SHD-E-EC

Hopper Dryer

Date: Jun., 2023

Version: Ver. C

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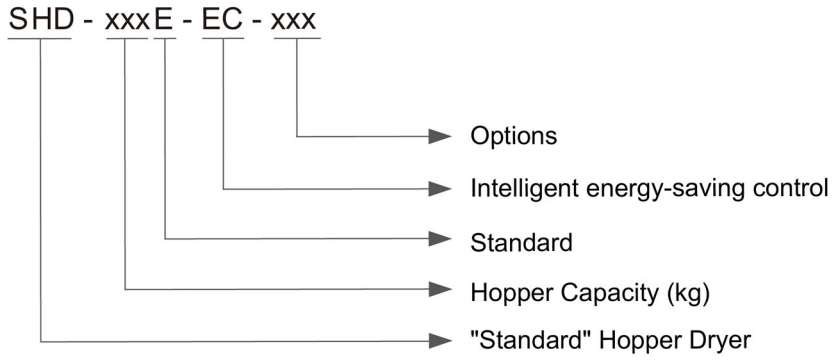
1. General Description

Please read through this operation manual before using the machine to prevent damages of the machine or personal injuries.

Picture 1-1: Hopper DryerSHD-50E-EC

1.1 Coding Principle



1.2 Feature

1) Adopt hot air diffuser to keep plastics dry and temperature stable, thus improving drying efficiency.
2) All material contact surfaces are made of stainless steel to eliminate material contamination.
3) All models are equipped with external power switch.
4) For SHD-25E-EC~150E-EC, heater pipes are connected by lead sheets and other models are equipped with temperature protector to prevent heater pipe from damaging by blower fault.
5) When the actual drying temp. exceeds the set value, the system will cut off the heater power automatically, and the alarm light will flicker and alarm.
6) Adopt heat-insulated blower to prolong blower lifespan.
7) All models standard equipped with 7-day timer and intermittent operation
8) The whole series of models are equipped with the microcomputer control.
9) Max. drying temperature is 160℃.
10) The series of blowers are equipped with overheat protector.
11) This machine can adjust the drying airflow and temperature automatically based on actual material consumption to achieve energy-saving and excessive drying prevention purpose. According to different material types and outputs, it can save up to 30％~80％ energy consumption.

1.3 Options

1) For high temp. (180℃) models, add “H” at the end of the model code (Applicable toSHD-12E-EC~200E-EC)

2) The option of magnetic base is available, add “M” at the end of the model code.
3) The option of insulated hopper is available, add “I” at the end of the model code.

All service work should be carried out by a person with technical training or corresponding professional experience. The manual contains instructions for both handling and servicing. Chapter 5, which contains service instructions intended for service engineers. Other chapters contain instructions for the daily operator.

Any modifications of the machine must be approved by SHINI in order to avoid personal injury and damage to machine. We shall not be liable for any damage caused by unauthorized change of the machine.

Our company provides excellent after-sales service. Should you have any problem during using the machine, please contact the company or the local vendor.

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Table 1-1：Dryer drying capacity（kg/hr）(Selection guide)

Model / Material	SHD-12E	SHD-25E	SHD-50E	SHD-75E	SHD-100E	SHD-150E	SHD-200E	SHD-300E	SHD-400E	Actual Drying Time	Drying Temp.
Polystyre	8	20	50	75	100	150	200	300	400	0.75hrs	80℃
Polyethylen	8	20	50	75	100	150	200	300	400	0.75hrs	80℃
Poly propyrene	8	20	50	75	100	150	200	300	400	0.75hrs	80℃
Poly styrence (EPR)	6	14	38	57	80	115	150	225	300	1hrs	80℃
ABS	4	8	20	30	40	60	80	120	160	1hrs	80℃
Nylon (Nylon)11,12	2	4	10	13	20	27	35	60	80	4hrs	75℃
(Nylon)6/6,6/10	1.5	3.2	8	11	16	22	30	45	65	5hrs	75℃
(Nylon) 6	1	2	5	7	10	15	20	35	50	7hrs	75℃
Acrylic fiber	2.5	6	12	22	30	45	60	100	140	2.5hrs	80℃
Cellulose acetate	2.5	6	17	26	35	52	70	110	150	2.25hrs	75℃
Butyrate	4	10	25	37	50	75	100	160	220	1.5hrs	-
Polycarbonate	1.5	4	10	15	20	30	40	75	90	3hrs	120℃
Rigid PVC	5	12	30	45	60	90	120	185	250	1.25hrs	70℃

Notes:Based on relative humidity 65% with ambient temperature of 20℃,moisture content after drying can be 0.2% ro less.

1.4 Safety Regulations

Note:

Electrical installation should be done by qualified electrician only.

Before connecting to AC Power Source, turn power switch to OFF position. While AC power source is connected, make sure specifications and overload protection rating of the power switch are suitable and reliable. When the machine is under care or maintenance, turn off both power switch and automatic operation switch.

1.4.1 Safety Signs and Labels

Danger!

High pressure!

It is attached to the control box.


Warning!

High temperature surface may burn hands!

It is attached on the cover of pipe heater.


Attention!

This mark reminds you to be more careful!


Warning!

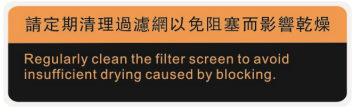
High temperature surface may burn hands!

This label should be stick to the shell of electric heating box.

1.4.2 Sign and Labels

Table 1-1: Label Description

Label	Description
	Push-and-pull switch for shut-off plate: I: Means "Pull" O: Means "Push"

	Regularly clean the filter screen to avoid insufficient drying caused by blocking.

