

# 录 CONTENTS

J-120

*нарезание косой бледки*

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# 使用说明 / OPERATING INSTRUCTIONS

## 一. 切带机简介

1. 120型切带机是缝制业裁剪带状织物料（如化纤、棉织物）的专用设备，特别适用于裁剪裤耳、背包、书包带等。裁剪物切口整齐、光滑、无毛刺。裁剪物长度一致。

### 2. 主要技术参数 / SPECIFICATIONS:

机型 Model	剪切长度 Cutting Length	误差 Error	剪切宽度 Cutting Width	布料剪切厚度 Cutting Thickness for Cloth	转速 Speed	电机功率 Motor Power	加热功率 Heating Power
120	0-1500mm	±1%	<50mm	<3mm	<23r/min	250W	无
120R	0-1500mm	±1%	<50mm	<3mm	<23r/min	250W	250W

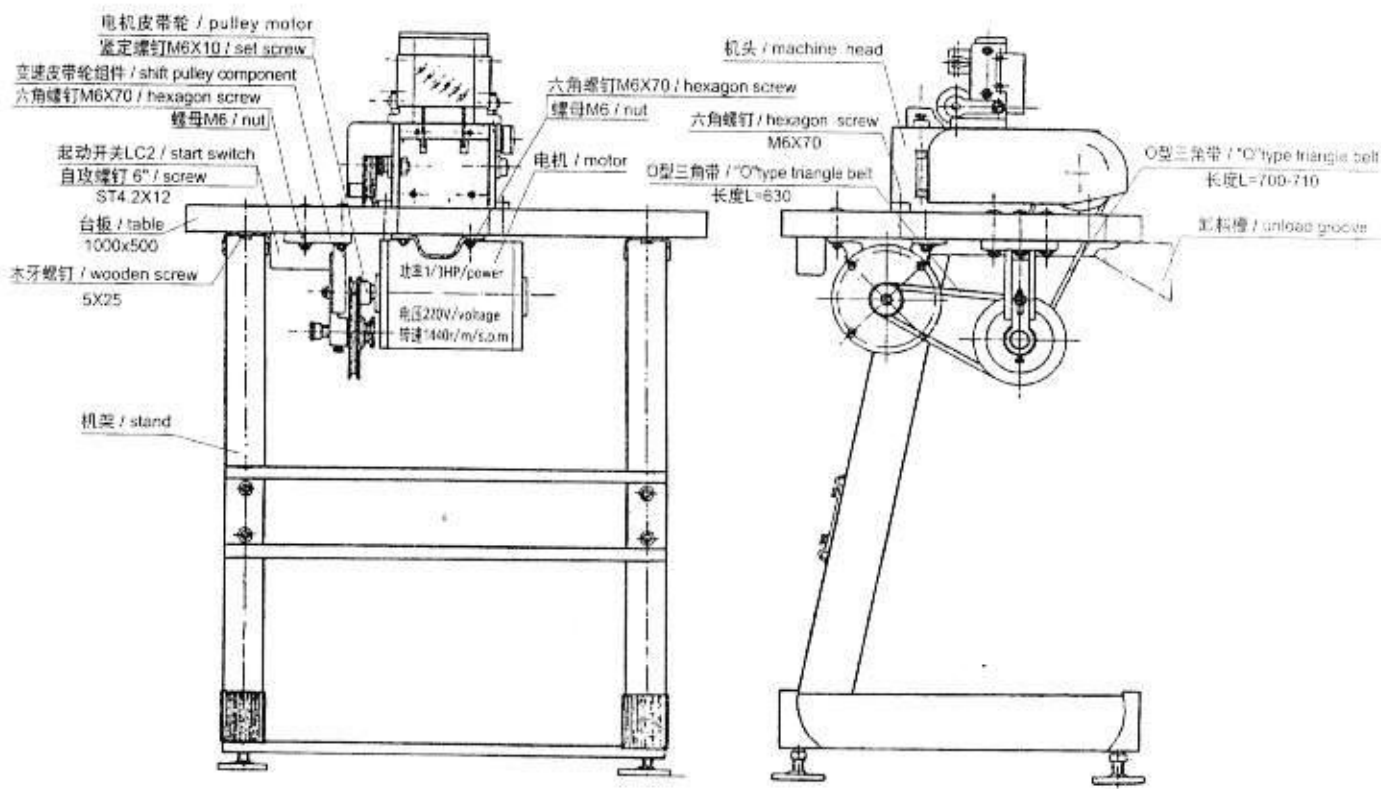
3. 切带机由曲柄滑块机构带动平整锋利的上切刀与下固定切刀配合完成带状织物裁剪动作。裁剪时可自动送料，切刀位置能调整，供不同客户的需要和切刀修磨后的安装。

## 1. BRIEF INTRODUCTION

1. Model 120 Cutting Belt machine is the special equipment for cutting the belt materials (such as chemical fibre, cotton textile), especially for cutting the belt loop, knapsack, schoolbag etc. The break point of the material is regular, smooth. The length of each cutting material is same.

