

使用说明书

User's manual



1808 电磁钉扣机
ELECTROMAGNETIC BUTTON MACHINE

前 言

注意事項:

此裝鈕機雖然配備安全裝置，但在工作時請絕對不要把手伸入衝模之間。如違反以上規定而導致發生事故廠方不負任何責任！

Preface

Matters Needing Attentions:

This button sewer is equipped with safety device but please you never extend your hand into the middle of dies when operation. The factory isn't responsible for any accident caused because doesn't comply with above regulations.

用戶須知

- 1、操作前請務必仔細閱讀使用說明書；
- 2、操作人員往模具裝鈕扣時，嚴禁踩下保險拉杆；
- 3、工作結束後或暫離機器時，請一定關閉電源。

Notices to users

1. Please carefully read the user's manual.
2. Prohibit strictly from tramp the safety pull rod when operator put button in the die.
3. Please be sure to turn off power supply.

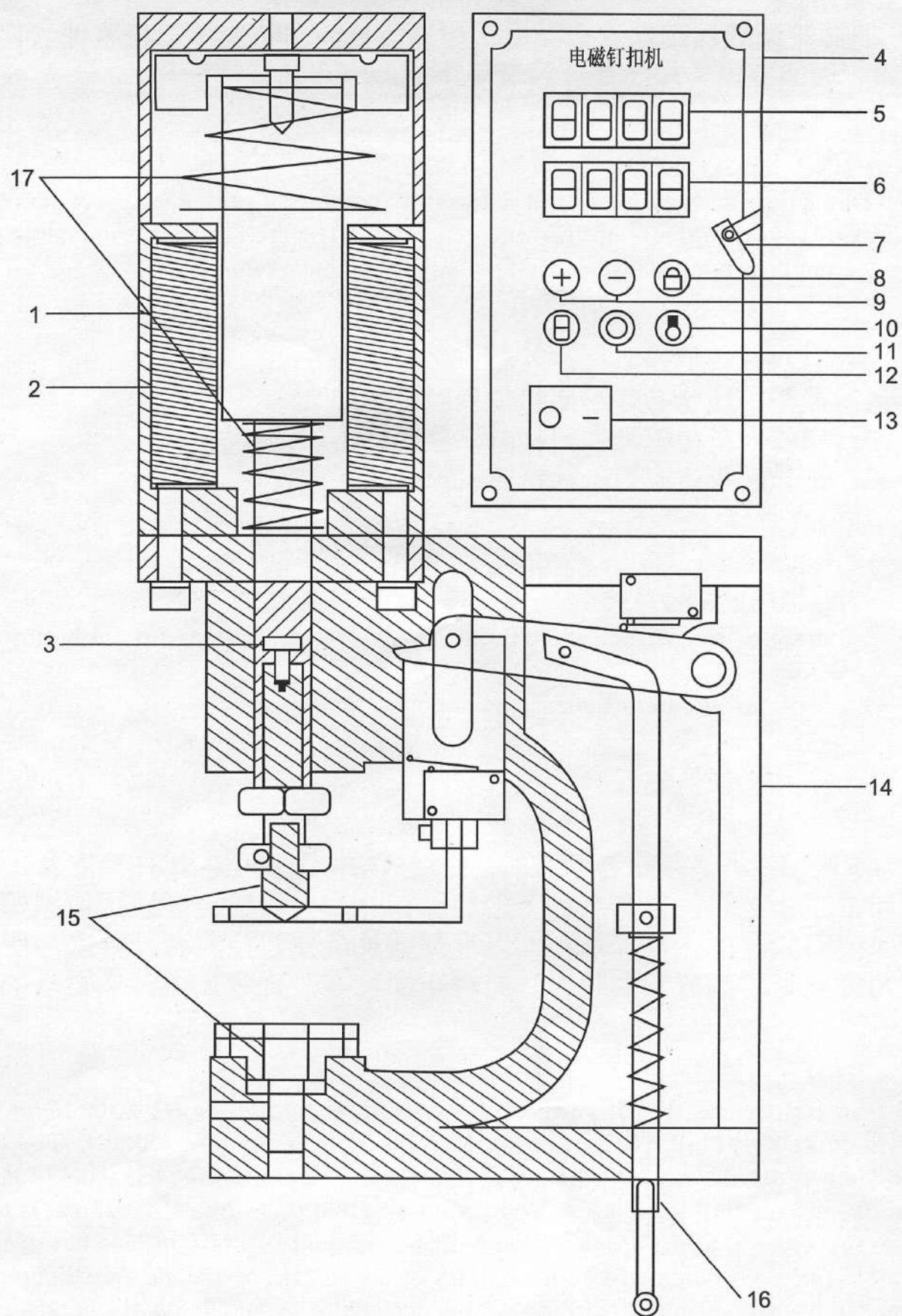
用 途

電磁裝鈕機適用於各類服裝、針織成衣、羽絨服、牛仔類服裝、鞋帽和皮革、塑料、帆布制品上裝釘鈕扣，用途廣泛，通過調節減壓閥來改變釘扣壓力，可滿足不同厚度面料及特種鈕扣的裝釘要求，所釘鈕扣能達到不損壞扣面鍍層，釘綴牢固美觀，符合技術質量要求的效果。

Uses

Electromagnetic button sewer and pneumatic button sewer are suitable for all kinds of clothes, knitting slopwork, down clothes, cowboy type clothes, shoe cap and leather, plastic, canvas products to sew buttons, this machine has wide uses, it can change the buttoning pressure by adjusting the pressure relive valve, it can meet the demand of different thickness of fabrics and special-purpose buttons. It won't damage the coating of button surface to the buttons sewed on, the stitching is firm and handsome, and it conforms to the demand of technical quality standards.

一、機體分組件(Organism divides the module)



一、機體分組件(Subassembly of machine body)

- | | |
|------------------------------------|----------------------------------|
