

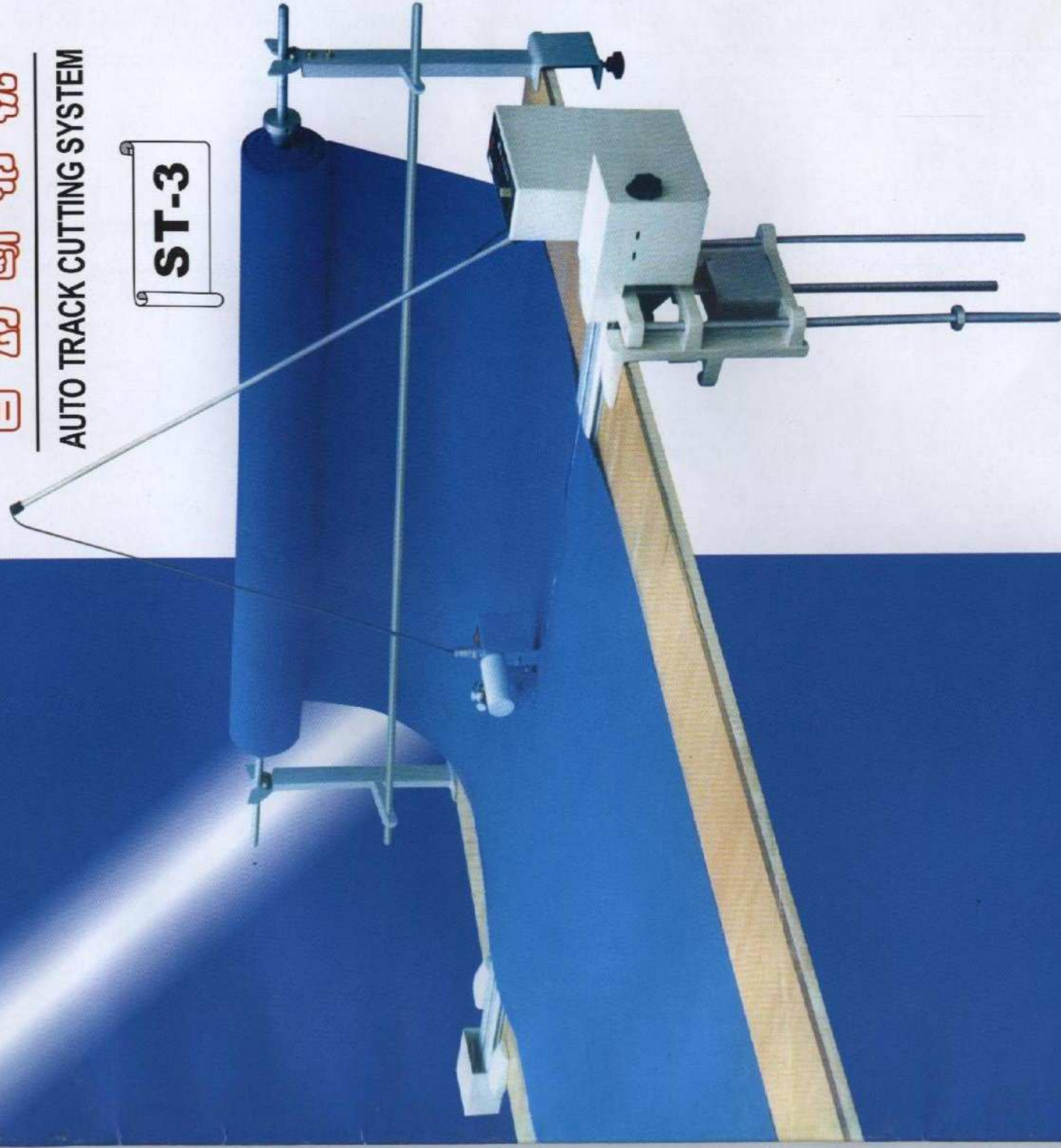
MANUAL PARTS BOOK
使用说明书



自动断布机

AUTO TRACK CUTTING SYSTEM

ST-3

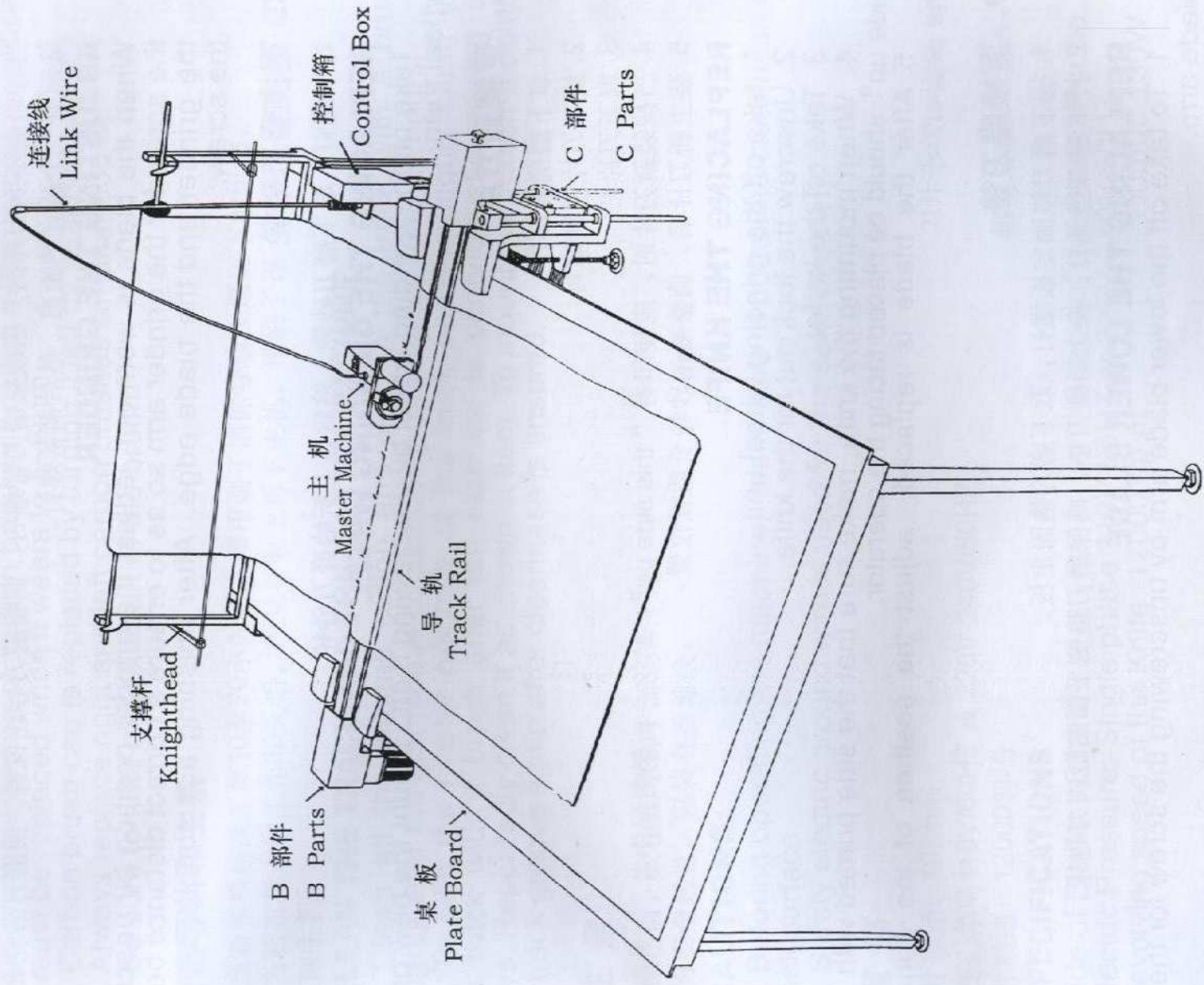


大洋衣车有限公司
DAYANG SEWING MACHINE CO., LTD.

