Spreading machine installation tutorial

1. Survey site

1.1 Temporary placement of the machine, direction, passage

1.2 The height of the lamp tube above the table used by the equipment, the installation position of the electric control box

1.3 Determine the path of machine entry

2. Un-boxing

2.1 Check if the outer box is intact

2.2 Use tools to open the wooden box and the screws to fix the machine

2.3 Find out the parts list and check if there are any missing parts

3. Lift the machine

3.1 The first floor: the whole machine can be directly lifted to the table with the table pole

On the second floor or above (it can be separated due to the width of the stairway): the upper and lower host separation lift

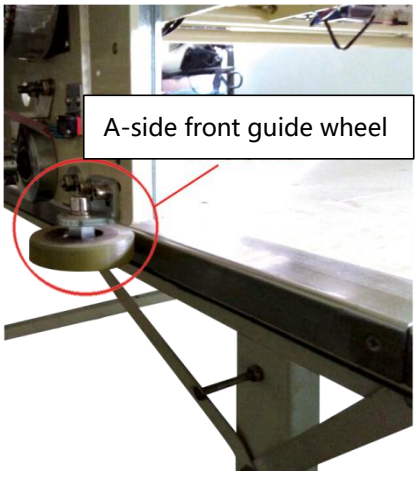
method (separation needs to be removed: anti-rocker, opposite motor connection line, induction connection line, warning light line), first lift the lower host to the designated position, then lift up the host

3.1 The second floor or above (cannot be split due to narrow stairway): use crane to lift the whole machine to the workshop

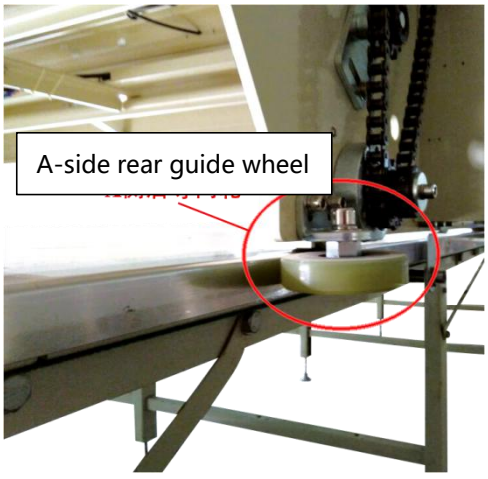
4. Installation

4.1 Guide wheel

First install the A-side guide wheel, the A-side is the fixed end; make the guide wheel fit the stainless steel edge of the cutting board; twist the guide wheel by hand to rotate normally.



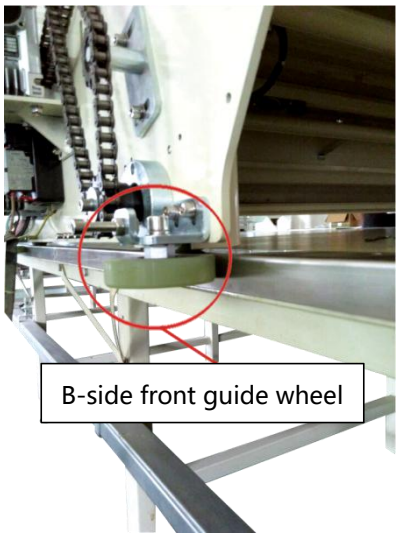
A-side front guide wheel



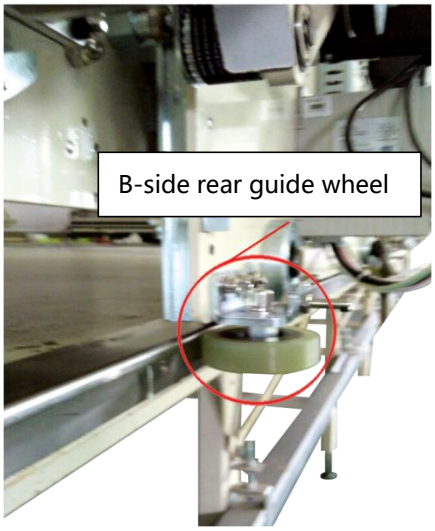
A-side rear guide wheel

4.2 Install the B-side guide wheel, the B-side is the adjustable end; the guide wheel fits the stainless steel plate; twist the guide wheel by hand

to rotate normally.



