



# **SIMAC 130 LR**

**MANUALE PARTI DI RICAMBIO**

## 一、简述

多功能电脑切带机是集气、机电一体化的新型专机，它是用输入电脑程序自动控制机械、气缸的动作，可按您所需长度、数量自动切断不同宽度、长度的编织带、魔术贴、塑料软管、鞋带、塑料拉链、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。选装件（红外定位装置：通过红外传感器系统定位精确切断各类不同宽度尺寸的商标。冲孔装置：根据用户需要，更换冲模，冲出大小不同的孔）。自动储存功能，在开关关闭前自动储存当前您所设置的所有数据。具有无料自动停止功能。切断材料厚、精度高、切断速度快、切断面平整无毛刺、尼龙材料不散丝、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。

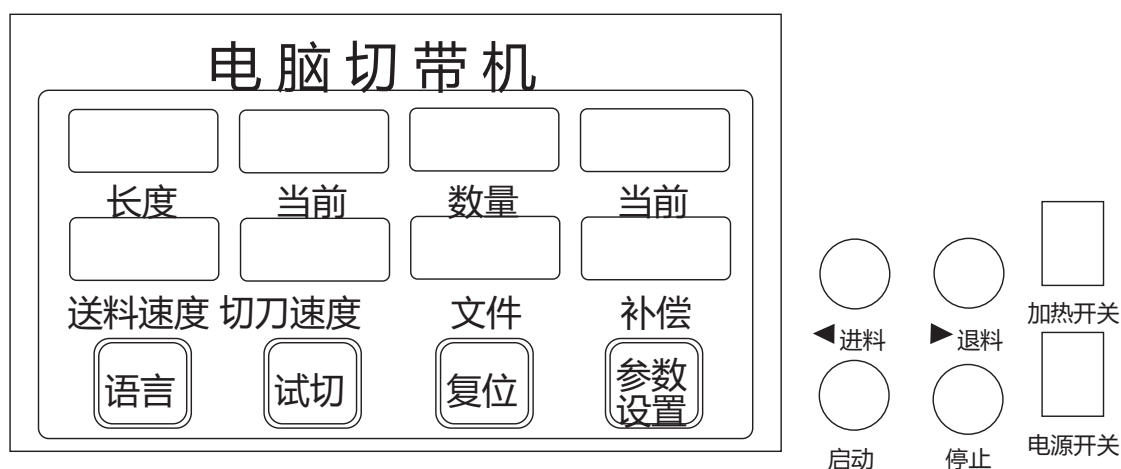
## 二、技术参数

型号	切断长度 (mm)	切断速度 (50mm)	切断宽度 (mm)	冲孔直径 (mm)	刀片温度 (°C)	建议气压 (mpa)	电压 (v)
130LR	20-99999	170	195/295	10	350	0.3-0.6	110/220
130H	20-99999	170	198/298	10	400	0.3-0.6	110/220
130L	20-99999	170	200/300	10	-	0.3-0.6	110/220
130R	20-99999	120	20-100	-	-	0.3-0.6	110/220

## 三、使用环境

本机是在一般常温下进行工作，如果在过高温（大于80摄氏度）下工作，将影响本机性能。

## 四、面板功能介绍



加热开关       电源开关

◀ 进料    按下该键手动向前送料       ▶ 退料    按下该键手动向后退料

启动    按下该键机器开始工作       停止    按下该键机器停止工作

上压轮按钮：按下该按钮，上压轮抬起，进行手动放料。松开按键，上压轮放下。  
上压轮

按下该键设置长度。

显示当前长度，按下该键当前长度清零。

按下该键设置数量。

显示当前数量，按下该键当前数量清零。

按下该键，输入数字，数字越大速度越快，数字越小速度越慢。

按下该键，输入数字，数字越小速度越快，数字越大速度越慢。

按下该键选择您储存的文件。

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，以达到您所需的尺寸。

按下该键选择语言。

按下该键手动切刀一次。

系统没有出错的情况下按该键，当前的数据将恢复为零。

按下该键进入其他功能设置。

<input type="button" value="关"/>	<input type="text" value="0"/>	<input type="text" value="0"/>
色标	色标间距	切刀次数
<input type="button" value="冲孔设置"/>		<input type="button" value="高级设置"/>
<input type="button" value="返回"/>		

总孔数	<input type="text"/>	连续打孔功能	<input type="text"/>
孔号	孔距	孔号	孔距
一号		六号	
二号		七号	
三号		八号	
四号		九号	
五号		十号	
<input type="button" value="确定"/>			

- 切商标时按下该键红外定位传感器开启。
- 按下该键 输入商标中废料的长度，如无废料直接输入0。
- 按下该键，输入数字，数字越大切刀次数越多。
- 按下该键输入冲孔数据。
- 按下该键修改系统设置（制造商或专业人员使用）。
- 按下该键返回上一页。
- 产品需要冲孔数量，点击数字可以设定（0-10）。
- 孔号：孔的排序。
- 孔距：1号孔的孔距：从刀片1到本孔的距离，2号孔的孔距：从1号孔到本孔的距离，以此类推。

## 五、操作方法

1、设置长度、数量（如：设定长度100mm，数量 50pcs）


打开电源开关，面板显示窗显示电脑界面

按下"键输入 100，再按下“确认”，长度设置完成。

按下"键输入 50，再按下“确认”，数量设置完成。

2、设置直角带冲孔、孔距有长短：按下 进入冲孔设置、按下 该键，输入你要冲孔的孔数（如：3个孔，就输入3”，选择 孔号，输入 孔距"10mm"、选择 孔号，输入 孔距"20mm"、选择 孔号，输入 孔距30mm"。按下 确认键设置完成。按下 返回键，点击 该键机器开始工作，并按照您所设定的参数自动完成。

