

JEMA

电脑切带机系列

零件样本
使用说明书



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SPARE PARTS			
Part No.	Description	Part No.	Description
A-61	clamping bolt M6	A-91	clamping bolt M8
A-62	casting	A-92	spring
A-63	bearing	A-93	heating plate
A-64	support shaft	A-94	heat bracket
A-65	holding pin	A-95	thermal shield
A-66	motor +reduction gear	A-96	safe cover of hot knife
A-67	motor bracket	A-97	cooling fan
A-68	clamping bolt M6	A-98	heat transfer
A-69	stepping motor	A-99	heating tube
A-70	bracket of stepping motor	A-100	clamping bolt M6
A-71	clamping bolt M6	A-101	nut
A-72	small gear of stepping motor	A-102	thermal shield
A-73	back cover	A-103	clamping bolt M5
A-74	cover of belt wheel	A-104	hot knife
A-75	v-belt of stepping motor	A-105	upper knife(mold) bracket
A-76	big gear of stepping motor	A-106	clamping bolt M6
A-77	v-belt of motor(reduction gear)	A-107	upper knife (mold)
A-78	big gear of reduction motor	A-108	lower knife (mold) bracket
A-79	small gear of reduction motor	A-109	clamping bolt M6
A-80	clamping bolt M6	A-110	material guide bracket
A-81	clamping bolt M6	A-111	side cover
A-82	safe cover of cold knife	A-112	rubber feet
A-83	condenser	A-113	clamping bolt M4
A-84	transformer	A-114	clamping bolt M6
A-85	base	A-115	arm shelf
A-86	relay	A-116	back-up-ring
A-87	relay bracket	A-117	big check plate
A-88	temperatuer control	A-118	arm shaft
A-89	clamping bolt M6	A-119	check ring
A-90	clamping bolt M4	A-120	wire

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一、简述

全自动电脑切带机属机电一体化新型专机，它是用输入电脑程序自动控制机械的动作，可按您所需长度数量自动切断不同宽度长度的纺织带，魔术贴，塑料软管，鞋带，塑料拉链，电脑排线，商标等带状物品。根据所切材料的弹性不同而设计的补偿功能，可为您的产品带来更高的精确度。并附带加热装置，可以热封不同尺寸的尼龙纺织带，尼龙带料，并在开关关闭前自动储存当前所设置的所有数据，具有精度高，速度快，断而平整，无料自动停止工作，操作简单等特点。是您提高生产效率，提高产品质量，节省人工的首选。

二、规格

功率	最大切断宽度	切断长度	切断速度	电压
L0.5-H1.4kW	L200mm H180mm	1mm-99999mm	80-100/分钟	110/230V 50/60Hz