Auto Track Cutting System

自动断布机

ST-3



检 查

CHECKING

A. 调整磨刀砂轮

当砂轮磨不到刀片时，应放松磨刀臂螺钉，调整磨刀砂轮位置，使磨刀砂轮和刀片边缘间有一个适宜的距离，然后锁紧螺钉。

ADJUSTING THE GRINDER

When the blade is worn out, adjust the grinder position by unscrewing the screw for the grinder arm so as to ensure a correct distance between the grinder and the blade edge. After finishing adjustment, screw up the screw.

B. 更换磨刀砂轮

拧下螺钉，取下磨刀砂轮，然后装上新的磨刀砂轮。

REPLACING THE GRINDING WHEEL

Take off the grinding wheel by unscrewing it off. Mount the new grinding wheel then.

C. 更换圆刀片

1. 拿下磨削轮部件。
2. 旋下刀片锁紧螺母。
3. 取下刀片。
4. 当按装新刀片时，应使印有“this side up”的这一面朝向操作者。
5. 装上新刀片后，调整磨削砂轮至适宜位置。

REPLACING THE KNIFE

1. take off the grinding wheel unit.
2. Unscrew the lock nut for the knife.
3. Take off the knife.
4. When mounting the knife, make sure that the side printed with “this side up” should be placed facing the operator.
5. After the blade is replaced, adjust the position of the grinder at the proper.

D. 更换磨刀垫

1. 旋下磨刀垫固定板螺钉，取下磨刀垫固定板。
2. 拧下磨刀垫螺钉，换上新磨刀垫，确保磨刀垫侧平面贴近圆刀边缘。

REPLACING THE LOWER BLADE

1. To take off the lower blade arm by unscrewing the screw for the lower blade arm.
2. Replacing the lower blade by unscrewing the fixed screw. Replace the lower blade and ensured the flat surface of the lower blade adjacent to the blade edge.

E. 更换碳刷

1. 碳刷的磨损会引起电机的故障，当碳刷磨得只剩下5至6mm时，必须更换碳刷。
2. 用螺丝刀旋下碳刷螺母，更换碳刷。
3. 须同时更换左右碳刷。
4. 更换时，接线弹簧须钩住碳刷壳金属部件。

REPLACE OF CARBON BRUSH

1. Too much weaving of carbon brush will cause motor troubles. Carbon brush must be replaced when it wears to 5~6mm.
2. Carbon brush cap is replaced by turning it left by attached wrench.
3. Always replace right and left carbon brushes simultaneously.
4. Be sure to hold metallic part of the brush.

F. 清洁导轨和主机

1. 当断布机连续工作10至20小时后，须用刷子清除导轨上遗留下的织物。
2. 当断布机连续工作30天后，须从导轨上拆下主机，用刷子逐一清洁各导轨槽，清洁后，装回主机。

CLEAN THE TRACK AND THE MASTER MACHINE

1. Clean all the wasted cotton and cloth in the track with a brush thoroughly after the machine is continuously running for 10 to 20 hours.
2. To take the master machine of the track and thoroughly clean the L-type track with a brush after the machine is continuously running for 30 days. Repeatedly clean it as shown in Item. To mount the master machine in the track groove again after cleanness is ensured.

G. 注意:

1. 操作前，应检查导轨平面是否干净。
2. 为安全起见，应装有接地线。

CAUTIONS:

1. Before operating the machine, make sure of complete cleanness of the track surface.
2. Safety electric ground wire is used for the sake of safety.

H. 规格:

刀片直径: 108mm
电压: 单向110V/60HZ 或 220V-240V/50HZ
刀片转速: 12000转/分

刀片形状: 圆形

输出功率: 130W

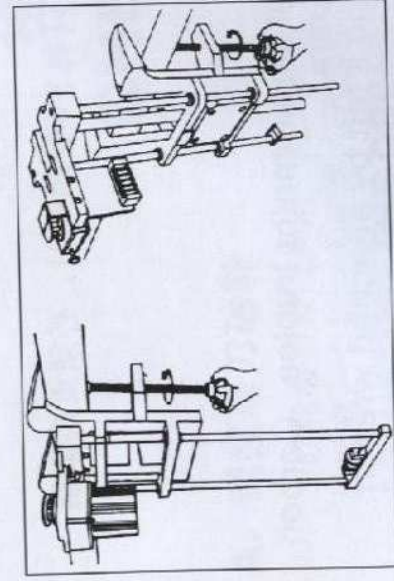
SPECIFICATIONS

Side of Blade: 108mm

Shape of the Blade: Round
Electric Pressure: Single phase 110V/60HZ or 220V-240V/50HZ

Revolving speed of the Knife: 12000 r.p.m

Output: 130W



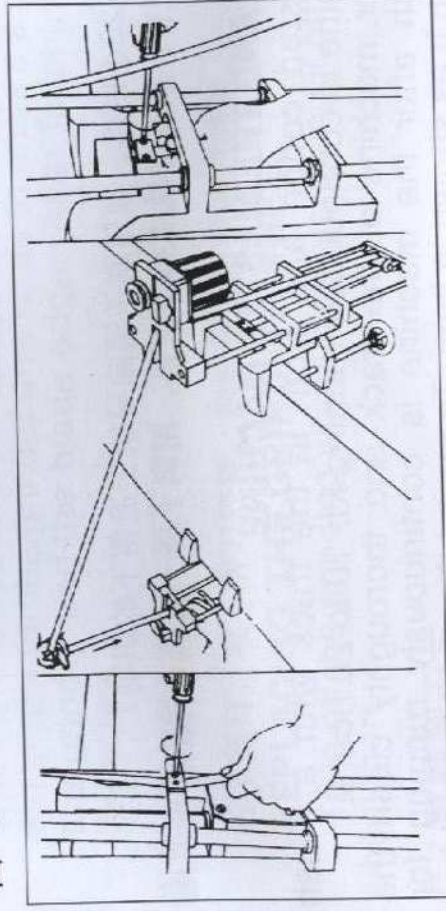
1 当支架位置正确后，应按左图所示旋紧手柄夹紧桌板。

◆ 注意：
装在支承轴下端的限位开关必须朝着正确的方向。

After turning the handle to the right, fix clamp on the plate board.

◆ Caution
Limit switch that is installed below the track in the control box should be always placed to the direction of polishing.