注：如孔距相同就输入同样孔距尺寸。

3、色标中间废料设置：色标间距是指两段商标间空白段"废料"的距离，如空白段长度10mm，则 色标间距输入数值"10mm"；如果中间没有空白段，"废料"不必输入长度（即色标间距输入"0"）；如图 

## 六、如何调色标传感器（选装）

(1). 按下 该键红外定位传感器开启。

(2). 将切断线对准切刀口，如图



图1

- (3). 测量商标需要切的长度并输入数值;
- (4). 将光标移动到商标的定位点 ( 最好颜色容易区别处 ), 按一下 " 色标设置按键 "2如图
- (5). 再将光标移到空白处 ( 如图按一下 " 色标设置按键 ", 最后将光标移到定位点 ( 如图然后固定螺丝。



图2



图3

- (6). 按下复位键, 再按启动开始工作。

切带中遇到的问题 :

- 1.请确定是否调节好传感器 ;
- 2.向前或向后移动传感器
- 3.检查传感器的灵敏度与高度
- 4.检查切断速度 ( 一般速度为90%)

注意 : 设置好色标传感器后, 请不要按任何按钮, 以免发生错误改变了之前输入的数据 .

## 七、如何调刀和切刀平台平衡

- 1、首先关闭电源
- 2、将调压阀上气压调至0气压
- 3、用32MM扳手松开气缸缸顶上的缸轴螺帽
- 4、将上刀压至最低使上刀和切刀平台相接触
- 5、从平台托板上八颗螺丝将平台调平衡使上刀转到任何角度没间隙 (四颗低的往下拉, 四颗高的往上抬) 调好后固紧螺帽。
- 6、用32MM 扳手固紧气缸缸轴上的螺帽 (注: 根据材料厚薄上刀和切刀平台间的空隙, 一般建议有 0.1MM 的间隙) 。

## 八、注意事项

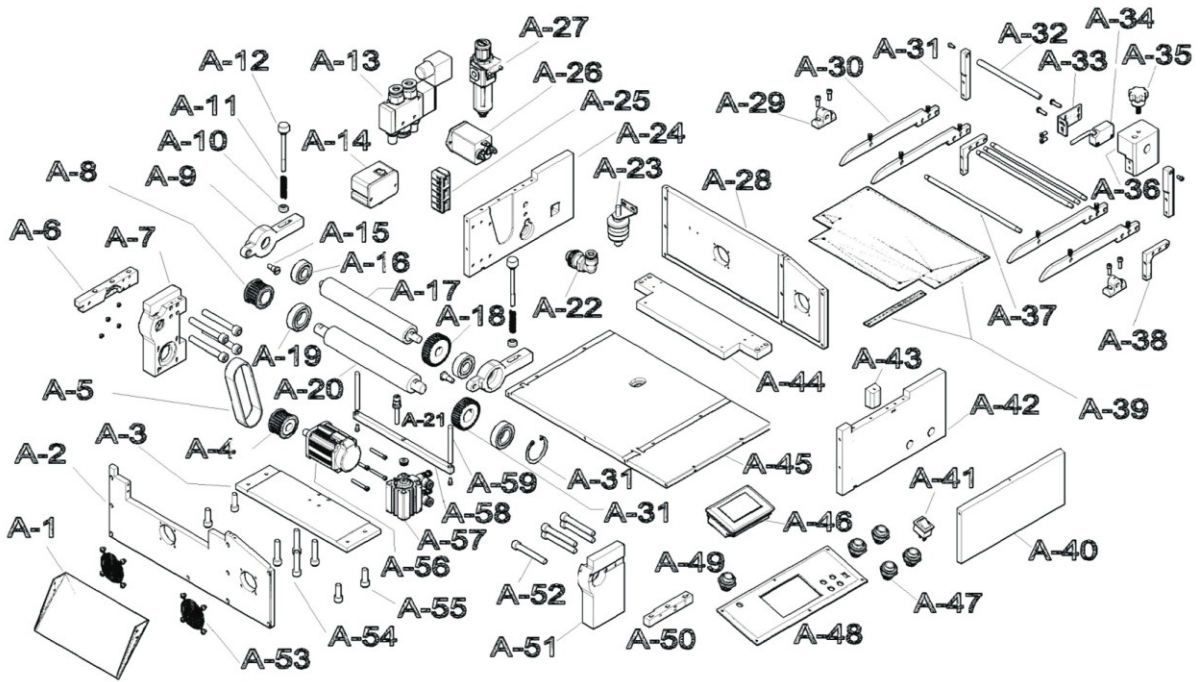
- 1、使用前请确认电源电压和连接地线。(注意: 接地线必须接地)
- 2、为了确保安全, 在机器运转过程中请不要将手或任何物体靠近切刀口。
- 3、在做任何调整时, 必须先切断电源、气源以保安全。
- 4、除了正常保养外, 请勿任意拆卸任何零部件。
- 5、每班开机前, 勿必在切刀座滑套上加机油一次, 以保滑套润滑。
- 6、如果刀具使用一段时间后变钝了, 可以到专业磨床进行磨刀 (注意: 此工作必须专业人士操作)
- 7、若在操作上有任何困难, 请与本公司联系, 我们将竭诚为您服务。

