

ST55 E-Mag Heat Shrink Machine

Instruction Manual



Dear users:

Firstly, thank you for using our products. Please read and follow the installation and maintenance instructions written in this manual carefully.

Product model: ST55 intelligent type

This machine is suitable for heat shrink knife handles of different materials like stainless steel (Diameter 3-25mm) and alloy steel (Diameter 3-16mm) .



二、 Data

Power Input	AC220V 50HZ 16A
Input Power	5Kva
Cooling Method	Gas Cooling
External Gas Pressure	0.4~0.8MPA
Heating Range(mm)	Φ3-25
Machine Size (mm)	L450*W420*H760
Machine Weight(kg)	Bare Machine(20KG)

三、 Interfaces Introduction

After power is turned on, the screen appears as follows.

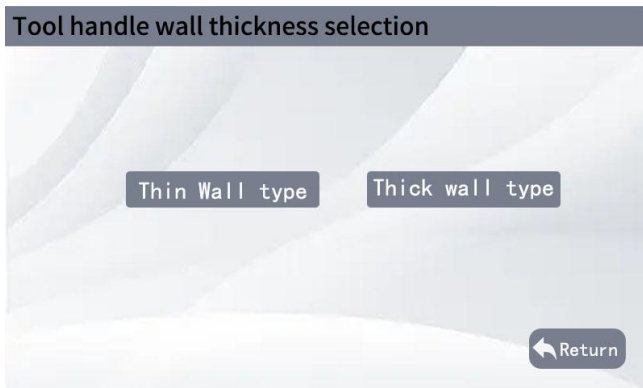
1、 Choose Language



2、 Choose Material

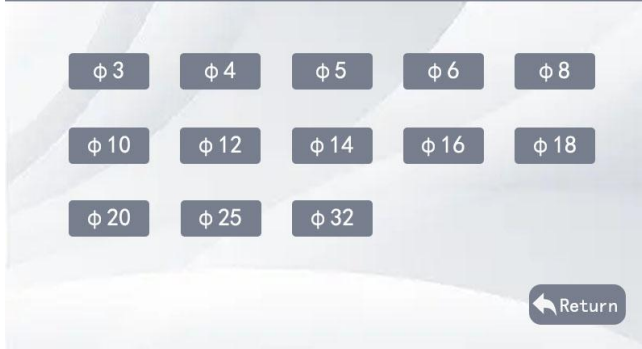


3、 Choose Handle Wall Type

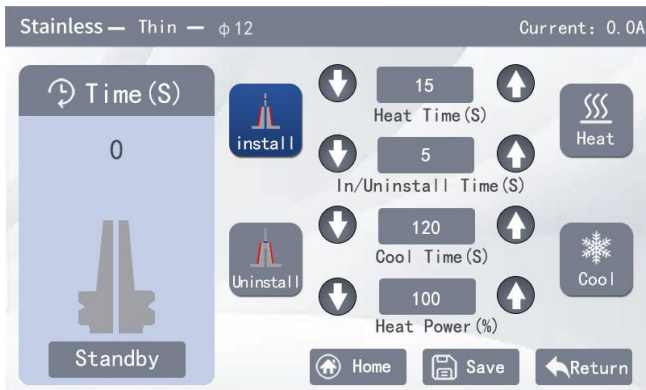


4、 Choose Milling Cutter Diameter

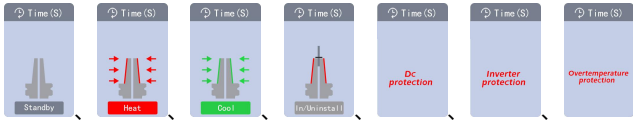
Milling cutter diameter selection



5、 Heating Interface



1、 There are the following types of system status :



2、 Operating buttons :



Milling cutter installation mode



Milling cutter disassembly mode



Heating start button



Cooling start button



Data plus



Data reduction



Back to language selection page



Save this page tool heating parameter



Go back to the main menu

3、 Display status box

Stainless-Thin-φ12: Show the current selection model

Current: Display equipment working current

Heat Time: Heating time of installation/disassembling tools

In/Uninstall Time: Working time for workers to installation/disassembling tools

Cool Time:

Heat Power:

四、 Use Method

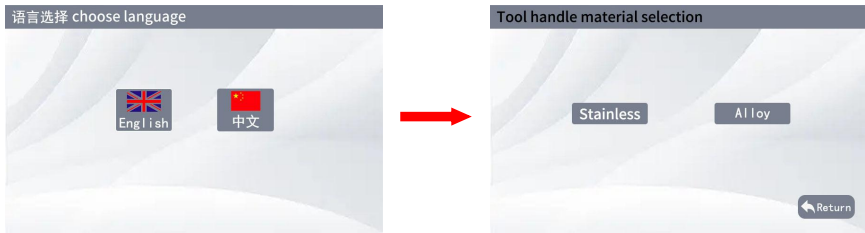
1、 Box examination: cut the packing belt and open the packaging box. Take out the machine, place it in the workbench and confirm if the product equipment is intact and all relevant accessories are complete.