| 1、機筒
Mahicne cylinder | 10、鐳射燈開關
Switch of laser lamp |
| 2、綫圖
Wiring diagram | 11、清零開關
Zero clearing switch |
| 3、油杯
Oil cup | 12、計數開關
Counting switch |
| 4、電器箱
Electric box | 13、電源開關
Power switch |
| 5、壓力顯示屏
Pressure display screen | 14、機體
Machine body |
| 6、計數顯示屏
Counting display screen | 15、上下模具
Up-down die(mould) |
| 7、鐳射燈
Laser lamp | 16、保險接杆
Protective pull rod |
| 8、壓力鎖定
Pressure locking | 17、復位簧
Return spring |
| 9、壓力調節
Pressure adjustment | |

二、機器操作及技術參數

1、技術參數

電源電壓: 220V

裝打次數: 50次/分鐘

工作壓力: 無極調壓

衝頭軸行程: 40cm

用電功率: 2-300W

2、結構概述

如圖所示: 接通電源、打開開關13, 調節好壓調節器9, 此時在衝模15上放入待加工的鈕扣, 踩下保險拉杆16, 電器箱電源進入2綫圖此時, 上模開始工作往下衝壓一次17馬上進行復位, 一個服裝鈕扣的釘制工序完成。

3、操作方法及調整:

該機操作簡單方便: 在衝模上放入待加工的鈕扣----將衣服放在所需裝釘鈕扣的位置上----腳踩下保險杆----上模下衝, 完成一次裝釘。

調整1、模頭間隙: 先將上模座擰到最高點---用螺絲刀在(圖四)手動調節模具孔, 壓下上衝頭, 調到最佳位置---擰緊緊固螺母---打開電源---踩下保險拉杆---試衝。

調整2、壓力: 打開電源, 顯示屏幕顯示壓力數字---將壓力調節器調到自己所需的壓力--試衝。

調整3、保險環: 根據模具不同高度, 布料的不同厚度, 調到各自需要的位置, 確保安全裝釘即可。

調整4、鐳射燈: 根據各自需要, 擰開固定架的蝶形螺帽, 進行方向調節, 調節最中心點, 擰緊螺帽後進行衝壓。

I. Main technical parameters

Power voltage: 220V

Times to sew button: 50times/min

Working pressure: stepless pressure adjustment

Stroke of punch shaft: 40cm

Power: 2-300W

II. Description on structure

Show in figure: switch power on, turn on the switch 13, adjust pressure adjuster 9, at the moment put the button ready to sew on die 15 and tramp safety pull rod 16, power supply of electric box get into 4, at the moment (figure 3) 4 start to work to do a time of downward punch and press 17 will do a return immediately, the sewing procedure of a clothes button is finished.

