

HF-705 多功能鞋子包边机

Multi-functional shoes folding machine

使用说明书/Instruction Book



一：主要参数/ Main Parameter list

电 压/Voltage: AC220V 50Hz

功 率/Power: 3.04KW

气 压/Pressure: 0.5MPa

工作宽度/Working Width: 一般为 normally 10mm、15mm

机身尺寸/Machine Dimension: 120cm(L) x 54cm(W) x 135cm(H)

机身重量/Machine Weight: 130KG

二：开机前检查 / Inspection before start

1. 机器是否放置平稳状态，如不平稳，可调校机底 4 个胶轮的高低，直至平稳；

Please check the steady of the machine, if not, please adjust the height of the 4 Omni-directional wheels until it is stable;

2. 电源接入 L(相线)，N（零线），E（地线），必须接地可靠；

Please connect the L and N Lines to make sure the grounding reliability;

3. 压缩空气接入气压不得低于 0.5MPa；

The compressed air pressure has to connect at least 0.5MPa;

4. 送带装置等零配件是否已正确安装好；

Please check the tape folder and all the spare parts are installed correctly or not;

5. 控制中心内部参数设定是否与出厂值一致，出厂值参数（如图 1 所示），工程师画面：A 电机滚轮上限值 60，B 电机滚轮上限值 100，C、D 电机滚轮上限值 96。上下吹风 350，上下皮带 250。

Please make sure that all the internal parameter list setting of control center are the same as factory standard set-up, the exact number are as shown as picture 1, Engineering page: the maximum data of A motor wheel is 60, B motor wheel is 100, C, D motor wheel is 96. Up and down blower is 350, up and down belt is 250.



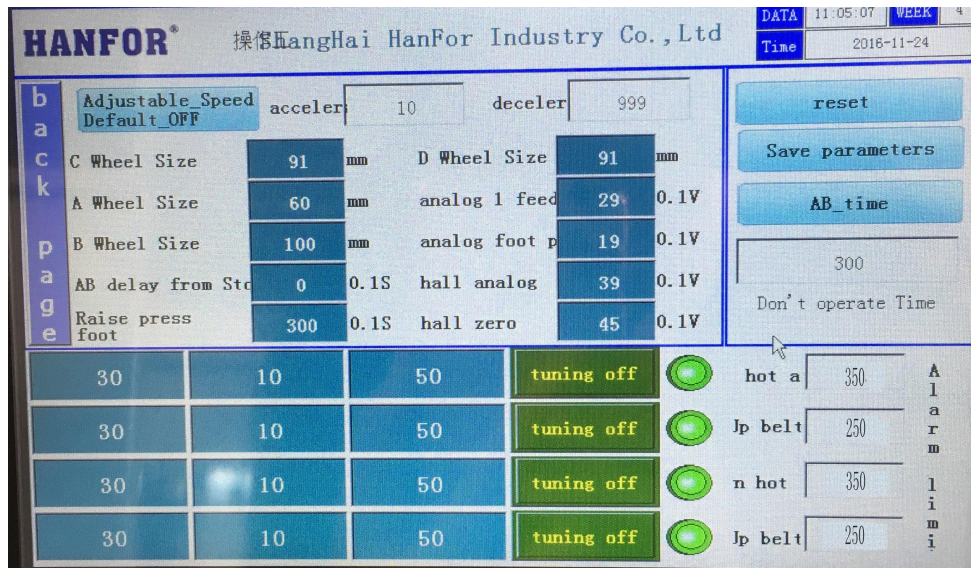


图 1 工程师画面参数

Picture 1: Engineering Page Parameter List

注：开机操作员与管理员出厂密码均为 1，工程画面参数为厂家调校机器时所设定的参数，不得随意更改，否则会影响机器运转性能。

Note: The original password from factory of operator and administrator is 1, all the parameter list of engineering page setting can not change arbitrary, otherwise it will effect the machine performance.

三：开机检测/ Inspection after start

1. 检测上下轮压力:接入主气管，在没有压力的情况下，向上抬起上轮臂，观察加压后抬起的力度是否增大。

Please check the pressure of up and down roller:connect the main air pipe, lift the up roller by pedal under the circumstance without any pressure, observe the strength will increase or not after putting more pressure.

2. 上轮臂：是否能够抬起，不能则有堵气状况。

Please check the up roller arm can be lifted or not, it can not allowed the status with the blocked air.

