

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

Instruction Manual



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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℃ about. It takes cutting tool 10-15 minutes to preheat 50-60℃ .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) 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.

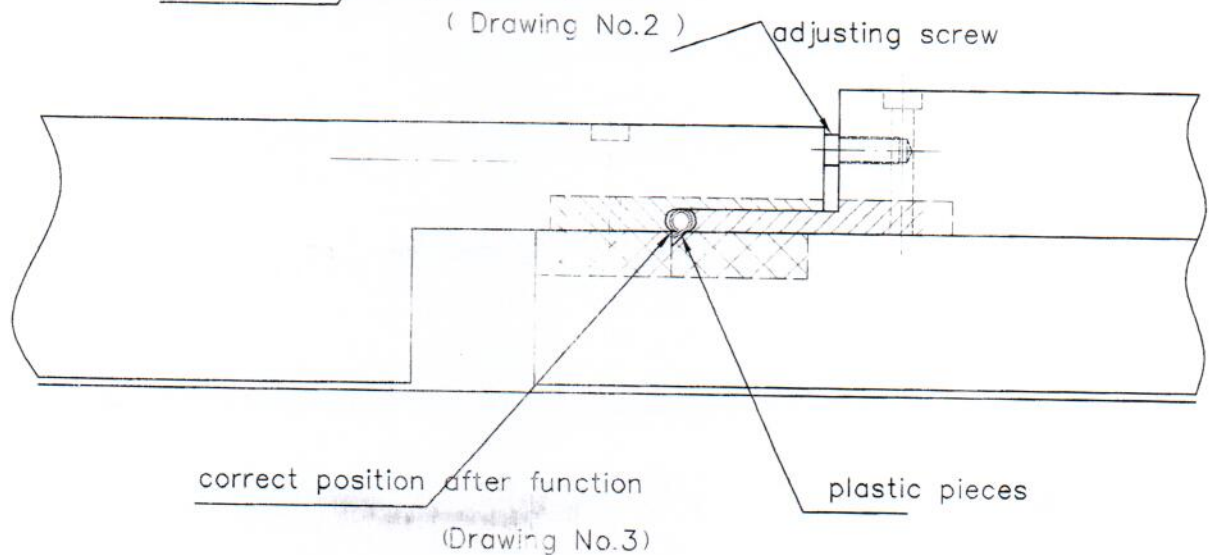
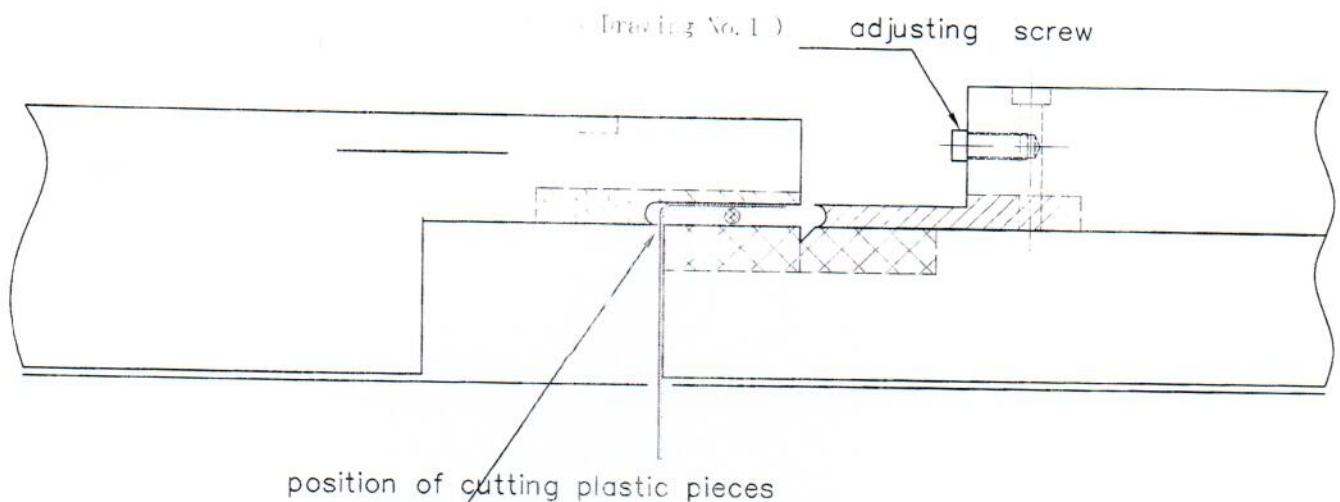
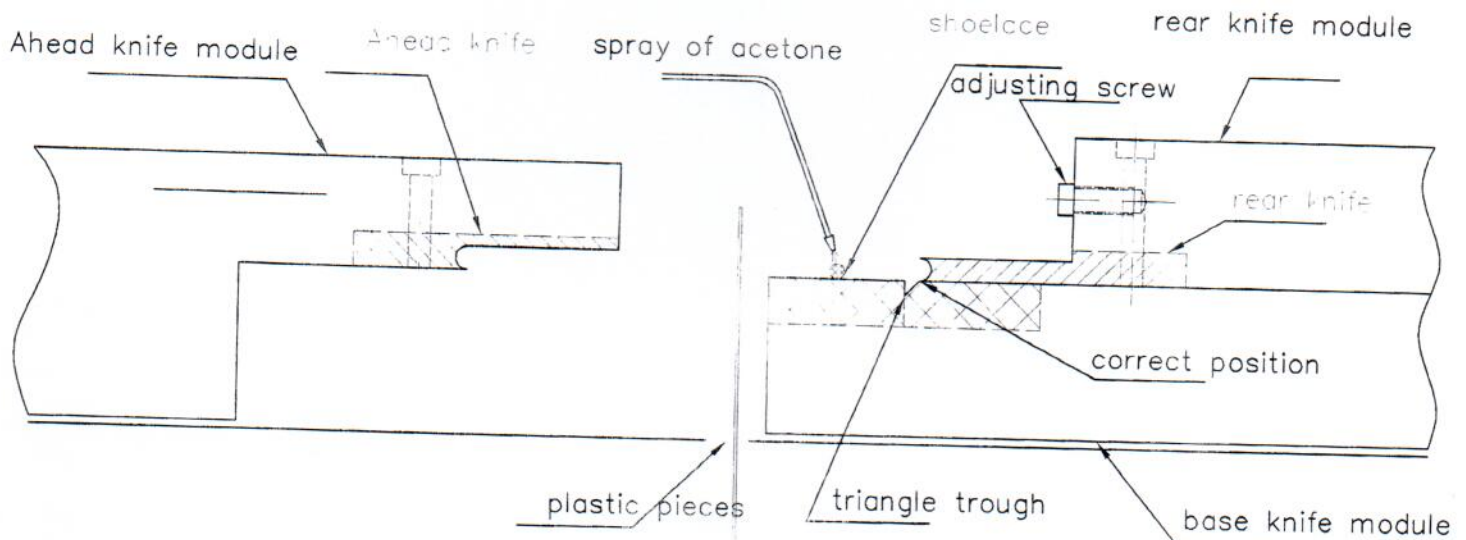
(2) Maintain voltage 220V about on production, if voltage is too higher, the thermostat will be damaged.

