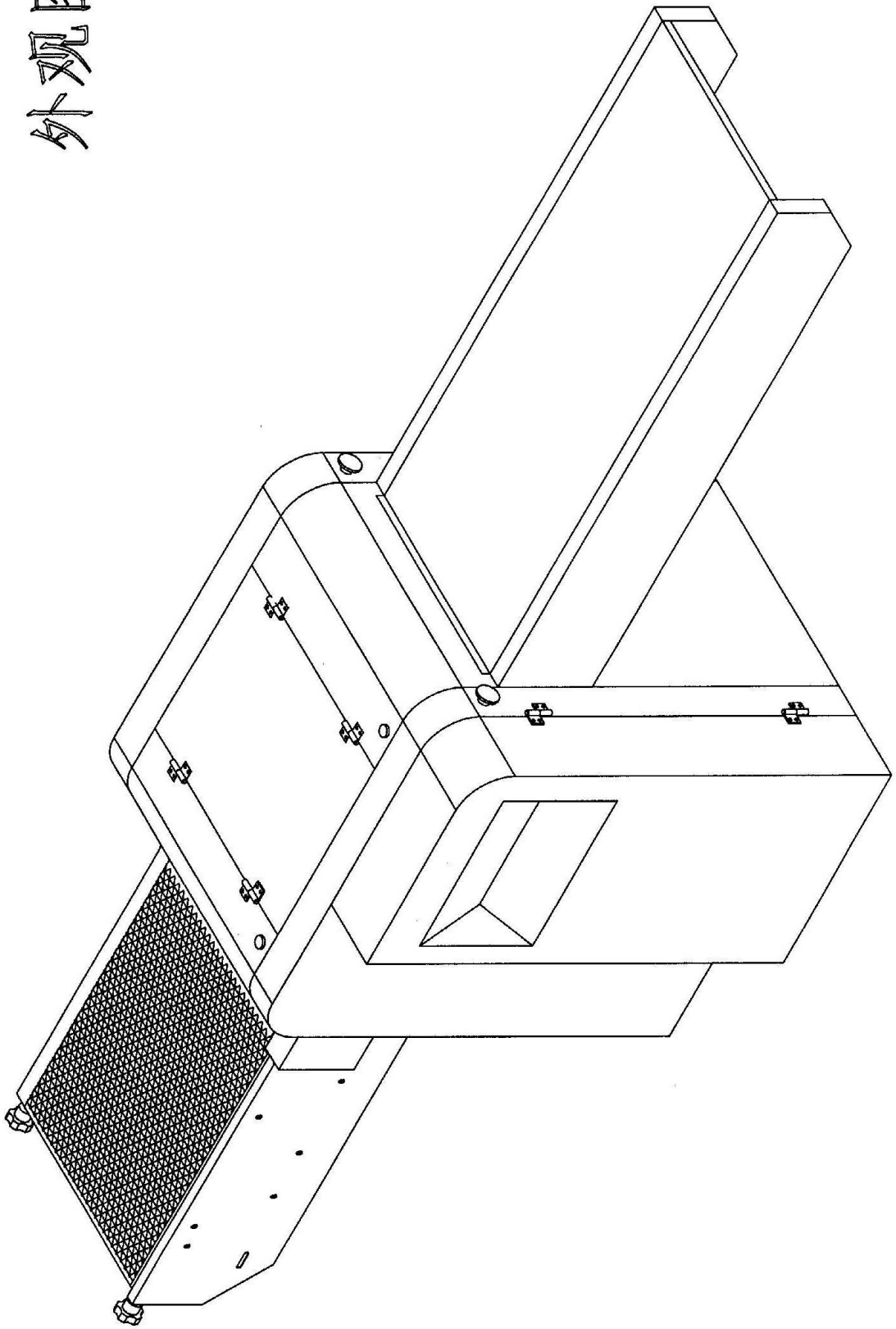
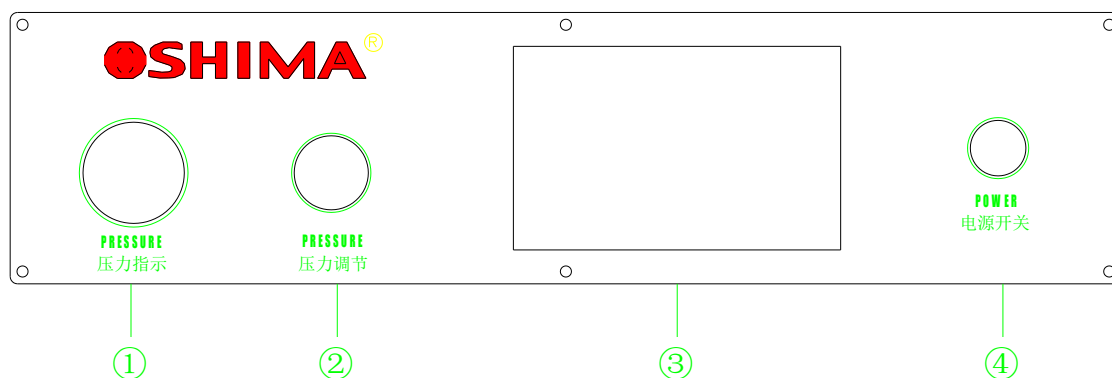


外观图



一、操作面板说明



- ①压力指示。
- ②压力调节：调节压力的高低。
- ③操作显示屏。
- ④电源开关：可转开或关该电源开关。

二、操作方法

1. 开机

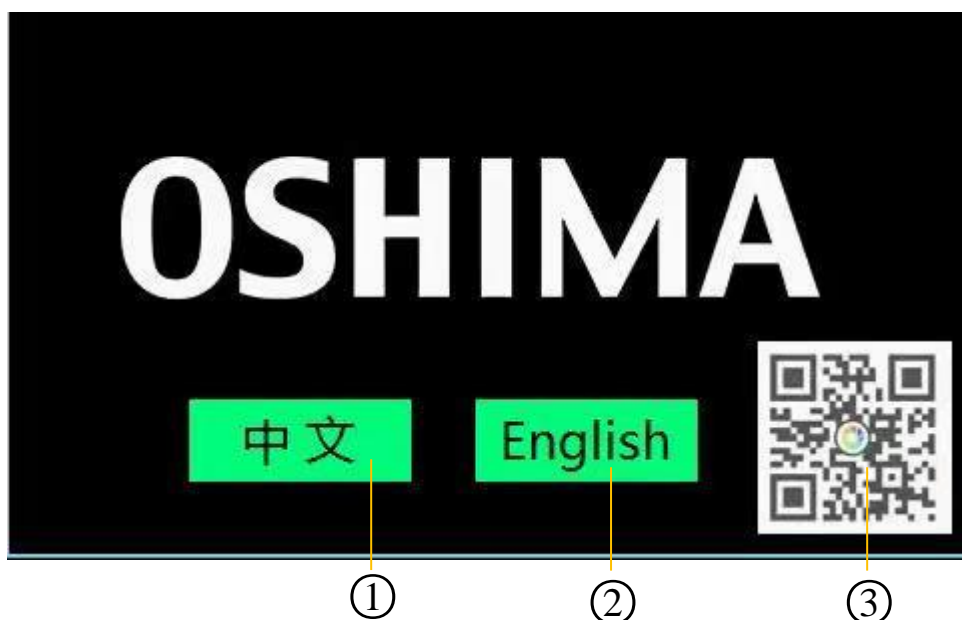
- (1.) 打上机器操作箱下右方的断路器接通电源。
- (2.) 按下电源开关（带锁式开关），开关里的绿灯会亮（开关锁定时为电源接通）
- (3.) 旋转调压阀，设定适当之压力。通常粘衫用的正常压力范围在：1.0-2.5kg/cm²。压力可调整的范围为：0-4.0kg/cm²。
- (4.) 完成工作后，将压力调整至“0”，再按下电源开关，解除锁定状态。

2. 关机：

當壓襯工作完成後，機器仍是處於“高溫”下，將触摸屏启动开关按下时状态显示延时停机中，当温度降至 60℃ 时，机台会自动断电。

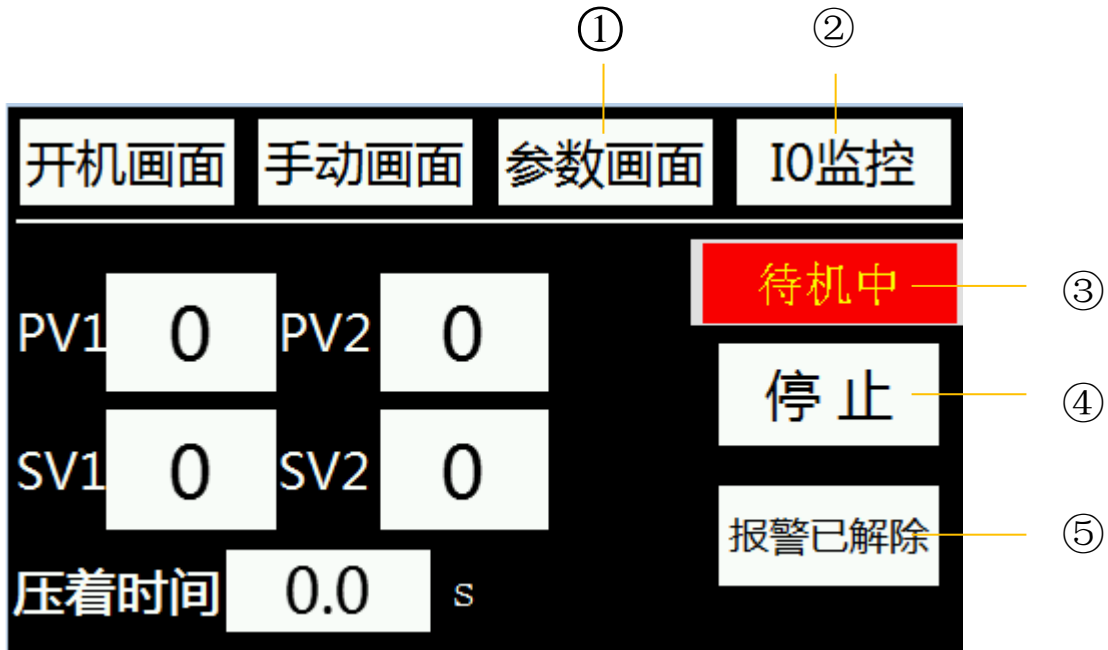
三、界面介绍

1. 启动页面：开启电源，触屏显示开机画面如图，选择界面语言（中文/英文）后，进入下一页。



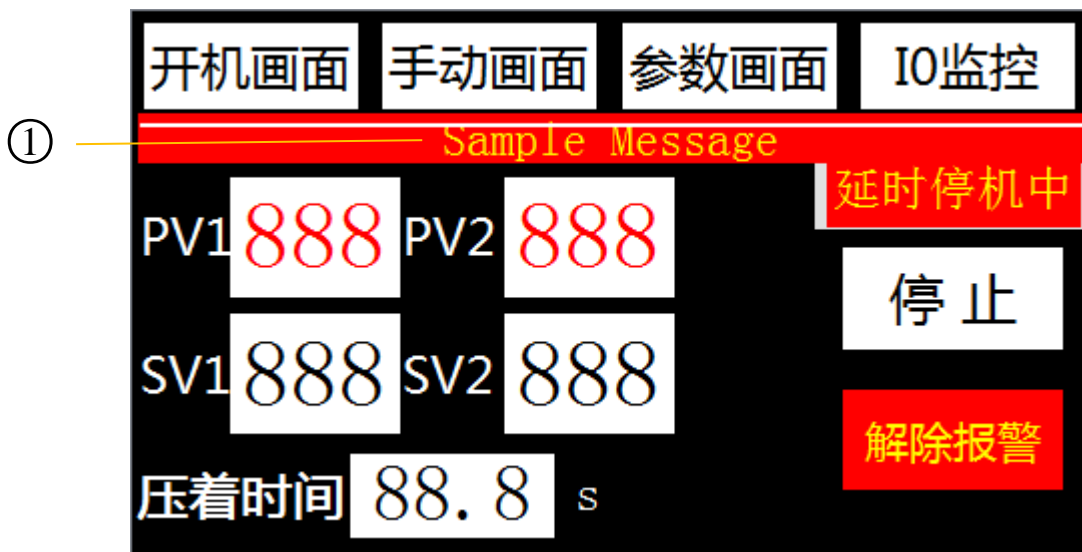
- ①按此键进入中文界面。
- ②按此键进入英文界面。
- ③扫此二维码可进入公司网站，了解欧西玛更多资讯。

2、自动页面：此画面仅供显示。



- ①按此键进入参数设置画面。
- ②按此键进入 PLC IO 监控画面。
- ③状态显示 1 待机中 2 运行中 3 延时停机中。
- ④启动/延时停机/停止按键。
- ⑤故障报警解除：故障排除后按此按键。

3、报警页面：



- ①报警故障显示。

4、手动页面。



- ①前段设定温度。
- ②后段设定温度。
- ③加热控制开关。
- ④马达点动运转开关。
- ⑤按此键进入速度调节页面。
- ⑥手动点动修正电机正转。
- ⑦手动点动修正电机反转。

5、速度调节页面：

压着时间	0.0	s	停止	自动画面
39	30	23	20	19
18	17	16	15	14
13	12.5	12	11.5	11
10.5	10	9.5	9	8.5
8	7.5	7	6.5	6

6、参数页面：进入此参数画面密码：1269。

自动画面	手动画面	参数画面	I0监控
上修正电机		下修正电机	下一页
① 延时正转	2.5 S	延时正转	2.5 S 温度停机
② 延时反转	2.5 S	延时反转	2.5 S 80 ④
③ 报警时间	15.0 S	报警时间	15.0 S

- ①修正马达延时正转时间
- ②修正马达延时反转时间
- ③修正马达跑偏报警时间
- ④设定停机温度

温度补偿1	0.0 °C	温度补偿2	0.0 °C
超温度数1	10 °C	超温度数2	10 °C
1路参数1	9100	2路参数1	9900
1路参数2	280	2路参数2	320
1路参数4	200	2路参数4	180
上一页	恢复出厂参数 ①		

- ①按此键恢复出厂设置。

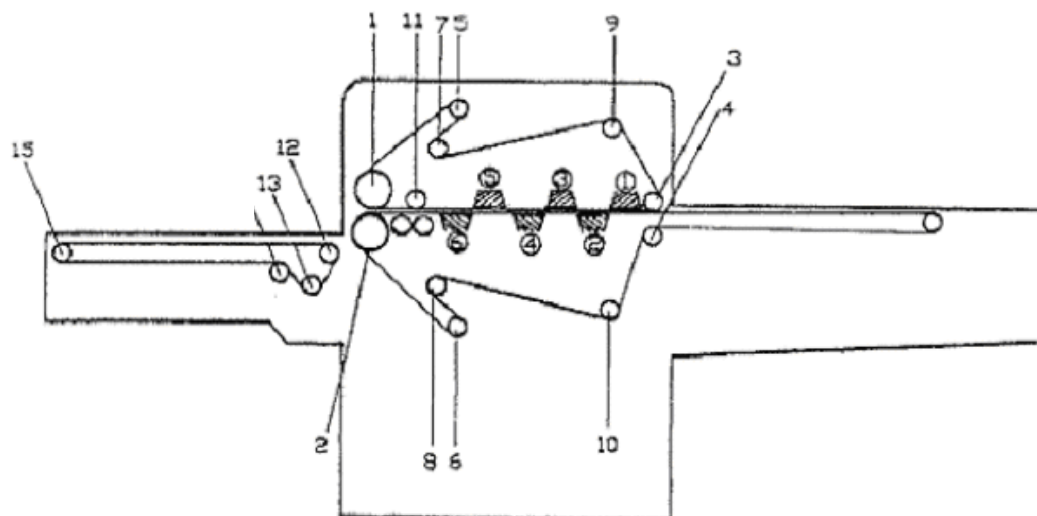
7、IO 监控页面：

自动画面		手动画面		参数画面		IO监控	
X0	上修正感应	X5	急 停	Y3	加 热		
X1	下修正感应	X6	断电信号	Y4	下修正（正转）		
X2	左限位	Y0	1加热固态	Y5	下修正（反转）		
X3	右限位	Y1	2加热固态	Y6	上修正（正转）		
		Y2	延时断电	Y7	上修正（反转）		

四、如何更换皮带清洁杆：

1. 该清洁杆是与拔片装置或刮片装置一起装在机器的后方。在恰可接触到上 / 下皮带位置。
2. 拉下拔片设置或刮片装置。
3. 该清洁杆是装置
4. 在拉出锁钉之后，可轻易的将清洁杆滑出取下。
5. 选用纯棉布作为更换之布，但不可用厚布，以免伤及皮带。
6. 但不要包上太多布，一般 3-4 层为宜以免造成材质分离不均衡。

