

空壓切翻燙領機

一、規格

電壓	1P220V 50/60HZ
耗熱量	1600W/H
氣壓	4-5kg/cm ²
耗氣量	240L/MIN
淨重	150KG
機器尺寸	920*950*1210
淨重	200KG

二、特點

1. 最新設計三機一體，集切、翻、燙領一次完成；
2. 全自動送料，收料裝置，減少操作員疲勞，提高生產效率；
3. 特殊的壓燙結構，可根據領尖的需求加以調整，使衣領更為多變化；
4. 壓領流程可配合布料，選擇單段壓燙或雙段壓燙；
5. 全新恆溫裝置，讓領尖不易產生發亮情況；
6. 換裝模具簡便，一般操作員即可自行處理；
7. 每小時正常產量 180-200 件。

三、操作說明

1. 接上電源（220V）及壓縮空氣（4-5kg/c m²），根據實際需要設定所需之溫度（加溫時間約為 15 分鐘）和壓著時間；
2. 將領片套上切領板（A）（襯布向上），往下壓到底，切刀自動下切，切掉多餘之布料和襯後，放鬆，讓其回復到原位，踩下中間腳踏開關（B）不動，翻領針（C）往上頂，頂住領片之尖端，固定於領板上，並將領片往下拉即完成領片之翻領定型；
3. 當溫度達到設定時，紅燈則熄滅，一般在設溫 15 分鐘後即可正常壓領；將準備好的領片套在左鋼模（D）上，然後用手將領尖及摺縫緊貼鋼模邊緣拉（壓）。當領片已準備好，踩住左踏板開關（E）（或按住左按鈕 F），

夾子（G）便會將領片夾持在鋼模上。並且鋼模會上移，左加壓台（H）便會加壓，加壓到設定時間後，夾領機械手（I）夾住布料，待鋼模上升後，夾領機械手（I）將領取出，並將其放在收料籃 J 中，完成一次壓燙動作；

4. 將左邊燙好的一半領片拿到右邊，過程與左邊一樣，踩住右踏板開關（或按住右按鈕），夾子便會將領片夾持在鋼模上。並且鋼模會上移，右加壓台便會加壓，加壓到設定時間後，夾領機械手夾住布料，不同之處在於燙好的領片在鋼模上升後，壓縮空氣打開將壓好之領料吹入左邊之收料（L）內，完成一個領片完整燙壓過程；
5. 無論任何時候，只要按下面板上紅色急停開關，正在運行的動作將會終止。
6. 本機雙單段選擇為客戶根據需要選擇領尖定型使用單段或者雙段。

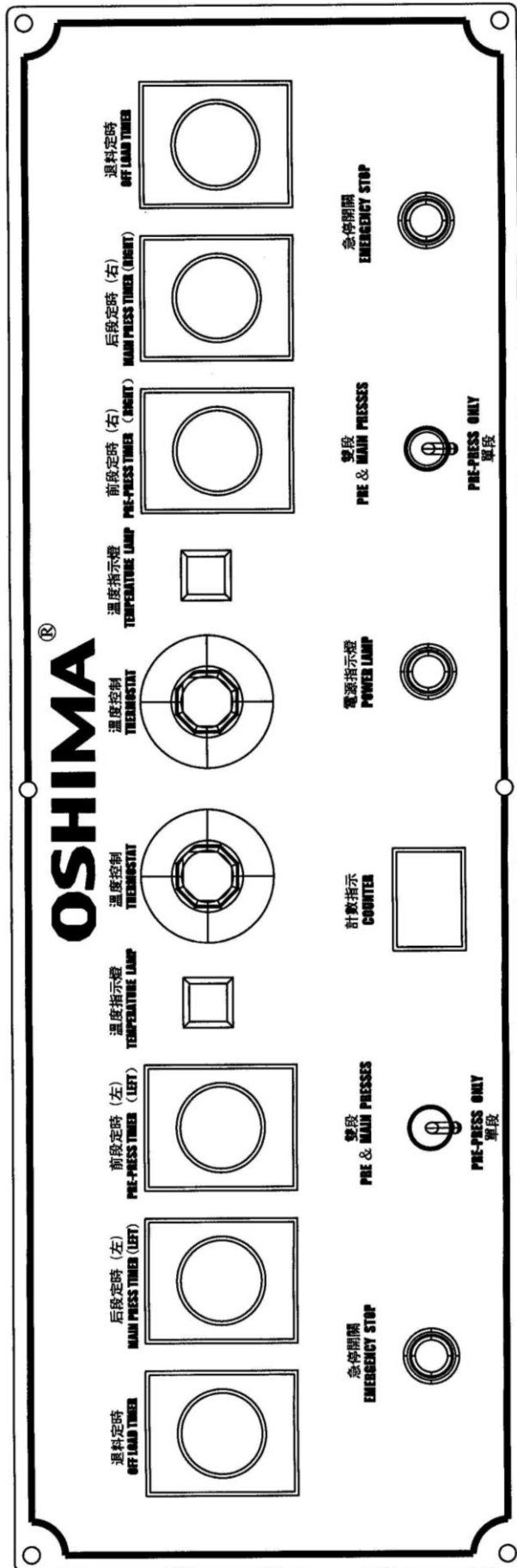
四、 注意事項

- 1、 保持機台清潔，每天開機前用壓縮空氣槍將機台內灰塵、線頭等予以清除；
- 2、 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；
- 3、 使用外界接入氣壓最大為 $7\text{kg}/\text{cm}^2$ ，其內部各部分所使用的氣壓請按出廠時設定值使用，勿隨便更改調整；
- 4、 請勿隨便拆卸、更換各模具或模具安裝螺絲，此項必須由專業技師操作方可；
- 5、 機械動作部分請務必保持清潔、潤滑，不得有灰塵、線頭，以防造成零部件磨損或機械動作異常；
- 6、 機台遷移原安裝位置後，請務必調整水準，以防機台振動；
- 7、 配備有自動吹風卸料的機台，所外接壓縮空氣必需配備油水篩檢程式，以防油污、水垢弄髒或損壞衣料；
- 8、 機械動作在運行時，請勿轉換程式操作開關，以免動作異常；
- 9、 切刀用完時，必須作防銹處理；
- 10、 本機器只在左邊燙領時才會計數；

五、故障簡易排除

故障現象	原因	排除方法
1· 機器不工作	A、電源沒有輸入(指示燈不亮)	檢查用戶電源插座，相線、零線是否完好，電壓是否正常
	B、保險處斷	更換同型號保險管
	C、電源開關問題	更換同型號開關
2· 不加熱	A、溫控器設定不當	設定至合適溫度，即可
	B、保險處斷	更換保險管（10A），並檢查發熱板的絕緣性能和阻值是否正確
3· 切領不良	A、模具與衣領不符	請根據不同的衣領選擇不同的模具
	B、切領片的位置調節不當	將切領片的尖端調至合適位置
4· 壓燙效果不佳	A· 鋼片上升速度不當	將調速閥調至合理速度
	B· 機械手夾布不當	調節機械手適當之位置

六、控制面板



Pneumatic Collar Trimming, Turning and Pressing machine

1. Specification

Power	1P220V 50/60HZ
Heater	1600W/H
Air pressure	4-5kg/cm ²
Air consumption	240L/MIN
Net Weight	150KG
Machine dimension	920*950*1210
Gross weight.	200KG

2. Features

- 1) Collar pressing, turning and trimming, all in one.
- 2) Auto Feeding and Collecting device, which ensures the high reduce the operator' s fatigue.
- 3) Its special pressing moulds which can be changed to fit different kinds of collar turning to sharp and smart.
- 4) Its two step-pressing option, which can press all kinds of fabric perfectly.
- 5) The new design of thermostat can ensure the collar point will not polish and shine.
- 6) To exchange the different moulds of collar is very easy by the operator himself.
- 7) Production quantity: 180 ~ 200 pieces per hour.

3 . Operating instructions

- 1) Please connect power (220V) and air compressor (4-5kg/c m²) , Please set up the temperature and pressing time accordingly.
- 2) Put the collar piece into the collar plate (A), press down to the bottom and cutter will cut automatically. Released and it will back to the original position. Stamp the middle pedal switch (B), and tipped the collar to the tip and fixed in the collar plate, pull down the collar and

finished the processing of collar turning.

- 3) When temperature reached the one you set, the red lamp will off, and after 15 minutes for pressing. Put the collar into the left mould (D), and use the hand to press the collar fitted with the mould. Once ready, stamp the right pedal switch (E), or press the left button (F), the clamp (G) will clamp the collar on the mould. And the mould will move up, and then the left pressing table (H) will press, after reached the pressing time, the clamp (I) will clamp the fabric, after mould lift up, the clamp (I) will take the collar and put it in the collecting box (J).
- 4) Put the pressed left collar to the right side, and the processing is same as left side. The different is when mould lift up, the air compressor will blow the pressed collar to the left collecting box (L).
- 5) Once press the red emergency stop on the panel, the machine will stop automatically.
- 6) The single or double step is choosing depends on your demand.

