNING

The machine must be started up and used only after that service and maintenance personnel has carefully read the present manual. The entrusted personnel must have fully read and understood its contents. The firm **AMC Industrial Development Company Limited** declines all responsibility for each failure occurring in consequence of improper and incautious operations, not in conformity with the present manual directions, carried out by unskilled or skilled personnel.

The present instructions are directed to qualified or experienced operators. In order to avoid damaging people or things, AMC Industrial Development Company Limited recommends Customers to adequately inform operators about the risk deriving from the use of the machine. In case of the machine being used by inexperienced personnel, it is advised that qualified personnel supports inexperienced workers at using the device. The operator must always make use of their personal protection means by law and what the employer places at his disposal.

Personnel responsible for the equipment maintenance must be experienced and fitting for the kind of duties, they must show the necessary reliability in order to ensure safety and scrupulous controls and maintenance works.

A) Power On/Power Off

I. Power On

Turn on the power source checking list:

- 1) Make sure the main power supply is consistent with the equipment's requirements, three-phase four wires alternating current 380V.
- 2) Checking air source (air source air pressure) setting is right or not, air pressure setting proper can start the equipment (no less than 5 Kg/cm²).
- 3) Clean all tools, dirt and peripheral materials on the equipment to avoid any mechanical perils.
- 4) All the doors and fences must have been closed.
- 5) Follow the correct procedure to turn the power on.
- 6) Connect the equipment with three-phase four-wire 380V AC power source.
- 7) Plug the equipment's air source connecting plug.
- 8) Close circuit breaker (MCB).
- 9) Turn on the main switch.
- 10) System return to origin point.
- 11) The operating system is initialized, then the device can run.

II. Power Off

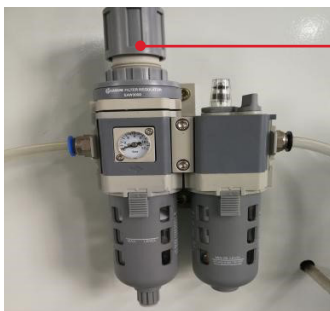
Turn off power source checking list:

- 1) Make sure the device has stopped or the operation is finished, then you can exit the program.
- 2) Remove unfinished products from the device before stopping operation.
- 3) All the doors and fences have been closed.
- 4) Follow the correct procedure to turn on the power.
- 5) Before exiting the program, confirm the equipment's power is off.
- 6) Follow the power off checking list.
- 7) Turn off the switch.

B) Settings Set Up

- 1) Please set the air pressure to needful air pressure value. Need 5Mpa.
- 2) Please set the oil pressure to needful oil pressure value. Need 5~10Mpa.

As following:



1. Rotate this button to adjust airpressure



2. Rotate this button to adjust oil pressure

3) Please set the oil pressure to needful oil pressure value.

4) According to the surrounding enviroment, please set the oil pressure to the needful speed, and confirm both sides are adjusting at the same time.

As follows:



3. Rotate this button to adjust oil cylinder pressure



4. Rotate this button to adjust coveying bed's lifting speed

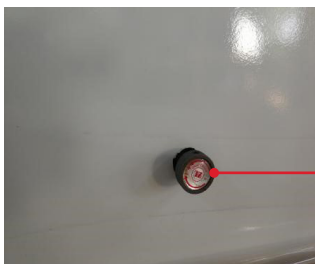
Note: Non professional workers do not modify the set parameters, Modify not right,Will cause the equipment to not work properly!

Please Set:

5) Rotate this button to adjust upper and lower conveying bed's speed.

6) Move the two halls to adjust the oil cylinder position.

As following:



5. Conveying bed speed



6. Oil cylinder position

7) Move this photoelectric switch to adjust pre-feeding cardboard thickness.

8) This button adjusts the front baffle's.

As following:



7. Pre-feeding cardboard thickness



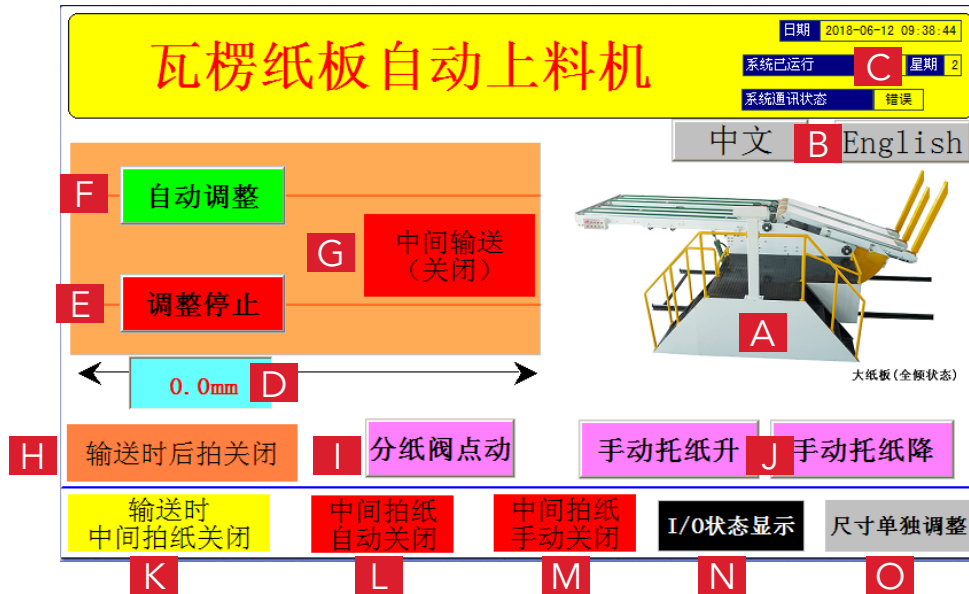
8. Front baffle position

Note: Non professional workers should not alter the set parameters, inadequate alterations could result on the equipment not performing properly.

