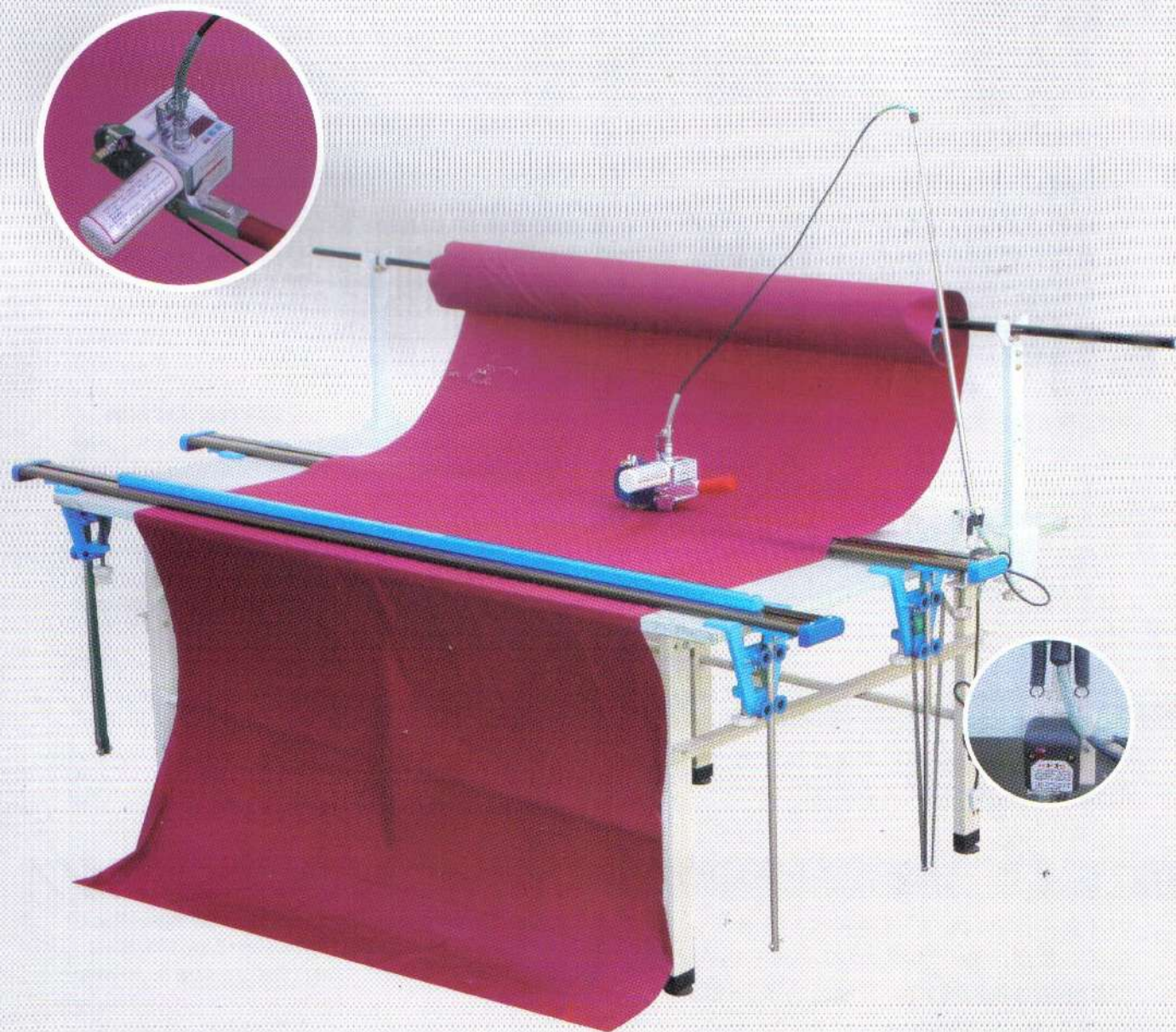


M 手动断布机说明书

MANUAL CLOTH END CUTTER BOOK



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。

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。

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 "Thissideup" 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。

D. 更换底刀

1. 旋下底刀固定板螺钉, 取下底刀固定板。
2. 拧下底刀固定螺钉, 换上新底刀, 确保底刀侧平面贴近圆刀边缘。

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5~6mm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。

F. 清洁导轨和主机

1. 当断布机连续工作10到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。

A. 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. REPLACING THE GRINDING WHEEL

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

C. 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 "thisside up" should be placed facing the operator.
5. After the blade is replaced, adjust the position of the grinder at the proper.

D. REPLACING THE KNIFE FRAME

1. TO take off the knife frame arm by unscrewing the screw for the knife frame arm.
2. Replacing the knife frame by Unscrewing the fixed screw. Replace the knife frame and ensure the flat surface of the knife frame adjacent to the blade edge.

E. 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. 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.

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:

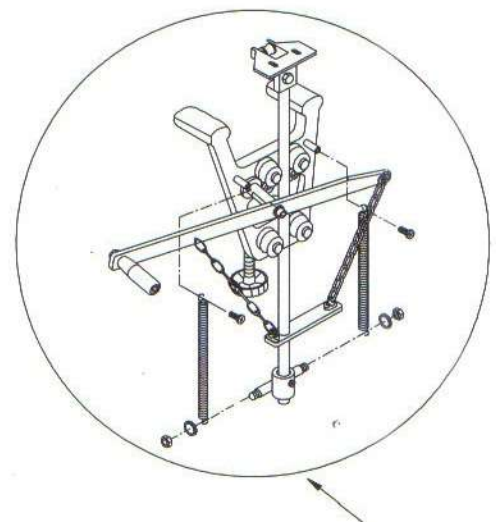
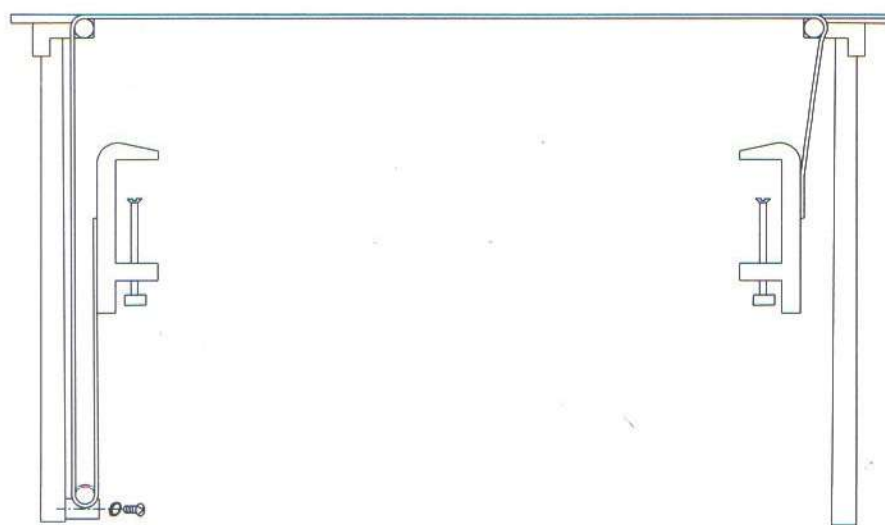
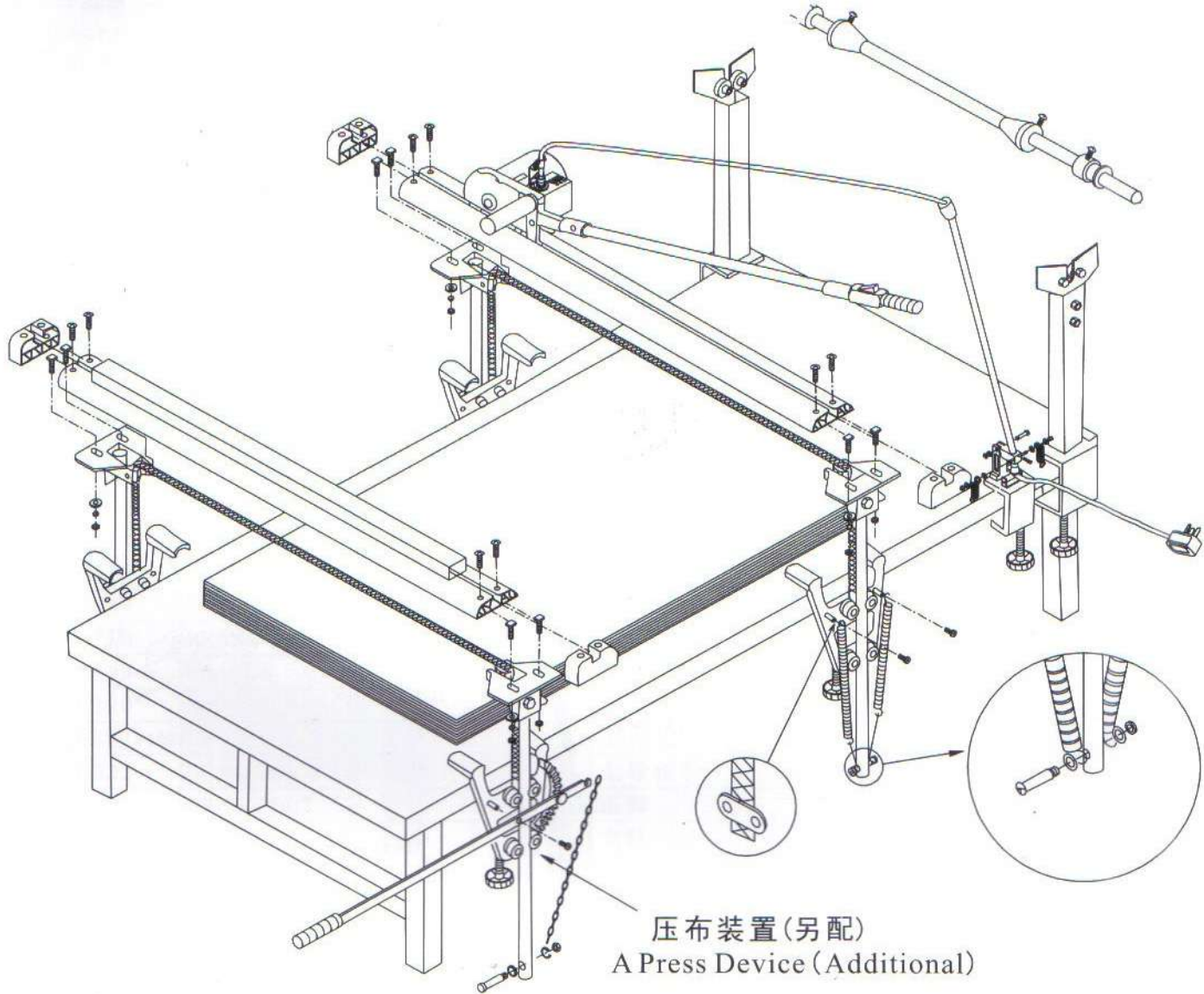
1. Before operating the machine, make sure of complete cleanness of the track surface.
2. Safety electric ground wire is used for the sake of safety.

技术参数:

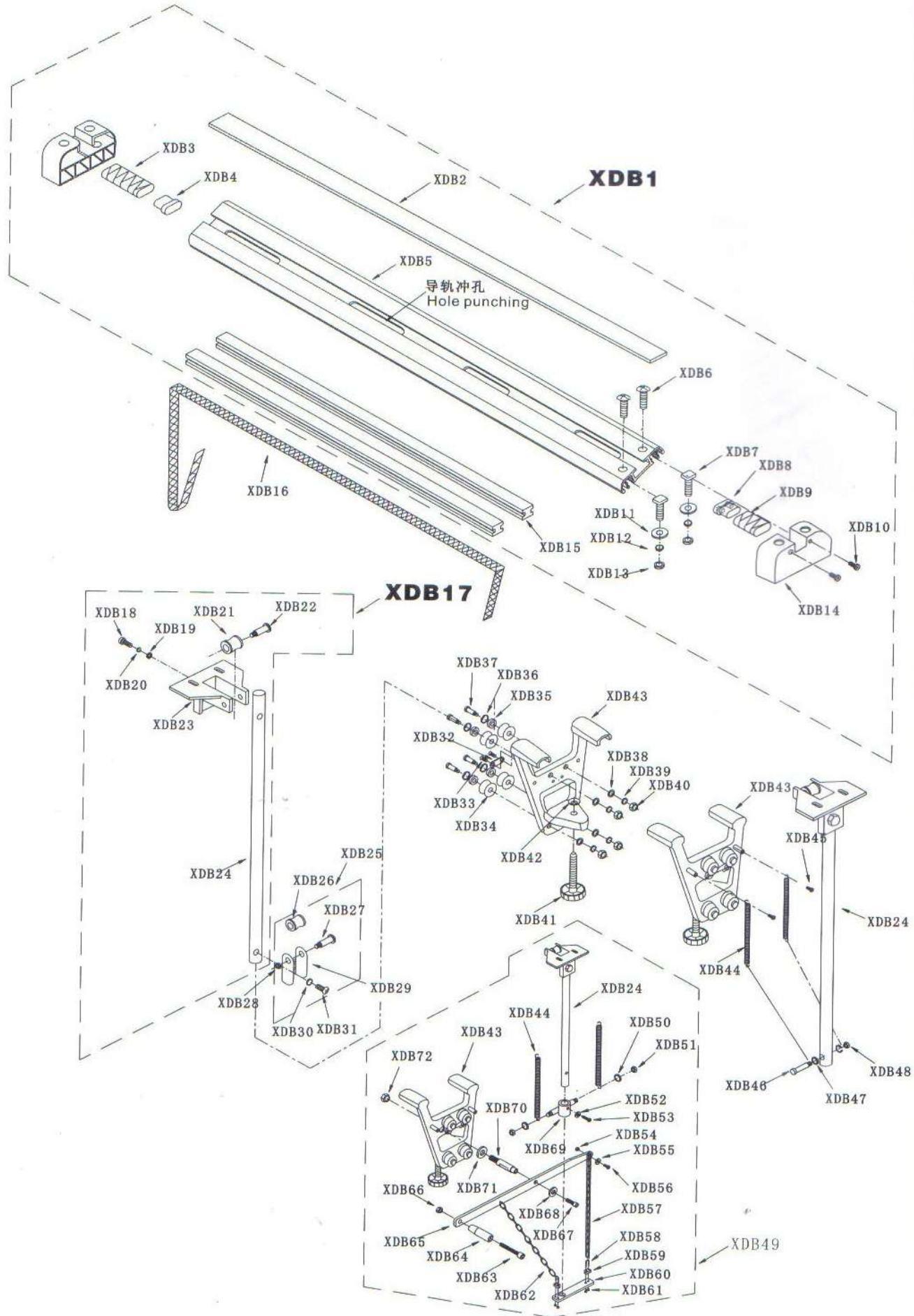
刀片直径: 108mm 刀片形状: 圆形
电压: 单相110V / 60HZ 或 220~240V / 50HZ
刀片转速: 12000转 / 分 输出功率: 160W

TECHNICAL PARAMETERS:

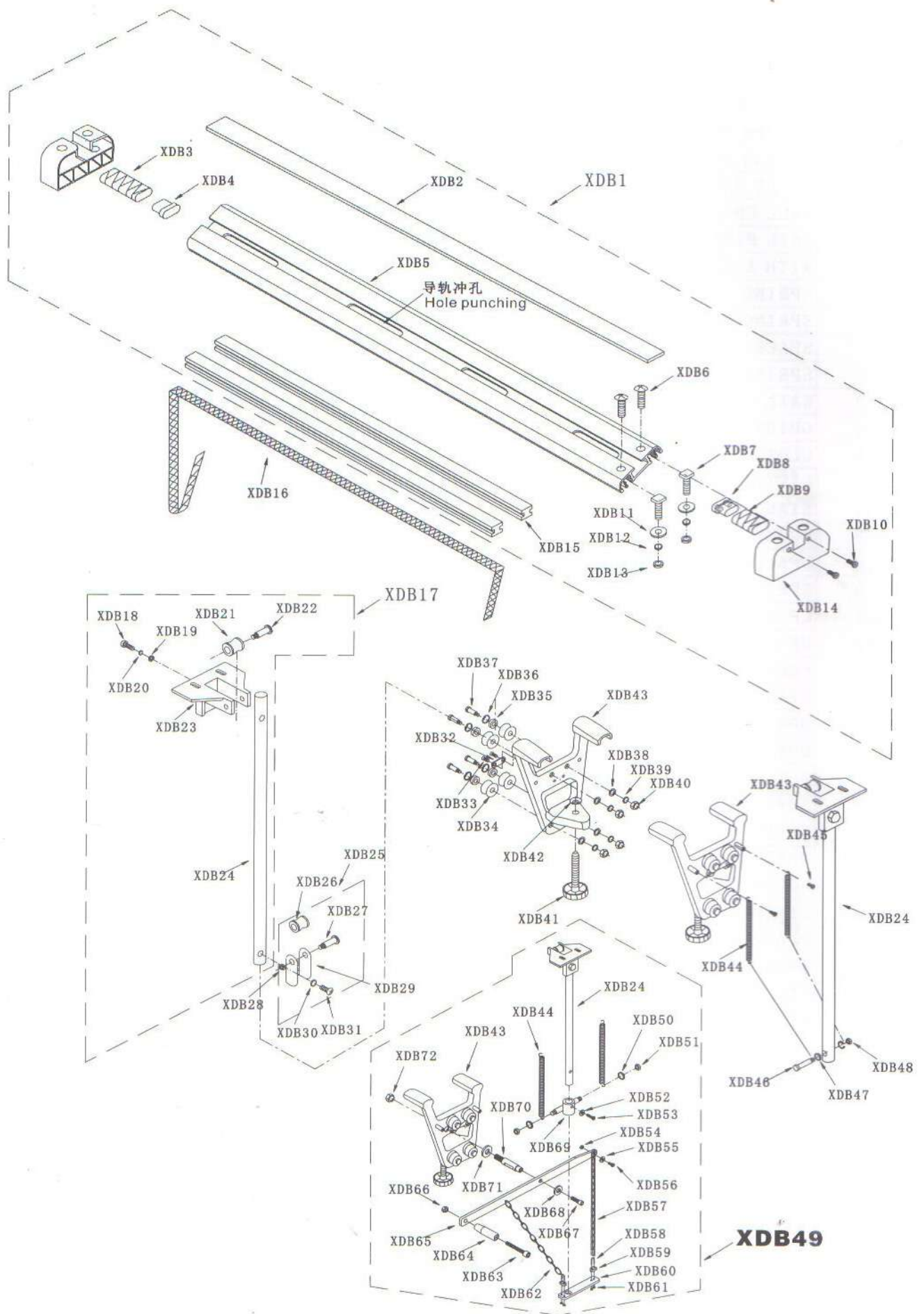
Side of Blade: 108mm Shape of the Blade: Round
Electric Pressure: Single phase 110V/60HZ or 220V-240V/50HZ
Revolving speed of the Knife: 12000 r.p.m Output: 160W



