









Inspections, Adjustments, Maintenance

- The following precautions apply to inspection, adjustment, and maintenance.

 Danger	
 <p>Maintenance and inspection of the rice milling machine must be performed by a person who fully understands this instruction manual.</p> <p>* There is a risk of electric shock, injury, failure, or damage when operated by a person who does not understand it.</p>	 <p>Always turn the power off when performing maintenance and inspection of the rice milling machine.</p> <p>* Otherwise, electric shock or injury may occur.</p>

 Warning	
 <p>Whenever a cover is removed, return it to its original position.</p> <p>* Otherwise, electric shock or injury may occur.</p>	 <p>Have the dealer repair or replace the wires.</p> <p>* Otherwise, electric shock or fire may occur.</p>
 <p>Do not let children play around the rice mill.</p> <p>* It may result in electric shock or injury.</p>	 <p>When multiple people are working together, make sure they communicate with each other.</p> <p>* Otherwise, electric shock or injury may occur.</p>

 **Caution**



When cleaning the discharge outlet, turn the power off and allow the heater in the discharge chute to cool.

* Otherwise, burns or injury may occur.



Do not damage, pull, or pinch wires.

* It may result in electric shock, failure, or damage.



Do not climb on the covers of the rice milling machine.

* They may become damaged or unable to be attached.



Do not subject the rice milling machine to severe impacts.

* It may result in failure or damage.



Do not modify the rice milling machine.

* It may result in injury, failure, or damage.

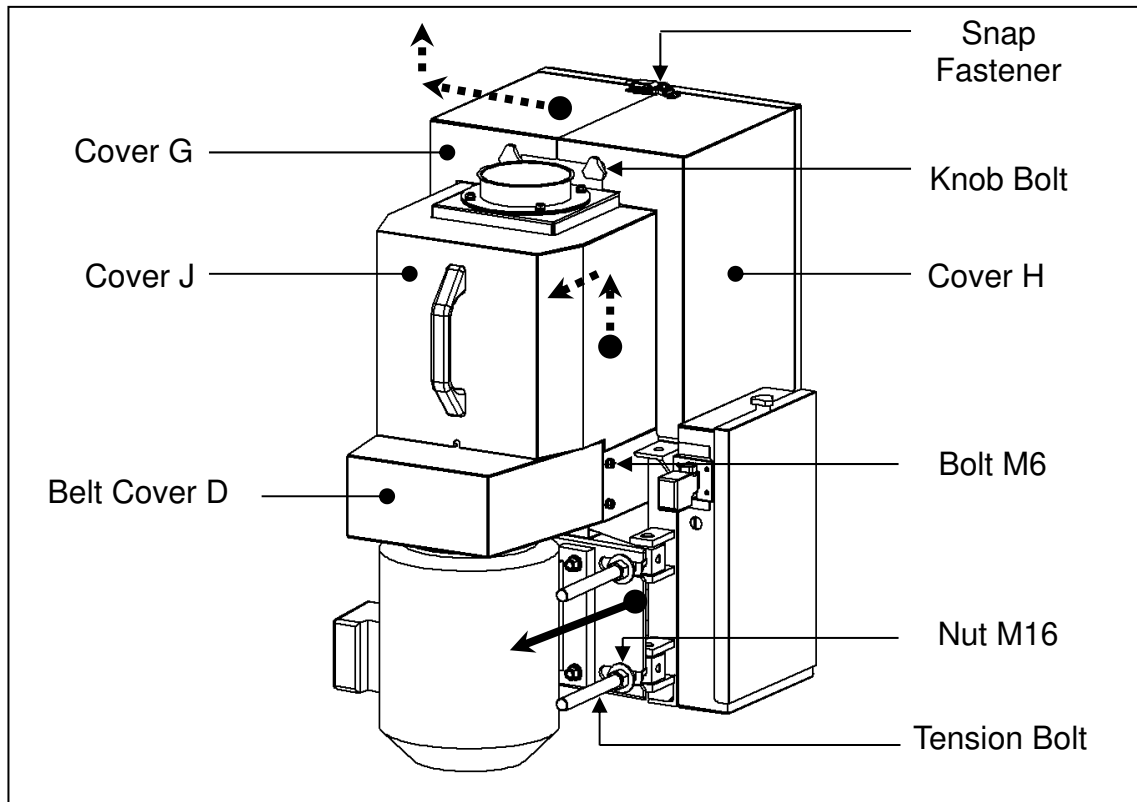
6.1 Regular check table

- Perform checking in accordance with the following regular check table.
The check timeline is the recommendation based on 8 operating hours per day.

Items for regular check	check period			Reference page	Comments
	Before operation	Weekly	Monthly		
Slack or damage in the Abrasive motor V-belt	•			Page 6-4	
Slack or damage in the Friction motor V-belt	•			Page 6-5	
Slack or damage in the raw material feed V-belt	•			Page 6-6	
Clean the Outlet	•			Page 6-7	
Clean the Bran Removal Chamber in the Friction section		•		Page 6-8	At least once a week
Clean the Bran Duct		•		Page 6-9	At least once a week
Clean the Bran Removal section in the Abrasive section			•	Page 6-10	At least once a month
Cleaning the Hopper and the raw material feed section			•	Page 6-12	At least once a month
Clean the Blower Fan Filter			•	Page 6-13	At least once a month
Check for damaged wires and retighten the terminal block			•	Page 6-14	At least once a month

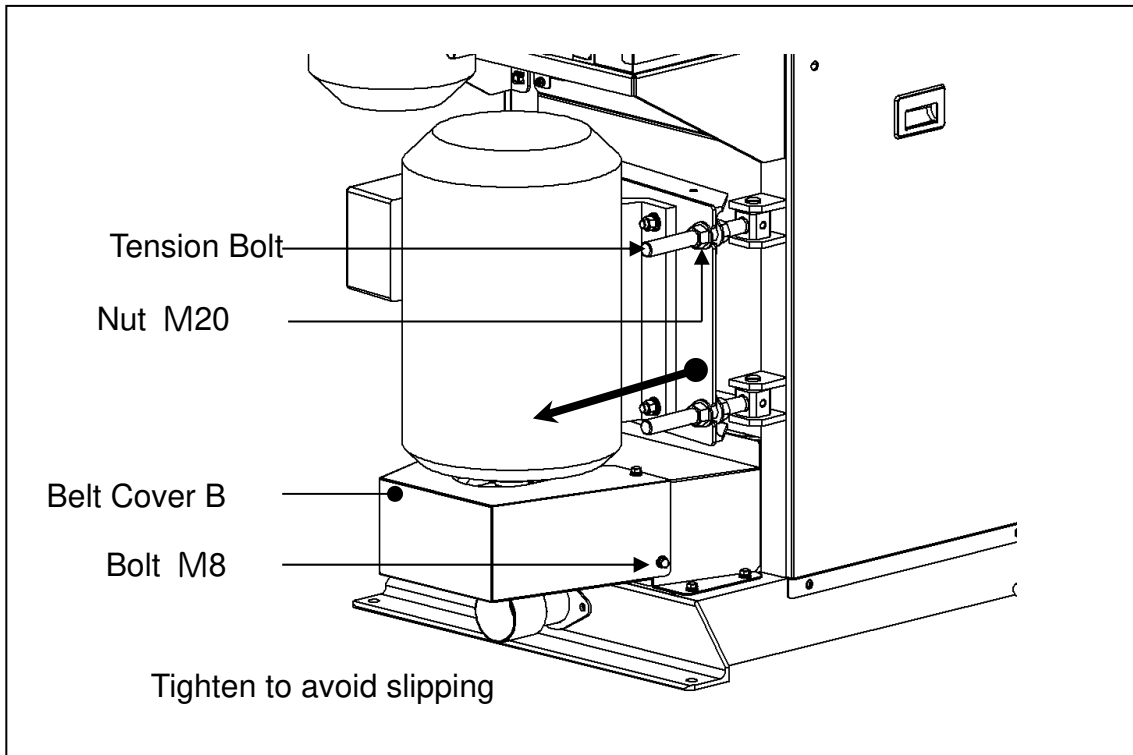
6.2 Check, Adjustment, Maintenance overview

