

电子型分线机

converting ZHX-205

零件說明書

一、操作準備：

架綫（紗）：操作者應將被分原綫分別裝在左右的綫盤上，拉上座拉手將未上綫的綫芯裝在綫架 9 上；并將被分原綫的綫頭，按結構圖中箭頭所示的順序，通過各處綫鉤及搭在槽筒 11 上，繞至綫架的綫芯上，架綫中注意將斷綫開關 10 壓下。

架綫完畢後，操作者應將左右綫架放在槽筒上，并使之與槽筒靠平，確保槽筒與綫芯之間無間隙。

本機已備有綫芯一套，供用戶分綫時使用，當用戶選用其他規格的綫芯（紗管）時，要注意使綫芯（紗管）與槽筒靠平無間隙。如有間隙存在，操作者可調正綫架螺釘 16，使之靠平。若所選用的綫芯（紗管）過短，造成下座銅套搭在槽筒上時，操作者應即調正綫架螺釘 16，并將下座銅套 14 外撥至適當位置，以免損壞槽筒。

將電源開關 2 發至“OFF”位置，將電源插頭插至電源。

將功能開頭插至所需位置（單或雙）上。

二、起動運轉：

本機起動前，操作者應檢查：A 各綫鉤及綫芯（紗管）之間的綫段是否按架綫前頭順序拉緊。B 斷綫開關 10 是否已被綫壓下，處於“開”的位置。C 功能開關 6 是否插至所需的位置（單或雙）上。

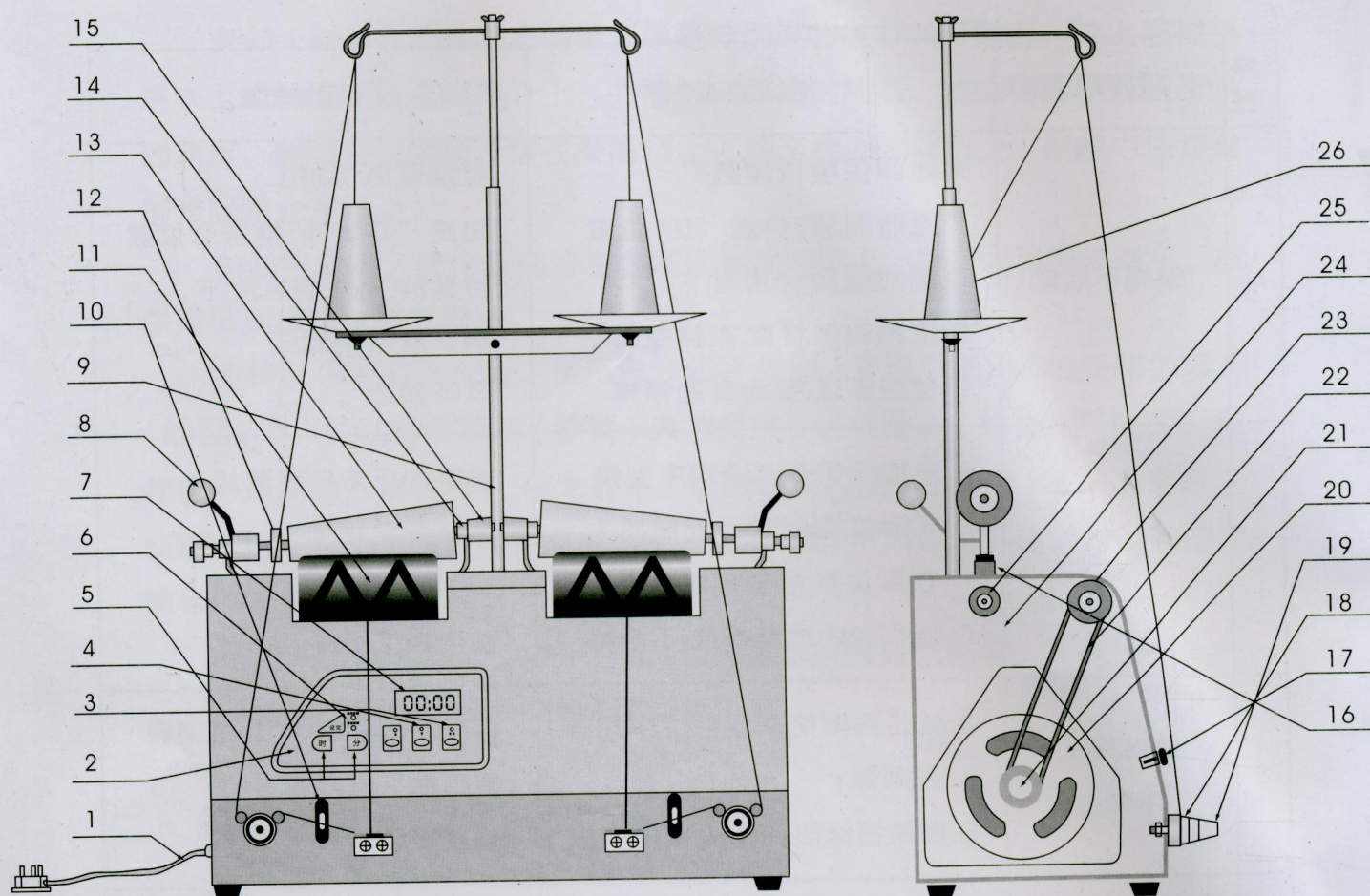
操作者應將電源開關 2，撥至“ON”位置，即指示燈 3 亮後，方可扭轉定時器至“ON”或扭至所需時分的位置上，本機即開始運轉，雙頭分綫。

