

上海香海织带机械有限公司

SHANGHAI XIANGHAI FABRIC MACHINERY CO., LTD.

COMPONENTS MANUAL

使用手册



高速绳带电缆编织机

High-speed cable straps weaving machine

目 录

1、序言	2
2、开箱验收、安装使用及安全事项	3
3、整机安装、维护保养	3
4、机器用途、特点	3
5、操作说明	4
6、零件手册	10
6.1链齿轮传动组	10
6.2送胶传动组	12
6.3送胶导轮组	14
6.4过芯线组	16
6.5出带滚轮组	18
6.6出带滚轮组	20
6.7纬密齿轮组	22
6.8纬密齿轮组	24
6.9出带支撑架组FHS/16	26
6.10出带支撑架组FHS24/32	28
6.11出带支撑架组FHS/48	30
6.12主体传动齿轮组	32
6.13基座组	34
6.14走马锭组	36
6.15包芯停电组	38
6.16停电组合	40
6.17电路图	42

1. FOREWORD
2. UNPACKING/CHECKING UPON DELIVERY; INSTALLATION/ OPERATION & SAFETY AFFAIRS
3. INSTALLATION OF A COMPLETE MACHINE SET AND REPAIR/MAINTENANCE
4. APPLICATIONS AND CHARACTERISTICS
5. OPERATING MANUAL
6. MACHINE PARTS AND ACCESSORIES MANUAL
6.1 ADJUSTING CHAIN WHEEL ASSEMBLY
6.2 RUBBER DRIVE ASSEMBLY
6.3 SHAFT/RUBBER DRIVE ASSEMBLY
6.4 FEEDER ASSEMBLY
6.5 TAKE-OFF ROLLER ASSEMBLY
6.6 TAKE-OFF ROLLER ASSEMBLY
6.7 GEAR ASSEMBLY
6.8 GEAR ASSEMBLY
6.9 SUPPORT FRAME ASSEMBLY
6.10 SUPPORT FRAME ASSEMBLY
6.11 SUPPORT FRAME ASSEMBLY
6.12 MAIN GEAR ASSEMBLY
6.13 BASE ASSEMBLY
6.14 BOBBIN-HOLDER ASSEMBLY
6.15 POWER CUT ASSEMBLY
6.16 POWER CUT ASSEMBLY
6.17 CIRCUIT DIAGRAM

Preface

上海香海织带机械有限公司是专门为电线电缆、橡胶石棉、电子电器纺织织带等行业生产多种型号，各种规格的编织机及专用辅机已形成不同需要的系列产品。多年来为上海及全国各地数以百计工厂企业，科研机构提供了大量生产设备，深得用户的赞扬与好评。

本公司主要产品有系列化绳带、电线电缆编织机、特种编织机、高速编织机、医用缝合线编织机、绞绳机、绕纤机、勾针机等。本公司技术力量雄厚，生产设备完善，产品质量可靠、品种规格繁多、系列通用性强、互换性好，使用维护保养方便，深受广大用户欢迎。

本公司还能根据用户提供的特殊编织带样品，进行特定设计、制造。

本公司宗旨：质量第一、用户至上、价格合理、交货准时、产品实行三包。

本公司地处上海市西郊318国道东端33公里处，为江苏、浙江、安徽、福建等省进入上海必经之地，交通方便。

The Shanghai Xianghai band loom weapon limited company specially spinning and weaving weaves profession produce many kinds of models and so on the belt for electric wire electric cable \rubberasbestos \ the electronic electron \, each kind of specificationestablishment machine and the special-purpose auxiliary engine, hasformed the different need the series product For many years, hasprovided the mass productions equipment for Shanghai and each placeseveral hundred factories enterprises and the scientific researchunit, obtains the user the high praise

This company main product has serialized zhidai \ electric wireelectric cable establishment machine \special establishment machine \high speed establishment machine \medical suture line establishmentmachine \wire-stranding machine \Rao Yuji \ to cancel the knittingmachine and so on This company technical force abundant, produceswell-equipped, product quality reliable, variety specification many,series versatility strong, interchangeability good, the useaintenance maintenance is convenient, deeply is welcome the usercommunities

This company also can according to user's special need, carry on thespecific design and the manufacture This company objective: Quality first \user supreme \pricereasonable \ delivers the punctual \product to implement threepackages This company carries 33 kilometers east the Shanghai western suburbs318 federal highways place, is Jiangsu \Zhejiang \ province and so onAnhui \Fujian enters Shanghai the road which must be taken, thetransportation is convenient

二、开箱验收、安装使用及安全事项

2.1 开箱验收：

产品开箱验收时，若发现产品、附件与装箱单不符，请电函与本公司联系。

2.2 安装使用：

对使用说明书有关安装、调试、操作、维护等事项应先了解清楚，避免造成事故。在正常运输、安装、使用和保养条件下，如现质量问题，在规定期限内，请及时与本公司联系。

2.3 安全事项：高速绳带纺织机输入电压为单相220V，机器马达功率为1HP；必须保证机器有良好的接地，避免对操作者造成危险，对您公司造成不必要的损失。

三、整机安装、维护保养

3.1 整机安装：

机台之间前面后面间距不能小于1米，左右间距不能小于0.4米。安装整机时必须对整机作水平校正，调整机脚四外六角螺丝。

3.2 维护保养：

3.2.1 每月检查机器基座箱内齿轮油是否在规定范围内（油位必须在测油针两刻度线中央，低于测油针最下线时需加油，但不可过多避免油外喷。）

3.2.2 每月检查蜗轮相中润滑油，油位低于油镜一半时需加油；建议用循环机油R90；

3.2.3 各链轮、齿轮需每周加适度润滑油，建议用循环机油R90；

3.2.4 每天必需润滑转子及轴心与走马锭并将台面擦拭干净，避免掉落物卡住走马锭；

3.2.5 开机前必需确认机器动作范围内没有障碍杂物，开机时请以低速运转10分钟后再提高转速。

四、机器用途、特点

4.1 用途：

用于编织各种鞋带、高拉力带、鱼网线、钓鱼线、拖车绳、船用绳、装饰带、松紧带、运动带、窗帘带、电线、纤维等。

4.2 特点：

标准零件补给、包心同步送料、简易操作维护、产量高品质佳、包心断纱控制、节省空间人力。

SECTION 2 UNPACKING CHECKING UPON DELIVERY

INSTALLATION OPERATION SAFETY AFFAIRS

2.1 Unpacking Checking Upon Delivery

If any of the machine products or parts or accessories found inconformity to the packing list please liaise with FH Co by e mail while unpacking and checking before acceptance

2.2 Installation Operation

Users are hereby required to get prior understandings of the operating manual inter alias its conternts relating to installation setting up operation and repair maintenance so as to avert accidents Under such normal conditions as transportation installation operation and repair maintenance if any quality problem found please timely liaise with FH Co Within the given period

2.3 Safety Affairs

A High Speed Rope Braiding Machine needs single phase input 220V and 1 HP motor and the machine frame must well be connected with the ground to create a safe working envirnment for the operators and prot your business organizations form unnecessary losses

SECTION 3 INSTALLATION OF A COMPLETE MACHINE SET AND REPAIR MAINTENANCE

3.1 I stallation of a complete machine set

The total interval required when installing the machine

I meter intervals from feeding end of the machine

I meter intervals from takeoff end of the machine

0 4 meter intervals from the left hand side of the machine

0 4 meter intervals from the right hand side of the machine

Before affixing 4 hexagon head bolts on the feet of a machine need to be calibrated horizontally

3.2 Repair Maintenance

3.2.1 Monthly oil check is required on the gears in the base assembly box the oil level is required to come between the UP and DOWN Scale Marks more oil should be added when the oil level comes under the DOWN Scale Mark and at the same time the oil level is not allowed to come over the UP Scale Mark

3.2.2 Lubricating oil in the wheel box should be checked on a monthly basis if the oil level comes under half an oil indicator more oil will be needed it is suggested to use R90

3.2.3 Weekly maintenance is needed on all sprockets and gears this is to make sure that they are sufficiently lubricated R90 is applicable

3.2.4 Rotors axes and bobbin holders are required to be lubricated every day with track plate cleaned so as so tu prevent the bobbin holders from being blocked with odds and ends abandoned

3.2.5 Operator must ensure that there are no obstacked within the braider working scope before switching on and start a braiding machine at a low speed for the first 10 minutes then accelerate speed

SECTION 4 APPLICATINS AND CHARACTERISTICS

4.1 Applications

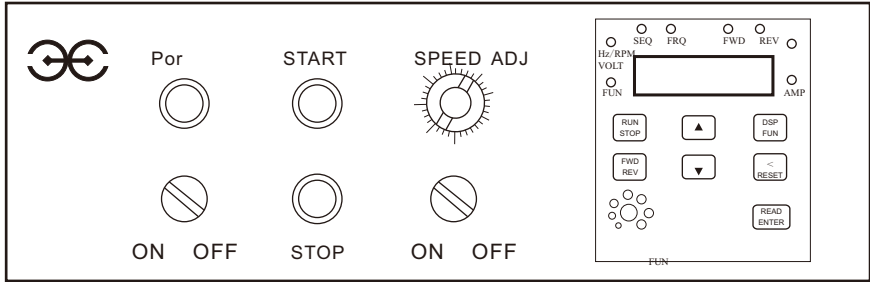
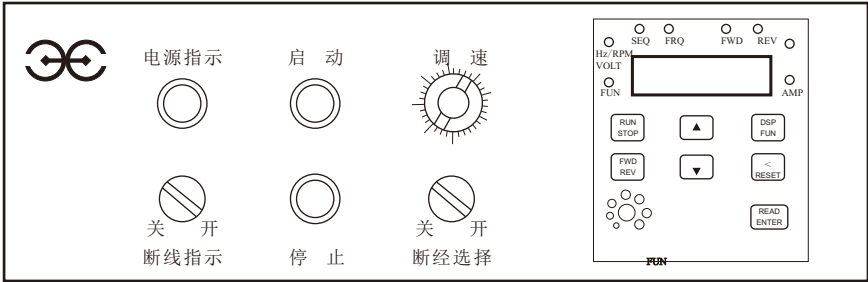
Braiders are applied to producing a variety of shoelaces high tensile strength belt fishing net thread fishing line trail rope hawses decorative ribbons elastic sporting accessories curtain accessories electric wires and fibres

4.2 Characteristics

Supply of standard machine parts and accessories synchronous filling material or rubber feeding devices easy operation and simple maintenance large amount of quality goods auto stop devices in case of thread breakage and less space and labour

五、操作说明

5. 1控制电箱面板操作说明：



5. 1. 1断线指示：

当包芯线或是纱断时感应器接触停机，应重新接线或是更换纱管重新启动。

5. 1. 2芯线开关：

当不织包芯带时此开关应关闭，织包芯带时打开，当包芯线断时会感应停机。

5. 1. 3调速：

调整机器运转速度，即更改变频器频率0-60HZ

1. 4启动：

固定纱管后按此启动机器开始运转。

5. 1. 5停止：

紧急状况时，按停止钮机器立即停止。

5. 1. 6变频器操作请参照变频器说明书。

5. 2穿纱路径：

请按下图进行穿纱，注意红色走马锭与绿色走马锭穿纱方式不一样。

5.1.1 Indicator of breakage

Filling material or rubber breakage touches the induction device to stop arunning braider promptly, and at the same time this indicator will light up advising the operator to reconnect the broken thread or replace/with yarn-wound bobbins.

5.1.2 On/Off switch of filled cord

This switch should be in an off position while braider is not weaving filled cord, and in an on position while weaving filled cord; in case of filling material breakage the braider in operation will be stopped by the induction device.

5.1.3Speed adjuster

This is used to adjust the speed R.P.M. Of braiders, that is to say, 0-60 Hz of the frequency converter.

5.1.4 Start Button

Press this buton to start a Braiding Machine when bobbins are fixed

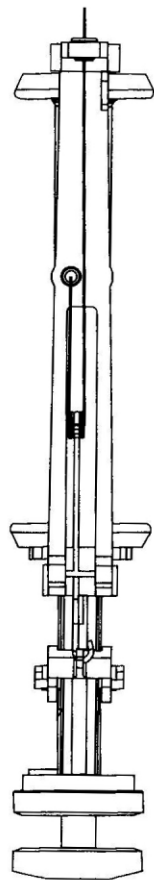
5.1.5 Stop Button

Press this button to stop a Braiding Machine Promptly in state of emergency

5.1.6 For frequency converter operation see additional manual

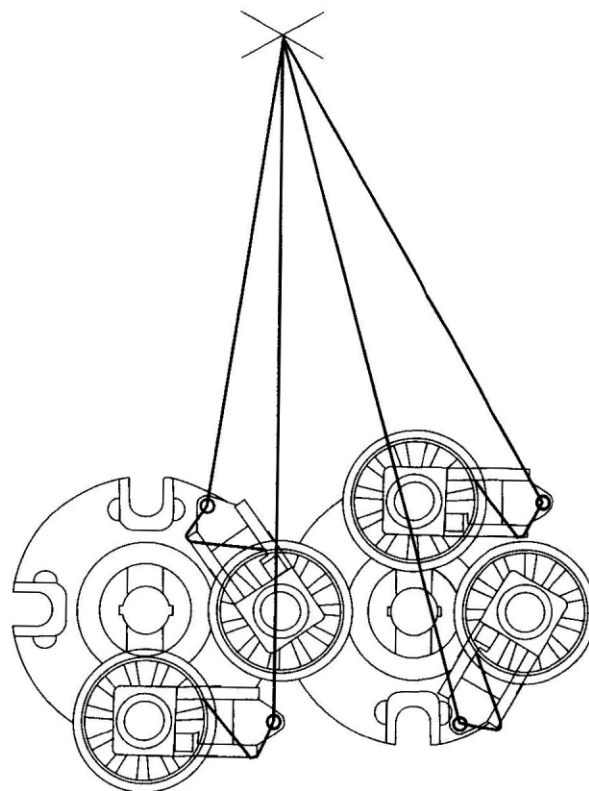
5.2 Routes of threading

Threading subject to the following, note there are a red bobbin holder & green bobbin holder; two rotations in different directions:



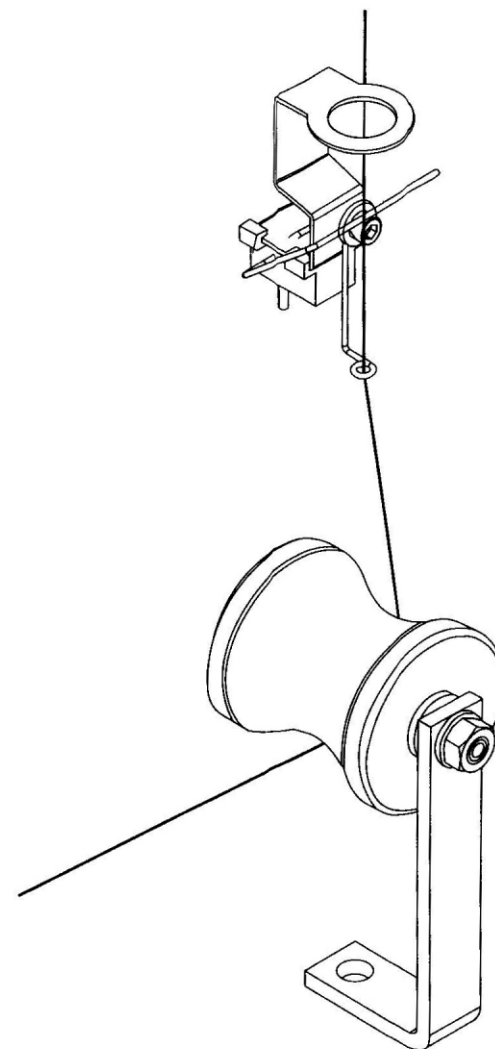
图一：穿线方式

DIAGRAM-1: ROUTE OF THREADING



图二：走马行径方向

DIAGRAM-2: ROUTE OF BOBBIN HOLDERS



图三：包芯线穿引路径

DIAGRAM-3: ROUTE OF FILLING MATERIAL

3. 故障排除:

原 因	排除方法
1.	1.
2.	2.
3.	3.
4.	4.
5.	5.
6. OL2	6. 1
7. OH	7.

3.Fix breakdowns

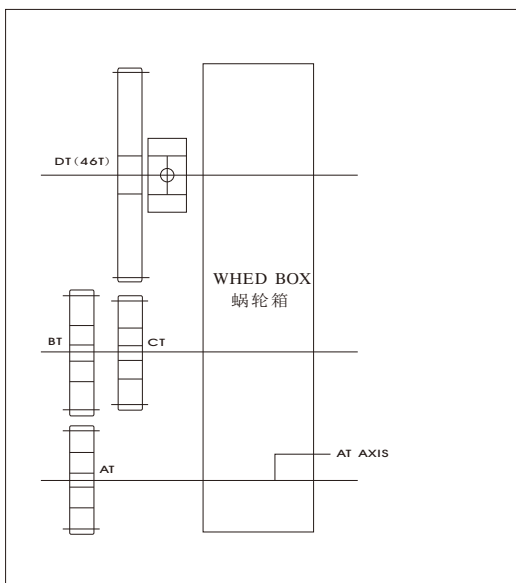
CAUSES OF BREAKDOWNS	METHODS TO FIX BREAKDOWNS
1.Abscnce of yarn on bobbins	1.Replace it with yarn- wound bobbins
2.Yarn brke	2.Reconnect the broken yarn
3.Filling material broke or used up	3.Supply with filling material
4. Clamp blocks the running of bobbinhobbin holder because it is not in place	4. Readjust the clamp and ensure it is positioned at centre
5. The switch wheel withstands over highly the indrction device	5. Lower the switch wheel a little, not too much; turn it left and right until it reaches its apex, that is to say, it touches the switch just right
6. OL2, which appears on the monitor of frequency converter, means the overload of motor	6. Check & remove any obstacles on the track plate which block the normal operation Then turn the hand- wheel to see if it rotates easily,if OK switch off the power supply for 1 minute and then restart the machine
7. OH, which appears on the monitor of frequency converter, means overheating trip or thermal detector failure	7. Take effective measures to improve the environmental ventilation If OH remains unchanged, the frequency converter should be sent to workshop for repair

4. 产量计算公式：

OUTPUT CALCULATION:

Hz NOTOR (HZ)	RPM ROTOR SPEED (RPM)	AT RPM AT AXIS (RPM)
60	362	12
59	356	11.8
58	350	11.6
57	344	11.4
56	338	11.2
55	332	11
54	326	10.8
53	320	10.6
52	314	10.4
51	308	10.2
50	302	10

MM PRODUCT DIAMETRE (MM)	F
1.0	265
1.5	268
2.0	272
1.5	275
3.0	278
3.5	281
4.0	284
4.5	287.5
5.0	290.5
5.5	294
6.0	297



$$\text{转子转速} = \text{频率} / 60 * 362.6$$

$$\text{ROTOR SPEED (RPM)} = \text{HZ} / 60 * 362.6$$

$$\text{AT轴转速} = \text{转子转速} * 0.033$$

$$\text{AT AXIS SPEED (RPM)} = \text{ROTOR SPEED (RPM)} * 0.03$$

$$\text{产量} = \text{AT轴转速} * \text{AT} / \text{BT} * \text{CT} / 46 * 0.49 * F$$

$$\text{OUTPUT} = \text{AT AXIS SPEED (RPM)} * \text{AT} / \text{BT} * \text{CT} / 46 * 0.49 * F$$

$$\text{产量} = \frac{\text{转子转速} * 2}{\text{产品节数}}$$

$$\text{OUTPUT} = \frac{\text{ROTOR SPEED (RPM)} * 2}{\text{PICK/CM}}$$

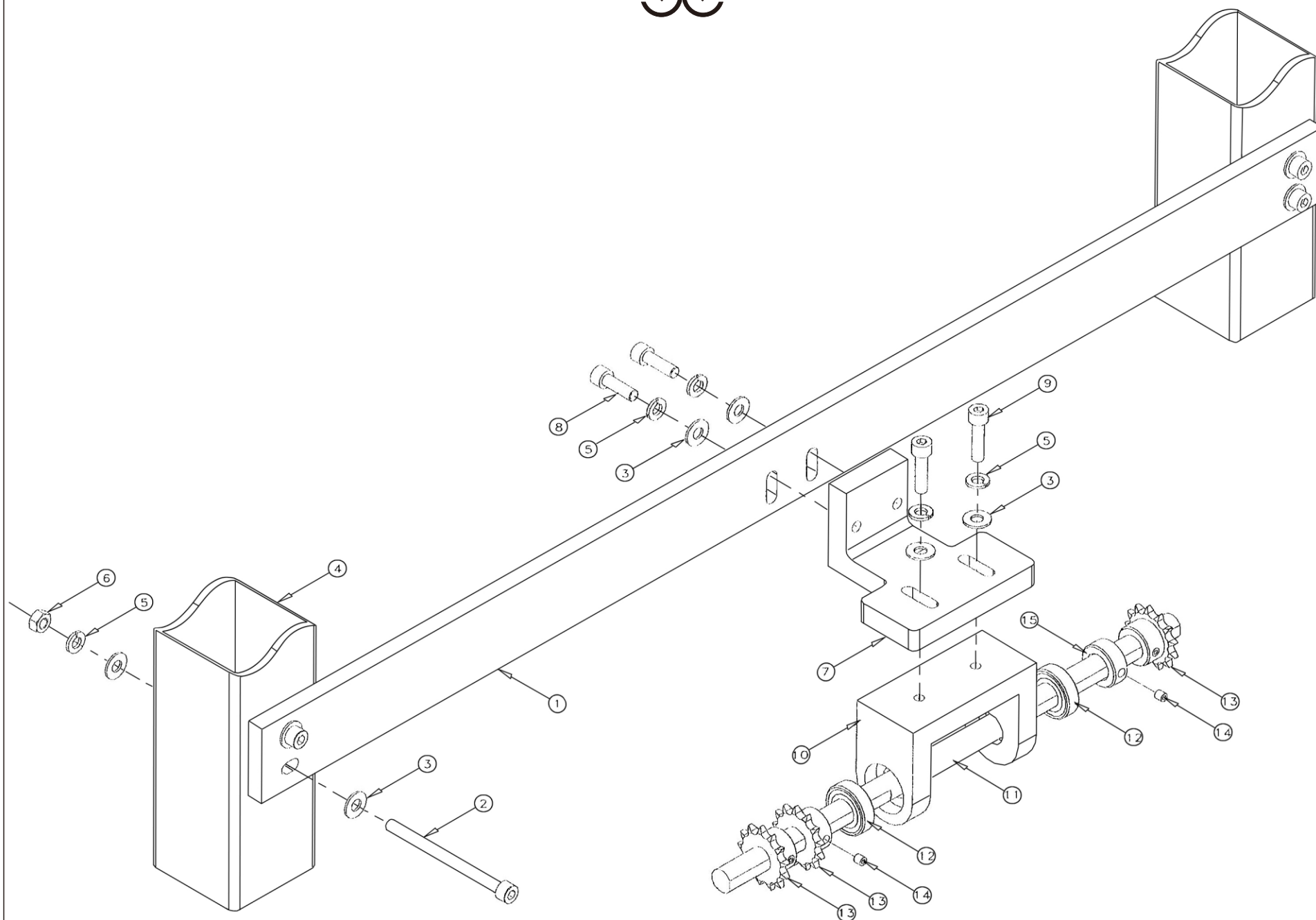
5、产品纬密及产量对照表：（产品直径为3MM CHART OF PICK/CM & OVTPUT: (PRODVCT DIAMETRE 3MM)

马达频率：60HZ, BT=30T, CT=28T MOTOR FREQUENCY			马达频率：60HZ, AT=36T, CT=36T MOTOR FREQUENCY		
AT	纬密PICK/CM	产量CM/MIN	BT	纬密PICK/CM	产量CM/MIN
19T	11.5	63	19T	3	241
20T	11	66	20T	3.15	230
21T	10.5	70	21T	3.3	219
22T	10	73	22T	3.46	209
23T	9.5	76	23T	3.62	200
24T	9	80	24T	3.78	191
25T	8.75	83	25T	3.94	183
26T	8.1	86	26T	4.1	176
27T	8	90	27T	4.25	170
28T	7.8	93	28T	4.41	164
29T	7.5	96	29T	4.57	158
30T	7.3	100	30T	4.73	153
31T	7	103	31T	4.88	148
32T	6.8	106	32T	5	145
33T	6.6	109	33T	5.2	139
34T	6.4	113	34T	5.36	135
35T	6.25	116	35T	5.52	131
36T	6.1	119	36T	5.67	127
37T	5.9	122	37T	5.83	124
38T	5.76	126	38T	6	120
39T	5.6	129	39T	6.14	118
40T	5.47	132	40T	6.3	115
41T	5.34	135	41T	6.46	112
42T	5.2	139	42T	6.62	109
43T	5.1	142	43T	6.78	106
44T	4.97	146	44T	6.93	104
45T	4.86	149	45T	7.1	102

ADJUSTING CHAIN WHEEL ASSEMBLY 链齿轮传动组

XIANGHAI

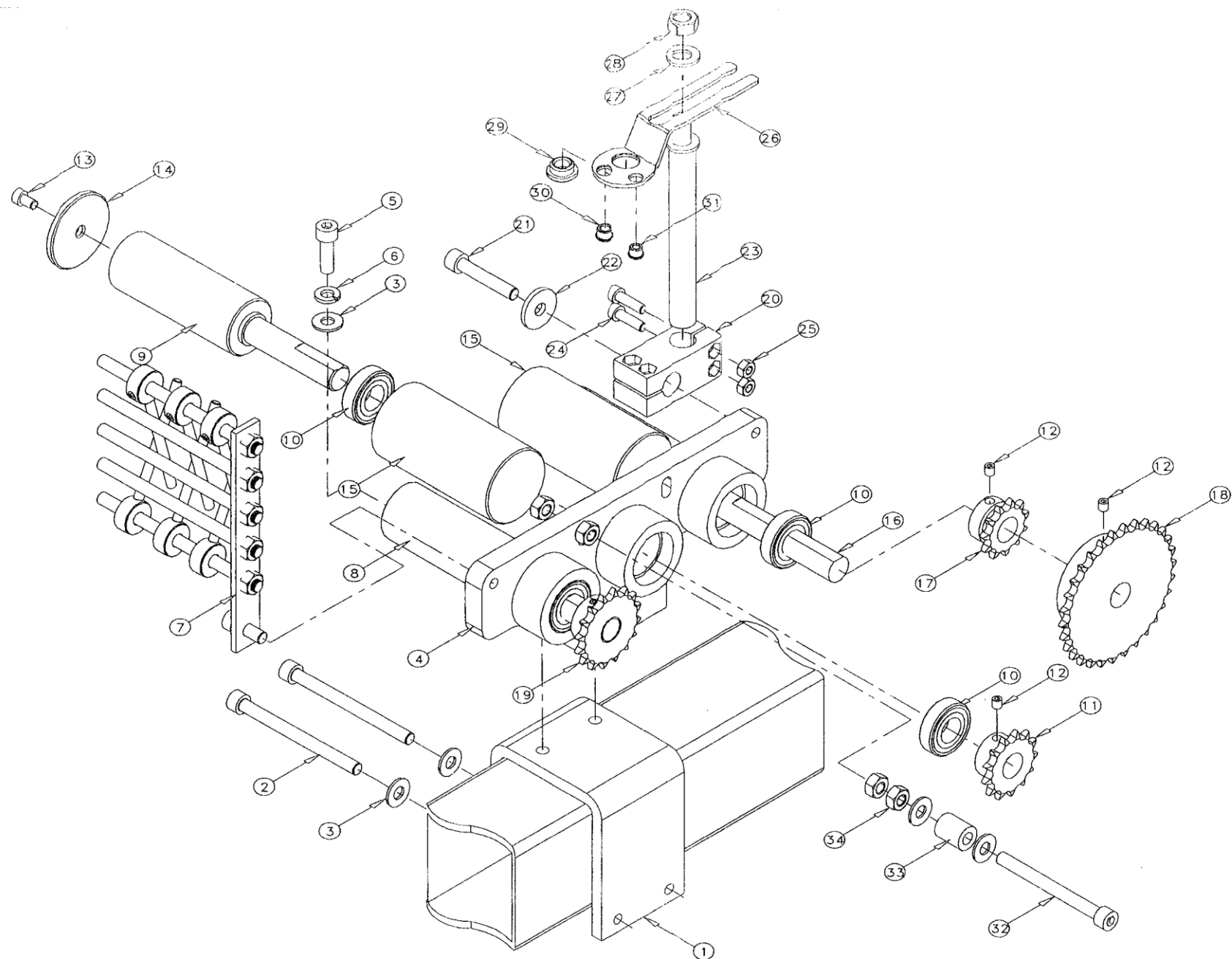
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-A001	BRACKET SUPPORT	传动支撑块	FHS/16
	FHS-A001A	BRACKET SUPPORT	传动支撑块	FHS/24
	FHS-A001B-48	BRACKET SUPPORT	传动支撑块	FHS/48
	FHS-A001C-32	BRACKET SUPPORT	传动支撑块	FHS/32
2	SC-M8*100	SOCKET CAP SCREW	内六角螺丝	
3	WAH-M8	WASHER	平垫片	
4	FHS-D002	BASE	基脚	FHS/16
	FHS-D002A	BASE	基脚	FHS/24
	FHS-D002B-48	BASE	基脚	FHS/48
	FHS-D002C-32	BASE	基脚	FHS/32
5	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
6	NUT-M8	NUT	螺母	
7	FHS-A002	BASE/GEAR	传动齿轮固定座	
8	SC-M8*25	SOCKET CAP SCREW	内六角螺丝	
9	SC-M8*30	SOCKET CAP SCREW	内六角螺丝	
10	FHS-A003	BASE/GEAR	传动齿轮固座	
11	FHS-A004	AXLE	传动轴心	FHS/16/24/48
	FHS-A004C-32	AXLE	传动轴心	FHS/32
12	HBN-6003ZZ	BEARING	轴承	
13	FHS-A006	SPROCKET	链齿轮	
14	SG-M6*6	SOCKET SET SCREW	止付螺丝	
15	FHS-A005	SPACER RING	间隔套	