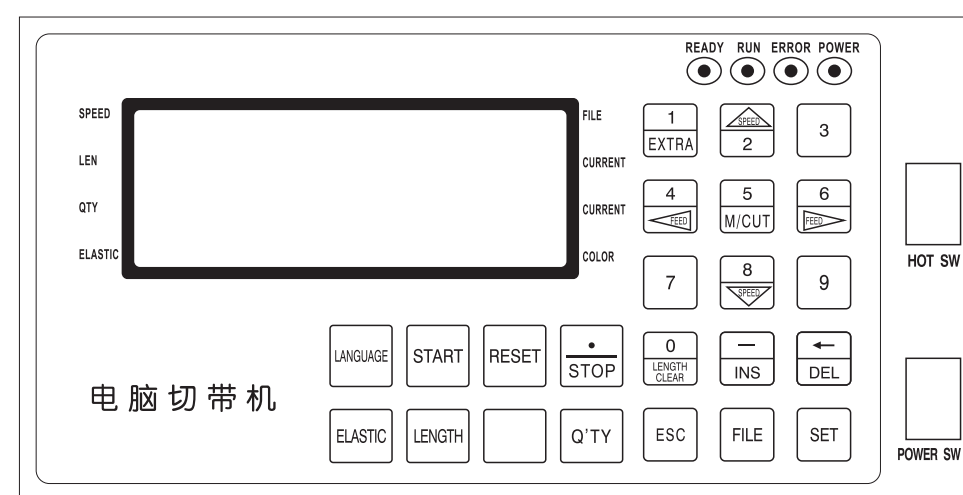
三、使用环境

本机是在一般常温下进行工作，如果在过高法度(大于80摄氏度)下工作，将影响本机性能，本机对环境能源不产生影响。

四、操作方法

如何操作：(假设设定长度120mm 数量50pes)
 打开电源开关(power sw)，面板显示窗出现长度和数量。
 按下(LENGTH) 1 2 0 (SET)
 这样长度数值输入完成，开始输入数量。50PCS
 按下(Q.TY) 5 0 (SET)
 长度和数量设定后，机器开始工作。
 按下开始键(START)机器将按照以上设定自动完成。

五、面板功能介绍



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SPARE PARTS			
Part No.	Description	Part No.	Description
A-1	Clamping Bolt M3	A-31	clamping bolt M6
A-2	Upper Cap of Cooling Fan	A-32	clamping bolt M6
A-3	Guide Shaft	A-33	bearing
A-4	Shaft ring	A-34	upper roller
A-5	Clamping Bolt M4	A-35	guide pin
A-6	Upper Knife Case	A-36	lower roller(feeder roller)
A-7	Upper knife (cold)	A-37	counting sensor
A-8	Neck Washer of Cold-knife Bracket	A-38	bearing
A-9	Clamping Bolt M6	A-39	clamping bolt M6
A-10	Pressure-control Spring	A-40	nut M6
A-11	Vertical axle	A-41	sensor ring
A-12	existence detector	A-42	bearing
A-13	clamping bolt	A-43	front case
A-14	guide knob	A-44	pin
A-15	front-guide pin	A-45	clip ring
A-16	lever shaft	A-46	crank bundle
A-17	micro limit switch	A-47	clamping bolt M6
A-18	extension spring	A-48	link
A-19	wrench bolt M5	A-49	case of crank bundle
A-20	cooling fan	A-50	clamping bolt M4
A-21	wrench bolt M6	A-51	clamping bolt M4
A-22	rear guide-in bracket	A-52	left cover
A-23	existence detector	A-53	clamping bolt M4
A-24	rear tesson-guide screw	A-54	infrundbulum
A-25	upper roller bracket	A-55	lower knife (cold)
A-26	Pressure-control Spring	A-56	upper knife tension
A-27	washer	A-57	screw
A-28	wrench bolt M5	A-58	clamping bolt M8
A-29	clamping bolt	A-59	spring
A-30	clamping bracket	A-60	clamping bracket

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- 使用前请确认电源电压和连接地线。
- 为了确保安全，在裁切过程中请不要将手或任何物体靠近切刀。
- 在做任何调整时，请先切断电源以维护安全。
- 除了正常保养外，请勿任意拆卸任何零部件。
- 每班开机前，务必加机油一次。
- 如果当刀具使用一段时间后变钝了，可以到专业磨床进行磨刀后方可使用。
- 若在操作有任何困难，请与本公司联系，我们将竭诚为您服务。

