全自动电脑冷热切带机

AUTO CUTTING COLD HEAT MACHINE

QD-9880
QD-1250

使用说明书

INSTRUCTION MANUAL

EAC

1.Brief introduction

The fully automatic computerized tape cutting machine is a new type of special machine. It uses computer software to automatically control the action of the machine. It can automatically cut the braided belts, Velcro, plastic hoses, shoelaces, plastic zippers, computer cables, trademarks and other makeup items of different widths and lengths according to the length you need. This machine is designed with compensation function according to the different elasticity of the material, so the accuracy cutting could be made. It is equipped with a heating device, which can heat and seal various nylon braided tapes of different sizes, nylon trademarks and other nylon tape materials. Cold cutting and hot cutting does not need to change the cutter. Infrared positioning device (CQ-130), through the infrared sensor system to locate and accurately cut all kinds of trademarks with different widths. The velcro cutting device for round corners cuts off all kinds of rounded velcro. And before the switch is turned off, all the data currently set are automatically stored. This machine is with high accuracy, fast speed and flat section, automatic stop working without material, simple operation and other characteristics, which is your first choice to improve production efficiency and product quality, and save labor cost.

2.Specification

power	Maximum cutting width	Cutting length	Cutting speed	Voltage	Package dimensions
0.28KW	105mm	1mm-99999mm	80-100/min	100/230V 50/60Hz	560*415*400

3.Use environment

This machine works at normal temperature. If it works at too high temperature (hihher than 80 degrees Celsius), it will affect the performance of the machine. This machine has no impact on the environment and energy.

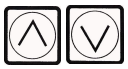
4.Method of operation

How to operate: (For example: set length 100mm and quantity 50pcs)

Turn on the power switch (power sw).

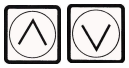
Press the length setting key 

then press the setting 

key , press the ∧∨  **key and then press the** 

setting key to enter the previous digit setting.

Press the Quantity setting 

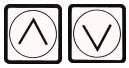
key , then press the setting key , press the  **∧∨ key, and then press the** 

setting key to enter the previous digit setting.

Speed setting: first press and hold the length setting key, 

then press the quantity setting key, 

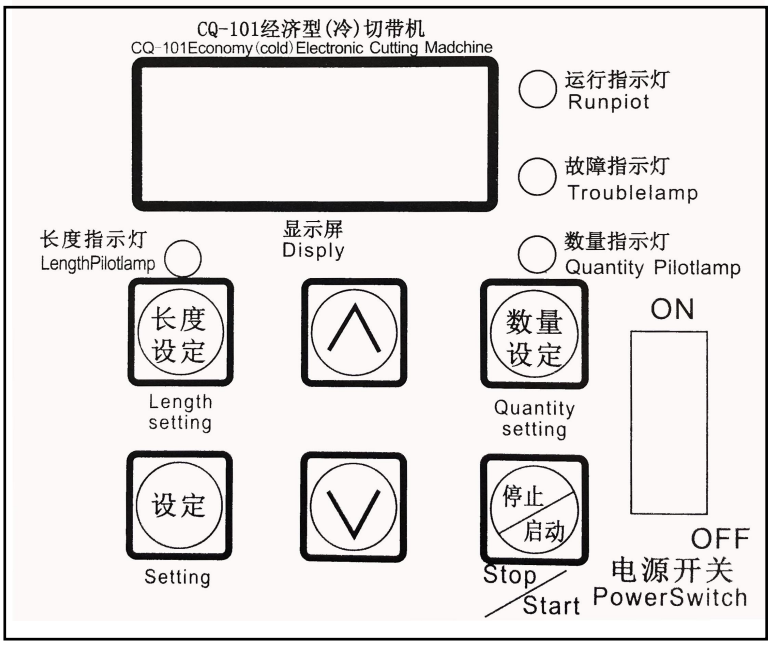
then press the setting key, 

and then press ∧∨  **to adjust.**

After the length is set, press the stop/start button, 

and the machine starts to work.

5.Panel function introduction



Power Switch 电源开关

Quantity set up **Press this key to enter the current quantity setting state.**

Length set up **Press this key to enter the current quantity setting state.**

set up **When you press the quantity setting, and length setting, Press the set button to enter the current quantity or length setting.**

Press one more time to jump one digit.

∧ **Press this key to indicate that the number increases, when machine is in stopped position, press it means feeding forward.**

∨ **After pressing this key, the number will decrease, when machine is in stopped position, press it means feeding backwards.**

Stop / Start up **Pressing this key, stop or star the machine.**

Speed adjustment: After the machine stops, press the length setting key first, Length set up **and then press the quantity at the same timeSet button,** Quantity set up **release with both hands, then press set button, then press button** ∧ **accelerate** ∨ **slow down.**

6.matters needing attention

1. Please confirm the power supply voltage and ground wire before use.

2. To ensure safety, please do not put your hands or any objects close to the cutter during the cutting process.

3. When making any adjustments, please cut off the power first to ensure safety。

4. Except for normal maintenance, please do not disassemble any spare parts arbitrarily.

5. Pls add oil each time before starting machine.

6. If the knife becomes blunt after using some period, it can be sharpened on a professional grinder. (Note: This work must be performed by professionals).

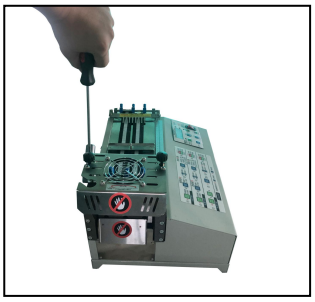
7. If you have any difficulties in operation, please contact our company, we will serve you wholeheartedly.

