上海香海织带机械有限公司
Shanghai Xianghai Braiding Machine Co.,Ltd

本公司已通过CE认证与ISO9001:2008质量体系认证
CE Certificate and ISO9001:2008 Certificate

Automatic Bobbin Winder

Instructions For Use



Shanghai Xianghai Braiding Machine Co., Ltd.
Tel: 008621-69750655
Website：www.xiang-hai.com
After-Sales Service: 0086-21-59754916

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Company Profile

Shanghai Xianghai Braiding Machine Co.,Ltd. specializes in the manufacturing of various braiding machines and braiding machine accessories. The Company is operated under ISO9001-2000 international management standards.

Shanghai Xianghai Braiding Machine Co., Ltd. specializes in the production of rope braiding machine, carrier braiding machine, high speed braiding machine, sleeve braiding machine, cable braiding machine, twisted rope braiding machine, elastic belt braiding machine, fancy rope braiding machine, automatic bobbin winding machine, semi-automatic bobbin winding machine, shoelace and gift bag rope tipping machine and other machinery and accessories.

Located in Qingpu District, Shanghai, the company has thirty years' experience in the design and production of braiding machinery and has been supplying high quality equipment and offering technical support to the textile, shipping, cable and rubber asbestine industries. The products are sold throughout the country and overseas to Japan, South Korea, Russia, America, Brazil, Morocco, Poland and other countries over the world. The company is a leading manufacturer and researcher in China's braiding machinery industry.

Operating Instructions

2.1 Notice

1. Read this manual carefully before running the machine.(The warranty is attached in the back of this manual.)

2. Please keep this manual in case of future need.

3. Improvements made to the machine after the issuing of this manual are not mentioned here.

2.2 Before Operation

1. Open the electric box and find the packing list. Check accessories and parts according to the list.

2. Make sure the voltage matches between the machine and your workshop. Ask a professional electrician to connect the power supply. Make sure of the grounding of the machine.

3. Check the balance of the machine before use.

4. Check all the oil filler holes and make sure they are well oiled.

5. Make sure the bearing is well oiled.

6. Yarn threading:

Attention：A. Each yarn should be threaded through one ceramic eyelet. Make sure the yarns do not cross.

B. Yarn diameter should be within 2mm.

C. Check if all the yarns have the same tension. Adjust

the conical spring on the yarn presser to adjust the yarn tension.

7、Placement of bobbins：

Attention：A. bobbins should be of the same size.

B. bobbins should be placed in the same direction.

C. do not place damaged bobbins in the machine.

2.3 Steps before Operation：

1. Thread the yarn through the ceramic eyelet.
2. Thread the yarn through the yarn presser.
3. Thread the yarn through broken yarn sensor（or else the machine would not stop when yarn is broken）.
4. Thread the yarn through the yarn assembling staff.
5. Thread the yarn through the traverse staff ceramic eyelets.
6. Better to put the yarn material in a box stead of on the ground.

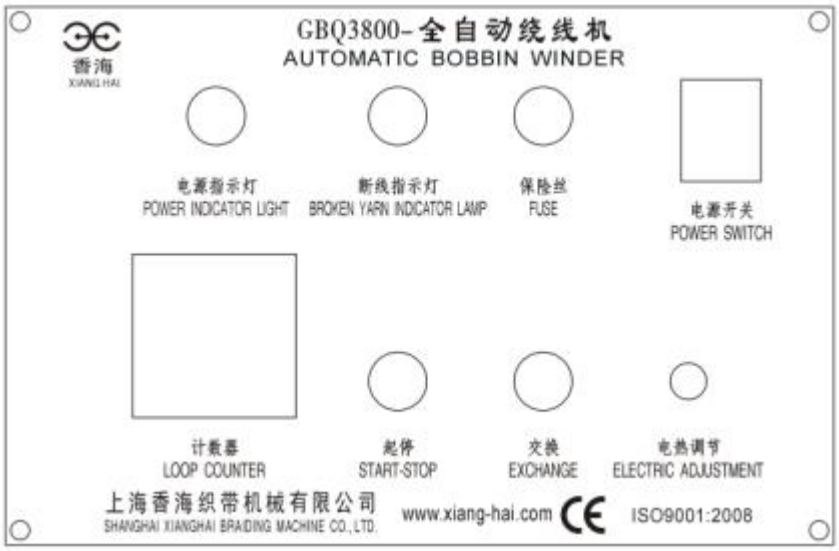
2.4 Functions of the buttons（**GBQ3800-1**）

1. Please refer to the inverter manual for instructions on the use of the inverter.
2. Press the operation panel reset switch to reset the counter.
3. Exchange button: press this button and the machine will stop winding and automatically change the bobbin.
4. Heating adjustment: adjust the heating temperature according to

your different yarn material. (high temperature may shorten the life span of the heating cord).

