

OSHIMA[®]

歡迎使用“歐西瑪”壓襯機

WELCOME YOU USE “OSHIMA” LOW TEMPERATURE
CONTINUOUS FUSING PRESS MACHINE

使用前，請詳閱

BEFORE YOU BEGIN，PLEASE READ CAREFULLY

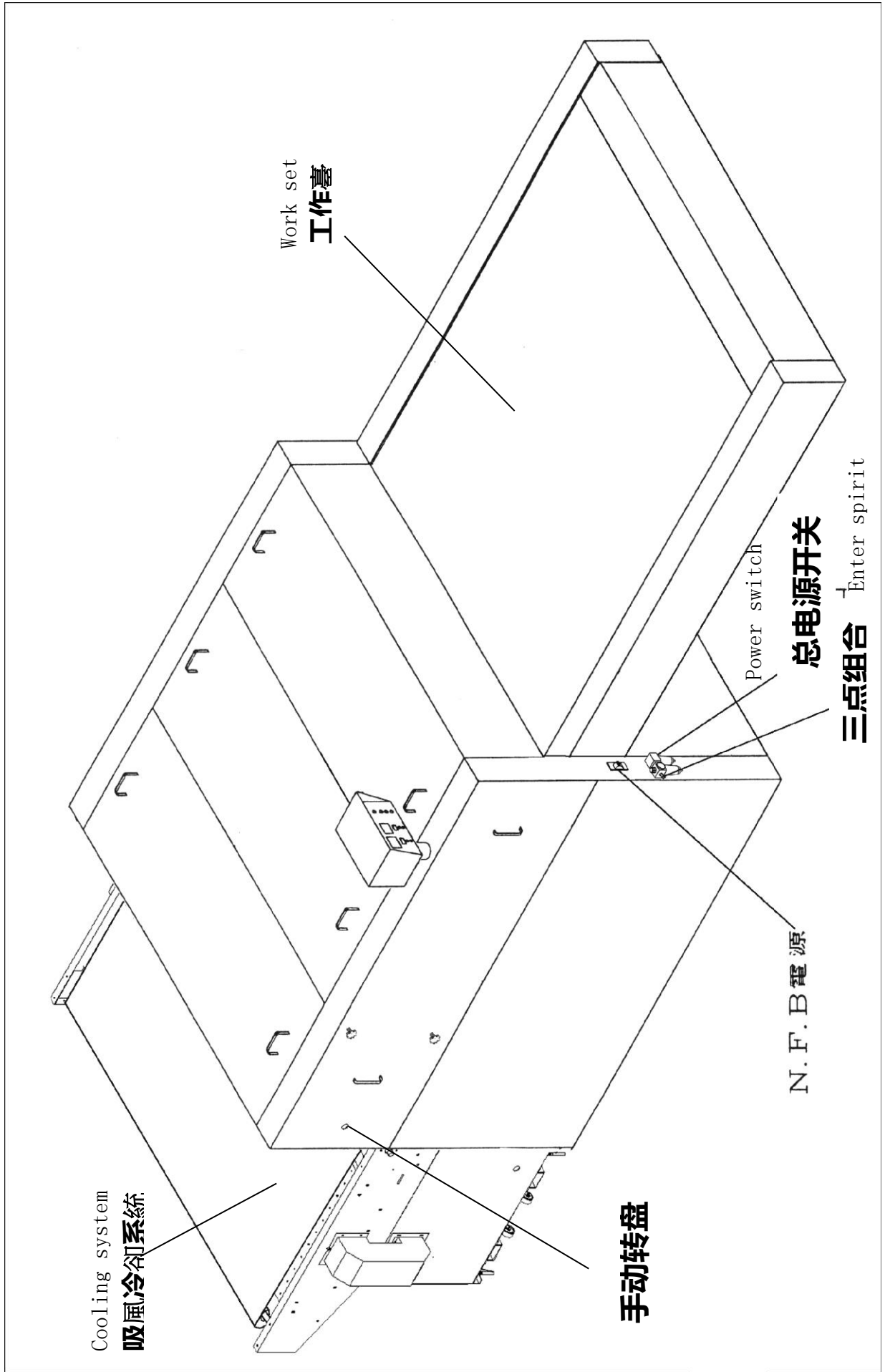
OP-1200

OP-1400

OP-1600

使用說明書

OPERATING MANUAL



連續式粘合機

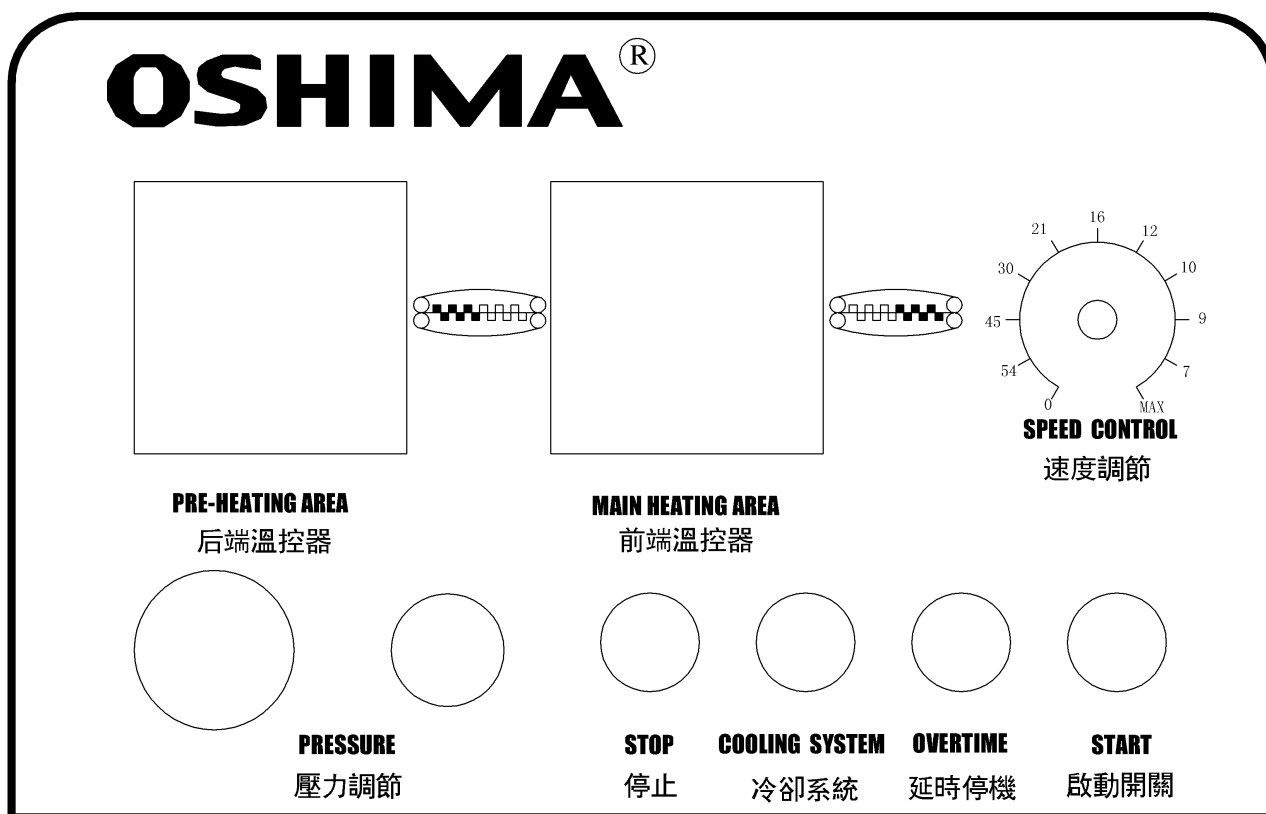
一、規格:

型號	OP-1200/L	OP-1400/L	OP-1600/L
電壓	3P 220V/380V	3P 220V/380V	3P 220V/380V
電熱	21.6 kw /24kw	26.4 kw/28.8kw	28.8kw/33.6kw
主馬達	0.4 kw	0.4 kw	0.4kw
最高溫度	230°C	230°C	230°C
最大壓力	0.5M pa	0.5M pa	0.5M pa
粘合時間	7-34sec	7-34sec	7-34sec
粘合寬度	1200mm	1400mm	1600mm

二、操作方法

- 1、將機器總電源開關拔向“ON”位置按下操作箱啟動開關；（*開關裏的紅燈會亮）；（*馬達同時開始運轉）：
 - A、先將調速旋鈕旋轉至最大數值；
 - B、檢查皮帶表面無異物後按啟動開關按鈕；
 - C、旋轉調速旋鈕使皮帶約 12—20 秒慢速運行，一周後無異常設定所需速度。
 - 2、設定溫度控制系統，將前/後的溫度設定在適當之溫度；（溫控器設定方法見第六點）。
 - 3、轉動速度控制旋鈕，設定適當之速度；
 - 4、調整壓力閥，將壓力調整至所需壓力；（本机压力使用范围：1—4 kg/cm²）
 - 5、工作時打開冷卻系統；
 - 6、完成工作後，將壓力調到 0kg/CM²；關閉冷卻系統再將冷卻定時開關啟動，馬達會自動運轉約 60 分鐘後自動停止，而後關閉總電源開關；
- ★初次安裝開機前或機台移動原位置後，首先必需以後上壓力滾筒為基準，調整主機台水平，以防止皮帶偏離或壓力不均現象產生。

三.操作面板:

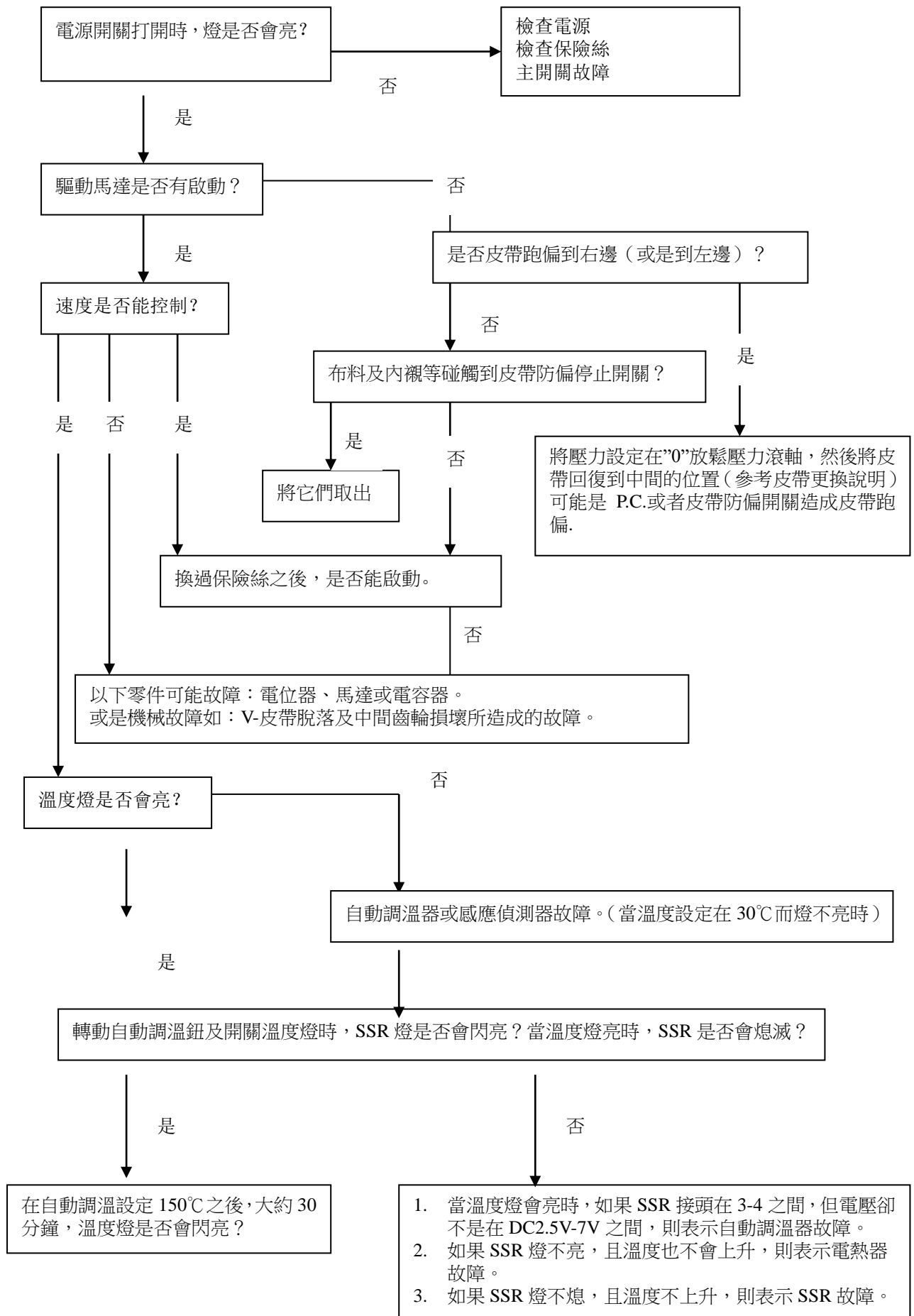


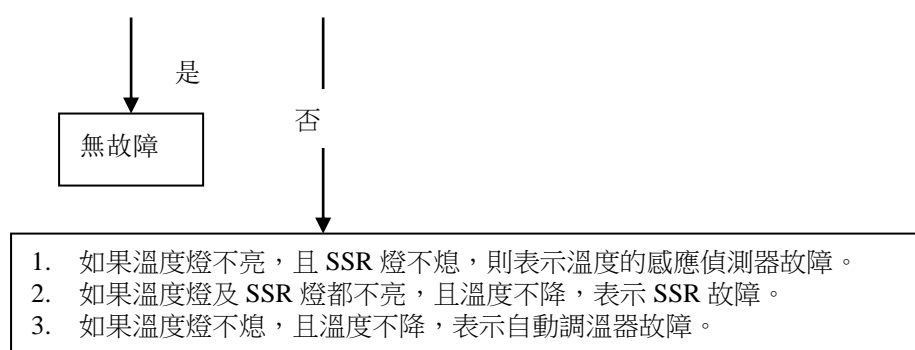
四、注意事項：

- 1、 務必將機器調整水平後再開機運行。
- 2、 請保持機台清潔，每天開機前用壓縮空氣槍將機台內灰塵、線頭予以清除；(特別注意皮帶張力滾筒上是否附有襯布)
- 3、 工作臺、外蓋板上均不得放置硬物(剪刀、筆、尺及各種金屬製品塑膠製品)，以免捲入皮帶將皮帶損壞；
- 4、 高溫運行時不可突然停機，遇此突發狀況時採用手動裝置將皮帶緩慢轉動，以防止皮帶因高溫損壞；
- 5、 根據工作時間及工作量，適時更換清潔杆布：(清潔杆所包裹的清潔布必需採用純棉布料)
- 6、 定時清潔皮帶：(請採用專用皮帶清潔劑、確保皮帶使用壽命)
 - A、 視透膠情況適時清潔皮帶，清潔皮帶時請將機器溫度開至 100°C 左右；

