

JEMA

电脑切带机系列

零件样本 使用说明书



扫码进入安
装维修教材

台州市箭马缝纫机有限公司

TAIZHOU JEMA SEWING MACHINE CO.,LTD.

一、简述

本机采用微电脑数控装置，长度、速度、数量可自由设定，具有精度高，速度快，切断面平整，操作简单等特点：适用于编织带、魔术贴、套管、塑料拉链等。是您提高生产效率，提高产品质量，节省人工的首选。

二、技术性能及指标

功率 KW	最大切断宽度	切断长度 MM	切断速度每分钟	电压	最高加热温度
0.28-0.68	100MM	0.1-99999	90-120	110/220V 50/60HZ	350°C(LR) 300-450°C(H)

三、使用环境

本机是在一般常温下进行工作，如果在过高温（大于 70 摄氏度）下工作，将影响本机性能。

四、操作方法

1、显示器：

第一位显示字母“q”时，后面 4 位数是当前数量。

第一位显示数字“1”时，后面 4 位数是速度设置。

第一位显示数字“2”时，后面 4 位数是长度设置。

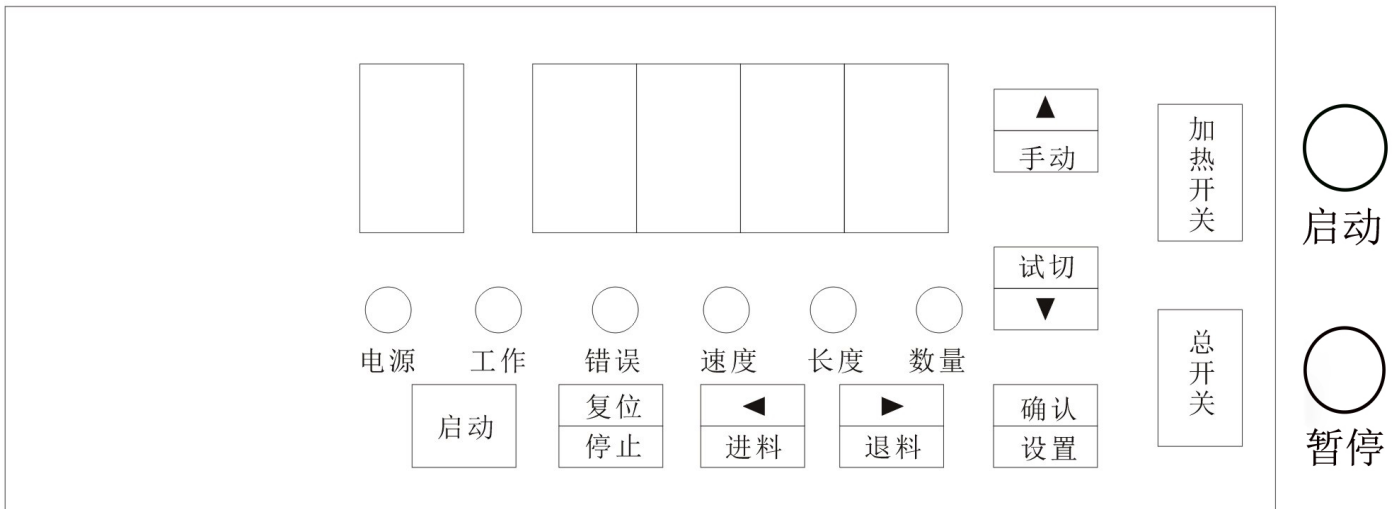
第一位显示数字“3”时，后面 4 位数是数量设置。

显示“E-1”时，切刀传感器出错。

2、设置说明：

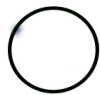
按“设置”键，第一位显示会在“1-2-3”变化，此时按“加”或“减”改变数值大小。“左移”或“右移”选择要输入的数据。再按确认键。注：在设置时，不能启动工作。

五、面板功能介绍



加热开关

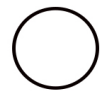
热刀



启动

总开关

电源



暂停

▲

手动

按在该键手动切刀，在设置时按下该键数字增加

▼

试切

按下该键试切，在设置时按在该键数字减少

确认
设置

确认

设置

按下该键开始设置，在设置完成后按下该键确认

▶

退料

按下该键手动退料，在设置时按在该键屏幕数字右移

◀

进料

按下该键手动进料，在设置时按下该键屏幕数字左移

复位
停止

复位

停止

按下该键停止，长按 1.5 秒复位当前长度、数量

启动

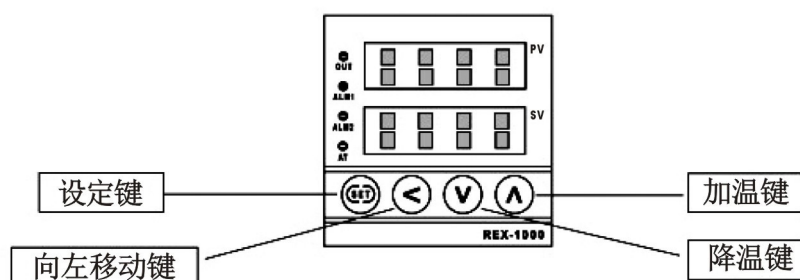
启动

按下该键开始工作

六、注意事项

- 1、使用前请确认电源电压和连接地线。（注意：接地线必须接地）
- 2、为了确保安全，在裁切过程中请不要将手或任何物体靠近切刀。
- 3、除了正常保养外，请勿任意拆卸任何零部件。
- 4、每班开机前，务必加机油一次，以保运动部件润滑。
- 5、刀具在使用一段时间后变钝了，可以到专业磨床进行磨刀后方可使用。
（注意：此工作一定要在专业人士操作）
- 6、在做任何调整时，请先切断电源以维护安全。
- 7、若在操作上有任何困难，请于本公司联系，我们将竭诚为您服务。

