

# 使用说明书

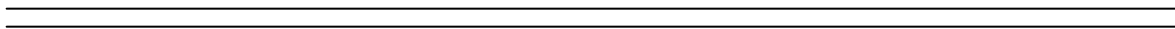
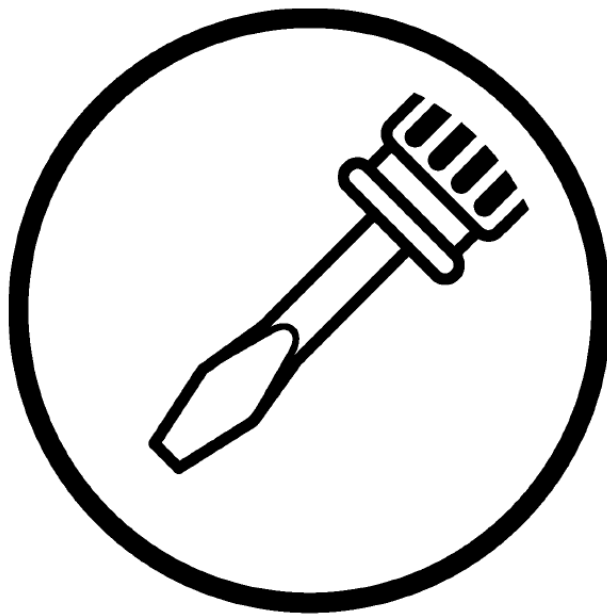
Operating Instruction

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## 衣领切翻机

Collar Trim Machine



# 衣领切翻机 Collar Trim Machine

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非常感谢您购买并使用本公司产品。在使用本产品前，为了您的安全使用，请仔细阅读使用说明书。今后产品改进所涉及的更改恕不通知。

Thank you very much for purchasing and using our products.

Before using this product, please read the instructions carefully for your safe use. The changes involved in future product improvements will not be notified.

## 一、 产品规格 **Product specifications**

电源电压	单相 200-230V
频率	50/60Hz
工作环境	温度： 5-35℃， 湿度： 35—85%
消耗功率	350W
气压	0.45MPa—0.75MPa

Supply Voltage	Single Phase : 200-230V
Frequency	50/60Hz
Work Environment	Temperature: 5-35℃ Humidity: 35—85%
Consumed Power	350W
Pressure	0.45MPa—0.75MPa

## 二、 安全使用注意事项 **Notes for safe use**

机器的安装必须由专业人员进行。

Installation of the machine must be performed by a professional person.

(1)、市电的插孔内必须有接地线（PE 线）。接地线没有或不牢固，是造成触电或误动作的原因。

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(1)、 There must be grounding wire (PE wire) in the jack of mains.

The ground wire is not strong or not firm, which is the cause of electric shock or malfunction.

(2)、为防止造成伤害或损坏，通电前，请先清除机器下部及旁边的所有物件。尤其不要把手放在切刀下方。

(2)、 In order to prevent damage or broken, remove all the lower and next parts of the machine before power on. **Especially don't put your hand under the knife.**

(3)、清理机器时，请先断开电源。

(3)、 Please turn off the power supply first when cleaning the machine.

(4)、在关闭电源开关并将电源插头从插座上拔下，至少等待 5 分钟后，再打开控制箱盖，否则，触摸带有高电压的区域将会造成人员伤亡。

(4)、 Turn off the power switch and unplug the power plug from the socket, and wait for at least 5 minutes before opening the cover of the control box, otherwise, touching the area with high voltage will cause casualties.

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## 三、 安装、调试: **Installation**

### 1、 开机检查 Open Check

打开包装后，先检查整体有无因碰撞造成损坏，如有，请先联系物流单位协商处理，再检查各部位有无因运输振动造成的螺钉松动或零件脱落，如有，则先紧固和恢复原位安装好。

After opening the package, first check whether the overall damage is caused by the collision. If so, please contact the logistics unit to negotiate for treatment, and then check whether the screws are loose or the parts fall caused by the vibration of transportation. If so, first tighten and install in place.

然后，将台板支架按人体舒适高度安装好，按台板上已有孔位，固定好机器。

Then, install the platform plate bracket according to the comfortable height of the human body, press the existing hole position on the platform plate, and fix the machine.

