



JR321 FLEXOGRAPHIC LABEL PRINTING MACHINE

## **Operation Manual**

**(Welcome to purchase Jingda Printing Machine )**

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## Flexographic Label Printing Machine

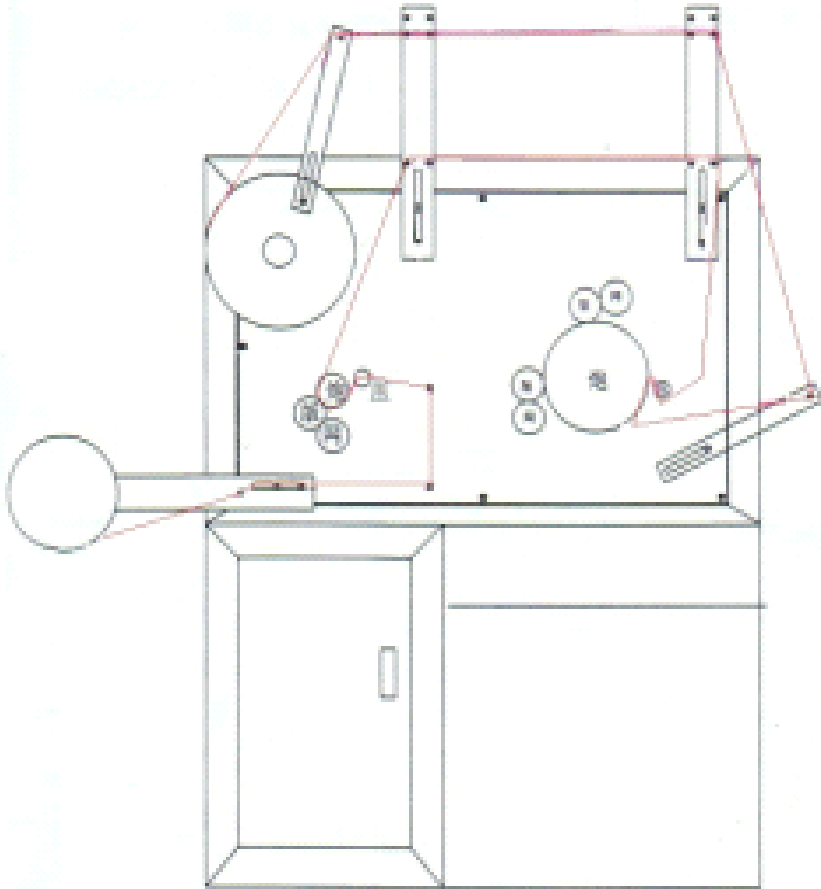
### Basic parameters

Color stations:	2 color + 1 color of back printing
Max. printing width	150 mm
Max. printing length	229 mm
Anilox roller	200 lines/in
Length counter	(pre-set), refer to Reference Table 2-1
Max. speed	60 meters/min
voltage	220V/50Hz

Optional accessories	Basic accessories
Ceramic anilox roller	200 line/in anilox roller
Gears	1 set of printing roller
Double rolling device	1 set of gears
Double unrolling device	Electric heated board
Printing cylinder and gears	Drying cabinet, 1 color of back printing

1. Please read the “User’s Manual” carefully and get a complete understanding of its content before transporting, installing, adjusting, operating and maintaining the JR flexographic plate series of trademark printers.
2. In transporting, installing, and operating of the machine as well as electricity and high temperature, the user should not only observe the safety specification and meet the requirement of the “User’s Manual”, but also the related national rules and regulations in the fields of machinery and electricity.
3. The “User’s Manual” and the intellectual property right of the flexographic plate printer series belong to Rui’an Jingda Printing Machinery Company, Ltd., which should not be disclosed to the third party. Should there be any violation of the right, the company is entitled to take a legal action.

Feeding chart



Note: the red in the chart stands for the route of double printing

Since 2000, the company has become a professional enterprise specializing in the design, development and manufacture of the printing machines. We have put into the national and international markets all kinds of printers and thus won the trust of users both at home and abroad. At the same time to improve quality and increase variety, we have also standardized and serialized our products.

The JR flexographic series of trademark printers are of high quality and variety. They have multiple functions and reasonable prices as well as reliable after sale services. They are the ideal choice for flexographic plate printer users. Since their introduction to the markets in Europe, America, Southeast Asia, the Middle East and South Africa in 2002, they have been highly evaluated and liked by the commercial agents and users in various countries and regions.

To correctly use the flexographic plate series of trademark printers, please read the “User’s Manual” carefully and get a complete understanding of its content before transporting, hoisting, installing, adjusting, and operating the machine.