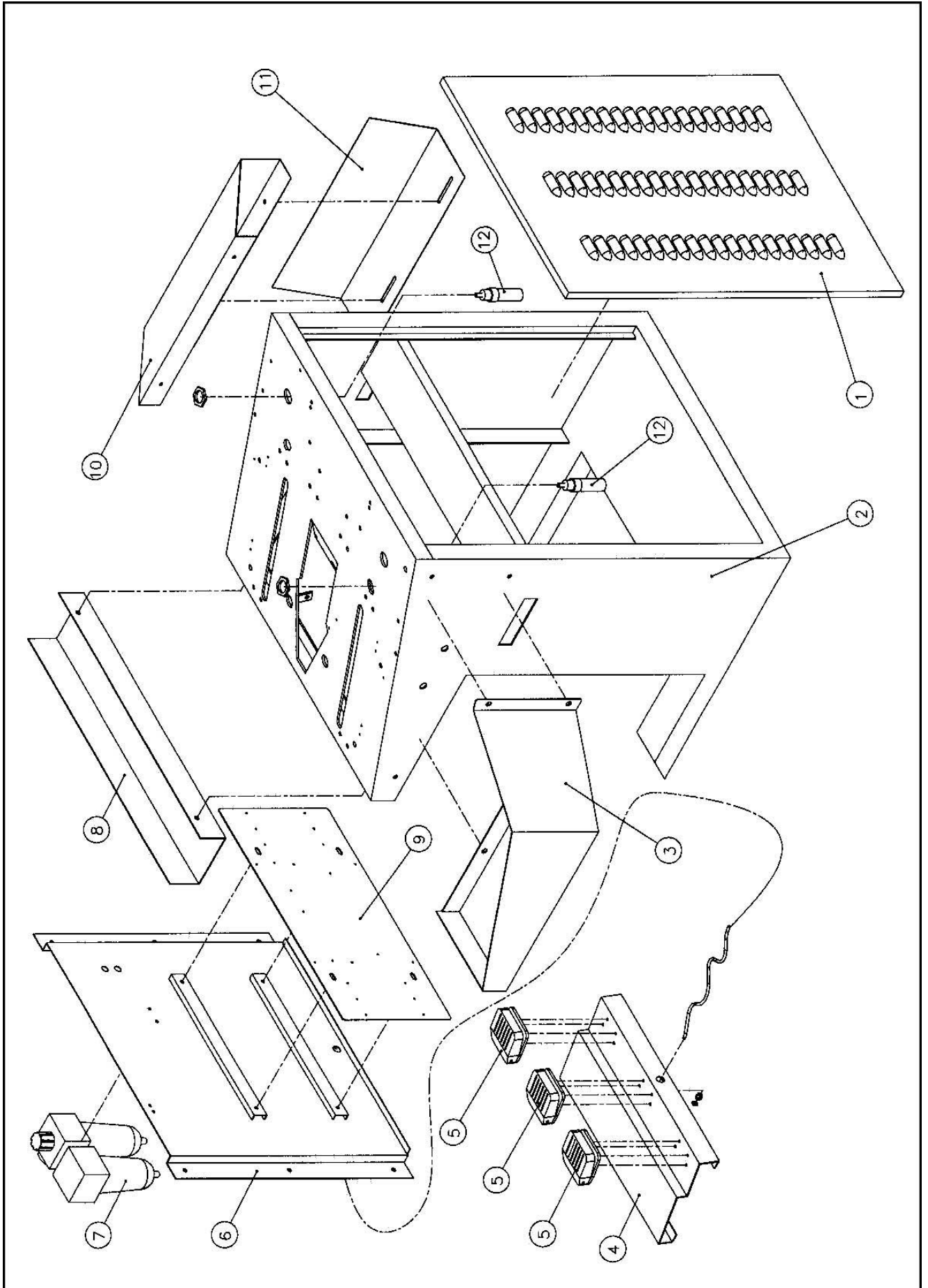
四 Notices

- 1) Please keep the machine clean, and please use the air gun the clean the dust or thread everyday before turn on the machine.
- 2) Please add the oil when out of oil, and please filter out the oil from the cup everyday.
- 3) The maximum air pressure is $7\text{kg}/\text{cm}^2$, don't adjust it.
- 4) Don't disassemble, replace or equipped with the mould or screw, this is doing by the professional technician.
- 5) The mechanical parts of machine must clean and lubricate in order to let the parts damaged.
- 6) Please adjust the level of machine after moving the machine to other places in order to prevent the machine vibrating.
- 7) The air compressor must equip with the sifter program in order to prevent the oil or water to dirty the fabric.
- 8) When machine running, don't change the program or operating switch in order to prevent the machine out of control.
- 9) After finished the cutter, please spray the antirust.

10) The machine only count in the left pressing collar.

5、Trouble shooting

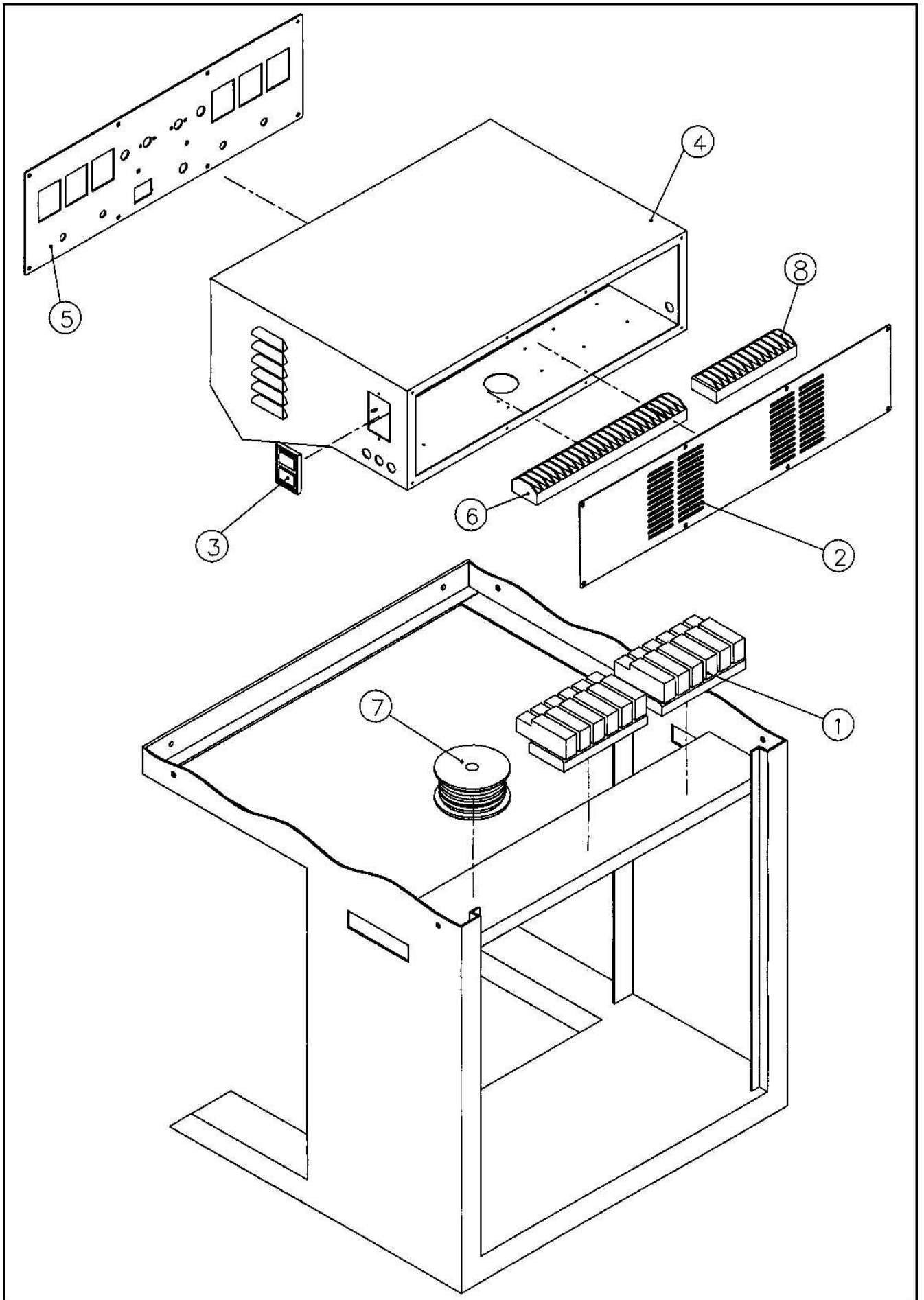
Trouble	Reason	Shooting
1 · Machine does not work.	A · Power is not connected	Please check the power connect, and input, and phase and neutral.
	B · FUSE is broken	Please change the FUSE.
	C · Power Switch	Please change the switch
2 · No heating function	A · Improper setting of thermostat	Please set the proper temperature.
	B · FUSE broken.	Please change the fuse.
3 · Fault on trimming.	A · Collar shape and mold is not fitted.	Please choose the proper collar die to fit the collar.
	B · Improper Trimming	Please adjust the top of the collar mold in proper position.
4 · Pressing fault	A · The collar die upward movement speed is improper	Please adjust the speed valve to fit the speed.
	B · The clamp does not work properly	Please adjust the position of the clamp's position.