QD-9880 QD-1250 Computerized old and hot tape Cutting Machine

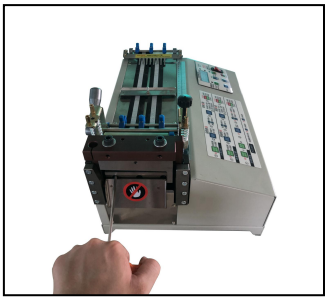
7. how to change the knives

1. First use a cross-shaped screwdriver to loosen the 4 pcs M3 screws on the safety cover, and then remove the safety cover. (Picture 1)

2. Use a 4m Allen key to loosen the 2 pcs M5 cylindrical head Allen screws on the upper knife and remove the upper knife. (Picture 2)



(Picture 1)

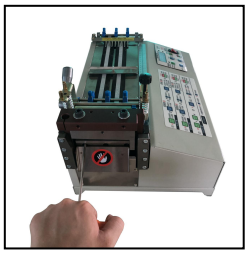


(Picture 2)

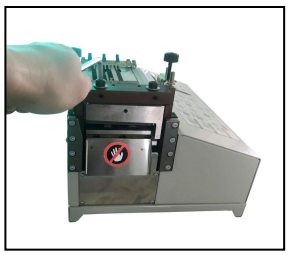
3. Loosen the 3 pcs M5 cylindrical head hexagon socket screws on the lower knife with a 4mm internal six-solution wrench, and remove the lower knife. (Picture 3)

4. Fasten the new knife to original position by 2 pcs M5 cylindrical head hexagon socket screws, press it tightly. (Picture 4)

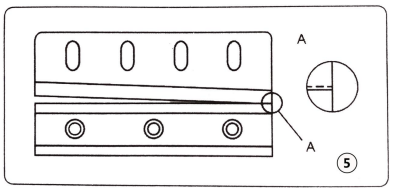
5. Press the start button after turning on the power switch, and then directly turn off the power switch when the upper knife shaft moves down and keep the upper knife shaft stay at the lowest position, and finally install the upper knife closely contact with the lower knife, and slightly tighten 2 pcs upper knife screws M6 cylindrical head hexagon sockets Screw. (Picture 5)



(Picture3)



(Picture4)



(Picture5)

6. Pressing start button, use paper or thin fabric to test and cut to see if the upper knife and lower knife are installed correctly.

7.If the knives work normally, please firmly tighten the two pcs M6 cylindrical head hexagon socket screws on the upper knife shaft and the 2 pcs control screws on the upper knife shaft.

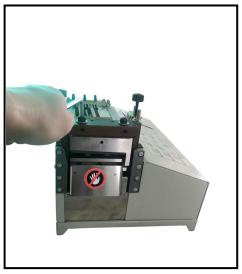
8.Re- install and fix the safety cover.

QD-9880 QD-1250 Computer Cold and Hot Tape Cutting Machine

8. how to change the knives

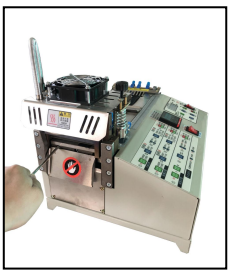
(Picture 1)

First loosen the 4 pcs cross-shaped screws and remove the safety cover.



(Picture 2)

Loosen the two pcs M10 hexagon socket screws of the upper knife, remove the upper knife, and then loosen the fixing screws of the electric heating part.

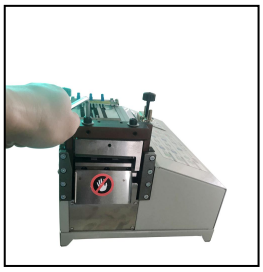


(Picture 3)

Loosen the 3 pcs M5 countersunk hexagon socket screws of the lower knife and remove the lower knife.

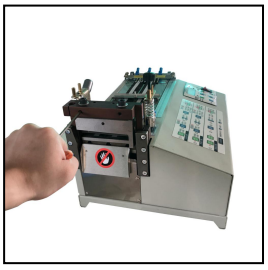
(Picture 4)

Replace with a new knife, and tighten 3 pcs M5 countersunk hexagon socket screws.



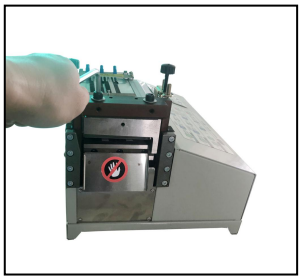
(Picture 5)

Install the upper knife and tighten the 2 pcs M10 hexagon socket screws.



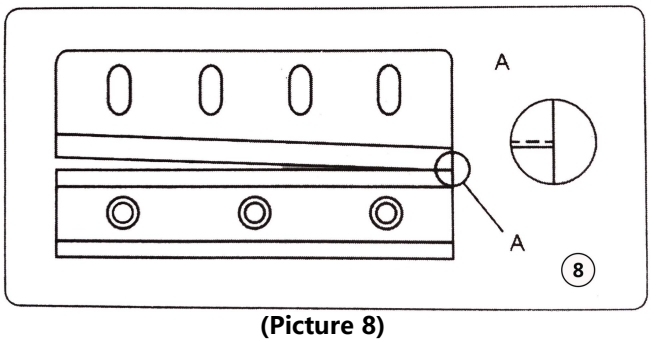
(Picture 6)

1. Loosen the first two pcs M5 set screws.
2. After the upper and lower cutters are installed, if the material is could not be cut, you can slowly tighten the 2 set screws inwards.