图 1



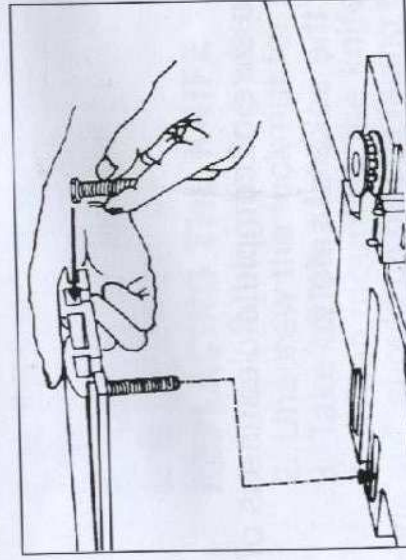
2 按图示方法，当悬挂

好带后，应在保持带水平下将带的两端用压板压紧。

Brake & reverse area

After hanging poly belt (green belt) on the reverse area, it should be fixed by holding the ends of both horizon to link with brake area as can be shown in the side picture.

图 2



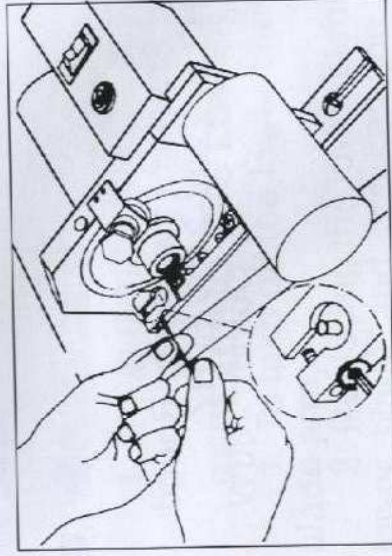
3 正确放置好铝导轨，然后按图示方向装上六角螺栓。

◆ 注意：
装六角螺栓时，你应同时装上垫圈和六角螺母。

Put aluminum track normally on both sides, then hang the hexagonal track bolt to the direction of the picture.

◆ Caution
Hanging the hexagonal track bolt, you should just hang nuts for washer without inserting.

图 3



4 当正确装好主机后，应放松底板上的紧定螺钉。见图。

After putting knife box in normal way, release the 2.0mm range bolt to the left side.

图 4

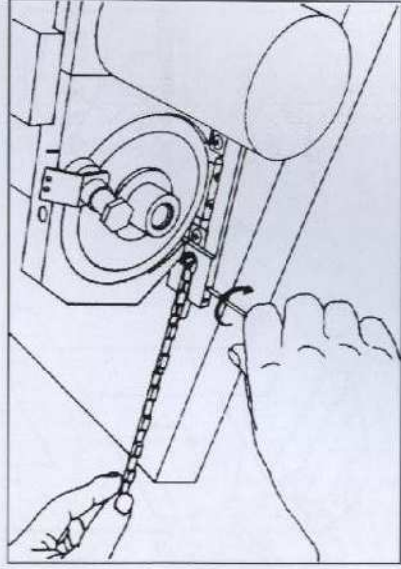


图 5

5 把同步带弯成U形套在弹簧销上，再锁紧固定螺钉。

Using range 2.0mm, the black belt should be fastened to the right with U-type pen.

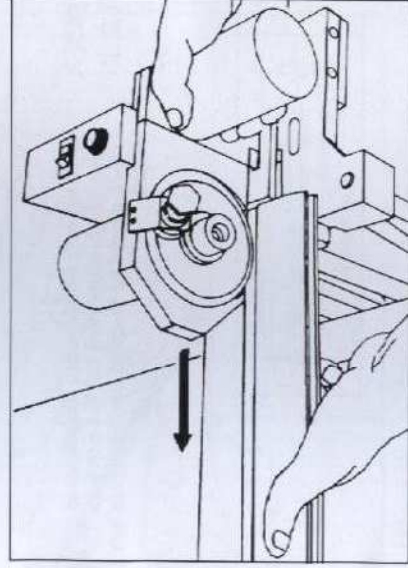


图 6

6 按图示方向，将主机装入导轨。

Front area of knife box should be headed for reverse side to put into the track.

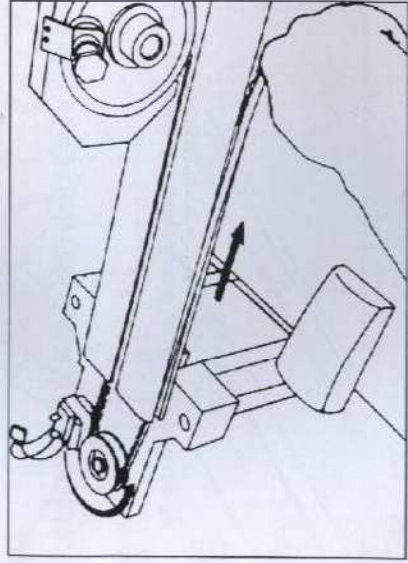


图 7

7 按住主机，把同步带绕过同步带轮，再引入铝导轨的凹槽。

- ◆ 注意：
不应扭转同步带。

In the state of standstill of aluminum box, you should hold on gear belt to turn to the reverse side, pushing the gear belt into the groove on the side of aluminum track.

- ◆ Caution
Be careful not to the gear belt get twisted.

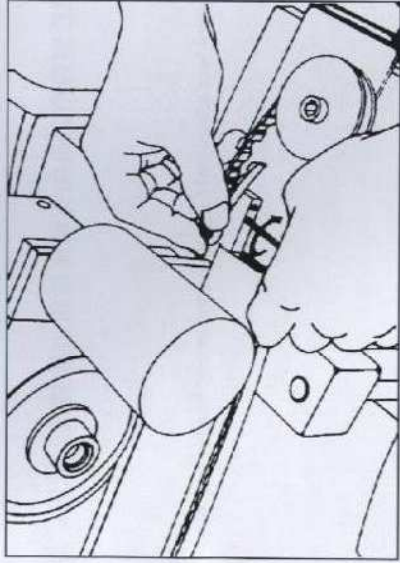


图 8

8 把绕回的同步带连接到地板的另一端后，再锁紧固定螺钉。

- ◆ 注意：
多余的同步带应用剪刀剪掉。

Fasten the inserted gear belt on the back part of knife box, using the 2.0mm range, after linking with timing pulley on the brake area.

- ◆ Caution
The remained gear belt should be cut out with scissors.

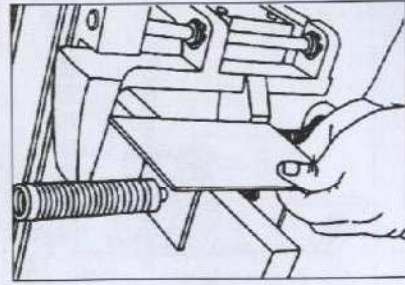


图 9

9 放上电线支架后，应旋紧手柄，夹紧桌板。

After put the wire supporting right, fix clamp the plate board.