6.2.1 Slack or damage in the Abrasive Motor V-Belt



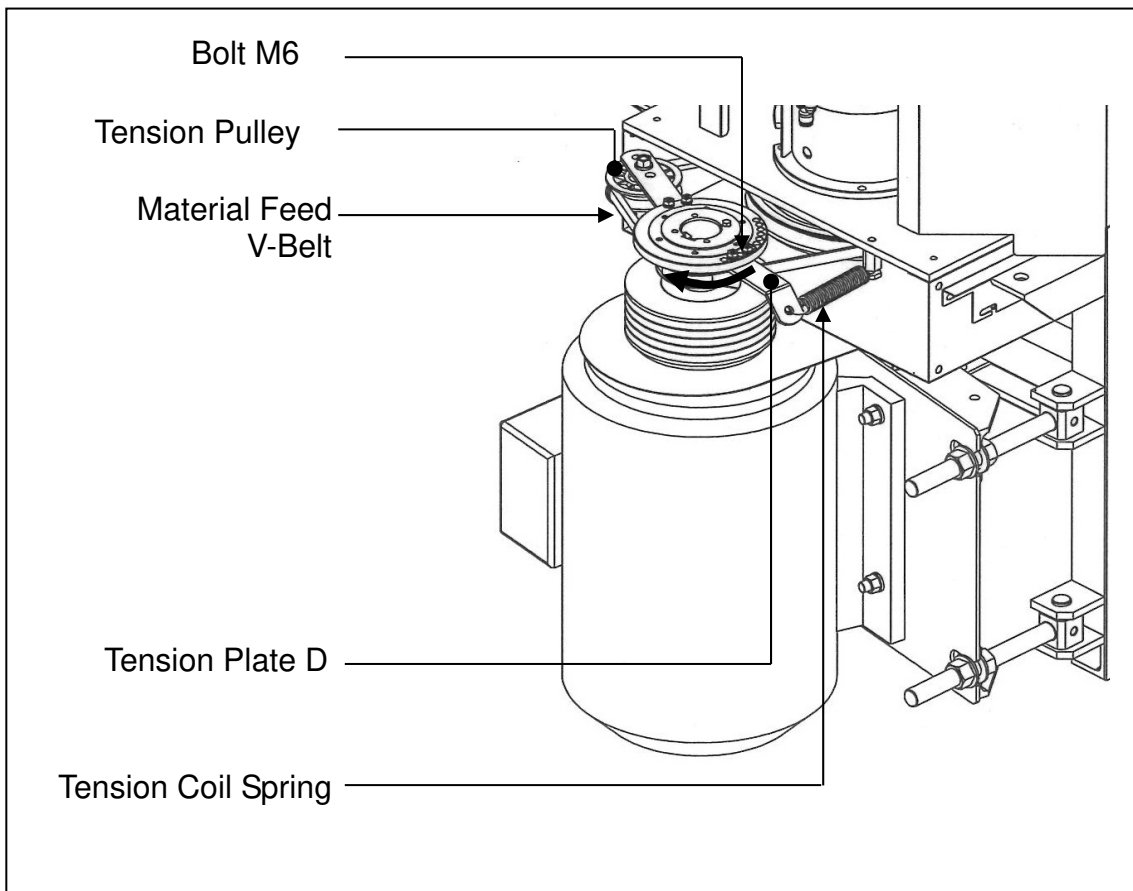
- 1** Remove the Cover H ⇒G⇒J, then Belt Cover D and turn the V-Belt while inspecting for slack or damage.
 - To remove Cover H, G, unfasten the Snap Fastener.
 - Lift the Cover J up and remove it.
 - For the Belt Cover D, remove Bolts M6 (4 pieces) on both sides.
- 2** If there is slack, use accessory wrench 24 to loosen Nut M16 on the Tension Bolts and tighten the Belt to prevent slipping in the direction of the arrow.
If there is damage, replace the V-Belts.
- 3** Tighten Nut M16 firmly.
Reassemble the removed Covers to its original position.

6.2.2 Slack or damage in the Friction Motor V-Belt



- 1** Remove Belt Cover B and turn the V-Belt while checking for slack or damage.
 - For Belt Cover B, remove Bolts M8 (4 pieces) on both sides.
- 2** If there is slack, use accessory wrench 30 to loosen Nut M20 on the Tension Bolts and tighten the Belt to prevent slipping in the direction of the arrow.
If there is damage, replace the V-Belts.
- 3** Tighten Nut M20 firmly.
Reassemble the removed covers to its original position.