5.Speed adjusting switch: clockwise--speed up, anticlockwise--speed down

6. Start/Stop button: start and stop the machine with the same button.



2.5 Functions of the buttons（**GBQ3800-2**）

1. Start button: press this button and the PLC screen starts.

2. PLC screen：

F1：start　F2：stop　F3：exchange

ALM: reset the alarm　ESC：exit

SET：switch to the setting of different parameters

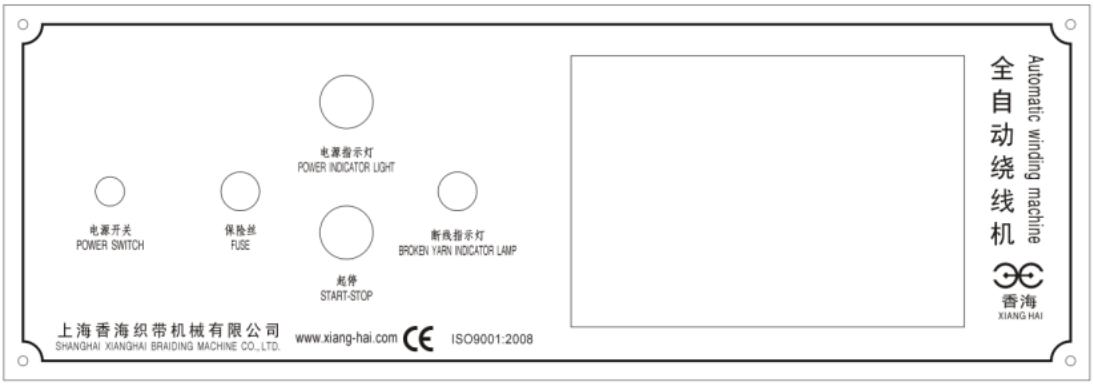
ENT：enter and save the settings

3. Δ ： enter settings page and turn to the next pages.

4. Press Δ once：manually testing the motion of each machine part.

5. Press △ twice：setting heating time and traverse loops.

6. Press △ thrice: testing of machine parts



P.S.：After setting the parameters please return to the homepage, or the machine will not work normally.

Maintenance Instructions

（A） Electric parts maintenance

1. Maintenance should be carried out every six months.

2. Turn off the power supply, wait till the display become blank, and then start the maintenance process.

3. Clean the broken yarn sensor.

4. Clear away dust and corrosive liquid in the electric box.

5. Check if the wires are loose.

6. Keep the air vent clean.

7. Keep the circuit board clean.

8. Clear away the fragments of the yarn.

9. Oil the machine regularly.

Installation Notice

Please pay attention to the following to keep the machine in a good state:

（1）Do not place the machine in direct sunlight. Keep the machine away from fire and high temperature.

（2）Do not place the machine in damp places. Do not let water on the machine. Keep the air humidity between 30% and 80%.

（3）Do not place the machine in places of severe pollution.

（4）Do not place the machine on tilt or uneven ground.

（5）Do not put heavy objects and unrelated things on the machine.

（6）Keep the machine from magnetic-field interference.

Common problem troubleshooting

Breakdowns	Methods to fix breakdowns
1.bobbins are not sent into the right position	a)check if obstacles blocked the parallel rod b)check if the sliding rail is blocked c)check if the feeding arm screws are loose d)check if the bobbin outlet screws are loose
2.bobbins are not clamped tightly	a)check if the rubber piece is worn out b)check if the bobbin is damaged c)check if the back pressing pins are loose
3.heating cord does not turn red or only part of it is red	a)check if the heating cord is burnt b)check if the power is disconnected c)check if the heating cord staff screws are loose d)check if the heating temperature control knob works
4.abnormal sound during operation	a)check if the machine is placed on even ground b)check if any screws are loose c)check if there is any obstacle in the belt pulley d)check if the pressing pin bearing is broken
5.uneven traverse	a)check if the yarn tension is even b)adjust the knurled nuts for even yarn tension
6.no PLC display	a)check if the 110V power switch works b)check if the plug behind the display is loose

Matters Needing Attention

Before running the machine:

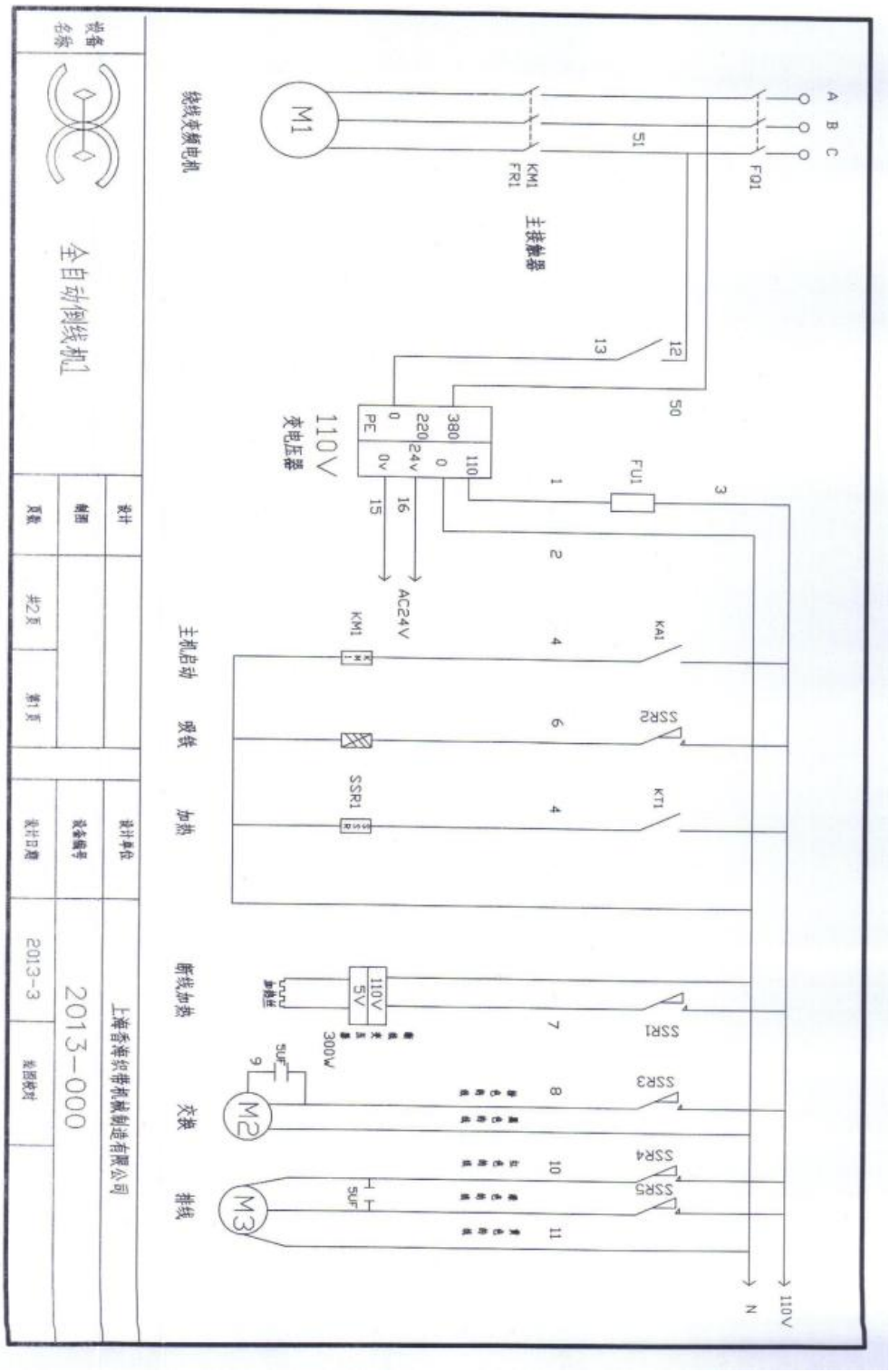
Make sure the parts are not loose and the gears are well oiled. During the operation of the machine the motor temperature should be less than 70 degrees Celsius, and no strange noise should be heard inside the machine.