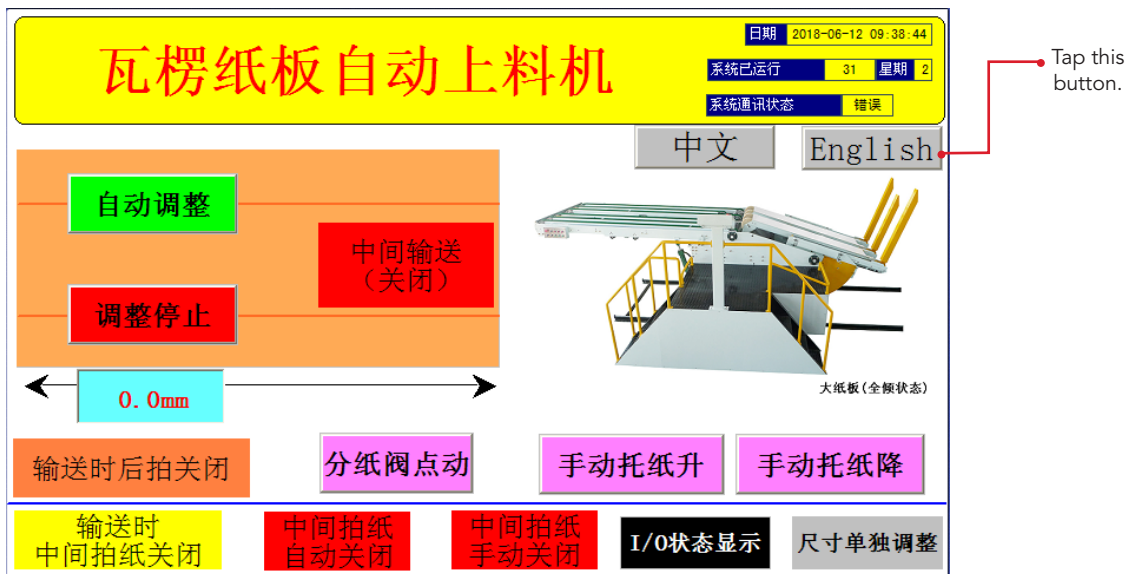
C) Auto/Manual Operation Mode

1) Please follow the correct procedure to operate the equipment in manual operation.

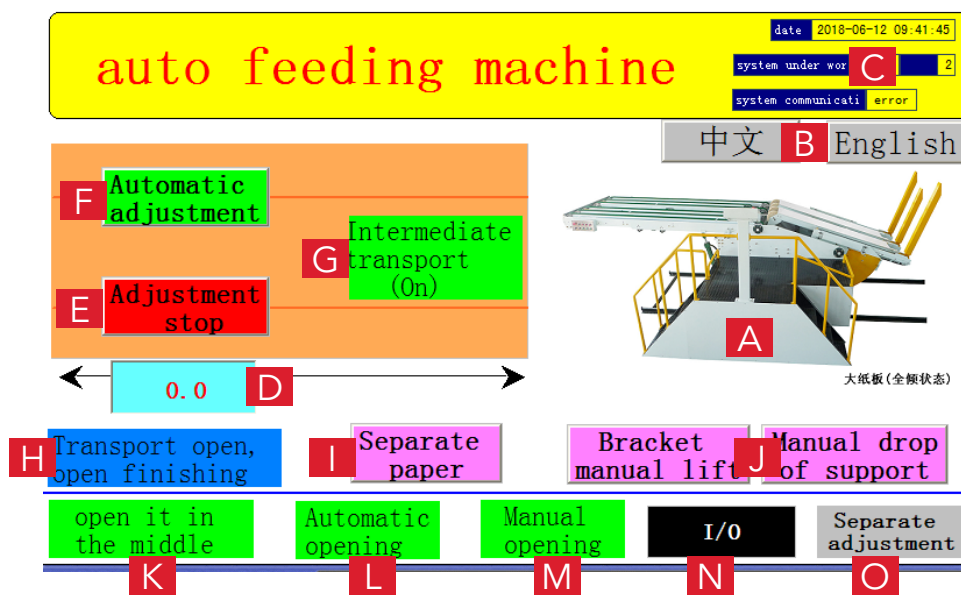
The following screen is displayed after the system is powered on



2) Select the English button to change the menu language.



3) The following screen will display, after press the English Button.



Code	Function
A	Equipment status graphical representation
B	Chinese /English change
C	System time
D	Cardboard length input window
E	Automatic adjustment stop
F	Automatic adjustment ON
G	Upper conveying bed belt ON/OFF
H	Printer flapping under belt conveying (transporting)ON/OFF
I	Paper separating valve test ON/OFF
J	Paper holding arm Rising /falling
K	Pre-arranging flapping under belt conveying ON/OFF
L	Pre-arranging auto flapping ON/OFF
M	Pre-arranging manual flapping ON/OFF
N	Enter input/output status window
O	Enter size separately adjusting window

D) Size Adjusting

1) Size Adjusting Screen

date 2018-06-12 09:42:20
system under working 247
system communication condition error

auto feeding machine

Left baffle adjustment
current position 0.0mm
jog adjust to big jog adjust to small
Set distance 0.0mm
Automatic adjustment Adjustment stop

Right baffle
current position 0.0mm
jog adjust to big jog adjust to small
Set distance 0.0mm
Automatic adjustment Adjustment stop

Side baffle
current position 0.0mm
jog adjust to big jog adjust to small
Set distance 0.0mm
Automatic adjustment Adjustment stop

back I/O Parameter setting

Left baffle adjusting Right baffle adjusting Side baffle adjusting

2) Size correcting window

Please make sizing corrections when real size and adjusting size are unmatched.