當本機在運行中，分綫斷頭其斷綫開關 10 即跳上，整機自動停車，操作者應及時按綫，按架綫順序架綫，并將斷頭開關壓下，重新起動。

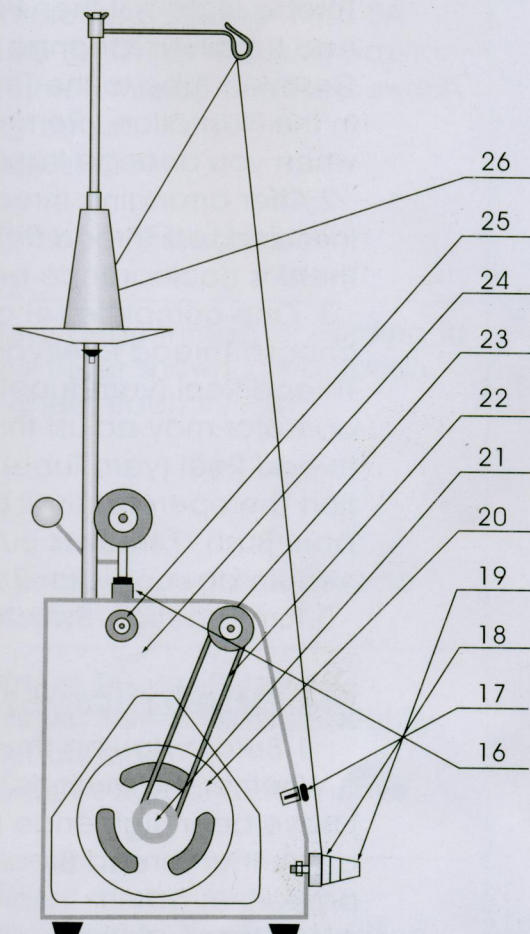
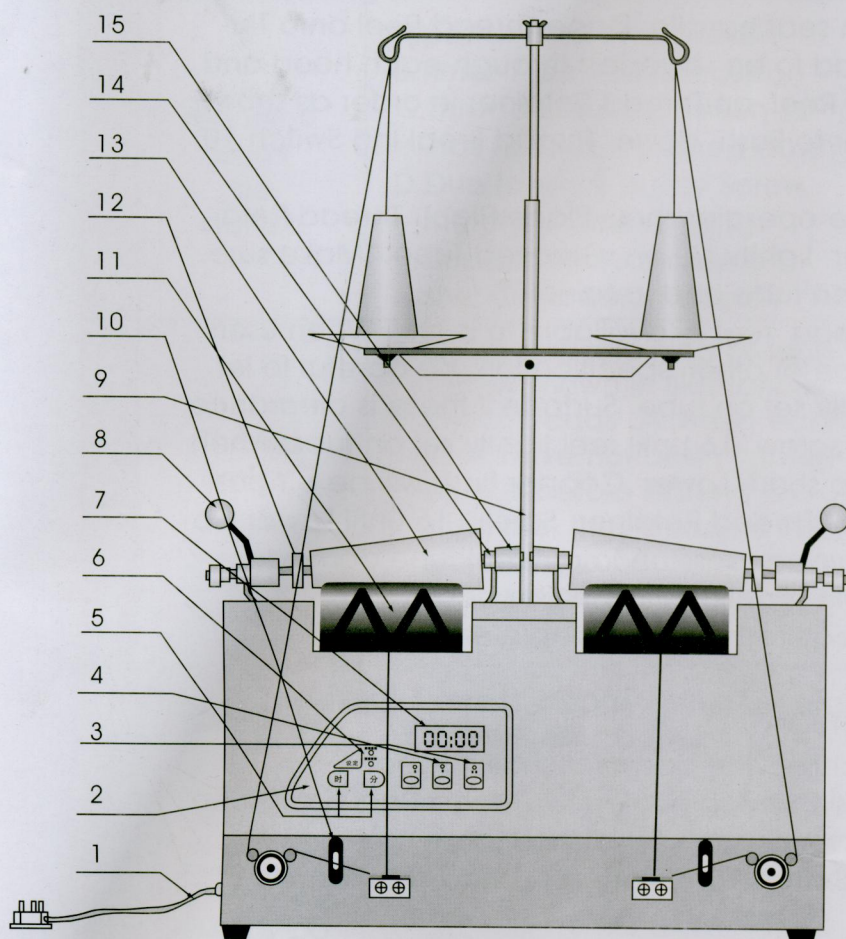
用戶若用需單頭分綫時，操作者應在左面綫架分綫。并將右面綫架推上，功能開關撥至“單”的位置，并按起動順序起動，本機即開始運轉單頭分綫。

