

使用前請詳細閱讀
PLEASE READ CAREFULLY
BEFORE USING

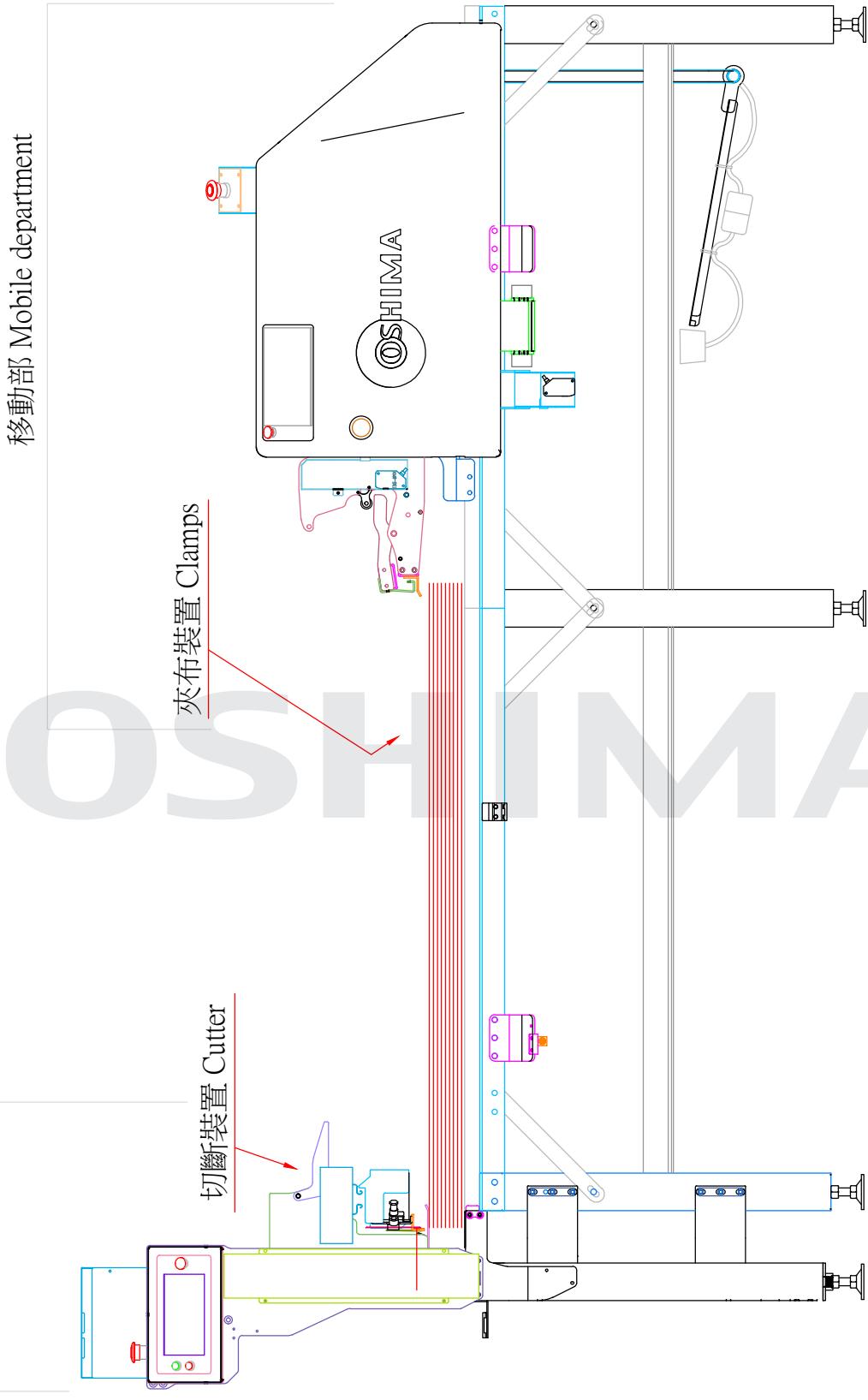
操作手冊
Operation Manual

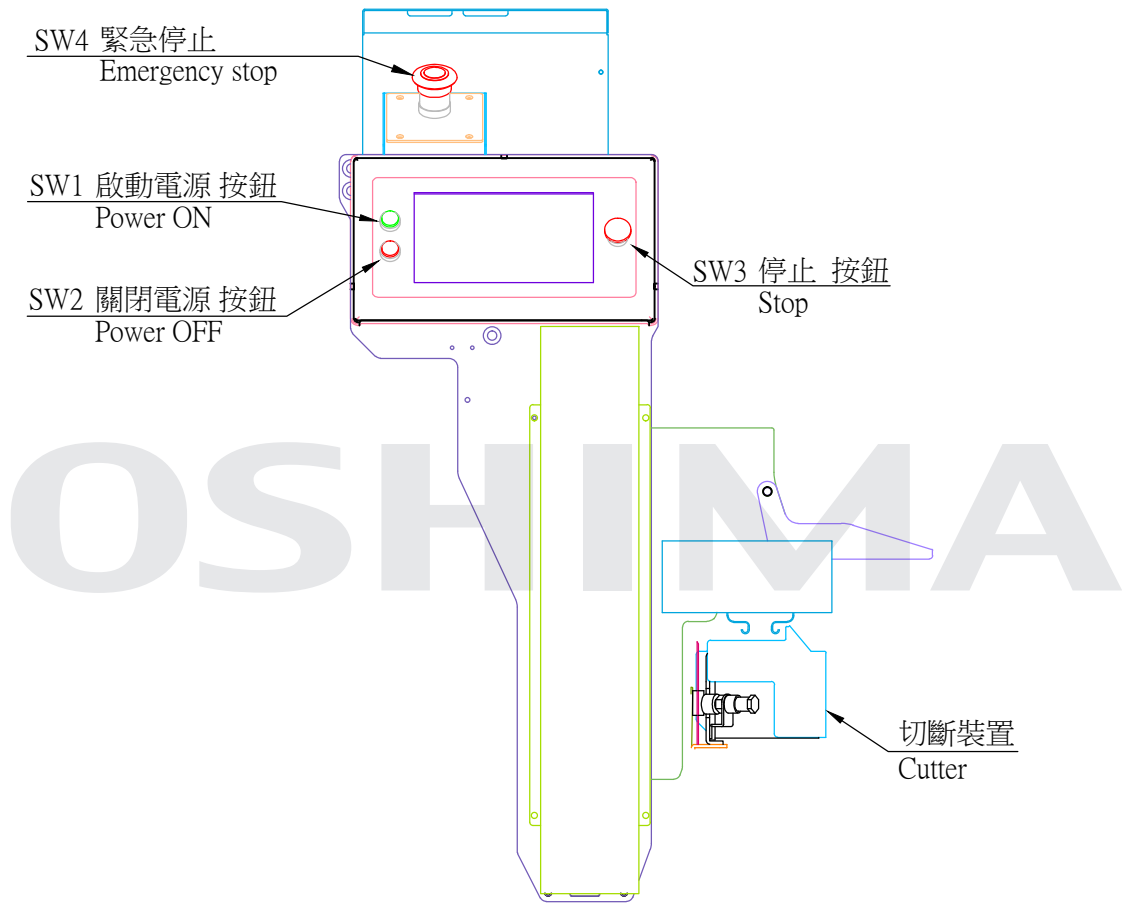
J3

自動拉布機
AUTO PULLING MACHINE

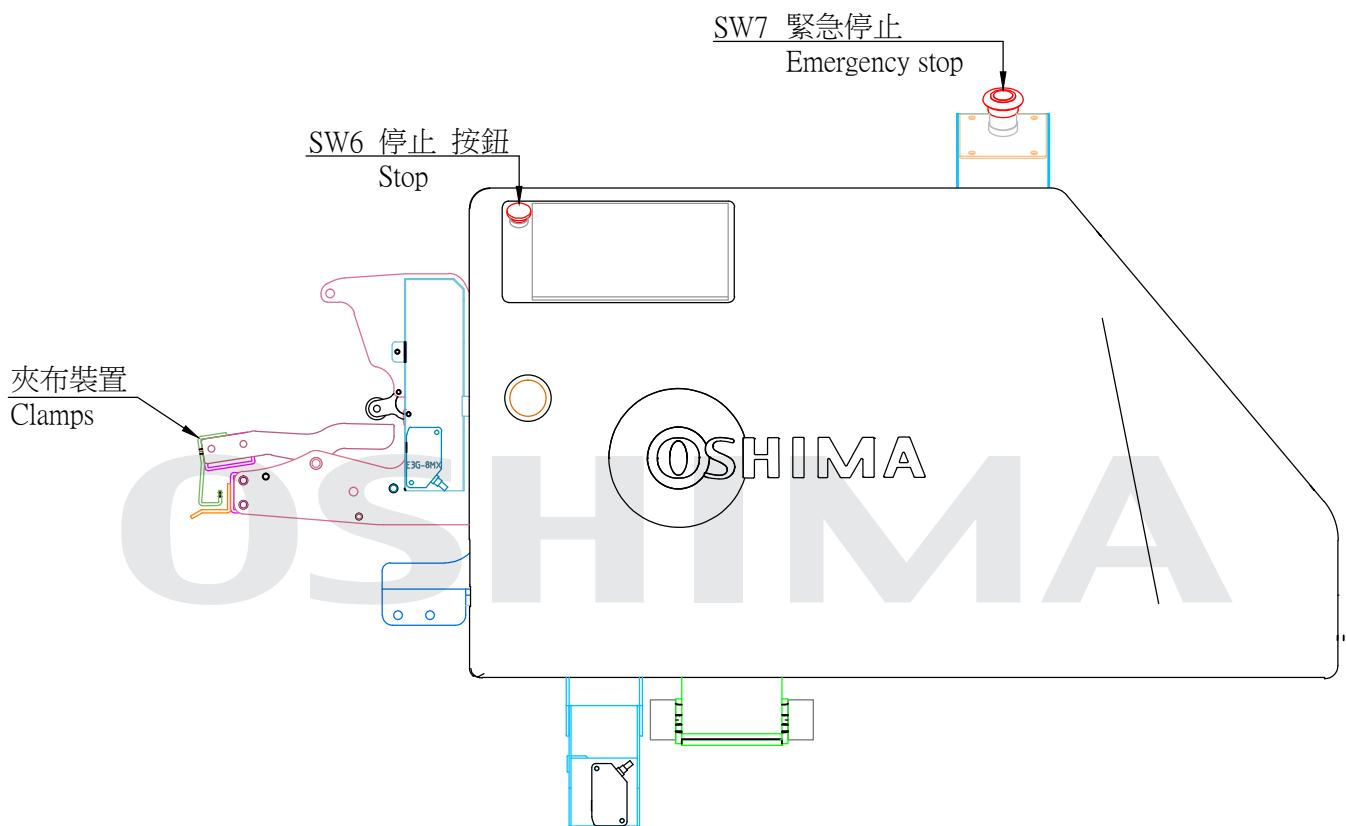
OSHIMA CO., LTD

固定部 Fixed department





SW1 啟動電源 按鈕 SW1 ON	啟動電源。 Power ON switch.
SW2 關閉電源 按鈕 OFF	斷電關機。另 機器可設定 靜止中時間到 自動斷電關機。 Power OFF switch. Besides machine will automatically switch off for 5 minutes.
SW3 停止 按鈕 STOP	停止按鈕。 另裁床操作側設有 停止鋼索,押動鋼索功能同 停止按鈕。 (停止鋼索 為最常用之 停止裝置) Stop Button. Besides, there are also press the wires to Stop Machine.
SW4 緊急停止 按鈕 Emergency Stop	緊急停止用安全開關。押下後切斷動力電源,機器滑動停止。 一經押下自動卡住,需轉動紅色扭順時針30度使其復原。 平常要停止機器時請用 SW3。 (此乃備用之 急停開關, 正常操作時切勿使用) To stop machine accidentally. To release this stop, it requires to turn the knc



SW6 停止 按鈕

停止按鈕.

另裁床操作側設有 停止鋼索,押動鋼索功能同 停止按鈕.
(停止鋼索 為最常用之 停止裝置)

STOP

Stop Button.

Besides, there are also press the wires to Stop Machine.

SW7 緊急停止 按鈕

緊急停止用安全開關. 押下後切斷動力電源,機器滑動停止.

一經押下自動卡住,需轉動紅色扭順時針30度使其復原.

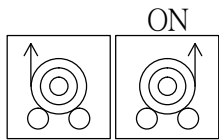
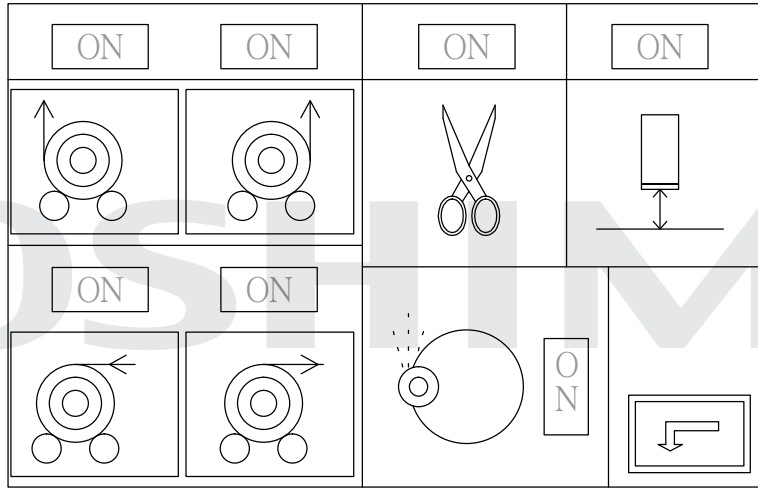
平常要停止機器時請用 SW3.

(此乃備用之 急停開關, 正常操作時切勿使用)

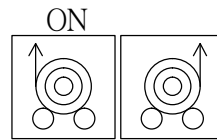
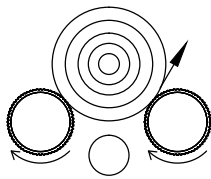
Emergency Stop

