

**Type TM-150/200 Automotive Machine For Seal
Both Ends Of Shoelace And Gift Bag Rope**

Instruction Manual



**SHANGHAI XIANGHAI BRAIDING MACHINE
CO.,LTD.**

**Address: No.8 Zone , No.3841 Huqingping
Road, Shanghai, 201703 , china**

Tel: +86-021-39293755

Fax: +86-021-69750655

Email: amy@xianghai-braider.com

Type—150/200 instruction manual

1. Main structure

Main structure is composed of mechanical parts , running parts, conveyer plastic pieces parts, cutting tool parts, conveyer liquid parts, conveyer shoelace mechanism and electrical parts.

2. Main technical data

Measurement: 2800*1150*1800

(length*width*height)

Weight: FL150 500kgs FL200 550kgs FL250 600kgs

Knife specification: Ø1.9 Ø2.1 Ø2.3 Ø2.5 Ø2.8
 Ø3.0 Ø3.2 Ø3.5 Ø3.7 Ø4.0
 Ø4.2 Ø4.5 Ø4.7 Ø5.0 etc

Plastic pieces specification: All colors, all specification.

Width: 25 30 32 40 50 etc

Acetone consumption: About 0.5kg per 1000 pairs of shoelace

Horizontal power motor: Y type 1.5kw triphase

Voltage specified AC 220V for thermostat, installed one thermostat of 250w

3. Performance

Suitable use shoelace made of cotton, acrylic, polypropylene, polyester etc. Auto-conveyer, cut and count shoelace. Free fix numbers with sound alarm. Auto-stop when break down. Safety and reliability. One person operate. Take capacity of production is 10000-12000 pairs by 8 hours.

4. Operation

Charge lubricant in each running parts before start. Charge acetone in acetone box. Release air from liquid conveyer pump. Enter acetone in pump. Install plastic pieces. Contact power. Turn on heating switch. Switch on conditioner to preheat 50°C about. It takes cutting tool 10-15 minutes to preheat 50-60 °C. Penetrate shoelace. Start motor. Put lever of clutch on the off position. Auto-conveyer shoelace carry on.

5. Adjustment

- (1) Equipment has been adjusted strictly before delivery, no need to be adjusted by the user self.
- (2) On function if the plastic pieces can not be cut, seal ends are not good, check spray position which is on shoelace in cutting tool or not. Adjust screw loose or tight on cutting tool. Check knife which is damaged or not. Adjust screw on cutting tool and rectify position of spray or change knife.

3. Performance

Suitable use shoelace made of cotton, acrylic, polypropylene, polyester etc. Auto-conveyer, cut and count shoelace. Free fix numbers with sound alarm. Auto-stop when break down. Safety and reliability. One person operate. Take capacity of production is 10000-12000 pairs by 8 hours.

4. Operation

Charge lubricant in each running parts before start. Charge acetone in acetone box. Release air from liquid conveyer pump. Enter acetone in pump. Install plastic pieces. Contact power. Turn on heating switch. Switch on conditioner to preheat 50°C about. It takes cutting tool 10-15 minutes to preheat 50-60 °C. Penetrate shoelace. Start motor. Put lever of clutch on the off position. Auto-conveyer shoelace carry on.

5. Adjustment

- (1) Equipment has been adjusted strictly before delivery, no need to be adjusted by the userself.
- (2) On function if the plastic pieces can not be cut, seal ends are not good, check spray position which is on shoelace in cutting tool or not. Adjust screw loose or tight on cutting tool. Check knife which is damaged or not. Adjust screw on cutting tool and rectify position of spray or change knife.

(3) If conveyer plastic pieces runs inordinate, in case of lengthy or shortern, adjust conveyer plastic pieces mechanism. Check screw on pattern roller, tight roller and ratchet gear, tighten up if necessary.

(4) Liquid conveyer pump is allocated type 195 diesel. If there is no spray when the pump starts, release all air from liquid conveyer system.

6. Attention

(1) Do not touch on knife with metallic matter in order to avoid damage on knife.