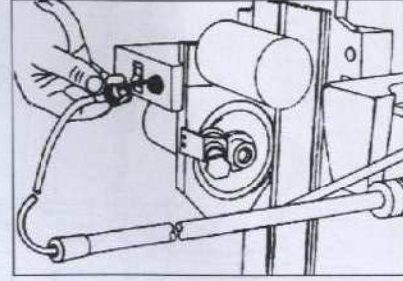


图 10

10 把电线装入按装空芯管的弹簧入口，再把3线插座插入主机盒上的3线插口。

Insert antenna suitably into the entrance of spring of the supporting bar for antenna. 3p jack should be inserted into the knife box 3p jack.

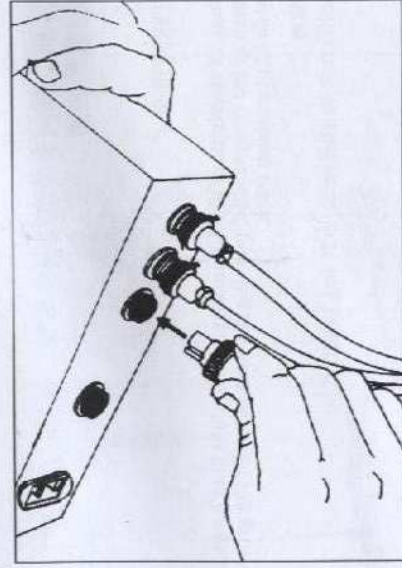


图 11

11 电线底端的3线插口应与控制箱底端的3线插口连接。

3p jack of bottom area of antenna should be inserted into the 3p jack of left area of control box.

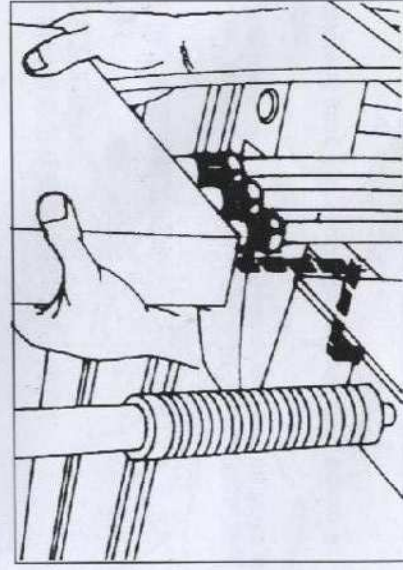


图 12

12 把控制箱沿着电线支承座后板边缘装入。见图。

Put control box adequately into the supporting bar for antenna.

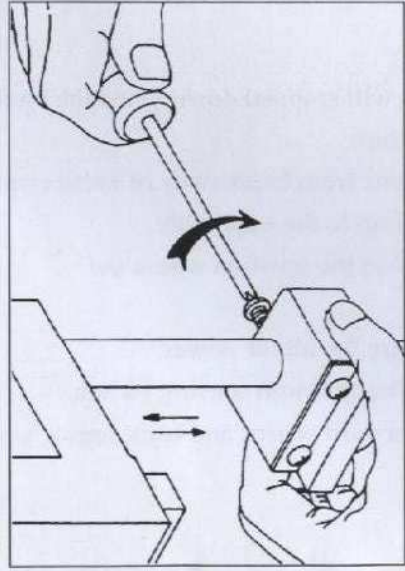


图 13

13 调节高度

假如你要调高升降高度，你应松开感应器上的紧固螺钉，把感应器调得更低。相反，你应调高感应器。

Function for regulation of height.

If you release bolt for regulation devices of height that is placed on low part of the left of brake area, up-and-down operation of track would be lower, but if you lower the regulation devices, the up-and-down operation of track would be higher.

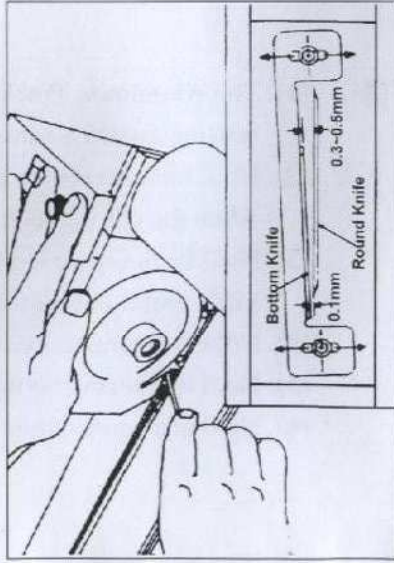


图 14

14 调节磨刀垫

当磨刀垫和旋转圆刀的间隙变得越来越大时，你应该重新调整磨刀垫，使间隙在图示范围内，从而使机器断布更完美。

When the interval between fixed bottom and rotation round knife becomes bigger, you should regulate the knife by using range to make enable perfect cutting.

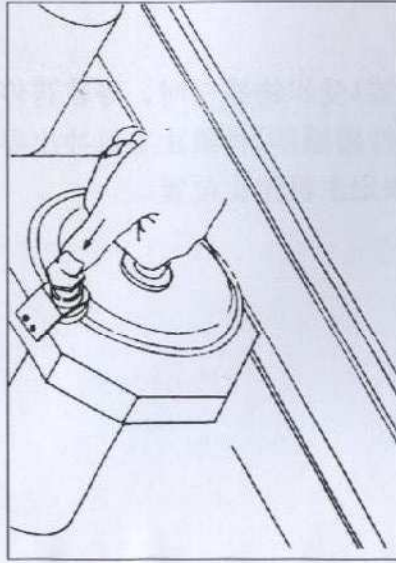


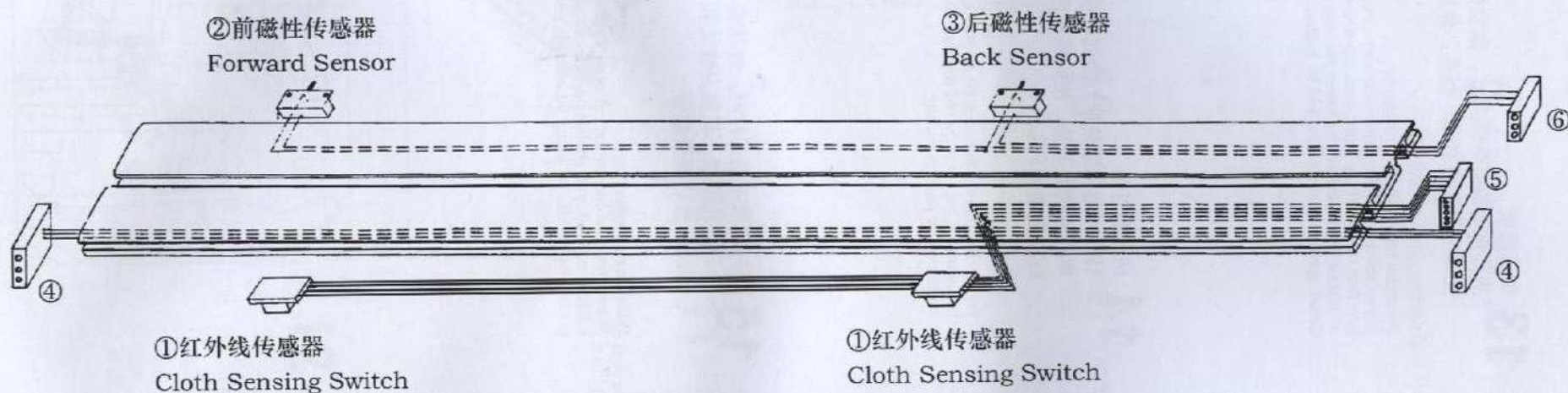
图 15

15 当砂轮磨不到刀片时，应放松磨刀臂螺钉，调整磨刀砂轮位置，使磨刀砂轮和刀片边缘间有个适宜的距，然后锁紧螺钉。

Polishing of round knife

When material can not be cut suitably or polishing of rotating round knife is needed, you should operate on/off switch of knife box to press 2 or 3 times by using the outside parts of grindstone.

