

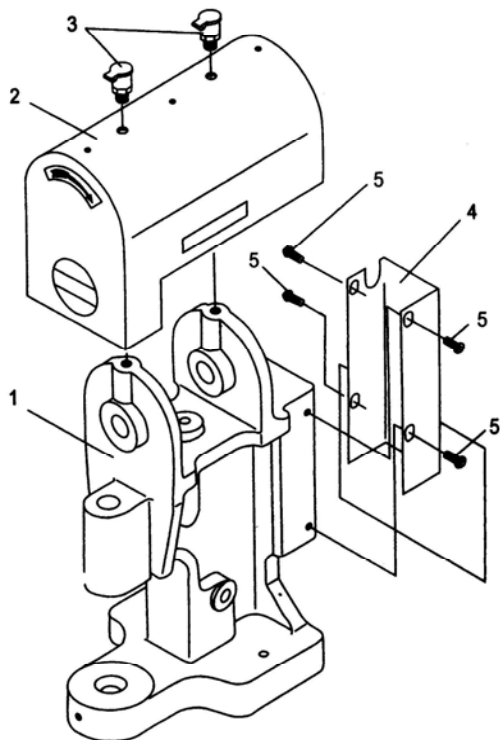
零件样本

ACCESSORY MUSTER

1、机壳分组件 Arm bed components

序号 Ref No.	件号 Part No.	名称 Description	数量 Amt
1	SD101	机壳 Arm bed	1
2	MD401	外罩 Arm bed cover	1
3	TR501	油杯 Grease cup	2
4	TQ307	后挡板 Tailgate	1
5	TR520	螺钉 M5 L7 Screw M5 L7	4

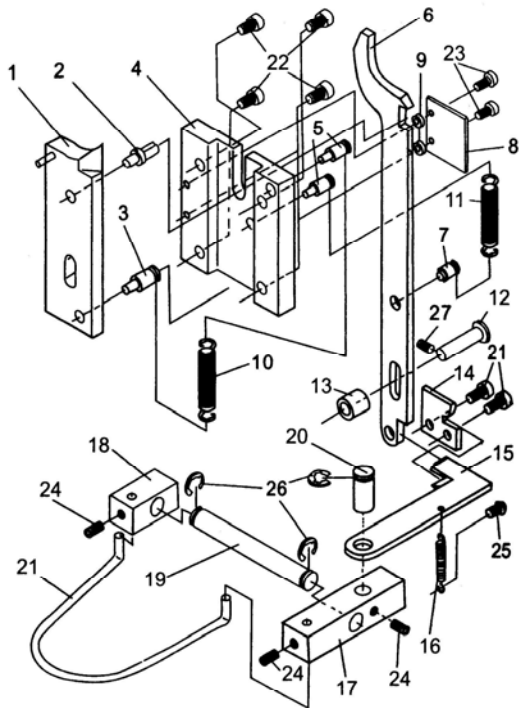
1、机壳分组件



3、离合分组件 Clutch components

序号 Ref No.	件号 Part No.	名称 Description	数量 Amt
1	TC215	滑板 Shippage board	1
2	TC215-1	保险柱 Pole use safety	1
3	TC215-2	拉簧销 Spring rod	1
4	TC216	滑板固定板 Rivet board	1
5	TQ211-1	铆合拉簧销 Rivet join the rod	2
6	TQ301	长拉杆 long rod	1
7	TQ301-1	拉簧销 Sprign rod	1
8	TC217	拉杆压板 Press board	1
9	TC218	压板垫圈 Gasket	2
10	TG603-1	复位簧 Diaplasis spring	1
11	TG603-2	复位簧 Diaplasis spring	1
12	TC219	拉杆销 Rod	1
13	TC220	限位圈 Gasket	1
14	TQ302	定位板 Ori entation board	1
15	TQ303	限位板 Rstrict locality	1
16	TG604	复位拉簧 Ori entation spring	1
17	TC221	右拉环固定板 Right rivet board	1
18	TC222	左拉环固定板 Left rivet board	1
19	TC223	拉环销 Rad	1
20	TC224	限位板销 Board rod	1
21	TQ304	压环 Fastness annulus	1
22	TR506	圆柱头内六角钉 Screw M6X10	6
23	TR507	圆柱头内六角螺钉 Screw M4X18	2
24	TR504	无头内六角螺钉 Screw M5X8	3
25	TR508	螺钉 Screw M6X8	1
26	TG605	挡圈 d10 Gaske d10	3
27	TR509	无头内六角螺钉 Screw M5X6	1