6.2.3 Slack or damage in the Material Feed V-Belt



1 Remove Cover G, H, J and Belt Cover D.

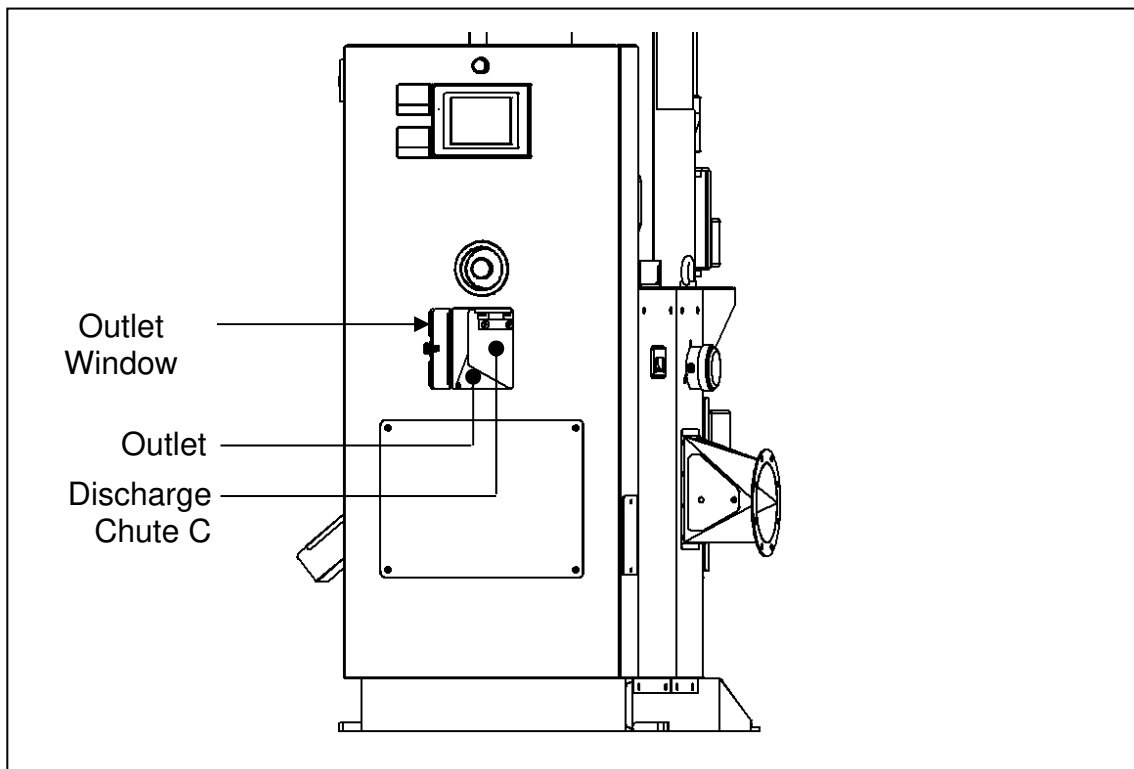
- Refer to P.6-4 **1**

2 If there is slack, remove Bolts M6 (2 pieces) that secure Tension Plate D, alter the mounting position in the direction of the arrow and tighten the V-Belt.

If damaged, remove the Tension Coil Spring, release the Tension Pulley and replace.

3 Reassemble the removed parts in their original positions.

6.2.4 Cleaning the Outlet



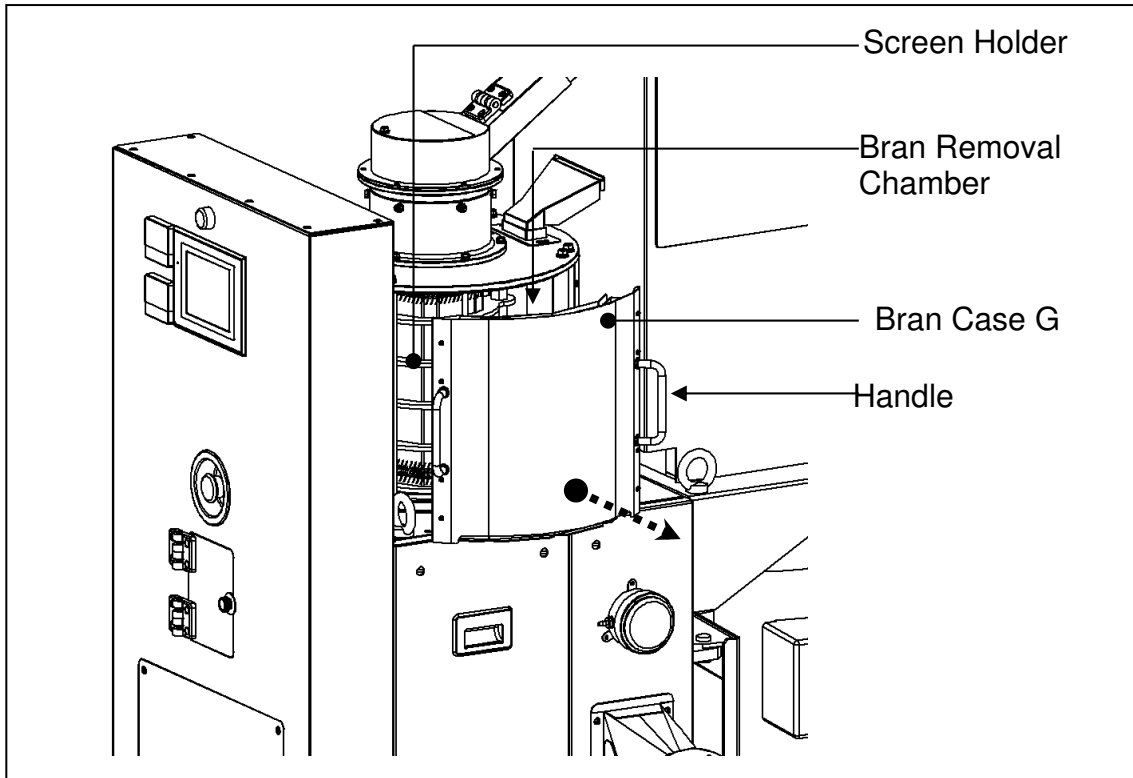
- 1** Open the Outlet Window, pull the Outlet Chute C in front and wipe away any bran attached to the Outlet, back side of Outlet Chute C with a soft cloth.

Note

- Do not use metal scrapers or brushes.
Bran will stick easier to a scratched surface.

- 2** Return position for Outlet Chute C and Outlet Window to its original position.
(Push Outlet Chute C slowly by stopping)

6.2.5 Cleaning the Bran Removal Chamber in the Friction section



- 1** Pull the Handle and remove the Bran Case G and wipe away any bran inside the Bran Cases. (Bran Case G is only fixed with magnet)
 - Clean the opposite side as well.

