

TL series Instruction Book

中国 · 深圳 · 力豪机械设备有限公司

CHINA SHENZHEN LIHAO MACHINE EQUIPMENT CO.LTD.



PREFACE

To our valued guest:

Hello! Welcome to use Lihao's Straightener machine!

In the development process, Lihao Machinery always adheres to the business philosophy of "quality first, service first". Lihao Machinery has passed ISO90000:2000 quality system certification and EU CE certification. It strictly implements standardized production, manufacturing processes and strict testing procedures in the production process, maximizing and guaranteeing product quality and reaching international standards.

Based on years of customer feedback and our service experience, proper use and timely maintenance enable the machine to perform its optimum performance and maintain its original accuracy and vitality. To this end, we hope that this instruction manual will help you make the most of the functions of this device.

If you have any questions during reading this instruction manual or using the device, please send email to our service email: export@lihaomachine.com

Thank you for purchasing Lihao Machinery

In order to use the equipment you purchased correctly, please read this manual carefully before use. Please be sure to submit this instruction manual to the actual user of the device.

1、 architectural feature

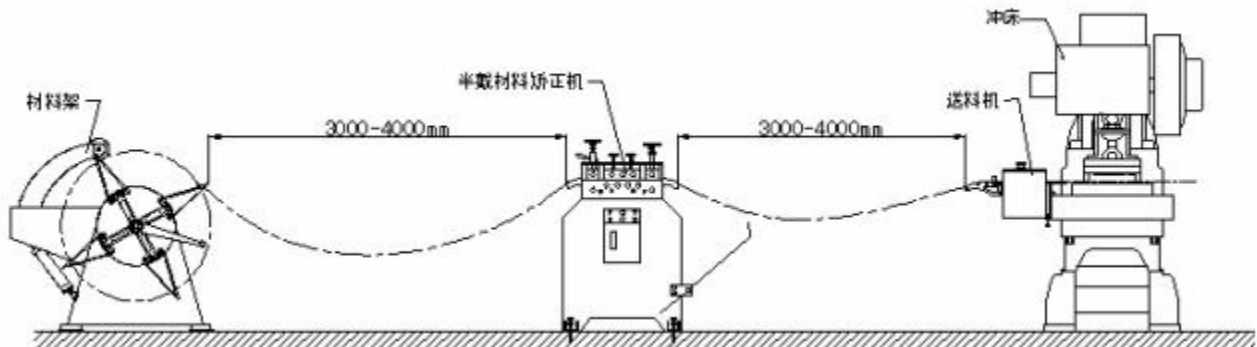
The machine is simple in structure and easy to operate, which is suitable for the correction of metal sheet with low flatness requirement.

2、 Standard Specification Table

model	TL-150	TL-200	TL-300	TL-400	TL-500	TL-600	TL-700	TL-800
Material width	150mm	200mm	300mm	400mm	500mm	600mm	700mm	800mm
motor	1HP	1HP	2HP	2HP	3HP	3HP	5HP	5HP
reduction box	70#	70#	80#	80#	100#	100#	120#	120#
Correction roller	Φ52.5*7				Φ60*7			
material thickness	0.4-2.8mm							
feed rate	15m/min							
Adjustment method	turbine fine-tuning							

3、 operation declaration

1. Position the half-material straightening machine between the material rack and the press, ensuring the center of the machine's rollers aligns with the material center of the rack and the feeding center of the feeder in a straight line. The distance between the straightening machine, the material rack, and the feeder is as shown in the figure below (it can be adjusted appropriately based on the material thickness).



2. Feed and discharge rods:

- (1) The front feeding rod feeds the material through rollers to the rear discharge rod.
- (2) The two stop wheels on the feeding rod are used to fix the left and right positioning of the material during its forward movement. The material should not be locked too tightly; for example, if the material width is 100mm, the stop wheel opening should be 105mm.

3. Feed handle:

When loading, press the handle to open the feeding roller automatically. Place the material inside, then pull the handle to secure it in place for use.

4. Large wheel:

Adjust the tension between the active and passive feeding wheels. If the material fails to advance, press the large handwheel until the material is fully discharged.

5. Small handwheel:

- (1) for adjusting the flatness of the orthodontic material;
- (2) If the material is concave, it indicates excessive pressing, requiring the handwheel to be loosened; if convex, it suggests insufficient pressing, necessitating tightening of the handwheel.
- (3) Adjust by no more than 1/8 turn at a time, gradually leveling the surface to meet the material's requirements.