To stop machine accidentally. To release this stop, it requires to turn the knot.

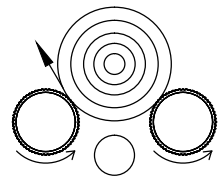
定機 Fixed unit



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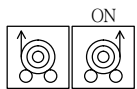
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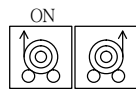
捲支布料 放置布斗內,由 或 控制 出布方向.

匹布料用不到布斗,押一下 方向鍵 → 把 ON 消去,使布斗不運轉.

Please place the Roll Fabric on the bucket and Press the bucket moving direction



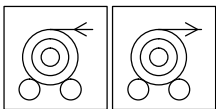
or



to control the feeding direction.

Folded Fabric is not need to use the BUCKET function. Please push button till "ON" icon disappear.

回收 寸動
Collect Feed



布斗滾輪 "手動" 鍵
BUCKET ROLLER MANUAL BUTTON

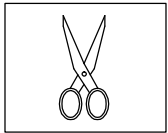
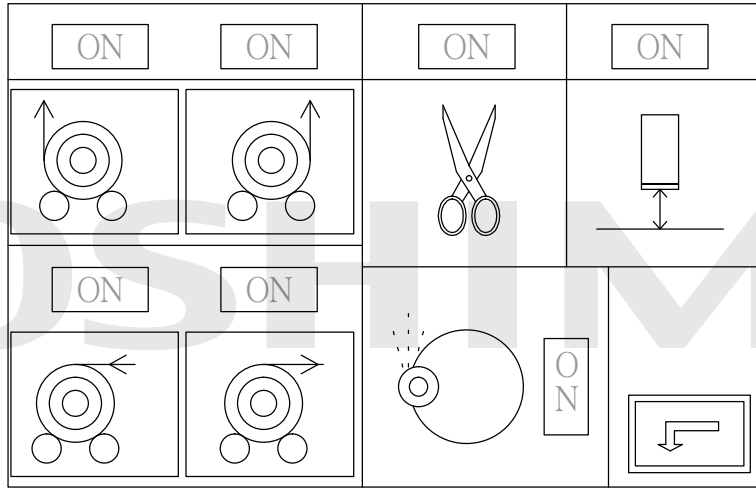
押住 時,布料低速捲回.

押住 時,布料低速捲出.

Press , Fabirc will be collect.

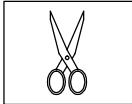
Press , Fabric will feed out.

定機 Fixed unit




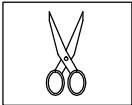
裁斷按鈕
Cutter Button

於機器停止時, 按一下  可進行一次裁斷動作。

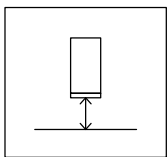
裁刀頭 如因 緊急停止 未停於 定位 時, 按一下  可讓裁刀頭回到 定位。

按此 裁斷按鈕 作手動裁斷時 層數值 不變。

When machine stops, and press  the machine will automatically cuts one time.