1.5 Exemption Clause

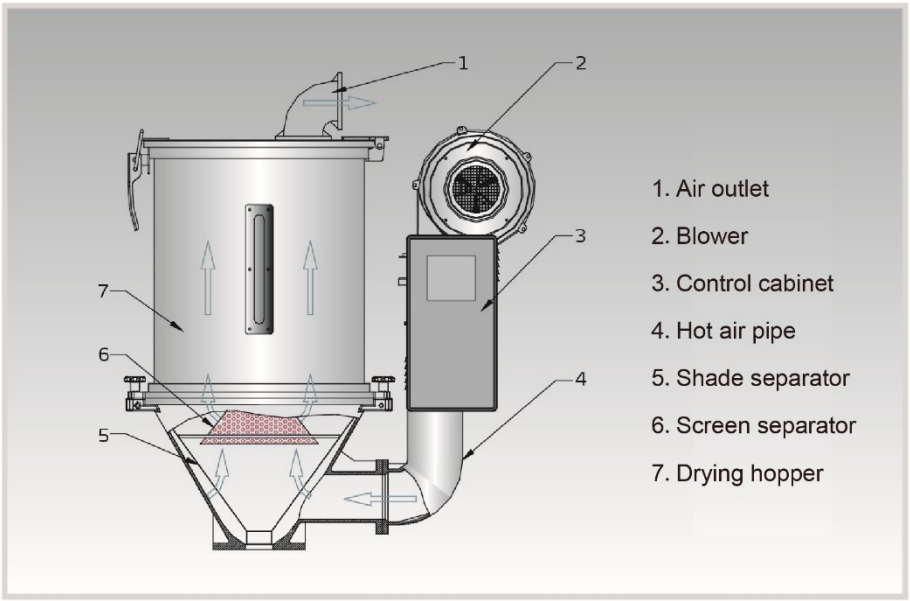
The following statements clarify the responsibilities and regulations born by any buyer or user who purchases products and accessories from Shini (including employees and agents).

Shini is exempted from liability for any costs, fees, claims and losses caused by reasons below:

1) Any careless or man-made installations, operation and maintenances upon machines without referring to the Manual prior to machine using.
2) Any incidents beyond human reasonable controls, which include man-made vicious or deliberatedamages or abnormal power, and machine faults caused by irresistible natural disastersincluding fire, flood, storm and earthquake.
3) Any operational actions that are not authorized by Shini upon machine, including adding or replacing accessories, dismantling, delivering or repairing.
4) Employing consumables or oil media that are not appointed by Shini.

2. Structure Characteristics and Working Principle

2.1 Working Principle



Picture 2-1 Working principle

In the drying process, the hopper dryer adjusts the blower frequency (2) according to the exhaust air temperature.The high-temperature air is blown into the drying hopper (7) through the hot air pipe (4), and evenly dispersed to the materials inside the drying hopper via the shade separator(5) and screen separator(6) to take away the moisture of materials in the hopper through the air outlet pipe (1), thus achieving the moistureremoval purpose.

3. Installation and Debugging

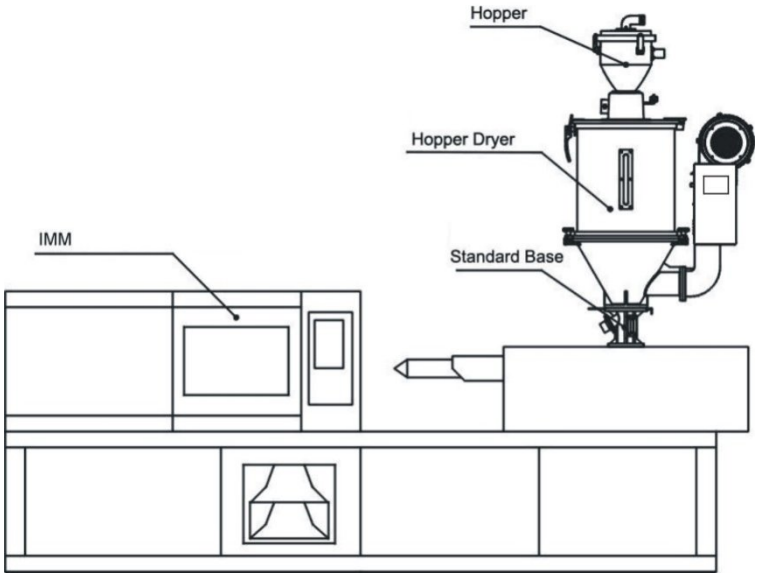
Notes for Installation and Positioning:

1) Machine just can be mounted in vertical position. Make sure there's no pipe, fixed structure or other objects above the installing location and around the machine which may block machine's installation, hit objects or injure human person.

2) In order to maintain convenient operation, it's suggested to keep 1m space around the machine. Please keep at least 2m distance between the device and the inflammable goods.

3) This series of models only could be applied in working environment with good ventilation.

3.1 Direct Installation



Picture 3-1：Direct Installation

Direct installation type is to mount the hopper dryer directly on the injection molding machine via a standard base.

When using the method to mount the dryer, the equipped standard base must according to material inlet diameter of the molding machine mounting drill holes. Then use the screw to fasten the base and the molding machine inlet.

3.2 Power Connection

1) Make sure the voltage and frequency of the power source comply withthose indicated on the manufacturer nameplate that attached to the machine.
2) Power cable and earth connection should conform to your local regulations.
3) Use independent electrical wires and power switch. Diameter of electrical wire should not be less than those used in the control box.
4) The power cable connection terminals should be tightened securely.
5) This series power adopts three phase five wire, the power (L1,L2,L3) is connected to the firing line, N is connected to the zero wire, and PE is connected to the earth wire.
6) Power supply requirements:
   Main power voltage: +/- 5%
   Main power frequency: +/- 2%
7) Please refer to the circuit diagram of each model for specific power accessspecifications.