B-side front guide wheel



B-side rear guide wheel

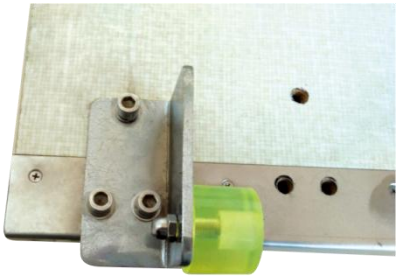
4.3 Electric rail

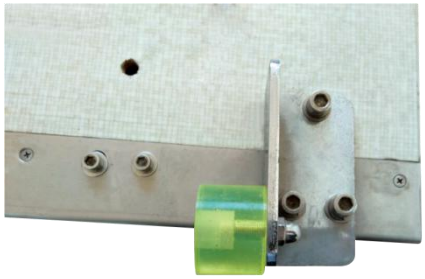
Install the L-shaped iron and hanging clips, and install the rail head 40 cm away from the first tripod of the platen; install the rail forward and adjust the rail joints; fix the screws, adjust the rail, and make it level .

4.4 Security baffle

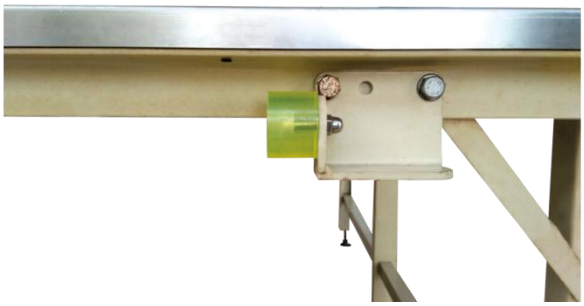
1. Rear baffle: The left and right rear baffles are installed on both sides of the first platen; fixed on the stainless steel side to prevent the machine

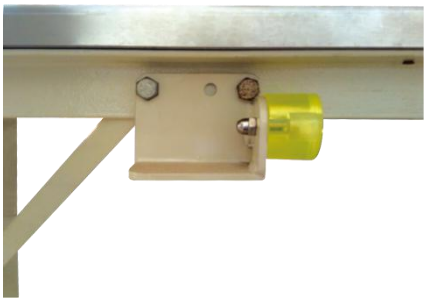
from retreating accidentally.





2. Front baffle: the left and right front baffle plates are fixed on both sides of the side of the cutting platen; the machine uses the position of the maximum rate of the electric rail.





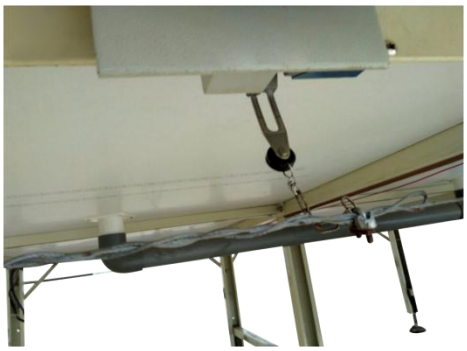
4.5 Brake column, brake cable

The brake column is installed on the feet on both sides of the platen, and the brake cable passes through the middle hole of the screw

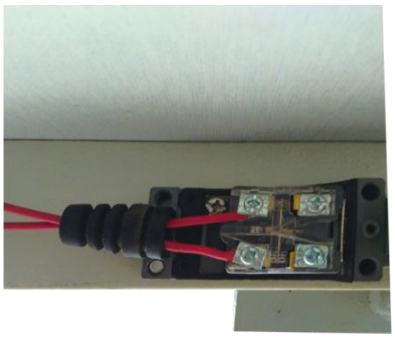
First fix one end of the brake cable with a wire clamp