## I. Operating principle

When the machine is switched on, the anilox roller will rotate in the ink duct. By controlling the clearance between the ink scraper and the anilox roller, you can deliver a proper amount of ink evenly to the flexographic plate of the circumferential surface of the printing plate wheel. The flexographic plate roller carries the ink to the surface of the material to be printed, which is dried and rolled by the electrically heated drying board to finish the process. The printed material is then put into the electric thermostat ventilating and drying cabinet for about 5 and 6 hours, with the effect of fast color and tolerant laundry. Environment friendly, the machine is characterized by its speed and efficiency. [azizmanver@yahoo.com](mailto:azizmanver@yahoo.com)

## II. Structure

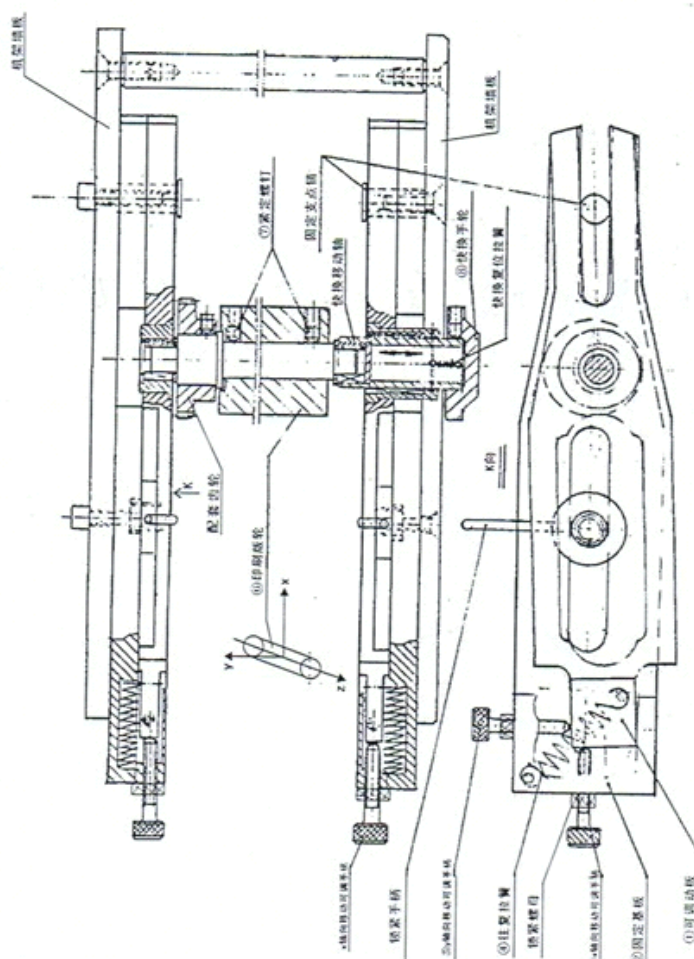
- i. Operating principle of photoelectric controlled band-feeder
- ii. Operating principle of printing plate wheel and adjustable plate assembly

Move the adjustable handle ③ of the x axle, the adjustable plate ① and the printing plate wheel ⑥ will move to and fro along the x axle; move the adjustable handle ⑤ of the y axle, the adjustable plate ① and the printing plate wheel ⑥ will move to and fro along the y axle. When the adjustable handle ③ and the adjustable handle ⑤ are moved simultaneously, the printing plate wheel will move along the x axle and the y axle simultaneously, thus fulfilling the function of simultaneous adjusting and controlling the printing plate wheel in its ink delivery, pressure of impression and accuracy of contact.

By loosening the fastening bolt(7), the printing plate wheel can be moved along the z axle or adjusted circumferentially around the z axle. By pulling the quick-change hand-wheel(8) outward (along the z axle), you can change

quickly the plate wheels with various diameters and their corresponding gears that are matched with plates of different printing circumferences. The manufactured diameter of the plates with different printing circumferences and the number of their accessory gears are corresponding to each other.