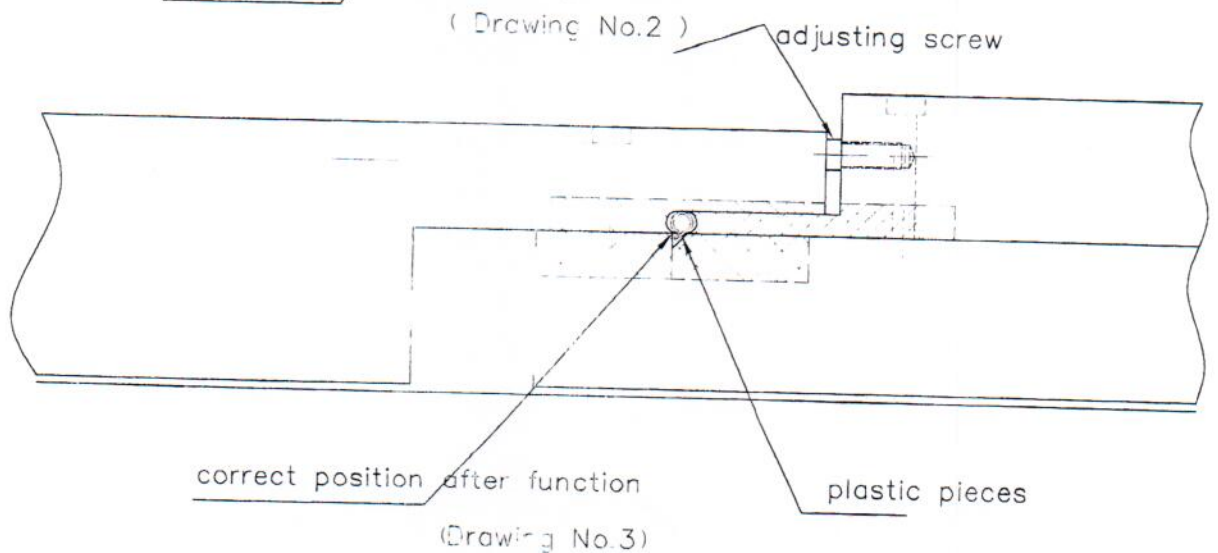
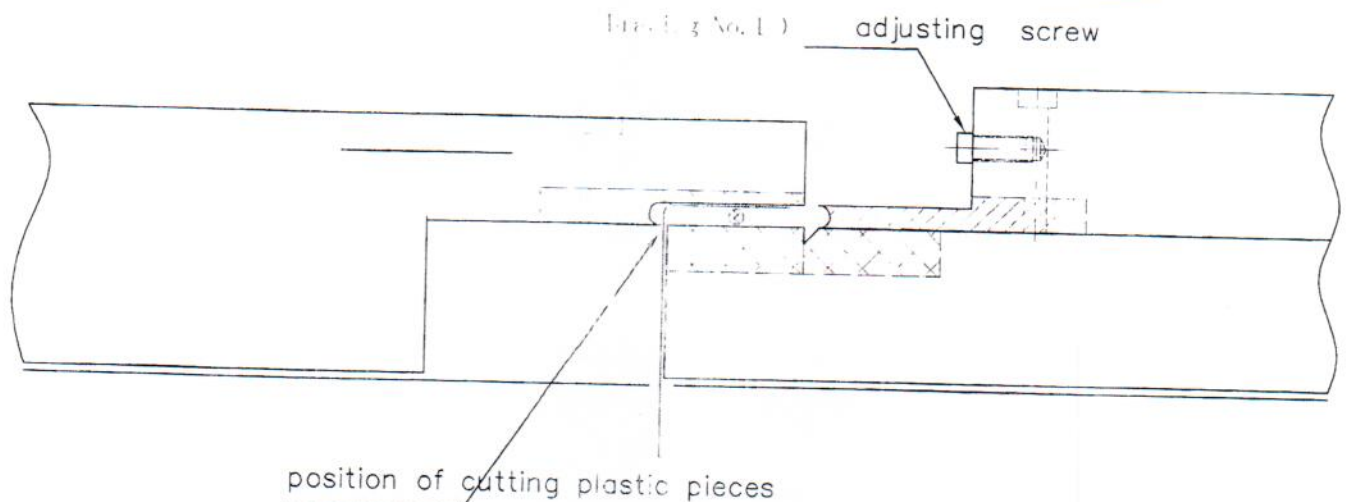
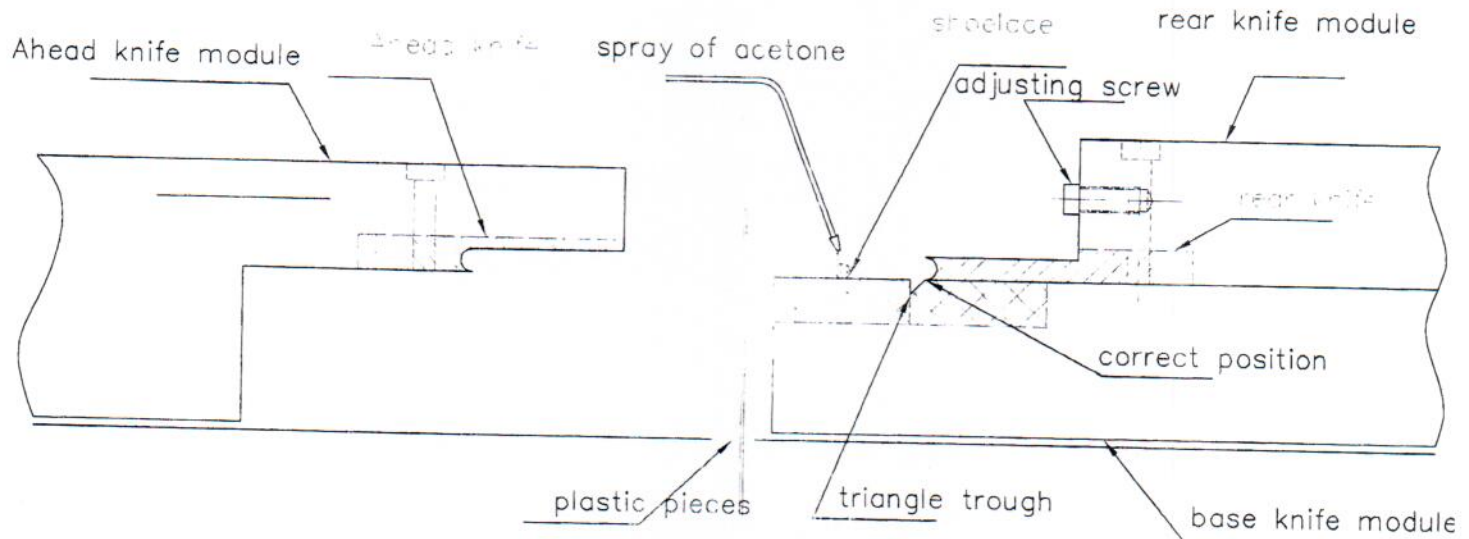
(2) Maintain voltage 220V about on production, if voltage is too higher, the thermostat will be damaged.

(3) Forbidden on conveyer plastic pieces twice for sealing one end, otherwise the knife will be damaged.

Attention:

1. Do not touch on knife with metallic matter in order to avoid damage on knife.
2. Equipment has been tested and adjusted strictly before delivery, no need to remove any parts before operation.