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

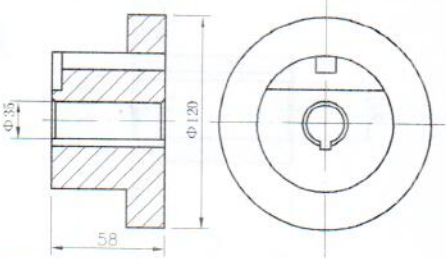
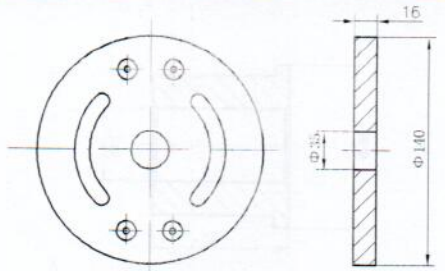
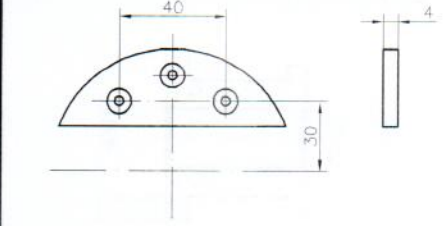

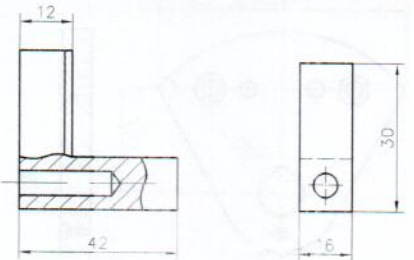
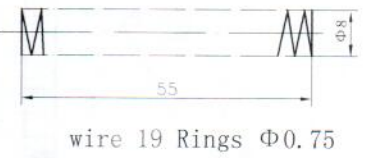
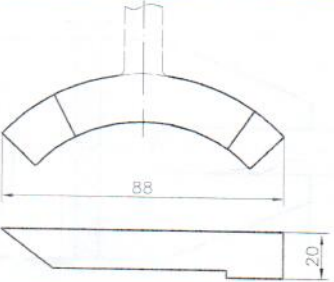
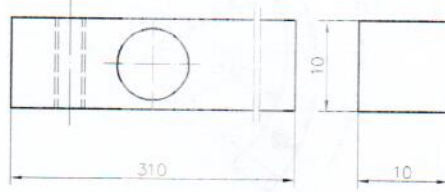
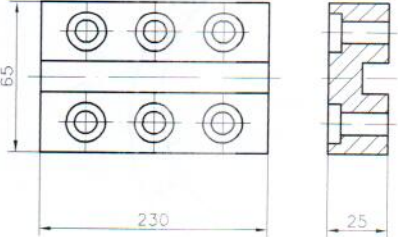
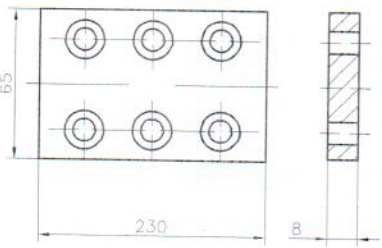
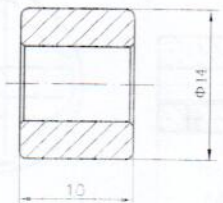
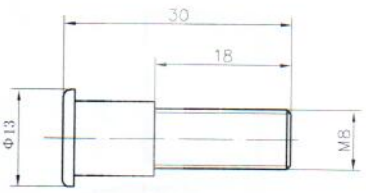
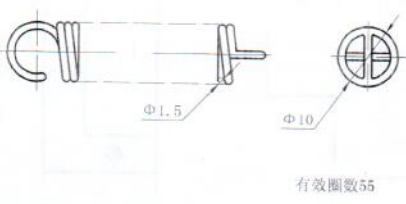
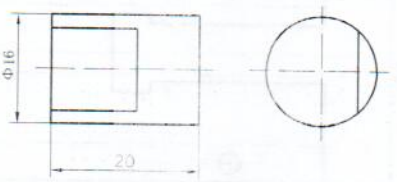
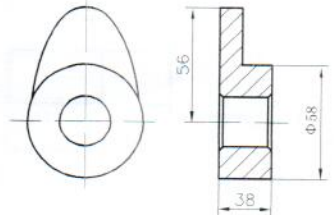
Attention:

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.