(Picture 7)

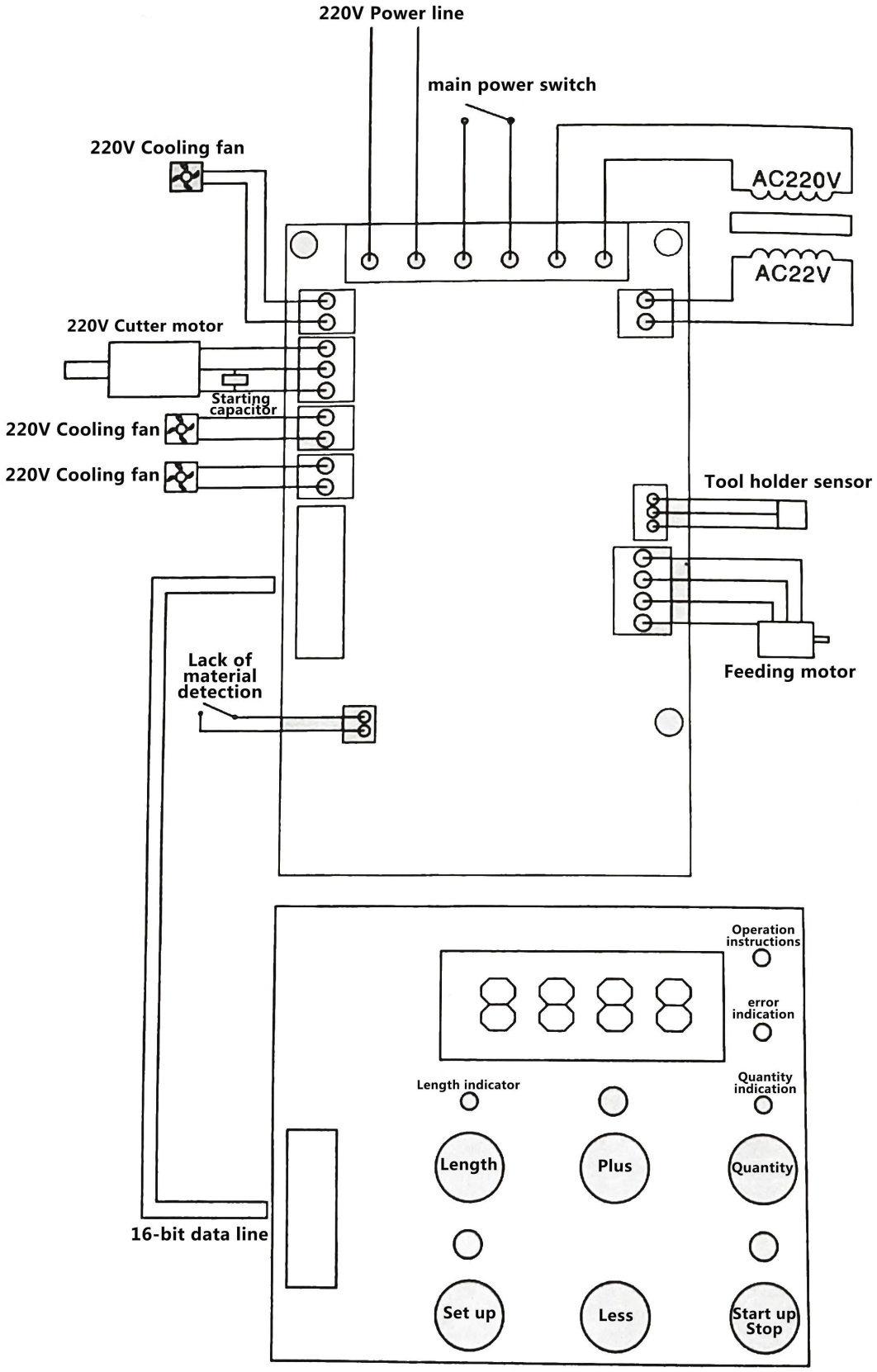
Loosen two pcs M10 hexagon socket screws, move them forward and lock them.



(Picture 8)

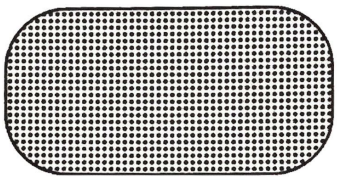
Turn on the power switch and press the start button, and then directly turn off the power switch when the upper knife shaft is moving down, so that the upper knife shaft stays at the lowest position, and finally the upper knife is installed in close contact with the lower knife, and then slightly tighten 2 pcs M10 cylindrical head hexagon socket screws on upper knife shaft. (Figure 8)

8.Wiring diagram



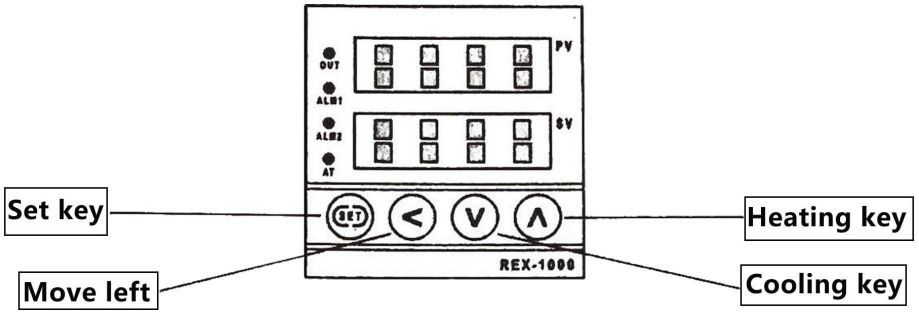
note:
Do not cut both sides of the Velcro tapes at the same time.
When cutting the Velcro and feeding material, the wool side must be facing up and the smooth side down .(as shown in the figure below)

Hair side up (correct)



Hairy side down (error)

9. How to use the temperature controller CHB401-011-0112023

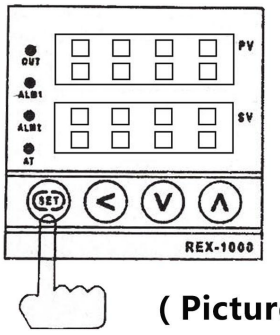


When you turn on the temperature controller, PV will display the current indoor temperature, and SV will display the temperature you set. It is recommended that the temperature be controlled between 130-350 degrees.