And sometimes cutter is not in position of some accident, or emergency stop, to press  will return the cutter back to position.

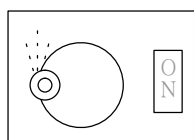
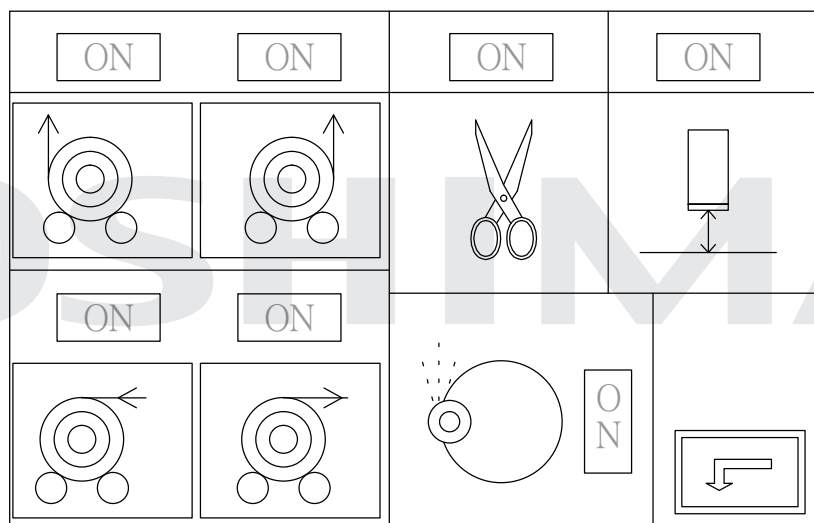
This manual Cutting will not increase the layer numbers.



壓條按鈕
Presser button


於機器停止時, 按一下  操作壓條輪替上升與下降。

In machine stopped, press  presser button to operating lift and fall.




手動研磨 鍵
Manual grinding

押一下  (刀片轉動)

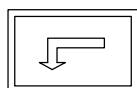
再押一下  圓刀片向磨石移動磨刀一次
(如果磨石面有了積塵,卸下磨石平貼於砂紙上可磨掉積塵).

Touch  (Blade rotation)

Touch again  The round blade moves to the grindstone to sharpen the knife once
(If there is dust on the surface of the grindstone, the dust can be removed by removing the grindstone and sticking it on the sandpaper).

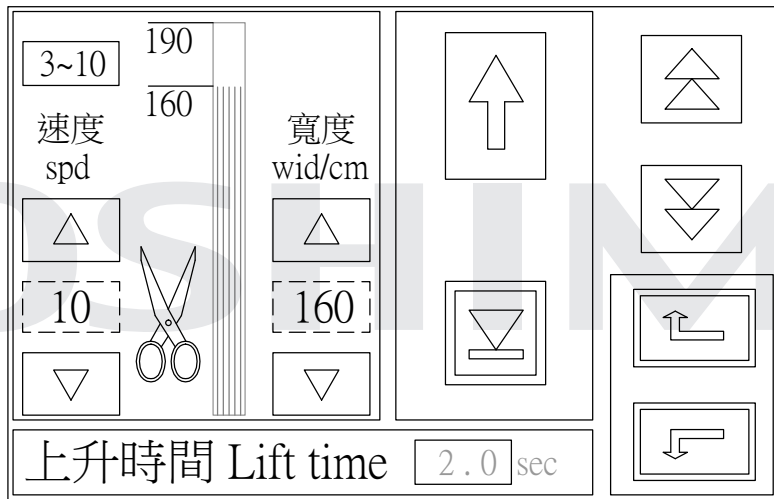
磨刀時圓刀片與磨石只需輕觸，磨石會跟著轉動為正常狀態。

When sharpening, the round blade and the grindstone only need to touch lightly, and the grindstone will rotate accordingly.

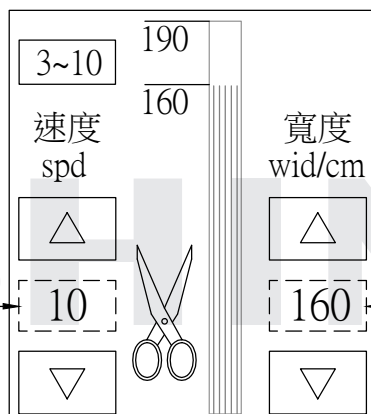


觸控頁面切換，下一頁
Next Page

定機 Fixed unit



依布料材質設定適當的裁斷速度
Set the appropriate cutting speed
according to the material of the fabric.



依布料寬度設定適當的裁斷寬度
Set the appropriate cutting length
according to the width of the fabric.

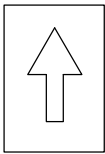
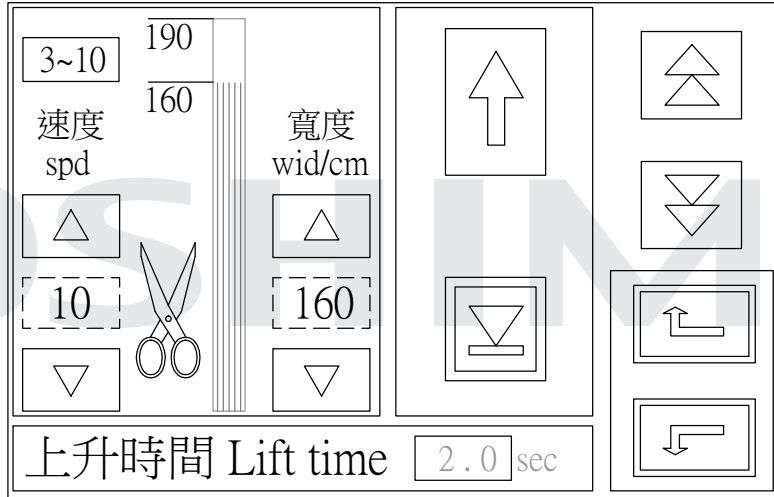
上升時間 Lift time 2.0 sec

設定適當的上升時間
Set the appropriate lift time.

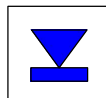
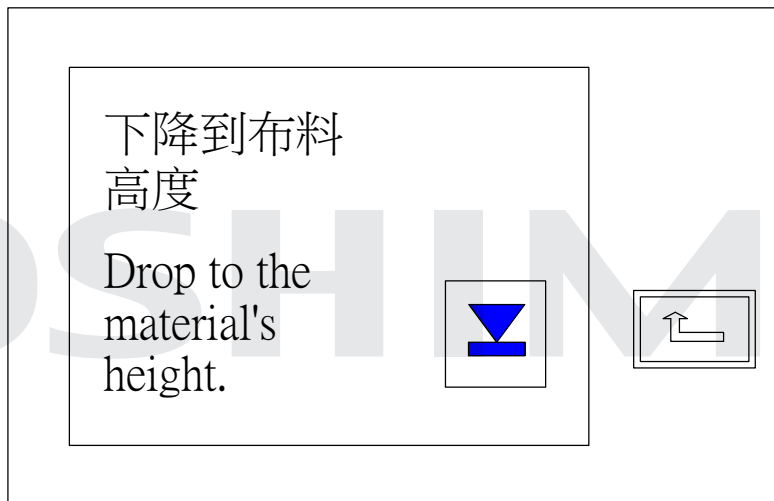
每次裁斷後 裁斷裝置 隨即上升，須有足夠高度才能讓布端掉下。
上升時間到達，隨即下降至夾布高度。

After each cut, the cutting device will rise and must be of sufficient height to allow the fabric to fall.
The lift time arrives and then it drops back to the height of the cloth.

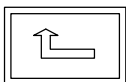
定機 Fixed unit



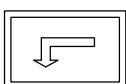
按一下裁斷裝置以上升時間上升至高點停住。同時觸控頁面變換如下：
When pressed, the cutting device will rise to a high point and stop at the set rise time.
Meanwhile the page changes as follows :



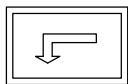
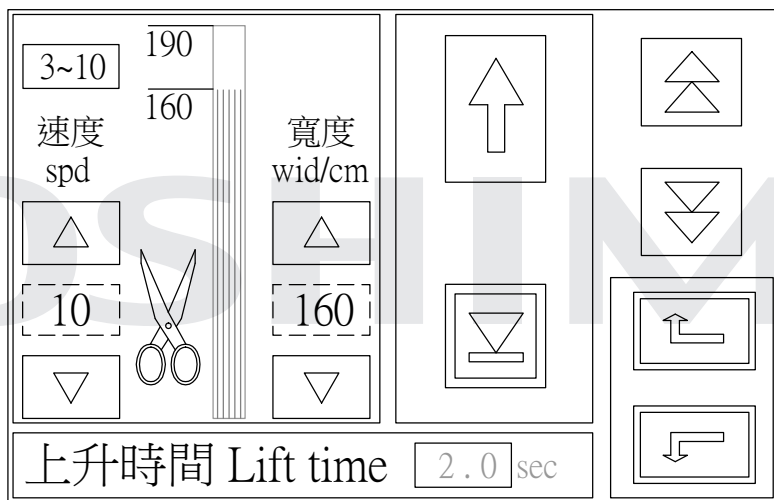
按一下下降至布料高度。
Press the button to drop to the height of the material.




