

Instruction Manual

Pneumatic Injection Molding Machine

PIMM-30-125-200

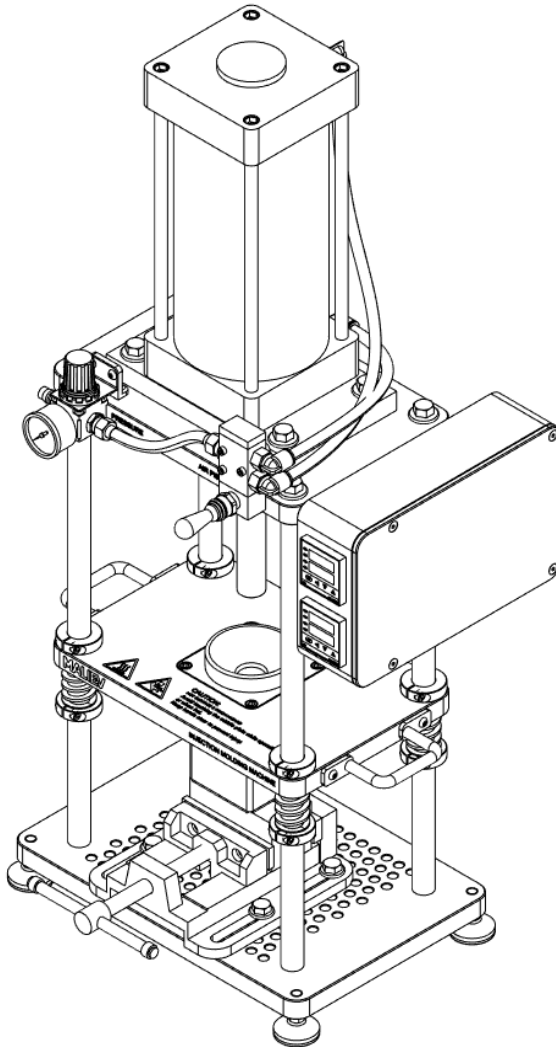


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1. Introduction

Welcome to the user manual for the Pneumatic Injection Molding Machine, Model **PIMM-30-125-200**. This state-of-the-art pneumatic plastic injection molding machine has been meticulously engineered to provide a reliable, efficient, and precise solution for manufacturing high-quality plastic parts and components. Our dedicated team of experts has crafted this machine to meet the demanding requirements of various industries, from automotive and medical to consumer goods and electronics.

This comprehensive manual will serve as your ultimate guide to the installation, operation, and maintenance of your new Pneumatic Injection Molding Machine. It contains detailed instructions, helpful tips, and essential safety information to ensure that you can confidently operate and maintain your machine for years to come. We strongly encourage you to read this manual from cover to cover before using your new machine in order to guarantee its safe and proper use.

By choosing the Pneumatic Injection Molding Machine, you have made an investment in a high-performance machine that is designed to deliver outstanding results while adhering to the highest safety standards. We are confident that your new pneumatic plastic injection molding machine will exceed your expectations and become an invaluable asset in your production process. As you embark on this exciting journey, remember that our dedicated support team is always here to help you with any questions or concerns you may have. We wish you the best of success with your new Pneumatic Injection Molding Machine, Model **PIMM-30-125-200**.

2. Safety Precautions

The safety of our users is our top priority. Before operating the machine, please carefully read and follow these safety precautions to ensure a safe and accident-free working environment:

- Wear appropriate PPE, including safety goggles, gloves, and ear protection, when operating the machine to protect against flying debris, hot surfaces, and noise.
- Ensure that the machine is installed on a stable, level surface in a well-ventilated area. Proper installation and adequate ventilation will prevent accidental tipping or overheating, both of which can lead to dangerous situations.
- Keep a safe distance from the machine while it is in operation. Do not place any body parts, especially hands and fingers, near the injection nozzle, mold area, or other moving components. This will help prevent potential injuries from accidental contact with these areas.
- Always turn off the machine and disconnect it from the power source before performing any maintenance, cleaning, or troubleshooting. This will prevent accidental activation of the machine while working on it, which can cause serious injuries.
- Regularly inspect the machine for any signs of wear, damage, or malfunction. Promptly address any issues to ensure the machine's safe and efficient operation. If you are unsure about how to resolve a particular issue, consult the **Troubleshooting** section of this manual or contact our customer support team for assistance.
- Train all operators on the proper use of the machine, including how to safely start, stop, and control the machine during operation. This will help minimize the risk of accidents and ensure a safe working environment for everyone.

By following these safety precautions and operating the machine in accordance with the instructions provided in this manual, you can minimize the risk of accidents and ensure a safe working environment for yourself and others around you.

3. Product Specifications

In this section, you will find the technical specifications for your Pneumatic Injection Molding Machine Model **PIMM-30-125-200**. These specifications are crucial for understanding the machine's capabilities and ensuring its safe and proper operation.

General Specifications:

Injection Pressure (0.7MPa):	8,590 N * 0.10197 kgf/N ≈ 876 kgf
Cylinder Stroke:	200 mm
Maximum Shot Size:	30 g
Temperature Controllers:	2
Pneumatic Switch:	Toggle
Vise Size:	4 inches

Electrical Specifications:

Operation Voltage:	220V@1000W
Heater Bands:	300W each

Pneumatic Specifications:

Maximum Input Air Pressure:	0.7 Bar
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Cylinder Specifications:

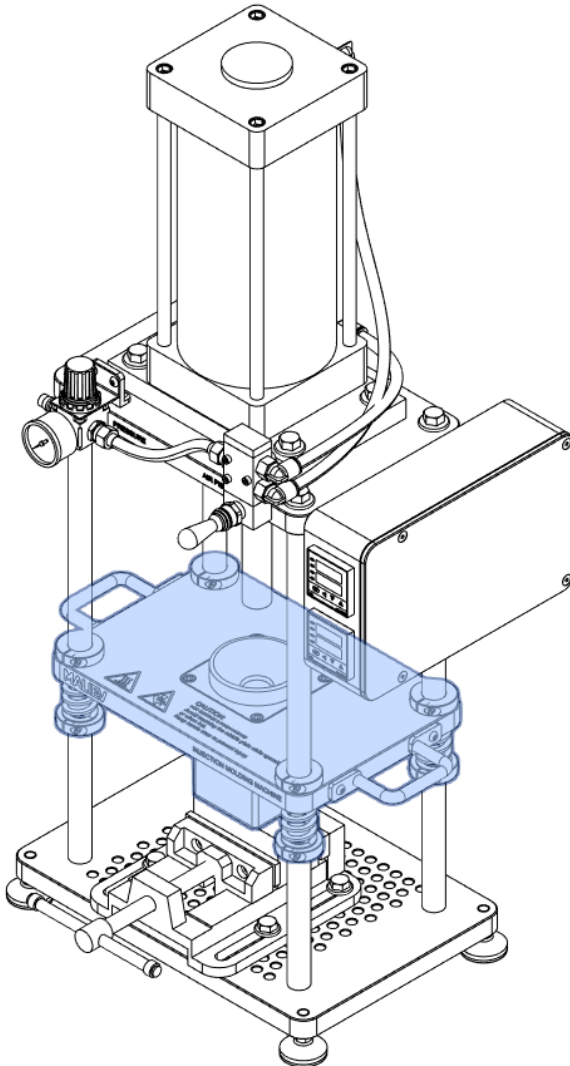
Cylinder Bore Size:	125 mm
Stroke Length:	200 mm
Rod Diameter:	32 mm
Piston area:	12,272 mm ²

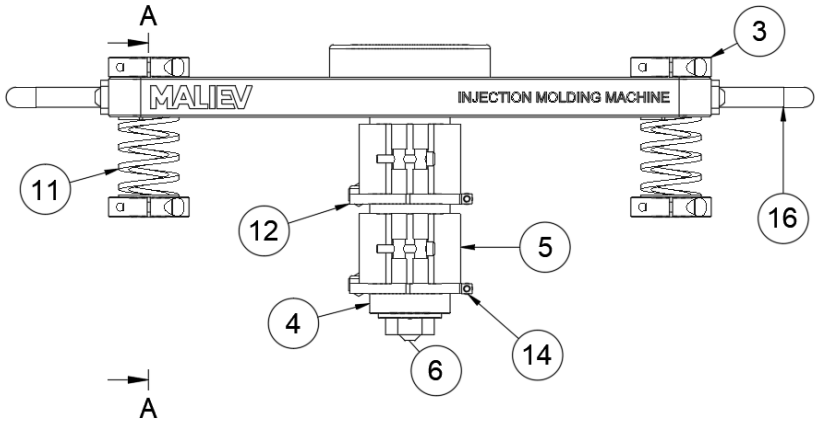
For more information on machine operation, setup, and maintenance, please refer to the respective sections in this manual.

4. Parts and Components

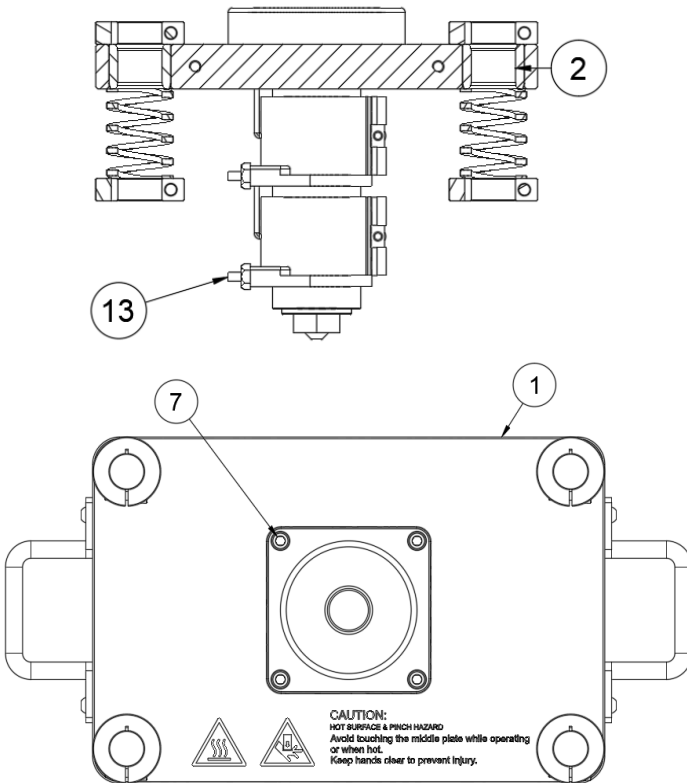
This section provides an overview of the main parts and components of the Pneumatic Injection Molding Machine. Please familiarize yourself with these before installation and operation