机械零件目录 Part list

NO.1

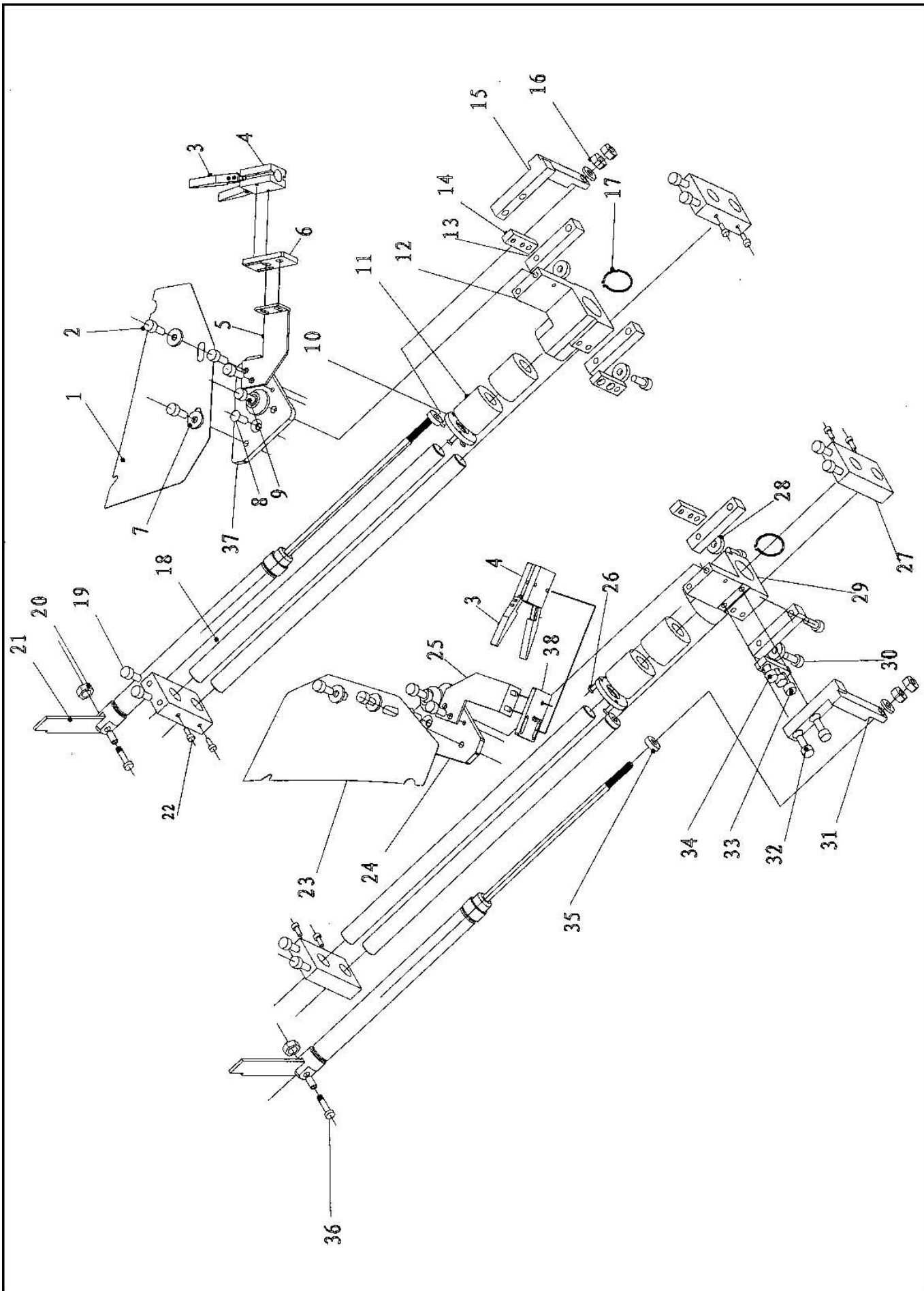
序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
1	313A018	後門	Back door	1	
2	565A001	底架	Bottom shelf	1	
3	313A015	料斗 2	Fabric feeder	1	
4	565A008	腳踏開關固定板	FOOT PEDAL FIXED BOARD	1	
5	DK1005	腳踏開關 TFS-201 5A	FOOT pedal switch TFS-201	3	
6	565A001-3	下底座	Lower bottom base	1	
7	QF0125	三點組合 3/8" UFR/L-03	THREE POINTS ASSEMBLY 3/8" UFR/L-03	1	
8	313A013	前工作臺	Front working table	1	
9	565A013	電路板	CIRCUIT BOARD	1	
10	565A019	左置物架內板	INNER BOARD OF LEFT LAYING SHELF	1	
11	565A020	左置物架外板	EXTERNAL BOARD OF LEFT LAYING SHELF	1	
12	QG0008	氣缸 SIA20-15	CYLINDER SIA20-15	2	



机械零件目录 Part list

NO.2

序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
1	QF0403	二位五通電磁閥 MFS-2120 24V-3W	ELECTRIC MAGNETIC VALE MFS-2120 24V-3W	12	
2	313A004	電控箱後蓋	BACK COVER OF ELECTRICAL BOX	1	
3	DK0901	押扣開關 3P	PRESS SWITCH 3P	1	
4	313A003	電控箱	ELECTRICAL BOX	1	
5	313A019	操作面板	CONTROL PANEL	1	
6	DF0107	端子排 20 位 15A	TERNIMAL ROWS 20 DIGITS 15A	1	
7	DB0227	變壓器 220V/20V 100VA	TRANSFORMER 220V/20V 100VA	1	
8	DF0101	端子排 6 位 25A	TERNIMAL ROWS 6 DIGITS 25A	3	