觸控頁面切換，上一頁
Previous Page



觸控頁面切換，下一頁
Next page

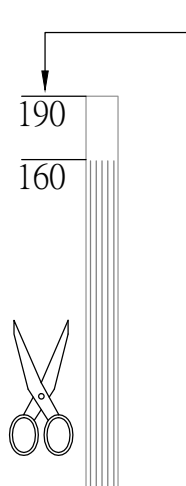


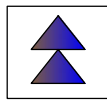
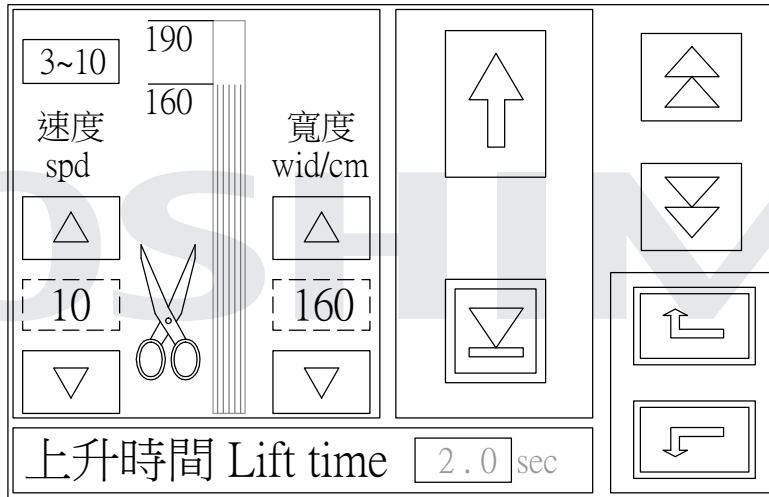
	CUTTER Slow-start (0 spd no Slow-start)	[2] spd
	切刀低速啟動 (0 spd 無低速啟動)	[1.2] s

切刀先以 [2] spd 速度行進 [1.2] s 再轉高速。
 The cutter first travels [1.2] s by [2] spd , then turns to high speed.

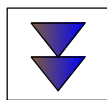
顯示機器拉布(裁切)寬度。

長按160處 直到條棒顯示變為160，裁切最長160cm。
 長按190處 直到條棒顯示變為190，裁切最長190cm。

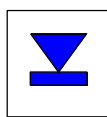




升降按鈕
LIFT BUTTON



*在機器未靠合時請勿隨意操作此按鍵改變高度
*When the machine is not together, please don't
operate this button to change the height at will.

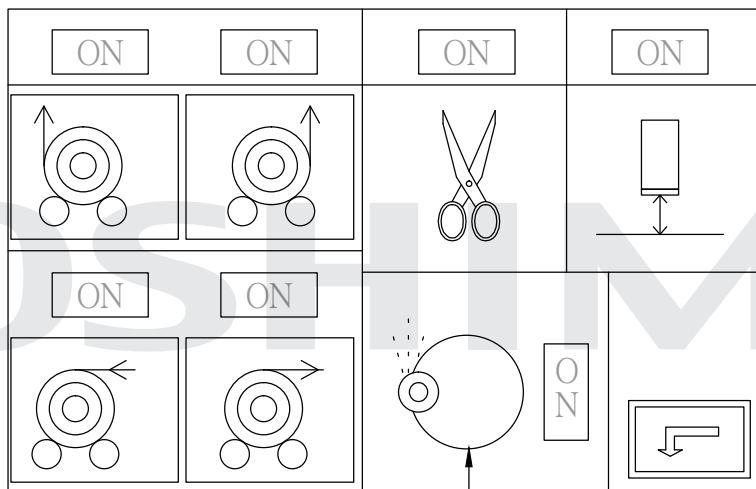
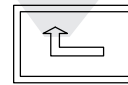


下降到布料高度
Drop to the material's height.

Automatically sharpen the knife
after the set number of cuts is reached.

設定裁切次數到達後自動磨刀一次。

###



每按住3秒 切換降收功能。

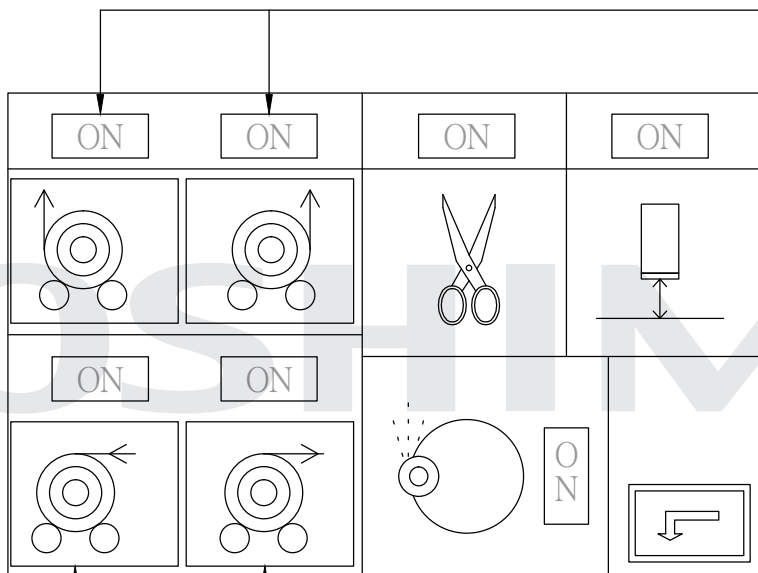
Each time you press and hold for 3 seconds
to switch the rewind function when lowering after cutting.

動機離開後下降時間之調整：

Adjustment of fall time after moving unit leaves:

When both lights show "blank",
perform the following operations.

2個燈號都顯示 "空白" 時進行下方操作

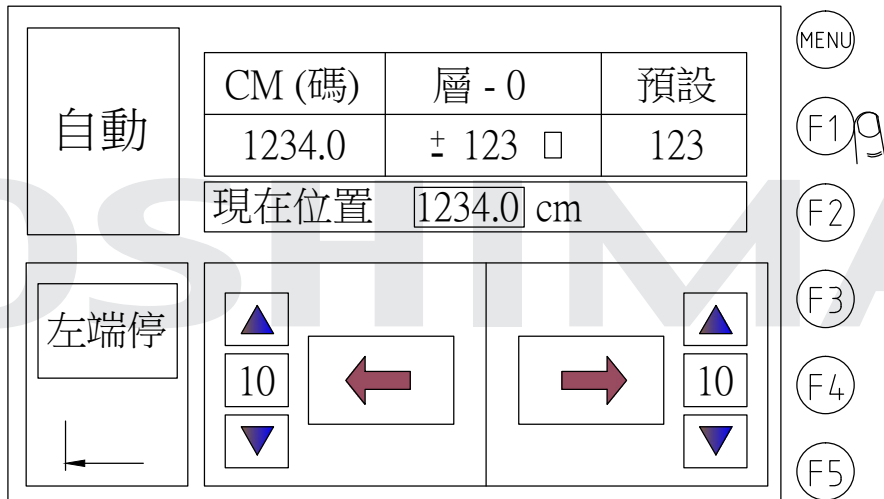


每按住3秒 下降時間增加 0.3 秒.

Each time you press and hold for 3 seconds,
the fall time increases by 0.3 seconds.