返回 日期 2018-06-12 09:41:23 系统已运行 190 星期 2 系统通讯状态 错误

左侧挡板尺寸校正
当前值 0.0mm
最小值 0.0mm
最大值 0.0mm

右侧挡板尺寸校正
当前值 0.0mm
最小值 0.0mm
最大值 0.0mm

侧拍挡板尺寸校正
当前值 0.0mm
最小值 0.0mm
最大值 0.0mm

参数设置
叉子上升等待时间 0.0s
印刷机延时送纸 0.0s
印刷机延时停送 0.0s
纸板堆码复位托板时间 0.0s
纸板堆码停止输送时间 0.0s
前拍拍出时间 0.0s
前拍退回时间 0.0s
堆码拍纸拍出时间 0.0s
堆码拍纸退回时间 0.0s
侧拍拍出时间 0.0s
侧拍退回时间 0.0s

back date 2018-06-12 09:42:59 system und 286 2 system comaur error

Left
CURRENT 0.0mm
MIN 0.0mm
MAX 0.0mm

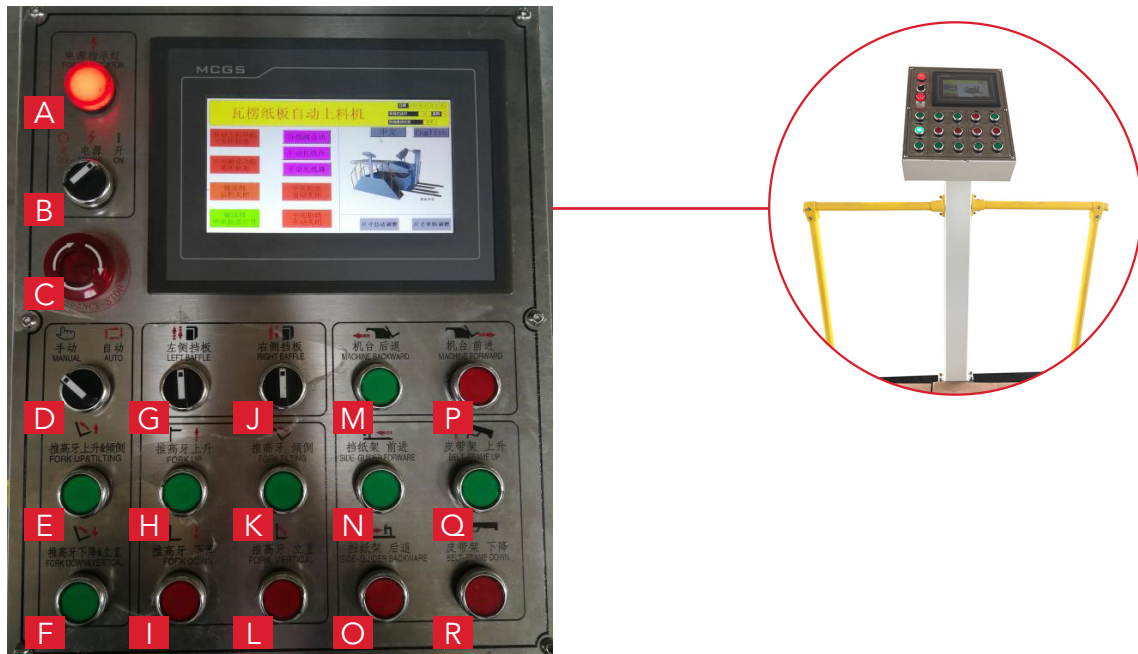
Right
CURRENT 0.0mm
MIN 0.0mm
MAX 0.0mm

Side
CURRENT 0.0mm
MIN 0.0mm
MAX 0.0mm

parameter set
lift fork rise up waiting time 0.0S
Printing press time delay paper delivery 0.0S
Printer delay stop delivery 0.0S
waiting time 0.0S
Stop time 0.0S
front pusher working time 0.0S
Stacking work time 0.0S
side pusher working time 0.0S
front pusher stop time 0.0S
Stacking stop time 0.0S
side pusher stop time 0.0S