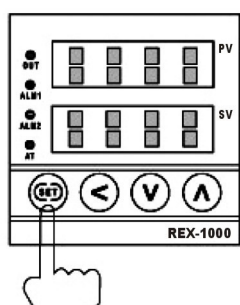
七、如何使用温控仪 K 型 注：（冷刀、圆角没有此装置）



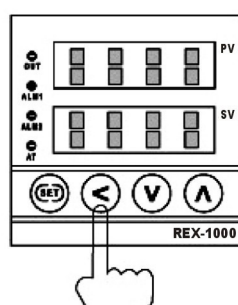
当你打开温控仪时，PV会显示当前室内的温度。而SV会显示你设置的温度，建议温度控制在150 - 250度之间。

大概在10分钟左右就可以达到您所设置的温度。

1. 按SET键进入设置程序，此时你会看到SV显示在闪烁，表示可以改动此数字。（如图1）
2. <是向左移动键，可以帮你选择而要改动的数字。（如图2）

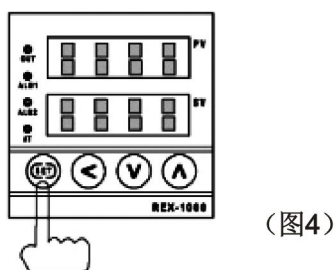
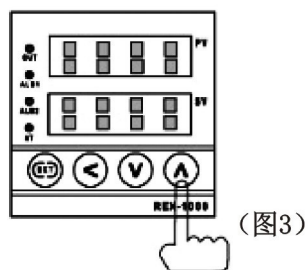


(图1)



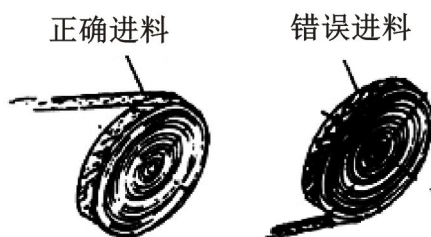
(图2)

3. \wedge \vee 是温度调节键， \wedge 表示升温， \vee 是表示降温。（如图3）
4. 设置完成后，需再按一次SET键停止数字闪烁，这时温控仪会退回自运行模式。（如图4）



故障排除:

1. 调温器不工作，检查接线处是否松动。
2. 切口没有完全粘合，调温器温度设定太低，需要逐步加高温度直到切口完全粘合。
3. 料带放置立式（见图），开始送料时可利用手动送料将料送入刀口，待温度到达所设定温度后方可正常工作。



4. 更换上切刀时固定上刀的螺钉太紧无法拧出，请将温控仪开启加热到200度左右，方可松开螺钉，松开螺钉后，请将温控仪关闭，待上切刀完全冷却后，可将螺钉完全拧出，更换上刀。
(注意：加热后松开螺钉时注意烫伤)

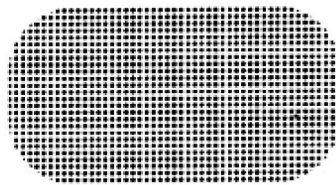
注意:

切魔术贴切勿将两条同时剪切。

切魔术贴进料时必须将毛面朝上，光面朝下。（如下图）





毛面朝上（正确）

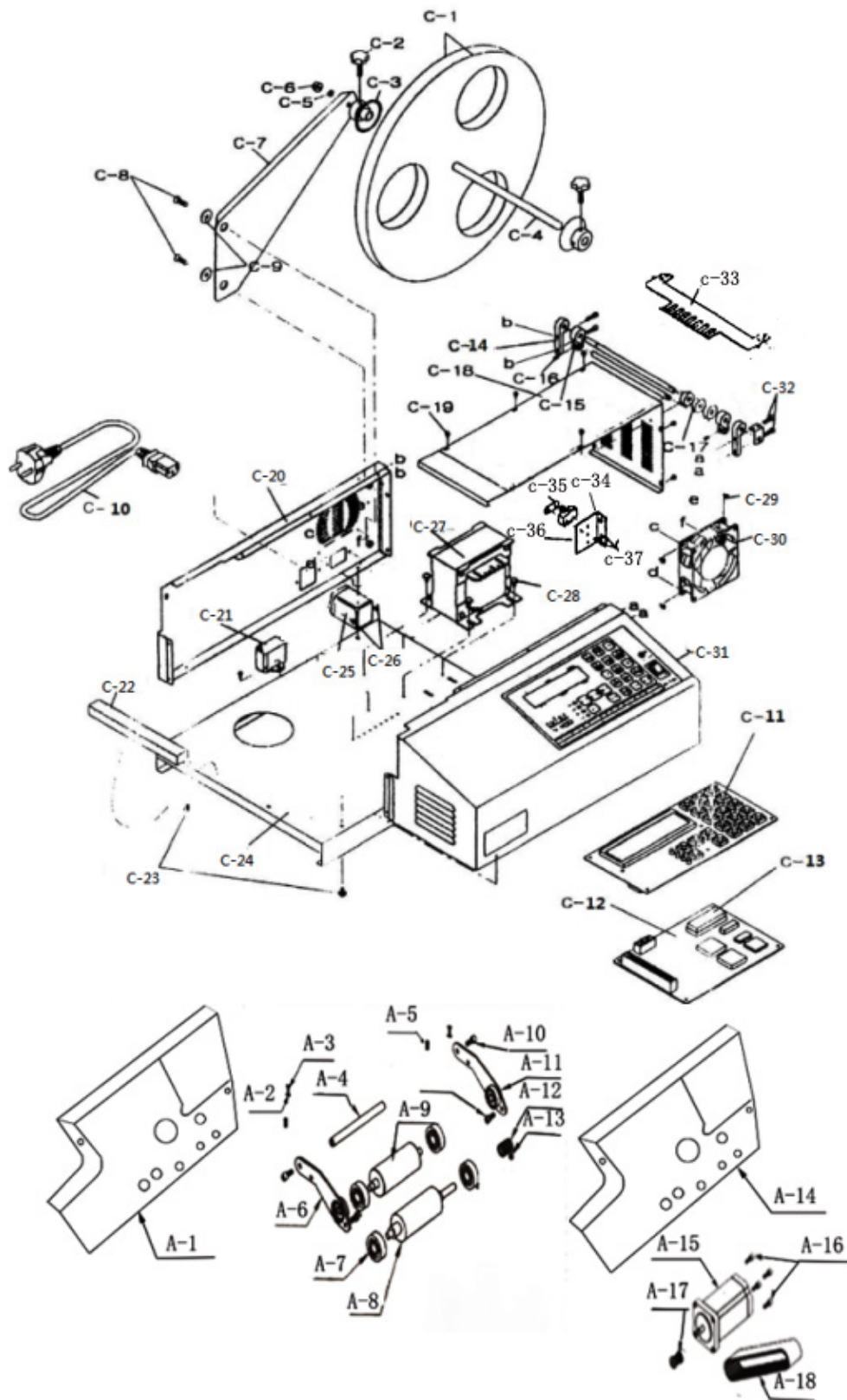


毛面朝下（错误）

八、一般故障的排除措施（供参考）

序号	发生现象		对应机种	原因及措施
1	无电源		全机种	检查电源连接插头线接触是否良好
				检查保险丝是否断开
2	有电源，但无法启动	滚轴不启动	全机种 全机种	检查滚轴上是否夹带杂物 如显示屏显示刀具传感器出错，则需要关闭电源，10秒钟后再打开电源，等控制面板绿色灯亮时，再按控制面板  手动、切断刀架上下移动。 如显示屏显示正常或不正常，则需要关闭电源，10秒钟后再打开电源，再按启动按钮键（START）还不能启动，则需要考虑更换驱动板。
		刀架不启动	全机种	检查压力板（冷刀：#20&29，热刀：#32&36）是否太紧
		屏面不显示	全机种	如果本机器连续超长时间工作使用，机箱里面温度可能超高，也许有可能出现显示不正常，属于正常现象，停止工作、关闭电源开关，过一会儿再开机显示应当正常，如果在冷态的时候，开机显示不正常请关闭电源等十秒钟再开机，上述做法反复几次仍然不正常，打开机箱盖检查电脑连接插线。 （尤其是操作板和CPU控制板）
3	无法切断带子		热刀	检查温度是否达到预设温度 检查热刀是否被加热
4	只切断带子的一边		全机种	检查热刀是否被损伤或磨损
				采用手切断键，调节刀，上刀和下刀对准，并保持水平。（如未保持水平，需旋开螺丝调节）
5	切断长度与设定值不同		全机种	放松滚轴或利用带子传送机（切断）
6	E--1 LCD显示屏显示 出错	刀具 传感器出错	全机种	切割马达或切割感应装置故障
				1. 正常开机后控制面板黄色的指标灯亮（START）时，按住  字键、刀架能上下移动，如不能移动可能是刀架被卡住。
				2. 打开刀架下方盖板，检查传感片是否松动错位。 3. 打开机箱盖，检查刀具传感接近开关是否失效和连接线的连接状态。
				检查刀具马达是否正常
7	手触到设备时，有电流		全机种	用户在安装本设备时顺自配防触电漏电开关，三脚插座接地极必须要有良好的接地线，才能确保本机器正常工作

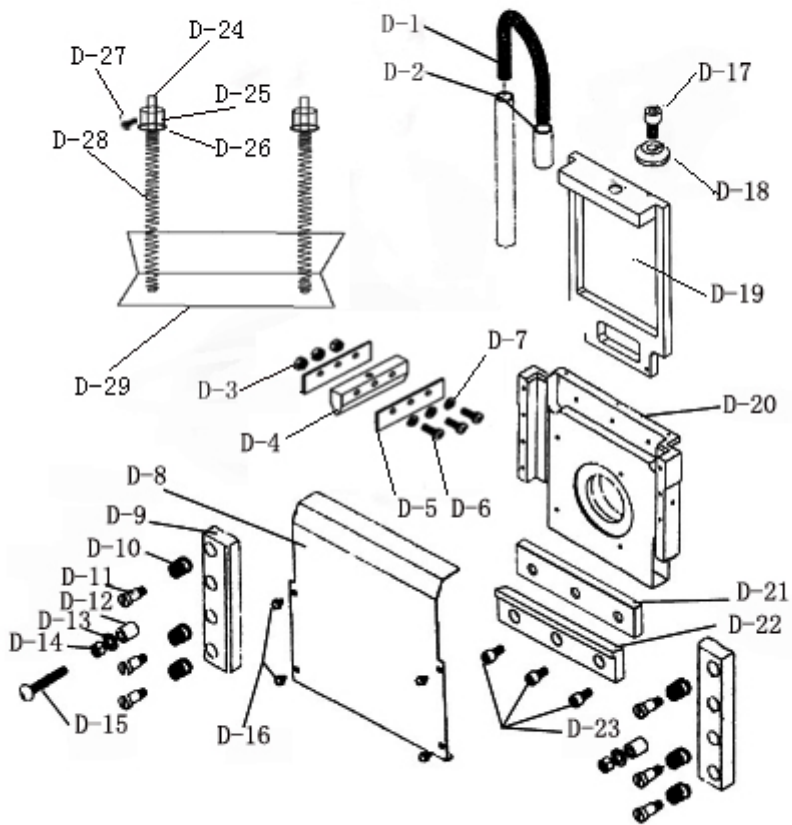
零件图



零件图

图号	名称	图号	名称
A-1	左圆筒座	C-11	按钮面板(OP)
A-2	垫片	C-12	控制刀具集成电路板 (MB)
A-3	螺钉	C-13	ROM
A-4	拉轴	C-14	压板座
A-5	弹簧	C-15	摇杆座
A-6	压料轮座 (右)	C-16	螺钉 M4×6L
A-7	轴承	C-17	滑动套
A-8	送料轮	C-18	右盖
A-9	压料轮	C-19	螺钉 M3×5L
A-10	M5 螺钉	C-20	后盖
A-11	压料轮座 (左)	C-21	电容
A-12	同步齿轮 (上)	C-22	吸油条
A-13	M4 螺钉	C-23	螺钉 M4×10L
A-14	右圆筒座	C-24	底座
A-15	步进电机	C-25	电器
A-16	M5 螺钉	C-26	螺钉 M3×5L
A-17	同步齿轮	C-27	变压器
A-18	同步齿形带	C-28	螺钉 M4×6L
C-1	挡盘	C-29	螺钉 M3×5L
C-2	梅花手把	C-30	排风扇
C-3	挡蕊	C-31	前壳
C-4	放料臂轴	C-32	螺钉 M4×15L
C-5	垫圈 6	C-33	压板
C-6	螺母 M6	C-34	行程开关
C-7	放料臂	C-35	行程开关压板
C-8	螺钉 M6×15L	C-36	行程开关座板
C-9	垫圈 C	C-37	螺钉 M2×10L
C-10	外接线	C-38	

