

JEMA

全自动电脑切带机
AUTO CUTTING MACHINE

使用说明书
INSTRUCTION MANUAL



台州市箭马缝纫机有限公司
TAIZHOU JEMA SEWING MACHINE CO.,LTD.

一、简述

全自动电脑切带机属机电一体化新型专机，它是用输入电脑程序自动控制机械的动作，可按您所需长度数量自动切断不同宽度长度的编织带，魔术贴，塑料软管，鞋带，塑料拉链，电脑排线，商标等带状物品。根据所切材料的弹性不同而设计的补偿功能，可为您的产品带来更高的精确度。并附带加热装置，可以热封不同尺寸的尼龙编织带，尼龙商标等各类尼龙带料，冷切和热切无需更换刀具。红外定位装置，通过红外传感系统定位精确切断各类不同宽度尺寸的商标。魔术贴切圆角装置，切断各类圆角的魔术贴。并在开关关闭前自动储存当前所设置的所有数据，具有精度高，速度快，断面平整，无料自动停止工作，操作简单等特点。是您提高生产效率，提高产品质量，节省人工的首选。

二、规格

功率	最大裁断宽度	裁断长度	裁断速度	电压	包装尺寸
0.28KW	110mm	15mm-99999mm	100-120/分钟	110/230V 50/60Hz	560x415x400

三、使用环境

本机是在一般常温下进行工作，如果在过高温度(大于80摄氏度)下工作，将影响本机性能，本机对环境和能源不产生影响。

四、操作方法

如何操作：（假设设定长度120mm 数量50pcs）

打开电源开关（power sw），面板显示窗出现长度和数量。

按下（LENGTH）1 2 0 （SET）

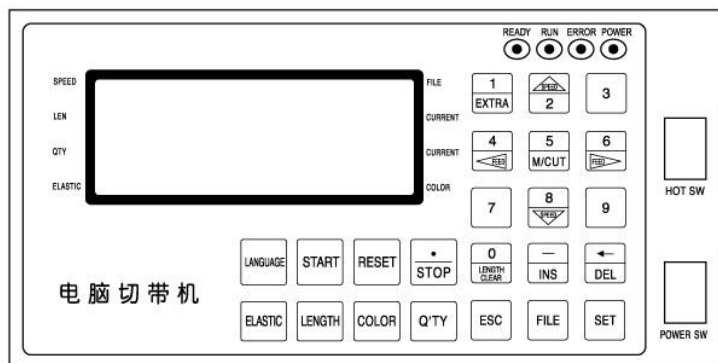
这样长度数值输入完成，开始输入数量。50PCS

按下（Q'TY）5 0 （SET）

长度和数量设定后，机器开始工作。

按下开始键（START）机器将按照以上设定自动完成。

五、面板功能介绍



Hot SW 热刀

Power SW 电源

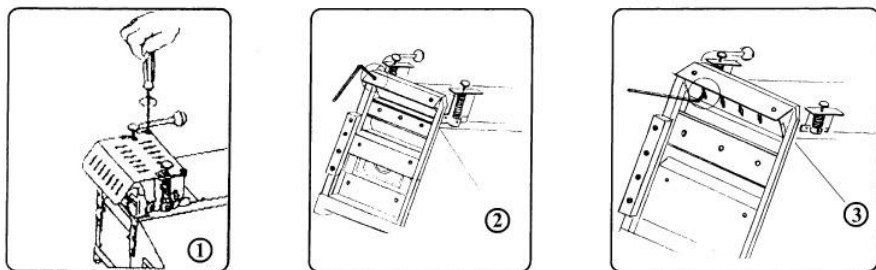
- 按下该键当前长度将恢复为零
- 按下该键切刀会增加切一次
- 按下该键切刀速度将会增加（一般速度为50%最高速度为100%）
- 按下该键切刀速度将会减少（一般速度为50%最高速度为100%）
- 按下该键滚筒将向前送料
- 按下该键滚筒将向后退料
- 按下该键切刀将慢慢向下移动
- 语言选择键（中文/英文）
- 启动键，数量和长度设置好之后按下该键机器开始工作。
- 复位键，系统没有出错的情况下按下该键当前的数量和长度都将恢复为零。
- 停止键加大数点，工作中按下该键将暂停当前的工作，设置长度时按下该键将增加一位小数。
- 负键，由于各种材料的弹性不同，当所切的长度比实际输入的长度长时使用该键来进行负的补偿，以达到标准尺寸。
- 清除键。
- 补偿键，由于各种材料的弹性不同，当所切长度比实际输入长度长或短时用该键来进行适当的补偿，以达到标准尺寸。
- 按下该键设置所需切材料的长度。
- 切商标时打开红外定位，以精确切断。
- 按下该键设置所需切材料的数量。
- 返回键。
- 文件选择，可供储存9种不同尺寸数量的文件。
- 按下该键确认当前的输入。

六、注意事项

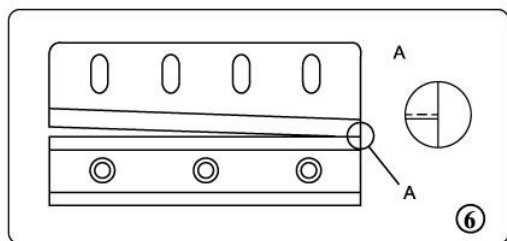
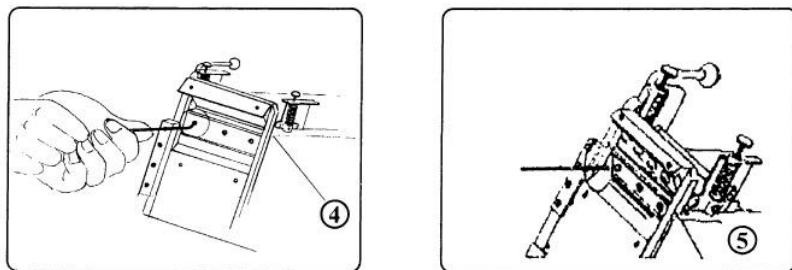
- 1、使用前请确认电源电压和连接地线。
- 2、为了确保安全，在裁切过程中请不要将手或任何物体靠近切刀。
- 3、在做任何调整时，请先切断电源以维护安全。
- 4、除了正常保养外，请勿任意拆卸任何零部件。
- 5、每班开机前，勿必加机油一次。
- 6、如果当刀具使用一段时间后变钝了，可以到专业磨床进行磨刀后方可使用。（注意：此工作一定要请专业人士操作）
- 7、若在操作上有任何困难，请与本公司联系，我们将竭诚为您服务。

七、如何换刀

1. 首先用十字形螺钉旋具（螺丝刀）松开安全罩上4颗M3螺钉，卸下安全罩。（如图1）
2. 用2.5mm内六角扳手松开上刀架上2颗M5内六角紧定螺钉。（如图2）
3. 用4mm内六角扳手松开上刀上3颗M5圆柱头内六角螺钉，卸下上刀。（如图3）



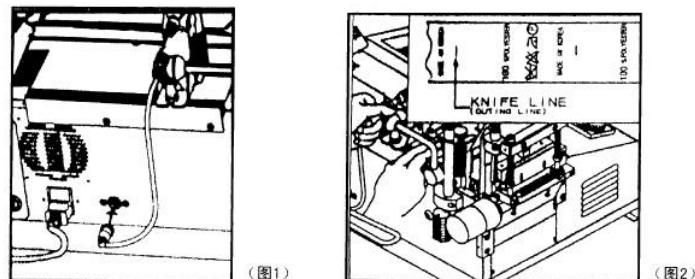
4. 用4mm内六角扳手松开下刀上3颗M5圆柱头内六角螺钉，卸下下刀。（如图4）
5. 先把新的下刀按原位置用3颗M5圆柱头内六角螺钉，固定压紧。（如图5）
6. 移动上刀架安装新的上刀，但在固定压紧时不要压得太紧，然后手动按下M/CUT键刚好让上刀低边缘位于下刀上边缘与下刀相接触，稍微拧紧上刀架3颗M5圆柱头内六角螺钉。（如图6）



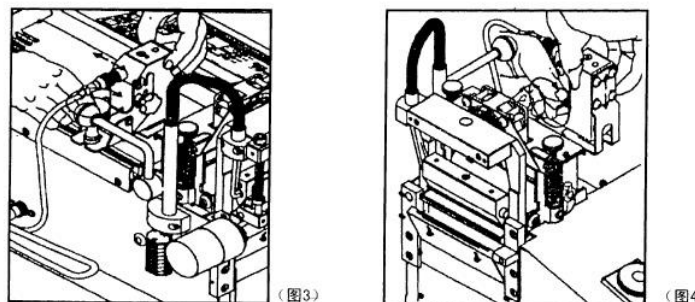
7. 用纸或者薄织物利用M/CUT键进行测试剪切，看上刀和下刀是否安装正确。
8. 如果剪切正常，请用力固定压紧上刀3颗M5圆柱头内六角螺钉及上刀架2颗紧定控制螺钉。
9. 把安全罩重新安装固定上。

