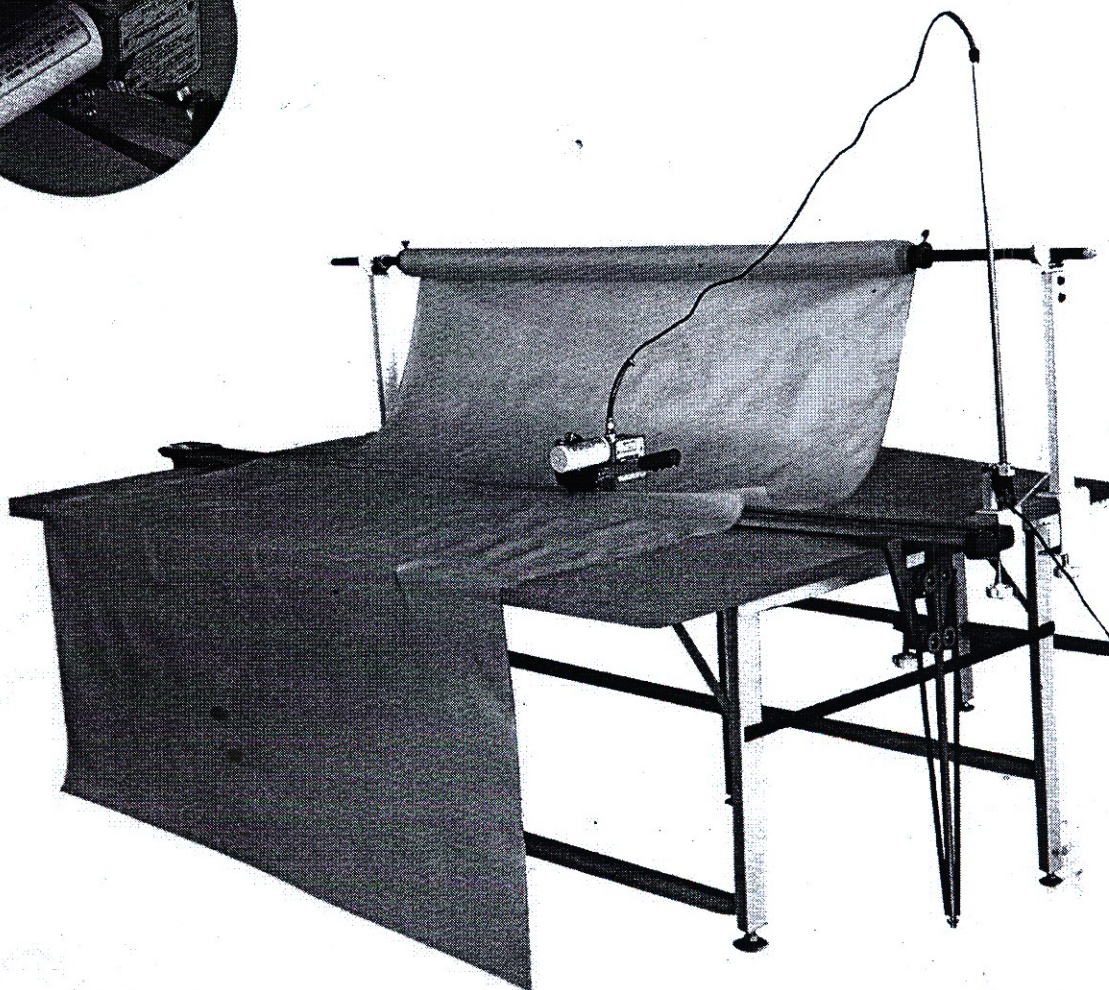
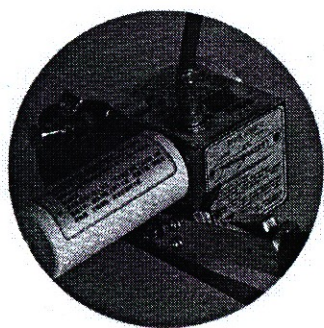


W-260/1-LA

M 手动断布机说明书

MANUAL CLOTH END CUTTER
BOOK



AM - ORIGINAL

A. 调整磨刀砂轮

当砂轮磨不到刀片时, 应放松磨刀臂螺钉, 调整磨刀砂轮位置, 使磨刀砂轮和刀片边缘间有一个适宜的距离, 然后锁紧螺钉。

B. 更换磨刀砂轮

拧下螺钉, 取下磨刀砂轮, 然后装上新的磨刀砂轮。

C. 更换圆刀片

1. 拿下磨削轮部件。
2. 旋下刀片锁紧螺母。
3. 取下刀片。
4. 当按装新刀片时, 应使印有 "Thissideup" 的这一面朝向操作者。
5. 装上新刀片后, 调整磨削砂轮至适宜位置。

D. 更换磨刀垫

1. 旋下磨刀垫固定板螺钉, 取下磨刀垫固定板。
2. 拧下磨刀垫固定螺钉, 换上新磨刀垫, 确保磨刀垫侧面贴近圆刀边缘。

E. 更换碳刷

1. 碳刷的磨损会引起电机的故障, 当碳刷磨得只剩下5~6mm时, 必须更换碳刷。
2. 用螺丝刀旋下碳刷螺母, 更换碳刷。
3. 须同时更换左右碳刷。
4. 更换时, 接线弹簧须钩住碳刷壳金属部件。

F. 清洁导轨和主机

1. 当断布机连续工作10到20小时后, 须用刷子清除导轨上遗留下的织物。
2. 当断布机连续工作30天后, 须从导轨上拆下主机, 用刷子逐一清洁各导轨槽, 清洁后, 装回主机。

A. ADJUSTING THE GRINDER

When the blade is worn out, adjust the grinder position by unscrewing the screw for the grinder arm so as to ensure a correct distance between the grinder and the blade edge. After finishing adjustment, screw up the screw.

B. REPLACING THE GRINDING WHEEL

Take off the grinding wheel by unscrewing it off. Mount the new grinding wheel then.

C. REPLACING THE KNIFE

1. take off the grinding wheel unit.
2. Unscrew the lock nut for the knife.
3. Take off the knife.
4. When mounting the knife, make sure that the side printed with "thisside up" should be placed facing the operator.
5. After the blade is replaced, adjust the position of the grinder at the proper.

D. REPLACING THE LOWER BLADE

1. TO take off the lower blade arm by unscrewing the screw for the lower blade arm.
2. Replacing the lower blade by Unscrewing the fixed screw. Replace the lower blade and ensured the flat SURface of the lower blade adjacent to the blade edge.