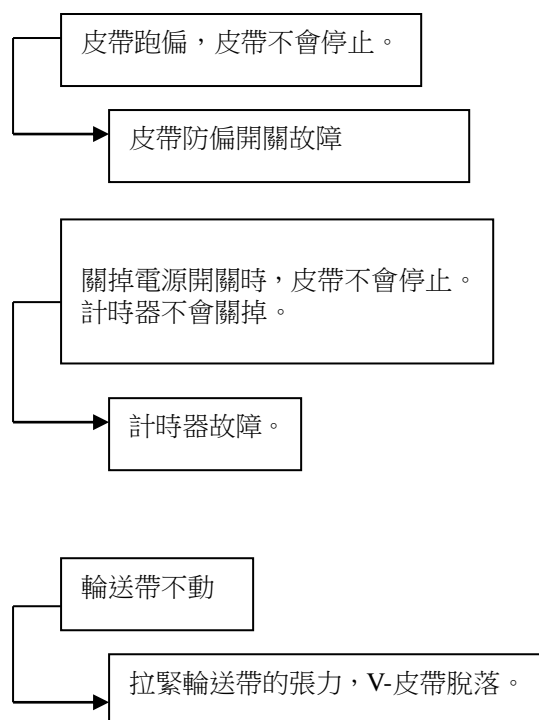
- B、 清潔擦拭皮帶時，請在皮帶下麵有支撐的地方或皮帶出口滾筒處擦拭；
 - C、 帶自動調偏修正系統的機台，清潔擦拭皮帶時需注意各開關與皮帶的接觸，以免調偏修正系統失靈；
- 7、 請不定期對機台各傳動部分、培林加注潤滑油（高溫黃油）；
 - 8、 超厚襯片粘合時，請適當減小壓力或放掉壓力,否則將會卡死；
 - 9、 機台遷移原安裝位置後，請務必調整水準，以防壓力不均或皮帶跑偏而損壞；
 - 10、 配備氣動加壓的機台，油杯內潤滑油用完時，請加注衣車油或機油，過濾杯內所過濾出的油、水請於每天下班時排放乾淨；★（排放時按住過濾杯底部，直至空氣排放乾淨即可）
 - 11、 襯片粘合時，請盡可能襯小於布，且整片襯布的寬度不得大於皮帶寬度，否則有可能影響粘合、皮帶跑偏或機台運轉停機；
※ 不按上述方式保養、清潔機台將會損傷皮帶或降低整機的使用壽命。

五、故障排除：





其它:



☆為了避免機械故障，請務必給驅動部分的零件上油作潤滑。

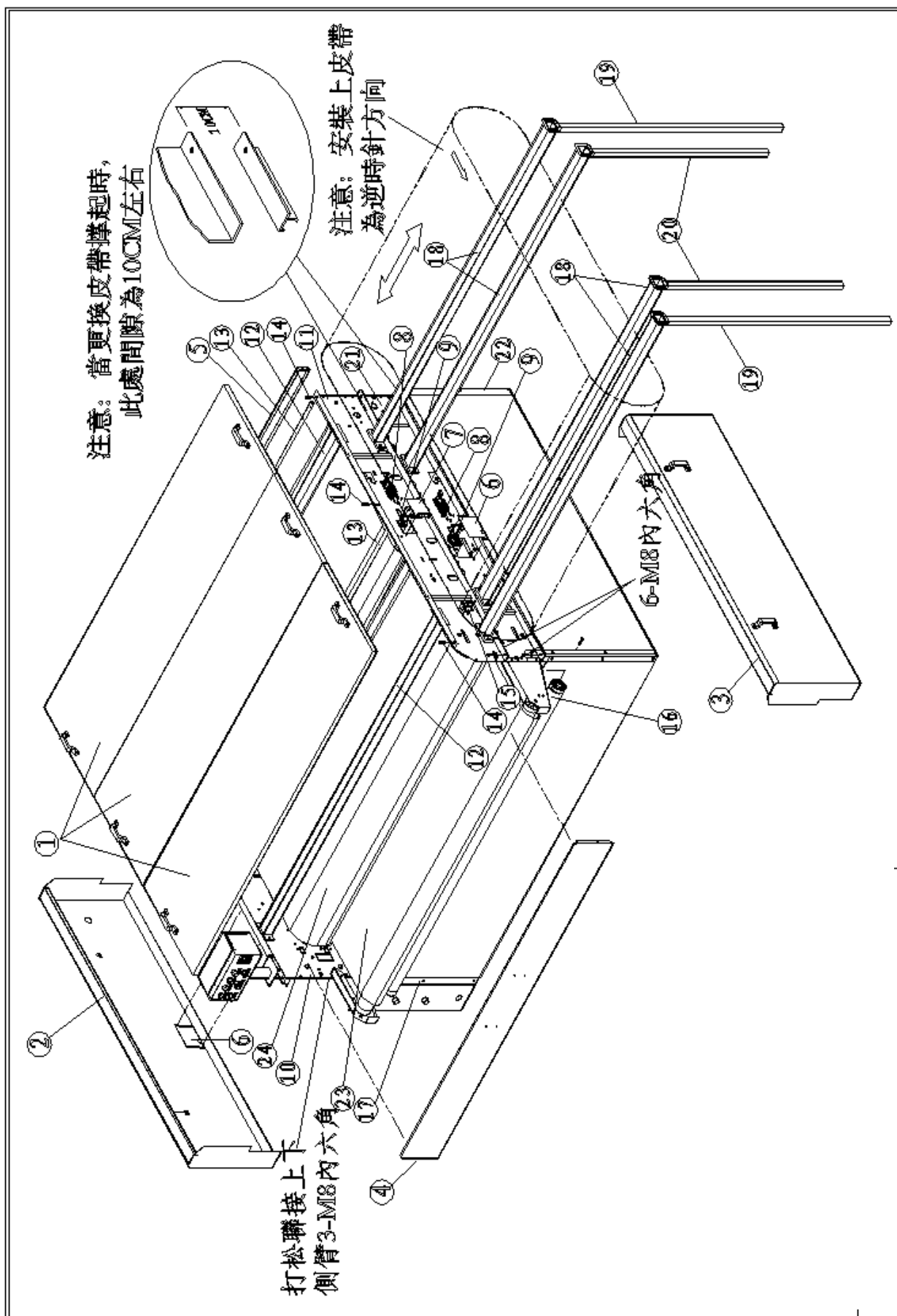
六、溫控器的設定方法

1. 溫度的設定方法：先按一下“SET”鍵，看到SV處顯示數值以後，通過F\◀、▲、OFF\▼三鍵配合，將溫度設定為所需溫度，然後再按一下SET鍵退出設定環境。
2. 警報溫度的設定：連續壓按SET鍵則會顯示AL1、SLH兩個參數，分別代表警報值與警報設定上限值，通過F\◀、▲、OFF\▼三鍵配合，即可設定此參數。
- 3、 設定完數值後，連續按住SET鍵，當顯示出“LCK”後，將其值改為“1”，以鎖定溫控器。
- 4、 注意：在機器使用過程中您只鬚根據您的要求來設定“SV”的值即可，若無其他需要或出現意外情況請不要隨便解開鎖定修改其他參數。否則將影響機器的效果！

七、溫控器異常及排除

現象	原因	排除方法
溫控器不工作	SV 值為 0000	設定 SV 溫度值高於常值
溫控器不工作顯示“FFFF”	溫感線斷裂	更換溫感線或從新接線
溫控器不工作顯示“、、、、”	溫感線接反	檢查並糾正
溫控器不工作 AL1 警報燈亮	AL1 警報值沒設定	從新設定 AL1 值
溫度有誤差	出入校正沒設定	設定 SHT 與實際溫差數值

八、皮帶拆裝步驟(附圖)



1. 先将 3 块上盖板○,1、左护罩○,2、右护罩○,3、上前封板○,4、上后封板○,5 拆除；
2. 拆除上下皮带张力滚筒处的左右滚筒座左右遮片○,6、○,7；
3. 将连接前上机台壁○,10和后上机台壁○,11的靠上的 2 支主体横梁○,12、2 支主体横杆○,13拆除。将后上机台壁顶部的 3 个上盖轴套○,14拆并将皮带修正开关固定座○,15拆松后悬挂在机台壁外侧。将入料端连接后中机台壁与前上机台壁的一支主机滚筒○,16拆除。最后将连接后上、后中、后下机台壁的 6-M8 内六角螺丝、M8 螺母完全拆除，将连接前上机台壁○,10和前下机台壁○,17的 3-M8 内六角螺丝打松少许（注意；不可完全拆除）
4. 把 4 根横梁○,18分别套在后上机台壁和后中机台壁固定主体横梁的 M10 螺杆上并用 M10 螺母锁紧，分清上、下皮带，较长的为下皮带○,23，较短的为上皮带○,24；
5. 二个人用撑杆○,19套入横梁○,18将后上机台壁○,11抬高至与后中机台壁○,21的间隙为 10CM 左右（撑杆○,19撑好后必须由专人扶住以防倒塌）。由两人在机器前、后端将上皮带○,24张开至大于后上机台壁○,11的宽度，然后将上皮带慢慢抽出放在横梁○,18上。再将横梁○,18抬起少许将撑杆○,19移除即可将上皮带拆除。
6. 四个人用撑杆○,19○,20套入横梁○,18将后上、后中机台壁○,11○,21抬高，使后上机台壁○,11与后中机台壁○,21以及后中机台壁○,21与后下机台壁○,22的间隙为 10CM 左右（撑杆○,19○,20撑好后必须由专人扶住以防倒塌）。由两人在机器前、后端将下皮带○,23张开至大于后中机台壁○,21的宽度，然后将皮带慢慢抽出摆在横梁○,18上，再将横梁○,18抬起少许将撑杆○,19○,20移除即可将下皮带拆除。
7. 四个人分两头拉住下皮带，检查皮带上的箭头指向是顺时针指向后将皮带套在后中机台壁上的 2 根横梁○,18上。然后另四个人用撑杆○,19○,20套入横梁

○,18将后上、后中机台壁○,21抬高,使后上机台壁○,11与后中机台壁○,21以及后中机台壁○,21与后下机台壁○,22的间隙为 10CM 左右(撑杆○,19○,20撑好后必须由专人扶住以防倒塌)。由两人在机器前、后端将下皮带○,23张开至大于后中机台壁○,21的宽度,另两人在后拉平皮带防止打折,然后将皮带慢慢套入摆在机器正中间。放下撑杆使后中机台壁○,21与后下机台壁○,22连接孔位完全对正后锁上 3-M8 螺丝。

8. 四个人分两头拉住上皮带○,24,检查皮带上的箭头指向是逆时针指向后将皮带套在后上机台壁上的 2 根横梁○,18上。然后另 2 个人用撑杆○,19套入横梁○,18上,使后上机台壁○,11与后中机台壁○,21的间隙为 10 mm左右(撑杆撑好后必须由专人扶住)。由两人在机器前、后端将上皮带○,24张开至大于后上机台壁○,11的宽度,另两人在后拉平皮带防止打折,然后将皮带慢慢套入摆在机器正中间。放下撑杆○,19使后上机台壁○,11与后中机台壁○,21连接孔位完全对正后锁上 3-M8 螺丝、螺母、弹垫、平垫。锁紧已打松的前上机台壁○,10与前下机台壁○,17的 3-M8 螺丝。
9. 拆下四根横梁○,18。将两根张力滚筒○,9分别从后上机台壁○,11及后中机台壁○,21方孔中缓缓放入(注意不可压伤皮带),保持皮带在机器最中间位置,左右同时拉紧张力弹簧○,8。然后装上左右遮片○,6、○,7。将入料端连接后中机台壁○,21与前上机台壁○,10的一支主机滚筒○,16装上。在后上机台壁顶部装上三个上盖轴套○,14。在后上机台壁上装上修正开关○,15。
10. 将两支主体横梁○,12,两支主体横杆○,13分别连接安装在前上机台壁○,10和后上机台壁上。
11. 检查皮带内无异物后开机慢速运行检查皮带有无跑边,如有跑边则调节微动开关使微动开关紧靠皮带并保证微动开关为闭合状态。或可调节前修正滚筒在长孔侧的固定位置达到皮带不跑边。
12. 装上上前封板○,4和上后封板○,5,再盖上三块上盖板○,1,最后盖上左右护罩○,2○,3即可。

CONTINUOUS FUSING PRESS MACHINE

1、SPECIFICATION

Model number	OP-1200/L	OP-1400/L	OP-1600/L
Power supply	3P 220V/380V	3P 220V/380V	3P 220V/380V
Heater	21.6 kw /24kw	26.4 kw/28.8kw	28.8kw/33.6kw
Main motor	0.4 kw	0.4 kw	0.4kw
Max temperature	230°C	230°C	230°C
Max pressure	0.5M pa	0.5M pa	0.5M pa
Fusing time	7-34sec	7-34sec	7-34sec
Fusing width	1200mm	1400mm	1600mm

二、INSTRUCTION MANUAL

1、Switch the power on, the switch button will be lighted. And the motor will be started :

- A、 Please turn the speed to the maximum by speed-adjust knob.
- B、 Please check there is no alien objects on the surface of the machine and then press the start switch button.
- C、 After starting the machine, please adjust the speed around 12~20 seconds for one circle working, and then turn to the speed you required.

