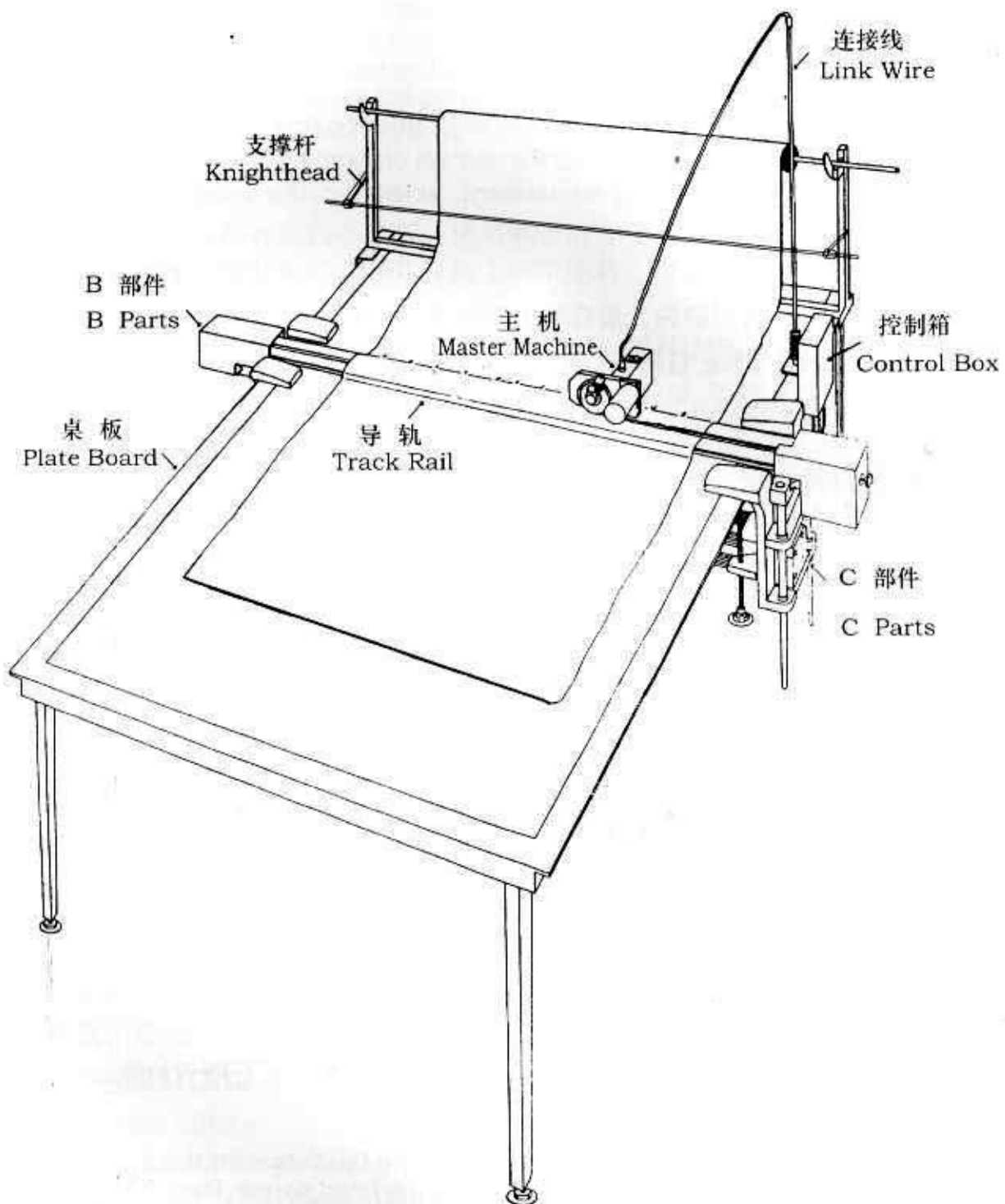


# Auto Track Cutting System

自动断布机



# 检 查

## CHECKING

### A. 调整磨刀砂轮

当砂轮磨不到刀片时，应放松磨刀臂螺钉，调整磨刀砂轮位置，使磨刀砂轮和刀片边缘间有一个适宜的距离，然后锁紧螺钉。

#### ADJUSTING THE GRINDER

When the blade is worn out, adjust the grinder position by unscrewing the screw for the grinder arm so as to ensure a correct distance between the grinder and the blade edge. After finishing adjustment, screw up the screw.

### B. 更换磨刀砂轮

拧下螺钉，取下磨刀砂轮，然后装上新的磨刀砂轮。

#### REPLACING THE GRINDING WHEEL

Take off the grinding wheel by unscrewing it off. Mount the new grinding wheel then.

### C. 更换圆刀片

1. 拿下磨削轮部件。
2. 旋下刀片锁紧螺母。
3. 取下刀片。
4. 当按装新刀片时，应使印有“this side up”的这一面朝向操作者。
5. 装上新刀片后，调整磨削砂轮至适宜位置。

#### REPLACING THE KNIFE

1. Take off the grinding wheel unit.
2. Unscrew the lock nut for the knife.
3. Take off the knife.
4. When mounting the knife, make sure that the side printed with “this side up” should be placed facing the operator.
5. After the blade is replaced, adjust the position of the grinder at the proper.

### D. 更换磨刀垫

1. 旋下磨刀垫固定板螺钉，取下磨刀垫固定板。
2. 拧下磨刀垫螺钉，换上新磨刀垫，确保磨刀垫侧平面贴近圆刀边缘。

#### REPLACING THE LOWER BLADE

1. To take off the lower blade arm by unscrewing the screw for the lower blade arm.
2. Replacing the lower blade by unscrewing the fixed screw. Replace the lower blade and ensured the flat surface of the lower blade adjacent to the blade edge.

## E. 更换碳刷

1. 碳刷的磨损会引起电机的故障，当碳刷磨得只剩下5至6 mm时，必须更换碳刷。
2. 用螺丝刀旋下碳刷螺母，更换碳刷。
3. 须同时更换左右碳刷。
4. 更换时，接线弹簧须钩住碳刷壳金属部件。

### REPLACE OF CARBON BRUSH

1. Too much weaving of carbon brush will cause motor troubles. Carbon brush must be replaced when it wears to 5~6mm.
2. Carbon brush cap is replaced by truning it left by attached wrench.
3. Always replace right and left carbon brushes simultaneously.
4. Be sure to hold metallic part of the brush.