机械零件目录 Part list

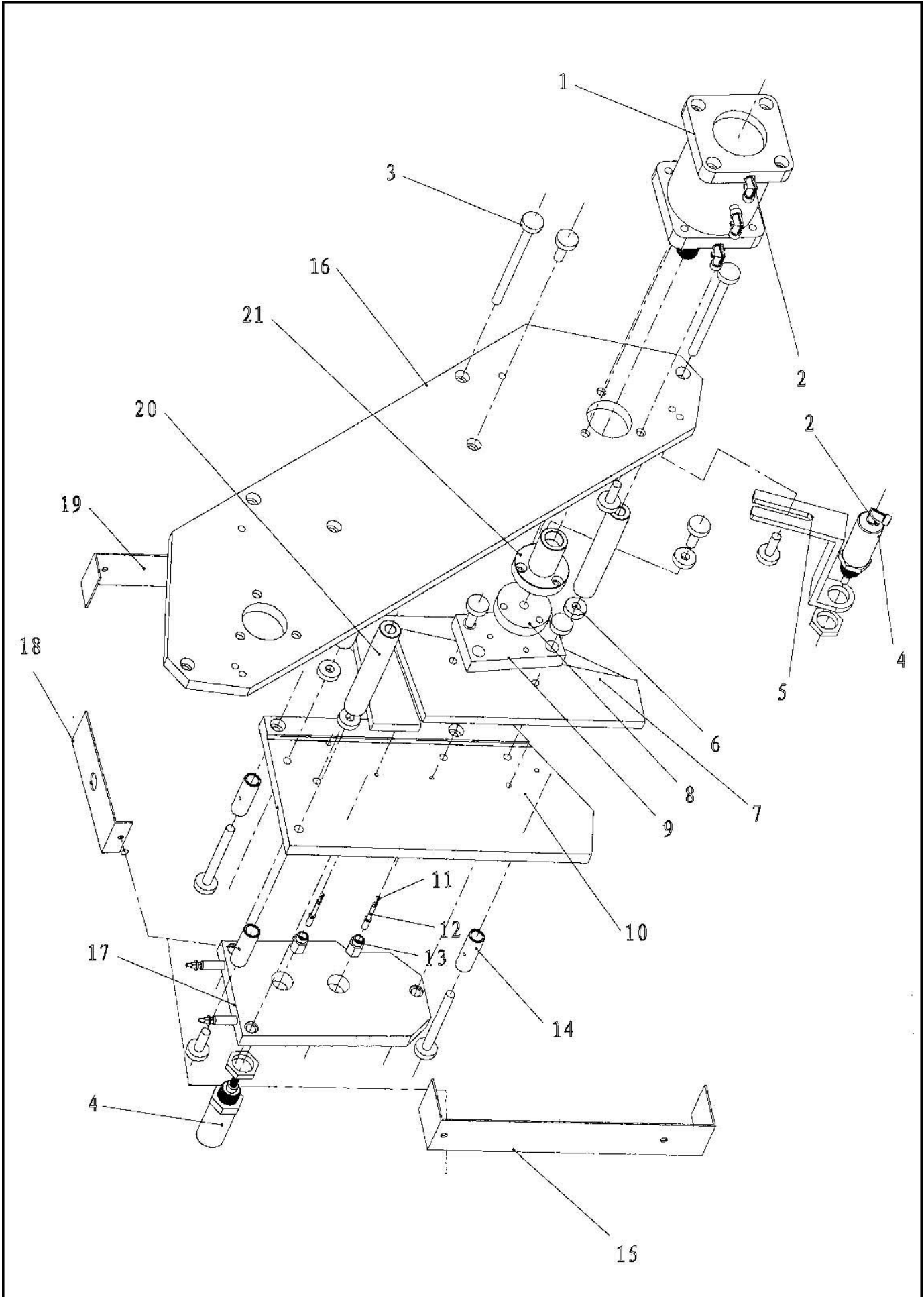
NO.3

序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
1	313B071	標準模 (右)	STANDARD MOULD (RIGHT)	1	
2	JD2058	M8*20 內六角螺釘	M8*20 INNER HEX SCREW	4	
3	555AB012-14	機械手爪	MACHANICAL arm	4	
4	QG0021	氣缸 MHCY2-16S	CYLINDER MHCY2-16S	2	
5	313B066	夾領氣缸座(右)	COLLAR CLIP CYLINDER BASE	1	
6	555AB007	右鋼片機械手固定板	FIXED BOARD OF RIGHT STEEL MECHANICAL	1	
7	JF1012	φ 8 平墊	φ 8 FLAT PAD	4	
8	JD7123	內六角錐端緊定螺釘	M8*20 INNER HEX TIGHTEN SCREW	2	
9	313B006	固定座 1	FIXED BASE 1	2	
10	313B016	軸承擋塊	BEARING SHELTER	2	
11	JB2016	軸承 608Z	BEARING 608Z	2	
12	313B017	導軌滑套 (右)	GUIDED RAIL SLIDING COVER (RLGHT)	1	
13	313B015	軸承固定塊	BEARING FIXING PIECE	4	
14	313B009	導軌夾塊	GUIDED RAIL CLIP PIECE	4	
15	313B007	導軌連接塊 1 (右)	GUIDED CONNECT PIECE 1 (LEFT)	1	
16	JM0005	M8 螺母	M8 NUT	4	
17	JC2020	孔用彈性擋圈 φ 28	φ 28 ELASTIC PAD BAND	2	
18	313B013	導軌 2	GUIDED RAIL 3	4	
19	JD2057	M8*16 內六角螺絲	M8*16 INNER HEX SCREW	4	
20	JM0004	M6 螺母	M6 NUT	2	
21	313B012	氣缸座	CYLINDER BASE	2	
22	JD2024	M6*26 內六角螺絲	M6*26 INNER SCREW	4	
23	313B072	右模壓板	RIGHT MOULD PRESS BOARD	1	
24	313B002	範本固定板 (左)	PATTERN FIXED BOARD (LEFT)	1	
25	313B067	夾領氣缸座	COLLAR CLIP CYLINDER BASE	1	
26	JD4014	不銹鋼十字沉頭螺釘	M4*12 STAINLESS CROSS SCREW	6	
27	313B014	滑軌固定座	SLIDING RAIL FIXED BASE	4	
28	JB2033	線性培林 20x30	BEARING 20x30 (N20 N-20V)	4	
29	313B018	導軌滑套 (左)	GUIDING RAIL SLIDING COVER (LEFT)	1	
30	JD2059	M8*25 內六角螺絲	M8*25 INNER HEX SCREW	2	

機械零件目錄 Part list

NO.3

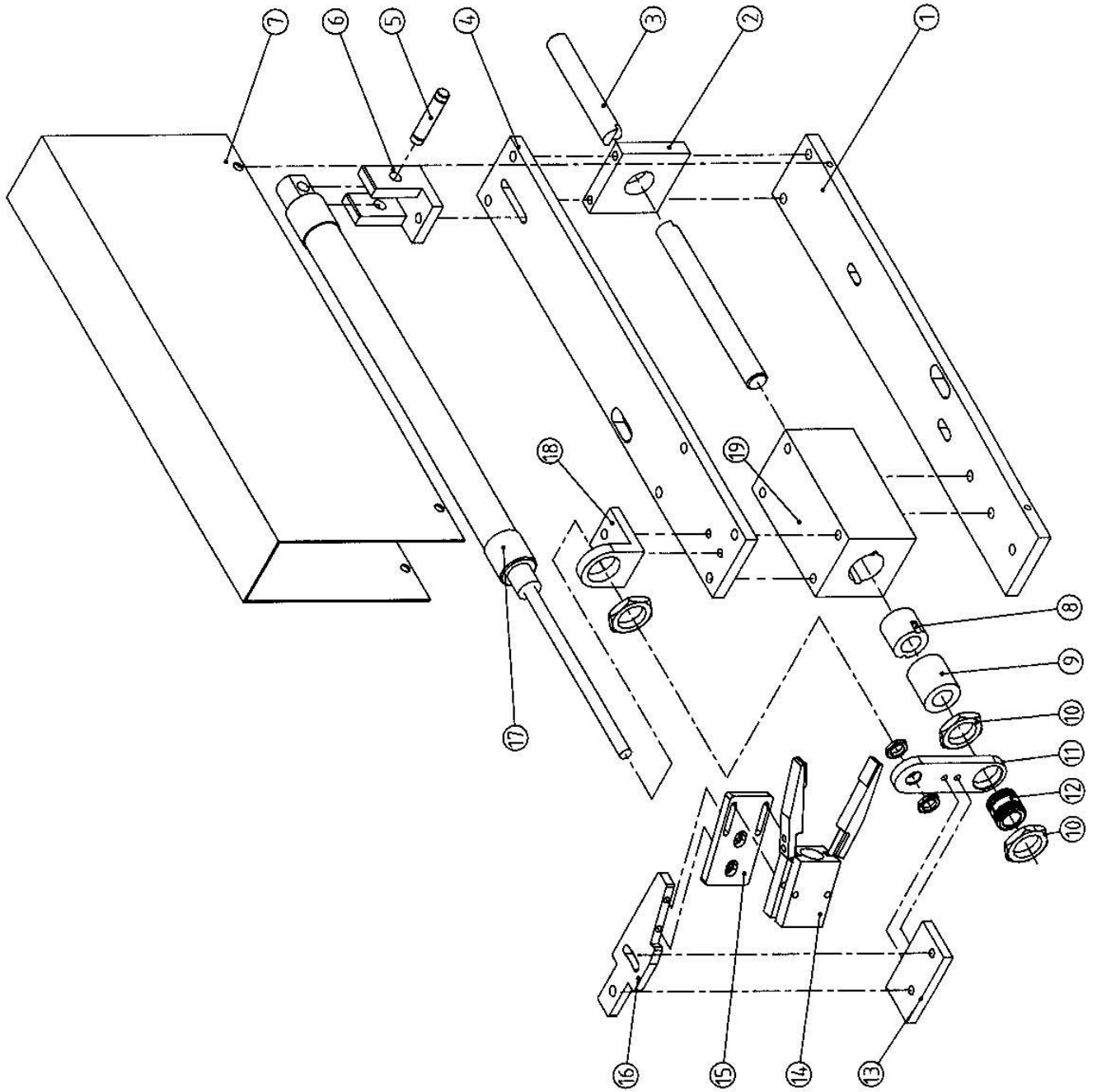
序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
31	313B008	導軌連接塊 1 (左)	GUIDING CONNECT PIECE 1 (LEFT)	1	
32	JD2059	M8*25 內六角螺絲	M8*25 INNER HEX SCREW	4	
33	JD7030	內六角端緊螺釘 M6*20	M6*20 INNER HEX TIGHTEN SCREW	2	
34	JD2041	M6*20 內六角螺絲	M6*20 INNER HEX SCREW	4	
35	JM0005	M8 螺母	M8 SCREW	2	
36	JD2044	內六角螺釘 M6*35	M6*35 INNER HEX SCREW	2	
37	313B001	範本固定板 (右)	PATTERN FIXED BOARD (RIGHT)	1	
38	555AB007	左鋼片機械手固定板	FIXED BOARD OF left STEEL MECHANICAL ARM	1	



