

# **KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD.**



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**NAME: KXV-SC02 Fully Automatic Varnish impregnation machine**



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## I.Human-Machine Interface Operation Guide

### 1. Initial Screen

After a delay, the main interface will automatically appear. Press the reset button on the screen to reset.



1.1. During the product replacement and debugging process, when adjusting the liquid immersion depth, you can operate in manual mode and use the oil tank to ascend and descend. The position data of the oil tank can be viewed on the main page and entered into the parameter settings. This step is an indispensable operation during the machine setup process.

## 2.Parameter Settings

2.1 On the initial screen, click to enter the system and you will be directed to the following interface.



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2.2 On this interface, click on the parameter settings, and it will automatically enter the parameter settings interface.

## 2.3 Parameter Settings:

One-time Vacuum (seconds): The time for vacuuming when the machine is first turned on

Defoaming Time (seconds): The time for venting when controlling the foam of the product

Defoaming Interval (seconds): The pause interval for venting when controlling the foam of the product

Defoaming Times (times): The number of times for repeated defoaming and the interval between each defoaming

Immersion time (seconds): The time the product is immersed in a vacuum environment

Inflation and extraction time (seconds): The time for replenishing vacuum during the immersion process

Secondary vacuum (seconds): The vacuum time when the product dries

Drying time (seconds): The time the product dries in a vacuum

Pre-immersion height (mm): Actions will be performed between the pre-immersion height and the immersion oil height

Defoaming action (when approaching the product): The defoaming action can be performed when approaching the product, thereby reducing the formation of bubbles when removing the product.

Immersion oil height (mm): The height position where the product needs to be immersed

Inflation and extraction interval (times): The intervals for exhausting air and replenishing during the immersion process

Extraction time during immersion (seconds): The time for exhausting air during the immersion process, allowing the insulating paint to penetrate deeper into the product.

2.4 The parameters set here can be directly exited and automatically saved. The top of the parameters can be set with the parameter number, and it can be named as the current parameter number.

## 3. Formula Management

3.1 When formula management is required, press F1. The last two digits of the formula will light up, and numerical values ranging from 0 to 25 can be input for formula storage. Up to 26 formulas can be stored.

## 4. Manual Operation

4.1 The received operation interface is as follows:

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4.2 When the oil tank is not at position 0, the automatic operation cannot be initiated. It is necessary to switch to manual mode and trigger the reset to the origin. The automatic operation can only commence when the upper oil tank position reaches position 0.

## 5. Automatic Operation

5.1 The interface of the automatic operation sequence is as follows:



5.2 When during automatic operation, if the rising value is too large and the motor reaches the upper limit of 100, then the next sequence of the automatic operation will be initiated, and the normal operation will proceed normally. If you need to stop, simply press the stop

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button to reset.

5.3 After switching to the automatic interface, press the start button, and the start process begins. The automatic screen displays the current action flow and the current running step.

5.4 During the automatic process, the current formula number, formula name, the set position of the motor and the current position, as well as the set time for each step and the current timing are displayed. The name of the current step being executed will also flash. If you want to skip a certain step, you can set the time of that step to 0.

After the automatic process is completed, the buzzer will alarm, and the left upper window will display the end information of the process. The buzzer will automatically turn off after the buzzer time is reached.

5.5 In any case, if the stop button is pressed, the current operation will be terminated, and all actions will be reset. After adjustment, you can continue to start the operation.

## II. Basic Operating Procedure

1. Connect the three-phase main power supply, turn on the panel power switch, open the intake valve, automatically activate the immersion machine cover, and manually insert the immersion materials.

Start the equipment, close the cover of the immersion tank, shut off the intake valve, and open the exhaust valve. Set the required parameters within the control interface.

If you need to observe the specific condition of the cylinder body, you can do so through the viewing window.

4.The machine operates automatically according to the preset program and cannot be manually controlled. If manual operation is required, please stop the automatic operation first.

5. Automatic operation program: Place the product - Close the lid - Vacuum - Raise the pre-impregnation height of the motor - Defoaming time - Defoaming interval - Number of immersion - Raise the immersion height of the motor - Immersion time - Drain time - Drain interval - Exhaust - Vacuum 2 - Drying - Exhaust 2 - Completion (Alarm) - Open the lid and remove the product. (This is the basic process of the immersion operation.)

## III. Main adjustment functions

1. When powered on, the vacuum timer on the touch screen panel can set the vacuum time. Generally, setting it to 120 seconds can meet the usage requirements.

2. The immersion time can be set on the touch screen, depending on the actual usage situation.

3.The duration of vacuuming and immersion should be determined based on the volume of the product and the requirements (for example, if the product has strict requirements for immersion quality, increase the vacuuming time, enhance the vacuum degree, and extend the immersion time).

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4. The speed of the motor's ascent and descent can be preset on the touch screen.
5. After setting the parameters, simply save them for future use.

## Packaging

Packaging Material: Carton/Wooden case with foam inside.

1. General package(Paper carton or plastic bag): For small equipped parts for Digital CNC Wire Coil Winding Machine, Package it with form and pack paper to guarantee unbroken during the transport.
2. Wooden case package: For larger scale Digital CNC Wire Coil Winding Machine, we have special skilled carpenter, who would make the proper wooden case with exact thickness, density, length. The up arrow ↑ marked on the outer wooden case. Buffer material would be put in the wooden case to prevent crack and shock.



## FACTORY:

Founded in 1993, KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD. has established itself as a well-known manufacturer specializing in high-performance winding machines, along with supporting production equipment, auxiliary technologies, and professional services. A standout in its comprehensive product range is the KXV-SC02 Fully Automatic Varnish Impregnation Machine—an advanced automated solution designed for precise, efficient varnish impregnation of wound components, enhancing their insulation, durability,

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and performance through fully automated processes that ensure consistent quality.

Beyond manufacturing core winding machines and integrating advanced auxiliary equipment like the KXV-SC02 Fully Automatic Varnish Impregnation Machine, KIOXIA LIGHT RING provides highly cost-effective comprehensive manufacturing solutions. These solutions cover the entire production cycle of various wound components, including transformers, chokes, and more, delivering end-to-end support for efficient, high-quality processing across diverse manufacturing needs.



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