

二、上电开机

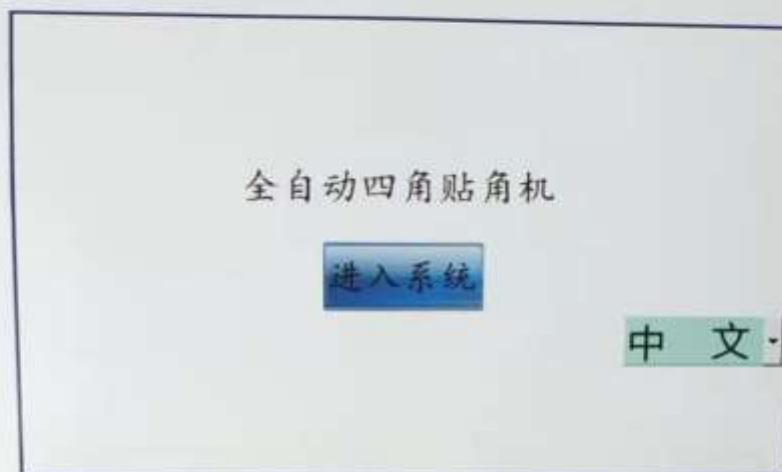


图1 主界面

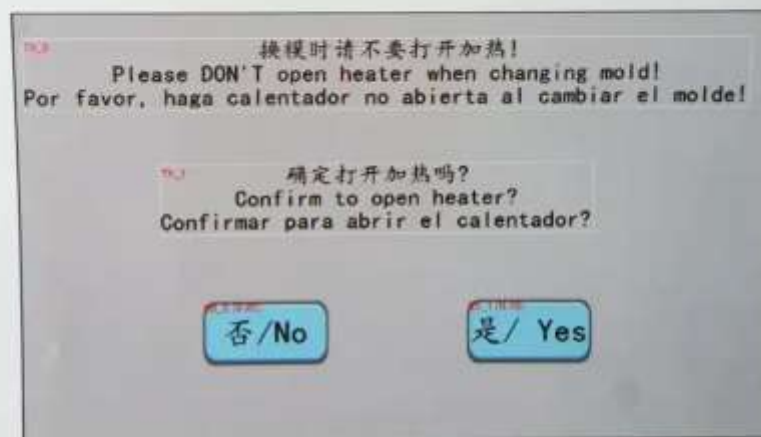


图2 预先加热选择界面

2.1、通电状态

1. 在设备开机正常后，人机界面自动弹出是/否要打开贴头加热(图2)，打开菜单选择手动画面进手动画面后按 点动贴角，确定气压是否正常。
2. 安装模具。将模具装在固定模具块上，锁紧后装上主轴（图3），主轴2个螺丝先不锁死，然后松开4组贴头组件固定座的8个M12螺丝（图3、图4），将贴头组件向外靠（图4），以模具下降碰不到的位置

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二. 上电开机

二. Power on

全自动四角贴角机

Automatic four-corner pasting machine

进入系统 enter the system

2.1、 通电状态

1、 在设备开机正常后，人机界面自动弹出是/否要打开贴头加热(图 2)，打开菜单选择手动画面进手动画面后按点动贴角，确定气压是否正常。

2、 安装模具，将模具装在固定模具块上，锁紧后装上主轴(图 3)，主轴 2 个螺丝先不锁死，然后松开 4 组贴头组件固定座的 8 个 M12 螺丝(图 3、图 4)，将贴头组件向外靠(图 4)，以模具下降碰不到的位置为准

2.1, power-on state

1. After the device is turned on normally, the man-machine interface automatically pops up Yes/No to turn on the head heating (Figure 2), open the menu and select the manual screen to enter the manual screen

Then press the click corner to confirm whether the air pressure is normal.

2. Install the mold, install the mold on the fixed mold block, and install the spindle after locking (Figure 3). The two screws of the spindle are not locked first, and then the 4 sets are loosened. 8 M12 screws (Figure 3, Figure 4) of the mounting head assembly fixing seat, lean the mounting head

assembly outwards (Figure 4), subject to the position where the die cannot be touched by the lowering



M12 螺丝(前后各 2 个, 左右各 2 个)

M12 screws (2 at the front and rear, 2 at the left and right)

模具锁紧螺丝 Mold lock screw

模具 Mould

贴头组件松开(4组) Loosen the head assembly (4 groups)

3. 模具装好后，打开人机界面菜单，进入手动界面，然后点击“慢降”按钮，将模具下降到4组贴头能夹住的位置(圖 6)然后点击“贴头开/关”按钮，贴头推出后，再将4组贴头慢慢向模具靠拔，4组贴头完全贴合模具，不能有縫隙(图 7)，确定贴头调好后，再分别将之前的8个 M12 螺丝锁紧(圖 3、4)所示。

3. After the mold is installed, open the man-machine interface menu, enter the manual interface, and then click the "slow down" button to lower the mold to a position where the 4 groups of paste heads can be clamped (group 6), and then click "Paste head on/off "Press the button, after the sticking head is pushed out, slowly pull the 4 sets of sticking heads toward the mold. The 4 sets of sticking heads are fully fitted to the mold without gaps (Figure 7). Tighten the 8 M12 screws (groups 3 and 4) as shown.



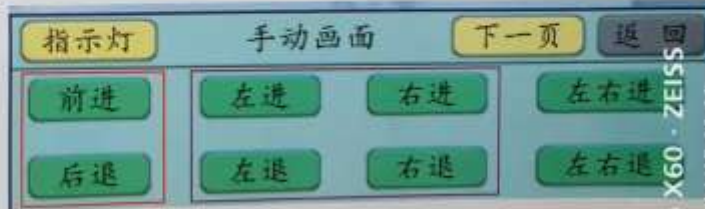
(图7)

4. 确定螺丝锁紧后，点击“贴头开/关”按钮，测试贴头动作是否对模具有太大冲击（模具主轴抖动），测试OK后保持贴头推出状态将模具固定螺丝锁紧。
5. 松开贴头。点击“慢升”按钮，将模头上升至平台上。放一张纸板在平台上，然后将模具慢慢下降到纸板上。将纸板左右前后的折边线与模具底边重合（图8），如果前后端折边线没对齐，打开手动菜单，在界面上点击料架前“前进”/“后退”按钮进行调整（图9）。

6. 前后调整好后，下一步进行左右折边线调整，将纸板放好（图8）。进入手动操作界面（图9）蓝色框，点击“左进”和“右进”按钮进行纸板折边线与模具左右边（注意：进行左右调节时，确认螺丝已扭松开）（图10），纸板最大宽度与挡板之间预留1毫米空隙，确保两边挡板之间纸板有褶皱。



(图8)



(图9)

4. 确定螺丝锁紧后，点击“贴头开/关”按钮，测试贴头动作是否对模具有太大冲击(模具主轴抖动)，测试OK后保持贴头推出状态将模具固定螺丝锁紧。

4. After confirming that the screws are locked, click the "head on/off" button to test whether the head movement has too much impact on the mold (mold spindle jitter). After the test is OK, keep the head pushed out and lock the mold fixing screws.