機械零件目錄 Part list

NO.4

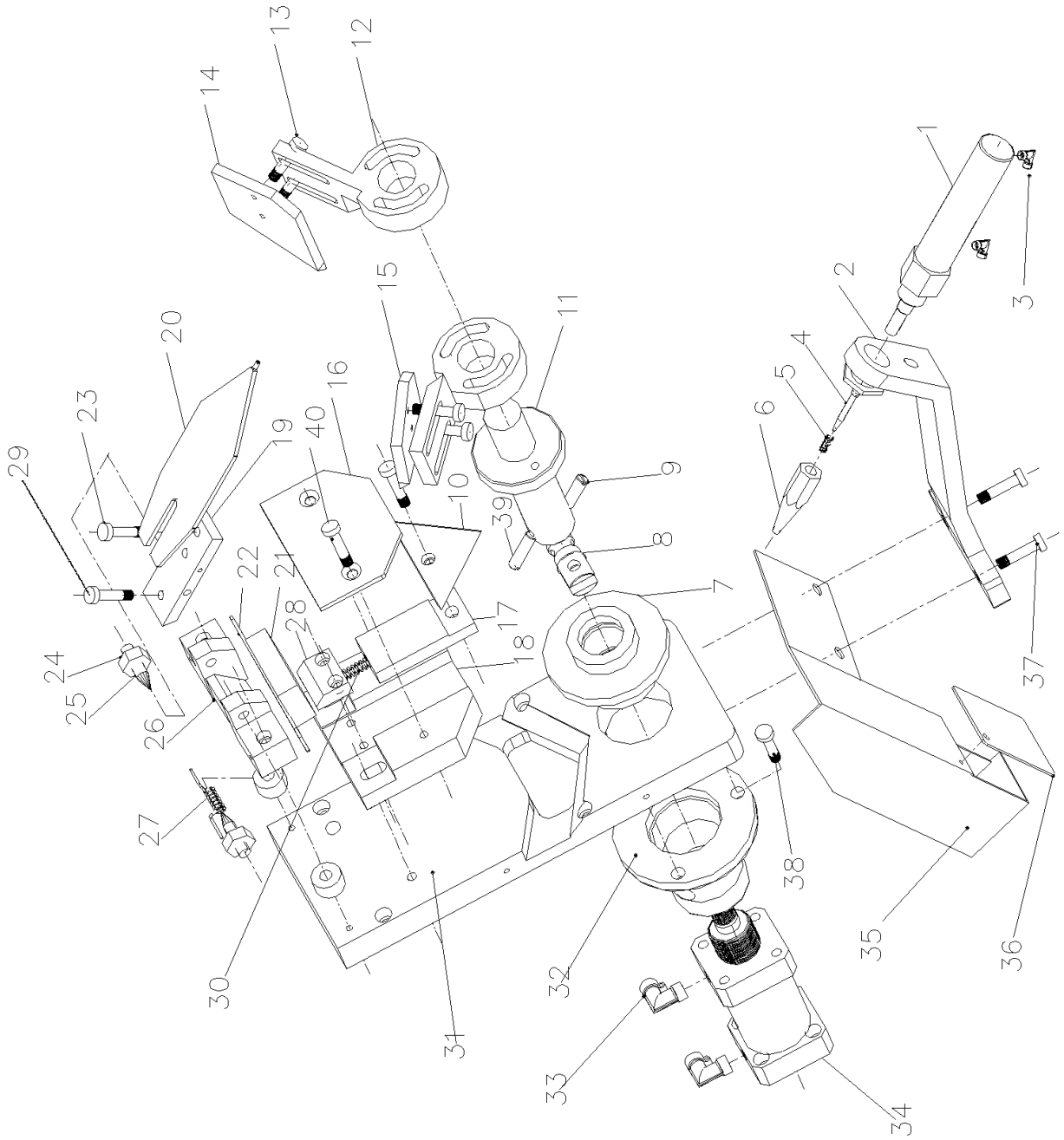
序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
1	QG0103	氣缸 DJ2-T-70*12*4	CYLINDER DJ2-T-70*12*4	2	
2	QJ0309	插入式可調彎頭 1/8*φ6 (A 型)	INSERTED ADJUSTABLE BEND JOINT	4	
3	JD2073	M8*130 內六角螺絲	M8*120 INNER HEX SCREW	6	
4	QG0008	氣缸 SIA20-15	CYLINDER SIA20-15	3	
5	313A006	氣缸固定座 4	CYLINDER FIXED BASE 4	1	
6	313B058	隔熱墊 2	INSULATOR PADDLE 2	6	
7	313A001-8	右上座	UPPER RIGHT BASE	1	
8	313B053	隔熱墊 1	INSULATOR PADDLE 1	2	
9	313B055	連接座	CONNECTING BASE	2	
10	313B064	左墊板	LEFT PADDLE	1	
11	JH1004	壓簧 φ0.5*φ5.8*30.5L*15n	PRESS SPRING 0.5*φ5.8*30.5L*15n	2	
12	313B062	頂針	THIMBLE	2	
13	313B063	頂針固定座	THIMBLE FIXED BASE	2	
14	313B057	連接杆 2	CONNECT ROD 2	8	
15	313A025	圍板 3	BOARDING 3	2	
16	313B059	電控箱固定板 1	ELECTRICAL BOX FIXED BOARD	1	
17	313B060	發熱板 1	HEATER 1	1	
18	313A023	圍板 1	BOARDING 1	2	
19	313A024	圍板 2	BOARDING 2	2	
20	313B056	支撐杆 1	SUPPORTING ROD 1	5	
21	313B054	連接套	CONNECTING COVER	2	



機械零件目錄 Part list

NO.5

序號 No.	部件編號 Part No.	部件名稱規格 Part Description	數量 Quantity	備註 Remark
1	555AB012-06	氣缸架下板 CYLINDER BASE BOTTOM BOARD	1	
2	555AB012-03	支撐板 SUPPORTING BOARD	1	
3	555AB012-01	氣缸隨動杆 CYLINDER SERVO ROD	1	
4	555AB012-04	氣缸架上板 CYLINDER BASE UPPER BOARD	1	
5	555AB012-17	轉軸 TURNING AXIS	1	
6	555AB012-08	氣缸架後支承 CYLINDER BASE REAR HOLDER	1	
7	555AA007	氣缸罩 CYLINDER COVER	1	
8	555AB012-09	導向滑套 GUIDED SLIDING COVER	2	
9	555AB012-10	緩衝器 BUMPER	1	
10	555AB012-16	拿背螺母 NUT	2	
11	555AB012-02	聯接板 CONNECTING BOARD	1	
12	555AB012-15	鎖緊螺母 TIGHTEN SCREW	1	
13	555AB012-13	機械手支承 MACHANIAL ARM HOLDER	1	
14	QG0021	氣缸 MHCY2-16S CYLINDER MHCY2-16S	1	
15	555AB012-11	機械手固定板 MACHANICAL ARM FIXED BOARD	1	
16	555AB012-12	機械手調整塊 MACHANICAL ARM ADJUSTING PIECE	1	
17	QG0004	氣缸 MIC20*250 CYLINDER MIC 20*250	1	
18	555AB012-05	前支撐板 FRONT SUPPORTING BASE	1	
19	555AB012-07	導向滑套座 GUIDED SLIDING COVER BASE	1	