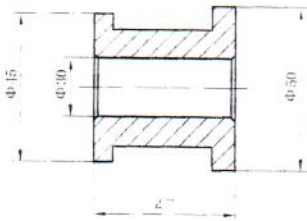

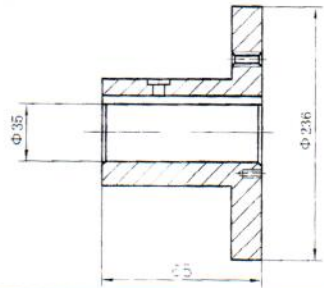
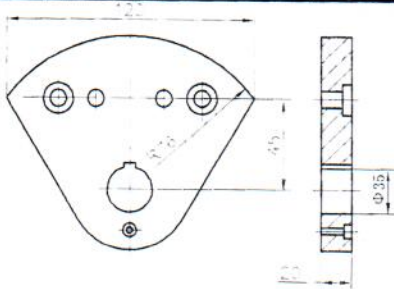
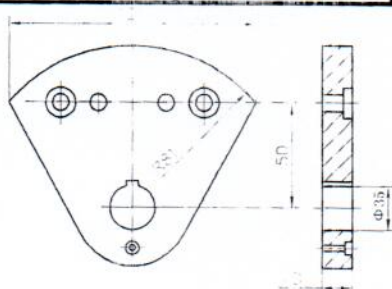
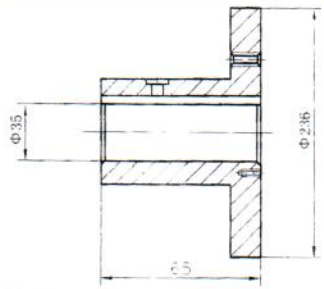
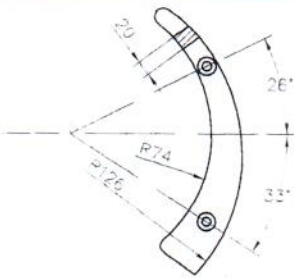
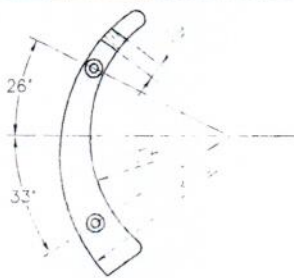
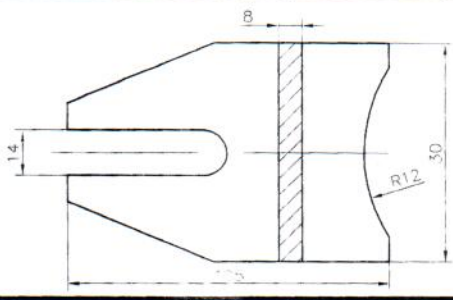

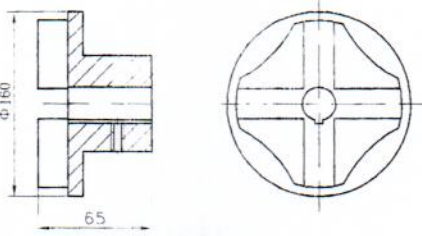

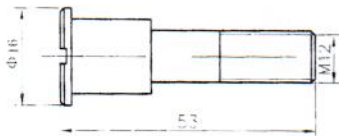
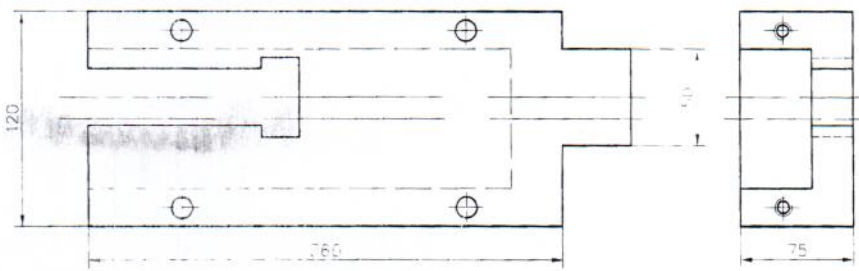
Operating cutting tool and adjusting position(see Drawing No.2、No.3、No.4)