E. REPLACE OF CARBON BRUSH

1. Too much weaving of carbon brush will cause motor troubles. Carbon brush must be replaced when it wears to 5-6mm.
2. Carbon brush cap is replaced by turning it left by attached wrench.
3. Always replace right and left carbon brushes simultaneously.
4. Be sure to hold metallic part of the brush.

F. CLEAN THE TRACK AND THE MASTER MACHINE

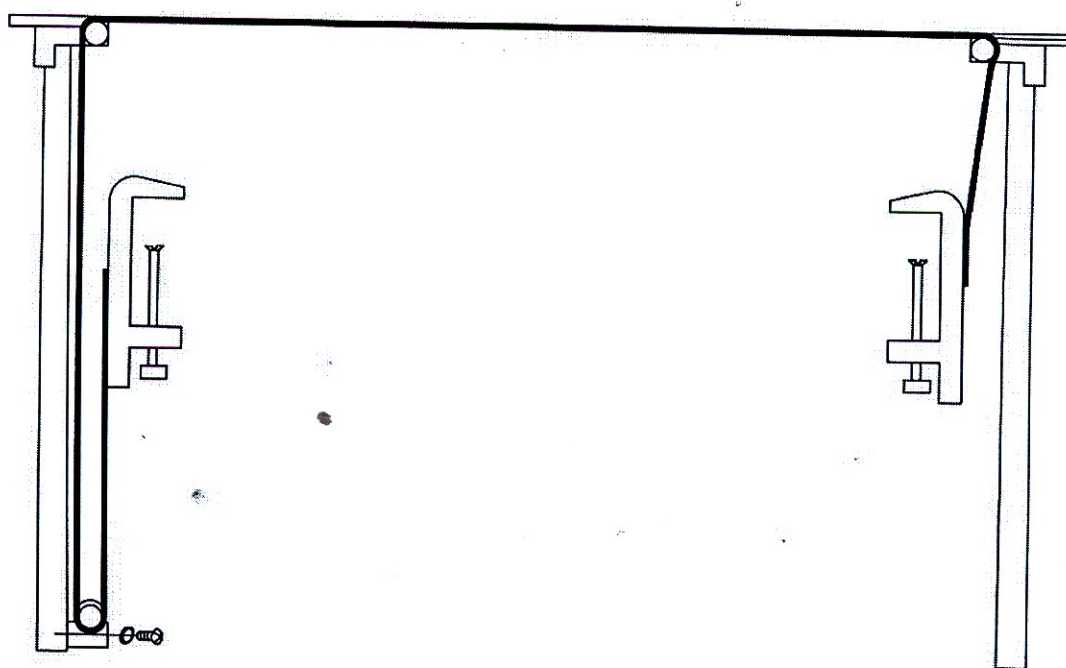
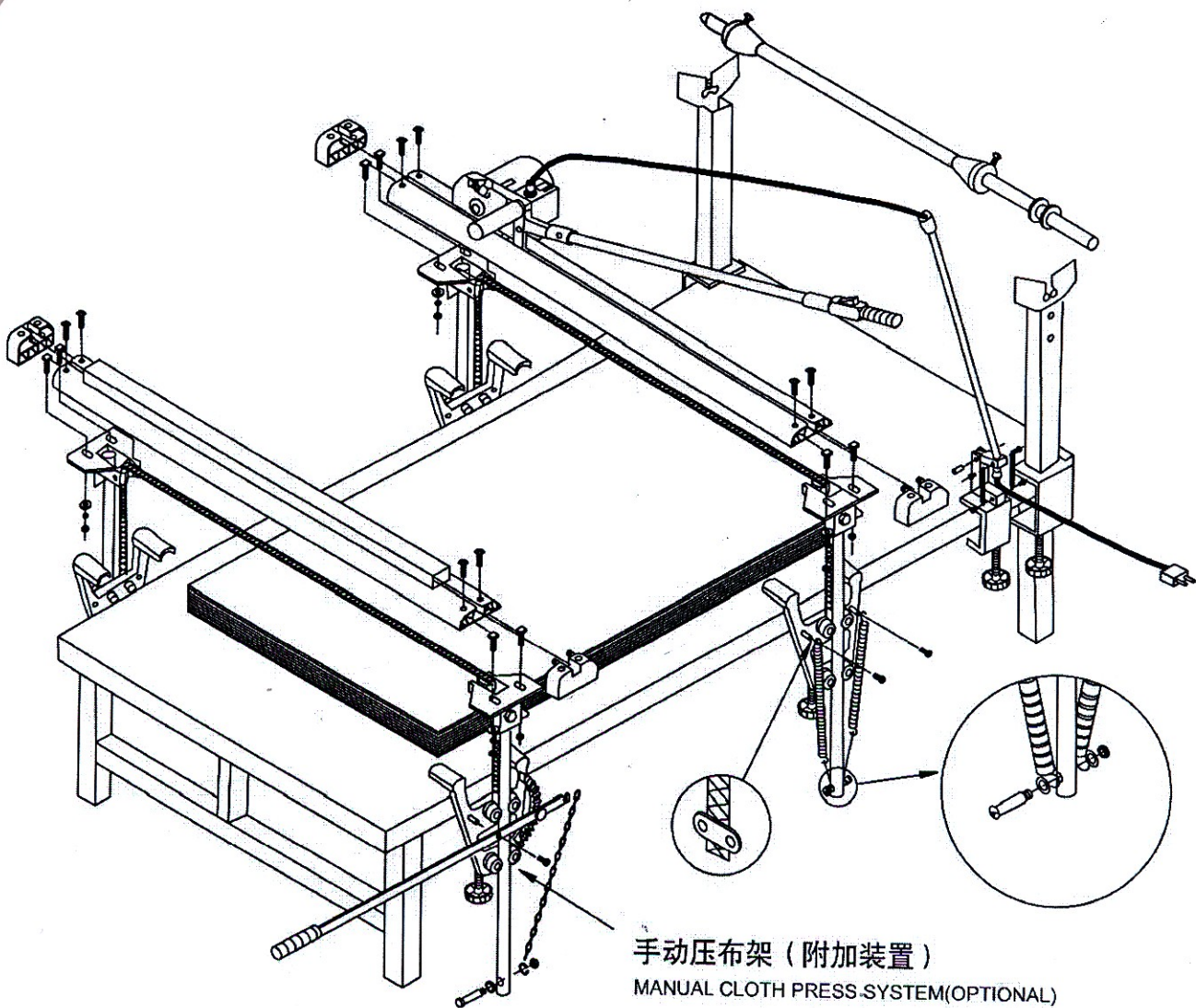
1. Clean all the wasted cotton and cloth in the track with a brush thoroughly after the machine is continuously running for 10 to 20 hours.
2. TO take the master machine of the track and thoroughly clean the L-type track with a brash after the machine is continuously running for 30 days. Repeatedly cleand it as shown in Item. To mount the master machinein the track groove again after cleanness is ensured.