八、如何使用色标传感器切断标签

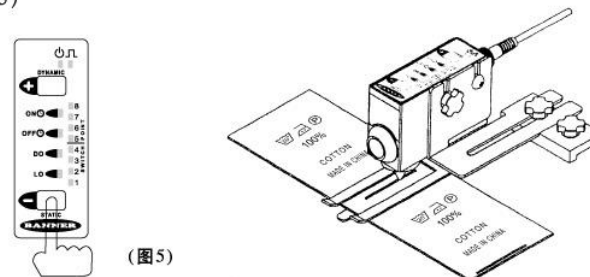
1. 首先测量标签的长度，确认后输入电脑。
2. 按下COLOR键打开色标传感器，当标签的切割线的颜色比底色浓的话请将色标正开，如果切割线的颜色比底色淡的话请将色标负开。（注：当色标在关的情况下，按一下COLOR键色标将正开，按两下色标将负开，按三下色标将关闭）
3. 把传感器固定在导轨上，然后连接传感器与机器底侧的插座。（如图1）
4. 把标签上的切割线与刀锋对准（必须在调节感应器前准备好）（如图2）



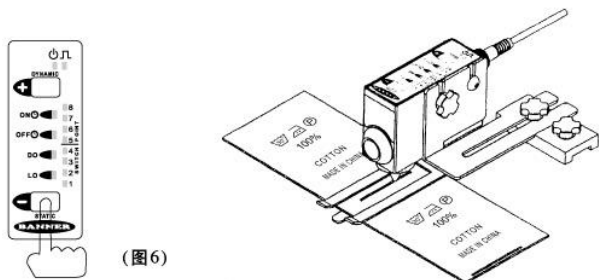
5. 调节色标传感器的光束到标点的中心。（如图3）
6. 调节高度螺母，使光点成清楚的“1”字形。（机器出售前都已调节好）（如图4）



7. 把光聚焦到标签的第一种灰度上，按下并保持“—”2秒，当LODO交替闪烁时点击一下“—”键。（如图5）



8. 再移动光点到第二种灰度上再点击一下“-”键。(如图6)



(图6)

9. 按下开始键START, 开始工作。

切带中如遇麻烦:

请确定是否调节好传感器

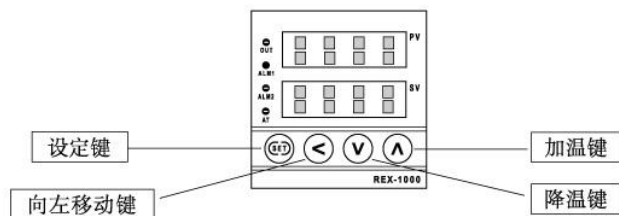
向前或向后移动传感器

检查传感器的灵敏度与高度

检查切断速度(一般速度为50%)

注意: 设置好色标传感器后, 请不要按任何按钮, 以免发生错误改变了之前输入的数据。

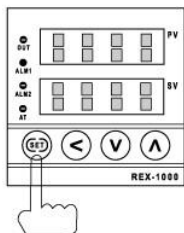
九、如何使用温控仪REX-1000LL



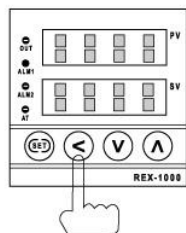
当你打开温控仪时, PV会显示当前室内的温度, 而SV会显示你设置的温度, 建议温度控制在130-150度之间。

大概在10分钟左右就可以达到您所设置的温度。

1. 按SET键进入设置程序, 此时你会看到SV显示在闪烁, 表示可以改动此数字。(如图1)
2. <是向左移动键, 可以帮你选择需要改动的数字。(如图2)



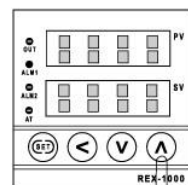
(图1)



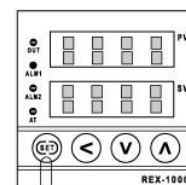
(图2)

3. ^V是温度调节键, ^表示升温, V是表示降温。(如图3)

4. 设置完成后, 需再按一次SET键停止数字闪烁, 这时温控仪会退回自运行模式。(如图4)



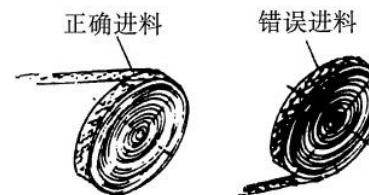
(图3)



(图4)

故障排除:

1. 调温器不工作, 检查接线处是否松动。
2. 切口没有完全粘合, 调温器温度设定太低, 需要逐步加高温度直到切口完全粘合。
3. 料带放置立式(见图), 开始送料时可利用手动送料将料送入刀口, 待温度到达所设定温度后方可正常工作。



4. 更换上切刀时固定上刀的螺钉太紧无法拧出, 请将温控仪开启加热到200度左右, 方可松开螺钉, 松开螺钉后, 请将温控仪关闭, 待上切刀完全冷却后, 可将螺钉完全拧出, 更换上刀。
(注意: 加热后松开螺钉时注意烫伤)

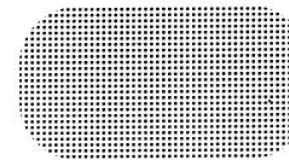
注意:

切魔术贴切勿将两条同时剪切。

切魔术贴进料时必须将毛面朝上, 光面朝下。(如下图)



毛面朝上(正确)



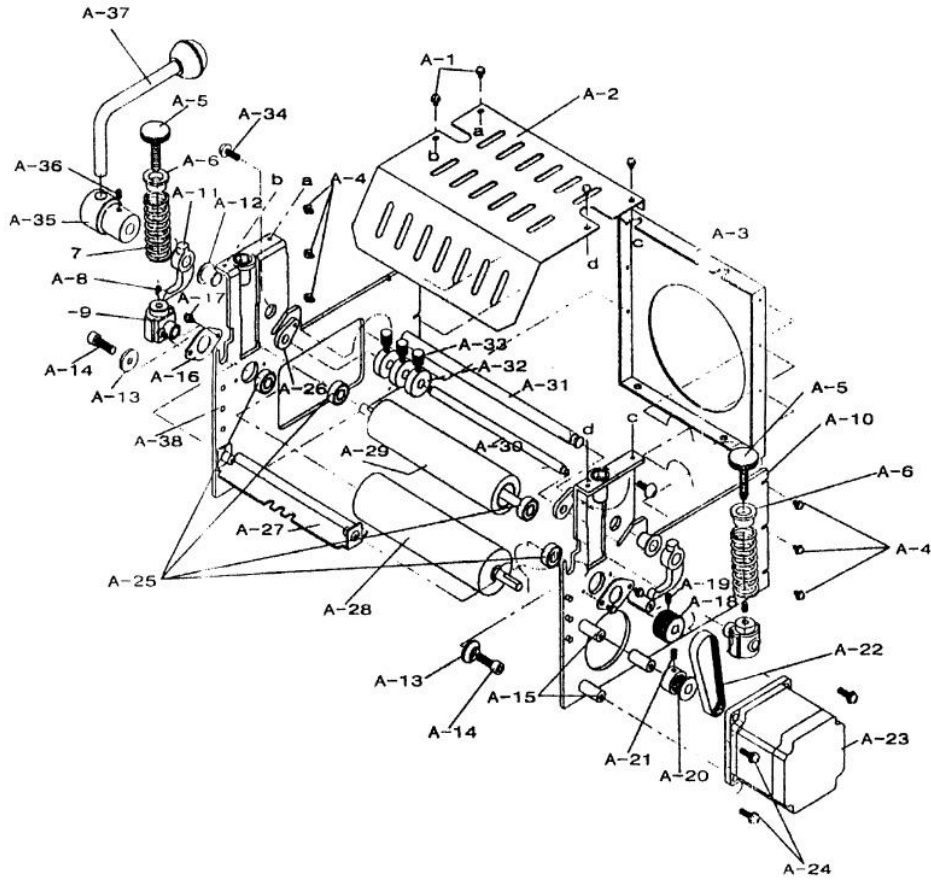
毛面朝下(错误)

十、一般故障的排除措施(供参考)

序号	发生现象	对应機種	原因及措施
1	无电源	全機種	<p>检查电源连接插头线接触是否良好</p> <p>检查保险丝是否断开</p>
2	有电源, 但无法启动	滚轴不启动	<p>全機種</p> <p>检查滚轴上是否夹带杂物</p> <p>如显示屏显示刀具传感器出错, 则需要关闭电源, 10秒钟后再打开电源, 等控制面板绿色灯亮时, 再按控制面板“5”字、切断刀架上下移动。</p> <p>如显示屏显示正常或不正常, 则需要关闭电源, 10秒钟后再打开电源, 再按启动按钮绿色键 (START) 还不能启动, 则需要考虑更换驱动板。</p>
		刀架不启动	<p>全機種</p> <p>检查压力板 (冷刀: #20 & 29, 热刀: #32 & 36) 是否太紧</p>
		屏面不显示	<p>全機種</p> <p>如果本机器连续超长时间工作使用, 机箱里面温度可能超高, 也许有可能出现显示不正常, 属于正常现象, 停止工作、关闭电源开关, 过一会儿再开机显示应当正常, 如果在冷态的时候, 开机显示不正常请关闭电源等十秒钟再开机, 上述做法反复几次仍然不正常, 打开机箱盖检查电脑连接插线。(尤其是操作板和CPU控制板)</p>
3	无法切断带子	热刀	<p>检查温度是否达到预设温度</p> <p>检查热刀是否被加热</p>