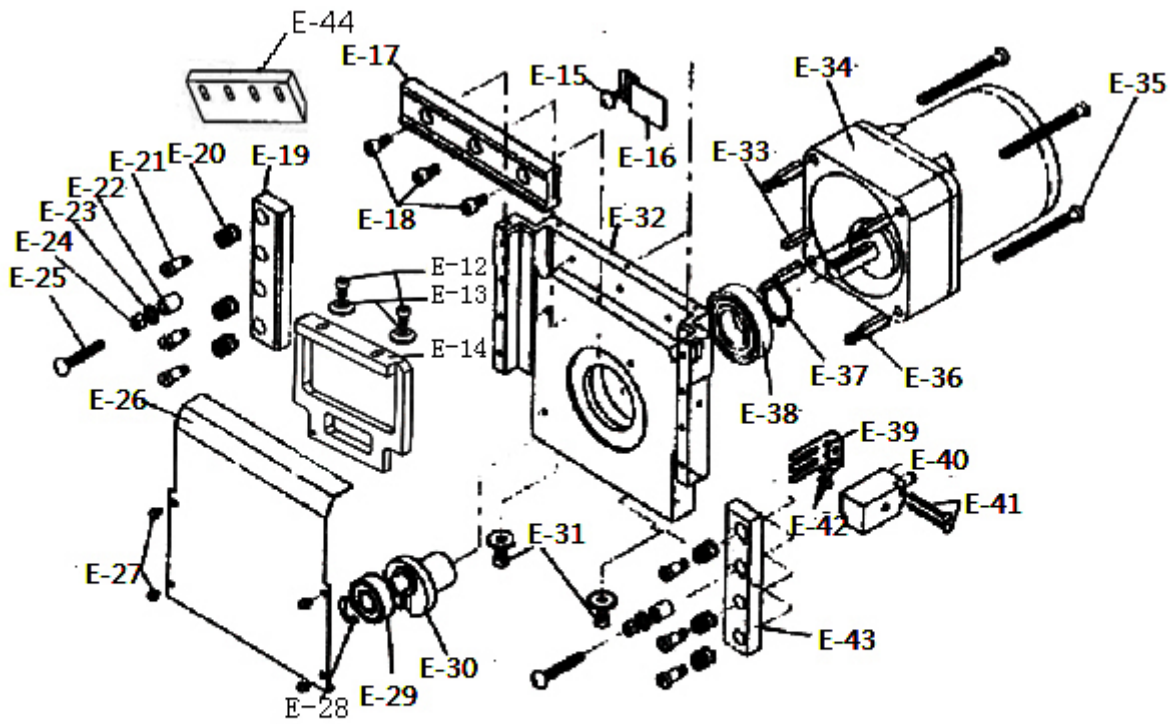
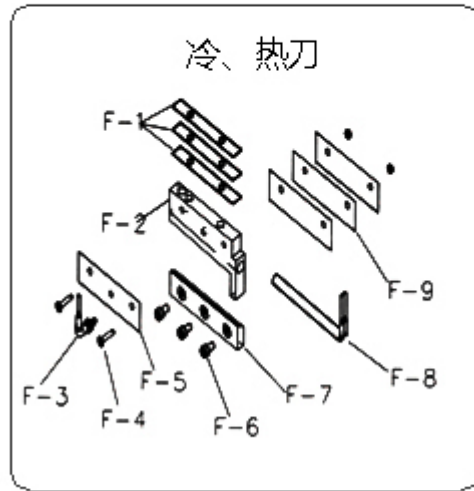
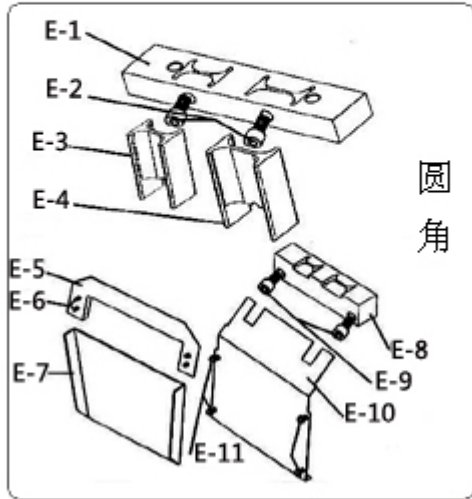
零件图



零件图

图号	名称	图号	名称
D-1	加热线弹簧	D-26	橡胶垫片
D-2	加热线管子	D-27	螺钉 M3
D-3	螺帽	D-28	弹簧
D-4	热刀	D-29	压料版
D-5	隔热纸		
D-6	M4 螺钉		
D-7	垫片		
D-8	落料板		
D-9	导轨压板		
D-10	压力弹簧		
D-11	阶梯螺钉		
D-12	压套		
D-13	垫圈		
D-14	螺母		
D-15	螺钉 M5×30		
D-16	螺钉 M3×5		
D-17	螺钉 M8×28		
D-18	垫圈		
D-19	上刀架		
D-20	下刀架		
D-21	下刀垫块		
D-22	下切刀		
D-23	螺钉 M5×15		
D-24	轴		
D-25	挡圈		

零件图



零件图

图号	名称	图号	名称
E-1	上刀模安装座	E-23	垫圈
E-2	螺钉 M6×12	E-24	螺母
E-3	上刀模 (1.5/1.0)	E-25	螺钉 M5×30L
E-4	上刀模 (2.0/2.5)	E-26	左侧盖
E-5	挡料板	E-27	螺钉 M3×5L
E-6	螺钉 M3×5	E-28	开口挡圈
E-7	落料板	E-29	轴承 (#6000)
E-8	下刀模	E-30	偏心轮
E-9	螺钉 M6×32	E-31	螺钉 M5×10L
E-10	前挡板	E-32	刀座 (L/LR/R)
E-11	螺钉 M3×5	E-33	键
E-12	螺钉 M6×30	E-34	减变速马达
E-13	垫圈	E-35	螺钉 M5×42L
E-14	上刀架	E-36	接减速机螺钉
E-15	螺钉 M4×6L	E-37	轴用弹性挡圈
E-16	挡板	E-38	轴承 (6004)
E-17	下切刀	E-39	电眼座
E-18	螺钉 M5×10L	E-40	电眼
E-19	导轨压板	E-41	螺钉 M3×15L
E-20	压力弹簧	E-42	螺钉 M3×15L
E-21	螺钉	E-43	导轨压板
E-22	压套	E-44	上切刀