機械零件目錄 Part list

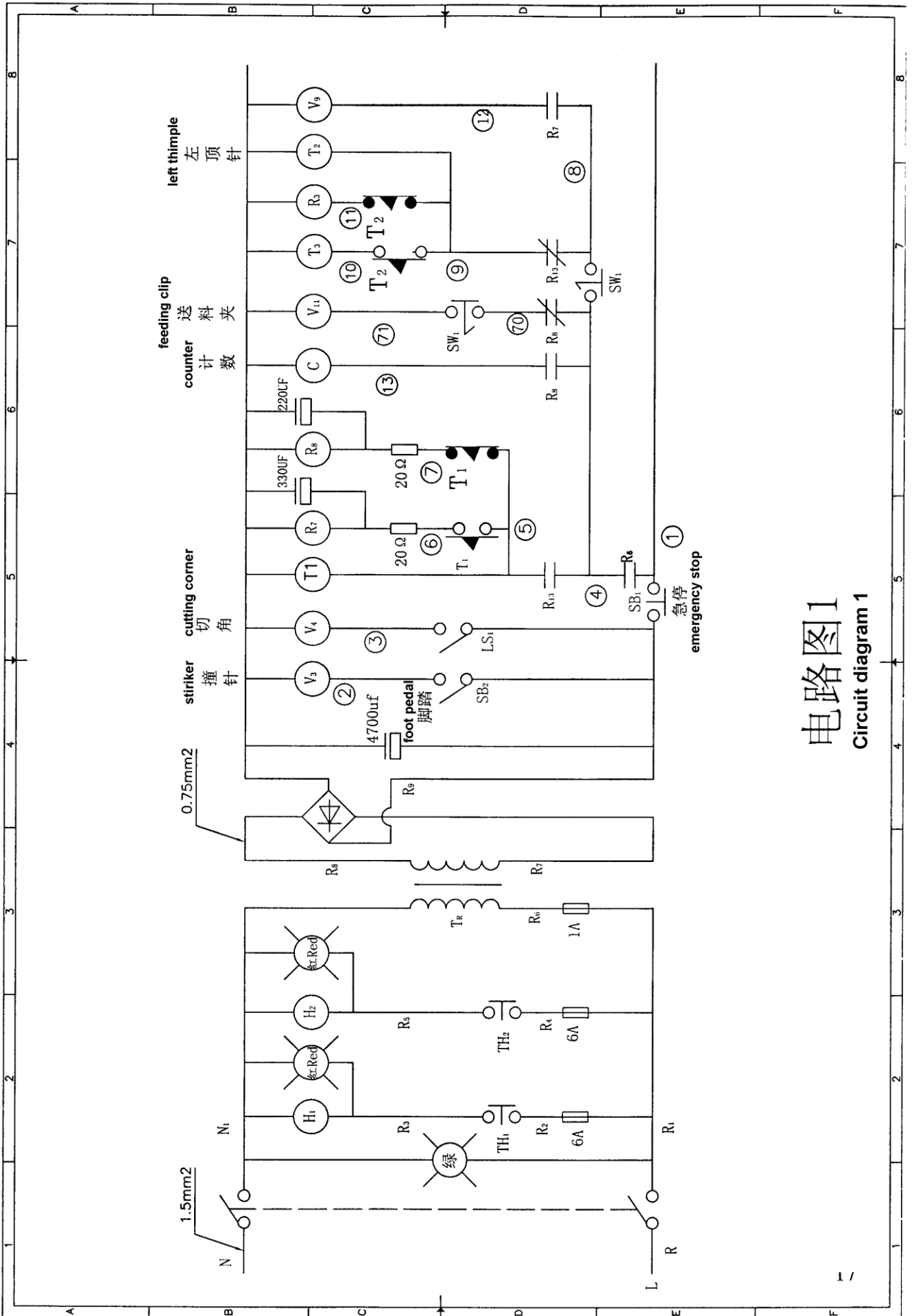
NO.6

序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
1	QG0041	气缸 MKL25-35	cyllnder	1	
2	313B034	翻领气缸固定座	cylinder fixed seat	1	
3	QJ0309	插入式可调直角 JSC6-01 (Φ6-1/8")	insert can move aright angle	1	
4	313B069	顶尖	thimble	1	
5	JH3011	顶针弹簧	thimble spring	1	
6	555AB001-02-1	机芯顶针	thimble	1	
7	313B031	轴芯铜座	axis long bolt	1	
8	313B028	切领轴芯接头	axis connector	1	
9	313B030	轴芯长螺栓 2		1	
10	120B015	三角刀片面性		1	
11	313B027	切刀轴芯		1	
12	313B020	切刀固定座		1	
13	JD2041	不锈钢圆柱头内六角螺栓 M6*20		2	
14	313B021	切刀片(右)		1	
15	313B022	切刀片(左)		1	
16	313A009	切领刀片座封板	bladw seat hood	1	
17	313B024	三角刀片滑块	sliping seat for tranglt blade	1	
18	313B026	切领刀片固定座	blade fixed seat	1	
19	120B008	切领机滑板		1	
20	120B019	翻领板		1	
21	DK0133	微动开关 OMRON V-15-1A5+VAQ-5 (配红色圆头按钮)		1	
22	313A007	電器固定板1		1	
23	JD2039	不锈钢圆柱头内六角螺栓 M6*12		1	
24	JM0005	不锈钢螺母 M8	nut	2	
25	JD7122	内六角锥端紧定螺栓 M8*30		1	
26	120B007	切领固定座			
27	JH3006	扭转弹簧 φ 1.2* φ 14*3 圈	spring	1	
28	313B025	弹簧挡块		1	
29	JD2042	不锈钢圆柱头内六角螺栓 M6*25	inside hexagon screw	1	
30	JH1026	压缩弹簧 φ 1.6* φ 8*75L*22 圈	spring	1	