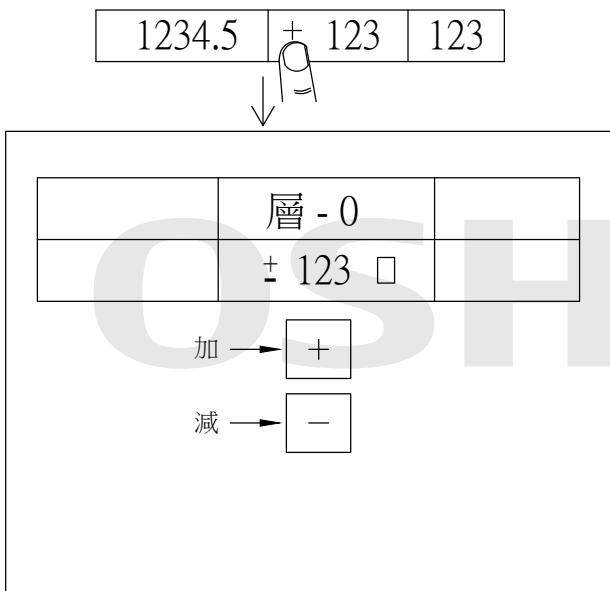
每按住3秒 下降時間減少 0.3 秒.

Each time you press and hold for 3 seconds,
the fall time decreases by 0.3 seconds.

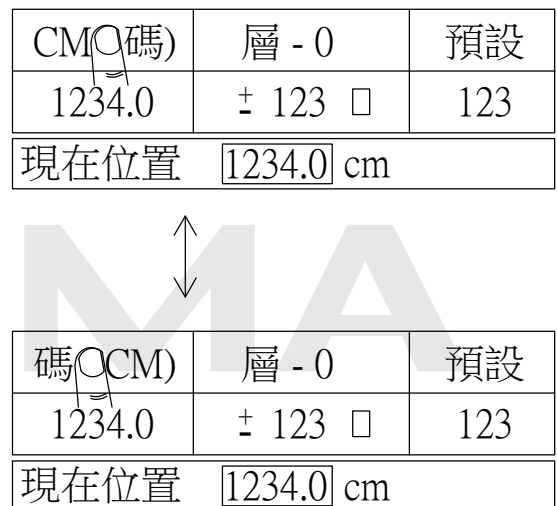


調整已拉 "層數顯示值" :

如有 "顯示值" 與 "實際層數" 不符時，可調整之。

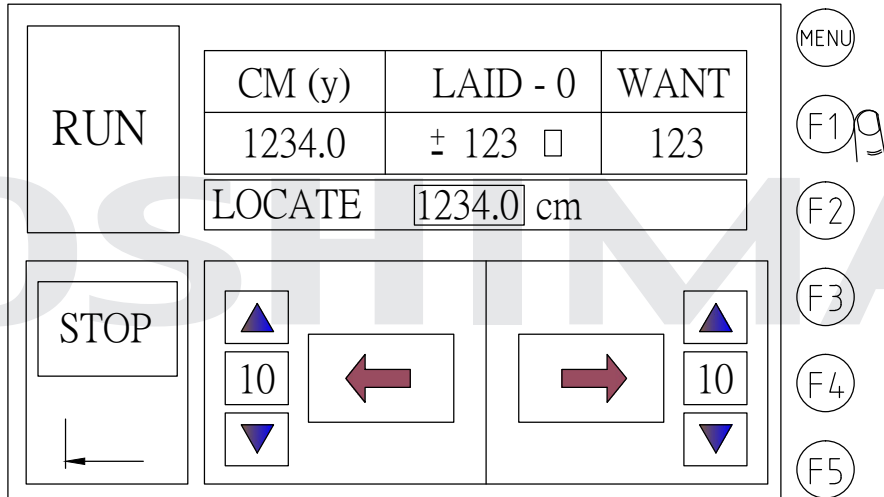


長度單位 可選擇 "碼" 或 "CM"



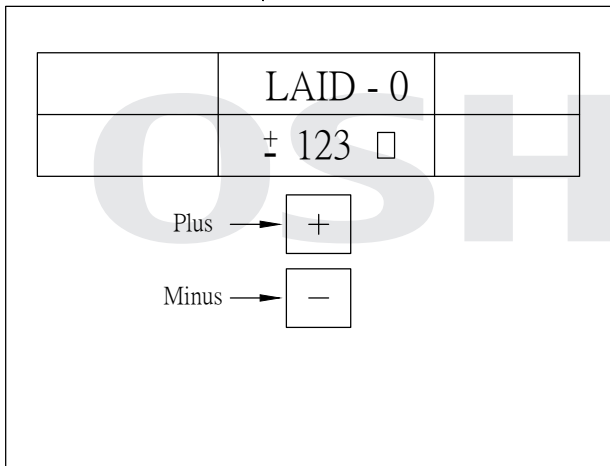
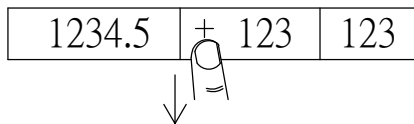
現在位置 [1234.0] cm

顯示機器的 "現在位置"

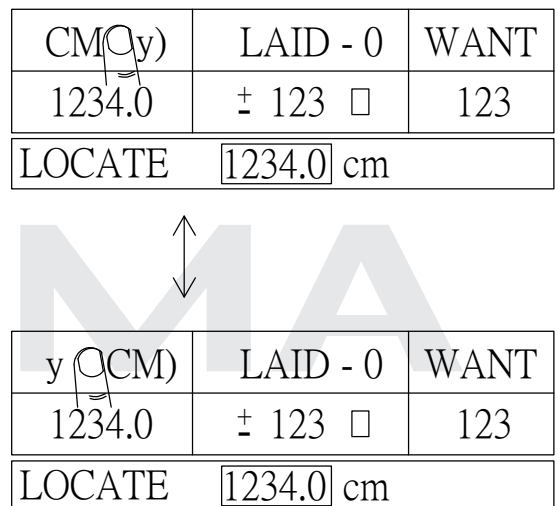


The number of "laid fabric" :

If the shown value is not the actual value of the layers.
You may adjust to synchronize the digits.

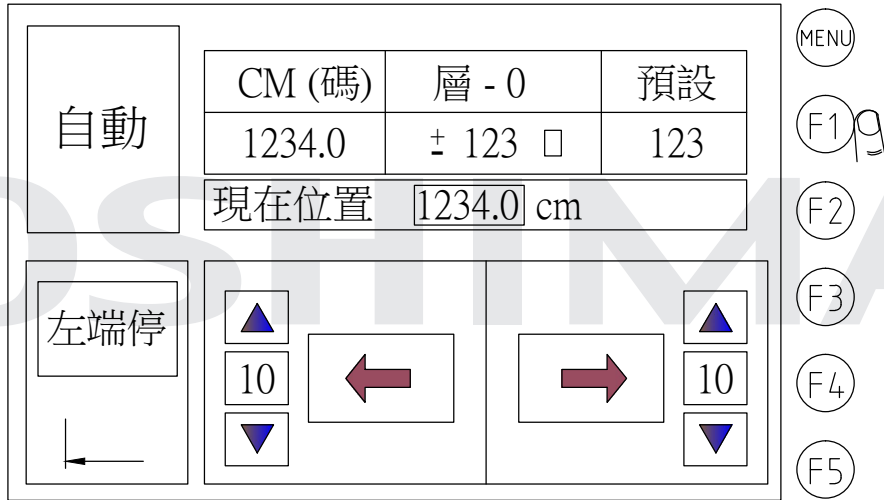


You may choose "yard" or "centimeter" for the spreading length unit.

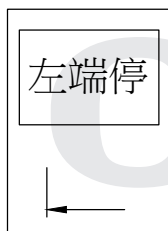


LOCATE 1234.0 cm

Display the "current position" of the machine.