五、内部组件

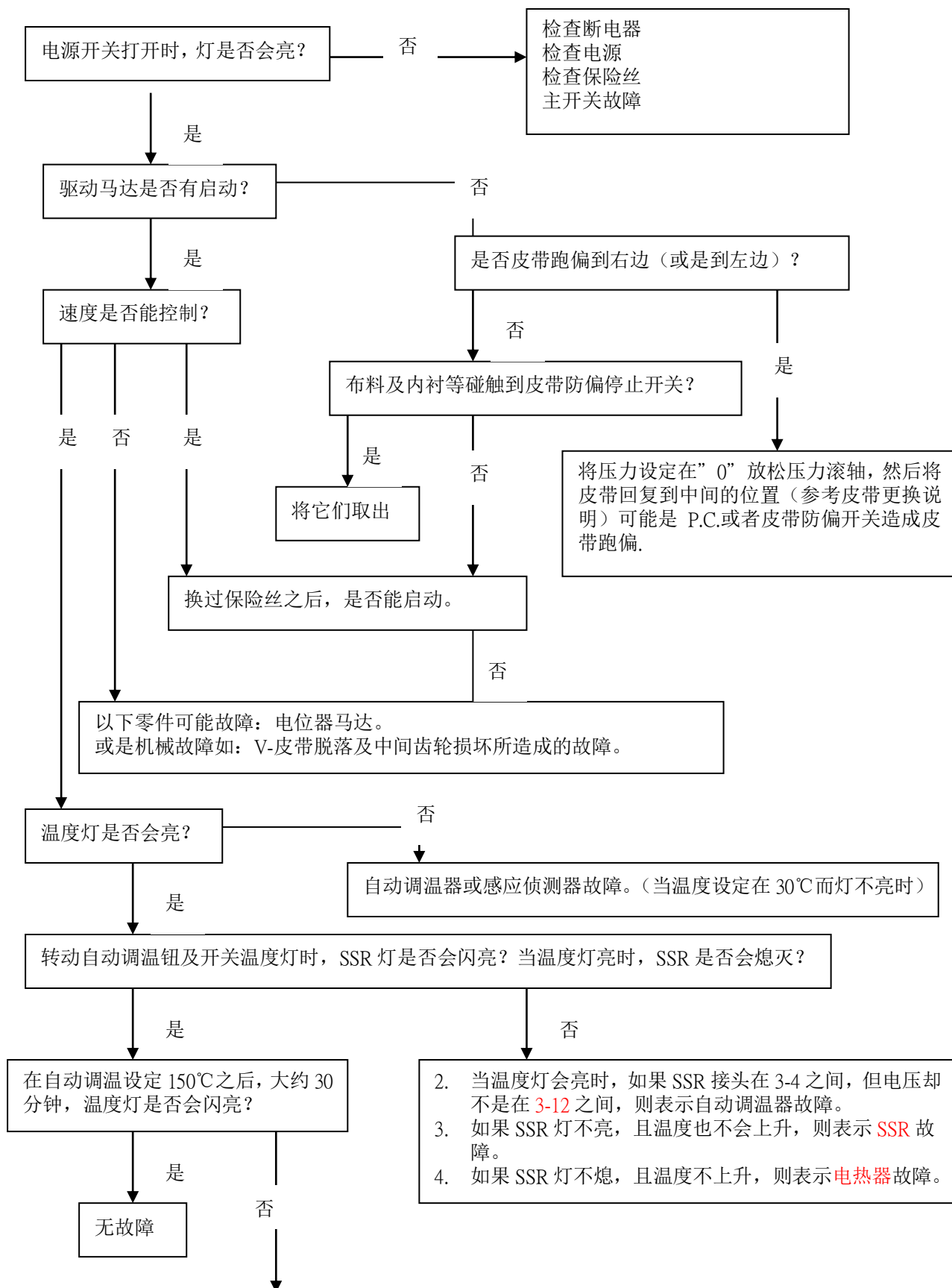


1. 压力滚筒（上）
2. 压力滚筒（下）
3. 进料滚筒（上）
4. 进料滚筒（下）
5. 副张力滚筒（上）
6. 副张力滚筒（下）
7. 张力滚筒（上）
8. 张力滚筒（下）
9. 防止皮带跑偏滚筒（上）
10. 防止皮带跑偏滚筒（下）
11. 波纹滚筒
12. 13. 直线式输送滚筒（前）

*5, 6 滚筒可调整作前, 后滑动 *3, 11, 滚筒可作上, 下滑动

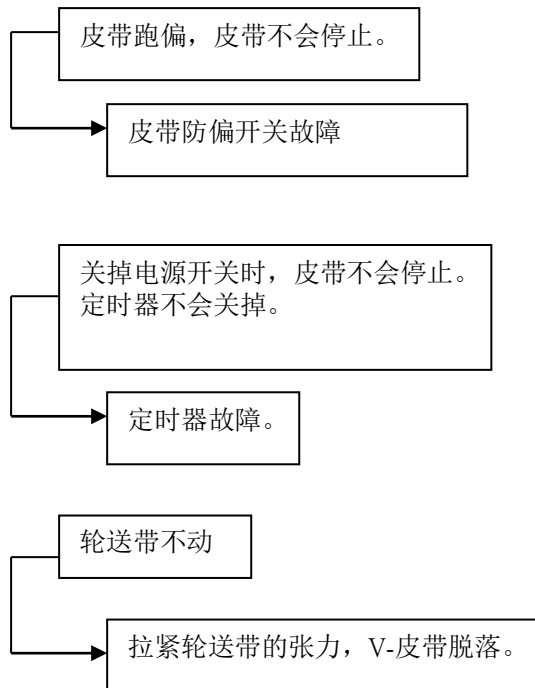
电热片的组合设定 前/后 组合

六、故障排除



1. 如果温度灯不亮，且 SSR 灯不熄，则表示温度的感应侦测器故障。
2. 如果温度灯及 SSR 灯都不亮，且温度不降，表示 SSR 故障。
3. 如果温度灯不熄，且温度不降，表示自动调温器故障。

其他：

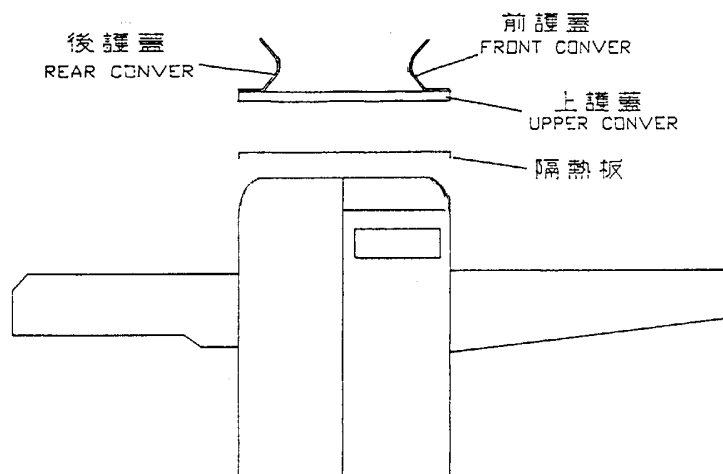


☆为了避免机械故障，请务必给驱动部份的零件上油作润滑。

七、注意事项

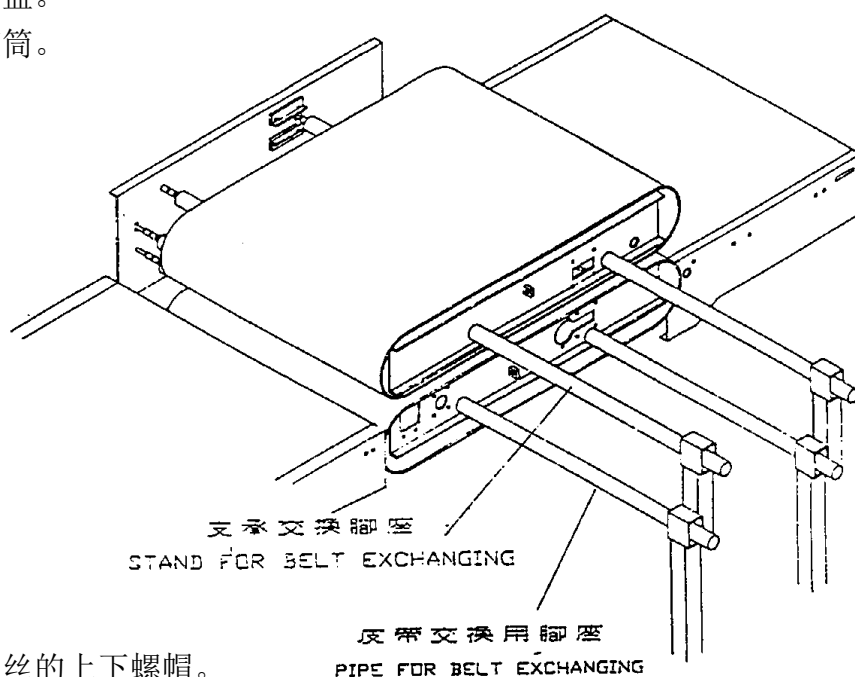
要根据所要作的内衬及布料的材质，来决定压衬所要设定的温度，压力及粘衬时间。

1. 请仔细查对适当的压衬条件（如温度，压力，及粘衬时间）。
2. 虽然皮带表面涂覆铁弗龙以作隔热之用，但是利器及铁质碎片及会造成皮带破损。
3. 所以要非常小心，不要将针，原子笔，或剪刀等东西放在皮带里。
4. 机器触摸屏内部参数，出厂前已设定好，切勿随意调节，否则会影响机器的正常运行。
用户只需设定所需的温度即可。
5. 不要把内衬反面倒放在皮带上，否则产品会被夹进上皮带的张力滚筒内。
6. 如果内衬本身超过布本身之范围，产品也有可能被夹进下皮带的张力滚筒内。
7. 偶尔要打开侧盖查看产品是否有夹进在张力滚筒内。
8. 请根据机器之使用状况，适时更换清洁布。
9. 要除去贴在皮带上之树脂相当困难，但如果用皮带清洁液，就能轻易清除。
10. 每个月或每两个月要给轴承及齿轮上油。
11. 请将机器调整水平后再开机运行。



如何更换皮带

1. 向机器后方的方向拉下拨片装置或刮片装置。
2. 打开前后盖将它们往侧边拉出。
3. 取下上盖及隔热板。
4. 将压力调到“0”位置，松开锁在压立柄上之螺丝。
5. 压立柄向左转，并将它取下。
6. 将左右侧盖取下。
7. 松开防偏急停开关固定螺丝将开关旋开以不影响皮带取出为准。
8. 稍微抬起后输送带即可取下螺丝一共6个，左右边各3个。
9. 稍微抬起工作台即可取下螺丝一共6个，左右边各3个。
10. 取下张力滚筒出口的外盖。
11. 取下张力弹簧及张力滚筒。
12. 取下主架轴。



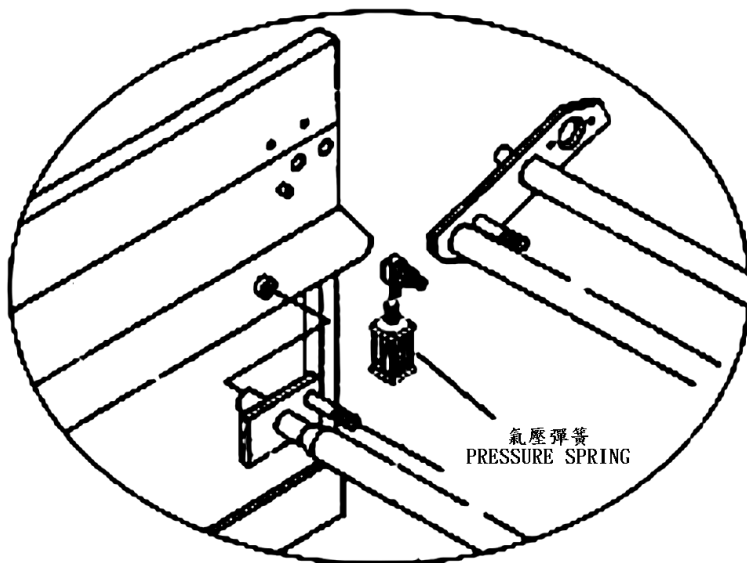
13. 取下右边压力弹簧上螺丝的上下螺帽。
14. 取下压力弹簧。
15. 取下固定上下主架之5个螺丝钉。
16. 抬起更换皮带用管，并将脚架放在管端部，然后从主架间之开口处拉出皮带。

※注意事项:

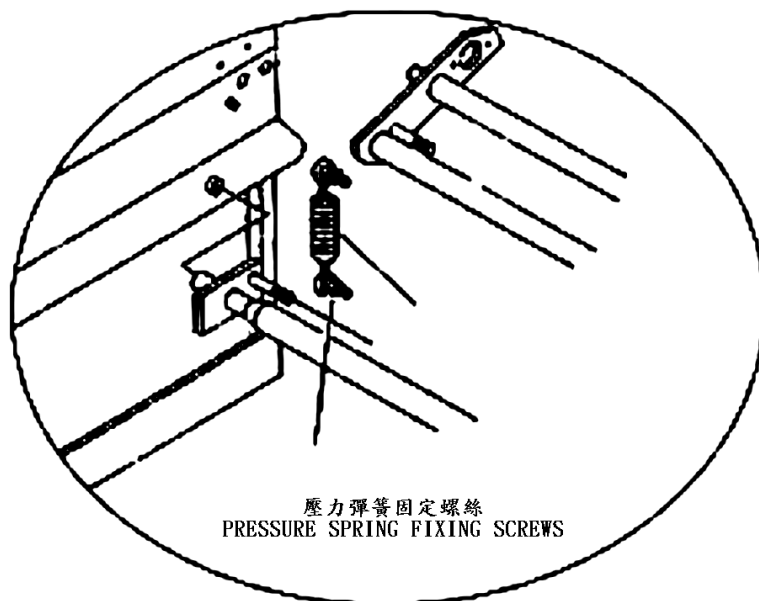
1. 拉出皮带时要小心，不要让皮带接触到异物。(如微动开关、铁件边角等异物。)
2. 主架上有组合的记号，在组合机器时务必对好记号然后销紧主架上的螺丝。
3. 更换新皮带之后，须重新调节机器的压力。
4. 组合完成后，将皮带速度设在35秒，等到皮带作2个循环后，确认无异常即可正常使用。

八、加压方式

1. 气动加压方式



2. 弹簧加压方式



十. 备用品之使用方法及说明：

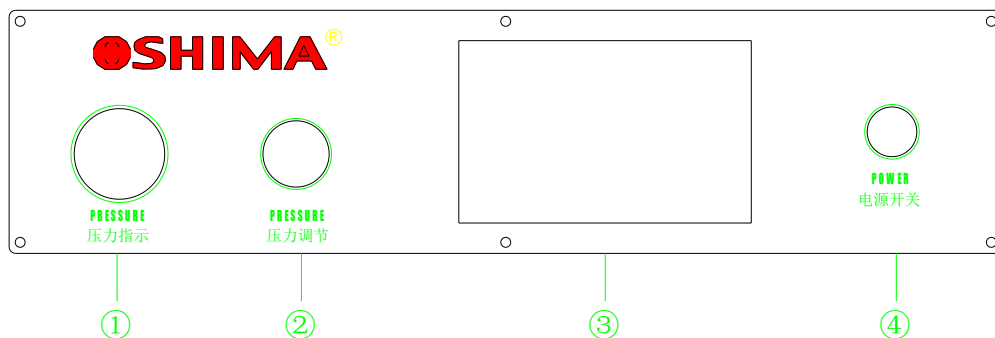
1. 耐温油（白色）

方法：将机油倒入后硅胶滚输边的油盖。

说明：白色的油脂可运用到修正螺杆及培林上使机器更容易运转。

2. 拉力弹簧：运用在拉力簧上，待拉力滚筒弹簧失效后便可更换之。

I. OPERATION PANEL:



- ① Pressure Indicator
- ② Pressure Adjust: Adjust the pressure level
- ③ Operation Display Panel
- ④ Power Switch: Turn on/ off the power.

II. OPERATION INSTRUCTIONS:

1. Turn on

- (1.) Turn on the circuit breaker switch on the right under the operation box of the machine.
- (2.) Press the power switch (Lock switch), the green lamp will be lit. (When the switch is locked, the power is on; when released the lock, the cooling system is running and the indicating lamp on the left side will be light.) Set up the speed switch (timer button), and the motor is running.
- (3.) Turning the thermostat button and setting up the suitable heating temperature of the front and back heater.
- (4.) Turning the fusing timer button for setting the suitable fusing time. (The shortest fusing time is 5 seconds.)
- (5.) Turning the pressure handle on the left side of the operating box, and setting the suitable pressure. The normal pressure is around 1.0-2.5kg/cm². The adjusting pressure range is around 0- 4.0kg/cm².
- (6.) After working, please adjust the pressure to "0", and press the power switch. When lock status is released, the machine will start cooling. When temperature decrease to 60°C, the machine will automatically stop.

2. Turn off the machine

After finishing the fusing process, it will be at a high temperature. Tap the power switch

on the screen, it will show shutdown delay, then the machine will shut down automatically while the temperature cools down to 60°C.

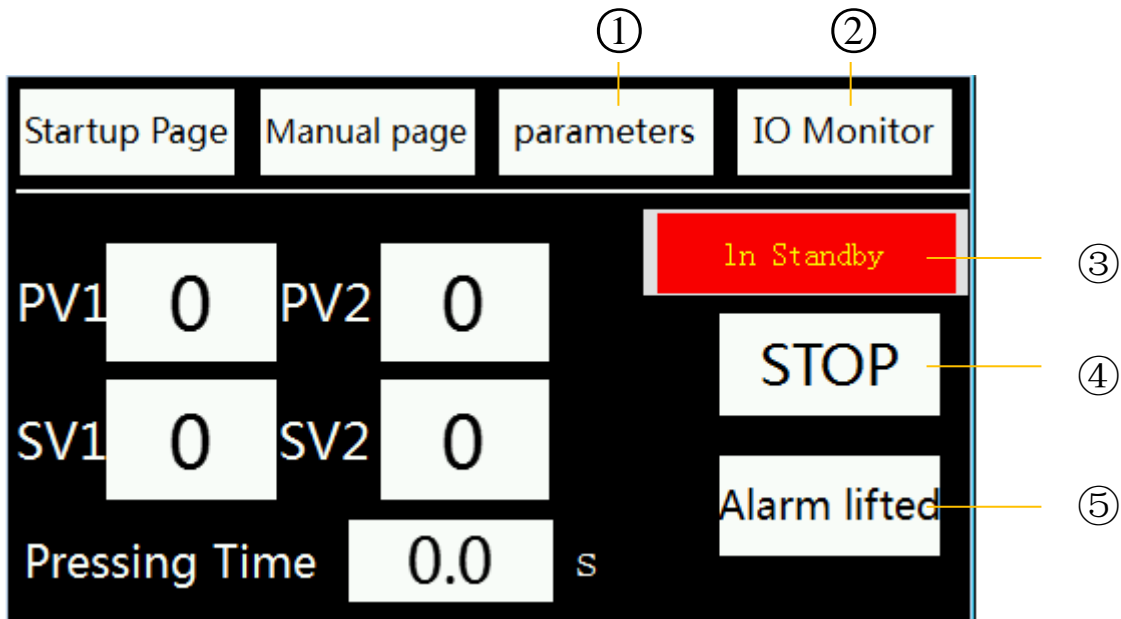
III. Interface

1. Startup Page: Turn on the power, the touch screen will display the startup page as shown in the image below. Select the language (中文/English) to enter the next page.