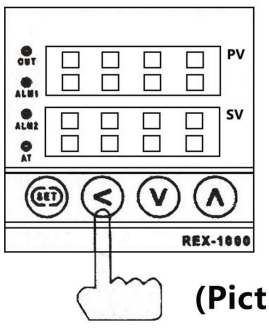
It will take about 10 minutes to reach the temperature you set.

1. Press the SET button to enter the setting program. At this time, you will see the SV display flashing, indicating that this number can be changed. (Picture 1)

2. <is the key to move to the left, which can help you select the number that needs to be changed. (Picture 2)

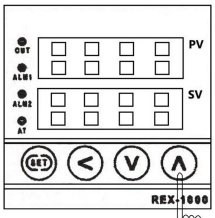


(Picture 1)

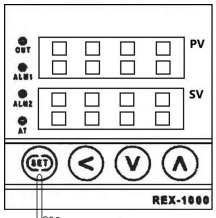


(Picture 2)

3. ∧∨ is the temperature adjustment key, ∧ means heating up, and ∨ means cooling down. (Picture 3)
4. After the setting is completed, you need to press the SET button again to stop the number flashing, and the temperature controller will return to the self-operating mode at this time. (Picture 4)



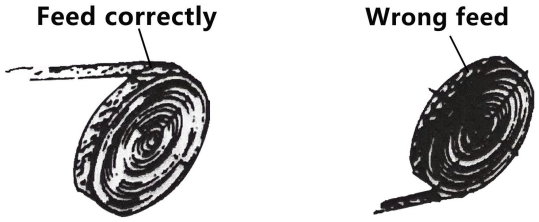
(Picture 3)



(Picture 4)

10. Trouble shooting:

1. If the thermostat does not work, check whether the wiring is loose.
2. If the cutting edge is not completely sealed, the temperature of the thermostat is set too low. It is necessary to gradually increase the temperature until the cut edge is completely sealed.
3. The material belt is placed in a vertical position (see picture). When starting to feed, the material can be fed into the knife edge by manual feeding, and it can work normally after the temperature reaches the set temperature.



4. When replacing the upper knife, the screw fixing the upper knife is too tight to be unscrewed. Please turn on the temperature controller and heat it to about 200 degrees before loosening the screw. After loosening the screw, turn off the temperature controller and wait. After the cutter is completely cooled, the screw can be completely unscrewed and the upper cutter can be replaced. (Caution: Be careful of burns when loosening the screws after heating)

Serial number	Happening		Corresponding model	Reasons and measures
1	No power		All models	Check whether the power connection plug wire is in good contact
				Check if the fuse is broken
2	There is power, but cannot start	The roller does not rotate	All models	Check whether there is debris on the roller
				Check whether the set screws of the synchronization wheel and stepper motor are loose
		Theknife shaft does not start	The red fault light does not flash	Loosen the sensor screw and move it up to lock
				Check the proximity switch of the knife shaft, whether the sensor is too far away from the proximity switch, the normal distance is 3mm
			Red fault light flashes	Check whether the lack of material device switch is reset
		Turn on the machine, the knife shaft moves then machine makes alarm		Check whether the B-27 screw is too tight
				Check whether the cut-off sensor is loose and the distance of the sensor sheet should be within 4mm. If the power-on display is abnormal, please turn off the power and wait 10 seconds before turning it on again. If the above procedure is repeated several times, machine is still abnormal, open the machine cover and check the computer connection plug. (Especially the operation panel and CPU control panel)
3	Unable to cut the strap		Hot knife	Check if the temperature reaches the preset temperature