4.1. Injection Tube Support Plate Subassembly



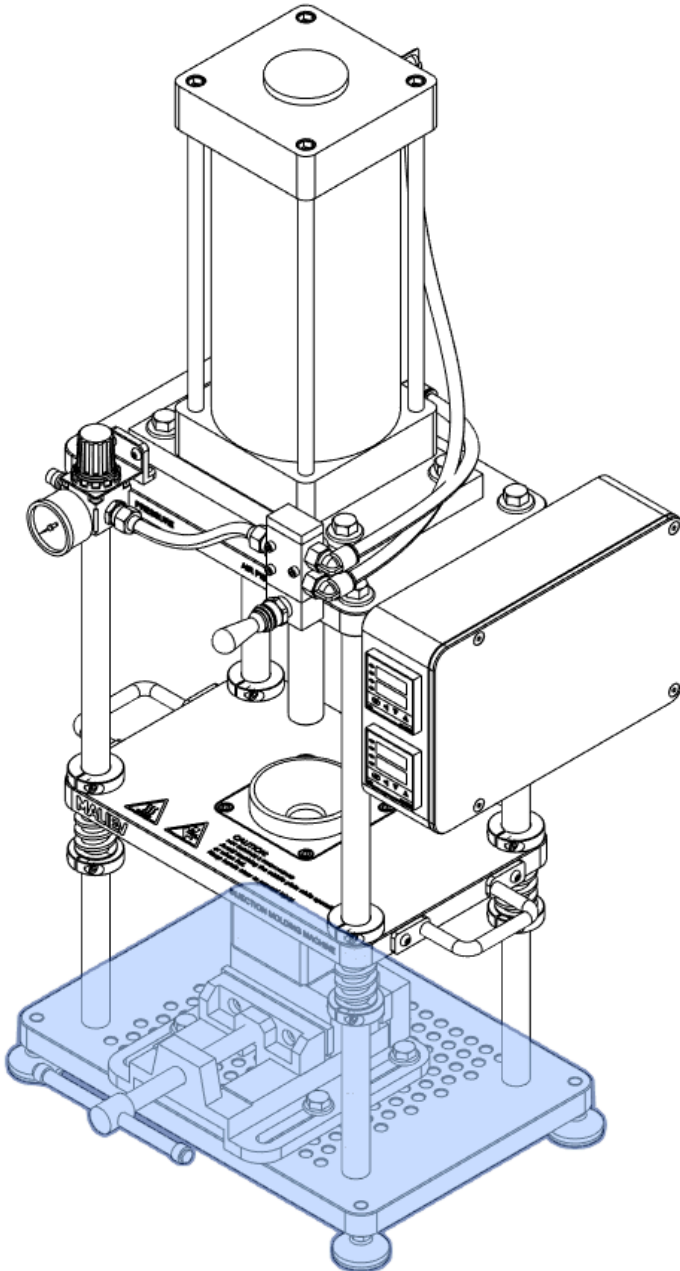


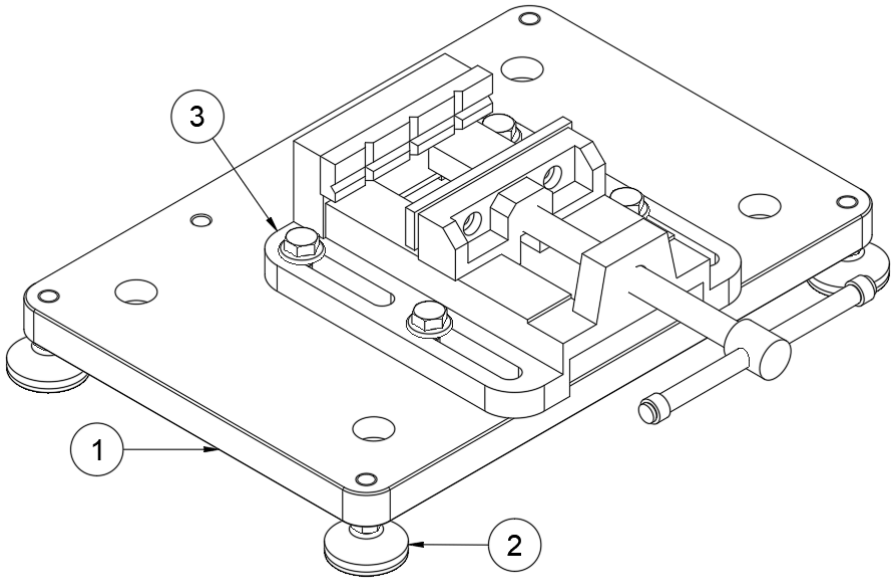
A-A



#	Component	Quantity
1	Injection Tube Support Plate	1
2	Oil-free bushing	4
3	Shaft Collar	8
4	Injection Tube	1
5	Heater Band	2
6	Nozzle	1
7	M6x12 Counterbore Screw	4
8	Finger Guard (optional)	1
9	Anti-drool Plug	1
10	Anti-drool return spring	1
11	Return spring	4
12	Thermocouple Holder	2
13	Thermocouple	2
14	M3x6 Counterbore Screw	2
15	Plastic Washer	4
16	Handle	2