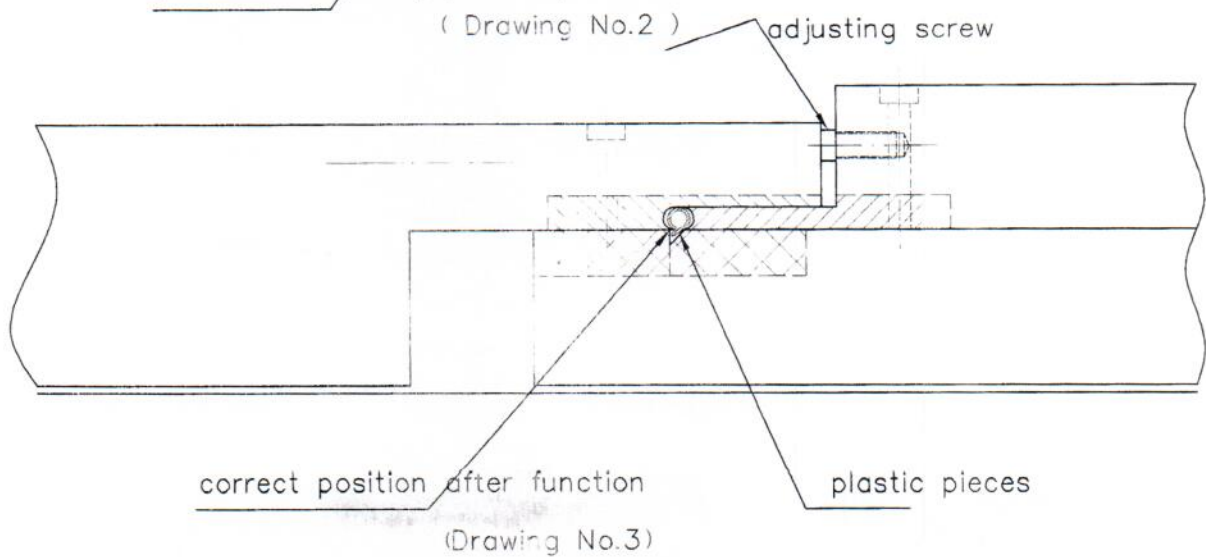
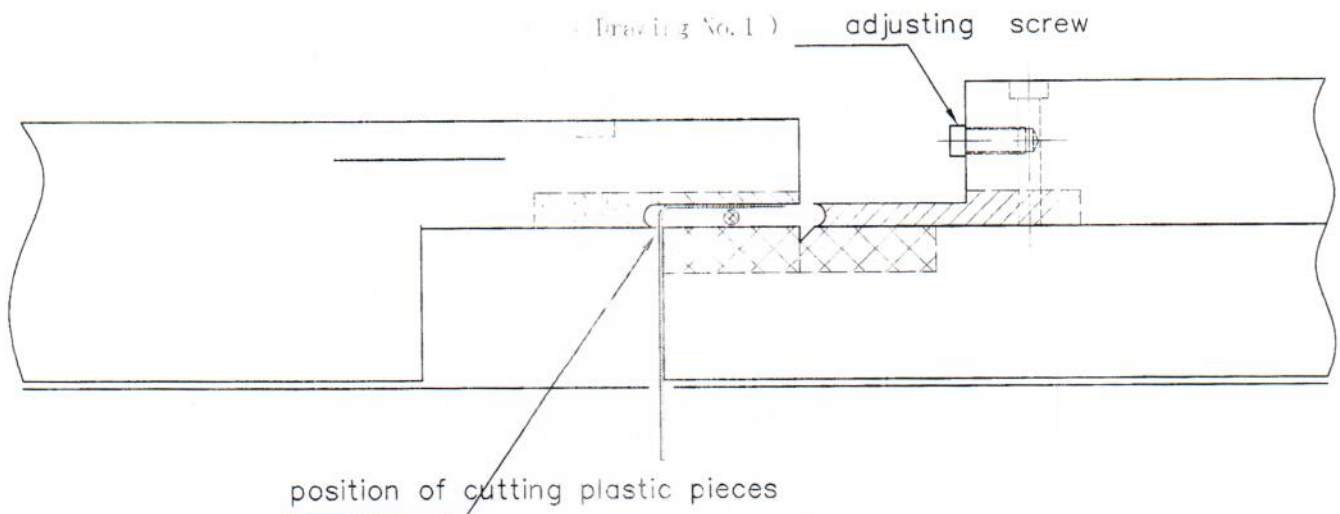
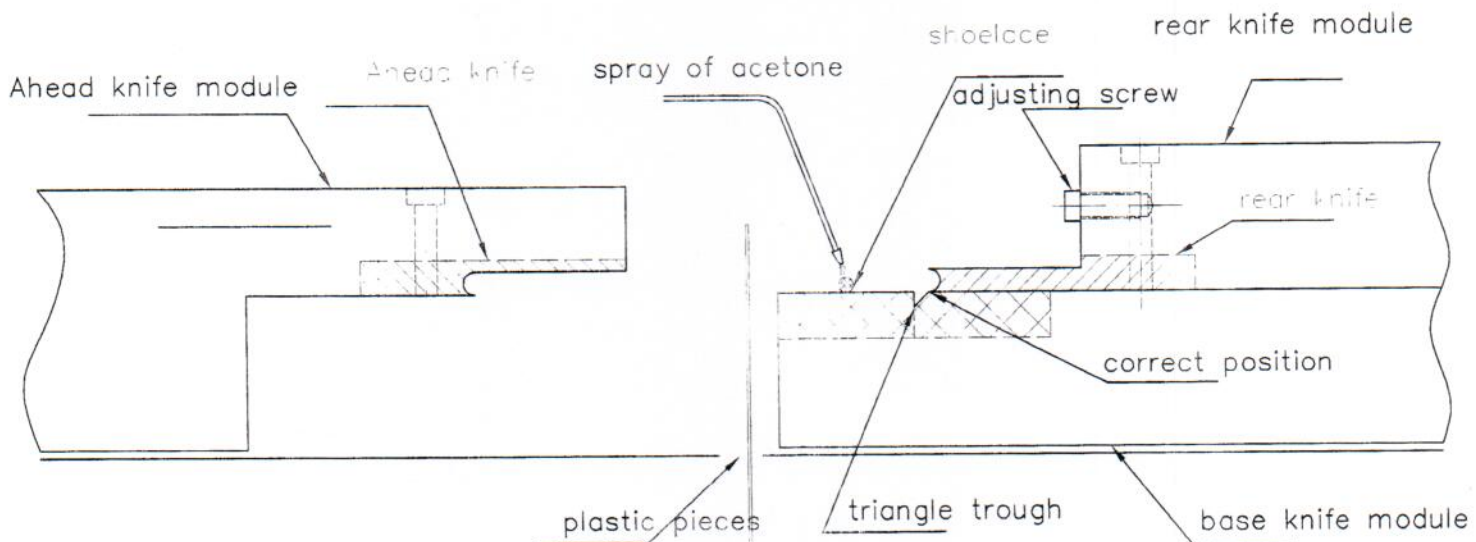
Operating cutting tool and adjusting position(see Drawing No.2、No.3、No.4)



Attention:

1. Do not touch on knife with metallic matter in order to avoid damage on knife.
2. Equipment has been tested and adjusted strictly before delivery, no need to remove any parts before operation.

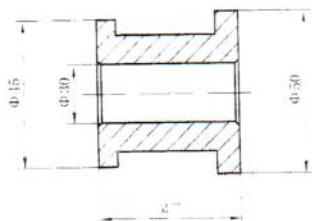
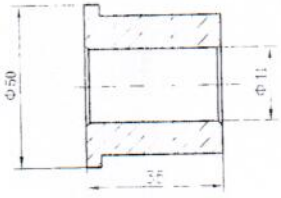
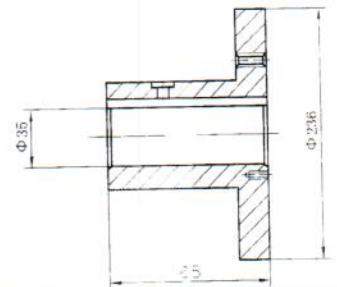
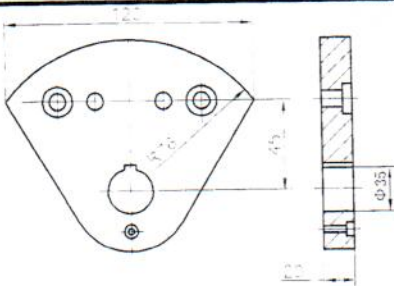
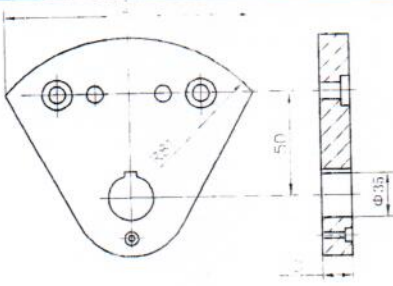
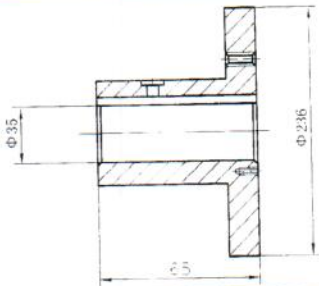
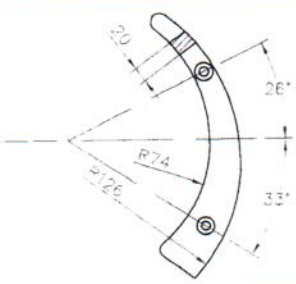
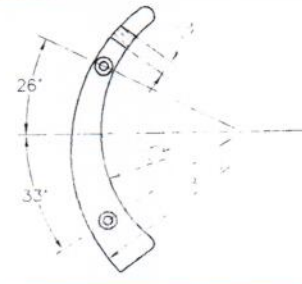
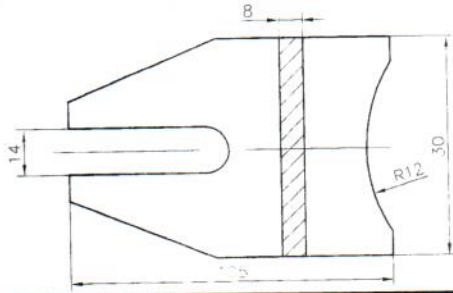