3. 送带检测：穿好胶条，胶条应该保持一定的张力，否则容易造成偏带。

Inspection of the tape folder: please get ready of the tape to make sure the fixed strength in case of the mis-leading.

4. 气流检测：检查上下吹气是否正常。

Please inspect the air flow of the up and down blower is normal or not.

5. 上下吹气，上皮带，下皮带，加热包等加热设备是否正常加热，改变加热温度，检测温度变化是否正常。

Please check the status of the heating equipment like up and down blower, up and down belt, heating bags can be worked properly or not, please change the heating temperature to check the degree change.

6. 上下轮右侧边平齐。

Please keep the same distance of the right side of the up and down roller.

7. 通气的环境下，加热包在脚踏板前后踩时，能够左右移动。

Under the circumstance of connecting the compressed air, the heating bag can move flexible when you step forward and back the pedal.

8. 控制面板检测/Control board inspection:

(1) 首页：速比设置所有值均为 100;

The first page: the set up data of rate should be 100;

上电机和下电机速度均为 4000mm/min;

The speed of up and down motor is 4000mm/min;

切换速比，检测速比是否改变。（如图 2 所示）

Please switch the rate to check if you can change the rate.

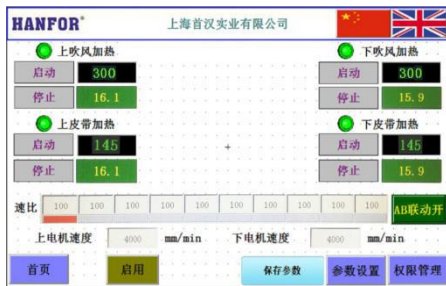


图 2 首页参数

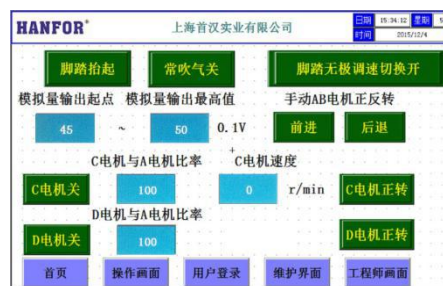
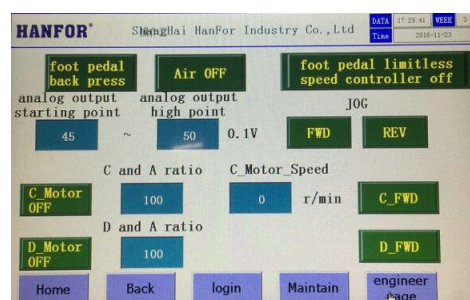


图 3 参数设置



Picture 2 First page parameter



Picture 3 First page parameter setting

(2) 参数设置/Parameter setting:

手动 A、B 电机前进后退是否正常；

Please check the manual A/B motor can move forward or back status;

脚踏无极调速，看是否会发生变化。（如图 3 所示）

Please check the non-polar speed adjusting, if they can change or not.

四. 320 皮带更换/ Belt Change

1. 如图 4 所示，更换上皮带：

As shown as picture 4, steps of changing the belt:

- (1) 拧下外罩固定螺钉/Screw out the cover and fix the bolt;
- (2) 拧松调节旋钮/loose and adjust the knob;
- (3) 取下外保护罩/take off the outer cover;
- (4) 拧下下皮带压轮/screw out the pinch roller of down belt;
- (5) 换取新皮带，按照既定位置安放，不能有偏移状况，然后按相反的顺序安装。

Please change the new belt and settle down as per the fixed position, then install by the reverse order to make sure misregistration.



图 4 皮带换取示意图

注：若要换取导槽，也可直接取下，按照拆卸相反方向装回即可。

Note: If you want to change the chute, you can take it out directly or replace it by opposite way when you tear down .

如图 5，图 6 所示，更换下皮带：

As shown as picture5 and 6, step of belt change as below:

- (1) 拧下下护罩固定螺钉/take off the down protection cover and stable the screw;
- (2) 取下护罩/take down the cover;
- (3) 拧下下加热块固定螺钉，取下加热块，皮带放松/take off the down heating block and stable the screw, get the heating block down and loose the belt;
- (4) 换取新皮带，按照既定位置安放，不能有偏移状况，然后按相反的顺序安装。

Please change the new belt and settle down as per the fixed position, then install by the reverse order to make sure misregistration.