序号	发生现象	对应機種	原因及措施
4	只切断带子的一边	全機種	<p>检查热刀是否被损伤或磨损</p> <p>采用手动切断键, 调节刀, 上刀和下刀对准, 并保持水平。(如未保持水平, 需旋开螺丝调节)</p>
5	切断长度与设定值不同	全機種	放松滚轴或利用带子传送机 (切断)
6	切断商标时, 未到切割线切断	色标	向刀口的方向移动感应器, 相当于差异隙距离
7	切断商标时, 超过切割线切断	色标	向刀口的反方向移动感应器, 相当于差异隙距离
8	LCD 显示屏显示出错	长度传感器出错	<p>色标</p> <p>传感器故障</p> <p>检查传感器是否连接好</p> <p>检查色标传感器的光标是否调准在被检测的参照物上。</p> <p>检查长度设定键 (LENGTH) 设定的长度是否与商标长度相符。</p>
		刀具传感器出错	<p>全機種</p> <p>切割马达或切割感应装置故障</p> <p>1.正常开机后控制面板黄色的指示灯亮(START)时, 按住“5”字键、刀架能上下移动, 如不能移动可能是刀架被卡住。</p> <p>2.打开刀架下方盖板, 检查传感片是否松动错位。</p> <p>3.打开机箱盖, 检查刀具传感接近开关是否失效和连接线的连接状态。</p> <p>检查刀具马达是否正常</p>
9	手触到设备时, 有电流	全機種	用户在安装本设备时须自配防触电漏电开关, 三脚插座接地极必须要有良好的接地线, 才能确保本机器正常工作。

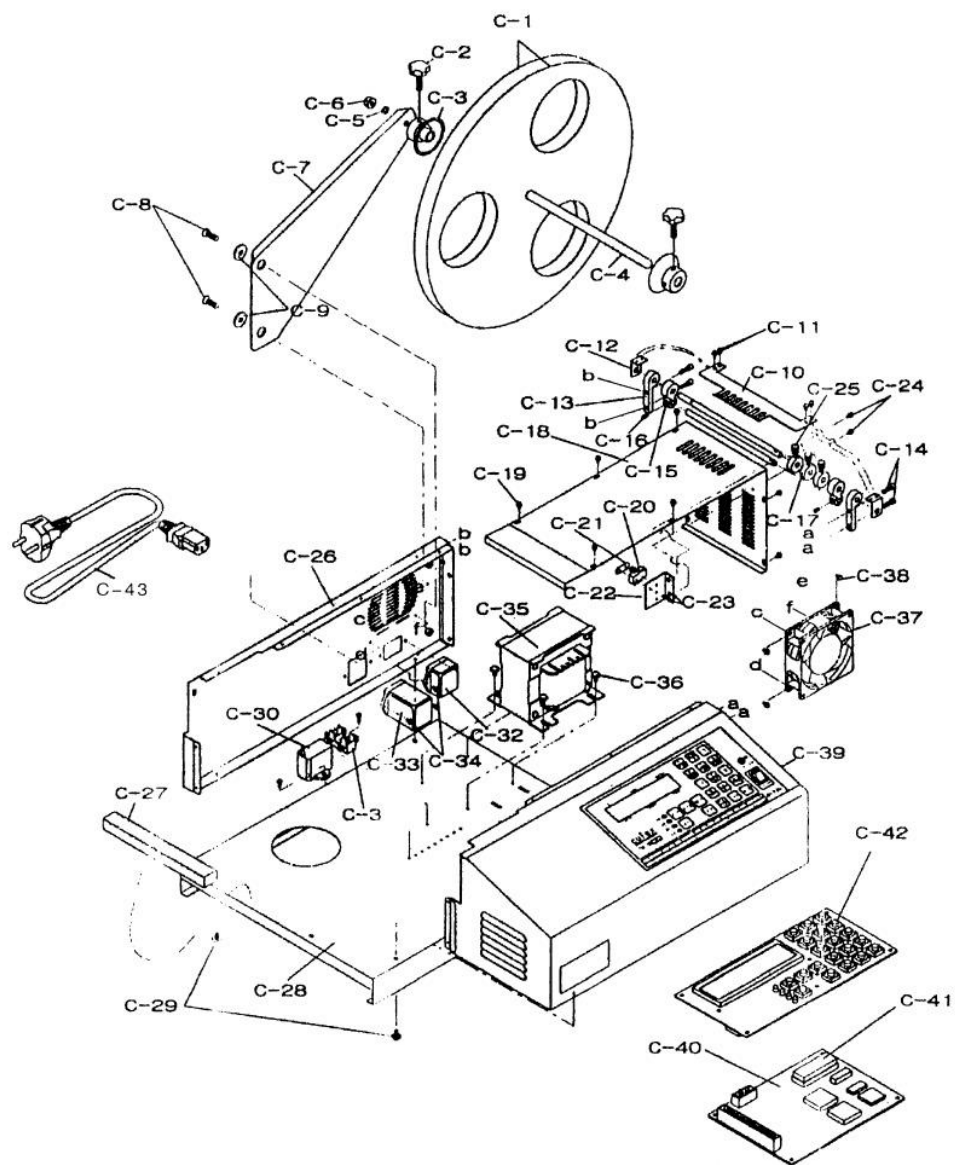
零件图



零件图

图号	名称	图号	名称
A-1	螺钉M3 x 5L	A-21	螺钉M3 x 5L
A-2	切带装置上盖	A-22	同步齿形带(M x L75)
A-3	后壁	A-23	伺服马达
A-4	螺钉M3 x 5L	A-24	螺钉M4 x 15L
A-5	调节螺钉	A-25	轴承(#696)
A-6	弹簧定位块	A-26	横轴座
A-7	压缩弹簧	A-27	刀前控制料压板
A-8	螺钉M4 x 6L	A-28	送带轮
A-9	压带辊座	A-29	压带轮
A-10	左圆筒座	A-30	横轴
A-11	弯压座	A-31	弯压座轴
A-12	轴套	A-32	滑动套
A-13	垫圈	A-33	螺钉
A-14	螺钉M4 x 15L	A-34	螺钉M4 x 5L
A-15	伺服马达座	A-35	手把座
A-16	小压盖	A-36	螺钉M5 x 5L
A-17	螺钉M3 x 5L	A-37	手把
A-18	同步齿轮1	A-38	右圆筒座
A-19	螺钉M4 x 6L		
A-20	小同步齿轮		

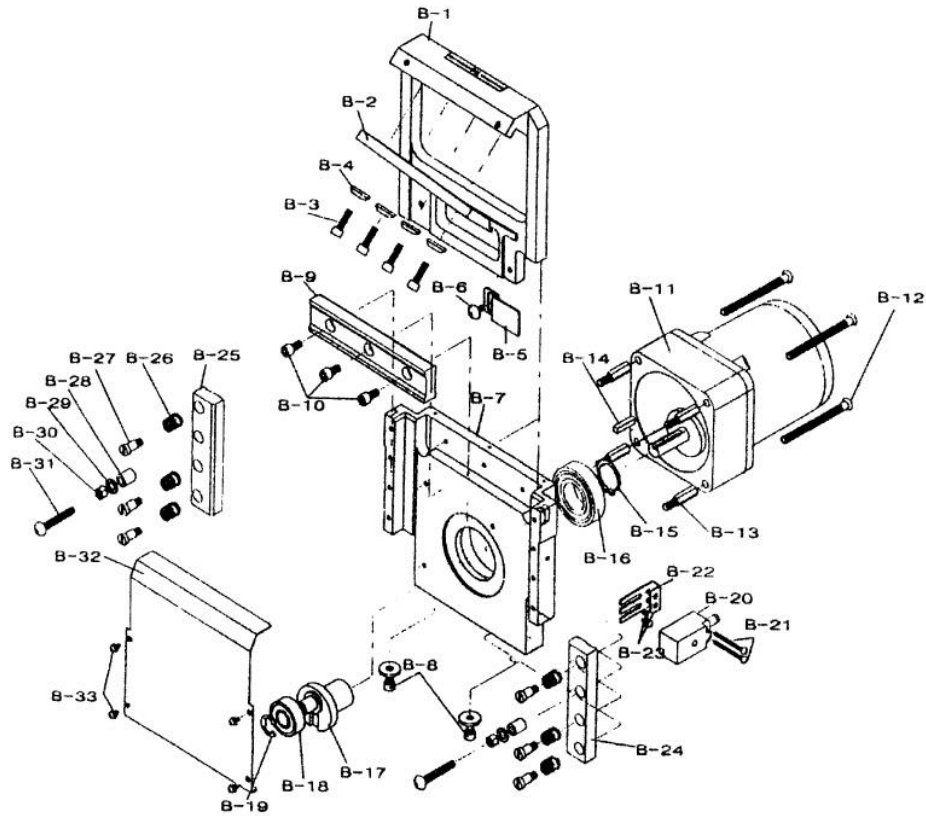
零件图



零件图

图号	名称	图号	名称
C-1	挡盘	C-23	螺钉M2 x 10L
C-2	梅花手把	C-24	螺钉M3 x 5L
C-3	挡蕊	C-25	螺钉
C-4	放料臂轴	C-26	后盖
C-5	垫圈6	C-27	吸油条
C-6	螺母M6	C-28	底座
C-7	放料臂	C-29	螺钉M4 x 10L
C-8	螺钉M6 x 15L	C-30	电容
C-9	垫圈C	C-31	接线端子
C-10	压板	C-32	电器
C-11	螺钉M3 x 15L	C-33	电器
C-12	压板架	C-34	螺钉M3 x 5L
C-13	压板座	C-35	变压器
C-14	螺钉M4 x 15L	C-36	螺钉M4 x 6L
C-15	摇杆座	C-37	排风扇
C-16	螺钉M4 x 6L	C-38	螺钉M3 x 5L
C-17	滑动套	C-39	前壳
C-18	右盖	C-40	控制刀具集成电路板(MB)
C-19	螺钉M3 x 5L	C-41	ROM
C-20	行程开关	C-42	按钮面板(OP)
C-21	行程开关压板	C-43	外接线
C-22	行程开关座板		