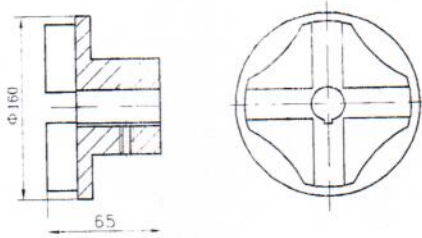

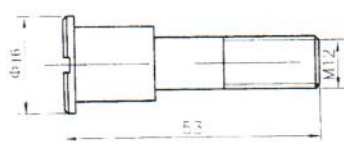
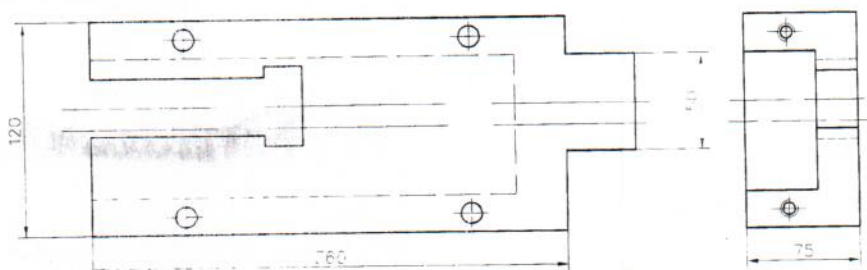
Operating cutting tool and adjusting position(see Drawing No.2、No.3、No.4)



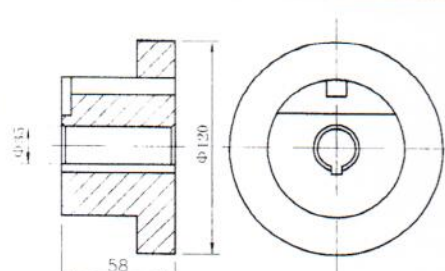
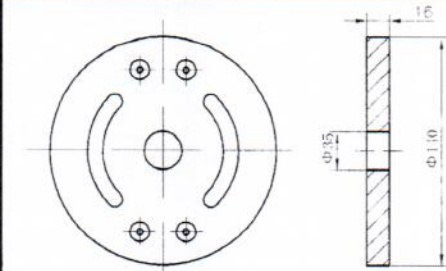
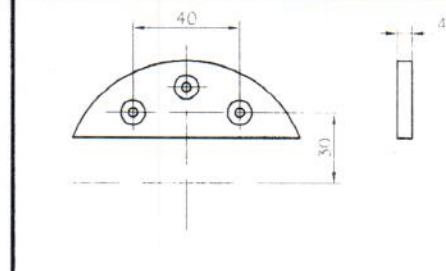
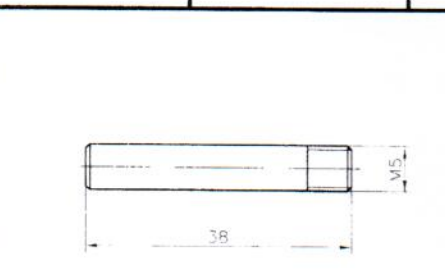
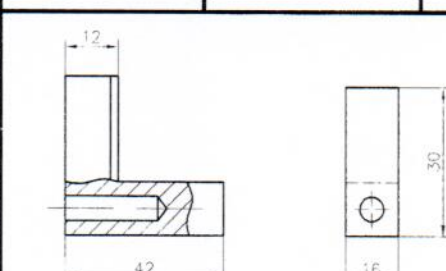
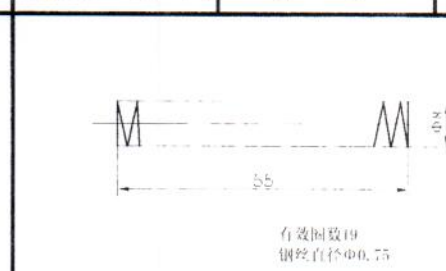
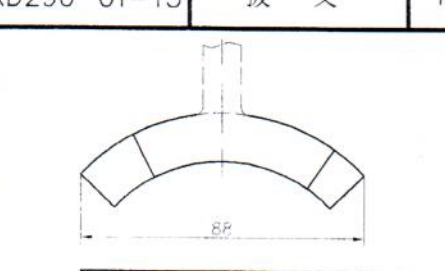
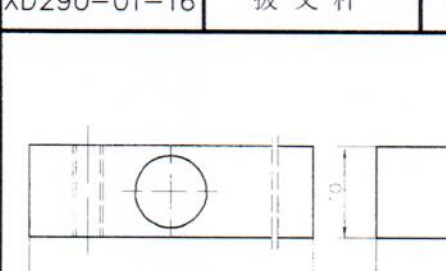
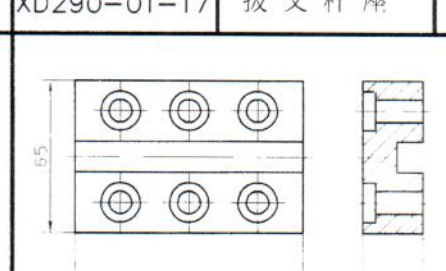
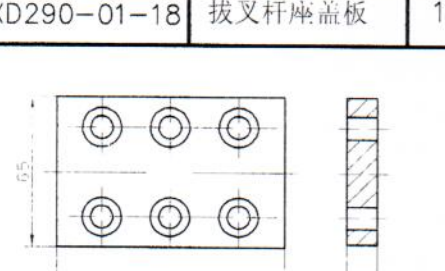
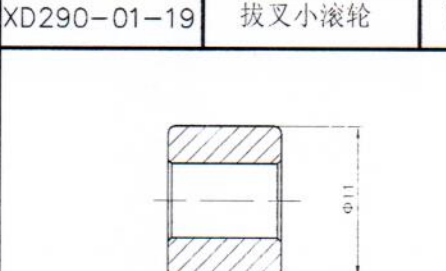
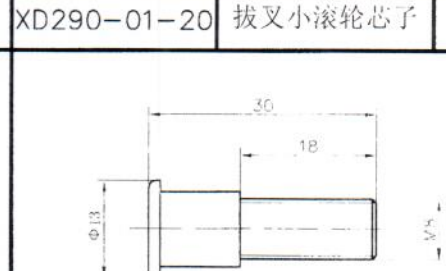
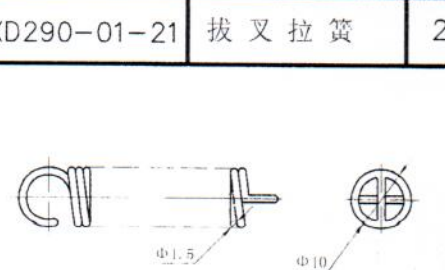
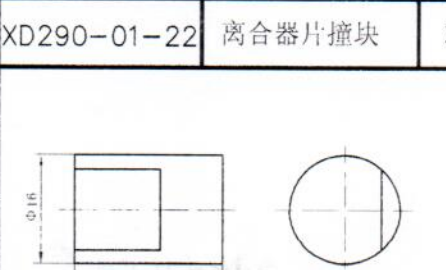
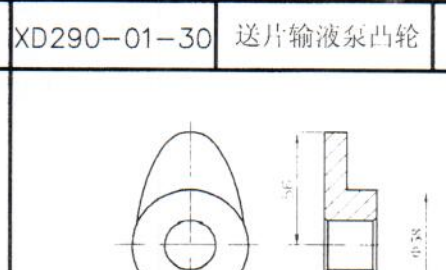
Drawing of separate parts

