



#0662 & #0663

# DIGITAL INCONTROL VACUUM WAX INJECTOR MULTI FUNCTION SYSTEM

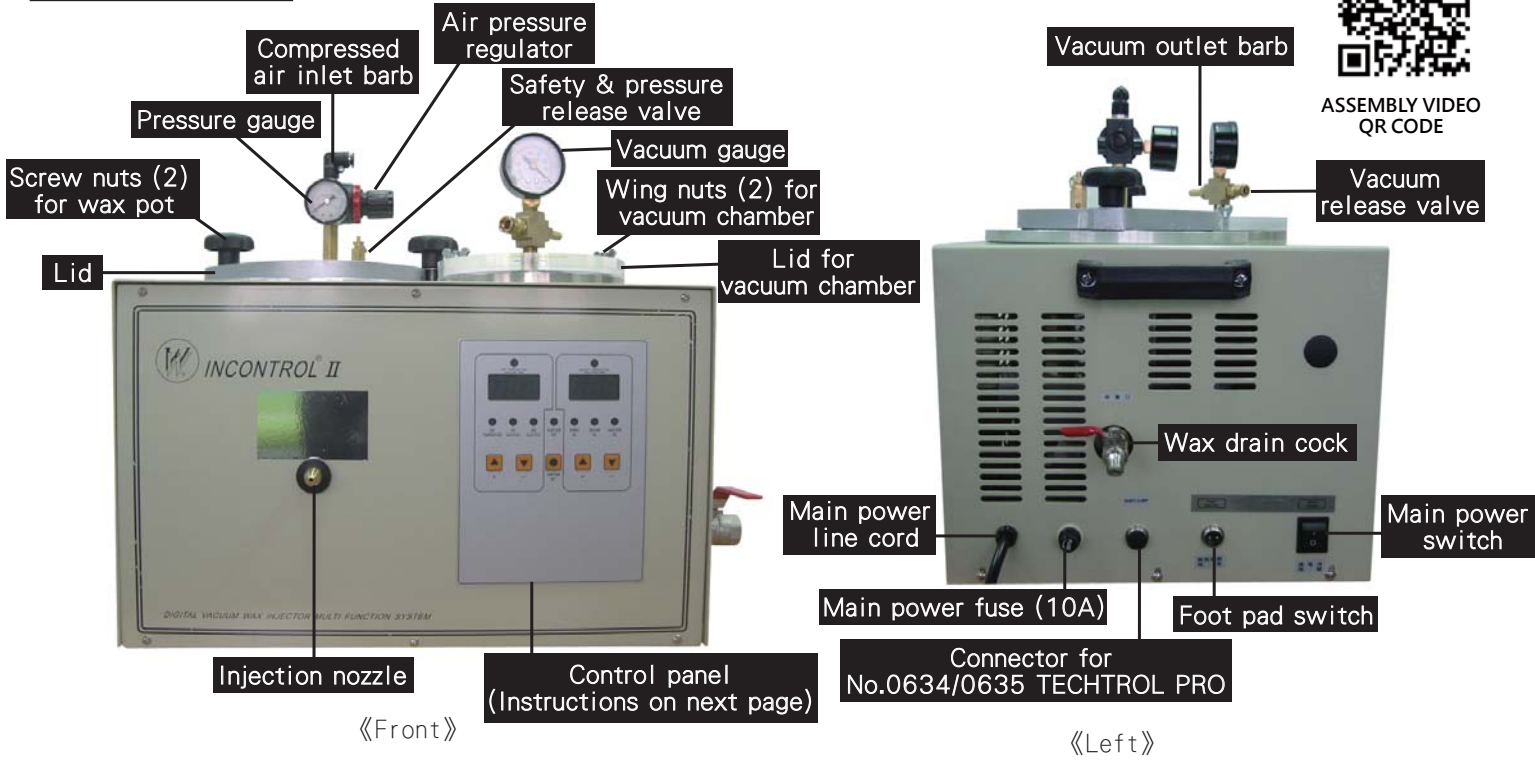


ONLINE SHOP QR CODE



24HR SERVICE QR CODE

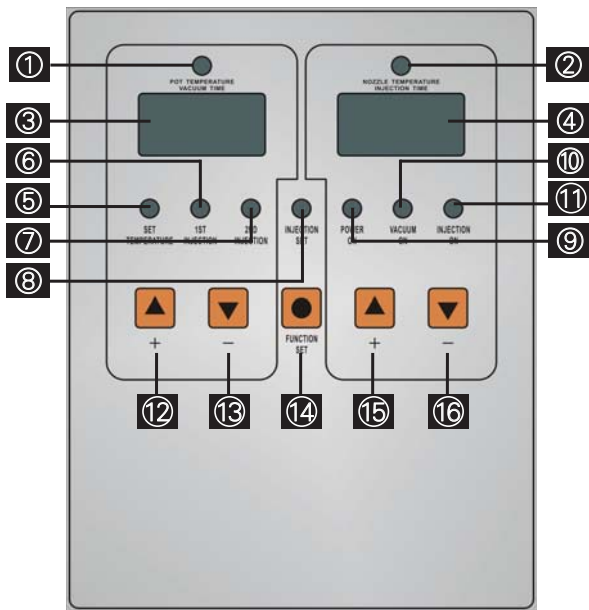
## PARTS NAME



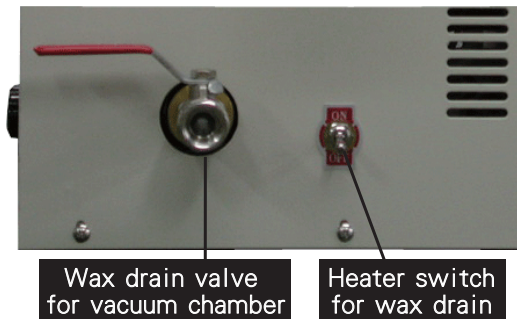
ASSEMBLY VIDEO QR CODE

《Front》

《Left》



《CONTROL PANEL INSTRUCTION》



《Right》

- ① Wax pot heater indicator light
- ② Nozzle heater indicator light
- ③ Wax pot temperature and vacuum time
- ④ Nozzle temperature and injection time
- ⑤ Set temperature indicator light
- ⑥ Single injection time set
- ⑦ Second injection time set
- ⑧ Single or Second injection set light
- ⑨ Power on
- ⑩ Vacuum on
- ⑪ Injection on
- ⑫ Wax pot temperature and vacuum time increasing button
- ⑬ Wax pot temperature and vacuum time decreasing button
- ⑭ Function set button
- ⑮ Nozzle temperature and injection time increasing button
- ⑯ Nozzle temperature and injection time decreasing button

## SPECIFICATIONS

	0662	0663
Power	120V/ 10A	240V/ 5A