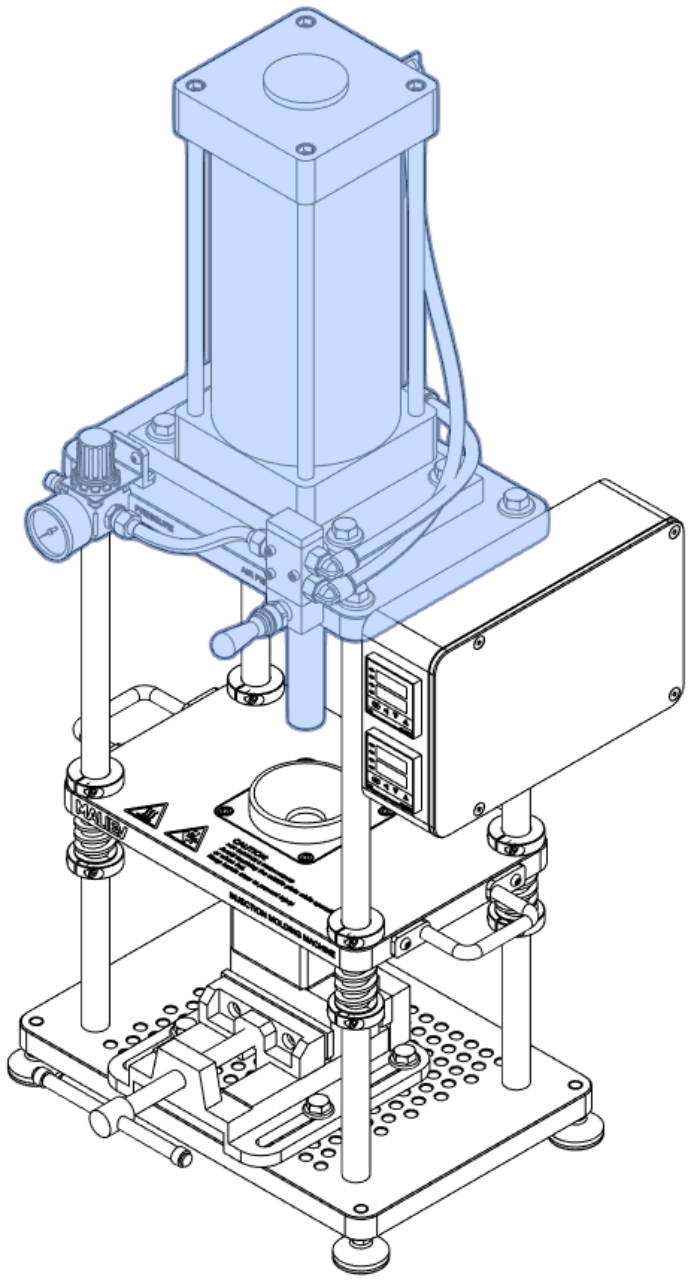
4.2. Base Plate Subassembly

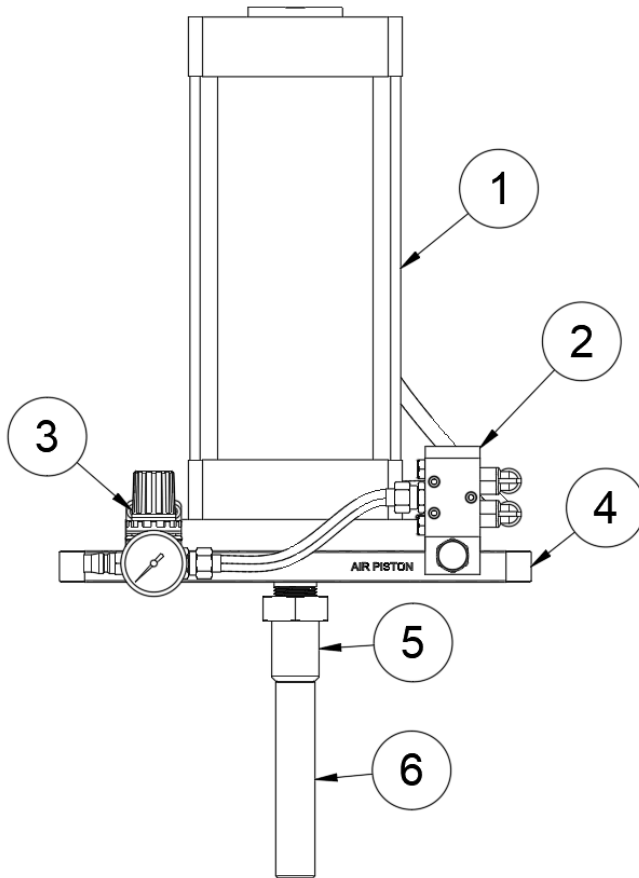




#	Component	Quantity
1	Base Plate	1
2	Footing	4
3	4" Vise	1

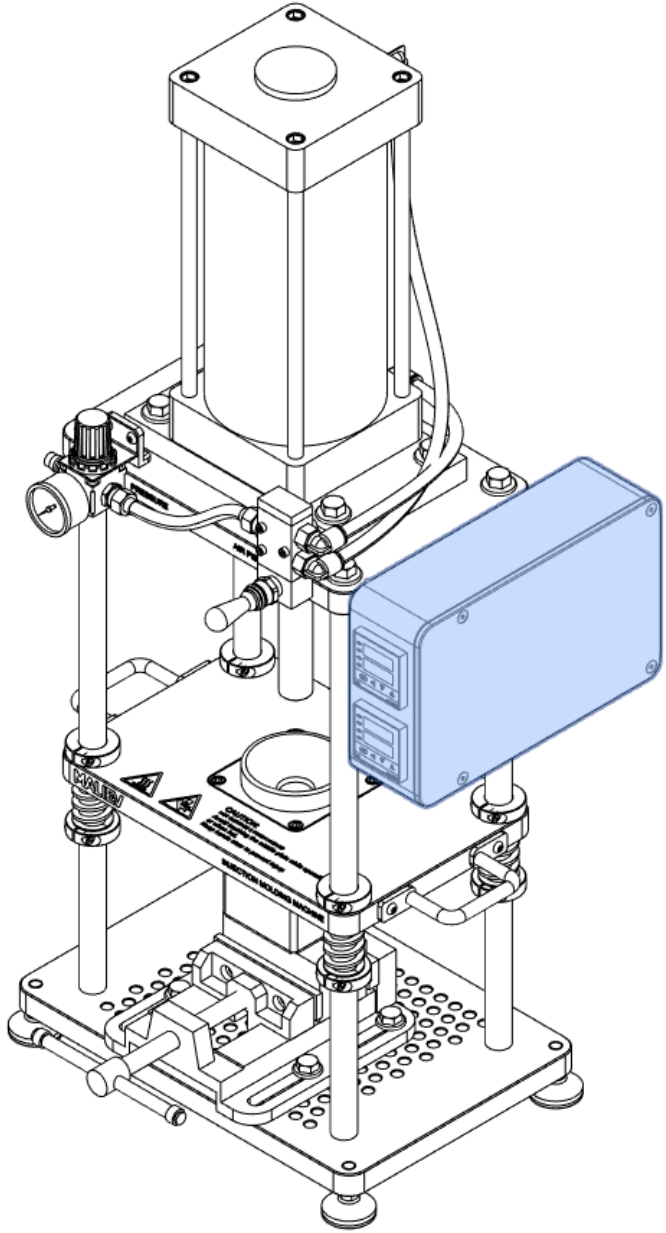
4.3. Pneumatic Cylinder Subassembly

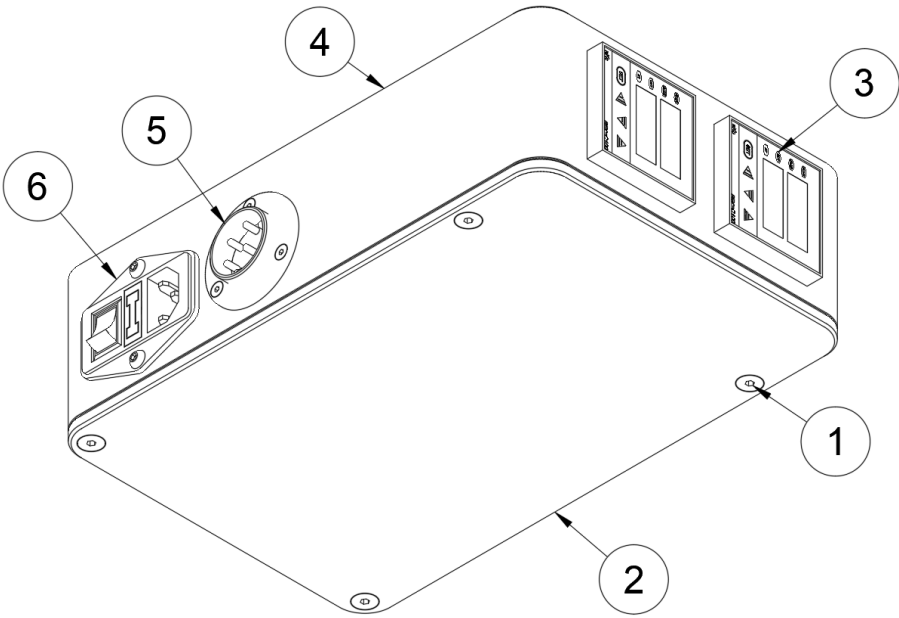




#	Component	Quantity
1	Pneumatic Cylinder	1
2	Pneumatic Toggle Switch	1
3	Pressure Regulator	1
4	Pneumatic Cylinder Support Plate	1
5	Extrusion Rod Adapter	1
6	Injection Rod	1