Note: Keep 2mdistance between the machine and flammable materials.

Note: Before connecting the power, turn the main power switchto"OFF" state, and the heater switch on dryer's control box to "OFF" state.

3.3 The Hopper Dryer Test

After ensuring all the circuits have been connected firmly, turn on the main switch to"ON" status, and observe whether the rotating direction of the blower is same as the arrow indicated direction. If it is not, randomly exchange two of the three power firing lines and connect them firmly.

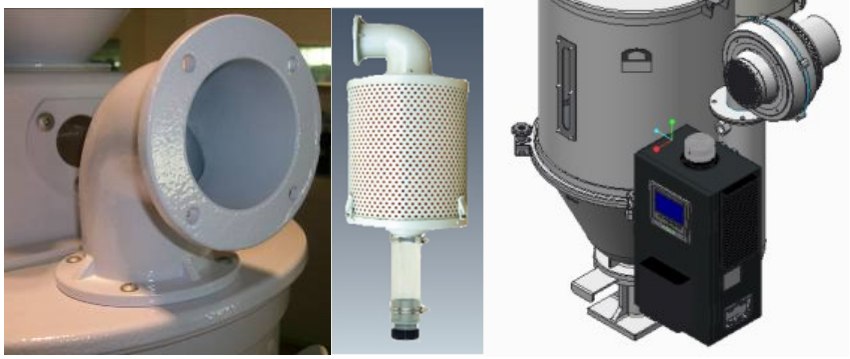
Picture 3-1: Blower

3.4 Options and Installation（purchased separately）

3.4.1 Installing the air-exhaust filter ADC

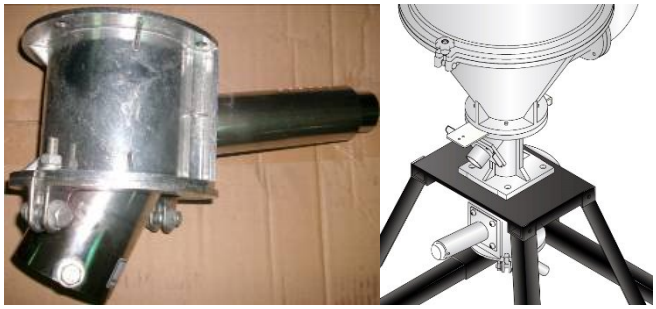
If the materials contain dust or to avoid the dust-contain air exhausted by dryer polluting the workshop's environment. Option with air-exhaust filter ADC can filter the exhausted air from the dryer. ADC can reach filter efficiency of 99%.

ADC is installed on air-exhaust elbow of the dryer. Point it to the installed holes then tighten up the screws, use rubber ring to seal the combined place.



Picture 3-2: Left：Air-exhaust elbow of dryer Middle: Air-exhaust filter ADC

3.4.2 Suction Box SBU Installation



Picture 3-3: Suction Box SBU

When SHD-Eis mounted on the floor stand, suction box should be equipped, so as to convey the dried plastic material conveniently. The installation of European

suction box and shut-off suction box is simple. Install them at bottom of the hopper, point to the holes and tighten up the screws.

Picture 3-4:Shut-off Suction BoxSBU

3.4.3 Blower Inlet Filter AIF Installation

When dryers in the dust-contain environment or hot air requires high cleanliness, it can option with AIF blower inlet filter.

Picture 3-5: Blower Inlet FilterAIF（Middle）

Installing AIF at blower inlet port when installing it, firstly loosen screws of the blower inlet screen, take down the screen; Then install the AIF at blower inlet port, point to the holes and tighten up the screws.

3.4.4 Hot Air Recycler HAR Installation

Install the HAR at the blower inlet, loosen the fixing screw of blower’s inlet air screen and remove the air screen. Install the HAR at the blower’s inlet, and tighten

the corresponding screws. With the hot air recycler, it can save up to 40% energy consumption.

Picture 3-6: Hot Air RecyclerHAR

3.4.5 N-type floor stand FSN Installation

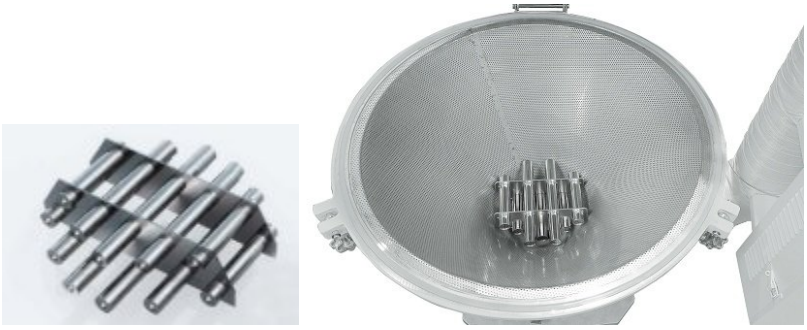
It helps to move the main body of the drying hopper out of the injection moulding workshop and is suitable for height limited plant. The floor stand is easy to move and able to work with any machine. Drill the installation holes on the base, and install the dryer on the floor stand.

Picture 3-7: N-type Floor Stand FSN

3.4.6 Hopper Magnet MR Installation

It is used to adsorb iron impuritiesin the materialsto prevent them from entering the screw and avoid screw damage.

