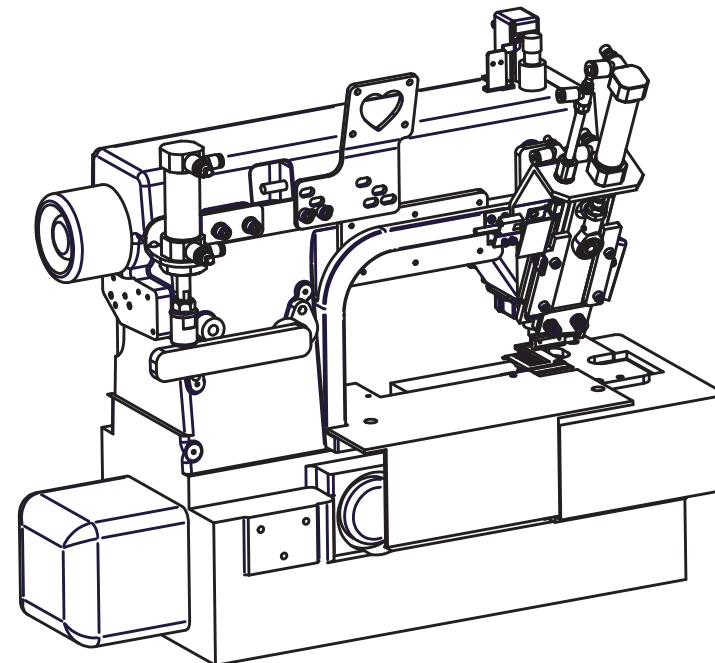


VF2500系列 自动切带装置

Series
安装说明书&零件手册
Installation Manual
Parts List



注意 Caution

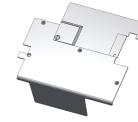
- 依照说明书之内容，可以在较短时间内安装完成；
Follow the installation manual can help you finish the installation in a short time;
- 安装前，确认电控箱输入电源为AC220V。
Before installation, assure the electric control box input voltage is AC220V.

警告 Warning

安装时务必将缝纫机电源开关切断，并由专门技术人员操作。
Shut down the power breaker before installation and only the technician people can operate.

自动切带装置的组成:

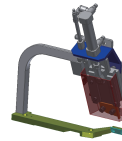
The components of the automatic trimmer device:



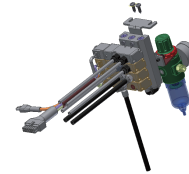
盖板



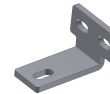
吹气组



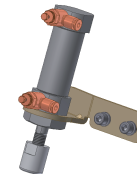
切带刀组



气源处理器组



上光眼支架



抬压脚组



针板座



注意
Caution

根据不同需求, 包装箱内的组件配置见外包装箱装箱标记。
Please check the outside package box marks. The ticks represent the devices you buy.

一、切刀刀组的安装:

Installation of the thread releaser:

1. 将原机针板座拆下, 换成我司专配针板座。(如图01)

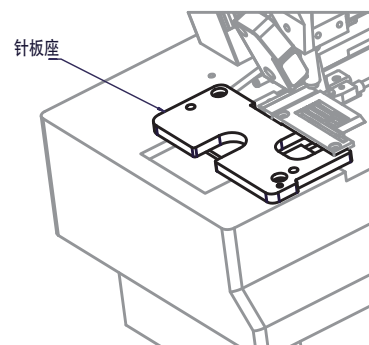


图01

2. 先用件①将刀组锁至机壳, 再用件②、件③固定底座。(如图02)

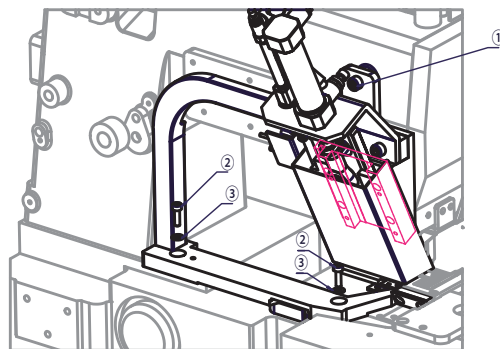


图02

3. 锁紧刀组后调整件①螺钉, 保证件②与件③切合时, 过盈约为0.2mm, 锁紧件④。(如图03)