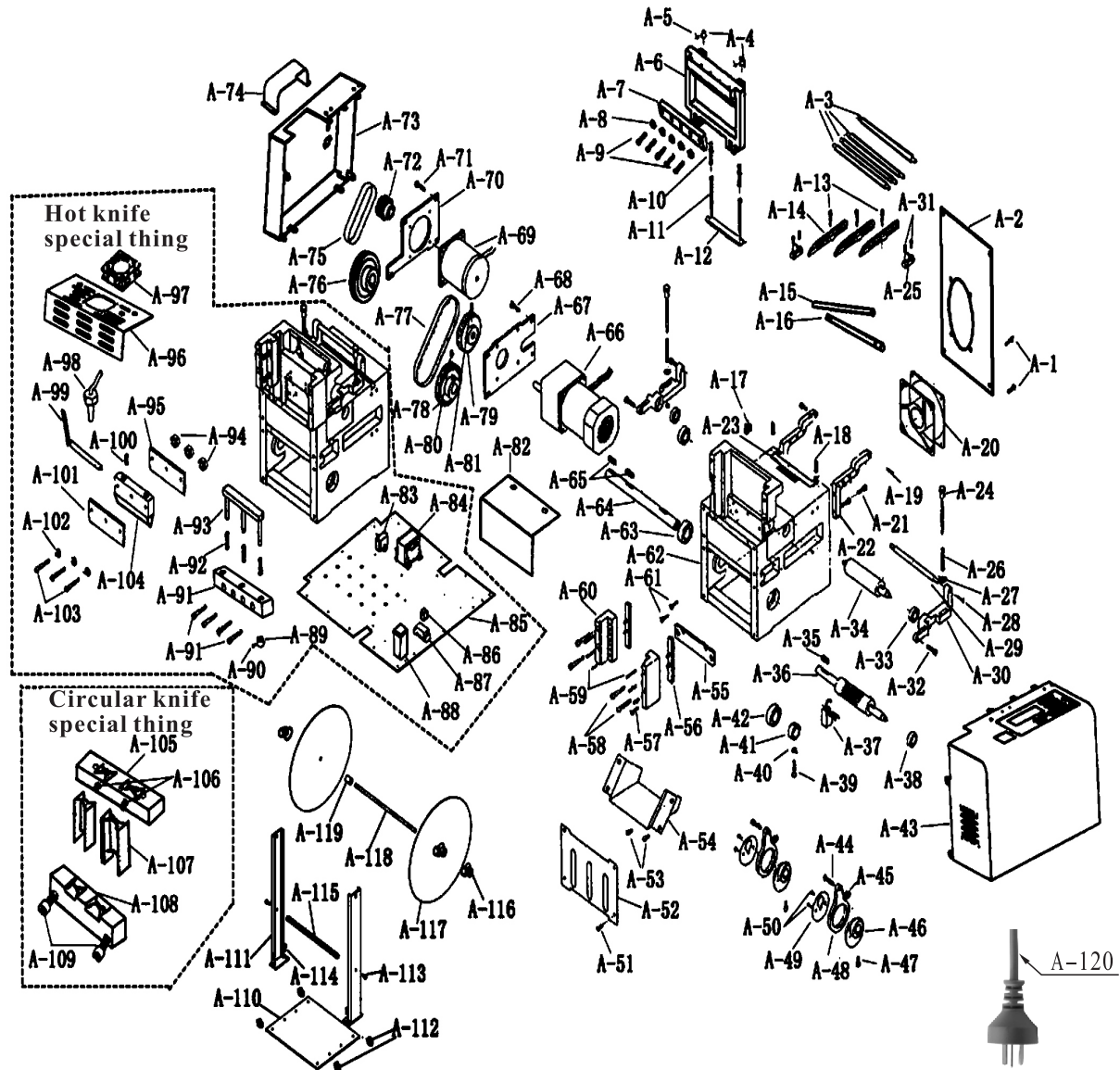
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六、注意事项

- 按下该键当前长度将恢复为零
- 按下该键切刀会增加一次
- 按下该键切刀速度将会增加(一般速度为50%最高速度为100%)
- 按下该键切刀速度将会减少(一般速度为50%最高速度为100%)
- 按下该键滚筒将向前送料
- 按下该键滚筒将向后送料
- 按下该键切刀将慢慢向下移动
- 语言选择键(中文/英文)
- 启动键，数量和长度设置好之后按下该键机器开始工作。
- 复位键，系统没有出错的情况下按下该键当前的数量和长度都将恢复为零。
- 停止键加小数点，工作中按下该键将暂停当前的工作，设置长度时按下该键将增加一位小数。
- 负键，由于各种材料的弹性不同，当所切的长度比实际输入的长度长时使用该键来
- 进行负的补偿，以达到标准尺寸。
- 清除键。
- 补偿键，由于各种材料的弹性不同，当所切长度比实际输入长度长或短时用该键
- 来进行适当的补偿，以达到标准尺寸。
- 按下该键设置所需切材料的长度。
- 按下该键设置所需切材料的数量。
- 返回键。
- 文件选择，可供储存9种不同尺寸数量的文件。
- 按下该键确认当前的输入。