## F. 清洁导轨和主机

1. 当断布机连续工作10至20小时后，须用刷子清除导轨上遗留下的织物。
2. 当断布机连续工作30天后，须从导轨上拆下主机，用刷子逐一清洁各导轨槽，清洁后，装回主机。

### CLEAN THE TRACK AND THE MASTER MACHINE

1. Clean all the wasted cotton and cloth in the track with a brush thoroughly after the machine is continuously running for 10 to 20 hours.
2. To take the master machine of the track and thoroughly clean the L-type track with a brash after the machine is continuously running for 30 days. Repeatedly clean it as shown in Item. To mount the master machine in the track groove again after cleanness is ensured.

## G. 注意:

1. 操作前，应检查导轨平面是否干净。
2. 为安全起见，应装有接地线。

### CAUTIONS:

1. Beforing operating the machine, make sure of complete cleanness of the track surface.
2. Safety electric ground wire is used for the sake of safety.

## H. 规格:

刀片直径: 108mm

电压: 单向110V/60HZ 或 220V-240V/50HZ

刀片转速: 12000转/分

刀片形状: 圆形

输出功率: 130W

### SPECIFICATIONS

Side of Blade: 108mm

Electric Pressure: Single phase 110V/60HZ or 220V-240V/50HZ

Revolving speed of the Knife: 12000 r.p.m

Shape of the Blade: Round

Output: 130W

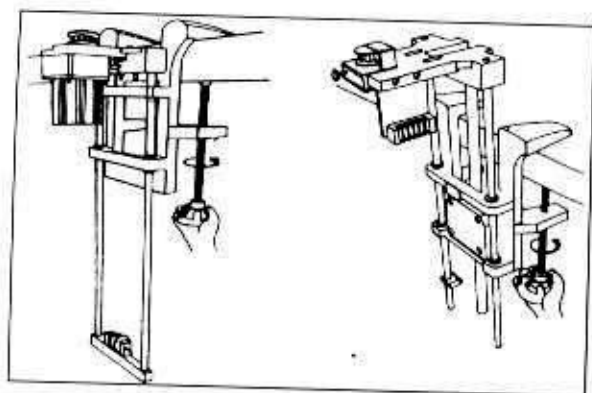


图 1

**1** 当支架位置正确后，应按左图所示旋紧手柄夹紧桌板。

◆ 注意：  
装在支承轴下端的限位开关必须朝着正确的方向。

After turning the handle to the right, fix clamp on the plate board.

◆ Caution  
Limit switch that is installed below the track in the control box should be always placed to the direction of polishing.

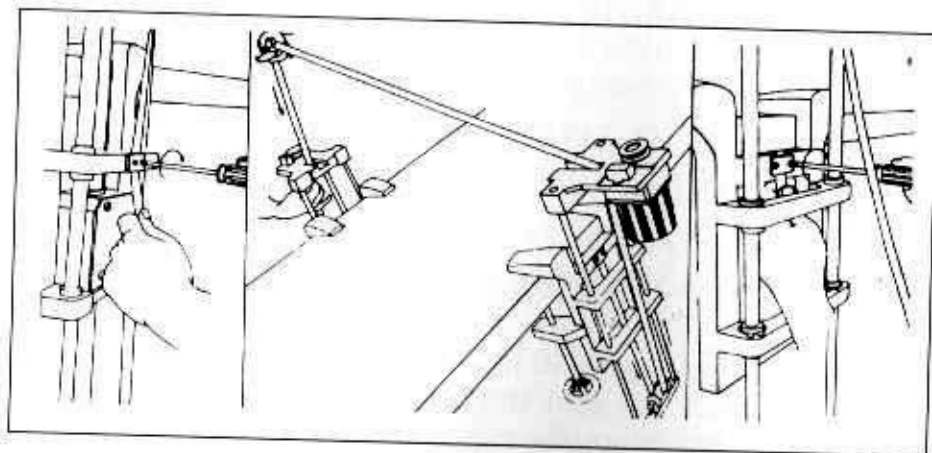


图 2

**2** 按图示方法，当悬挂

好带后，应在保持带水平下将带的两端用压板压紧。

Brake & reverse area

After hanging poly belt (green belt) on the reverse area, it should be fixed by holding the ends of both horizon to link with brake area as can be shown in the side picture.

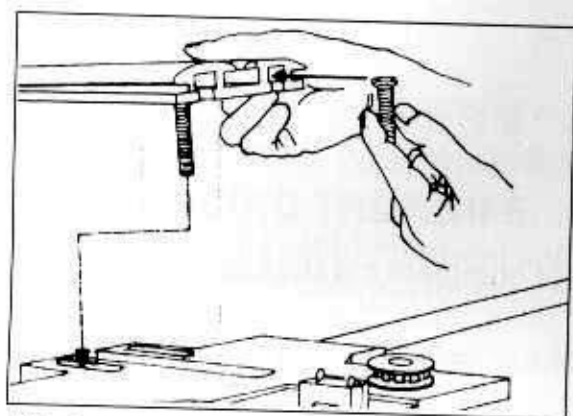


图 3

**3** 正确放置好铝导轨，然后按图示方向装上六角螺栓。

◆ 注意：  
装六角螺栓时，你应同时装上垫圈和六角螺母。

Put aluminum track normally on both sides, then hang the hexagonal track bolt to the direction of the picture.

◆ Caution  
Hanging the hexagonal track bolt, you should just hang nuts for washer without inserting.