3、离合分组件

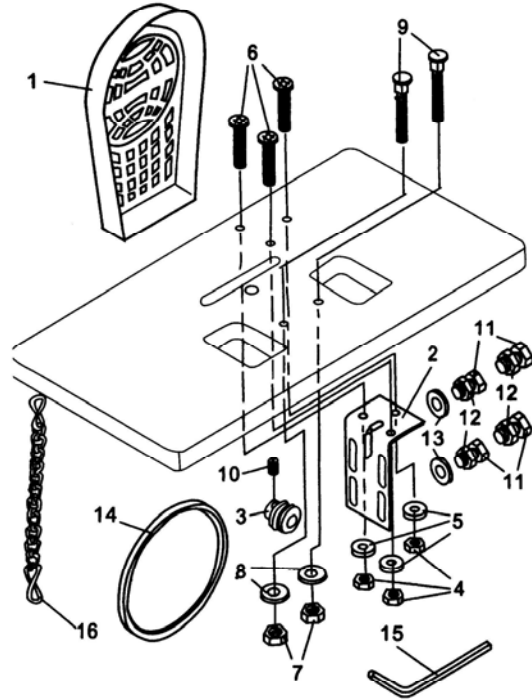


4、附件分组件 Appurtenance components

序号 Ref No.	件号 Part No.	名称 Description	数量 Amt
1	MD402	皮带轮罩 Strap wheel cover	1
2	TQ305	电机安装板 Setting board	1
3	TZ702	电机皮带轮 Strap weel	1
4	TR510	安装板螺母 M6 Bulid in board nut	3
5	TR511	垫圈 d6 Qasket d6	3
6	TR512	安装板螺钉 Nut M6×60	3
7	TR513	机头安装螺母 M8 Machine head nut M8	2
8	TR514	垫圈 d8 Gasket d8	2
9	TR515	机头安装螺钉 Bolt M8×80	2
10	TR516	皮带轮紧固螺钉 Bolt M5×8	1
11	TR517	电机紧固螺钉 Bolt M8×30	4
12	TR518	电机紧固螺母 Nut M8	4
13	TR519	垫圈 d8 Gasket	4
14	TZ703	传动带 V 字 Starp A-1372	1
15	TZ704	内六角扳手 Wrench M3/32	1
16	TG606	踏脚链条 Bedal chain L=680	1