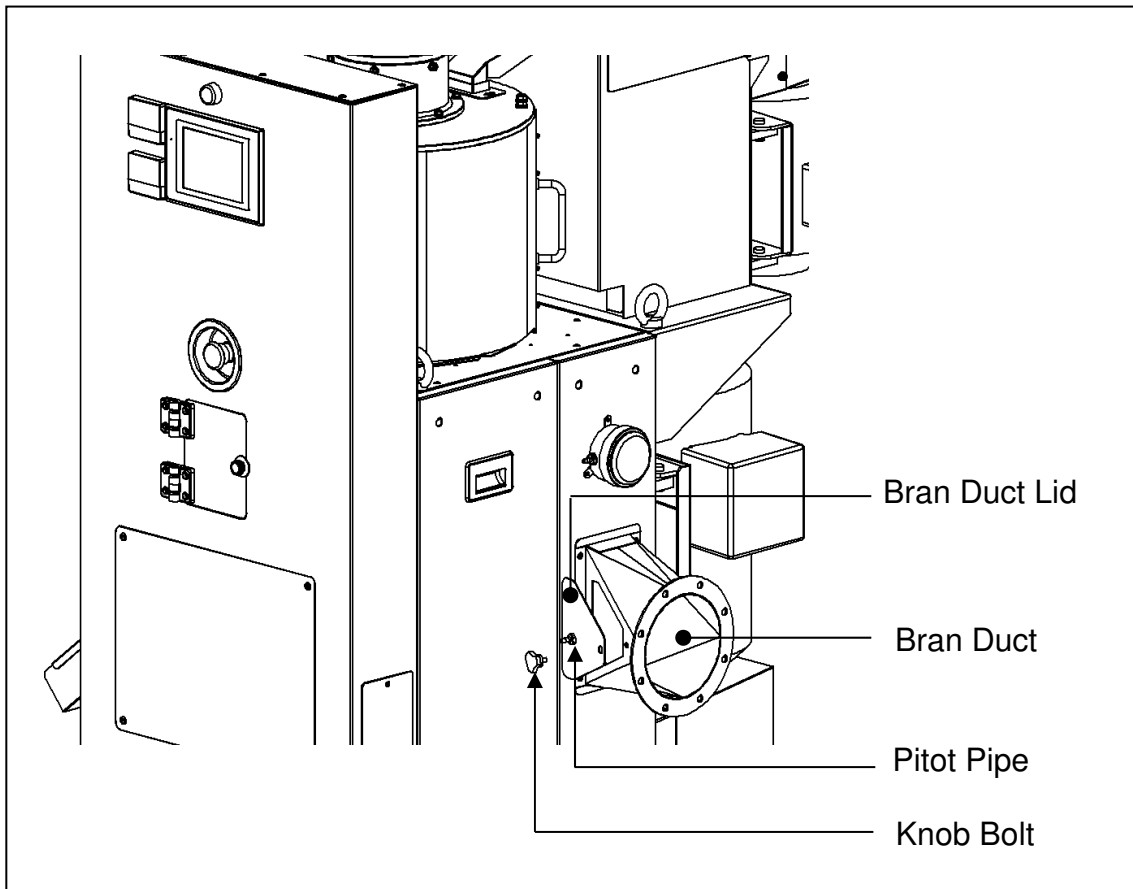
Note

- Do not use metal scrapers or brushes.
Bran will stick easier to scratched surface.

- 2** Using a blow gun or vacuum cleaner, clean any bran on the Bran Removal Chamber, the Screen Holder and the Screens.
 - When using a blow gun, start the Bran removal equipment (bag filter, etc.) at the set static pressure.

- 3** Reassemble Bran Removal Case G in their original positions.

6.2.6 Cleaning the Bran Duct



1 Remove the Knob Bolt and take out the Bran Duct Lid and wipe away the bran inside of the Bran Duct Lid. In case the Pitot Pipe is clogged with bran, remove it.

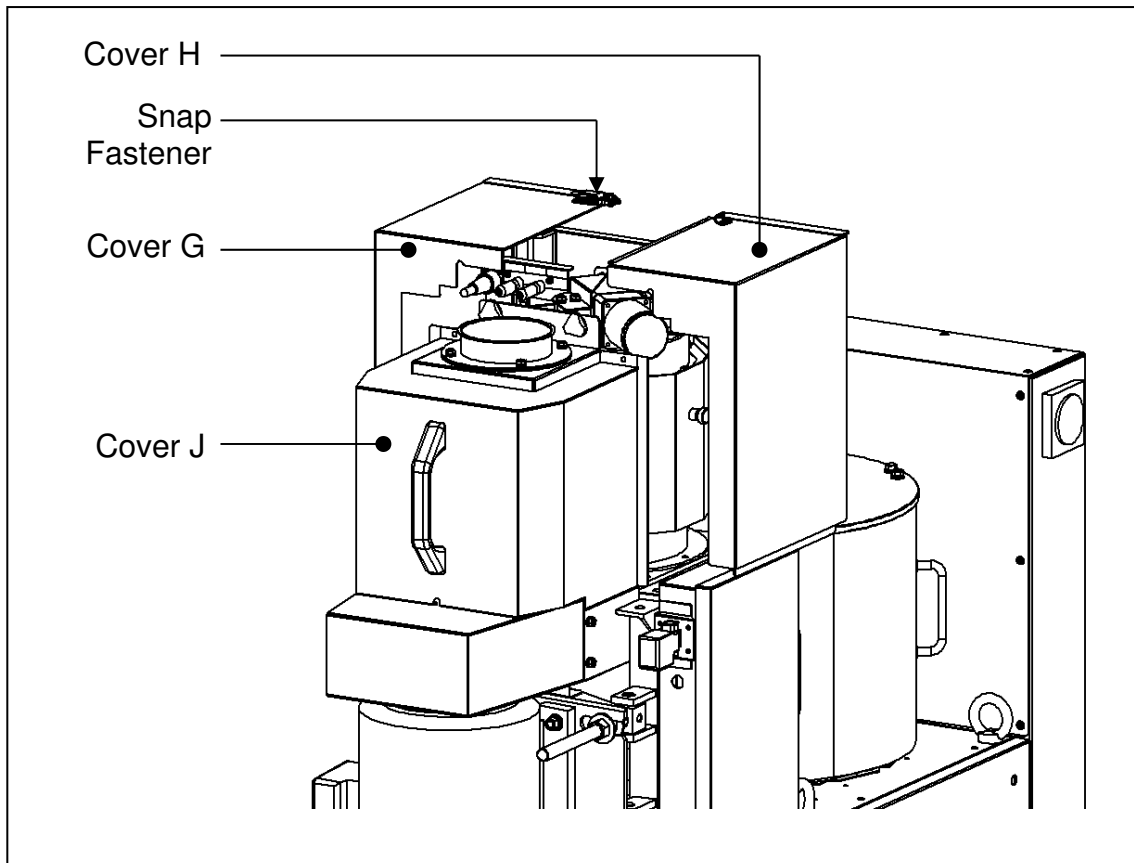
2 Use a blow gun or vacuum cleaner to clean bran inside of the Bran Duct Lid.

Note

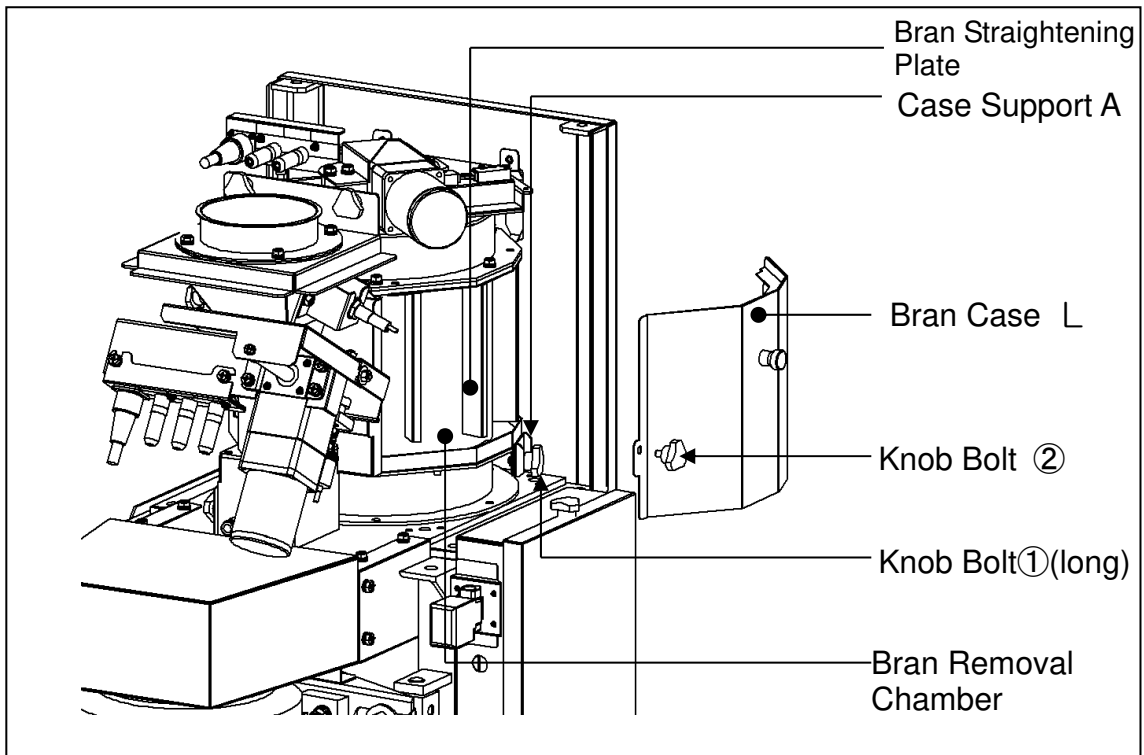
- Do not use metal scrapers or brushes.
Bran will stick easier to a scratched bran duct or bran duct lid.