			Check if the hot knife is heated

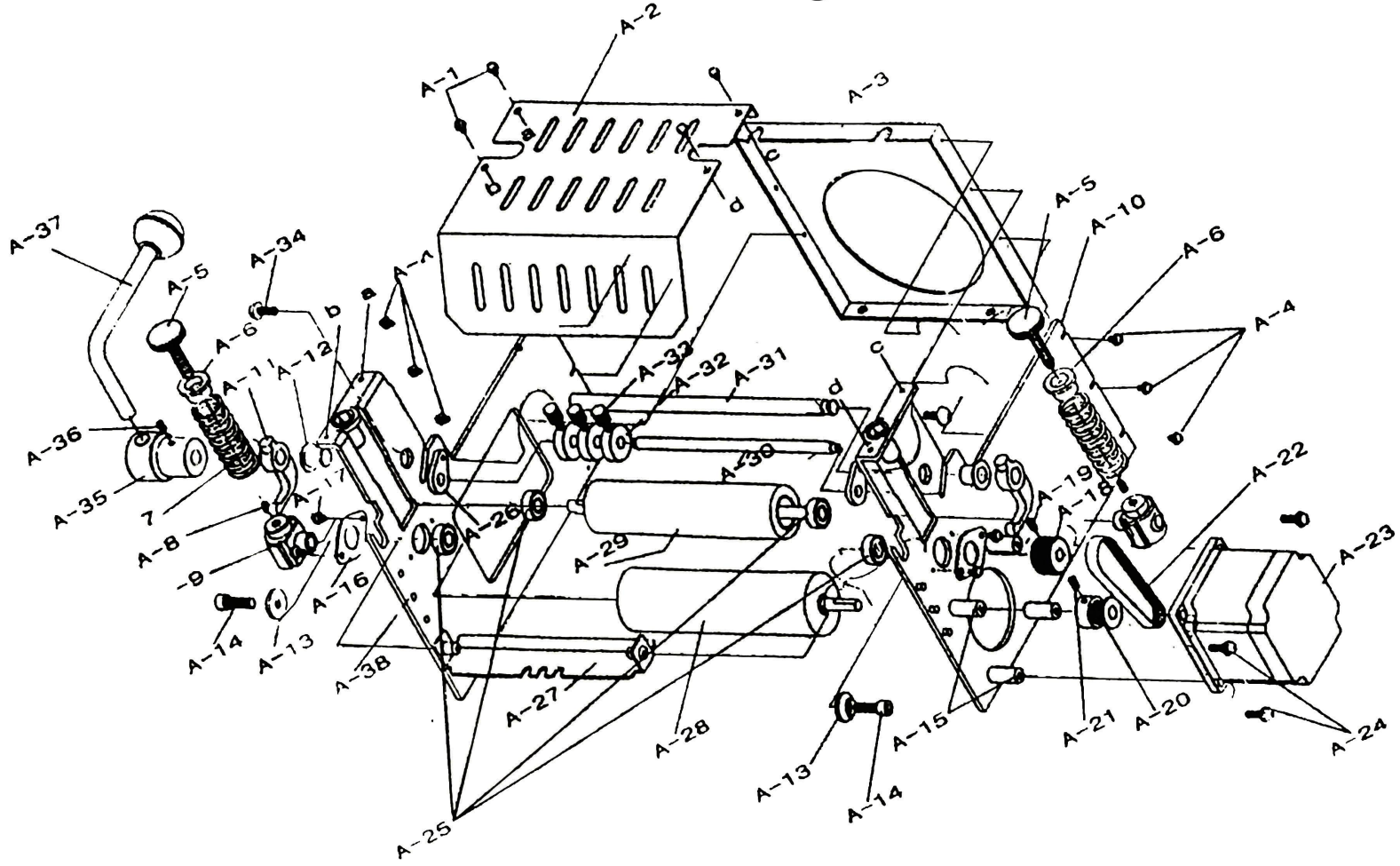
4	Cut only one side of the belt	All models	Check whether the hot knife is damaged or wear off
			Check the alignment of the upper knife and the lower knife and keep them horizontal. (If the level is not maintained, loosen the screw and adjust)
5	The cut length is different from the set value	All models	Tighten the A-5 adjusting screw or use the belt conveyor (cut off)
6	When the hand touches the device, there is electric current	All models	When installing this equipment, users need to equip themselves with an anti-shock leakage switch. The ground pole of the three-pin socket must have a good grounding wire to ensure the normal operation of the machine.

11. Warranty and maintenance instructions

1. Warranty for one year from the date of purchase; Knives are not warranted.

2. Oil must be added to the sliding part of the machine before starting each time, and the cooling fan must be cleaned of dust every week. Ensure good ventilation.