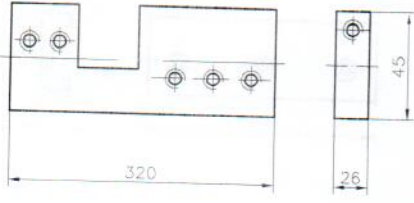
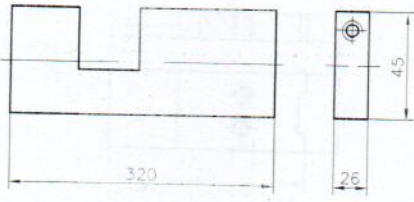
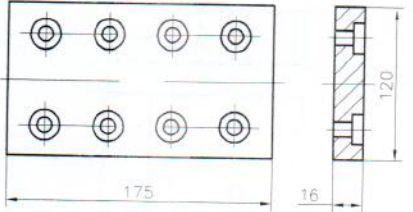
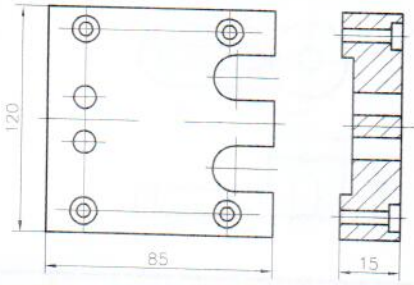
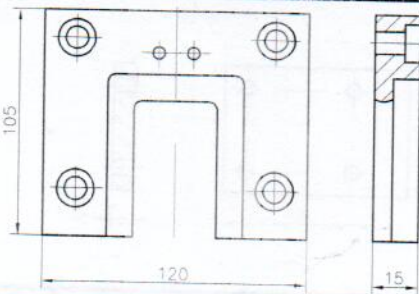
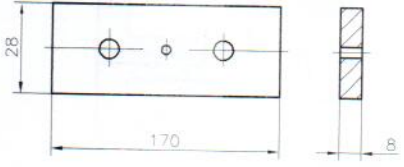
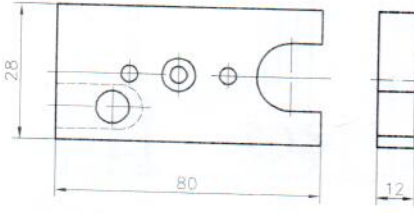
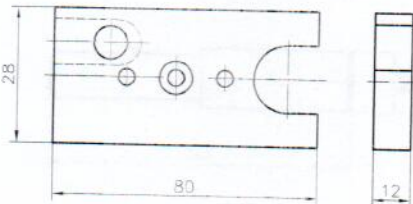
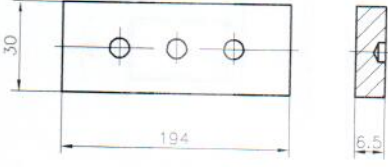
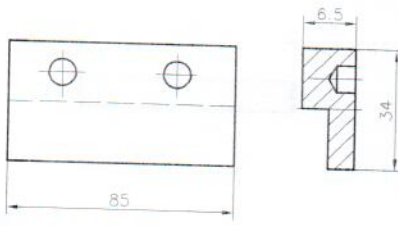
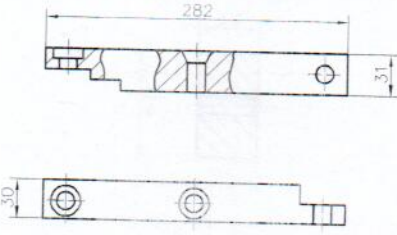
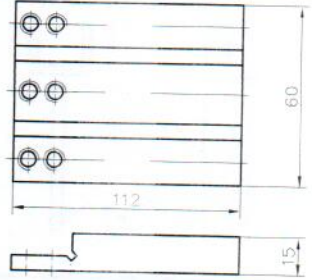
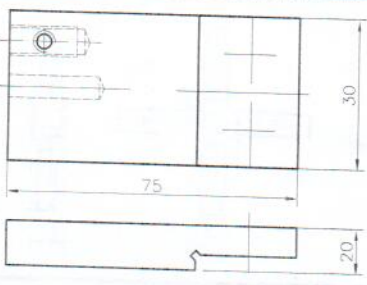
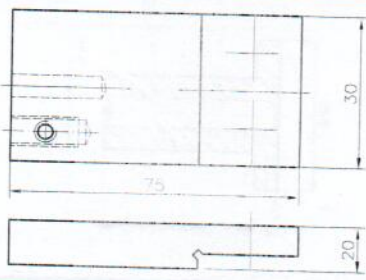
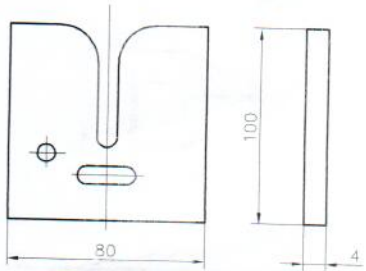
Drawing of sepearte parts