## 九、一般故障的排除措施 (供参考)

序号	故障现象	对应機種	原因与措施
1	无电源	全機種	<ol style="list-style-type: none"> <li>1. 检查电源连接插头接触是否良好；</li> <li>2. 检查保险丝是否断开；</li> </ol>
2	有电源，但无法启动，传感器出错	全機種	<ol style="list-style-type: none"> <li>1. 检查气缸是否通气，如果未通气，请开启阀门；</li> <li>2. 检查切刀座滑套是否卡死，在滑套上注上润滑油；</li> </ol>
			<ol style="list-style-type: none"> <li>1. 材料是否用完，请更换新材料；</li> <li>2. 检查是否装有材料或压板掉槽里；</li> <li>3. 如果都正常检查行程开关是否卡住没弹回去；</li> </ol>
			检查是否有气压或冲孔架卡住
			如果本机器连续超长时间工作使用，机箱里面的温度可能超高，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，等温度冷却后再开机显示应当正常，如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，打開箱检查电脑连接插线、保险丝。
3	无法切断带子	全機種	<ol style="list-style-type: none"> <li>1. 检查气压是否达到，如未达到请增加气压；</li> <li>2. 检查刀片是否锋利，刀片要锋利；</li> <li>3. 热刀刀片是否加热，热刀刀片是否跟平台接触。刀片要加热，刀口要跟平台接触到；</li> </ol>
4	只切断带子的一边	热刀	检查切刀平台是否有高低，如有，请在平台下面的调节螺丝这里调节切不断的这一边适当往下拧，或在高的一边往上适当的松螺丝。调节好了再紧固螺帽。
5	切断长度与设定值不同	全機種	放松滚轴或利用送带机辅助送料。开启补偿功能。
6	切断长度不一致	全機種	<ol style="list-style-type: none"> <li>1. 放慢送料速度；</li> <li>2. 放松档盘；</li> <li>3. 必要时配送带机辅助送料；</li> </ol>
7	切断商标时，未到切断线切断	色标	向刀口的方向移动感应器，相当于差异隙距离。商标印刷不标准，建议用印刷标准的商标。
8	切断商标时，超出切断线切断	色标	向刀口的反方向移动感应器，相当于差异隙距离。商标印刷不标准，建议用印刷标准的商标。
9	色标传感器出错	色标	按下弹出窗口，刀口对准切断线，再按启动键。
10	无材料供给	全機種	材料用完，重新装上材料。
11	转刀复位传感器出错	转角	按复位键重新复位。
12	手触到设备时，有电流	全機種	<p>用户在安装本设备是须自配防触电漏电开关，三脚插座接地极必须要有良好的接地线，才能确保机器正常工作。</p> <p>注：在工作时请不要打開箱门，以免中断正常切割工作。本机具有开门自动断电功能。</p>



# 零件图

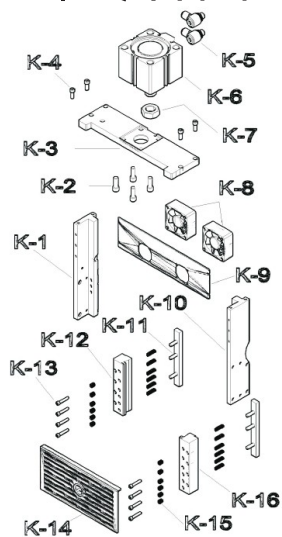


# 零件图

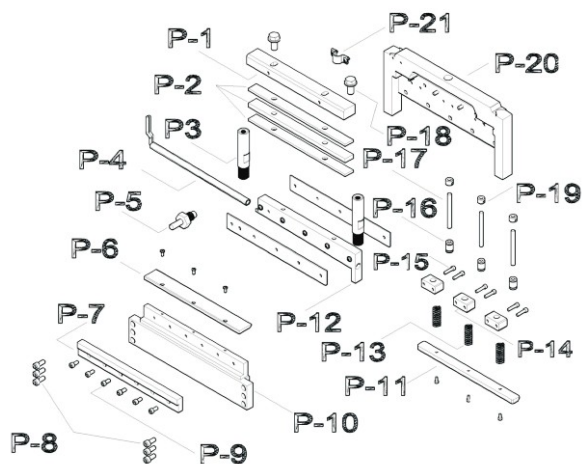
图号	名称	图号	名称
A-1	滑料板	A-33	传感器支架
A-2	前盖	A-34	无材料传感器
A-3	电机座固定板	A-35	梅花螺丝
A-4	下同步齿轮	A-36	滑块
A-5	同步带	A-37	过带轴
A-6	左电机座上固定板	A-38	过带轴座
A-7	左电机座	A-39	上盖
A-8	上同步齿轮	A-40	右侧盖
A-9	压料架	A-41	开关
A-10	垫片	A-42	中间板
A-11	上轮压力弹簧	A-43	面板固定块
A-12	调节螺丝	A-44	冲孔座
A-13	电磁阀	A-45	底板
A-14	电磁阀	A-46	触摸屏
A-15	固定螺丝	A-47	按键
A-16	轴承 6203 ZZ	A-48	面板
A-17	压料轮	A-49	按键
A-18	尼龙齿轮	A-50	右电机座固定板
A-19	轴承 6005 ZZ	A-51	右电机座
A-20	送料轮	A-52	M6螺钉
A-21	M6螺钉	A-53	风扇网
A-22	接头	A-54	M6螺钉
A-23	消音器	A-55	M6螺钉
A-24	左侧板	A-56	送料电机
A-25	接线端	A-57	抬压轮气缸
A-26	滤波器	A-58	抬压轮架
A-27	调压阀	A-59	抬压轮轴
A-28	后盖		
A-29	挡料板固定架		
A-30	挡料板		
A-31	传感器固定架		
A-32	传感器固定轴		