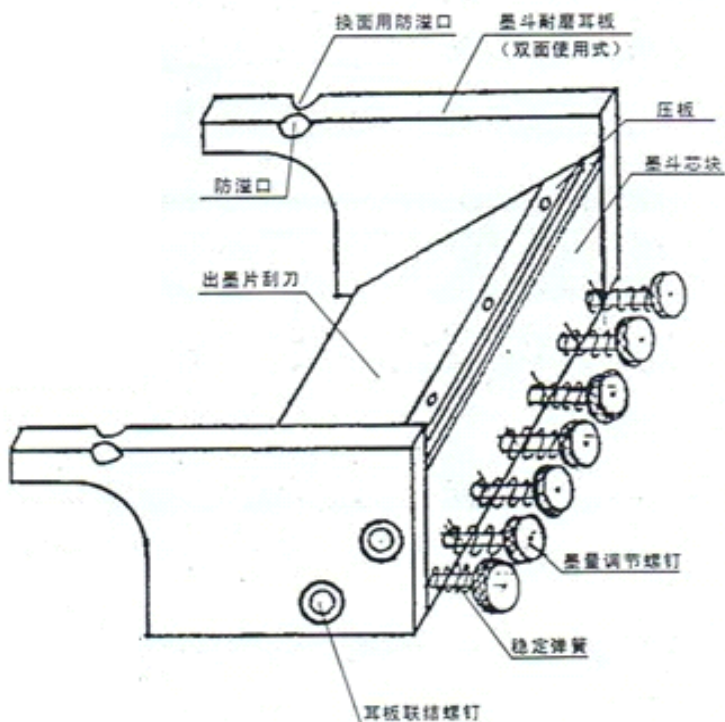
Diagram of operating principle of printing plate wheel and adjustable plate assembly



1. 可调动板 Adjustable plate
2. 固定基板 Fixed plate



3. X 轴向移动可调手柄 Adjustable handle of X shaft
  4. 锁紧螺母 Locked nut
  5. 往复拉簧 Rebound spring
  6. X 轴向移动可调手柄 Adjustable handle of X shaft
  7. 锁紧手柄 Locked spring
  8. X 轴向移动可调手柄 Adjustable handle of X shaft
  9. 印刷版轮 Printing offset gear
  10. 配套齿轮 Completed gear
  11. 紧定螺钉 Locked screw
  12. 固定支点销 Fixed supporting pin
  13. 快换移动轴 Moveable shaft
  14. K 向 K
  15. 快换手轮 Handwheel
  16. 快换复位拉簧 Reset spring
  17. 机架墙板 Frame plate
  18. 机架墙板 Frame plate
- iii. Correct use and maintenance of anilox roller
- iv. Ink duct structure and its adjustment



19. 出量片刮刀 Blade
20. 防溢口 Anti-overflow exit
21. 换面用防溢口 Mask-changed anti-overflow exit
22. 墨斗耐磨耳板 Ink bearable plate (双面使用式) (double-side use)
23. 压板 Press plate
24. 墨斗芯块 Ink core
25. 墨量调节螺钉 Ink adjusting screw
26. 稳定弹簧 Steady spring
27. 耳板连接螺钉 Connecting screw

The ink duct is removable for easy clean. It is recommended that the ink duct be cleaned at each change of color, type and shift.

The ink duct at every position, the parallel and the distance accuracy of the left and the right wear-proof ear plates, and the length of the anilox roller at the position are matched in pairs and marked with serial numbers; therefore, cares must be taken in installing ink ducts. The number must correctly correspond to each other.

The wear-proof ear plates are made of precious metal; therefore, we have considered a structure in which the side of the ear plate can be changed. Thus, the embedded hole of the connecting bolt and the anti-overflow hole are so designed that their sides can be changed. As a result, the life of the ear plate can be doubled.

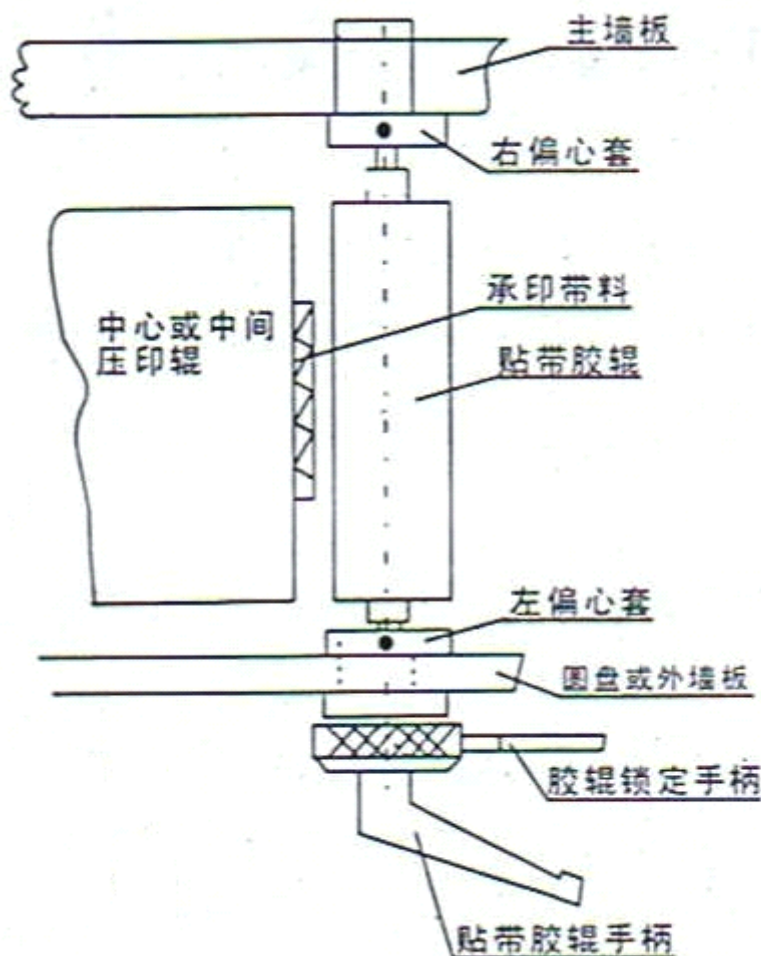
The anti-overflow hole has served functions. On the one hand, it enables the ink brought out by the upper half circle of the anilox roller to return to the ink duct and, on the other hand, a little lubricating oil can be dripped in through the hole before operation so as to reduce friction and prolong the life of the ear plate.