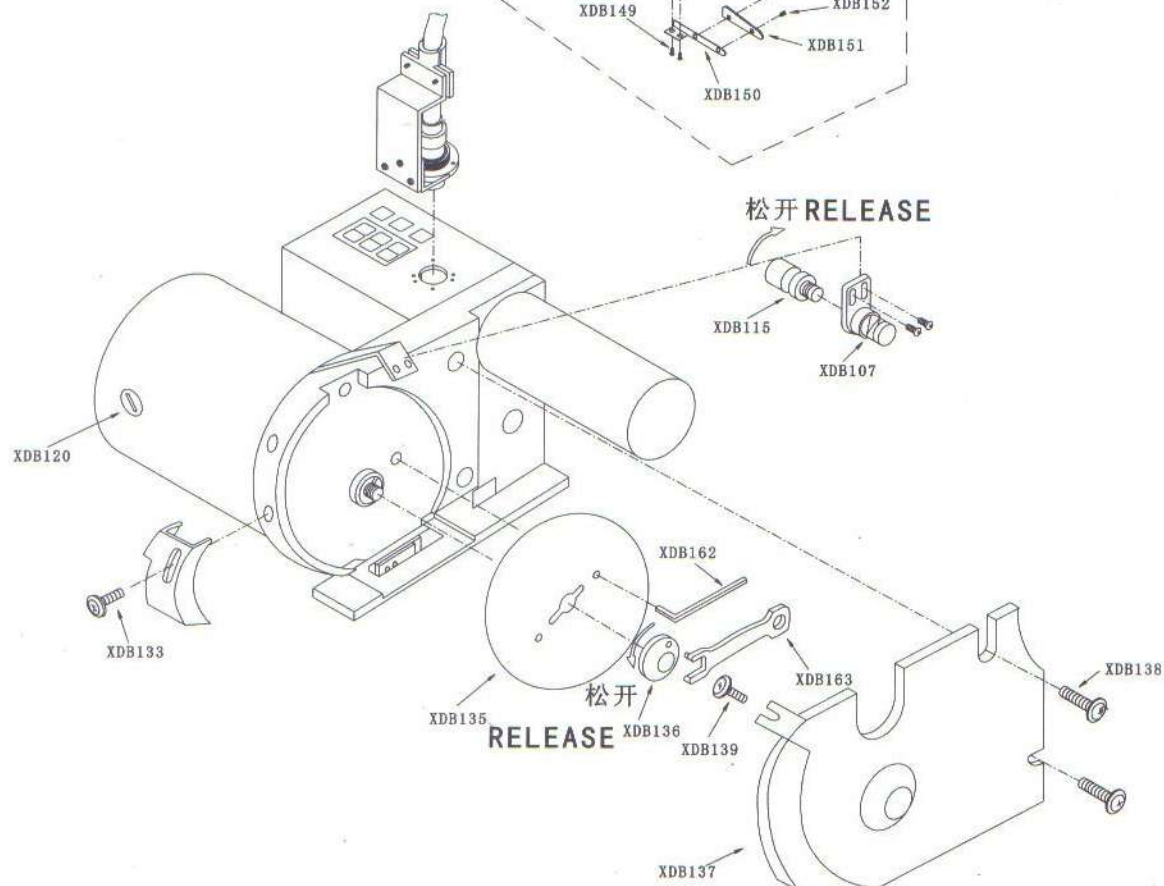
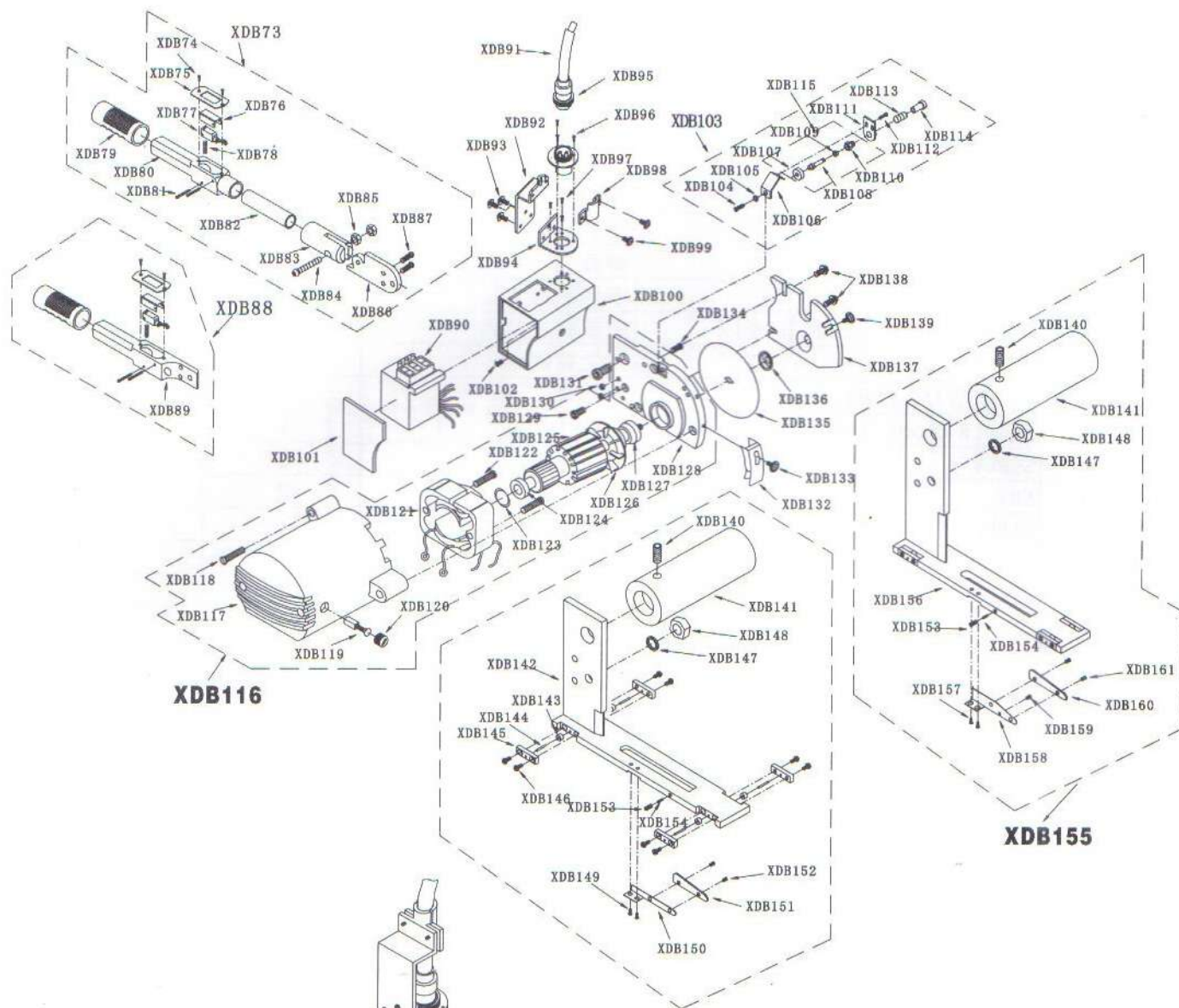
带助力器装置(选配)
Power Booster (Optional)