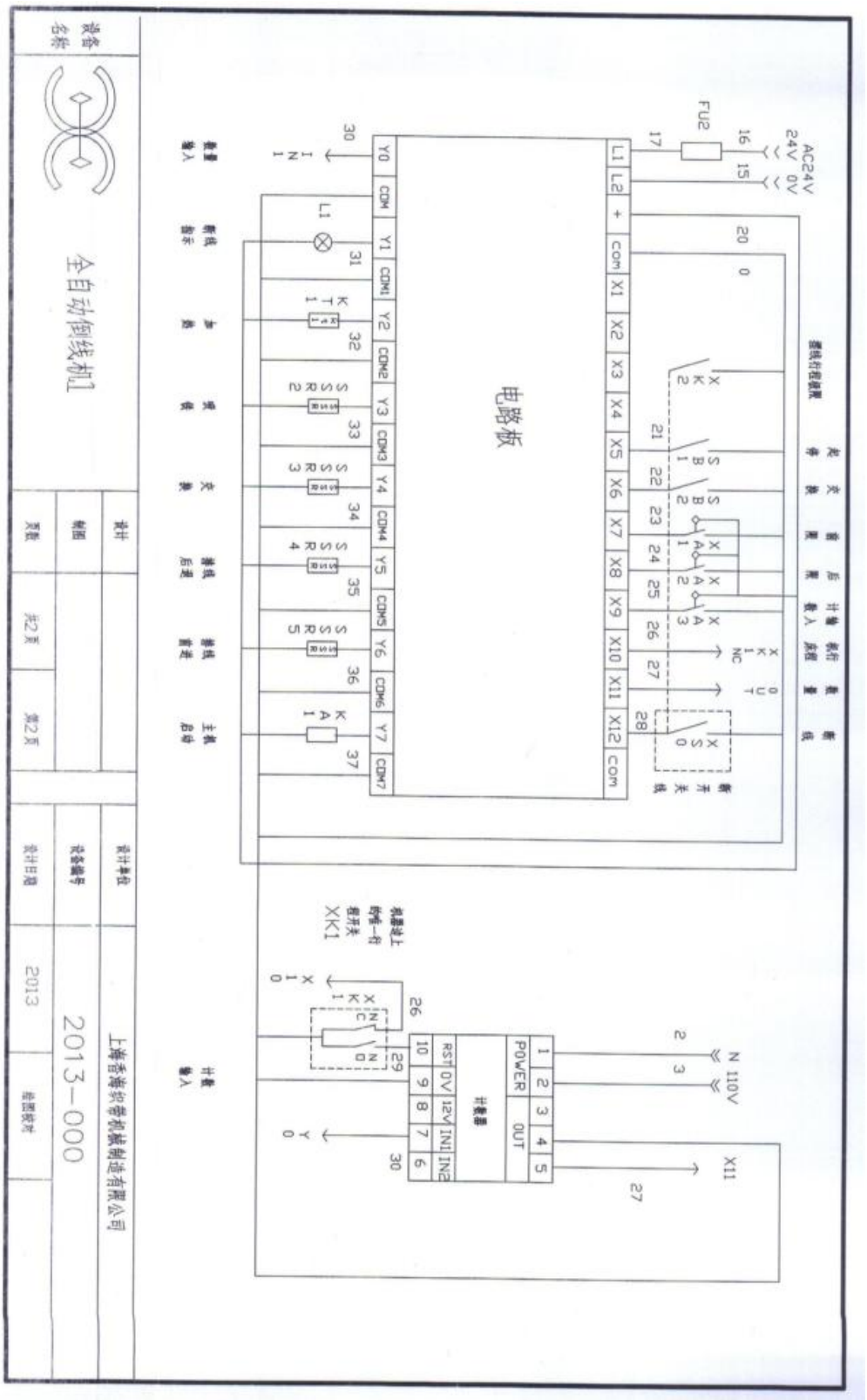
Pay attention to the temperature of the machine frame and make sure it is not too hot.