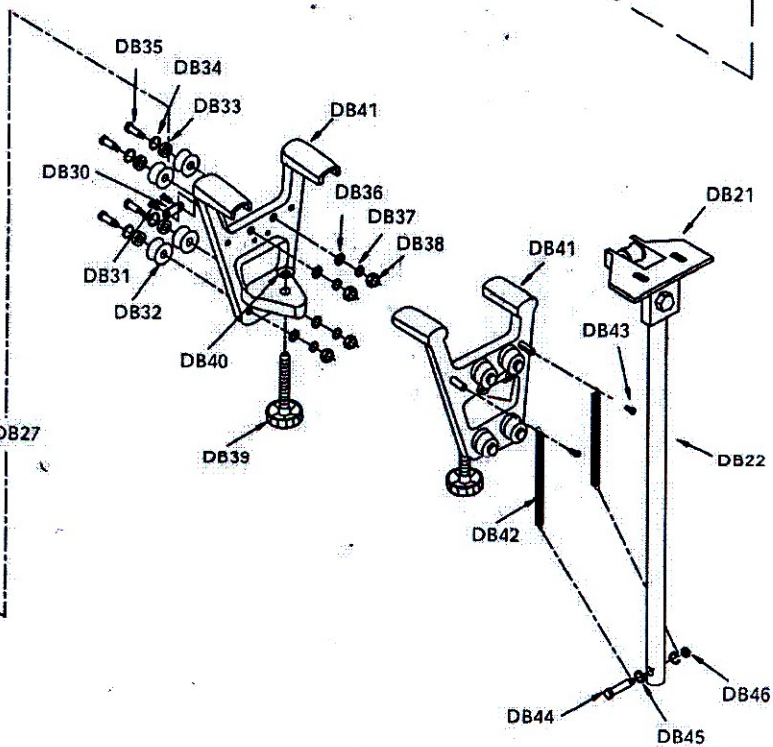
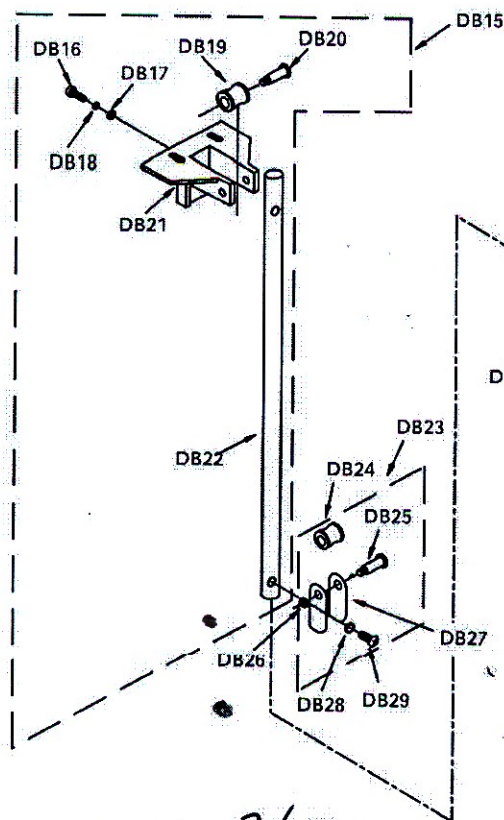
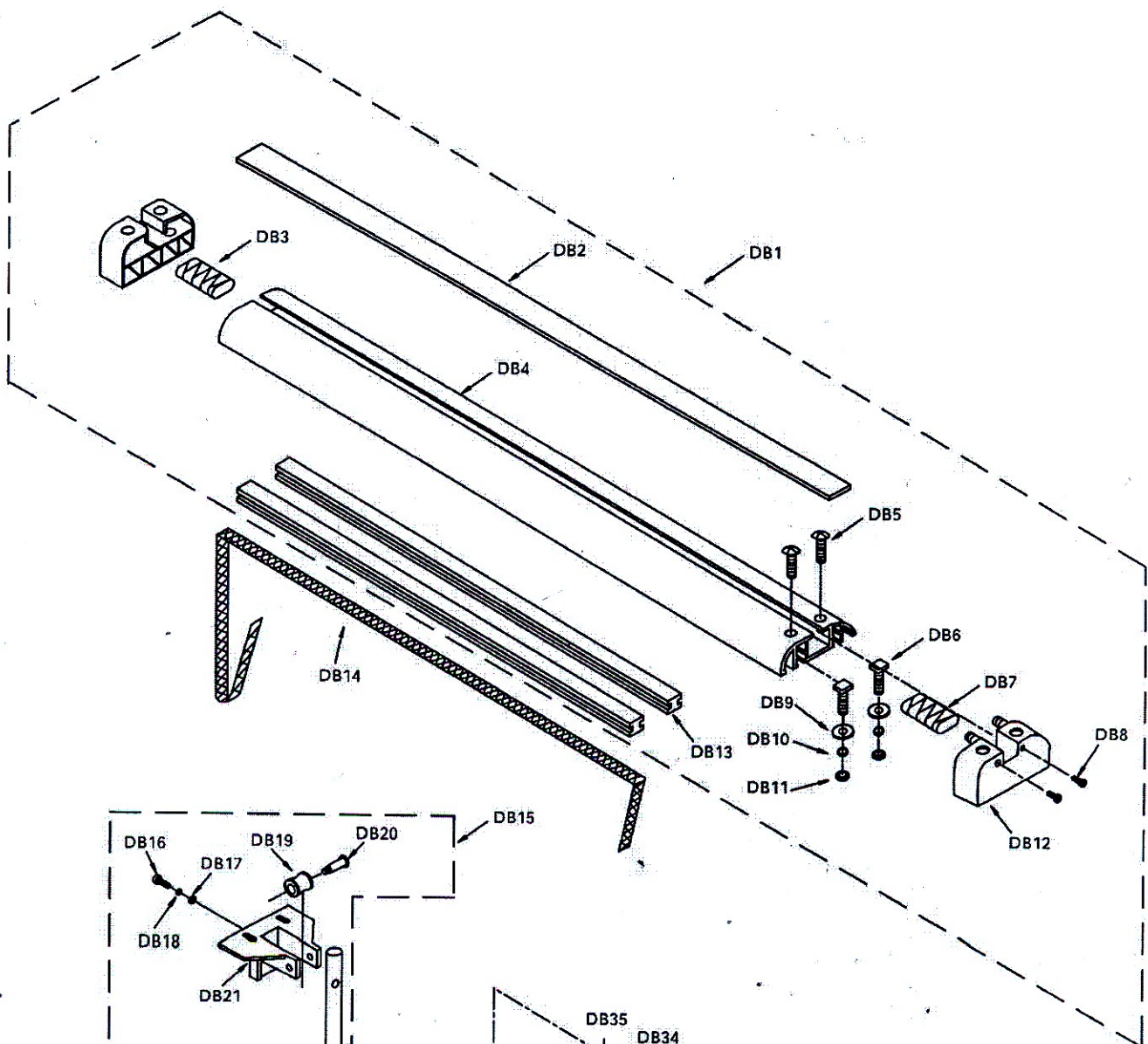
1. 操作前, 应检查导轨平面是否干净。
2. 为安全起见, 应装有接地线。