## 刀架零件图

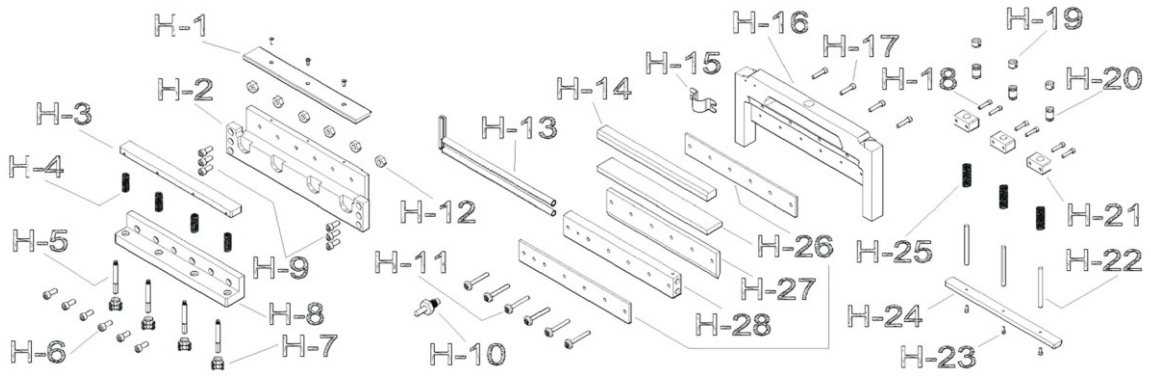


## 冷热刀零件图

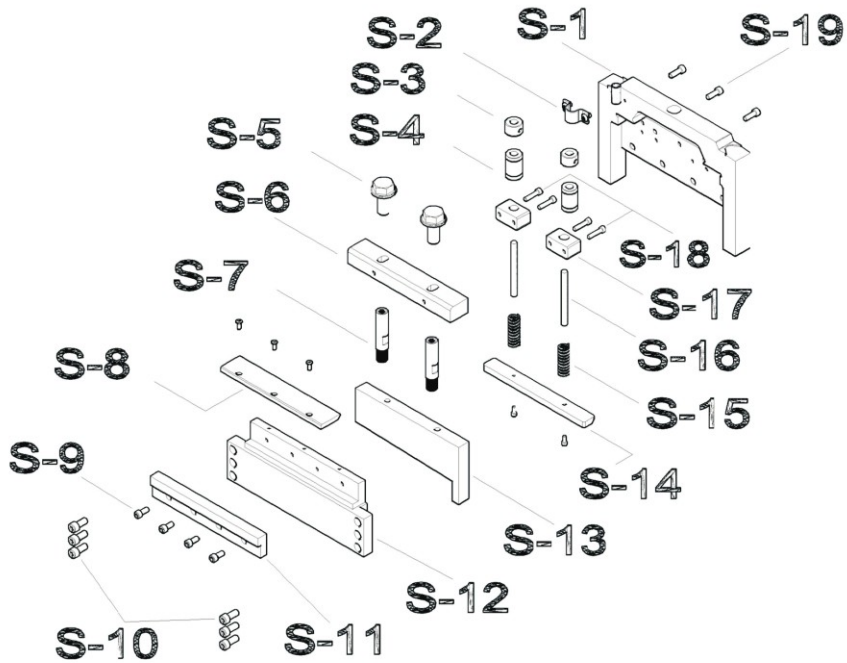


图号	名称	图号	名称
K-1	左支架	P-1	上垫块
K-2	M10 螺钉	P-2	隔热板
K-3	切刀气缸托板	P-3	上刀螺钉
K-4	M8 螺钉	P-4	加热管
K-5	节流阀	P-5	热电偶
K-6	切刀气缸	P-6	送料垫板
K-7	气缸螺帽	P-7	下刀
K-8	6x6 风扇	P-8	M6 螺钉
K-9	风扇架	P-9	M6 螺钉
K-10	右支架	P-10	下刀固定座
K-11	导轨压板	P-11	压料板
K-12	左压板架	P-12	上刀
K-13	M6 螺钉	P-13	弹簧
K-14	保护罩	P-14	压料板固定座
K-15	导轨压板弹簧	P-15	M4 螺钉
K-16	右压板架	P-16	直线轴承
		P-17	压料板轴
		P-18	M8 螺钉
		P-19	挡圈
		P-20	刀架
		P-21	M6 螺钉

# 热刀零件图



# 冷刀零件图



# 零件图

图号	名称	图号	名称
H-1	送料垫板	S-1	刀架
H-2	下刀固定座	S-2	热电偶
H-3	导轨压板	S-3	挡圈
H-4	M4螺钉	S-4	直线轴承
H-5	M6螺钉	S-5	M8螺钉
H-6	M6螺钉	S-6	上垫块
H-7	刀架压力弹簧	S-7	上刀固定螺钉
H-8	支架	S-8	送料垫板
H-9	M6螺钉	S-9	M6螺钉
H-10	热电偶	S-10	M6螺钉
H-11	M6螺钉	S-11	下刀
H-12	M6螺钉	S-12	下刀固定座
H-13	加热管	S-13	上刀
H-14	上垫块	S-14	压料板
H-15	电线固定座	S-15	压料板弹簧
H-16	刀架压力弹簧	S-16	压料板轴
H-17	M5螺钉	S-17	压料板轴
H-18	M4螺钉	S-18	M4螺钉
H-19	挡圈	S-19	M6螺钉
H-20	直线轴承		
H-21	压料板固定座		
H-22	压料板轴		
H-23	M3螺钉		
H-24	压料板 (H)		
H-25	压料板弹簧		
H-26	隔热板		
H-27	上刀		
H-28	发热块		

## I. Brief Introduction

The multi-function auto-cutting machine is a new special integrating pneumatic, mechanical and electrical actions automatically through the computer program and automatically cut off the belt-shaped objects such as woven belt, plastic hoods, widths, lengths and angles according to the length and quantity required. The precision is higher thanks to the compensation function designed according to the elasticity of materials (the infrared positioning device: the trademarks of different widths can be cut off by the infrared sensor system. The punching unit: the punch die can be replaced according to the punch holes of different sizes). With the function of automatic stopping when the end of cutting of thick materials, high precision, high cutting speed, flat cut surfaces, etc, this machine is the best choice for production efficiency, improve product quality and save labor cost.