6. electric cabinet :

- (1) The control box features time-based controls (e.g., 3-second delay before material leaves the sensor rod, motor activates automatically after 3 seconds, etc.) to regulate material feed and speed.
- (2) After completing the above operations, manually eject the material to verify the ejection process before activating the automatic mode.

7. Discharge control rod:

- (1) The material stops when it contacts the rod, and after a controlled stop time, it is released again.
- (2) Do not touch the machine itself. If contact occurs, it may cause signal backflow and loss of automatic feeding control, resulting in immediate shutdown.

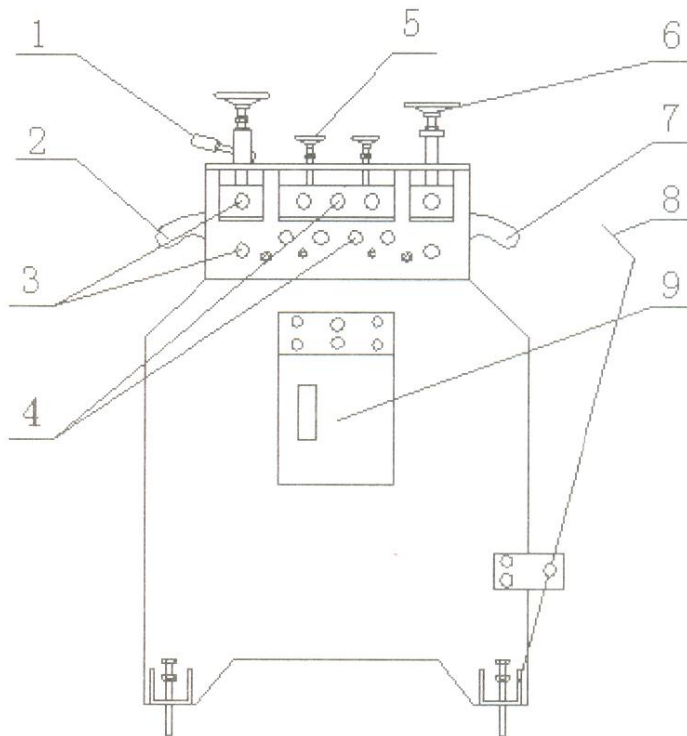
4、 matters need attention

1. When connecting the power supply, first check if the voltage matches and verify phase contact integrity to prevent motor damage.
2. A reliable grounding system should be installed to prevent injuries caused by electrical equipment failure.
3. Cut off the power supply when loading.