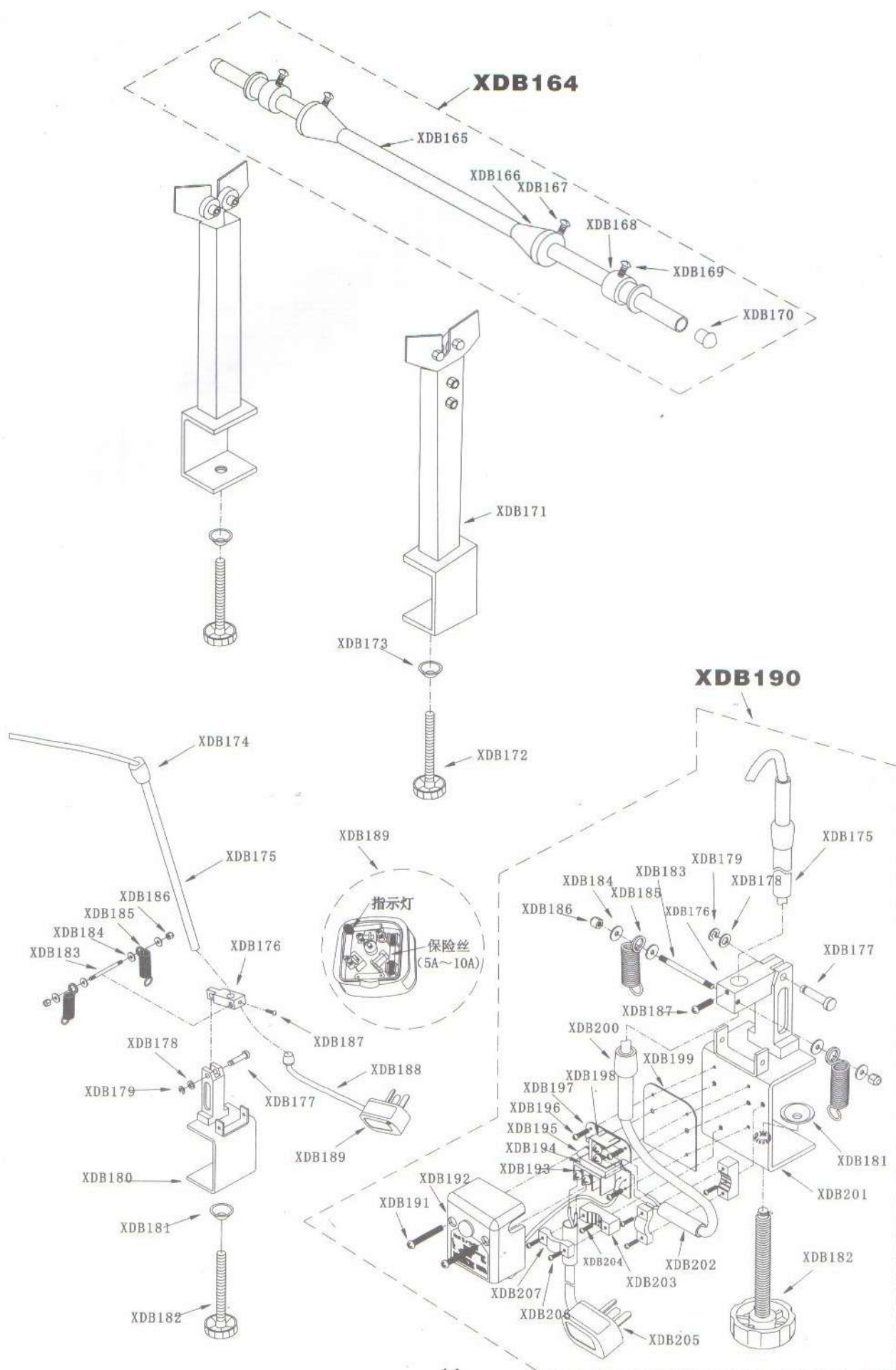
零件号 PART NO.	名 称 DESCRIPTION		数 量 NO Req'd	备注 Remarks
XDB1	GUIDE RAIL ASSEMBLY	导轨组件	1	
XDB2	GUIDE RAIL BOTTOM BELT	导轨垫带	1	
XDB3	RETURN SPRING	反弹器	1	
XDB4	SPRING PAD	弹力器碰头	1	
XDB5	GUIDE RAIL	导轨	1	
XDB6	RAIL COVER SCREW	导轨端盖螺钉	4	
XDB7	RAIL FIXED SCREW	导轨固定螺钉	4	
XDB8	WITH ALNICO SPRING PAD	带磁钢弹力器碰头	1	
XDB9	SPRING	弹簧	1	
XDB10	SPRING SCREW	弹簧螺钉	2	
XDB11	SPACER	垫片	4	
XDB12	SPRING SPACER	弹性垫片	4	
XDB13	RAIL FIXED NUT	导轨固定螺母	4	
XDB14	GUIDE RAIL COVER	导轨端盖	2	
XDB15	CLOTH PRESS PLASTIC	压布泡沫条	2	
XDB16	LIFT BELT	升降带	1	
XDB17	STAND ASSEMBLY	支杆组件	1	
XDB18	PRESS FOOT SCREW	压脚螺钉	2	
XDB19	SPACER	垫片	2	
XDB20	SPRING SPACER	弹性垫片	2	
XDB21	UP GUIDE WHEEL	上导轮	1	
XDB22	UP GUIDE WHEEL SHAFT	上导轮轴	1	
XDB23	PRES FOOT	压脚	2	
XDB24	STAND	支杆	2	
XDB25	DOWN WHEEL BRACKET ASSEMBLY	下导轮架组件	1	
XDB26	DOWN GUIDE WHEEL	下导轮	1	
XDB27	DOWN GUIDE SHAFT	下导轮轴	1	
XDB28	DOWN GUIDE SHAFT NUT	下导轮轴螺母	1	
XDB29	GUIDE WHEEL BRACKET	导轮架	1	
XDB30	SPACER	垫片	1	
XDB31	SCREW	导轮架螺钉	1	
XDB32	LIFT BELT PRESSING PLATE	升降带压板	2	
XDB33	PLATE SCREW	压板螺钉	4	
XDB34	STAND GUIDE WHEEL	支杆导轮	8	
XDB35	STAND GUIDE WHEEL SHAFT	支杆导轮轴承	8	
XDB36	BEARING SPRING	轴承卡簧	8	
XDB37	SCREW	支杆导轮螺钉	8	
XDB38	SPACER	垫片	8	
XDB39	SPRING SPACER	弹性垫片	8	
XDB40	NUT	螺母	8	
XDB41	CLAMPING HANDLE	夹紧手柄	2	
XDB42	HANDLE PRESS PLATE	手柄压板	2	
XDB43	STAND GUIDE WHEEL BRACKET	支杆导轮架	2	
XDB44	EXTENSION SPRING	拉升弹簧	3	
XDB45	SCREW	拉升弹簧螺钉	3	
XDB46	EXTENSION SPRING SHAFT	拉升弹簧轴	1	