Air pressure	30 psi maximum (Air compressor not supplied)	
Vacuum	High vacuum 27 Hg or higher (Vacuum pump order separately)	
Wax capacity	6 lbs (2.7kg)	
Overall	22-1/4" (W) X 14-1/4" (D) X 16-3/8" (H)	
Machine weight	51lbs (23Kgs)	
Shipping weight	57lbs (26Kgs)	

※NOTE: For better performance,  
use No.0465 oil-type vacuum pump for No.0662 injector;  
No.0466 vacuum pump for No.0663 injector.

## ACCESSORIES



A

《No.0660-113B Wax drain filter 1pc.》



B

《No.0660-067S Foot pad switch 1pc.》



C

《No.0660-119 PU hose 2M》

## SET-UP INSTRUCTION :

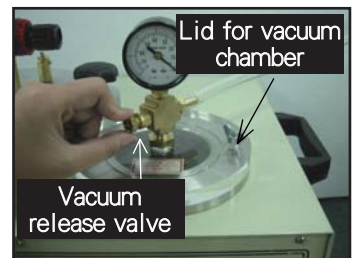
- 1 Place machine on a working bench. Connect foot pad switch to **Foot pad switch** connector. Close **wax drain cock** for the wax pot before wax is heated. Loosen **screw nuts** from lid of wax pot.



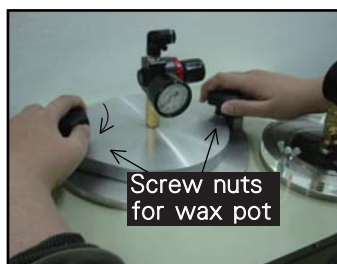
- 2 Open **lid** from wax pot. Unpack wax drain filter (accessory A) from the Wax tank. Insert the wax drain filter into the wax drain hole inside the wax tank. Connect air hose to **compressed air inlet barb**.