5. 松开贴头，点击“慢升”按钮，将模头上升至平台上，放一张纸板在平台上，然后将模具慢慢下降到纸板面上，将纸板左右前后的折边线与模具底边重合(图 8)，如果前后端折边线没对齐，打开手动菜单，在界面上点击料架前“前进” 1 “后退”按钮进行调整(图 9)

5. Loosen the pasting head and click the "slow rise" button to raise the die head to the platform, place a piece of cardboard on the platform, and then slowly lower the mold onto the cardboard surface. The bottom edge coincides (Figure 8). If the front and rear hem lines are not aligned, open the manual menu, and click the "forward" 1 "back" button in front of the rack on the interface to adjust (Figure 9).

前后调整好后，下一步进行左右折边线调整，将纸板放好(图 8)，进入手动操作界面(图 9)蓝色框，点击“左进”和“右进”按钮进行纸板折边线与模具左右边(注意：进行左右调节时，确认螺丝已扭松开)(图 10)，纸板最大宽度与挡板之间预留 1 毫米空隙，确保两边挡板之间纸板有顺畅。

After adjusting the front and back, the next step is to adjust the left and right fold lines. Put the cardboard (Figure 8) and enter the blue box in the manual operation interface (Figure 9). The left and right sides of the mold (note: make sure the screws are loosened when adjusting left and right) (Figure 10), leave a 1mm gap between the maximum width of

the cardboard and the baffle to ensure that the cardboard between the two baffles is smooth.

指示灯 Indicator light

手动画面 Manual screen

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返回 return

前进 go ahead

左进 Left in

右进 Go right

左右进 Go left and right

后退 Back

左退 Back left

右退 Back right

左右退 Retreat left and right



(图10)

7. 纸板上料调整，将纸板放入进料输送带上，纸板放入压纸刀底部，调整压纸刀手轮调至纸板1.5倍的高度，生产过程中如有同时出两张纸板，适当将压纸刀降低。



(图11)



(图12)

8. 出料辊调整，先将出料辊调至比纸板大的宽度，放入纸板再调节手轮（图12），将纸板压住以不伤纸板为最佳。

9. 纸板装料，在纸板比较平整可将纸板直放入输送带上，如纸板有弯的，需将上料架的两个托纸板放入纸板底下后半部份，将纸板后面抬起纸板，前端触到压纸刀及输送带进口口（图13）。

皮带与档板之间距保持在1厘米以上距离防止皮带被刮伤



(图13)



(图14)

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2023年11月24日 技术参数更新不另行通知

7. 纸板上料调整，将纸板放入进料输送带上，纸板放入压纸刀底部，调整压纸刀手轮调至纸板 1.5 倍的高度，生产过程中如有同时出两张纸板，适当将压纸刀降低。

Board feeding adjustment, put the cardboard on the feeding conveyor belt, put the cardboard into the bottom of the paper knife, adjust the hand wheel of the paper knife to 1.5 times the height of the cardboard, if there are two cardboards at the same time during the production process, properly The press knife is lowered.

8、出料辊调整，先将出料辊调至比纸板大的宽度，放入纸板再扭调节手轮(图 12)，将纸板压住以不压伤纸板为最佳。

8. To adjust the discharging roller, first adjust the discharging roller to a width larger than that of the cardboard, put the cardboard into it, and then twist the adjustment handwheel (Figure 12). It is best to press the cardboard so as not to crush the cardboard.

9、纸板装料，在纸板比较平整可将纸板直放入输送带上，如纸板有弯的，需将上料架的两个托纸板轴放入纸板底下后半部份，将纸板后面抬起纸板，前端触到压纸刀及输送带进料口(图 13)。

9. Cardboard loading. When the cardboard is relatively flat, you can put the cardboard straight on the conveyor belt. If the cardboard is bent, you need to put the two supporting cardboard shafts of the loading rack into the lower part of the bottom of the cardboard, and lift the back of the cardboard. Pick up the cardboard, and the front end touches the

paper knife and the feed opening of the conveyor belt (Figure 13).

皮带与档板之间距保持在 1 厘米以上距离防止皮带被刮伤

Keep the distance between the belt and the baffle at more than 1 cm to prevent the belt from being scratched



(图15)



(图16)



(图17)



(图18)

左/右挡板宽度调节时，为了不夹伤皮带，请按图15、图16所示先松开挡板固定螺丝，再按图17、图18所示装挡板提高，提高后再将图15、图16上所示的螺丝锁紧，然后再根据纸板大小调节左/右挡板，调好后再将挡板降下来。

左/右挡板宽度调节时，为了不夹伤皮带，请按图 15、图 16 所示先松开挡板固定螺丝，再按图 17、图 18 所示装挡板提高，提高后再将图 15、图 16 上所示的螺丝锁

紧，然后再根据纸板大小调节左/右挡板，调好后再将挡板降下来。

When adjusting the width of the left/right baffle, in order not to pinch the belt, please loosen the fixing screws of the baffle as shown in Figure 15 and Figure 16, and then install the baffle as shown in Figure 17 and Figure 18 to raise it. Tighten the screws shown in Figure 15, Figure 16, and then adjust the left/right baffle according to the size of the cardboard, and then lower the baffle after adjustment.