三、常見故障及檢查消除方法

序號	故障現象	原因檢查	消除方法
1	整機不起動	A. 電源保險17熔斷 B. 定時開關7仍處“0”位置 C. 斷綫開關10未壓下 D. 皮帶輪螺釘鬆, 電機空轉 E. 發生斷綫, 整機自動停車	更換電源保險5 扭至“ON”所需時分位置 拉緊綫, 用綫將其壓下 調正皮帶輪螺釘 及時接綫
2	斷綫	A. 未按結構圖穿綫順序架綫 B. 起動前, 各綫鈎之間障段未拉緊拉直, 在運轉中打結 C. 綫或紗的強度過低, 不合格	重新按所示順序架綫 拉緊各處綫段 選用合格綫或紗
3	綫芯繞的不漂亮	A. 綫芯與槽筒未靠平, 中間存在間隙; B. 槽筒槽緣表面不光潔或有痕	調正綫架螺釘, 將綫架與槽筒靠平無間隙 修復槽緣
4	綫芯繞的過硬或過軟	夾綫盤未調好	調正夾綫盤螺母至適當位置
5	綫芯繞的不規則	A. 紗管26不規則不合格 B. 下綫鈎位置不適當	更換合格紗管 調正下綫鈎至適當位置
6	噪音振動過大	A. 馬達皮帶過緊 B. 機臺安放不平穩	適當調正馬達距離平穩放置
7	綫架推上後不能定位	定位彈簧片彈力不足或斷裂	調正或更換彈簧片



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|-----------|---------|----------|------------|
| 1 電源插頭 | 8 上座拉手 | 15 下座螺釘 | 22 皮帶18"O型 |
| 2 電源控制面板 | 9 綫芯 | 16 綫架螺釘 | 23 大皮帶輪 |
| 3 電源開關 | 10 斷綫開關 | 17 電源保險管 | 24 中間支架 |
| 4 單 / 雙開關 | 11 槽筒 | 18 夾綫盤 | 25 扭矩彈簧 |
| 5 操作預選鍵 | 12 上座銅套 | 19 調節螺母 | 26 紗管 |
| 6 LED狀態指示 | 13 綫芯 | 20 馬達 | |
| 7 數碼顯示器 | 14 下座銅套 | 21 小皮帶輪 | |