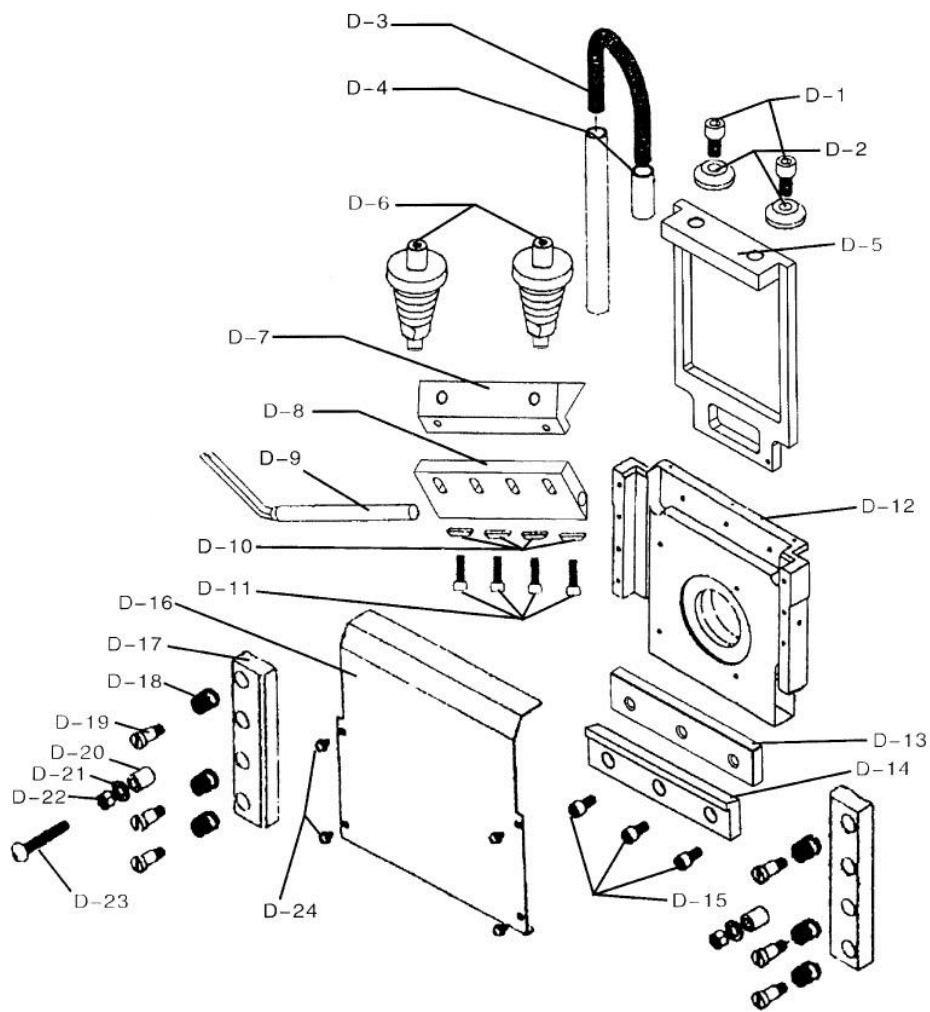
冷刀零件图



冷刀零件图

图号	名称	图号	名称
B-1	上刀座	B-21	螺钉M3 x 20L
B-2	上切刀	B-22	电眼座
B-3	螺钉M5 x 15L	B-23	螺钉M3 x 15L
B-4	垫圈	B-24	导轨压板
B-5	挡板	B-25	导轨压板
B-6	螺钉M4 x 6L	B-26	压力弹簧
B-7	下刀座	B-27	螺钉
B-8	螺钉M5 x 15L	B-28	压套
B-9	下切刀	B-29	垫圈
B-10	螺钉M5 x 10L	B-30	螺母
B-11	减变速马达	B-31	螺钉M5 x 30L
B-12	螺钉M5 x 42L	B-32	左侧盖
B-13	接减速机螺钉	B-33	螺钉M3 x 5L
B-14	键		
B-15	轴用弹性档圈		
B-16	轴承(#6004)		
B-17	偏心轮		
B-18	轴承(#6000)		
B-19	开口挡圈		
B-20	电眼		

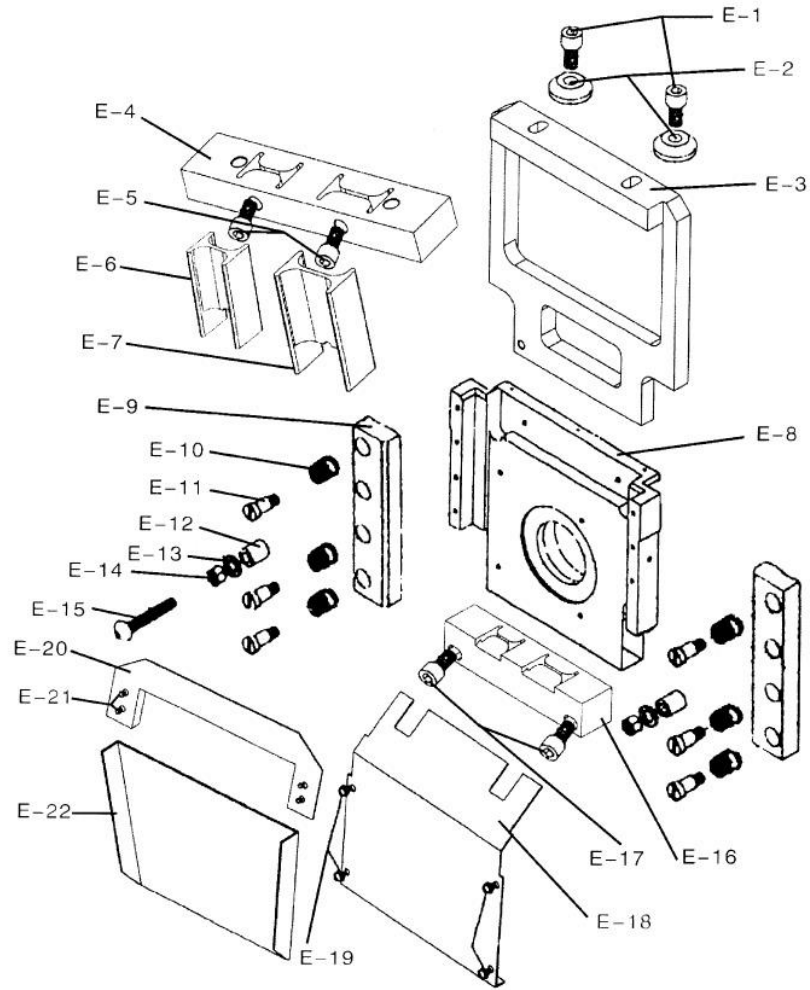
冷热刀零件图



冷热刀零件图

图号	名称	图号	名称
D-1	螺钉M8 x 28	D-21	垫圈
D-2	垫圈	D-22	螺母
D-3	加热线弹簧	D-23	螺钉M5 x 30
D-4	加热线管子	D-24	螺钉M3 x 5
D-5	上刀架		
D-6	加热刀托架		
D-7	加热刀固定块		
D-8	上切刀		
D-9	加热管		
D-10	垫圈		
D-11	螺钉M5 x 15		
D-12	下刀架		
D-13	下刀垫块		
D-14	下切刀		
D-15	螺钉M5 x 15		
D-16	落料板		
D-17	导轨压板		
D-18	压力弹簧		
D-19	阶梯螺钉		
D-20	压套		