2、To set the temperature, is to set the front and rear heaters set in proper temperature to the products demand.

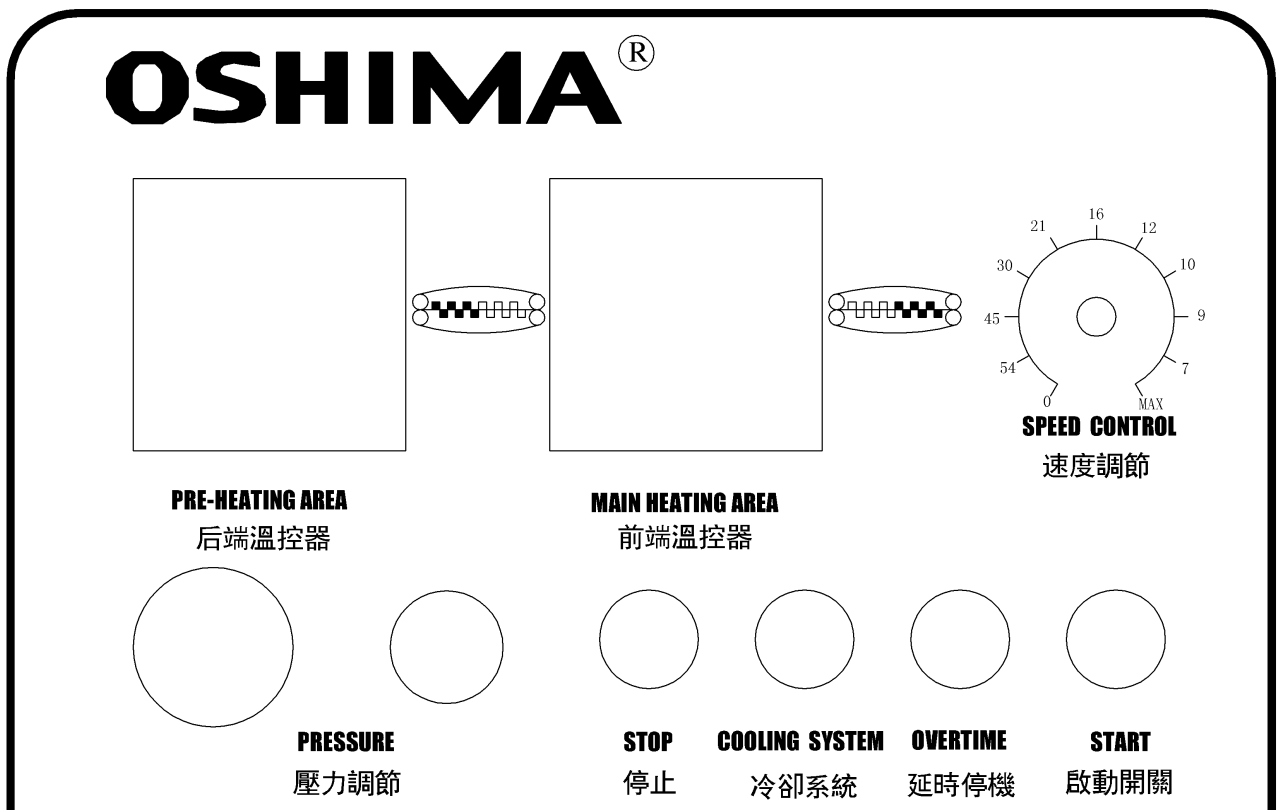
3、Turn the speed control knob and set proper speed.

4、Adjust the front and back pressure to needed pressure valve.

5、Turn the Cooling System on while working, to ensure better bonding effects.

- 6、 After job finished, please adjust the pressure valve to pressure 0kg/cm, and then to turn off the cooling system, and start the auto stop cooling. The auto stop cooling will cool the machine for 60 minutes, and the power will be automatically shut off.

三. CONTROL PANEL



四、NOTICE：

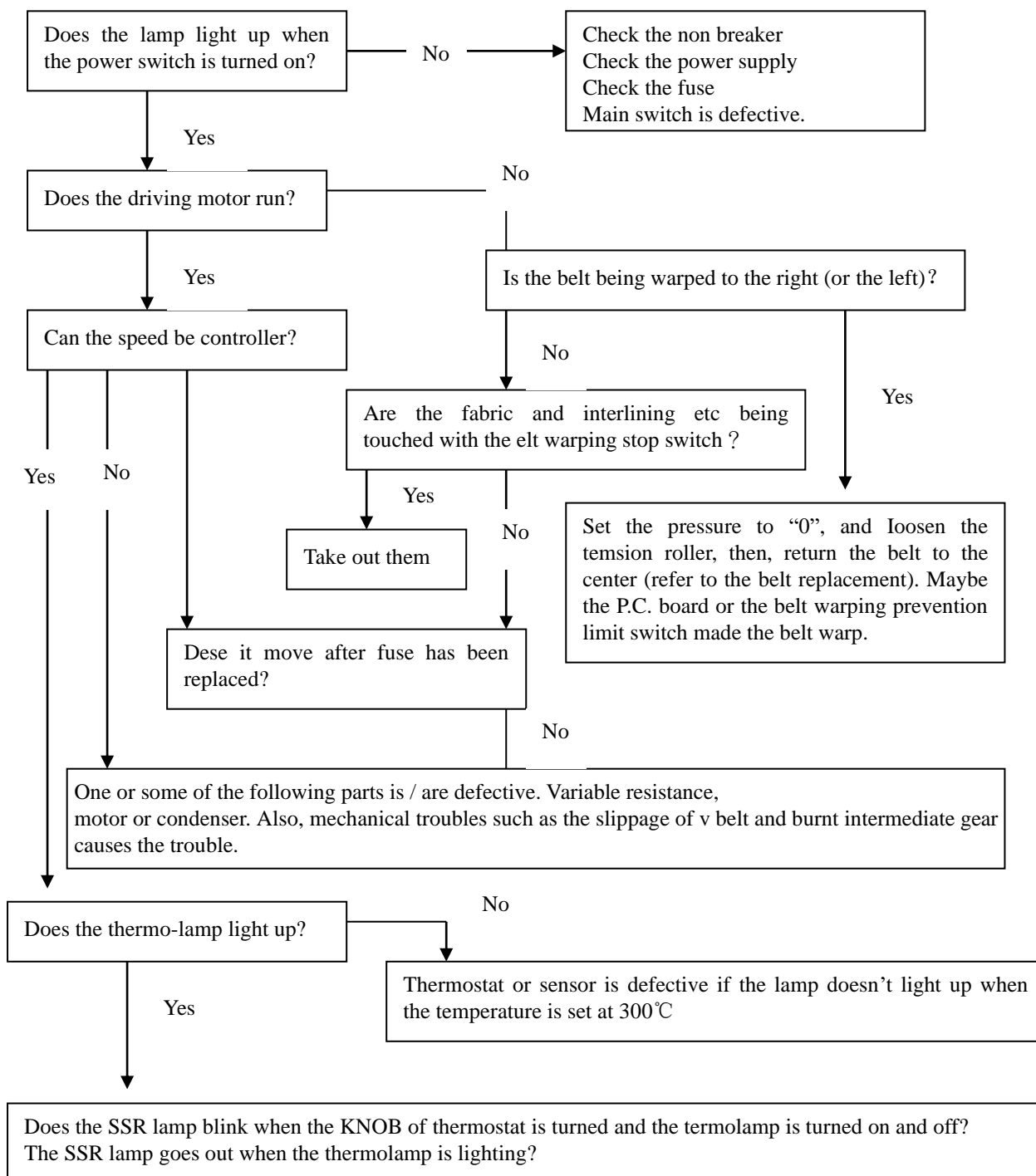
- 1、 Please kindly keep the machine clean. Before using machine, please use the air spray gun to clean the inside dust and alien object away. (Please pay extra attention to check whether there is any interlining stuck on the roller.)
- 2、 On the working table, any hard material such as scissor, pens, rulers, hardware, plastic, are prohibited.
- 3、 When machine is working in high temperature fusing, the sudden stop will be damaging machine. If there is any sudden stop occurs, please do rotate the machine

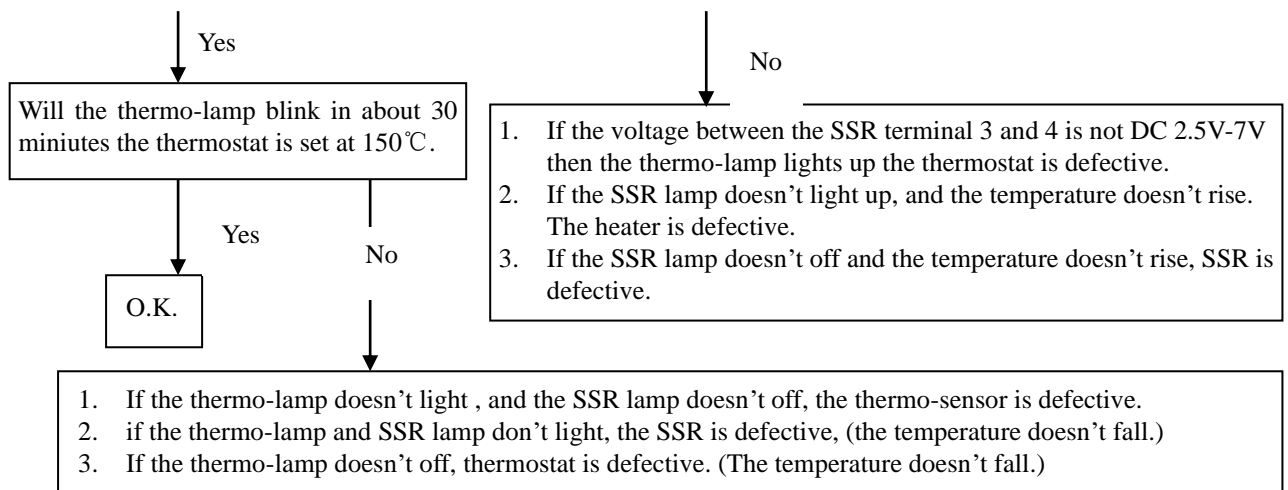
run by manual to prevent damage of high heating temperature.

- 4、 To replace the cleaning rod regularly. The fabric folded on the cleaning rod must be pure cotton.
- 5、 Please clean the Teflon belt regularly after work and also replace the cover of cleaning rod. (Please do use the specific belt cleaning solution to ensure the belt duration.)
 - a) If the glue of the interlining is left too much on the belt during fusing work, the belt must be cleaned every 4 working hours.
 - b) If the glue of the interlining is not left on the belt during fusing work, the belt must be cleaned every 16 working hours.
 - c) When cleaning the belt, please rob the Teflon belt above the rollers or the exit of the machine.
 - d) If the belt guiding is controlled by microswitch, please do keep away from these electronic components to avoid malfunction.
- 6、 Please do lubricate the bearing and chains and all the transmission parts every month to ensure the parts duration.
- 7、 When fusing the thicker of the interlining with fabric, please do release the pressure as less as possible (or even non pressure) or the machine will be stuck.
- 8、 If machine is to be moved place to place, to keep the machine in Horizontal is necessary. Keep the machine horizontal will ensure the belts from warping.
- 9、 With the cylinder type pressure machinery, please avoid the oil gauge empty. Please do put the oil sufficient all the time. And the left oil of the filter, please do release to keep it clean.
- 10、 When doing the fusing jobs, please do keep the interlining smaller than the fabrics to ensure the machine working properly.