-13-

4、附件分组件

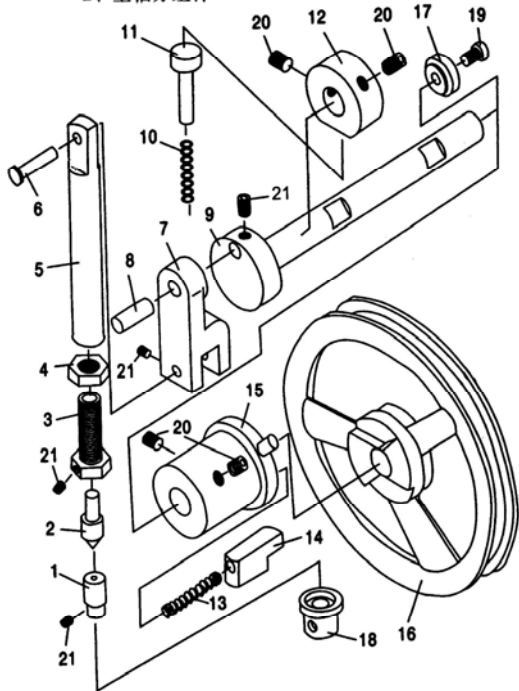


-14-

2、主轴分组件 Principal axis components

序号 Ref No.	件号 Part No.	名称 Description	数量 Amt
1	TC201	下模 Down moulage	1
2	TC202	上模 Up moulage	1
3	TC203	上模座 Seat of up moulage	1
4	TC205	紧固螺母 M16X1.5Nut M16X1.5	1
5	TC206	纵轴 Upright shaft	1
6	TC207	纵轴销 Upright shaft rod	1
7	SD102	连杆 Joint staff	1
8	TC208	曲轴销 Curv shaft rod	1
9	TC209	主轴 Main shaft	1
10	TG601	制动簧 Aplay the brake spring	1
11	TC210	制动销 Aplay the brake rod	1
12	TC211	制动轮 Aplay the brake wheel	1
13	TG602	滑舌簧 Shippage spring on tongue	1
14	TC212	滑舌 Shippage on tongue	1
15	TC213	滑套 Shippage busing	1
16	TZ701	皮带轮 Strap wheel	1
17	TC214	垫圈 Washer	1
18	TC204	下模套 Down moulge bushing	1
19	TR502	圆柱头内六角螺钉 M8X80 Screw	1
20	TR503	无头内六角螺钉 M10X12 Screw	4
21	TR504	无头内六角螺钉 SM3/16X24 Screw	4

2、主轴分组件



一、用途

大白扣装订机是为在羽绒服、衬衫、睡衣裤、各种茄克衫、卡曲衫上装订大白扣类的专用服装设备，也可在皮包、钱包、眼镜盒、帽子等皮塑制品上装订大白扣，用途广泛。对于不同厚度的装订，只要稍加调节装模螺钉，就能获得和达到牢固、美观、不损伤扣面镀层，符合技术质量要求的预期效果。

二、主要技术参数

- 1、偏心距 18mm
- 2、行程 38mm
- 3、闭合高度 最大51mm
最小16mm
- 4、主机尺寸 310X280X70mm
- 5、主机重量 23.5kg
- 6、电机功效 1/3HP
电压 220 (50Hz)
转速 1440rps

三、结构概述：

本机器有下列主要部件构成，床身、保险机构、电动机及底板、台面板及机脚组成，简述如下：

(1) 床身：

床身是本机的主要部件（铸件），具有足够的刚度。

床身的前端装有滑座，滑座的内孔中安装着圆柱型的导柱，导柱下端的内螺孔M16x1中旋入装模螺钉，大白扣专用冲压模安装在装模螺钉内孔中，并用M6螺钉固定之。

床前的上部装有偏心轴、滑套、阻尼块、联动盘、大皮带轮等零件，大皮带轮在偏心轴上作无负荷空转，只有当滑舌伸出嵌入联动盘的空挡中，大皮带轮才能通过联动盘、滑舌、滑套带动偏心轴旋转一圈。

（也只能转一圈）。阻尼块保证装在偏心轴上的连杆停于止点位置，完成一次大白扣装订工作。

床身的后部有滑板、拖板、保险叉等零件，当脚踏板踏下时，

通过链条拉动保险叉，滑板下行，滑舌靠弹簧张力，插入大皮带轮上的联动盘空档中，偏心轴转动。

由于滑套上装有一个“和尚头”，偏心轴转过一定角度后迫使保险叉与滑板脱钩，滑板将拉簧主力上行，滑舌缩回，大皮带轮又回复到空转状态，该机构保证不会发生连冲。

床身与台面用螺钉固定，台面上还装有大皮带轮的防护罩等辅件。

(2) 保险机构：

保险机构是防止操作者无意识脚踏板而导致上模下冲可能，造成工伤事故的保险装置。该机构保证只有操作者先按散保险环，脚踏才能起作用。保险机构有保险环、小轴、角尺杆、摇臂、导槽等另件组成。结构简单，一目了然。注意：保险机构决不允许拆下，如有拆下现象，一旦造成后果一切由拆下单位自理。

(3) 电动机及底板：

大白扣装订机的电动机为单相交流 220(50Hz), 1440rps, 它只安装在电机角尺底板上，底板用螺钉悬挂于台机板下面，电动机上装马达皮带轮，两者用键或M6螺钉固定。