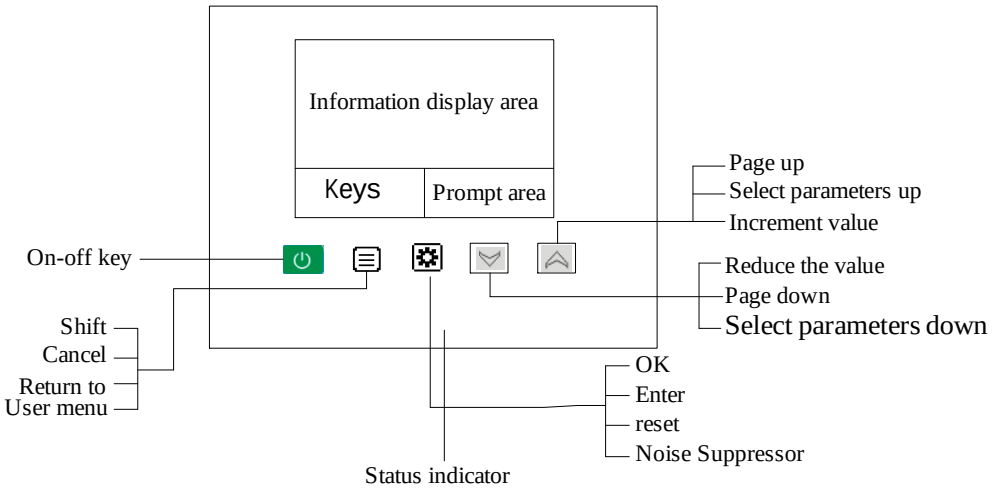
Open the drying hopper lid and place the hopper magnet inside.



Picture 3-8: Hopper MagnetMR

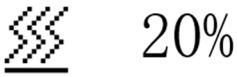
4. Operation Guide

4.1 Control Panel



Picture 4-1：Control Panel

Table4-1：Control Panel

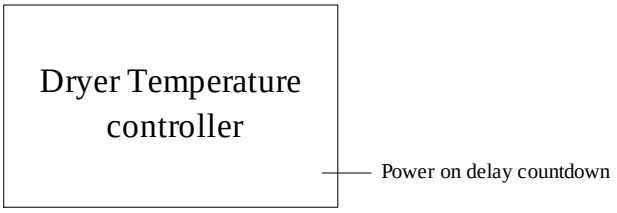
ICONS	Name	Use
	Heating ICONS	Represents the percentage of the current electric heating operating power, with a maximum value of "100" and a minimum value of "0". The current value is 20%, indicating that the power of the electric heating operation is 20% of the maximum power
	Fan Running icon	Represents the percentage ofcurrent blower operating power, with a maximum of "100" and a minimum of "0". If it shows 10%, it means the blower's operating power is 10% of the maximum power.
	Lock icon	Lit: Set temperature lock, cannot be modified under the main screen Off: Set temperature lock, can be quickly modified in the main screen

	Appointment timing icon	On: The reservation timing function is enabled Off: The reservation timing function is disabled
ECO	Heat Preservation Mode icon	Lit: The unit is in Heat preservation mode Off: The unit is not in Heat preservation mode
AT	Self-setting icon	Lit: PID parameter self-tuning is on Off: PID parameter self-tuning is off
	Status indicator	Steady yellow: Stop/In stopping Steady green: In operation Flickering red: Fault alarm
	On/Off button	On/off button
	Menu button	Enter the user menu
	Set button	Set key
	Up button	Add value, select parameter up
	Down button	Reduce the value and select the parameter down

4.2 Common Interface

4.2.1 Startup delay screen

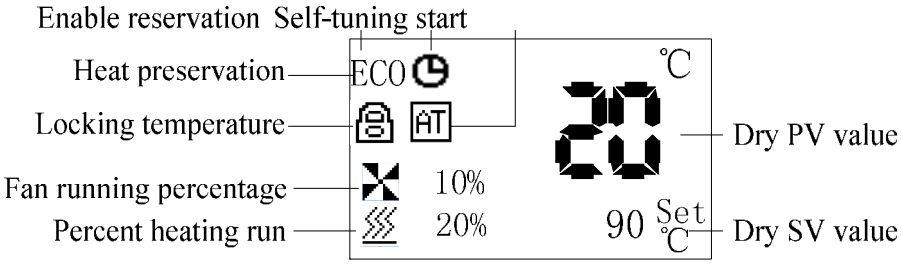
When the device is powered on, the system has a 7-second delay. After the countdown is over, the system automatically enters the "home screen".



Picture 4-2: Startup delay screen

4.2.2 Home screen

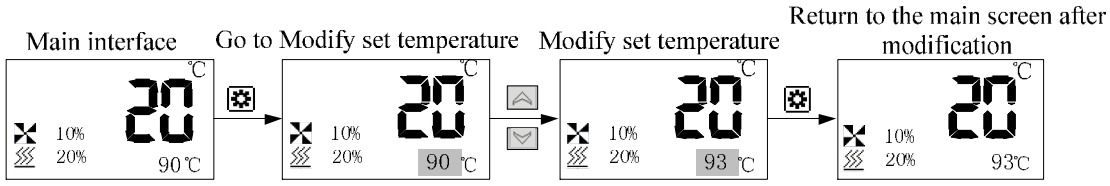
All startupsare performed on the "Main operation interface". The corresponding icon indicates the relevant status. If the drying temperature now is 20 ° C and the drying temperature is set to 90 ° C (During operation, the blower and heating are on, the timing function is enabled, and the temperature lock is enabled), the "main operation interface" will be displayed as follows:



Picture 4-1: Home screen

4.2.2.1 Quickly modify the set temperature under the main interface

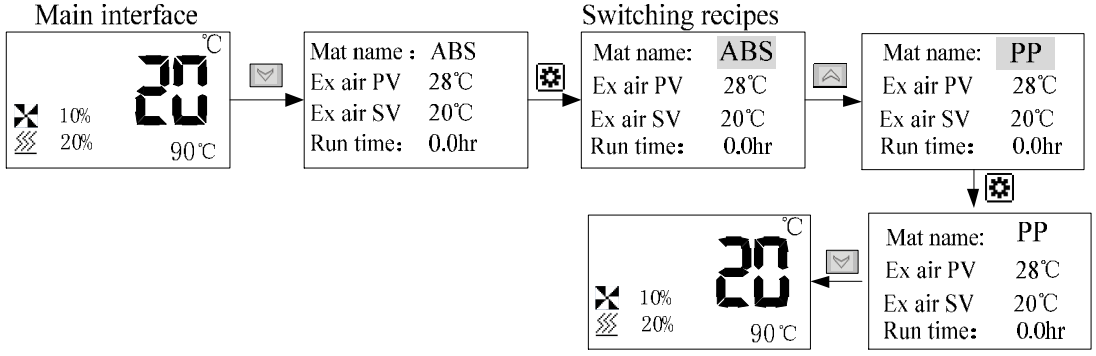
If the user parameter [lock temperature] is set to "no", the set temperature can be directly modified under the main interface, the operation is as follows:



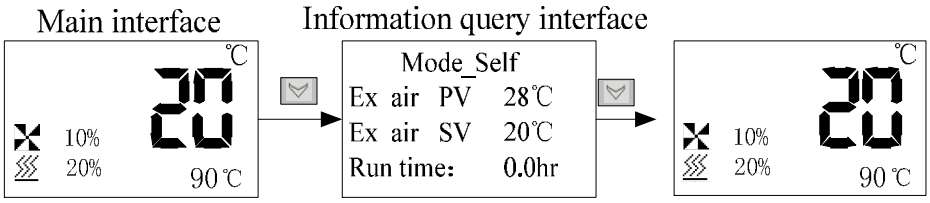
Note: You can also modify the set temperature in the user parameter.

4.2.2.2 Check related information on the main screen

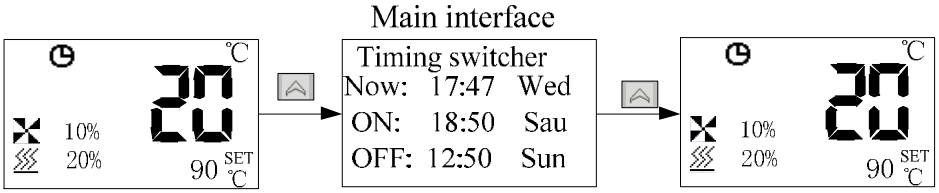
1) The control mode is: Recipe mode:



2) The control mode is: Self-adaption mode:



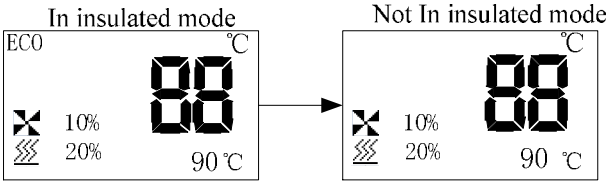
4.2.2.3 The timing time is displayed on the main screen



Note: If there is no timed startup, the time is displayed 00:00.

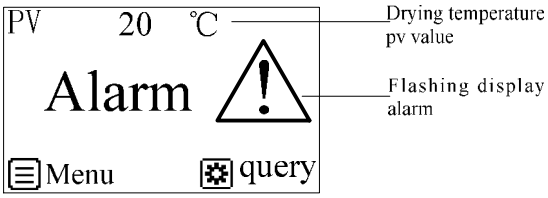
4.2.2.4 ECO Mode/Insulation Mode

After the first start-up and the drying time, when the actual exhaust air temperature > exhaust air set temperature, and the anti-excessive drying time (default 30 minutes) is over, the unit will enter the ECO mode. The actual drying temperature decreases and the temperature is determined by the cooling deviation (default 20 ℃); When the actual exhaust air temperature < exhaust air set temperature, the unit exits the ECO mode. To enter the ECO mode again, it only needs the actual exhaust air temperature > exhaust air set temperature and it lasts the anti-excessive drying time.



4.2.3 Fault screen

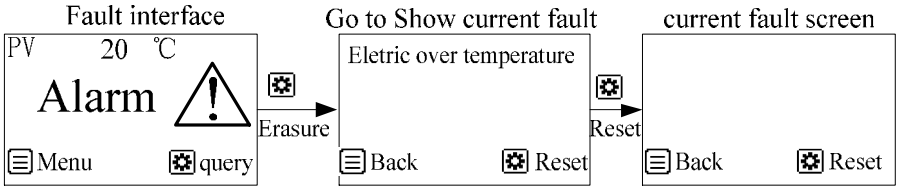
When the unit fails, it will automatically enter the fault interface, and the corresponding fault icon will be displayed. If the current drying temperature PV value is 20.0℃, the fault interface will be displayed as follows:



Picture 4-3: Fault screen

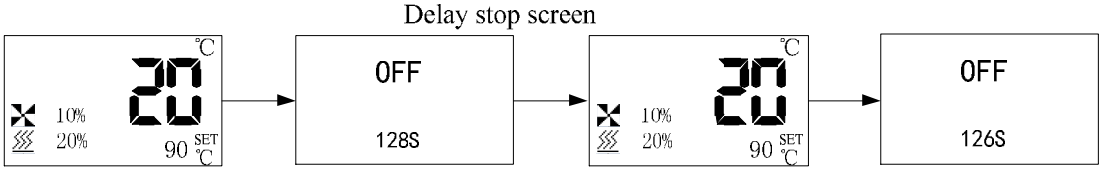
4.2.3.1 Fault query/reset interface

When the fault occurs, the alarm interface will automatically pop up. The fault query and reset operation are as follows:



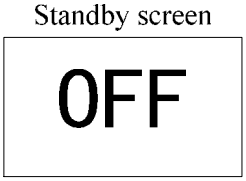
4.2.4 Delayed shutdown and standby interface

4.2.4.1 Delay stop interface



Note: In the case of delayed shutdown, the main interface and the delayed shutdown interface are alternately displayed every 2 seconds until the shutdown countdown is over.