III. Operation method and adjustment:

This machine is simple and convenient to operate: put the button ready to sew on the die-----put clothes on the position required to sew button-----tramp safety rod----upper die and lower punch, a time of button sewing is finished.

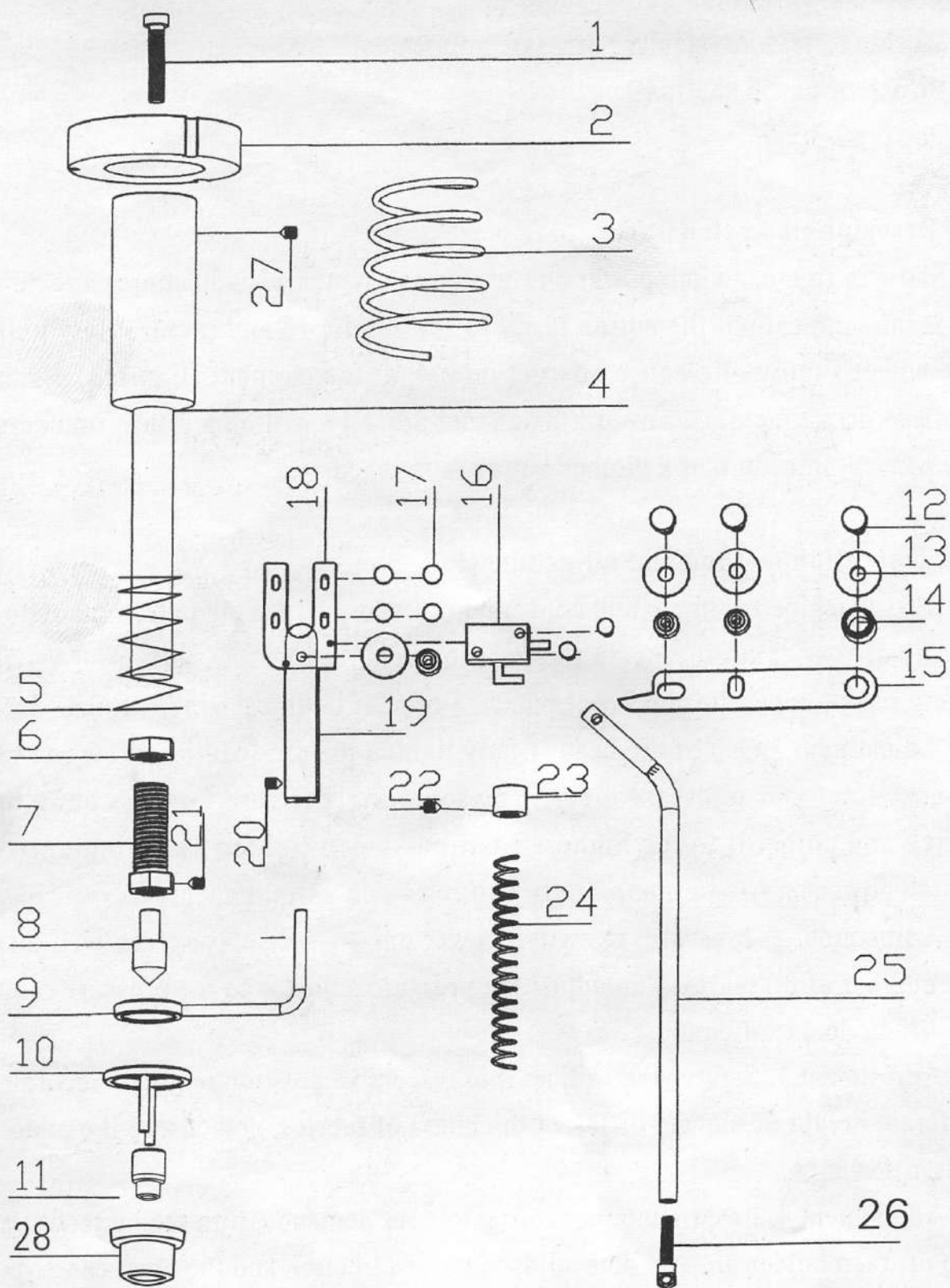
Adjustment 1. Gap of die head: firstly tighten the die-loading screw rod to the upmost point---to adjust the die hole by screwdriver (figure 4), press down upper punch and adjust it to the highest position-----to tighten fastening nut-----to switch power on -----to tramp safety pull rod----do a trial punch.