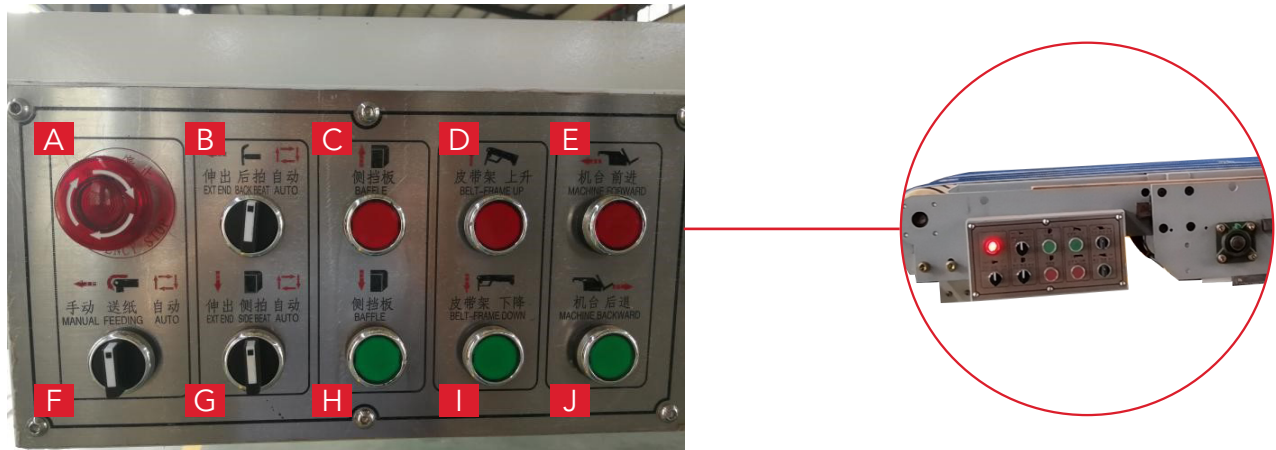
3) Operation panel description as below:

Main Panel



Code	Function
A	Power Indicator
B	Power On/Off
C	Emergency Stop
D	Manual/Auto
E	Fork Up & Tilting
F	Fork Down & Vertical
G	Left Baffle
H	Fork Up
I	Fork Down
J	Right Baffle
K	Fork Tilting
L	Fork Vertical
M	Machine Backward
N	Side-Guider Forward
O	Side-Guider Backward
P	Machine Forward
Q	Belt-Frame Up
R	Belt-Frame Down

Front Panel



Code	Function
A	Emergency Stop
B	Ext End/Back Beat/Auto
C	Up Baffle
D	Belt-Frame Up
E	Machine Forward
F	Manual/Feeding/Auto
G	Ext End/Side Beat/Auto
H	Down Baffle
I	Belt-Frame Down
J	Machine Backward

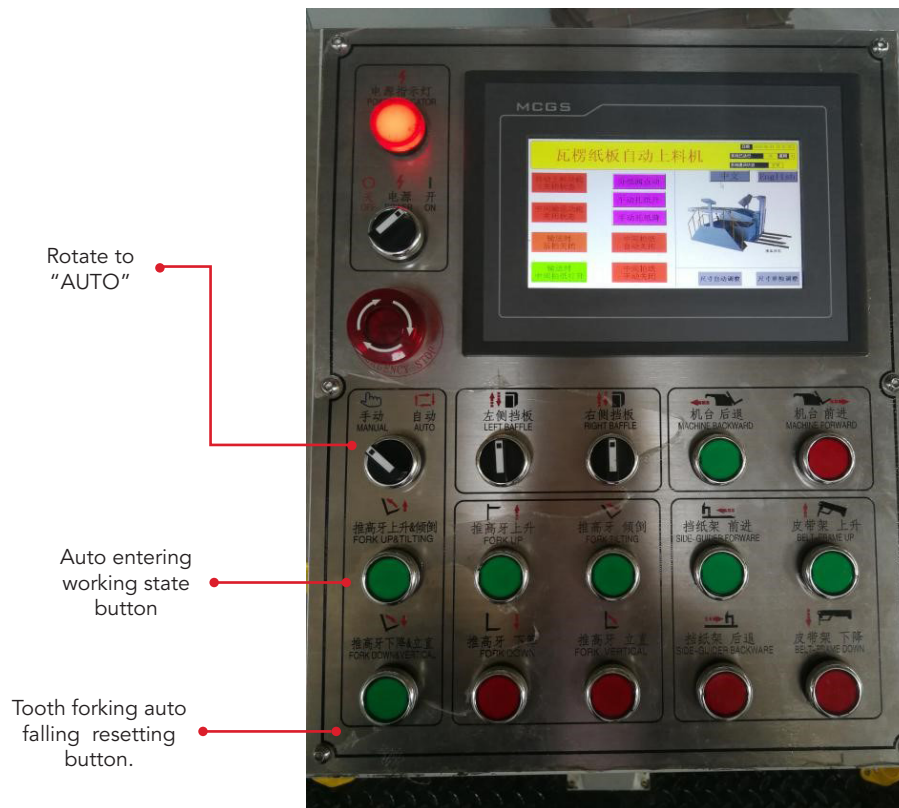
Please follow the panel graphical representation and text instructions to operate.

4) Adjust to right place according to the cardboard size, start to operate on the machine.

4.1 Manually testing before start working.

4.2 Through the physical distribution (logistics), provide cardboard to the tooth forking place, proceed to press the manual feeding button to start the first cardboard piling, verify if the adjusting size is matched or not, if unmatched, perform a manual micro adjustment.

4.3 After running normally, rotate the button to "auto" status, to do auto working.



E) Cylinder Speed Adjustment

- 1) Press "STOP" button, to stop the machine.
- 3) Manual triggering solenoid valve.
- 3) Press or loosen solenoid valve's triggered button, to make cylinder do extending and retracting movements by visually testing cylinder's speed.
- 4) Rotate the throttle valve adjusting button, counter-clockwise direction for the speed to slow down, clockwise direction to speed up.
- 5) Repeat step 3 and step 4, until speed is set properly.

F) Magnetic Ring Cylinder Testing

- 1) Press "STOP" button, to stop the machine.
- 3) Manually triggering solenoid valve.
- 3) Press or loosen solenoid valve's triggered button, to make cylinder do extending and retracting movements by visually testing cylinder's speed. Check the magnetic switch.
- 4) Loosen the magnetic's switch supporting screw, moving the magnetic switch until the indicator light is on.

