

AUTOMATIC SPRAY MACHINE

AUTOMATIC SPRAY MACHINE (LINE 1)							
Cycle Time Program				Auto Mode Setting (Spray Gun)			
Machine Speed :		12 ± 5		ON		OFF	
Cycle Pulse :		240 ± 50	L=>R		110 ± 50		120 ± 50
Rotary Program			L<=R		140 ± 50		150 ± 50
Rotary Speed :		65000±15000	L=>R		180 ± 50		190 ± 50
Position Forward :		21850±5000	L<=R		220 ± 50		230 ± 50
Auto Mode Setting				Auto Mode Setting (Spray Bridge)			
	ON	OFF		ON		OFF	
Tension :			L=>R		110 ± 50		120 ± 50
	80 ± 50	240 ± 50	L<=R		140 ± 50		150 ± 50
Insert :			L=>R		180 ± 50		190 ± 50
	15 ± 5	80 ± 50	L<=R		220 ± 50		230 ± 50

AUTOMATIC SPRAY MACHINE (LINE 2)							
Cycle Time Program				Auto Mode Setting (Spray Gun)			
Machine Speed :		12 ± 5		ON		OFF	
Cycle Pulse :		240 ± 50	L=>R		110 ± 50		120 ± 50
Rotary Program			L<=R		140 ± 50		150 ± 50
Rotary Speed :		65000±15000	L=>R		180 ± 50		190 ± 50
Position Forward :		21850±5000	L<=R		220 ± 50		230 ± 50
Auto Mode Setting				Auto Mode Setting (Spray Bridge)			
	ON	OFF		ON		OFF	
Tension :			L=>R		110 ± 50		120 ± 50
	80 ± 50	240 ± 50	L<=R		140 ± 50		150 ± 50
Insert :			L=>R		180 ± 50		190 ± 50
	15 ± 5	80 ± 50	L<=R		220 ± 50		230 ± 50

AUTOMATIC SPRAY MACHINE (LINE 3)							
Cycle Time Program				Auto Mode Setting (Spray Gun)			
Machine Speed :		12 ± 5		ON		OFF	
Cycle Pulse :		240 ± 50	L=>R		110 ± 50		120 ± 50
Rotary Program			L<=R		140 ± 50		150 ± 50
Rotary Speed :		65000±15000	L=>R		180 ± 50		190 ± 50
Position Forward :		21850±5000	L<=R		220 ± 50		230 ± 50
Auto Mode Setting				Auto Mode Setting (Spray Bridge)			
	Auto Mode Setting	OFF		ON		OFF	
Tension :			L=>R		110 ± 50		120 ± 50
	80 ± 50	240 ± 50	L<=R		140 ± 50		150 ± 50
Insert :			L=>R		180 ± 50		190 ± 50
	15 ± 5	80 ± 50	L<=R		220 ± 50		230 ± 50

วิศว : _____
 พนักงาน : _____
 หัวหน้ากะ : _____