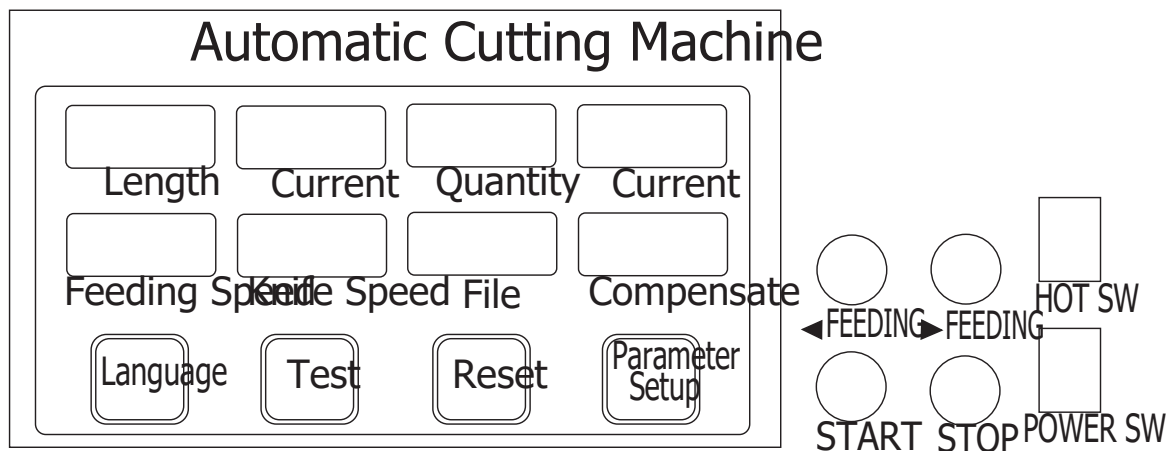
## II. Specification

Model	Cutting Length (mm)	Cutting Speed (p/min)	Max. Cutting Width (mm)	Punching Diameter (mm)	Max. Blade Temp(C)	Recommended Pressure (Mpa)	Voltage (v)
130LR	20-99999	170	195/295	10	350	0.3-0.6	110/220
130H	20-99999	170	198/298	10	400	0.3-0.6	110/220
130L	20-99999	170	200/300	10	-	0.3-0.6	110/220
130R	20-99999	120	20-100	-	-	0.3-0.6	110/220

## III. Service Environment

This Machine works at room temperature, and its performance will be influenced by the environment (higher than 50°C)

## IV. Introduction of Panel Functions



HOT SW  POWER SW

◀ FEEDING Press this key to feed the materials forward manually

▶ FEEDING Press this key to return the materials backward manually

Press this key and the machine will stop to work. Press this key and the machine will stop work.

Press down this button, the upper pressing wheel will be lifted up to manually switch and the upper pressing wheel will be put down.

Length Press this key to set the length.

Current Display current length, press this key and the current length will be reset to 0.

Quantity Press this key to set the quantity.

Current Display current quantity, press this key and the current quantity will be reset to 0.

Feeding Speed Press the key, input the number, the larger the number, the faster the speed, the smaller the number, the slower the speed.

Knife Speed Press the key, input the number, the smaller the number, the faster the speed, the larger the number, the slower the speed.

File Press this key to select the stored file.

Compensation Due to the different elasticity of various materials, when the cut length is longer than the actual input length, use this key to appropriate compensation to achieve the target length.

Language Press this key to select language.

Test Press this key to cut once manually.

Reset Press this key when the system has no error, and the current data will be reset to 0.

Parameter Setup Press this key to enter other function settings.

ON      0      0

Sensor      The Distance Between The Color Code      Cutting Times










Hole Set      Advanced Setup

Return







Quantity of holes      Continuous punching functions OFF

Hole Number	Distance Between Holes	Hole Number	Distance Between Holes
NO.1		NO.6	
NO.2		NO.7	
NO.3		NO.8	
NO.4		NO.9	
NO.5		NO.10	

Return

-  Press this key when cutting off the trademark, and the infrared position sensor will be turned off.
-  Press this key to input the scrap length in the trademark. If there is no scrap length, input 0.
-  Press this key, input the number, the larger the number, the more times of cutting.
-  Press this key to input the data of punched hole.
-  Press this key to modify the system settings (to be used by manufacturer or technician).
-  Press this key to return to the previous page.
-  The quantity of punched holes needed by product, which can be set by clicking this key.
-  The sequence of the hole.
-  The pitch of No. 1 hole: the distance from the blade 1 to this hole; the pitch of No. 2 hole: the distance from No.1 hole to this hole; and so on.

## V. How To Operate

1. Set the length and quantity (for example: set the length to be 100mm and the quantity to be 50). Turn on the power switch, and the display window of the panel will display the code. Press  Length key, input 100, then press enter key, and the length setting is 100mm. Press  Quantity key, input 50, then press enter key, and the quantity setting is 50.
2. Set the straight angle and punched hole, with different pitches: Press  to enter the punched hole settings, press  key, input the quantity of holes. (As shown in the figure below: to punch three holes, input "3" for the total holes, input "1" for No.1 hole, input 20mm for pitch of No.2 and 30mm for pitch of No.3). Press  key to return to the previous page. Press  key and the machine will start to work. Note: If the pitch is the same, input the same pitch value, as shown below:
3. Setting of waste in the middle of the color code: the color code spacing refers to the blank segments of "waste" between two trademarks. If the length of the blank segment is 10mm, the color code spacing input is "10 mm"; if there is no blank segment in the middle, the color code spacing input is "0"; if there is a blank segment in the middle, the length of the blank segment need to be input (i.e. the color code spacing input is "10mm"; as shown in the figure below).