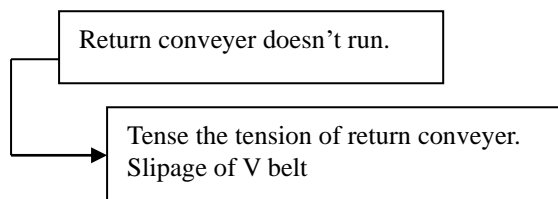
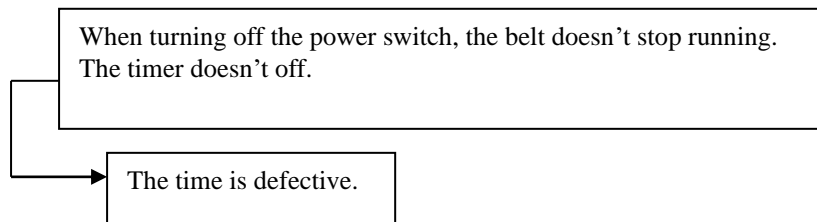
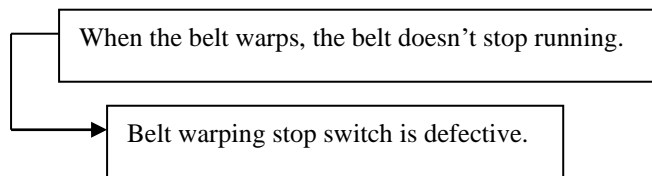
※ Without obeying the above instructions to maintain the machine, the duration of machine will be seriously decreased.

五、TROUBLESHOOTINT :





OTHERS :



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

六、The adjusting method of the temperature controller

1. The adjusting method of the temperature: Press" SET" key first, see SV manifestation number hereafter, pass the F\ ◀,▲ , OFF\ ▼ three keys match with, setting up temperature as the temperature needed, then clicking the key of SET once to withdraw the enactment environment.

2. The enactment of the alert temperature: Continue to press to press the key of SET then would show ALI, SLH two parameters, represent respectively the alert value set up with alert the upper limit the value, passing the F\◀◀, ▲ , OFF\ ▼ three keys match with, can immediately set up this parameter.

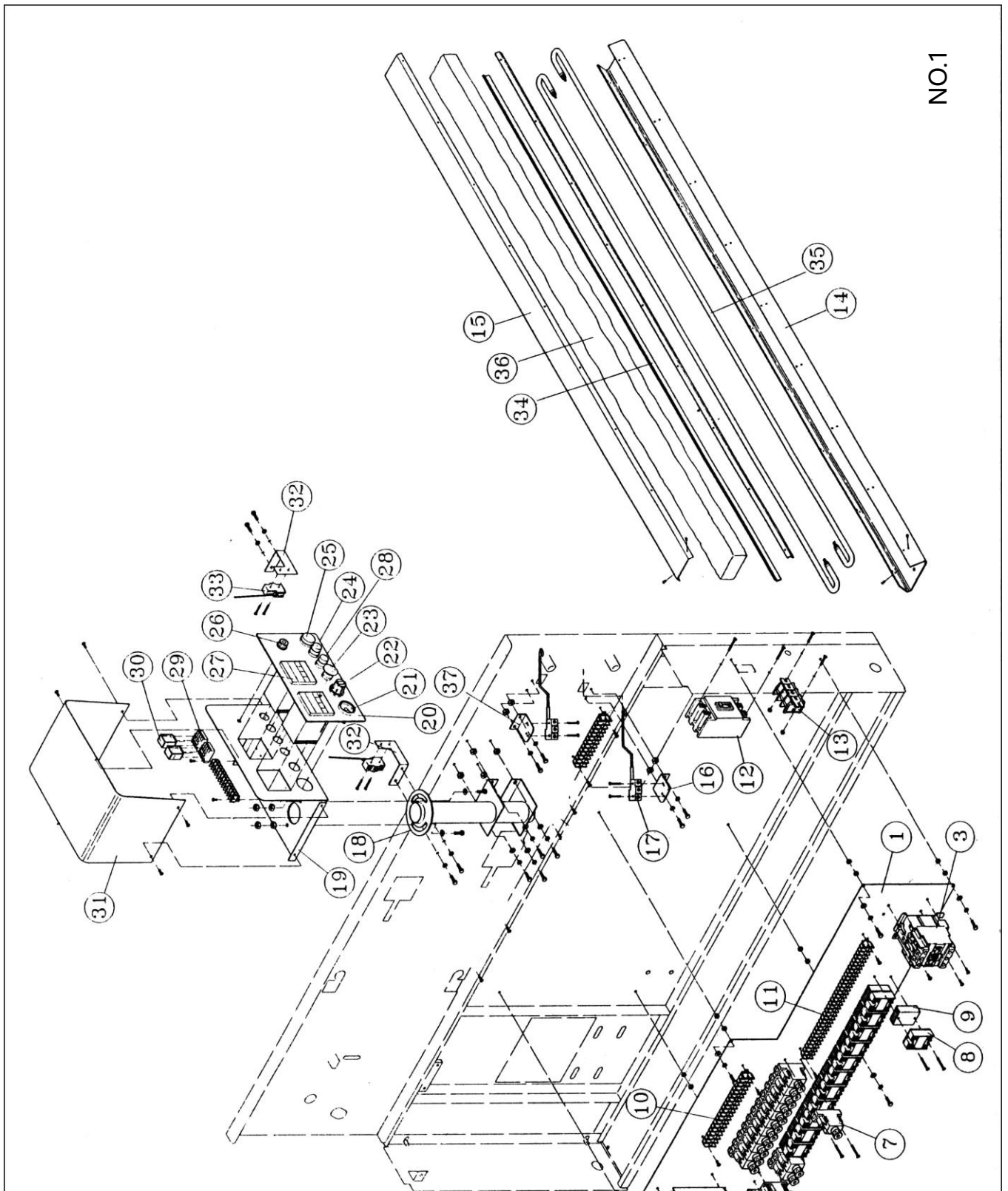
3, after setting up the over number, continue press down the key of SET, be after displaying the " LCK", change its value as the "1", to target the temperature controller.

4, attention: In machine use process you a root of whiskers is then to the value that set up the " SV" according to your request, if have no the other demand or appear the accident circumstance please do not change the parameters of thermostat without certificated OSHIMA technician!

七、Temperature controller abnormality and expel

Phenomenon	Reason	Expel the method
The temperature controller do not work	SV value is 0000	Set up the SV temperature the value higher than often worth
The temperature controller	The temperature	Replacing the temperature

does not work to show the "FFFF"	responds the line breaks	responds the line or from new connect the line
The temperature controller does not work to show ".,,,"	The temperature responds the line connects anti	The check combines to rectify
The temperature controller do not work the AL1 alert light is bright	The AL1 alert value did not set up	From new set up the AL1 the value
Temperature contain error margin	The discrepancy correct and did not set up	Set up the SHT with the actual difference in temperature number



机械零件目录 Part list

NO: 1-1

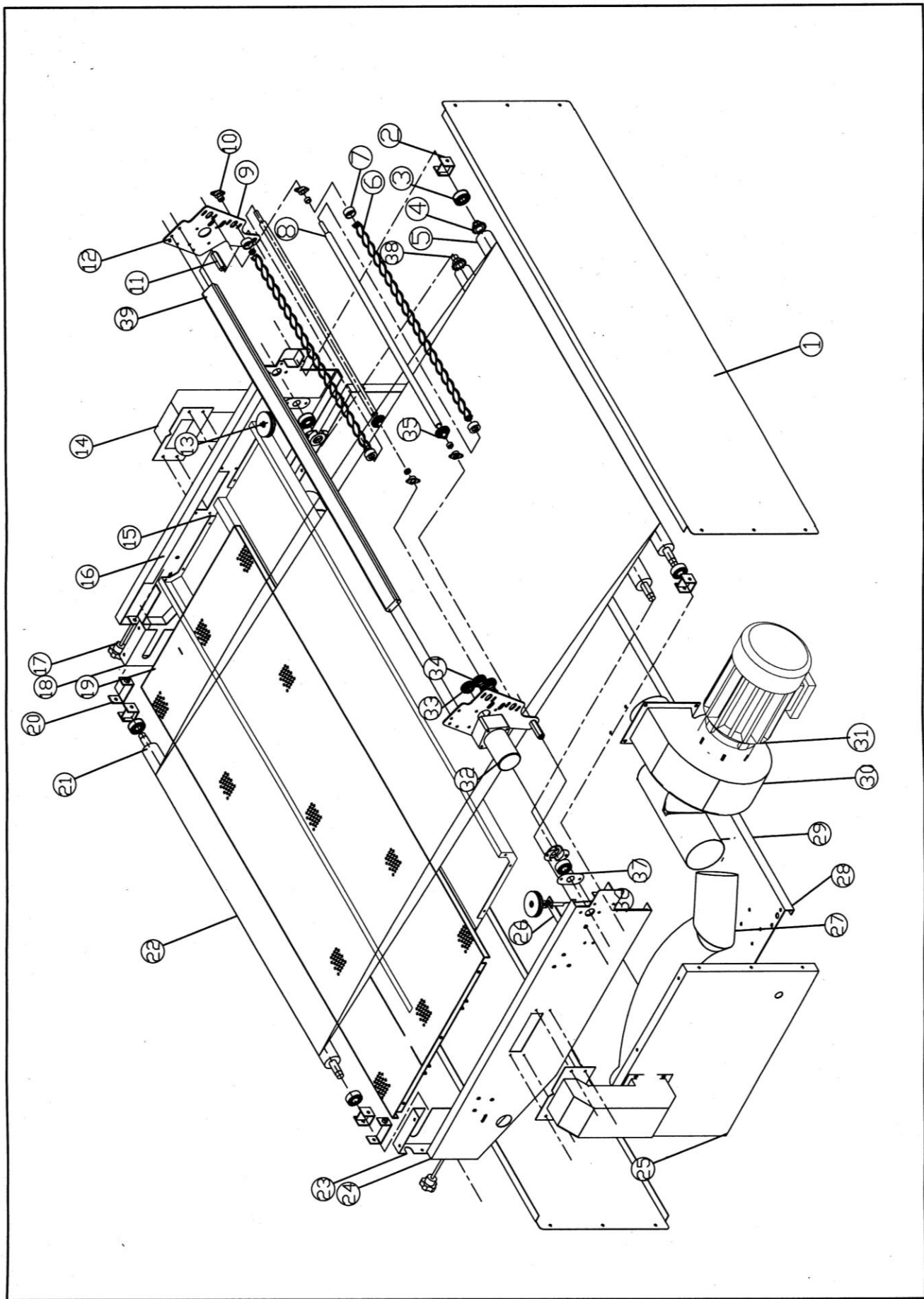
序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
1	1600A121	線路板	circuit board	1	
2	DZ0303	變頻器	inverter	1	
3	DJ0119	電磁接觸器 CN-65S 50HZ	magnetic contactor	1	
4	DJ0120	接觸器 LCID1810M7 220V	magnetic contactor	2	
5	DZ0124	時間控制器 AH3-230m/220V	time relay	1	1 套
6	DJ0301	MY2 底座 30X0Y (PYP08A)	bottom base	1	
7	DF0201	RT14-20 保險管座	fuse base	14	
8	DJ0217	固態繼電器	solid relay	12	
9	DZ0314	散熱片	radiate plate	12	
10	DF0107	端子盤	terminal fixer	3	
11	DF0109	端子盤	terminal fixer	1	
12	DK0604	無熔絲開關 NF-50-SS 50A	N.F.B. switch	1	
13	DF0102	端子盤	terminal fixer	1	
14	1200B014	電熱座	heater base	12	For OP-1200
	1400B014	電熱座	heater base	12	For OP-1400
	1600B132	電熱座	heater base	12	For OP-1600
15	1200B015	電熱座護蓋	protective cover for heater base	12	For OP-1200
	1400B015	電熱座護蓋	protective cover for heater base	12	For OP-1400
	1600B133	電熱座護蓋	protective cover for heater base	12	For OP-1600
16	1600A024	右固定耳	right fixer	1	
17	DK0104	微動開關 E-15HW-78-B	micro switch	2	
18	1600A026	固定座	fixed base	1	
19	1600A056	操作箱	control box	1	

20	1600B153	控制面板	control panel	1	
21	QF0133	氣壓錶 0-5kgkm2	air pressure meter	1	
22	QF0105	調壓閥 1/4" R200	adjusted valve for air pressure	1	
23	DA0128	緊急開關 10A/250VXBZ-ES542	stop switch	3	
24	DA0138	綠色圓型 (點動.帶燈) φ 22	green switch	1	
25	DD0114	白色指示燈 J2PR/220V φ 22	white switch	1	
26	DZ0701	電位器 B502	variable resistor	1	
27	DZ0203	溫控器 CB700 RKC CB700	temperature controller	2	
28	DA0139	黃色Φ22 押扣指示燈	yellow indicated light	1	
29	DJ0301	繼電器底座	bottom base for relay	2	
30	DJ0201	繼電器	relay	2	
31	1600A060	操作箱蓋	cover for control box	1	
32	1600A075/ 76	左右微動開關固定座	fixed base for micro switch	各 1	
33	DK0104	微動開關 E-15HW-78-B	micro switch	2	

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NO:1 -2

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
34	1200B016	電熱管固定片	fixer for heater	24	For OP-1200
	1400B016	電熱管固定片	fixer for heater	24	For OP-1400
	1600B134	電熱管固定片	fixer for heater	24	For OP-1600
35	1200B026	電熱管	heater	24	For OP-1200
	1400B026	電熱管	heater	24	For OP-1400
	1600B194	電熱管	heater	24	For OP-1600
36	ZA3113	保溫綿	cozy sponge	12	
37	1600A023	左固定耳	left fixed ring	1	