XD290-01-09	cluth	1	XD290-01-10	piec. f cluth	1	XD290-01-11	cover of cluth	1
XD290-01-12	spring pin	1	XD290-01-13	let. t of cluth	1	XD290-01-14	spring	1
XD290-01-15	fork	1	XD290-01-16	fork lever	1	XD290-01-17	base of fork lever	1
XD290-01-18	base cover of fork lever	1	XD290-01-19	fork roller	1	XD290-01-20	core of fork roller	1
XD290-01-21	extention spring for fork	2	XD290-01-22	g. o. t of cluth	2	XD290-01-30	can of pump for liquid conveyer	2

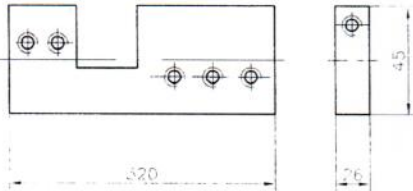

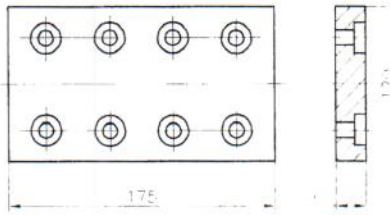
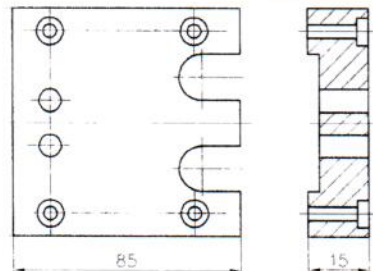
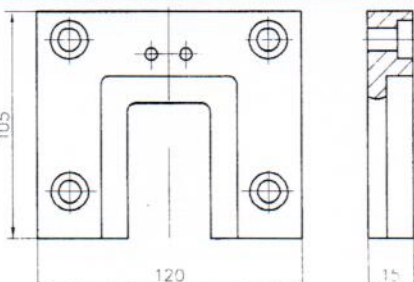
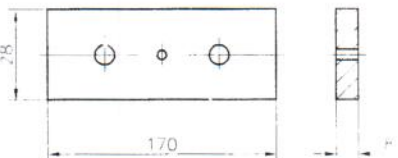
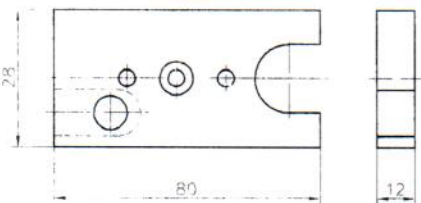
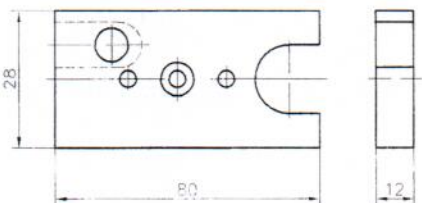
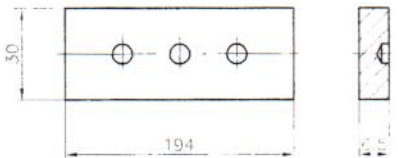
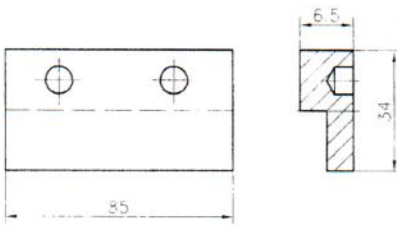
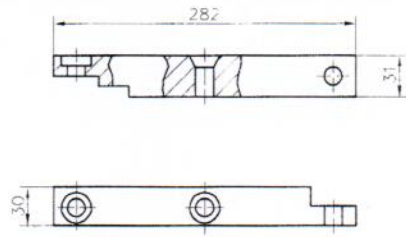
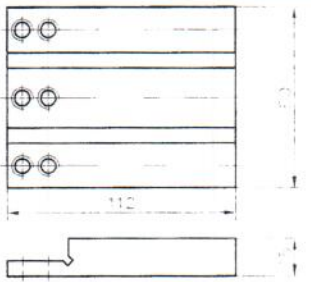
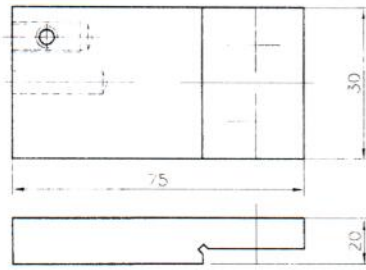
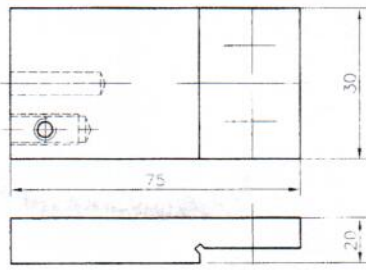
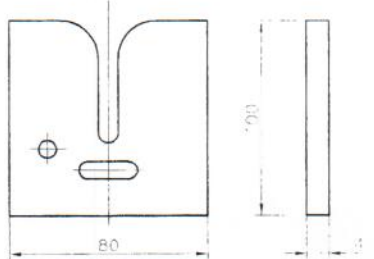
Drawing of separate parts

XD290-01-31	copper steeve of main shaft	2	XD290-01-32	copper steeve of main shaft	1	XD290-01-33	fan-shape cam fix board A	1
								
XD290-01-34	fan-shape cam A	1	XD290-01-35	fan-shape cam B	1	XD290-01-36	fan-shape cam fix board B	1
								
XD290-01-37	fan-shape board A	2	XD290-01-38	fan-shape board B	2	XD290-01-49	fork for main shaft of lever	1
								
XD290-01-50	fork base for main shaft of lever	1	XD290-01-58	intermittent wheel	1	XD290-01-60	intermittent elliptic roller	1
								