## VI. How To Use the Color Sensor (Option)


- (1) Press the  key to turn on the infrared positioning sensor.
- (2) Locate label's cutting line and upper knife precisely (Fig. 1);



Fig.1



- (3) Measure the length of the label and enter the value;
- (4) Move the cursor to the positioning point of the trademark (the best color is ea "color mark setting button", as shown in Figure 2;
- (5) Then move the cursor to the blank (as shown in Figure 3), press the "color co the cursor to the positioning point (as shown in Figure 2), then fix the screws.



fig2



fig3

9. Press the "RESET" button to restore the system, then press "START" to working

#### Troubles in cutting

- Check if you adjust sensor after cutting line of label on the knife blade.
- Move the sensor forwards and backwards.
- Check sensitivity & height of the sensor.
- Check the cut speed (normal 50%).

#### Caution:

After setting the sensor, do not press DELAY, L/D button, it may happen an error

### VII. How To Adjust the Balance of the Knife and Cutting Knife Platform

1. First turn off the power supply.
2. Adjust the air pressure on the pressure regulating valve to be zero air pressure
3. Loosen the cylinder shaft nut on the top of cylinder with 32MM wrench.
4. Press the top knife to the lowest position to make the top knife contact the cut
5. Adjust the platform to be in balance with eight screws on the support plate of matter the top knife rotates at whatever angle (pull down the four lower screws a and then fasten the nuts.
6. Fasten the nuts on cylinder shaft with 32MM wrench (note: usually 0.1MM gap top knife and cutting knife platform according to the material thickness.)

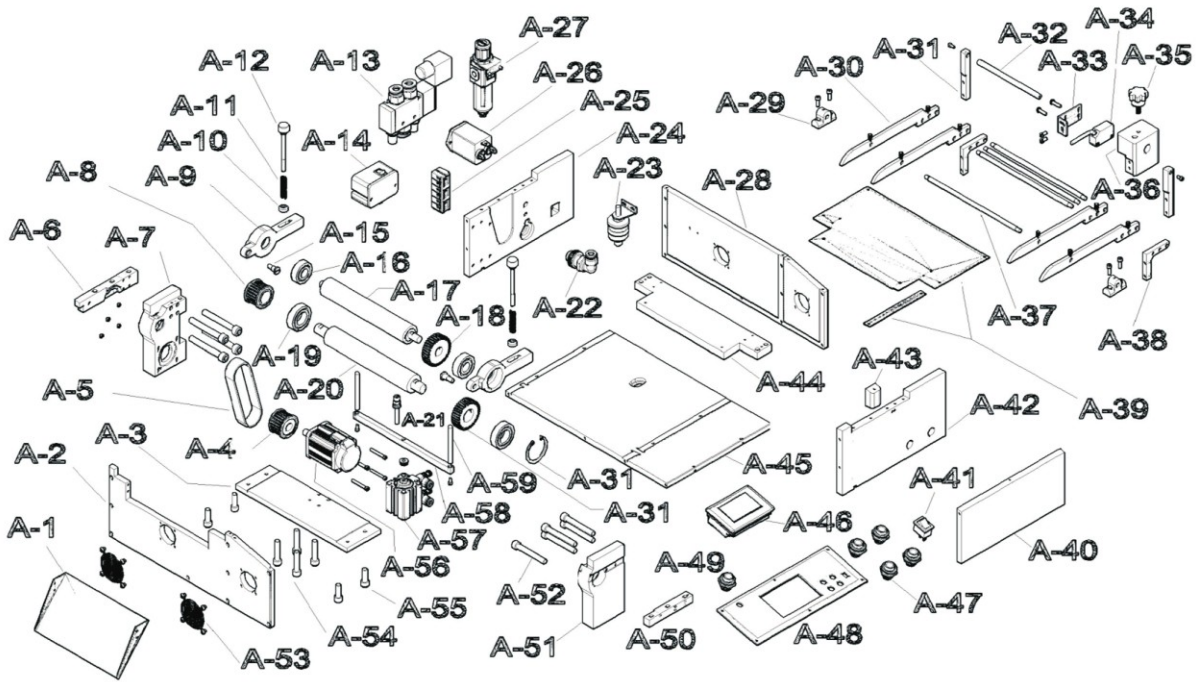
### VIII. Precautions

1. Please confirm the power voltage and connection of ground wire before use. (grounded)
2. Please don't put your hand or any object close to the cutting knife edge during the safety.
3. Be sure to cut off the power source and air source before any adjustment for t
4. Please don't dismantle any components unless in normal maintenance.
5. Please fill oil timely when there is no oil on the guide rail of cutting knife base t (Fill the engine oil for automobiles rather than the white oil of sewing machine.)
6. Sharpen the knife with the special grinding machine if the knife is blunt after u work must be performed by professionals).
7. In case of any difficulty in the operation, please contact our company and we v