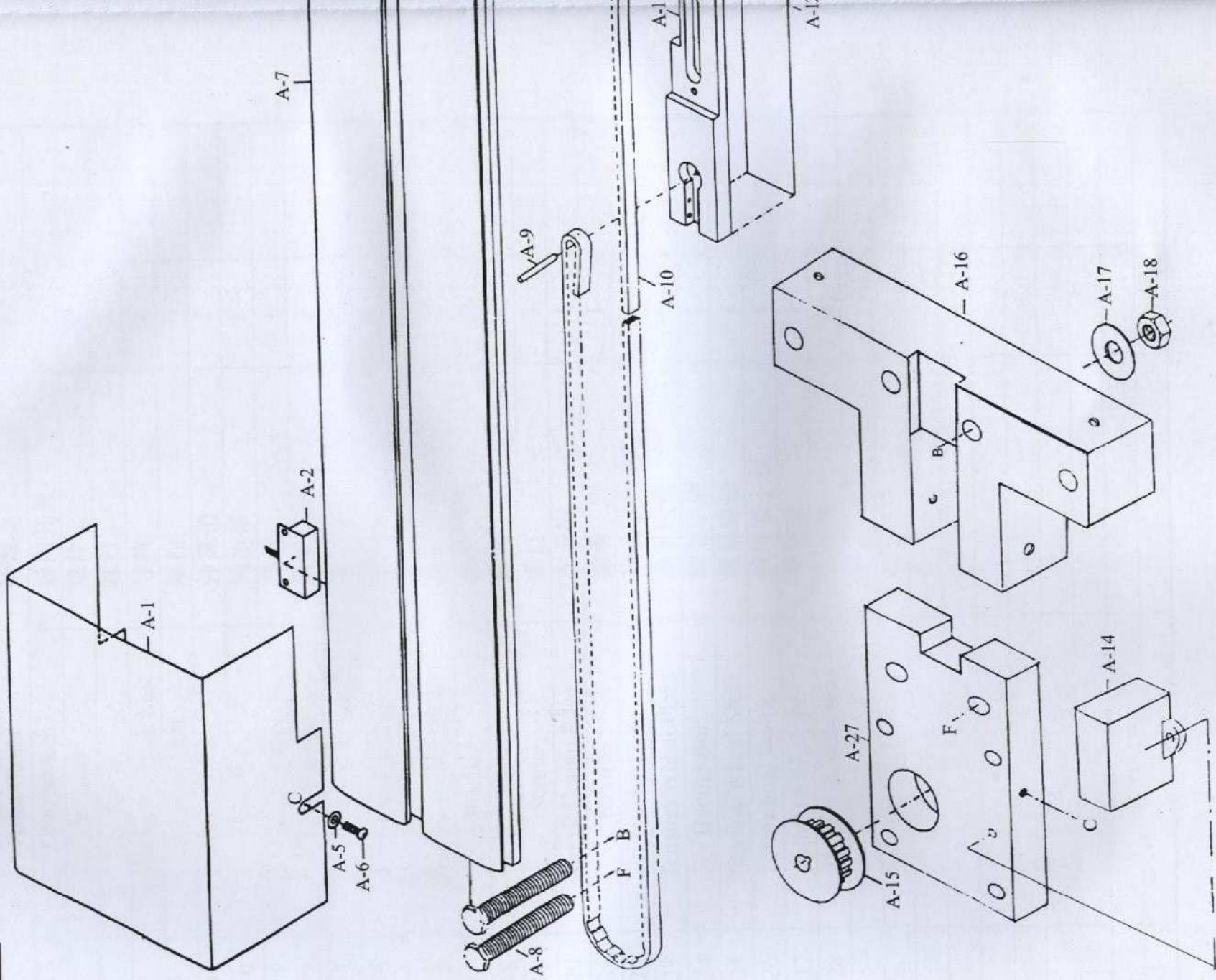
接线图解/WIRING DIAGRAM



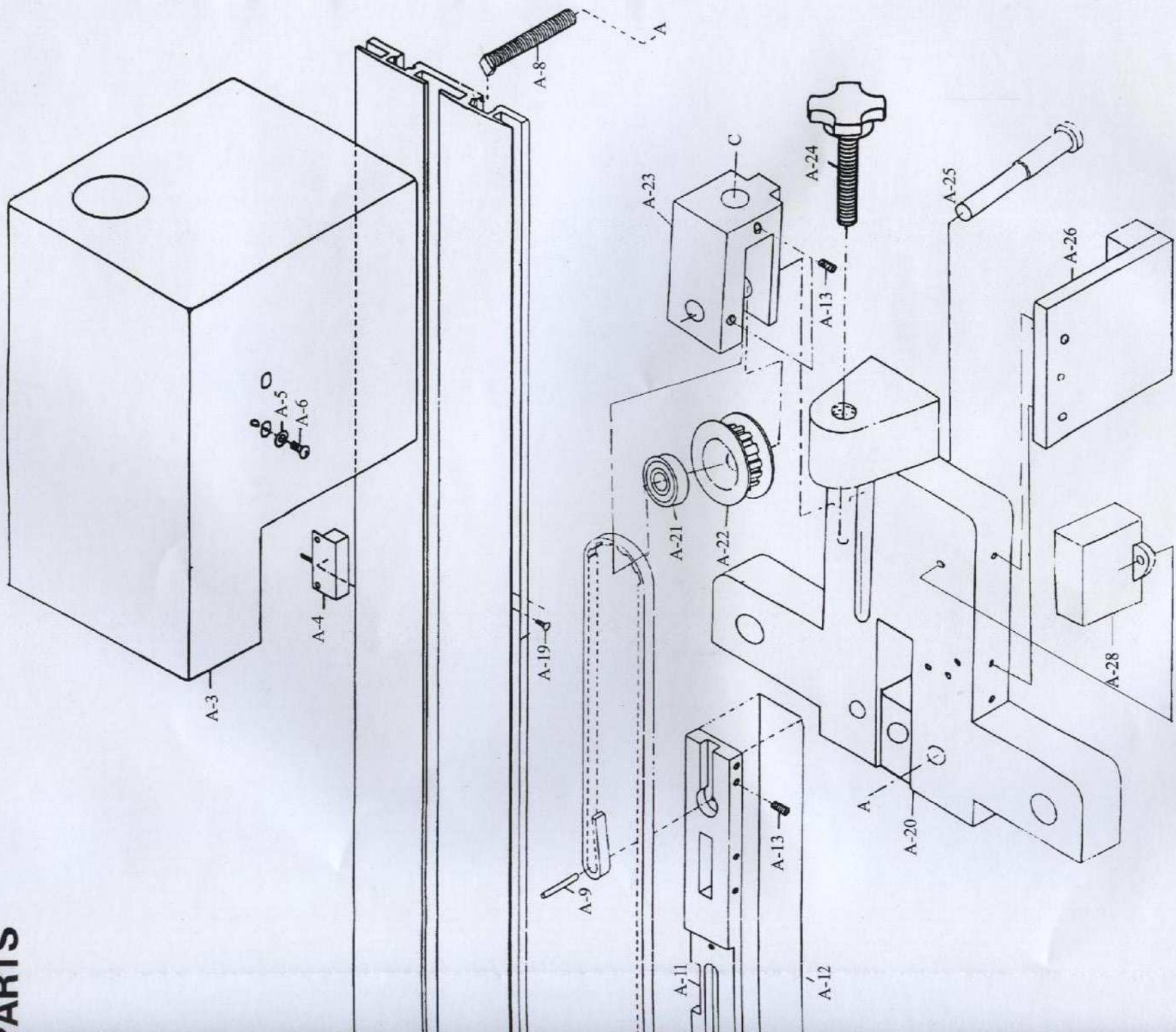
- (1). 导轨下降过程中，当红外线传感器1受织物感应时，导轨将停止下降。
- (2). 当长度设定超出最大值时，前磁性传感器2将阻止主机冲出导轨。
- (3). 主机返回时，后磁性传感器3用来定主机停止位置。
- (4). 4为电机电源线连接盒。
- (5). 5为红外线传感器线连接盒。
- (6). 6为磁性传感器线连接盒。