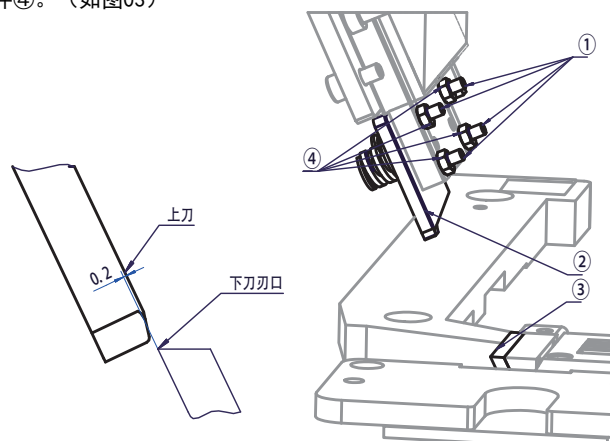


图03

二、光眼与手动开关的安装:

1. 将手动开关支架安装到机器上, 调整左右位置, 防止护罩落下时撞到支架。
2. 用螺钉将电控中手动开关装到支架上。(如图04)

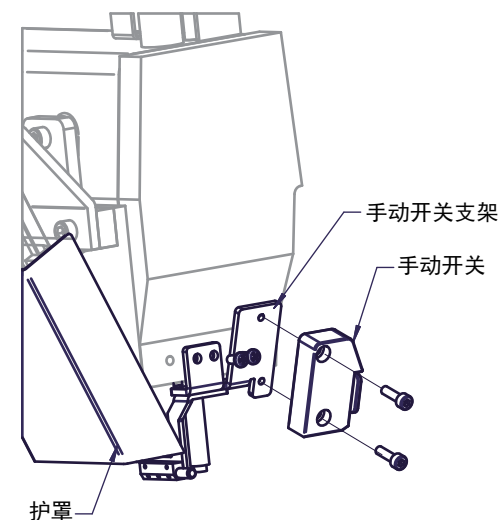


图04

3. 用螺钉将下光眼装到支架上, 再将支架装配到盖板上。

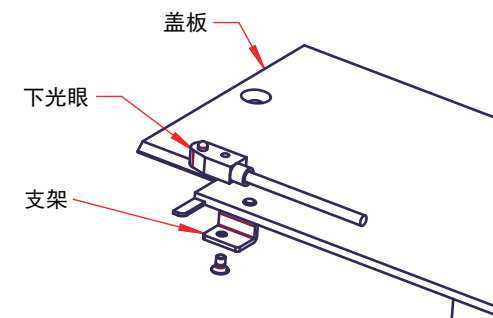


图05

4. 将电控中上光眼安装到支架上，用螺钉将支架固定到机器。调节上光眼位置，使之与下光眼对齐。

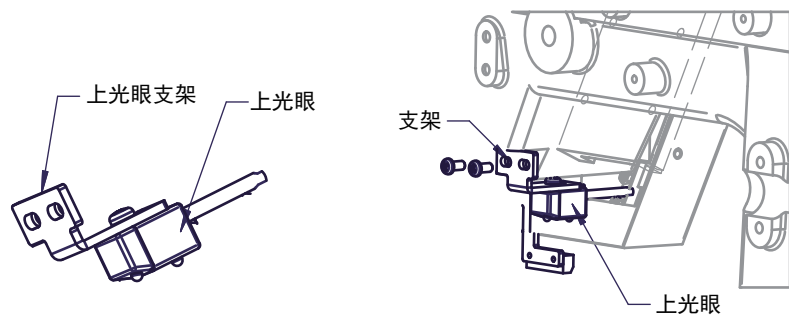


图07

三、抬压脚的安装：

先将抬压脚组与连板安装至机壳，再用螺钉将面板支架锁至连杆。

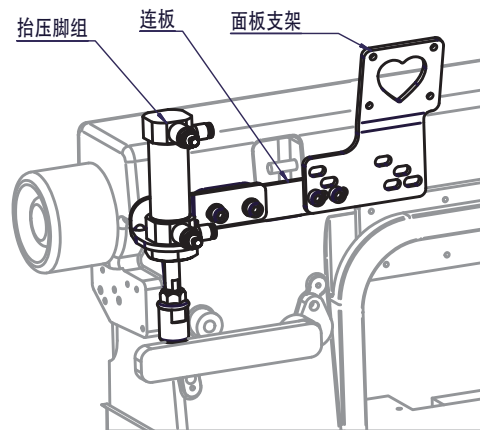


图08

四、气源处理组的安装与连接：

1. 将电磁阀用自攻螺钉安装到台板上。
2. 用气管按图示进行连接。

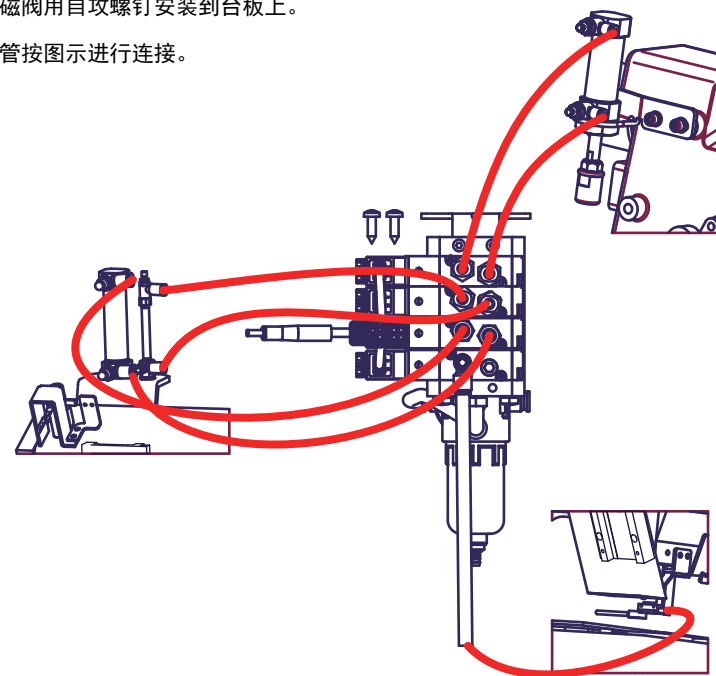


图09

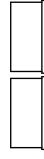
五、缝制工艺参数调整：

Stitch parameter adjustment.

注意：短按“P”键可调出P区参数；长按“剪线”键或“停针”键可调出S区参数。

按“L”“R”键在参数号和参数值之间切换，按“+”“-”键更改参数号或参数值，按“OK”键确认。

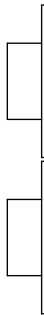
Remark: light pressing "P" key can show the parameter of "P" area; Heavy pressing "thread trimmer" key or "stop needle" key can show the parameter of "S" area. Press "L" or "R" can change between parameter number and parameter value. Press "+" or "-" can change parameter number or parameter value. After that, save it with pressing "OK" key.



参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P03	剪线 Thread trimmer	3 (前后剪) front and back thread trimmer
P05	强制剪线 Compulsory thread trimmer	3 (前后剪) front and back thread trimmer