4.2.4.2 Standby interface



Picture 4-4: Standby interface

Note: Enter the standby interface after the delayed shutdown ends.

4.3 User Menu

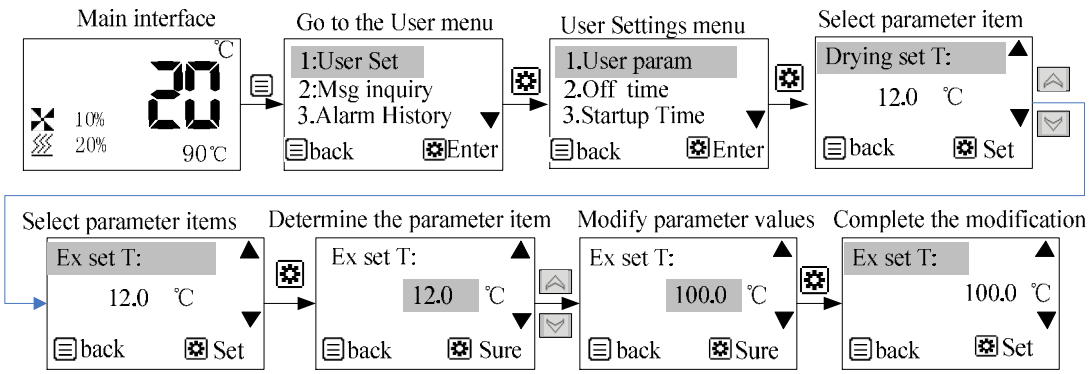
Press <Menu> key in the main interface to enter the user menu, the user menu parameters are as follows:

Table4-2: User Menu Parameter Table

Serial No.	Parameter Items	Parameter Function	Remarks
1	User settings	Set user parameters Set the shutdown time Set the boot time Communication settings Recipe settings	User Settings in the relevant parameter Settings, see the User Settings parameter table
2	Information inquiry	Check the PV value of the drying temperature Check information such as the PV value of the return air temperature	
3	Historical fault	You can query all faults that have occurred in the last 10 times	Press the <Set> key for 2s to clear the history of failures.
4	Time settings	Set the current time to include year/month/day/hour/minute/second/week	
5	Version information	Inquire about the software version currently in use	

4.4 User Parameter Operations

To modify the parameter, modify the exhaust air setting temperature in the user Settings in the user menu as an example.Refer to the user parameter setting table for the parameternumber and meaning in the user menu. The specific configuration method is as follows.



4.5 Parameter Table

4.5.1 User Parameter Setting Table

Table4-3: User Parameter Setting Table

Serial No.	Items	Initial Value	Set Range	Units	Remarks
User parameters (public) : On the home screen, press the "Menu" key to enter the menu. Select User Settings in the menu bar and press the "Set" key to access. Select User parameters and press the "Set" key to enter. Press the "Up" or "Down" button to pollor modify the parameters, and press the "Set" button to modify or confirm, and press the "Menu" button to exit.					
1	Drying time	120	1-999	Mins.	
2	Set drying temperature	90	0.0 ~ 200.0	℃	
3	Set exhaust air temperature	60	0.0 ~ 200.0	℃	
4	Timing function	Disable	Disable/use		Disable: The reservation timing function is disabled. Enable: The reservation timing function is enabled.

5	Lock the temperature	no	Yes/No		No: The setting temperature can be quickly modified from the home screen. Yes: The set temperature can't be quickly modified on the home screen.
6	Self-tuning	Disabled	Disable/use		This parameter is displayed only when the machine is running
7	Multiple languages	Chinese	Chinese /English		
8	Control mode	Recipe Mode	Recipe mode/Adapt ive mode		
Shutdown time parameters (public) : On the home screen, press the "Menu" key to enter the menu. Select User Settings in the menu bar and press the "Set" key to access. Select the shutdown time and press the "Set" key to enter. Press the "Up" or "Down" to poll or modify parameters, press the "Set" button to modify or confirm the setting, and press the "Menu" button to exit.					
1	Monday shutdown time:	00:00	00:00 to 23:59		(1) The time is set to 00:00, and the timed shutdown function is disabled.
2	Tuesday shutdown time:	00:00	00:00 to 23:59		
3	Wednesday shutdown time:	00:00	00:00 to 23:59		
4	Thursday shutdown time:	00:00	00:00 to 23:59		
5	Friday shutdown time:	00:00	00:00 to 23:59		

6	Saturday shutdown time:	00:00	00:00 to 23:59		
7	Sunday shutdown time:	00:00	00:00 to 23:59		
Boot time parameters (public) : Press the "Menu" key from the home screen to enter the menu. Select User Settings in the menu bar and press the "Set" key to access. Select the boot time and press the "Set" key to enter. Press the "Up" or "Down" button to poll or modify parameters, press the "Set" button to modify or confirm, and press the "Menu" button to exit.					
1	Monday start time:	00:00	00:00 to 23:59		(1) The time is set to 00:00, and the timed power-on function is disabled.
2	Tuesday boot time:	00:00	00:00 to 23:59		
3	Wednesday boot time:	00:00	00:00 to 23:59		
4	Thursday boot time:	00:00	00:00 to 23:59		
5	Friday boot time:	00:00	00:00 to 23:59		
6	Saturday boot time:	00:00	00:00 to 23:59		
7	Sunday boot time:	00:00	00:00 to 23:59		
Communication setup parameters (public) : Press the "Menu" key from the main interface to enter the menu. Select User Settings in the menu bar and press the "Set" key to access. Select Communication Settings and press "Set" to enter. Press the "Up" or "Down" button to poll or modify parameters, press the "Set" button to modify or confirm, and press the "Menu" button to exit.					
1	Communication protocol	RTU	RTU		
2	Mailing address	1	1-99		
3	Baud rate	19.2 K.	4.8 K / 9.6 K / 19.2 K		