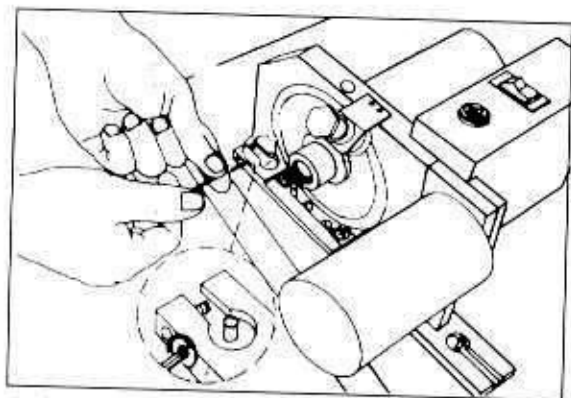
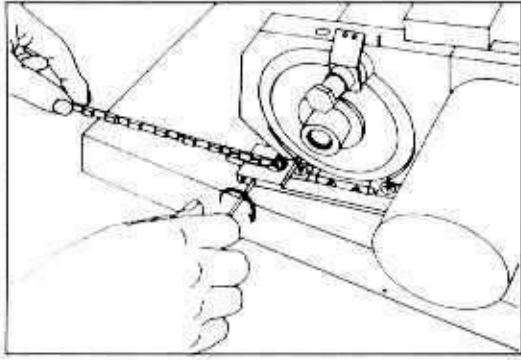


图 4

**4** 当正确装好主机后，应放松底板上的紧定螺钉。见图。

After putting knife box in normal way, release the 2.0mm range bolt to the left side.

图 5



**5** 把同步带弯成U形套在弹簧销上，再锁紧紧定螺钉。

Using range 2.0mm, the black belt should be fasten to the right with U-type pen.

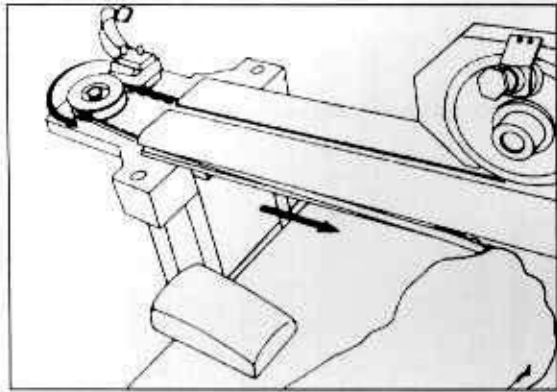


图 7

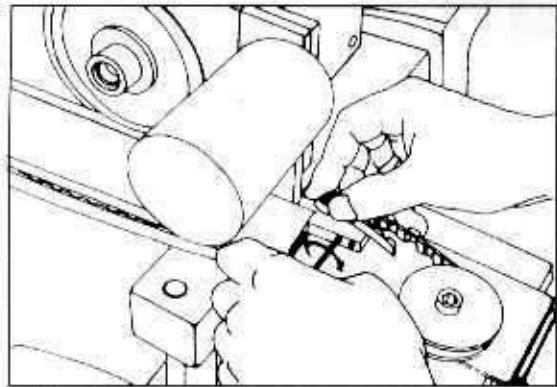


图 8

**9** 放上电线支架后，应旋紧手柄，夹紧桌板。

After put the wire supporting right, fix clamp the plate board.

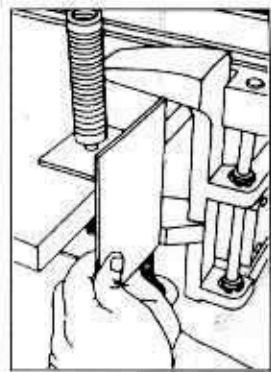
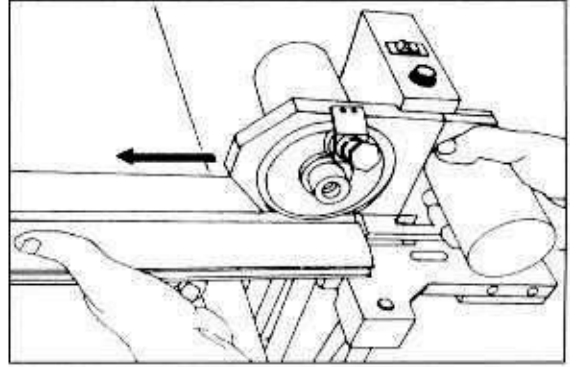


图 9

图 6



**6** 按图示方向，将主机装入导轨。

Front area of knife box should be headed for reverse side to put into the track.

**7** 按住主机，把同步带绕过同步带轮，再引入铝导轨的凹槽。

◆ 注意：  
不应扭转同步带。

In the state of standstill of aluminum box, you should hold on gear belt to turn to the reverse side, pushing the gear belt into the groove on the side of aluminum track.

◆ Caution  
Be careful not to the gear belt get twisted.

**8** 把绕回的同步带连接到底板的另一端后，再锁紧紧定螺钉。

◆ 注意：  
多余的同步带应用剪刀剪掉。

Fasten the inserted gear belt on the back part of knife box, using the 2.0mm range, after linking with timing pulley on the brake area.

◆ Caution  
The remained gear belt should be cut out with scissors.

**10** 把电线装入按装空心管的弹簧入口，再把3线插座插入主机盒上的3线插口。

Insert antenna suitably into the entrance of spring of the supporting bar for antenna. 3p jack should be inserted into the knife box 3p jack.

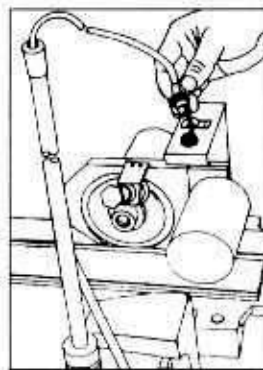


图 10

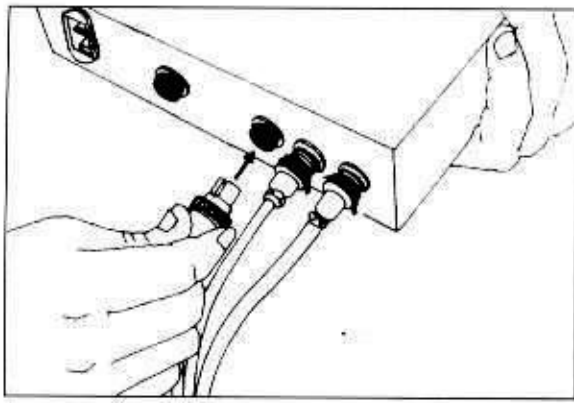


图 11

## 11 电线底端的3线插口应与控制箱底端的3线插口连接。

3p jack of bottom area of antenna should be inserted into the 3p jack of left area of control box.