五、参数设置



(图19)



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(图20)

五. 参数设置 parameter settings

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返回 return

手动画面 Manual screen
贴角时间 Sticking time
纸盒深度 Carton depth
慢升 Slow rise
胶纸长度 Tape length
模具高度 Mold height
上升速度 Ascent speed
下降速度 The rate of decline
慢降 Slow down
参数设置 parameter settings
返回 return
二次间距 Secondary spacing
贴角高度 Corner height
胶纸速度 Tape speed
预备高度 Preparation height
胶纸延时 Tape delay
加减速速度 Acceleration and deceleration
脱模间距 Demoulding distance
加热时间 heating time
卡纸停机 Paper jam shutdown
无料停机时间 No material downtime
满料时间 Full time
送料延时停止 Feeding delay stop
延时启动 Delay start

- 1、在设置参数设置之前，需要测量纸板成形后的深度及模具高度，测量好后，按以下步骤修改默认参数：点击“手动画面”）“纸盒深度”/“模具高度”
- 2、贴角时间：胶带贴盒时间设定；点击“手动画面”）“贴角时间”
- 3、胶纸长度：根据纸盒深度的需要设置贴角胶带的长度；点击“手动画面”）“胶纸长度”
- 4、二次间距：当盒子贴角需贴2次是（即模式2）时，需设定2次贴角胶带的距离点击“菜单”）“参数设置”）“二次间距”
- 5、模具运行速度：上升/下降的速是由模具的大小来决定，当模具尺寸比较小速度可适当加快，模具比较大时，由于大的模具相对重，此时适当降低模具的上升/下降速度；点击“手动画面”）“上升速度”/“下降速度”
- 6、贴角高度：贴好纸盒后看胶纸与纸盒上口高低，来调整正负误差mm。点击“菜单”）“参数设置”）“贴角高度”
- 7、预备高度：开启自动模式运行时模具位置上升到平台以上的高度。点击“菜单”）“参数设置”）“预备高度”
- 8、加减速度：模具主轴上下运动起步/停止时间，此参数根据模具体积重量而定（出厂时已设定），此参数时间如设置过小，可能会造成模具主轴失步，影响设备稳定性；点击“菜单”）“参数设置”）“加减速度”
- 9、胶纸速度：分别是4个贴角送胶带送带速度点击“菜单”）“参数设置”）“胶纸速度”
- 10、胶纸延时：送胶带的的时间设定，注意：此时间设定要大于贴角时间，也不能超过0.5秒。点击“菜单”）“参数设置”）“胶纸延时”
- 11、满料时间：纸板送料输送带电眼开启时有效。（开启自动启停功能时有效）点击“菜单”）“参数设置”）“满料时间”
- 12、延时启动：纸板送料输送带电眼没检测到纸板时，输送带延时启动。（开启自动启停功能时有效）点击“菜单”）“参数设置”）“延时启动”
- 13、脱模间距：当贴角完成时，主轴模具向下推盒到靠角倒钩位置脱模。点击“菜单”）“参数设置”）“脱模间距”（出厂已设置）
- 14、无料停机时间：当来料电眼长时间没检测到有纸板时，设备将在设定时间内停机。点击“菜单”）“参数设置”）“无料延时停机”
- 15、送料延时停止：纸板输送带送料的时间，此功能需关掉出料检测电眼才有效。点击“菜单”）“参数设置”）“送料延时停止”
- 16、加热时间：根据气候季节、环境温度、贴角效果适当调节加热时间长短。正常设为8-10秒。（旧版画面为辅助加热开）点击“菜单”）“参数设置”）“加热时间”
- 17、卡纸停机：纸板从出料辊筒出来后到达前面挡纸位的时间，出厂已设好50毫秒，如果纸没到位或者前面检测电眼没照到纸板上，时间到后将停机,不用此功能时请设为600。点击“菜单”）“参数设置”）“卡纸停机”
- 18、相关参调好后，将一张纸板放入模具下的托纸板架上，以调整来料电眼检测的灵敏度，电眼没检测到纸时亮绿灯，检测到纸时亮红灯，如纸板反光效果比较差时将电眼与纸板距离调近或调整电眼的灵敏度电位器。（说明书最后有图片说明）
- 19、打开加热开关进行贴头预热5-10分钟（注：调模时，如果是塑胶模具请勿加温，以免烫伤模具）点击“菜单”）“手动画面”）“加热开关”；

1、在设置参数设置之前，需要测量纸板成形后的深度及模具高度，测量好后，按以下步骤修改默认参数：点击“手动画面”）“纸盒深度” / “模具高度”

1. Before setting the parameter settings, you need to measure the depth of the cardboard after forming and the height of the mold. After the measurement is completed, modify the default parameters according to the following steps: Click "Manual Screen"> "Carton Depth" / "Mold Height"

2. 贴角时间: 胶带贴盒时间设定: 点击“手动画面”>“贴角时间”

2. Corner sticking time: tape sticking time setting: click "Manual Screen"> "Corner Sticking Time"

3、胶纸长度: 根据纸盒深度的需要设置贴角胶带的长度; 点击“手动画面”>“胶纸长度”

3. Adhesive tape length: Set the length of the corner tape according to the needs of the carton depth; click "Manual Screen"> "Adhesive Tape Length"

4、二次间距: 当盒子贴角需贴 2 次是(即模式 2)时, 需设定 2 次贴角胶带的距离点击“菜单>”参数设置”>“二次间距”

4. Secondary spacing: When the corner of the box needs to be pasted twice (that is, mode 2), you need to set the distance of the corner tape for the second time. Click "Menu>"Parameter Settings"> "Secondary Spacing"

5、模具运行速度: 上升下降的速是由模具的大小来决定, 当模具尺寸比较小速度可适当加快, 模具比较大时, 由于大的模具相对重, 此时适当降低模具的上升/下降速度:

点击“手动画面”)“上升速度”/“下降速度”

5. Mould running speed: The speed of rising and falling is determined by the size of the mold. When the size of the mold is relatively small, the speed can be appropriately increased. When the mold is relatively large, because the larger mold is relatively heavy, the rising/falling speed of the mold should be appropriately reduced at this time : Click "Manual screen") "Ascent speed"/"Descent speed"

6、贴角高度:贴好纸盒后看胶纸与纸盒上口高低,来调整正负误差 mm。点击“菜单”>“参数设置”>“贴角高度”

6. The height of the sticking angle: After sticking the paper box, look at the height of the tape and the top of the carton to adjust the plus or minus error mm. Click "Menu"> "Parameter Settings"> "Corner Height"

7、预备高度:开启自动模式运行时模具位置上升到平台以上的高度。点击“菜单”>参数设置>“预备高度”

7. Preliminary height: the mold position rises to the height above the platform when the automatic mode is turned on. Click "Menu">Parameter Settings>"Preparation Height"

8、加减速度:模具主轴上下运动起步/停止时间,此参数根据模具体积重量而定(出厂时已设定),此参数时间如设置过小,可能会造成模具主轴失步,影响设备稳定性;

点击“菜单”>“参数设置”>“加减速 度”