- (1). The Aluminum Track Rail will stopped down when the cloth sensing switch 1 sense fabrics.
- (2). No.2 forward sensor prevents from breakaway of knife even when the cutting length set up to the maximum.
- (3). No.3 back sensor is placed on the position where the knife motor comes back.
- (4). No.4 is a connect box of wire for motor power.
- (5). No.5 is a connect box of wire for cloth sensing switch.
- (6). No.6 is a connect box of forward sensor and back sensor wire.

A

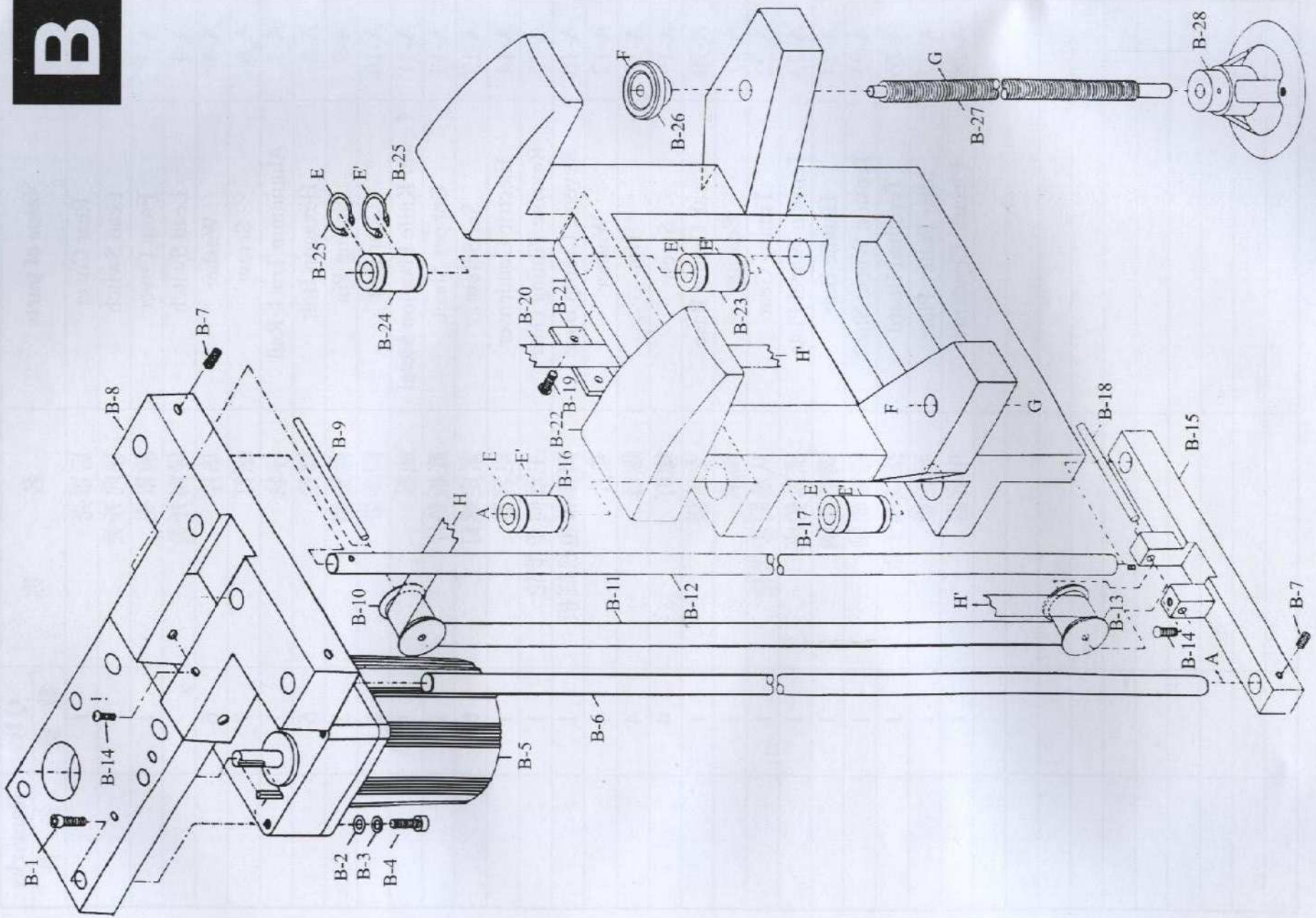


零件 PARTS

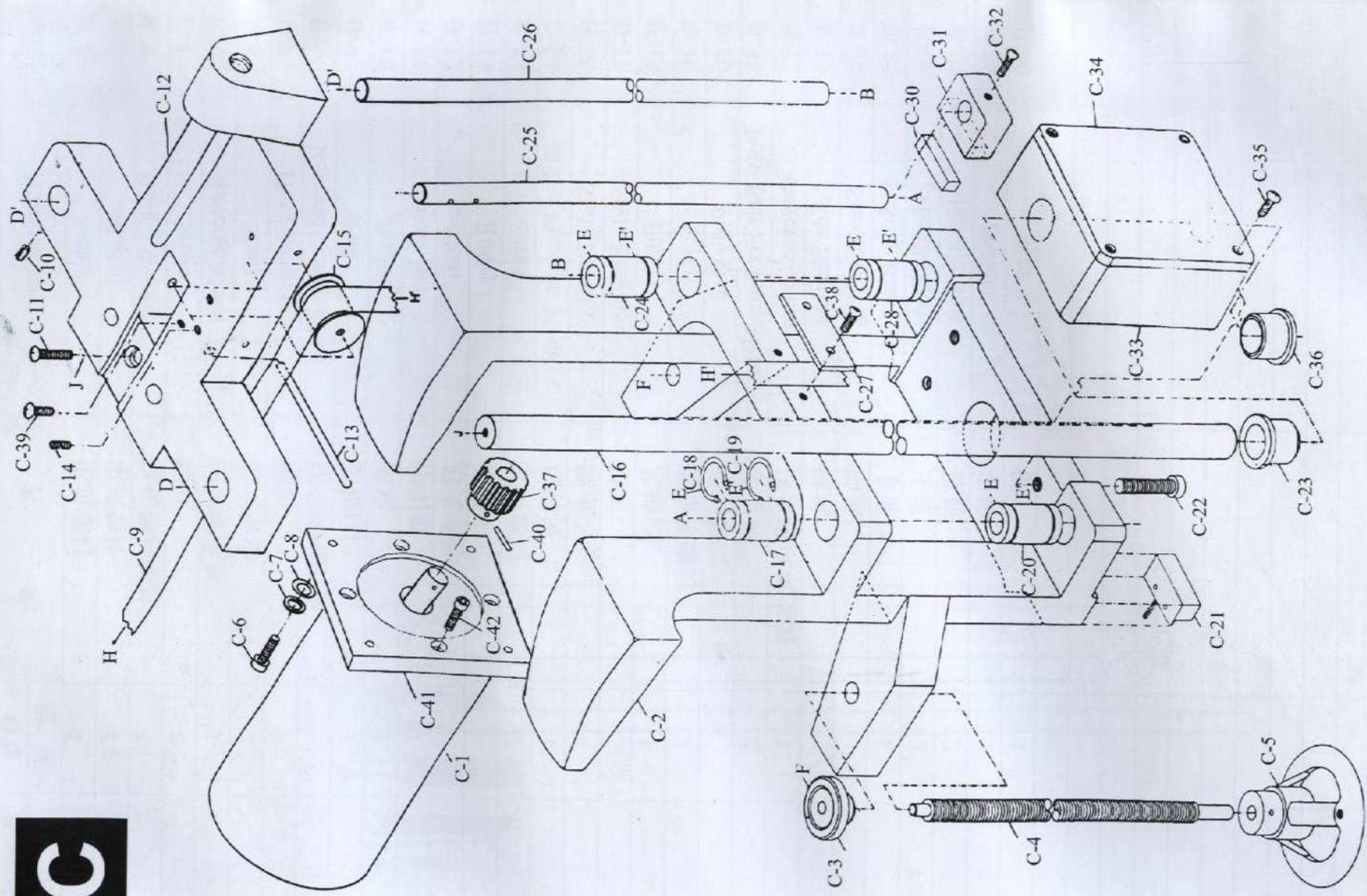


Ref.no 序号	Name of parts	名称	Qty 数量	Remarks 备注
A-2	Lead Switch	导向开关	2	
A-3	Front Cover	前罩壳	1	
A-4	Lead Switch	导向开关		
A-5	Washer	垫片	6	
A-6	Screw	螺钉	7	
A-7	Aluminum Track Rail	导轨	1	
A-8	Hexagon Bolt	螺栓	6	
A-9	Spring Pin	弹簧销	2	
A-10	Gear Belt	同步带	1	
A-11	Lower Knife Fixation Metal	底板	1	
A-12	Copper Sheet	底板垫片	1	
A-13	Set Screw	紧定螺钉	6	
A-14	Electric Condenser	电容器	1	
A-15	Reverse Timing Gear	主动同步带轮	1	
A-16	Reverse Cramp Base	同步带电机底板	1	
A-17	Washer	垫片	4	
A-18	Nut	螺母	4	
A-19	Screw	螺钉	4	
A-20	Break Cramp Base	支承板	1	
A-21	Bearing	轴承	1	
A-22	Timing Gear	从动同步带轮	1	
A-23	Tension Wheel Plate	涨紧轮座	1	
A-24	Handle Bolt	调节手柄	1	
A-25	Tension Wheel Shaft	涨紧轮轴	1	
A-26	Terminal Board	接线端子板	1	
A-27	Idle Pulley Plate	导轮板	1	
A-28	Electric Condenser	电容器	1	