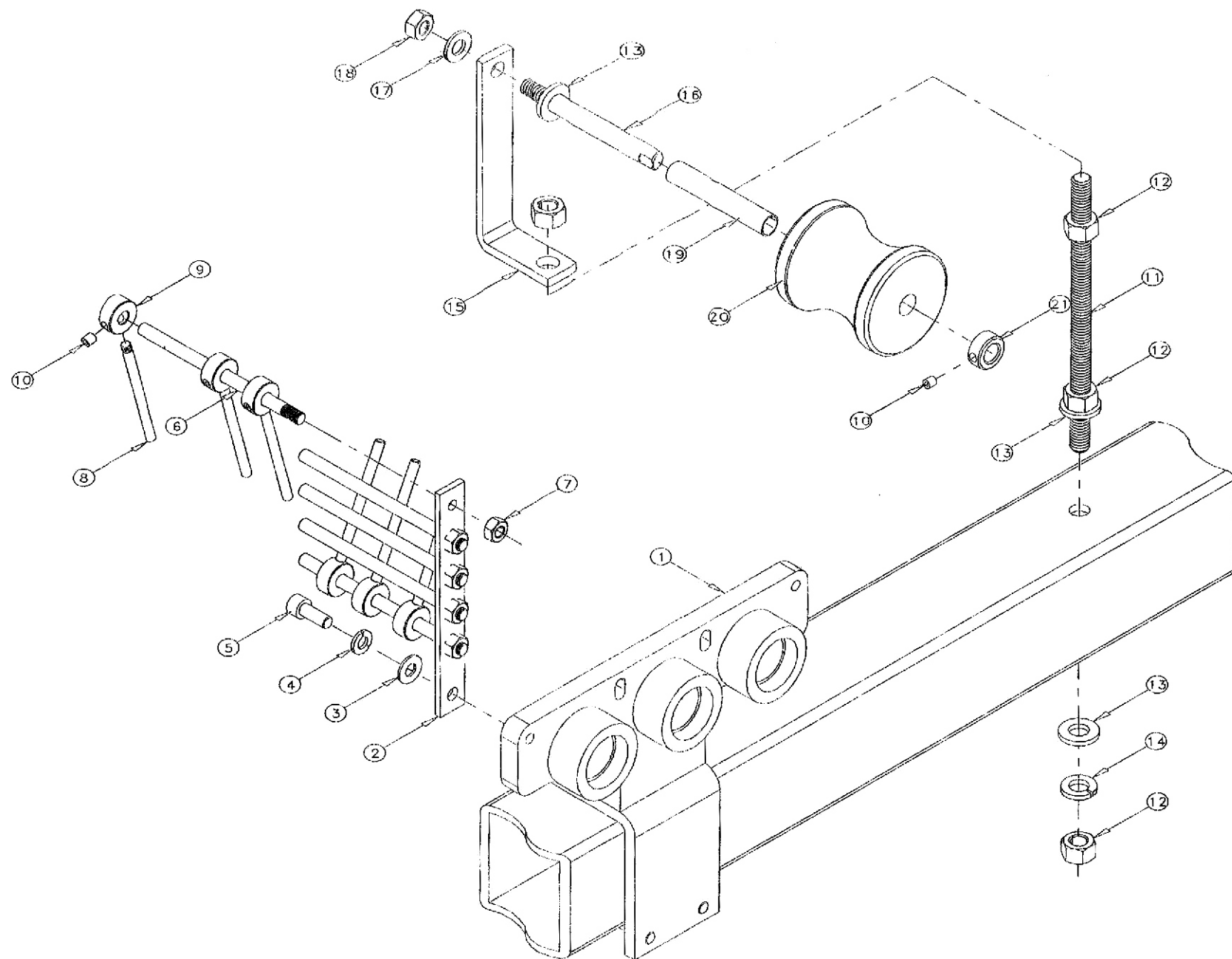
RUBBER DRIVE ASSEMBLY 送胶传动组

XIANGHAI

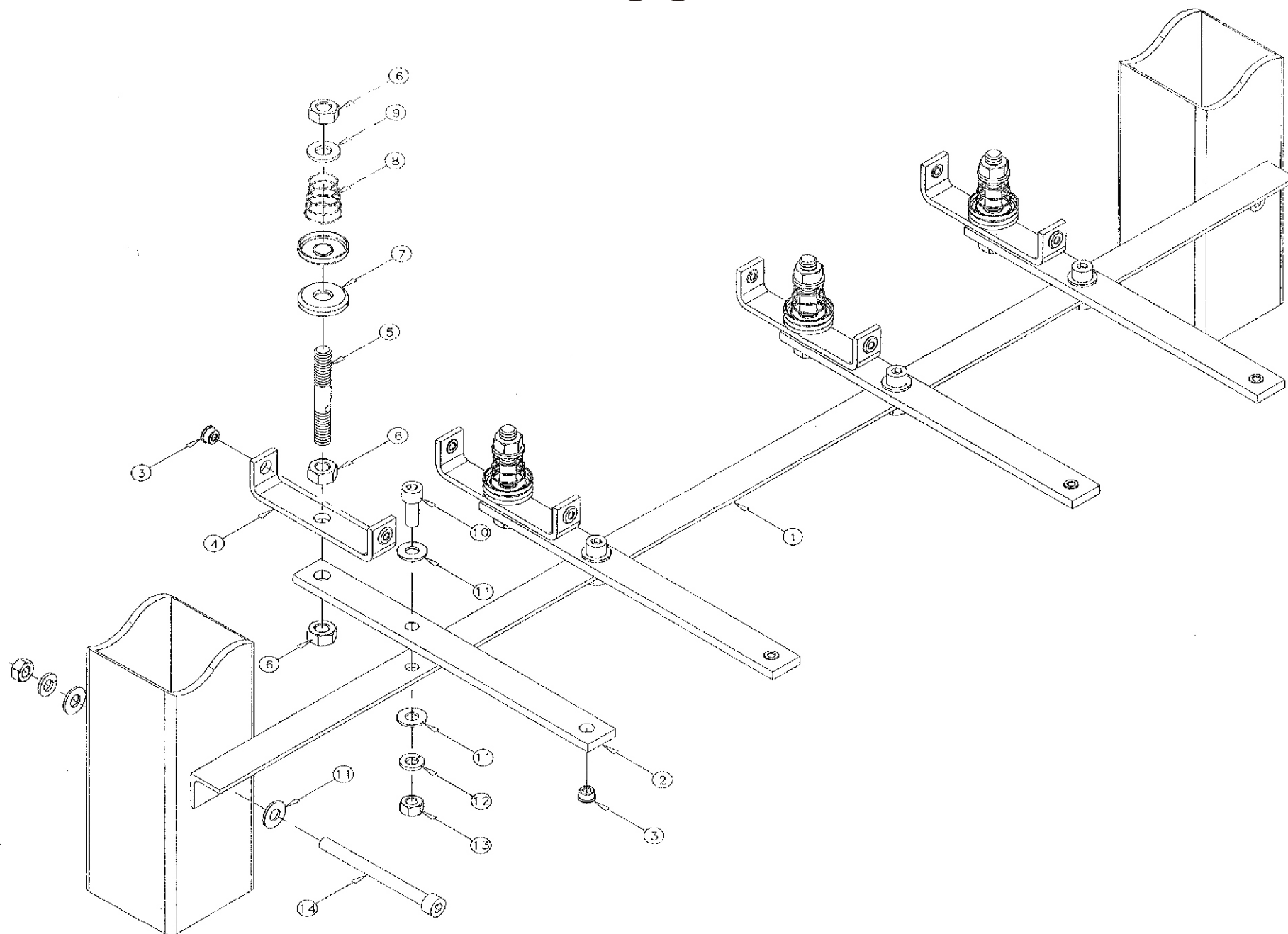
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-A007	HOLDER	调整座	
2	SC-M8*95	SOCKET CAP SCREW	内六角螺丝	
3	WAH-M8	WASHER	平垫片	
4	FHS-A008	HOLDER	送胶传动固定座	
5	SC-M8*25	SOCKET CAP SCREW	内六角螺丝	
6	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
7	FHS-A024%	RUBBER SUPPORT ASSEMBLY	过胶丝架	
8	FHS-A010	PRESSURE ROLLER	滚轮	
9	FHS-A011	PRESSURE ROLLER	滚轮	
10	HBN-6003ZZ	BEARING	轴承	
11	FHS-A006	SPROCKET	链齿轮	
12	SG-M6*6	SOCKET SET SCREW	止付螺丝	
13	SC-M6*10	SOCKET CAP SCREW	内六角螺丝	
14	FHS-A017	WASHER	挡圈	
151	FHS-A013	PRESSURE ROLLER	滚轮	
16	FHS-A012	PRESSURE ROLLER	滚轮	
17	FHS-A015	SPROCKET	链齿轮	
18	FHS-A016	SPROCKET	链齿轮	
19	FHS-A014	SPROCKET	链齿轮	
20	FHS-A018	CLAMP	固定块	
21	SC-M8*45	SOCKET CAP SCREW	内六角螺丝	
22	WAH-M8(8.5* 26.5*3T)	WASHER	大平垫片	
23	FHS-A019	AXLE	固定轴心	
24	SC-M6*20	WOCKET CAP SCREW	内六角螺丝	
25	NUT-M6	NUT	螺母	
26	FHS-A020L	EYELET CLAMP	瓷眼板	
27	WAH-M10	WASHER	平垫片	
28	NUT-M10	NUT	螺母	
29	FHS-A023	EYELET	瓷眼	
30	FHS-A022	EYELET	瓷眼	
31	FHS-A021	EYELET	瓷眼	
32	SC-M8*85	SOCKET CAP SCREW	内六角螺丝	
33	FHS-A009	TUBE	链轮压轮	
34	NUT-M8	NUT	螺母	



ITEM	PART NO.	DESCRIP TION	中文名称	REMARK
1	FHS-A008	HOLDER	送胶传动固定座	
2	FHS-A024	CLAMP	固定块	
3	WAH-M8	WASHER	平垫片	
4	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
5	SC-M8*20	SOCKET CAP SCREW	内六角螺丝	
6	FHS-A025	BAR	导纱杆	
7	NUT-M8	NUT	螺母	
8	FHS-A027	AXLE	间隔轴心	
9	FHS-A026	SPACER RING	间隔套	
10	SG-M6*6	SOCKET SET SCREW	止付螺丝	
11	FHS-A028	SCREW	调整螺杆	
12	NUT-M12	NUT	螺母	
13	WAH-M12	WASHER	平垫片	
14	SW-M12	SPRING LOCK WASHER	弹簧垫圈	
15	FHS-A029	CLAMP	过胶丝固定块	
16	FHS-A030	AXLE	过胶丝轮轴心	
17	WAH-M10	WASHER	平垫片	
18	NUT-M10	NUT	螺母	
19	FHS-A032	OIL BUSHING	油铜	
20	FHS-A031	ROLLER	过胶丝轮	
21	FHS-A033	ADJUSTMENT RING	固定套	