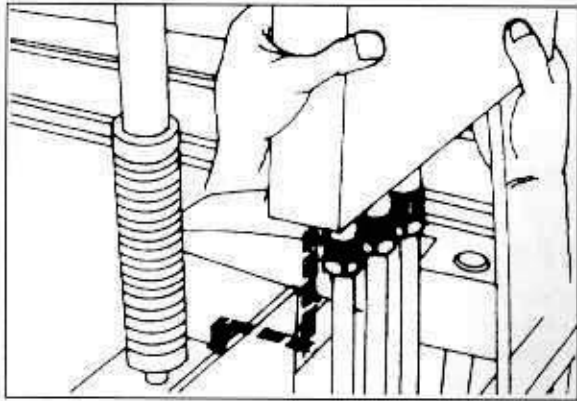


图 12

## 12 把控制箱沿着电线支承座后板边缘装入。见图。

Put control box adequately into the supporting bar for antenna.

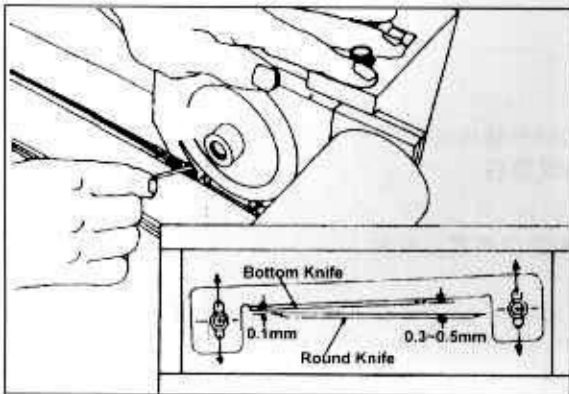


图 13

## 13 调节磨刀垫 当磨刀垫和旋转圆刀的间隙变得越来越大时，你应该重新调整磨刀垫，使间隙在图示范围内，从而使机器断布更完美。

When the interval between fixed bottom and rotation round knife becomes bigger, you should regulate the knife by using range to make enable perfect cutting.

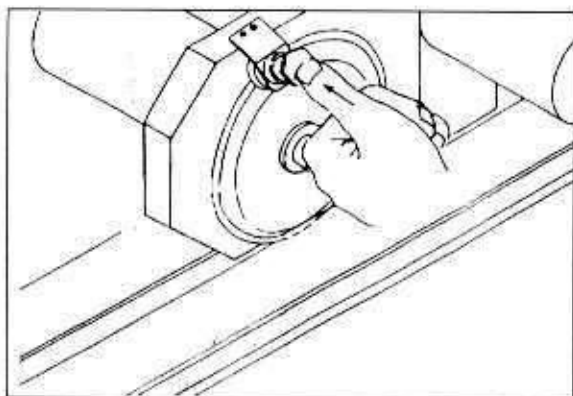


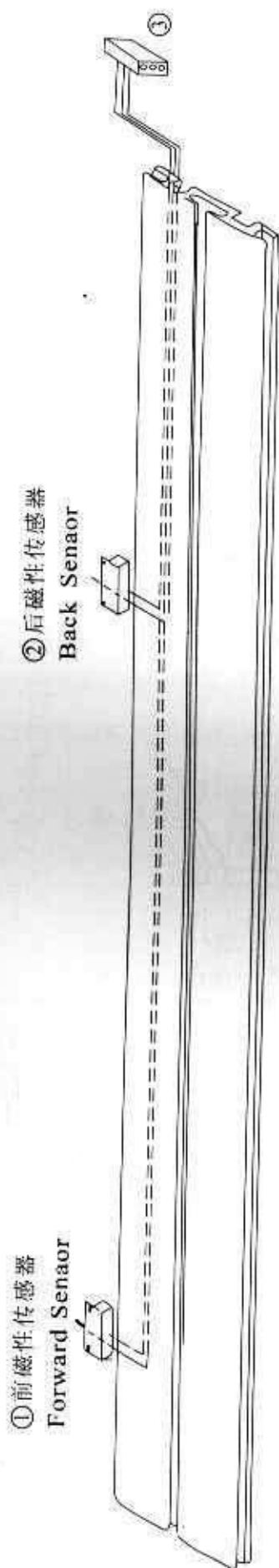
图 14

## 14 当砂轮磨不到刀片时，应放松磨刀臂螺钉，调整磨刀砂轮位置，使磨刀砂轮和刀片边缘间有个适宜的距离，然后锁紧螺钉。

Polishing of round knife

When material can not be cut suitably or polishing of rotating round knife is needed, you should operate on/off switch of knife box to press 2 or 3 times by using the outside parts of grindstone.