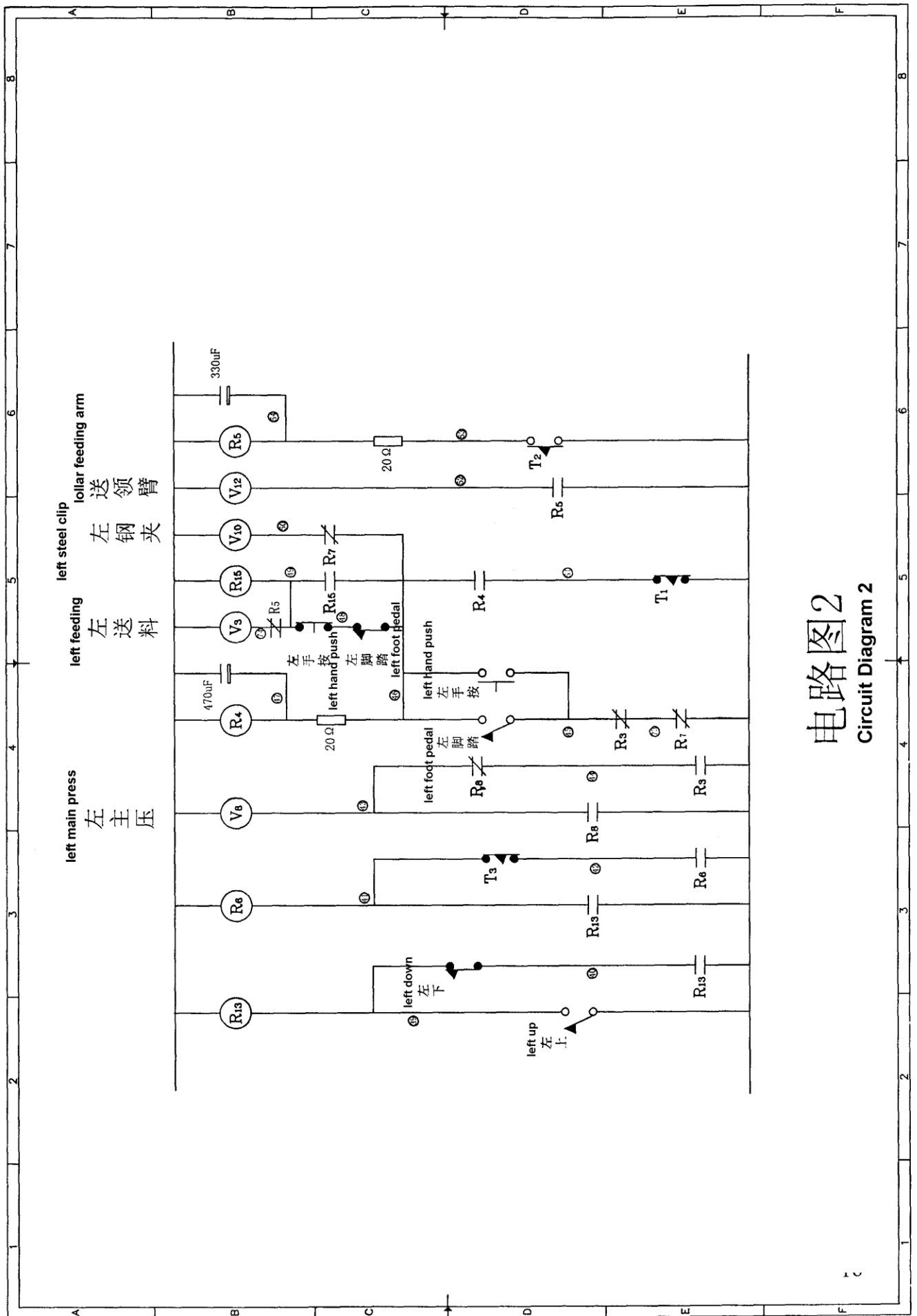
機械零件目錄 Part list

NO.6-1

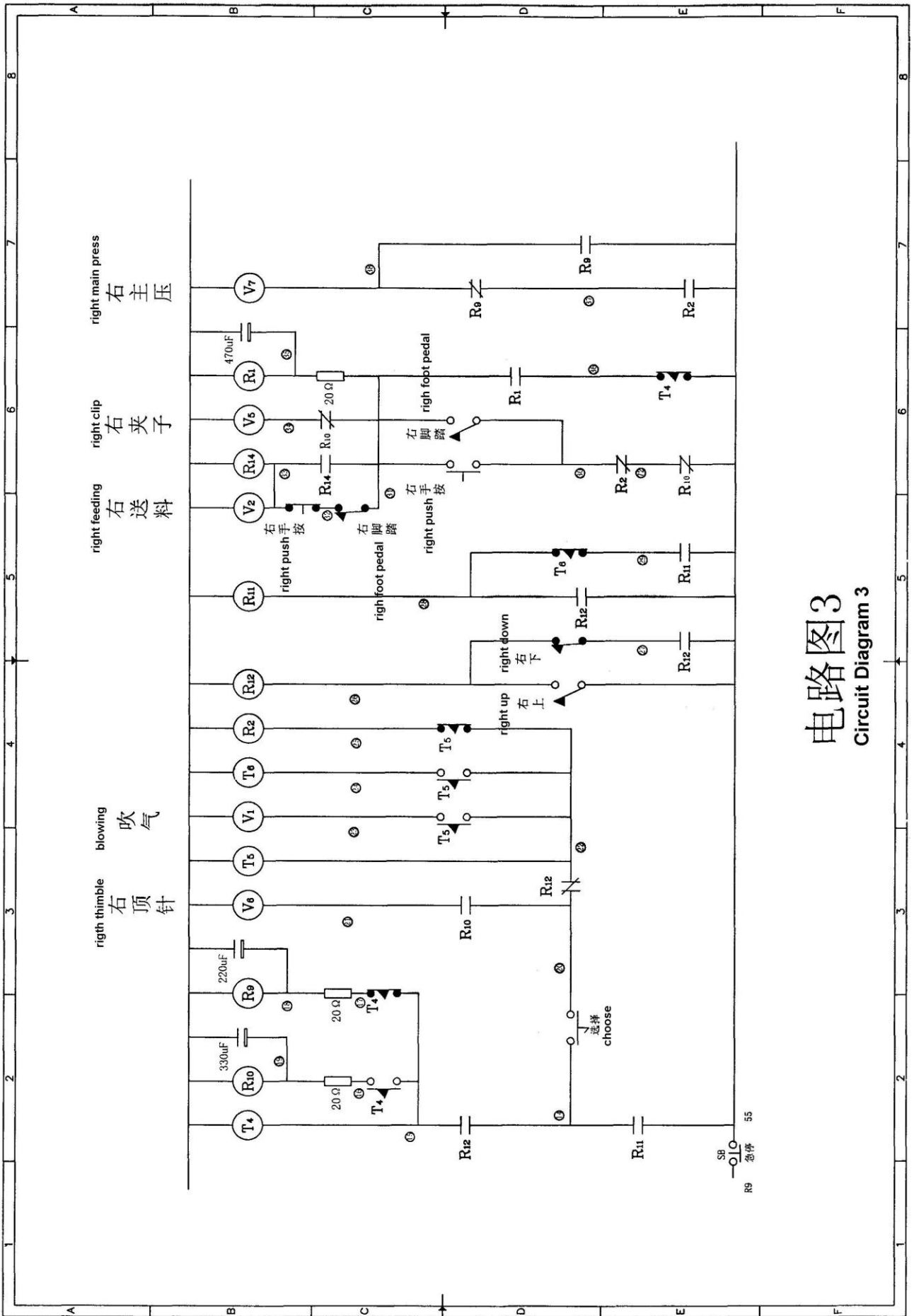
序號 No.	部件編號 Part No.	部件名稱規格 Part Description		數量 Quantity	備註 Remark
31	313B032	切領铸铁座		1	
32	313B033	切領气缸固定座		1	
33	QJ0309	插入式可调直角	insert can move a right angle	2	
34	QG0011	气缸 MAAL-40*30 (切領气缸)	cyllnder	1	
35	313A021	护罩	Protect cover	1	
36	313A022	护罩盖	Protect cover	1	
37	JD2059	不锈钢圆柱头内六角螺栓 M8*25	inside hexagon screw	2	
38	JD2058	不锈钢圆柱头内六角螺栓 M8*20	inside hexagon screw	3	
39	313B029	轴芯长螺栓 1		1	
40	JD8012	不锈钢内六角沉头螺栓 M6*12		2	