- ① Tap "中文" to enter the Chinese interface.
- ② Tap "English" to enter the English interface.
- ③ Scan this QR Code to enter the official website to learn more about OSHIMA.

2. Automatic page: This page is for inspecting only.



(1.) Tap "Parameters" to enter the Parameter Setting Page.

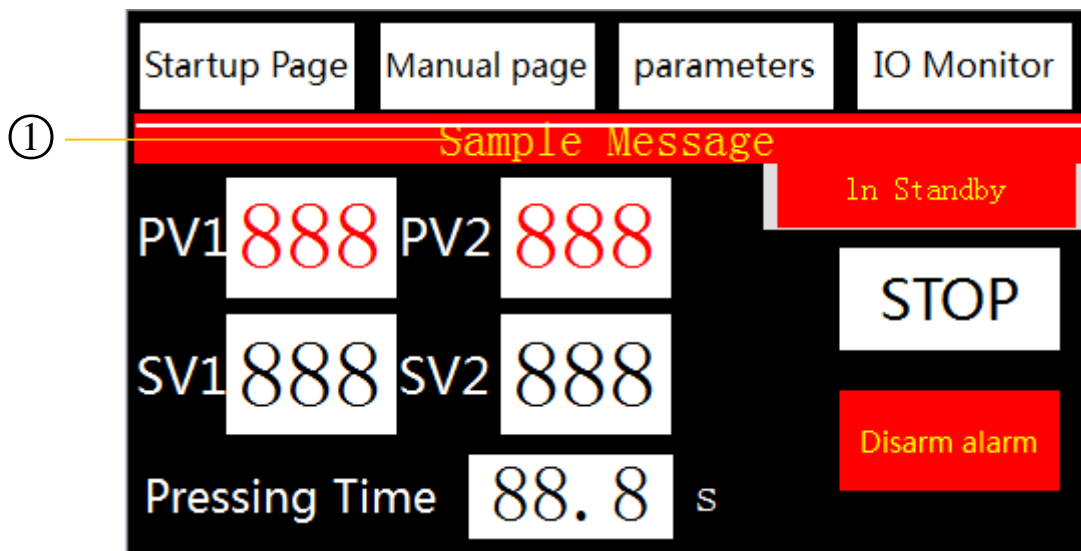
(2.) Tap "IO Monitor" to enter the PLC I/O Monitor Page.

(3.) The displaying status 1. In Standby 2 Running 3 Shutdown Delay

(4.) Startup / Shutdown Delay/Stop.

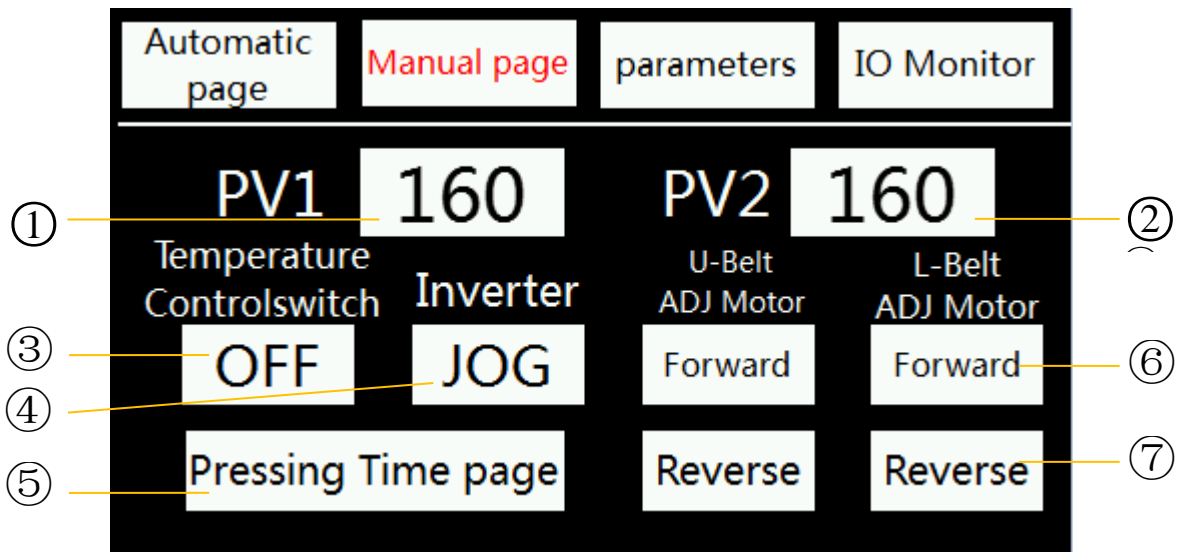
(5.) Alarm lifted: Tap "Alarm lifted" after troubleshooting.

3. Alarm Page:



(1.) Failure alert displayed

4. Manual Page

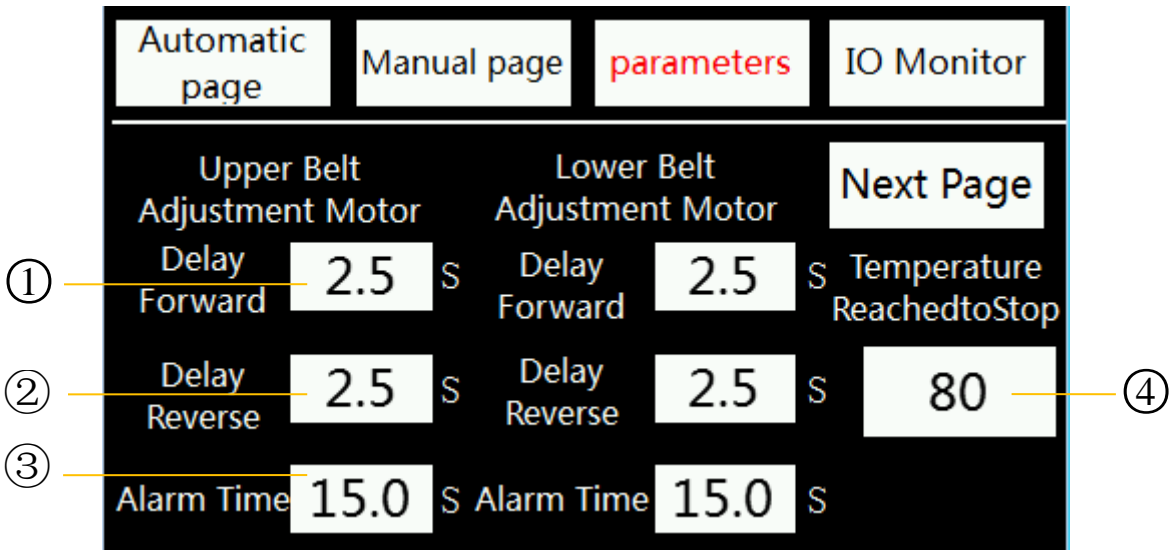


- (1.) Front Zone Temperature Setting
- (2.) Rear Zone Temperature Setting
- (3.) Heating control Switch
- (4.) Motor jogging operation
- (5.) Tap "Pressing time page" to enter the "speed adjustment page".
- (6.) Manual belt adjustment jogging Motor Forward Rotation
- (7.) Manual belt adjustment jogging Motor Reverse Rotation

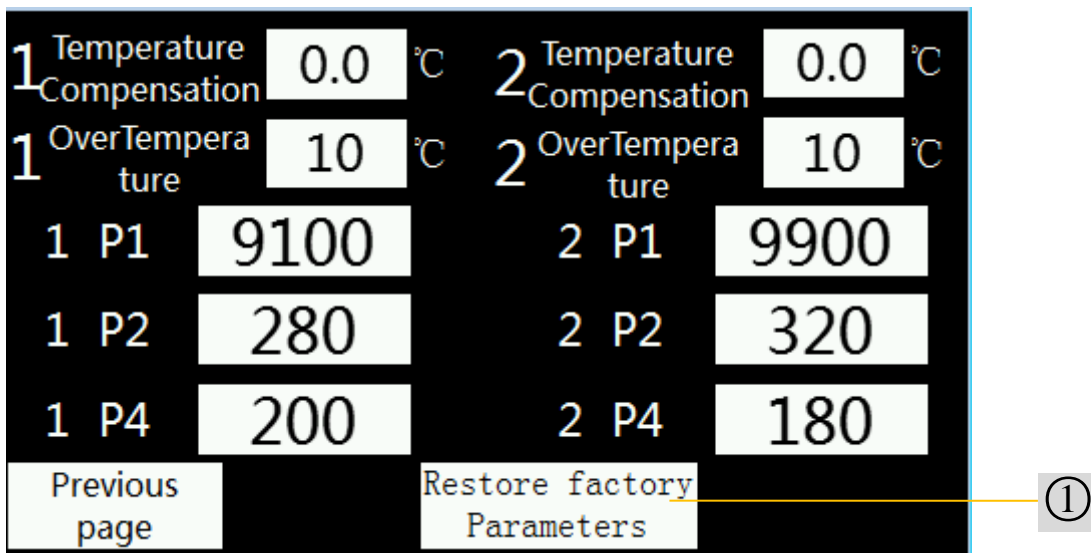
5. Speed adjustment page

Pressing Time	0.0 s	Stop	Automatic page
39	30	23	19
18	17	16	14
13	12.5	12	11
10.5	10	9.5	8.5
8	7.5	7	6

6. Parameters Page: The code for entering this page is “1269”



- (1.) Belt adjustment motor forward rotation delay time
- (2.) Belt adjustment motor reverse rotation delay time
- (3.) Belt adjustment motor belt deviates alarm time
- (4.) Set the temperature to stop the machine.



- (1.) Tap here to restore factory parameters

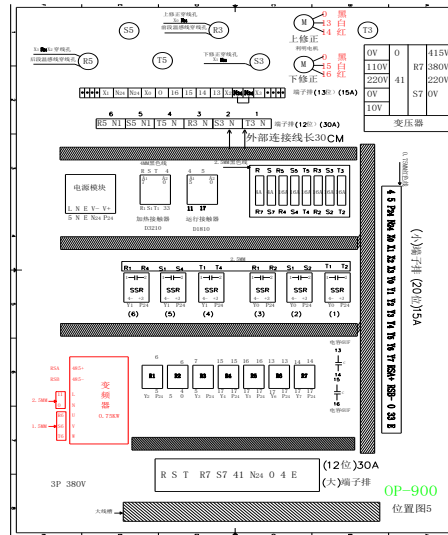
7. IO Monitor Page

Automatic page		Manual page		parameters		IO Monitor	
X0	U-Belt ADJ Sensor	X5	Stop	Y3	Heating		
X1	L-Belt ADJ Sensor	X6	Power Failure Signal	Y4	Lower Belt Adjustment Motor Forward Rotation		
X2	Left Limit	Y0	1 SSR	Y5	Lower Belt Adjustment Motor Reverse Rotation		
X3	Right Limit	Y1	2 SSR	Y6	Upper Belt Adjustment Motor Forward Rotation		
		Y2	Delay Stops	Y7	Upper Belt Adjustment Motor Reverse Rotation		

IV. HOW TO REPLACE THE BELT CLEANING ROD :

- (1.) The cleaning rod and scraper device are attached to the back of the machine.
- (2.) Take out the scraper device.
- (3.) The cleaning rod is attached to the position that can touch the upper and lower belt.
- (4.) When loosening the screw, the cleaning rod can be easily taken away. .
- (5.) Using the cotton cloth for replacing the cover of the rod, don't use the thick and rough cloth in order to prevent the belt from being damaged.
- (6.) Wrap 3 to 4 layers of cloth with rod to have the best cleaning result.

V. INNER COMPONENTS :



- (1.) Pressure roller (Upper)
- (2.) Pressure roller (Lower)
- (3.) Feed-in roller (Upper)
- (4.) Feed-in roller (Lower)
- (5.) Sub tension roller (Upper)
- (6.) Sub tension roller (Lower)
- (7.) Tension roller (Upper)
- (8.) Tension roller (Lower)
- (9.) Belt warping prevention roller (Upper)
- (10.) Belt warping prevention roller (Lower)
- (11.) 11 . Moiré roller
- (12.) Straight conveyor roller (Front)

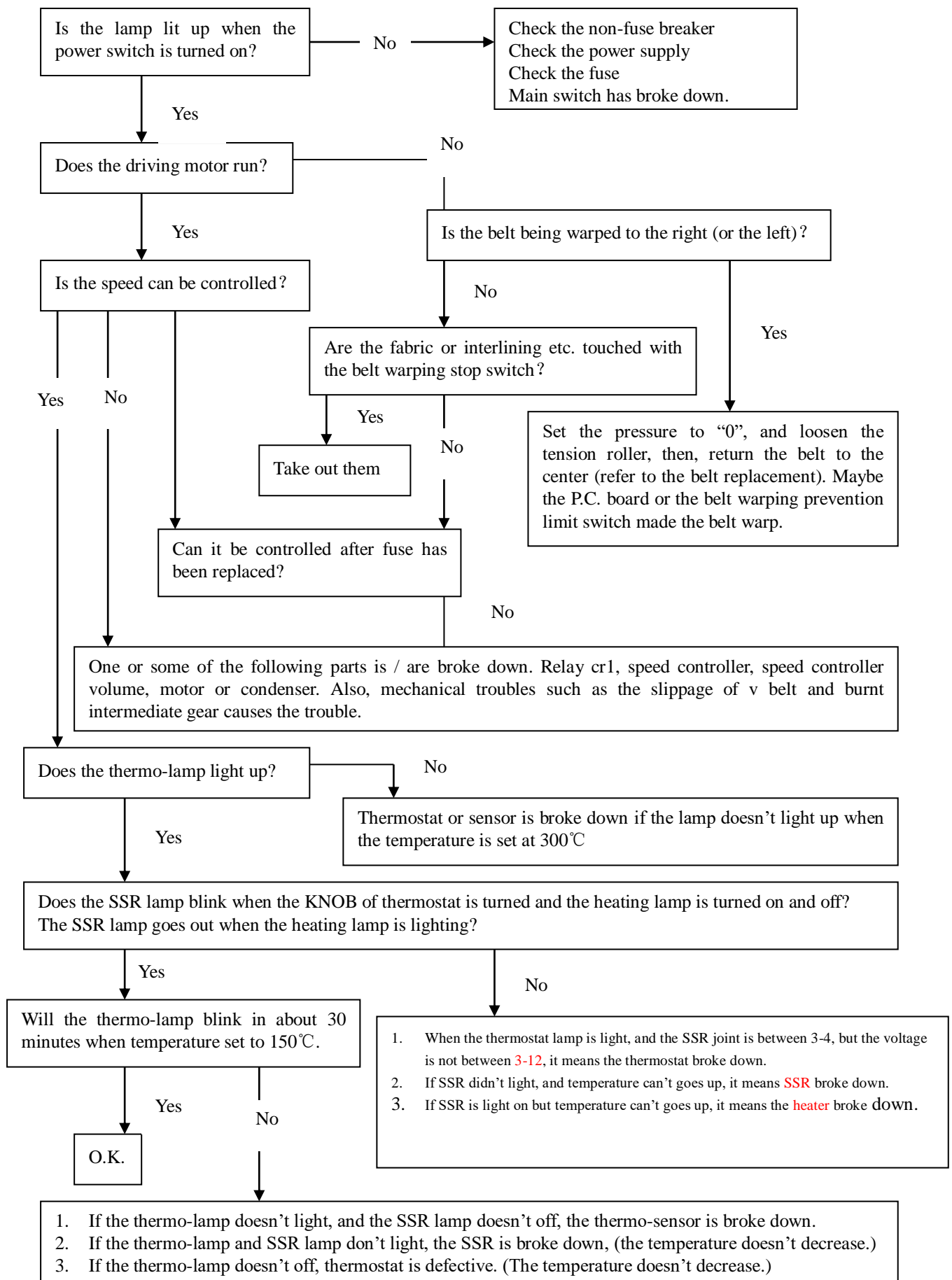
*Roller 5,6,13,15 can be adjusted to slide forward and backward.

*Roller 3,11 can be adjusted to slide up and down.