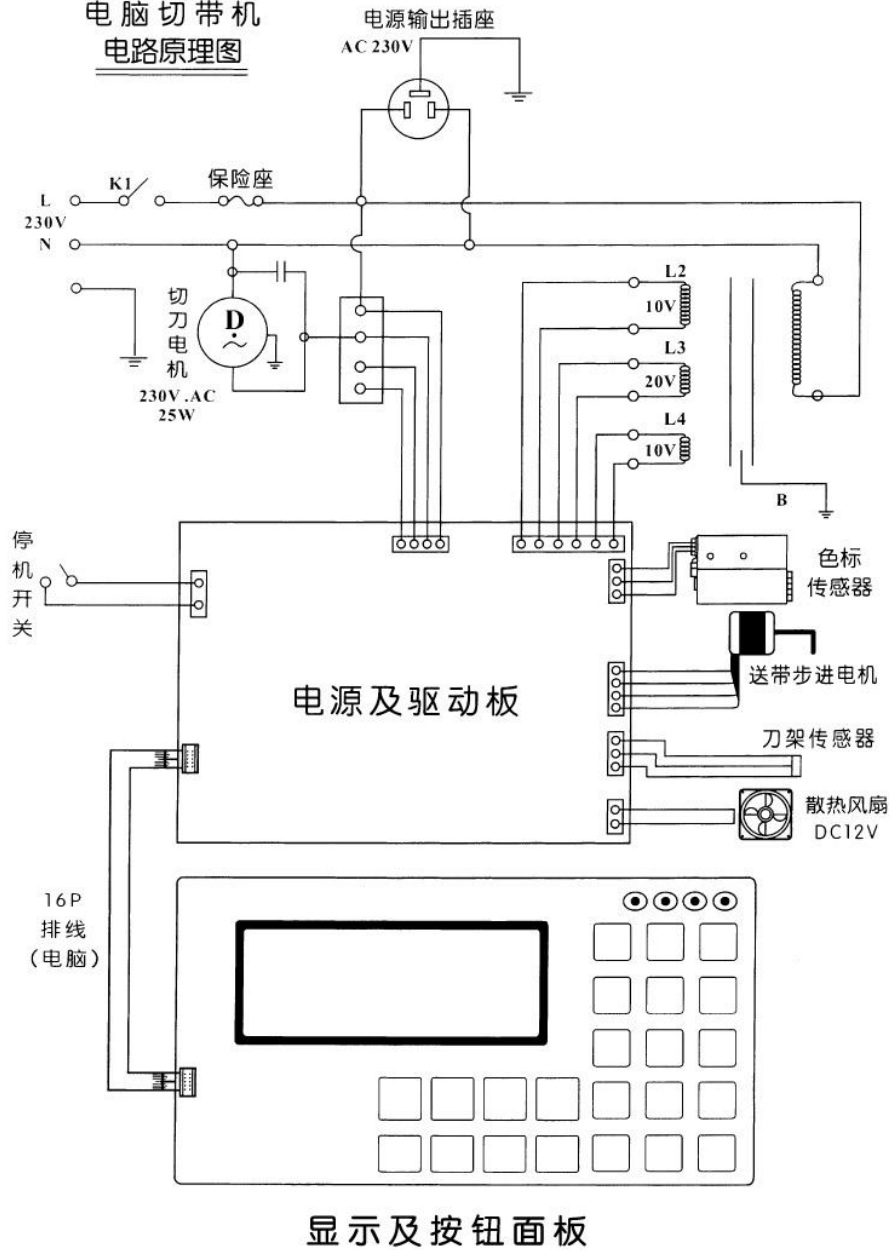
圆角零件图



圆角零件图

图号	名称	图号	名称
E-1	螺钉M6×30	E-21	螺钉M3×5
E-2	垫圈	E-22	落料板
E-3	上刀架		
E-4	上刀模安装座		
E-5	螺钉M6×12		
E-6	上刀模(1.5/1.0)		
E-7	上刀模(2.0/2.5)		
E-8	下刀架		
E-9	道轨压板		
E-10	压力弹簧		
E-11	阶梯螺钉		
E-12	压套		
E-13	垫圈		
E-14	螺母		
E-15	螺钉M5×30		
E-16	下刀模		
E-17	螺钉M6×32		
E-18	前挡板		
E-19	螺钉M3×5		
E-20	挡料板		

电脑切带机 电路原理图



1. GENERAL DISCRIPTION

Auto cutting machine adopts electromechanical integrating technology, it automatically adjusts the length data through the input of computer program. Automatically cutting various straps of different sizes such as braided tape. Velcro tape, plastic tube, bootlace, plastic zipper, electrical wire, label, etc. All the data will be saved automatically before put off the switch. With features of high accuracy, high speed, easy operation and stop working without materials. It's an ideal machine for increasing efficiency, improving quality and saving labour.

2. SPECIFICATION

power	MAX. cutting width	cutting length	cutting speed (pcs/min)	voltage	packing siza (L.W.H)
0.28KW	110mm	15mm-99999mm	100-120	110/230V 50/60Hz	560x415x400

3. USE ENVIROMENT

The machine should work under the normal temperature, if the environment temperature is more than 80℃, would influence the performance of the machine.

4. HOW TO OPERATE

How to operate (i.e., cutting length: 120mm, cutting quantity: 50pcs)

Put on the POWER SW.

Set cutting length 120mm.(press the following bottons in order.)

👉 LENGTH → → → →

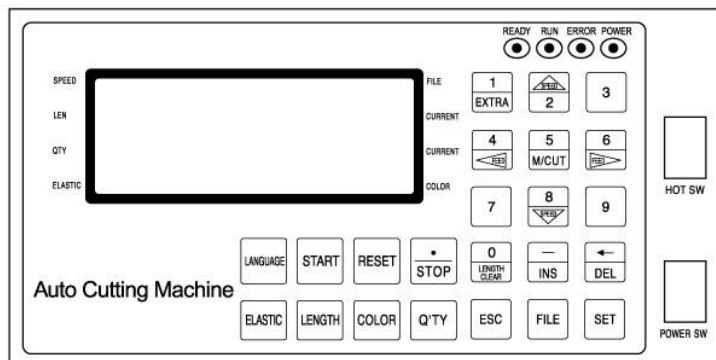
☆ Botton "0" has a double function of "0" and eraising current lengh

Set cutting qauty 50pcs.

👉 QTY → → →

Press START botton to start the machine.

5. KEY FUNCTIONS



How sw Use for hot cut

Power sw Power



Current length on display will back to "0"



Cut one more time



Speed up (nomal speed 50%, max. speed 100%)



Speed down

*Speed up & down is possible in any time (operation or stop) and set-speed will not be Changed even through you press RESET botton or power off&on.



To move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.



Moving knife only.



Language shift (Chinese/English)



To start the working after finish length and qauty setting



All of current length and current quantity on display will back to "0"



To pause the working as well as a decimal point in the length setting



To insert new program between programs inputted already in time of program-input.



To delete the wrong program in time of program-input. (All things of the STEP will be deleted.)



Compensation use for the elastic material cutting



Resoring to normal condition in ERROR



Can save 9 files for you to select



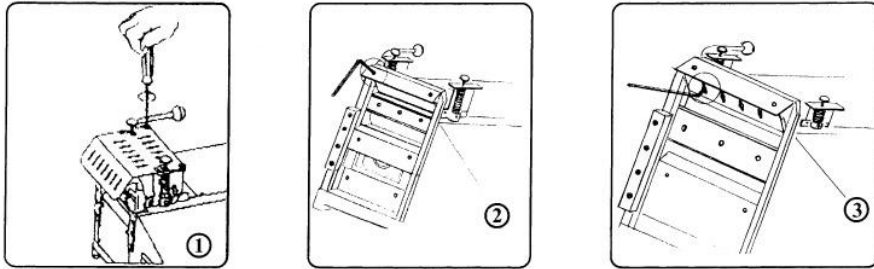
Infrared function

6. CAUTION

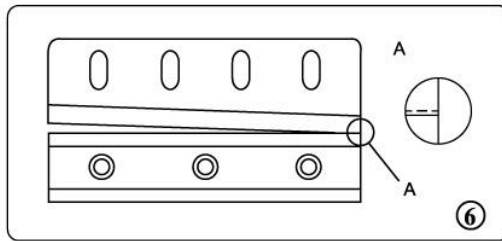
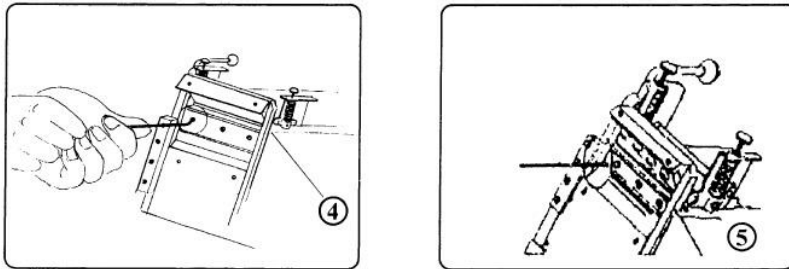
1. Before use,pls confirm the voltage and make ground (earth) connection.
2. Do not access hands or any object close to the working knife.
3. Cut off the eletricity before any adjustment (for safty) .
4. Pls do not take off any of the parts except for normal maintance.
5. Lubricate the machine every time use the machine.
6. When the knife blade becomes dull, pls use it after griding with the grinding machine (pls do not let the unskilled person grind manually or install the knife blade)
7. Welcome to contact us for more information!

7. EXCHANGE OF KNIFE

1. First of all, unscREW 4 bolts on safely cap and take off the cap. take off anti-static device by 8mm-spanner for taking off upper knife. (see picture 1)
2. Uncrew 2 control bolts of upper knife by 2.5mm-wrench (don't take off)
3. UnscREW 4 fixing bolts by 4mm-wrench and take off upper knife



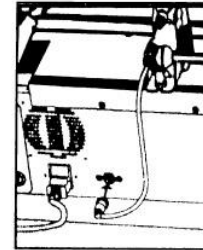
4. Unscrew 3 fixing bolts of lower knife by 4mm-wrench and take off lower knife.
5. Move up upper knife frame and install new upper knife and fix it but don't fasten it firmly.
6. By soft touch of M/CUT button, make the upper knife contacted to the lower knife plate.