4.4. Electronic Box Subassembly





#	Component	Quantity
1	M5x20 (Countersunk Screw)	4
2	Electronic Box Lid	1
3	Temperature Controller	2
4	Electronic Box Body	1
5	Heater Band and Temperature Sensor Connector	1
6	Power Connector	1

5. Installation and Setup

The chapter provides detailed instructions and guidance to assist users in properly installing and setting up their pneumatic injection molding machine. By following the instructions outlined in this chapter, users can ensure that their machine is installed and set up correctly, allowing them to achieve consistent, high-quality results from their injection molding operations.

5.1. **Unbox and Assemble the Machine**

Carefully unbox the machine and all its components. Assemble the machine as per the assembly instructions provided in the manual, ensuring that all parts are securely attached and aligned correctly.

5.2. **Electrical Connection**

Connect the heater band, temperature sensor, and electronic control box to their respective terminals on the machine, following the wiring diagram provided in the manual. Ensure that all connections are secure and correctly positioned to avoid any electrical hazards.

5.3. **Pneumatic Side Installation**

5.3.1. **Pressure Regulator**

Install the pressure regulator on the air supply line to control the air pressure supplied to the machine. Connect the pressure using the quick coupling connector to the input side of the regulator at the mounting position.

5.3.2. **Pneumatic Toggle Switch**

The pneumatic toggle switch should be mounted on the mounting plate on the "AIR PISTON" side to control the airflow to the cylinder's piston, allowing for accurate control of the piston's movement during the injection molding process.

5.3.3. **Air Hoses**

Connect air hoses from the air supply to the air cylinder, pressure regulator, and pneumatic switch, ensuring all connections are secure and leak-free.

5.4. Vertical Stop Ring Installation

For optimal molding results, position the nozzle 3-5mm above the mold injection port, and install the vertical stop ring on the machine to prevent the aluminum plate from traveling too far up or down during operation.

5.5. Vise Installation

To secure and stabilize the mold during the injection process, the user should attach the 4-inch vise to the machine's base plate using the appropriate screws provided with the package.

5.6. Machine Install Location

Choose a well-ventilated, level, and stable surface to install your machine. Ensure the location has adequate space for safe operation and easy access to electrical outlets and air supply.

5.7. Installation Precheck

5.7.1. Electronic Check

Verify that all electronic connections are secure and functioning properly. Test the heater band, temperature sensor, and electronic control box for correct operation.

5.7.2. Pneumatic Check

Ensure that the pneumatic system is functioning correctly by checking for any leaks or malfunctions in the pressure regulator, pneumatic toggle switch, and air hoses.

5.7.3. Mechanical Check

Inspect the machine for any misalignments, loose parts, or other mechanical issues that may affect the performance of the machine.

By following these installation and setup instructions, you can ensure that your Pneumatic Injection Molding Machine is ready for safe and efficient operation.

6. Operating Instructions

This section will walk you through the process of operating your Pneumatic Injection Molding Machine for optimal performance

6.1. Vertical Stop Ring Position Adjustment

Prior to mold installation, adjust the vertical stop ring's position to ensure that the tip of the injection nozzle is positioned approximately 3-5mm above the mold injection port. This optimal positioning will allow for proper material flow during the injection process and prevent potential issues, such as overflow or underfilling of the mold cavity.

6.2. Mold Installation and Alignment

Securely install the mold in the 4-inch vise, ensuring it is properly aligned with the injection nozzle. Double-check that the mold is tightly clamped and will not shift during the injection process.

6.3. Plastic Pellet Filling

Fill the machine's hopper with the appropriate plastic pellets for your desired part. Ensure that the hopper is filled to a suitable level, avoiding overfilling or underfilling, which could affect the injection process.

6.4. Machine Power-On

Turn on the machine by connecting it to a power source and switching it on using the main power switch. Verify that all indicator lights and displays are functioning correctly.

6.5. Temperature Settings for different plastics

Please consult the [Material Compatibility Chart](#) in this manual for the appropriate temperature range and nozzle temperature settings for your chosen plastic material. Following these guidelines will ensure optimal machine performance, minimize waste, and maintain component longevity. Proper temperature and nozzle settings contribute to a smooth injection molding process, resulting in higher quality end products.

6.6. Input Air Connection

Before connecting the air supply to the pressure regulator, ensure that the input air is clean and free of debris or moisture. Using dry and clean air will help prevent any potential issues or damage to the machine's components. A suitable air filter or dryer can be used to maintain the quality of the input air supply.

Connect the air supply to the pressure regulator, making sure that the connection is secure and leak-free. Properly secured connections will not only provide the necessary pneumatic pressure for operating the machine but also prevent any loss of pressure, ensuring efficient machine operation.

By maintaining clean and dry input air and securing connections, you'll contribute to the machine's optimal performance, prolong the lifespan of its components, and ensure a safe and effective injection molding process.

6.7. Pressure Settings

Adjust the pressure settings on the pressure regulator to match the requirements of your specific mold size and material. Remember to always start on the lower end (0.2 MPa) and work your way up until the plastic fully fills the mold cavity.

6.8. Injection Process

Once the machine has reached the desired temperature and pressure settings, activate the pneumatic toggle switch to initiate the injection process. The plastic material will be heated, melted, and injected into the mold cavity to form the desired part.

6.9. Part Demolding

After the injection process is complete and the part has sufficiently cooled, carefully remove the part from the mold. Use appropriate tools and safety precautions to avoid damaging the part or injuring yourself during demolding.

6.10. Mold Stop Adjustment

If necessary, adjust the mold stop to accommodate any changes in mold size or injection stroke for the next shot. This will ensure that the aluminum plate does not travel too far during the injection process.