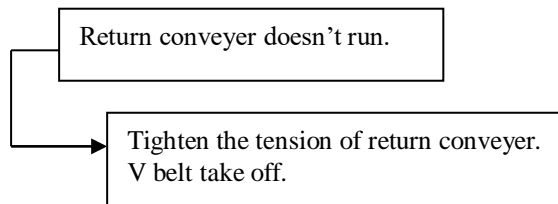
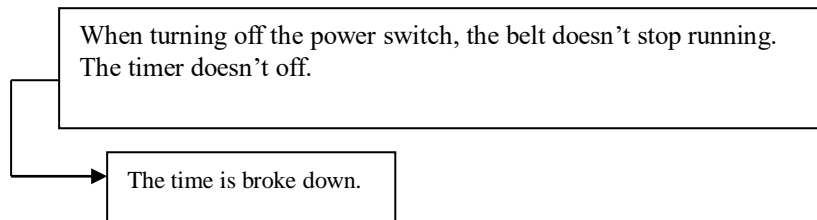
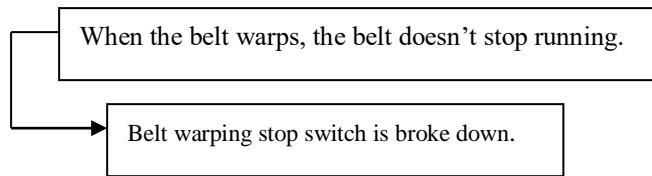
Setting combination of the heaters

Font /Rear Combination

VI. TROUBLESHOOTING :



OTHERS:



※In order to prevent mechanical trouble, Be sure to lubricate and grease-up the driving section.

VII. NOTE :

Please set up the temperature, pressure and fusing time for fusing according to the material of fabric and interlining.

- (1.) Please check the suitable fusing conditions. (Such as temperature, pressure and fusing time.)
- (2.) Although the surface of the belt is coated with Teflon material for heat proofing, but the sharp tools or ferrous pieces still will damage the belt.
- (3.) Please be careful, don't put the needle, pen or scissors onto the belt.
- (4.) Don't put the interlining upside down on the belt, or it will be caught in the tension roller of the upper belt.
- (5.) If the interlining is too long and over the fabric, it will be caught in the tension roller of the lower belt.
- (6.) Please open the side cover to check whether interlining has caught in the tension roller sometimes.
- (7.) Replace the cloth of the cleaning rod with a new cover before it gets dirty.
- (8.) It is very hard to remove the glues adhered to the belt, but it can be cleaned up easily with " belt cleaner " .
- (9.) Lubricates the bearings and gears every month.
- (10.) Please make sure to open the machine and operate it after adjusting the machine to level.

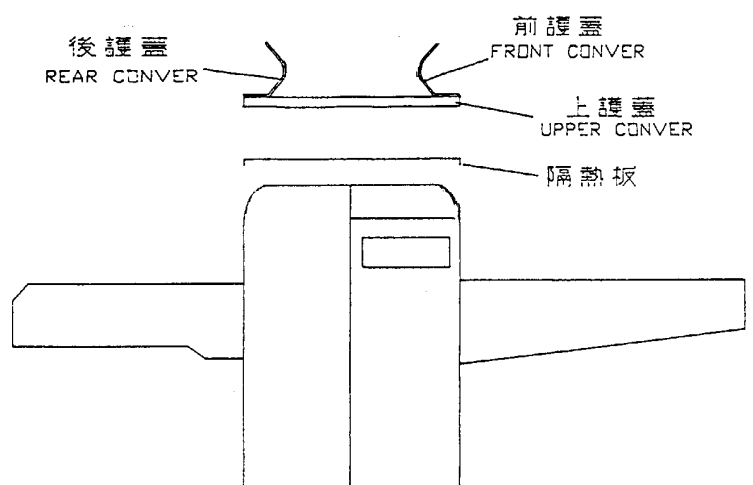
VIII. HOW TO REPLACE THE BELT :

- (1.) Take out the rotary strip-off device or scraper backward the machine.
- (2.) Open the front and back cover.
- (3.) Lift the upper cover and adiabatic plate.
- (4.) All the parameters are set at the factory.

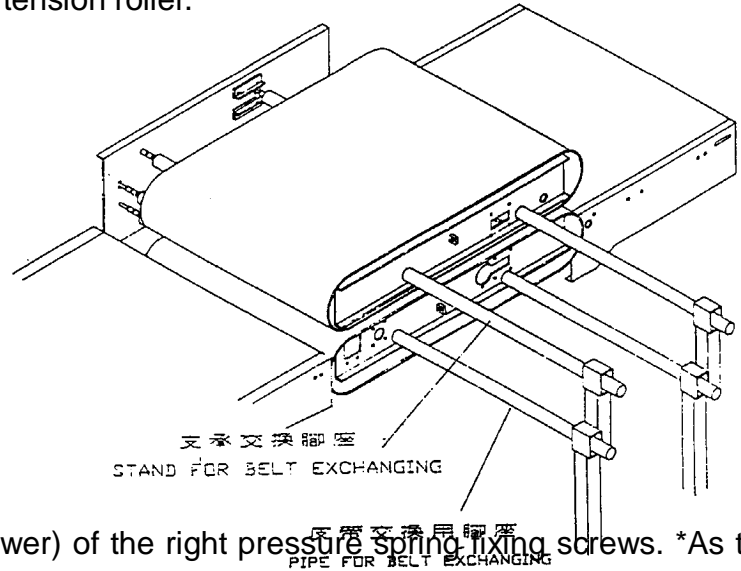
Please do not adjust the parameters.

The user only has to set the needed temperature.

- (5.) Adjust the pressure to "0", and lose the screw of the pressure handle.
- (6.) Turn the pressure handle to the left, and take it off.
- (7.) Remove the left and the right covers.
- (8.) If the machine is return type, please loose the screw of the roller at the front of the conveyor belt.



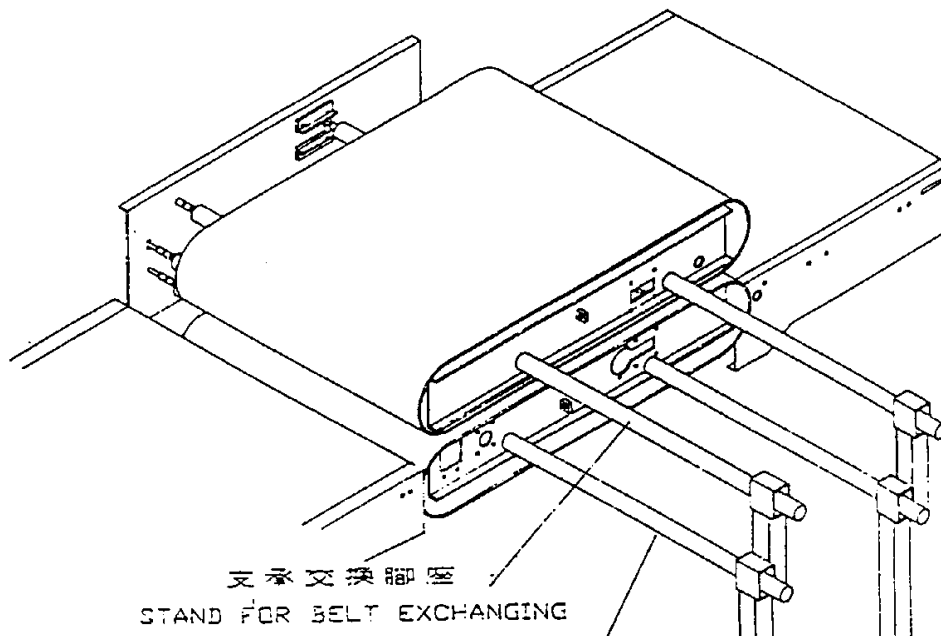
- (9.) Lift the back conveyor belt and there are 4 pieces of screw that can be taken out. 2 each on the left and the right side.
- (10.) Lift the working table and there are 4 pieces of screw can be taken out. 2 each on the left and right side.
- (11.) Remove the cover which is in front of the exit of the tension roller.
- (12.) Take out the tension spring and tension roller.
- (13.) Remove the frame shaft.



- (14.) Take off the nuts (upper & lower) of the right pressure spring fixing screws. *As the nut is double type, please use the spanner to loosen the nut.
- (15.) Remove the pressure spring.
- (16.) Loose the 5 screws which are fixed in the upper and lower main shelf. Lift the pipe, which is used for replacing the belt, and put the stand to support the pipe, and then take out the belt.

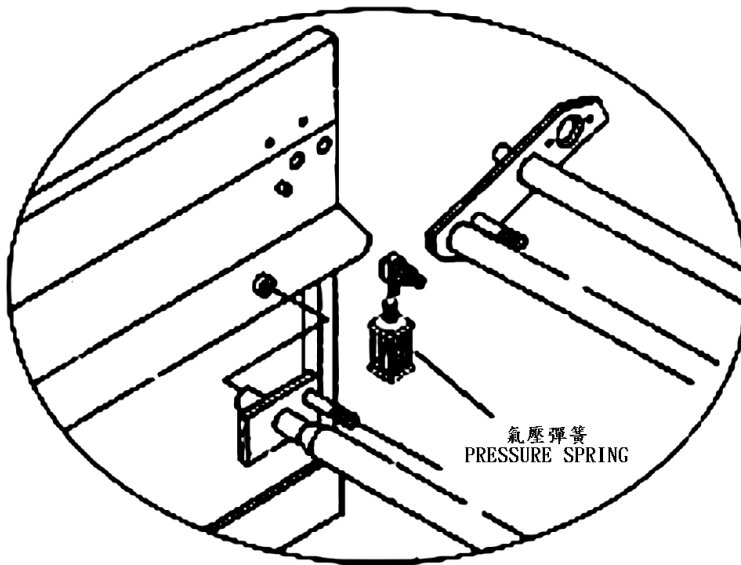
※NOTE :

- (1.) Please take out the belt carefully, don't let the belt touch the belt warping prevention limit switch.
- (2.) There is a mark on the main shelf to let you know how to combine the parts. Please follow it to combine the parts.
- (3.) After replacing the new belt, the tension spring must be attached at the same time.
- (4.) After combining all the parts, please set up the belt speed of the belt at 35 seconds. When the belt runs 2 circles and then the machine can be working as usual.

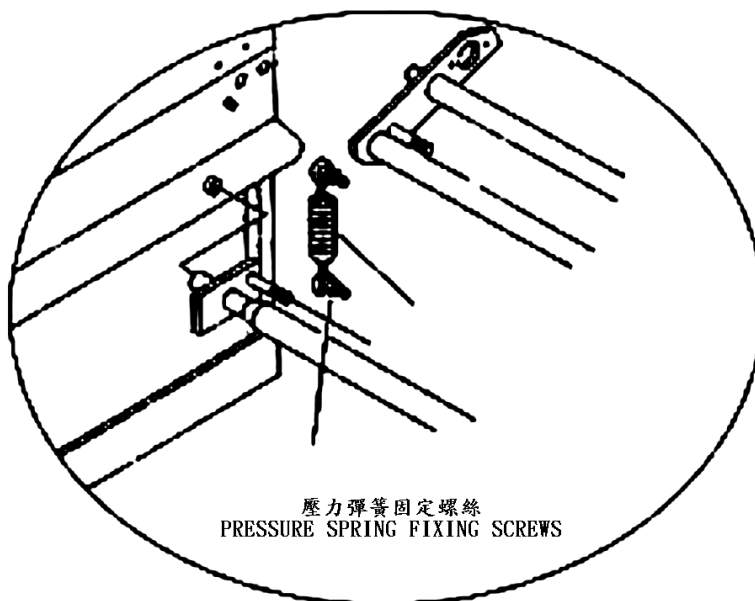


IX. The pressure type :

1. Pneumatic type



2. Spring type



3. The description of spare parts:

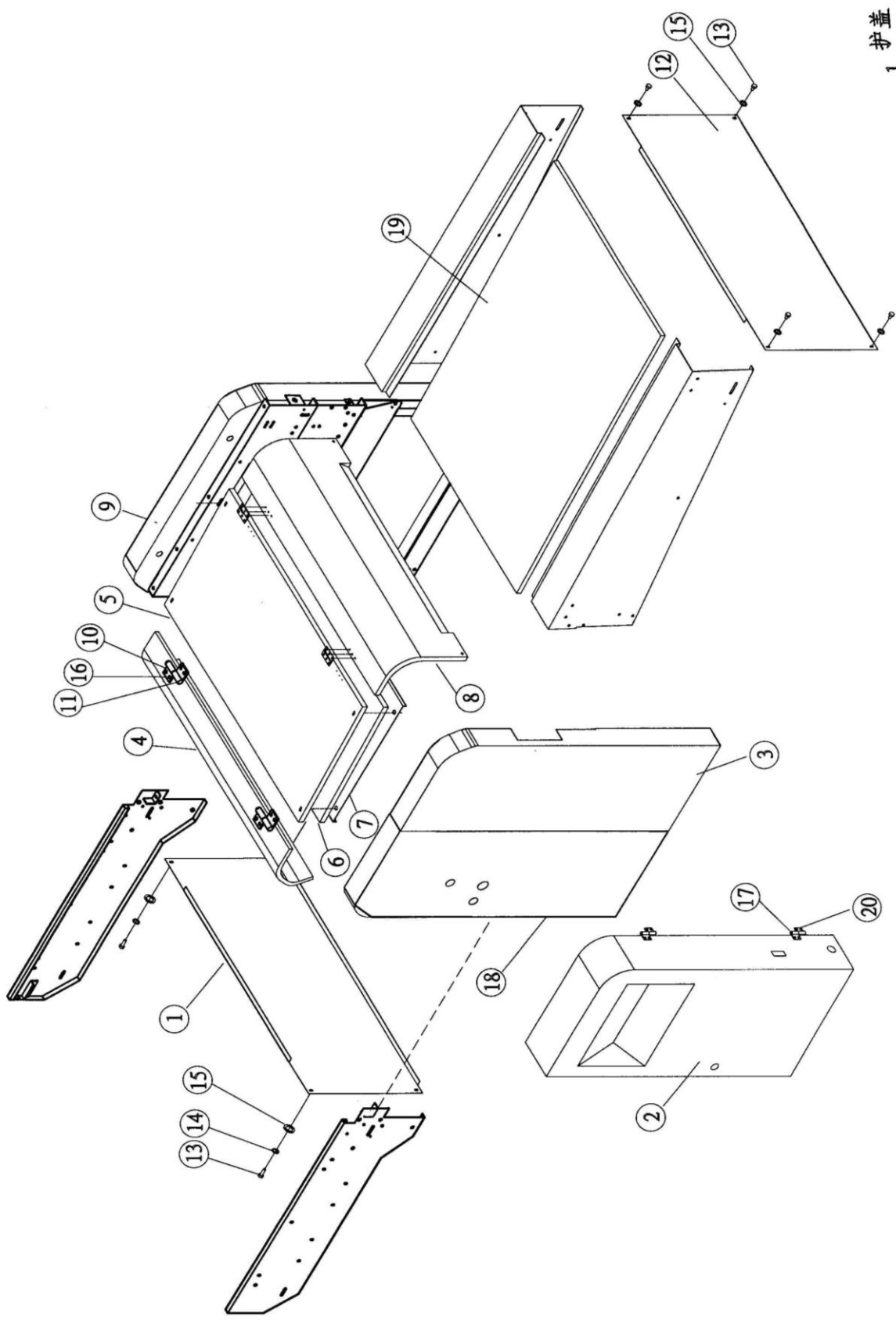
(1.) Heatproof oil (white)

Put the oil into the oil tank near the back silicon roller. The white grease may be applied on adjusting screw shafts and bearings, so as to make the machine operate more smoothly.

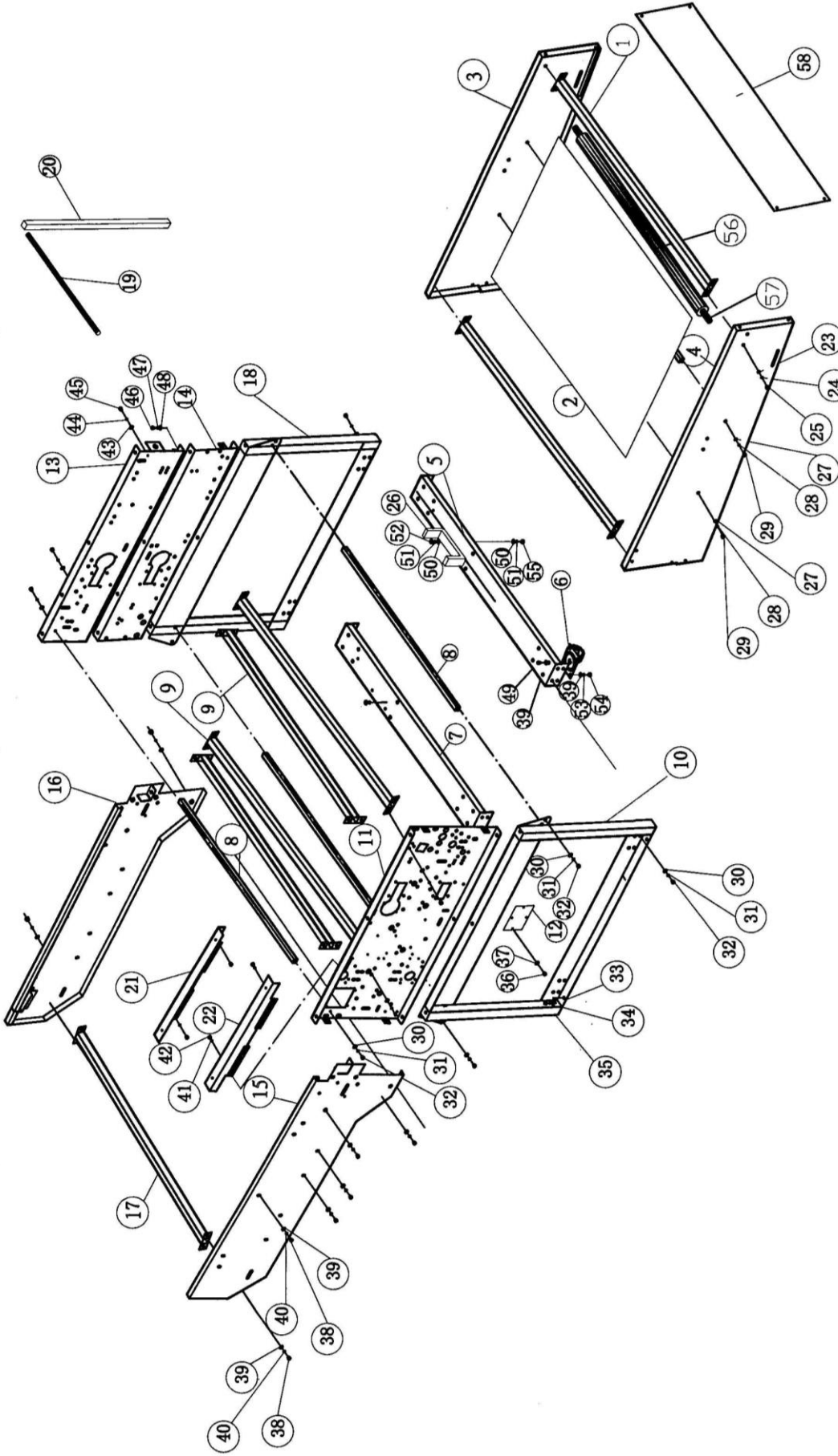
(2.) Tension spring

It is for replacement, when the tension roller spring is out of function.