机械零件目录 Part list

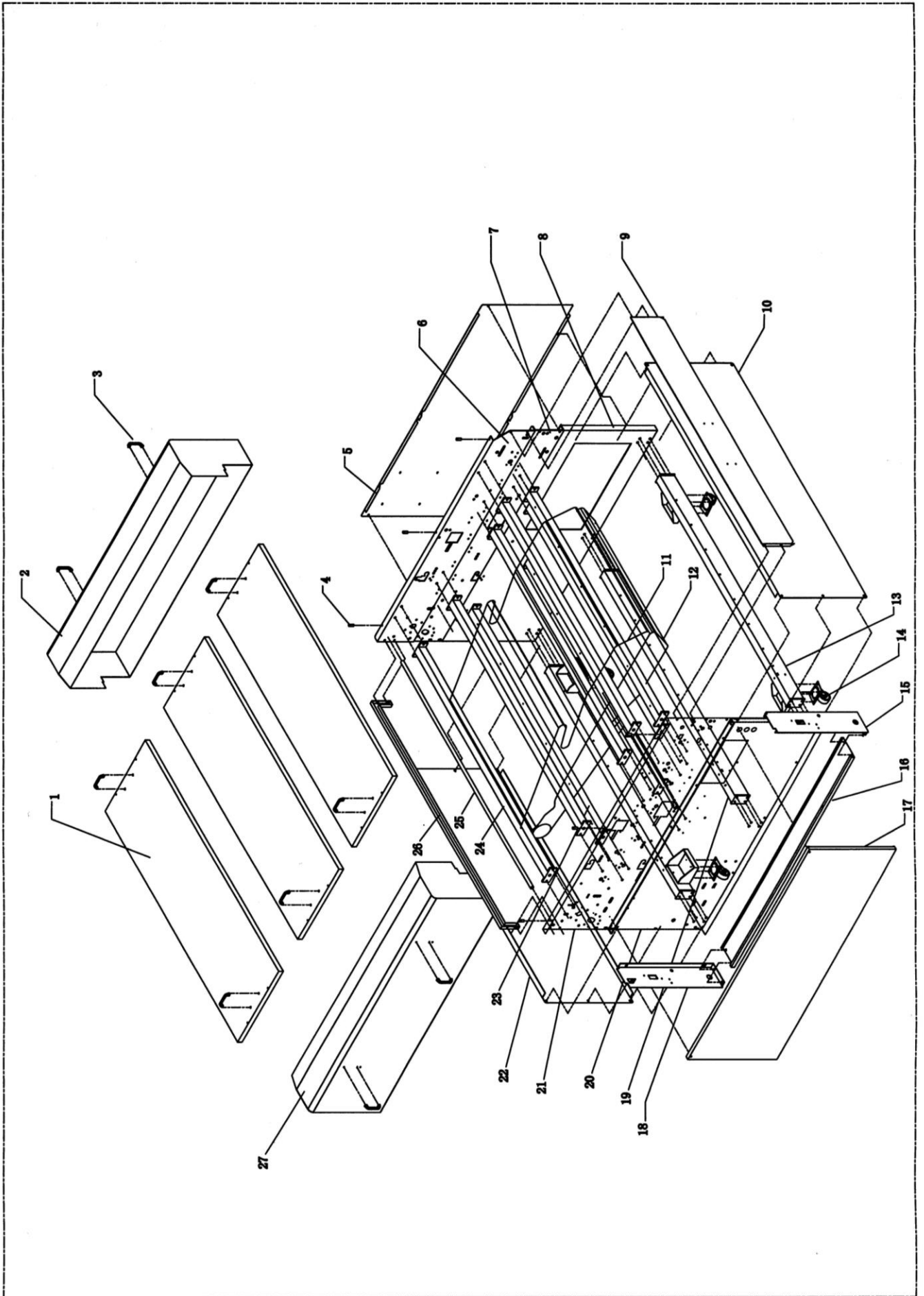
NO: 3-1

序號	部件編號	部件名稱規格		數量	備註
Ref No	Part No	Description		Customer	Remark
1	1600A073	入料下封板	feeding lower covered board	2	
2	1600A134	培林座	washer	4	
3	JB2021	培林 6202	adjusted base	4	
4	1600B148	布架链齿	chain	2	
5	1200B029	輸送帶滾筒	roller for pass belt	1	For OP-1200
	1400B030	輸送帶滾筒	chain wheel for pass belt	1	For OP-1400
	1600B202	輸送帶滾筒	bottom plate	1	For OP-1600
6	1200B002-1	剝離片 四片式	scraper	2	For OP-1200
	1400B002-1	剝離片 四片式	scraper	2	For OP-1400
	1600B102-1	剝離片 四片式	scraper	2	For OP-1600
7	120LEB012	拔片器止環	stop ring for scraper	4	
8	1200B001	剝離杆	Removal pole	2	For OP-1200
	1400B001	剝離杆	Removal pole	2	For OP-1400
	1600B101	剝離杆	Removal pole	2	For OP-1600
9	1600A129	拔片側板(分左右)	side board for scraper	各一	
10	JB1023	培林	adjusted base	4	
11	900B106	端塞	stopper	2	
12	1600A129	拔片側板(分左右)	side board for scraper	各一	
13	900SPB052	止偏輪	stop wheel	2	
14	1600A041	護罩	protective cover	2	
15	1200A009	冷卻箱體	box body for cooling	1	For OP-1200
	1400A009	冷卻箱體	box body for cooling	1	For OP-1400
	1600A034	冷卻箱體	box body for cooling	1	For OP-1600
16	1600A031	右後機台壁	right back machine body	1	
17	ZW0058	梅花手柄	roller	2	
18	1600A136	調節座罩(右)	roller for pass belt	1	
19	1200A010	冷卻罩板	cooling cover	1	For OP-1200
	1400A010	冷卻罩板	cooling cover	1	For OP-1400
	1600A036	冷卻罩板	cooling cover	1	For OP-1600
20	JB2018	培林 6202	adjusted base	2	
21	1200B012	滾筒	roller	2	For OP-1200
	1400B012	滾筒	roller	2	For OP-1400

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NO: 3-1

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
22	JP2203	網帶 1000*2190	mesh belt	1	For OP-1200
	JP2205	網帶 1400*2190	mesh belt	1	For OP-1400
	JP2206	網帶 1600*2190	mesh belt	1	For OP-1600
23	1600A137	調節座罩 (左)	adjusted cover (left)	1	
24	1600A030	左後機台壁	left back machine body	1	
25	1600A071	後下左側板	back bottom left side board	1	
26	900SPA063	止偏輪座	be partial to round seat	2	
27	ZA0208	高溫風管	high temperature duct	1	
28	1600A070	底板	bearing	1	
29	1600A146	風機三通	wind engine three port tie-in	1	
30	2000A277	蝸牛	snail	1	
31	DM0115-2	馬達	motor	1	
32	DM0106	馬達 M81A25GV4Q/110V	motor	1	
33	301B009	馬達齒輪	motor gear	1	
34	60FSAB010	惰輪	idler	2	
35	60FSAB007	馬達齒輪	motor gear	2	
36	900SPB053	軸	axle	2	
37	1600A029	墊片	bearing base	2	
38	1200B003	輸送帶軸心	axis for pass belt	1	For OP-1200
	1400B003	輸送帶軸心	axis for pass belt	1	For OP-1400
	1600B103	輸送帶軸心	axis for pass belt	1	For OP-1600
39		拔片橫梁	beam	1	



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NO: 4

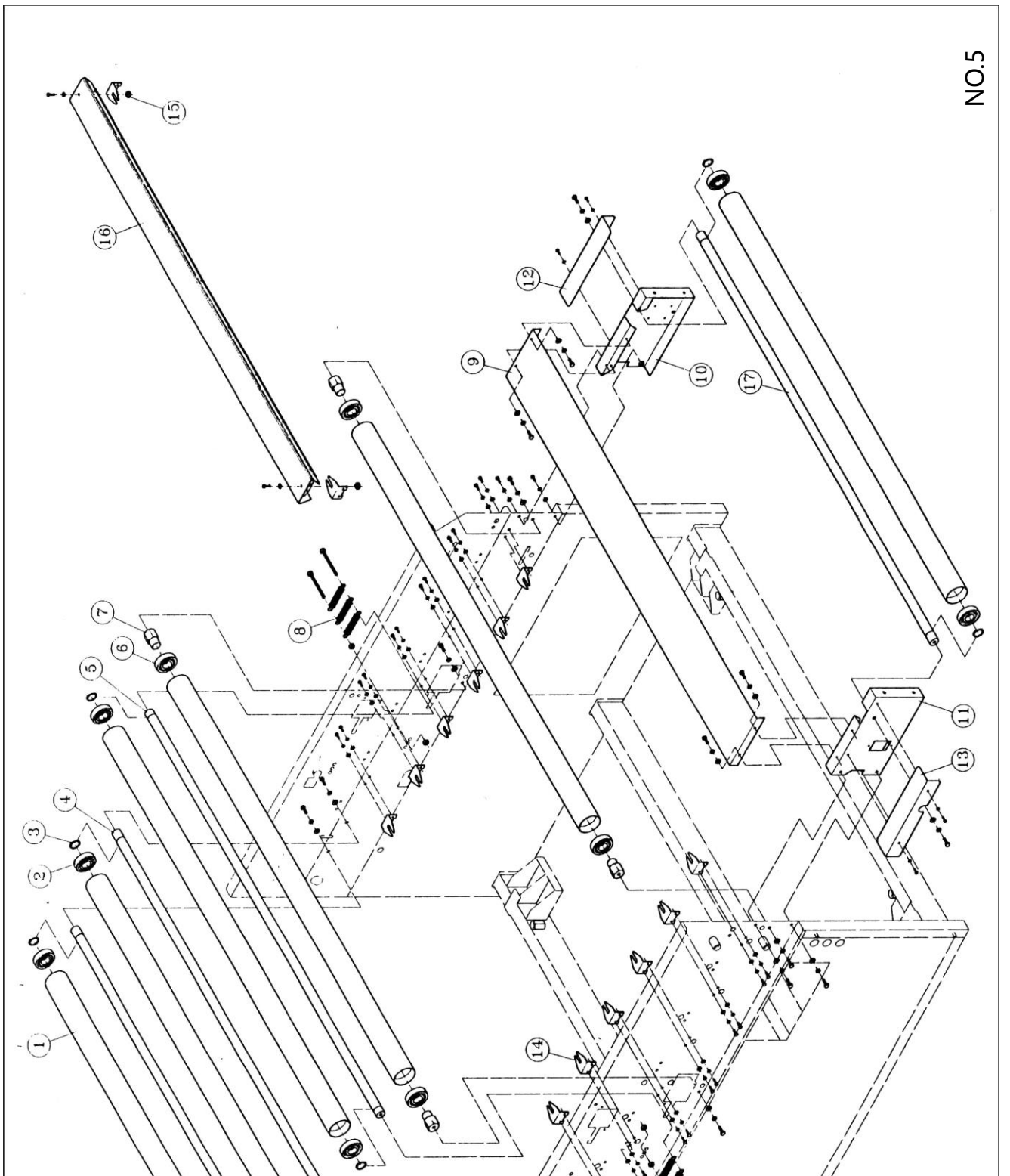
序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
1	1200A011	上盖板	Upper cover plate	3	
	1400A011	上盖板	Upper cover plate	3	
	1600A037	上盖板	Upper cover plate	3	
2	ZW0061	外盖把手	Cover handle	10	
3	1600A042	左护罩	Left protecting cover	1	
4	1600B137	上盖轴套	Upper cover axis	1	
5	1600A038	底座侧盖板	Side cover plate of bottom base	1	
6	1600A002	后上机台壁	Back upper machine board	1	
7	1600A003	后中机台壁	Back middle machine board	1	
8	1600A005	后下机台壁	Back lower machine board	1	
9	1600A018	遮板	Cover plate	1	
10	1200A016	封板	Plate	1	
	1400A016	封板	Plate	1	
	1600A053	封板	Plate	1	
11	JP2008	上皮帶 1200*3920	Upper belt	1	
	JP2011	上皮帶	Upper belt	1	
	JP2014	上皮帶	Upper belt	1	
12	JP2009	(1)下皮帶 1200*4500	Lower belt	1	For OP-1200
	JP2010	(2) 下皮帶 加長 1200*6350	Longer lower belt	1	For OP-1200L
	JP2012	(1)下皮帶 1400*4500	Lower belt	1	For OP-1400
	JP2013	(2) 下皮帶 加長 1400*6350	Longer lower belt	1	For OP-1400L
	JP2015	(1)下皮帶 1600*4500	Lower belt	1	For OP-1600
13	JP2016	(2) 下皮帶 加長 1600*6350	Longer lower belt	1	For OP-1600L
	1200A001	底架	Bottom shelf	1	
	1400A001	底架	Bottom shelf	1	
	1600A006	底架	Bottom shelf	1	
14	ZW0132	防中轮	Wheel	4	
15	1600A062	侧盖板	Side cover plate	1	
16	1600A059	封板	Plate	1	
17	1600A057	下侧盖	Lower side cover	1	

18	1600A058	后侧盖板	Back side cover plate	1	
19	1200A002	中间底架	Middle bottom shelf	1	
	1400A002	中间底架	Middle bottom shelf	1	
	1600A007	中间底架	Middle bottom shelf	1	
20	1600A004	前下机台壁	Front lower machine board	1	
21	1600A001	前上机台壁	Front upper machine board	1	
22	1200A016	封板	Cover plate	1	
	1400A016	封板	Cover plate	1	
	1600A053	封板	Cover plate	1	