## IX. Measures for Removal of Common Faults (for reference)

NO.	Troubles	Applicable Model	Causes & Measures
1	No power supply	All models	1.Check if electric cord is connected well; 2.Check if the fuse blows out or not;
2	There is power, but the machine fails to be started and the sensor has an error and the sensor has an error	All models	The sliding sleeve of cutting knife base is stuck or there is no air pressure 1.Check if the air cylinder is connected to the air and if not, please open the valve; 2.Check if the sliding sleeve of cutting knife base is stuck, and inject the lubricating oil on the sliding sleeve;
			Alarm of no material 1.Check if the materials are used up, and please replace with new material when needed; 2.Check if there is material or if the pressing plate drops into the slot 3.If all is confirmed normal, check if the travel switch is stuck and doesn't bounce back.
			There is punching error Check if there is air pressure or if the punching holder is stuck.
			The panel has no display 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)
3	Fail to cut off the belt	All models	1.Check if the air pressure reaches the required value, and if not, please increase the air pressure. 2.Check if the blade of heat contacts the platform, the blade should be sharp. 3.The blade of heat knife should be heating and the blade of heat knife should be heating and the knife edge should contact the platform
4	Only on side of the belt is cut off	Hot cutter	Check if the air pressure reaches the required value, and if not, please increase the air pressure. Check if the blade is sharp, if the blade of heat knife is heating and if the blade of heat knife contacts the platform. The blade should be sharp, the blade of heat knife should be heating and the knife edge should contact the platform.
5	The cutting length is different from the set value	All models	Loosen the roller or use the belt transmitter to feed the materials. Enable the compensation function.
6	The cutting length is not uniform	All models	1.Slow down the deeding; 2.Loosen the baffle plate; 3.Use the belt transmitter to feed the materials when necessary.
7	The trademark is cut off before reaching the cutting line	Color code	Move the sensor in the direction of the knife edge till the distance of the difference gap. The trademark printing is not standard. The trademark of standard printing is recommended.
8	The trademark is cut off after exceeding the cutting line	Color code	Move the sensor in the opposite direction of the knife edge till the distance of the difference gap. The trademark printing is not standard. The trademark of standard printing is recommended.
9	The color code sensor has an error	Color code	Press down the pop-up window, align the knife edge with the cutting line, press "RESET" key and then press "START" key.
10	No material supply	All models	Replace new materials.
11	The reset sensor of rotating knife has an error	Rotating angle	Press "RESET" key to reset.
12	There is current when touching the equipment	All models	When installing the equipment, the user must equip the anti electric shock leakage switch by himself, and the grounding electrode of the three pin socket must have a good grounding wire to ensure the normal operation of the machine. Note: please do not open the door of the case during operation to avoid interrupting the normal cutting work. This machine has the function of automatic power-off when opening the door.

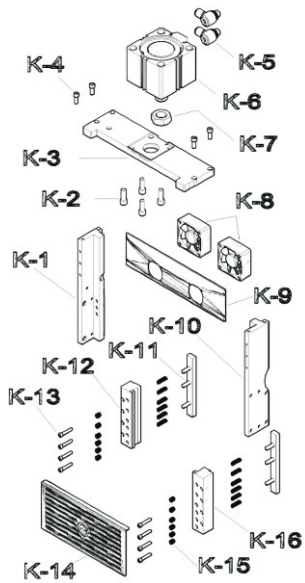
# Parts Drawing



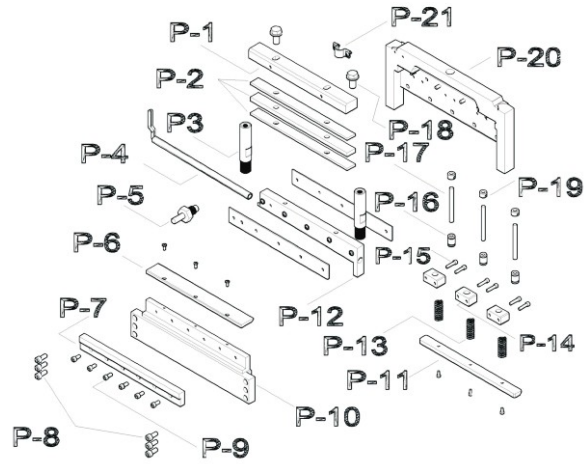
# SPAREPARTS

NO.	Name	NO.	Name
A-1	Material sliding plate	A-33	sensor bracket
A-2	Front cover	A-34	sensor for materials run out
A-3	fixed plate of motor base	A-35	screw
A-4	lower Synchronous belt	A-36	slider
A-5	Synchronous belt	A-37	ober band axis
A-6	left fixed plate of motor base	A-38	ober axle housing
A-7	left motor base	A-39	upper cover
A-8	upper Synchronous gear	A-40	Right cover
A-9	Clamping bracket	A-41	power switch
A-10	Gasket	A-42	Intermediate late
A-11	upper gear pressure spring	A-43	Fixed block of panel
A-12	regulating screw	A-44	punching seat
A-13	Solenoid valve	A-45	Base plate
A-14		A-46	touch screen
A-15	fixing screw	A-47	key
A-16	Bearing(6203 ZZ)	A-48	Panel
A-17	Upper roller	A-49	key
A-18	nylon gear	A-50	right fixed plate of motor base
A-19	Bearing(6005 ZZ)	A-51	right motor base
A-20	Feeding wheel	A-52	Clamping bolt M6
A-21	Clamping bolt M6	A-53	Fan net
A-22	joint	A-54	Clamping bolt M6
A-23	silencer	A-55	Clamping bolt M6
A-24	Left plate	A-56	feeding motor
A-25	connect	A-57	booster cylinder
A-26	wave filter	A-58	booster shaft
A-27	pressure gegulating valve	A-59	booster rack
A-28	Rear cover		
A-29	fixing frame of retaning plate		
A-30	retaning plate		
A-31	Fixed frame of sensor		
A-32	sensor fixed shaft		