B

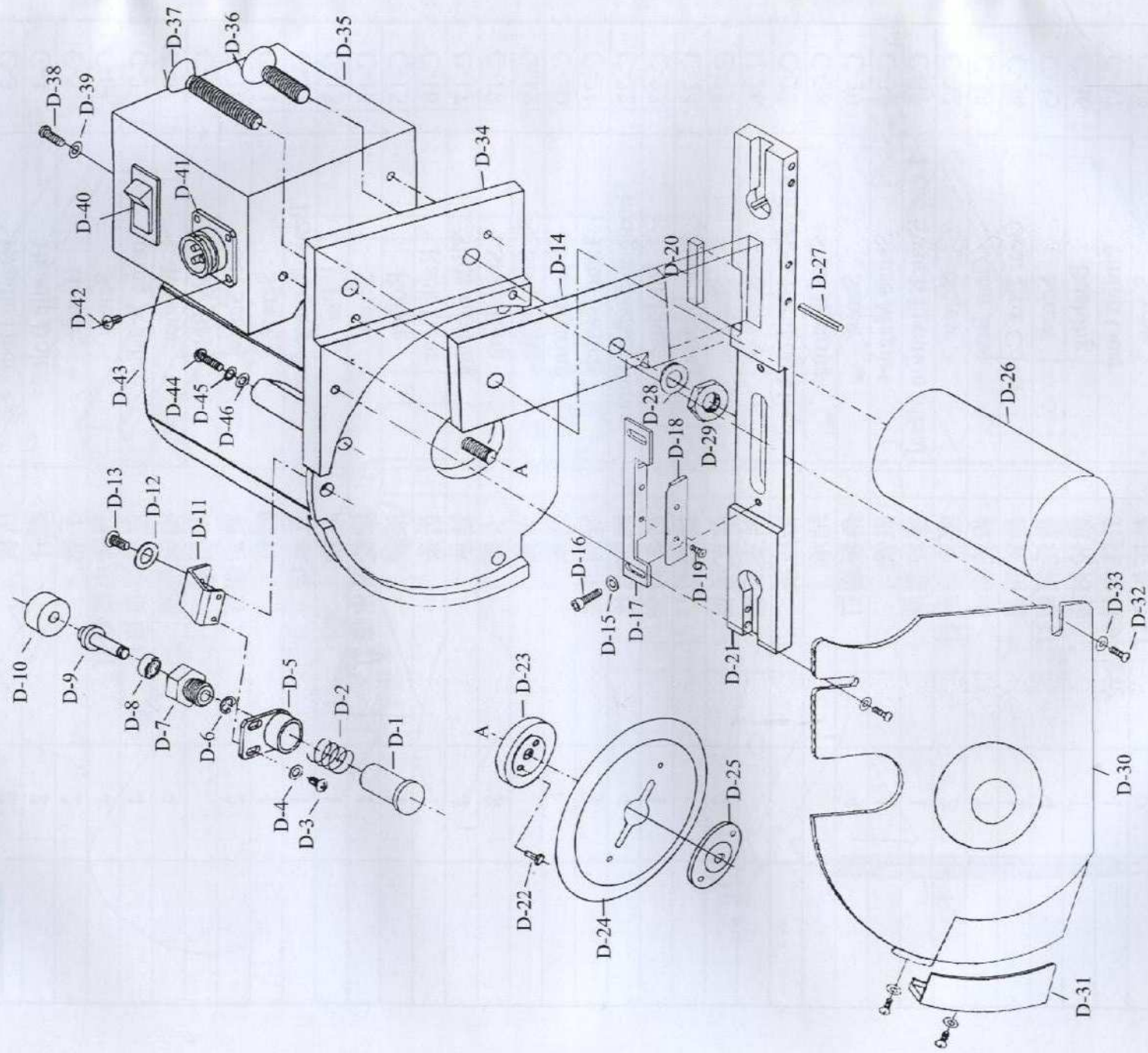


Ref.no 序号	Name of parts	名 称	Qty		Remarks
			数量	备注	
B-1	Screw	电机螺钉	4		
B-2	Washer	电机垫片	4		
B-3	Spring Washer	电机弹性垫片	4		
B-4	Screw	螺钉	4		
B-5	Reverse Motor	同步带电机	1		
B-6	Shaft	后支承轴	2		
B-7	Hexagon Screw	螺钉	4		
B-8	Reverse Cramp Base	同步带电机板			
B-9	Pin(1)	芯轴(1)	1		
B-10	Roller	滚轮	2		
B-11	Poly Belt	牵引带	1		
B-12	Shaft	后支承轴			
B-13	Roller	滚轮			
B-14	Screw	紧定螺钉	2		
B-15	Roller Fixation Metal	底脚板	1		
B-16	Slide Bearing	轴承	4		
B-17	Slide Bearing	轴承			
B-18	Pin(2)	芯轴(2)	1		
B-19	Screw	带压板螺钉	2		
B-20	Poly Belt	牵引带			
B-21	Poly Belt Fixation Metal	带压板	2		
B-22	Reverse Cramp	同步带电机支架	1		
B-23	Slide Bearing	轴承			
B-24	Slided Bearing	轴承			
B-25	Snap Ring	卡簧	8		
B-26	Handle Dish	压板	2		
B-27	Handle Bolt	螺杆	2		
B-28	Handle	手轮	2		
B-29	Key	键	1		



Ref.no 序号	Name of parts	名称	Qty		Remarks 备注
			数量	数量	
C-1	Brake Motor	升降电机	1		
C-2	Brake Cramp	升降电机支架	1		
C-3	Handle Dish	压板	2		
C-4	Handle Bolt	螺杆	2		
C-5	Handle	手轮	2		
C-6	Screw	升降电机螺钉	4		
C-7	Spring Washer	电机弹簧垫片	4		
C-8	Washer	电机垫圈	4		
C-9	Poly Belt	牵引带			
C-10	Set Screw	紧定螺钉	2		
C-11	Screw	螺钉	1		
C-12	Brake Cramp Base	支承板	1		
C-13	Pin	芯轴	1		
C-14	Screw	滚轮紧定螺钉	1		
C-15	Roller	滚轮	1		
C-16	Rack Gear	齿条	1		
C-17	Slide Bearing	轴承	4		
C-18	Snap Ring	卡簧	8		
C-19	Snap Ring	卡簧			
C-20	Slide Bearing	轴承			
C-21	Lead Switch	导向开关	1		
C-22	Hexagon Socket Screw	固定螺丝	4		
C-23	Bushing	齿条衬套	1		
C-24	Slide Bearing	轴承			
C-25	Shaft	前支承轴	2		
C-26	Shaft	前支承轴			
C-27	Poly Belt Fixation Metal	带压板			
C-28	Slide Bearing	轴承			
C-29	Screw	角板螺钉	4		
C-30	Sense Magnet	磁铁	1		