3. The Cutting Belt Machine is operated by the crank block mechanism which leads the smooth sharp upper knife and lower fixed knife cooperate to cut the belt material. It can auto-feed while cutting and the position of the knife can be adjusted in order to install the sharpened knife and meet the customer's needs.

## 二. 机器安装示意图 / INSTALLED FIGURE:



### 作前注意事项:

- 前运动位置应加润滑油。
- 前必须安装各皮带轮防护罩。
- 刀前面的防护挡板装好后,才能开动机器。
- 定方向输送裤耳或带状织物。
- 时不允许将防护罩、防护挡板卸下。

### 度调整:

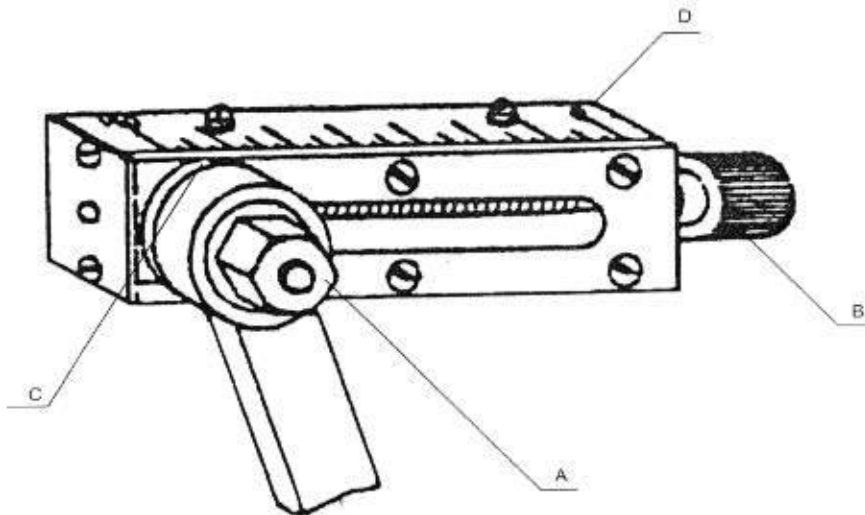
- 手旋松六角螺母A(15-69);
- 丝刀转动调节螺杆B(15-25), 将刻度垫圈(15-30)上的指针调至刻度板D(15-94)上指所需长度处;
- 裁剪物长度适合后, 再将螺母A旋紧。