XD290-01-09	cluth	1	XD290-01-10	piece of cluth	1	XD290-01-11	cover of cluth	1
								
XD290-01-12	spring pin	1	XD290-01-13	dash pot of cluth	1	XD290-01-14	spring	1
						 <p>wire 19 Rings $\Phi 0.75$</p>		
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	dash pot of cluth	2	XD290-01-30	cam of pump for liquid conveyer	2
 <p>有效圈数55</p>								

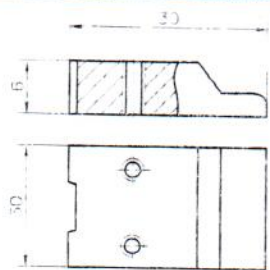
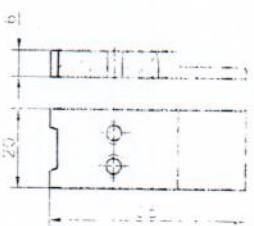
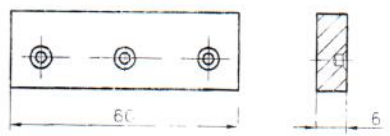
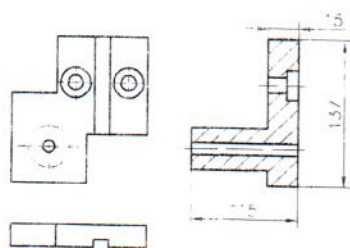
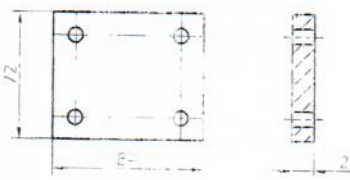
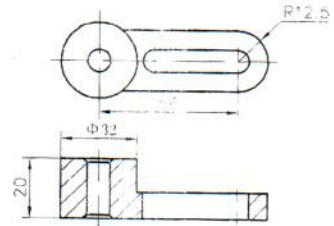
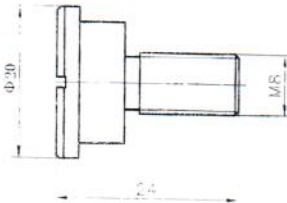
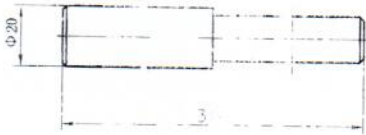
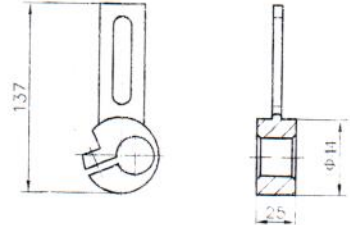
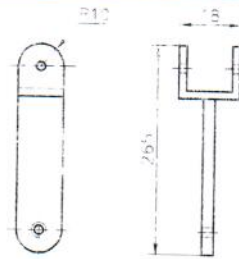
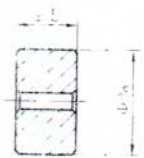

