

## 产品说明书 OPERATION MANUL





#### Safety Precautions

#### 1. Sign and Meanings of safe operation

The safety signs used in this instruction manual and the product are designed to allow you to use the product correctly and safely to prevent injury to you and others. The pattern and meaning of the logo are as follows:

Danger	If you ignore this mark and perform the wrong operation, it will result in serious injury or death.
Caution	If you ignore this mark and perform the wrong operation, it may result in personal injury and equipment damage.
A	This symbol indicates "should be noted". The pattern in the triangle indicates what must be noted. (For example, the pattern on the left indicates "Beware of injury")
$\oslash$	This symbol means "prohibited"
	This symbol indicates "must". The pattern in the circle indicates what must be done. (For example, the pattern on the left indicates "must be grounded")

#### 2、Safety Precautions

	Danger				
Â	When opening the electric control box, first turn off the power switch and unplug the power plug from the outlet, wait at least 5 minutes, then open the control box cover. Touching an area with a high voltage can cause personal injury.				
	Caution				
	Use environment				
0	Avoid using the sewing machine near strong electrical interference sources such as high frequency welders. Strong electrical interference sources may affect the normal operation of the sewing machine.				
0	The fluctuation of the power supply voltage should be used within $\pm 10\%$ of the rated voltage. Large fluctuations in voltage can affect the normal operation of the sewing machine and require a voltage regulator.				
0	The ambient temperature should be used in the range of 0 °C ~ 45 °C. Low temperatures or high temperatures can affect the normal operation of the sewing machine.				
0	The relative humidity should be in the range of 35% to 85%, and the device should not be used in the environment where condensation does not form. Dry, wet or dew condensation can affect the proper operation of the sewing machine.				

•	The air supply to the compressed air should be greater than the total air consumption required by the sewing machine. Insufficient air supply to the compressed air can cause the sewing machine to malfunction.		
	In the event of a lightning storm, turn off the power switch and unplug the power cord from the outlet. Lightning can affect the correct operation of the sewing machine.		
Installation			
$\oslash$	Please have a trained technician install the machine.		
$\oslash$	Do not connect the power supply and air pressure until the installation is complete. If the start switch is pressed by mistake, the machine will cause injury.		
	When disassembling or moving the machine, use both hands. Do not press the machine hard. If the machine is out of balance, falling over to the ground can cause injury or damage.		
	Must be grounded. The grounding wire is not secure, which is the cause of electric shock or malfunction.		
•	All cables should be secured at least 25 mm from the moving parts. Also, do not over-bend or over-tighten with staples. Risk of fire or electric shock		

Sewing			
$\oslash$	This sewing machine is limited to those who have been trained in safe operation.		
A	During the sewing process, do not touch any moving parts or place objects against the moving parts as this may result in personal injury or damage to the sewing machine.		
0	If the sewing machine malfunctions during operation, or if you hear unusual noise or smell an unusual smell, turn off the power immediately. Then please contact the store or trained technician.		
	Maintenance and inspection		
A	<ul><li>Turn off the power and unplug the power cord when the following conditions occur,</li><li>Otherwise, accidentally pressing the start switch will result in injury.</li><li>1. Inspection, adjustment and maintenance</li><li>2. Replace consumable parts such as needles and cutters</li></ul>		
$\triangle$	Be sure to observe all safety precautions carefully when the power switch and air supply switch must be connected for adjustment.		
$\oslash$	Damage to the sewing machine caused by unauthorized modification of the sewing machine is not covered by the warranty.		

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#### 1. Summarize

#### 1.1 Technical parameter table

No.	Name	Specification
1	Maximum speed	3000rpm
2	Sewing range	XY:60mmx40mm
3	Stitch length	0.1mm-10mm(0.1mm unit)
4	Storage	A total of 20,000 needles, a single maximum of 2000 needles
5	Standard number of patterns	100 species
6	Memorable data	200 patterns
7	Zoom in and out	20-200% (1% unit) in the X direction and Y direction, the length of the stitch length is increased or decreased.
8	Motor	550W servo motor
9	Voltage	220VAC±10%, 50-60Hz
10	Air pressure	≥0.5Mpa (5 standard atmospheric pressures)
11	Operating temperature range	0°C-50°C
12	Trademark size	Length: no folding size 28-100mm, double folding size 56-200mm; width 5-40mm
13	Machine configuration	Left and right feeding (1-4 labels) / left or right feeding (1-2 labels)
14	Dimensions	1600mm×710mm×1320mm
15	Total Weight	approximately 100kg
16	Sewing mode	1. Full automatic mode 2. Pedal semi-automatic mode 3. Pedal manual mode 4. Test mode

#### 1.2 Machine Parts



- ① Sewing machine head
- ② Clipping device
- ③ Care label operation panel
- ④ Sewing panel control
- ⑤ Power switch
- 6 Care label electric control box
- O Sewing machine electric control box
- (8) Pedal switch

#### 2. Transportation and installation

#### 2.1 Lift and transportation

The machine must be packaged before the shipping. When lifting, check that the load capacity of the truck's insert can support the weight of the machine.

When the machine is placed in trucks and vans, ensure that there are fixed by ropes or belts.



Figure 2.1 Transportation sketch

#### 2.2 Loading and unloading

When unloading, ensure that the forklift's insert can withstand the full weight of the machine.

Check the machine for obvious damage during transport when removing the package. If it is damaged, do not use the machine and contact the manufacturer. Place the machine on a flat surface and do not expose it to the outdoors..

#### 2.3 installation

Note: The machine must only be installed by a professional.

The manufacturer is not responsible for any property or personal injury caused by improper installation of the machine. These installation errors are mainly due to non-compliance with the instructions and failure to meet the main part of the connection requirements.

 ${igt \Delta}$  If the machine is mounted on a suspended surface, check that the surface can withstand the weight of the

#### machine。

There may be no flammable or explosive materials or objects in the area where the machine is located...

Mandatory 0.5 m space must be left around the machine to operate and maintenance machine.

The machine must be placed on a hard and flat surface Turn the foot nut "A" (Fig. 2.2) to adjust the height.



Fig. 2.2 foot nut

In order to make transportation more convenient, the movable part of the machine is tied and fixed by a tie. Please check before use:

- Straight-line cylinders on both sides, fixed by a cable tie (Fig. 2.3), and the cable tie should be removed before use;

- The pedal is fixed by a cable tie (Fig. 2.4). Before use, remove the cable tie and place the pedal on the ground for convenient operation.;

- Two display screens (Fig. 2.5), remove the cable ties before use;



Fig.2.3 Straight-line cylinders tied



Fig2.4 The pedal is fixed by a cable tie



Fig2.5 screen fixed by a cable tie

#### 3. Preparation before sewing

When the machine is initially installed in the factory, the following adjustments are required to ensure safe operation and sewing effect:

1) When the air source and power supply are not turned on, manually push the straight line clamping cylinders on both sides to the presser foot of the machine head to Check if the label clips on both sides interfere with each other (as shown in Figure 3.1), if there is interference, it must be adjusted by referring to Chapter 6 of this manual. It is not possible to connect the power in the presence of interference. If there is no interference, proceed to the next step;



Figure 3.1 Checking whether the label clamp interferes

- 2) Turn on the power switch and the air supply main switch to adjust the air pressure to 0.5MPa (5 standard atmospheres);
- 3) Wait for the head operation panel to start, enter the work interface, and then check whether the pattern displayed on the head control panel is a care label pattern.;
- 4) Wait for the care label operation panel to start entering the work interface, then enter the sewing interface and wait for sewing.

#### 4. Preparation of sewing pattern

The machine uses the bartacker head to sew the care label. This manual uses the Jack bartacker 19006BS-D (touch screen) that is equipped with this machine as an example to introduce how to prepare the pattern for the care label.

#### 4.1 Enter the pattern editing interface

1) After startup, do not perform any operation, enter the main interface (as the picture shows 4.1), Click the System Settings button in the red circle to enter the System Settings screen. (as the picture shows 4.2)

2) In the system setting interface, click the pattern editing button in the red circle in the figure to enter the pattern editing confirmation interface. (As shown in pic. 4.3)

3) After confirmation, enter the pattern editing interface. (As shown in pic 4.4)









Fig.4.1 Start the main interface

Fig.4.2 System settings interface

Fig.4.3 Pattern editing enters the world

Fig.4.4 Pattern editing interface

#### 4.2 Pattern editing set the second home

Feeding: in the pattern editing interface (as show pic 4.4) Click the feeding button in the red circle on the 1st Pic, Enter the confirmation screen and click Ok, Enter the confirmation screen and click OK (as pic. 4.5).
 Select coordinate point: Through the editing interface (as show pic4.5) in tirst Arrow button in no.1 red circle, The coordinates of feeding in the no.2 red circle (0,18), click OK in the no.3 red circle to complete the first feeding coordinate.

3) Set the second home coordinate: Click the specific function button in the no.2 red circle of the pattern editing interface to enter the function list. (Pic.4.6), Click the "Second Origin" function in the no.1 red circle, and then click the "Select" button in the no.2 red circle to enter the second origin editing interface, select the "OK", and then enter into the pattern editing interface.

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Pic. 4.9 Sewing parameter interface

Pic.4.10 Output interface

Pic 4.11 automatically inserts the trimming interface

#### 4.3 Pattern editing setting stitch

1) In the pattern editing interface (Pic 4.4) Click the "Feeding" button in the no.1 red circle. Follow the above steps to set the new feeding point coordinates to (14,18) .

2) In the pattern editing interface (pic 4.4) click "Ordinary sewing" button in the no. 3 red circle, enter the sewing parameter setting interface (pic 4.7), click the number in the no.1 red circle, enter the setting stitch distance interface, and input the required stitch length. (If you use the default value of 2mm, you do not have to enter the setting), click OK to return to the sewing parameter setting interface, click the "OK" button in the no.2 red circle to enter the sewing editing interface (Pic. 4.8), use the arrow keys to determine the coordinate point

(18,18), Click the "OK" button, the same reason, set the next sewing point (-18,18), and the next one (-16,18).
3) In the pattern editing interface (Figure 4.4) click the "Output" button in the no.4 red circle to enter the output interface (as shown in the figure.4.10), Enter the number as the pattern name, note that the name cannot be repeated with the existing pattern name. It is recommended to choose a larger number, such as 161, click the "OK" button in the no.1 red circle to complete the naming, then the automatic insertion trimming interface will pop up (Figure 4.11), click the "OK" button to complete the editing of the new pattern.

#### 5. Care label control system

#### 5.1 Sewing data input interface

The sewing data input interface is shown in the right figure. For detailed function description, please refer to the function key description table.



Sewing data input interface

Serial number	Function	Detail	
А	Pattern browsing	Can browse, select and delete patterns	
В	New Pattern	Can create 99 new patterns	
С	Pattern copy	Can copy patterns	
D	L1,label settings	The label parameter setting of the first line L1 on the left side under the current pattern number	
E	L2,label settings	The label parameter setting of the second line L2 on the left side under the current pattern number	
F	R1,label settings	The label parameter setting of the first row R1 on the right side under the current pattern number	
G	R2,label settings	Label parameter setting of the second row R2 on the right side under the current pattern number	
н	Adjustment	Can adjust the position of the label and adjust the fiber parameters	
I	feeding test	Pattern parameter verification of L1, L2, R1, and R2 can be achieved by feeding labels	
J	Label arrangement	Display label up and down order	

#### Function Description:

#### 5.2 Sewing interface

Function

Press on the sewing data input interface.

Enter the **sewing interface** as shown on the right. Press

again to return to the **sewing data**.



Sewing interface

Serial Number	Function	Detail
А	Pattern number	Display current pattern number
В	Presser pedal detection	Presser pedal detection Show if the presser foot pedal can be used (cannot be used as automatic presser, can be modified in the machine parameter interface)
С	Sewing pedal detection	Show if the sewing pedal can be used (cannot be used for automatic sewing, can be modified in the machine parameter interface)
D	Sewing count	Display sewing count (can be cleared in the sewing count interface)
E	Time	Show current time
F	L1,Label length	First line on the left L1 label length
G	L2,Label length	Second line on the leftL2 label length
Н	R1,Label length	First line on the rightR1 label length
I	R2,Label length	Second line on the rightR2 label length
J	Start up	Press the button to enter the continuous sewing state, press this button to switch to continuous sewing state when the machine is started once. $_{\circ}$
К	Start once	Press the button to enter the single sewing state, press this button to switch to the single sewing state when the machine is in continuous state, Stop when the sewing ends.

L	Stop	Stop the action and reset immediately during the "Repeat Run" or "Start
		Once" process.

#### 5.3 Pattern Browsing



to enter the pattern browsing interface (as shown below). For detailed function Press the right icon

descriptions, see the function key description table.

#### **Function Description:**

					and the second		
No.	Function	Content	А	$\rightarrow$	♪ 🛛 <		С
Δ	Pattern	Displays the current pattern number					
Π	Number	Displays the current pattern hamser			$\begin{bmatrix} 1 \\ 1 \end{bmatrix} \begin{bmatrix} 1 \\ 2 \end{bmatrix} \begin{bmatrix} 2 \\ 1 \end{bmatrix} \begin{bmatrix} 1 \\ 1 \end{bmatrix} \begin{bmatrix} 1 \\ 2 \end{bmatrix} \begin{bmatrix} 1 $		
л	Selection						
в	Area	Display the patterns that can be selected					
G	т.'.	Exit the pattern browsing selection and keep the				_	n
С	Exit	pattern selection before entering the interface.					ν
D	Confirm	Confirm the new selected pattern	В	$\rightarrow$	Li 100.0 mm Li 100.0 mm		
F	Dagaun	Pageun					E
Ľ	Tage up				<b>O</b> +	_	F
F	Page down	Page down					•
<i>a</i>	51	Delete selected patterns (cannot delete all			<b>∭</b> ≮	_	G
G	Delete	patterns, must retain at least one pattern)			Pattern Browsing Interface		

#### 5.4 Design new pattern

No. Press the right icon . Enter the new pattern design interface (as shown below). For detailed function descriptions, you can see the function key description table.

#### **Function Description:**

No.	Function	Content
А	Pattern Number	Display the number of the new pattern you need to create
В	Input Area	Display pattern number keyboard input area
С	Exit	If you exit new pattern design, no new pattern will be created
D	Confirm	Confirm that the new pattern needs to be created. If the pattern already exists, this button will not be displayed.



New pattern design interface

Press the right icon descriptions, you can



enter the pattern copy interface(as show on the right side). For detailed function

#### see the function key description table.

#### **Function Description:**

No.	Function	Content
А	Pattern Number	Display the copied pattern number
В	Selection Area	Display the copied pattern number selection area
С	Exit	If you exit pattern copy, the pattern will not be copied
D	Confirm	Confirm the selected pattern and it will be copied
Е	Сору	Enter the pattern copy interface 2
F	Page Up	Page Up
G	Page Down	Page Down
Н	Copied pattern number	Display the copied pattern number
Ι	Input Area	Input the copied pattern number
J	Exit	Exit the pattern copy
K	Copy pattern number	Display the copied pattern number
L	Confirm	Confirm the pattern of copying H to K



Pattern copy interface 2

#### 5.6 Label Parameter Setting

Press the right icon

, enter the corresponding label parameter setting interface, two trademarks on the

left and right side, click the corresponding button to enter the corresponding label parameter setting interface (as shown in the right figure). At the same time, the button screen will change according to the functions of

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"Enable" and "Fold". For detailed function description, see the function key description table.





Label parameter setting

Functio	Function Description:		
No.	Function	Content	
А	Whether it works	It determines whether the label works. If it works, the label can be transferred and the opposite will not. The 4 labels overlap as shown on the right figure.	
В	Whether it is folded in half	It determines whether the label is folded in half. If the label can be folded in half, the label cannot be transferred and the opposite will not.	
С	First delivery length	The folding delivery label is divided into two sections. The first section determines whether the front end of the folding is flush, which is generally set as 22-24mm. As shown in the figure below, when the lower part is too short, parameters need to be increased. When the bottom is too long, you need to reduce the parameters.	
D	Mode Selection	Select mark line mode or first discoloration point detection	
Е	Label line before marking the length of solid color	Take the black line on a white background as an example, there will be a blank area before and after the black marker line, and the length of this area is required to be input, generally 6mm, as shown in the figure below	
F	Label line before marking the length of solid color	Take the black line on a white background as an example, there will be a blank area before and after the black marker line, and the length of this area is required to be input, generally 6mm, as shown in the figure below	
G	Label length	Enter label length. Enter the length between the two label lines as shown in the figure below.	
Н	The distance from the fiber point to the edge	Optical fiber point to the knife edge distance, generally 43mm, related to the mechanical structure of the machine itself, generally not adjusted.	
I	Label incision fine adjustment	Label notch trimming. When the black marker line is too much, set this value to -1 if it is 1mm too much. When there are not enough black lines, set this value to 1 if 1mm is missing. As shown in the figure below.	
J	Stepper motor speed	Stepper motor speed gear, a total of 10 files, respectively 1-10.	
K	Send labels only by label length	When this option is selected, it will not be sent according to the marking line. The more the number of labels is sent, the higher the offset error is. This option is generally not selected.	
L	The length from the tangent point to the first discoloration point	It is suitable for the detection method without marking lines, taking the black text on a white background as an example, the distance from the cutting point to the point of the first color change.	
Μ	Exist	Exit settings	



#### 5.7 label position adjustment

Press \_\_\_\_\_ to enter the label position adjustment mode to adjust the label (as shown in figure below). See function key description table for detailed function description.

#### function description:

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label position adjustment-

Name	Function	Contents
А	First label on the left side	First label area on the left side.
В	Second label on the left side	Second label area on the left side.
С	First label on the right side	First label area on the right side.
D	Second label on the right side	Second label area on the right side.
E	Exit	Exit the label position adjustment mode.

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F	Enabling	Enable corresponding label, lift cylinder below, make label move
G	Label comes out	Keep press corresponding label to make label come out, it stops
		when not pressed.
Н	Label retracts	Keep press corresponding label to make label retract, it stops
		when not pressed.
	Knife	It moves when press corresponding knife, and it resets when
I		press it again.

#### 5.8 Label feeding test mode

Press to enter label feeding test mode to do test of label feeding (as shown in figure below). See function key description table for detailed function description.

#### function description:



Name	Function	Contents
А	Exit	Exit label feeding test mode.
В	Single label feeding	Press the corresponding label to feed the label once (no fold), which can be used to confirm the corresponding label parameters.
С	Repetitive	Press the corresponding label to feed the label repeatedly ( no
	label feeding	fold).

#### 5.9 Program information interface

i

to enter program information interface as shown in the figure

In the **sewing data input interface**, press below, and then press again to return to sewing data input interface. The program information interface displays the program version.

į	
HMI software version:	V 02 · 03
MCU software version:	$\mathbf{V}$ 00 $\pm$ 00

Program version

#### 5. 10 pattern parameter file transfer

In sewing data input interface, press

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to enter pattern parameter file transfer as shown in the figure below, and then press again to return to sewing data input interface. See function key description table for detailed function description.

#### Note: insert usb flash drive before operation. **Function description:**

Name	Function	Contents
А	File selection	Select standard file.bin.
В	File selection	Select userfile.bin.
С	File selection	Select statussfile.bin.
D	Transfer direction selection	Sets up transferring files from the usb flash drive to panel.
E	Transfer direction selection	Sets up transferring files from panel to the usb flash drive.
F	Execution	Execute based on file selection and transfer direction selection.Follow the prompts to Execute subsequent movements.



pattern parameter file transfer+

#### 5.11 Setting interface



sewing data input interface @

to enter setting interface as shown in the figure below, and then In sewing data input interface, press press again to return to sewing data input interface. See function key description table for detailed function description.

#### Function description:

Name	Function	Contents
	Machine parameter	Set common machine parameters, such as delay, malfunction and pedal
A	1 setting	setting.
В	Malfunction history	Display malfunction history.
C	Machine parameter	Set not commonly used machine parameters, which requires password to
C	2 setting	enter.
П	Single step	Test single stop operation which requires password to opter
D	operation	Test single step operation, which requires password to enter.
E	Parameter reset	Parameter reset, which requires password to enter.
F	Diagnostic mode	Enter input/output diagnostic mode.
	Switch between	
G	Chinese and	Language switching between Chinese and English.
	English	
Н	Count	Display count information.

#### 5.12 Machine parameter 1 setting

to enter machine parameter 1 setting interface, there are 4 pages in total. Page turning can be done Press by up and down page, and press the exit key to exit, as shown in the figure below. See function key description table for detailed function description.



#### **Function description:**

Name	Function	Contents
А	Left label 1 label clamping cylinder delay	Left label 1 label clamping cylinder delay, the default time is 400ms.
В	Left label 2 label clamping cylinder delay	Left label 2 label clamping cylinder delay, the default time is 400ms.
С	The left knife delays to cut downwards	The left knife delays to cut downwards, the default time is 300ms.
D	The left knife delays to lift upwards	The left knife delays to lift upwards, the default time is 100ms.
E	The left rotating cylinder delays to fold	The left rotating cylinder delays to fold, the default time is 300ms.
F	The left rotating cylinder delays to stretch	The left rotating cylinder delays to stretch, the default time is 400ms.
G	It delays to blow left downwards	It delays to blow left downwards, the default time is 500ms.

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Н	Right label 1 label clamping cylinder delay	Right label 1 label clamping cylinder delay, the default time is 400ms.
I	Right label 1 label clamping cylinder delay	Right label 2 label clamping cylinder delay, the default time is 400ms.
J	The right knife delays to cut downwards	The right knife delays to cut downwards, the default time is 300ms.
К	The right knife delays to lift upwards	The right knife delays to lift upwards, the default time is 100ms.
L	The right rotating cylinder delays to fold	The right rotating cylinder delays to fold, the default time is 300ms.
М	The right rotating cylinder delays to stretch	The right rotating cylinder delays to stretch, the default time is 400ms.
Ν	lt delays to blow right downwards	It delays to blow right downwards, the default time is 500ms.
0	Left label 1 fails to track label thread detection	Left label 1 fails to track label thread detection, it's switched on by default.
Ρ	Left label 2 fails to track label thread detection	Left label 2 fails to track label thread detection, it's switched on by default.
Q	Right label 1 fails to track label thread detection	Right label 1 fails to track label thread detection, it's switched on by default.
R	Right label 2 fails to track label thread detection	Right label 2 fails to track label thread detection, it's switched on by default.
S	Pressure detection	Detection for pressure malfunction, it's switched on by default.
Т	Automatic presser foot	Automatic press presser foot when detecting fabric placed, it's switched off by default.
U	Automatic sewing	It automatically sews when press presser foot, it's switched off by default.
V	The safe time from the photoelectric sensor detects fabric placed and automatic presser foot pressing	It delays after the photoelectric sensor detects fabric placed and automatic presser foot pressing, the default time is 200ms.
W	The safe time from the photoelectric sensor detects fabric taken away and label feeding	After sewing, it delays after the photoelectric sensor detects fabric taken away and label feeding, the default time is 200ms.
х	Rodless cylinder delays to feed label	Rodless cylinder delays to feed label the default time is 400ms.

#### 5.13 Alarm history interface



to enter Alarm history interface

See function key description table for detailed function description.



#### Function description:

Name	Function	Contents
А	Alarm history display	Display alarm history
В	Exit	Exit alarm history display

#### 5.14 Machine parameter 2 setting



Press , and input password"21" to enter **Machine parameter 2 setting interface** as shown in the figure below. See function key description table for detailed function description.

		Parameter	I
Α	$\rightarrow$		
В	$\rightarrow$	Light Start Sensor not work (used only in runing in test)	
С	$\rightarrow$	Left blow down function disable Right blow down function	
D	$\rightarrow$	disable Left stepmotor factor 6250 pulse	
E	$\rightarrow$	Deliver by length 100mm server the label length as 11, record the original factors as 2, then the correct factor shall be yrs2 *100 /11 <b>Right stepmotor factor</b> 6250 pulse	
F	$\rightarrow$	Left cut counts 0 0	
G	$\rightarrow$	Right cut counts 0	
Н	$\rightarrow$	All sewing counts 0	
		<b>∑</b> ← J	

Page 1 function description

#### Page 1 function description:

Name	Function	Contents
А	Photoelectric sensor non effective	For durable run-in, it's switched off by default.
В	Blow left downwards function off	For turning off blow left downwards function, it's switched off by default.
С	Blow right downwards function off	For turning off blow right downwards function, it's switched off by default.
D	Left stepping motor coefficient	Set left stepping motor coefficient, the default value is 6250.
E	Right stepping motor coefficient	Set right stepping motor coefficient, the default value is 6250.
F	Left knife operation times	Record left knife operation times, it needs password when zero cleaning.
G	Right knife operation times	Record right knife operation times, it needs password when zero cleaning.
Н	Total sewing times	Record total sewing times, it needs password when zero cleaning.
	Exit	Exit machine parameter 2 setting
J	Next page	Enter into page 2 setting

#### Page 2 function description:



к	Left 1 knife heated function on	For factory data reset, suitable for knife heated machine.
L	Left 2 knife heated function on	For factory data reset, suitable for knife heated machine.
М	Right 1 knife heated function on	For factory data reset, suitable for knife heated machine.
Ν	Right 2 knife heated function on	For factory data reset, suitable for knife heated machine.
0	Heated knife going forward distance	Set knife heated parameter and going forward distance
Ρ	Heated knife going backward distance	Set knife heated parameter and going backward distance
Q	Exit	Exit machine parameter 2 setting
R	Previous page	Back to page 1 setting

#### 5.15 Factory data reset



#### 5.16 Diagnostic mode



enter **Diagnostic mode** as shown in the figure below. See function key description table for detailed

function description.

Page 1 function description:



#### Diagnostic mode-

Name	Function	Contents
А	Input	Enter input port testing interface
В	Motor	Enter stepper motor testing interface
С	Output	Enter output port testing interface
D	Exit	Exit diagnostic mode



Input port testing







#### Output port testing

#### 5.17 Language setting



then Chinese and English can be switched.

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#### 5.18 Count information display



and enter **Count information display** as shown in the picture below.



Count information display

#### 6. Adjustment

#### 6.1 Process of replace washing label and machine equipment setting

When replacing washing label and technology, the program and equipment should be debugged. This manual explains the debugging of up to 4 trademarks.

1) debug the alignment between the two washing marks on the left. When both washing marks are not fold,



fig. 6.1.1 left washing label

alignment fig.



6.1.2 left secondary cylinder

adiustment

alignment between the two marks mainly includes left alignment, right alignment and center alignment, which is actually to adjust the distance X1 on the left side of the washing label (as shown in figure 6.1.1). The adjustment of the parameter is mainly achieved by moving the position of the left secondary cylinder on the fixed frame, as shown in fig. 6.1.2, loosen screw A, then move the fixed seat to the left and therefore the left washing label 1 shown in fig. 6.1.1 moves to the left, same as adjustment towards right.

2) when the trademark is folded, as shown in fig. 6.1.3, if the two cutting edges of the washing label are not aligned after folding, the length of label can be folded by adjusting the distance Y1 between the two cutting edges (refer to label parameter setting of 5.6), and the factory default parameter of folded length is 24mm.



fig. 6.1.3 left washing label alignment

adjust the left side distance of the two right washing marks by adjusting screw B in fig. 6.1.4 2)



fig. 6.1.4 right washing label alignment

4) after washing labels on both sides are adjusted in place, then adjust Z1 parameters between washing labels on the left and the right (as shown in fig. 6.1.5), loosen the nuts C and D of the oil buffer in fig. 6.1.6 and 6.1.7, then rotate and adjust the position of the oil buffer to close, and then lock the nuts C and D. It is recommended to adjust one side first, and then adjust the other side after the adjustment first time fails.

5) finally, adjust the alignment of the cutting edges of washing labels on both sides. Loosen screw E in fig. 12.8 on the



fig. 6.1.5 left washing label alignment fig.6.1.6 left washing label alignment alignmentalignment

adjustment

fig.6.1.7 right washing label alignment adjustment

left side and follow the arrow direction in fig 12.8 and then lock E, same as adjustment of the right side. Or just adjust only one side to make alignment.



fig.6.1.8 adjust the alignment of the cutting edges of washing labels

6) when washing label is folded, the folding deviation may occur, as shown in fig. 6.1.9. At this time, it is necessary to adjust label feeding device and clamp feeding device to perpendicular, as shown in fig. 6.1.10. The following is detailed adjustment:



fig.6.1.9 adjust washing label on right side to make alignment.



fig.6.1.10 position

Firstly, observe whether clamp feeding device and the presser foot are parallel, as shown in fig. 6.1.11. If it is not parallel, release screw F shown as fig. 6.1.12, and adjust clamp feeding device's position to parallel presser foot and then lock screw F.



Then measure whether label feeding device and clamp feeding device are perpendicular (as shown in fig. 6.1.10). If

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not, continue to adjust the position of label feeding device as shown in fig. 6.1.13, loosen screw G and adjust label feeding device and clamp feeding device to be perpendicular and then tighten screw G.



fig. 6.1.13 adjust label feeding device

#### 6.2 Photoelectric Sensors Adjustment

There is one photoelectric sensor, numbered LS01, located at the head.

Step 1: Turn Knob A to the picture as shown

Step 2: Adjust knob C to achieve the following effect: When no fabric is placed below, the indicator B is orange; when the fabric is placed below, the indicator B is off.



Knob A Indicator B Knob C



#### 6.3 Optical Fiber Amplifier Adjustment

There are four optical fiber amplifier, numbered LS43、LS44、LS23、LS24, located at the label feeding device on two sides.

Note: The distance between the fabric and the fiber has a large influence on the value, so the fiber amplifier should be adjusted so that the label feeding plate is in the working position. Refer to "5.7 Label Position Adjustment" to enter the label position adjustment, press the ABCD button in "5.7 Label Position Adjustment", and then adjust the corresponding fiber amplification according to the following steps.



#### 2) L-on/d-on Settings

When the label is black on white, it should be set to d-on; when it is white on black, it should be set to L-on.

•MODE indicator •When L/D(Yellow) lighting, can set the detection output action



3) Setting the amount of light, generally setting the amount of light to be medium



is still the low sensitivity ("L-P").

#### 4) Threshold setting

Method 1: 2 points Instruction, as shown below. Take the black text on the white label as an example, when the red dot of the fiber shines on the white background, press the first SET; when the red dot of the fiber shines on the black line, press the second SET. If "good" is displayed, the Instruction is successful.



Method 2: The fiber values for the white background and black lines can be recorded separately, and then the threshold is adjusted by pressing "+" or "-" to make it at the average of the two values.

#### 6.4 Rodless Cylinder Sensor Adjustment

There are four rodless cylinder sensors, numbered SE41、SE42、SE21、SE22, located at the two sides of the two rodless cylinders

The adjustment effect is: when the rodless cylinder is at both ends, the corresponding detection sensor light is on.



Sensor



#### 6.5 Proximity Switch Adjustment

There is one proximity switch, numbered SE10, located at the end of the machine head, covered by a tail hood. When the presser foot moves, the detected object moves. Therefore, the detected object is detected to indicate the presser foot action.

Adjustment requirements: When the presser foot is raised, the indicator light is on; when the presser foot is pressed, the indicator light is off.



#### 6.6 Air Pressure Detection Adjustment

There is one air pressure detector, located on the lower left side of the platen. The black arrow in the barometer is the Set pressure, and the green arrow is the Alarm indicating pressure

After the machine is connected to the air, pull out the Adjustment knob and turn the adjustment knob to set the air pressure to 0.5 MPa.

Open the glass cover of the barometer and turn the green arrow to set the Alarm indicating pressure to 0.4 MPa.



#### 6.7 Pressure Regulator Adjustment

Enter the diagnostic mode, respectively air the corresponding tube, and then adjust the corresponding air pressure. After the air pressure is adjusted, the nut should be locked.

The air pressure in the table below is for reference only, and the actual air pressure will vary depending on the actual commissioning.

Label	Air pressure
TB45	4bar
TS45	4bar
TB41	4bar
TB40	4bar
TB25	4bar
TS25	4bar
TB21	4bar
TB20	4bar



#### 7. Maintenance



The power and air pressure sources must be disconnected when replacing machine parts, maintaining or disassembling the machine. Only professionals can do the following operations.

#### Motor cleaning

Clean the motor regularly with a gas nozzle.

#### Needle plate cleaning

Loosen the screws, clean the needle plate, and then restore the position

#### Lubrication

Check the surface level of the head lubricant regularly and fill it up with white oil if necessary.

#### Destroy the machine

If want to destroy the machine, separate the parts and send them to the appropriate collection point.

#### 8. Fault Resolution

ER01 Left label 1 didn't find the label line				
	The label is used up; the label line is printed incorrectly; the			
Cause	label sending is invalid; the label parameter setting is			
	incorrect; others.			
	Check the label and label line and please check if the label			
Solution	is sent correctly. If it is not correct, you can finely adjust it			
	manually to clear the fault.			

ER02 Left label 2 didn't find the label lineCauseThe label is used up; the label line is printed incorrectly; the<br/>label sending is invalid; the label parameter setting is<br/>incorrect; others.SolutionCheck the label and label line and please check if the label<br/>is sent correctly. If it is not correct, you can finely adjust it<br/>manually to clear the fault.

ER03 Right label 1 didn't find the label line			
	The label is used up; the label line is printed incorrectly;		
Cause	the label sending is invalid; the label parameter setting is		
	incorrect; others.		
	Check the label and label line and please check if the label		
Solution	is sent correctly. If it is not correct, you can finely adjust it		
	manually to clear the fault.		

ER04 Right label 2 didn't find the label line				
	The label is used up; the label line is printed incorrectly;			
Cause	the label sending is invalid; the label parameter setting is			
	incorrect; others.			
	Check the label and label line and please check if the label			
Solution	is sent correctly. If it is not correct, you can finely adjust it			
	manually to clear the fault.			

ER05 The head is not reset (the presser foot is not raised)			
Cause	The head is not reset; the sensor SE10 is faulty or its wiring		
	is faulty.		
Solution	Please enter the sewing machine into the sewing mode or		
	check the sensor SE10, self-recovery after troubleshooting.		

ER06 Insufficient pressure			
Cause	No air o air pressure detection sensor setting failure or		
	wiring failure.		
Solution	Please check the air pressure or air pressure detection		
	settings and wiring, self-recovery after troubleshooting		

ER07 Machine reset was unsuccessful							
Cause	Rodless cylinder sensor SE22 and SE42 signal abnormalities						
Please check if the rodless cyl				ess cylir	cylinder sensors SE22 and SE42		
Solution	are	abnormal,	and	they	will	self-recovery	after
	trou	oleshooting					

ER08 Touch screen communication reception failure				
Cause	Touch screen communication reception failure			
Solution	Please power off and check the communication line and			
	restart			

ER09 Control board communication reception failure				
Cause	Control board communication reception failure			
Solution	Please power off and check the communication line and			
Solution	restart			

ER10 Remove items from the sewing table			
Causa	There are items on the sewing table; or the sensor LS01 is		
Cause	abnormal.		
Solution	Please remove the items on the sewing table or check if the		
Solution	photoelectric sensor LS01 is abnormal.		

ER11 Please put a piece of fabric to sew						
Cause	No fabric is placed; or sensor LS01 is abnormal					
Solution	Please put a piece of fabric to sew, or check if the					
	photoelectric sensor LS01 is abnormal.					

ER12 The	presser foot is not raised. The threading operation is in				
progress.					
Causa	The presser foot is not raised. The threading operation is in				
Cause	progress.				
Solution	End the threading, self-recovery after exiting the threading				
Solution	mode				

#### 9. Remaining list

In order to quickly and easily confirm the remaining part of the need, a Parts Manual is provided, which contains a list of parts, an exploded view and its serial number.



# Parts Manual



## 9.1、折叠装置(左/右)

序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量(Number)
1	48102051		夹紧架	Clamping frame	1
2	207S14014		止浮螺丝M3*3	Anti-floating screw M3*3	2
3	48109053		销轴座	Pin seat	2
4	48102072		轴座固定轴	由座固定轴 Axle seat fixed shaft	
5	S05093		4*25内六角螺钉 M4*25 hexagon socket screws		2
6	S09012		止浮螺丝M4*5 Anti-floating screw M4*5		2
7	48109051		偏心轮支架 Eccentric bracket		1
8	701S13033		M3*16内六角螺钉	M3*16 hexagon socket screws	3
9	B09008		HK1208轴承 HK1208 bearing		1
10	48102052		偏心柱	Eccentric column	1
11	48145010		倒钩式气管弯头	Barbed tracheal elbow	2
12	48145004		摆动气缸	Swing cylinder	1
13	48109052		夹紧架	Clamping frame	1
14	48112051		右折叠板	Right folding board	1
	48112052		左折叠板	Left folding board	1
15	S04116		十字槽小盘头螺钉 M5×8 不锈钢	Cross recessed small pan head screw $M5 imes 8$ stainless steel	2
16	48112052		GL21-01-007左折叠板	GL21-01-007 left folding board	1

### 9.2、放料标架 Unwinding frame



9.2、放料标架 Unwinding frame

序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1	701S13001		M5*16内六角螺钉	M5*16 hexagon socket screws	2
2	48109055		长支撑板	Long support plate	2
3	48103053		轴环	Shaft ring	3
4	S09021		M4*3止浮螺丝	M4*3 anti-floating screw	3
5	S02068		M4*8沉头螺钉	M4*8 anti-floating screw	2
6	48112055		挡标板	Plate to block the label	2
7	48103052		放置套	Ring to load label	2
8	S09012		止浮螺丝M4*5	M4*5 anti-floating screw	2
9	48102055		放料轴	Axis to load label	1
10	4810905400		大压标架	Large shelf to hold down the label	2
11	W01001		M4用平垫片	Flat gasket for M4	2
12	S05859		M4*8内六角螺钉	M4*8 hexagon socket screws	2
13	4810905600		宽度调节板 Width adjustment board		2
14	48102054		制动轴	Brake shaft	1
15	701S13001		M5*16内六角螺钉	M5*16 hexagon socket screws	2
16	701S13006		M8*35圆柱头螺钉	M8*35 Cylinder head screws	1
17	W06003		M8碟形垫圈	Dish gasket for M8	1
18	41228004		M8平垫	Flat gasket for M8	4
19	S05008		M8*50内六角圆头螺钉	M8*50 hexagon socket head screw	1
20	S05263			M8*100 hexagon socket screws	1

9.3、送标装置部件Label feeding device parts



9.	3、	送标装置部件Label	feeding	device	parts
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序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName 零件描述 Description		数量 (Number)
1	48111003		机	Rack guard	1
2	\$05058		かに未めず 平 M4*10曜年T	Max10 scrows	4
3	48147002		圆形磁铁	Round magnet	3
4	701\$16015		M4螺母	M4 nut	3
5	S02068		M4*8沉头螺钉	M4*8 countersunk head screws	4
6	48112062		弹簧片压板	Spring plate	2
7	48109081		左送料板	Left feed plate	1
8	48109082		右送料板	Right feed plate	1
9	48112061		弹簧板	Spring plate	2
10	S05911		内六角圆柱头螺钉 M3X3	Hexagon socket head screw M3X3	6
11	48145017		圆柱形气缸	Cylindrical cylinder	1
12	42130032		节流阀	Throttle valve	2
13	48109080		气缸固定架	Cylinder fixing frame	1
14	S09114		M5*5止浮螺丝	M5*5 anti-floating screw	1
15	70128219		M5斜印花垫片	M5 diagonal printing gasket	3
16	701S13001		M5*16圆柱头螺钉	M5*16 cheese head screw	2
17	701S16017		M6螺母	M6 nut	1
18	48145022		气缸叉形头	Cylinder cross head	1
19	S09021		M4*3止浮螺丝	M4*3 anti-floating screw	5
20	48103053		轴环	Shaft ring	1
21	48127001		刀轴弹簧	Knife shaft spring	1
22	48103058		圆柱轴套686	Cylindrical bushing 686	1
23	48109087		气缸连杆1个	Cylinder connecting rod 1 pcs	1
24	H05018		3.5卡簧	3.5 circlip	1
25	S05005		M5*12螺钉	M5*12 screw	1
26	48109078		连接架	Connection frame	1
27	48103057		圆柱轴套575	Cylindrical bushing 575	1
28	48102074		短销	Short tip	1
29	48102058		刀主轴	Knife spindle	1
30	48103056		圆柱轴套8*10*10	Cylindrical sleeve 8*10*10	2
31	48102062		下滚轮轴	Lower roller shaft	2
32	48109085		右滚轮架	Right roller frame	1
33	207S14014		M3*3止浮螺丝	M3*3 anti-floating screw	19
34	48109086		滚轮架	Roller frame	1
35	S05021		内六角圆柱头螺钉M3X5	Hexagon socket head screw M3X5	6
36	48125010		下滚轮	Lower wheel	2
37	B09001		HK0408TN轴承	HK0408TN bearing	4
38	48109091		压料杆座	Fabric holder rod base	1
39	48102061		压料杆	Fabric holder rod	1
40	48112076		标签限位轴环	Label limit ring	3
41	S05403		M3*8内六角螺钉	M3*8 hexagon socket screws	10
42	48112072		长磁吸座	Long magnetic holder	1
43	S09012		M4*5止浮螺丝	M4*5 anti-floating screw	4
44	48130006		螺纹式M3光纤头	Threaded M3 fiber optic head	2
45	48109093	ļ	镜头座	Lens mount	2
46	48109095	ļ	透光块	Transparent block	2
47	48130007	ļ	光纤镜头	Fiber optic lens	2
48	28045035		微型气缸 ϕ 4-5	Micro cylinder Φ4-5	2