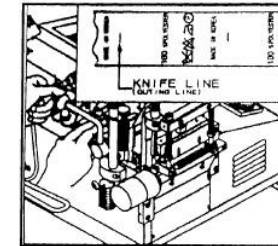
7. Check the lever between upper knife & lower knife plate with paper or tissue and adjust the gap.
8. If cutting is normal, fasten the control bolts of upper knife firmly.

8. HOW TO USE SENSOR

1. Put the label length into computer.
2. Press COLOR button to open the sensor. Open in + direction when the background is lighter and - direction when is darker. (Note: first touch COLOR button always on + direction, second time is - direction)
3. Mount the sensor on the guide-rail and connect the jack of sensor into the connector of machine downside. (picture 1)
4. Locate the cutting line of label on the lower knife blade precisely & move the sensor close to the knife. (picture 2)

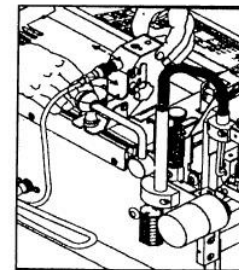


(picture 1)

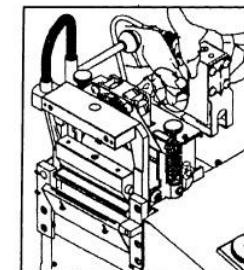


(picture 2)

5. Adjust the sensor with guide-control bolt for lightening the beam on the center of marking point. (picture 3)
6. By the height-control bolt of sensor, make the focused beam clear to be 1 shape. (picture 4) (note that it is supplied after adjustment of the height from the factory.)

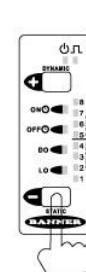


(picture 3)

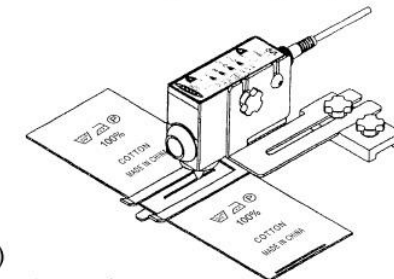


(picture 4)

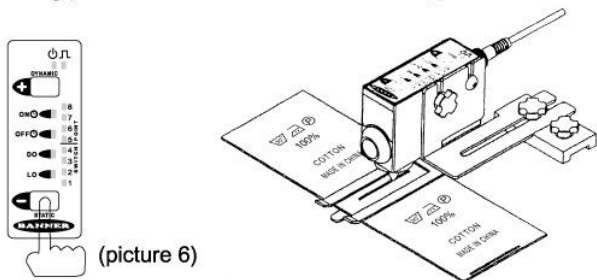
7. Focused the light on one of the marks (cutting lines or figure, letters) and press "-" button for more than 2 seconds, lamp "L/D" will blink and press "-" again. (picture 5)



(picture 5)



8. Move the lightening point to the second mark of the label, press "-" button.



(picture 6)

9. Press START button

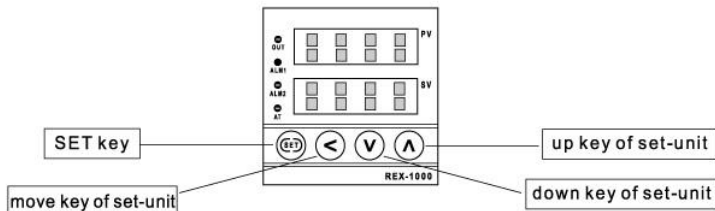
Troubles in cutting

- Check if you adjust sensor after cutting line of label on the knife blade.
- Move the sensor forwards and backwards.
- Check sensitivity & height of the sensor.
- Check the cut speed (normal 50%)

Caution:

After setting the sensor, do not press DELAY, L/D button, it may happen an error changing input data.

9. HOW TO USE TEMPERATURE-CONTROL REX-1000LL

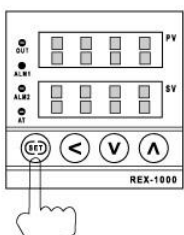


When you power on the controller, PV shows current room temperature and SV shows set temperature.

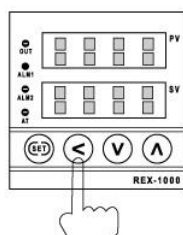
Recommendation is 130~150.

After turn on & set, within 10minutes, it reaches to set temperature.

1. You can enter set mode by pressing SET key, you may see one cipher blinks, it means it can be changed. (picture 1)
2. By pressing < key, you can move between numbers of four ciphers. (picture 2)



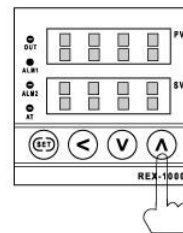
(picture 1)



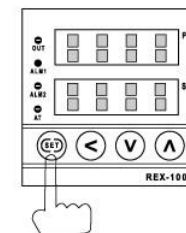
(picture 2)

3. Set desirous temperature by pressing \wedge and \vee keys. Set-temperature will be increased by \wedge key and it will decreased by \vee key. (picture 3)

4. After finishing setting, press SET key once more. then, it stops blinking. And the controller will return to auto-turning mode. (picture 4)



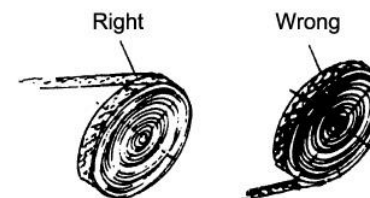
(picture 3)



(picture 4)

Fault clearance

1. Check the connection if the temperature does not work.
2. Increase the temperature if the cut unsealed
3. Pls wait the temperature reaches to the set temperature before working and with right material putting.



4. If you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200°C. Then loose the screw and turn off the control. And screw out completely after the knife is cool. (note that is hot and not burned yourself)

Caution:

- Do not cut two velcros in the same time.
- When cut velcros, pls make sure that the rough surface is upward.



the rough surface is upward
(correct)



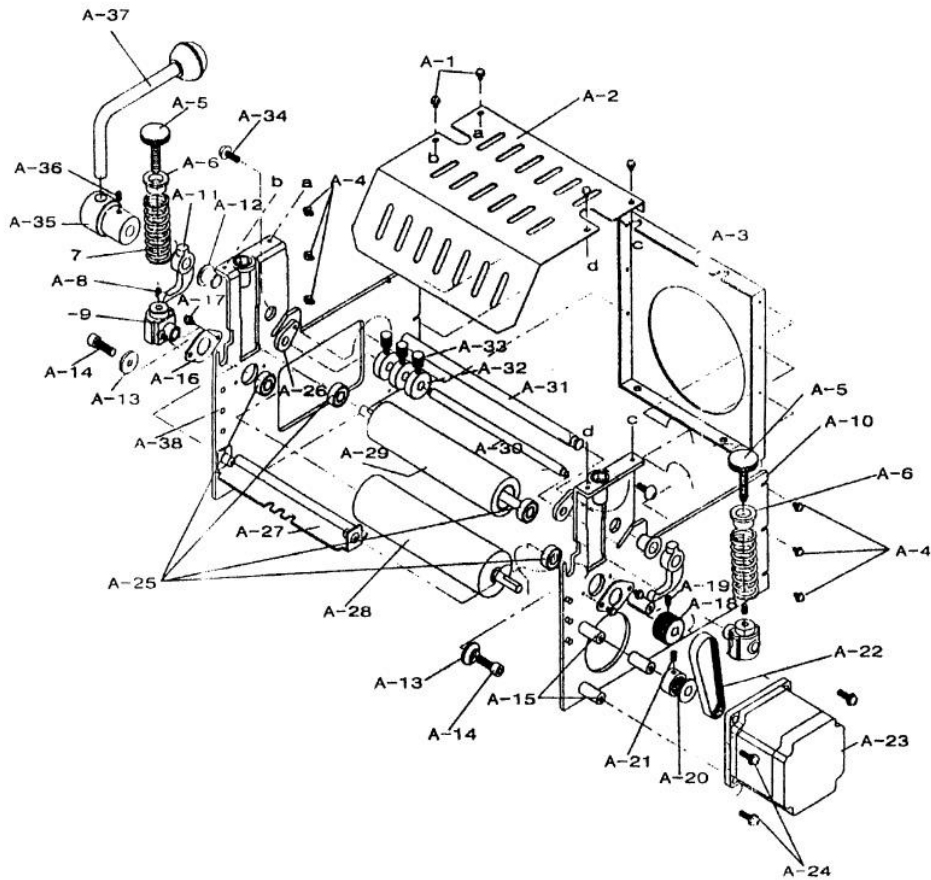
the rough surface is downward
(false)

10. TROUBLE SHOOTING OF 120 SERIES

NO	TROUBLES	APPLICABLE MODEL	CAUSES & MEASURES
1	No power supply	All models	<p>Check if electric cord is connected well</p> <p>Check if the fuse blows out or not</p>
2	Power is on, But no work	All models	<p>Check if there is inserted any alien substance in roller</p>
			<p>If the display shows "sensor error" or any other error, put off SW for 10 seconds and put on again</p>
			<p>If still does not work, exchange the drive board.</p>
	Knife does not work	All models	<p>Check if pressure plates of upper knife are too much fastened or not. (cool: 20 & 29, hot: 32 & 36)</p>
	LCD display does not work	All models	<p>Check if the temperature is too high with over-time working, switch off the machine for seconds, if still doesn't after several times' trying. Please opening the cover and check the connection. (especially between operation and MB board)</p>
3	Material is no cut	Hot cutter	<p>Check if temperature goes up to set-degree</p>
			<p>Check if knife blades are even.</p>