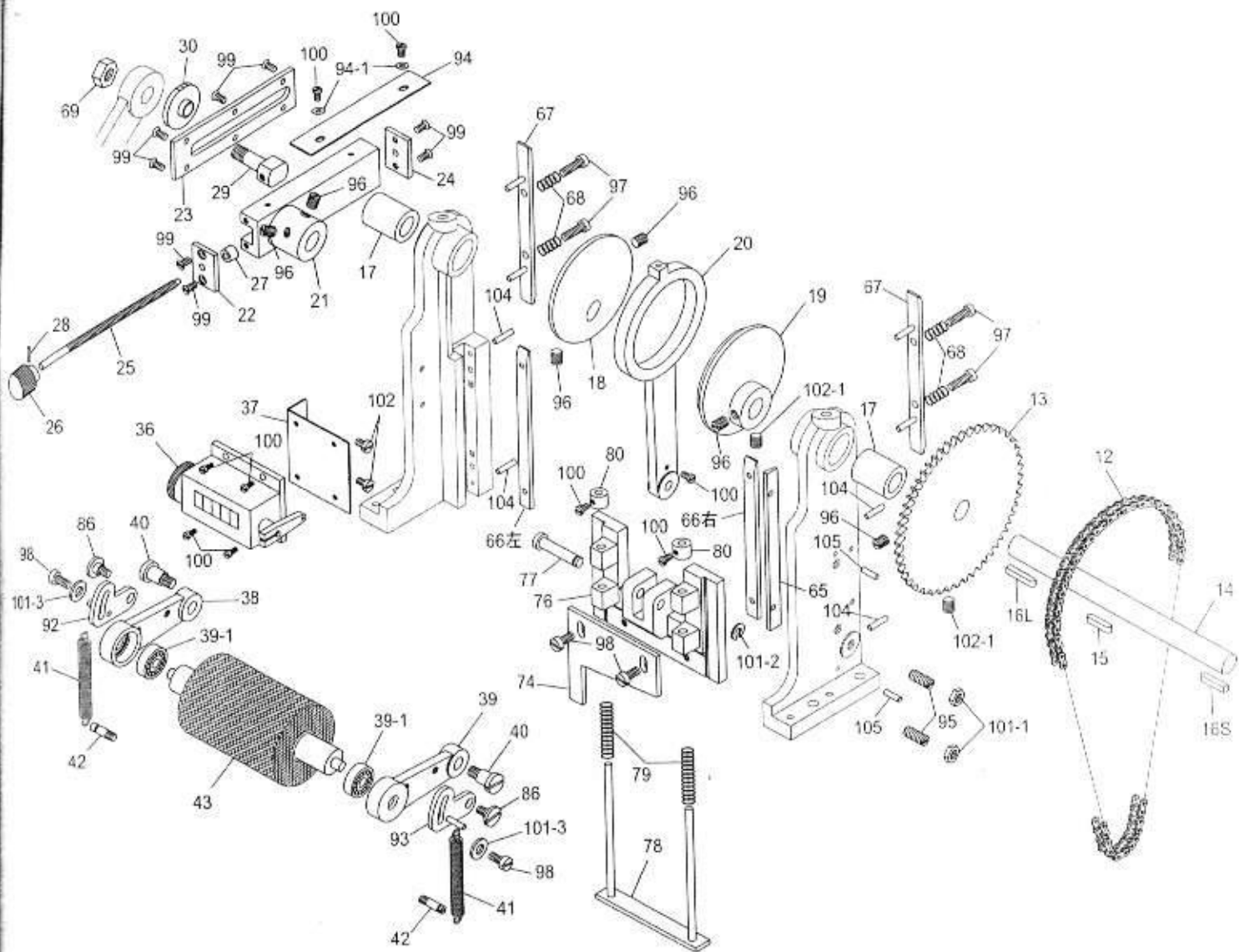
### 3. INSTRUCTION BEFORE OPERATION

- 1 Add the lubrication oil to the movable position before operation.
- 2 It is necessary to install the pulley safety cover before operation.
- 3 After installed the safety plate in front of the knife, start to operate the machine.
- 4 Feed the belt loop or belt material in according to the stipulated direction.
- 5 Can't unload the safety cover and the safety plate while operation.

### 4. ADJUSTING THE CUTTING LENGTH

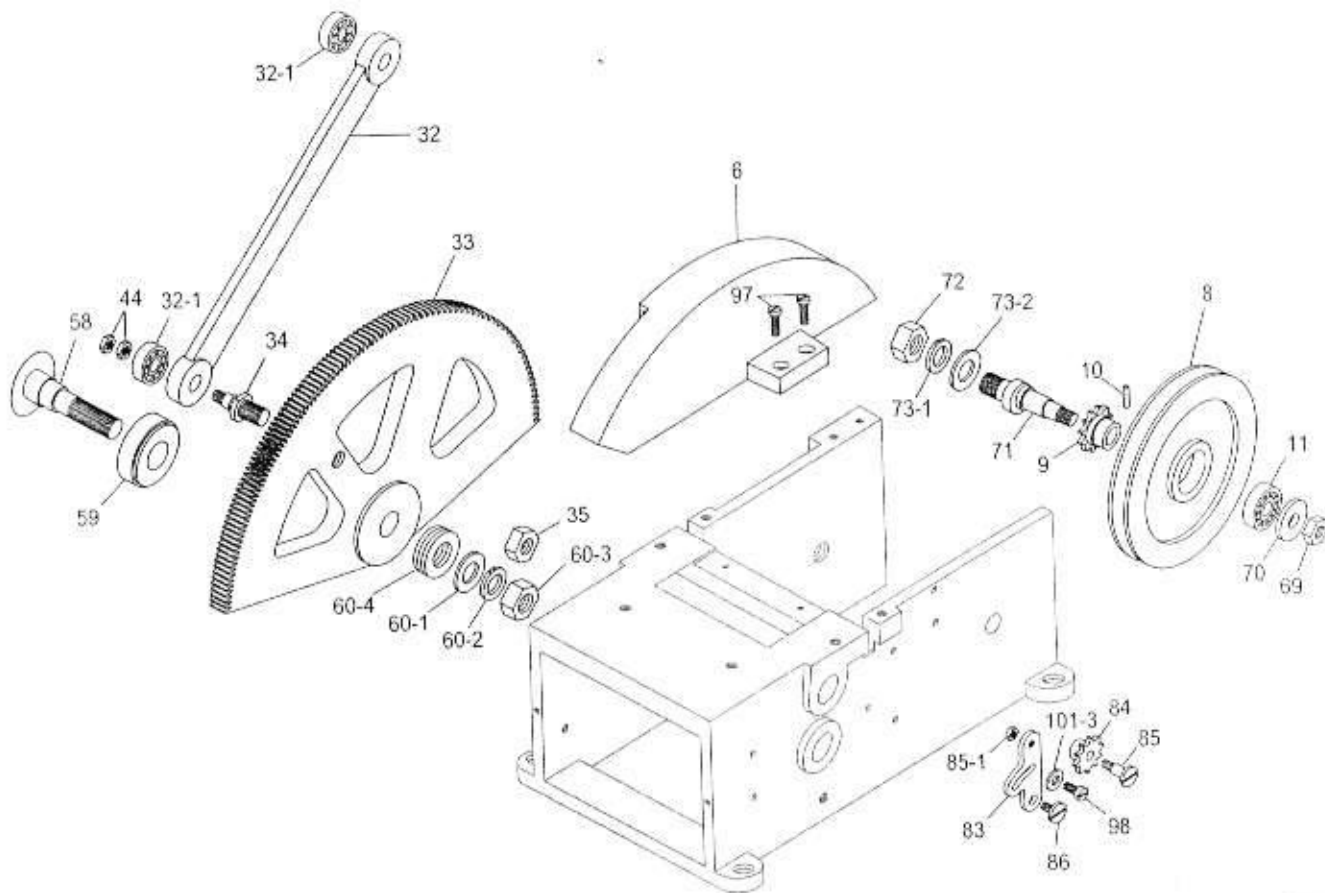
- 1 Loose the hexagon nut A(15-69) by spanner,
- 2 Rotate the adjusting bolt B(15-25) by screw driver, and adjust the finger on the scale washer C(15-30) to the length indicated in scale plate D(15-94) .
- 3 After adjust the length of the cutting material, tighten the nut A.