热刀 Hot SW 电源 Power SW

Parts drawing



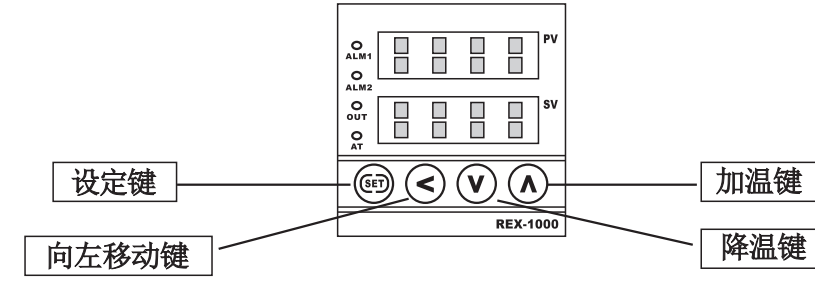
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NO	TRoubles	APPLICABLE MODEL	CAUSES & MEASURES
1	no power supply	all models	check if electric cord is connected well check if the fuse blows out or not
2	power is on, but no work	all models	check if pressure plates of upper knife are too much fastened or not (cool:#20&29,hot:#32&36) check if the temperature is too high with over-time working, switch off the machine for seconds, if still doesn't after several times' trying. Please opening the cover and check the connection (especially between operation and CPU board)
	Feed roller does not work	all models	if the display shows "sensor error" or any other error, put off SW for 10 seconds and put on again, if still does not work, exchange the drive board.
3	material is no cut	hot cutter	check if temperature goes up to set-degree
			check if knife blades are even.
			check if blades are damaged or wears
4	material is cut one side	all models	after making both knives close each other by M/CUT button and check if they are even or not (if they are not, adjust them by bolts)
			check if length is different from set-length
5	cut-length is different from set-length	all models	test after loosening material from the reel by hand or attaching feeding device.
6	cutting error	all models	troubles in cutting motor or counting sensor turn on the machine and press the M/CUT button, check if the knife can be moved or knife may locked. open the bottom cover of the knife, check if the sensor is loose and wrong positioned. open main cover, check the SW of cutting sensor is right or not. If not, exchange it. check the cutting motor is right or not.
	operator feels electric current in touch of machine	all models	connect the earth cord (green) to any bolt of backside of machine.

Trouble shooting of 130 series(only reference)

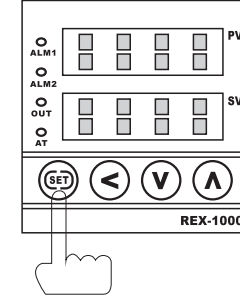
七、如何使用温控义K型。注：（冷刀、圆角没有此装置）



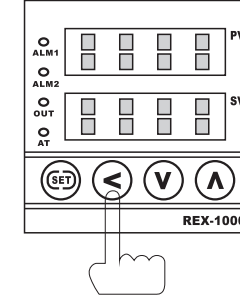
当你打开温控仪时，PV会显示当前室内的温度。而SV会显示你设置的温度，建议温度控制在300-450度之间。

大概在10分钟左右就可以达到您所设置的温度。

1. 按SET键进入设置程序，此时你会看到SV显示在闪烁，表示可以改动此数字。（如图1）
2. <是向左移动键，可以帮你选择而要改动的数字。（如图2）



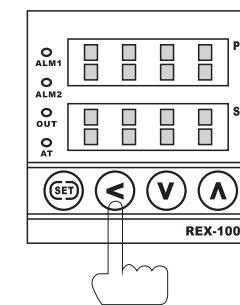
(图1)



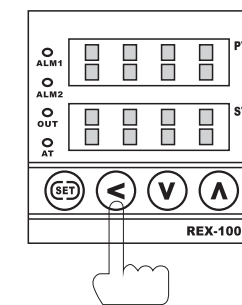
(图2)

3. ΔV是温度调节键，Δ表示升温，V表示降温。（如图3）

4. 设置完成后，需再按一次SET键停止数字闪烁，这时温控仪会退回自运行模式。（如图4）



(图3)



(图4)

故障排除:

1. 调温器不工作，检查接线处是否松动。
2. 切口没有完全粘合，调温器温度设定太低，需要逐步加高温度直到切口完全粘合。
3. 料带放置立式（见图），开始送料时可利用手动送料将料送入刀口，待温度到达所设定温度后方可正常工作。