(4) 台面板和机脚：

台面板和机脚为定制件组成专用机架，机架上装床身，电动机及底板，电动机启动开关。

四、操作方法及调整方法：

(5) 该机操作简单，方法如下：上下模装好相应钮扣——将衣服放入需装订大白扣的位置上——手按保险环——脚踩下脚踏板，上模下冲，完成一次装订。

(6) 上模最低点（下死点）的调整：

调整上模下死点（即调整订扣的松紧度）的方法如下：停机用手转动大皮带轮，使上模处于最低点（下死点）——旋松拼装螺母——转动装模螺钉到适合位置——拧紧拼装螺母——试冲。

五、试车及保养：

- (7) 开车前须检查马达转向是否正确。
- (8) 开车前检查各部螺钉是否松动。
- (9) 各润滑点加注润滑油，每班一次。
- (10) 下班后清理机器，若机器长期停用，应先擦净机器各部件，润滑各转动，滑动部位。
- (11) 电气设备必须接地良好。
- (12) 操作者必须在了解机器结构和读懂说明书，方可开车。
- (13) 工作完毕后，应关闭机电，切断电源，用干净的纱头擦净机器各部。

六、可能发生的故障，原因及排除方法：

可能发生的故障	原因	解决方法
钉子装订过松，与衣服原形差别较大。	装模螺钉位置过高	往下调整装模螺钉至合适位置
钉子冲紧式粗粗变小	装模钉位置过低	往上调整装模螺钉至合适位置
冲紧无力	皮带过松	调整皮带至合适松紧
连冲	(1) 保险装置失灵 (2) 撞板不能复位	(1) 调整和检修装置，加涂润滑油 (2) 更换撞板位置
不冲	滑舌头部打环	调换滑舌

七、随机文件、附件

序号	名称	数量	序号	名称	数量
1	合格证	1	7	内六角扳手	1
2	使用说明书	1	8	自攻螺钉3X5	2
3	链条	1	9	螺钉M8X24	4
4	挂钩	2	10	螺母M8	6
5	电机皮带轮	1	11	半圆头螺栓M8X30	2
6	电机安装板	1	12	垫片φ8	6

1. Usages:

Model bigwhite button binding machinery is a machine which fixes big white buttons for shirts of eider down outerwears, sleeping dresses and all kinds of jackets, and it can also be used for fixing big white buttons for leather, plastic products, such as leather bags, wallets, glasses boxes and caps. We can adjust the mould-fixing screw a bit, and reach the ideal effects.

2. Main technical parameter

1. eccentric distance: 18mm
2. stroke: 38mm
3. closed height: Max: 51mm
Min: 16mm
4. main engine dimension: 310X280X70mm
5. weight of main engine: 23.5kgs
6. Power of electrical machinery: 1/3HP
Voltage: 220(50Hz)
Rotation speed: 1440rps

3. Summarization of structures

The machine is composed of the following parts: bed body, safety installations, electric motor, bottom board, platform board and machine foot, etc.

(1) Bed body:

Bed body is the main part of the machine, it has enough steel strength.

The front part of the bed body is fixed with slide seat. The inner hole of slide seat is fixed with the cylinder guide post. The mould-fixing screw is in the inner screw hole M16X1 of lower end of the guide post. The big white button special bumping mould is fixed in the inner hole of the mould-fixing screw, and fastened with M6 screw.

The upper part of the bed is fixed with eccentric axle, shippage busing damping block, joining coil and big leather belt wheel. The big leather belt wheel makes no-load rotations on the eccentric axle. Only when the shippage on tongue extends and plugs into the empty shelves of joining coil, can the big leather belt wheel carry eccentric axle to rotate one circle through the joining

coil, shippage on tongue and shippage busing (only one circle). Thus, it finishes the big white button fixing work.

The rear part of the bed body are shippage board, dragging board and safety fork. When you step on the treadle, the chain pulls the safety fork, the shippage board goes down, the shippage on tongue plugs into the empty shelves of joining coil on the big leather belt, then the eccentric axle rotates.