1. Beforing operating the machine, make sure of complete cheanness of the track surface.
2. Safety electric ground wire is used for the sake of safety.

刀片直径: 108mm 刀片形状: 圆形
电压: 单相110V / 60HZ或220~240V / 50HZ
刀片转速: 12000转 / 分 输出功率: 130w

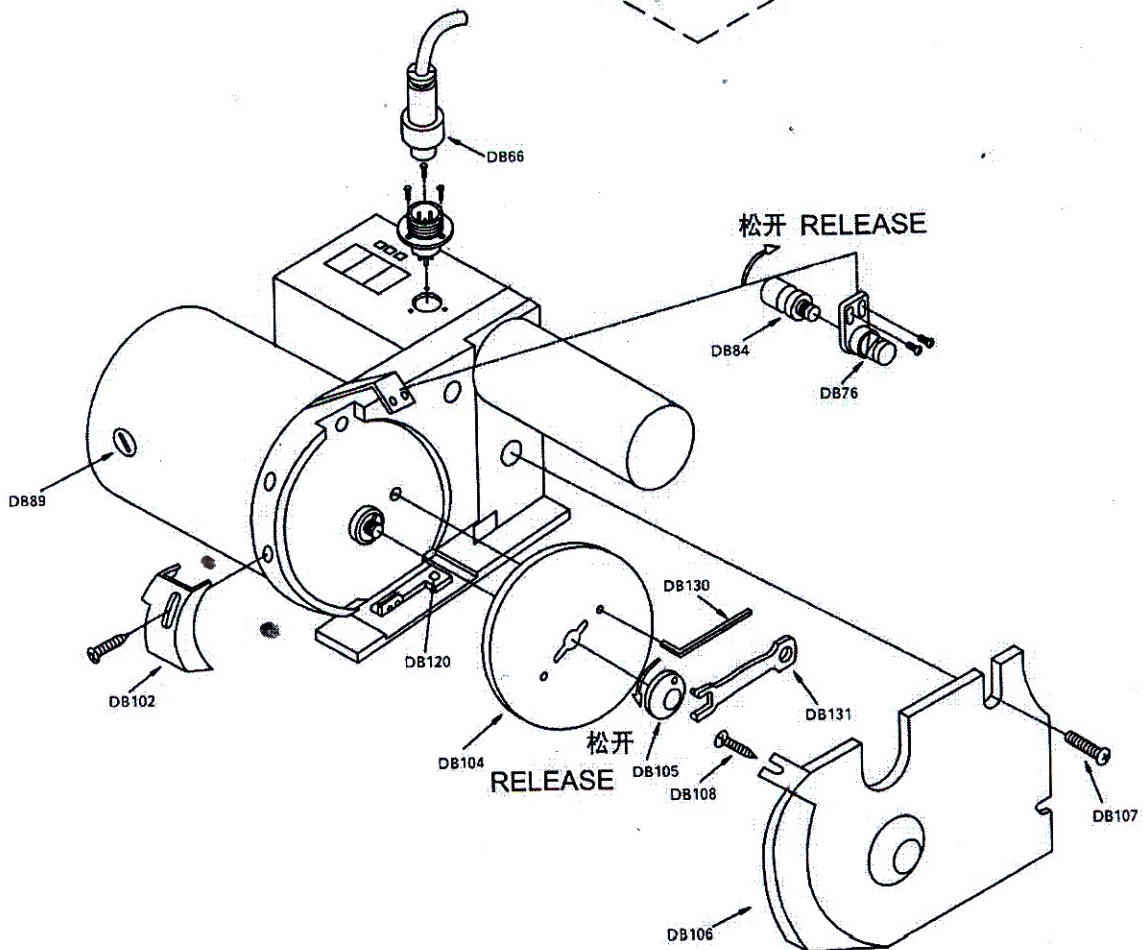
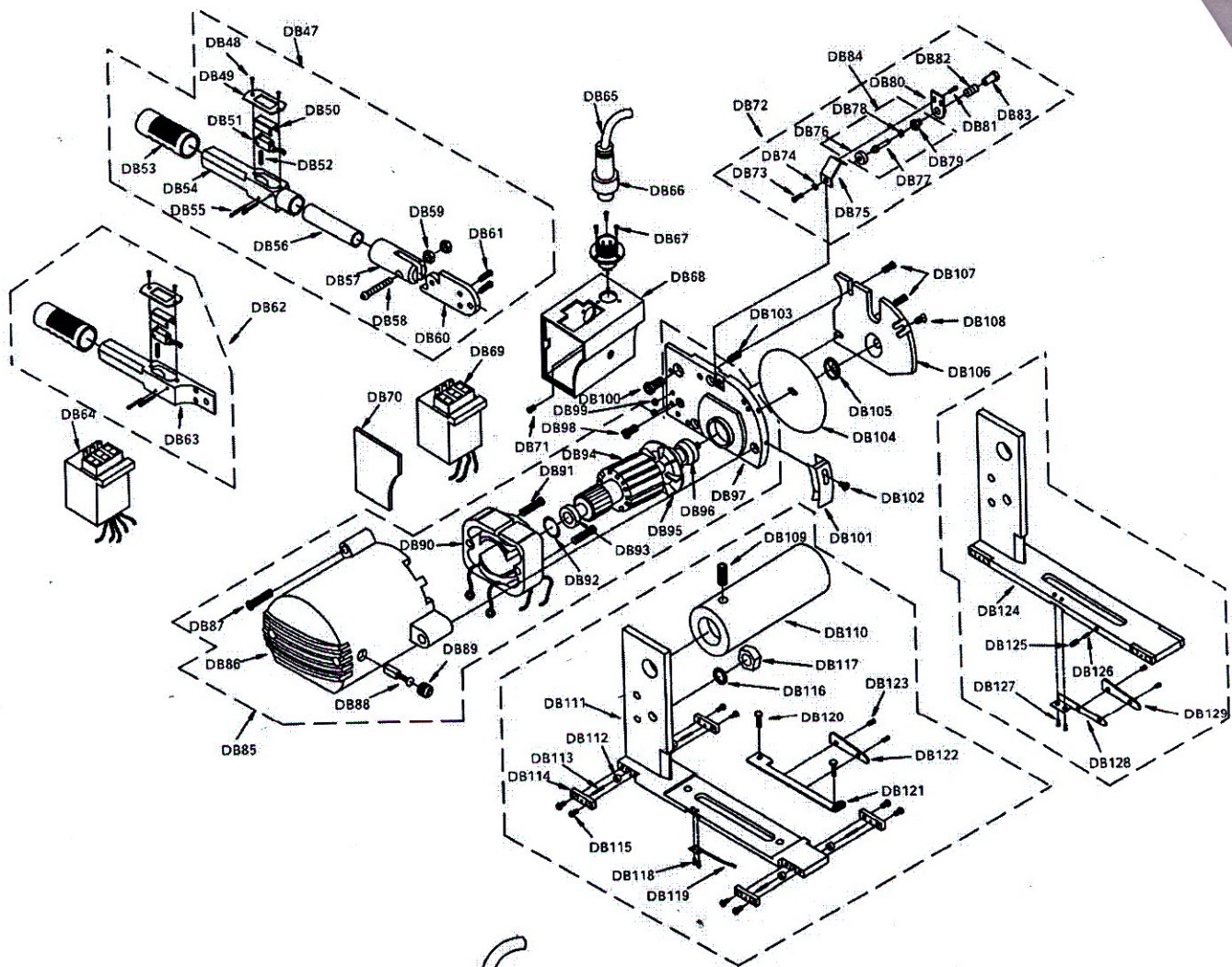
Side of Blade: 108mm Shape of the Blade: Round
Electric Pressure: Single phase 110V/60HZ or 220V-240V/50HZ
Revolving speed of the Knife: 12000 r.p.m Output: 130W