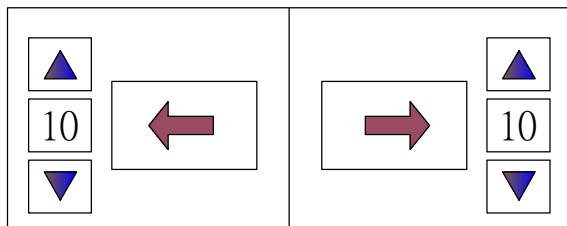




按此鍵,拉布機進入 自動拉布 狀態。
當布料準備就緒後,確認方向正確,按此鍵進行拉布作業。



"與定機靠合" 停止 鍵

本動機夾布裝置高度只能由定機帶動上升下降，
需要調整高度時，先按 "自動" 再按此 "左端停"，
在靠合後即停止不動，再從定機方操作升降。



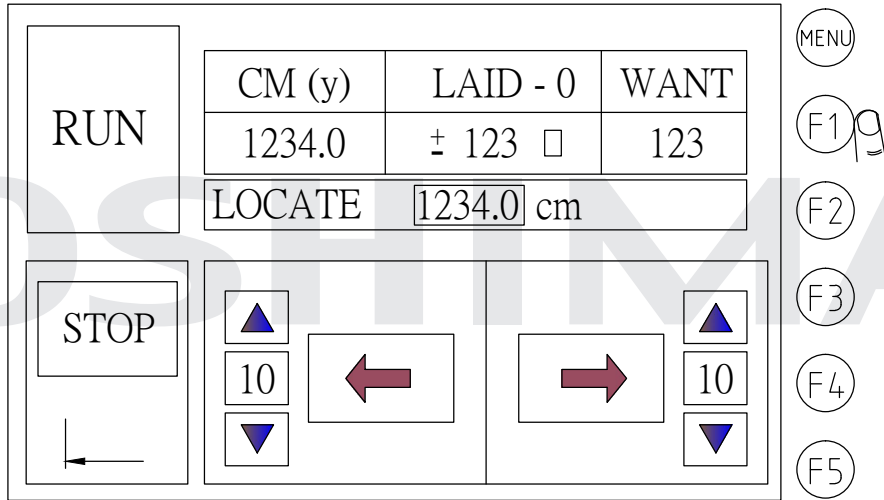
  機器行走方向顯示選擇鍵

啟動機器前 先確認方向顯示正確與否再按 "自動"。



機器行走速度設定鍵

設定機器適當的行走速度。

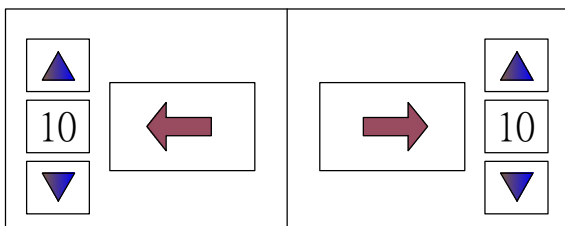


Pressing this Button, the spreader will turn into Auto spread condition, when machine is placed ready, and make sure the feeding direction.



"Reach with the fixed part" STOP Button

The height of the clamps on the moving parts can only be driven up and down by the fixed parts. When you need to adjust the height, please first press "RUN" and then "STOP". After relying on and stopping, operate the lift on the fixed parts.



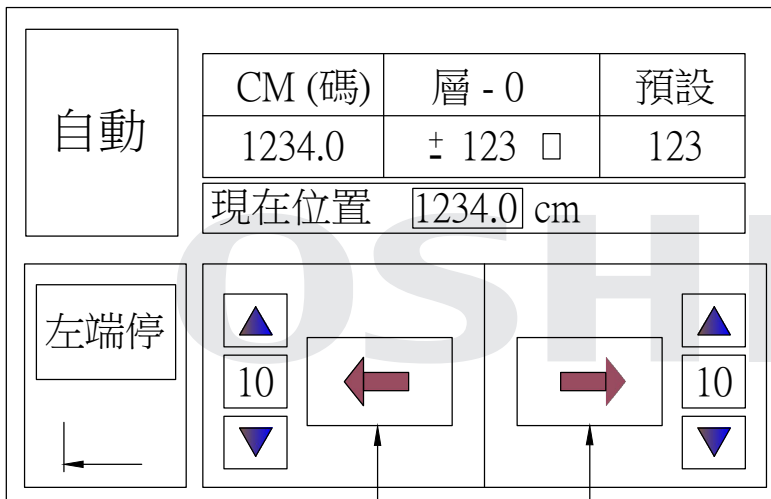
Machine motion direction button

Before starting the machine, please confirm that the direction is correct.



Machine motion speed adjustment button

Adjust the correct movement speed of the machine.



按住3秒 起動慢速速度
增加 1 hz.

(MENU) Press and hold for 3 seconds
to increase the slow
start speed by 1 hz.

(F1)

(F2)

按住3秒 起動慢速速度
減少 1 hz.

(F3)

(F4)

Press and hold for 3 seconds
to reduce the slow
start speed by 1 Hz.

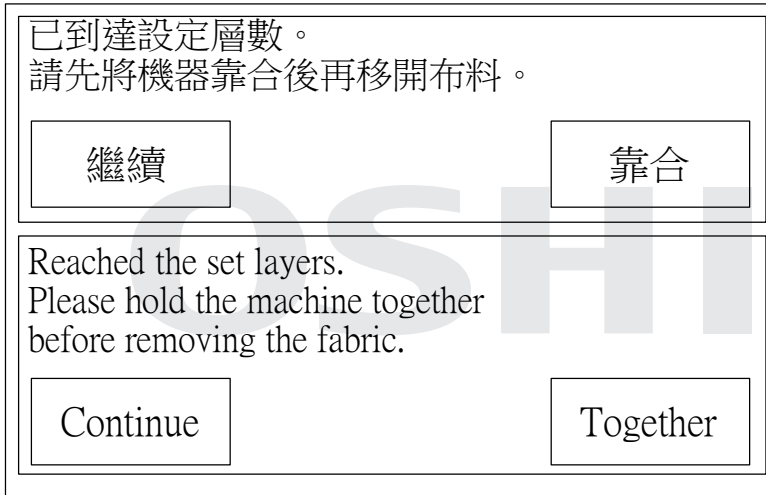
(F5)

按住3秒 起動慢速行走時間增加 1 秒.

Press and hold for 3 seconds to increase the
slow speed walking time by 1 second.

按住3秒 起動慢速行走時間減少 1 秒.

Press and hold for 3 seconds to reduce the
slow speed walking time by 1 second.



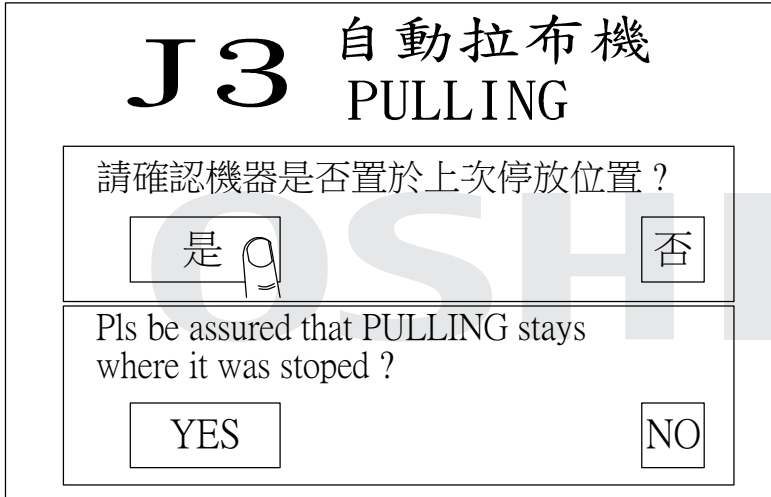
當設定層數到達時會出現此一畫面，提醒您先將機器靠合後再移開布料。
從新操作時先將裁刀高度降至底部。

或按 繼續 回操作頁面。

This screen will appear when the set number of layers is reached, reminding you to close the machine before removing the fabric.

When starting a new operation, first reduce the cutter height to the bottom.

Or press to continue to return to the operation page.



MENU

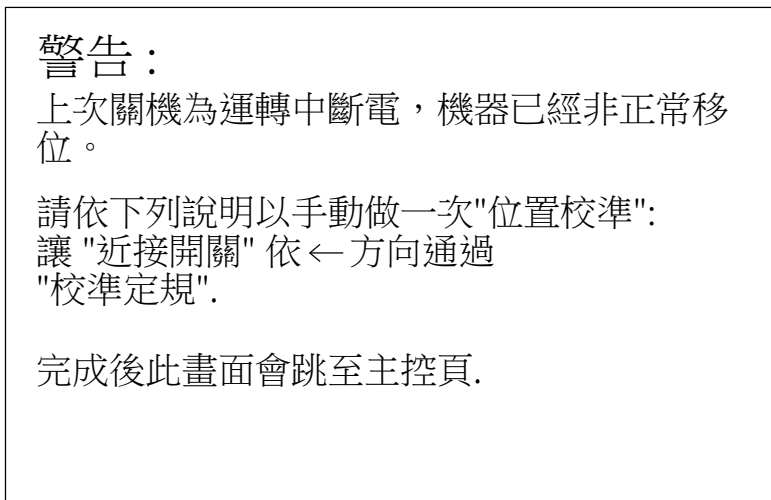
F1

F2

F3

F4

F5



MENU

F1

F2

F3

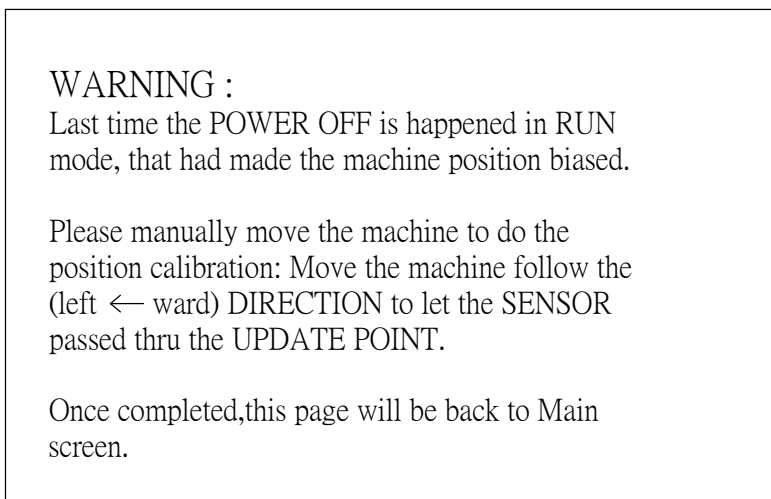
F4

F5

當運轉中斷電時,機器在無電力狀態下會有短距離的慣性滑動,於是產生"基準點移位".