- 3 Connect PU hose (accessory C) to **vacuum chamber outlet barb**. (Make sure it is tie fit and no leaking air during vacuum is in processing.) Connect the other end of PU hose to vacuum pump. Close Vacuum chamber wax drain valve and ensure **vacuum chamber heater** switch is in "OFF" position. Check both **lid of vacuum chamber** and **vacuum chamber air release valve** are closed.



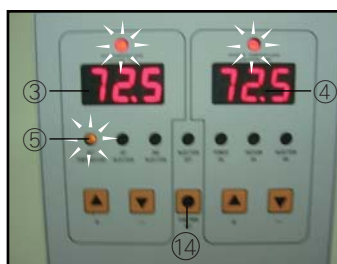
- Make sure **main power switch** in "OFF" position. Fill in waxes to the full line mark inside wax pot. Close the wax pot lid with 2 screw nuts. Plug **Main power line cord** to power source.



※Note:Electrical outlet of power source must be well grounded.

## SET WORKING TEMPERATURE FOR WAX POT AND INJECTION NOZZLE

- Switch power on. ③ indicates wax pot current temperature; ④ indicates nozzle current temperature; ①、②、⑨ lights are on. Press ④ button one time, ⑤ light will on and same time both ③、④ display will show "72.5" (Factory default setup temperature).



- Wax pot temp set by pressing ⑫ button for increasing and ⑬ button for decreasing to your desired set temperature will show on ③ display.
- Nozzle temp set by pressing ⑮ button for increasing and ⑯ button for decreasing to your desired set temperature.
- Stop and wait for 6 seconds the both ③ and ④ will show present temperature and ⑨ lights (power on) will on.



※Note:

- When heating both wax pot and nozzle temp and both ① and ② indicate lights will be on.
- For desired set temperature, please confirm the correct temperature with your wax supplier for best use with WW DIVWI.

## SET VACUUM AND INJECTION TIME

- Pressing ⑭ button TWICE and ⑥ lights will on ③、④ will show 002 (factory default setup time).  
**Set vacuum time:** pressing ⑫ to increase and ⑬ to decrease. Set to your desired vacuum time as shown on ③ display. 003 for 3 seconds, 004 for 4 seconds and up or down.  
**Set injection time:** pressing ⑮ to increase and ⑯ to decrease. Set to your desired injection time as shown on ④ display 004 for 4 seconds, 005 for 5 seconds and up or down.  
 Stop and wait for 6 seconds. The ⑨ light will on and ③、④ will show present temperature of wax pot and injection nozzle.

※Note:

- Both vacuum and injection time can set from 1 second to 990 seconds working time.
- Injection time must be set from one second and up. Do not set at 0 second and the machine will not function.

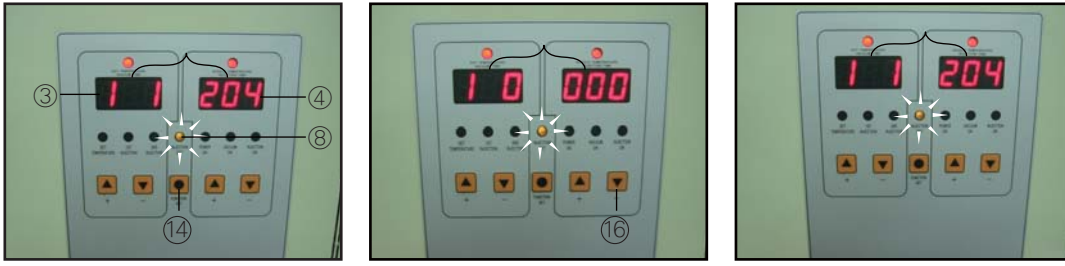


## YOU ARE READY TO WORK!!

- Make sure wax has fully melted and ready to work.
- Increasing air pressure by adjusting the ② air regulator to read ④ vacuum gauge to your desired pressure.