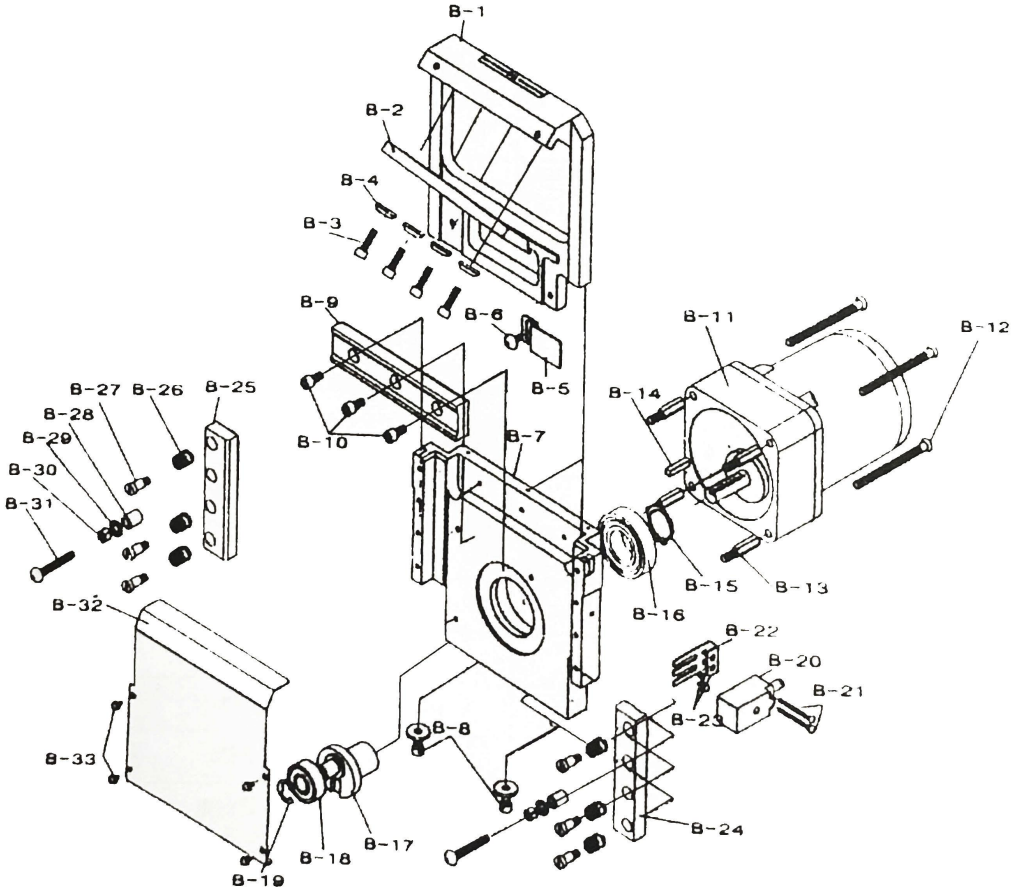
零件图
Parts drawing



Parts drawing

image name	name	image name	name
A-2	Upper cover of tape cutting device	A-22	Synchronous toothed belt (MxL75)
A-3	Back wall	A-23	Servo motor
A-4	Screw M3x5L	A-24	Screw M4x15L
A-5	Adjusting screw	A-25	Bearing (#696)
A-6	Spring positioning block	A-26	Transverse shaft seat
A-7	compressed spring	A-27	Knife front control material pressure plate
A-8	Screw M4x6L	A-28	Send pulley
A-9	Press belt roller seat	A-29	Pinch roller
A-10	Left cylinder seat	A-30	Horizontal axis
A-11	Bending seat	A-31	Bending and pressing shaft
A-12	Shaft sleeve	A-32	Sliding sleeve
A-13	washer	A-33	Screw
A-14	Screw M4x15L	A-34	Screw M4x15L
A-15	Servo motor seat	A-35	Handle seat
A-16	Small gland	A-36	Screw M5x5L
A-17	Screw M3x5L	A-37	Handle
A-18	Synchronous gear 1	A-38	Right cylinder seat
A-19	Screw M4x6L		
A-20	Small synchronous gear		

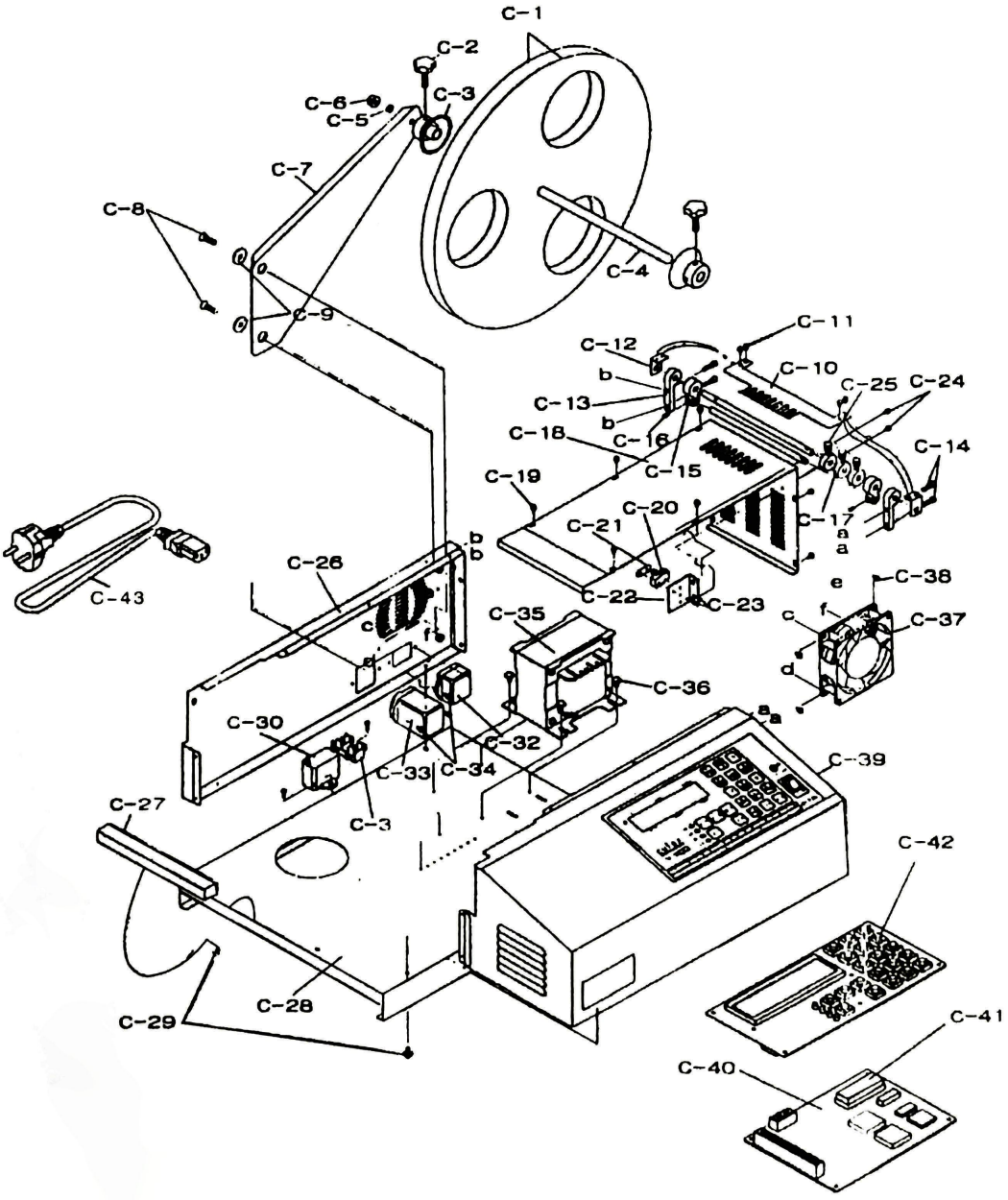
冷刀零件图
Cold knife parts drawing



Cold knife parts drawing

Drawing number	name	Drawing number	name
B-1	Upper knife seat	B-21	Screw M3x20L
B-2	Upper cutter	B-22	Electric eye seat
B-3	Screw M5x15L	B-23	Screw M3x15L
B-4	washer	B-24	Rail pressure plate
B-5	Baffle	B-25	Rail pressure plate
B-6	Screw M4x6L	B-26	Pressure spring
B-7	Lower knife seat	B-27	Screw
B-8	Screw M5x15L	B-28	Pressure sleeve
B-9	Lower cutter	B-29	washer
B-10	Screw M5x10L	B-30	Nut
B-11	Reduced speed motor	B-31	Screw M5x30L
B-12	Screw M5x42L	B-32	Left side cover
B-13	Connect the reducer screw	B-33	Screw M3x5L
B-14	key		
B-15	Elastic circlip for shaft		
B-16	Bearing (#6004)		
B-17	Eccentric wheel		
B-18	Bearing (#6000)		
B-19	Open ring		
B-20	Electric eye		