When you loosen the pressure plate, the ink scraper, which can also be used double faces, can be extended or supplemented to a proper position. When the position of the ink scraper is decided, the three socket-head-cap screws on the pressure plate must be tightened. It should be noted that in adjusting the contact between the edge of the ink scraper and the anilox roller should be kept in parallel with the central line of the axle, as well as with the surface of the anilox roller. The pressure of the contact should be great enough to fulfill the normal printing.

The ink adjusting bolt is used to adjust the amount of ink brought out by the anilox roller from the ink duct. When it is adjusted clockwise, the amount

of ink is reduced; when counterclockwise, the amount of ink is increased. The pressure on each and every adjusting bolt should be even and constant. Care must be taken not to let the pressure on a certain bolt distinctly greater than that on other bolts, or adjust the ink scraper to exceed the normal operating pressure or, above all, let the ink scraper dryly frictionate with the anilox roller to cause damage to the roller.

v. Eccentric labeling roller and central impress roller



28. 中心或中间压印辊 Center or middle printing roller

- 29. 主墙板 Main wall
- 30. 右偏心套 Right eccentric sleeve
- 31. 承印带料 Bearing printing
- 32. 贴面胶辊 Stick roller
- 33. 左偏心套 Left eccentric sleeve
- 34. 圆盘或外墙板 Disc or exterior plate
- 35. 胶辊锁定手柄 Locking handle
- 36. 贴带胶辊手柄 Stick handle

Through the rotation of its handle, the eccentric labeling roller makes the left and the right eccentric covers to rotate synchronously, which uses the eccentric distance to press the material to be printed onto the circumferential surface of the central impress roller. When this is done, the locking handle of the roller should be tightened clockwise to ensure that the material to be printed to rotate synchronously at a certain tension with the central impress roller without slipping or deviating. Thus, the color registering is accurate and the printing quality is guaranteed.

The central impress roller is the central element of the machine, the material, processing, and static balance testing of which are very strict. The accuracy of coaxiality of the outer circumferential surface relative to the bearing position at both ends of the main axle and the vibrating error of the outer circle relative to the rotating center are strictly kept within the permissible scope of designing and printing. It has also had enough accuracy reservation to ensure the performance, life and reliability of the whole machine. Besides, an anti-slippery film is added to the circumferential surface of the central impress roller to increase the friction factor with the material to be

printed during printing process.

vi. Name and function of operating panel control, display and knobs

1. Operation indicator: When the operation knob SB2 is pressed, the indicator is lit and the machine begins to operate.

2. Speed display: The digit number shows the printing speed.

3. Counter: To preset the quantity of the material to be printed. When the actual quantity of the printed material has reached the preset number or the multiplication of the preset number, the machine will stop automatically. At this time when the machine needs to be restarted, just press the “clear” key on the counter to make the number accumulated on the counter reset to zero.

4. Stop button: The knob is marked red. When this knob is pressed, the printing motor will stop.

5. Inching button: The knob is marked yellow. When this knob is pressed, the printing motor will rotate slowly; when this knob is released, the printing motor will stop rotating. This function is used for page correction or testing the stepping of the machine. When the machine is in operation, press this knob and the printing motor will stop immediately.

6. Operation button: This knob is marked green. When this knob is pressed, the operation indicator will be lit and the machine will begin to operate

7. Speed button: By turning this knob, stepless speed regulation of the printing motor can be realized. When it is turned clockwise, the printing speed will increase; when it is turned counterclockwise, the printing speed will be decrease.