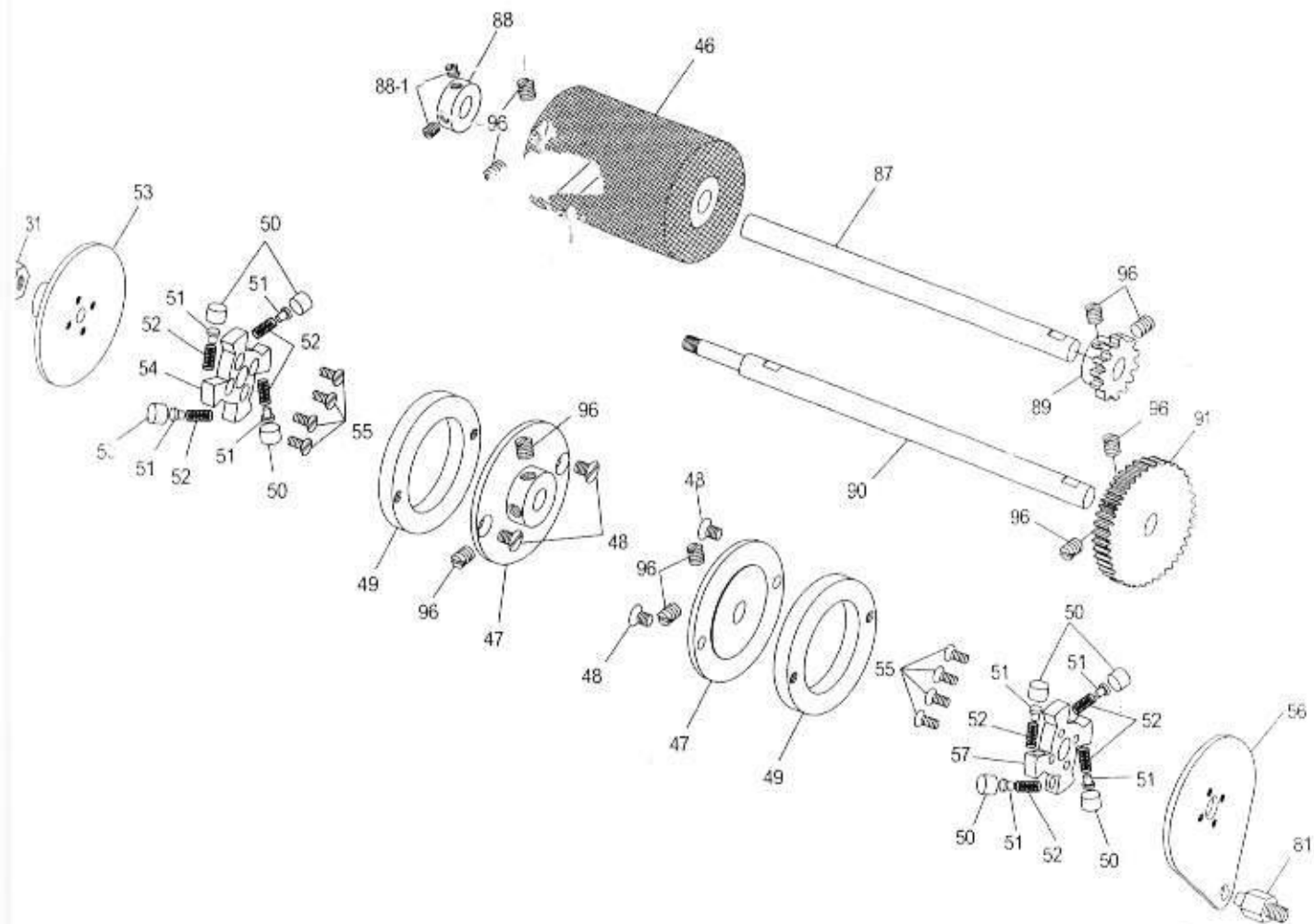


序号 Ref.No	图号 Symbol	件号 Part-No	零件名称 Description	数量 Amt Req.
12	15-12	402	1/4" 链条(711.2mm) / Chain	112节
13	15-13	403	大链轮 / Big Chain Wheel	1
14	15-14	404	上轴 / Upper Shaft	1
15	15-15	404K	键 / Key	1
16L	15-16L	404K	键 / Key	1
16S	15-16S	404K	键 / Key	1
17	15-17	404M	上轴轴套 / Upper Shaft Bushing	2
18	15-18	405	大连杆夹板 / Big Connecting Rod Clamp Plate	1
19	15-19	406	偏心轮 / Eccentric	1
20	15-20	407	大连杆 / Big Connecting Rod	1
21	15-21	408	尺码调节器体 / Size Adjuster	1
22	15-22	409	尺码调节螺杆卡板 / Size Adjusting Bolt Check Plate	1
23	15-23	410	尺码调节槽板 / Size Adjusting Plate	1
24	15-24	411	尺码调节螺杆托板 / Size Adjusting Bolt Serving Plate	1
25	15-25	412	尺码调节螺杆 / Size Adjusting Bolt	1
26	15-26	412-1	尺码调节螺杆头 / Size Adjusting Bolt Head	1

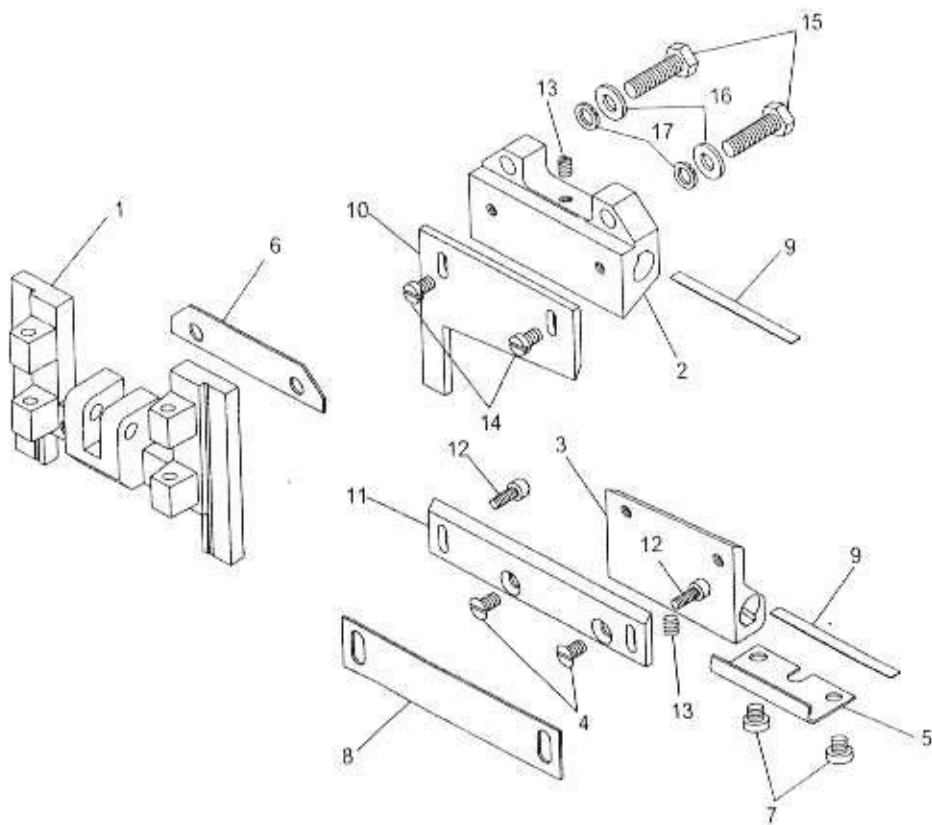
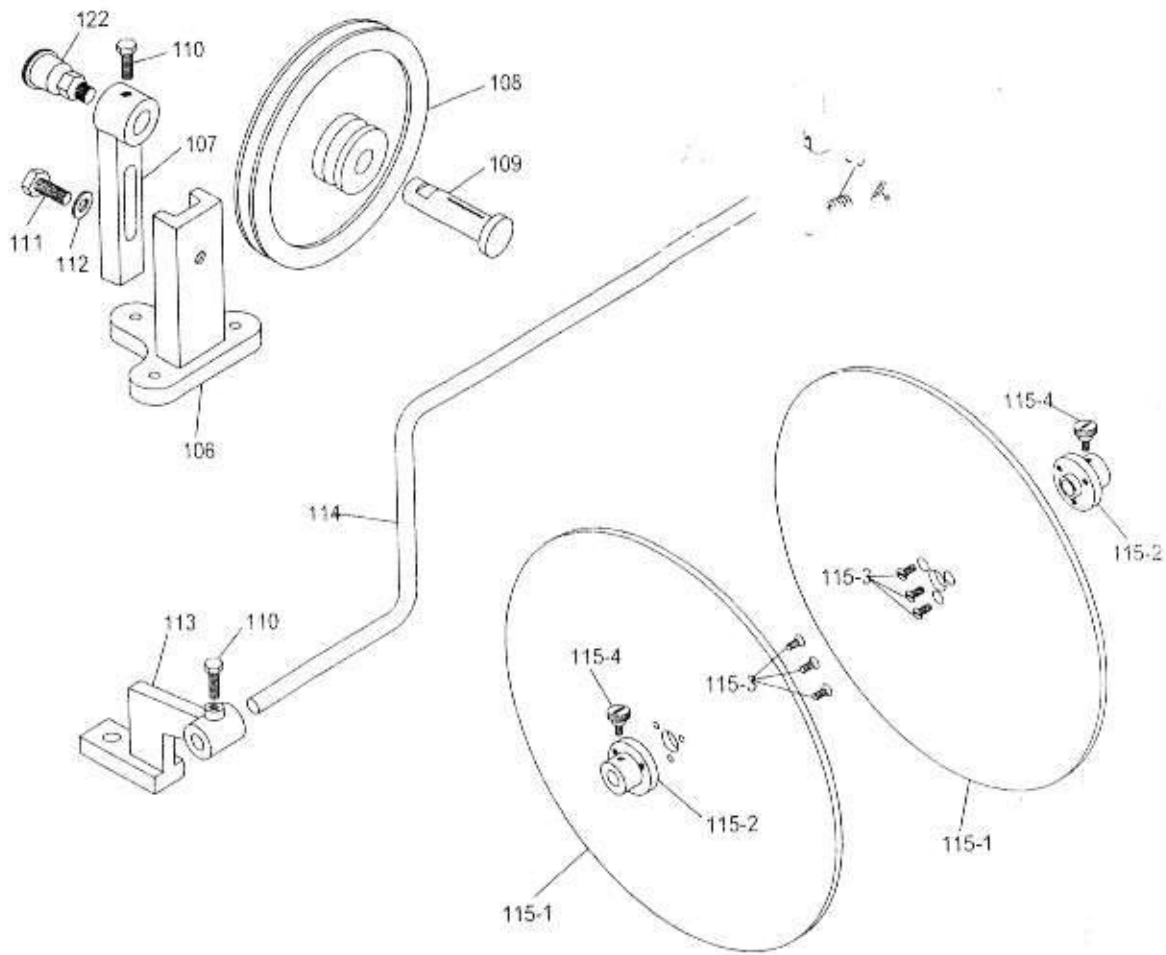
序号 Ref.No	图号 Symbol	件号 Part.No	零件名称 Description	数量 Amt./Req.
27	15-27	412-2	尺码调节螺杆挡圈 / Size Adjusting Bolt Collar	1
28	15-28	412-3	尺码调节螺杆销钉 / Size Adjusting Bolt Pin	1
29	15-29	413	尺码调节螺母 / Size Adjusting Nut	1
30	15-30	414	尺码调节刻度垫圈 / Size Adjusting Scale Washer	1
36	15-36	421	计数器 / Counter	1
37	15-37	423	计数器连接板 / Counter Connecting Plate	1
38	15-38	424	上胶轮左压臂 / Upper Rubber Wheel Left Presser Arm	1
39	15-39	425	上胶轮右压臂 / Upper Rubber Wheel Right Presser Arm	1
39-1	15-39-1	426	滚珠轴承626 / Ball Bearing	2
40	4E-17	427	左右压臂螺钉 / Presser Arm Screw	2
41	11-4-5	428	左右上胶轮拉簧 / Upper Rubber Wheel Spring	2
42	11-4-4	429	弹簧挂钉 / Spring Screw	2
43	11-4-1	430	上胶轮 / Upper Rubber Wheel	1
65	11-25	460	侧线条 / Side Plate	1
66左	11-17左	462	左导柱线条 / Left Guide Stick Plate	1
66右	11-17右	462	右导柱线条 / Right Guide Stick Plate	1
67	11-15	463	线条调节板 / Plate Adjuster	2
68	11-14	464	线条调压弹簧 / Plate Adjusting Spring	4
69	15-69	415	六角螺母M8 / Hexagon Nut	1
74	11-8-2	470	上切刀 / Upper Knife	1
76	15-76	472	切刀滑板 / Knife Slide Block	1