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— 4 —

序号	发生现象	原因及措施
1	无电源	检查电源线是否断开
2	有电源，但无法启动	检查滚轴上是否有夹带杂物
		如显示屏显示刀具传感器出错，则需要关闭电源，10秒钟后再打开电源，等待侧面板绿色灯亮时，再按控制面S、切全机种 如显示屏显示不正常或不正常，则需要关闭电源，10秒钟后再打开电源，再按启动按钮（START）还不能启动，则需要考虑更换驱动板。

八、一般故障的排除措施（供参考）

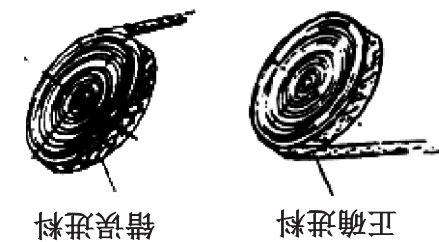


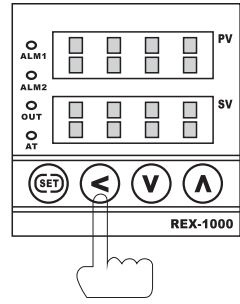
切魔术贴进料时必须将毛面朝上，光面朝下。（如下图）

切魔术贴切勿将两条同时剪切。

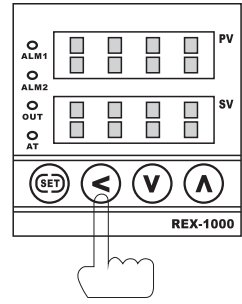
注意:

4. 更换上切刀时固定上刀的螺钉太紧无法拧出，请将温控仪开启加热到200度左右，方可松开螺钉，松开螺钉后，请将温控仪关闭，待上切刀完全冷却后，可将螺钉完全拧出，更换上刀。（注意：加热后松开螺钉时注意烫伤）





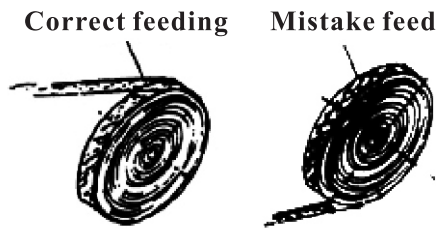
(Picture 3)



(Picture 4)

Fault Clearance

- 1 Check the connection, if the temperature does not work.
- 2 Increase the temperature if the cut unsealed
- 3 Please wait the temperature reaches to the set temperature before working and with right material putting.



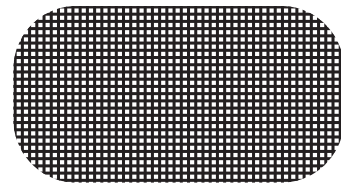
4 if you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200°C. Then loose the screw and turn off the control. And screw out completely after the knife is cool.(note that is hot and not burned yourself)

Caution:

- Do not cut two Velcro in the same time
- when cut Velcro .Please make sure that the rough surface is upward.



MAO face up (right)



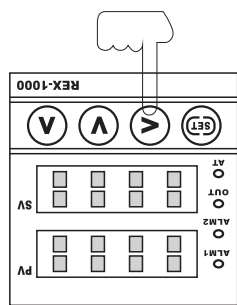
MAO facing down (wrong)

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—11—

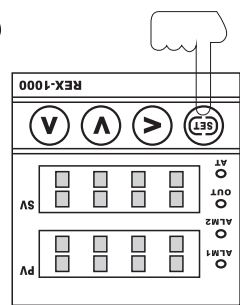
3 set desired temperature by pressing Δ and ∇ keys. Set-temperature will be increased by Δ key and it will decreased by ∇ key.(picture3)
4 after finishing setting, press SET key once more then , it stops blinking. And the controller will return to auto-turning mode.(picture4)

(Picture 2)