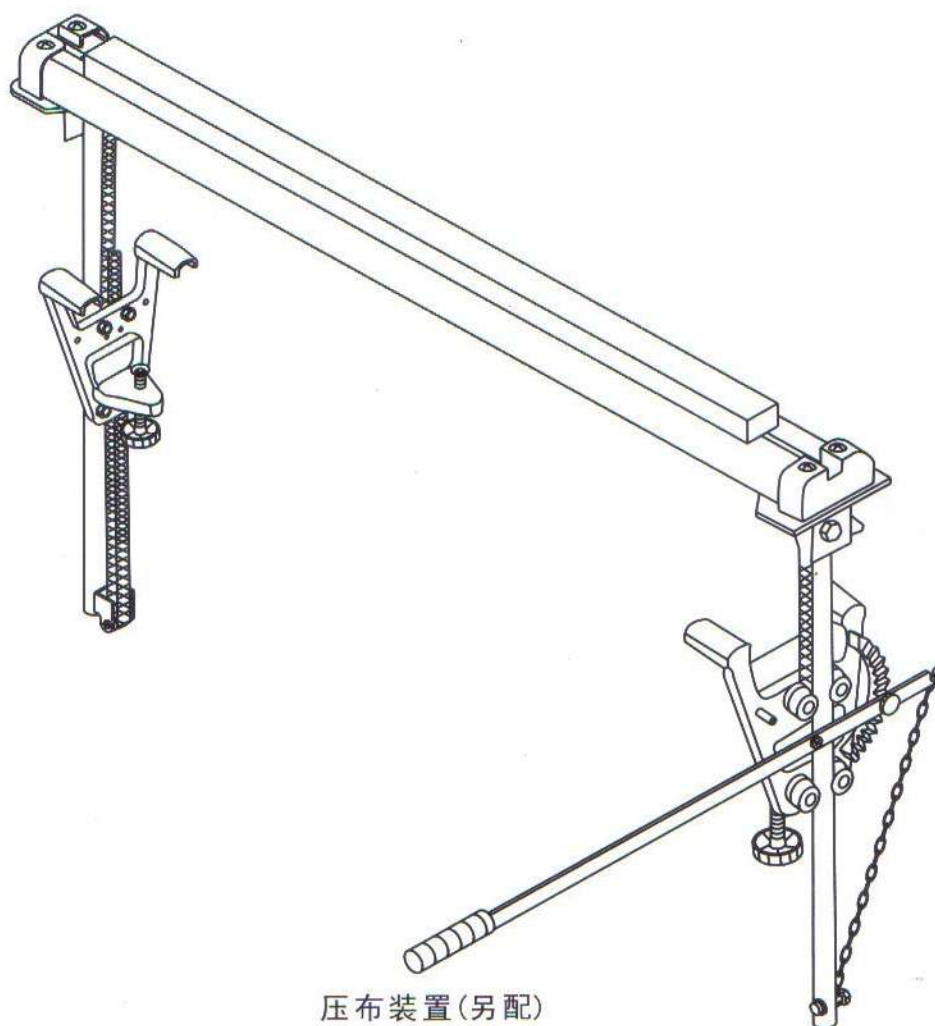
零件号 PART NO.	名 称 DESCRIPTION		数 量 NO Req'd	备注 Remarks
XDB73	LONG HANDLE ASSEMBLY	长手柄组件	1	
XDB74	SWITCH PLATE SCREW	开关压板螺钉	2	
XDB75	SWITCH PLATE	开关压板	1	
XDB76	SWITCH COVER	开关盖	1	
XDB77	SWITCH	开关	1	
XDB78	SPRING	弹簧	1	
XDB79	HANDLE COVER	手柄护套	1	
XDB80	SWITCH BOX FOR LONG HANDLE	长手柄开关盒	1	
XDB81	SCREW	开关盖螺钉	2	
XDB82	CONNECTING PIPE	连接管	1	
XDB83	HANDLE CONNECTOR	手柄连接头	1	
XDB84	SCREW	连接头螺钉	1	
XDB85	NUT	连接头螺母	2	
XDB86	HANDLE CONNECTING PLATE	手柄连接板	1	
XDB87	SCREW	连接板螺钉	2	
XDB88	SHORT HANDLE ASSEMBLY	短手柄组件	1	
XDB89	SWITCH BOX FOR SHORT HANDLE	短手柄开关盒	1	
XDB90	DELAY COUNNTER FOR SHORT HANDLE	短柄延时计数器	1	
XDB91	WIRE COVER	电线保护套	1	
XDB92	FIX BOARD	固定板	1	
XDB93	SCREW	固定板螺钉	3	
XDB94	FIX BOARD BASE	固定板座	1	
XDB95	AVIATION PLUG	航空插座	1	
XDB96	SCREW	航空插座螺钉	3	
XDB97	SCREW	固定板座螺钉	3	
XDB98	FRESS PLATE	压板	1	
XDB99	SCREW	压板螺钉	2	
XDB100	ELECTRICAL BOX	电器盒	1	
XDB101	BOX COVER	电器盒盖	1	
XDB102	SCREW	电器盒盖螺钉	1	
XDB103	GRINDING STONE BRACKET ASSEMBLY	砂轮连架组件	1	
XDB104	SCREW	砂轮架螺钉	1	
XDB105	SPACER	垫片	1	
XDB106	GRINDING STONE BRACKET	砂轮架	1	
XDB107	GRINDING STONE	砂轮	1	
XDB108	GRINDING STONE MANDREL	砂轮芯轴	1	
XDB109	GRINDING STONE BEARING	砂轮轴承	1	
XDB110	MANDREL TUBE	芯轴套	1	
XDB111	FIXED TUBE	固定套	1	
XDB112	SCREW	固定套螺钉	2	
XDB113	SPRIGN	弹簧	1	
XDB114	NUT COVER	螺套	1	
XDB115	GRINDING STONE ASSEMBLY	砂轮组件	1	
XDB116	MOTOR ASSEMBLY	电机组件	1	
XDB117	MOTOR COVER	电机外壳	1	
XDB118	SCREW	电机螺钉	3	