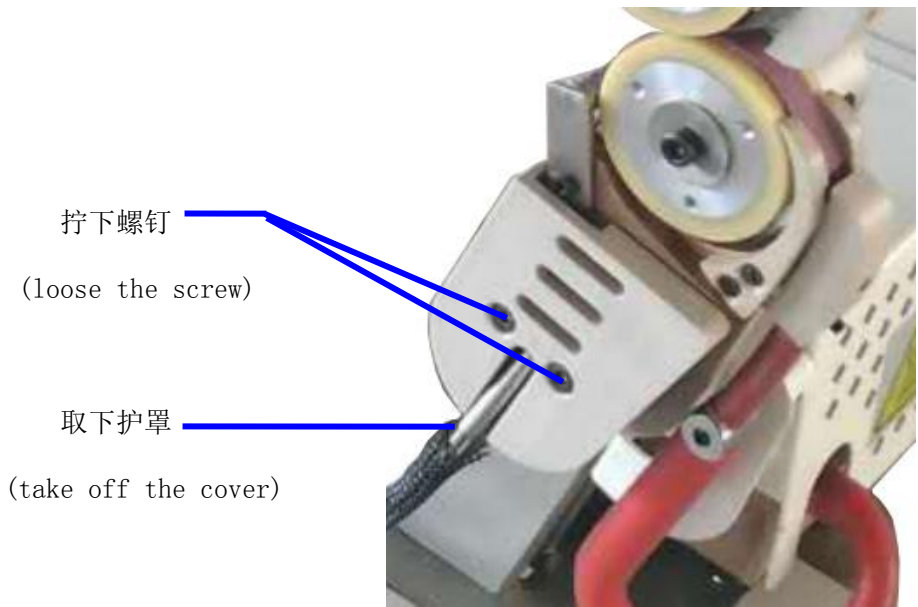


图5 下护罩拆卸示意图/ Drawing of down cover remove

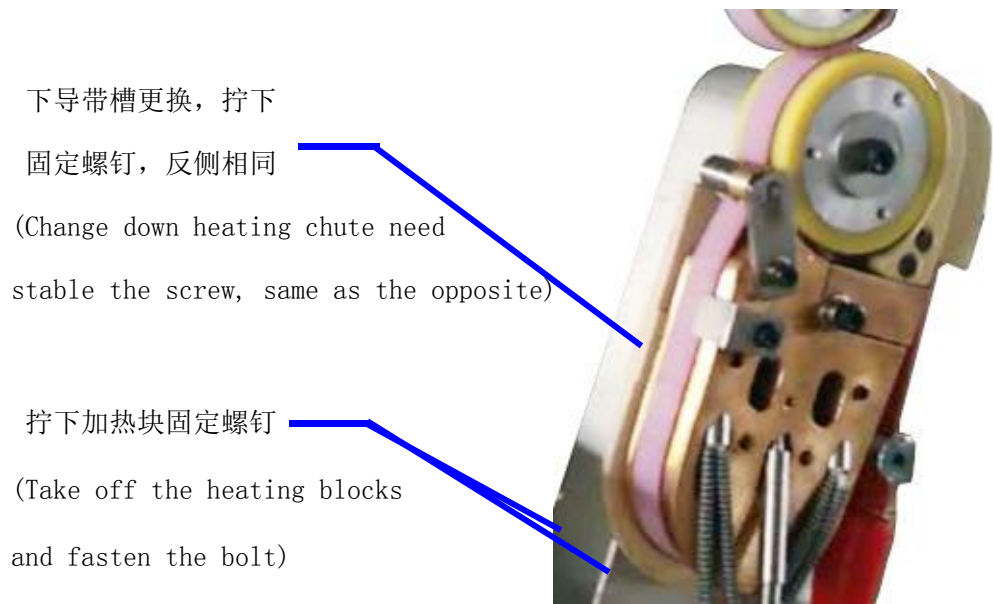


图6 下加热块拆卸示意图/Diagram of down chute change

五. 开机步骤/ Starting up

1. 双贴条: 1)调校好工件所需上、下吹风, 上、下皮带温度 ($T_{\text{皮带}} < T_{\text{吹风}}$), 设置合适的上下电机速度。一般上下轮速比为 100, 缩率可改变速比进行调节(如图 7 所示)。本机可保存 10 个速比, 每次可通过台板下方速比切换开关进行选择。

1. Bond the cloth tape at both side:

1) adjust the required temperature of up and down belt and blower ($T_{\text{belt}} < T_{\text{blower}}$), set the appropriate speed of up and down electronic motor. Normally the speed rate of up and down roller is 100, the buckling can be adjusted according to the different rate as shown as picture 7. We have already saved 10 rates in the machine, you can switch the button which below the table to adjust it.