77	15-77	473	大连杆销 / Big Connecting Rod Pin	1
78	11-8-5	474	压料架 / Presser Frame	1
79	11-8-6	475	压料弹簧 / Presser Spring	2
80	11-8-4	476	压料弹簧挡圈 / Presser Spring Collar	2
86	15-86	482	调压螺钉 / Pressure Adjusting Screw	2
92	15-92	620	上胶轮调节铰(右) / Upper Rubber Wheel Adjusting Hinge(right)	1
93	15-93	621	上胶轮调节铰(左) / Upper Rubber Wheel Adjusting Hinge(left)	1
94	15-94		尺码调节刻度板 / Size Adjusting Scale Plate	1
94-1	15-94-1		Ø3垫圈(镀锌) / Washer	2
95	11-26	800	侧线条调节螺钉 / Side Plate Adjusting Screw	2
96	2B-5	801	紧定螺钉15/64-28X7.5 / Set Screw	8
97	2B-21	802	螺钉11/64-40X15.5 / Screw	4
98	3C-2	803	螺钉11/64-40X9 / Screw	4
99	11-10	807	沉头螺钉9/64-40X7.5 / Screw	10
100	2C-15	808	圆柱头螺钉1/8-44X5.5 / Round Stick Head Screw	9
101-1	10G-18	810	线条调节螺母15/64-28 / Plate Adjusting Nut	2
101-2	15-101-2		Ø5开口垫圈 / Open Washer	1
101-3	15-101-3	459	Ø5垫圈 / Washer	2
102	4D-37	813	圆头螺钉9/64-40X5.5 / Round Head Screw	2
102-1	2B-5	820	紧定螺钉15/64-28X5 / Set Screw	2
104	11-1-9	822	导柱线条定位销3X14 / Guide Stick Plate Fixing Pin	4
105	11-1-10	823	导柱边线条定位销3X10.5 / Guide Stick Side Plate Fixing Pin	2