XD290-01-61	inner shaft of elliptic roller	1	XD290-02-02	machine body				1
								

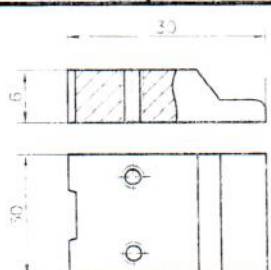
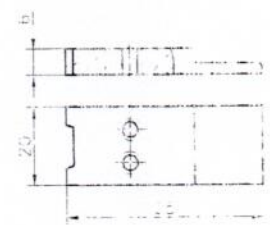
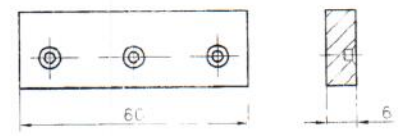
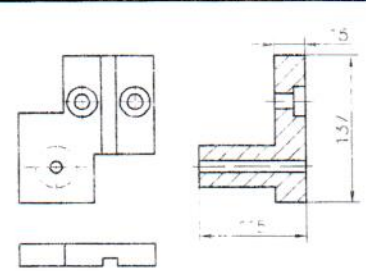
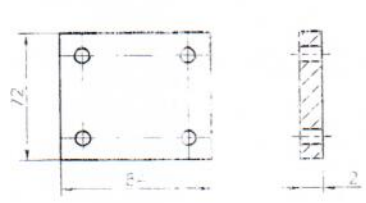
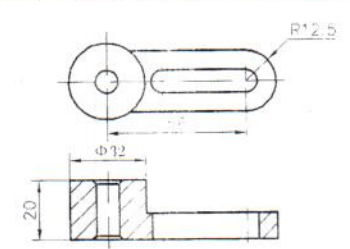
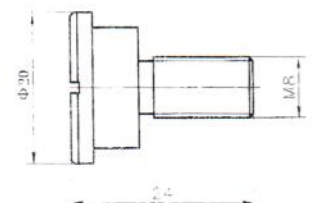
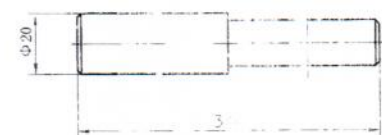
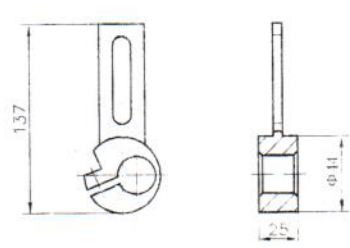
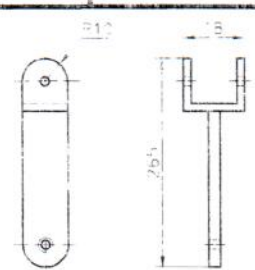
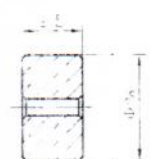

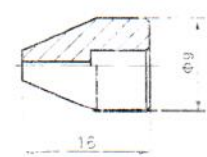
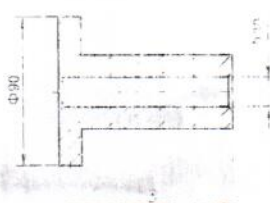
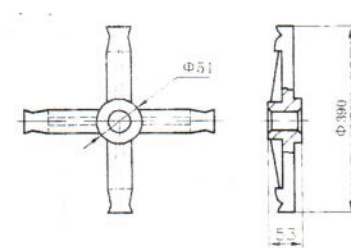
全自动鞋带打头机机件略图

XD290-01-09	离合器	1	XD290-01-10	离合器片	1	XD290-01-11	离合器盖板	1
								
XD290-01-12	弹簧定位销	1	XD290-01-13	离合器撞块	1	XD290-01-14	弹簧	1
								
XD290-01-15	拨叉	1	XD290-01-16	拨叉杆	1	XD290-01-17	拨叉杆座	1
								
XD290-01-18	拨叉杆座盖板	1	XD290-01-19	拨叉小滚轮	1	XD290-01-20	拨叉小滚轮芯子	1
								
XD290-01-21	拨叉拉簧	2	XD290-01-22	离合器片撞块	2	XD290-01-30	送片输液泵凸轮	1
								

全自动鞋带打头机机件略图

XD290-02-03	右墙板	1	XD290-02-04	左墙板	1	XD290-02-05	前盖板	1
								
XD290-02-06	后盖板	1	XD290-02-07	后座板	1	XD290-02-08	上垫铁	2
								
XD290-02-09	后刀模上垫铁A	1	XD290-02-10	后刀模上垫铁B	1	XD290-02-11	前刀模侧垫铁	1
								
XD290-02-12	后刀模侧垫铁	1	XD290-02-13	前刀模	1	XD290-02-14	电热丝刀模	1
								
XD290-02-15	左后刀模	1	XD290-02-16	右后刀模	1	XD290-02-17	导线板	2
								

Drawing of separate parts

XD290-02-20	wide knife module	2	XD290-02-23	narrow knife module	1	XD290-02-24	rear-low knife	1
								
XD290-02-25	conveyer prop	1	XD290-02-26	cover of conveyer prop	1	XD290-02-27	conveyer rocker	1
								
XD290-02-28	screw of conveyer rocker	1	XD290-02-29	conveyer shaft	1	XD290-02-30	conveyer camshaft	1
								
XD290-02-31	conveyer prop	1	XD290-02-32	conveyer roller prop	1	XD290-02-33	pin of conveyer roller prop	1
								
XD290-03-36	spray nozzle for acetone	1	XD290-04-15	cross steeve	2	XD290-04-16	cross	1
								

50°~60° 时.穿上线带,启动电机.将离合器手柄放在合的位置,既可自动送带,投入正常生产.

五 调整方法

1 本机在出公司前已进行严格调试,一般情况下用户不必自己调正

2 在使用过程中,如发现胶片切不断,包头质量差,应查喷液是否喷在刀模间的鞋带上,刀模机构的调整螺钉是否松动或过紧,或已损坏刀片.如发现以上情况,应调整刀模机构的调节螺钉和喷液的位置,或换刀片.

3 如发现送片不正常,有过长或过短送不上等,应调整送片机构,检查送片花纹滚轮和涨紧轮.棘轮齿轮等固定螺钉是否松动,送片板槽内是否有杂物粘牢,如发现以上情况应拧紧螺钉去除杂物.

4 输液泵配用 195 柴油机喷油泵,在开机时如发现不喷液,应放尽液路气体.

六 注意事项

1 刀口上不可用金属件敲击或切刮,以免碰坏刀口.

2 电热板工作电压在正常生产时,保持在 220V 左右,不可过高否则烧坏电热丝.

3 不能二次送片轧一个头 如二次送轧一个头就要损坏刀片.