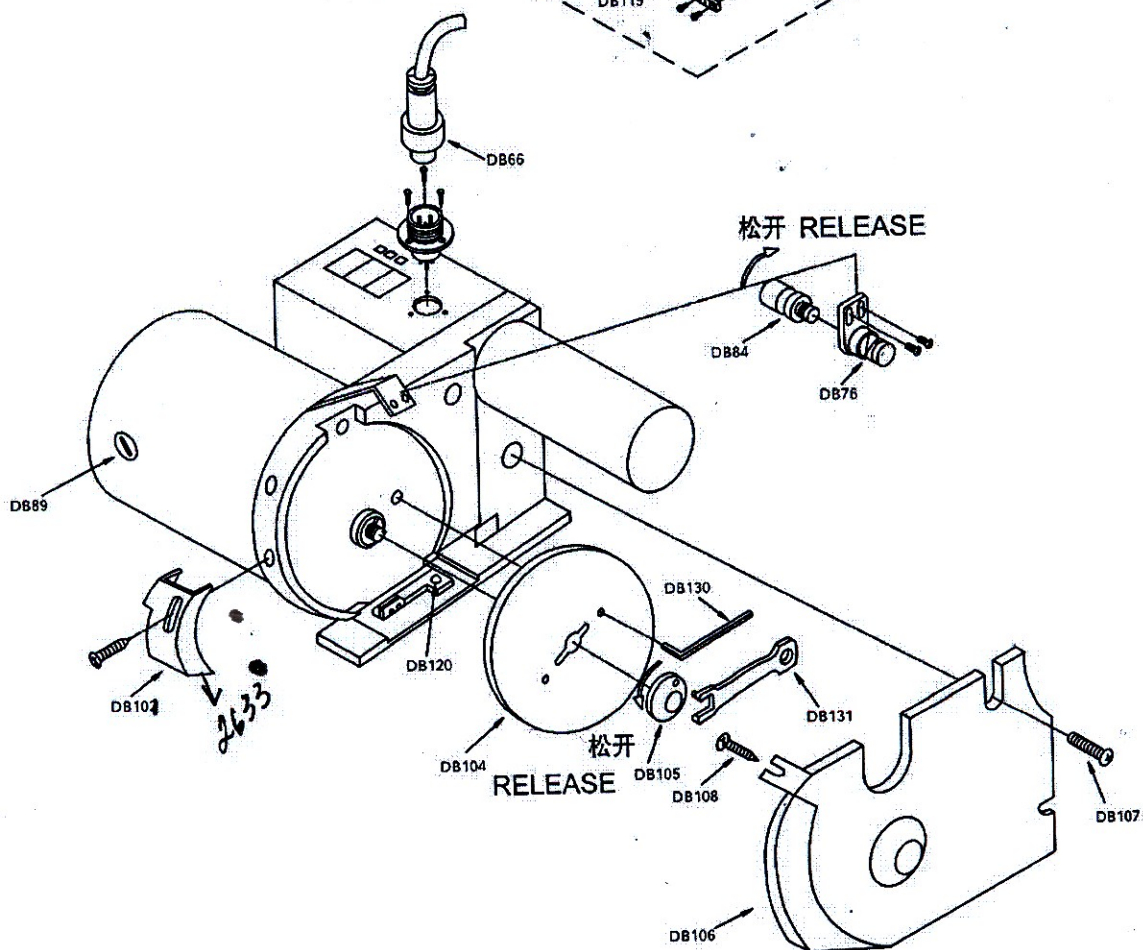
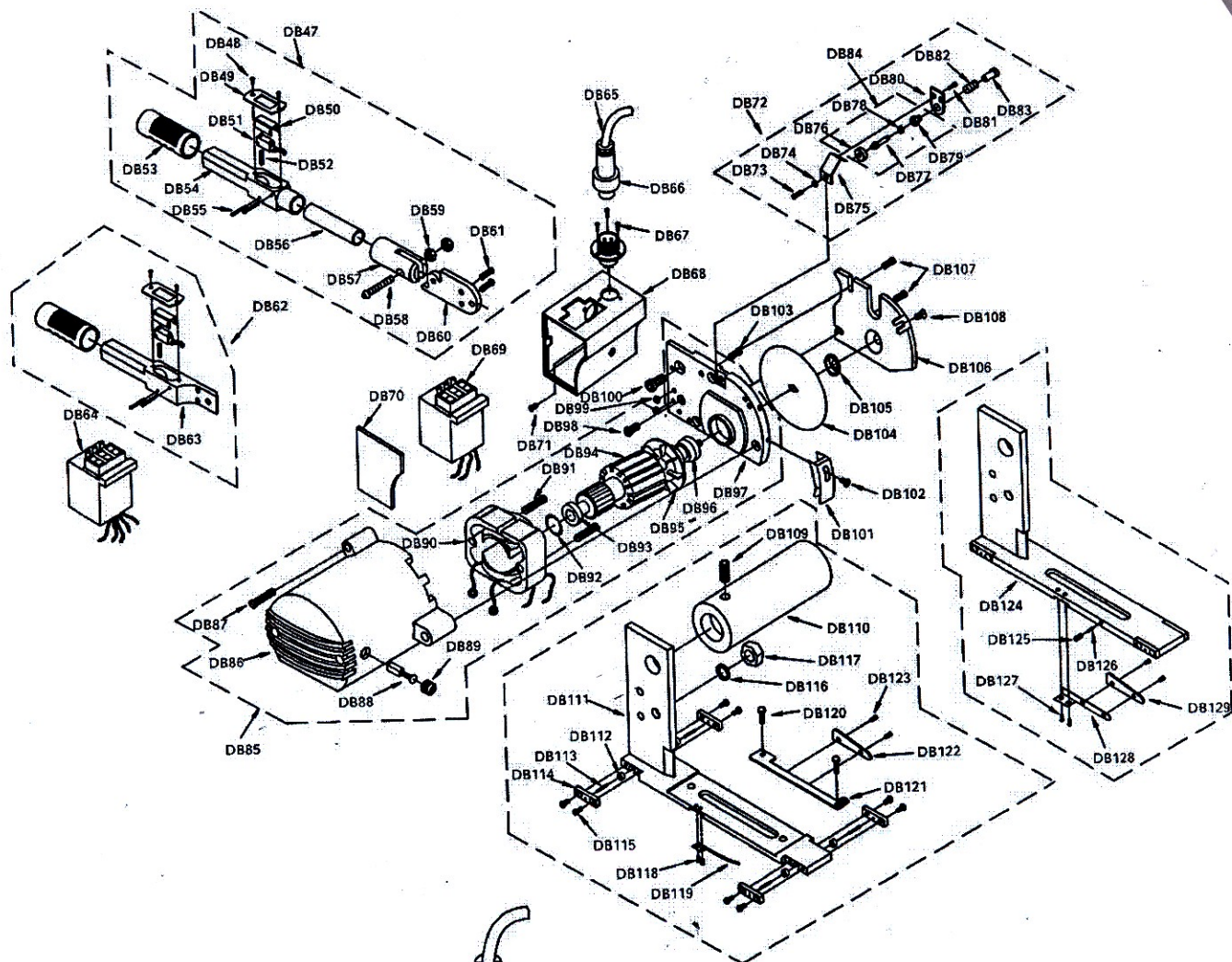