**A:** 气路检查：将气源接入机器后方的空气减压滤清器入口，将图 1 左侧的蓝色开关向右拉动到位打开气阀，此时，机器的切刀气缸抬起，顶针气缸缩回。如果没有以上动作，请检查气源和气路。

**A:** Gas path check: connect the gas source to the entrance of the air decompression filter behind the machine, pull the blue switch on the left side of Figure 1 to the right to open the air valve to the right,

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and then the cutter cylinder of the machine is lifted and the thimble cylinder is retracted. If there is no above action, please check the gas source and gas path.

B: 气压的调节: 将图 1 中过滤调压阀上部的圆柱上拉, 然后顺时针旋, 则压力加大, 逆时针旋, 压力减小, 把压力调节到  $0.5+0.5\text{MPa}$  (根据布料厚薄, 大小不同造成的阻力调节, 以保证拉动正常速度合适为好)。

B: Air pressure adjustment: pull the cylinder on the upper part of the filter pressure regulator in Figure 1, and then rotate clockwise, the pressure will increase, counterclockwise, pressure reduction, the pressure is adjusted to  $0.5+0.5\text{MPa}$  (according to the thickness of the cloth caused by different resistance adjustment, in order to ensure that the normal speed is appropriate).

注意: 机器出厂基本上已调定好, 先检查, 不在范围再调整。

**Note: the machine factory has basically been adjusted well, check first, not in the scope of adjustment.**



图 1

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## 2、通电检查调试 **Power-on inspection and debugging**

A: 上电检查: 将机器的电源插头插入带有 PE 线的市电插孔内, 按机器前方右侧的电源开关“ON”键, 开机, 机器前端面上数码管灯亮。

A: Power-on inspection: insert the power plug of the machine into the mains jack with PE cable, press the power switch "ON" key on the right side of the front of the machine, turn it on, and light the digital light on the front end of the machine.



图 2

## B、面板按键说明 **Panel key instructions**

符号	按键名称	功能说明
P	设置键	按此键切换当前显示的参数内容 (即 F→O→d→N→H→P→…), 并可通过▲、▼进行更改 高温报警可通过 P 键消除
▲	增加键	按此键可增加当前显示参数值, 长按快速增加
▼	减少键	按此键可减少当前显示参数值, 长按快速减少
↑↑↑	加热键	按此键可开关加热功能

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symbol	Key name	function declaration
P	Set key	Press this key to switch the currently displayed parameter content (F→0→d→N→H→P→...), and you can change the high temperature alarm through ▲, ▼, which can be eliminated by the P key
▲	Increase key	Press this key to increase the current display parameter value, and press a long press to increase quickly
▼	Reduce key	Press this key to reduce the current display parameter value, and press a long press to quickly reduce
↑↑↑	Heat key	Press this button to switch on and off the heating function

## 参数设置说明 Parameter setting instructions

控制面板显示内容：开机后显示 2S 设定温度后，切换到常态显示当前温度。

按 P 键时，面板循环显示下列参数内容，并在当前显示的内容下可通过▲、▼进行更改，同时保存记忆，下次开机时，设定的参数仍然有效。5s 没有任何按键回到当前温度显示。

Control panel display content: after boot display 2S set temperature, switch to normal display the current temperature.

When pressing the P key, the panel cycles the following parameters, which can be changed through ▲ and ▼, and the memory can be saved. The next time, the set parameters are still valid. 5s Without any keys back to the current temperature is displayed.

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代号	说明	出厂值
×××	温度设定，050~200	80
d ××	热压保持时间设定：0~50，单位 100ms，0 代表不使用热压保持功能，跟随热压踏板放下和抬起	30
U ××	顶针脚踏控制设定：00~01，00 代表实用脚踏控制，01 代表自动控制，脚踏无效	01
T ××	顶针气缸延时自动退回时间设定：05~50，单位：100ms	05
H ××	无烫领动作加温自动关闭延时时间，00~30，单位 1 分钟，0 代表没有自动关闭加热功能	0

Code	Note	default
xxx	Temperature setting, 050~200	80
d xx	Thermal pressure holding time is set: 0~50, per unit of 100ms, 0 means that by not using the thermal pressure holding function, follow the thermal pressure pedal down and lift	30
U xx	Top pin foot control setting: 00~01,00 Representative Practical Foot Control, 01 Represents automatic control, foot pedal ineffective	01
T xx	The thimble cylinder automatically returns to the thimble for delay time, the unit is 100ms	05
H xx	The auto stop heat delay time of no operation, 00~30, the unit is 1 minute, 0 means no auto stop heat function	0