8. Acceleration and deceleration: the start/stop time of the mold spindle up and down. This parameter is determined by the volume and weight of the mold (set at the factory). If the parameter time is set too small, it may cause the mold spindle to lose step and affect the stability of the equipment. Performance; click "menu"> "parameter settings"> "acceleration and deceleration"

9、胶纸速度:分别是4个贴角送胶带送带速度点击“菜单”>“参数设置”>“胶纸速度”

9. Adhesive tape speed: 4 sticking angles, tape feeding speed, click "Menu"> "Parameter Settings"> "Adhesive Tape Speed"

10、胶纸延时:送胶带的时间设定,注意:此时间设定要大于贴角时间,也不能超过0.5秒。点击“菜单”参数设置”>“胶纸延时”

10. Adhesive tape delay: Time setting for tape delivery. Note: This time setting should be greater than the corner sticking time, and it should not exceed 0.5 seconds. Click "Menu" Parameter Settings"> "Adhesive Tape Delay"

11、满料时间:纸板送料输送带电眼开启时有效。(开启自动启停功能时有效)点击“菜单”>参数设置”>“满料时间”

11. Full material time: it is effective when the cardboard feeding conveyor is turned on with the

electric eye. (Valid when the automatic start-stop function is turned on) Click "Menu"> Parameter Settings> "Full Material Time"

12、延时启动:纸板送料输送带电眼没检测到纸板时,输送带延时启动。(开启自动启停功能时有效)点击“菜单”>“参数设置”>“延时启动”

12. Delayed start: When the cardboard feeding conveyor belt electric eye does not detect the cardboard, the conveyor belt will start delayed. (Valid when the automatic start-stop function is turned on) Click "Menu"> "Parameter Setting"> "Delayed Start"

13、脱模间距:当贴角完成时,主轴模具向下推盒到靠角倒钩位置脱模。点击“菜单”>“参数设置”>“脱模间距”(出厂已设置)

13. Demoulding distance: When the corner bonding is completed, the spindle mold pushes the box down to the corner barb position for demolding. Click "Menu"> "Parameter Settings"> "Strip Distance" (default setting)

14、无料停机时间:当来料电眼长时间没检测到有纸板时,设备将在设定时间内停机。点击“菜单”>“参数设置”>“无料延时停机”

14. No material shutdown time: When the incoming sensor does not detect any cardboard for a long time, the equipment will shut down within the set time. Click "Menu"> Parameter Settings> "No Material

Delayed Stop”

15、送料延时停止:纸板输送带送料的时间,此功能需关掉出料检测电眼才有效。点击“菜单”>“参数设置”>“送料延时停止”

15. Feeding delay stop: the feeding time of the cardboard conveyor belt, this function needs to turn off the discharge detection electric eye to be effective. Click "Menu"> "Parameter Setting"> "Feeding Delay Stop"

16、加热时间:根据气候季节、环境温度、贴角效果适当调节加温时间长短。正常设为 8-10 秒。(旧版画面为辅助加热开)点击“菜单”>“参数设置”>“加热时间”

16. Heating time: Adjust the length of the heating time appropriately according to the climate season, ambient temperature, and the effect of the corner. Normally set to 8-10 seconds. (The old version of the screen is auxiliary heating on) Click "Menu"> "Parameter Settings"> "Heating Time"

17、卡纸停机:纸板从出料辊筒出来后到达前面挡纸位的时间,出厂已设好 50 毫秒,如果纸没到位或者前面检测电眼没照到纸板上,时间到后将停机,不用此功能时请设为 600。点击“菜单”>“参数设置”>“卡纸停机”

17. Shutdown for paper jam: the time for the cardboard to reach the front paper stop position after it comes out of the discharging roller, the factory has been set for 50 milliseconds. If the paper is not in place or the front detection sensor

does not shine on the cardboard, it will stop after the time is up. Please set to 600 for this function. Click "Menu"> "Parameter Settings"> "Paper Jam Stop"

18、相关参数调好后,将一张纸板放入模具下的托纸板架上,以调整来料电眼检测的灵敏度,电眼没检测到纸时亮绿灯,检测到纸时亮红灯,如纸板反光效果比较差时将电眼与纸板距离调近或调整电眼的灵敏度电位器。(说明书最后有图片说明)

18. After the relevant parameters are adjusted, put a piece of cardboard on the cardboard holder under the mold to adjust the sensitivity of the incoming sensor. The sensor will turn on a green light when it does not detect paper, and a red light when it detects paper, such as cardboard. When the reflection effect is poor, adjust the distance between the electric eye and the cardboard or adjust the sensitivity potentiometer of the electric eye. (There is a picture at the end of the manual)

19. 参数设置及装置调整好,打开加热开关进行贴头预热5-10分钟(注:调模时,如果是塑胶模具请勿加温,以免烫伤模具)点击“菜单”>“手动画面”>“加热开关”

After setting the parameters and adjusting the device, turn on the heating switch and preheat the head for 5-10 minutes (Note: When adjusting the mold, if it is a plastic mold, please do not heat the mold

to avoid scalding the mold) Click "Menu"> "Manual Screen"> " Heating on/off"

六、运行测试



(图21)

- 1、点动送料：在进料输入带放上灰纸板，放好后点动送料，测试送料是否顺畅；点击“菜单”>“手动画面”>“带料开”>“点动送料”
- 2、点动胶纸：贴角胶带出料测试，手动测试胶带是否顺畅；点击“菜单”>“手动画面”>“点动胶纸”
- 3、单步运行：点击“菜单”>“手动画面”>“单步运行”，模具下降到托纸架上方预备高度，再点击“单步运行”按钮，模具将纸板推到贴角位置，再点击“点动胶纸”按钮，再点动“点动贴角”，完成贴角后，再点击“单步运行”，模具停在脱料位置，点击“单步运行”模具回到原点位（调好后确认模具不会撞到4个贴头）。
- 4、确认纸盒贴角是否OK，再根据测试结果进行位置及运行参数的调整，如果纸盒测试OK可点击“单步循环”进行边缘测试。
- 5、如果在测试打出的纸盒贴角没打紧，检查模具是否偏小，如果偏小在模具贴角面贴上胶纸以增加模具宽度及长度，如果模具偏大需拆下进行加工改小。
- 6、主轴模具单步运行到贴角位置时，目测查贴角机构上的8个靠角是否挨贴着纸盒四周，如果没有贴着纸盒，而进行靠角进行调整（图18）。调试OK后，设备进行连续送料运行，速度由慢至快进行生产。如下图，调节送料速度。



(图22)