1. Power Plug
2. Computer Controlling Facial Deck
3. Power Switch
4. Mono/Double Switch
5. Operating Pre-selected Key
6. LED Conditional Indicator
7. Digital Displayer
8. Upper Seat Handle
9. Thread Retainer
10. Switch of Thread Cut
11. Grooved Tube
12. Upper Copper Bush
13. Thread Real

14. Lower Copper Bush
15. Lower Screw
16. Thread Retainer Screw
17. Fuse
18. Thread Retainer Plate
19. Adjusting Nut
20. Motor
21. Small Pulley
22. Belt 18"0" Type
23. Large Pulley
24. Central Bracket
25. Torque Spring
26. Yarn Tube

Operation Preparation

1. The operator shall place the thread to be divided on Right and Left Thread Plate first, then Pull on seat handle. Place Thread Reel onto Thread Retainer 9 arrange thread to be divided through each hood and Grooved Tube to the Thread Reel on Thread Retainer in order as shown in the illustration. Remember to Push down Thread Breaking Switch 10 when you arrange thread.

2. After arranging thread, the operator shall Place Right Thread Retainer and Left Thread Retainer tightly set on Grooved Tube. Make sure there is no clearance between tube and retainer.

3. One complete set of thread reel is available to users. When users choose Thread Reel (yarn Tube) of other specification, be careful to let Thread Reel (yarn Tube) tightly set on tube. Surface if there is clearance operator may adjust thread screw 16 until reel tightly set on tube. When thread Reel (yarn Tube) is too short, Lower Copper Bush will be off position. The operator shall adjust Thread Retainer Screw 16 until Lower Copper Bush 14 moves out to proper position to prevent tube damage.

4. Turn power Switch 2 to "OFF" Position, Plug in power plug.

5. Turn Function Switch to required position (single or Double)

Operation Starting

1. Before starting the machine, the operator shall inspect.

a. Whether the threads between each hook and Thread Reel (yarn Tube) have been tightened in order as shown in illustration.

b. Whether Thread Breaking Switch 10 has been pushed down in "Open" position.

c. Whether Function Switch 6 has been turned to required position (Single or double)

2. The operator shall turn the power Switch to "ON" position, waiting indicating Light 3 on, then turn Timer to "ON" Or required position, now the machine begins normal operation.

3. During operation, when thread end breaks, Thread Breaking Switch 10 will automatically make machine shut down. The operator shall connect the end of thread immediately and arrange thread in order, push down Thread Breaking Switch and start the machine again.

4. If user only needs to divide single thread, the operator shall divide thread on Left Retainer, pull Right Thread Retainer up, turn Function Switch to "Single" position, Then start the machine following instruction.

No.	Trouble	Probabic Cause.	Suggsted Rcmedy
1	Machine can't be started	A.power Fuse 17 is broken B.Timer 7 is still in "0" Position C.Thread Breaking Switch 10 has not been pushed down D.Due to loose pulley Screw motor is in idle running E.Thread breaks,machine shut down automatically	Interchange power Fuso 5A Turn to "ON"or required position Tighten thread and Fress switch by thread adjust crew Connect thread soon
2	Thread broken	A.the thread retaining order is not as shown in illustration B.Since threads between each hook nave not been tighten- ed well before starting the machine, they become knot- ted during o peration C.Strength of thread or yarn is unaccptable	Rearrange thread according to the order shown in illustration Tighten each thread Choose acceptable fthread or yarn
3	Thread reel be wound is poor	A.There is clearance between thread reel and tube B.Surfaces of tube and its edge are not well finished or scared	Adjust Thread Retainer Nut,let Thread Retainer tightly set on tube polish edge of tube groove
4	Thread reelbe wound is too hard or too soft	Thread Retaining plate is not adjusted well	Adjust thread retaining plate nut to required position
5	Irregularly woond thread reel	A.yarn core 26 is unacceptable B.Lower hook position is unacceptable	Change yarn core with accept- able one Adjust Lower hook to suitable position
6	Excessive noise and vibration	A.Motor belt is too tight B.Machine seat is not stable	Adjust belt tension properly Set machine stable
7	Thread retainer can't be in position	Retaining plate spring is of Lower tension or broken	Adjust or change plate spring