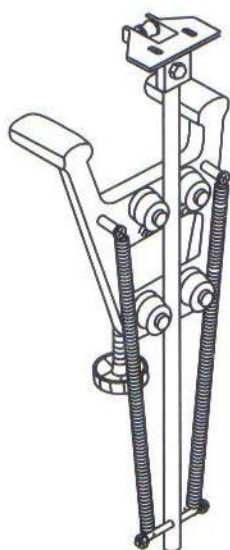
零件号 PART NO.	名 称 DESCRIPTION		数 量 NO Req'd	备注 Remarks
XDB119	CARBON BRUSH	碳刷组件	2	
XDB120	CARBON BRUSH COVER	碳刷盖	2	
XDB121	STATOR ASSEMBLY	定子组件	1	
XDB122	STATOR FIXED SCREW	定子固定螺钉	2	
XDB123	WAVE WASHER	波形垫圈	1	
XDB124	BACK BEARING	后轴承	1	
XDB125	ROTOR ASSEMBLY	转子组件	1	
XDB126	FAN	风叶	1	
XDB127	FRONT BEARING	前轴承	1	
XDB128	KNIFE BRACKET	刀架	1	
XDB129	SCREW	螺钉	1	
XDB130	NUT	螺母	2	
XDB131	BALANCE STAND SCREW	平衡柱螺钉	1	
XDB132	KNIFE HEAD PROTECTOR	刀头防护罩	1	
XDB133	SCREW	防护罩螺钉	1	
XDB134	SCREW	螺钉	1	
XDB135	KNIFE	刀片	1	
XDB136	KNIFE FIXED NUT	刀片锁紧螺母	1	
XDB137	KNIFE PROTECTOR	刀片防护罩	1	
XDB138	SCREW	防护罩螺钉	2	
XDB139	SCREW	防护罩螺钉	1	
XDB140	FIXED SCREW	紧定螺钉	1	
XDB141	BALANCE STAND	平衡柱	1	
XDB142	WEIGHT STAY PLATE	立板(1型)	1	
XDB143	ROLLER	滚轮	4	
XDB144	ROLLER SHAFT	滚轮轴	4	
XDB145	ROLLER PRESS PLATE	滚轮压板	4	
XDB146	SCREW	压板螺钉	8	
XDB147	SPRING SPACER	弹性垫片	1	
XDB148	NUT	螺母	1	
XDB149	SPRING SCREW	弹簧螺钉	2	
XDB150	BOTTOM KNIFE FIXATION	底刀固定板(1型)	1	
XDB151	BOTTOM KNIFE	底刀(1型)	1	
XDB152	SCREW	底刀螺钉	2	
XDB153	SCREW	底刀螺钉	1	
XDB154	SPRING	底刀弹簧	1	
XDB155	HEIGHTEN WEIGHT STAY PLATE	加高立板(2型)	1	
XDB156	WEIGHT STAY PLATE	立板(2型)	1	
XDB157	SPRING SCREW	弹簧螺钉	2	
XDB158	BOTTOMKNIFE FIXATION	底刀固定板(2型)	1	
XDB159	SCREW	底刀螺钉	1	
XDB160	BOTTOM KNIFE	底刀(2型)	1	
XDB161	SCREW	底刀螺钉	2	
XDB162	WRENCH	内六角扳手	1	
XDB163	WRENCH FOR FIXING KNIFE	刀片安装扳手	1	