6.11. Machine Power-Off

Once you have completed your production run, turn off the machine by disconnecting it from the power source and switching off the main power switch.

By following these operating instructions, you can ensure a smooth and efficient production process with your Pneumatic Injection Molding Machine while minimizing the risk of accidents or damage to the machine.

7. Maintenance and Cleaning

Proper maintenance and cleaning are essential for the longevity and performance of your Pneumatic Injection Molding Machine. Follow these guidelines to keep your machine in peak condition

7.1. Smooth Rod Lubrication

Periodically lubricate the smooth rods using a high-quality, machine-grade lubricant to ensure smooth and consistent movement during operation. Check the manual for the recommended lubrication interval and type of lubricant to use.

7.2. Nozzle Cleaning

Regularly clean the nozzle using a brass brush to remove any accumulated plastic residue. This will help prevent clogging or uneven material flow during the injection process.

7.3. Plastic Ooze Inspection

Inspect the machine for any plastic ooze around the nozzle, heater band, or temperature sensor. If found, carefully remove the excess material to prevent interference with the machine's heating and temperature control systems.

7.4. Air Line Connection

Regularly inspect the air line connections for any signs of wear, damage, or leaks. Promptly replace or repair any damaged hoses or connectors to ensure consistent pneumatic pressure and machine performance.

7.5. Smooth Air Cylinder Operation

Periodically check the air cylinder for smooth operation, ensuring that it moves freely and without obstruction. If necessary, lubricate the air cylinder or adjust the cylinder's alignment to prevent any potential issues during operation.

7.6. Mold and Vise Cleaning

Clean the mold and vise regularly to remove any residual plastic material or debris. This will help maintain proper mold alignment and prevent part defects or damage to the mold during the injection process.

7.7. Electronic Component Inspection

Inspect the electronic components, such as the heater band, temperature sensor, and electronic control box, for any signs of wear, damage, or malfunction. Address any issues promptly to ensure the machine's safe and efficient operation.

7.8. Purging

Purging is a cleaning process to remove remaining thermoplastics in the injection tube from the previous run. Start by placing an empty container below the nozzle, and lower the input air pressure to the regulator until the pressure gauge reads zero. Heat up the machine to appropriate melting temperature from the previous run, then toggle the pneumatic switch down and slowly increase the input pressure to the regulator until the injection rod is inside the tube and starts to compress the return spring a little bit. Observe until there is no more ooze coming out of the nozzle.

7.9. General Cleaning

Keep the machine's exterior and surrounding area clean and free of dust, debris, and spilled material. This will help maintain a safe and efficient working environment and prevent any potential hazards or interference with the machine's operation.

By following these maintenance and cleaning instructions, you can extend the lifespan of your Pneumatic Injection Molding Machine and ensure optimal performance during the injection molding process.

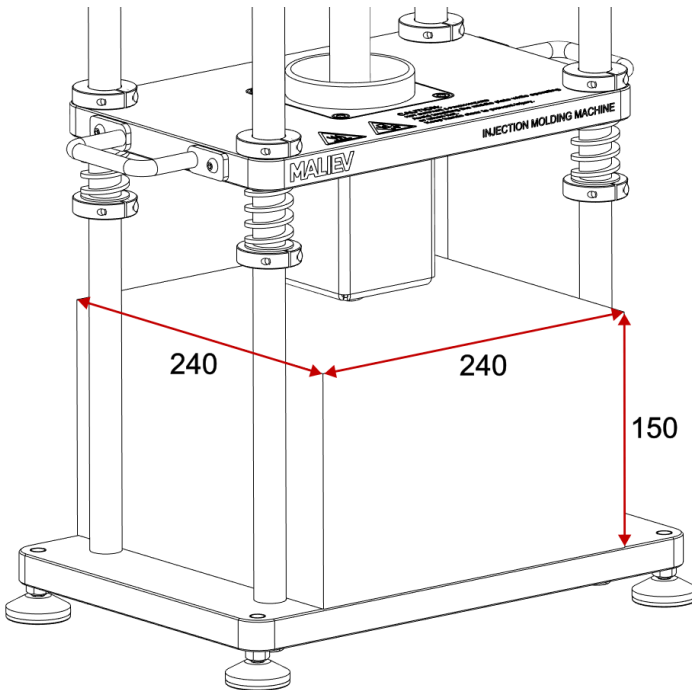
8. Frequently Asked Questions

What type of plastic materials can be used with this machine?

The Pneumatic Injection Molding Machine can process a wide range of thermoplastic materials, such as ABS, PP, PE, and more. Please refer to the material manufacturer's guidelines for appropriate temperature and pressure settings.

What is the maximum mold size this machine can accommodate?

The largest mold that this machine can handle is **240 x 240 x 150mm**



How do I set the temperature for different types of plastics?

Set the temperature using the dual temperature controllers on the machine. Refer to the material manufacturer's guidelines or consult the manual for recommended temperature settings.

What is the maximum injection pressure of the machine?

The maximum injection pressure of the Pneumatic Injection Molding Machine is 1,000 kg (2,204 lbs).

Can I adjust the injection pressure for different mold sizes?

Yes, you can adjust the pressure settings on the pressure regulator to match the requirements of your specific mold size and material.

How do I ensure the nozzle is correctly positioned for the injection process?

Adjust the vertical stop ring to position the tip of the injection nozzle approximately 3-5mm above the mold injection port. This optimal positioning will allow for proper material flow during the injection process.

What is the operating voltage of the machine?

The operating voltage of the machine is 220V@1000W.

What is the maximum input air pressure for this machine?

The maximum input air pressure for the Pneumatic Injection Molding Machine is 0.7 Bar.

How often should I clean the nozzle and the mold?

Regular cleaning of the nozzle and mold is essential for proper operation. Clean the nozzle using a brass brush and remove any residual plastic material from the mold. The frequency of cleaning depends on the usage and material, but it is recommended to clean them after each production run.

What type of lubricant should I use for the smooth rods and air cylinder?

Use a high-quality, machine-grade lubricant for the smooth rods and air cylinder. Consult the manual for the recommended lubricant type and lubrication intervals.

How do I troubleshoot issues with the machine?

Refer to the troubleshooting section in the manual or contact our customer support team at info@maliev.com for assistance.

What is the warranty period for this machine?