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序號 Ref No	部件編號 Part No	部件名稱規格 Description		數量 Customer	備註 Remark
23	1200A014	橫梁	Beam	1	
	1400A014	橫梁	Beam	1	
	1600A050	橫梁	Beam	1	
24	1200A013	橫梁	Beam	1	
	1400A013	橫梁	Beam	1	
	1600A049	橫梁	Beam	1	
25	1200B007	軸心	Axis	3	
	1400B007	軸心	Axis	3	
	1600B113	軸心	Axis	3	
26	1200A016	封板	Cover plate	1	
	1400A016	封板	Cover plate	1	
	1600A130	封板	Cover plate	1	
27	1600A042	左護罩	Left protecting cover	1	

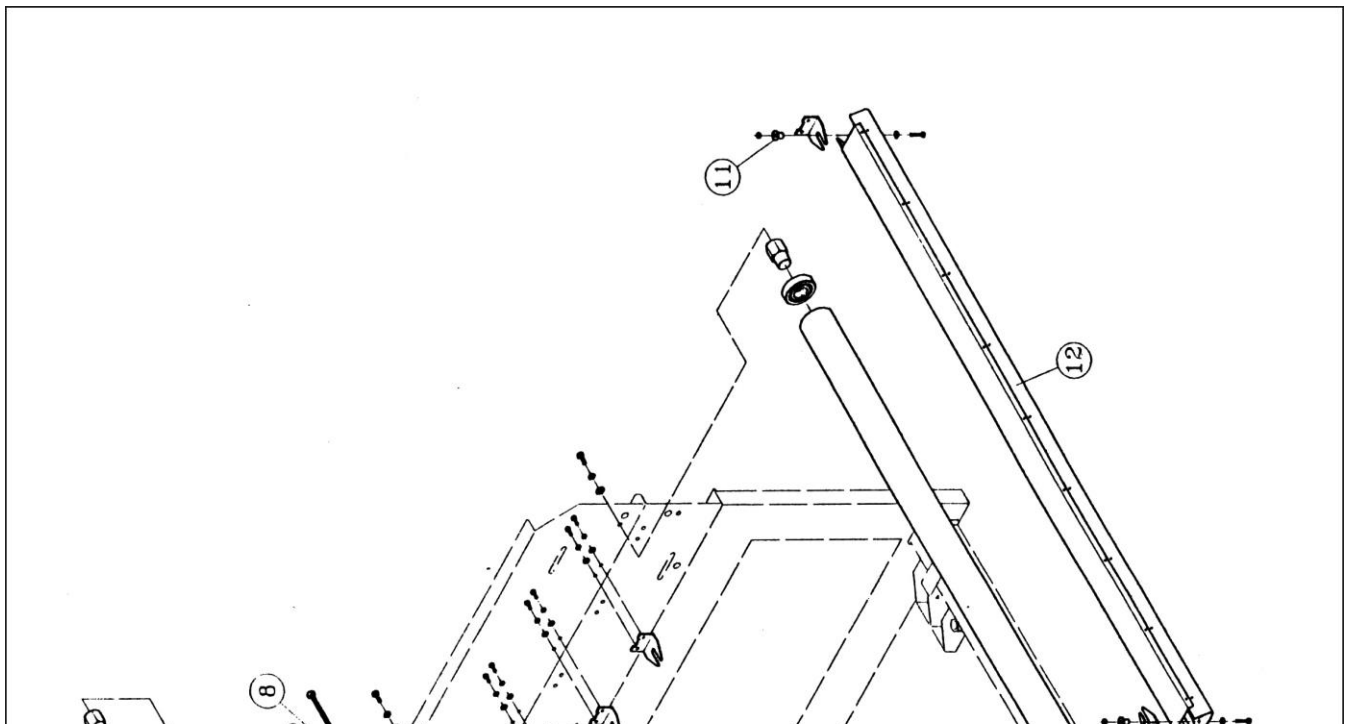


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NO: 5

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
1	1200B004	滾筒	roller	6	For OP-1200
	1400B004	滾筒	roller	6	For OP-1400
	1600B104	滾筒	roller	6	For OP-1600
2	JB2105	培林 6306C4	bearing	8	
3	JC1025	軸用彈性擋圈 $\phi 29$	flexible stopper for axis	8	
4	1200B007	車壁軸心	axis for main body	3	For OP-1200
	1400B007	車壁軸心	axis for main body	3	For OP-1400
	1600B107	車壁軸心	axis for main body	3	For OP-1600
5	1200B006	拉彈簧軸心	axis for spring	1	For OP-1200
	1400B006	拉彈簧軸心	axis for spring	1	For OP-1400
	1600B106	拉簧軸心	axis for spring	1	For OP-1600
6	JB2008	培林 1306	bearing	4	
7	2000B114	長軸銷	longer shaft	4	
8	JH2050	拉簧	spring	6	
9	1200A018	封板	coverd board	1	
	1400A018	封板	coverd board	1	
	1600A101	封板	coverd board	1	

10	1600A103	右端側板	right side board	1	
11	1600A102	左端側板	left side board	1	
12	1600A108	右端側封板	right side covered board	1	
13	1600A107	左端側封板	left side covered board	1	
14	1600A028	加熱器支座	supporting base for heater	12	
15	1600B136	下電熱片固定栓	fixer for lower heater	12	
16	1200B014	電熱座	heater base	6	For OP-1200
	1400B014	電熱座	heater base	6	For OP-1400
	1600B132	電熱座	heater base	6	For OP-1600
17	1200B005	入料軸心	axis for feeding	1	For OP-1200
	1400B005	入料軸心	axis for feeding	1	For OP-1400
	1600B105	入料軸心	axis for feeding	1	For OP-1600



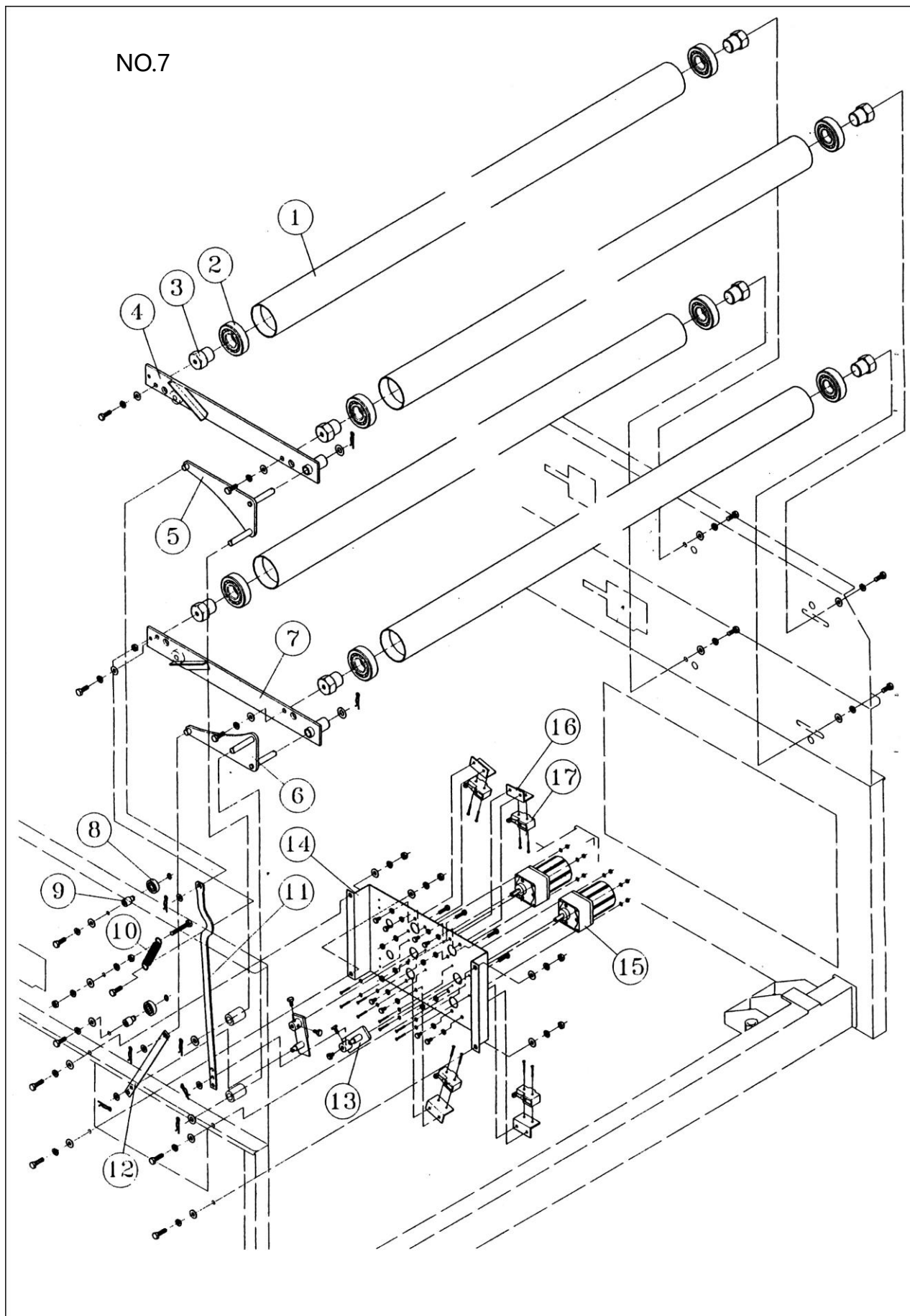
機械零件目錄 Part list

NO: 6

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
1	1200B010	滾筒	roller	4	For OP-1200
	1400B010	滾筒	roller	4	For OP-1400
	1600B104	滾筒	roller	4	For OP-1600
2	JB2105	培林 6306C4	bearing	4	
3	JC1025	軸用彈性擋圈 $\varphi 29$	flexible stopper for axis	4	
4	1200B007	車壁軸心	axis for main body	1	For OP-1200
	1400B013	車壁軸心	axis for main body	1	For OP-1400
	1600B107	車壁軸心	axis for main body	1	For OP-1600
5	1200B006	拉簧軸心	axis for spring	1	For OP-1200
	1400B006	拉簧軸心	axis for spring	1	For OP-1400
	1600B106	拉簧軸心	axis for spring	1	For OP-1600
6	1600B114	長軸銷	longer shaft	4	
7	JB2008	培林 1306	bearing	4	
8	JH2050	拉簧	spring	6	

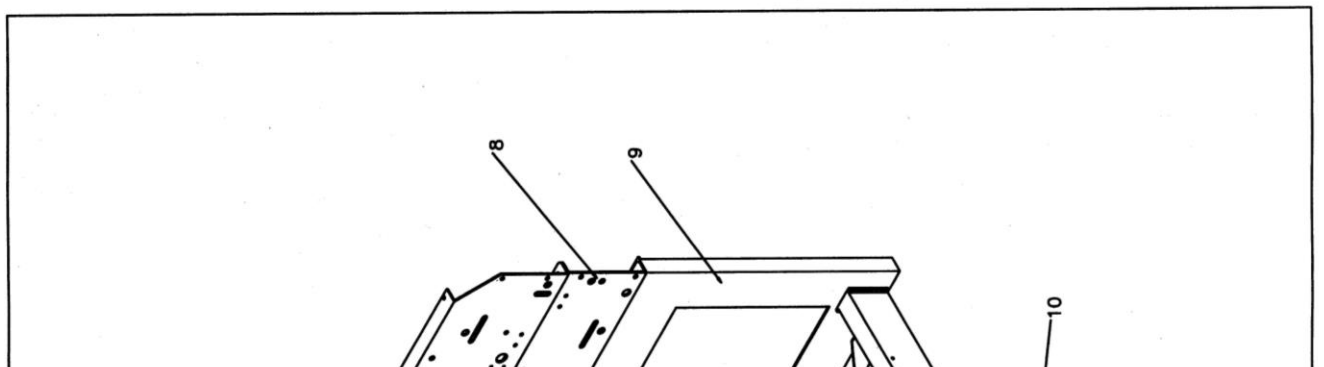
9	1600A067	調整杆	adjusted rod	2	
10	1600A028	加熱器支座	supporing base for heater	12	
11	1600B135	上電熱片固定栓	fixer for upper heater	12	
12	1200B014	電熱器座	heater base	6	For OP-1200
	1400B014	電熱器座	heater base	6	For OP-1400
	1600B132	電熱器座	heater base	6	For OP-1600

NO.7



機械零件目錄 Part list

序號	部件編號	部件名稱規格		數量	備註
Ref No	Part No	Description		Customer	Remark
1	1200B010	滾筒	roller for main body	4	For OP-1200
	1400B010	主體滾筒	roller for main body	4	For OP-1400
	1600B104	主體滾筒	roller for main body	4	For OP-1600
2	JB2008	培林 1306	bearing	8	
3	2000B115	短軸銷	shorter shaft	6	
4	1600A032	左軌道	left rail	1	
5	1600A043	上修下臂	upper modified lower arm	1	
6	1600A044	下修正臂	lower modified arm	1	
7	1600A033	右軌道	right rail	1	
8	JB2012	培林	beaing	2	
9	1600B121	培林軸銷	bearing shaft	1	
10	JH2050	拉簧	spring	1	
11	1600A066	拉板(3)	Pull the plank	1	
12	1600A040	拉板(2)	Pull the plank	1	
13	1600A035	卡板	board	2	
14	1600A022	馬達座	motor base	1	
15	DM0101-1	馬達 M6RX6G4GGA	motor	2	DM0301-1 減速機
16	1600A025	固定耳	fixer	4	
17	DK0107	微動開關 Z15G1704	micro switch	4	