Adjustment 2. Pressure: to switch power on-----display screen will display the number of pressure-----to adjust the pressure adjustor to the pressure required -----to do a trial punch.

Adjustment 3. Safety ring: Adjust it to respective position required according to different height of die and different thickness of fabrics, and ensure it can do safe button sewing.

Adjustment 4. Laser lamp: according to your demands, turn the butterfly screw cap of fixed holder on, and do a adjustment of direction and the most center point, and do a punch and press after tighten screw cap.

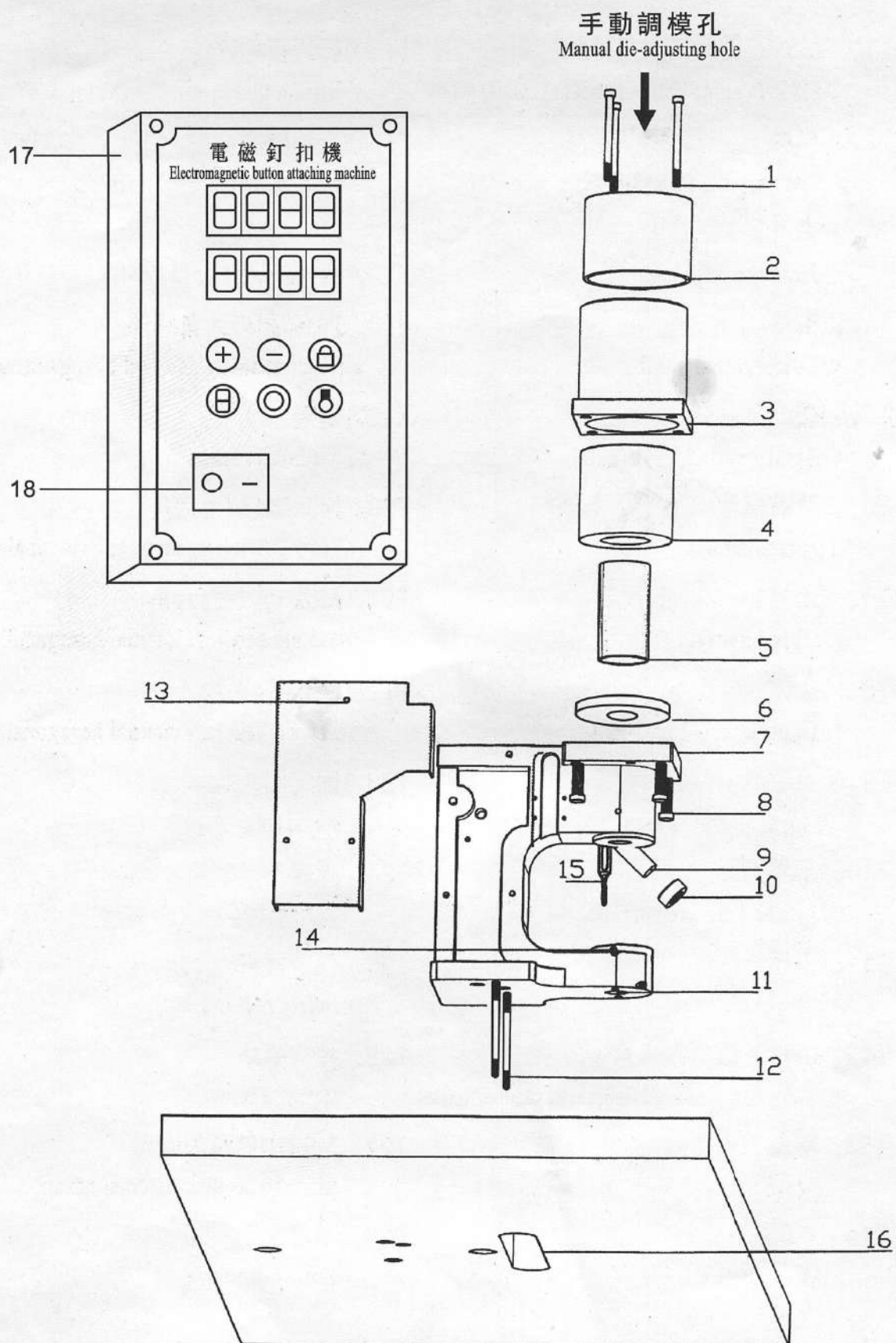
三、零件分布 (一) (Parts distribution)