3 Reassemble the Bran Duct Lid to its original position.

6.2.7 Cleaning the Bran Removal Chamber in the Abrasive section



- 1** Remove Cover G, H and Cover J.
 - Refer to P.6-4 **1** .



2 Loosen the Knob Bolt① , set Case Support A free, and remove the Knob Bolt②, then remove the Bran Case L and K (opposite side). Wipe away any bran inside of the Bran Case.

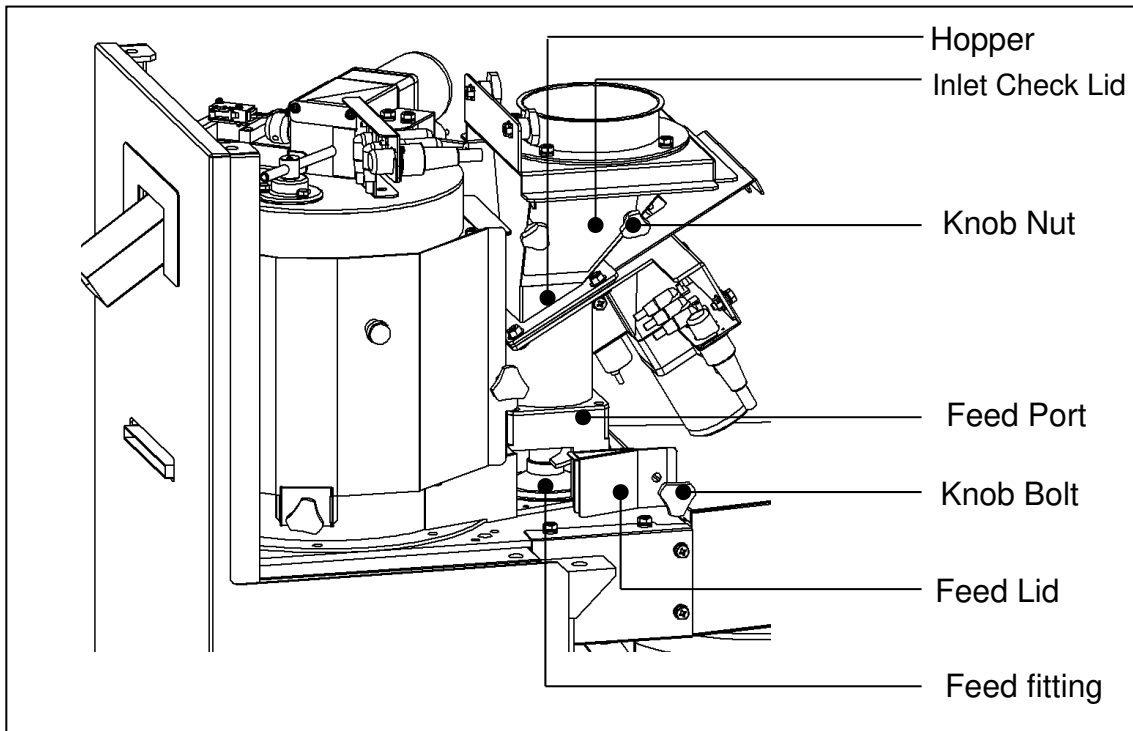
3 Use a vacuum cleaner to clean any bran in the Bran Removal Chamber. Wipe away any bran on the Bran Straightening Plate.

Note

- Do not use metal scrapers or brushes.
Bran will stick easier to a scratched Bran Case or Bran Straightening Plate.
- Please do not bend the Bran Straightening Plate.
If you bend them, bran will clog easily.

4 Reassemble the removed parts in their original positions.

6.2.8 Cleaning the Hopper and Material Feed section



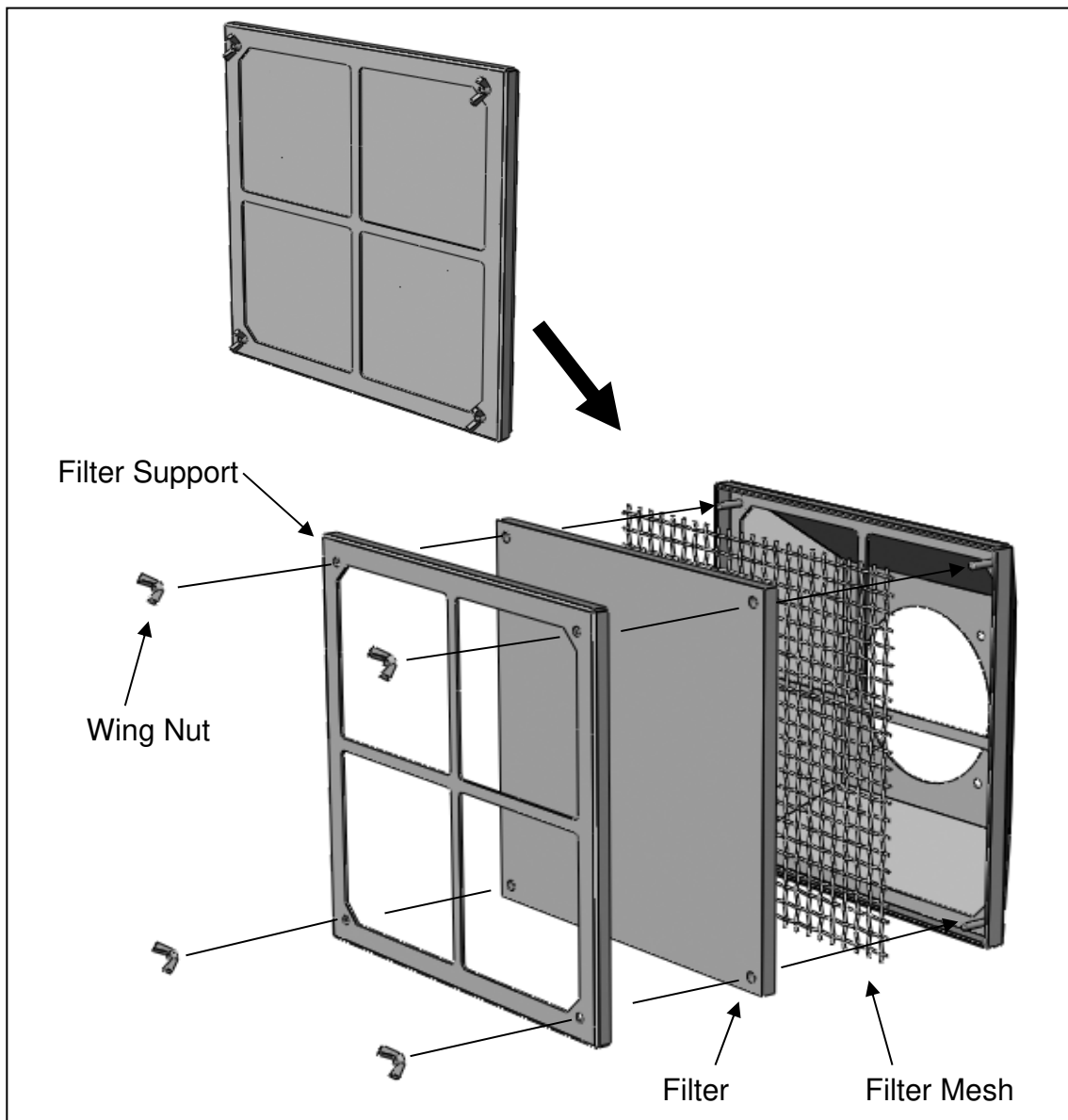
- 1** Remove Cover G, H and J.
 - Refer to P.6-4 **1** for removing Cover G, H and J.