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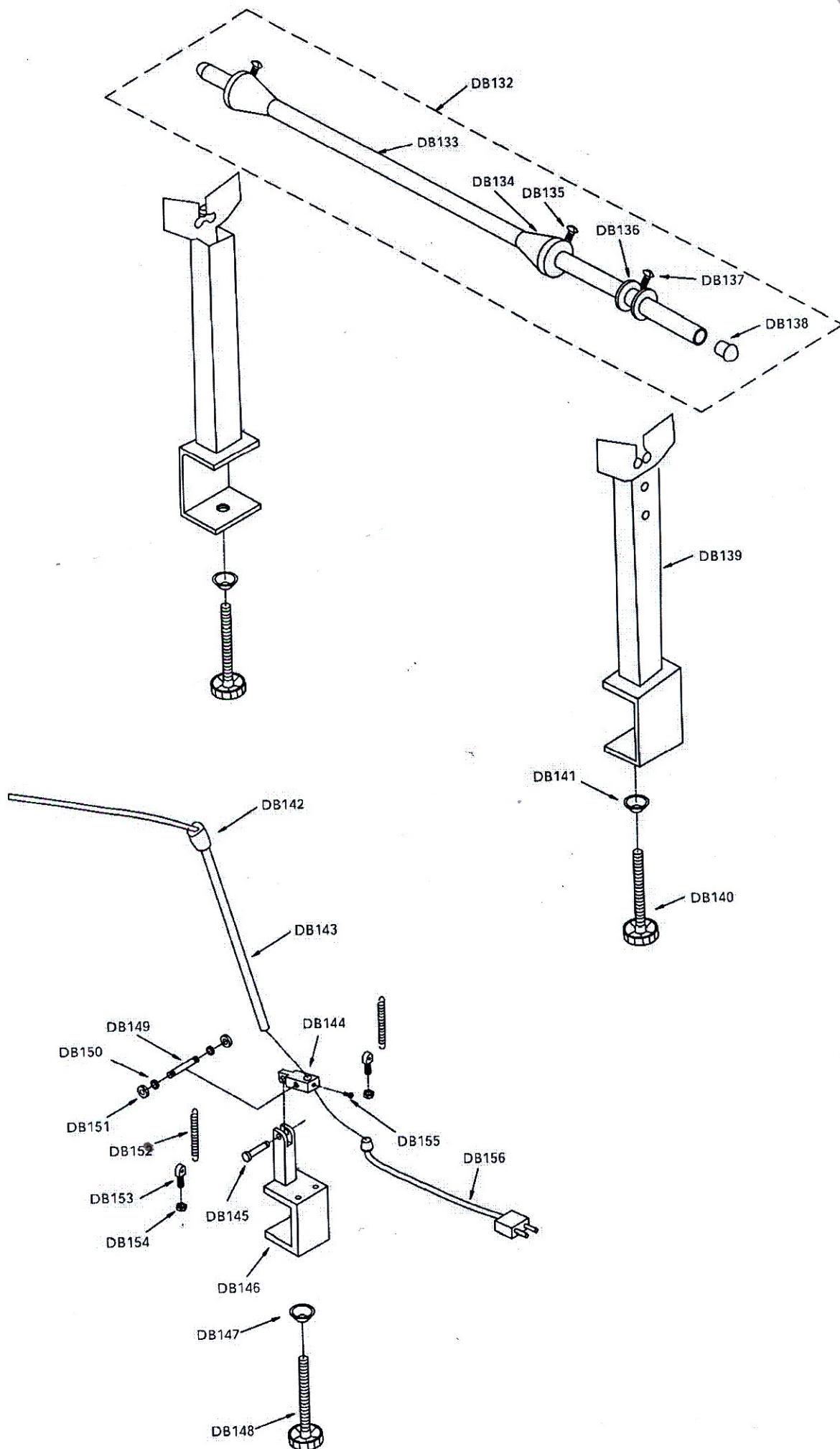
零件号 PART NO.	名 称 Description	数 量 NO. Req'd	备注 Remarks
DB1	GUIDE RAIL ASSEMBLY	导轨组件	1
DB2	GUIDE RAIL BOTTOM BELT	导轨垫带	1
DB3	RETURN SPRING	反弹器	1
DB4	GUIDE RAIL	导轨	1
DB5	RAIL COVER SCREW	导轨端盖螺钉	4
DB6	RAIL FIXED SCREW	导轨固定螺钉	4
DB7	SPRING	弹簧	1
DB8	SPRING SCREW	弹簧螺钉	2
DB9	SPECER	垫片	4
DB10	SPRING SPACER	弹性垫片	4
DB11	RAIL FIXED NUT	导轨固定螺母	4
DB12	BUIDE RAIL COVER	导轨端盖	2
DB13	CLOTH PRESS PLASTIC	压布泡沫条	2
DB14	LIFT BELT	升降带	1
DB15	STAND ASSEMBLY	支杆组件	1
DB16	PRESS FOOT SCREW	压脚螺钉	2
DB17	SPACER	垫片	2
DB18	SPRING SPACER	弹性垫片	2
DB19	UP GUIDE WHEEL	上导轮	1
DB20	UP GUIDE WHEEL SHAFT	上导轮轴	1
DB21	PRES FOOT	压脚	2
DB22	STAND	支杆	2
DB23	DOWN WHEEL BRASKET ASSEMBLY	下导轮架组件	1
DB24	DOWN GUIDE WHEEL	下导轮	1
DB25	DOWN GUIDE SHAFT	下导轮轴	1
DB26	DOWN GUIDE SHAFT NUT	下导轮轴螺母	1
DB27	GUIDE WHEEL BRASKET	导轮架	1
DB28	SPACER	垫片	1
DB29	SCREW	导轮架螺钉	1
DB30	LIFT BELT PRESS PLATE	升降带压板	2
DB31	PLATE SCREW	压板螺钉	4
DB32	STAND GUIDE WHEEL	支杆导轮	8
DB33	STAND GUIDE WHEEL SHAFT	支杆导轮轴承	8
DB34	BEARING SPRING	轴承卡簧	8
DB35	SCREW	支杆导轮螺钉	8
DB36	SPACER	垫片	8
DB37	SPRING SPACER	弹性垫片	8
DB38	NUT	螺母	8
DB39	CLAMP HANDLE	夹紧手柄	2
DB40	HANDLE PRESS PLATE	手柄压板	2
DB41	STAND GUIDE WHEEL BRASKET	支杆导轮架	2
DB42	EXTENSTION SPRING	拉升弹簧	3
DB43	SCREW	拉升弹簧螺钉	2
DB44	EXTENSION SPRING SHAFT	拉升弹簧轴	1
DB45	SPACAR	垫片	2
DB46	NUT	螺母	1