NO	TROUBLES	APPLICABLE MODEL	CAUSES & MEASURES
4	Material is cut on one side	All models	<p>Check if blades are damaged or worn</p>
			<p>After making both knives close each other by M/CUT button and check if they are even or not. (if they are not, adjust them by bolts.)</p>
5	Cut-length is different from set-length	All models	<p>Test cutting after loosening material from the reel by hand or attaching feeding device.</p>
6	It cuts before the cutting line of label	Label	<p>Move the sensor towards knife side as long as the difference by pushing.</p>
7	It cuts after the cutting line of labels	Label	<p>Move the sensor towards counter-knife side as long as the difference by pushing.</p>
8	Error on LCD	All models	<p>Trouble in MARK SENSOR</p>
			<p>Check if the sensor is connected well or not</p>
			<p>Check if the sensor is adjusted well or not</p>
			<p>Check if the input length is correct with the label length.</p>
			<p>Troubles in cutting motor or counting sensor</p>
			<p>1. Turn on the machine and press the 5 button, check if the knife can be moved or not. If not, the knife may be locked. 2. Open the bottom cover of the knife, check if the sensor is loose or wrong positioned. 3. Open machine cover, check the SW of cutting sensor is right or not. If not, exchange it</p>
			<p>Check the cutting motor is right or not.</p>
9	Operator feels electric current in touch of machine	All models	<p>Connect the earth cord (green) to any bolt of backside of machine.</p>

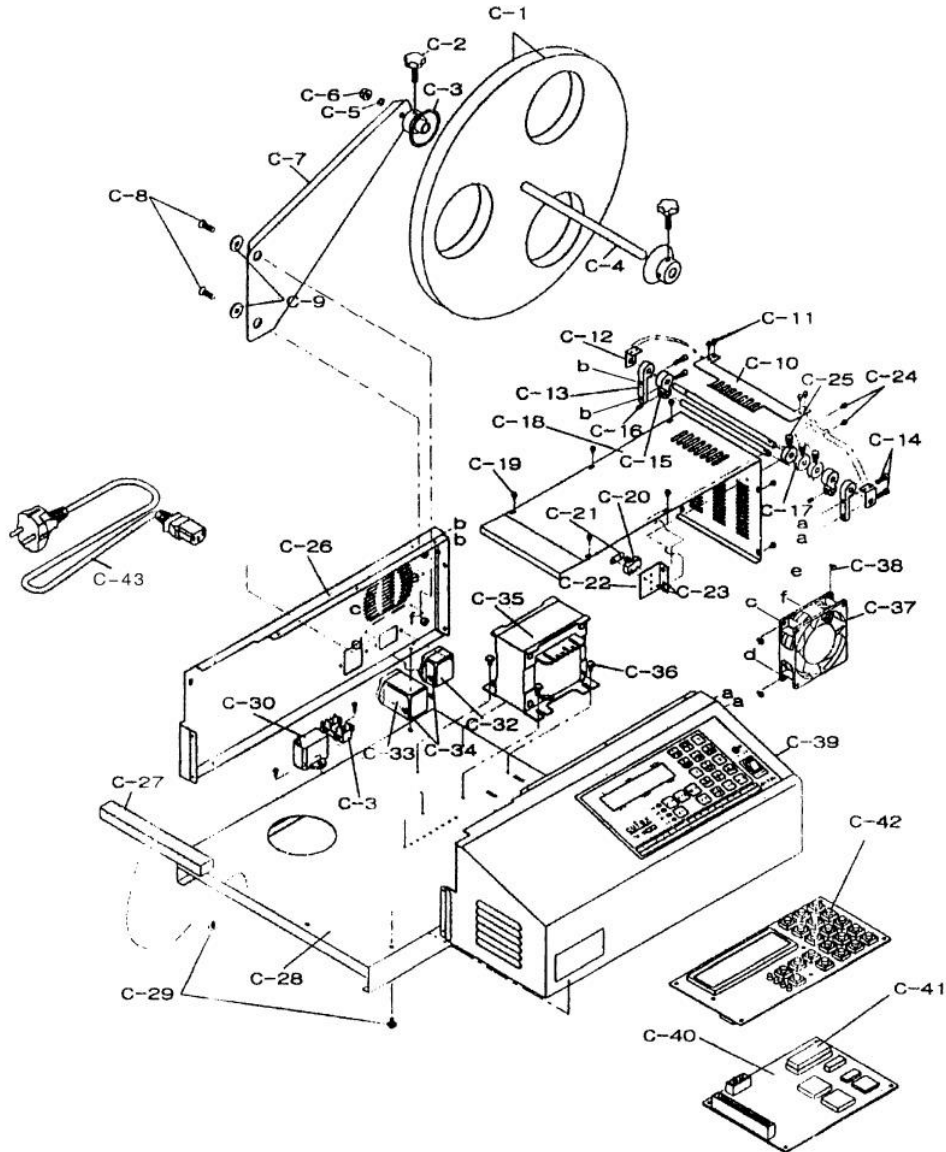
SPARE PARTS



SPARE PARTS

Part No.	Decription	Part No.	Decription
A-1	clamping bolt (M3x5L)	A-21	detent screw (M3x5L)
A-2	knife safety cover	A-22	timing belt (MxL75)
A-3	space plate of roller bracket	A-23	stepping motor
A-4	clamping bolt (M3x5L)	A-24	clamping bolt (M4x15L)
A-5	pressure-control bolt	A-25	ball bearing (#696)
A-6	pressure-control spring cover	A-26	guide-clamping bracket
A-7	pressure-control spring	A-27	stopper
A-8	detent screw (M4x6L)	A-28	lower roller
A-9	slide block of upper roller	A-29	upper roller
A-10	right roller bracket	A-30	front-guide pin
A-11	slide lever	A-31	lever shaft
A-12	oilless	A-32	guide ring
A-13	clamping washer	A-33	knob bolt of guide ring
A-14	wrench bolt (M4x15L)	A-34	roud screw (M4x5L)
A-15	tie bar of stepping motor	A-35	lever bracket
A-16	bearing cover	A-36	detent screw (M5x5L)
A-17	clamping bolt (M3x5L)	A-37	lever
A-18	feed-timing gear	A-38	right roller bracket
A-19	detent screw (M4x6L)		
A-20	drive-timing gear		

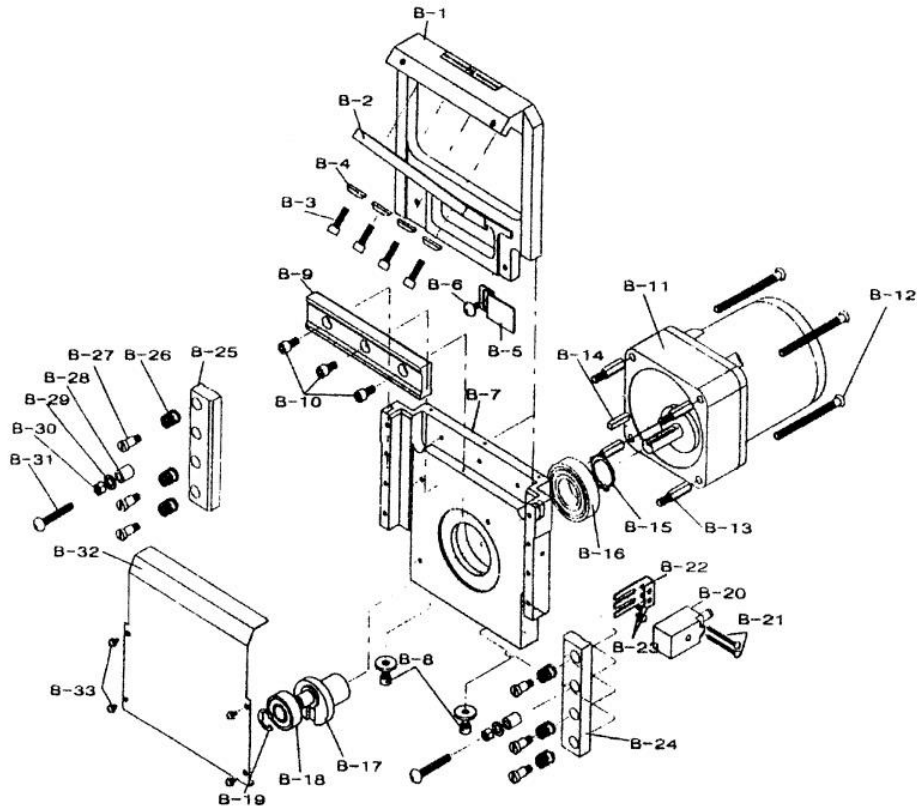
SPARE PARTS



SPARE PARTS

Part No.	Decription	Part No.	Decription
C-1	roll-hanger wheel	C-23	clamping bolt (M2x10L)
C-2	clamping bolt of holder	C-24	clamping bolt (M3x5L)
C-3	holder	C-25	knob bolt
C-4	roll-hanger shaft	C-26	back cover
C-5	roll-hanger shaft washer	C-27	sponge
C-6	check nut (M6)	C-28	base
C-7	roll-hanger	C-29	clamping bolt (M4x10L)
C-8	flat-head bolt (M6x15L)	C-30	condenser
C-9	neck washer of roll-hanger	C-31	terminal
C-10	existence detector	C-32	AC connector (OUT-PUT)
C-11	clamping bolt (M3x15L)	C-33	AC connector (IN-PUT)
C-12	clamping bracket	C-34	clamping bolt (M3x5L)
C-13	rear guide-pin bracket	C-35	transformer
C-14	wrench bolt (M4x15L)	C-36	clamping bolt (M4x6L)
C-15	rear tension-guide block	C-37	cooling fan
C-16	detent screw (M4x6L)	C-38	clamping bolt (M3x5L)
C-17	guide ring	C-39	control cover
C-18	upper guide plate	C-40	control circuit board (MB)
C-19	clamping bolt (M3x5L)	C-41	ROM
C-20	micro limit switch	C-42	operation board
C-21	plate-nut	C-43	out connect plug
C-22	limit switch bracket		