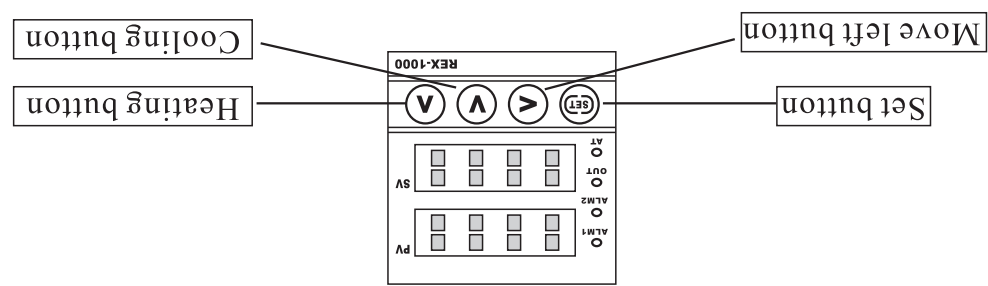


2 by pressing $>$ key, you can move between numbers of four ciphers.(picture2)
changed.(picture1)

(Picture 1)



1 you can enter set mode by pressing SET key, you may see one cipher blinks, it means it can be After turn on & set within 10minutes, it reaches to set temperature.
Recommendation is 300~500.
When you power on the controller, PV shows current room temperature and SV shows set temperature.



7. How To Use Temperature Controller K (NOTE: ONLY HOT CUT HAS IT)

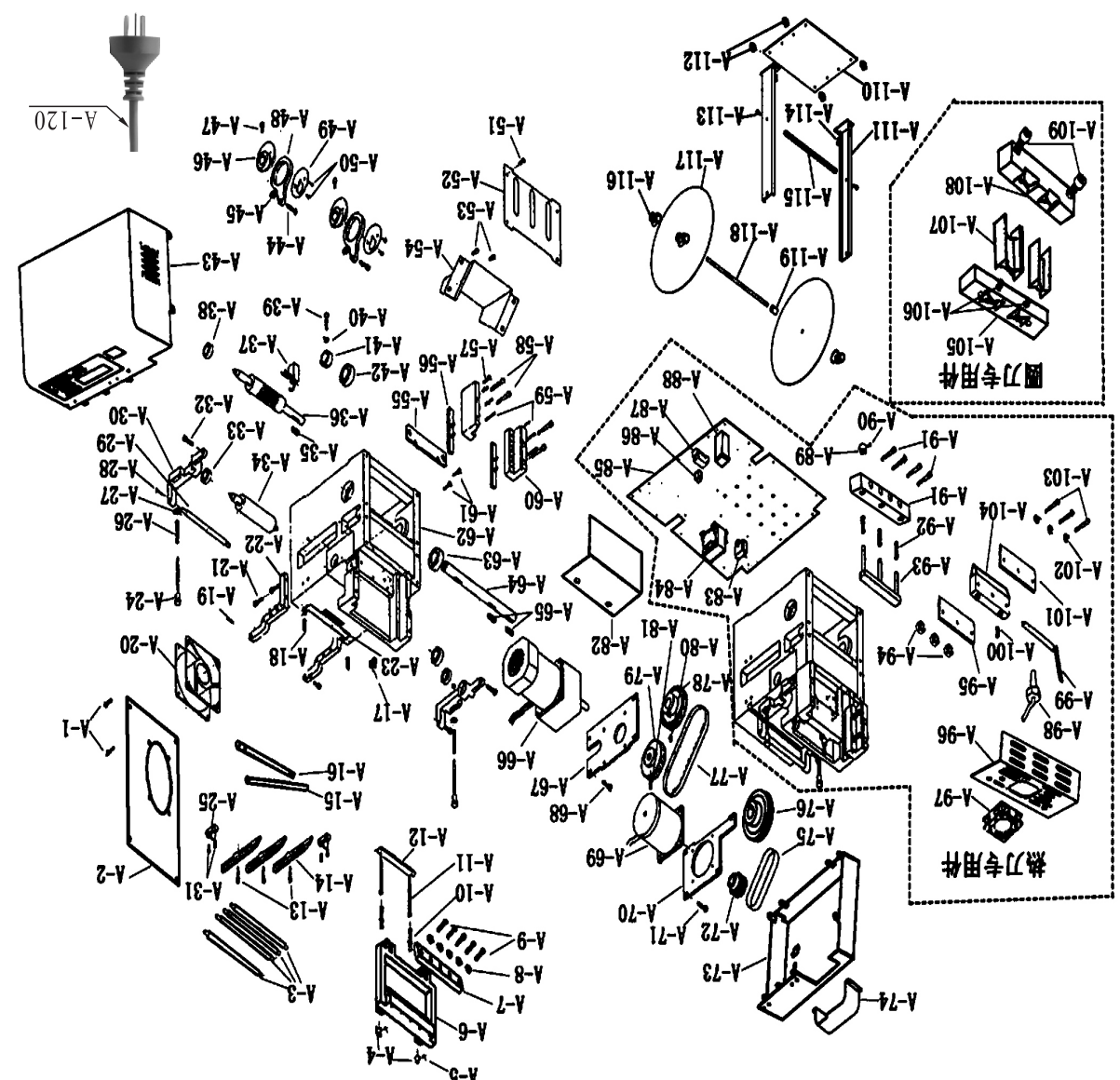
1. Before operation, please confirm the voltage and make ground (earth) connection.
2. Do not access hands or any object close to the working knife.
3. Cut off the electricity before any adjustment (for safety).
4. PIs do not take off any of the parts except for normal maintenance.
5. Lubricate the machine every time use the machine.
6. When the knife blade becomes dull, pls use it after grinding with the grinding machine (pls do not let the unskilled person grind manually or install the knife blade)
7. Welcome to contact us for any further information!