三、零件分布 〈一〉 (Parts distribution)

T1、 M8x25圓頭內六角螺絲 M8 × 25 round head internal hexagonal screw	T15、行程板 Stroke plate
T2、 壓塊 Pressure block	T16、行程開關 Stroke switch
T3、 寶塔簧 Tower spring	T17、 M4x6大圓頭 M4 × 6 big round head
T4、 縱軸 Longitudinal shaft	T18、固定板 Fixed plate
T5、 復位簧 Return spring	T19、滑塊 Sliding block
T6、 緊固螺母 Fastening nut	T20、 M5x6無頭內六角 M5 × 6 headless internal hexagonal screw
T7、 上模座 Upper die seat	T21、 M5x6無頭內六角 M5 × 6 headless internal hexagonal screw
T8、 上模 Upper die	T22、 M5x6無頭內六角 M5 × 6 headless internal hexagonal screw
T9、 上壓環 Upper pressure ring	T23、固定圈 Fixed ring
T10、下壓環 Lower pressure ring	T24、彈簧 Spring
T11、下模 Lower die	T25、保險拉杆 Safety pull rod
T12、 M8x20圓頭內六角 M8 × 20 round head internal hexagonal screw	T26、拉杆螺絲 Pull-rod screw
T13、墊圈 Washer	T27、 M5x10無頭內六角 M5 × 10 headless internal hexagonal screw
T14 Φ8平墊 Φ8 flat cushion	T28、下模套 Lower die cover

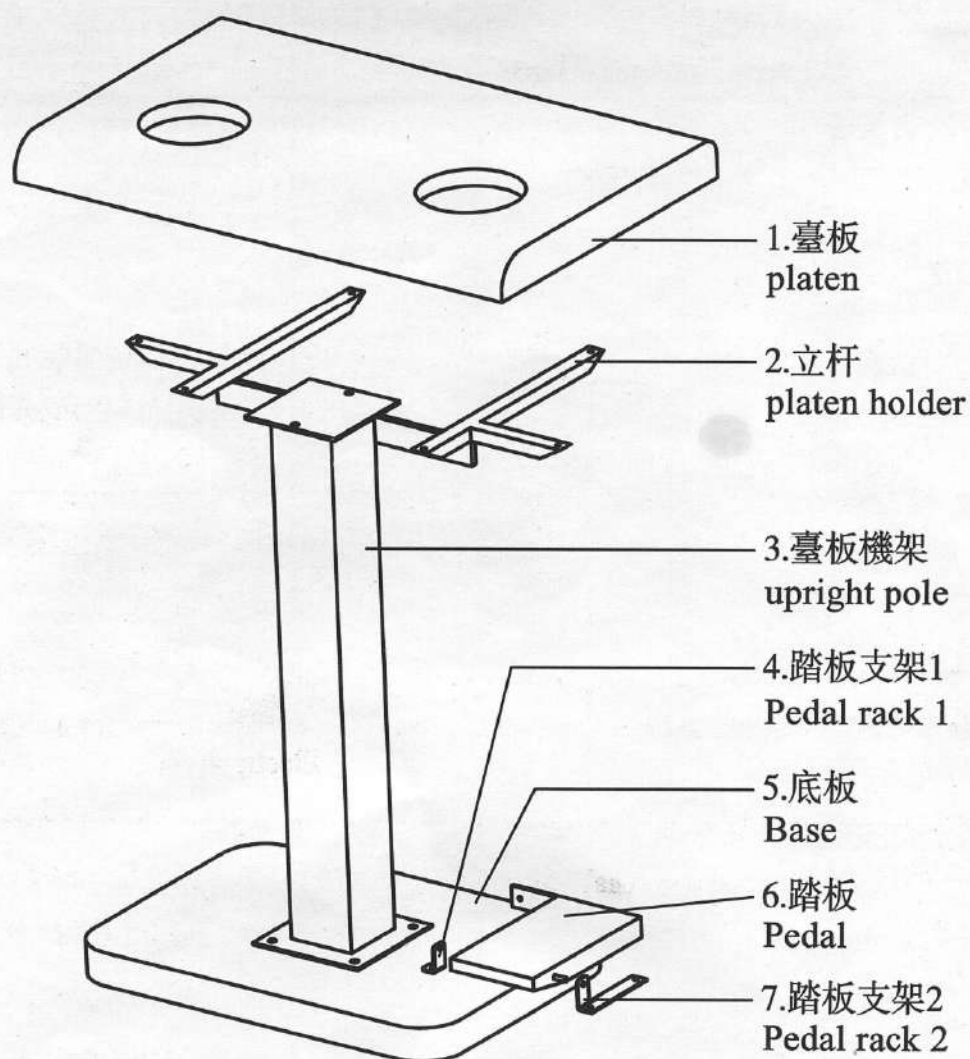
四、零件分布 (二) (Parts distribution)