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NO.8

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
1	1200B009	驱动滚筒	driving roller	1	
	1400B009	驱动滚筒	driving roller	1	
	1600B109	驱动滚筒	driving roller	1	
2	1200B008	驱动滚筒	driving roller	1	
	1400B008	驱动滚筒	driving roller	1	
	1600B108	驱动滚筒	driving roller	1	
3	1600B138	轴承座	bearing base	1	
4	JB2104	培林 6305C4	bearing	4	
5	1600A016	垫片	washer	2	
6	1600A002	后上机台壁	back upper machine body	1	
7	1600A052	支座固定块	fixed block for supporting base	2	
8	1600A003	后中机台壁	back middle machine body	1	
9	1600A005	后下机台壁	back lower machine body	1	

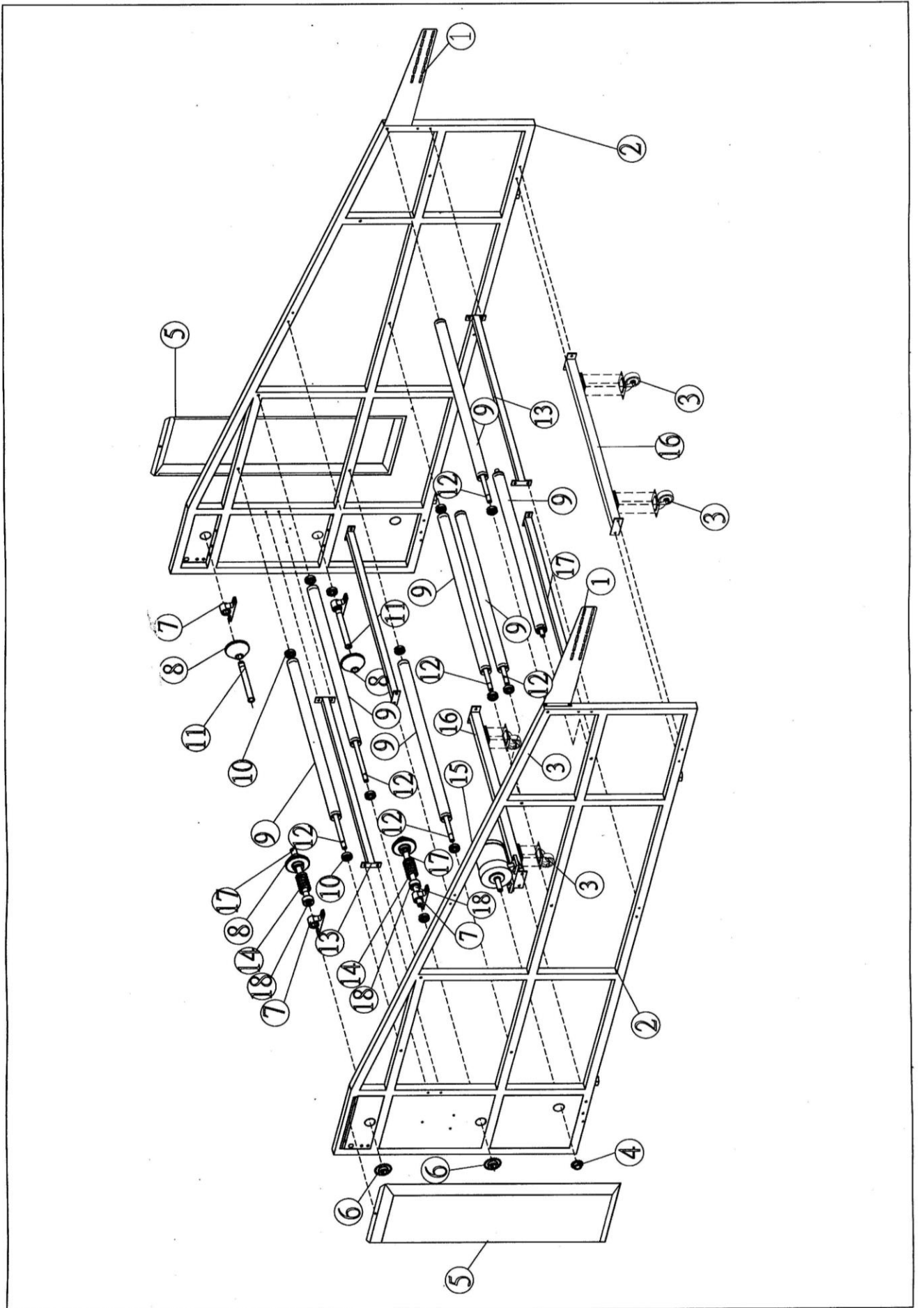
10	1200A001	底梁	bottom girder	2	For OP-1200
	1400A001	底梁	bottom girder	2	For OP-1400
	1600A006	底梁	bottom girder	2	For OP-1600
11	1200A002	中間底梁	middle bottom girder	1	For OP-1200
	1400A002	中間底梁	middle bottom girder	1	For OP-1400
	1600A007	中間底梁	middle bottom girder	1	For OP-1600
12	1200A001	底梁	bottom girder	2	For OP-1200
	1400A001	底梁	bottom girder	2	For OP-1400
	1600A006	底梁	bottom girder	2	For OP-1600
13	1600B116	轴承座	bearing base	2	
14	JB2104	培林 6305C4	bearing	4	
15	1600A078	垫片 2	washer	1	
16	1600A082	左摇杆	Left joystick	1	
17	1600B117	导轨	rail	1	
18	1600A080	垫片 4	washer	1	
19	1600A083	右摇杆	Right joystick	1	
20	JB1012	鱼眼轴承	bearing	2	
21	QG0013	气缸	cylinder	2	
22	1600A014	气缸固定座	fixed base for cylinder	2	
23	1600A004	前下机台壁	front lower machine body	1	
24	1600A001	前上机台壁	front upper machine body	1	
25	1600A064	马达座	motor base	1	
26	2000B338	马达齿轮	motor gear	1	
27	2000B341	惰轮	idle wheel	1	
28	JL1003	链条	chain	1	
29	JB2018	轴承	beaing	3	

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NO.8-1

序號	部件編號	部件名稱規格		數量	備註
Ref No	Parst No	Description		Customer	Remark
30	1600B147	惰轮	idle wheel	1	
31	DM0113	马达	motor	1	
32	1600B167	拨片链轮	chain wheel for scraper	1	
33	1600B164	拨片主传动座 2	base for scraper	1	

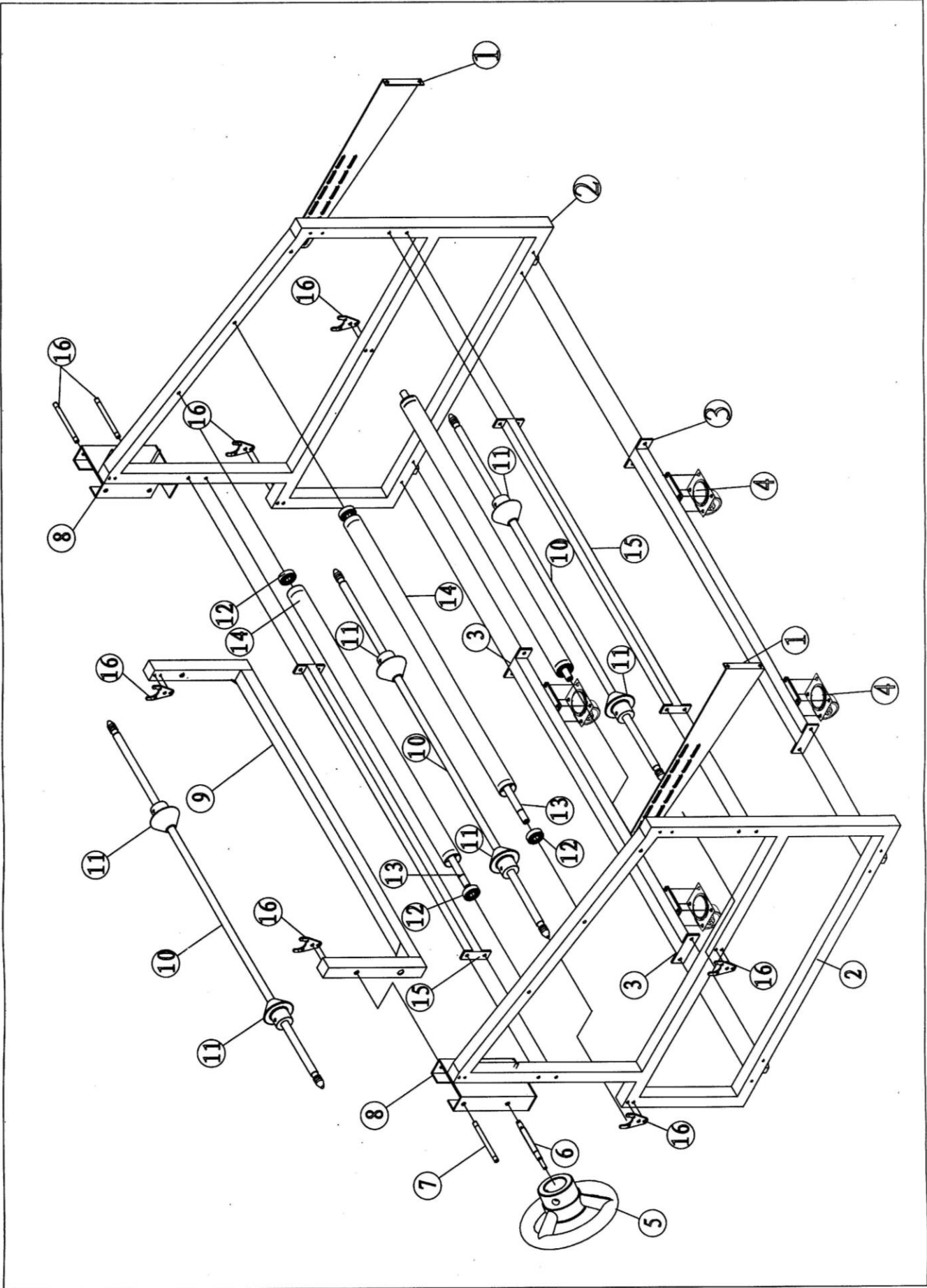
34	1600B163	拨片主传动座 1	base for scraper	1	
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机械零件目录 Part list

NO.9

序号	部件编号	部件名称规格		数量	备注
Ref No	Parst No	Description		Customer	Remark
1	900TA001	连接片	Connect plate	4	
2	900TA005	后侧架	Back side frame	2	
3	ZW0130	肥仔轮 45X75 Φ8	Wheel	8	
4	900TB007	拉簧钩	Spring clasp	6	
5	900TA006	后侧盖	Back side frame	2	
6	900TB003	链轮	Chain wheel	2	
7	900TB009	培林座	Bearing stand	4	
8	900TB006	活动挡块	Activity blocks the piece	6	
9	1600TB003	连接架	Connect frame	1	
10	JB2021	培林	Bearing	20	
11	1600TB004	滚轴	Roller axes	4	
12	1600TB003	滚筒	Roller	10	
13	1600TA002	机身横梁	Body beam	8	
14	JH1051-1	压簧 Φ3.0X Φ32X70L	Spring	8	
15	DM0112-1	主马达 1/4 1:30	Main motor	1	
16	1600TA001	底梁	Bottom beam	4	
17	1600TB005	滚轴	Roller axes	2	
18	900TB008	活动挡块	Active baffle	2	

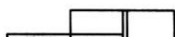


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NO.10

序号	部件编号	部件名称规格		数量	备注
Ref No	Parst No	Description		Customer	Remark
1	900TA001	连接片	Connect plate	4	
2	900TA002	前侧架	Front side frame	8	
3	1600TA001	底梁	Bottom beam	4	
4	ZW0130	肥仔输 45X75 Φ8	Wheel	8	
5	90LDB042	手轮	Hand wheel	1	
6	900TB015	螺杆	Screw	1	
7	900TB013	短轴	Short axes	3	
8	900TA009	固定块	Fixed plate	2	
9	1600TA003	滚筒	Roller	4	
10	1600TB001	穿布杆	Cloth beam	3	
11	900TB002	活动挡块	Active baffle	6	
12	JB2021	培林 6204	Bearing	20	
13	1600TB002	主体轴芯	Body axes core	10	
14	1600TB004	滚轴	Roller axes	4	
15	1600TA002	机身横梁	Body beam	8	
16	900TA004	Y 型铁	Y swage	6	