重新開機後點選 鍵時會出現左列畫面.

請依畫面說明做 "位置校準".



MENU

F1

F2

F3

F4

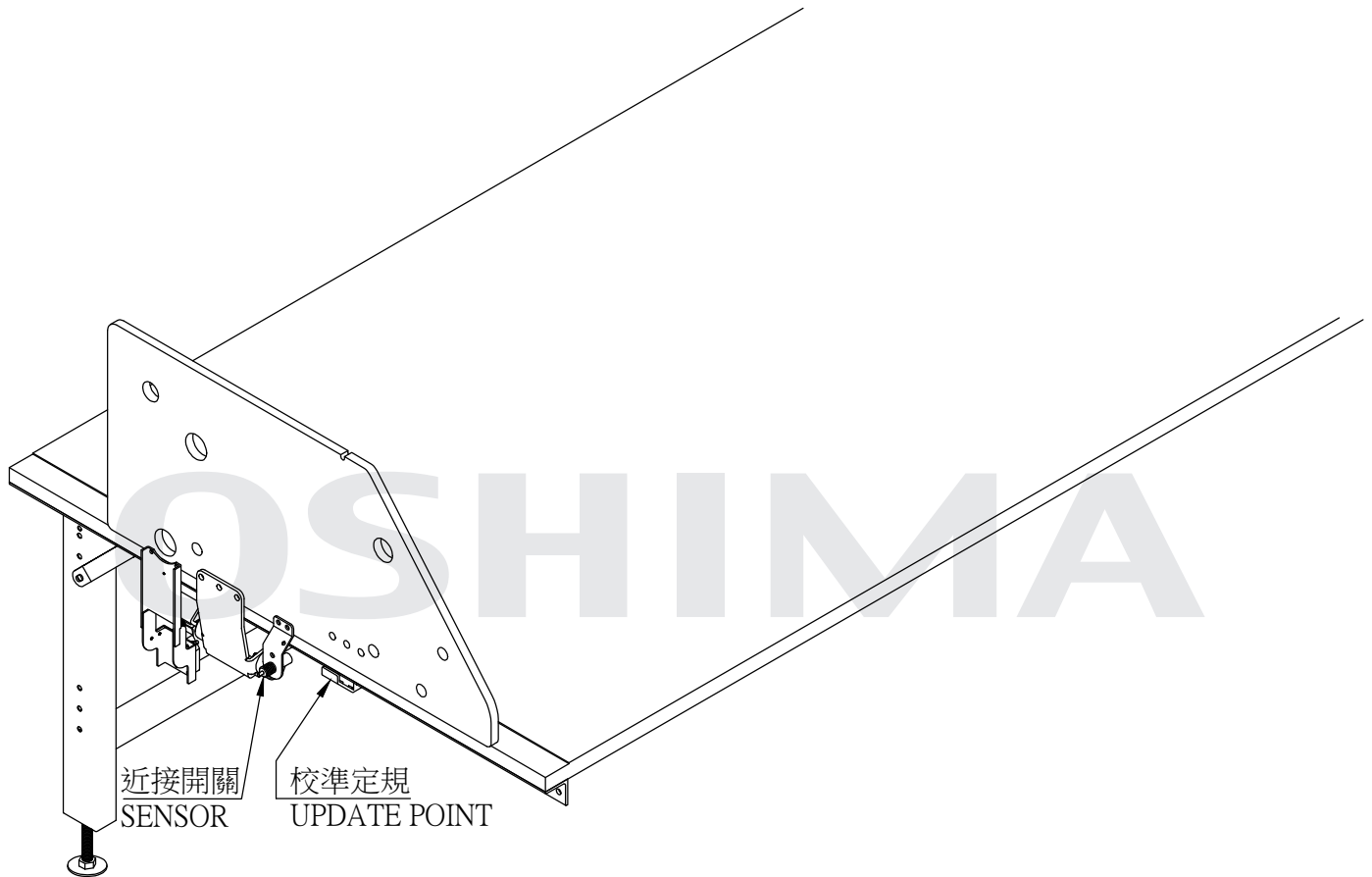
F5

Once the power is sudden shutdown in RUN mode the encoder will record the wrong length value because of Inertia, thus the Position will be also recorded in error.

When the POWER is switched on again, ← this screen will be shown after you pressed .

Please repeated the steps said in WARNING to do the position calibration.

動機 Moving unit



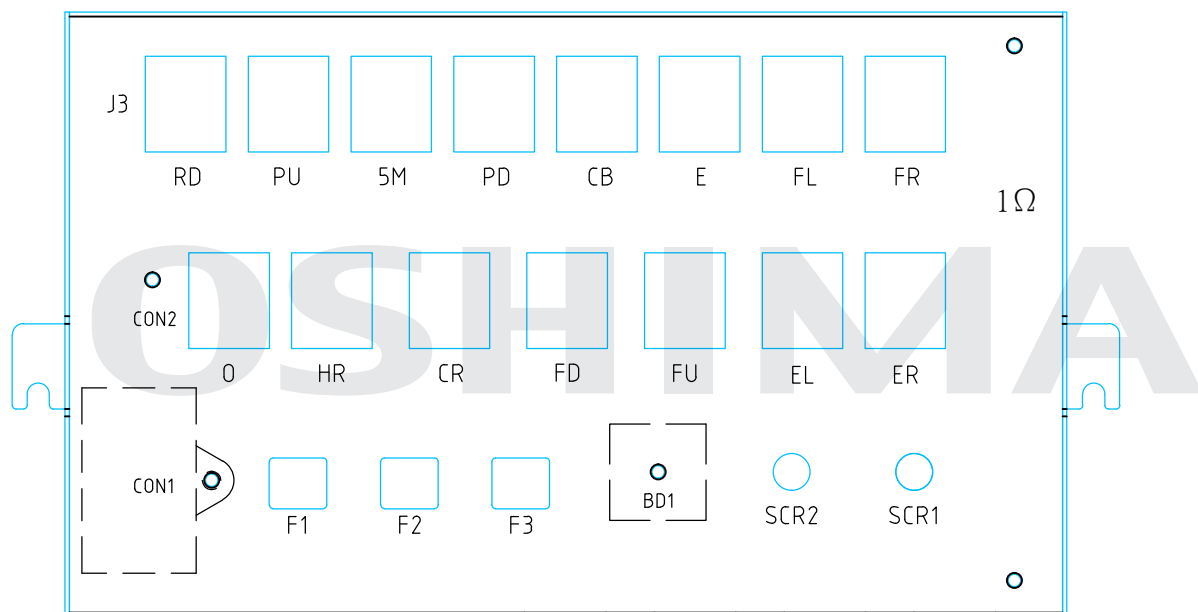
每一次 近接開關 左行 通過 校準定規 時,都會把現在位置 更新成 20.0 .
即機器通過基準點後的20cm處為0點位置.
此為機器決定位置的 基準點.

機器行進中突然斷電,機器會在無電力狀態下滑行停止.
因此, 基準位置 會跑掉而不在原來的的位置. 碰到這種狀況,
再送電後,必須以 寸動 方式讓機器往定機移動讓 近接開關 左行 通過 校準定規,
讓機器重新確定自己的 基準位置.

Every time when the SENSOR passed thru UPDATE POINT will re-set the position as "20.0"
That is, the 0 position is 20cm after the machine passes the UPDATE POINT.
This is the reference point for the machine to determine the position.

If the machine suddenly loses power while it is moving, the machine will slide and stop without power, after the power is turned on, manually move the machine forward to fixed unit, let the SENSOR passed thru UPDATE POINT to calibrate position.