- 2** Remove the one side Knob Nut, loosen the other side Knob Nut and remove the Inlet Check Lid.
Remove any foreign objects (bran ball etc.) in the Hopper.

- 3** Remove the Knob Bolt and remove the Feed Lid, inside the Feed Port and clean the brown rice plaque.

- 4** Reassemble the removed parts in their original positions.

6.2.9 Cleaning the Blower Fan Filter



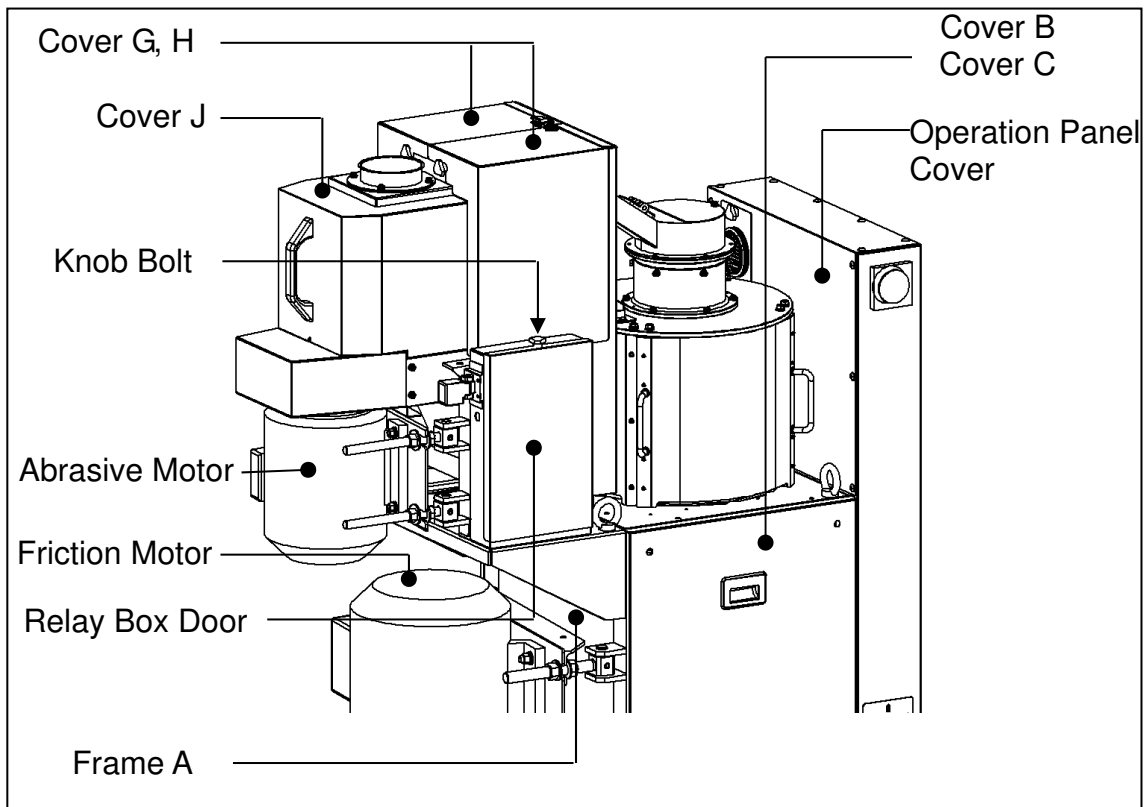
- 1** Vacuum the dust on the filter with a vacuum cleaner. Alternatively, remove the wing nuts (4 pieces), remove the filter, and clean it with a blow gun.
 - Replace it when it is damaged or when the dust cannot be removed.

- 2** Reassemble the parts to their original positions.

Note

- Do not use a blow gun on the filter while the filter is attached to the blower fan.

6.2.10 Checking for damaged wires and retightening the terminal block



- 1** Loosen the Knob Bolt and open the Operation Panel Door then check whether the wires in Relay Box are damaged. Tighten the terminal block.
- 2** Remove the Operation Panel Cover and check the internal wires for damage. Tighten the terminal block.
 - Remove bolts M6 (12 pieces) from the operation panel cover.
- 3** Remove the covers on both sides of the rice mill machine (covers B and C) and inspect the internal wires for damage.
 - For covers B and C, remove the four corner bolts M8 (4 pieces).

- 4** Check the wires inside Frame A for damage.
 - it is the wire that comes out from the back of the rice milling machine and enters the Relay Box, Inlet section and Abrasive section.