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C: 此机配有双联脚踏开关：左边的为切领机的顶针气缸伸缩，脚踏下，气缸伸出，脚松开，气缸退回。右边的为定型机的上压板上、下动作控制，脚踏下，上压板压下，脚松开，上压板抬起。

C: This machine is equipped with a double pedal switch: on the left is the cutting machine thimble cylinder expansion, press the foot, the cylinder out, the foot release, the cylinder back. The right is the setting machine's upper pressure plate, the action control, press the foot, the pressure plate put down, the foot release, the pressure plate lifted.



图 3

### 3、操作 operate

当参数设定好后，将领尖套在衣领衬板上调整好并压下时，后端的传感器感应到信号，切刀自动下压切掉一边领角多余布并自动抬起（注意，此时手压住领尖衬板不要动），同时，电机带动切刀自动旋转  $180^\circ$  到另一个对应角度后，切刀再次下压切掉另一边领角多余布并自动抬起，此时踩下脚踏开关，切领机的顶杆气缸伸出，手带动切好尖角的衣领回

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到上位置，尖部正好与顶杆尖端相压，手动将衣领拉向人体侧（**注意，用力要适当，否则易刺穿领角**），同时切刀就停留在胡位等下次动作。脚踏松开，气缸退回，完成一次工作循环。

When the parameters are set, When the collar put on the collar liner and pressed down, The sensor at the rear end senses the signal, The cutter automatically cuts off the extra cloth and automatically **(note, Press the collar tip liner and do not move)**, at the same time, After the motor drives the cutter and automatically rotates set angle to another corresponding angle, Cut the knife again and off the other corner and automatically lift, Press on the foot switch right now, The top rod cylinder of the cutting is out, The hand drives the pointed collar back to the upper position, The tip is exactly pressed with the top rod tip, Manually pull the collar toward the human side (note, Apply a proper force, Otherwise, it can easily puncture the collar horn), At the same time, the knife stays in place for the next action. The foot loosened, the cylinder returns to complete a working cycle.

压烫时，先用领型衬板立于台板上的衬板座内，将领角套在衬板上，用手调整对称，并用手压紧，将领尖前端放入定型机的上、下压板之间，用脚踏下右侧脚踏开关，上压板压下，当热压保持时间设定 $\geq 1$ 时，垫压的时间是由机器内部自动控制的，当热压保持时间设定=0时，则由脚控制，脚离开脚踏开关，定型机的上压板即抬起。

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When pressing, collar put on the liner, adjust symmetry with the hand, and hand pressing, between the tip front into the shaping machine press plate, with the foot press the right foot switch, under the pressure plate, when the hot pressure holding time set 1, pad pressure time is automatically controlled by the machine, when the hot pressure holding time set =0, is controlled by the foot, foot leave the foot switch, set the machine press plate lift.

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## 四、故障类型、代码与处理

### Fault type, code and handling

故障均需排除故障之后重新上电才能恢复，如果经过初步的故障处理指示排除问题后仍然报警，请联系当地经销商或厂家。

The fault can only be restored after troubleshooting. If the alarm is still reported after the preliminary troubleshooting instructions, please contact the local dealer or the manufacturer.

故障类型	故障指示	故障处理
过压	E01	检查市电交流输入，如正常则更换控制器。
欠压	E02	检查市电交流输入，如正常则更换控制器。
加热器失控	E04	加热器失控温度过高，请联系厂家更换控制器。
电机过流	E05	检查步进电机是否有堵转、卡死，无则更换控制器。
电机不转	E06	检查电机接线或更换电机，仍不行，则更换控制器。
EEPROM 数据错误	E07	重启一次，仍报则更换控制器。
过零点检测不到	E08	重启一次，仍报则更换控制器。

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Fault Type	Fault Indication	Fault Treatment
Over voltage	E01	Check the AC input and replace the controller if normal.
Under voltage	E02	Check the AC input and replace the controller if normal.
The heater is out of control	E04	The heater runaway temperature is too high, please contact the manufacturer to replace the controller.
Motor over current	E05	Check whether the stepper motor is blocked and stuck, and replace the controller without it.
The motor does not turn	E06	Check the motor wiring or replace the motor, then replace the controller.
EEPROM data error	E07	Restart once, still report, then replace the controller.
Zero test error	E08	Restart once, still report, then replace the controller.