5、tending

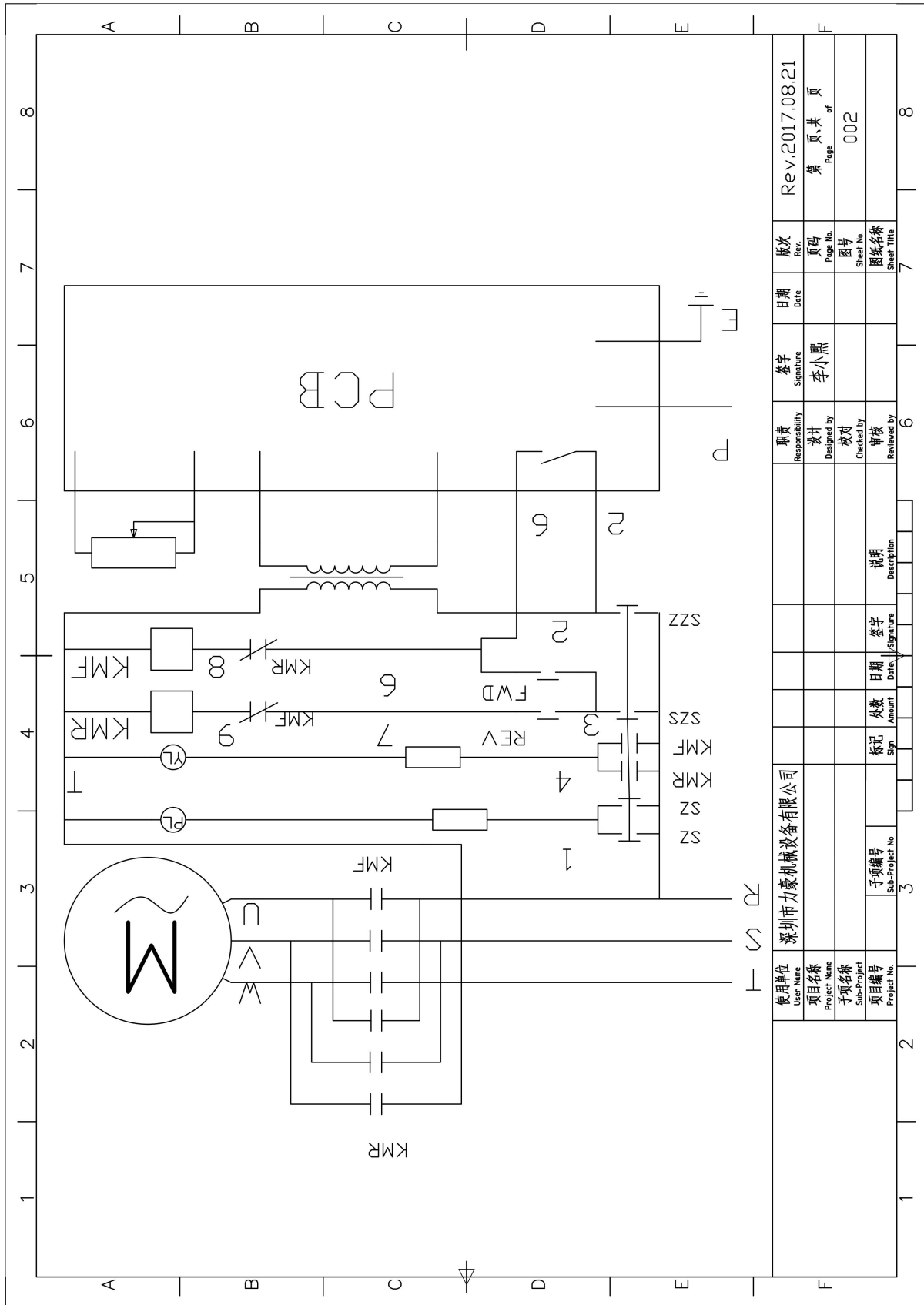
1. For extended use, apply main shaft bearing grease monthly and replace reducer oil every six months, filling it to one-third capacity.
2. All wiring points in the electrical control box must remain secure to prevent electrical damage and ensure normal operation, and must be kept free from oil or water ingress.
3. If not used for a long time, apply grease to the spindle and inspect the electrical control box.
4. Keep all parts of the machine clean.

6、structural representation



1. 入料把手 2. 进料杆 3. 送料轮 4. 矫正轮 5. 小手轮 6. 大手轮
7. 出料杆 8. 出料控制感应杆 9. 电控箱

7、circuit diagram



使用单位 User Name	深圳市力豪机械设备有限公司	版次 Rev.	Rev.2017.08.21
项目名称 Project Name		页码 Page No.	第 页 共 页
子项目名称 Sub-Project		图号 Sheet No.	002
项目编号 Project No.		图纸名称 Sheet Title	
子项目编号 Sub-Project No.		日期 Date	
日期 Date		签字 Signature	李小雨
人数 Amount		职责 Responsibility	设计 Designed by
标记 Sig.		校对 Checked by	
说明 Description		审核 Reviewed by	



Certificate of inspection

Product type: _____

Product code: _____

**The product is qualified in accordance with the
technical standards of the product.**

Permission to leave the factory

Examination clerk:

Date:



Warranty card

User name		Factory number	
Production type		Date of production	
Date of purchase		Invoice number	

Instructions for warranty

Thank you for using Lihao stamping peripheral equipment ,in order to ensure the interests of users,our company sincerely promises to provide you with the following services with this warranty card.

1. Lihao servo feeder is guaranteed for one year from the date of purchase.
2. The machine can be repaired free of charge within the stipulated warranty period for any faults that occur in manufacturing problems.
3. The following conditions do not belong to the scope of free maintenance,but can be implemented by fee-based maintenance,life-long service.

1) Don't show the warranty card or the warranty card without the company's seal confirmation.

2) Faults caused by accidental factors or user failure to operate according to random instructions.

3) Fill in the warranty card that the products does not conform to or be altered with the repaired product.

4) Over the stipulated warranty period,the repairs will continue.

Seal:

Service email: export@lihaomachine.com

Please keep this card properly.



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