护盖
1 COVER



序	R																																									
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NO.2

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机械零件目录

NO.2-1

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	90LDA059	工作台横梁	Beam of working table	2	
	100LDA019	工作台横梁	Beam of working table	2	
2	90LDA304	皮带底板	Belt bottom board	1	OP-900L/LA 用
	100LDA022	皮带底板	Belt bottom board	1	OP-1000L/LA 用
3	900A101	入口侧板 (左)	Enter sideboard(左)	1	OP-900/A/1000/A 用
	90LDA301	入口侧板 (左)	Enter sideboard((左)	1	OP-900L/LA 1000L/LA 用
4	900A102	入口侧板 (右)	Enter sideboard(右)	1	OP-1000/A/900/A 用
	90LDA302	入口侧板 (右)	Enter sideboard(右)	1	OP-900L/LA 1000L/LA 用
5	90LDA033	前底架	Front bottom shelf	1	
	100LDA015	前底架	Front bottom shelf	1	
6	ZW0132	仿中古轮 3"	Copy wheel	4	
7	90LDA032	后底架	The back shelf	1	
	100LDA014	后底架	The back shelf	1	
8	90LDB103	主体轴芯	The bearing of main body	3	
	100LDB006	主体轴芯	The bearing of main body	3	
9	90LDA026	机身横梁	Beam of machine body	3	
	100LDA012	机身横梁	Beam of machine body	3	
10	90LDA003	架体	Shelf body	1	
11	90LDA001	左侧臂	Left side arm	1	
12	90LDA041	封板	Cover board	1	
13	90LDA021	右上侧壁	Right upper side	1	
14	90LDA020	右下侧壁	Right lower side	1	
15	900A013	后右侧板	The back right side board	1	
16	900A014	后左侧板	The back right side board	1	
17	90LDA024	输送带横梁	Beam of conveyor belt	2	OP-900/L/LA 用
	100LDA013	输送带横梁	Beam of conveyor belt	2	OP-1000/L/LA 用
18	90LDA002	架体	Shelf body	1	
19	90LDA066	装皮带抬架杆	The shelf of install belt	4	
20	90LDA049	上撑杆	Upper rod	2	

机械零件目录

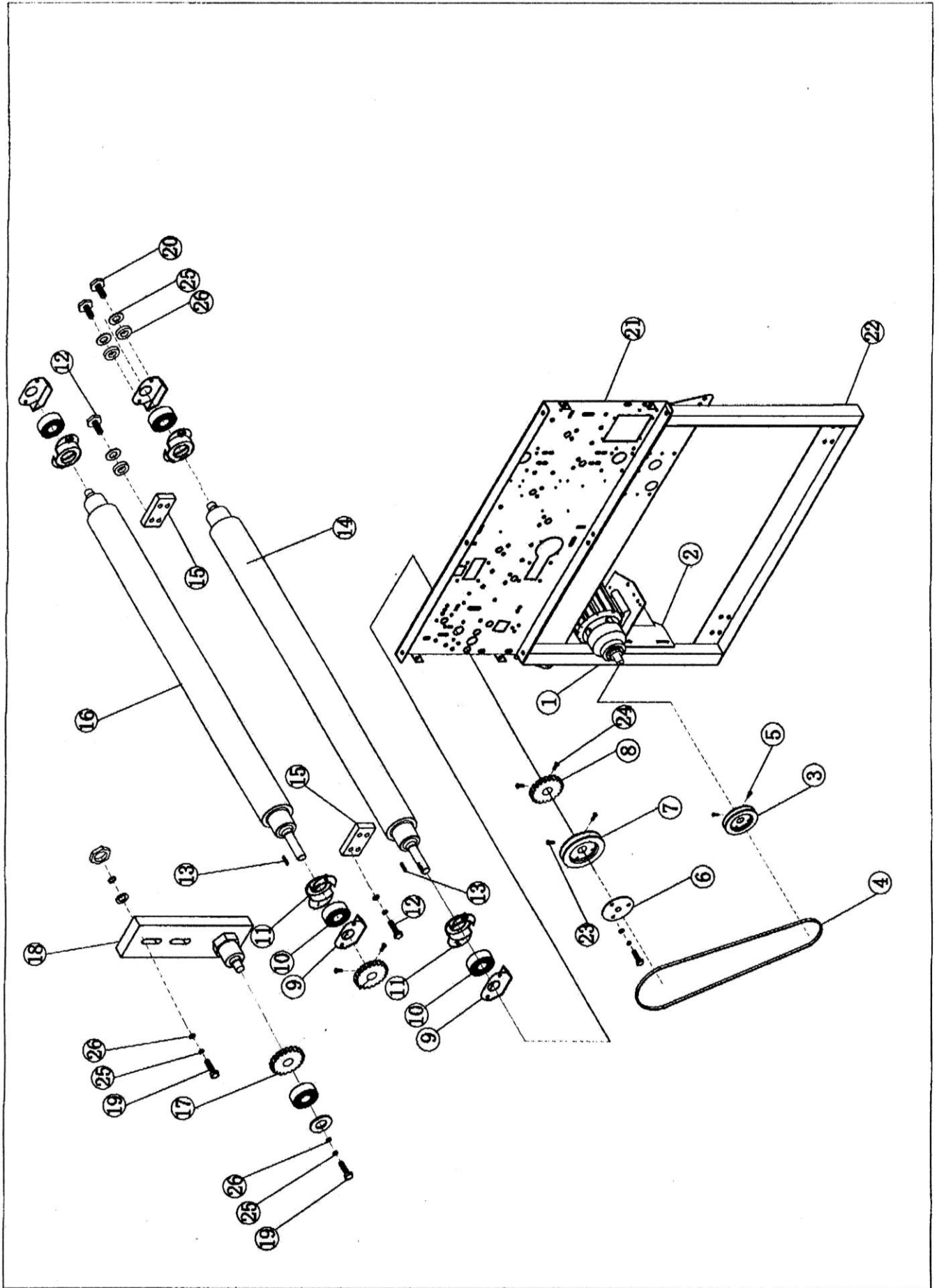
NO.2-2

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
21	90LDA054	上盖挡板	Upper cover stopper	1	
22	90LDA054	上盖挡板	Upper cover stopper	1	
23	JF1013	平垫 8	Flat coaster	8	
24	JF2007	弹垫 8	Spring coaster	4	
25	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
26	90LDA060	中间架	Middle shelf	1	
27	JF1013	平垫 8	Flat coaster	8	
28	JF2007	弹垫 8	Spring coaster	4	
29	JD1228	外六角螺丝 M8	Outside hexagon screw	6	
30	JF1013	平垫 8	Flat coaster	8	
31	JF2007	弹垫 8	Spring coaster	4	
32	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
33	JM1009	外六角螺丝 M8	Outside hexagon screw	4	
34	JM1009	外六角螺丝 M8	Outside hexagon screw	4	
35	JD1354	外六角螺丝 M16	Outside hexagon screw	4	
36	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
37	JF1013	平垫 8	Flat coaster	8	
38	JF1013	平垫 8	Flat coaster	8	
39	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
40	JF2007	弹垫 8	Spring coaster	4	
41	JF2006	弹垫 6	Spring coaster	4	
42	JD1314	外六角螺丝 M6	Outside hexagon screw	4	
43	JF1013	平垫 8	Flat coaster	8	
44	JF2007	弹垫 8	Spring coaster	4	
45	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
46	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
47	JF2007	弹垫 8	Spring coaster	4	
48	JF1013	平垫 8	Flat coaster	8	
49	JD1228	外六角螺丝 M8	Outside hexagon screw	4	
50	JF1013	平垫 8	Flat coaster	8	
51	JF2007	弹垫 8	Spring coaster	4	

机械零件目录

NO.2-3

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
52	JD1228	外六角螺丝 M8	outside hexagon screw	4	
53	JF2007	弹垫 8	spring coaster	4	
54	JM2005	外六角螺母 M8	outside hexagon screw	8	
55	JF1013	平垫 8	flat coaster	8	
56	90LDB108	滚筒	roller	1	OP-900L/LA 用
	100LDB011	滚筒	roller	1	OP-1000L/LA 用
57	90LDB104	皮带滚筒轴芯	Belt Roller Shaft	2	OP-900L/LA 用
	100LDB007	皮带滚筒轴芯	Belt Roller Shaft	2	OP-1000L/LA 用
58	90LDA303	前侧封板	Front Side cover	1	
	100LDA021	前侧封板	Front Side cover	1	

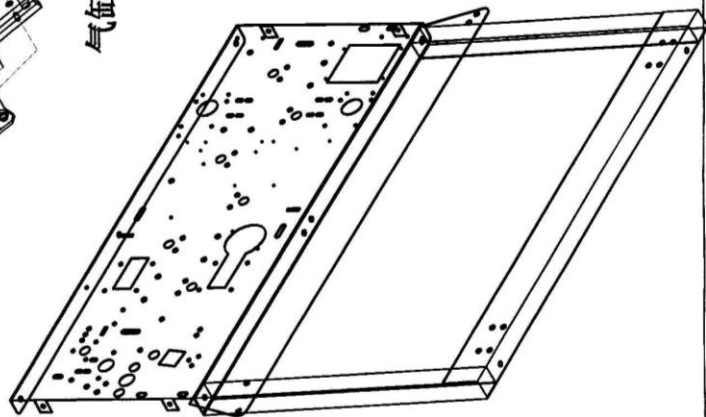
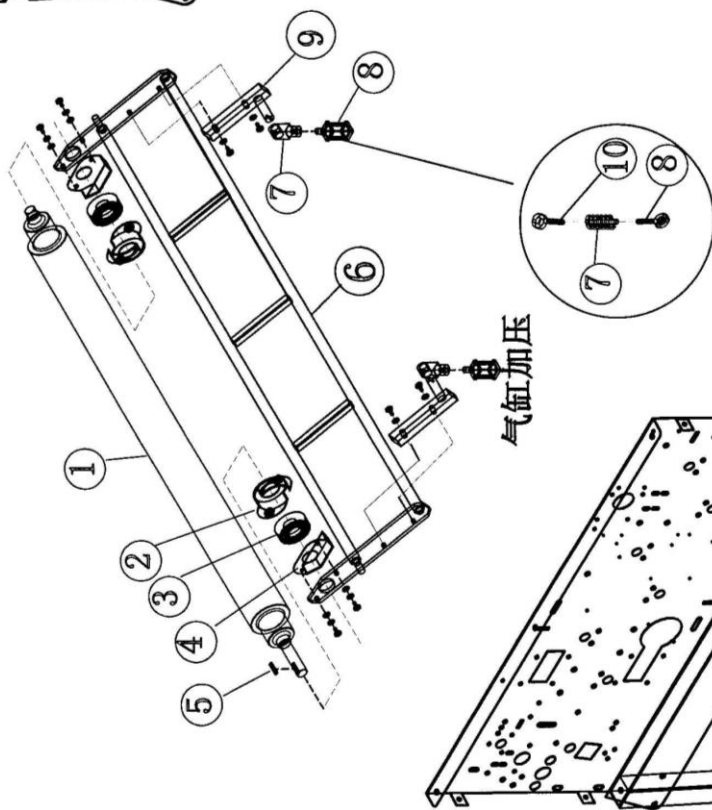
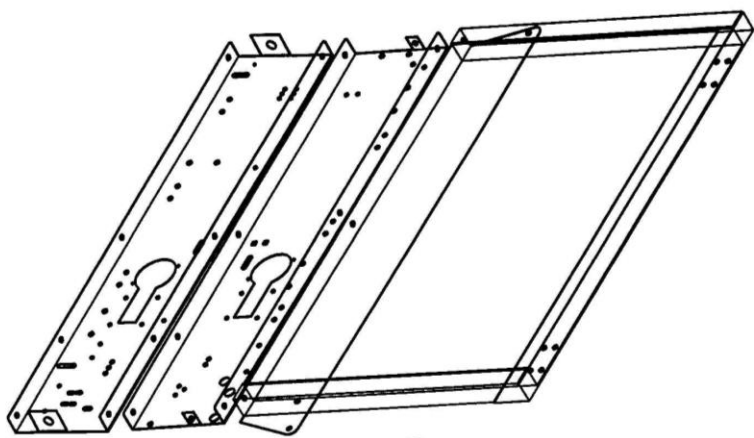


机械零件目录

NO.3

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	DM0112-1	主马达	Main motor	1	
2	90LDA038	马达座	Motor base	1	
3	90LDB121	马达皮带轮	The belt wheel of motor	1	
4	JP0114	皮带 A-46	Belt	1	
5	JD7027	内六角凹端紧定螺钉 M6*10	Inner hexagon screw	2	
6	90LDA028	手动盘	Manual plate	1	
7	90LDB120	被动皮带轮	Passive belt wheel	1	
8	90LDB123	硅胶滚筒齿轮	Silicid idler	2	
9	90LDA036	油壶	oiler	1	
10	JB2071	培林 6204	bearing	4	
11	90LDB134	轴承座	Bearing base	4	
12	JD2040	圆柱头内六角 M6*16	Within hexagon screw	8	
13	JJ1003	键 5*5	Key	2	
14	100LDB004	上硅胶滚筒	The upper silicid roller	1	OP-1000/L/LA 用
	90LDB101	上硅胶滚筒	The upper silicid roller	1	OP-900/L/LA 用
15	90LDB132	压力挡板	Pressure stopper	2	
16	90LDB102	下硅胶滚筒	The lower silicid roller	1	OP-900/L/LA 用
	100LDB005	下硅胶滚筒	The lower silicid roller	1	OP-1000/L/LA 用
17	90LDB124	输送带惰轮	The idler of conveyor	1	
18	90LDB007	惰轮座	Idler base	1	
19	JD1037	外六角螺丝 M8*20	Outside hexagon screw	2	
20	JD2041	内六角螺丝 M6*20	Inner hexagon screw	8	
21	90LDA001	左侧壁	left side board	1	
22	90LDA003	架体	shelf body	1	
23	JD7037	内六角凹端紧定螺钉 M8*10	Inner hexagon nook bolt	2	
24	JD7027	内六角凹端紧定螺钉 M6*10	Inner hexagon nook bolt	4	
25	JF2007	弹垫 M8	Spring coaster	2	
26	JF1012	平垫 M8	Flat coaster	2	
27	JF2006	弹垫 M6	Spring coaster	16	