## 接线图解/WIRING DIAGRAM



(1)当长度设定超出最大值时，前磁性传感器 1 将阻止主机冲出导轨。

(2)主机返回时，后磁性传感器 2 用来定主机停止位置。

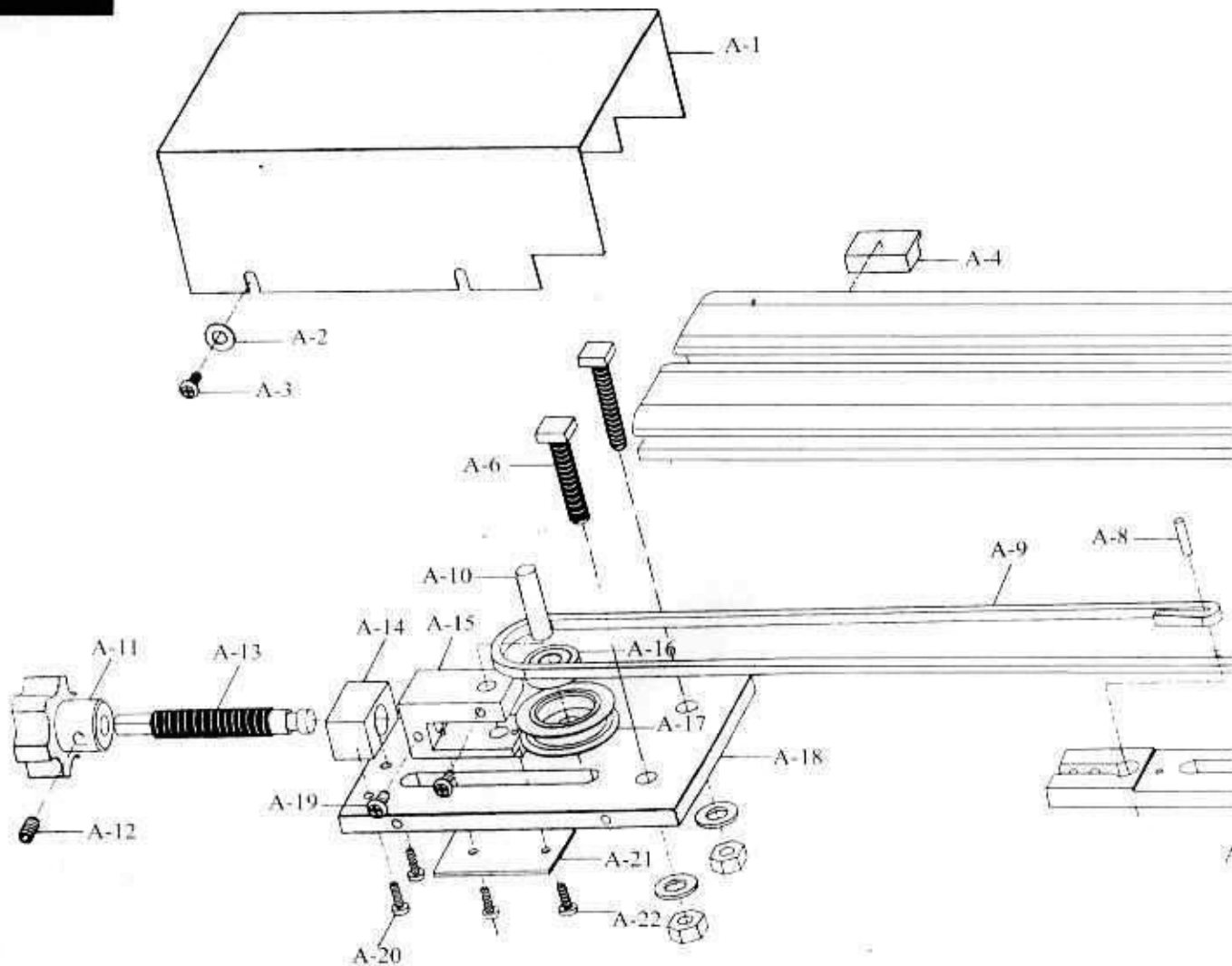
(3)3 为磁性传感器线连接盒。

(1)No. 1 forward sensor prevents from breakaway of knife even when the cutting length set up to the maximum.

(2)No.2 back sensor is placed on the position where the knife motor comes back.

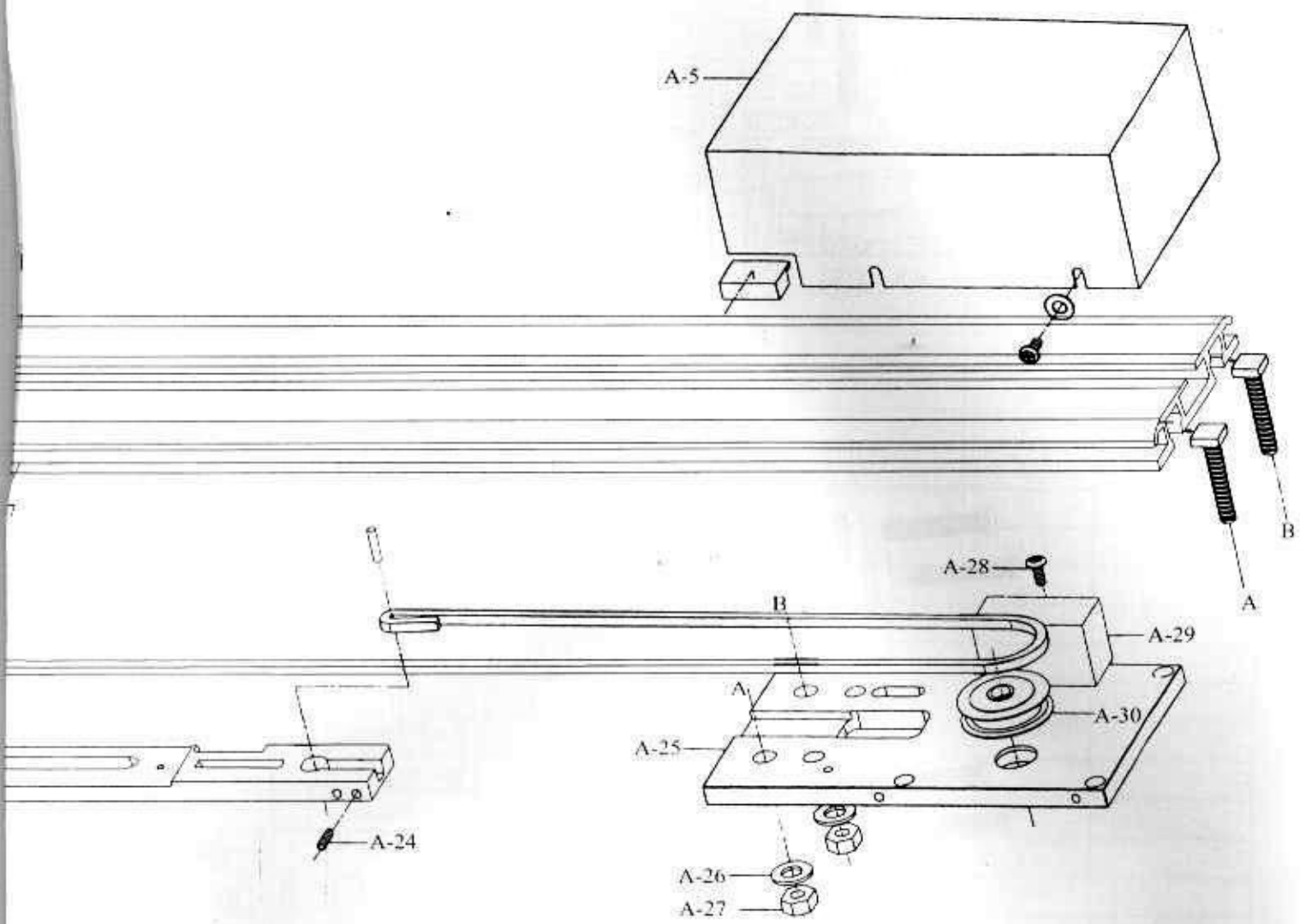
(3)No.3 is a connect box of forward sensor and back sensor wire.