6. Caution

序号	发生现象	对应机种	原因及措施
2	刀架不启动	全机种	检查压力板 (冷刀: #20&29, 热刀: #32&36) 是否太紧
	有电源, 但无法启动	全机种	如果本机器连续超长时间工作使用, 机箱里面温度可能超高, 也许有可能出现显示不正常, 属于正常现象, 停止工作、关闭电源开关, 过一会儿再开机显示应当正常, 如果在冷态的时候, 开机显示不正常请关闭电源等十秒钟再开机, 上述做法反复几次仍然不正常, 打开机箱盖检查电脑连接插线。(尤其是操作板和 CPU 控制板)
3	无法切断带子	热刀	检查温度是否达到预设温度 检查热刀是否被加热
4	只切断带子的一边	全机种	检查热刀是否被损伤或磨损 采用手切断键, 调节刀, 上刀和下刀对准, 并保持水平。(如未保持水平, 需旋开螺丝调节)
5	切断长度与设定值不同	全机种	放松滚轴或利用带子传送机 (切断)
6	LCD 显示屏显示出错	刀具传感器出错	切割马达或切割感应装置故障
			<ol style="list-style-type: none"> 1. 正常开机后控制面板黄色的指示灯亮 (START) 时, 按住 "5" 字键、刀架能上下移动, 如不能移动可能是刀架被卡住。 2. 打开刀架下方盖板, 检查传感片是否松动错位。 3. 打开机箱盖, 检查刀具传感接近开关是否失效和连接线的连接状态。
7	手触到设备时, 有电流	全机种	检查刀具马达是否正常 用户在安装本设备时顺自配防触电漏电开关, 三脚插座接地板必须有良好的接地线, 才能确保本机器正常工作

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


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










零件图

5.Key Functions

Hot SW HOT KNIFE

-  current length on display will back to "0"
-  cut one more time
-  speed up (normal speed 50%, max. speed 100%)
-  speed down

*speed up & down is possible in any time(operation or stop) and set-speed will not be Changed even through you press RESET button or power off&on.

-   to move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.
-  moving knife only.
-  language shift (Chinese/English)
-  to start the working after finish length and qautity setting
-  all of current length and current quantity on display will back to "0"
-  to pause the working as well as a decimal point in the length setting
-  to insert new program between programs inputted already in time of program-input.
-  to delete the wrong program in time of program-input.(all things of the STEP will be deleted.)
-  use for the elastic material cutting
-  resoring to normal condition in ERROR
-  can save 9 files for you to select