## HOW TO READ DAILY PRODUCTION RATE COUNTER

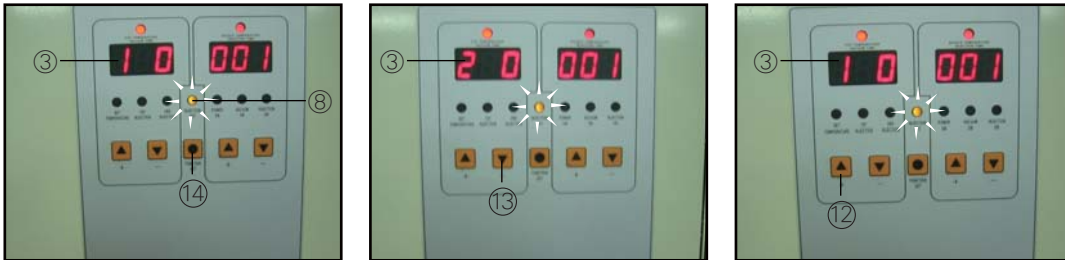
- 1 Pressing ⑭ button 4 times ⑧ lights will be on and same time both ③ and ④ display will show "1 204." This means that 1204 injections been made. To reset, press ⑯ one time and all counter will show "0 000". After reset, if turn off the machine without any injection, it will show "1204" times when turn on.



## DOUBLE PRESSURE INJECTION FUNCTION SETUP

- 1 Pressing ⑭ button 4 times and ⑧ lights will be on. ③ display will show "1 0". This means single injection. Pressing ⑬ one time and ③ display will show "2 0". It is ready to work with our NO.0634 120V / 0635 240V, TECHTROL PRO ROBOT CLAMP. You may change back to single injection work by pressing ⑫ button one time. (③ display will read "1 0").

※Note: Double pressure injection function must work with TECHTROL PRO ROBOT CLAMP. (No.0634 120V / 0635 240V)



## SET DOUBLE PRESSURE INJECTION TIME

- 1 Pressing ⑭ button 3 times. ⑦ light will be on and ④ display will show "002" for 2 seconds. Pressing ⑮ button to increase injection time as shown "005" for 5 seconds and you may increase up to 990 seconds for large mold and decrease by pressing ⑯ button.



## USEFUL GUIDELINES :

- 1 Machine must be correctly grounded.
- 2 Different waxes should be used at their suitable temperatures (actual injection temperature depends on the wax being used).
- 3 Temperatures of wax in tank and nozzle are significant and must be adjusted by experienced operator according to wax property and test result. Vacuum and injection time are also the same.
- 4 Keep molds clean and free of wax residues at all times.
- 5 Lubricate mold with very light application of mold release compound as required.
- 6 Air pressure is depending on the size, shape, and delicacy of a wax pattern and its mold. Writing such information on each mold as reference for later use is suggested.
- 7 Wax pot should be drained and kept clean from time to time. Old contaminated wax should be discarded and replaced. Do not re-use dirty or contaminated wax because this could cause nozzle stoppage and poor fidelity in patterns.
- 8 If nozzle stoppage is caused by contaminated wax, wax pot has to be emptied and cleaned. Set maximum air pressure and activate injection cycle several times to force out foreign objects that might be jammed inside the nozzle.
- 9 Raising wax pot temperature 10~20°F above operating temperature for about one hour may speed up the melting process of newly added wax.

- 10 Do not allow wax level to get below 2 lbs (1 kg), because low level of wax in tank could cause air bubbles in wax pattern.
- 11 It is not necessary to shut down the unit everyday after work. Keep unit warmed up over night will save you time and electricity.
- 12 Call service personnel, if you have problems that can not be resolved.

## MAINTENANCE :

- 1 Keep a minimum space distance of 8" from back and all sides of unit.
- 2 Turn off unit completely, if it is not going to be used within 24 hours.
- 3 Always release vacuum by loosening air release valve before shutting off vacuum pump. Otherwise, due to in-balance of air pressure, wax can be sucked into vacuum pump and hence damage the pump.
- 4 Vacuum pot has to be cleaned regularly, at least once a day, to maintain the best performance of the unit. Too much leftover wax in vacuum tank may disable vacuum cycle. To clean wax, turn on vacuum chamber **heater switch** wait for wax to melt completely (about 10 min.), make sure vacuum pump is off, and then open wax drain valve to have wax drained out. Until wax drained and close **wax drain valve** and must to shut off **heater switch**.
- 5 If No.0465/0466 vacuum pump is used, change vacuum pump oil every three months.