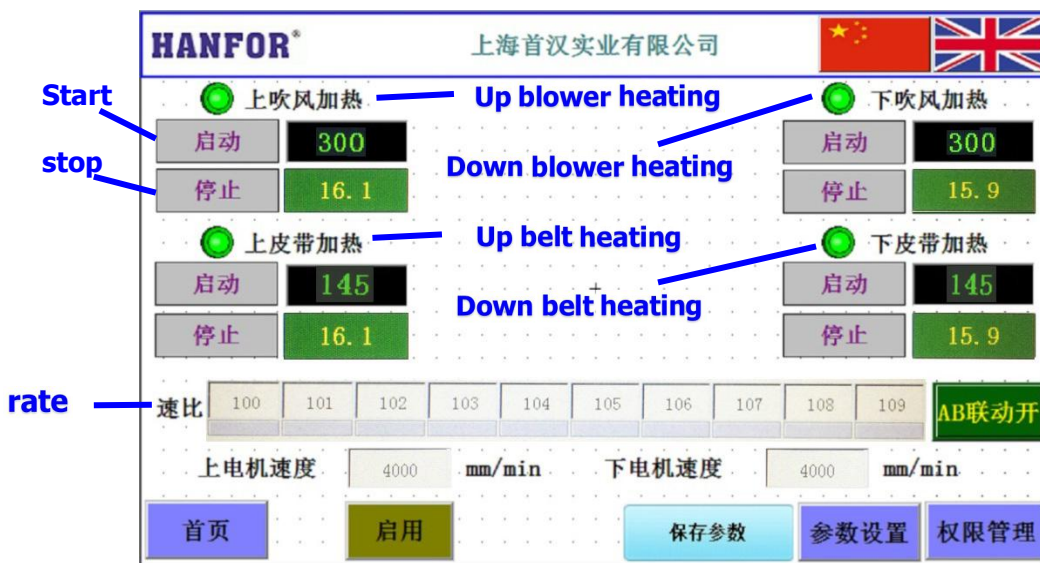


图 7 速比/ Picture7 rate

注: 吹风温度可设置在 240~280 之间, 皮带温度可设置在 180~200 之间(此数值仅供参考, 以实际布料能够贴胶为主)。单贴条上吹风温度可设置 260~300 之间, 上皮带可设置在 240~260 之间。

Note: The temperature of blowers can be set up around 240-280 degree, the temperature of belts can be settled around 180-200 degree (This data is just for reference, the actual temperature has to set up for bonding properly of the exact fabric)

2)脚向前按下脚踏开关, 上轮下压/Step the pedal forward, the roller goes down

3)脚踏向后踩, 上轮抬起, 机器工作停止/Step the pedal back, the roller goes up, the machine stops working

2. 双包边:

1) 安装好拉筒, 调校好上、下吹风, 上、下皮带温度, 设置合适的电机速度。

Install the tape folder, adjust the temperature of up and down blowers and belts, set up the proper speed of electronic motor.

2) 布料测试拉筒位置安装是否正确, 不正确则进行调整, 直至正常工作。

Check the tape folder location whether it is suitable, if not please adjust until it works properly.

注: 吹风温度可设置在 260~300 之间, 皮带温度可设置在 200~220 之间(此数值仅供参考, 以实际布料能够贴胶为主)。单包边上吹风温度可设置 260~300 之间, 上皮带可设置在 240~260 之间。

Note: The temperature of blowers can be set up around 260-300 degree, belts temperature around 200-220 degree (This data is just for reference, the actual temperature has to set up for bonding properly of the exact fabric). The temperature of shoes mouth single side folding can be set up around 260-300 degree, the up belt temperature around 240-260 degree.

六. 维护与保养/ Maintenance

1. 定期清理皮带上的残胶及污垢/ Please clean the reserved tape and dirt of the belts at fixed date.

2. 定期检查各气管接头是否有漏气现象, 及时处理检修恢复原位。以免影响加热, 加压等效果。

Please inspect the phenomenon of air leak between the gas pipe connections, please it occurs, please repair it in time in case of effecting the performance of the heating process and pressure increasing!