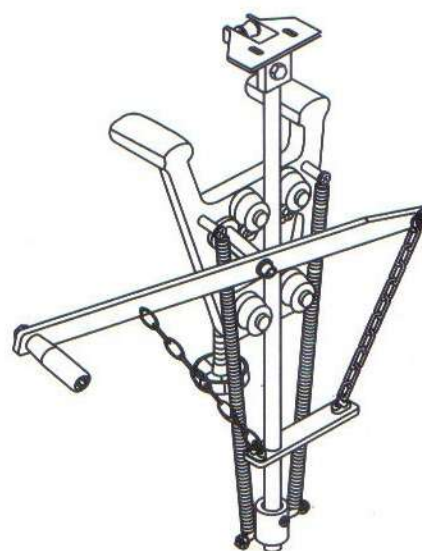
零件号 PART NO.	名 称 DESCRIPTION		数 量 NO Req'd	备 注 Remarks
XDB164	STAND SHAFT ASSEMBLY	支撑杆组件	1	
XDB165	STAND SHAFT	支撑杆	1	
XDB166	TUBE COVER	锥挡套	2	
XDB167	SCREW	T型螺钉	2	
XDB168	FIXER	扎头	2	
XDB169	SCREW	扎头螺钉	2	
XDB170	SHAFT PLUG	支撑杆堵头	2	
XDB171	SHAFT ASSEMBLY	支架组件	2	
XDB172	HANDLE	支架压紧手柄	2	
XDB173	HANDLE PLATE	手柄压板	2	
XDB174	WIRE TUBE COVER	电线护套	2	
XDB175	WIRE STANDER	电线竖管	1	
XDB176	MOVABLE BLOCK	竖管活动块	1	
XDB177	SCREW	支架螺钉	1	
XDB178	SPRING SPACER	弹性垫片	1	
XDB179	CIRCLIP	卡簧	1	
XDB180	WIRE STANDER BASE	电线支架座	1	
XDB181	HANDLE PRESS PLATE	手柄压板	1	
XDB182	STAND HANDLE	支架座手柄	1	
XDB183	SPRING BOLT	弹簧螺栓	1	
XDB184	WASHER	挡圈	4	
XDB185	SPRING	弹簧	2	
XDB186	NUT	弹簧保险螺母	2	
XDB187	SCREW	竖管紧定螺钉	1	
XDB188	WIRE	电源线	1	
XDB189	PLUG WITH FUSE 5A~10A	带保险丝插头5A~10A	1	
XDB190	FUSE BOX STANDER ASSEMBLY	保险盒支架座组件	1	
XDB191	SCREW	保险盒螺钉	2	
XDB192	FUSE BOX	保险盒	1	
XDB193	3 SLOT OF CONNECT WIRE	3槽接线座	1	
XDB194	FUSE WIRE PLACE	保险丝座	1	
XDB195	PILOT LAMP	指示灯	1	
XDB196	SCREW	线路板螺钉	3	
XDB197	CIRCUIT BOARD	线路板	1	
XDB198	2 SLOT OF CONNECT WIRE	2槽接线座	1	
XDB199	INSULATION BOARD	绝缘板	1	
XDB200	WIRE TUBE COVER	电线护套	2	
XDB201	WIRE STANDER BASE	电线支架座	1	
XDB202	WIRE TUBE COVER	电缆护套	2	
XDB203	PROTECT CASE CLIP (DOWN)	护套下线夹	2	
XDB204	SCREW	护套下线夹螺钉	2	
XDB205	PLUG	普通插头	1	
XDB206	PROTECT CASE CLIP (UP)	护套上线夹	2	
XDB207	SCREW	护套上线夹螺钉	4	



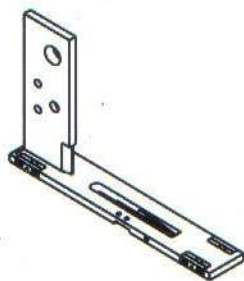
压布装置(另配)
A Press Device (Additional)



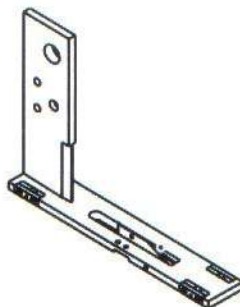
标配
Standard



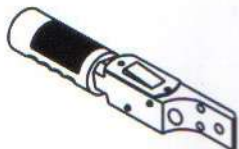
XDB49
带助力器装置(选配)
Power Booster (Optional)



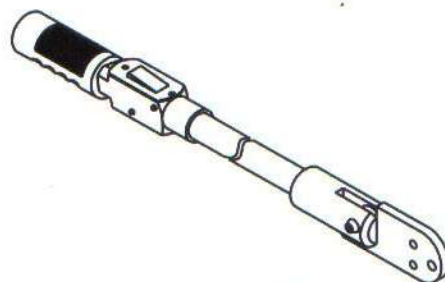
立板(标配)
Upright Plate (Standard)



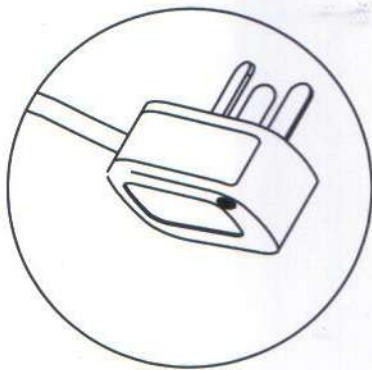
XDB155
加高立板(选配)
Heightened Upright Plate
(Optional)



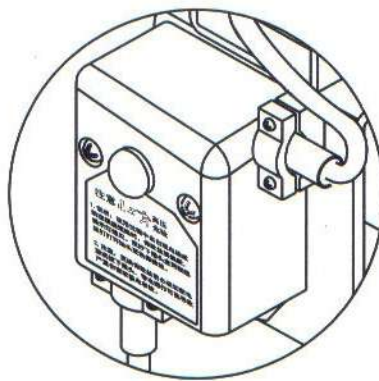
XDB88
短手柄(标配)
Short Handle (Standard)



XDB73
长手柄(选配)
Long Handle (Optional)



XDB189
带保险丝三扁插(标配)
Three-flat Plug with Fuse
(Standard)



XDB190
豪华型(选配)
电器盒内带保险丝、开关,
插头可配各种型号规格
Deluxe Socket (Optional)
An electrical Box with Fuses and Switch
Matching various types of plugs