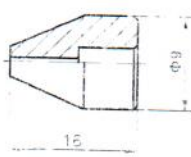
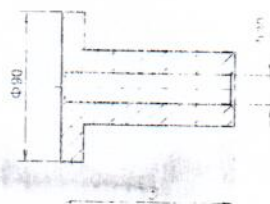
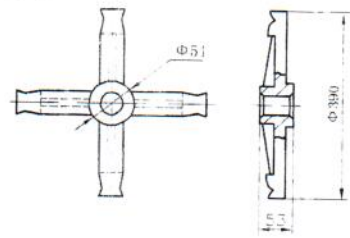
Drawing of separate parts

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
								

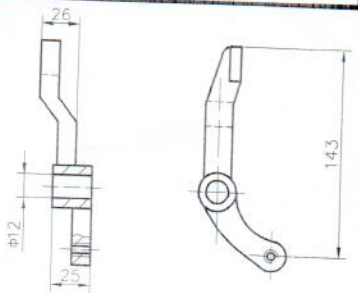
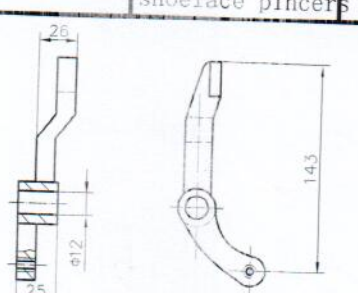
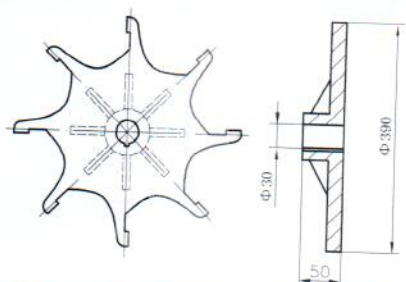
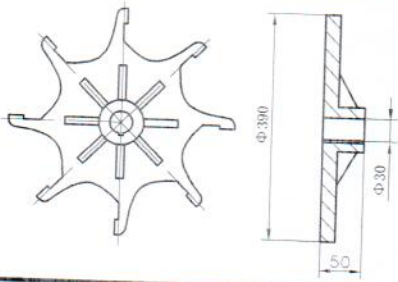
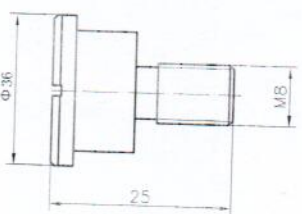
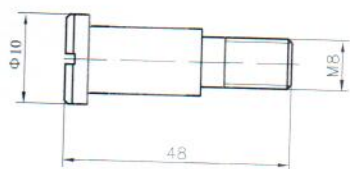
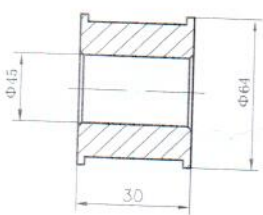
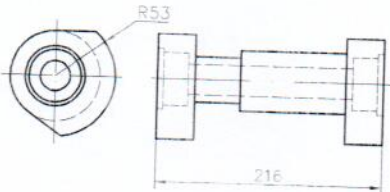
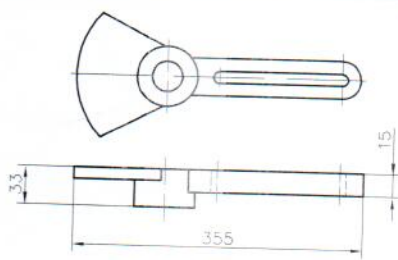
Drawing of separate parts

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	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 separate parts

XD290-02-20	wide knife module	2	XD290-02-21	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
								

Drawing of separate 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 foot	1	XD290-04-27	fix shoelace cam	1	XD290-04-57	rocker module	1
								
XD290-04-60	joint for shaft	1	XD290-04-77	copper lining for fix shoelace cam	2			