8. Broken-band protection switch: when the material to be printed is used

up, the machine will stop automatically. This is done through a probe. When there is material to block the probe, the machine will operate; when there is no material to block the probe, the machine will stop.

9. Counter switch: When there is need to count the printed material, just press this knob to “ON” position; when there is no need, press this knob to “OFF” position.

10. Temperature control and display of the upper drying board: Temperature control I is used for the temperature control of six-color group arranged in satellite form, and the 2 positive 1 negative type is used for the temperature control of 2 positive printing.

11. Electric switch of the upper drying board: When the 6 positive 2 negative type is used only for the drying of two-color group, or the 2 positive 1 negative type is used only for the drying of single-color group, the upper drying board can be switched off.

12. Temperature control and display of the lower drying board: The 6 positive 2 negative type is used for the temperature control of two-color group, and the 2 positive 1 negative type is used for the temperature control of single-color group.

13. Electric switch of the lower drying board: When the 6 positive 2 negative type is used only for the temperature control of six-color group arranged in satellite form, or the 2 positive 1 negative type is used for the temperature control of two-color group, the lower drying board can be switched off.

Make sure that the machine is in OFF position. Thread the material to be printed along the threading line according to the sketch diagram of the

purchased type of the machine.

Pull outward (z direction in the diagram) the quick-change hand-wheel (8), and place the roller wheel threaded with the flexographic plate and the accessory gear with the confirmed correct number of gears into the bearing holes of the adjustable plate assembly at both ends of the corresponding printing color position.

Mesh the accessory gear of the plate roller wheel with the central impression roller gear, and then tighten the locking handle of the adjustable plate assembly.

Run the machine slowly and adjust every adjustable handles of the adjustable plate assembly. Adjust the ink between the printing plate wheel and the anilox roller and the contact pressure and accuracy on the impression roller till satisfactory. In printing practice, the contact pressure between the plate roller and the material to be printed is generally very small, sometimes approaching “zero”, i.e., the “zero pressure” contact in flexographic plate printing terms. In short, adjust the machine till the printed pictures, words and lines are clear and satisfactory. Needless to say, practice makes perfect. Everyone can learn and improve his skills with time going by.

In normal printing, adjust the speed knob until the rotation or the ink amount corresponds with the electric drying speed of the machine.

The maximum printing speed can reach 60 meters per minute.

14. The switch-off procedure is as follows: Turn off all the electric drying knobs → turn off the stop knob → switch off the power switch of the main control box → switch off the external power source.

And then clean the anilox roller, the ink duct, the plate wheel and finally



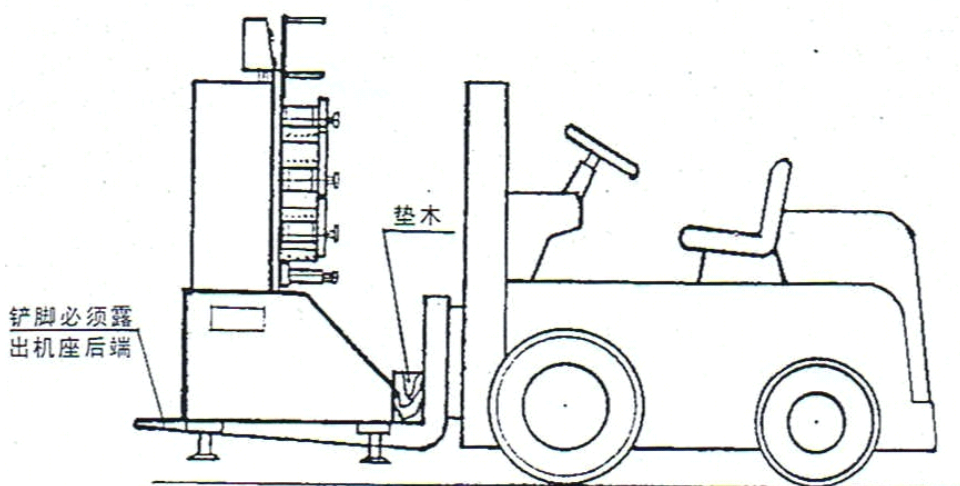
the whole machine.