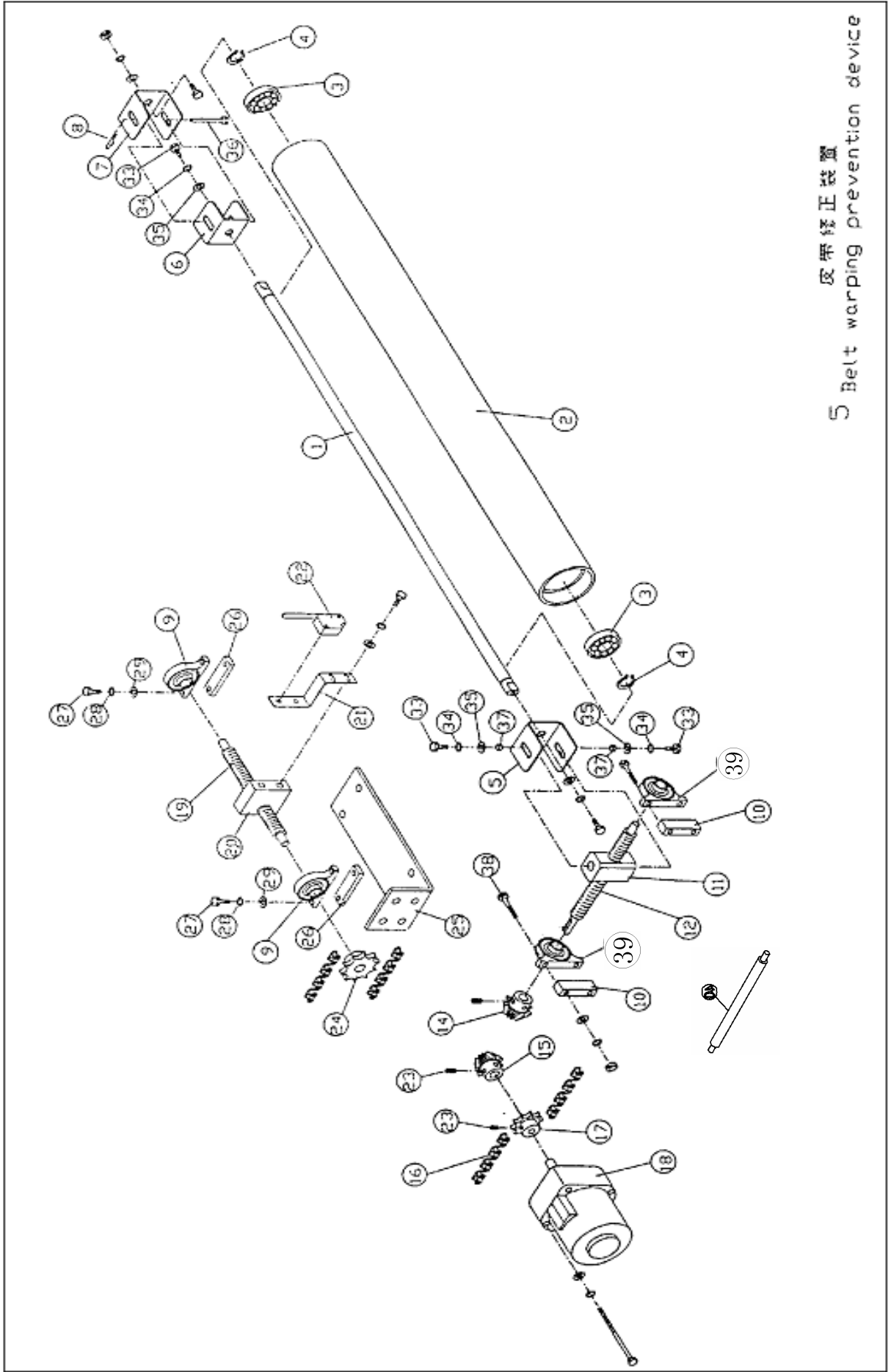
壓力調整
4 Pressure adjustable



机械零件目录

NO.4

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	90LDB102	下硅胶滚筒	The lower silicic roller	1	
	100LDB005	下硅胶滚筒	The lower silicic roller	1	
2	90LDB039	轴承座	Bearing base	6	
3	JB2021	轴承 6204	Bearing	2	
4	90LDA036	油壶	Oiler	4	
5	JJ1002	键 4*4	Key	2	
6	90LDA052	压力臂架	Pressure arm shelf	1	
	100LDA018	压力臂架	Pressure arm shelf	1	
7	JB1030	培林 SA10T/K	Bearing	2	OP-900A/LA 1000A/LA 用
	90LDB207	弹簧 $\phi 6.5 \times 14$ 圈	Spring coaster circle	2	OP-900/L 1000/L 用
8	QG0121	气缸 SC50-20	Cylinder	2	OP-900A/LA 1000A/LA 用
	JB1014	培林 POS-8 左牙	Bearing	2	OP-900/L 1000/L 用
9	90LDB061	气缸支援块 2	Cylinder of support	2	OP-900A/LA 1000A/LA 用
	90LDB061-1	气缸支援块	Cylinder of support		OP-900/L 1000/L 用
10	JB1015	培林 POS-8 右牙	Bearing	2	OP-900/L 1000/L 用



5 皮带修正装置
Belt warping prevention device

机械零件目录

NO.5-1

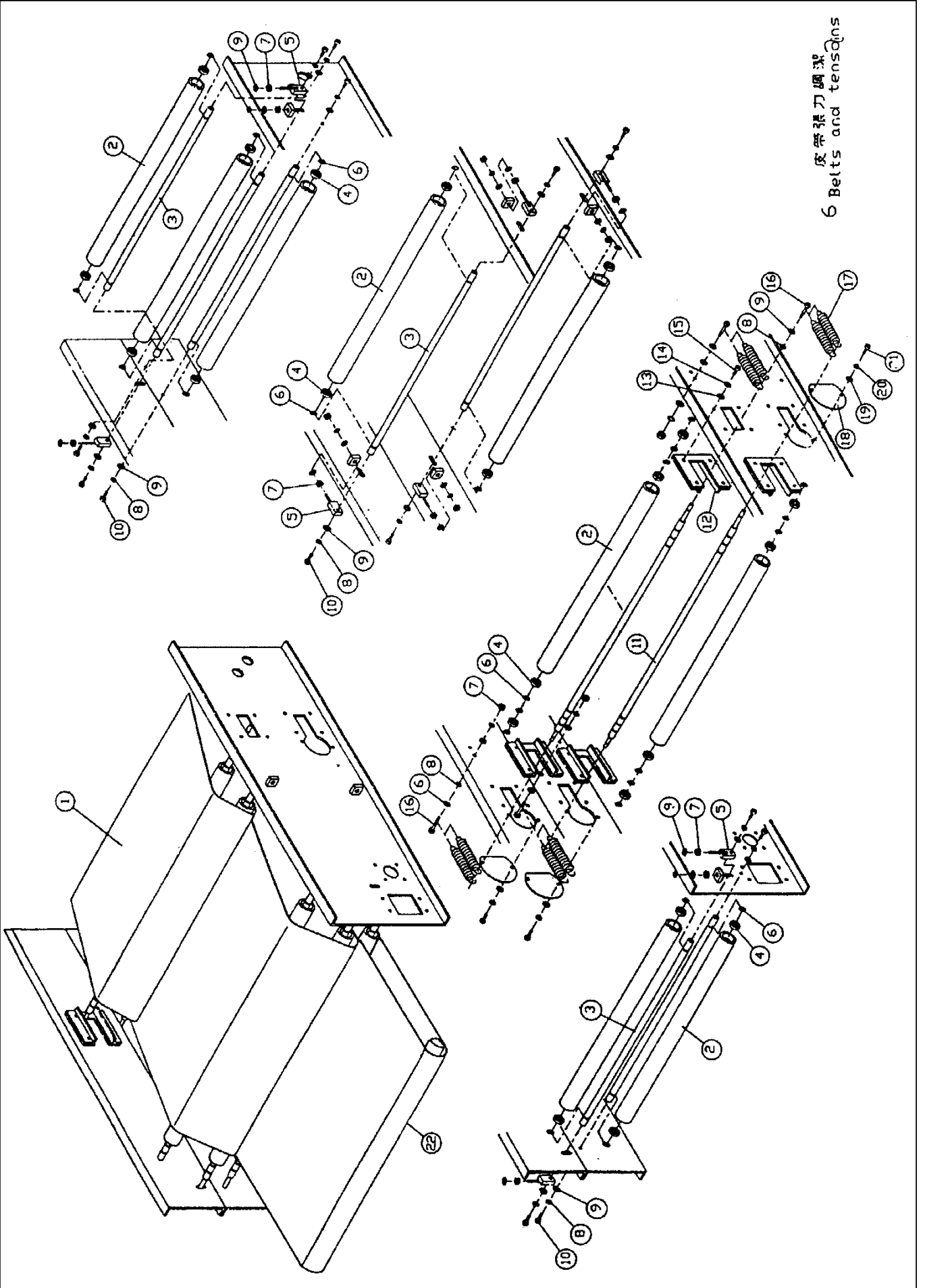
序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	90LDB110	修正轴	Redress shaft	2	
	100LDB013	修正轴	Redress shaft	2	
2	90LDB109	修正滚筒	Redress roller	2	
	100LDB012	修正滚筒	Redress roller	2	
3	JB2071	轴承 6204C4	Bearing	2	
4	JC1016	轴用挡圈 $\phi 18$	Elasticity stopper for axes	4	
5	90LDA055	修正固定耳	Redress fixer	2	
6	90LDA015	修正固定耳	Redress fixer	2	
7	90LDA023	修正固定耳	Redress fixer	2	
8	JX0005	开口销	Cotter	2	
9	JB1006	轴承 UP000	Bearing	4	
10	90LDB130	大轴承垫块	Big bearing coaster	4	
11	90LDB112	修正滑块	Redress slide piece	2	
12	90LDB118	修正螺杆	Redress screw rod	2	
14	90LDB126	伞形齿轮组 M1.5*20/20T	Umbrella rowel	2	
15	90LDB126	伞形齿轮组 M1.5*20/20T	Umbrella rowel	2	
16	JL1007	2分链条 38目	Chain	2	
17	90LDB129	修正链轮 RS25*14T	Redress motor	2	
18	DM0344-1	修正马达 YN80-25/JB50G10-T220V	Redress motor	2	
19	90LDB119	修正螺杆	Redress screw rod	2	
20	90LDB133	修正垫块	Redress coaster	2	
21	90LDA031	下修正开关座	Lower micro switch base	1	
22	DK0101	修正开关 AH7153360-5A	Micro switch	2	
23	JD7029	紧定螺钉 M6	Fixed screw	2	
24	90LDB128	修正链轮 RS25*20T	Redress chain wheel	2	
25	90LDA050	修正支持座	Redress support base	2	
26	90LDB131	小培林垫块	Small bearing	4	
27	JD1314	外六角螺栓 M6	Outside hexagon screw	8	
28	JF2006	弹垫 6	Spring coaster	8	
29	JF1011	平垫 6	Flat coaster	8	
30	JD1102	外六角螺栓 M4	Outside hexagon screw	4	

机械零件目录

NO.5-2

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
31	JF2004	弹垫 4	Spring coaster	4	
32	JF1011	平垫 6	Flat coaster	4	
33	JD1228	外六角螺栓 M8	Outside hexagon screw	8	
34	JF2007	弹垫 8	Spring coaster	8	
35	JF1013	平垫 8	Flat coaster	8	
36	90LDB122	销	Shaft	2	
37	90LDB135	修正衬套	Redress bushing	4	
38	JD1314	外六角螺栓 M6	Outside hexagon screw	8	
39	JB1020	轴承 UP001	bearing	4	
40	90LDB130-1	支撑杆	supporting base	2	

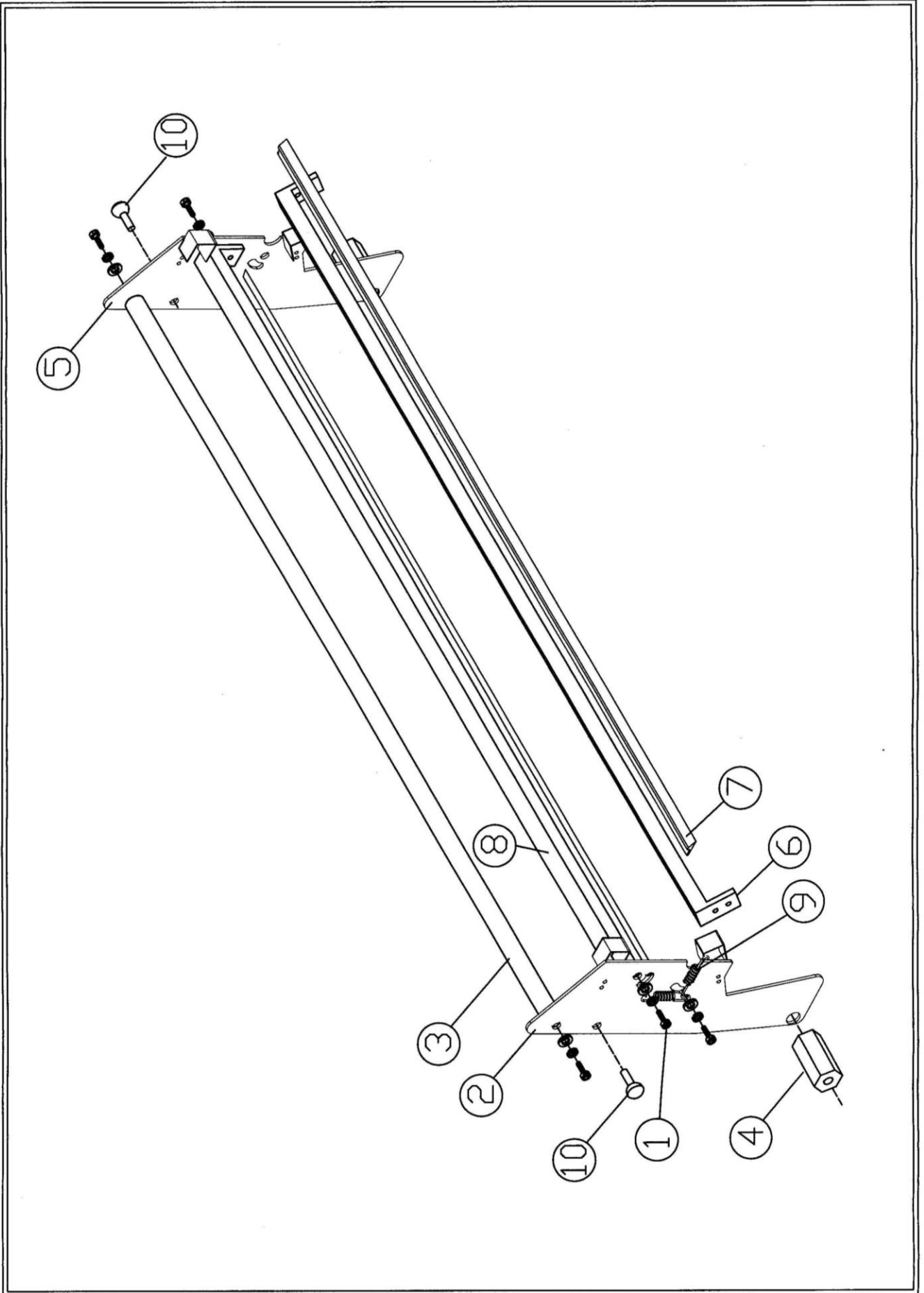
皮帶張力調整
6 Belts and tensions



机械零件目录

NO.6

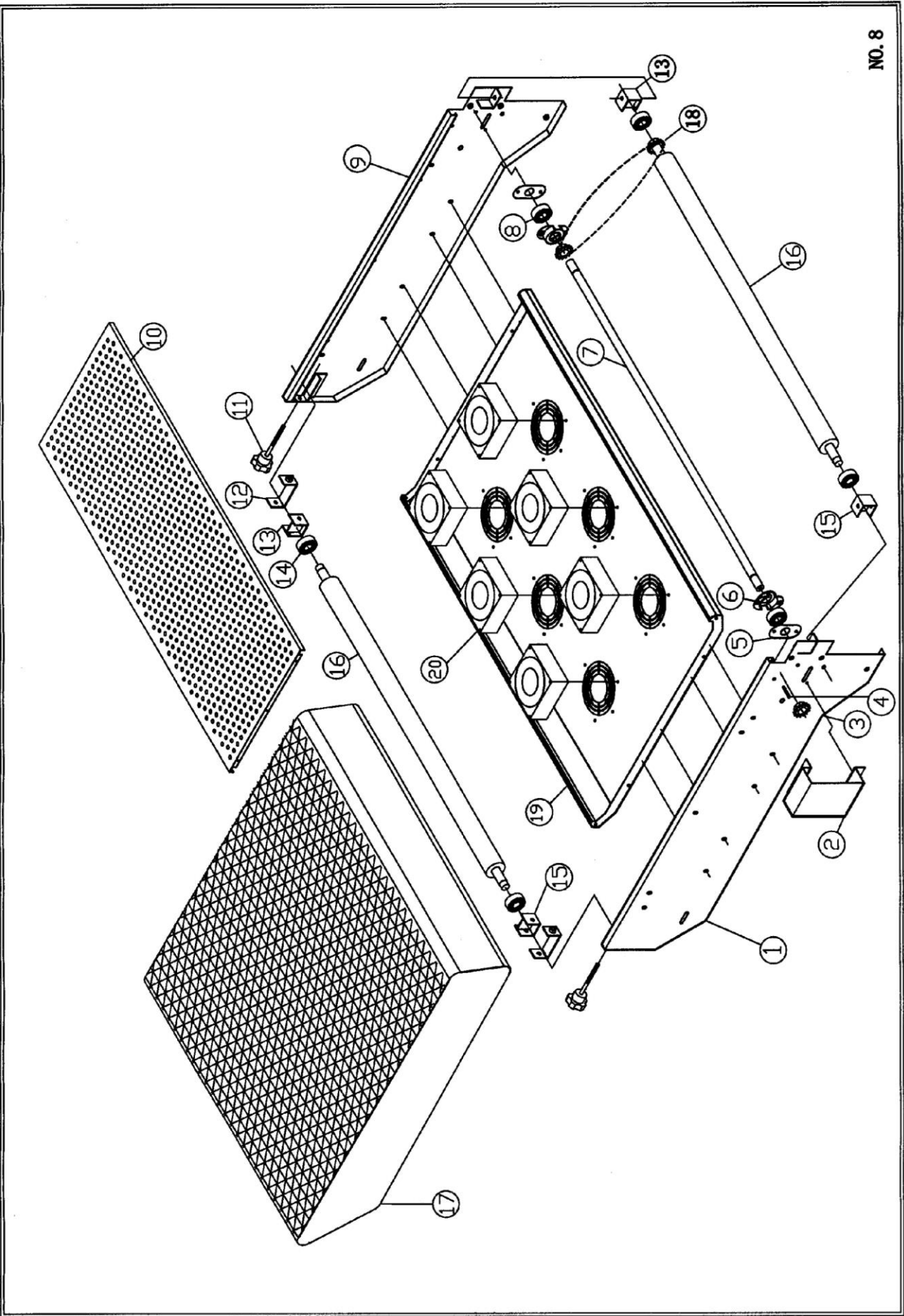
序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	JP2001	上皮带 910*2450	Upper belt	1	OP-900/A 用
	JP2001	下皮带 910*2450	Lower belt	1	OP-900/A 用
	JP2002	上皮带 1010*2450	Upper belt	1	OP-1000/A 用
	JP2002	下皮带 1010*2450	Lower belt	1	OP-1000/A 用
2	90LDB108	滚筒	Roller	9	加长型用 10
	100LDB012	滚筒	Roller	9	
3	90LDB103	主体轴芯	Bearing of main body	10	
	100LDB006	主体轴芯	Bearing of main body	10	
4	JB2071	轴承 6204C4	Bearing	14	
5	90LDA061	修正座	Redress base	8	
6	JC1016	轴用弹性挡圈 $\phi 18$	Shaft spring washer	2	
7	JM2005	螺母	Nut	4	
8	JH1022	弹簧 $\phi 1.4 * \phi 11 * 53 * 14$	Spring	4	
9	JF1013	平垫 6	Flat coaster	4	
10	JD1228	螺钉 M6	Screw	4	
11	90LDB107	张力滚轮轴芯 the	Tension roller of bearin	2	
	100LDB010	张力滚轮轴芯	The tension roller of bearin	2	
12	90LDA053	张力位置导座	The tension position base	4	
13	JF1011	平垫 8	Flat coaster	16	
14	JF2006	弹垫 8	Spring coaster	16	
15	JD1314	紧定螺钉 M6	Fixed screw	16	
16	JD1228	紧定螺钉 M8	Fixed screw	4	
17	JH2050	弹簧 $\phi 2.3 * \phi 20 * 90.5 * 40$ 圈	Tension spring	4	900L/1000L 用 6
18	90LDA041	盖片	Cover piece	3	
19	JF1011	平垫 5	Flat coaster	4	
20	JF2006	弹垫 5	Spring coaster	4	
21	JD7111	紧定螺钉 M5	Fixed screw	4	
22	JP2038	下皮带 910X4850	Lower belt	1	OP-900L/LA 用
	JP2030	下皮带 1010X4850	Lower belt	1	OP-1000L/LA 用