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六、运行测试 Six, run the test

下一页 Next page

返回 return

手动画面 Manual screen

贴角时间 Sticking time

纸盒深度 Carton depth

胶纸长度 Tape length

模具高度 Mold height

慢升 Slow rise

慢降 Slow down

贴头关 Tie Tou Guan

点动送料 Jog feeding

单次循环 Single cycle

脱盒开 Unboxing

带料关 With material off

点动胶纸 Inching tape

复位 Reset

参数清零 Parameter clear

加热关 Heating off

点动贴角 Click to move the corner

单步运行 Single step

异常清除 Exception clear

1、点动送料:在进料输入带放上灰纸板,放好后点动送料,测试送料是否顺畅;点击“菜单“〉手动画面”〉“带料开”〉点动送料’

1. Jog feeding: put a gray cardboard on the feeding input tape, and then jog the feeding after placing

it, to test whether the feeding is smooth; click "Menu"> Manual Screen> "Tip On"> Jog Feeding'

2、点动胶纸:贴角胶带出料测试,手动测试胶带是否顺畅;点击“菜单”>“手动画面”>“点动胶纸”

2. Jogging tape: tapping tape discharge test, manually test whether the tape is smooth; click "menu"> "manual screen"> "clicking tape"

3、单步运行:点击“菜单”)“手动画面”)“单步运行”,模具下降到在托纸架上方预备高度,再点击“单步运行”按钮,模具将纸板推到贴角位置,再点击“点动胶纸”按钮,再点动“点动贴角”,完成贴角后,再点击“单步运行”,模具停在脱料位置,点击“单步运行”模具回到原点位(调好后确认模具不会撞到4个贴头)。

3. Single-step operation: click "menu") "manual screen") "single-step operation", the mold will drop to the preparatory height above the paper support, and then click the "single-step operation" button, the mold will push the cardboard to the corner position, And then click the "increase tape" button, and then click the "increase the corner", after finishing the corner, click "single step operation", the mold stops at the stripping position, click "single step operation" to return to the mold Origin position (make sure that the mold will not hit the 4 heads after adjustment).

4、确认纸盒贴角是否 OK,再根据测试结果进行位置及运行参数的调整,如果纸盒测试 OK 可点击“单步循环”

进行边续测试。

4. Confirm whether the carton sticking angle is OK, and then adjust the position and operating parameters according to the test results. If the carton test is OK, you can click "Single Step Cycle" to continue the test.

5、如果在测试打出的纸盒贴角没打紧，检查模具是否偏小，如果偏小在模具贴角面贴上胶纸以增加模具宽度及长度，如果模具偏大需拆下进行加工改小。

5. If the corners of the carton printed in the test are not tight, check whether the mold is too small. If it is too small, stick adhesive paper on the corners of the mold to increase the width and length of the mold. If the mold is too large, it needs to be removed for processing to change the size. .

6、主轴模具单步运行到贴角位置时，目测查贴角机构上的8个靠角是否挨贴着纸盒四周，如果没有贴着纸盒，而进行靠角进行调整(图 18)，调试 OK 后，设备进行连续送料运行，速度由慢至快进行生产。如下图，调节送纸速度。

6. When the spindle mold runs to the corner position in a single step, visually check whether the 8 corners on the corner sticking mechanism are close to the carton. If there is no sticking to the carton, adjust the corners (Figure 18). After the commissioning is OK, the equipment will carry out continuous feeding operation, and the speed will be

changed from slow to fast for production. As shown in the figure below, adjust the paper feeding speed.
速度 speed

手动画面下一页功能键如下



(图23)

- 1、自动启停开/关：当机器配自动定位机时才用此功能。
- 2、送料开/关：当调节送料皮带时打开此开关，调好后关闭此功能。
- 3、胶纸退开/关：打开此功能时胶纸会自动进退，以减少堵胶纸。
- 4、出料检测开/关：当出纸检测开关检测不灵敏时请关闭。
- 5、计数停机开/关：在主画面设置（设定数量）后打开此功能时，当生产数量达到设定数量后会自动停机。

手动画面下一页功能键如下 Manual screen next page
function keys are as follows

指示灯 Indicator light

手动画面 Manual screen

下一页 Next page

返回 return

前进 go ahead

左进 Left in

右进 Go right

左右进 Go left and right

后退 Back

左退 Back left

右退 Back right

左右退 Retreat left and right

送料进 Feeding

送料退 Feeding and returning

胶纸进 Tape in

胶纸退 Tape back

自动启停关 Automatic start and stop

送料关 Feed off

慢升 Slow rise

慢降 Slow down

胶纸退关 Tape off

出料检测开 Discharge detection on

计数停机关 Counting stop

1、自动启停开/关:当机器配自动定位机时才用此功能。

1. Automatic start and stop on/off: this function is only used when the machine is equipped with an automatic positioning machine.

2、送料开/关:当调节送料皮带时打开此开关,调好后关闭此功能。

2. Feeding on/off: turn on this switch when adjusting the feeding belt, and turn off this function after adjustment.

3、胶纸退开/关:打开此功能时胶纸会自动进退,以减少堵胶纸。

3. Adhesive tape retreat on/off: When this function is turned on, the adhesive tape will automatically advance and retreat to reduce the jamming of the tape.

4、出料检测开/关:当出纸检测开关检测不灵敏时请关闭。

4. Discharge detection on/off: When the discharge detection switch is not sensitive, please turn it off.

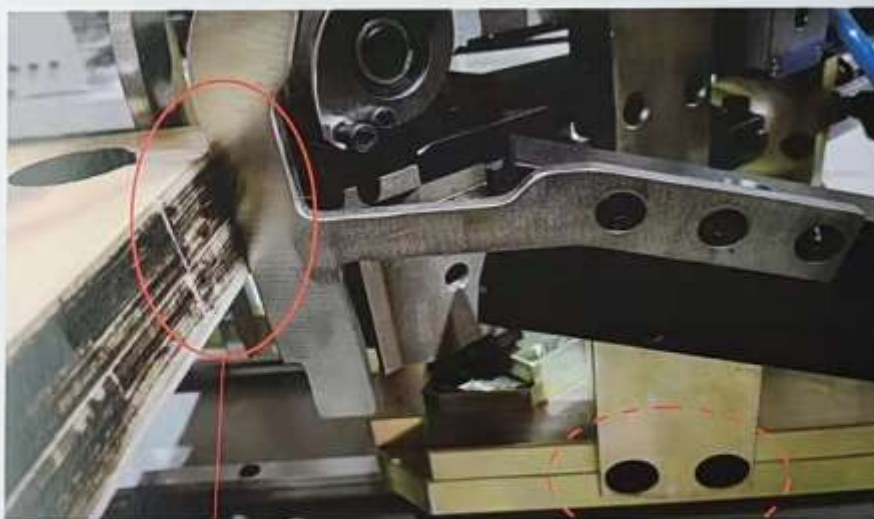
5、计数停机开/关:在主画面设置(设定数量)后打开此功能时,当生产数量达到设定数量后会自动停机。

5. Counting stop on/off: When this function is turned on after setting (set quantity) on the main screen, it will automatically stop when the production quantity reaches the set quantity.