4	Check bit	No parity	No parity / Odd parity / Even parity		
5	Data length	8	8		
6	Stop bit	1	1 ~ 2		

4.5.2 Recipe list

Table4-4: Recipe List

Groups	Ingredients	Drying time (min)	Drying temperature (℃)	Exhaust air temperature (° C)
1	ABS	180	80	50
2	PP	120	90	45
3	PE	120	90	45
4	PS	120	80	45
5	PPS	240	140	65
6	PVC	120	70	40
7	PBT	240	120	60
8	PC	180	120	60
9	CAB	180	75	45
10	SAN	180	80	50
11	PEI	240	150	70
12	PEN	300	170	85
13	SB	120	80	50
14	PET	360	160	80
15	PETG	360	60	45
16	PI	180	120	60
17	PMMA	180	70	45
18	POM	180	95	50
19	CA	180	75	45
20	PPO	120	110	45
21	LCP	240	150	70
22	CP	180	75	45
23	PSU	240	120	60
24	PUR	180	90	50
25	TPE	180	105	55
26	PEEK	240	150	70

27	PES	240	160	80
28	PA	360	70	45

Note: Under the condition that the moisture content of materials meets the standard, decrease the exhaust air temperature appropriately can improve the energy-saving effect.

4.5.3 Trouble Table

This controller has various alarm functions. When a failure occurs, the alarm interface displays the current fault. The specific fault code meaning is shown in the following Table.

Table4-5: Trouble Table

Faults	Action
Flash error	1. When the alarm occurs, the machine stops running. After troubleshooting, manually reset it. 2. Start detection after powering on, it occurs when the correct data can't be read in the flash.
Probe failure	1. Stop heating, delay stop blower, trip output for 5 secs. After troubleshooting, automatic reset. 2. The test starts as soon as it is powered on.
High temperature	When it alarms, stop heating, trip output 5 seconds, delay to stop the blower. After troubleshooting, manually reset. Start testing as soon as you power it on (1)【PV】-【SV】>【over temperature protection temperature】 and delay 2 seconds alarm. (2) After modifying the set temperature, only after the current temperature passes through the set temperature once, if the conditions in (1) are still met, the alarm will be given.
Probe reverse connection	1. Stop heating, delay stop the blower. After troubleshooting, automatically reset it. 2. The test starts after power-on.
Blower overload	Stop the heat and the blower. Reset manually after dismissing the fault. Start testing as soon as you power it on.

No battery.	The machine continues to run when the alarm is given. After the fault is removed, the machine automatically resets. The alarm is detected only when the reservation timing function is enabled.
Pipe overheat	Stop heating, delay stop blower, trip output 5 seconds. After troubleshooting, manually reset. 2. Start testing immediately after power-on:
Low temperature	1. The machine continues to run when the alarm is given. After troubleshooting, the machine automatically resets. 2. Detection after power on (1) [SV] - [PV] > [low temperature alarm] and delay [low temperature reaction time] alarm. When the temperature rises, automatic reset. If you want to prohibit, set [low temperature reaction time] = 0. (2) Wait until the current temperature passes through the set temperature once before starting to detect.
Heating failure	When it alarms, the machine continues to run and automatically resets after the fault is removed. Detection after starting up (1) After starting up, the temperature within the [heating alarm] time, can't reach the [SV] -5℃ range, and it alarms. If you want to prohibit, set [heating alarm] = 0. (2) After the current temperature passes through the set temperature, the alarm is no longer detected.
Return air probe fault	1. Stop heating and delay stop blower. After troubleshooting, automatically reset. 2. The test starts after power-on.
Return air probe reversely connected.	1. Stop heating and delay stop blower. After troubleshooting, automatically reset. 2. The test starts after power-on.
Inverter communication failure	1. Stop the blower, stop heating. After troubleshooting, manually reset. 2. Start the test as soon as it is powered on.