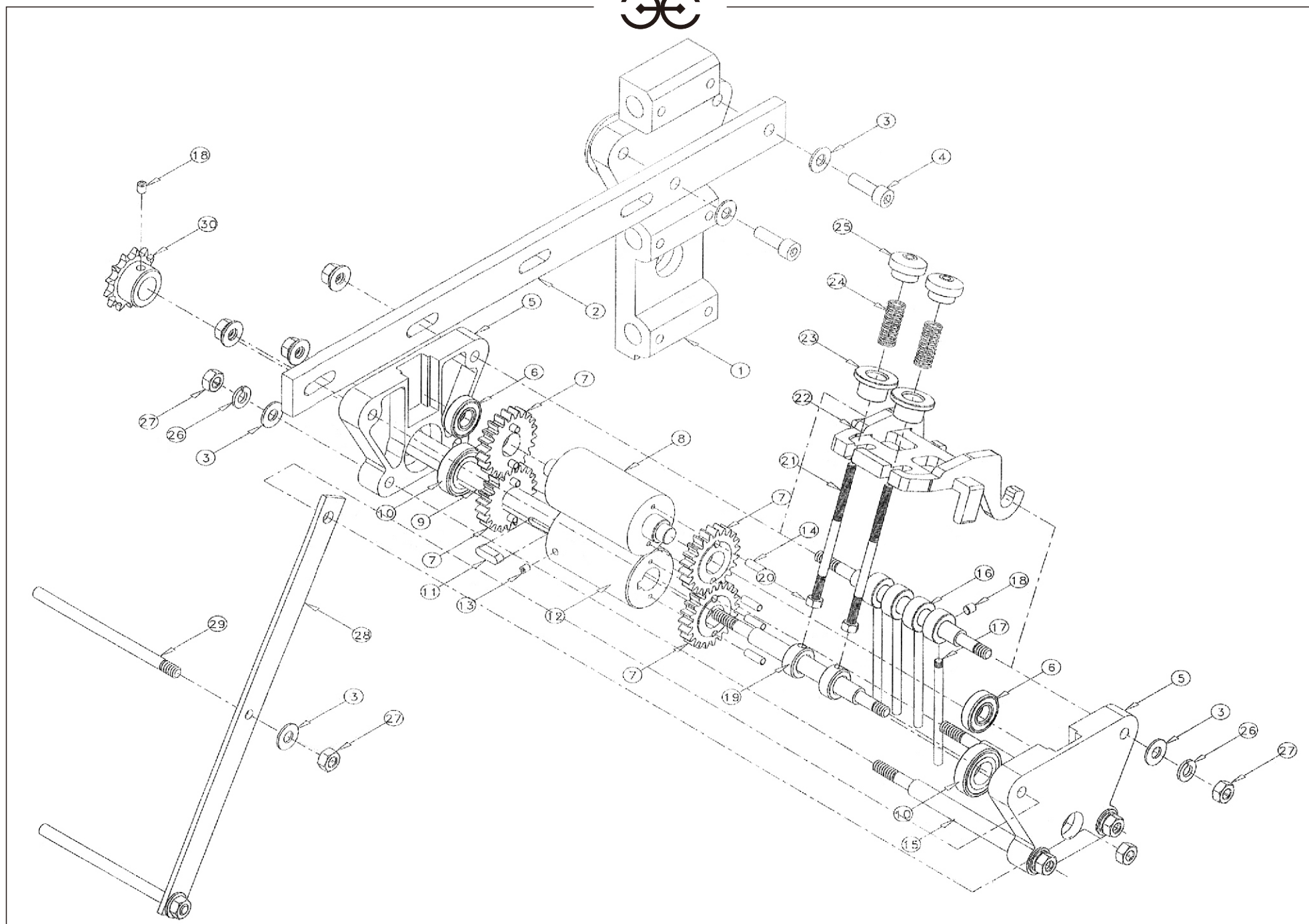
ITEM	PART NO.	DESCRIP TION	中文名称	REMARK
1	FHS-A034	FRAME	支持杆	FHS/16
	FHS-A034A	FRAME	支持杆	FHS/24
	FHS-A034B-48	FRAME	支持杆	FHS/48
	FHS-A034C-32	FRAME	支持杆	FHS/32
2	FHS-A035	CLAMP	固定块	
3	FHD-F008	EYELET	瓷眼	
4	FHS-A036	CLAMP	张力固定块	
5	FHS-A037	HOLDING ROD	张力支持杆	
6	NUT-M10	NUT	螺母	
7	FH-M10-104	PIECE	调整铁片	
8	FH-M10-106	SPRING	调整弹簧	
9	WAH-M10	WASHER	平垫片	
10	SC-M8*20	SOCKET CAP SCREW	内六角螺丝	
11	WAH-M8	WASHER	平垫片	
12	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
13	NUT-M8	NUT	螺母	
14	SC-M8*90	SOCKET CAP SCREW	内六角螺丝	



TAKE OFF ROLLER ASSEMBLY 出带滚轮组

XIANGHAI

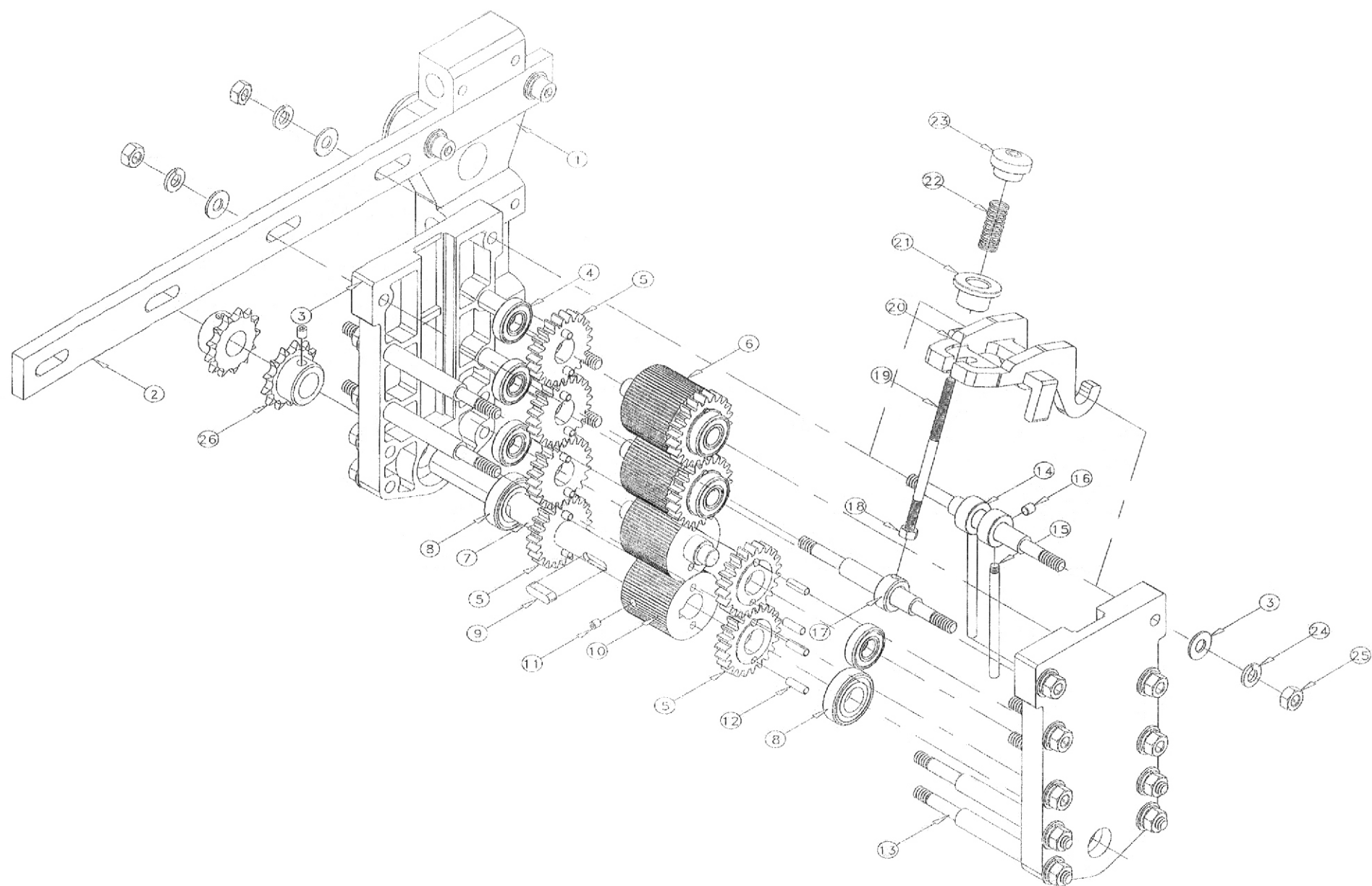
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-B016	BRACKET SUPPORT	支撑块	
2	FHS-B014	CLAMP	固定块	
3	WAH-M8	WASHER	平垫片	
4	SC-M8*25	SOCKET CAP SCREW	内六角螺丝	
5	FHS-B001	CLAMP	固定块	
6	HBN-6001ZZ	BEARING	轴承	
7	FHS-B010	GEAR	收带正齿轮	
8	FHS-B011	TAKE-OFF ROLLER	拉带轮	FHS/16
	FHS-B011A	TAKE-OFF ROLLER	拉带轮	FHS24/48/32
9	FHS-B013	GEAR SHAFT	传动轴心	FHS/16
	FHS-B013A	GEAR SHAFT	传动轴心	FHS24/48/32
10	HBN-6003ZZ	BEARING	轴承	
11	KEY-B6*20	KEY	双圆键	
12	FHS-B012	TAKE-OFF ROLLER	拉带轮	FHS/16
	FHS-B012A	TAKE-OFF ROLLER	拉带轮	FHS24/48/32
13	SG-M5*5	SOCKET SET SCREW	止付螺丝	
14	Φ5*15	SPRING PIN	弹簧销	
15	FHS-B002	HOLDING ROD	支持杆	FHS/16
	FHS-B002A	HOLDING ROD	支持杆	FHS24/48/32
16	FHS-B007	SPACER RING	间隔套	
17	FHS-B008	SPACER ROD	间隔轴心	
18	SG-M6*6	SOCKET CAP SCREW	止付螺丝	
19	FHS-A033	CLAMP RING	固定套	
20	NUT-M6	NUT	螺母	
21	FHS-B003	SCREW	调整杆	
22	FHS-B009	CLAMP	压块	FHS/16
	FHS-B009A	CLAMP	压块	FHS/24/48/32
23	FHS-B004	TUBE	轴套	
24	FHS-B006	SPRING	压缩弹簧	
25	FHS-B005	NUT	锁紧套	
26	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
27	NUT-M8	NUT	螺母	
28	FHS-B015	CLAMP	固定块	
29	FHS-A025	BAR	导纱杆	
30	FHS-A006	SPROCKET	链齿轮	



TAKE OFF ROLLER ASSEMBLY 出带滚轮组

XIANGHAI

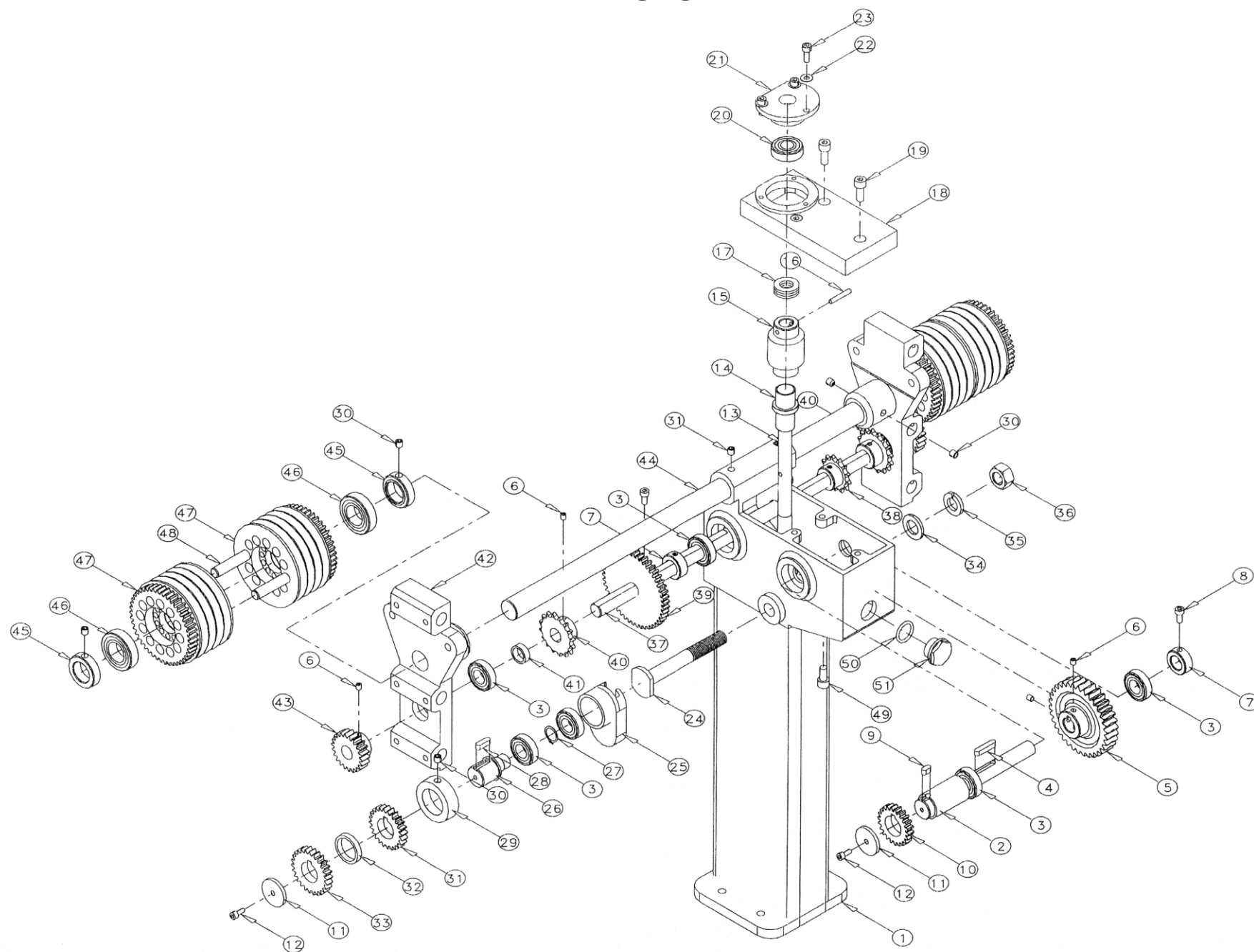
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-B016	BRACKET SUPPORT	支撑块	FHS24/48/32专用
2	FHS-B014	CLAMP	固定块	
3	FHS-B001	CLAMP	固定块	
4	HBN-6001ZZ	BEARING	轴承	
5	FHS-B010	GEAR	收带正齿轮	
6	FHS-B011A-1	TAKE-OFF ROLLER	拉带轮	
7	FHS-B013A	GEAR SHAFT	传动轴心	
8	HBN-6003ZZ	BEARING	轴承	
9	KEY-B6*20	KEY	双圆键	
10	FHS-B012A-1	TAKE-OFF ROLLER	拉带轮	
11	SG-M5*5	SOCKET SET SCREW	止付螺丝	
12	Φ5*15	SPRING PIN	弹簧销	
13	FHS-B002A	HOLDING ROD	支持杆	
14	FHS-B007	SPACER RING	间隔套	
15	FHS-B008	SPACER ROD	间隔轴心	
16	SG-M6*6	SOCKET CAP SCREW	止付螺丝	
17	FHS-A033	CLAMP RING	固定套	
18	NUT-M6	NUT	螺母	
19	FHS-B003	SCREW	调整杆	
20	FHS-B009A	CLAMP	压块	
21	FHS-B004	TUBE	轴套	
22	FHS-B006	SPRING	压缩弹簧	
23	FHS-B005	NUT	锁紧套	
24	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
25	NUT-M8	NUT	螺母	
28	FHS-A006	SPROCKET	链齿轮	



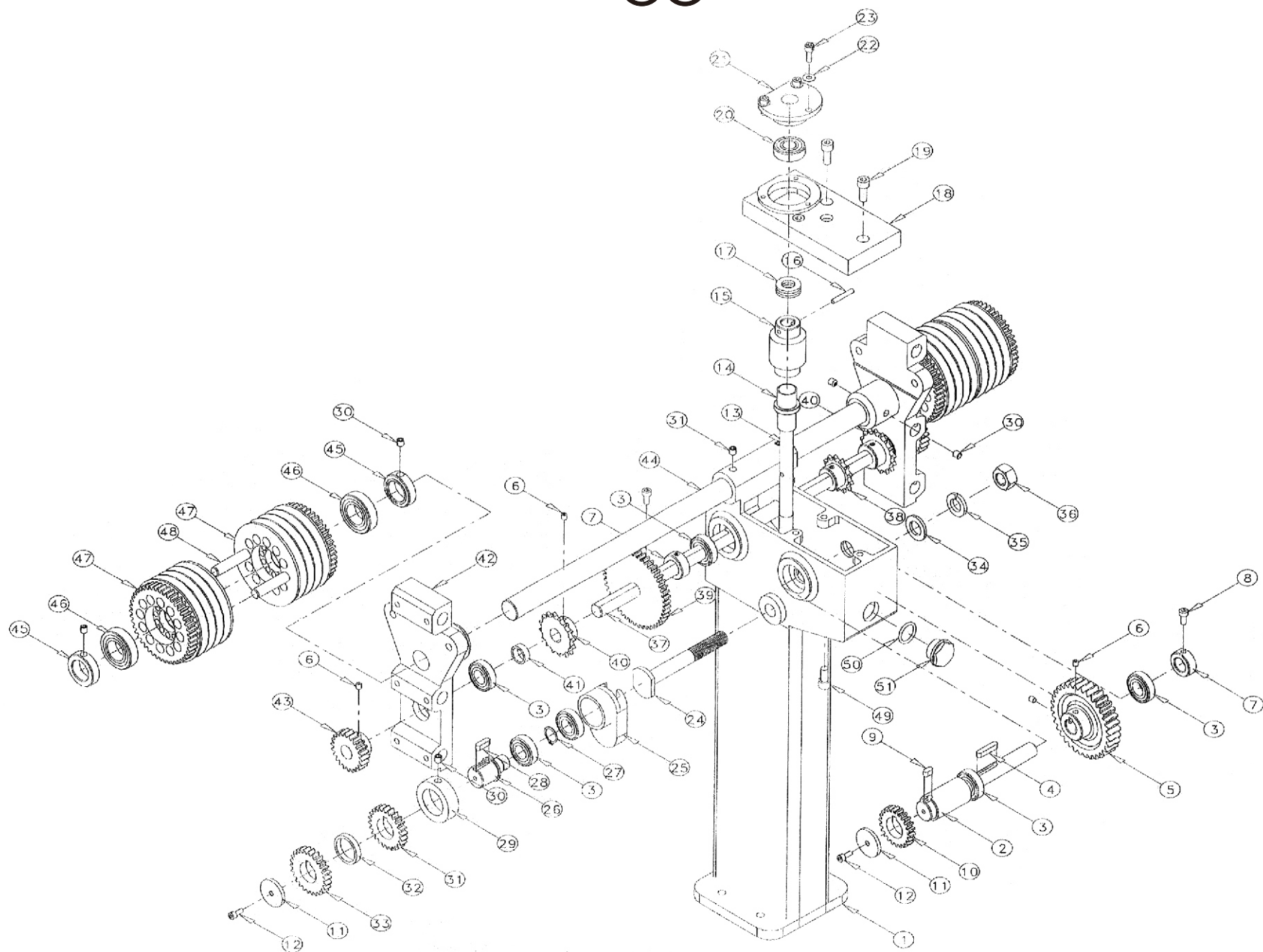
GEAR ASSEMBLY 纬密齿轮组

XIANGHAI

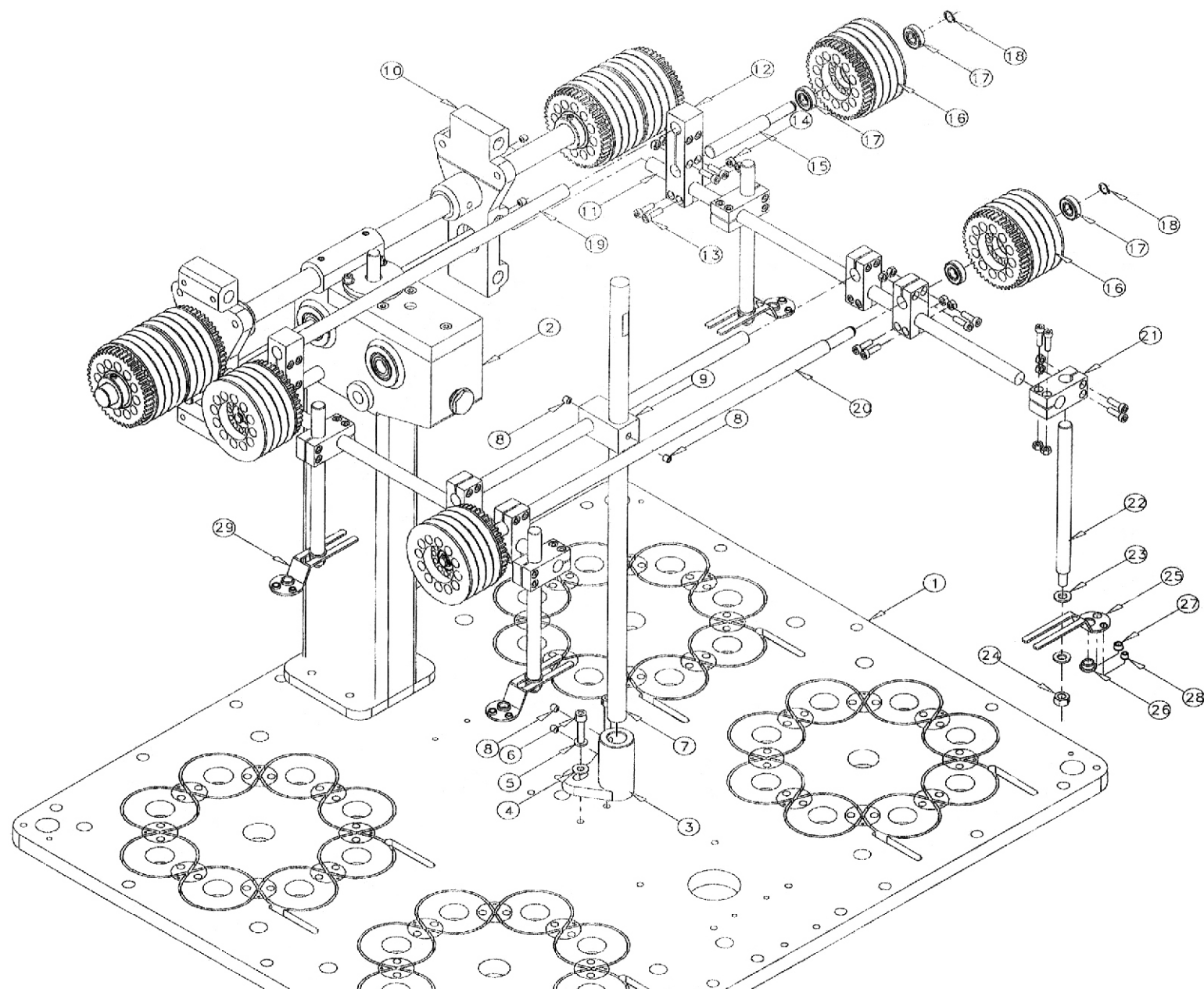
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-C001	WHEELBOX	蜗轮箱	
2	FHS-C009	AXLE	传动轴心	
3	HBN-6003ZZ	BEARING	轴承	
4	KEY-B6*30	KEY	双圆键	
5	FHS-C012	WORM WHEEL	蜗轮	
6	SG-M6*6	SOCKET SET SCREW	止付螺丝	
7	FHS-A005	SPACER RING	间隔套	
8	SC-M6*12	SOCKET CAP SCREW	内六角螺丝	
9	KEY-B6*12	KEY	双圆键	
10	FHS-C013	GEAR	正齿轮	
11	FHS-C028	WASHER	垫片	
12	SC-M5*12	SOCKET CAP SCREW	内六角螺丝	
13	FHS-C010	AXLE	蜗杆轴心	
14	FHS-C001-1	TUBE	轴套	
15	FHS-C011	WORM	蜗杆	
16	Φ5*30	SPRING PING	弹簧销	
17	HBN-51102	BEARING	轴承	
18	FHS-C002	COVER	蜗轮箱盖	
19	SC-M8*20	SOCKET CAP SCREW	内六角螺丝	
20	HBN-6202-2RS	BEARING	轴承	
21	FHS-C003	BEARING BUSHING	轴承套	
22	WAH-M6	WASHER	平垫片	
23	SC-M6*16	SOCKET CAP SCREW	内六角螺丝	
24	FHS-C026	SCREW	固定螺杆	
25	FHS-C024	BASE/GEAR	托座	
26	FHS-C027	AXLE	齿轮轴心	
27	S-17	RETAINING RING (EXTERNAL)	轴用扣环	
28	KEY-B6*20	KEY	双圆键	
29	FHS-C025	CLAMP RING	固定套	
30	SG-M8*8	SOCKET SET SCREW	止付螺丝	
31	FHS-014	GEAR	正齿轮	
32	FHS-C023	SPACER RING	间隔套	



ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
33	FHS-C015	GEAR	正齿轮	
34	WAH-M16	WASHER	平垫片	
35	SW-M16	SPRING LOCK WASHER	弹簧垫片	
36	NUT-M16	NUT	螺母	
37	FHS-C004	AXLE	轴心	FHS/16
	FHS-C004A	AXLE	轴心	FHS/24
	FHS-C004B-48	AXLE	轴心	FHS/48
	FHS-C004C-32	AXLE	轴心	FHS/32
38	FHS-A006	SPROCKET	链齿轮	
39	FHS-C006	GEAR	齿轮	
40	FHS-A014	SPROCKET	链齿轮	
41	FHS-C008	CLAMP RING	固定套	
42	FHS-B016	SUPPORT	支撑块	
43	FHS-C005	GEAR	齿轮	
44	FHS-B017	AXLE	轴心	FHS/16/48
	FHS-B017A	AXLE	轴心	FHS/24
	FHS-B017C-32	AXLE	轴心	FHS/32
45	FHS-B018	SPACER RING	间隔套	
46	HBN-6005ZZ	BEARING	轴承	
47	FHS-B019	ROLLER	出带轮	
48	Φ12*80	PIN	实心销	
49	SC-M8*16	SOCKET CAP SCREW	内六角螺丝	
50	FHS-C001-2	O-RING	密封圈	
51	FHS-C001-3	OIL INDICATER	油镜	

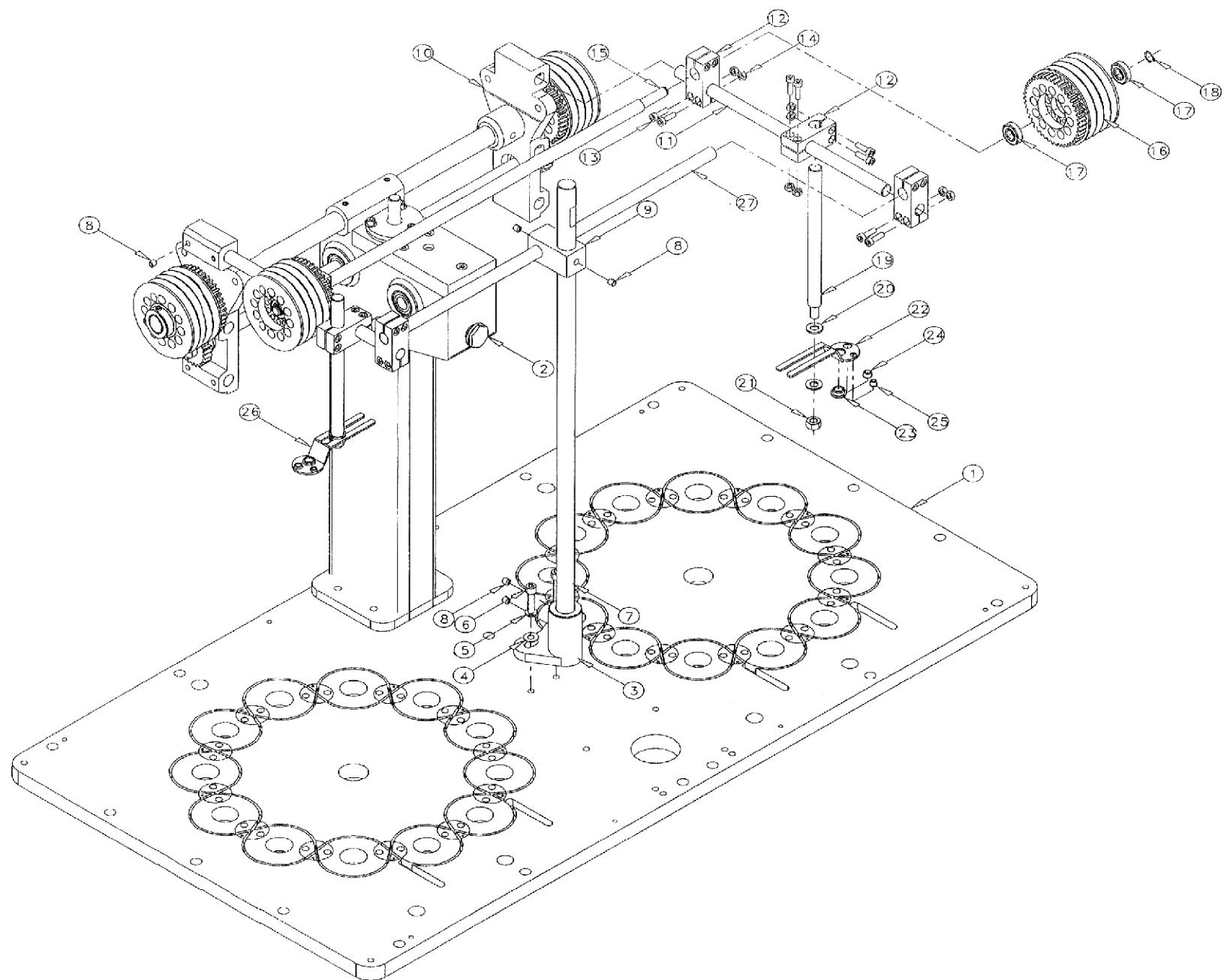


ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-D020	TRACK PLATE	跑道板	FHS/16专用
2	FHS-C001	WHEELBOX	蜗轮箱	
3	FHS-B025	CLAMP	固定块	
4	WAH-M8	WASHER	平垫片	
5	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
6	SC-M8*35	SOCKET CAP SCREW	内六角螺丝	
7	FHS-B027	AXLE	固定轴心	
8	SG-M8*8	SOCKET SET SCREW	止付螺丝	
9	FHS-B026	CLAMP	固定块	
10	FHS-B016	BRACKET SUPPORT	支撑块	
11	FHS-B020	AXLE	固定轴心	
12	FHS-A018-1	CLAMP	固定块	
13	SC-M6*20	SOCKET CAP SCREW	内六角螺丝	
14	NUT-M6	NUT	螺母	
15	FHS-B023	AXLE	带轮轴心	
16	FHS-B019	ROLLET	出带轮	
17	HBN-6001ZZ	BEARING	轴承	
18	S-12	RETAINING RING (EXTERNAL)	轴用扣环	
19	FHS-B021	AXLE	固定轴心	
20	FHS-B022	AXLE	固定轴心	
21	FHS-A018	CLAMP	固定块	
22	FHS-A019-1	AXLE	固定轴心	
23	WAH-M10	WASHER	平垫片	
24	NUT-M10	NUT	螺母	
25	FHS-A020L	EYELET CLAMP	瓷眼板	
26	FHS-A023	EYELET	瓷眼	
27	FHS-A022	EYELET	瓷眼	
28	FHS-A021	EYELET	瓷眼	
29	FHS-A020R	EYELET CLAMP	瓷眼板	



SUPPOPT FRAME ASSEMBLY 出带支撑架组FHS24/32**XIANGHAI**

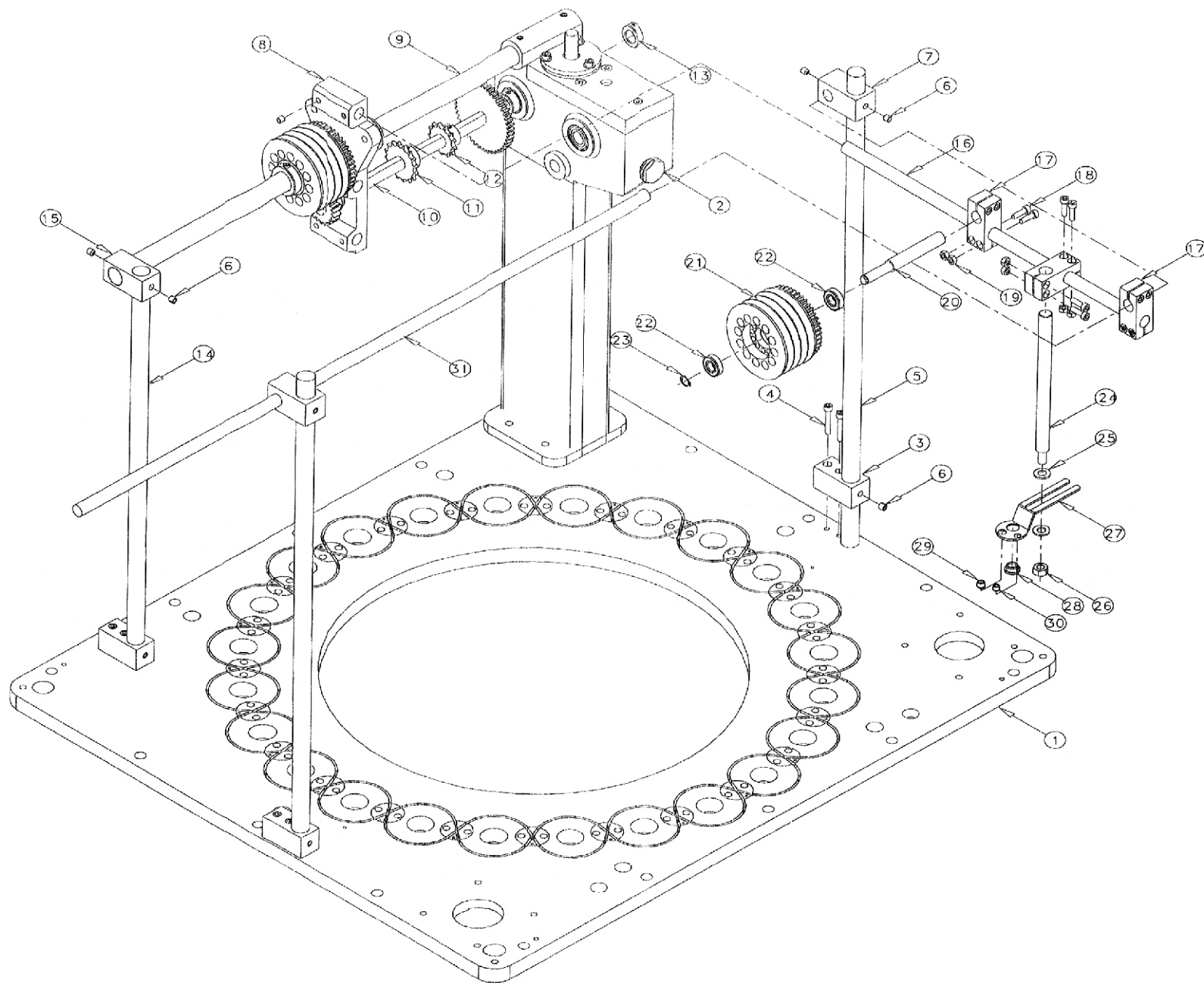
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-D020	TRACK PLATE	跑道板	FHS/24
	FHS-D020C-32	TRACK PLATE	跑道板	FHS/32
2	FHS-C001	WHEELBOX	蜗轮箱	
3	FHS-B025	CLAMP	固定块	
4	WAH-M8	WASHER	平垫片	
5	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
6	SC-M8*35	SOCKET CAP SCREW	内六角螺丝	
7	FHS-B027A	AXLE	固定轴心	FHS24/32
8	SG-M8*8	SOCKET SET SCREW	止付螺丝	
9	FHS-B026	CLAMP	固定块	
10	FHS-B016	BRACKET SUPPORT	支撑块	
11	FHS-B020A	AXLE	固定轴心	FHS/24
	FHS-B020C-32	AXLE	固定轴心	FHS/32
12	FHS-A018	CLAMP	固定块	
13	SC-M6*20	SOCKET CAP SCREW	内六角螺丝	
14	NUT-M6	NUT	螺母	
15	FHS-B022A	AXLE	固定轴心	FHS/24
	FHS-B022C-32	AXLE	固定轴心	FHS/32
16	FHS-B019	POLLET	出带轮	
17	HBN-6001ZZ	BEARING	轴承	
18	S-12	RETAINING RING(EXTERNAL)	轴用扣环	
19	FHS-A019-1	AXLE	固定轴心	
20	WAH-M10	WASHER	平垫片	
21	NUT-M10	NUT	螺母	
22	FHS-A020L	EYELET CLAMP	瓷眼板	
23	FHS-A023	EYELET	瓷眼	
24	FHS-A022	EYELET	瓷眼	
25	FHS-A021	EYELET	瓷眼	
26	FHS-A020R	EYELET CLAMP	瓷眼板	
27	FHS-B021A	AXLE	固定轴心	FHS/24
	FHS-B021C-32	AXLE	固定轴心	FHS/32



SUPPORT FRAME ASSEMBLY 出带支撑架组FHS48

XIANGHAI

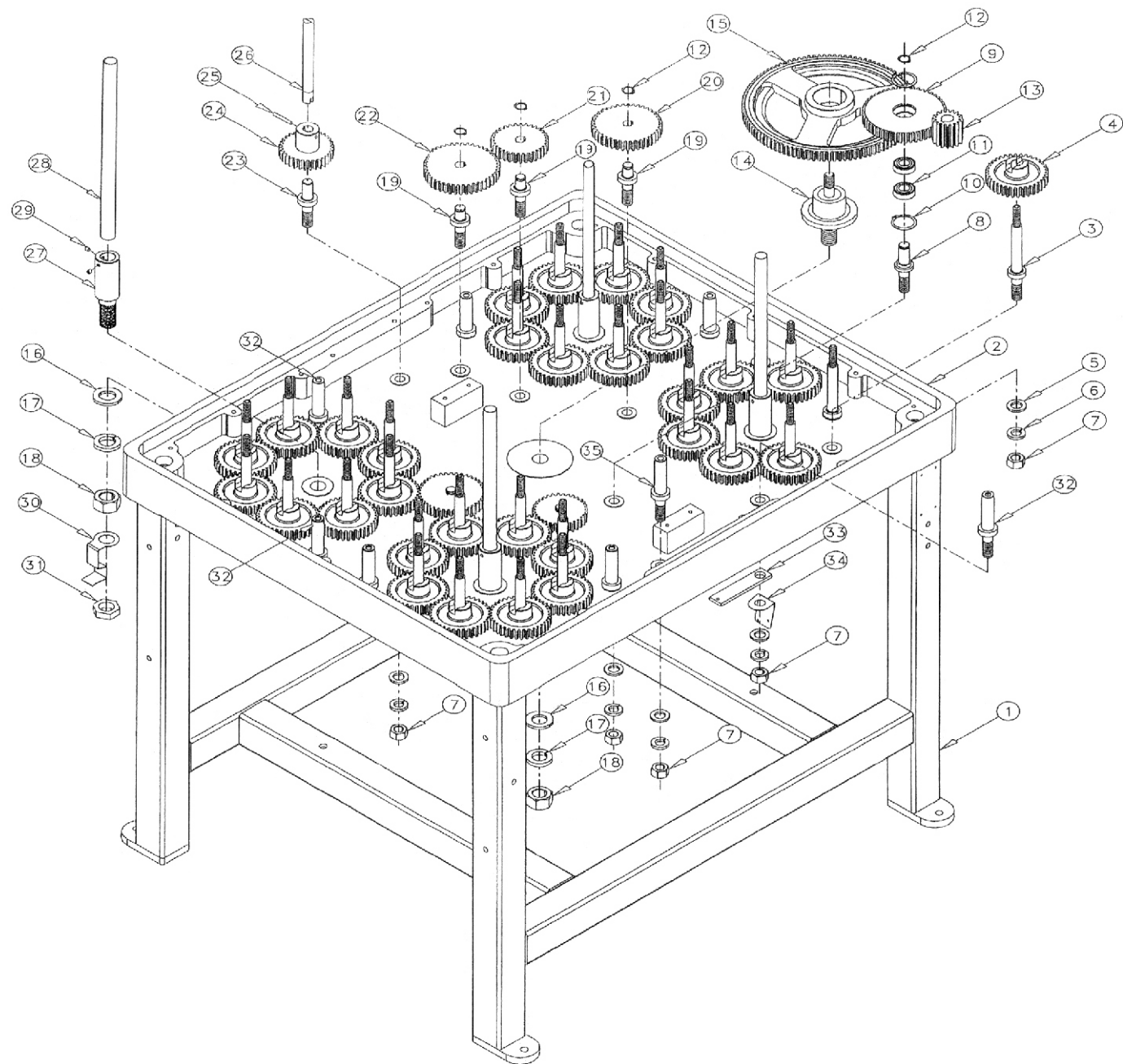
ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-D020	TRACK PLATE	跑道板	FHS/48专用
2	FHS-C001	WHEELBOX	蜗轮箱	
3	FHS-G003	CLAMP	固定块	
4	SC-M6*35	SOCKET CAP SCREW	内六角螺丝	
5	FHS-B027A	AXLE	固定轴心	
6	SG-M8*8	SOCKET SET SCREW	止付螺丝	
7	FHS-G001	CLAMP	固定块	
8	FHS-B016	BRACKET SUPPORT	支撑块	
9	FHS-B017	AXLE	轴心	
10	FHS-C004B-48	AXLE	固定轴心	
11	FHS-A014	SPROCKET	链齿轮	
12	FHS-A006	SPROCKET	链齿轮	
13	FHS-A005	SPACER RING	间隔套	
14	FHS-G002	AXLE	支撑轴心	
15	FHS-G005	AXLE	轴心	
16	FHS-B020B-48	AXLE	固定轴心	
17	FHS-A018	CLAMP	固定块	
18	SC-M6*20	SOCKET CAP SCREW	内六角螺丝	
19	NUT-M6	NUT	螺母	
20	FHS-B023	AXLE	带轮轴心	
21	FHS-B019	POLLET	出带轮	
22	HBN-6001ZZ	BEARING	轴承	
23	S-12	RETAINING RING(EXTERNAL)	轴用扣环	
24	FHS-A019-1	AXLE	固定轴心	
25	WAH-M10	WASHER	平垫片	
26	NUT-M10	NUT	螺母	
27	FHS-A020L	EYELET CLAMP	瓷眼板	
28	FHS-A023	EYELET	瓷眼	
29	FHS-A022	EYELET	瓷眼	
30	FHS-A021	EYELET	瓷眼	
31	FHS-B022B-48	AXLE	轴心	



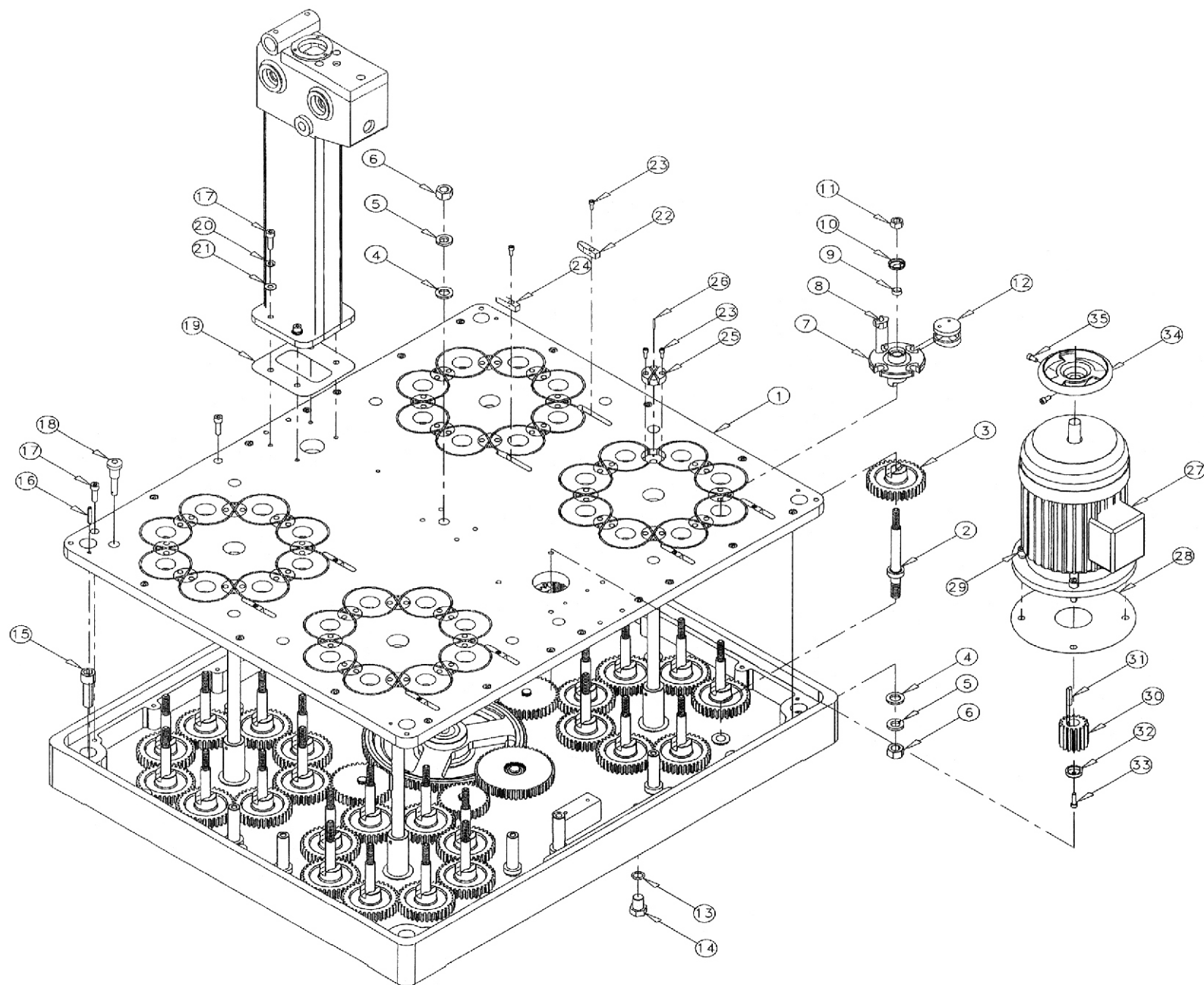
MAIN GEAR ASSEMBLY 主体传动齿轮组

XIANGHAI

ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-D002	BASE	基脚	
2	FHS-D001	BASE	基座	
3	FHS-D011	AXLE	轴心	
4	FHS-D006	GEAR	正齿轮	
5	WAH-M16	WASHER	平垫片	
6	SW-M16	SPRING LOCK WASHER	弹簧垫片	
7	NUT-M16	NUT	螺母	
8	FHS-D016	AXLE	轴心	
9	FHS-D004	GEAR	双联齿轮	
10	R-35	RETAINING RING(INTERNAL)	孔用扣环	
11	HBN-6003ZZ	BEARING	轴承	
12	S-16	RETAINING RING(EXTERNAL)	轴用扣环	
13	FHS-D005	GEAR	变位齿轮	
14	FHS-D017	AXLE	齿轮轴心	
15	FHS-D003	GEAR	正齿轮	
16	WAH-M24	WASHER	平垫片	
17	SW-M24	SPRING LOCK WASHER	弹簧垫片	
18	NUT-N24	NUT	螺母	
19	FHS-D014	AXLE	轴心	
20	FHS-D008	GEAR	正齿轮	
21	FHS-D009	GEAR	正齿轮	
22	FHS-D007	GEAR	正齿轮	
23	FHS-D015	AXLE	轴心	
24	FHS-D010	GEAR	正齿轮	
25	5*35	PIN	实心销	
26	FHS-C010	AXLE	蜗杆轴心	
27	FHS-D012	AXLE	固定轴心	
28	FHS-D013	TUBE	过胶丝轴	
29	SG-M6*6	SOCKET SET SCREW	止付螺丝	
30	FHS-E026	BRACKET SUPPORT	断线开关固定板	
31	FHS-D012-1	NUT	螺母	
32	FHS-D018	AXLE	停电杆支持轴心	
33	FHS-E030	AXLE	停电弹簧固定板	
34	FHS-E025	BRACKET SUPPORT	开关固定块	
35	FHS-D019	AXLE	过电源线轴心	

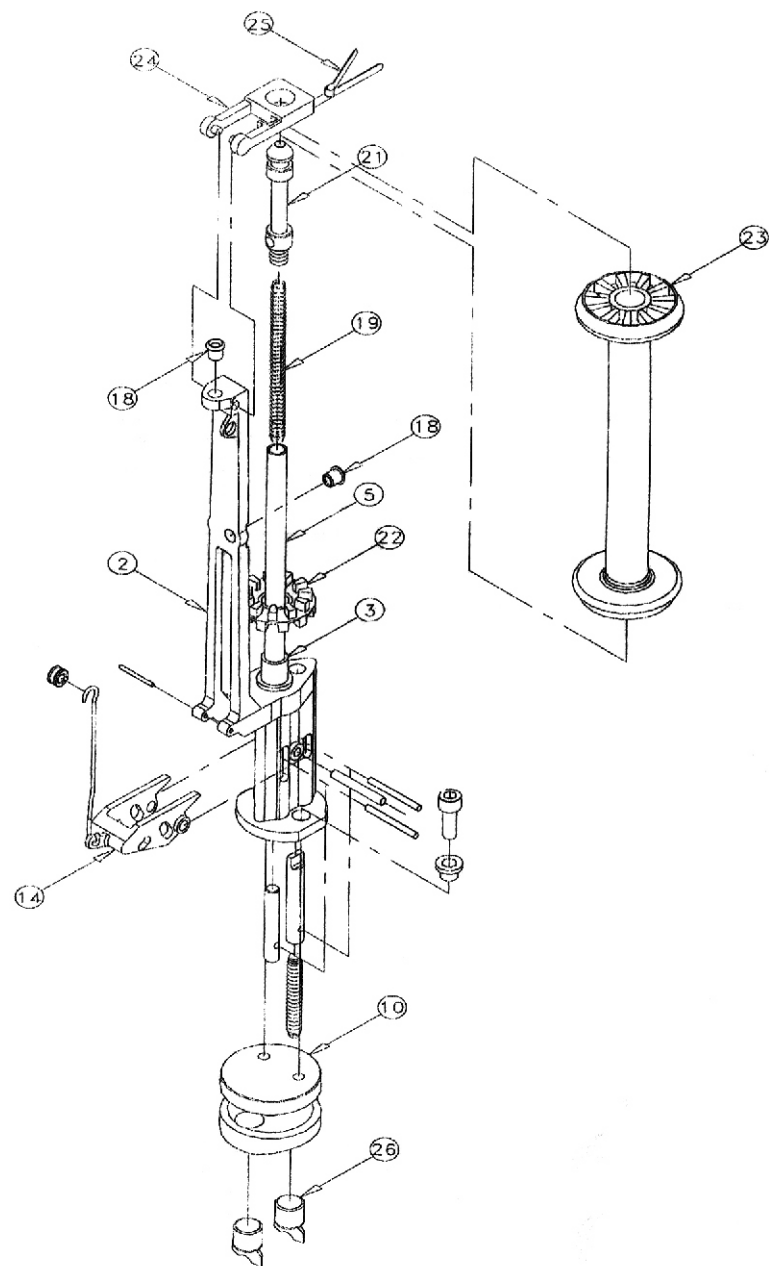
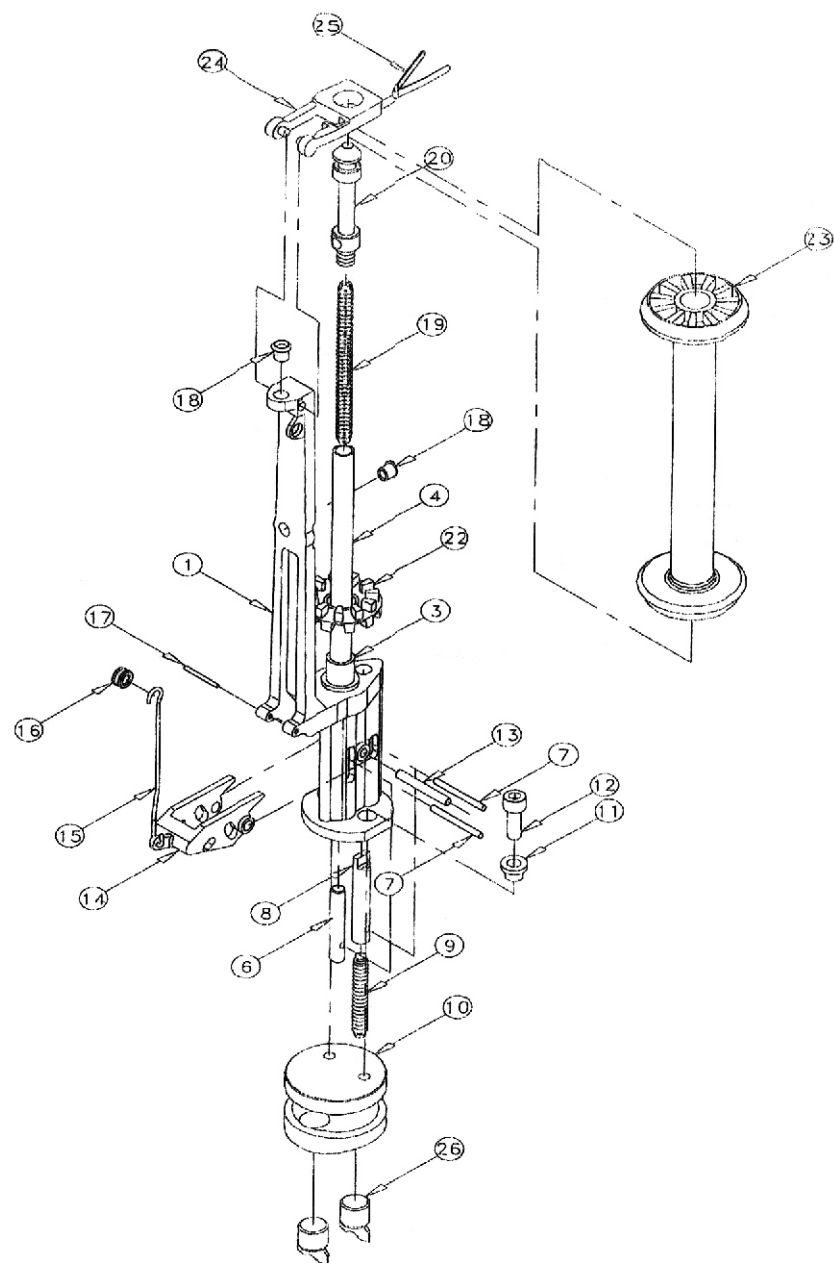


ITEM	PART NO.	DESCRIP TION	中文名称	REMARK
1	FHS-D020	TRACK PLATE	跑道板	
2	FHS-D011	AXLE	轴心	
3	FHS-D006	GEAR	正齿轮	
4	WAH-M16	WASHER	平垫片	
5	SW-M16	SPRING LOCK WASHER	弹簧垫圈	
6	NUT-M16	NUT	螺母	
7	FHS-D022	ROTOR	转子	
8	FHS-D022-1	ROTOR-TUBE	转子尼龙垫	
9	FHS-D021-1	SPACER RING	间隔套	
10	FHS-D021	WASHER	垫片	
11	NUT-M12	NUT	螺母	
12	FHS-E007	CLAMP	走马铰固定座	
13	FHS-D026	O-RING	密封圈	
14	SH-M18*20	HEXAGON HEAD BOLT	外六角螺丝	
15	SC-M16*50	SOCKET CAP SCREW	内六角螺丝	
16	Φ6*30	SPRING PIN	弹簧销	
17	SC-M8*25	SOCKET CAP SCREW	内六角螺丝	
18	FHS-E023	PLANIMETER	测油针	
19	FHS-D025	WASHER	石棉垫	
20	SW-M8	SPRING LOCK WASHER	弹簧垫圈	
21	WAH-M8	WASHER	平垫片	
22	FHS-D020-1R	BAFFLE	挡块——右	
23	SC-M5*12	SOCKET CAP SCREW	内六角螺丝	
24	FHS-D020-1L	BAFFLE	挡块——左	
25	FHS-D020-2	TRACT PLATE--MODULE	跑道板组件	
26	Φ3*20	SPRING PIN	弹簧销	
27	MOTOT 1HP 4P 220V	MOTOR	马达	
28	FHS-D024	WASHER	石棉垫	
29	SC-M10*30	SOCKET CAP SCREW	内六角螺丝	
30	FHS-D005	GEAR	变位齿轮	
31	KET-B6*30	KEY	半圆键	
32	FH-B10*203	WASHER	垫片	
33	SC-M6*20	SOCKET CAP SCREW	内六角螺线	
34	FHS-D027	HANDWHEEL	手转轮	
35	SC-M6*12	SOCKET CAP SCREW	内六角螺丝	

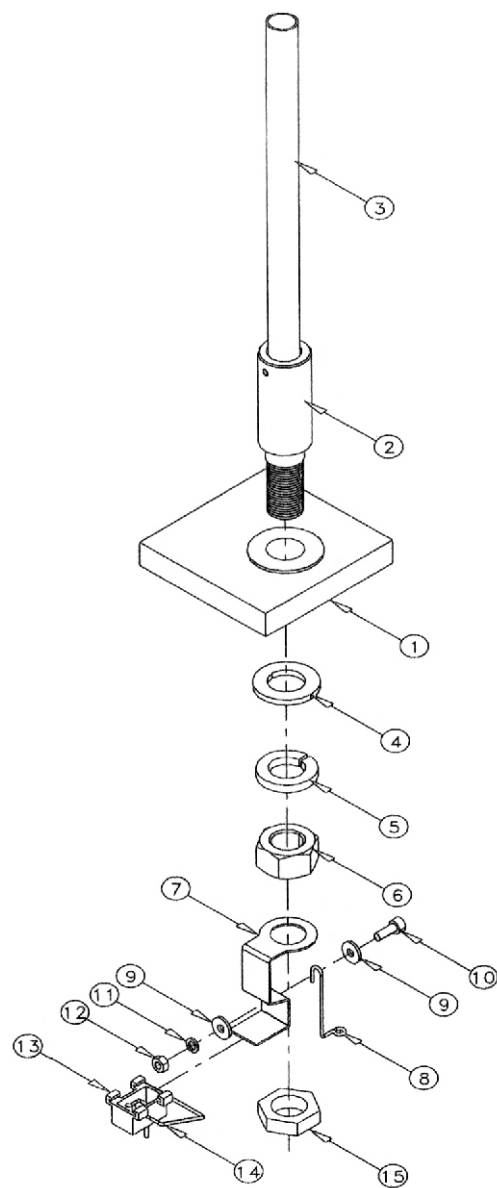


BOBBIN—HOLDER ASSEMBLY 走马锭组**XIANGHAI**

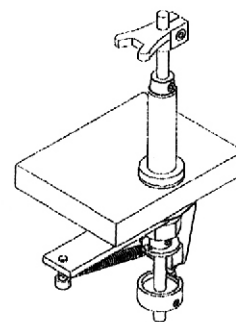
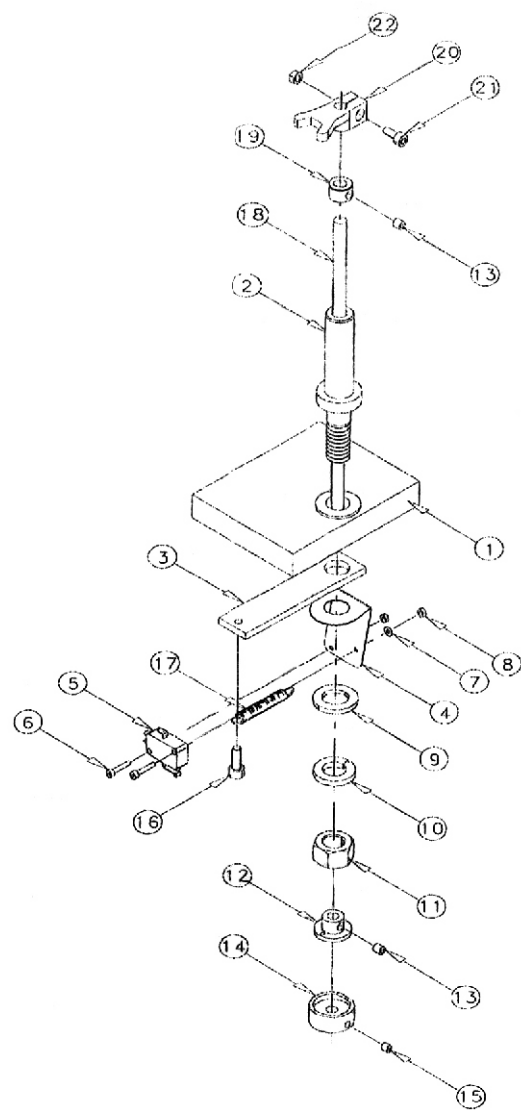
ITEM	PART NO.	DESCRIP TION	中文名称	REMARK
1	FHS-E001L	BOBBIN--HOLDER (GREEN)	走马锭—绿色	
2	FHS-E001R	BOBBIN--HOLDER (RED)	走马锭—红色	
3	FHS-E008	TUBE	离合套	
4	FHS-E008L	ROD	固定杆——左	
5	FHS-E008R	ROD	固定杆——右	
6	FHS-E009	SPRING ROD	弹簧顶起杆	
7	Φ 3*30	SPRING PIN	弹簧销	
8	FHS-E010	CONTROL ROD	控制杆	
9	FHS-E014	SPRING	压缩弹簧	
10	FHS-E007	CLAMP	走马锭固定座	
11	FHS-E011	WASHER	垫圈	
12	SC-M6*16	SOCKET CAP SCREW	内六角螺丝	
13	Φ 4*30	SPRING PIN	弹簧销	
14	FHS-E002	CLAMP	控制扣	
15	FHS-E016	HOOK	铁钩	
16	FHS-E016-1	EYELET	瓷眼	
17	Φ 2*20	SPRING PIN	弹簧销	
18	FHS-E013	EYELET	瓷眼	
19	FHS-E017	SPRING	压缩弹簧	
20	FHS-E006L	CONTROL ROD	固定杆	
21	FHS-E006R	CONTROL ROD	固定杆	
22	FHS-E005	CLUTCH	离合套	
23	FHS-E015	BOBBIN	纱管	
24	FHS-E004	CLAMP	防脱扣	
25	FHS-E031	CLIP	卡子	
26	FHS-D023	SPNDLE	锭子	

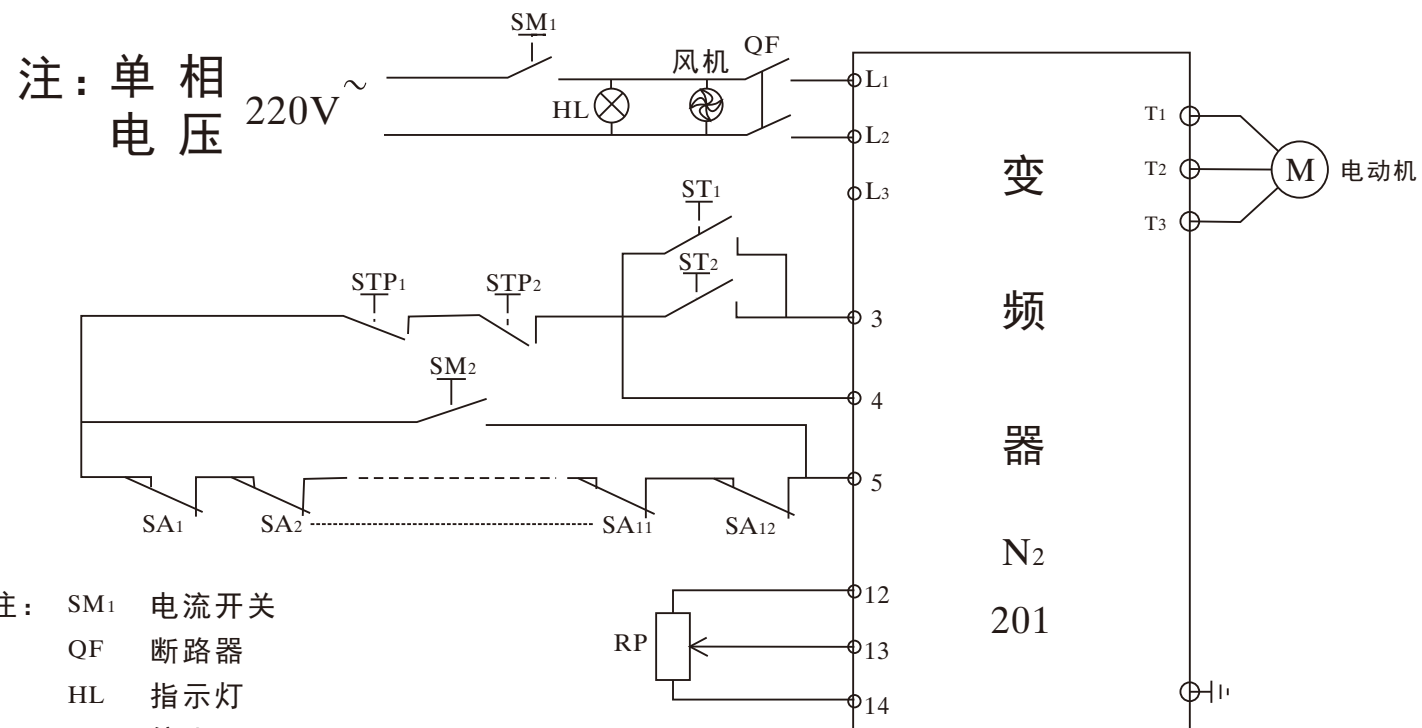


ITEM	PART NO.	DESCRIP TION	中文名称	REMARK
1	FHS-D001	BASE	基座	
2	FHS-D012	AXLE	固定轴心	
3	FHS-D013	TUBE	过胶丝轴	
4	WAH-M24	WASHER	平垫片	
5	SW-M24	SPRING LOCK WASHER	弹簧垫圈	
6	NUT-M24	NUT	螺母	
7	FHS-E026	BRACKET SUPPORT	断线开关固定板	
8	FHS-E028	STEEL WIRE	导线钢丝	
9	WAH-M6	WASHER	平垫片	
10	SC-M6*16	SOCKET CAP SCREW	内六角螺丝	
11	SW-M6	SPRING LOCK WASHER	弹簧垫圈	
12	NUT-M6	NUT	螺母	
13	FHS-E027	BRACKET SUPPORT	断线开关固定合	
14	FHS-E029	STEEL WIRE	停电铁丝	
15	FHS-D012-1	NUT	螺母	



ITEM	PART NO.	DESCRIPTION	中文名称	REMARK
1	FHS-D001	BASE	底座	
2	FHS-D018	AXLE	停电杆支持轴心	
3	FHS-E030	BRACKET SUPPORT	停电弹簧固定板	
4	FHS-E025	BRACKET SUPPORT	开关固定板	
5	SW	SWITCH	停电限位开关	
6	SC-M3*16	SOCKET CAP SCREW	内六角螺丝	
7	WAH-M3	WASHER	平垫片	
8	NUT-M3	NUT	螺母	
9	WAH-M16	WASHER	平垫片	
10	SW-M16	PRING LOCK WASHER	弹簧垫圈	
11	NUT-M16	NUT	螺母	
12	FHS-E022	ADJUSTMENT RING	弹簧固定套	
13	SG-M6*6	SOCKET SET SCREW	止付螺丝	
14	FHS-E021	IDLER	开关导轮	
15	SG-M5*5	SOCKET SET SCREW	止付螺丝	
16	SC-M6*16	SOCKET CAP SCREW	内六角螺丝	
17	FHS-E024	SPRING	开关拉簧	
18	FHS-E018	ROD	支持杆	
19	FHS-E019	FIXATION RING	固定圈	
20	FHS-E020	CLAMP	停电控制块	
21	SC-M5*12	SOCKET CAP SCREW	内六角螺丝	
22	NUT-M5	NUT	螺母	



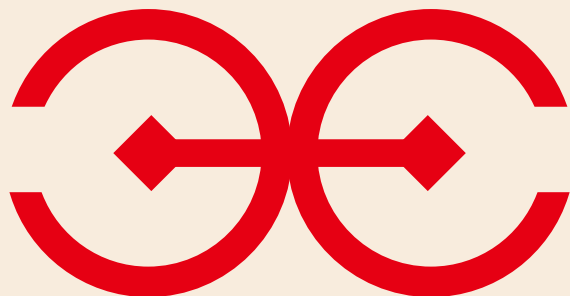


- 注：
- SM₁ 电流开关
 - QF 断路器
 - HL 指示灯
 - STP 停止
 - ST 起动
 - SM₂ 停经选择
 - SA 停经行程开关
 - RP 转速选择

高 编 机 控 制 电 路

上海香海织带机械有限公司

电话：021-59754916



上海香海织带机械有限公司

SHANGHAI XIANGHAI FABRIC MACHINERY CO., LTD.

总 部:

地址: 上海市沪青平公路3841弄8号

青岛办事处:

电话/传真: 0532-89225869

广东办事处:

电话/传真: 0769-88316506

网址: www.xiang-hai.com

电话: 021-59754916 传真: 021-69750655

地址: 青岛汽车北站后门

地址: 东莞市道窖镇

E-mail: wjp@xiang-hai.com