The other end is connected to the tension spring

Connected to the brake switch with an iron chain

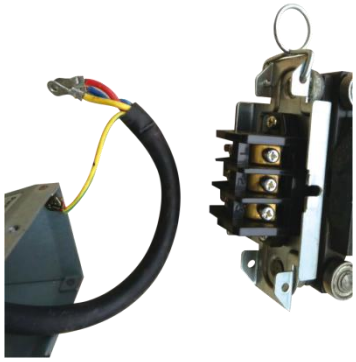


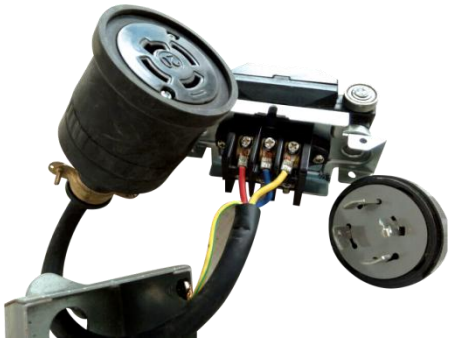
Connect two wires from the normally closed point (NC) in series



4.6 Power cord

Install the pulley first and use four core wires to connect the male-female connectors. The "1" of the pulley is connected to the live wire, the "2" is connected to the zero wire, the "3" is connected to the brake wire, and the ground wire of the pulley shell.



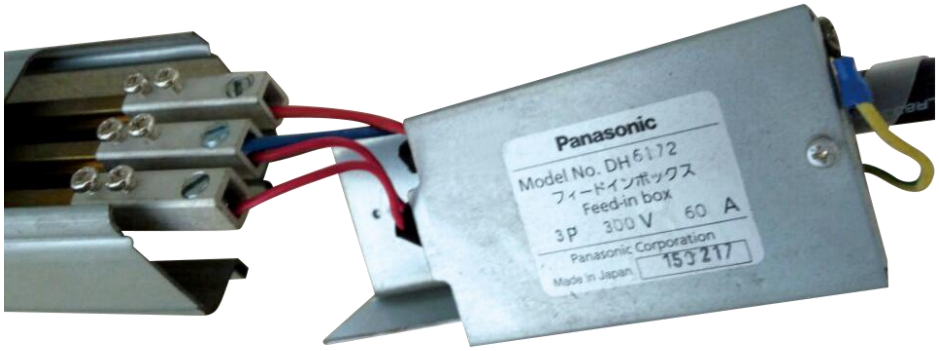


Three copper bars inside the power rail are connected to the power cable:

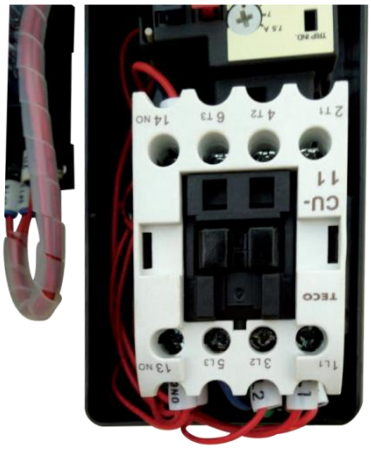
1. Live wire connected to the inner copper strip;

2.The middle copper bar is connected to the zero wire and one of the brake wire;

3. The outer copper strip is connected to another brake wire, and the ground wire is connected to the electric rail shell



The male head of the male-female connectors is connected to the AC contactor with four core wires. 1L1 is connected to the live wire, 3L2 is connected to the neutral wire, 5L3 is connected to the brake switch wire, and the ground wire is connected to the machine shell.



1. Connect the upper host-computer cable and lower host-computer cable

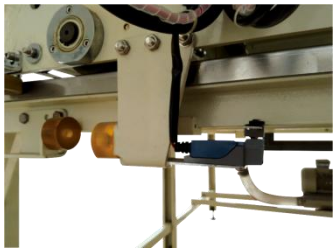
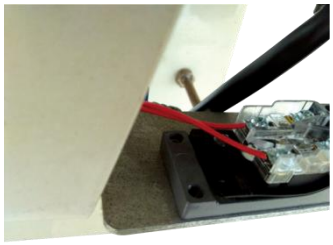
1. The line connecting the upper host-computer and the lower host-computer, there are unwinding motor wire and cloth motor wire

2. Go-to-edge motor cable, warning light cable, manual wiring, unwiring

4. Safe power off device

1. The safety power-off switch is installed under the baffle B of the host machine "connected to the normally closed point" (NC)

2. The power-off block is installed 5cm behind the original point and 10cm before the front limit position to ensure the safe use of the machine