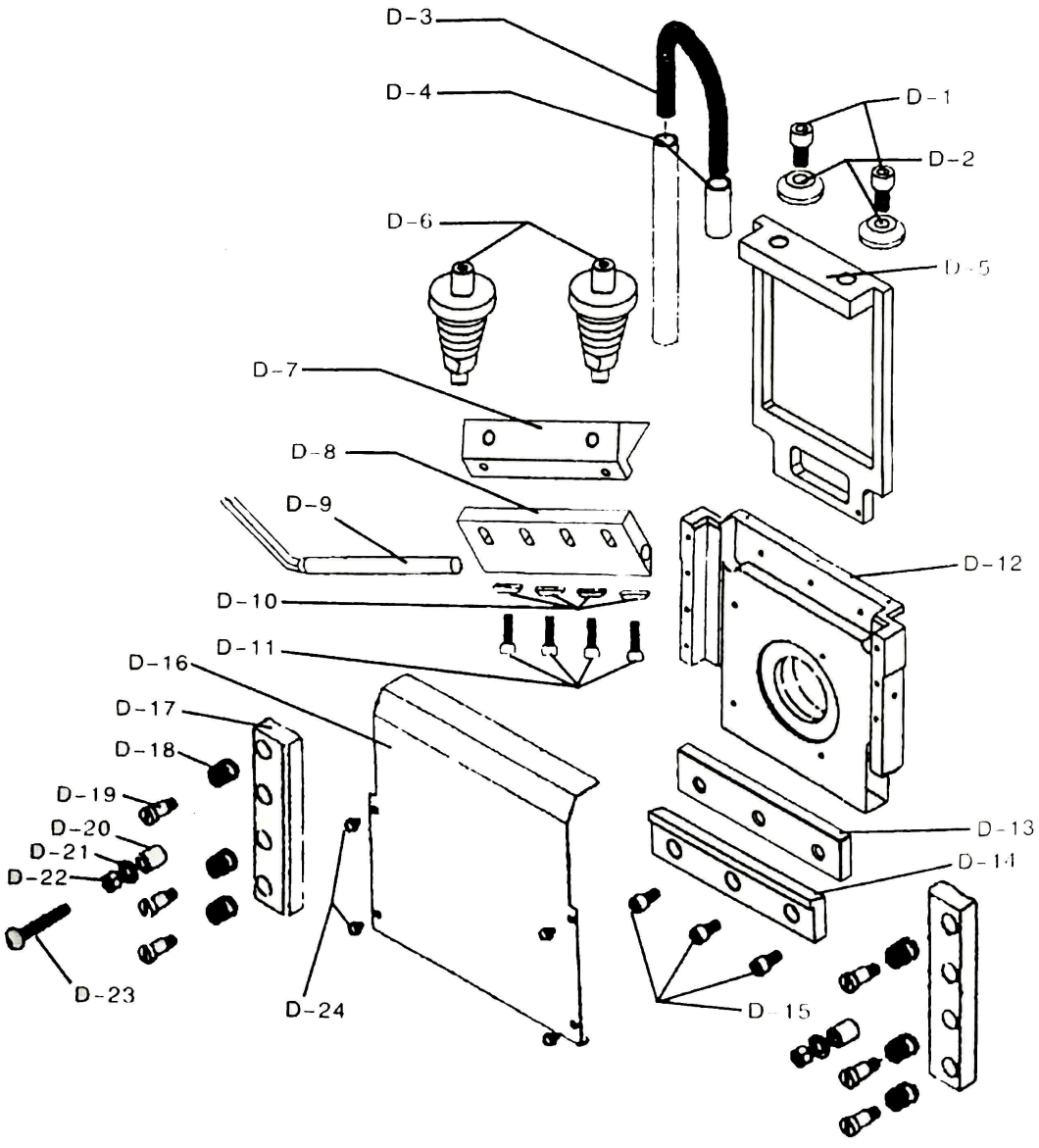
零件图
Parts drawing



Parts drawing

Drawing number	name	Drawing number	name
C-1	Stop plate	C-23	Screw M2x10L
C-2	Plum blossom handle	C-24	Screw M3x5L
C-3	Stop core	C-25	Screw
C-4	Unwinding arm shaft	C-26	Back cover
C-5	Washer 6	C-27	Fritters
C-6	Nut M6	C-28	Base
C-7	Unwinding arm	C-29	Screw M4x10L
C-8	Screw M6x15L	C-30	capacitance
C-9	Washer C	C-31	Terminals
C-10	Pressure plate	C-32	Electrical appliances
C-11	Screw M3x15L	C-33	Electrical appliances
C-12	Platen frame	C-34	Screw M3x5L
C-13	Pressure plate seat	C-35	transformer
C-14	Screw M4x15L	C-36	Screw M4x6L
C-15	Rocker seat	C-37	exhaust fan
C-16	Screw M4x6L	C-38	Screw M3x5L
C-17	Sliding sleeve	C-39	Front shell
C-18	Right cover	C-40	Control tool integrated electrical board (MB)
C-19	Screw M3x5L	C-41	ROM
C-20	Limit switch	C-42	Button Panel (OP)
C-21	Limit switch pressure plate	C-43	External wiring
C-22	Travel switch seat plate		