机械零件目录

NO.7

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	900B107	镙钉	Nut	4	
2	90LDA250	左刮片座组	Left doctorblade	1	
3	90LDB301	刮片横轴	Doctor blade abscissa axis	1	
4	900B106	端塞	End play	2	
5	90LDA251	右刮片座组	Right doctor blade seat suit	1	
6	90LDA252	刮片座	Doctor blade seat	2	
7	ZA3220	刮片	Doctor blade	2	
8	90LDA314	清洁布杆	Fabric-cleaning pole	2	
9	JH2050	拉伸弹簧	Pulling spring	4	
10	ZW0042	黑色圆球手柄	Black ball shape crank.	2	

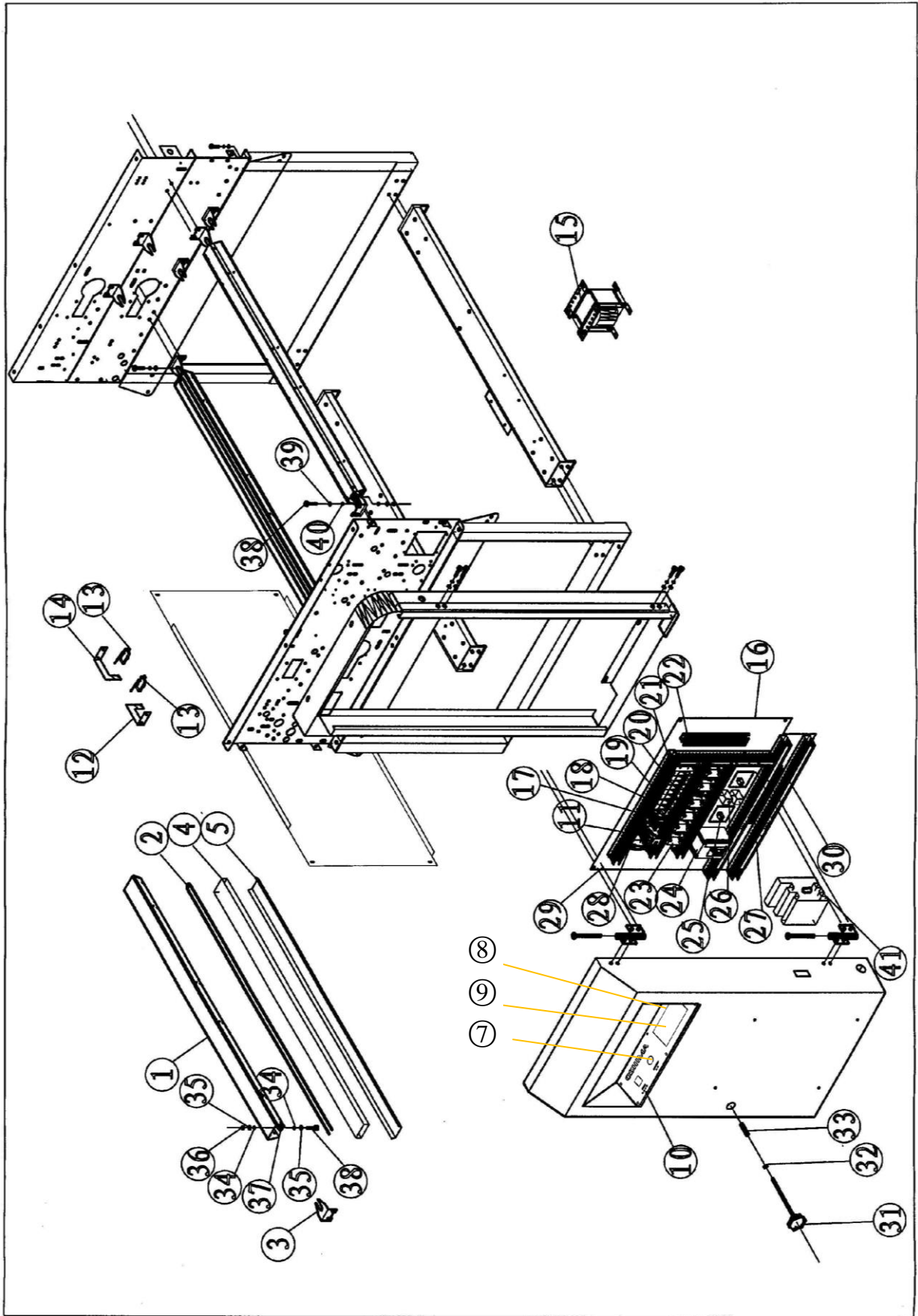


NO. 8

机械零件目录

NO. 8

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	900A014	后右侧板	The bask right side board	1	
2	90LDA039	齿轮盖	The cover of rowel	1	
3	90LDB125	输送带齿轮 M2.5*20T	The rowel of conveyor	1	
4	JJ0003	平键 5*35	Flat key	1	
5	90LDA037	轴承盖板	The cover of bearing	2	
6	90LDB134	轴承座	Bearing base	6	
7	900B005	输送带滚轮轴	The wheel of conveyor	1	900 系列
	1000NB002	输送带滚轮轴	The wheel of conveyor	1	1000 系列
8	JB2071	轴承 6204	Front wheel of conveyor	2	
9	900A013	后左侧板	Back left side board	1	
10	900A201	冷却罩板	Cooling cover	1	900 系列
	1000NA004	冷却罩板	Cooling cover	1	1000 系列
11	ZW0058	手柄 M10	Handle	2	
12	1600A135	调整座	Whole base	2	
13	1600A134	培林座 (右)	Bearing base (right)	2	
14	JB2018	培林 6202	Bearing	4	
15	1600A133	培林座 (左)	Bearing base (left)	2	
16	900B002	输送带前滚筒	Front roller of conveyor	2	900 系列
	100LEB003	输送带前滚筒	Front roller of conveyor	2	1000 系列
17	JP2007	网带 900*2190	Mesh belt	1	900 系列
	JP2203	网带 1000*2190	Mesh belt	1	1000 系列
18	1600B148	输送带链轮	The sprocket wheel of conveyor	2	
19	900A201	冷却箱体	Cooling box	1	900 系列
	1000NA003	冷却箱体	Cooling box	1	1000 系列
20	DM0207	风扇 130*130*50	Fan	6	



机械零件目录

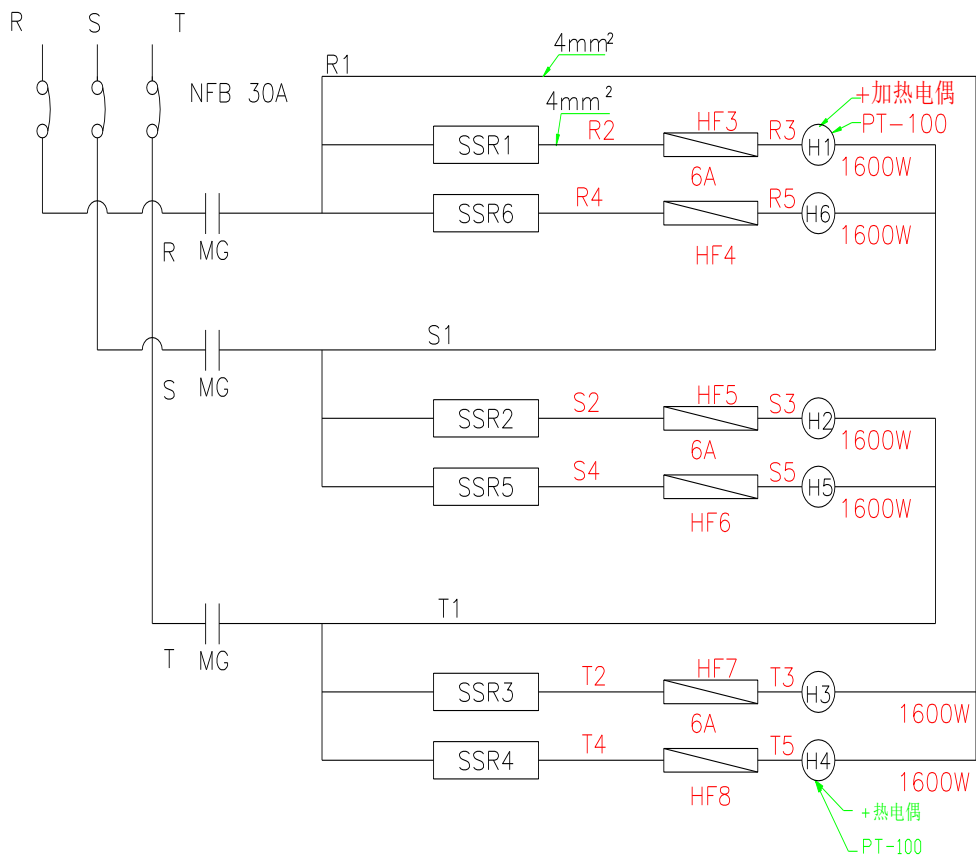
NO.9

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	90LD113	电热座	heating base	6	OP-900/L/LA 用
	100LDB014	电热座	heating base	6	OP-1000/L/LA 用
2	900B003	发热管	heater	12	OP-900/L/LA 用
	100LDB031	发热管	heater	12	OP-1000/L/LA 用
3	90LDA034	电热片座	heating piece base	12	
4	ZA3113	保温棉	foam	4	
5	90LDB114	电热器护盖	cover of heater	6	OP-900/L/LA 用
	100LDB015	电热器护盖	cover of heater	6	OP-1000/L/LA 用
7	QF0105	调压阀	adjusting pressure valve	1	
8	AD0163	电源开关	Power	1	
9	DH0440	一体机	OPERATION PANEL	1	
10	QF0132	压力表 1/8" φ 42	manometer	1	
11	DJ0125	接触器 LCID3210M7-220V	connector	1	
12	90LDA029	停止开关(左)	stop switch(left)	2	
13	DK0101	修正开关 AH715346-10	micro switch	1	
14	90LD030	停止开关(右)	stop switch(right)	1	
15	DB0204	变压器 380/220V/110.10V 500VA	transformer	1	
16	DF1214	线槽 310×25×50	wire tank	1	
17	DJ0120	接触器 LCID1810-220V	connector	1	
18	DF0306	RT14-20 6A 保险管	fuse	2	
19	DF0201	RT14-20 保险管座	heating base	8	
20	DF0308	RT14-20 16A 保险管	fuse	6	
21	DF1214	线槽 350×25×50	wire tank	1	
22	DF0107	端子排 20P15A	terminal row	1	
23	DJ0217-1	固态继电器SSR ZS480V	solid relay	6	
24	DZ0305	变频器	transformer	1	
25	DJ0205-1	中间继电器		2	
26	DM0403	电容器 6uf	capacity	2	
27	DF0107	端子排 20P15A	terminal row	1	
28	DH0441	开关电源 LRS-35-24(明伟)	Powermodule	1	

机械零件目录

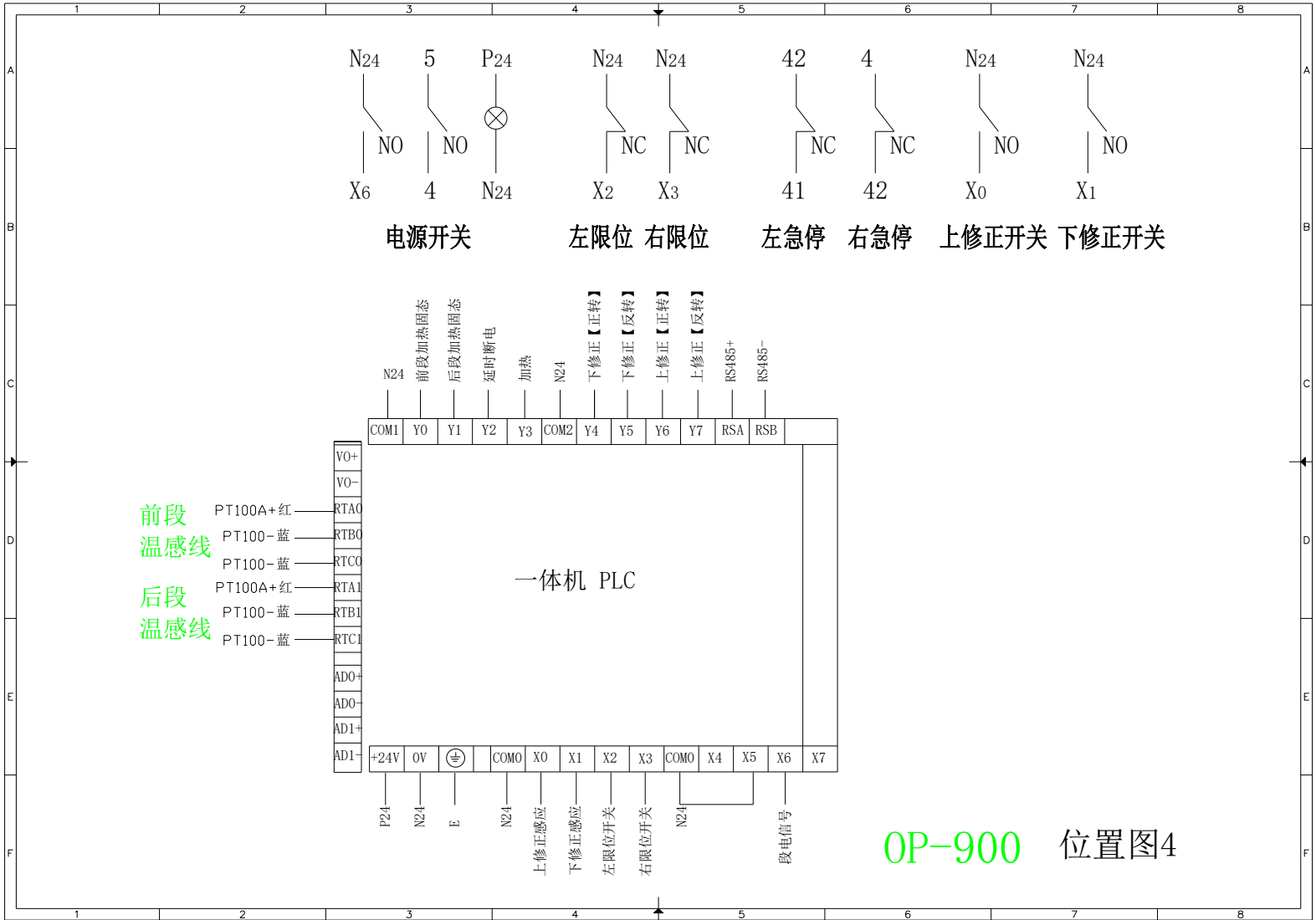
NO.9-1

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
29	90LDA057	配电板二	switch board(二)	1	
30	DF1214	线槽 440×25×50	wire tank	1	
31	ZW0055	梅花手柄 M10	handle	1	
32	JM1005	外六角螺母 M8	outside hexagon screw	1	
33	JD1226	外六角螺丝 M8	outside hexagon screw	5	
34	JF1012	平垫 8	flat coaster	5	
35	JF2007	弹垫 8	spring coaster	5	
36	JM1005	外六角螺母 M8	outside hexagon screw	1	
37	JD1226	外六角螺丝 M6	outside hexagon screw	2	
38	JF1009	平垫 6	flat coaster	2	
39	JF2006	弹垫 6	spring coaster	2	
40	JD1226	外六角螺丝 M6	outside hexagon screw	2	
41	DK0504	无熔丝开关	un-fuse switch	1	

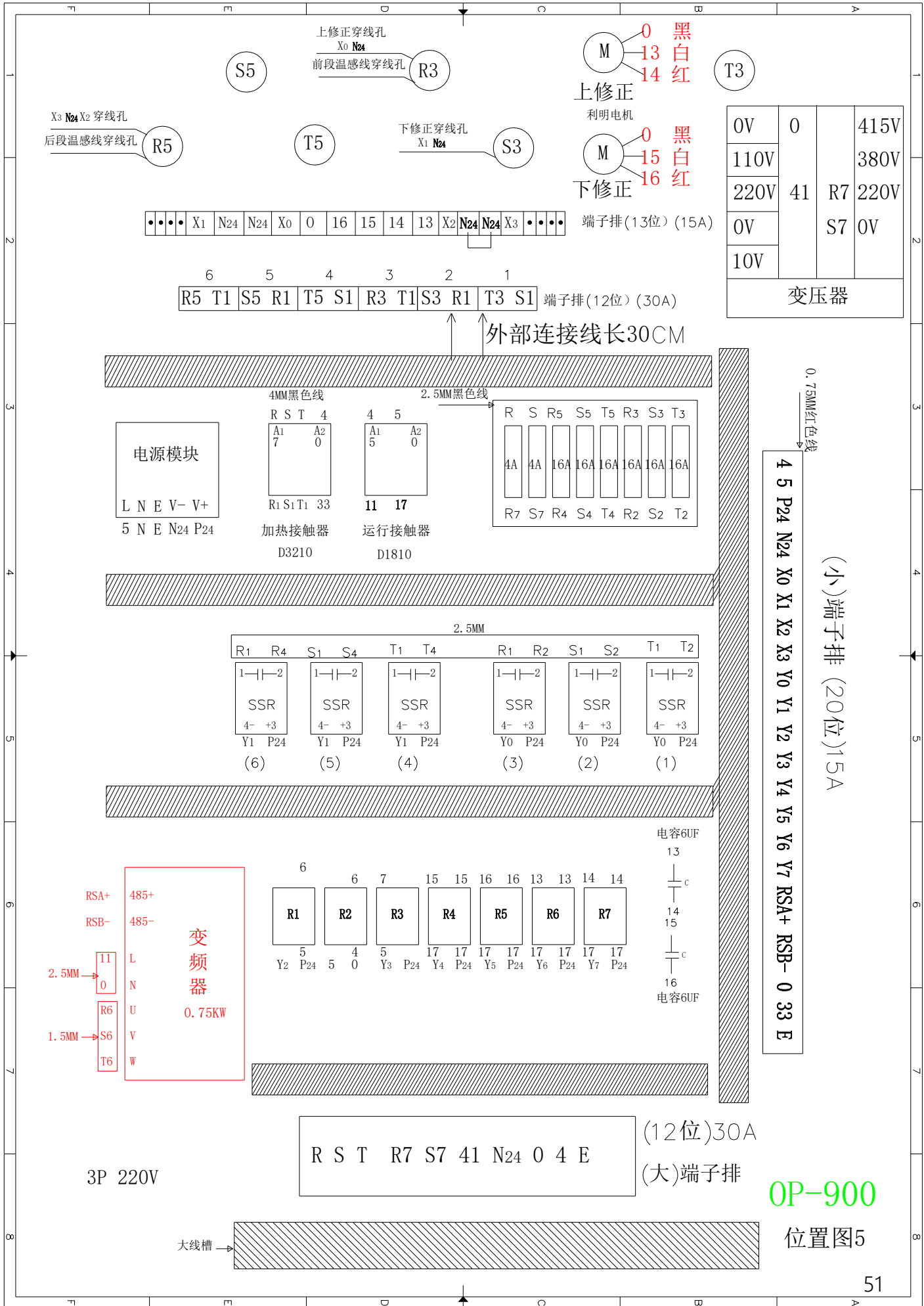


OP-900

主电路图3p 220V



OP-900 位置图4



0V	0		415V
110V			380V
220V	41	R7	220V
0V		S7	0V
10V			

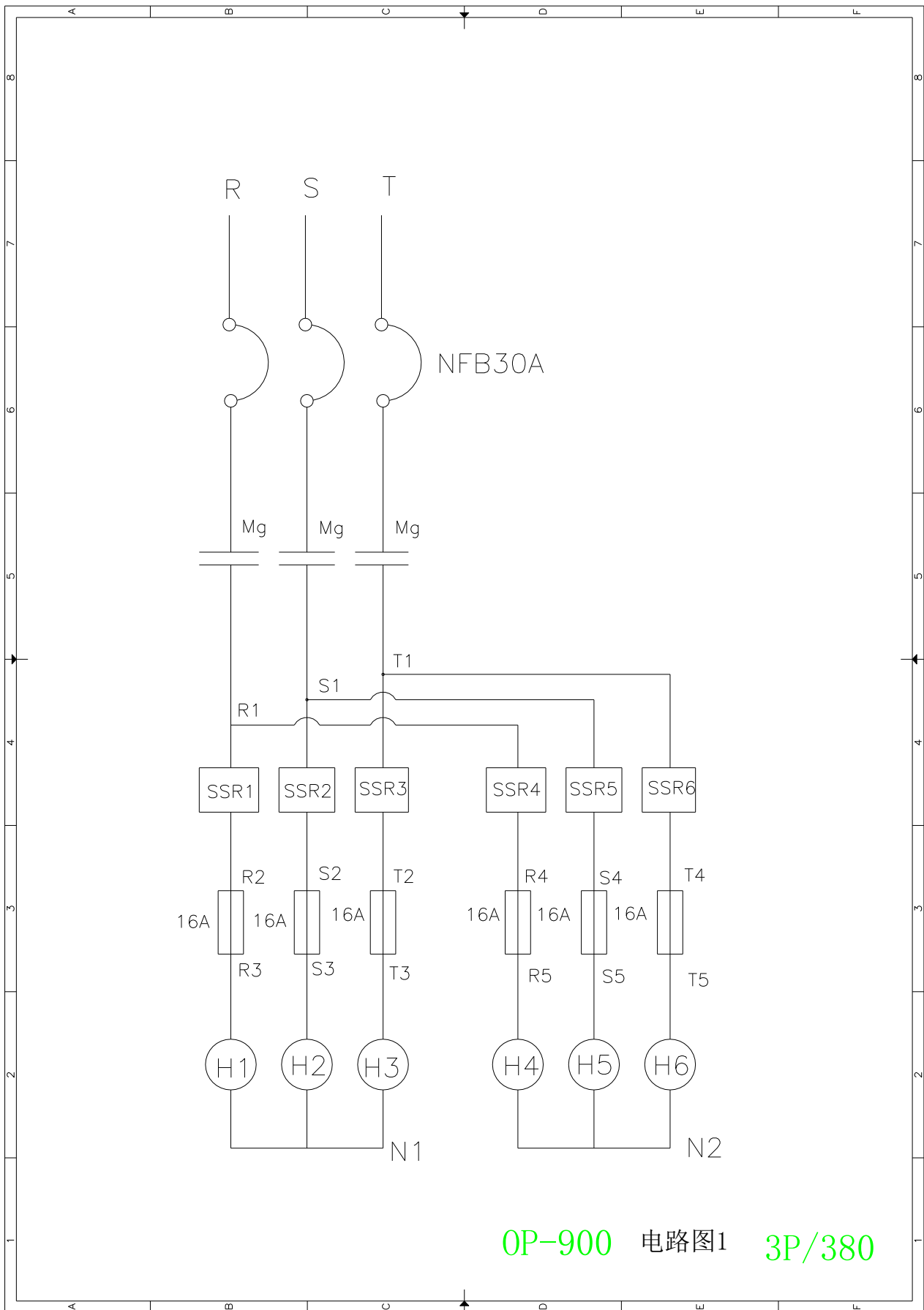
变压器

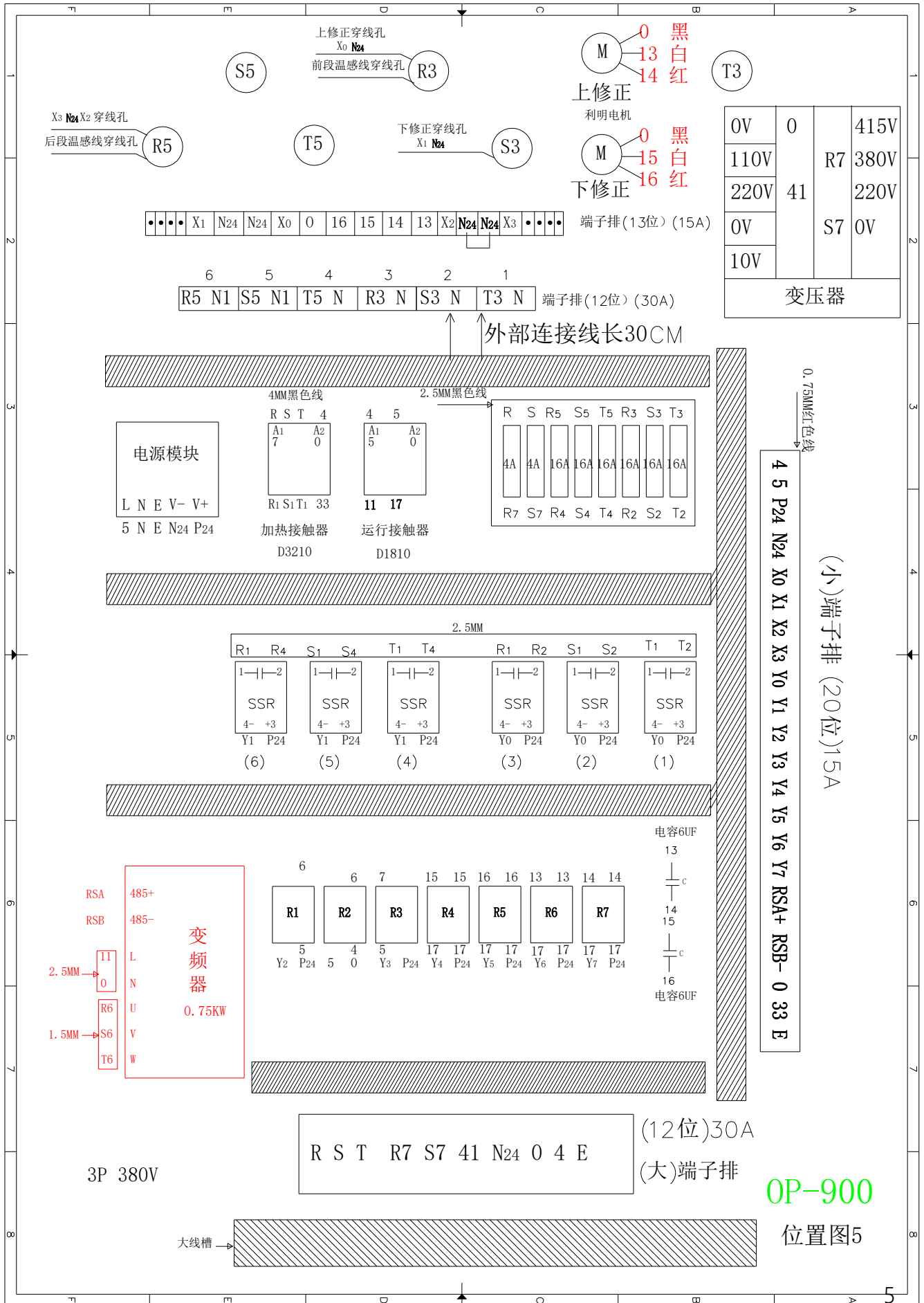
(小)端子排 (20位)15A

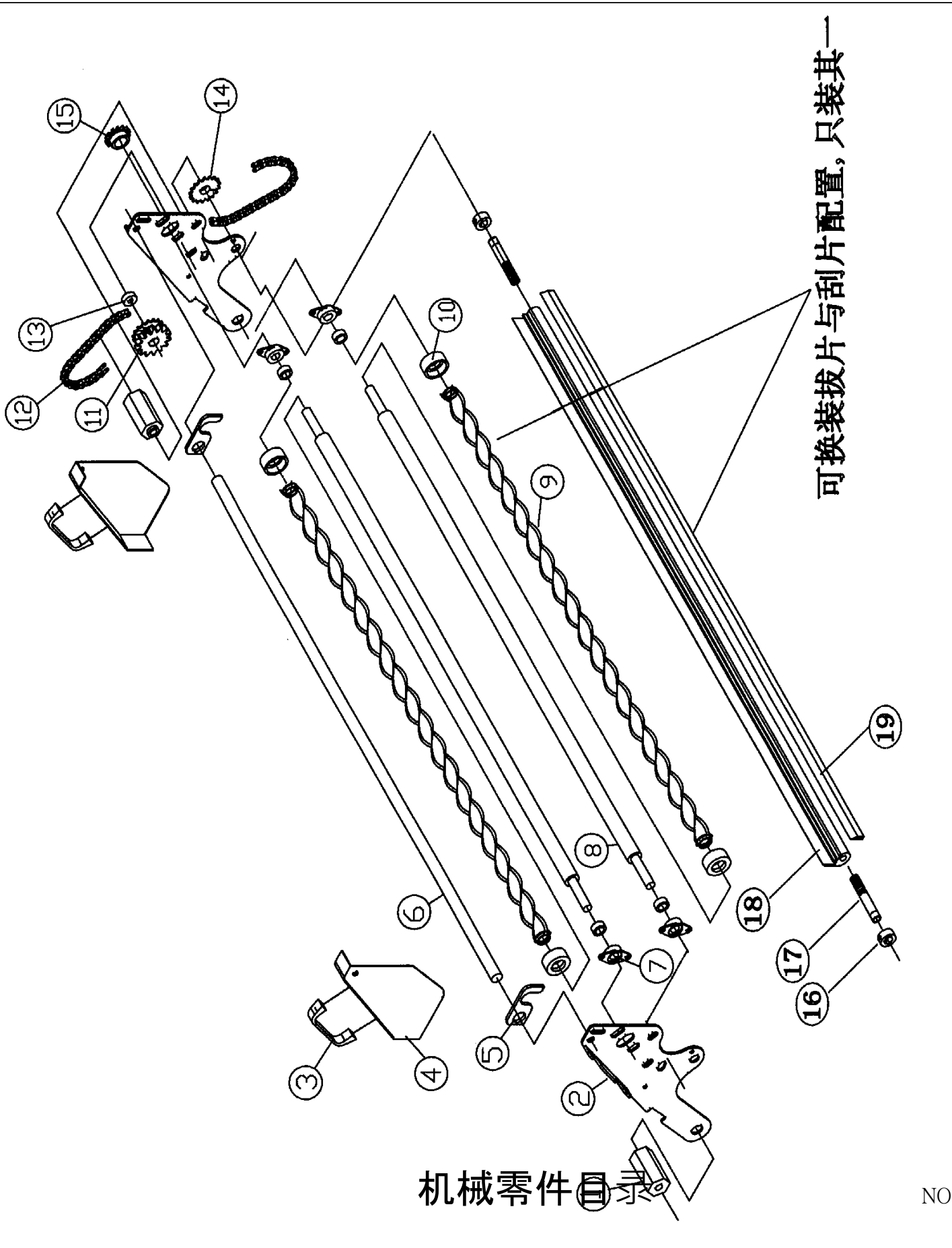
4 5 P24 N24 X0 X1 X2 X3 Y0 Y1 Y2 Y3 Y4 Y5 Y6 Y7 RSA+ RSB- 0 33 E

OP-900

位置图5







NO.7

序号	部件编号	部件名称规格		数量	备注
Ref No	Part no.	Description & spec.		Q'ty	Remark
1	900B105	端塞	Tap	2	
2	900A302	拨片座	Scraper base	各一	
3	ZW0060	A-303 把手 100×25×14	Handle	2	
4	900A303	拨片座护罩	Scraper base cover	各一	
5	900A301	固定片	Fixed plate	2	
6	900B102	连杆	Rod	1	OP-900/L/LA 用
	1000NB001	连杆	Rod	1	OP-1000/L/LA 用
7	JB1023	培林 FL001	Bearing	4	
8	90LDB353	拨片杆芯轴	The axis of Scraper rod	2	OP-900/L/LA 用
	100LDB019	拨片杆芯轴	The axis of scraper rod	2	OP-1000/L/LA 用
9	900SPB059-1	拨离片	Plate	2	OP-900/L/LA 用
	100LEB010-1	拨离片	Plate	2	OP-1000/L/LA 用
10	100LEB012	拨片器止环	Stop ring of scraper	4	
11	900SPB054	惰轮	Idler	1	
12	JL1005	2分链条	Chain	1	
13	JB2015	培林 607	Bearing	2	
14	900SPB055	拨片链轮	Chain wheel for scraper	1	
15	900B104	拨片齿轮	Rowel for scraper	1	
16	900SPB103	下刮片座止环	Stop ring of lower scraper base	2	
17	900SPB102	下刮片座支柱	Hold of lower scraper base	2	
18	900SPB101	下刮片座	Lower scraper base	1	
19	ZA3220	刮片 920MMX32MMX3MM	Scraper	1	OP-900/L/LA 用
	ZA3219	黑色刮片	Black scraper	1	OP-1000/L/LA 用

易驱变频器参数一览表

参数编号	名称	出厂值	设定值
P0.01	频率给定通道 Flat frequency channel	1	3
P0.04	运行命令通道选择 Run the command channel selection	0	2
P0.06	上限频率 Maximum frequency	50HZ	50HZ
P5.07	最大输入设定频率	50HZ	50HZ
P0.14	加速时间 Acceleration time	0.1S	3S
P0.15	减速时间 Deceleration time	0.1S	3S
P2.42	载波频率 Carrier frequency	机型设定 Model setting	视情况而定 It depends
P3.01	恢复出厂值 Restore Factory defaults	0	1
P8.01	通讯配置	013	003