四、零件分布〈二〉 (Parts distribution)

- | | |
|---------------------------------------------------|--------------------------------------------------------------|
| 1、 M5x75內六角螺絲
M5 × 75 internal hexagonal screw | 11、 M5x6無頭內六角螺絲
M5 × 6 headless internal hexagonal screw |
| 2、 機筒蓋
Cover of machine cylinder | 12、 M8x65雙頭螺杆
M8 × 65 double head screw rod |
| 3、 機筒
Machine cylinder | 13、 蓋板
Cover plate |
| 4、 綫圈
Winding | 14、 M5x6無頭內六角螺絲
M5 × 65 headless internal hexagonal screw |
| 5、 銅管
Copper tube | 15、 固定架
Fixed holder |
| 6、 復位簧
Return spring | 16、 臺板
Table plate |
| 7、 機體
Machine body | 17、 電器箱
Electrical box |
| 8、 M8x35內六角螺絲
M8 × 35 internal hexagonal screw | 18、 電源開關
Power switch |
| 9、 10、 鐳射燈
Laser lamp | |

五、臺板機架簡易安裝指南 (Table installation guide)



步驟一：先將部件1臺板倒置在地上，將部件2立杆如圖對孔安裝在部件1臺板的底部。

步驟二：將部件3臺板機架與部件5底板如圖安裝。

步驟三：將步驟一與步驟二完成的部分如展示圖安裝固定。

步驟四：將部件4踏板支架1固定在部件5底板上，套入部件6踏板後固定部件7踏板支架2。

步驟五：套入鏈條，安裝結束。

Step 1: Put platen upside down on the floor, install platen holder on the bottom of the platen, see the picture

Step 2: install upright pole on the base, see picture

Step 3: Fix all screw in step 1 & step 2

Step 4: Install pedal rack 1 on the base, insert pedal, at last fix pedal rack 2

Step 5: install link chain, finish installation.

六、可能發生的故障、原因及排除方法 (General faults and its causes and solutions)

可能發生的故障 General faults	原因 Cause	解決方法 Solutions
鈕子裝訂過鬆,衣服相對轉動 The Button is attached too loose, the clothes is rotated relatively.	裝模螺釘位過高 The position of die-filling screw is excessive.	下調整裝模螺釘到合適位置 Adjust the die-filling screw downward for a suitable position.
鈕子衝偏可鈕眼變小 The button is punched with a deviation but the button eye become small.	裝模釘位過低 Position of die-filling screw is too low	上調整裝模螺釘到合適位置 Asjust upward the die-filling screw for a suitable position.
衝裝無力 Punching is weak.	壓力過低 The pressure is too slow	按壓力調節+調到自己合適位置 To depress the pressure adjustment button +, and adjust it to a suitable position for you.
不衝 can't punch	1.檢查行程開關 To check the stroke switch 2.檢查保險環 To check protective ring	必要是時更換行程開關 To replace the stroke switch if necessary 根據布料的不同厚要進行上下調節 To do an up-down adjustment according to the different thickness of fabric.

七、 附件
Attachment

序號 Serial No .	名稱 Description	數量 Quantity
1	說明書 User' S Manual	1
2	附件包 Accessory bag	1
3	合格證 Certificate of conformity	1

感謝購買本公司的產品。

爲了安全地使用，本機一定要可靠接地。請保管好使用說明書，以便隨時查閱。封本產品有不明之處，請向代理商或本公司營業部門詢問。

Thank you to purchase our products.

To use the machine safety , please make the machine ground properly. Please keep the user's manual well ,so that you can check any time. Should you have any question , please inquiry our local agent or our customer service department .

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