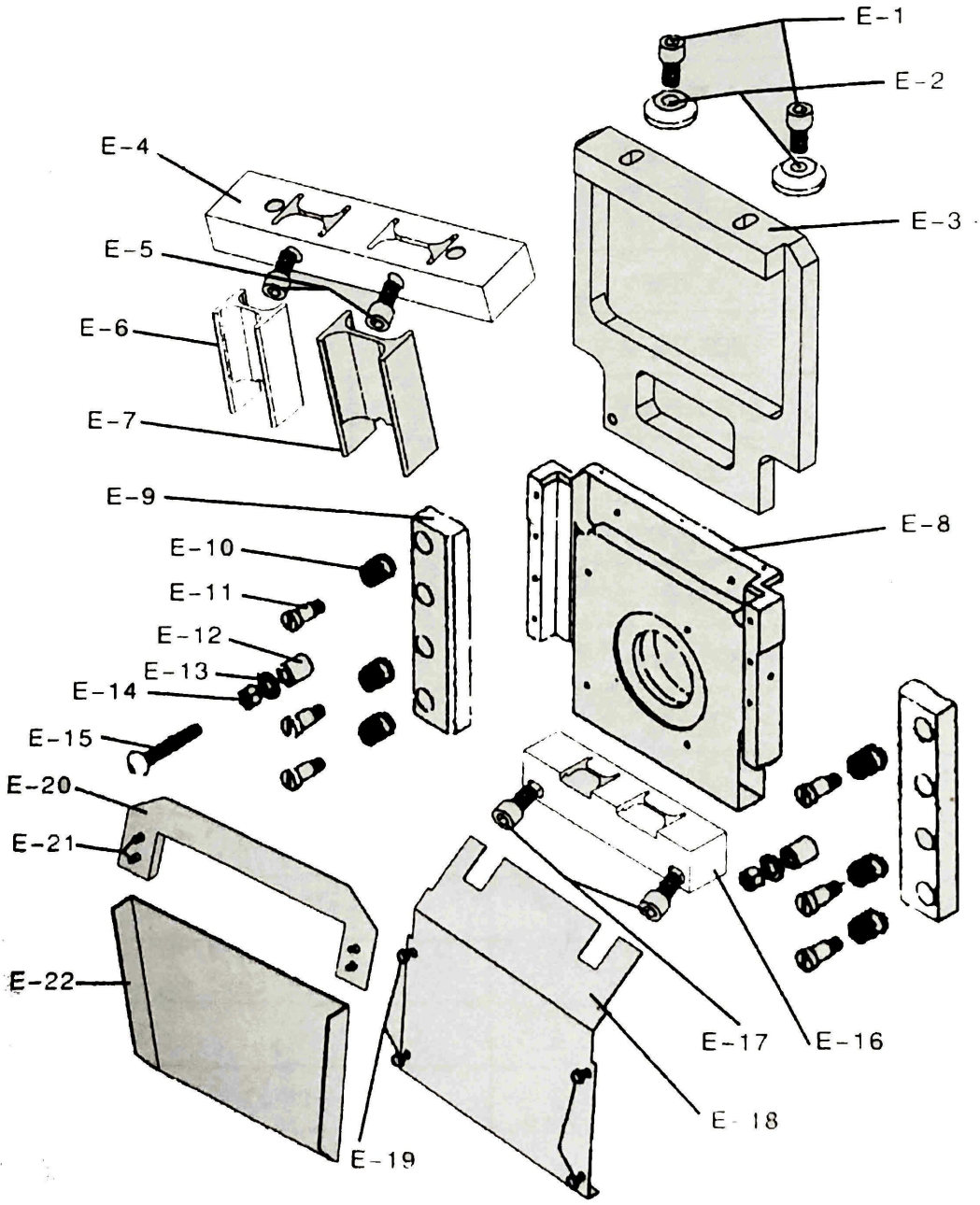
冷热刀零件图
Hot and cold knife parts drawing



Hot and cold knife parts drawing

Drawing number	name	Drawing number	name
D-1	Screw M8x28	D-21	washer
D-2	washer	D-22	Nut
D-3	Heating wire spring	D-23	Screw M5x30
D-4	Heating wire tube	D-24	Screw M3x5
D-5	Upper tool holder		
D-6	Heated knife holder		
D-7	Heating knife fixing block		
D-8	Upper cutter		
D-9	Heating pipe		
D-10	washer		
D-11	Screw M5x15		
D-12	Lower tool rest		
D-13	Lower knife block		
D-14	Lower cutter		
D-15	Screw M5x15		
D-16	Blanking board		
D-17	Rail pressure plate		
D-18	Pressure spring		
D-19	Step screw		
D-20	Pressure sleeve		

圆角零件图
Fillet parts drawing



Fillet parts drawing

Drawing number	name	Drawing number	name
E-1	Screw M6x30	E-21	Screw M3x5
E-2	washer	E-22	Blanking board
E-3	Upper tool holder		
E-4	Upper knife mold mounting seat		
E-5	Screw M6x12		
E-6	Upper die (1.5/1.0)		
E-7	Upper die (2.0/2.5)		
E-8	Lower tool rest		
E-9	Rail pressure plate		
E-10	Pressure spring		
E-11	Step screw		
E-12	Pressure sleeve		
E-13	washer		
E-14	Nut		
E-15	Screw M5x30		
E-16	Lower die		
E-17	Screw M6x32		
E-18	Front baffle		
E-19	Screw M3x5		
E-20	Baffle board		