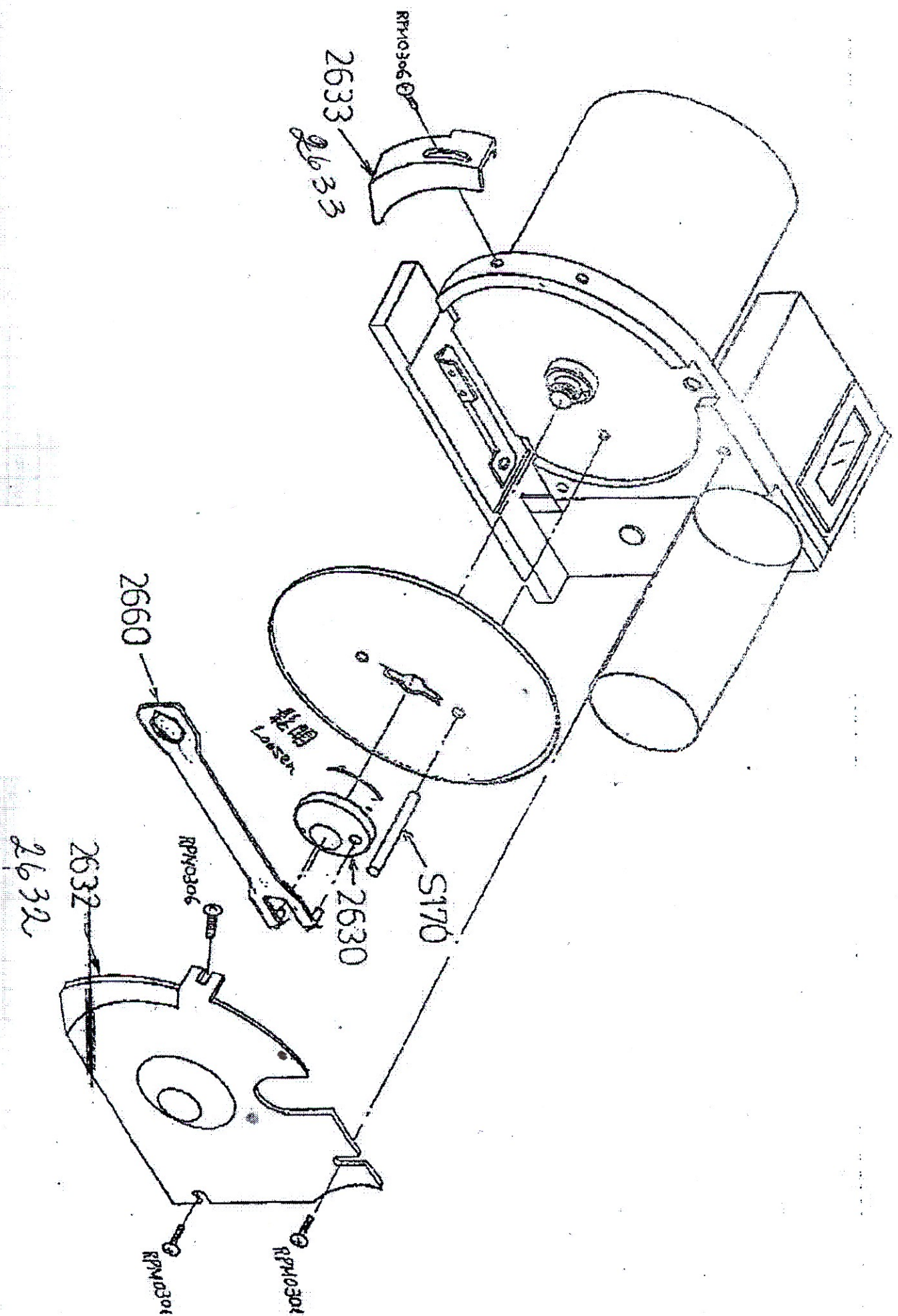
零件号 PART NO.	名 称 Description		数 量 NO.Req'd	备注 Remarks
DB47	LONG HANDLE ASSEMBLY	长手柄组件	1	
DB48	SWITCHER PLATE SCREW	开关压板螺钉	2	
DB49	SWITCHER PLATE	开关压板	1	
DB50	SWITCHER COVER	开关盖	1	
DB51	SWITCHER	开关	1	
DB52	SPRING	弹簧	1	
DB53	HANDLE COVER	手柄护套	1	
DB54	SWITCHER COVER	长手柄开关盒	1	
DB55	SCREW	开关盖螺钉	2	
DB56	NUT	连接管	1	
DB57	HANDLE CONNECTOR	手柄连接头	1	
DB58	SCREW	连接头螺钉	1	
DB59	NUT	手柄连接螺母	2	
DB60	HANDLE CONNECTING PLATE	手柄连接板	1	
DB61	SCREW	连接板螺钉	2	
DB62	SHORT HANDLE ASSEMBLY	短手柄组件	1	
DB63	SWITCHER COVER	短手柄开关盒	1	
DB64	DELAY COUNNTER	短柄延时计数器	1	
DB65	WIRE COVER	电线保护套	1	
DB66	AVIATION PLUG	航空插座	1	
DB67	PLUG SCREW	插座螺钉	3	
DB68	ELECTRIC BOX	电器盒	1	
DB69	LONG HANDLE COUNTER	长柄计数器	1	
DB70	BOX COVER	电器盒盖	1	
DB71	SCREW	电器盒盖螺钉	1	
DB72	GRINDING STONE BRASKET	砂轮连架组件	1	
DB73	STONE	砂轮架螺钉	1	
DB74	SPACER	垫片	1	
DB75	GRINDING STONE BRASKET	砂轮架	1	
DB76	STONE	砂轮	1	
DB77	STONE INSIDE SHAFT	砂轮芯轴	1	
DB78	STONE BEARING	砂轮轴承	1	
DB79	SHAFT TUBE	芯轴套	1	
DB80	FIXED TUBE	固定套	1	
DB81	SCREW	固定套螺钉	2	
DB82	SPRING	弹簧	1	
DB83	NUT COVER	螺套	1	
DB84	GRINDING STONE ASSEMBLY	砂轮组件	1	2626
DB85	MOTOR ASSEMBLY	电机组件	1	
DB86	MOTOR COVER	电机外壳	1	
DB87	SCREW	电机螺钉	3	
DB88	CARBON BRUSH	碳刷组件	2	2604
DB89	CARBON BRUSH COVER	碳刷盖	2	2605
DB90	STATOR ASSEMBLY	定子组件	1	
DB91	STAOR FIXED SCREW	定子固定螺钉	2	
DB92	WAVE WASHER	波形垫圈	1	



零件号 PART NO.	名 称 Description		数 量 NO. Req'd	备注 Remarks
DB93	BACK BEARING	后轴承	1	
DB94	ROTOR ASSEMBLY	转子组件	1	
DB95	FAN	风叶	1	
DB96	FRONT BEARING	前轴承	1	
DB97	KNIFE BRASKET	刀架	1	
DB98	SCREW	螺钉	1	
DB99	NUT	螺母	2	
DB100	BALANCE STAND SREW	平衡柱螺钉	1	
DB101	KNIFE HEAD PROTECTER	刀头防护罩	1	2633
DB102	SCREW	防护罩螺钉	1	
DB103	SCREW	螺钉	1	
DB104	KNIFE	刀片	1	2631
DB105	KNIFE FIXED NUT	刀片锁紧螺母	1	
DB106	KNIFE PROTECTER	刀片防护罩	1	2632
DB107	SCREW	防护罩螺钉	2	
DB108	SCREW	防护罩螺钉	1	
DB109	FIXED SCREW	坚定螺钉	1	
DB110	BALANCE STAND	平衡柱	1	
DB111	WEIGHT STAY PLATE	立板(1 型)	1	
DB112	ROLLER	滚轮	4	
DB113	ROLLER SHAFT	滚轮轴	4	
DB114	ROLLER PRESS PLATE	滚轮压板	4	
DB115	SCREW	压板螺钉	8	
DB116	SPRING SPACER	弹性垫片	1	
DB117	NUT	螺母	1	
DB118	SPRING SCREW	弹簧螺钉	2	
DB119	KNIFE FIXATION SPRING	磨刀垫弹簧 (1 型)	1	
DB120	SCREW	固定板螺钉	2	
DB121	KNIFE FRAME	磨刀垫固定板 (1 型)	1	
DB122	KNIFE FIXATION	磨刀垫 (1 型)	1	
DB123	SCREW	磨刀垫螺钉	2	
DB124	WEIGHT STAY PLATE	立板 (2 型)	1	
DB125	SCREW	紧定螺钉	1	
DB126	KNIFE FIXATION SPRING	磨刀垫弹簧	1	
DB127	SPRING SCREW	弹簧螺钉	2	
DB128	WEIGHT STAY PLATE	磨刀垫固定板 (2 型)	1	
DB129	KNIFE FIXATION	磨刀垫 (2 型)	1	
DB130	WRENCH	内六角扳手	1	
DB131	WRENCH	刀片安装扳手	1	



零件号 PART NO.	名 称 Description	数 量 NO. Req'd	备注 Remarks
DB132	STAND SHAFT ASSEMBLY	1	
DB133	STAND SHAFT	1	
DB134	TUBE COVER	2	
DB135	SCREW	2	
DB136	FIXER	2	
DB137	SCREW	2	
DB138	SHAFT FIXER	2	
DB139	SHAFT ASSEMBLY	2	
DB140	HANDLE	2	
DB141	HANDLE PLATE	2	
DB142	WIRE TUBE COVER	2	
DB143	WIRE STANDER	1	
DB144	TUBE MOVABLE PLATE	1	
DB145	SCREW	1	
DB146	WIRE STANDER	1	
DB147	HANDLE PRESS PLATE	1	
DB148	STAND HANDLE	1	
DB149	SPRING BOLT	1	
DB150	WASHER	2	
DB151	NUT	2	
DB152	SPRING	2	
DB153	SPRING FIXER	2	
DB154	NUT	2	
DB155	SCREW	1	
DB156	WIRE	1	



2