The Pneumatic Injection Molding Machine comes with a 1 year limited warranty. For details on the warranty coverage and terms, please visit our website at www.maliev.com.

Can I use this machine for overmolding or insert molding?

The Pneumatic Injection Molding Machine can be adapted for overmolding or insert molding applications. However, it may require additional setup and alignment considerations. Consult the manual or contact our customer support team for guidance.

What maintenance tasks are required for this machine?

Regular maintenance tasks include lubricating the smooth rods and air cylinder, cleaning the nozzle and mold, inspecting the air line connections and electronic components, and ensuring smooth operation of the machine. Consult the manual for a comprehensive maintenance guide.

9. Troubleshooting

If you experience any issues with your Pneumatic Injection Molding Machine, please refer to the following troubleshooting guide

Machine does not power on

Solution: Check the electrical connection and ensure the power cable is securely plugged into a working outlet. Inspect the cable and connections for any damage.

Insufficient or uneven heating

Solution: Verify that the temperature settings are correct for the specific type of plastic being used. Ensure the heater bands are properly secured and in contact with the barrel. Check for any loose connections or damage to the temperature controllers.

Incomplete or deformed molded parts

Solution: Adjust the injection pressure or mold clamping force. Inspect the mold for any damage or wear. Increase the temperature and ensure the plastic pellets are properly filled and uniformly melted.

Air bubbles in molded parts

Solution: Check for proper venting in the mold. Increase the injection pressure or decrease the injection speed to allow air to escape.

Poor mold release or sticking parts

Solution: Inspect the mold for damage, dirt, or wear. Clean and lubricate the mold as needed. Adjust the mold temperature, cooling time, or injection pressure.

Nozzle leakage or drooling

Solution: Inspect the nozzle for damage, wear, or misalignment. Check the nozzle's temperature and adjust as needed. Verify that the nozzle is properly seated against the mold.

Pneumatic system failure or air leakage

Solution: Check all air hoses, connections, and seals for damage or leaks. Inspect the pressure regulator, pneumatic toggle switch, and air cylinder for proper function.

Excessive machine noise or vibration

Solution: Ensure the machine is properly installed and leveled on a stable surface. Inspect all moving components for wear, damage, or lack of lubrication. Tighten any loose bolts or fasteners.

Electronic control box malfunction

Solution: Verify that all connections to the control box are secure and undamaged. Inspect the control box for any signs of damage or overheating. If the issue persists, contact customer support.

Difficulty adjusting the vertical stop ring

Solution: Inspect the vertical stop ring and its components for damage, wear, or misalignment. Ensure the machine is turned off and cooled down before attempting adjustments. Lubricate the stop ring and components if needed.

10. Warranty and Support

Your Pneumatic Injection Molding Machine comes with a **1 year** limited warranty, providing you with peace of mind and assurance that you are investing in a quality product. Our warranty covers any defects in materials or workmanship under normal use and operation during the warranty period. For details on the warranty coverage, terms, and conditions, please visit our website at **www.maliev.com**.

If you encounter any issues with your Pneumatic Injection Molding Machine during the warranty period, our dedicated customer support team is here to help. You can reach us by email at **info@maliev.com**. Our knowledgeable and friendly support staff will work with you to diagnose the issue and provide the necessary guidance or assistance, which may include troubleshooting, repair, or replacement of defective parts.

In addition to our warranty support, our customer service team is available to answer any questions you may have about the operation, maintenance, or features of your Pneumatic Injection Molding Machine. We strive to provide exceptional service to ensure that you have a positive experience with our product and company.

By offering a comprehensive warranty and reliable customer support, we are committed to ensuring your satisfaction with your Pneumatic Injection Molding Machine and helping you achieve your production goals.

11. Appendix

This section includes additional resources and information for your Pneumatic Injection Molding Machine:

11.1. Material Compatibility Chart

The following Material Compatibility Chart provides information on the suitable processing temperature range, nozzle temperature, and draft angle for various materials that can be used with our Pneumatic Injection Molding Machine. Ensure that you select materials that are compatible with the machine's capabilities to guarantee optimal performance and safety during operation.

Material	Temperature Range (°C)	Nozzle Temperature (°C)	Draft Angle
ABS (Acrylonitrile Butadiene Styrene)	220-260	230-250	0.5-1.5
PLA (Polylactic Acid)	190-210	190-210	0.5-1.5
PET (Polyethylene Terephthalate)	240-280	250-270	0.5-1.5
PP (Polypropylene)	200-240	210-230	0.5-1.5
HDPE (High-Density Polyethylene)	180-230	190-220	0.5-1.5

11.2. Pneumatic Cylinder Data

The following table presents the force output at various input air pressure levels and the equivalent force in kgf (kilogram-force).

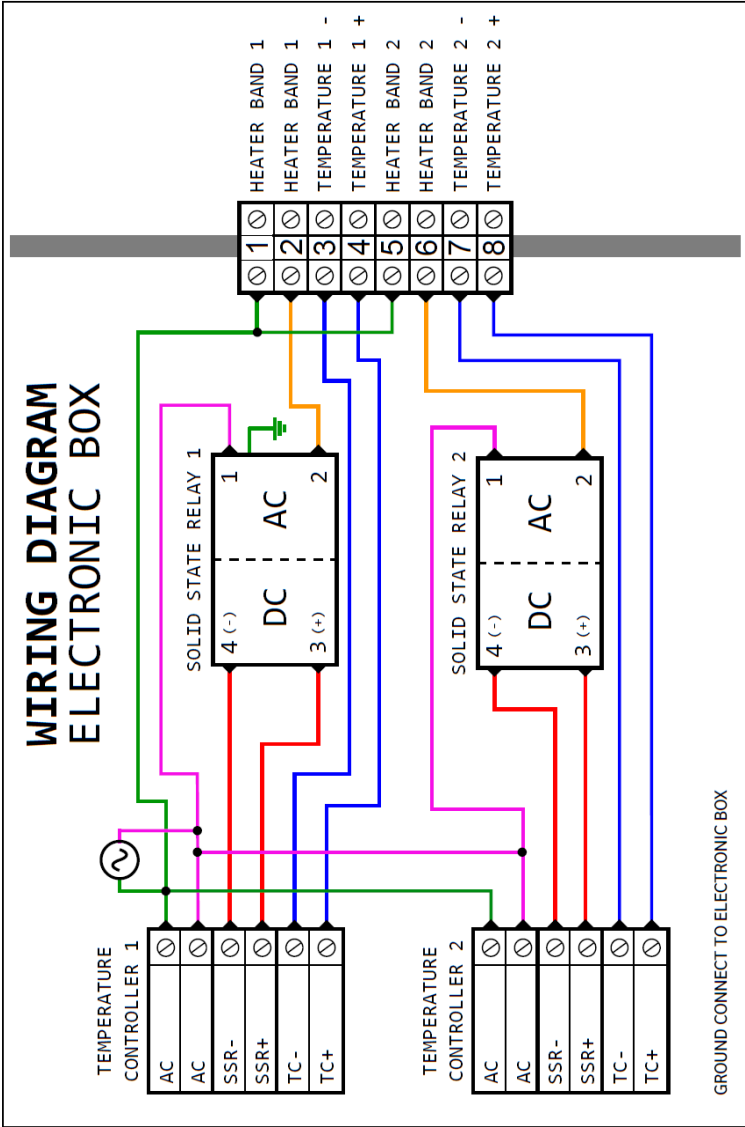
Cylinder Bore Size: 125 mm
Stroke Length: 200 mm
Rod Diameter: 32 mm
Piston Area: 12,272 mm²