## 五、常见问题处理方法 **FAQ methods:**

1、角度不对称问题的处理：由于该机的旋转是由步进电机完成，当受阻时会有失步现象存在，造成角度偏差积累，当发现剪切二边不对称时，可断电，手动让剪刀基本处于零位，再上电，电机自动找回零位，即可继续工作。

1、 Angle asymmetry processing: because the rotation of the machine is completed by the stepping motor, when blocked, there will be out of step phenomenon, causing angle deviation accumulation, when the shear side asymmetry, can be cut off, manually let the scissors are basically in zero, and then power, the motor automatically find the zero, can continue to work.

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## 2、剪切力的调整 Adjustment of the shear force:

我们的剪切力出厂时是按中等厚度的布料调整的，当布料厚了剪切力偏小时，可以打开下图 4 的盖子，将螺母向弹簧方向旋 1-2 圈，调大定刀向动刀的压力（但必须保证弹簧还有压缩量），最后再将二个螺母相互锁紧。同时，可调节 2A\B，加大气压的速度，直到满足要求。但一定不能调整三个刀（技术好的专业机修工除外）。反之，如果布料较薄，为了延长刀的寿命，建议将弹簧力减小些。

Our cut force is adjusted according to the medium thickness of the factory. When the cloth thick cut force is small, we can open the lid of figure 4 below, turn the nut to the spring 1-2 times, adjust the pressure of the cutter to the moving knife (but must ensure the spring and compression amount), and finally lock the two nuts to each other. Meanwhile, 2A \ B can be adjusted to increase the speed of air pressure until the requirements are met. But must not adjust three knives (good professional mechanic except). On the contrary, if the cloth is thin, in order to extend the life of the knife, it is recommended to reduce the spring force.

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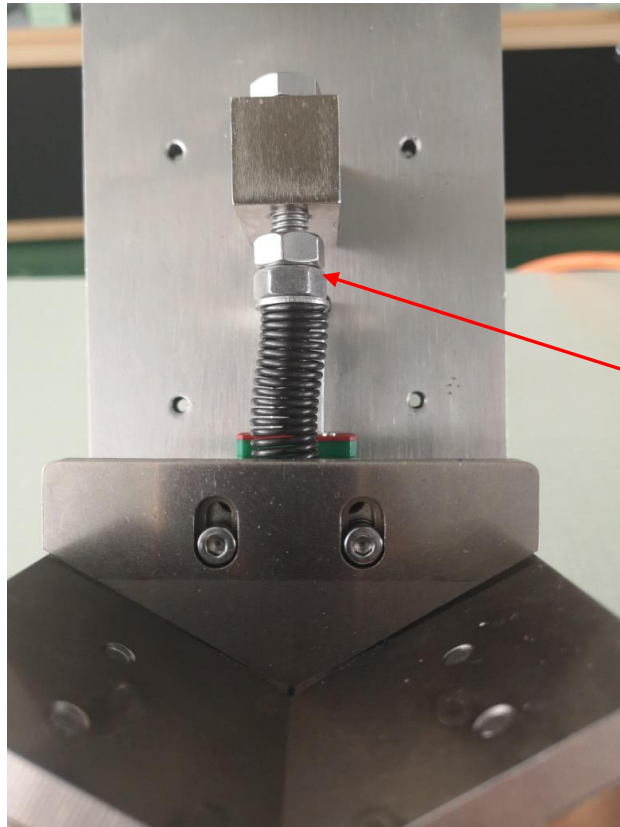


图 4

如果想单独用布试切刀，请用 15mm 左右宽的布条试切即可，不可用很宽的布条试，否则可能会出现不能完全切断的现象，这并不代表切衣领也是切不断的。因此，不必也不要轻易的去重新调整刀。

If you want to use a cloth test cutter, please use about 15mm wide cloth to try cutting, do not use a very wide cloth test, otherwise there may be the phenomenon of not completely cut off, which does not mean that the collar is also cut constantly. Therefore, do not have to and do not easily go to readjust the knife.

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## 六、线路图 Wiring diagram:

