

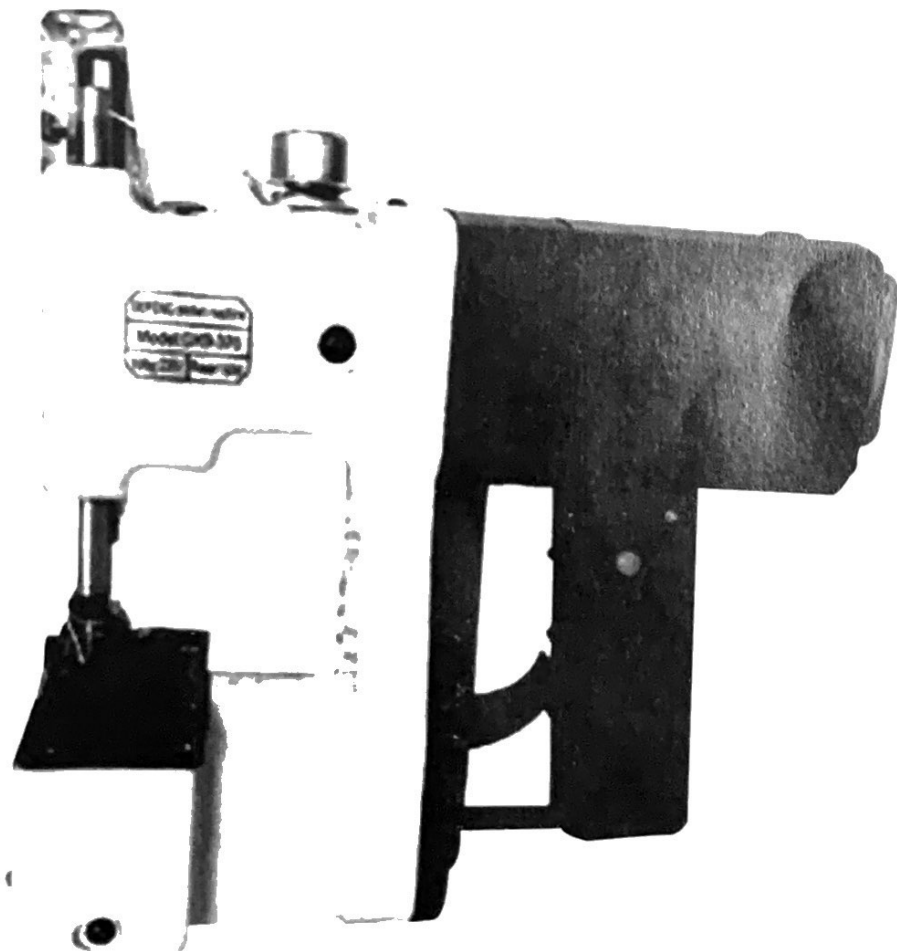
Portable Hi-speed Package Closing Machine

Model GK9-370

Patent No:201410667105.2

201420700162.1

Operational Instructions Sample of Components



前言

首先欢迎使用我厂生产的手提电动封包机。本产品已获得国家专利授权（专利号 201410667105.2, 201420700162.1）。

该机具有以下优点：使用安全、压紧力可调、自动剪线等特点。

First, welcomed the use of hand-held electric sealing machine produced by our factory. This product has obtained the national patent (Patent No.

201410667105.2/201420700162.1).

The machine has the following advantages: the use of safety, pressure adjustable automatic shear line, etc..

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一、技术规格：/ Technical specifications:

(1) 线迹：单线链式（101）。

(2) 机针型号：本产品使用 9K9 普通机即可。

(3) 使用缝线规格：9K9 普通涤纶线。

(4) 缝纫速度：1300-1700 针/分。

(5) 电动机规格：电压 210~230 伏，输入功率 90 瓦，转速 1500 转/分。

(6) 外型尺寸：25X8X25(长宽高)。

(7) 机器净重：2.8 公斤。

(1) a single thread chain stitch: (101).

(2) needle type: This product use ordinary 9K9 machine.

(3) the use of specification: 9K9 polyester suture line.

(4) the sewing speed: 1300- 1700 needle / min.

(5) motor specifications:voltage 210 to 230 volts, the input power of 90 watts, 1500 rpm.

(6) size: 25X8X25 (length and width and height).