# A



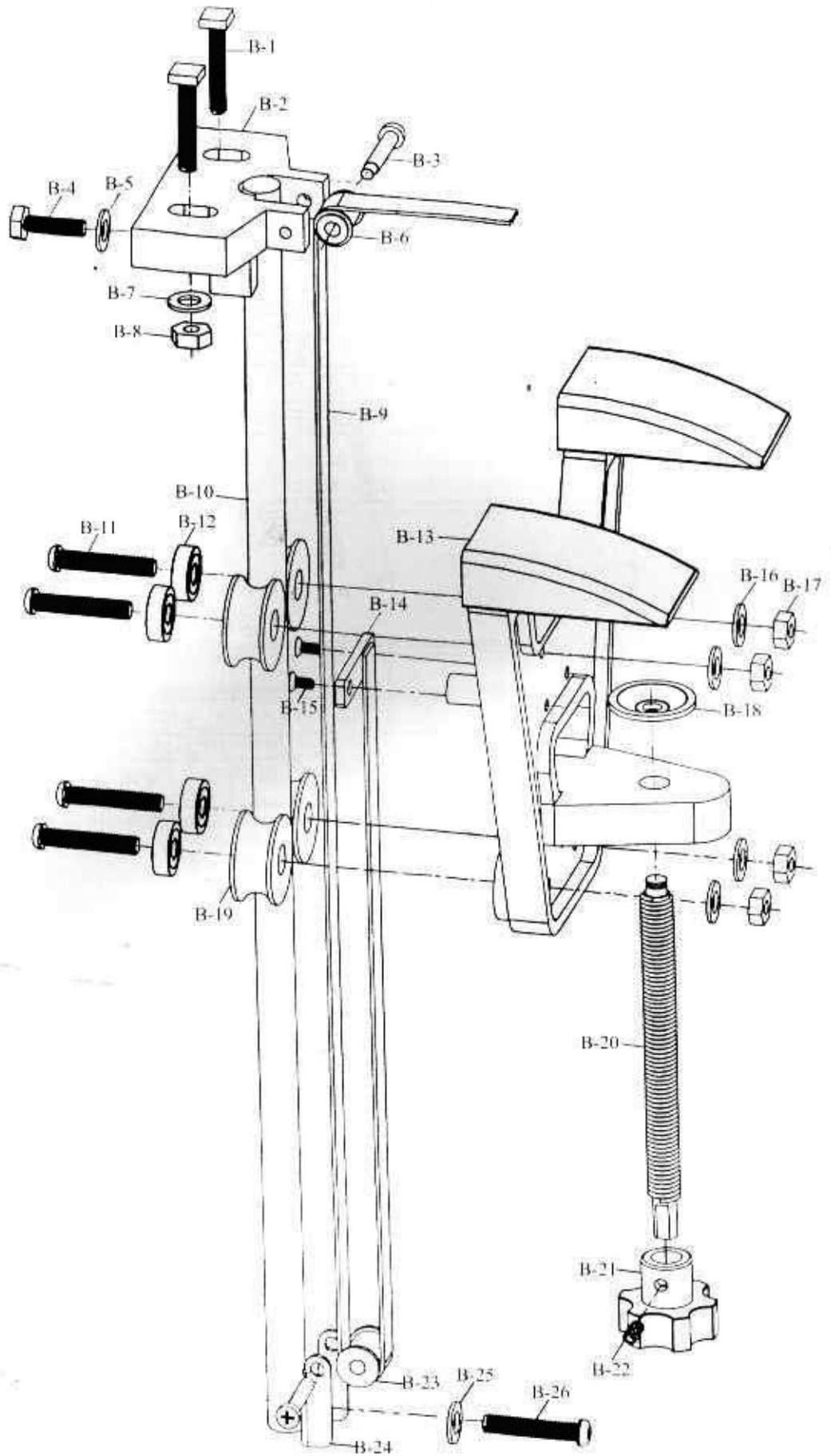
Ref.no 序号	Name of parts	名 称	Q'ty 数量	Remarks 备注
A-1	Rear Cover	后罩壳	1	
A-2	Washer	垫圈	8	
A-3	Screw	螺钉	8	
A-4	Lead Switch	导向开关	2	
A-5	Front Cover	前罩壳	1	
A-6	Bolt	螺栓	4	
A-7	Aluminum Track Rail	导轨	1	
A-8	Spring Pin	弹簧销	2	
A-9	Gear Belt	同步带	1	
A-10	Tension Wheel Shaft	涨紧轮轴	1	
A-11	Handle Bolt	调节手柄	1	
A-12	Set Screw	紧定螺钉	1	
A-13	Handle Bolt	螺杆	1	
A-14	Fixing Block	固定块	1	
A-15	Tension Wheel Plate	涨紧轮座	1	





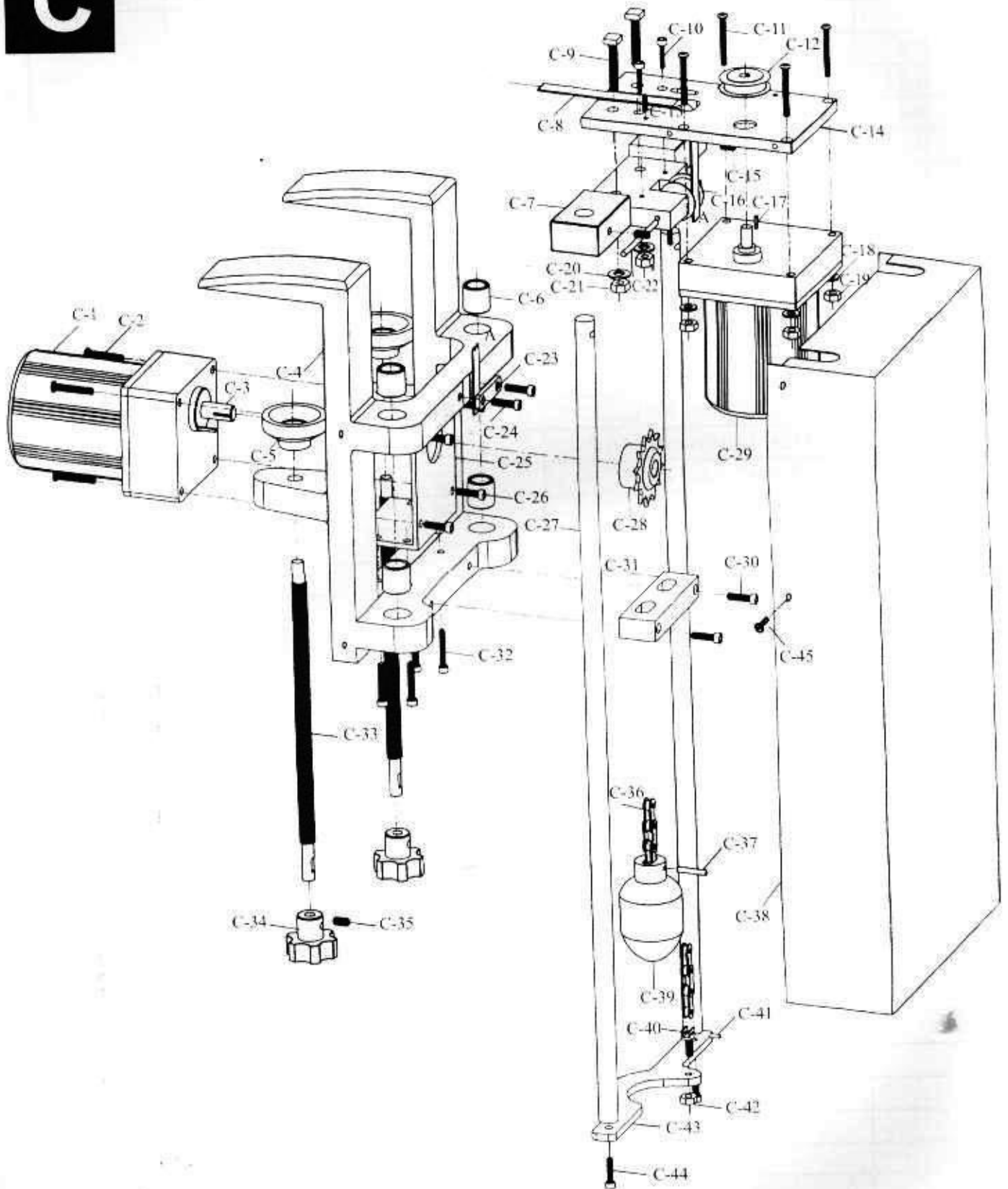
Ref.no 序号	Name of parts	名称	Q'ty 数量	Remarks 备注
A-16	Bearing	轴承	1	
A-17	Timing Gear	从动同步带轮	1	
A-18	Idler Pulley Plate	导轮板	1	
A-19	Screw	螺钉	2	
A-20	Screw	螺钉	2	
A-21	Lock Plate	固定板	1	
A-22	Screw	螺钉	4	
A-23	Lower Knife Fixation Metal	底板	1	
A-24	Set Screw	紧定螺钉	4	
A-25	Break Cramp Base	支承板	1	
A-26	Washer	垫圈	4	
A-27	Nut	螺母	4	
A-28	Screw	螺钉	1	
A-29	Electric Condenser	电容器	1	
A-30	Reverse Timing Gear	主动同步带轮	1	

**B**



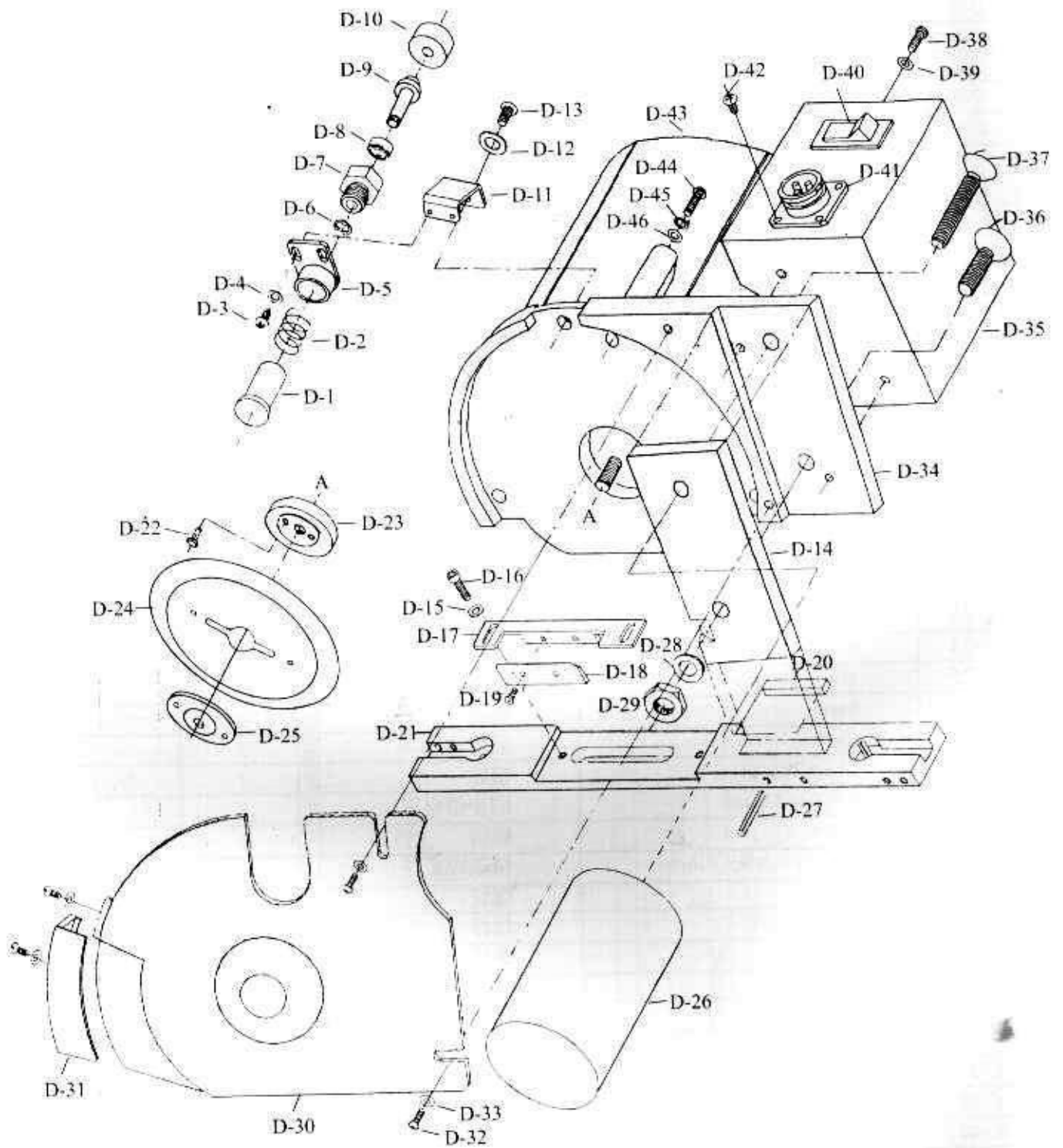


C



Ref.no 序号	Name of parts	名 称	Qty 数 量	Remarks 备 注
C-1	Brake Motor	升降电机	1	
C-2	Bolt	螺栓	4	
C-3	Key	键	1	
C-4	Brake Cramp	升降电机架	1	
C-5	Handle Dish	压板	2	
C-6	Bushing	衬套	4	
C-7	Idler Puller Plate	导轮板	1	
C-8	Poly Belt	牵引带	1	
C-9	Bolt	螺栓	1	
C-10	Screw	螺钉	2	
C-11	Screw	螺钉	2	
C-12	Reverse Timing Gear	主动同步带轮	1	
C-13	Set Screw	紧定螺钉	1	
C-14	Reverse Cramp Base	同步带电机板	1	
C-15	Set Screw	紧定螺钉	1	
C-16	Roller	滚轮	1	
C-17	Key	键	1	
C-18	Washer	垫圈	4	
C-19	Nut	螺母	4	
C-20	Washer	垫圈	2	
C-21	Nut	螺母	2	
C-22	Pin	芯轴	1	
C-23	Poly Belt Fixation Metal	带压板	1	
C-24	Screw	螺钉	2	
C-25	Motor Fixing Plate	电机固定板	1	
C-26	Screw	螺钉	4	
C-27	Shaft	后支承轴	2	
D-28	Chain Wheel	链轮	1	
C-29	Reverse Motor	同步带电机	1	
C-30	Screw	螺钉	2	
C-31	Chain Fixation Block	链条固定块	1	
C-32	Screw	螺钉	4	
C-33	Handle Bolt	螺杆	2	
C-34	Handle	手柄	1	
C-35	Set Screw	紧定螺钉	1	
C-36	Chain	链条	1	
C-37	Pin	销	1	
C-38	Guard	防护罩	1	
C-39	Loll Block	垂块	1	
C-40	Chain Bolt	链条螺栓	1	
C-41	Pin	销	1	
C-42	Nut	螺母	1	
C-43	Sinus Plate	弯板	1	
C-44	Screw	螺钉	1	
C-45	Screw	螺钉	4	

# D



Ref.no	Name of parts	名 称	Q'ty	Remarks
序 号			数 量	备 注
D-1	Sharpening Switch	磨刀按钮	1	
D-2	Grind Return Spring	弹簧	1	
D-3	Screw	螺钉	2	
D-4	Washer	垫圈	2	
D-5	Fixer	固定套	1	
D-6	Retaining Ring	卡簧	1	
D-7	Cylindrical Screw	锁紧螺钉	1	
D-8	Bearing	轴承	1	
D-9	Mandril	芯轴	1	
D-10	Grind Stone	砂轮	1	
D-11	Grind Fixation Metal	砂轮架	1	
D-12	Washer	垫圈	1	
D-13	Screw	螺钉	1	
D-14	Balance Weight Stay Metal	立板	1	
D-15	Washer	垫圈	2	
D-16	Screw	螺钉	2	
D-17	Knife Frame	磨刀垫固定板	1	
D-18	Fixation Knife	磨刀垫	1	
D-19	Set Screw	磨刀垫螺钉	2	
D-20	Sense Magnet	磁铁	1	
D-21	Kinfe Bottom Metal	底板	1	
D-22	Pin	刀片传动销	2	
D-23	Knife Transmission Wheel	刀片传动轮	1	
D-24	Circle Knife	刀片	1	
D-25	Knife Screw Nut	刀片锁紧螺母	1	
D-26	Balance Weight	平衡柱	1	
D-27	Spring Pin	弹簧销	2	
D-28	Screw	垫圈	1	
D-29	Nut	螺母	1	
D-30	Knife Guard	刀片防护罩	1	
D-31	Knife Edge Guard	刀头防护罩	1	
D-32	Screw	螺钉	4	
D-33	Washer	垫圈	4	
D-34	Knife Rest	刀架	1	
D-35	Switch Box	开关盒	1	
D-36	Screw	螺钉	1	
D-37	Hexagon Screw	平衡柱螺钉	1	
D-38	Screw	螺钉	1	
D-39	Washer	垫圈	1	