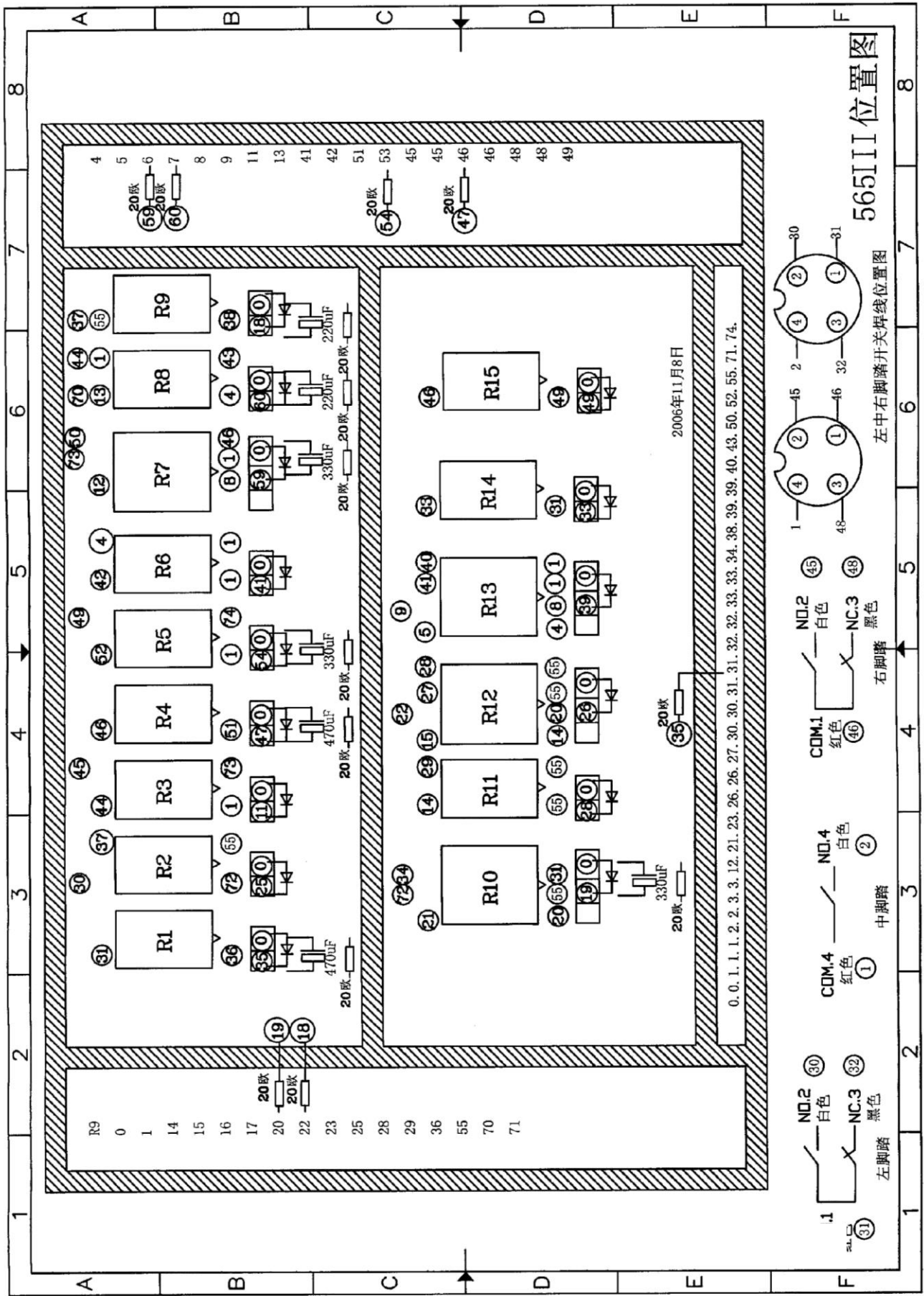
电路图1
Circuit diagram 1

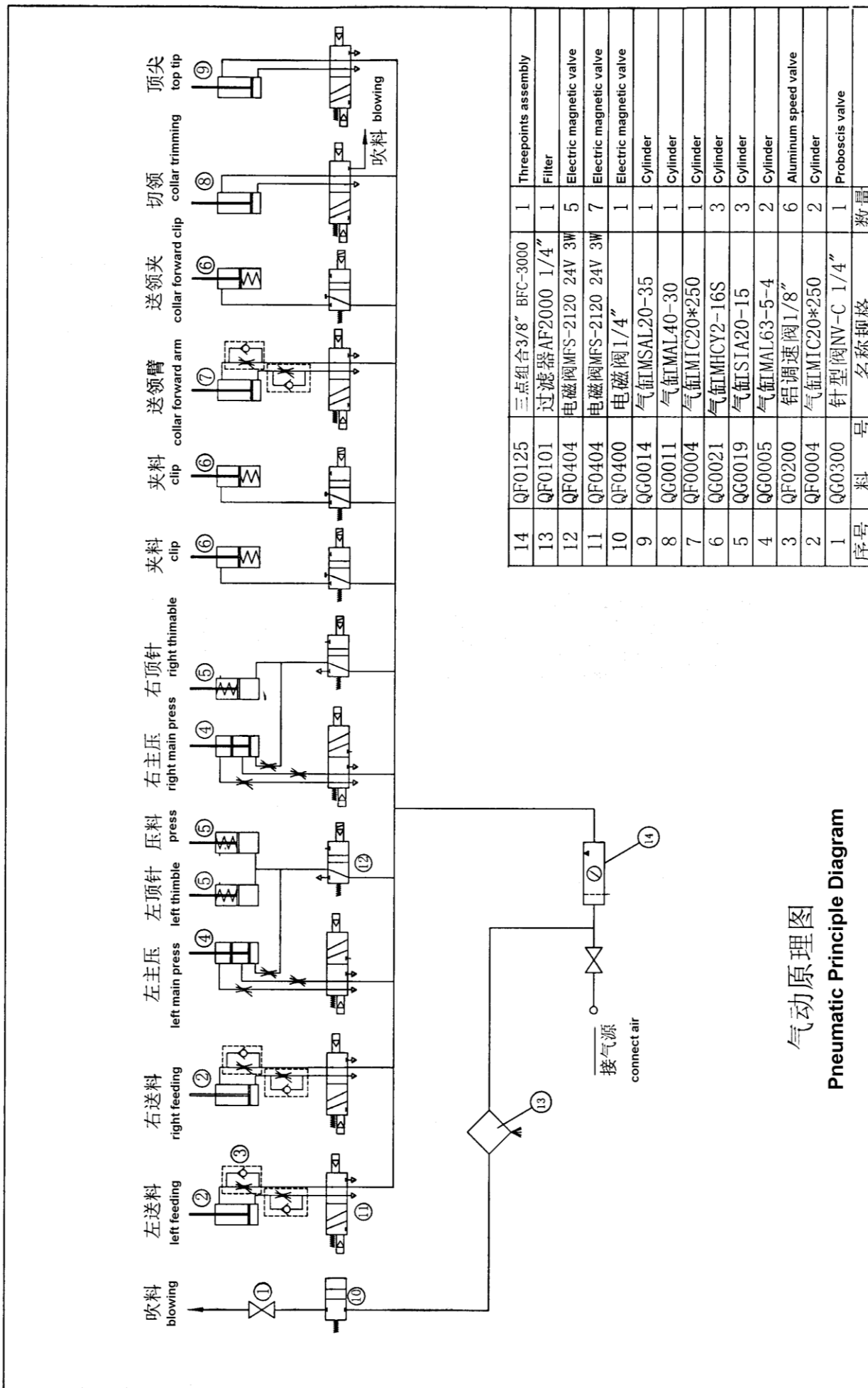


电路图2
Circuit Diagram 2



电路图3
Circuit Diagram 3

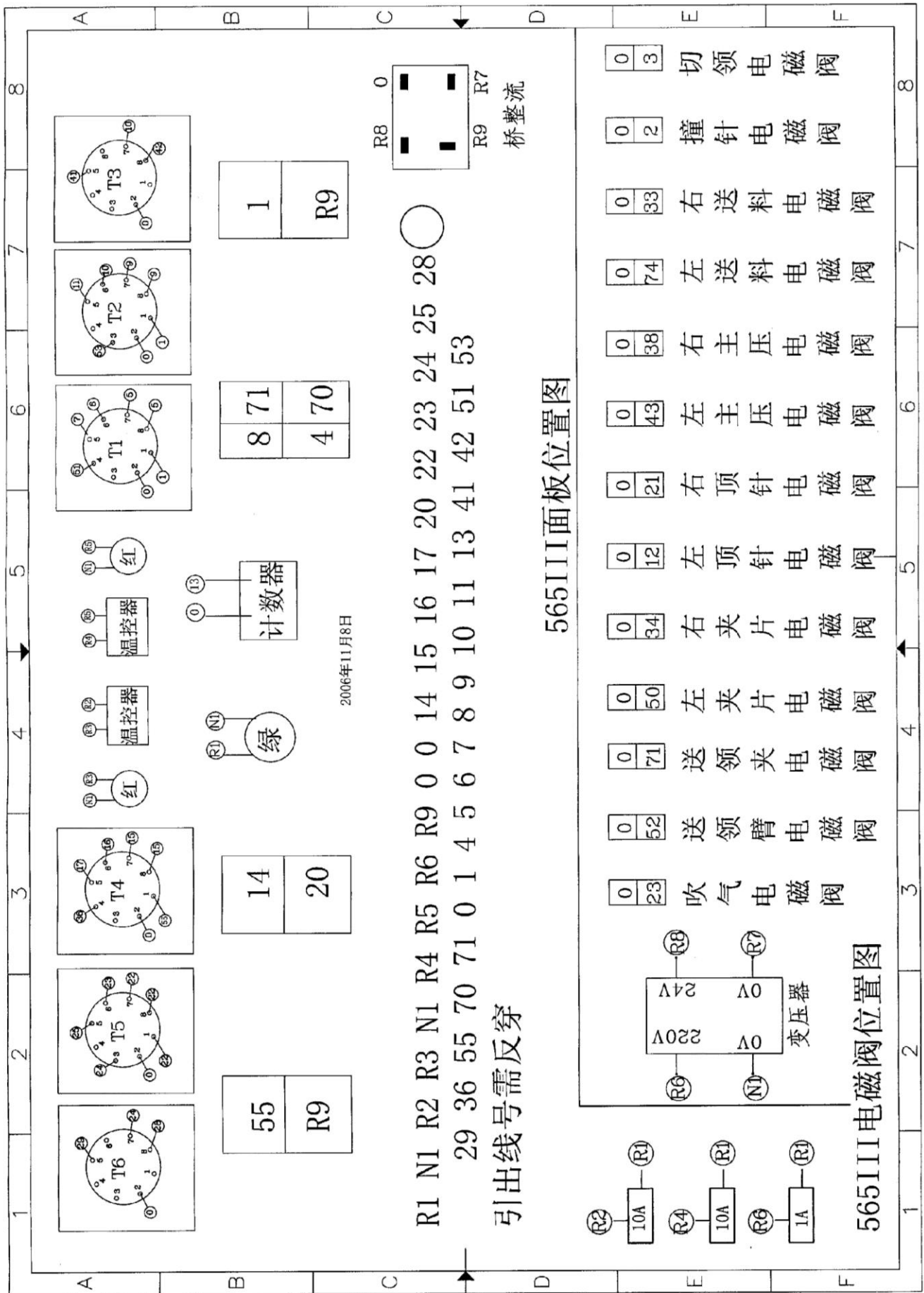




序号	料号	名称规格	数量
14	QF0125	三点组合3/8" BFC-3000	1
13	QF0101	过滤器AF2000 1/4"	1
12	QF0404	电磁阀MFS-2120 24V 3W	5
11	QF0404	电磁阀MFS-2120 24V 3W	7
10	QF0400	电磁阀1/4"	1
9	QG0014	气缸MSAL20-35	1
8	QG0011	气缸MAL40-30	1
7	QF0004	气缸MIC20*250	1
6	QG0021	气缸MHCY2-16S	3
5	QG0019	气缸SIA20-15	3
4	QG0005	气缸MAL63-5-4	2
3	QF0200	铝调速阀1/8"	6
2	QF0004	气缸MIC20*250	2
1	QG0300	针型阀NV-C 1/4"	1

气动原理图

Pneumatic Principle Diagram



隨機工具及附件一覽表 Tools and Accessories List

機型及名稱 Model no. and Item Name		自動空壓切.翻.燙領機 COLLAR AND CUFF BLOCKING MACHINE			
序號 No	部件編碼 Part no.	部件名稱規格 Part description and specification		數量 Quantity	備註 Remark
1	ZW0315	工具袋	TOOL BAG	1	
2	JG1067	M5 內六角扳手	M5 INNER HEX SPANNER	1	
3	JG1068	M6 內六角扳手	M6 INNER HEX SPANNER	1	
4	JG1030	雙頭開口扳手 14*17	TWIN-HEADS OPEN SPANNER 14*17	1	
5	DF0314	保險管 3A	FUSE 3A	1	
6	DF0317	保險管 10A	FUSE 10A	2	
7	JG6058	螺絲刀 (兩用) 150mm	SCREW BLADE (DUAL USABLE) 150MM	1	
8	QJ0110	C 式快速接頭 SP-20	C TYPE FAST CONNECTOR SP-20	1	
9	QJ0119	C 式快速接頭 PM-20	C TYPE FAST CONNECTOR PM-20	1	
10	QJ0112	C 式快速接頭 PP-20	C TYPE FAST CONNECTOR PP-20	1	
11	QH0106	氣管 $\varphi 8*6X4M$	AIR PIPE $\varphi 8*6X4M$	1	
12	JH3006	扭簧 $\varphi 1.4* \varphi 14*3n$	WRING SPRING $\varphi 1.4* \varphi 14*3n$	6	
13	ZA1102	說明書	EXPLANATION MANUAL	1	
14	313A013	前工作臺板	FRONT WORKING TABLE	1	
15	313A015	料斗 2	FABRIC FEEDER 2	1	
16	565A008	踏開關固定板	FOOT PEDAL FIXED BOARD	1	
17	JG1065	M3 內六角扳手	M3 INNER HEX SPANNER	1	