Input Air Pressure (MPa)	Force Output (N)	Force Output (kgf)
0.2	2,454	250
0.3	3,682	375
0.4	4,909	500
0.5	6,136	625
0.6	7,363	750
0.7	8,590	875

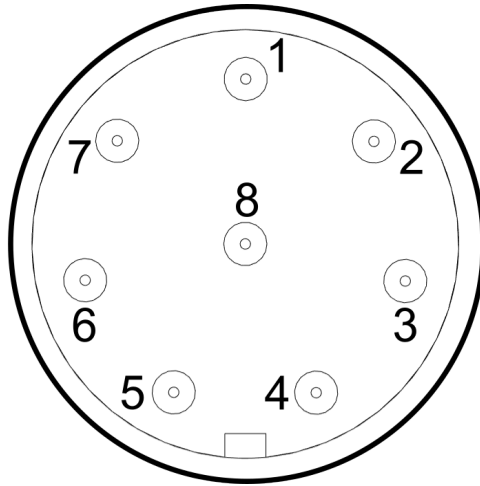
* *Theoretical output (N) = Pressure (MPa) × Piston area (mm²)*

11.3. Wiring Diagram

A visual guide illustrating the connections between different components of the machine, including power, heater bands, thermocouples, and control systems.



A visual representation of the 8-pin round connector. The wiring is wired in the following order.



Wire	1	2	3	4	5	6	7	8
Color	Black	White	Red	Green	Yellow	Brown	Blue	Gray

This color coding and pin assignment is crucial when you're wiring the 8-core cable to the connector. It ensures that each wire is correctly connected to its corresponding pin, which is essential for the machine to function correctly. Please follow this diagram carefully when you're wiring your 8-core cable. If you're unsure, it's always best to seek help from a professional.

11.4. Maintenance Schedule

Regular maintenance is crucial for ensuring the efficient operation and longevity of your machine. By following the maintenance schedule below, you can keep your machine in peak condition and minimize the risk of potential issues or breakdowns. Please note that the maintenance intervals are suggested guidelines and may vary depending on the specific operating conditions and usage patterns of your machine.

- **Lubricate smooth rods (Every 3 months)**

Clean the smooth rods using a soft cloth to remove any dust or debris. Apply a thin layer of high-quality silicone or lithium grease to the rods, and gently move the carriage back and forth to distribute the lubricant evenly.

- **Lubricate air cylinder (Every 6 months)**

Ensure the machine is turned off and disconnected from the power source. Remove the air hose from the cylinder. Apply a thin layer of high-quality silicone or lithium grease to the piston rod, and move the piston rod in and out to distribute the lubricant evenly. Reconnect the air hose to the cylinder.

- **Clean nozzle with a brass brush (As needed)**

Ensure the machine is turned off and cooled down. Use a brass brush to gently clean around the nozzle, removing any plastic residue or buildup.

- **Inspect heater bands and temperature sensor (Every 6 months)**

Ensure the machine is turned off and cooled down. Visually inspect the heater bands and temperature sensor for any signs of wear, damage, or loose connections. If any issues are found, consult the manual or contact our customer support team for assistance.

- **Inspect pneumatic hoses and connections (Every 6 months)**

Ensure the machine is turned off and disconnected from the power source. Visually inspect the pneumatic hoses and connections for leaks, cracks, or loose connections. Tighten any loose connections and replace any damaged hoses as needed.

- **Check for wear and tear on moving components (Every 6 months)**

Ensure the machine is turned off and disconnected from the power source. Inspect the moving components, such as the carriage, mold, and injection unit, for signs of excessive wear or damage. If any issues are found, consult the manual or contact our customer support team for assistance.

- **Replace worn or damaged parts as necessary (As needed)**

If any worn or damaged parts are identified during the inspections, consult the manual for part numbers and ordering information. Replace the parts according to the instructions provided in the manual or contact our customer support team for help.

Please remember to always turn off the machine and disconnect it from the power source before performing any maintenance tasks. If you are unsure about how to perform a specific maintenance task or need assistance, consult the manual or contact our customer support team for help.

11.5. Contact Information

If you have any questions, concerns, or need assistance with your Pneumatic Injection Molding Machine, please feel free to reach out to our customer support team using the contact information below. Our team is committed to providing prompt and efficient support to ensure you have the best experience with our product.

Company Name: **MALIEV Co., Ltd.**
Address: 36/1 Moo 3, Khlong Khoi, Pak Kret
City, Zip: Nonthaburi 11120
Country: Thailand
Email: info@maliev.com
Website: www.maliev.com

Facebook: www.facebook.com/maliev.manufacturing
LINE Official Account: <https://page.line.me/maliev> (ID: @maliev)
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For the fastest response, please have your machine model number and serial number available when contacting our customer support team. This information will help us provide you with the most accurate and relevant assistance for your specific machine.

Thank you for choosing the Pneumatic Injection Molding Machine! We hope this manual helps you make the most of your new pneumatic plastic injection molding machine.