### III. Trial running and switch on and off machine

1. Switch on the power source.
2. When there is no material to block the photoelectric probe, use material to block the photoelectric switch; otherwise, the machine is unable to start.
3. Check the counter to see if it is in the position of “zero”. When the number reaches the preset number and the “zero” is not pressed, the machine will stop automatically.
4. When the machine is trial running without load, all the inkless ducts should be taken down and put aside. Check every part and see if they are running normally, especially the rotating direction of the anilox roller. Whatever types of the machine, the correct rotating direction of the anilox roller should rotate towards its matched ink duct. If the rotating direction is not correct, ask the electrician to change the rotating direction of the motor. When everything is confirmed normal, enter the next step.
5. Press the yellow “spot move” knob on the main control box, and the machine will be in the position of spot movement.
6. Press the green “operation” knob on the main control box and adjust the “printing speed” knob to let the machine run at low speed. If everything is normal, continue the following adjustment.
7. Press the red “OFF” knob on the main control box, and the machine stops running. When the machine is in operation, press the yellow “spot move” knob or the yellow “spot move” knob on the main wall board of the 6/2 type and the 2/1 type, the machine can also stop running.
8. put on the ink ducts (according to the actual use, if there is an empty color

position or positions, there is no need to put on the ink ducts), drop a moderate amount of lubricating oil into the anti-overflow hole in the combination of the ear plate of the ink duct and the anilox roller. Add a proper amount of ink in the ink duct; adjust evenly the adjusting bolt of ink until the amount of ink on the anilox roller meets the requirement. (slow speed while adjusting)

#### IV. Attention, transportation and hoisting



搬运示意图

1. 垫木 Pad 2. 铲脚必须露出机座后端 Spade foot must be exposed to the rear end of the machine 3. 搬运示意图 Shipping chart

1. Before switching on the machine, the machine must have a good ground connection lest there should be damage to humans or the frequency converter of the machine. In maintenance, first switch off the power supply until all the displays disappear and the high-voltage indicator inside the frequency converter dies off before doing maintenance and check.

2. The machine will stop in the following 4 cases:
  - ① When there is no material to be printed to block the photoelectric probe. Block the photoelectric probe is OK.
  - ② When the printing speed adjusting (potentiometer) knob is at the lowest speed. Turn this knob clockwise is OK.
  - ③ When the counter has reached the preset number. Reset the counter to “zero” is OK.
  - ④ When the power voltage is greater than 250 V or lower than 190 V. It is necessary to use a stable power source, the power of which should be greater than the overall power indicated on the machine.
3. For other specifications concerning machine operation and electricity safety not listed in this “User’s Manual”, the user should strictly observe the rules and regulations formulated by the state and the departments concerned.
4. The wall board and other components are precision elements, therefore, in hoisting the steel cable should not be tied at the position other than the hoisting rings. The user will be responsible for the damage caused by violation.
5. It is recommended to use a forklift truck to carry the machine. When the wooden packaging box is removed, the forklift truck will shovel the machine from the front (see the sketch diagram). Pay attention to the center of gravity when the machine is lifted 50-100 mm from the ground. Only when it is adjusted in balance, can the machine be carried to the place for installation, which should be a solid and even floor (The machine is permitted to be placed on the wooden base of the packaging

box). Adjust the anchor bolts, and make the surface of the wall board vertical or 0.5 degrees tilted backward to the ground level.

#### V. Table of accompanying accessories

Name	Quantity	Remarks
User's Manual	1	Compiled by the company
Screw spanner for dismantling bearing cover	1	Special tools made by the company
Wedge for reel core	2	
Labeling plate seat	1 (assembly)	
Additional plate wheels and their matched gears of other specifications	Packaged according to contract	Manufactured according to requirement
Socket head cap spanner	1 set	Purchased
screwdriver	1	Purchased
Speed adjusting potentiometer	1	Purchased
15A fuse	4	Purchased
8A fuse	4 (only for 2/1 type)	Purchased
Trip switch	1	Purchased
MK2 switch	2 for 6/2 type	Purchased
	1 for 2/1 type	
(MK6) 322B/88 switch	2 for 6/2 type	Purchased
	1 for 2/1 type	

### Trouble Shooting Table

Trouble	Phenomenon	Cause	Solution
Double image	<p>There are unwanted lines around printed image; there is clear contour at the edge; ink piles; or collapsed images.</p> <p>The printed material has deep color at the edge and light color in the middle.</p>	<p>The pressure between the material to be printed and the plate is too big; or the lateral pressure between anilox roller and the frame roller is too big, so that the ink has been squeezed to the edge of the images.</p>	<ol style="list-style-type: none"> <li>1. Readjust the frame pressure. Since a good printing result requires even ink and clear mark, the contact between the image and the material to be printed must be elastic enough. So careful adjustment is necessary before each use of lining-up cylinder. The pressure between printing plate and anilox roller is 0.02mm, and that between printing plate and the material to be printed is 0.01mm.</li> <li>2. The pressure between anilox roller and printing roller is constant (0.02-0.03mm).</li> </ol>