(7) net weight: 2.8 kg.

二、安全注意事项：/Safety precautions:

(1) 使用后维护前拔下电源插头。

(2) 本机与电源连接之前确认与电压机匹配。

(3) 必须用三芯电源线并确认接地良好。

(4) 电机散热孔应保持畅通。

(5) 不要用硬物和重力撞击本机。

(6) 应请经培训的修理人员对本机进行定期维护。

(7) 不得将本机受潮、及失水以免引起电器短路。

(1) first unplug the power plug maintenance after use.

(2) before the machine is connected with the power supply voltage to confirm the match.

(3) must use the three core power line and confirm the good grounding.

(4) motor heat dissipation holes should be kept clear.

(5) do not use a hard object collision and gravity of the machine.

(6) should be invited to the training of personnel to repair the machine maintenance.

(7) shall not be affected with damp, and the machine was so as not to cause electrical short circuit.

三、使用方法：/Method of use:

(1) 针机调换：将本机升高到最高的位置，松开紧固螺丝即可，拔出机针，换上新机针，并使用机针往上顶住不动为止并注意机针缺口平面朝里紧固螺丝即可。（图）

(2) 钩针调换：将送料牙升至最高点，打开内六角螺丝 B,然后针头向外倾斜，并往上抽即可。（图）

(3) 穿线步骤。(按图说明)

(4) 压线盘的调整: 转动压线螺母, 顺时针为紧, 逆时针为松。

(5) 压紧力的调整: 顺时针调整转动螺丝压紧力增大, 逆时针减小, 建议在不影响送料效果的前提下适当减小压紧力, 有利于减轻电机负担和机件磨损。(图)

(1): the machine needle exchange will be increased to the highest position, loosen the fastening screws, pull out the needle, to replace the new machine needle, and use the machine needle to stop and pay attention to the needle plane gap in fastening screws. (Figure)

(2) a change: the feed dog rose to the highest point, open the inner six angle screw B, and then the needle to tilt, and to draw. (Figure)

(3) the threading process. (according to the diagram)

(4) the line wheel adjustment: turn the pressing nut clockwise, counterclockwise to loose.

(5) the pressing force: adjusted clockwise rotation adjustment screw clamping force increases, counterclockwise decreases, suggested in the premise of not affecting the feeding effect of decreasing properly the pressing force, favorable to reduce the motor weight and mechanical wear. (Figure)

四、产品特点和用途: /Product characteristics and uses:

(一) 产品特点: /Product features:

(1) 产品特点: 本机系创新设计的专利产品, 具有速度快、运动可靠性好、彻底改变旧机型运动稳定差、机件易磨损、噪声大等设计缺点。采用低传动副, 耐磨损、可靠性强, 重量轻, 绝缘性能好, 结构紧凑合理等特点, 能减轻工人长时间使用的劳动强度。

(2) 压紧力可调: 在缝制不同缝物时, 调整压紧力大小, 以达到提高工作效率、延长零部件使用寿命。

(3) 自动剪线: 在缝毕时无需人工剪线, 只需将尾线引入线槽即可。

(1) product features: This machine is the patent product innovative design, has the advantages of fast speed, good reliability, completely change the old model of motion stability is poor, easy to wear, noise and other mechanical design flaws. The low gear, wear resistance, high reliability, light weight, good insulation

performance, compact and reasonable structure and other characteristics, can reduce the labor intensity of workers and long time use.

(2) the pressing force is adjustable seam sewing: in different time, adjust the pressing force, in order to improve the work efficiency, prolong the service life of the parts.

(3) automatic shear line: in the gap at the end without the need for manual cutting line, only the tail line into the line can be.

(二) 用途: /Uses:

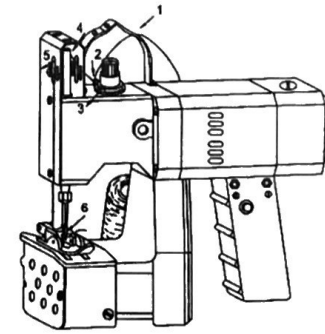
本机是化工建材、化肥、粮食邮电、港口、码头仓库及制袋等各种行业包装专用设备。线迹单线链式, 具有弹性好、牢固、拆卸方便、操作简单, 易修理等特点。

This machine is a special equipment for packaging, chemical building materials, fertilizer, grain of Posts and telecommunications, port and dock warehouse and bag making and other industries.