2. Shell and chassis

The outer shell has left part and right part of the upper main machine, left part and right part of the lower main machine, left part and right part of the cutting knife, round knife and left part and right part of the chassis

Left chassis

Middle Chassis

Right chassis

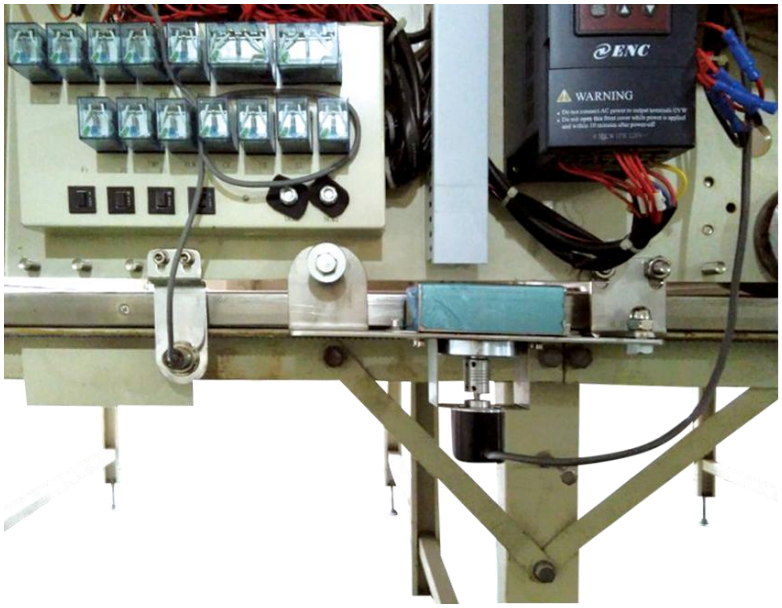
The left and right chassis are respectively fixed on the support tube, and the middle chassis is fixed on the left and right chassis

5. Cutter assembly

When the cutter is installed, it is hung on the L iron washer of the lifting wall and connected with the 17P male-female connectors

6. Synchronous encoder

6.1 The synchronous encoder is installed on the side of the stainless steel table and fixed on the A side safety baffle



5. Testing

After installing the machine, carry out a trial operation of the machine, detect the presence of abnormal sound, adjust the length of the feed, adjust the distance of the machine in operation to the length required by the customer, and adjust the left deceleration distance and the right deceleration distance to maximize the machine efficiency.

6. Training

1. Train operating personnel not less than 2 people (except maintenance personnel)
2. Train operators to familiarize themselves with operating instructions
3. Train operators to become familiar with pushbutton switches
4. Train operators to be familiar with computer screen pages
5. Train the operator to enter the parameter page and adjust the parameter
6. ACC OFFSET: Acceleration compensation. Adjust the tightness during acceleration . "+" means the bigger the looser; "-" means the bigger the tighter.
7. DEC OFFSET: Deceleration compensation. Adjust the tightness during deceleration. "+" means the bigger the looseness; "-" means the

bigger the tightness

8. ZIG-ZAG OFFSET: When pulling in both directions, the tightness of the cloth when running backwards. "+" means the larger the looser, "-" means the larger the tighter

9. 1-WAY NO FEEDING AT ORC: Before the machine reaches the origin, the cloth feed roller stops laying

10. Z-Z NO FEEDING: Before the machine reaches the origin and end position, the cloth feed roller stops laying.

11. Z-Z LEFT EXTRA FEEDING & Z-Z RIGHT EXTRA FEEDING: The parameters to be adjusted when using the moving and folding device, spit out more fabric and press the moving and folding device.

12. When adjusting different fabrics, use the data recipe to save the parameters and call them for later use for easy operation

Train the operator, pay attention when laying the cloth, the cloth should be neat, the cloth edge on the computer screen should be in line with the align-edge sensor.

13. Train the operator, when the machine is laid, both ends are neat (1cm), the side of the align-edge sensor should be neat, the cloth surface is flat, the elasticity is consistent, and meets the customer requirements.

14. Train the operator, after the machine has finished laying the cloth, turn on the air pump to move the cloth forward, which is convenient for the machine to spread the cloth