49	48109094	小圆柱气缸座	Small cylindrical cylinder seat	2
50	48103054	铜塞	Copper plug	2
51	S05054	M3*20螺钉	M3*20 screw	2
52	48102059	传感器固定轴	Sensor fixed axis	1
53	48130003	光纤放大器	optical fiber amplifier	2
54	S05402	M3*6内六角螺钉	M3*6 hexagon socket screws	8
55	48112064	放大器座	Amplifier base	1
56	48102060	上滚轮轴	Upper roller shaft	1
57	4812500400	40滚轮	40 roller	1
58	4812500700	43滚轮	43 roller	1
59	S05031	M6*20内六角螺钉	M6*20 hexagon socket screws	2
60	70128220	M6印花垫圈	M6 printed washer	4
61	41228016	M6平垫圈	M6 flat washer	2
62	48109077	机架支撑臂	Frame support arm	1
63	B01001	F686轴承	F686 bearing	2
64	701S13027	M6*35内六角螺钉	M6*35 hexagon socket screw	2
65	48109092	连接块	Connector	1
66	701S16013	M6方形扁螺母	M6 square flat nut	2
67	S05264	M6*12沉头螺钉	M6*12 countersunk head screws	2
68	S05160	M3*30内六角螺钉	M3*30 hexagon socket screws	4
69	42136001	快换弯头	Quick change elbow	2
70	48145003	薄型气缸	Thin cylinder	2
71	48133001	42步进电机	42 step motor	1
72	S05859	M4*8内六角螺钉	M4*8 hexagon socket screws	2
73	48109083	电机支架	Motor bracket	1
74	48125003	主动同步带轮	Active timing pulley	1
75	W01002	M3垫片	M3 gasket	6
76	48109079	送料机架	Feeding frame	1
77	48109090	吹气座	Blow seat	1
78	48121001	鼓风弯管	Blow elbow	1
79	48121002	长鼓风弯管	Long blow elbow	1
80	48109084	导布板	Plate	1
81	48119004	下刀	Lower knife	1
82	48119003	上刀	Upper knife	1
83	S02081	M5*10内六角沉头螺钉	M5*10 Hexagon socket countersunk head screws	1
84	48109088	上刀盖板	Upper knife cover	1
85	701S13033	M3*16螺钉	M3*16 screw	1
86	48121003	左上吹气管	Upper left blowpipe	1
87	48112074	吹气管安装块	Blowpipe installation block	1
88	48125002	从动同步带轮	Driven synchronous pulley	1
89	48135001	T5-245-6同步带	T5-245-6 timing belt	1
90	48109089	同步带盖板	Timing belt cover	1
91	S05266	M4*12螺钉	M4*12 screw	2
92	48112073	短磁吸座	Short magnetic holder	1
93	48147001	强磁铁	Strong magnet	4
94	48121004	右上吹气管	Upper right blowpipe	1

9.4、送夹部分(左)Clamping part (left)



## 9.4、送夹部分(左)Clamping part (left)

序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1	48111002		左气缸防护罩	Left cylinder guard	1
2	42136001		快换弯头KQ2L04	Quick change elbow KQ2L04	2
3	42130032		节流阀	Throttle valve	4
4	48126010		销钉	Pin	1
5	48145001		圆柱形气缸	Cylindrical cylinder	2
6	48145006		气缸叉形头M4*8	Cylinder fork head M4*8	2
7	48109075		左后夹	Left rear clip	1
8	S09012		M4*5止浮螺丝	M4*5 anti-floating screw	1
9	48109073		左下夹	Lower left clip	1
10	48109074		左前夹	Left front clip	1
11	48102073		夹紧销	Clamping pin	1
12	70128224		M4斜印花垫片	M4 diagonal printing gasket	2
13	S05266		M4*12内六角螺钉	M4*12 hexagon socket screws	3
14	48109076		左支撑臂	Left support arm	1
15	207S14014		M3*3止浮螺丝	M3*3 anti-floating screw	1
16	48109067		轴承座	Bearing base	1
17	207S11012		M4*10圆头十字螺钉	M4*10 round head cross screw	2
18	S05403		M3*8内六角螺钉 M3*8 hexagon socket screws		18
19	48112060		拖链支撑板 Drag chain support plate		1
20	S05402		M3*6内六角螺钉 M3*6 hexagon socket screws		6
21	S05188		M4*30内六角螺钉 M4*30 hexagon socket screws		2
22	48109071		左侧垫块 Left pad		1
23	48145008		舌簧式气缸C型槽接近开关 C-slot proximity switch for reed cylind		2
24	S05058		M4*10螺钉 M4*10 screws		4
25	48112071		气缸防护罩支撑座	Cylinder protective cover support base	2
26	48145002		无杆气缸	Rodless cylinder	1
27	48145007		无杆气缸支撑件	Rodless cylinder supporting item	4
28	41536009		节流阀	Throttle valve	1
29	48145024		消声器	Silencer	1
30	48145016		圆柱形气缸	Cylindrical cylinder	1
31	48109072		左气缸支架	Left cylinder bracket	1
32	W01009		M5平垫圈	M5 flat washer	2
33	70128219		M5斜印花垫片	M5 diagonal printing gasket	2
34	701S13001		M5*16内六角螺钉	M5*16 hexagon socket screws	2
35	48102057		气缸杆帽	Cylinder rod cap	1
36	48109066		调节板	Adjustment plate	1
37	48109070		左	Left partition bracket	1
38	48109060			Fixed bracket	1
39	S05031		M6*20内六角螺钉	M6*20 hexagon socket screws	4
40	70128220	<b> </b>	M6斜印花垫片	M6 diagonal printing gasket	4
41	41228016		M6垫片	M6 gasket	4
42	701S16013		M6万形螺母	M6 square nut	4
43	48131010	L	拖链0.33米 Drag chain 0.33m		1



9.5、送夹部分(右)Clamping part (right)

## 9.5、送夹部分(右)Clamping part (right)

序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1	48111001		右气缸防护罩	Right cylinder guard	1
2	S05188		M4*30内六角螺钉	M4*30 hexagon socket screws	2
3	48109062		右支撑臂	Right support arm	1
4	48109064		右侧垫块	Right pad	1
5	S05266		M4*12内六角螺钉	M4*12 hexagon socket screws	3
6	S05403		M3*8内六角螺钉	M3*8 hexagon socket screws	18
7	48112060		拖链支撑板 Drag chain support plate		1
8	S05402		M3*6内六角螺钉	M3*6 hexagon socket screws	6
9	207S14014		M3*3止浮螺丝	M3*3 anti-floating screw	1
10	48109067		轴承座	Bearing base	1
11	48126010		销钉	Pin	1
12	207S11012		M4*10圆头十字螺钉	M4*10 round head cross screw	2
13	48145001		圆柱形气缸	Cylindrical cylinder	2
14	42136001		快换弯头KQ2L04	Quick change elbow KQ2L04	2
15	42130032		节流阀	Throttle valve	4
16	48145006		气缸叉形头M4*8	Cylinder fork head M4*8	2
17	48109068		右后夹	Right rear clip	1
18	48109069		右下夹	Lower right clip	1
19	S09012		M4*5止浮螺丝	M4*5 anti-floating screw	1
20	48109061		右前夹 Right front clip		1
21	48102073		夹紧销 Clamping pin		1
22	70128224		M4斜印花垫片	M4 diagonal printing gasket	2
23	S01199		M2*3内六角螺钉	M2*3 hexagon socket screws	2
24	48112077		标签引导板 Label guide plate		1
25	48112075		送布导向板	Feeding guide plate	1
26	S05058		M4*10螺钉	M4*10 screws	4
27	48112071		气缸防护罩支撑座	Cylinder protective cover support base	2
28	48145008		舌簧式气缸C型槽接近开关	C-slot proximity switch for reed cylinder	2
29	48145002		无杆气缸	Rodless cylinder	1
30	48145007		无杆气缸支撑件	Rodless cylinder supporting item	4
31	S05031		M6*20内六角螺钉	M6*20 hexagon socket screws	4
32	70128220		M6斜印花垫片	M6 diagonal printing gasket	4
33	41228016		M6垫片	M6 gasket	4
34	48109060		固定支架	Fixed bracket	1
35	701S16013		M6方形螺母	M6 square nut	4
36	48109065		右隔板支架	Right partition bracket	1
37	48102057		气缸杆帽	Cylinder rod cap	1
38	48109063		右气缸支架	Right cylinder bracket	1
39	W01009		M5平垫圈	M5 flat washer	2
40	70128219		M5斜印花垫片	M5 diagonal printing gasket	2
41	701S13001		M5*16内六角螺钉	M5*16 hexagon socket screws	2
42	48109066		调节板	Adjustment plate	1
43	48145016		圆柱形气缸	Cylindrical cylinder	1
44	41536009		节流阀	Throttle valve	1
45	48145024		消声器	Silencer	1
46	48131010		拖链0.33米	Drag chain 0.33m	1