## CAUTIONS :

- 1 Release air pressure, if the unit is not in operation.
- 2 Do not remove cover lid with air pressure in wax pot.
- 3 Do not use bottled oxygen as air pressure supply.
- 4 Electrical plug must be properly grounded at electrical outlet.
- 5 Do not use your hand to touch liquid wax in tank. Hot wax can cause painful burns.
- 6 Do not press foot pad switch and activate injection process while not injecting wax patterns. Spilled wax on body, especially on eyes and face, could cause serious injury.
- 7 Do not sit (or stand) right in front of injection nozzle to prevent from possible harm, particularly while doing maintenance or troubleshooting the unit.

## TROUBLESHOOTING :

Problem	Possible Causes	Solution
<b>1.MACHINE DOES NOT OPERATE</b>	· No power	<ul style="list-style-type: none"> <li>· Check circuit breaker or fuse.</li> <li>· Check if unit is plugged properly.</li> <li>· Check Main power fuse.</li> <li>· Change fuse if necessary. (Spec: #0662:10A/250V, #0663:5A/250V).</li> </ul>
<b>2.WAX POT DOES NOT MELTING WAX</b>	· Broken fuse	<ul style="list-style-type: none"> <li>· Check Main power fuse.</li> <li>· Replace fuse if necessary. (Spec: #0662:10A/250V, #0663:5A/250V).</li> </ul>
	· Incorrect temperature setting	<ul style="list-style-type: none"> <li>· Check wax pot temperature setup page 3.</li> </ul>
<b>3.NOZZLE DOES NOT HEAT</b>	· Broken fuse	<ul style="list-style-type: none"> <li>· Check Main power fuse.</li> <li>· Replace fuse if necessary. (Spec: #0662:10A/250V, #0663:5A/250V).</li> </ul>
	· Incorrect temperature setting	<ul style="list-style-type: none"> <li>· Check injection nozzle temperature setup page 3.</li> </ul>
<b>4.UNIT HAS NO VACUUM</b>	· Air leakage	<ul style="list-style-type: none"> <li>· Check that vacuum release valve is shut.</li> <li>· Check if vacuum chamber O-ring is properly sealed.</li> <li>· Check tightness of vacuum hose connection.</li> </ul>
	· Too much wax in vacuum chamber	<ul style="list-style-type: none"> <li>· Check if there is too much wax left in the vacuum chamber and needs to be cleaned.</li> </ul>

Problem	Possible Causes	Solution
5.UNIT VACUUMS BUT CAN NOT INJECT WAX	· Incorrect injection time	· Check nozzle injection time setting.
	· Wax in pot not melted	· Check wax in pot. If not melted, raise temperature slightly. Allow enough time for wax to melt. Also refer to the solution of problem 2.
	· Injection nozzle not heated	· Refer to the solution of problem 3.
	· Air pressure in wax pot is too small	· Check air pressure indicator gauge for correctness. Adjust air pressure control to desired pressure. · Check all air hoses and connection for leakage.
	· Injection nozzle clogged	Process: (1) Open wax drain valve to have wax drained out. (2) Take off wax drain filter (Accessory A) and clean the foreign object with heat. (3) Raise wax pot and injection nozzle temperature 10~20°F above operating temperature for about 10 min. (4) Increase wax pot air pressure. (5) Step on foot pad continuously to make injections. (6) After air injects successfully from injection nozzle, put the wax drain filter (Accessory A) back and add new wax for melting. Set to normal operation process. Note: Use a container to hold the possibly injected wax when troubleshooting.
6.WAX LEAKAGE FROM INJECTION NOZZLE	· Parts stuck	· Raise injection nozzle temperature and air pressure, and then step on foot pad for several times to start injection process and restore the stuck parts. <b>※Note: 1. Do not step on foot pad before wax melted. 2. Use a container to hold the possibly injected wax when troubleshooting.</b>
	· Silicon rubber pad damaged	· Replace silicon rubber pad.