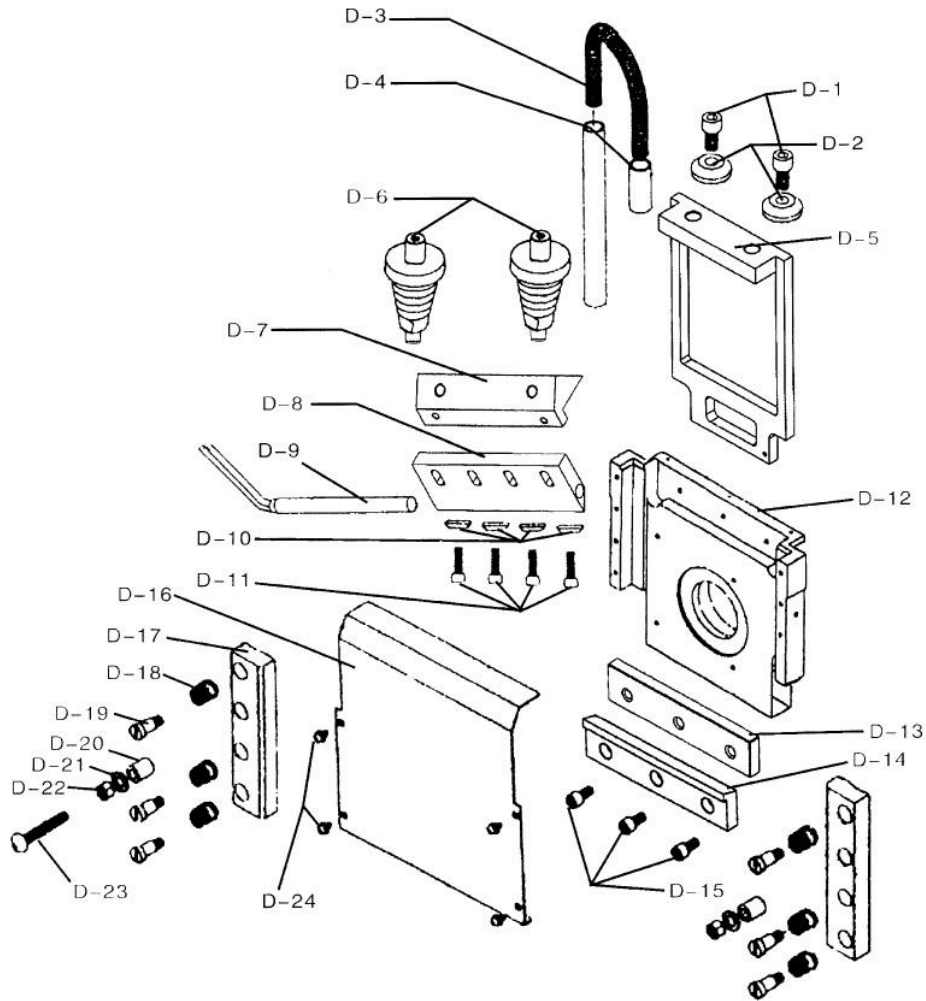
(COLD) SPARE PARTS



(COLD) SPARE PARTS

Part No.	Decription	Part No.	Decription
B-1	upper knife case	B-21	clamping bolt (M3x20L)
B-2	upper knife case	B-22	clamping bracket
B-3	wrench bolt (M5x15L)	B-23	clamping bolt (M3x15L)
B-4	neck washer	B-24	right pressure plate
B-5	couting-sensor bracket	B-25	left pressure plate
B-6	clamping bolt (M4x6L)	B-26	pressure spring
B-7	lower knife case	B-27	clamping bolt of pressure plate
B-8	wrench bolt (M5x15L)	B-28	urethane bush
B-9	lower knife	B-29	tesion-control washer
B-10	wrench bolt (M5x10L)	B-30	tension-control nut
B-11	motor+reduction gear	B-31	clamping bolt (M5x30L)
B-12	clamping bolt (M5x42L)	B-32	front cover
B-13	motor supporter	B-33	clamping bolt (M3x5L)
B-14	motor key		
B-15	snap ring		
B-16	ball bearing (#6004)		
B-17	crank bundle		
B-18	ball bearing (#6000)		
B-19	E-ring		
B-20	couting sensor		

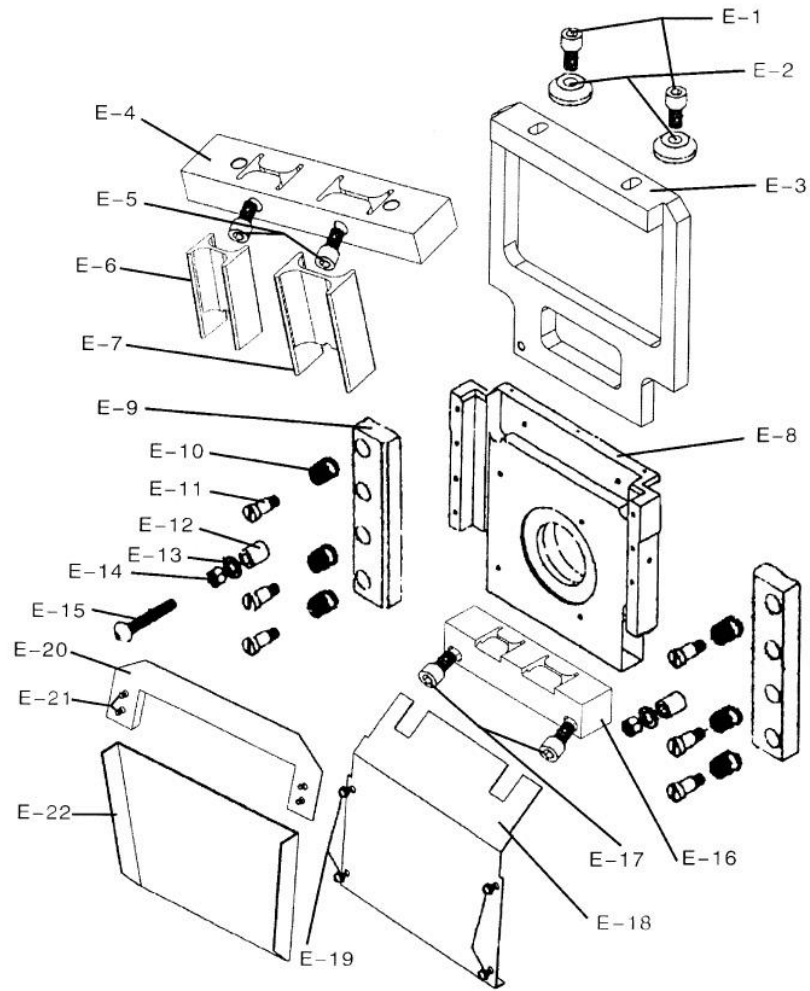
(COLD & HOT) SPARE PARTS



(COLD & HOT) SPARE PARTS

Part No.	Decription	Part No.	Decription
D-1	bolt M8x28	D-21	washer
D-2	washer	D-22	but
D-3	heating spring	D-23	bolt M5x30
D-4	heating spring	D-24	bolt M3x5
D-5	upper knife holder		
D-6	knife holder		
D-7	knife fixed block		
D-8	upper knife		
D-9	heating tube		
D-10	washer		
D-11	bolt M5x15		
D-12	lower knife holder		
D-13	lower knife packing block		
D-14	lower knife		
D-15	bolt M5x15		
D-16	bed plate		
D-17	guide way plate		
D-18	spring		
D-19	T-shape bolt		
D-20	pressing sleeve		

ROUD SPARE PARTS



ROUD SPARE PARTS

Part No.	Decription	Part No.	Description
E-1	bolt M6x30	E-21	bolt M3x5
E-2	washer	E-22	material guid plate
E-3	upper knife holder		
E-4	upper cutting die soleplate		
E-5	bolt M6x12		
E-6	upper cutting die (1.5/1.0)		
E-7	upper cutting die (2.0/2.5)		
E-8	lower knife holder		
E-9	guide way plate		
E-10	spring		
E-11	T-shape bolt		
E-12	pressing sleeve		
E-13	washer		
E-14	nut		
E-15	bolt M5x30		
E-16	lower cutting die		
E-17	bolt M6x32		
E-18	front cover		
E-19	bolt M3x5		
E-20	baffle		

**AUTO CUTTING MACHINE
CIRCUIT DIAGRAM**