七 操作方法

在开机前,各部位加上润滑油,将台面上的工作指示灯开亮,表示电热管已通电.过约 15 分钟左右,待刀模预热至 50~60℃,倒入丙酮,排出泵内空气直到丙酮能从管中喷出.即可启动电动

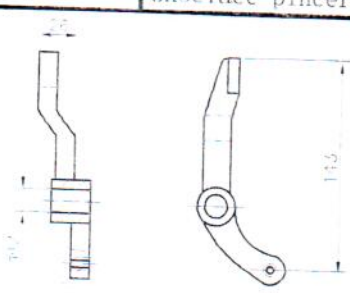
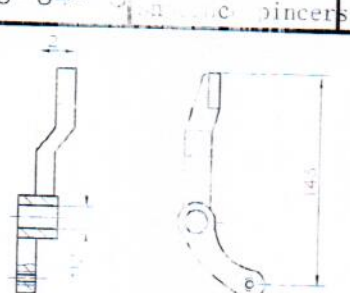
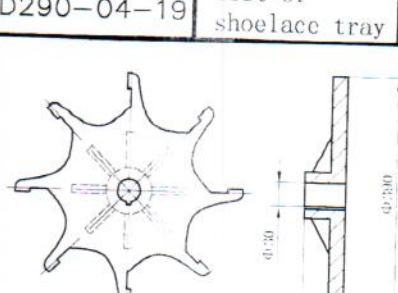
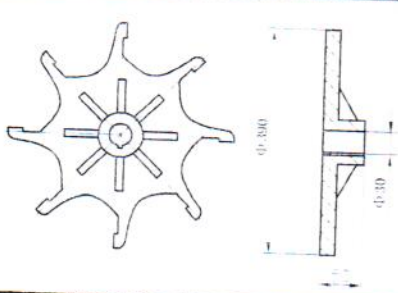
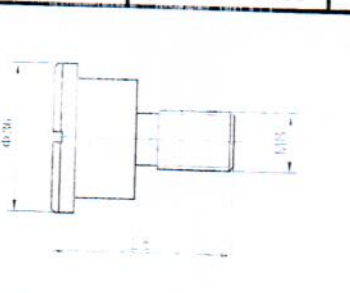
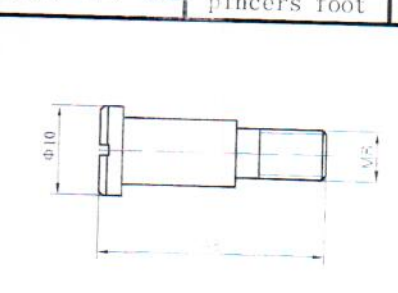
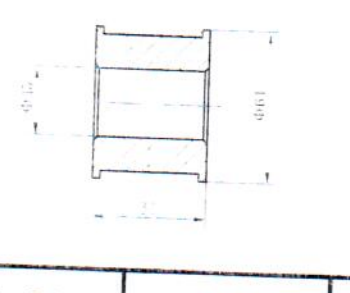
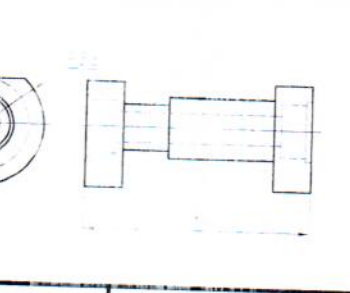
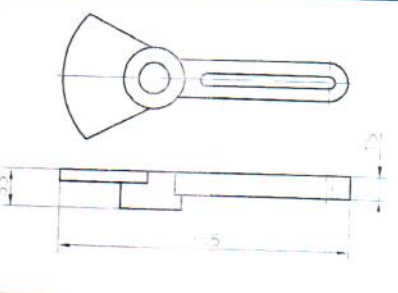
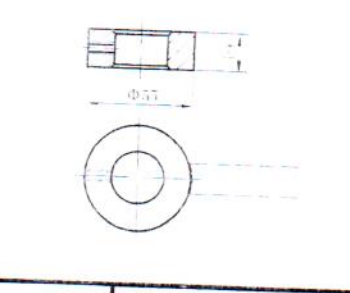
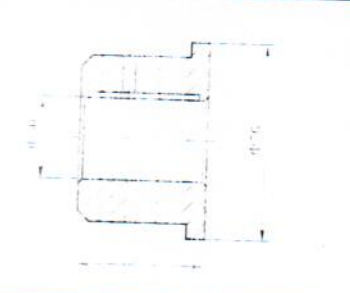
外六角调整钉,使后刀模上的刀片 R 槽保持平行。(刀模工作与调整位置,见图一)注意 R 槽一定要退过三角槽

8. 装好后,要用手动来检验调整的结果。分离离合器转动皮带轮到凸轮打在最高位置停下。(见图二)松掉后座板上的两个 M6 内六角锁紧螺钉,再把两个 M16 空心螺钉稍稍顶紧,然后锁紧上面的螺钉。
9. 加注润滑油后,再开车试运行。
10. 在刀片规格选择适当的情况下,如发现鞋带头包不好,可调整前后盖板上的调整螺钉前面 4 个 M8 内六角螺钉,后面 6 个 M6 内六角螺钉,使其少量压紧,注意不可压死,前后刀模调整一致。
11. 在工作过程中,如发现鞋带切不断或切断处有毛刺,可调整刀模固定壳右侧的 M6 外六角调整螺钉,合适为止(注意前后刀模调整一致,见图一 不能压死)
12. 如在操作过程中发现送片不正常,应查送片机构,花纹滚轮和涨紧轮棘轮,固定螺钉是否松动,送片固定板槽内是否有杂物粘牢,如发现以上情况,应拧松螺钉去除杂物,然后再锁紧。
13. 正常运行后每班加注两次润滑油。