2、 Installation: Place the machine on the workbench (the workbench needs to be stable and smooth, not tilted), and connect to the 10mm -diameter external gas source (the external gas tube needs to install the front oil water separator to ensure that the gas source is dry), plug in the power cable, and turn on the power supply. Start the following operations after the screen is on for 2-3 seconds.

3、 Let' s take the Stainless steel CR12-12-80 assembling as an example to explain how it works.

3.1 Choose the knife handle adapter set CR12-M10;

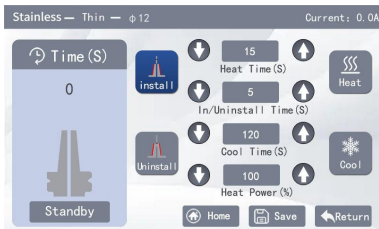
3.2 Place the knife handle into the adapter set and align the green line of the coil with the end face of the knife handle










3.3 Press **English** Enter the next page 3.4 Press **Stainless** Enter next page



3.5 Press **Thin Wall type** Enter next page 3.6 Press **φ 12** GO to this page



3.7 Set parameters: click install key  to select install mode, the heating time is set to 15s, the installation and disassembling are adjusted

according to the assembly proficiency, the cooling time is set to 120s, the heating power is set to 100% by default. Press  to save all parameters. Click  to start heating , wait for the heating keys to jump to , and start installing the knife. The In/ Uninstall time is completed, System automatically jumps to  to start cooling, Cooling runs complete and jump to . Press the lifting Switch, improve Sensing heating coil, take out the tool (**note that you need to wear heat thermal gloves to avoid being get burned**). So far, the installation process is completed.

- 4、 Turn off the power if the machine will not be used for a long time.

五、 Product list

Name	Model	Quantity
Heating Machine	ST55	1
Power cord	2.5P*3-1.5	1
Knife Handle adapter	Increase	1
Knife Handle adapter	BT40(CAT40、 HSK63A)	1
Knife Handle adapter	BT30(CAT30、 ISO30)	1
Knife Handle adapter	CR12-M10	1

Manual	ST55-SMS	1
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六、Precautions

- 1、 The equipment is prohibited from being heated without load to avoid equipment failure.**
- 2、 Ensure power output is 220V/50HZ**
- 3、 Do not wear any metal items like cardiac pacemaker during heating.**
- 4、 Only use >16A Earthing cable A reliable grounded three-hole flat head fixed socket must be used, with a specification of not less than 16A.**
- 5、 Do not overheat to prevent the handle from burning red and accumulating carbon, which can affect the disassembly and assembly of the knife handle.**
- 6、 Clean inside of the knife handle to ensure smooth assembly, disassembly and installation.**
- 7、 When the knife holder cannot be put into the tool after being heated, the tool holder should be completely cooled, and check whether the diameter tolerance of the knife holder is in line with the standard; If the knife handle diameter tolerance is within the standard tolerance (refer to the equipment sticker for the standard knife handle diameter tolerance), please adjust the heating time. If the tool cannot be removed, it is the same as the above operation, and it is strictly forbidden to start the heating again when the tool holder cannot be loaded after being heated.**
- 8、 The external compressed gas source must be equipped with an oil-water separator and ensure that the device is valid. Otherwise, the water vapor will burn the heating coil if it gets into the coil. This is damaged by improper human operation. It is not within the scope of the entire machine warranty, please know!**

9、 Cooling process takes more than 120 seconds. Please wear gloves all the time.

10、 The machine needs to dissipate heat moderately, do not pile up debris at the inlet and outlet of the fan, and ensure a good ventilation environment

11、 There is a high-voltage power at the rear access port of the machine. Please do not disassemble it by yourself to avoid electric shock! (Please note that there is still residual voltage after the power supply is turned off!) After the machine frequently fails and cannot be used, please contact the manufacturer for maintenance. **The manufacturing company is not responsible for any secondary damages and personal injuries caused by unauthorized disassembly!**

12、 This machine is warranted for one year, and human damage is not supported during the warranty period.

13、 Keep the machine on a stable flat table and ensure that the workbench is clean and dry. If the workbench is unstable during heating, it is prone to rollover and scalding accidents!

14、 The machine is sold on ____ Month ____ Day ____ Year

Before using the device, please read this manual carefully. The company is not responsible for any machine failure and personal safety caused by improper operation or other force majeure!