(Knife Holder)Parts Drawing

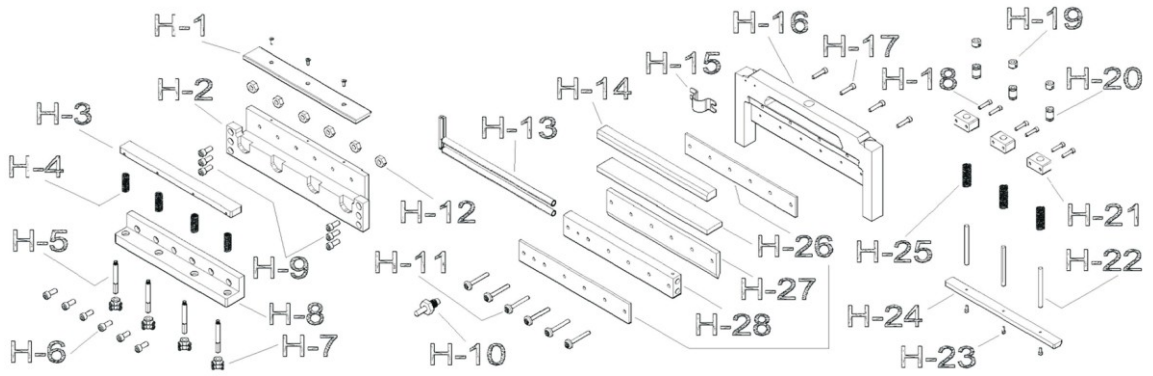


(Cold & HOT)Parts Drawing

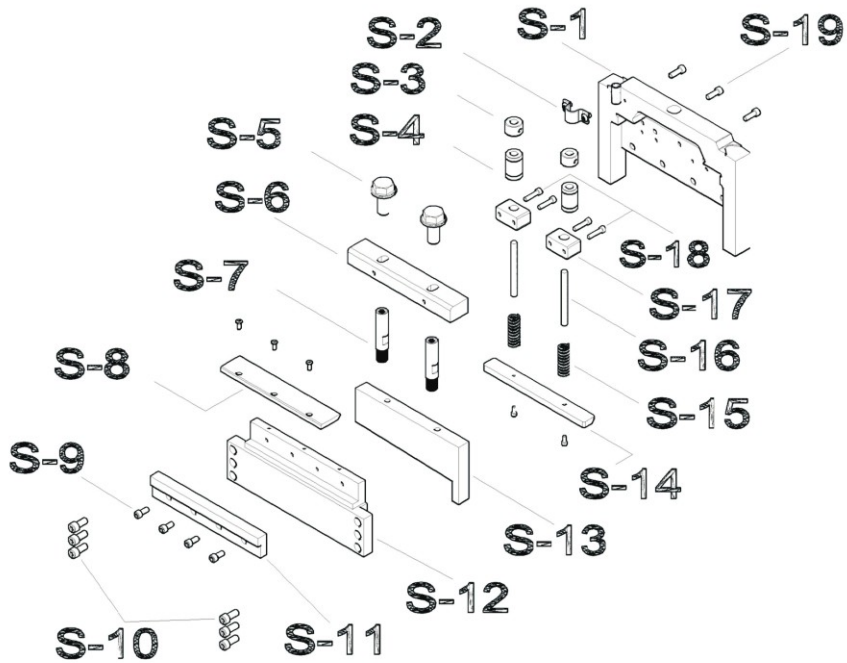


NO.	Name	NO.	Name
K-1	left bracket	P-1	upper backing plate
K-2	Clamping bolt M10	P-2	insulation board
K-3	cutter cylinder support plate	P-3	upper knife screw
K-4	Clamping bolt M8	P-4	Heating tube
K-5	throttle valve	P-5	Thermal couple
K-6	cutter cylinder	P-6	feeding pad
K-7	cylinder nut	P-7	Bottom knife blade
K-8	6*6 fan	P-8	Clamping bolt M6
K-9	fan frame	P-9	Clamping bolt M6
K-10	right bracket	P-10	lower knife fixing seat
K-11	guide plate	P-11	Material pressing plate
K-12	left pressboard rack	P-12	Top knife blade
K-13	Clamping bolt M6	P-13	spring
K-14	protective cover	P-14	fixed seat of pressing plate
K-15	guide plate spring	P-15	Clamping bolt M4
K-16	right pressboard rack	P-16	Linear bearing
		P-17	Material pressing plate axle
		P-18	Clamping bolt M8
		P-19	Retaining ring
		P-20	knife carrier
		P-21	Clamping bolt M6

(Hot) Parts Drawing



(Cold) Parts Drawing





# SPAREPARTS

NO.	Name	NO.	Name
H-1	feeding pad	S-1	Knife rest
H-2	lower knife fixing seat	S-2	Thermal couple
H-3	guide plate	S-3	Retaining ring
H-4	Clamping bolt M4	S-4	Linear bearing
H-5	Clamping bolt M6	S-5	Clamping bolt M8
H-6	Clamping bolt M6	S-6	upper block
H-7	knife carrier pressure spring	S-7	upper knife fixing screw
H-8	bracket	S-8	feeding pad
H-9	Clamping bolt M6	S-9	Clamping bolt M6
H-10	Heat transfer	S-10	Clamping bolt M6
H-11	Clamping bolt M6	S-11	Bottom knife blade
H-12	Clamping bolt M6	S-12	lower knife fixing seat
H-13	Heating tube	S-13	Top knife blade
H-14	upper block	S-14	Material pressing plate
H-15	wire holder	S-15	Material pressing plate spring
H-16	knife carrier pressure spring	S-16	Material pressing plate axle
H-17	Clamping bolt M5	S-17	fixed seat of pressing plate
H-18	Clamping bolt M4	S-18	Clamping bolt M4
H-19	Retaining ring	S-19	Clamping bolt M6
H-20	Linear bearing		
H-21	fixed seat of pressing plate		
H-22	Material pressing plate axle		
H-23	Clamping bolt M3		
H-24	Material pressing plate (H)		
H-25	Material pressing plate spring		
H-26	Thermal baffle		
H-27	Top knife blade		
H-28	heating block		

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