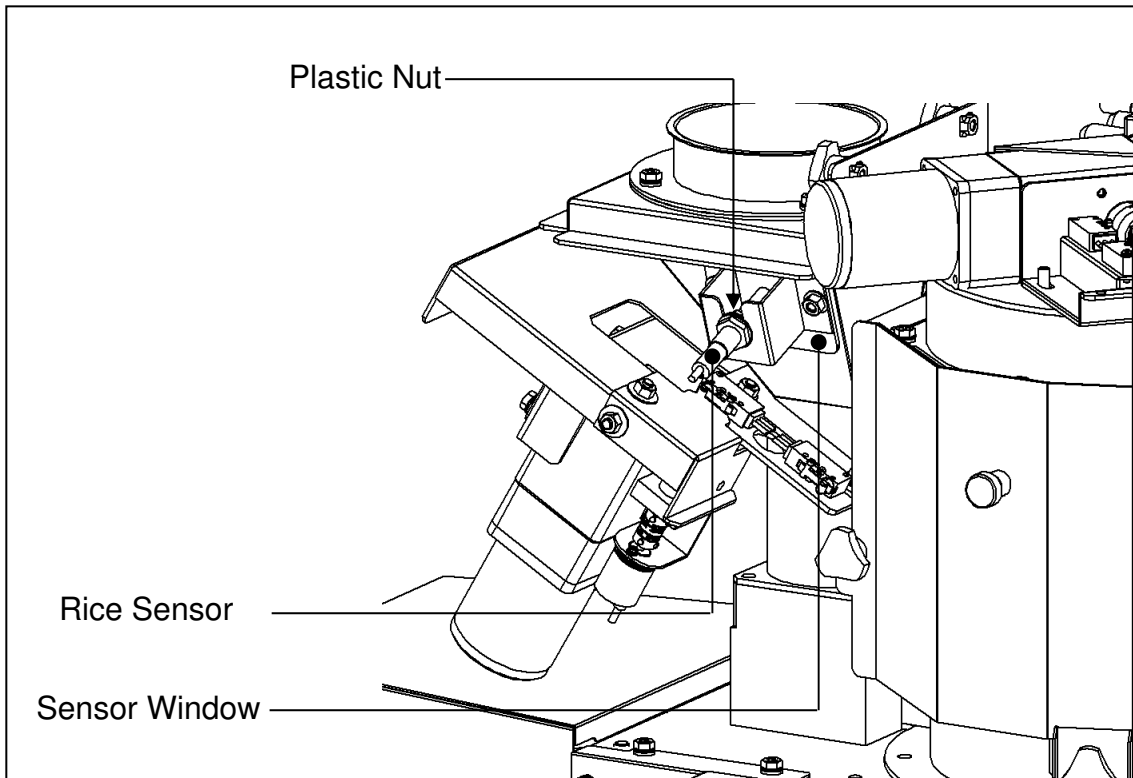
- 5** Remove the Cover G, H and J and check for damage in the wires in the Inlet and Abrasive section.
 - Refer to P.6-4 for removing Cover G, H and J **1** .

- 6** Check the Abrasive Motor, Friction Motor and Blower Motor wires for damage.

- 7** Reassemble the removed parts in their original positions.

6.3 Adjusting the Rice Sensor

- The rice sensor detects whether brown rice is present. If the mounting position is wrong, the rice mill will not stop automatically, or may malfunction by stopping automatically during the milling process, etc.

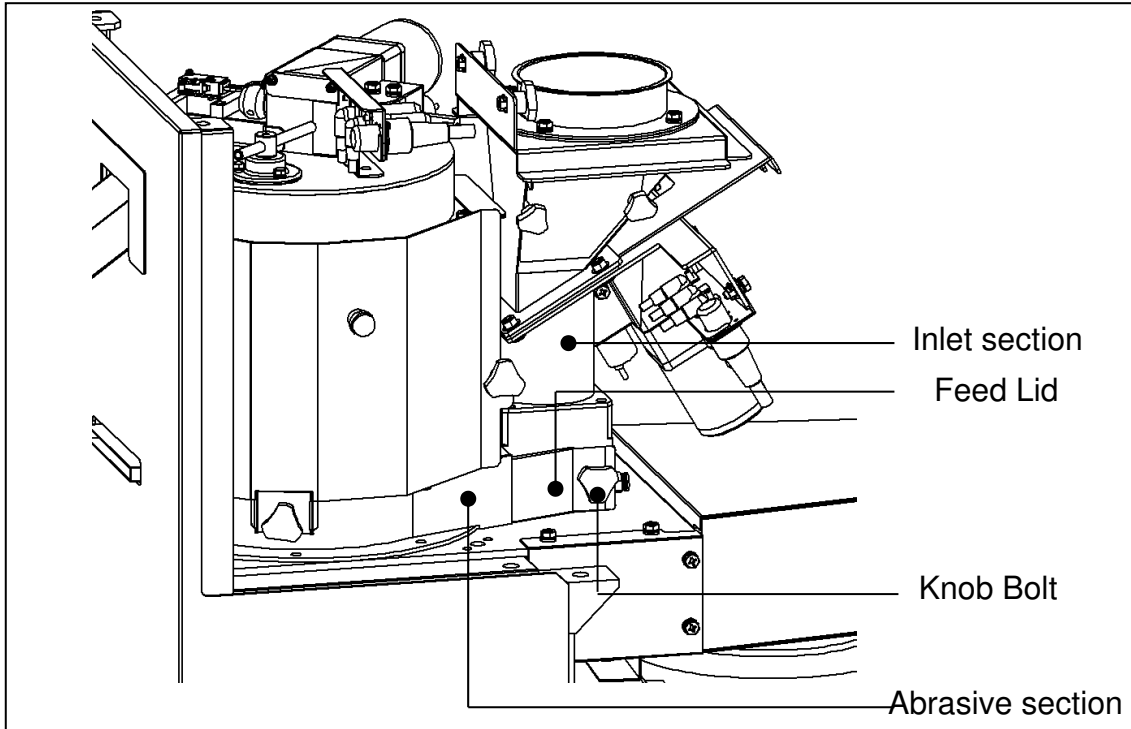


- 1** Loosen the plastic nuts on the raw material sensor and set the sensor approx. 1 mm with the sensor window.
 - Check whether the **Rice** light in the <Milling operations> screen indicates that materials are present in accordance with the presence or absence of raw materials.
 - Increasing the distance from the sensor window will impede detection.

6.4 When rice is stuck

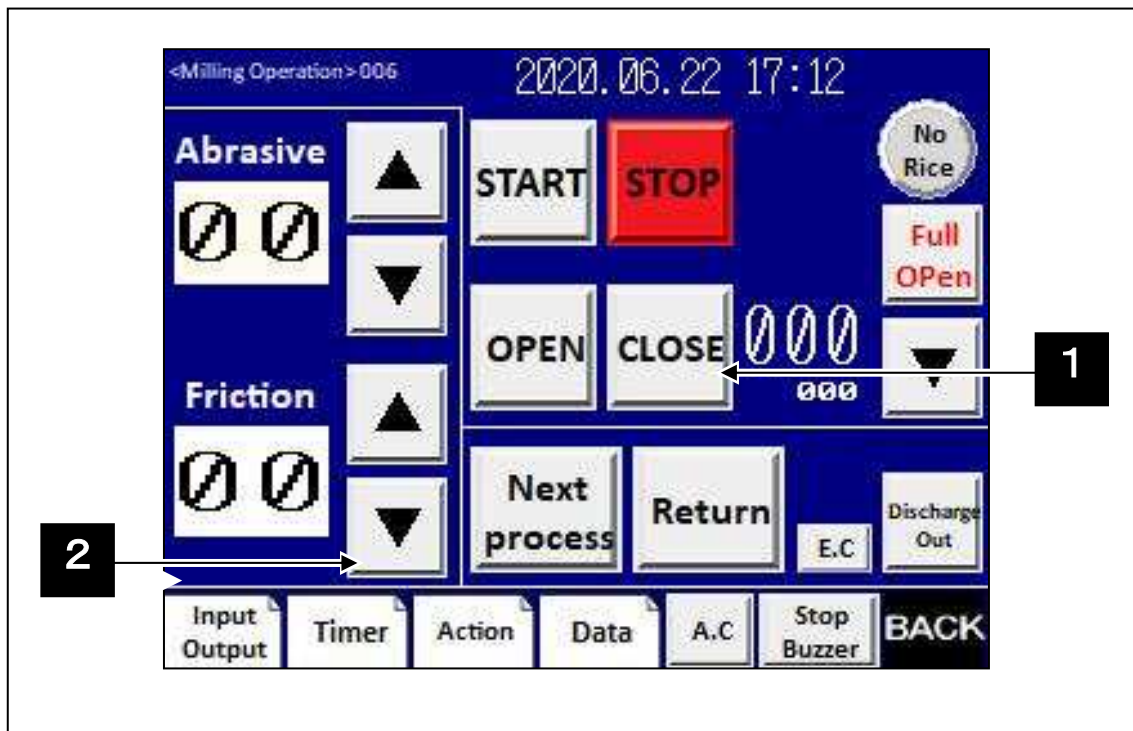
- If rice becomes stuck, remove it using the following procedures.