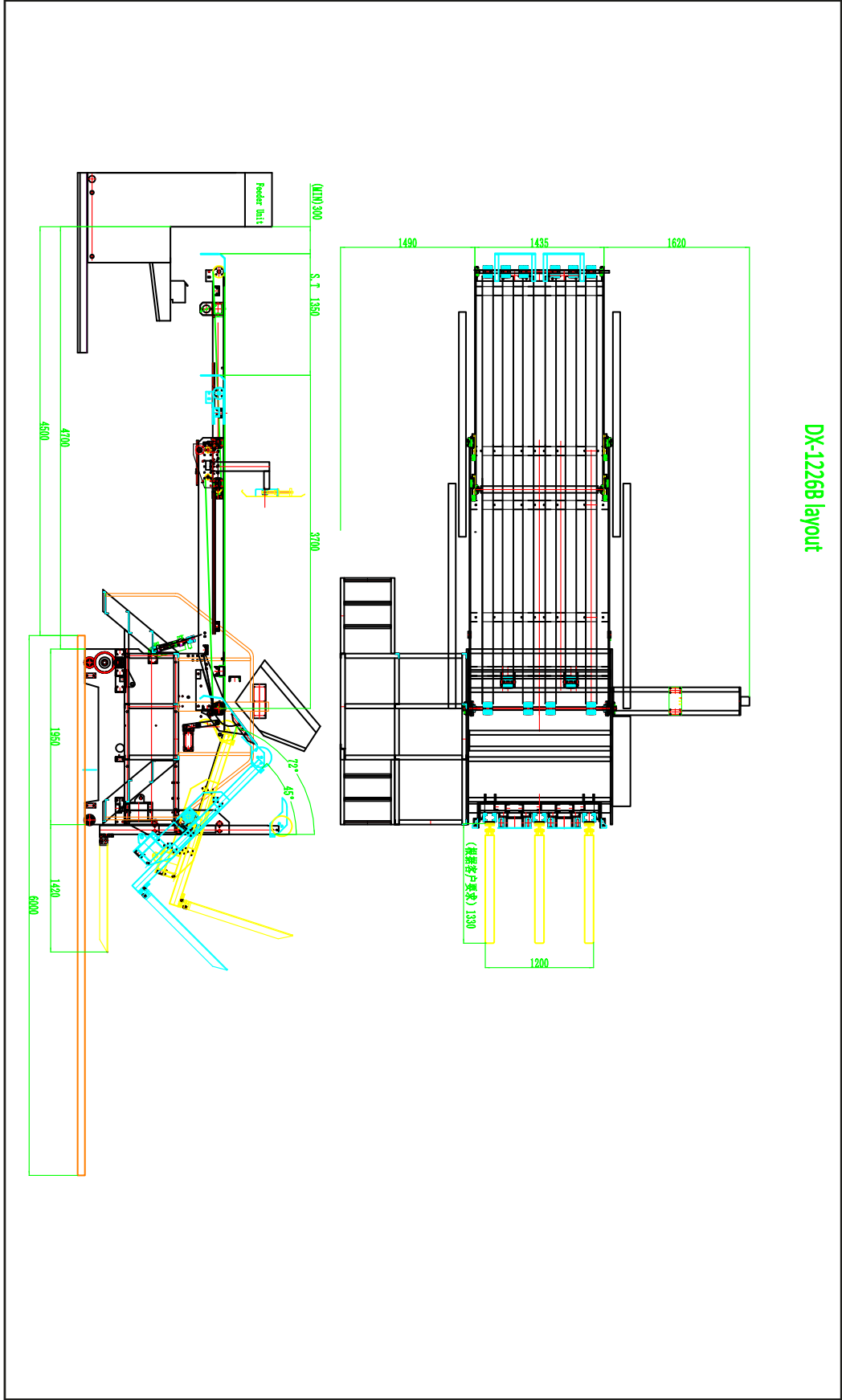
G) Troubleshooting

Problem	Possible Cause	Solution	Standard
Auto mode can't start	- Cylinder doesn't return to original position. - The "switch on" button or the "start" button are not being pressed therefore not starting the triggering signal. - Equipment has problem, but not eliminate. - Emergency stop switch is pressed.	According to auto operation flow	When cylinder is at original point, original point sensor is ON. Press the button, signal is ON.

Electric appliance parts fault treatment

Parts	Solution	Standard
Sensor (Including photoelectric switch, travel switch, proximity switch)	Manual triggering checking sensor's location.	Sensor should be normally working.
Solenoid valve (including oil pressure solenoid valve and pneumatic solenoid valve)	Manual triggering solenoid valve.	Air cylinder , oil cylinder should be extending or retracting.
Power	Measuring input and output voltage.	Input and output voltage should be in the right range.