C-31	Lead Switch Fixation Metal	感应器座	1		
C-32	Screw	感应器螺钉	2		
C-33	Gear Box	齿轮箱体	1		
C-34	Gear Box Cover	齿轮箱盖	1		
C-35	Screw	齿轮箱螺钉	4		
C-36	Bushing	齿轮衬套	1		
C-37	Pinion Gear	升降电机斜齿轮	1		
C-38	Screw	带压板螺钉	2		
C-39	Screw	螺钉	1		
C-40	Pin	销	1		
C-41	Motor Box Cover	电机前端盖	1		
C-42	Screw	螺钉	4		

D



Ref.no 序号	Name of parts	名称	Qty		Remarks
			数量	备注	
D-1	Sharpening Switch	磨刀按钮	1		
D-2	Grind Return Spring	弹簧	1		
D-3	Screw	螺钉	2		
D-4	Washer	垫圈	2		
D-5	Fixer	固定套	1		
D-6	Retaining Ring	卡簧	1		
D-7	Cylindrical Screw	锁紧螺钉	1		
D-8	Bearing	轴承	1		
D-9	Mandril	芯轴	1		
D-10	Grind Stone	砂轮	1		
D-11	Grind Fixation Metal	砂轮架	1		
D-12	Washer	垫圈	1		
D-13	Screw	螺钉	1		
D-14	Balance Weight Stay Metal	立板	1		
D-15	Washer	垫圈	2		
D-16	Screw	螺钉	2		
D-17	Knife Frame	磨刀垫固定板	1		
D-18	Fixation Knife	磨刀垫	1		
D-19	Set Screw	磨刀垫螺钉	2		
D-20	Sense Magnet	磁铁	1		
D-21	Knife Bottom Metal	底板	1		
D-22	Pin	刀片传动销	2		
D-23	Knife Transmission Wheel	刀片传动轮	1		
D-24	Circle Knife	刀片	1		
D-25	Knife Screw Nut	刀片锁紧螺母	1		
D-26	Balance Weight	平衡柱	1		
D-27	Spring Pin	弹簧销	2		
D-28	Screw	垫圈	1		
D-29	Nut	螺母	1		
D-30	Knife Guard	刀片防护罩	1		
D-31	Knife Edge Guard	刀头防护罩	1		
D-32	Screw	螺钉	4		
D-33	Washer	垫圈	4		
D-34	Knife Rest	刀架	1		
D-35	Switch Box	开关盒	1		
D-36	Screw	螺钉	1		
D-37	Hexagon Screw	平衡柱螺钉	1		
D-38	Screw	螺钉	1		
D-39	Washer	垫圈	1		

Ref.no 序号	Name of parts	名称	Qty 数量	Remarks 备注
D-40	Switch	开关	1	
D-41	Electrical Outlet	插座	1	
D-42	Screw	螺钉	4	
D-43	Knife Motor	电机	1	
D-44	Screw	螺钉	3	
D-45	Spring Washer	弹簧垫圈	3	
D-46	Washer	垫圈	3	



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