Because there is a "Buddhist work head" in the shippage busing, the eccentric axle will make the safety fork and shippage board unhook after it rotates to a certain degree, the shippage board pulls up the main strength of the extension spring, the shippage on tongue with draws, and the big leather belt will restore itself to the empty rotation situation.

The bed body and platform board are fixed by screw, on the platform, there is also a protection cover for the big leather belt.

(2) Safety installations:

Safety installation is used for guarding against the industrial accidents caused by operators' careless stepping on the treadle. The installation makes sure only when the operator lifts the composed of safety ring, small axle, angle square rod, rocker arm, guide groove, and so on. Cautions: The safety installation are not allowed to disassemble, or you will be responsible for the consequence.

(3) Electric motor and bottom board:

The electric motor of the machine is single-phase alternating current 220 (50Hz), 1440rps, and it can only be fixed on the angle square bottom board of the electrical machinery, the bottom board is fixed under the table board by screw the electric motor must be fixed with motor leather belt wheel. Both of them can be fastened by M6 screw of Key.

(4) Platform board and machine foot:

The platform board and machine foot are special machine shelves. On the machine shelves, there are bed body, electric motor, bottom board and the switch of motor.

4. Operations and adjusting methods

(5) Place the proper buttons in the upper mould and lower mould-put the clothes in the place of the big white button-lift the safety ring-step on the treadle, then it finished one-time work.

(6) Adjusting the upper mould's Lowest point:
Stop operating and rotate the big leather belt wheel with your hands, make the upper mould in the lowest point-Loosen the fastening nut-rotate the mould-fixing screw to a proper place-fasten the nut-have a try.

5. Thesting run and maintaining

- (7) Check if the motor is OK before operating.
- (8) Check if the screws of parts are loosening or not.
- (9) Add the lubricating oil to the necessary points, one time every shift.
- (10) Clean the machine after working. If the machines doesn't operate for a long time, first clean the parts, then oil the rotating and sliding parts.
- (11) Electrical equipments must OK.
- (12) The operators must know the structures of machine and understand the instruction manual.
- (13) After operating, you should shut the machine and turn off the power, then clean the machine with the clean gauze head.

零件样本

ACCESSORY MUSTER

6. Possible stoppages, reasons and solving methods

Possible stoppages	Reasons	Methods
The buttons are loosening and movable	The mould-fixing screw is too high	pull down and adjust the screw to the proper place
The buttons are out of place or the buttons are too small	The mould-fixing screw is too low	pull up and adjust the screw to the proper place
The bump is weak	The leather belt is loosening	Adjust the leather belt to the proper degree of fit tightness
Continuous shpping	(1)The safety installation is broken (2)The shpping board can't connect to its normal place	(1)Adjust the safety installation and interlocking oil (2)Change the extension spring of shpping board
Stop bumping	The head of shpping on tongue is broken	change the shpping on tongue

7. Files and appendix

NO	Names	Quantity	NO	Names	Quantity
1	Certificate of quality	1	7	Inner six-angle spanner	1
2	Instruction manual	1	8	Auro-screw 3X5	2
3	Chain	1	9	Screw M8X24	4
4	Hook	2	10	Nut M8	6
5	Leather belt sheet of electrical machinery	1	11	Half-circle head bolt M8X30	2
6	Insulation board of electrical machinery	1	12	Spacer Ø8	6

7

装 组 机 装 箱 单
Zhuang Niu Ji Zhuang Xiang Dan

序 号 Serial No.	名 称	Description	数 量 Q'ty
1	机 头	Machine head	1
2	皮带轮罩	Cover of the pulley	1
3	链条	Chain	1
4	挂钩	Hangers of chain	2
5	电机安装板	Assembly plate for motor	1
6	电机皮带轮	Pulley of the motor	1
7	皮带	Belt	1
8	内六角扳手	Hexangular wrench	1
9	自攻螺钉	Screws	3
10	螺钉	Screws	4
11	螺母	Nuts	4
12	半圆头螺栓	Screw bolts	2
13	垫片	Washers	6
14	说明书	Instruction manual	1
15	合格证	Certification of inspection	1