序号 Rel.No	图号 Symbol	件号 Part.No	零件名称 Description	数量 Amt./Req.
6	15-6	202	扇齿防护罩 / Fan Gear Safety Cover	1
8	15-8	400	皮带轮 / Pulley	1
9	11-6-2b	400-1	小链轮 / Small Chain Wheel	1
10	11-6-3	400-2	定位销 / Pin	1
11	15-11	401	滚珠轴承629 / Ball Bearing	1
32	15-32	416	尺码连杆 / Size Connecting Rod	1
32-1	15-32-1	417	滚珠轴承608 / Ball Bearing	2
33	15-33	418	扇齿轮 / Fan Gear	1
34	15-34	419	连杆轴 / Connecting Rod Shaft	1
35	15-35	420	M10六角螺母 / Hexagon Nut	1
44	10G-18		六角螺母15/64-28 / Hexagon Nut	2
58	15-58	449	扇齿轮轴 / Fan Gear Shaft	1
59	15-59	450	轴承30203 / Bearing	1
60-1	15-60-1		M12垫圈 / Washer	1
60-2	15-60-2	451	M12弹簧垫圈 / Spring Washer	1
60-3	15-60-3	452	M12六角螺母 / Hexagon Nut	1
60-4	15-60-4	453	平面轴承51102 / Plane Bearing	1
69	15-69	465	M8六角螺母 / Hexagon Nut	1
70	11-6-5	466	防尘垫圈 / Dust Washer	1
71	15-71	467	偏心轴 / Eccentric Shaft	1
72	15-72	468	M12六角螺母 / Hexagon Nut	1
73-1	15-73-1	469	M12弹簧垫圈 / Spring Washer	1
73-2	15-73-2		M12垫圈 / Washer	1
83	15-83	479	张紧链轮支架 / Tension Chain Wheel Frame	1
84	15-84	480	张紧链轮 / Tension Chain Wheel	1
85	15-85	481	张紧轮螺钉 / Tension Chain Wheel Screw	1
85-1	3F-14		张紧轮螺钉母 / Tension Chain Wheel Nut	1
86	15-86	482	调压螺钉 / Pressure Adjusting Screw	2
97	2B-21	802	螺钉11/64-40X15.5 / Screw	1
98	3C-2	803	螺钉11/64-40X9 / Screw	1
101-3	15-101-3	459	Ø5垫圈 / Washer	1