靠角调紧螺丝

(图23)



(图24)

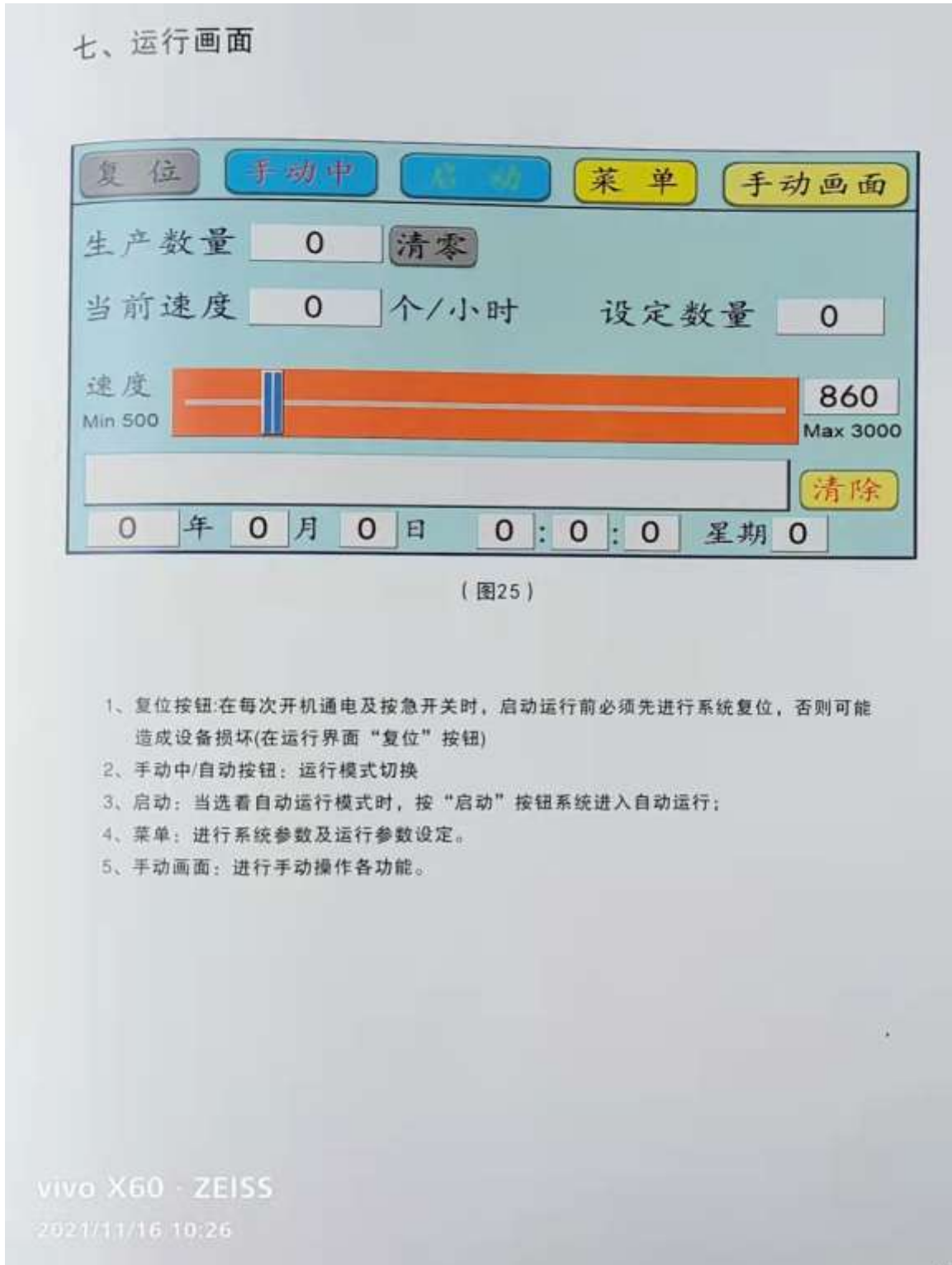
如上图所示，当靠脚更换过，重新装上时靠脚要和模具靠平垂直

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17 注：设备结构、功能、技术参数更新不另行通知

靠角调紧螺丝 Tighten the screws by corner
如上图所示，当靠脚更换过，重新装上时靠脚要和模具靠平垂直

As shown in the figure above, when the backrest has been replaced, the backrest should be horizontal and vertical to the mold when reinstalled



七、运行画面 Run screen

复位 Reset

手动中 Manually

启动 start up

菜单 Lebanon

手动画面 Manual screen

生产数量 Production quantity

清零 Cleared

当前速度 Current speed

个/小时 Hours

设定数量 Set quantity

速度 speed

清除 Clear

年 year

月 moon

日 day

星期 Week

1、 复位按钮:在每次开机通电及按急开关时,启动运行前必须先进行系统复位,否则可能造成设备损坏(在运行界面“复位”按钮)

1. Reset button: every time the power is turned on and the emergency switch is pressed, the system must be reset before starting operation, otherwise it may cause damage to the equipment (“reset” button on the running interface)

2、 手动中/自动按钮:运行模式切换

2. Manual middle/auto button: switch operation mode

3、 启动:当选着自动运行模式时,按“启动”按钮系统进入自动运行;

3. Start: When the automatic operation mode is selected, press the "Start" button to enter the automatic operation;

4、 菜单:进行系统参数及运行参数设定。

4. Menu: Set system parameters and operating parameters.

5、 手动画面:进行手动操作各功能。

5. Manual screen: perform manual operation of various functions.



(图26)

特点:

- 1、装模具快，旧模具换模只需5-10分钟，新模具调试只需10-30分钟，无论量大量少全部适用。
- 2、速度快，最高贴盒时速达到 6000个/小时。每分钟100个左右。不停机加纸，适合连续高速工作。（具体纸盒大小，模具大小有关）
- 3、操作方便，无需熟练工，让普通员工简单培训即可就可以操作机器。更换产品时只需在触摸屏调整挡板宽度及输入产品长宽高即可，稍作微调即可完成装模。
- 4、省人力，按人工8小时贴盒6000计算，自动贴角机8小时能贴盒3.2万个，约等于5人的效率，只需1人开机，节省4人
- 5、优势，效率、功能、可操作性、实用性远高于现市面上的传统全自动贴角机，与单头贴角机相比优势更加突出。