1 General Discription

The machine adopts microcomputer numerical control device, length, speed, volume can be set freely, with features of high precision, fast, smooth cutting surface and easy operation. And It's suitable for braided belt, Velcro belt tape, casing, plastic zipper.etc.. It's your choice to increase productivity, Improve product quality and saving labor.

2.Specifications

Power(KW)	max.cutting width(MM)	cutting length(MM)	cutting speed(pcs/min)	Voltage HZ	Temperature (°C)
0.28-0.68	100	0.1-99999	90-120	110/220V 50/60HZ	350°C(LR) 300-450°C (H)

3.Use Enviroment

The machine should work under the normal temperature,if the environment temperature is more than 70 °C,would influence the performance of the machine.

4. Operation

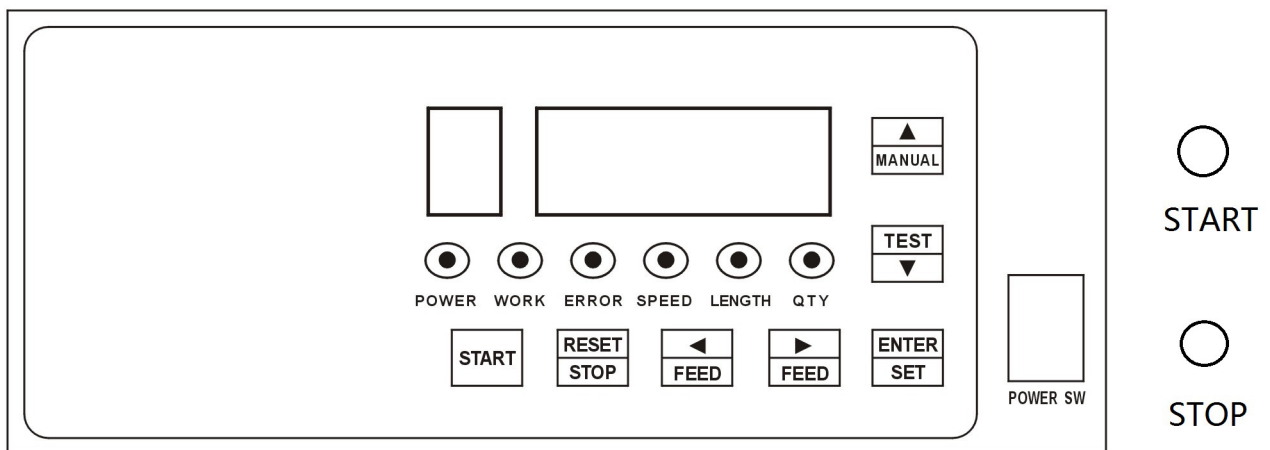
1 Screen

- Q shows current quantity
- No.1 is to set up speed
- No.2 is to set up length
- No.3 is to set up quantity

2 Set Up

Please press SET UP button and put in datas by direction keys. And don't forget to confirm by ENTER .
Note: you can not start work while setting.

5 Key Functions



HOT \equiv Hot Knife

○ START

○ STOP



SWITCH====Power Supply



Manual cut and add quantity, length and speed



Test cut and lessen quantity,length and speed



Put datas in by SET UP and ENTER to confirm



Manually backward the tape and to set up quantity ,length and speed.



Manually frontward the tape and to set up quantity, length and speed.



Stop work and hold on 1.5 second to recover current length and quantity



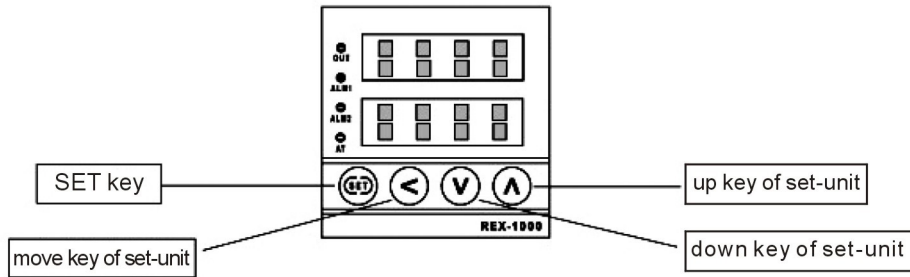
Start work.

6 Caution:

1. Before operation.,Please confirm the voltage and make ground (earth) connection.
2. Do not access hands or any object close to the working knife.
3. Cut off the eletricity before any adjustment(for safty).
4. Pls do not take off any of the parts except for normal maintance.
5. Lubricate the machine every time use the machine.
- 6 .When the knife blade becomes dull,pls use it after griding with the grinding machine (pls do not let the unskilled person grind manually or install the knife blade)

Welcome to contact us for any further information!

7. How To Use Temperature Controller K (NOTE: ONLY HOT CUT HAS IT)

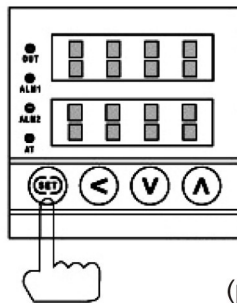


When you power on the controller, PV shows current room temperature and SV shows set temperature. Recommendation is 150 — 250 °.

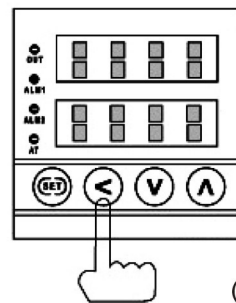
After turn on & set within 10minutes, it reaches to set temperature.