9.6、支撑架部件(右)Support frame parts (right)



9.6、	支撑架部件	(右)	Support	frame	parts	(right)	
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序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1			机头自带显示屏座	Machine head comes with display base	1
2	70128219		M5印花垫片	M5 printed gasket	4
3	S05083		GB/T 70.1 螺钉 M5×30 8.8级 镀白锌	GB/T 70.1 screw M5 $ imes$ 30 8.8 grade white zinc plated	2
4	S05092		GB/T 70.1 螺钉 M5×20 8.8级 镀白锌	GB/T 70.1 screw M5 $ imes$ 20 8.8 grade white zinc plated	2
5	42111007		显示屏座	Display base	1
6	70133611		M5方形螺母	M5 square nut	4
7	70101339		TB751820-15-028 8040型材盖板	TB751820-15-028 8040 profile cover	8
8	48142054		250铝型材	250 aluminum profile	1
9	S05040		M6*16内六角螺钉	M6*16 hexagon socket screws	27
10	70128220		M6斜印花垫片	M6 diagonal printing gasket	31
11	48109057		铰接板	Hinge plate	6
12	701S16013		方形扁螺母	Square flat nut	31
13	48142052		190铝型材	190 aluminum profile	3
14	48112059		型材连接板	Profile connecting plate	1
15	S05156		M6*60内六角螺钉	M6*60 hexagon socket screw	4
16	48112067		型材L型连接件	Profile L-shaped connector	2
17	701S30038		Φ5×30圆头木螺钉	$\Phi5 \times 30$ round head wood screws	1
18	48142053		150铝型材	150 aluminum profile	1
19	48142051		440铝型材	440 aluminum profile	1



序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1	S05040		M6*16内六角螺钉	M6∗16 hexagon socket screws	25
2	70128220		M6斜印花垫片	M6 diagonal printing gasket	33
3	48109057		铰接板	Hinge plate	2
4	701S16013		方形扁螺母	Square flat nut	33
5	48142051		440铝型材	440 aluminum profile	1
6	70101339		8040型材盖板	8040 profile cover	8
7	48112059		型材连接板	Profile connecting plate	2
8	48142053		150铝型材	150 aluminum profile	2
9	48142052		190铝型材	190 aluminum profile	2
10	48102056		销柱	Pin	1
11	48112058		轴座安装块	Shaft mounting block	1
12	48112067		型材L型连接件	Profile L-shaped connector	2
13	701S30038		Φ5×30圆头木螺钉	$\Phi5{ imes}30$ round head wood screws	1
14	48142055		350铝型材	350 aluminum profile	1
15	S05910		M6*80内六角螺钉	M6*80 hexagon socket screws	8
16	48109059		旋转座	Rotating seat	1
17	S05184		M8*25内六角螺钉	M8*25 hexagon socket screws	5
18	48112057		调节板连接块	Adjusting plate connection block	1
19	48109058		调节板连接块	Adjusting plate connection block	1
20	41228004		M8平垫	M8 flat washer	3
21	W06003		碟形弹簧	Disc spring	3
22	48112056		旋转调节板	Rotating adjustment plate	1

9.7、支撑架部件(左)Support frame parts(left)



## <u>9.8、热切部件 Hot cut parts</u>

序号 NO.	公司件号 Part NO.	参考件号 Ref.Part NO.	名称 PartName	零件描述 Description	数量 (Number)
1	148109013		热切送料机架	Hot cutting feeding rack	1
2	148109005		下刀快换定位板	Positioning plate for quick change of tool	1
3	970791		M2*5沉头螺钉	M2*5 countersunk head screws	2
4	148119004		热切下刀	Hot cutting lower knife	1
5	S05403		M3*8内六角螺钉	M3*8 hexagon socket screws	1
6	148109007		下刀延展块	Lower knife extension block	1
7	970792		手拧螺钉	Thumb screw	2
8	S05021		内六角圆柱头螺钉M3X5	Hexagon socket head screw M3X5	3
9	148119003		热切上刀	Hot cutting upper knife	1
10	148109001		加热板	Heating plate	1
11	48130051		加热管 Φ4	Heating tube $\Phi 4$	1
12	48130052		热电偶 Φ 3	Thermocouple $\Phi 3$	1
13	148123002		铜块隔热条	Copper block insulation strip	1
14	S05403		M3*8内六角螺钉	M3*8 hexagon socket screws	2
15	S05267		M4*20内六角螺钉	M4*20 hexagon socket screws	2
16	148109009		散热铝件	Aluminum parts for heat dissipation	1
17	935870		双轴气缸	Double shaft cylinder	1
18	S05407		M3*35内六角螺钉	M3*35 hexagon socket screw	2
19	148109003		气缸连接板	Cylinder connecting plate	1
20	S05058		M4*10内六角螺钉	M4*10 hexagon socket screws	2
21	148103001		隔套	Spacer	2
22	148109004		铜块锁紧板	Copper block locking plate	1
23	S02074		M3*16内六角沉头螺钉	M3*16 hexagon socket countersunk head screws	3
24	S05859		M4*8内六角螺钉	M4*8 hexagon socket screws	2
25	S02129		M4*25内六角沉头螺钉	M4*25 Hexagon socket countersunk head screws	4
26	148130005		6015散热风扇	6015 cooling fan	1
27	148112087		6060风扇支座	6060 fan support	1
28	148109002		气缸安装板	Cylinder mounting plate	1
29	148109012		支座垫块	Bearing block	1
30	701S13033		M3*16内六角螺钉	M3*16 hexagon socket screws	2
31	S05058		M4*10内六角螺钉	M4*10 hexagon socket screws	4
32	148112086		4040风扇支座	4040 fan support base	1
33	148130004		4010散热风扇	4010 cooling fan	1
34	S05074		M3*16内六角沉头螺钉	M3*16 hexagon socket countersunk head screws	4
35	S05051		M3*6内六角螺钉	M3*6 hexagon socket screws	2
36	148123001		前后隔热板	Front and rear insulation panels	1
37	148109011		热切导布板	Hot cut cloth guide	1
38	148109008		支撑座	Support base	2
39	S05403		M3*8内六角螺钉	M3*8 hexagon socket screws	2
40	148109006		机架附加定位块	Rack additional positioning block	1
41	S05410		M3*10内六角螺钉	M3*10 hexagon socket screws	4