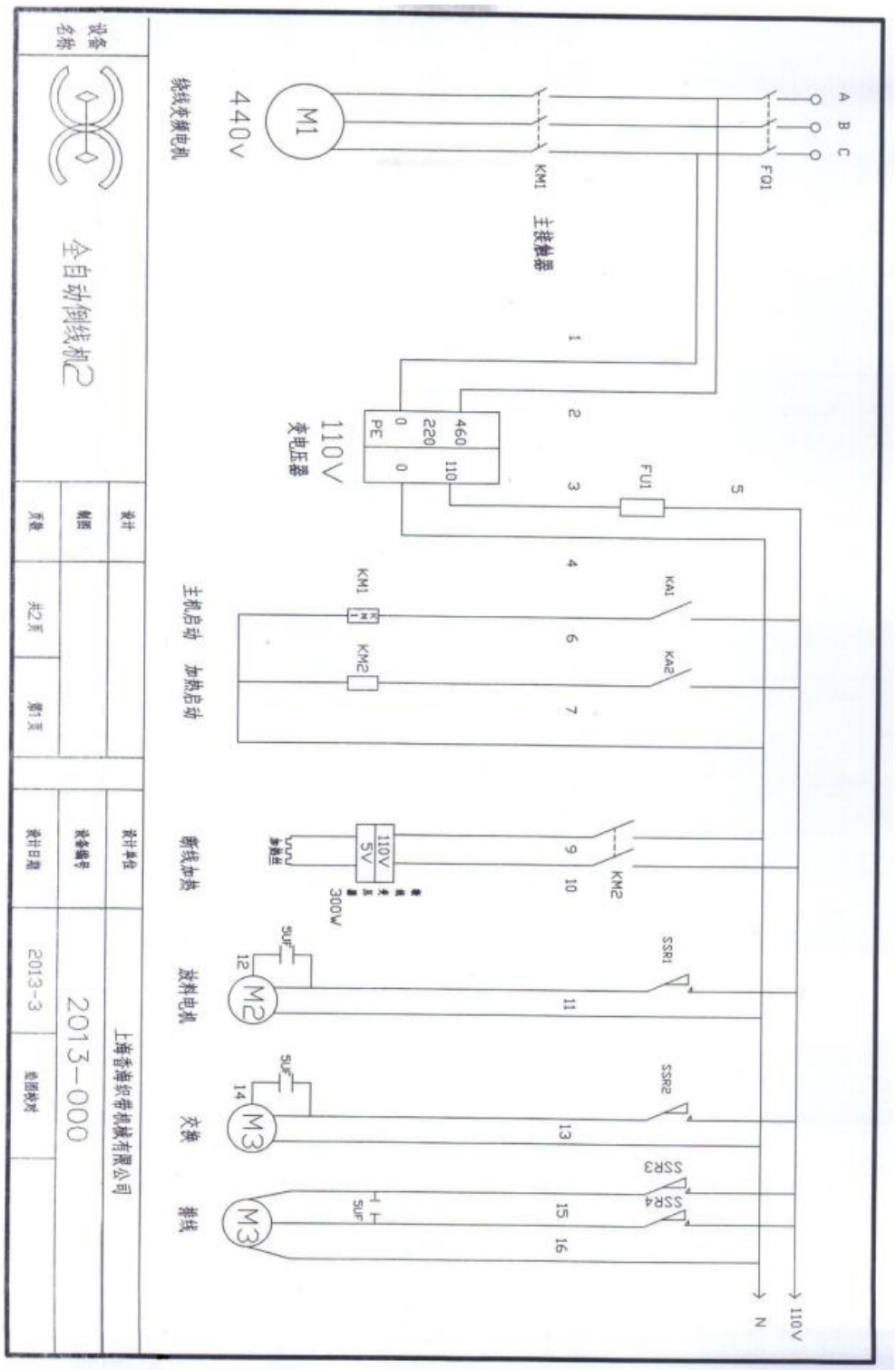
WARNING

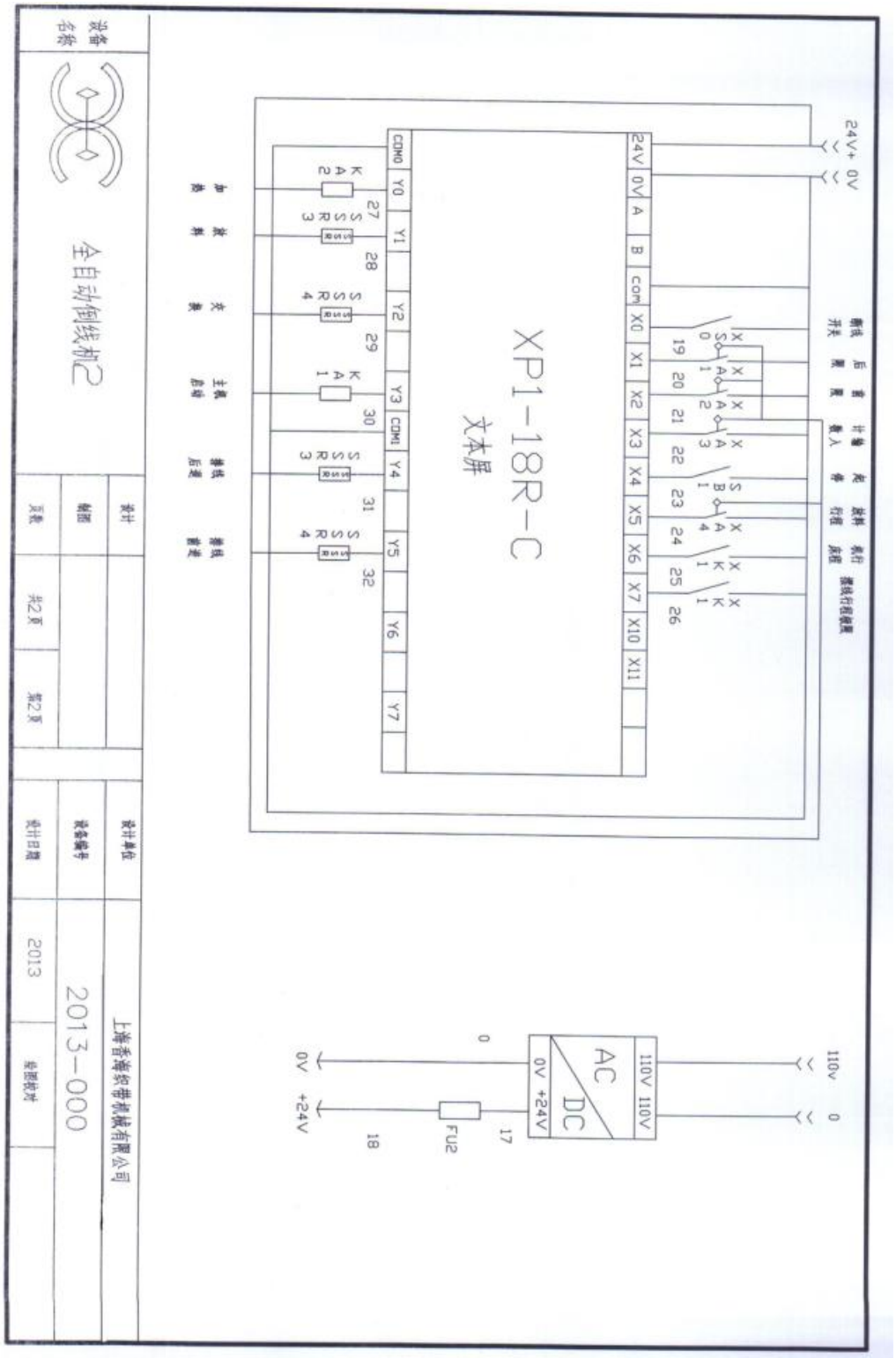
Pay attention to the grounding sign“⏚”in the electric box. Mistakes in grounding may lead to electric shock or fire.

Circuit Diagram




电路板
全自动倒线机1
上海香海编织机械制造有限公司
2013-000
2013
AC24V
24V 0V
FU2
N 110V
POWER
OUT
X11
XK1
L1
RST 0V 12V IN1 IN2


A B C
FQ1
KM1 主接触器
M1
440v
绕线变频电机
110V
变电压器
PE
460
220
110
0
FU1
KA1
KA2
KM2
主机启动
加热启动
断线加热
放料电机
交换
排线
SSR1
SSR2
SSR3
SSR4
5UF
110V
5V
300W
N
设备名称
全自动倒线机2
设计
制图
审核
共2页
第1页
设计单位
上海香海织带机械有限公司
设备编号
2013-000
设计日期
2013-3
底图号
底图核对


XP1-18R-C
文本屏
全自动倒线机2
上海香海织带机械有限公司
2013-000
2013
24V+ 0V
110v 0
AC
DC
0V +24V
110V 110V
FU2

Warranty

IS9001-2000 International Management Standards certified

Date of manufacture：_____

Model: _____

Examiner：_____

Repair log: _____

_____

_____

Shanghai Xianghai Braiding Machine Co., Ltd.

Repair：

1. The machine has a warranty of 1 year, during which time all damaged parts of the machine can be repaired and replaced without charge(man-made damages not included).
2. The customer may send the machine to Xianghai factory for repair and is responsible for one way transportation expenses.
3. Xianghai also offer on-site repair, in which case the customer is responsible for repairmen's travel and accommodation expenses.

Packing List

NO: Number of boxes:1

No.	Name	Quantity	Size	Remarks
1	Winding machine	1 set		
2	Rubber ring	2 pieces		
3	Heating cord	1 piece	30CM	
4	Spanner	3 pieces		
5	Hexagon Socket	4 pieces		
6	Instructions for use	1		
7	Warranty	1		