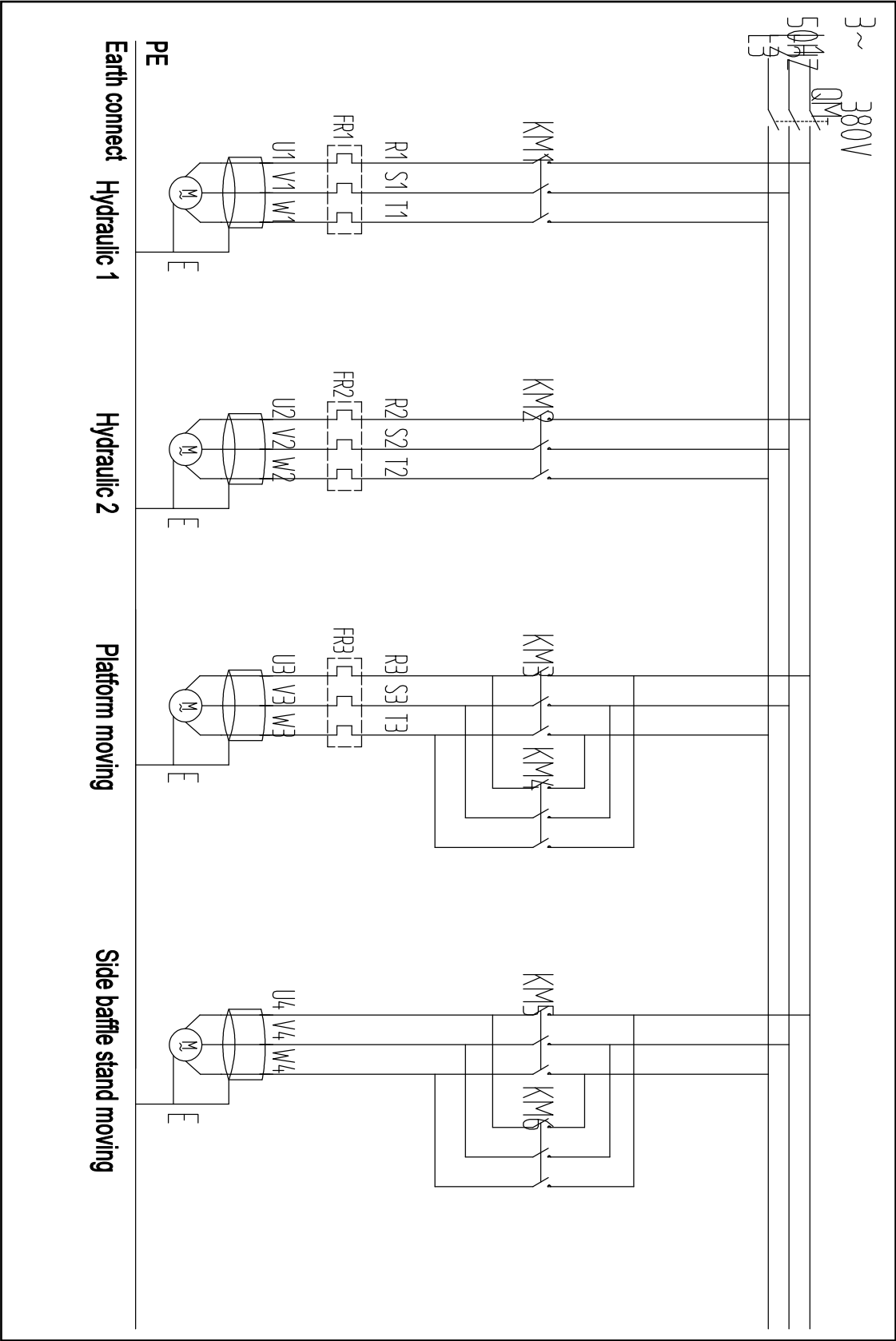
Chapter 7: LAYOUT



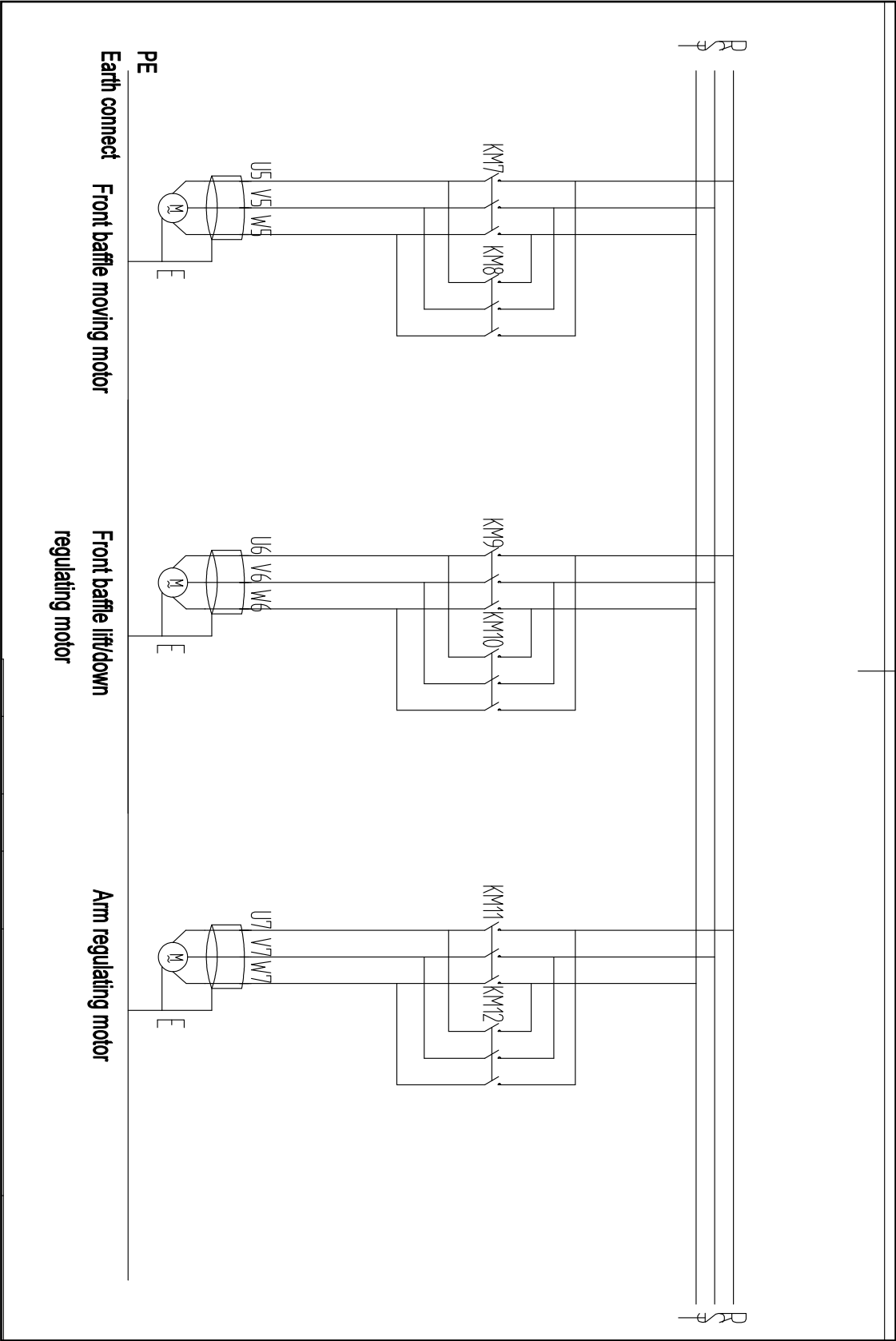
Chapter 8:

ELECTRICAL DIAGRAMS

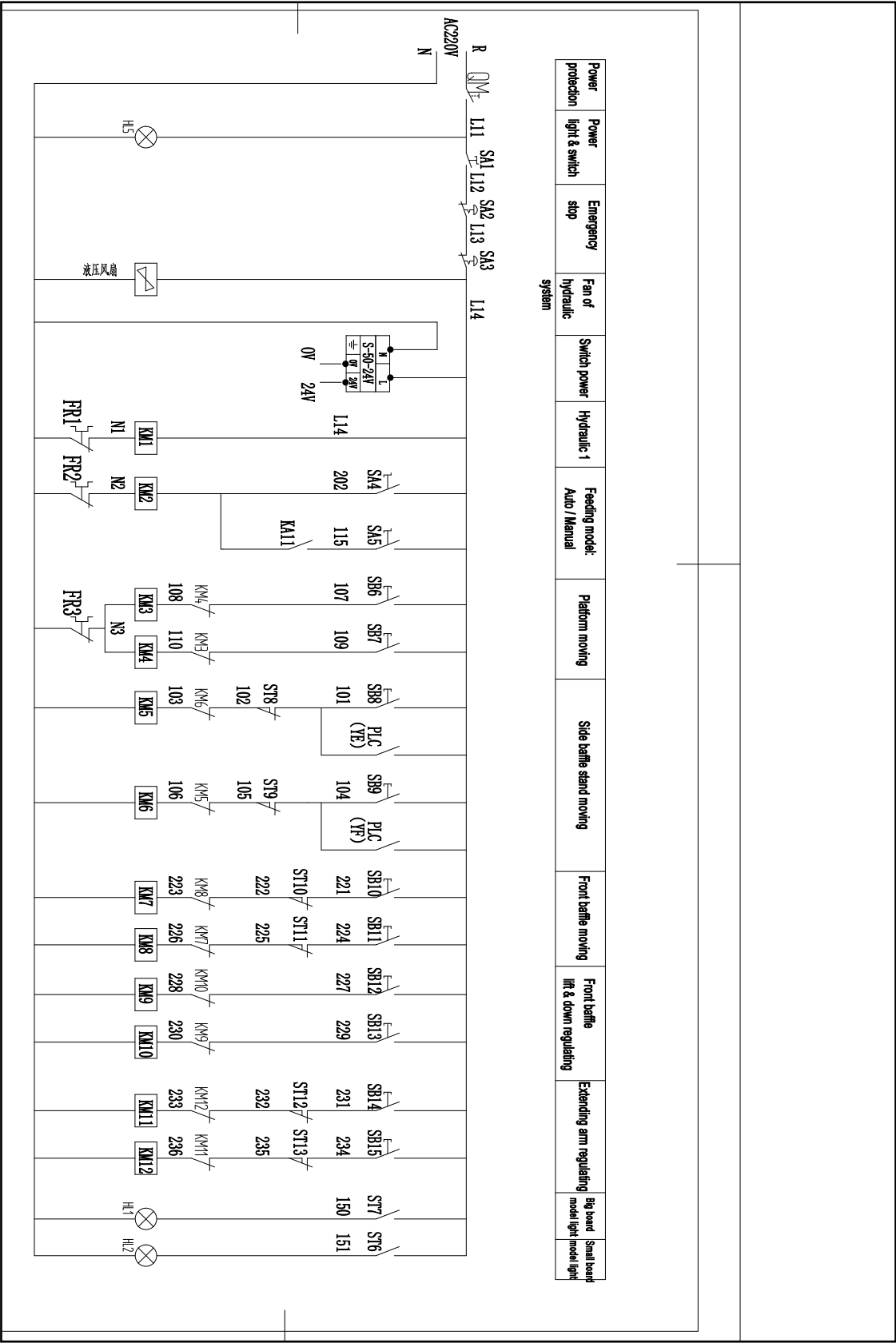
Electrical Diagram #1



Electrical Diagram #2



Electrical Diagram #3



[illegible]



Chapter 9: MAINTENANCE

A) Maintenance Spare Parts

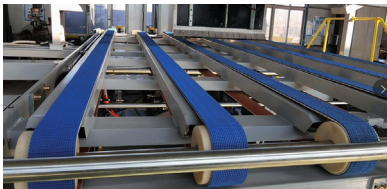
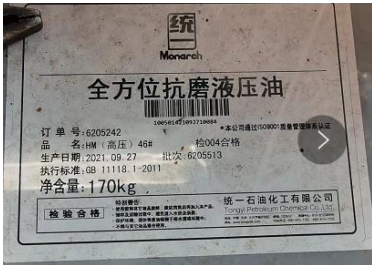
The pieces of the machine are classified in two types:

A) The ones that can be used almost permanently unless they are damaged.