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13 课：设备结构、功能、技术规格等知识

托纸板轴 Supporting paper shaft
 可调压纸刀 Adjustable paper knife
 后挡纸板 Backboard

模具驱动 Mould drive

人机界面 HMI

前纸板托架 Front cardboard bracket

前挡纸板 Front stopper

纸盒输送带 Carton conveyor belt

贴头组件 Header assembly

特点: Features:

1、装模具快，旧模具换模只需 5-10 分钟，新模具调试只需 10- -30 分钟，无论量大量少全部适用。

1. It is fast to install the mold, it only takes 5-10 minutes to change the old mold, and 10--30 minutes to debug the new mold. It is applicable regardless of the amount of large or small.

2、速度快，最高贴盒时速达到 6000 个/小时。每分钟 100 个左右。不停机加纸，适合连续高速工作。（具体纸盒大小，模具大小有关）

2. The speed is fast, and the maximum sticking speed is 6000 pcs/hour. About 100 per minute. Non-stop paper feeding, suitable for continuous high-speed work. (The specific carton size is related to the mold size)

3、操作方便，无需熟练工，让普通员工简单培训即可就可以操作机器。更换产品时只需在触摸屏调整挡板宽度及输入产品长宽高即可，稍作微调即可完成装模。

3. Convenient operation, no skilled workers are required, and ordinary employees can operate the

machine with simple training. When replacing the product, you only need to adjust the width of the baffle on the touch screen and enter the product length, width and height, and you can complete the mold installation with a slight adjustment.

4、省人力，按人工 8 小时贴盒 6000 计算，自动贴角机 8 小时能贴盒 3.2 万个，约等于 5 人的效率，只需 1 人开机，节省 4 人

4. Save manpower. Calculated as 6000 boxes in 8 hours of labor, the automatic corner sticking machine can stick 32,000 boxes in 8 hours, which is equivalent to the efficiency of 5 people. Only 1 person is required to start the machine and save 4 people.

5、优势，效率、功能、可操作性、实用性远高于现市面上的传统全自动贴角机，与单头贴角机相比优势更加突出。

5. Advantages, efficiency, function, operability, and practicability are much higher than the traditional automatic corner sticking machine on the market, and the advantages are more prominent compared with the single-head corner sticking machine.

八、气源气动部件日常保养事项

8.1 油水分离器（气源三联件，如图23）。减压阀可对气源进行稳压，使气源处于恒定状态，可减小因气压突变时对阀门或执行器等硬件的损伤。过滤器用于对气源的清洁，可过滤压缩空气中的水份，避免水份随气体进入装置。

油雾器可对机体运动部件进行润滑，可以对不方便加润滑油的部件进行润滑，大大延长机体的使用寿命。

8.2. 油水分离器的日常保养，根据设备的使用情况定期给油水分离放水及添加油雾器专用油，如果气源水气比较严重建议每天给气罐和油水分离器排水，如图所示

(图27)



(图28)



此处为加油孔，扭开此黑色螺帽，
加好油后再扭紧。
加油时请拔掉气管接头！

(图29)

八、气源气动部件日常保养事项

8.1 油水分离器(气源三联件,如图 23),减压阀可对气源进行稳压,使气源处于恒定状态,可减小因气通气压突变时对阀门或执行器等硬件的损伤。过滤器用于对气源的清洁,可过滤压缩空气中的水份,避免水份随气体进入装置。

油雾器可对机体运动部件进行润滑,可以对不方便加润滑油的部件进行润滑,大大延长机体的使用寿命。

8.2、油水分离器的日常保养,根据设备的使用情况定期给油水分离放水及添加油雾器专用油,如果气源水气比较严重建议每天给气罐和油水分离器排水,如图所示

Daily maintenance of air source pneumatic components

8.1 Oil-water separator (three-piece air source, as shown in Figure 23), the pressure reducing valve can stabilize the air source, keep the air source in a constant state, and reduce the impact on hardware such as valves or actuators due to sudden changes in air pressure. damage. The filter is used to clean the air source. It can filter the water in the compressed air and prevent the water from entering the device with the gas.

The lubricator can lubricate the moving parts of the body, and can lubricate the parts that are inconvenient to add lubricating oil, which greatly extends the service life of the body.

8.2. Daily maintenance of the oil-water separator, according to the use of the equipment, regularly separate and drain the oil and water and add special oil for the lubricator. If the gas source
If the moisture is serious, it is recommended to drain the gas tank and the oil-water separator every day, as shown in the figure

泄压阀 Pressure relief valve

进气 Intake

出气 Vent

油水过虑杯 Oil-water filter cup

排水阀 Drain valve

加油杯 Refueling cup

排水阀 Drain valve

此处为加油孔，扭开此黑色螺帽，加好油后再扭紧。

加油时请拔掉气管接头！

This is the oil filling hole. Unscrew the black nut and tighten it after filling in the oil.

Please unplug the gas pipe joint when refueling!

九、出纸光电开关的调节方法

9.1 出纸光电开关和前面纸张到位光电开关的调节方式，有纸时光电开关会亮桔红色，没纸时亮绿色灯。如有纸光电开关照到纸上桔红色灯没亮，请用螺丝刀顺时针旋转到灯亮后再多调一点就好。出纸光电开关红点不能照到滚筒上，要往红色皮带方向调一点。



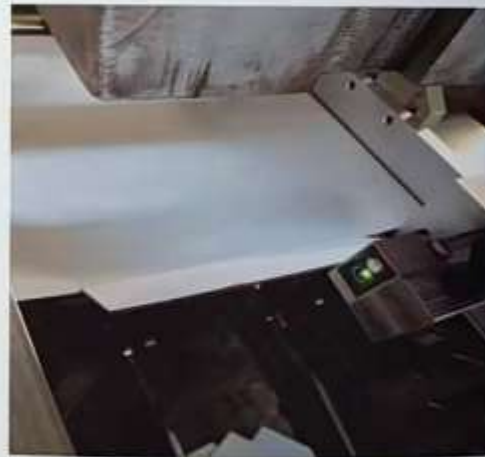
顺时针调加大检测距离
逆时针调减小检测距离



顺时针调加大检测距离
逆时针调减小检测距离



viva X60 有纸状态



没纸状态

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九、出纸光电开关的调节方法

9.1 出纸光电开关和前面纸张到位光电开关的调节方式，有纸时光电开关会亮桔红色，没纸时亮绿色灯。如

有纸光电开关照到纸上桔红色灯没亮，请用螺丝刀顺时针旋转灯亮后再多调一点就好。出纸光电开关红点不能照到滚筒上，要往红色皮带方向调一点。

Nine, the adjustment method of the paper output photoelectric switch

9.1 The adjustment method of the paper output photoelectric switch and the photoelectric switch of the front paper. The photoelectric switch will light orange when there is paper, and it will light green when there is no paper. If the paper photoelectric switch shines on the paper, the orange light does not turn on, please turn it clockwise with a screwdriver until the light turns on and then adjust it a little more. The red dot of the photoelectric switch of the paper output cannot be irradiated on the roller, so adjust it to the direction of the red belt.