6.4.1 When rice is stuck in the Abrasive section



- 1** Check whether the inlet is closed.
If open, press the **Inlet close** button to close it.
- 2** Turn the power off and remove the Cover G, H and J.
 - Refer to P.6-4 **1** for removing Cover G, H and J.
- 3** Open the Feed Lid and remove the rice from the Inlet and the Abrasive section.
 - Remove the Knob Bolts from the Feed Lid.
 - After removing the rice, reassemble the removed parts in their original position.
- 4** Reset thermal relay THR3 on the standard power panel.
 - Refer to P.6-19 「6.4.3 Thermal Relay reset」

6.4.2 When rice is stuck in the Friction section



1 Check whether the Inlet is closed.
If it opens, press the **Inlet Close** button to close it.

2 Press the friction resistance **▼ (decrease)** button and set friction resistance to 0.

- Rice is discharged from the friction area.

Note

- If the rice is not discharged, turn the power off and turn the V-belt of the friction motor to discharge the rice. (Refer to **1** on page 6-5 “6.2.2 Slack or damage in the friction motor V-belt”)

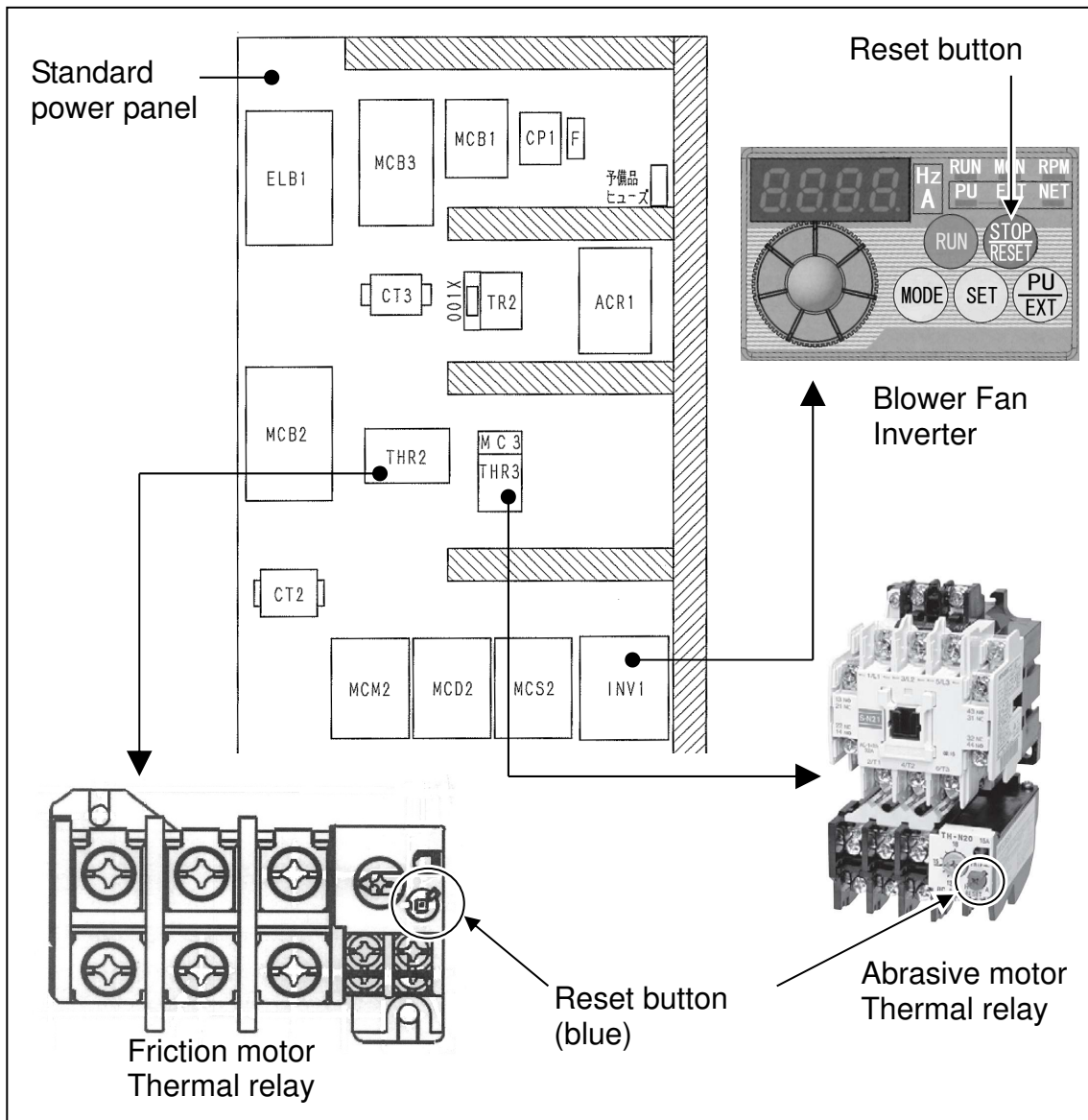
If the rice is still not discharged, remove the screen. (See “7.1.1 Replacing the screen” on page 7-2.)

3 Reset thermal relay THR2 on the standard power panel.

- Refer to P.6-19 「6.4.3 Thermal Relay reset」

6.4.3 Thermal Relay reset

- After removing the stuck rice, reset the thermal relay.
- The figure below provides a description of the optional standard power panel.
If you are not using the standard power panel, follow the handling instructions for the thermal relay you are using.



1 Turn the power off and press reset button THR2 when the Friction motor is clogged (the Friction motor has thermally tripped) and press reset button THR3 when the Abrasive motor is clogged (the Abrasive motor has thermally tripped).

- When it resets, each Motor thermal light on the touch panel will turn off.

2 To reset the Blower Fan Inverter, turn the power off and turn it on again. Or press the STOP/RESET key on the inverter itself.

- Once it resets, Abnormal lamp on the touch panel will turn off.