B) Consumables, which are divided into parts that can be stored in case of a failure, and the pieces that need to be changed periodically, a good handling of the consumable pieces is essential.

In order to keep and operate the machine in the best conditions, emphasis is placed in the importance of preventive maintenance, as well as, to keep an inventory of consumable pieces in order to avoid prolonged machine shutdown due to absence of consumable pieces.

List of Recommended Consumable Parts

Piece name	Code's name	Picture	Quantity	Notes
25ZZ Bearing25ZZ	SP-001- DX1226B		12	For Pre-Feeder DX-1226B
Belt	SP-002- DX1226B		8	For Pre-Feeder DX-1226B
			4	
46# High pressure hydraulic oil 46#	SP-003- DX1226B		170 kg/barrel	For Pre-Feeder DX-1226B

B) Table

Inspection Area	Item	Way
Machine body	Clean	Clean Inspect
	Spare parts and accessories	Inspecting deckle edge and degree of tightness
	Alarm light	Inspecting function
	Horizontal	Checking machine's body is horizontal
Electric part	Relay	Inspecting function
	Switch on-off	Inspecting function
	Inductor	Clean the inductor surface, Confirm the inductor's susceptibility, Locking the inductor's support, Inspecting function.
Oil pressure Air pressure	Oil pipe Air pipe	Inspecting: 1) Contact joint 2) Has leakage, Knots and breakage or not
	Pressure gage	Checking pressure
	Oil cylinder	Inspecting function
	Hydraulic oil	Inspecting quantity and temperature
	Air cylinder	Inspecting function
	Solenoid valve	Inspecting function
	Pressure changing valve	Checking pressure

Standard and checking point	Frequency					Estimated time required
	Every Day	Every Week	Every Month	Every Season	Every Year	
Machine body is clean	✓					5 Min
Using tools to tighten				✓		10 Min
Working normally					✓	5 Min
Using gradienter to check					✓	5 Min
Function normal			✓			10 Min
Function normal		✓				10 Min
Function normal		✓				10 Min
Working normally			✓			10 Min
Standard oil pressure <10 kgf/cm ²	✓					5 Min
Function normal		✓				5 Min
Below 60 degree centigrade	✓					5 Min
Working normally				✓		5 Min
Working normally				✓		10 Min
Standard pressure is 5 kgf/cm ²			✓			5 Min

Chapter 10:

WARRANTY CONDITIONS

1. AMC Industrial Development Company Limited warrants that the equipment is guaranteed to be free from defects in material and workmanship at time of shipment. If during the first year of the date of shipment, the buyer establishes to the seller's satisfaction that any parts manufactured by **AMC Industrial Development Company Limited** were defective at the time of shipment, **AMC Industrial Development Company Limited** will, at its own expense, repair or replace (but not install) replacement parts.

Sellers liability under this warranty is limited to replacement parts only and the seller will make no allowance for corrective work to be done unless agreed to by the seller in writing. Charges for correction of defects by others will not be acceptable, unless authorized in writing, prior to the work being performed, by an officer of the company.

Damage caused by deterioration due to extraordinary wear, improper maintenance or lubrication and improper storage prior to installation, shall not be taken as manufacturing defects. Failure to install equipment properly shall not be taken as manufacturing defects. Warranty does not cover consumable items. Warranty does not cover adjustment to installation or periodic adjustment that may be required during normal operation.

2. The term of guarantee is equal to 12 (twelve) months from the date when the installation and commissioning of the equipment fulfilled. Within one year from the date of accomplishing the installation and commissioning of the equipment fulfilled (don't guarantee the serving life of the wearing parts).

Within the period of quality guarantee, in case of any defects or malfunctions of mechanical parts, which have been proven to be caused by seller's poor materials and assembly technology, upon receipt of the buyer's information in writing and photos, the seller will post spare parts which were mentioned by the buyer as soon as possible at its own cost and the spare parts should be installed by the buyer. The expense of the spare parts and the freight will be borne by the buyer.

3. The following components are not covered by the warranty;

- a. The repair, service and/or installation of any electric component or related replacement part for use with the equipment.
- b. The consumables, that are parts that have limited life expectancy and are designed to be replaced.

4. AMC Industrial Development Company Limited has made no representation, warranties, or guarantees, expressed or implied, not expressly set forth on above paragraph. **AMC Industrial Development Company Limited** shall not be liable hereunder for any consequential damages, losses of profit, loss of production, or contract, financial, economic or any other indirect loss or consequential damage that in any form could suffer the other party.

5. No representative of **AMC Industrial Development Company Limited** has been conferred with any authority to waive, alter, vary or add to the terms of the warranty state herein, without prior authorization in writing executed by an officer of the company.

Chapter 11:

CONTACT INFORMATION

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