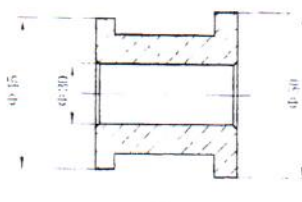
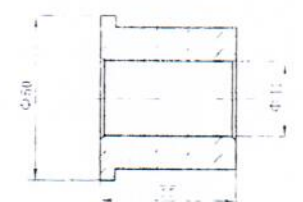
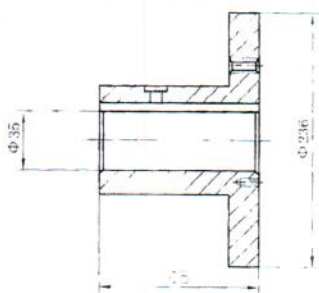
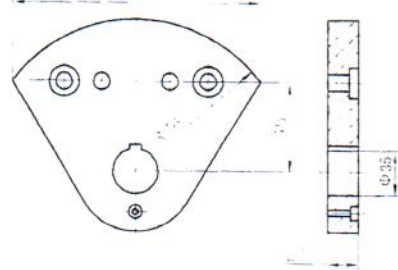
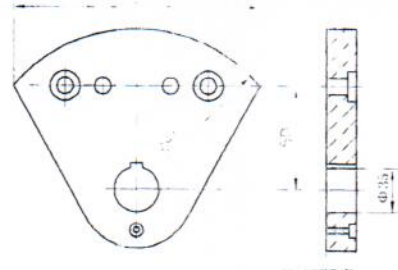
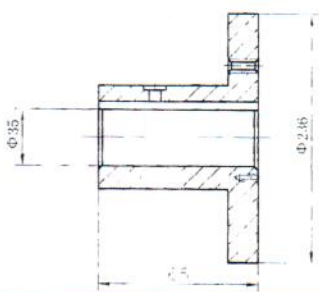
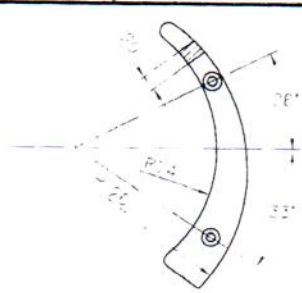
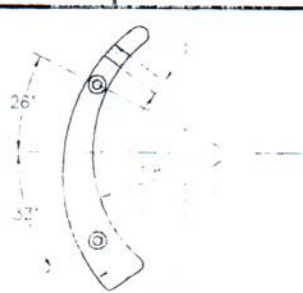
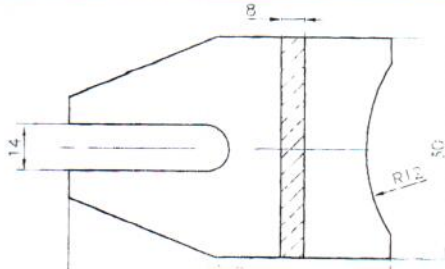
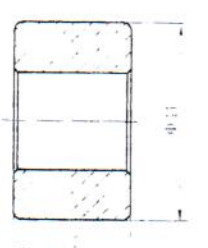
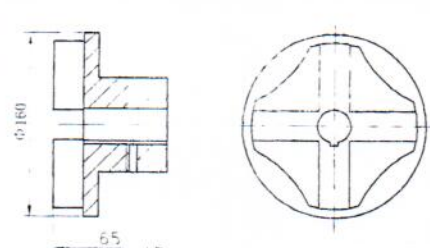
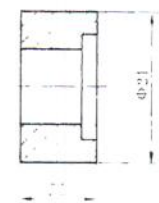
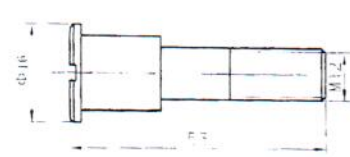
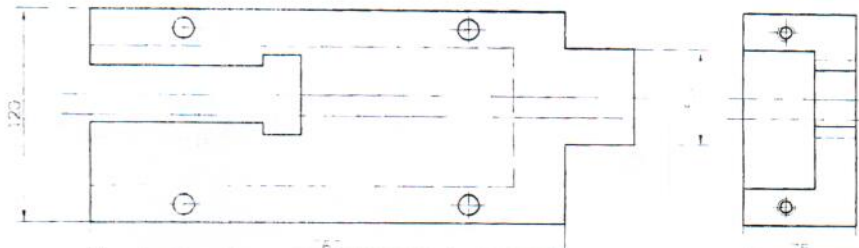
九 更换刀片的步骤:

1. 分离离合器。
2. 切断机器电源。
3. 松掉后刀模拉簧(见图二)取下机身的前盖板和后盖板。
4. 先对前刀模进行操作:

Drawing of sepearte parts

XD290-04-17	left foot of shoelace pincers	8	XD290-04-18	right foot of shoelace pincers	8	XD290-04-19	left of shoelace tray	1
								
XD290-04-20	right of shoelace tray	1	XD290-04-21	screw for pincers foot	16	XD290-04-22	pin for pincers foot	16
								
XD290-04-26	copper lining for fix shoelace cam	1	XD290-04-27	fix shoelace	1	XD290-04-57	rocker module	1
								
XD290-04-60	joint for shaft	1	XD290-04-77	copper lining for fix shoelace cam	2			
								

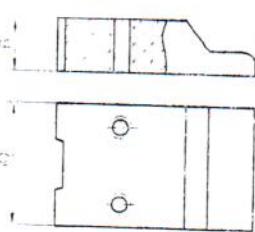

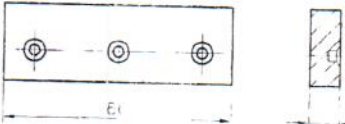
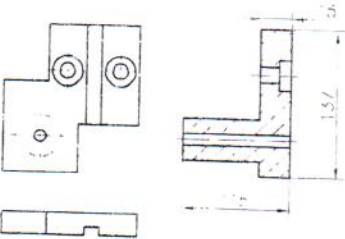

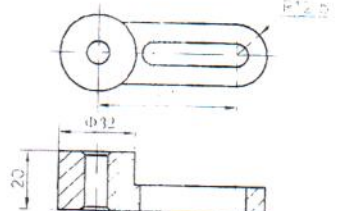
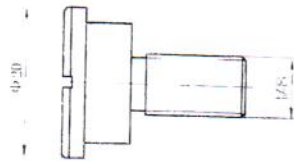
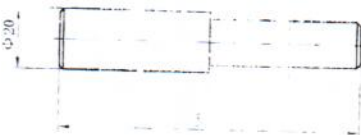
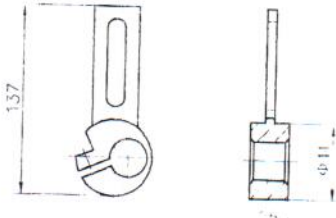
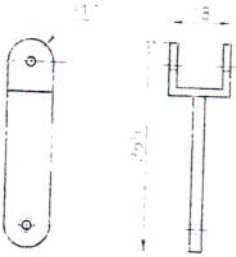
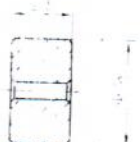

Drawing of separate parts

XD290-01-31	copper steeve of main shaft	2	XD290-01-32	copper steeve of main shaft	1	XD290-01-33	fan-shape cam fix board A	1
								
XD290-01-34	fan-shape cam A	1	XD290-01-35	fan-shape cam B	1	XD290-01-36	fan-shape cam fix board B	1
								
XD290-01-37	fan-shape board A	2	XD290-01-38	fan-shape board B	2	XD290-01-49	fork for main shaft of lever	1
								
XD290-01-50	fork base for main shaft of lever	1	XD290-01-58	intermittent wheel	1	XD290-01-60	intermittent elliptic roller	1
								
XD290-01-61	inner shaft of elliptic roller	1	XD290-02-01		machine body		1	
								

Drawing of separate parts

XD290-02-03	right board	1	XD290-02-04	left board	1	XD290-02-05	ahead cover	1
XD290-02-06	rear cover	1	XD290-02-07	rear base	1	XD290-02-08	top spacer	2
XD290-02-09	top spacer A for rear knife module	1	XD290-02-10	top spacer B for rear knife module	1	XD290-02-11	side spacer for ahead knife module	1
XD290-02-12	side spacer for rear knife module	1	XD290-02-13	ahead knife module 2	1	XD290-02-14	thermostat knife module	1
XD290-02-15	left-rear knife module	1	XD290-02-16	right-rear knife module	1	XD290-02-17	fix shoelace board	2

Drawing of the same parts

XD290-02-20	wide knife module	2	XD290-02-21	narrow knife module	1	XD290-02-24	rear-low knife
							
XD290-02-25	conveyer prop	1	XD290-02-26	conveyer r prop	1	XD290-02-27	conveyer rocker
							
XD290-02-28	screw of conveyer rocker	1	XD290-02-29	conveyer shaft	1	XD290-02-30	conveyer camshaft
							
XD290-02-31	conveyer prop	1	XD290-02-32	conveyer roller	1	XD290-02-33	pin of conveyer roller prop
							
XD290-03-36	spray nozzle for acetone	1	XD290-04-15	cross steeve	2	XD290-04-16	cross