顺时针调加大检测距离逆时针调减小检测距离

Turn clockwise to increase the detection distance and counterclockwise to decrease the detection distance

顺时针调加大检测距离逆时针调减小检测距离

Turn clockwise to increase the detection distance and counterclockwise to decrease the detection distance

有纸状态 Paper state

没纸状态 Out of paper state

十、保险丝的更换方式及四组贴头发热片对应保险和编号



更换保险丝时请关闭电源及拔掉电源插头，切记！



总电源保险亮红灯时代表保险丝已烧，请更换250V10A的保险

发热片保险，亮红灯时代表保险丝已烧，请更换那个灯亮就代表那组贴头发热片有短路，请检查那组线路及更换。



用螺丝刀撬开保险丝座上的盖子，取出烧坏的保险丝，更换新的250V4A的保险

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十、保险丝的更换方式及四组贴头发热片对应保险和编号

10. How to replace the fuse and the corresponding

insurance and serial number of the four groups of hair-attached hot plates

更换保险丝时请关闭电源及拔掉电源插头，切记！

When replacing the fuse, please turn off the power and unplug the power plug, remember!

总电源保险亮红灯时代表保险丝已烧，请更换 250V10A 的保险

When the main power fuse lights up in red, it means that the fuse has been burned. Please replace the 250V10A fuse

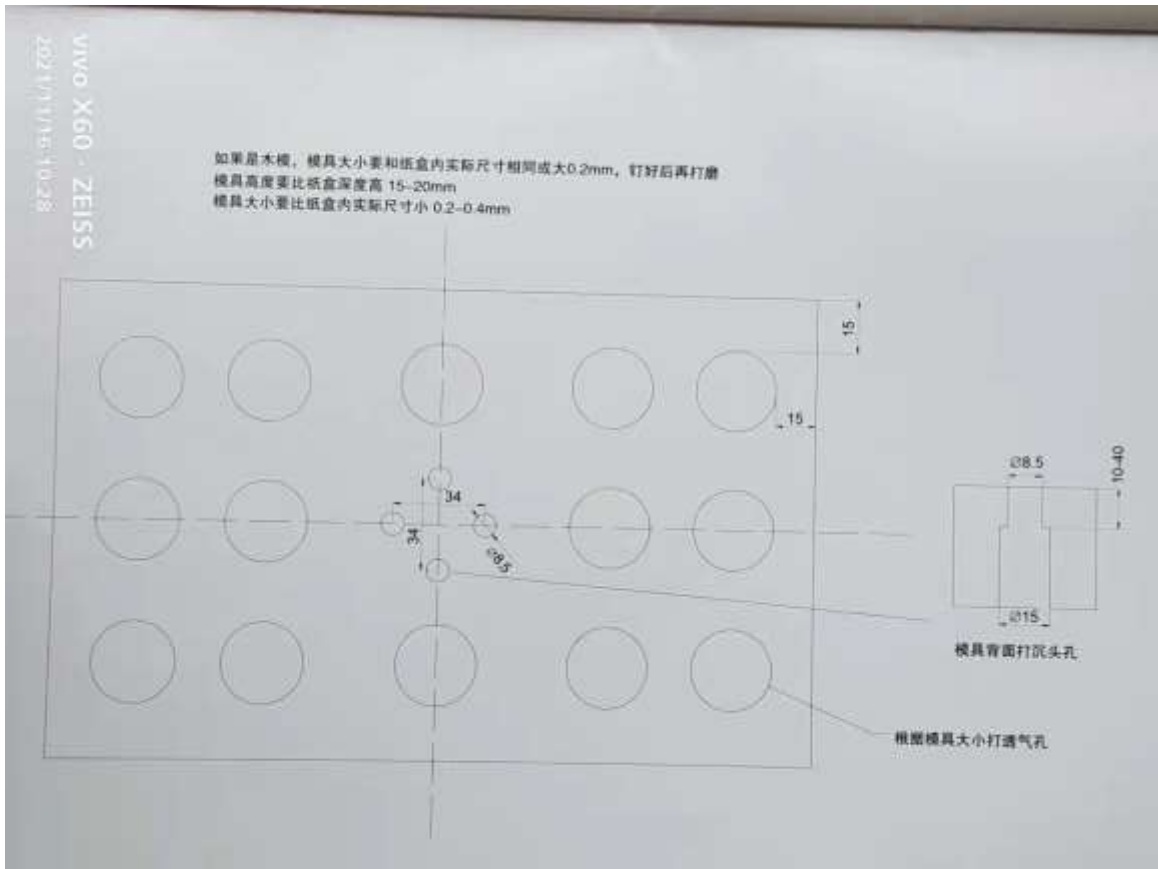
发热片保险，亮红灯时代表保险丝已烧，请更换那个灯亮就代表那组贴头发热片有短路，请检查那组线路及更换。

The heating element is insured. When the red light is on, it means that the fuse is burned. If the light is on, it means that there is a short circuit in the set of hot plates. Please check the set of wiring and replace it.

用螺丝刀撬开保险丝座上的盖子，取出烧坏的保险丝，更换

新的 250V4A 的保险

Use a screwdriver to pry open the cover on the fuse holder, take out the burned fuse, and replace it
New 250V4A insurance



If it is a wooden mold, the size of the mold should be the same as or 0.2mm larger than the actual size in the carton. After nailing, the height of the mold should be 15-20mm higher than the depth of the carton.

The mold size is 0.2-0.4mm smaller than the actual size in the carton

模具背面打沉头孔 Countersunk holes on the back of the mold

根据模具大小打透气孔 Punch vent holes according to the size of the mold