序号 Ret.No	图号 Symbol	件号 Part.No	零件名称 Description	数量 Ant.Req.
31	15-31	415	六角螺母 15/64-28 / Hexagon Nut	1
46	11-3-4	434	下胶轮 / Lower Rubber Wheel	1
47	15-47	435, 445	步进器端盖 / Step Top Cover	2
48	15-48	436	沉头螺钉3/16-32X7.5 / Screw	4
49	15-49	437	步进器外环 / Step Out-ring	2
50	15-50	438	步进器滚柱 / Step Roller	8
51	15-51	439	弹簧顶钉 / Spring Plug	8
52	15-52	440	步进器弹簧 / Step Spring	8
53	15-53	441	步进器齿轮 / Step Gear	1
54	15-54	442	步进器左制动芯 / Step Left Brake Core	1
55	15-55	443	沉头螺钉9/64-40X9 / Screw	8
56	15-56	446	步进器定位板 / Step Set Plate	1
57	15-57	448	步进器右制动芯 / Step Right Brake Core	1
81	15-81	477	步进器定位钉 / Step Set Screw	1
87	15-87	150N500	中轴 / Middle Shaft	1
88	15-88	150N501	挡圈 / Collar	1
88-1	8D-29		紧定螺钉3/16-32X4.8 / Set Screw	2
89	15-89	150N502	小齿轮 / Small Gear	1
90	15-90	150N503	下轴 / Lower Shaft	1
91	15-91	504	大齿轮 / Big Gear	1
96	2B-5	801	紧定螺钉15/64-28X7.5 / Set Screw	10





序号 Ref.No	图号 Symbol	件号 Part.No	零件名称 Description	数量 Amt.Req.
106	11-35-1	830	皮带轮支架座 / Pulley Frame Support	1
107	11-35-2	831	皮带轮支架 / Pulley Frame	1
108	15-108副	832	变速皮带轮 / Speed Changing Pulley	1
109	11-35-3	833	变速皮带轮主轴 / Speed Changing Pulley Main Shaft	1
110	15-110	834	M6X20六角螺钉 / Hexagon Screw	2
111	15-111	835	M8X22六角螺钉 / Hexagon Screw	1
112	15-112	836	M8垫圈(镀锌) / Washer	1
113	15-113	901	卷料支架 / Hemming Frame	1
114	15-114	902	卷料轴 / Hemming Shaft	1
115-1	15-115-1A		卷料夹板 / Hemming Clamp Plate	2
115-2	15-115-2A		卷料夹板支座 / Hemming Clamp Plate Frame	2
115-3	B-32		沉头螺钉M4X10 / Screw	6
115-4	10A-12		螺钉 9/64-40 / Screw	2
122	15-122		油杯 / Oil Cup	1

序号 Ref.No	图号 Symbol	件号 Part.No	零件名称 Description	数量 Amt.Req.
1	15R-1		切刀滑板(热切) / Knife Slide Block(heat cutting)	1
2	15R-2		上切刀支架 / Upper Knife Frame	1
3	15R-3		下切刀发热支架 / Lower Knife Heating Frame	1
4	2F-26		沉头螺钉11/64-40X8.5 / Set Screw	2
5	15R-5		测热棒固定夹 / Heat Checking Stick Fixing Clamp	1
6	15R-6		切刀滑板隔热片 / Knife Slide Block Heating Guard Plate	1
7	15R-7		螺钉M5X5 / Screw	2
8	15R-8		机体隔热片 / Machine Body Heating Guard Plate	1
9	15R-9		垫片 / Washer	2
10	11-8-2		上切刀 / Upper Knife	1
11	11-11A		下切刀(热切用) / Lower Knife(use in heat cutting)	1
12	3C-2		螺钉11/64-40X10 / Screw	2
13	2F-19		紧定螺钉1 1/64-40X6 / Set Screw	2
14	10B-54		螺钉11/64-40X7 / Screw	2
15	15R-15		六角螺钉M6X22 / Hexagon Screw	2
16	15R-16		垫圈6 / Washer	2
17	15R-17		弹簧垫圈6 / Spring Washer	2