1 you can enter set mode by pressing SET key, you may see one cipher blinks, it means it can be changed.(picture1)

2 by pressing < key, you can move between numbers of four ciphers.(picture2)



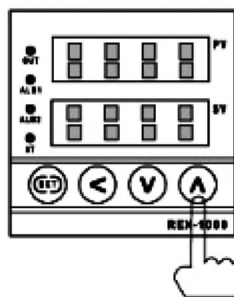
(picture 1)



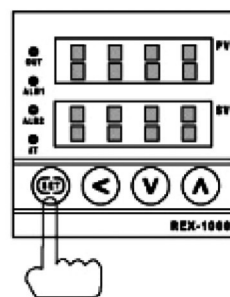
(picture 2)

3 set desirous temperature by pressing ^ and V keys. Set-temperature will be increased by ^ key and it will decreased by V key.(picture3)

4 after finishing setting, press SET key once more then , it stops blinking. And the controller will return to auto-turning mode.(picture4)



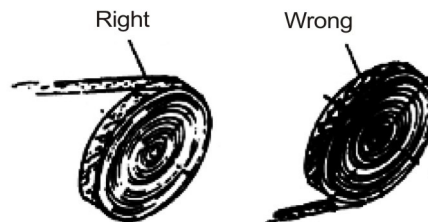
(picture 3)



(picture 4)

Fault Clearance

- 1 Check the connection, if the temperature does not work.
- 2 Increase the temperature if the cut unsealed
- 3 Please wait the temperature reaches to the set temperature before working and with right material putting.



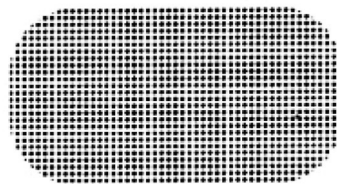
- 4 if you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200°C. Then loose the screw and turn off the control. And screw out completely after the knife is cool.(note that is hot and not burned yourself)

Caution:

- Do not cut two Velcro in the same time
- when cut Velcro .Please make sure that the rough surface is upward.




the rough surface is upward
(correct)



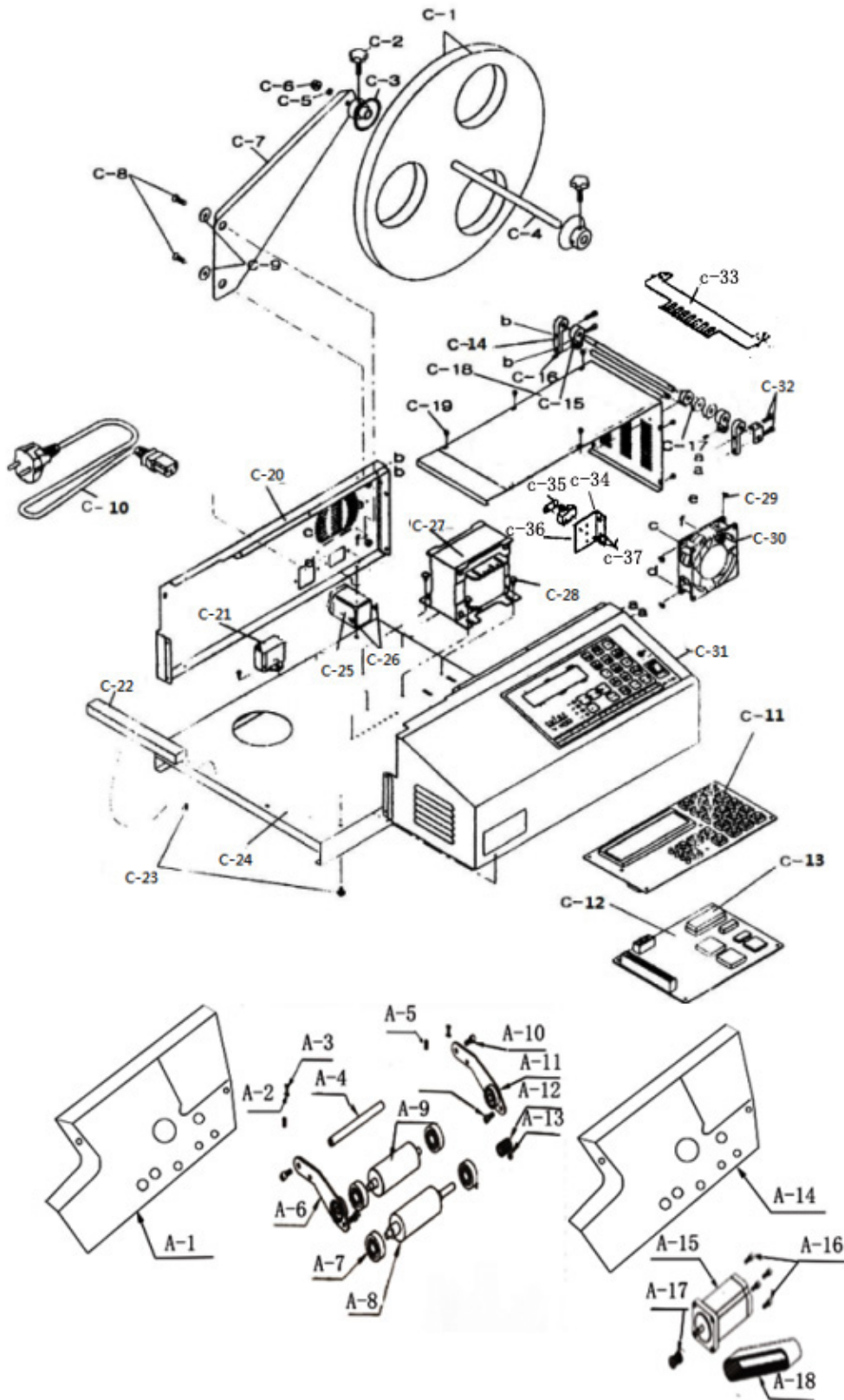
the rough surface is downward
(false)

Trouble shooting of 110 series(only reference)

NO	TROUBLES		APPLICABEL MODEL	CAUSES & MEASURES
1	no power supply		all models	-check if electric cord is connected well -check if the fuse blows out or not
2	power is on, but no work	Feed roller does not work	all models	-check if there is inserted any alien substance in roller -if the display shows “sensor error” or any other error ,put off SW for 10 seconds and put on again -if still does not work, exchange the drive board.
		Knife doesn't work	all models	-check if pressure plates of upper knife are too much fastened or not.(cool:#20&29,hot:#32&36)
		LCD display doesn't work.	all models	-check if the temperature is too high with over-time working, switch off the machine for seconds, if still doesn't after several times' trying.. Please opening the cover and check the connection.(especially between operation and CPU board)
3	material is no cut		hot cutter	-check if temperature goes up to set-degree -check if knife blades are even.
4	material is cut one side		all models	-check if blades are damaged or wears -after making both knives close each other by M/CUT button and check if they are even or not.(if they are not, adjust them by bolts.)
5	cut-length is different from set-length		all models	-test after loosening material from the reel by hand or attaching feeding device.

cutting error E--1	all models	<p>troubles in cutting motor or counting sensor</p> <p>-turn on the machine and press the  button, check if the knife can be moved or knife may locked.</p> <p>-open the bottom cover of the knife, check if the sensor is loose and wrong positioned.</p> <p>-open main cover, check the SW of cutting sensor is right or not. If not, exchange it.</p> <p>-check the cutting motor is right or not.</p>	
9	operator feels electric current in touch of machine	all models	-connect the earth cord (green) to any bolt of backside of machine.

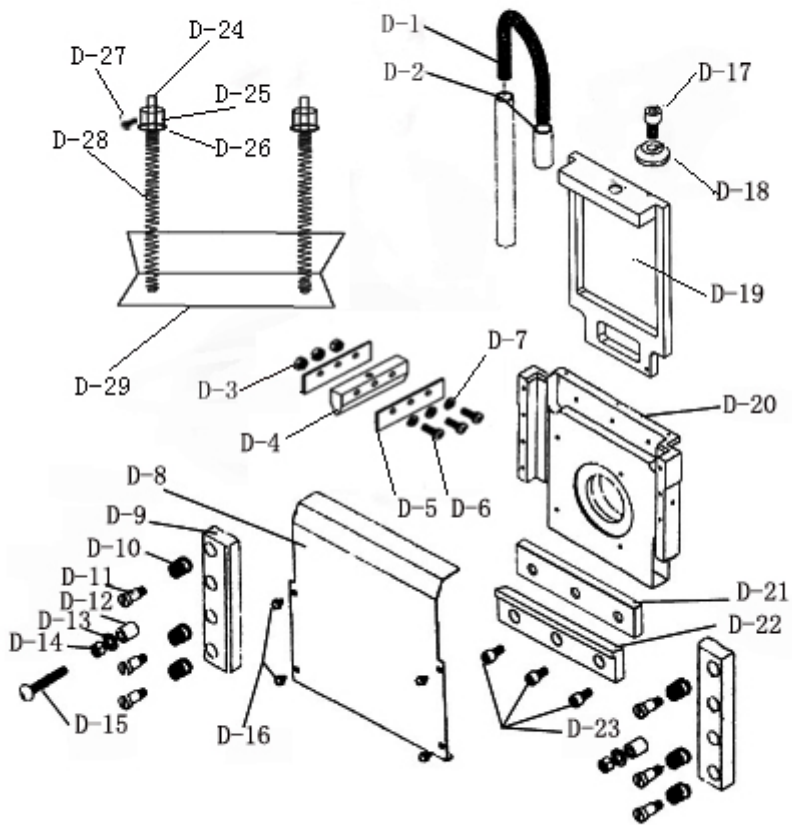
SPARE PARTS



Parts Drawing

Part No.	Description	Part No.	Description
A-1	Left barrel bracket	C-11	Operation board
A-2	Neck washer	C-12	Control circuit board(MB)
A-3	Clamping bolt	C-13	ROM
A-4	Pull shaft	C-14	Rear guide-pin bracket
A-5	Spring	C-15	Rear tension-guide block
A-6	Upper -roller bracket(right)	C-16	Detent screw(M4×6L)
A-7	Bearing	C-17	Guide ting
A-8	Lower roller	C-18	Upper guide plate
A-9	Upper -roller	C-19	Clamping bolt (M3×5L)
A-10	Clamping bolt M5	C-20	Back cover
A-11	Upper -roller bracket(left)	C-21	Condenser
A-12	Feed -timing belt	C-22	Sponge
A-13	Clamping bolt M4	C-23	Clamping bolt(M4×10L)
A-14	Right barrel bracket	C-24	Base
A-15	Stepping motor	C-25	AC connecter(IN-PUT)
A-16	Clamping bolt M5	C-26	Clamping bolt (M3×5L)
A-17	Feed timing gear	C-27	Transformer
A-18	Timing belt	C-28	Clamping bolt (M4×6L)
C-1	Roll-hanger wheel	C-29	Clamping bolt (M3×5L)
C-2	Clamping bolt of holder	C-30	Cooling fan
C-3	Holder	C-31	Control cover
C-4	Roll-hanger shaft	C-32	Wrench bolt(M5×15L)
C-5	Roll-hanger shaft washer	C-33	Existence detector
C-6	Check nut(M6)	C-34	Micro limit switch
C-7	Roll-hanger	C-35	Plate-nut
C-8	Flat-head bolt(M6×15L)	C-36	Limit switch bracket
C-9	Neck washer of roll-hanger	C-37	Clamping bolt(M2×10L)
C-10	Out connect plug		