定機配線盤 Relay Box of fixed unit



F1—圓刀馬達 電路保護器.

F1—Cutter Motor Electricity Protective.

F2—DC24V 電路保護器.

F2—DC24V Electricity Protective.

F3—對邊馬達 電路保護器.

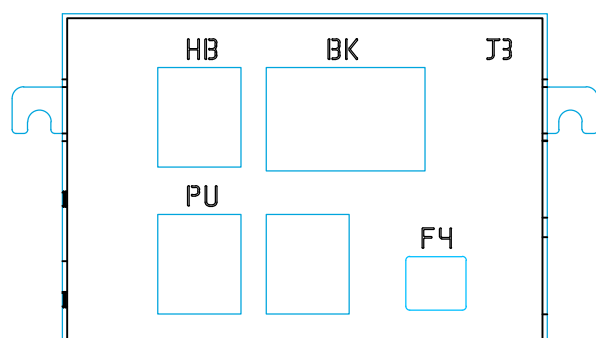
F3—Auto Edging Motor Electricity Protective.

電路保護器 於過電流時 會跳脫, 押回後再試用, 如不再跳脫, 則可安心繼續操作.
如一再跳脫, 有可能短路, 或電路保護器本身故障.

If any jump of the Protective, please press it back to use.

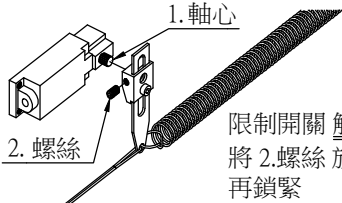
If the protective keeps jumped, please change the parts, and check the power supply.

動機配線盤 Relay Box of moving unit

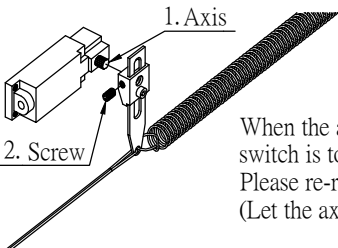


F4—DC24V 電路保護器.

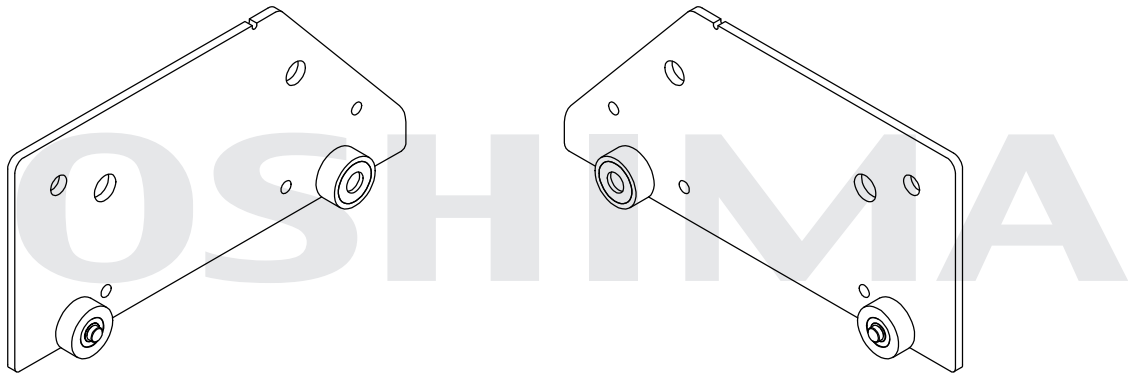
簡易故障排除

狀 況	原 因	對 策
裁斷刀片不轉動	<ol style="list-style-type: none"> 1. 電路保護器F1跳脫 2. 繼電器CR接點燒毀 3. 馬達碳刷或轉子磨損 	<ol style="list-style-type: none"> 1. 押回再試,正常則繼續使用. 如一再跳脫,有可能短路,或電路保護器本身故障. 2. 更換繼電器. 3. 馬達壽命約1.5-3年,屬消耗品.
對邊布料台 不動	<ol style="list-style-type: none"> 1. 電路保護器F3跳脫 2. 繼電器ER EL接點燒毀 3. 對邊馬達故障 	<ol style="list-style-type: none"> 1. 押回再試,正常則繼續使用. 如一再跳脫,有可能短路,或電路保護器本身故障. 2. 更換繼電器. 3. 此馬達在未遭撞擊情況下不易故障.
無法啟動電源	<ol style="list-style-type: none"> 1. 電磁接觸器內熱電譯跳脫 2. 機器外電源斷路 	<ol style="list-style-type: none"> 1. 掀開電磁接觸器外殼,押一下復歸桿即可. 2. 用電表循線測查.
押 自動 不能自動行走 PLC/X3 燈號亮著	<p>⊙OP 繼電器 異常.</p> <p>在送電中 ⊙OP 必處於 ON (吸磁)狀態,</p> <p style="text-align: center;">押鋼索</p> <p style="text-align: center;">↓</p> <p>讓定機 ⊙CN 斷電以及 讓動機 ⊙OP 斷電</p> <p style="text-align: center;">↓</p> <p>機器停止</p> <p>如果 ⊙OP 持續斷電 = 不能自動行走</p>	<p>⊙CN 電源經由 停止鋼索 端的 限制開關 提供,</p> <p>⊙OP 電源則由 ⊙CN 接點提供,這兩顆繼電器同時動作</p> <ol style="list-style-type: none"> 1. 檢查有無布削包或台車之類壓到鋼索 2. 鋼索端的 限制開關 故障 或 <u>觸動柄角度歪斜</u> 3. 參考 電路圖 循線檢查有無斷線 <div style="text-align: right;">  <p>限制開關 <u>觸動柄角度歪斜</u> 過大時 將 2.螺絲 放鬆(讓 1.軸心 彈回原點) 再鎖緊</p> </div>

TROUBLE SHOOTING

TROUBLE	CHECK	SOLUTION
Cutter blade is not rotating.	<ol style="list-style-type: none"> 1. F1 protective is jumped. 2. CR relay joints are burnt. 3. Brush motor and bearings. 	<ol style="list-style-type: none"> 1. Press the protective back to use. 2. Change the CR relay. 3. Motor Life duration is 1.5-3 years in average. This is a consumables.
Auto Edging is not working.	<ol style="list-style-type: none"> 1. F3 protective is jumped. 2. ER EL relay joints are burnt. 3. Edging Motor is broken. 	<ol style="list-style-type: none"> 1. Press the protective back to use. 2. Change ER EL relays. 3. Change the edging motor.
Unable to turn the power ON	<ol style="list-style-type: none"> 1. Magnetic contactor the inner protective jumped. 2. The power supply is cut. 	<ol style="list-style-type: none"> 1. Press the protective back to us. 2. Please use the galvanometer to check the power supply.
Press RUN But machine is not in Auto Mode.	<p>⊙ OP Relay is damaged.</p> <p>When the power is on, ⊙ OP relay must be ON.</p> <p style="text-align: center;">Press the Wire</p> <p style="text-align: center;">↓</p> <p style="text-align: center;">The fixed part ⊙ CN and moving part ⊙ OP power is cut.</p> <p style="text-align: center;">↓</p> <p style="text-align: center;">Machine Stop.</p> <p>⊙ OP is damaged will make the Auto mode no function.</p>	<p>⊙ RP Relay Power is supplied by the Limit Switch in the end of the wire. ⊙ OP Relay Power is supplied by the ⊙ CN. The two relays operate simultaneously.</p> <ol style="list-style-type: none"> 1. Check whether any object press the wires. 2. The Limit Switch is damaged or handle angle skew. 3. Please refer to the Electricity diagram whether any cord cut. <div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>When the angle of the handle of the limit switch is too large. Please re-release and lock the screws. (Let the axis bounce back to the origin.)</p> </div> </div>

基本定期保養 BASIC AND ROUTINE MAINTENANCE.



1. 清除輪子表面污垢
輪子表面污垢多為積塵附著，積塵一多容易打滑，造成長度不準。建議每天擦拭。
WHEELS:
Wheels will be stained of dust and dirt, will cause the wrong measurement, and slippery movement. Please clean the wheel accordingly.
2. 清除積塵
一個星期至少以風槍清潔一次。
DUST:
Please use the air gun to clean the machine. To keep clean is the first step of quality.

維修記錄 SERVICE RECORD

裝機 Installed	日期 Date	機器編號 SER No.	使用者編號 USER No.	程式 Program	簽名 Sign
	日期 Date	內容 Subject Matter			簽名 Sign
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					

OSHIMA

	日期 Date	内容 Subject Matter	簽名 Sign
16			
17			
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