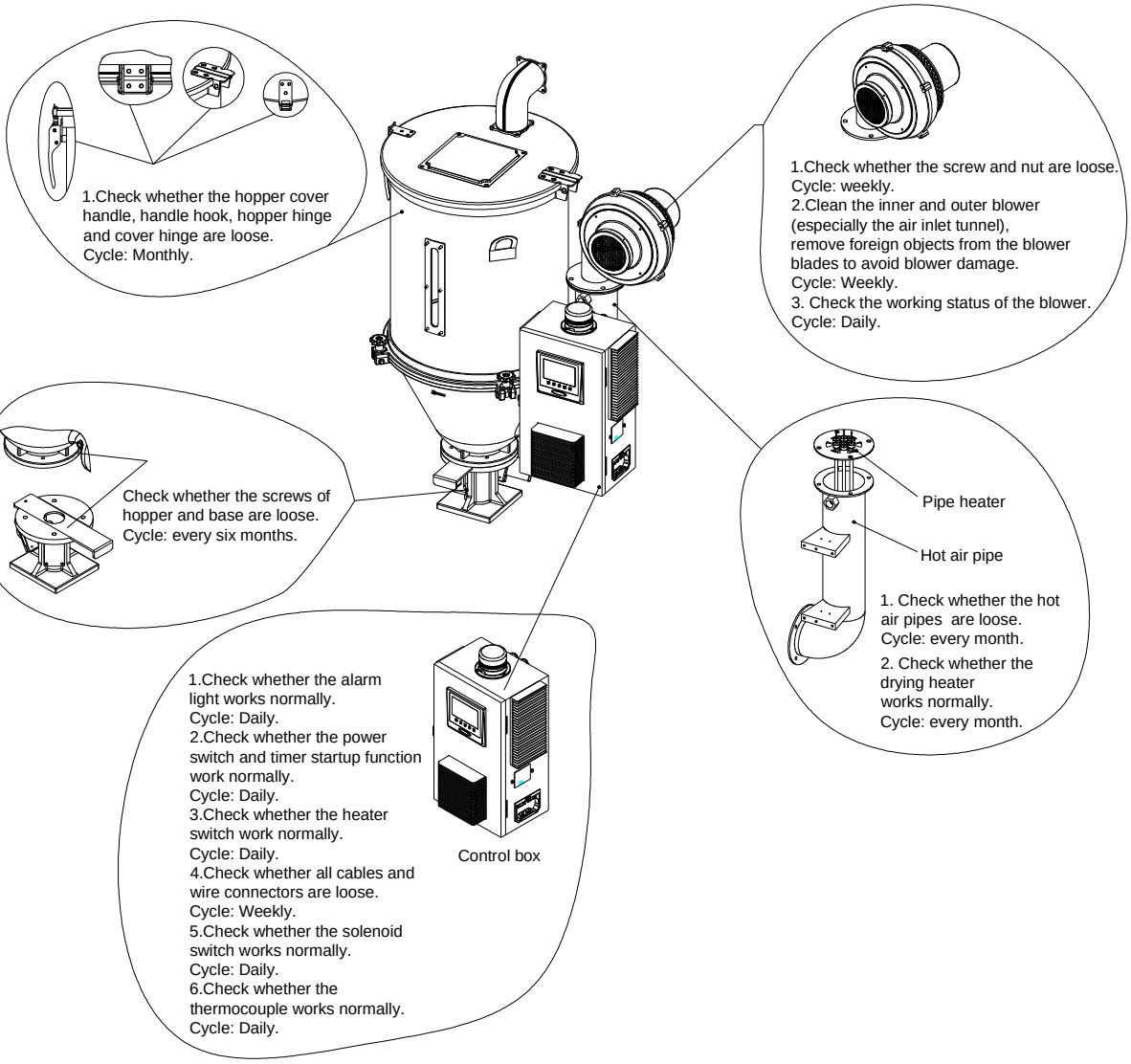
5. Troubleshooting

Table 5-1：Common Faults and Troubleshooting

Fault	Possible Reasons	Solution
Probe failure	1. Thermocouple poor contact. 2. Thermocouple wire broken.	1. Check and connect it closely. 2. Check and replace.
Overheat	1. Temp. control large error or fault of the controller. 2. Blower air inlet blocked. 3. Solid state contactor bonded.	1. Check and replace. 2. Check and clean. 3. Check and replace.
Blower overload	1. Blower fault. 2. Too high ambient temp.	1. Check, clean or replace. 2.Reduce the ambient temp.
Heater overheat	1. Temp. control large error or fault of the controller. 2. Blower air inlet blocked. 3. Solid state contactor bonded.	1. Check and replace. 2. Check and clean. 3. Check, clean or replace.
Low temperature	1. Solid-state contactor short circuit or phase shortage. 2. Temp. control large error or fault of the controller. 3.Electromagnetic contactor short circuit or phase shortage. 4. Pipe heater fault. 5.Lead fuse.	1. Check and replace. 2. Check and replace. 3. Check and replace. 4. Check and replace. 5. Check and replace.
Heating failure	1. Solid-state contactor short circuit or phase shortage. 2. Temp. control large error or fault of the controller. 3.Electromagnetic contactor short circuit or phase shortage. 4. Pipe heater fault. 5.Lead fuse.	1. Check, reset or replace. 2. Check and replace. 3. Check, reset or replace. 4. Check and replace. 5. Check and replace.
Return air probe failure	1. Thermocouple poor contact. 2. Thermocouple wire broken.	1. Check and connect it closely. 2. Check and replace.
Invertercomm. fault	1.Inverter poor contact. 2.Inverterfault.	1. Check and connect it closely. 2. Check and replace.

 Notes: Before inspecting or changing spare parts, make sure the main switch should be off.

6. Maintenance and Repair



6.1 Maintenance Schedule

6.1.1 General Machine Information

Model _____ SN _____ Manufacture date _____

Voltage_____Φ_____V Frequency _____ Hz Power _____ kW

6.1.2 Installation & Inspection

☐Check if the pipe joint is tightly locked by clips or not.

☐Check that the material clearance door is firmly closed.

☐Check that the piping system is correctly connected.

Electrical Installation

☐Voltage _____ V _____ Hz

☐Fuse melt current:1Phase _____A 3Phase _____A

☐Check phase sequence of the power supply.

☐Check the rotating direction of the blower.

6.1.3 Daily Checking

☐ Check the switches of the machine.

☐Check auto-start function of the machine.

6.1.4 Weekly Checking

☐ Check all the electrical cables of the machine.

☐Check if there are loose electrical connections.

6.1.5 Monthly Checking

☐Check that the pipe heater is working properly.

☐Check the performance of blower.

☐Check the functions of electrical components.

6.1.6 Half-yearly Checking

☐Check if there are damages of heat-resistant hose or not.

☐Check the process heater.

☐Check the blower.