

Instructions:

一：开启(15)机器正常通电，过多 10 秒 机器就可正常运行

一： Turn on (15)to power up the machine , after 10 seconds ,machine can be operated normally.

二： 踩踏(13)（上下刀模接近)同时下刀模发波旋转，放进物料就可切断物料

二： Tread (13) (upper and lower mould get close)at the same time the lower cutter mould rotates and releases the ultrasonic , then the fabric can cut off if put them on the lower cutter.

如果不能切断可能有以下原因

Possible reason if it can not be cut off:

1. 上下刀模未接触可调松 (14)让上下刀模刚好接触即可，如接触太多就会发出刺耳的响声

1. loosen (14) to let the upper and lower cutter mould just touch, touching to much will cause a loud noise.

2. ⑦压力指针可调大，一般数值在 0.1~0.4Mpa 即可，不可长时间高过 0.5Mpa

2. ⑦ pressure pointer is adjustable, normally, 0.1~0.4Mpa is OK, Can't higher than 0.5Map for long time.

3. 参考⑥说明书，振幅输出可从 50%~100%（如果是 100%就无须调整）

3.Refer to the ⑥ instruction, the amplitude output can range from

50%~100% (if it is 100%, no adjustment is required).

4. 上刀摸⑧是否钝了，如果钝了直接更换

以上 4 种情况如果都排除，物料还是无法切断，则需要检查⑨下刀模是否有振动发波。以上检查之前看是否与能切的布料不同，切不断的布料偏厚或很厚。如果很厚，建议调试⑩可视操控面板里面的上下刀模速度，建议放慢上下刀模的速度。

4.To check whether ⑧ the Upper cutter mould is blunt, if so ,change a new one.

If all of the above 4 cases are excluded, the material still cannot be cut off. You need to check ⑨ to see if the lower cutter mould have vibrated and released the ultrasonic. Before checking the ⑨, you need to see whether this fabric is different from the fabric that can be cut. If the fabric is thick, we recommended you to slow down the upper and lower cutter by touch the ⑩ visual control panel.

三：打开(11)可直接跟换下刀模（下刀模是正牙，用扳手往逆时针方向即可松出。反方向则紧）

三： You can replace the lower cutter mould directly after opening the(11) (Use a wrench to release the lower cutter mould in counterclockwise , reverse direction is tight)

四：开机之前确保(12)压力表在 0.6Mpa 以上

四： Ensure (12) the pressure gauge is above 0.6mpa before start the machine

五：如果机器正常操作过程中上下刀模不转动则有可能是图 2 中的③螺丝松动。下模不转则可能是图 3 中⑨组件皮带轮松动

五：

If the upper and lower cutter mould do not rotate during the normal operation , it may be the loosening of the ③screws in Figure 2. If the lower cutter mould do not rotate, it may be the loosening of the ⑨belt pulley in Figure 3.