		<ol style="list-style-type: none"> <li>1. The plate is worn.</li> <li>2. In printing, the trademark band is crumpled so that there is local change in depth.</li> <li>3. There is dirt on the impression cylinder.</li> </ol>	<ol style="list-style-type: none"> <li>1. Make a new plate.</li> <li>2. Find the cause of crumple and get rid of it.</li> <li>3. Clear it away.</li> </ol>
<b>Trouble</b>	<b>Phenomenon</b>	<b>Cause</b>	<b>Solution</b>
Double image	<p>There are unwanted lines around printed image; there is clear contour at the edge; ink piles; or collapsed images.</p> <p>The printed material has deep color at the edge and light color in the middle.</p>	<p>The accuracy of printing plate, the abrasion of the gears of the plate cylinder, or the big clearance of bearings can cause vibration in printing, leading to double image.</p>	<p>Check the printing cylinder, axle, axle neck and the gear.</p>
		<p>The printing plate is too hard or not even.</p>	<p>Grind the back side of the plate or stick the adhesive bar for adjustment; change a new plate.</p>
		<p>Too much ink with high viscosity.</p>	<p>Reduce the ink and lower the viscosity.</p>
		<p>The ink is not mixed well, and the</p>	<p>To make them even and reasonable.</p>

		color is not evenly distributed.	
		The hardness of plate is not enough so as to be deformed when pressed.	
		The drying process of ink is too fast.	
		The double-surface glue is too thin or too hard or bubbled so as to cause local thickness.	
There is register difference. (peripheral)			Adjust tension, spring and the printing plate.
There is register difference. (peripheral)		There is too much pressure in operating so that gears generate comparably great impact.	Adjust pressure reasonably.
		After adjusting pressure, the adjusted parts fail to be fastened properly.	After pressure adjustment, fasten the plate and its parts timely to avoid vibration.

<b>Trouble</b>	<b>Phenomenon</b>	<b>Cause</b>	<b>Solution</b>
		The thickness of glue tape for sticking plate is not even.	Use double-surface glue tape with even thickness.
There is ink in non-image part.	There is dirt (ink) in non-image part of the material to be printed.	The stickiness of the adhesive tape is poor.	Use double-sided tape with better stickiness.
		There is too much pressure in printing zone so that the ink is squeezed outside the image.	Reduce the pressure properly.
		There is lint, dirt, etc.	Clear it away.
		There is too much ink.	Control ink properly.
		The image on the printing plate is too shallow, the crown is too low.	Reduce exposure or deepen the relief.
		The plate clearing time is not enough or the pressure is not enough.	Adjust the pressure.
		The printing plate is too soft.	Choose the plate reasonably.



		<p>The connection of the printing plate is not reliable.</p>	<p>Use the special adhesive tape for sealing.</p>
		<p>When making plate, there is pervious to light in the non-image part of the film.</p>	<p>Before making plate, first check if the film has been repaired and there is pervious to light.</p>
		<p>The ink in the depression and protruding parts of the plate is not cleaned thoroughly and left on the plate, which is left on the material to be printed when printing again.</p>	<p>Clean the printing plate and keep a correct printing pressure to avoid expansion of ink mark.</p>

<p>There is peripheral turning up of the printing plate; there are stripes on both ends of the image.</p>	<p>In printing, the two ends of the printing plate gradually leave from the two-sided tape and turn up so as to affect normal printing.</p>	<p>In sticking plate, the cleaning is not thorough so that the base of the printing plate is contaminated to affect the stickiness of the two-sided tape.</p>	<p>In sticking plate, try to keep the base of the printing plate and the two-sided tape clean so as not to affect the stickiness of the tape. When cleaned well, cut the peripheral connecting part of the plate into a 45 degree angle to reduce the bouncing back of the plate.</p>
		<p>When cleaning the printing plate, too much detergent is used with some remained in the connecting part of the two ends of the plate so that the two-sided tape is eroded.</p>	<p>Use adhesive tape to seal the connecting part of the two ends of the printing plate.</p>

<b>Trouble</b>	<b>Phenomenon</b>	<b>Cause</b>	<b>Solution</b>
<p>Ink supply is not stable.</p>	<p>The quantity of ink is clearly uneven.</p>	<p>The scraping blade is not even.</p>	<ol style="list-style-type: none"> <li>1. Clean the blade</li> <li>2. Check if there is damage and have it repaired.</li> <li>3. Tighten the fastening bolts from middle to side, replacing the missing ones.</li> <li>4. Ensure that the blade is not too long.</li> </ol>
		<p>The blades are not even.</p>	<ol style="list-style-type: none"> <li>1. Ensure that the middle line of the blade is in line with that of the anilox roller.</li> <li>2. Ensure that the upper and the lower blades contact the anilox roller simultaneously.</li> </ol>