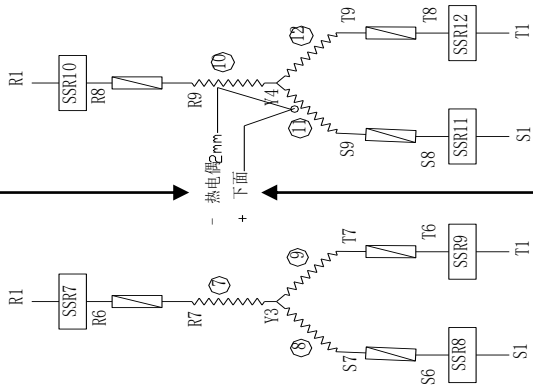
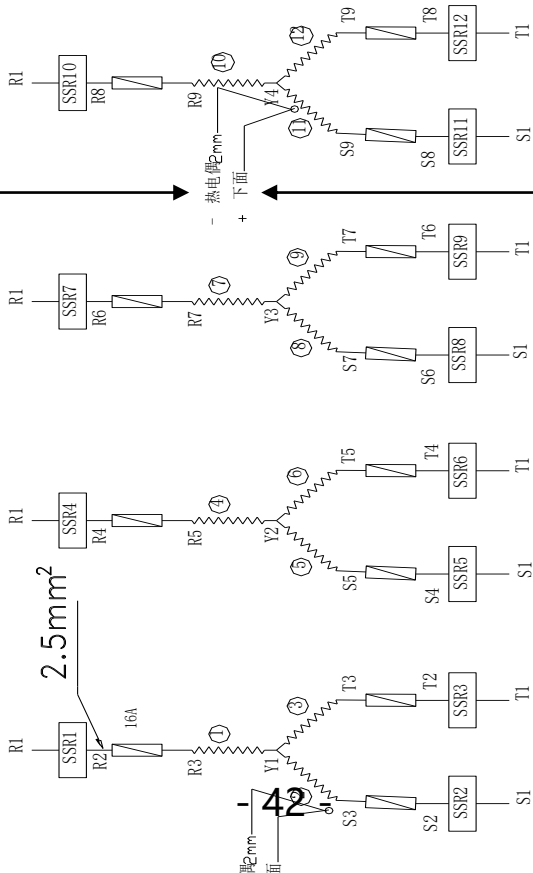
cylinder
氣缸 SC50*50



电源线规格: 3*10mm + 1*6mm
specification for power circuit

The temperature responds the line

air released valve



cylinder

Underneath

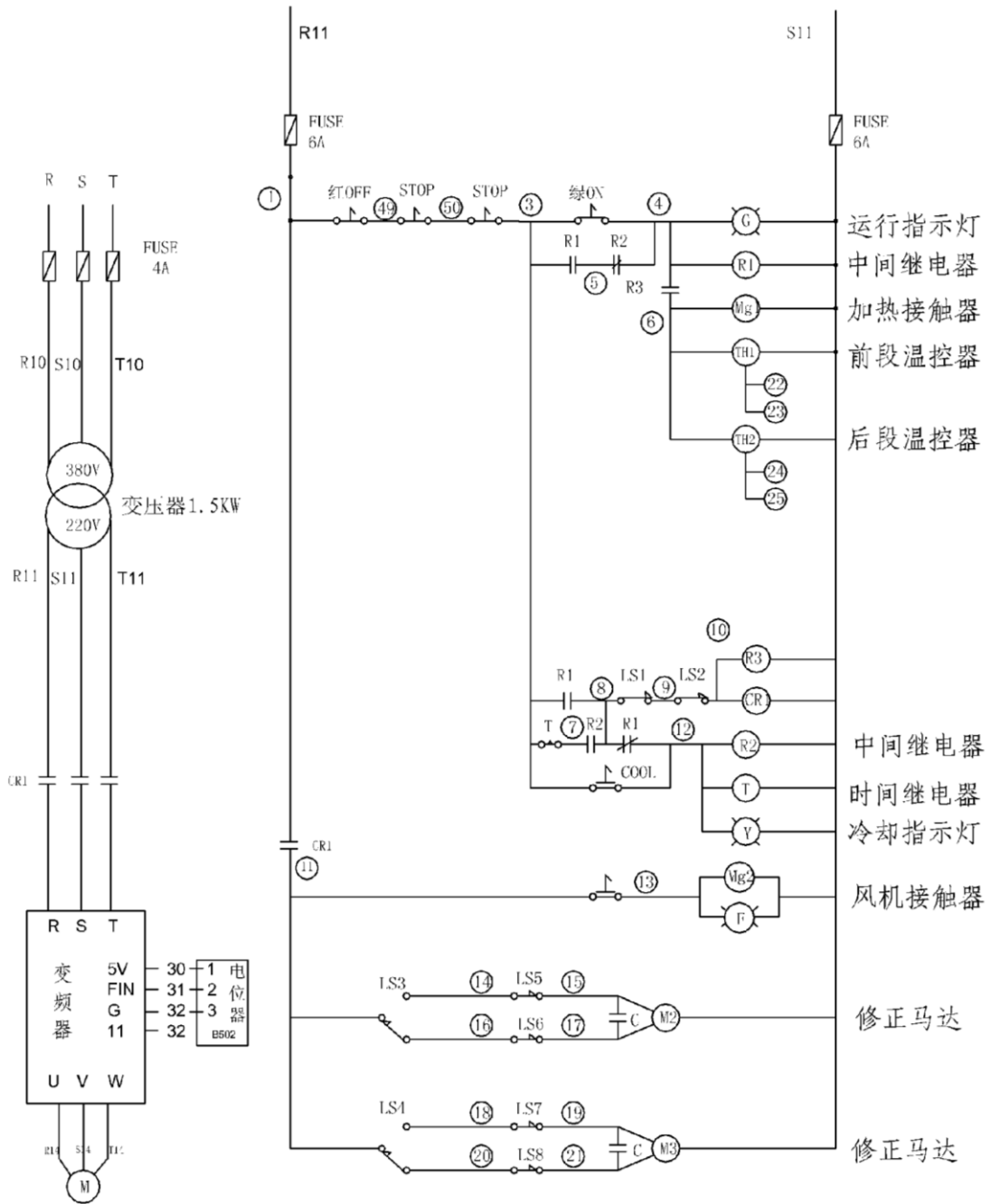
start for air connection connection

Combination

pressure released valve

电路原理图1
circuit drawing 1

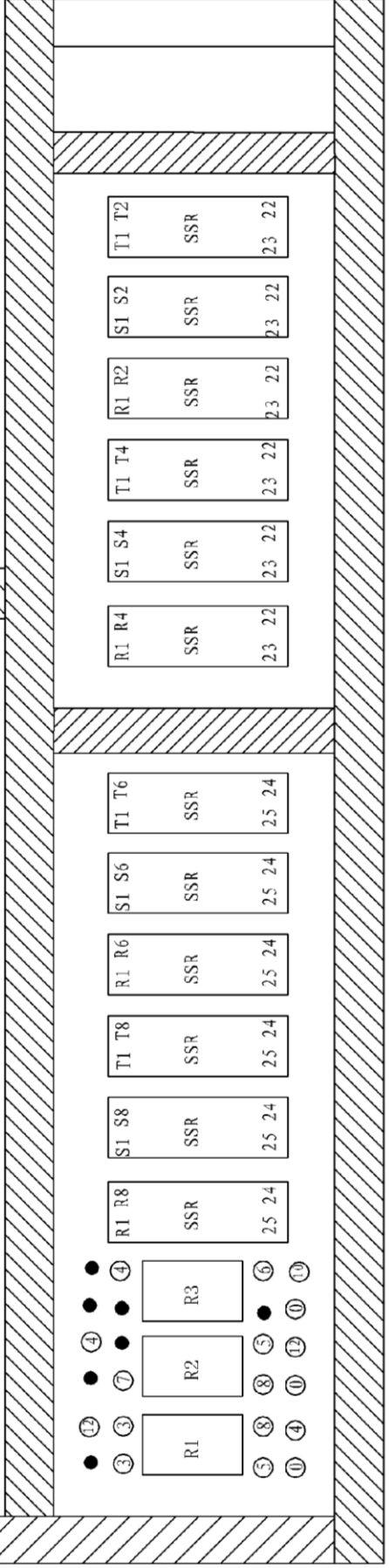
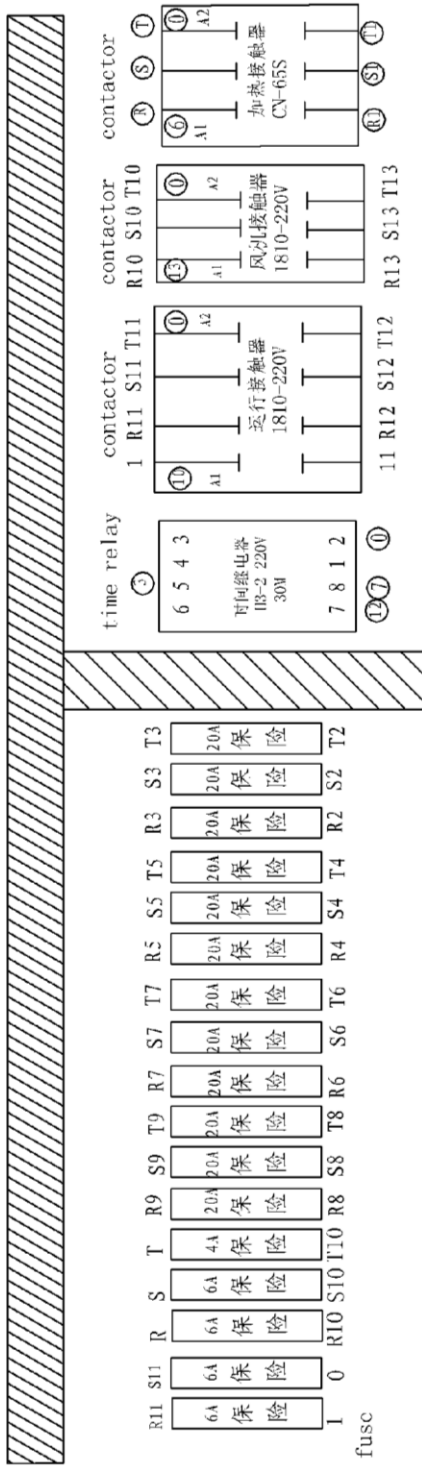
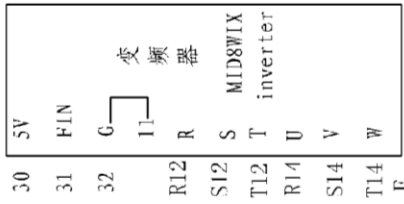
Drum



电路原理图2

R9 N4 S9 N4 T9 N4 R7 N3 S7 N3 T7 N3 R5 N2 S5 N2 T5 N2 R3 N1 S3 N1 T3 N1 R1 Q S10 T10 R1 S11 T11 E
 0 1 3 4 6 7 8 9 10 11 12 13 22 23 24 25 30 31 32 11 1 49 50
 15A 21位 location

30 30位 location



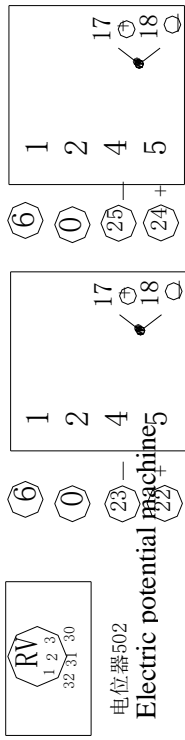
position diagram

位置图3

Behind temperature controller

后段温控

Front temperature 前段温控



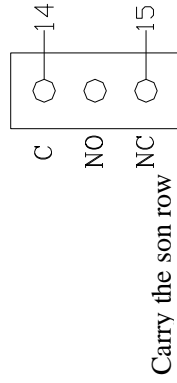
运行开关 working switch
冷却开关 Cool switch
风机开关 fan switch
停止开关 stop switch

Front-panel position diagram 4

0 1 3 4 6 11 12 13 22 23 24 25 30 31 32 49

面板位置图4

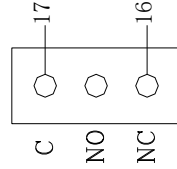
端子排 20P 15A



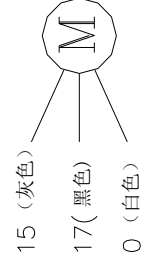
LS5 switch 微动开关



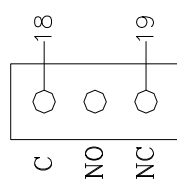
Electric capacity



LS6 switch 微动开关



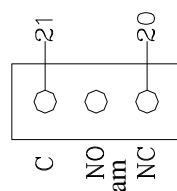
Motor 马达



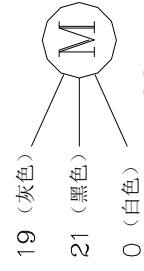
LS3 switch 微动开关



Electric capacity



LS4 switch 微动开关



Motor 马达

Revise the position diagram

修正位置图5

隨機工具及附件一覽表

THE ATTACHED TOOLS AND FORMS

型及名稱 Model and Name		低溫連續式粘合機 CONTINUOUS FUSING PRESS MACHINE			
序號 REF NO	部件編碼 The parts codes	部件名稱規格 Parts specification		數量 Q'ty	備註 REMARK
1	JG1067	5 內六角扳手	hexagon spanner	1	
2	JG1068	6 內六角扳手	hexagon spanner	1	
3	JG1016	8X10 開口扳手	spanner	1	
4	JG1018	12X14 開口扳手	spanner	1	
5	JG1019	17X19 開口扳手	spanner	1	
6	JG1081	17#套筒 T 型扳手	spanner	1	
7	JG4008	水準尺 DP-S93B	ruler	1	
8	JG6058	螺絲刀(兩用)150mm	screw knife	1	
9	ZH0019	皮帶清潔劑	belt cleaner	1	
10	DF0306	RT14-20 保險管 6A	fuse	2	
11	DF0308	RT14-20 保險管 16A	fuse	12	
12	ZA1005	說明書	manual	1	
13	ZW0132	工具袋	tool bag	1	
14	JG6365	風槍	Breeze gun	1	
15	QH0106-1	氣管 Φ8*6M	Windpipe	1	