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零件图

图号	名称	图号	名称
A-1	M3 螺钉	A-31	M4 螺钉
A-2	风扇架	A-32	M6 螺钉
A-3	过带轴	A-33	轴承
A-4	挡圈	A-34	压料轮
A-5	M4 螺钉	A-35	销子
A-6	上刀架	A-36	送带轮
A-7	冷刀上刀	A-37	传感器
A-8	冷刀垫圈	A-38	轴承
A-9	M6 螺钉	A-39	M6 螺钉
A-10	压缩弹簧	A-40	M6 螺帽
A-11	压料板轴	A-41	感应圈
A-12	压料板	A-42	轴承
A-13	螺钉	A-43	前壳
A-14	挡料板	A-44	销子
A-15	压板轴	A-45	卡簧
A-16	挡料板轴	A-46	偏心轮
A-17	行程开关	A-47	M6 螺钉
A-18	拉簧	A-48	连杆
A-19	M5 螺钉	A-49	偏心盖
A-20	风扇	A-50	M4 螺钉
A-21	M6 螺钉	A-51	M4 螺钉
A-22	压板座	A-52	左侧盖
A-23	压板	A-53	M4 螺钉
A-24	调节螺丝	A-54	漏斗
A-25	挡料架	A-55	冷刀下刀
A-26	压缩弹簧	A-56	导轨压板
A-27	螺钉	A-57	弹簧
A-28	M5 螺钉	A-58	M8 螺钉
A-29	拉轴	A-59	弹簧
A-30	压料架	A-60	压板架

— 7 —

— 9 —

— 8 —

Put on the POWER SW.
Set cutting length 120mm.(press the following bottons in order):
LENGTH 1 2 0 SET ☆ botton "0"has a double function of "0"and
Erasing current length.
Set cutting quality 50pcs.
Qty 5 0 SET
Press START button to start the machine.

4.How To Operate (i.e., cutting length:120mm, cutting quantity:50pcs)

3.Use Environment
The machine should work under the normal temperature,if the environment temperature is more than 80℃,would influence the performance of the machine.

Power (KW)	Max cutting width (MM)	Cutting length (MM)	Cutting speed (pc/min)	Voltage (Hz)
L0.5-H1.4	L 200 H 180	1 - 99999	80-100	110/230V 50/60

2.Specifications

1.General Description
Auto cutting machine adopts electromechanical integrating technology, it automatically adjusts the length data through the input of computer program. Automatically cutting various straps of different sizes such as braided tape, Velcro tape, plastic tube, plastic zipper, electrical wire, etc. All the data will be saved automatically before putting off the switch. With features of high accuracy, high speed, easy to operate and stop working without materials. It's an ideal machine for increasing efficiency, improving quality and saving labour.

图号	名称	图号	名称
A-61	M6 螺钉	A-91	M8 螺钉
A-62	机壳	A-92	弹簧
A-63	轴承	A-93	加热板
A-64	支架轴	A-94	加热板支架
A-65	支架销子	A-95	隔热纸
A-66	切刀电机	A-96	热刀保护罩
A-67	切刀电机座	A-97	风扇
A-68	M6 螺钉	A-98	热电阻
A-69	步进电机	A-99	发热管
A-70	步进电机座	A-100	M 6 螺钉
A-71	M6 螺钉	A-101	隔热纸
A-72	步进电机齿轮 (小)	A-102	螺帽
A-73	后盖	A-103	M5 螺钉
A-74	皮带轮罩	A-104	热刀
A-75	步进电机同步带	A-105	上刀模安装座
A-76	步进电机齿轮 (大)	A-106	M6 螺钉
A-77	切刀电机同步带	A-107	上刀模
A-78	切刀电机齿轮 (大)	A-108	下刀模安装座
A-79	切刀电机齿轮 (小)	A-109	M6 螺钉
A-80	M6 螺钉	A-110	放料架底座
A-81	M 6 螺钉	A-111	侧板
A-82	冷刀保护罩	A-112	橡皮垫钉
A-83	电容	A-113	M4 螺钉
A-84	变压器	A-114	M6 螺钉
A-85	底板	A-115	固定轴
A-86	继电器	A-116	挡芯
A-87	继电器座	A-117	挡盘
A-88	温控仪	A-118	放料架轴
A-89	M6 螺帽	A-119	挡圈
A-90	M4 螺钉	A-120	电线