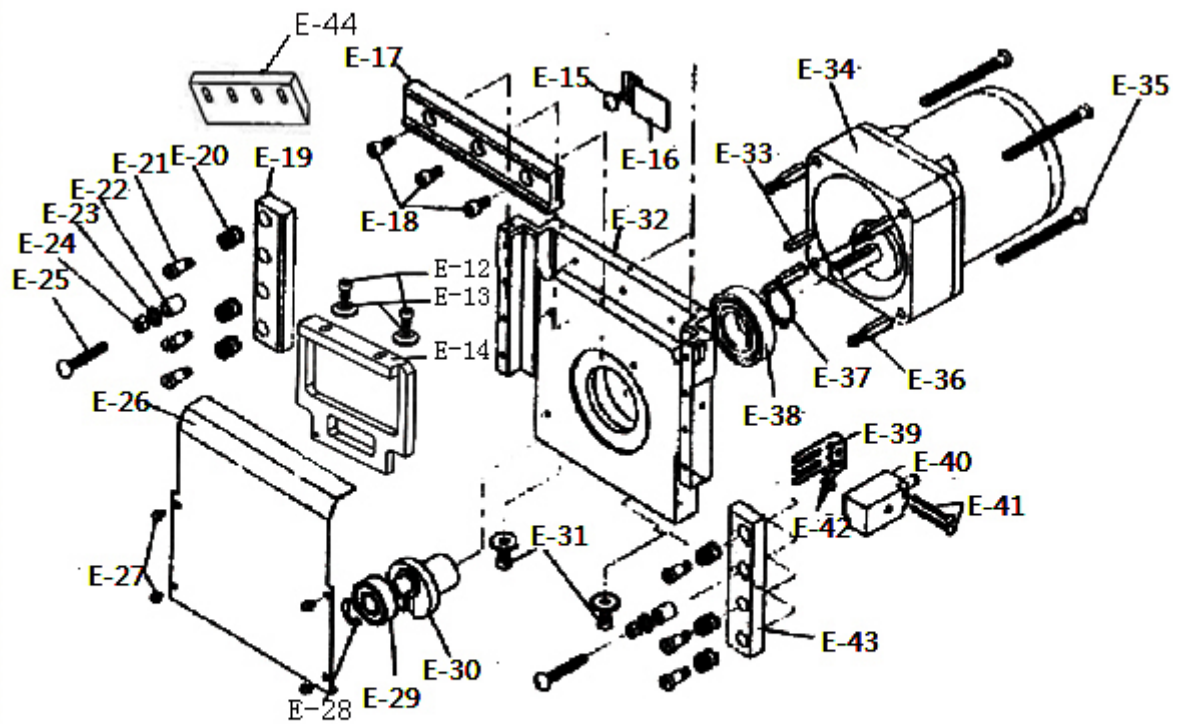
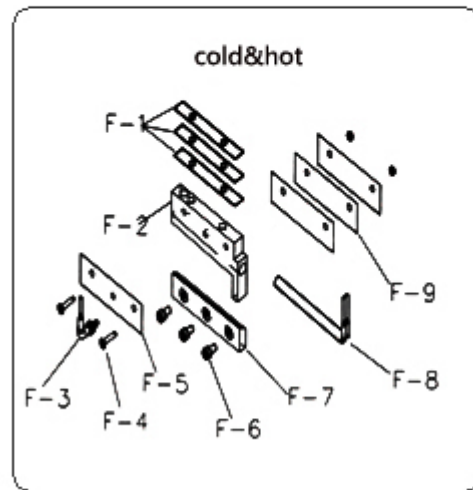
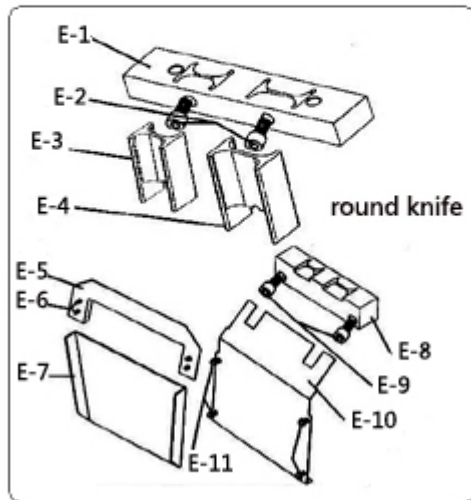
SPARE PARTS



Parts Drawing

Part No.	Description	Part No.	Description
D-1	Heating spring	D-26	Washer
D-2	Heating spring	D-27	Clamping bolt M3
D-3	Screw cap	D-28	Spring
D-4	Hot knife	D-29	Tape tension plate
D-5	Thermal shield		
D-6	Clamping bolt M4		
D-7	Neck washer		
D-8	Bed plate		
D-9	Guide way plate		
D-10	Spring		
D-11	T-shape bolt		
D-12	Pressing sleeve		
D-13	Washer		
D-14	But		
D-15	Bolt M5×30		
D-16	Bolt M3×5		
D-17	Bolt M8×28		
D-18	Washer		
D-19	Upper knife holder		
D-20	Lower knife holder		
D-21	Lower knife packing block		
D-22	Lower knife		
D-23	Bolt M5×15		
D-24	Bearing		
D-25	Shaft ring		

SPARE PARTS



Parts Drawing

Part No.	Description	Part No.	Description
E-1	Upper cutting die soleplate	E-23	Tension-control washer
E-2	Bolt M6×12	E-24	Tension-control nut
E-3	Upper cutting die(1.5/1.0)	E-25	Clamping bolt(M5 × 30L)
E-4	Upper cutting die(2.0/2.5)	E-26	Front cover
E-5	Baffle	E-27	Clamping bolt(M3 × 5L)
E-6	Bolt M3 × 5	E-28	E-ring
E-7	Material guide plate	E-29	Ball bearing(#6000)
E-8	Lower cutting die	E-30	Crank bundle
E-9	Bolt M6 × 32	E-31	Wrench bolt(M5 × 10L)
E-10	Front cover	E-32	Knife case(L/LR/R)
E-11	Bolt M3 × 5	E-33	Motor key
E-12	Bolt M6 × 30	E-34	Motor+reduction gear
E-13	Washer	E-35	Clamping bolt(M5 × 42L)
E-14	Upper knife holder	E-36	Motor supporter
E-15	Clamping bolt(M4 × 6L)	E-37	Snap ring
E-16	Couting –sensor bracket	E-38	Ball bearing(#6004)
E-17	Lower knife	E-39	Clamping bracket
E-18	Bolt M5 × 10L	E-40	Couting sensor
E-19	Left pressure plate	E-41	Clamping bolt(M3 × 20L)
E-20	Pressure spring	E-42	Clamping bolt (M3 × 15L)
E-21	Clamping bolt of pressure plate	E-43	Right pressure plate
E-22	Urethane bush	E-44	Upper knife

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