		<p>The printing plate is worn.</p>	<ol style="list-style-type: none"> <li>1. Use a proper method to make the plate.</li> <li>2. Use elastic two-sided tape to avoid big or dry friction.</li> </ol>
		<p>Affected by the solvent of the ink.</p>	<ol style="list-style-type: none"> <li>1. The printing plate should be cleaned thoroughly so as to avoid ink remained on the plate.</li> <li>2. Change the solvent to avoid the solvent in the ink dissolved with and expanding the plate.</li> </ol>
		<p>The surface of the material to be printed is rough.</p>	<p>Replace the material.</p>
		<p>There is too much pressure.</p>	<p>Control the pressure reasonably.</p>

<b>Trouble</b>	<b>Phenomenon</b>	<b>Cause</b>	<b>Solution</b>
There is impurities and remaining ink in the hole of the anilox roller.	Use a high-powered amplifier to see if there are impurities in the hole.	The dirt on the surface of the material to be printed enters the hole.	Try to ensure the trademark band

		<p>There is no regular check or thorough cleaning.</p>	<p>The cleaning should be thorough and check with a high-powered amplifier.</p> <p>1. Clean the anilox roller when the ink on its surface is damp.</p> <p>Generally, use a special chemical detergent to soften and dissolve the ink in the hole.</p> <p>Methods: put the anilox roller in the detergent for some time before brushing it evenly with a special brush on the surface.</p> <p>2. Clean the anilox roller regularly,</p>
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especially the ink dried in the hole.

There is damage to the anilox roller.	There is crack on the wall of the ceramic roller so that the color of the surface is not even.	There is too much pressure on the blade.	Find the cause and solve the problem.
		The contact area is too big.	Check the angle of the ink blade.
		The blade is too hard.	Change for a suitable blade.
<b>Trouble</b>	<b>Phenomenon</b>	<b>Cause</b>	<b>Solution</b>
The printing plate is not durable.	When used for a short time, there is crack on the surface of the plate.	The remaining ink is not cleared thoroughly.	Use natural soft hair brush and detergent to clear away the remaining ink on the flexographic plate and store it when dried.
		There is big difference in storage temperature so that the hardness and elasticity of plate is affected.	The storage temperature and humidity should be constant, the difference should not exceed 5 °C , and the temperature is preferably 15~30 °C.

		The storage is near the heating source.	Move it from the heating source for storage.
		Affected by the ultraviolet ray in the sunlight.	The margin should be sealed to avoid direct sunlight; the plate should be placed horizontally.
The printed material is not clear.	Some of the image on the printing plate fails to be printed onto the material to be printed. (blurred image)	The printing pressure is too small.	Readjust the pressure.
		There is vibration caused by the plate cylinder.	Check the coaxality of the frame roller.
		The ink dries too fast.	Reduce the drying power or the ink drying speed.
		There is foreign matter on the printing plate.	Clear away the foreign matter.

## Detailed electric list (only for areas with 220V 50Hz)

Model	Name	Specification	Qty	No.
DV-900	Freq. Converter	1.5KW 220V	1	DV-900
	Heating plate	2KW 220V	2	Q
	Temperature-controlled adjuster	0-300℃	2	TE1 TE2
G18-3A10NA	Photoelectric switch		1	
HM12-2010A	Approaching switch		1	JE



WH118-1	Potentiometer	4.7K	1	
N482A	Counter		1	JQ
JTX-3Z	Relay	10A coil voltage DC12V	1	KM1
JTX-3Z	Relay	10A coil voltage DC12V	1	KM2
	Fluorescent lamp	220V 20W	1	HL1
AD-16-16	Indicator	220V	2	HL2 HL3
DZ47-20/2P	Air-break switch	20A	1	QF
RT23-16	Fuse seat		3	FU2 FU3 F4
	Fuse	16A	2	FU2 FU3
	Fuse	3A	1	FU4
LYA16-11M	Stop button		1	SB1 (red)
LYA16-A10	Start button		1	SB2 (green)
LYA16-A11	Inch button		1	SB3 (Yellow)
LYA16-D10	Counter switch		1	SB4
LYA16-D10	Lighting switch		1	SB5
LYA16-D10	Heating switch		2	SB6 SB7
	Motor	1.5KW	1	M1
JX5-10005	Connector socket	10A		XT