A single thread chain stitch, good elasticity, firmness, convenient disassembly, simple operation, easy to repair.

穿线步骤按图所指的顺序穿线

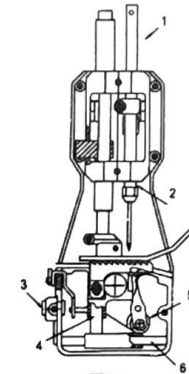
The steps of threading is according to the threading order of below picture



图一


按箭头所指每班加油一次

Put on steam once per turn according to the arrows

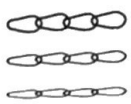


图二

五、压紧力的调紧/the pressing force of tightening




松 Loose 紧 Tight



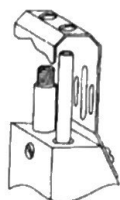
太松/Too loose
正确/Correct
太紧/Too tight

压线盘的调整: 转动压线螺母, 顺时针为紧, 逆时为松。
Pressing wheel adjustment: turn the pressure screw clockwise for tight, inverse is loose.



机针的调换: 将机针升高到最高位置, 拔出机针换上新针, 使机针尾部顶丝面对准紧顶螺丝端面, 同时针槽缺口平面与钩针平面相平行, 然后拧紧螺丝即可。

Needle exchange: the needle rises to the highest position, pull out the needle exchange process, The needle tail screw tight screw end face alignment, and the needle groove gap plane in parallel with a plane, and then tighten the screw.



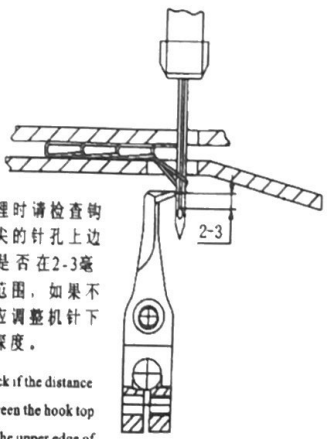
松 Loose 紧 Tight

压紧力的调整: 顺时针转动调整螺丝压力增大, 逆时针减轻, 建议在不影响送料效果的前提下适当减转压力有利于电机负担和机件磨损。

Pressure adjustment: clockwise rotation adjustment screw clamping force increases, inverse time money loss, in does not affect the Under the premise of feeding effect reducing the rotating clamping force to the motor load and the wear of machine parts


六、机针和钩针正确位置的调整

The needle and crochet correct position adjustment




修理时请检查钩针尖的针孔上边缘是否在2-3毫米范围, 如果不对应调整机针下降深度。

Check if the distance between the hook top and the upper edge of the needle eye is 2-3mm when repair the machine. Otherwise, adjust the load-lowering height.



机针下降到最低点时, 钩针尖与机针边缘距离应在3-3.5毫米范围, 不然就要松开螺丝A进行调整。

The distance between the hook top and the upper edge of the needle eye should be 3-3.5mm when fall the needle on the lowest position. Otherwise, loose the screw A for adjusting.

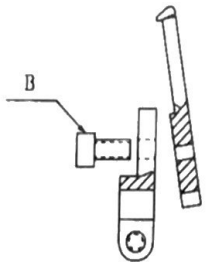


当钩针与机针凹槽相交时, 其间隙应在0.05-0.15毫米范围。

The gap should be 0.05-0.15mm when the hook meets the needle slot.

钩针调换: 将送料牙升至最高点, 松开内六角螺丝B然后针头向外倾斜, (图) 并往上抽即可。

Replacement of the hook: Raise the giving materials teeth on the highest position, loosen socket head screw B, incline the hook top then up out the hook.



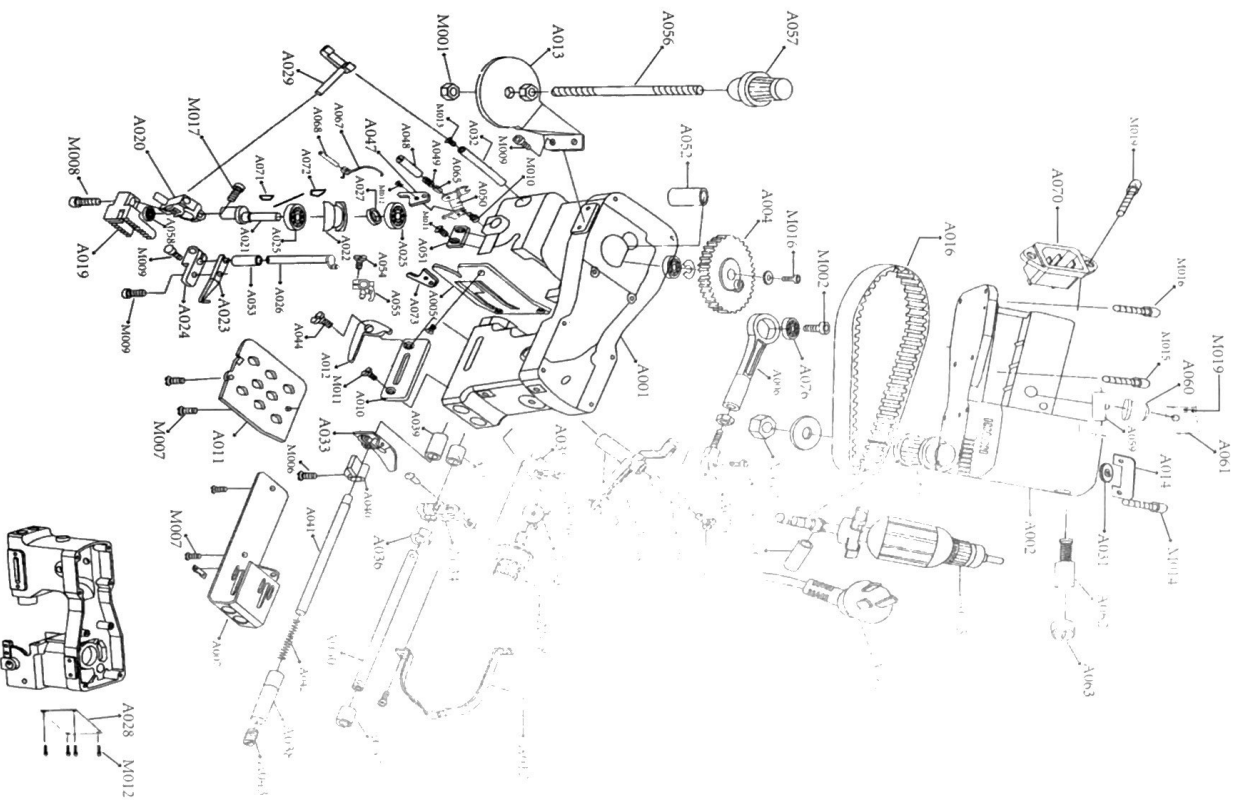
七、一般故障的处理方法 / The treatment methods of general function

故障类型	故障情况	发生故障的原因	处理方法
断针	缝物过后时断针	针尖锐偏或弯曲造成 钩针相碰	停止使用或更换新
	机针与压脚或钩针相碰	压紧导架或压脚及钩针锁紧螺丝松动	拧紧后检查
跳针	机针没有穿过钩针线圈	机针偏高, 下行时机针动作相对滞后	对照说明书调整
	钩针不勾线	钩针与机针缺口平面间隙过大或机针偏高钩针动作相对滞后	对照说明书调整
	快速缝厚物时偶尔跳针	机针缺口平面倾斜	调整机针缺口平面与钩针平行
		缝线张力不均, 时松时紧	更换优质缝线
断线	线头呈剥丝状	机针的针孔或线槽不光滑	更换机针
	尾绒很毛	针板孔及钩针头表面粗糙	用砂布打磨
	线头呈割断状	机针孔粗糙, 压线器太紧	检查后更新调整
面板的挑线器太高等			
其他	送料不流畅	压脚表面不光滑, 送料牙齿不锋利, 送料牙抬高高度不够	更换压脚, 更换牙齿, 太高牙齿高度
	出尾不流畅	送料牙与压脚底面接触不平	修整压脚底面
电机	电机不转	检查碳刷是否磨损	更换新碳刷
	电机不转或转过高	开关接触不良、整流管损坏	更换新开关或整流器

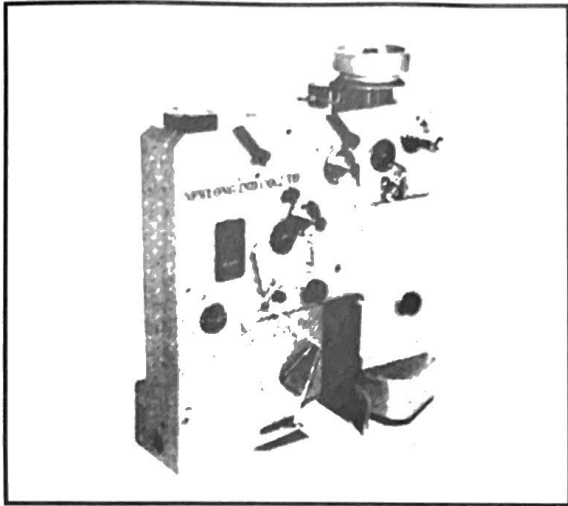
八 零件名称及编号对照示意图 / Part name and number of the control diagram

零件编号	零件名字	零件编号	零件名字	零件编号	零件名字
A001	机壳	A019	送料牙	A037	针杆套
A002	电机	A020	牙架	A038	压杆上套
A003	转子	A021	主轴	A039	压杆下套
A004	盘形槽皮带轮	A022	凸轮	A040	压杆导架
A005	针板	A023	钩针	A041	压紧杆
A006	大连杆	A024	钩针架	A042	压杆弹簧
A007	面板	A025	轴承 30x10x9	A043	压脚弹簧螺钉
A008	针杆摆杆	A026	钩针架轴	A044	压脚扳手螺钉
A009	杠杆轴	A027	主轴压垫	A045	压线器过线
A010	小面板	A028	主箱盖	A046	链条节
A011	罩壳板	A029	滑块	A047	动刀片
A012	压脚扳手	A030	针杆	A048	刀架轴
A013	线架托盘	A031	手轮	A049	刀架弹簧
A014	手轮护架	A032	平行轴	A050	刀架
A015	皮带轮	A033	压脚底	A051	定刀片
A016	同步带	A034	针杆连接	A052	钩针轴下轴套
A017	过线环	A035	链条节销	A053	钩针轴上轴套
A018	压线器	A036	针夹	A054	滚球螺钉

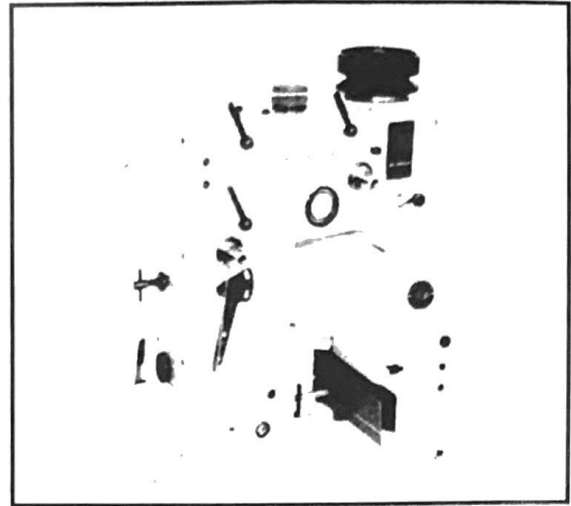
A055	滚球座	A070	电机插座	M008	内六角螺钉 M4x16
A056	线钉	A071	凸轮半圆肖	M009	内六角螺钉 M5x10
A057	线钉帽	A072	盘型皮带轮半圆肖	M010	半圆头内六角螺钉 M4x8
A058	牙架轴承 16x8x6	A073	手用刀片	M011	沉头螺钉 M4x5
A059	开关	A074	平垫	M012	半圆头螺钉 M3x4
A060	开关按钮	A075	关节轴承	M013	半圆头内六角螺钉 M4x6
A061	开关护罩	A076	600 轴承	M014	内六角螺钉 M4x75
A062	碳刷	A077	销子卡簧	M015	内六角螺钉 M4x20
A063	碳刷盖	M001	螺母 M6	M016	内六角螺钉 M4x15
A064	电源线	M002	左牙螺钉 M6x18	M017	内六角钉丝 5x16
A065	刀架轴套	M003	螺母 M5	M018	沉头螺钉 5x5
A066	230#机针	M004	外六角螺钉 5x14	M019	自攻螺钉 4x10
A067	扭簧	M005	半圆头内六角螺钉 M5 x8	M020	针板螺钉
A068	扭簧螺钉	M006	内六角钉定 6x6		
A069	圆柱销	M007	半圆头螺钉 M4x6M4x16		



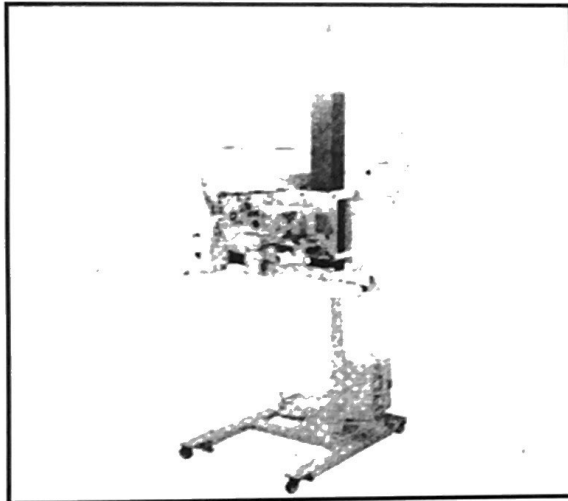
代理纽朗公司产品本厂同时代理纽朗公司产品
The factory also agent NEWLONG products



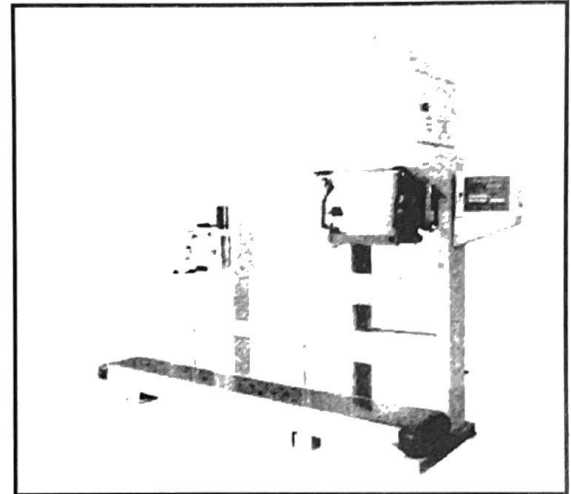
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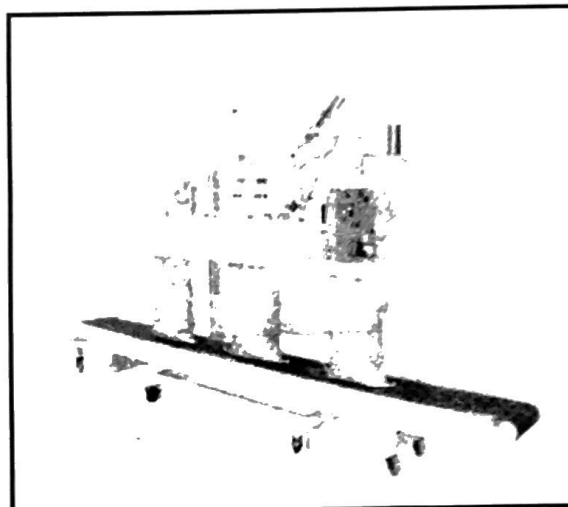
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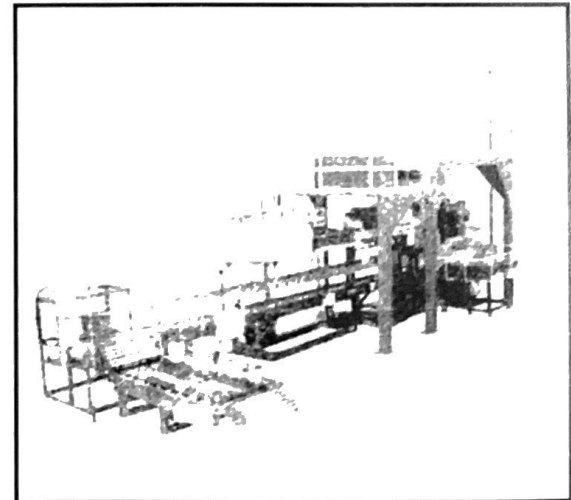
A1-PB+CP4900



定量包装机组



KS-1



3CM-P