S03	前剪线延迟针数 Front thread trimmer delay needle number	3
S04	后剪线延迟针数 Back thread trimmer delay needle number	12
S12	停车延迟针数 Stop sewing delay needle number	15

参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P03	剪线 Thread trimmer	1 (前剪) Front thread trimmer
S03	前剪线延迟针数 Front thread trimmer delay needle number	3
S12	停车延迟针数 Stop sewing delay needle number	15

参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P03	剪线 Thread trimmer	1 (前剪) Front thread trimmer
S03	前剪线延迟针数 Front thread trimmer delay needle number	3
S12	停车延迟针数 Stop sewing delay needle number	按需 As requirement



参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P03	剪线 Thread trimmer	2 (后剪) back thread trimmer
S04	后剪线延迟针数 Back thread trimmer delay needle number	12
S12	停车延迟针数 Stop sewing delay needle number	按需 As requirement

参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P03	剪线 Thread trimmer	2 (后剪) back thread trimmer
S04	后剪线延迟针数 Back thread trimmer delay needle number	按需 As requirement
S12	停车延迟针数 Stop sewing delay needle number	按需 As requirement

参数表 PARAMETER LIST		
参数号 Parameter number	参数名称 Parameter name	参数值 Parameter value
P02	电眼开关 Light sensor switch	0 (关) (全手工模式) (close) (all hand operation model)
P03	剪线 Thread trimmer	4 (定长切布) (cut cloth as fixed length)
S09	定长切针数 Needle number of fixed length cutting	按需 As requirement

六、常见问题及解决方法:

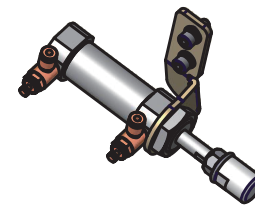
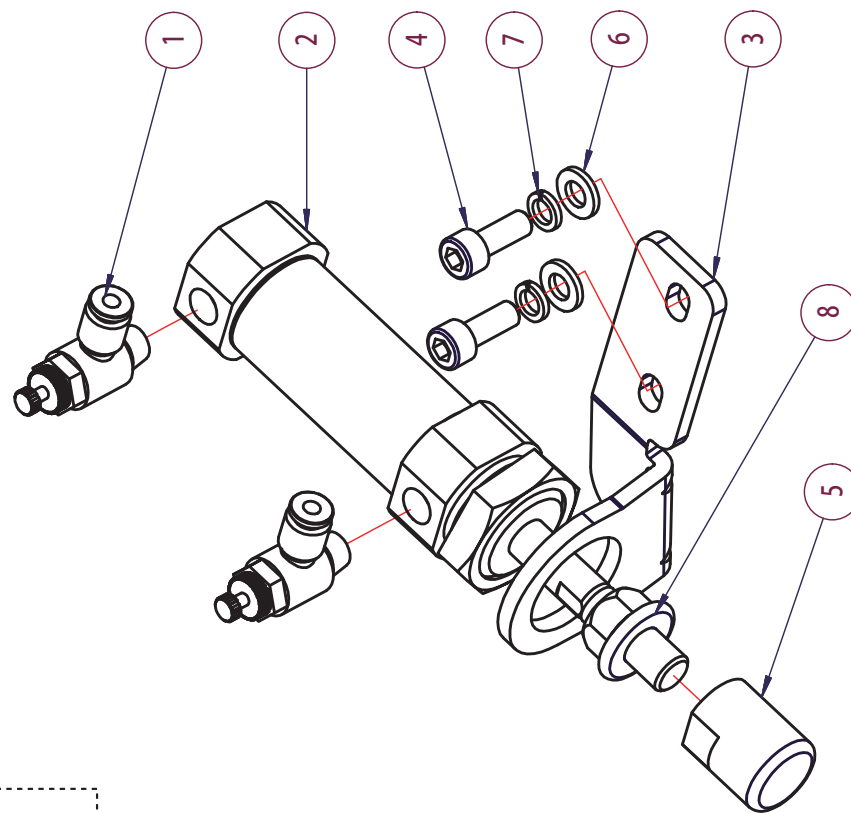
Common problems and solution

序号 Description	问题描述 Description	原因分析 Analyze	解决方法 Solution
1	切刀不动作 cutter no action	光眼灵敏度过低 sensor sensitive too low	长按感应键，一般布料将光眼灵敏度（百分号下面的对应值）调到65-70之间，较薄布料调到55-60之间。 Long press induction button, set the sensitive value to 65-70 if general cloth, thinner cloth set to 55-60.
		后剪线或前后剪线模式下前 停开启打开且强制剪线关闭 Back or front thread trimmer mode, front stop ON and compulsory thread trimmer OFF	按P键，将P25前停开启改为0（关闭）或将P5强制剪线打开 Press "P" button, change "P25" value to 0(OFF) or change "P5" compulsory thread trimmer ON.
		使用双光眼模式	请长按模式键，将光眼数量改为1（单光眼模式）。 If the parts which cover the sensor is necessary parts, long press "Mode" button, change the Sensor quantity to "1"(Single sensor mode).
2	切刀乱动作 Cutter disorderly action	开启了剪线光眼 Trimming sensor ON	关闭剪线光眼 Turn off the trimming sensor
		气缸气路或电磁铁电路不通 Cylinder or electromagnet magnet impassable	检查气缸气路或电磁铁电路 Check the cylinder and electromagnet magnet
		光眼灵敏度过高 Sensor sensitive too high	长按感应键，一般布料将光眼灵敏度（百分号下面的对应值）调到65-70之间，较薄布料调到55-60之间。 Long press induction button, general cloth set the value to 65-70, thinner cloth set the value to 55-60
3	前剪线剪到布 Front thread trimmer cut the cloth	前剪线延迟针数过大 Front thread trimmer delayed stitches too many	长按剪线键，将S03前剪线延迟针数调小 reduce the delayed stitches of front thread trimmer S03
4	前剪线留的 滚条过长 The tape too long after cut by front trimmer	前剪线延迟针数过小 Front thread trimmer delayed stitches too less	长按剪线键，将S03前剪线延迟针数调大 enhance the delayed stitches of front thread trimmer S03.
5	后剪线剪到布 Back thread trimmer cut the cloth	后剪线延迟针数过小 Back thread trimmer delayed stitches too less	长按剪线键，将S04后剪线延迟针数调大 long press Trimming button enhance the delayed stitches of back thread trimmer S04.
6	后剪线留的 滚条过长 The tape too long after cut by back trimmer	后剪线延迟针数过大 Back thread trimmer delayed stitches too many	长按剪线键，将S04后剪线延迟针数调小 Long press Trimming button, reduce the delayed stitches of back thread trimmer S04.
7	安全开关断开 Safety switch disconnect	安全开关未感应到 Safety switch doesn't interaction	将安全开关参数值调为0 setting the safety switch value to "0"

VF2500 零件手册

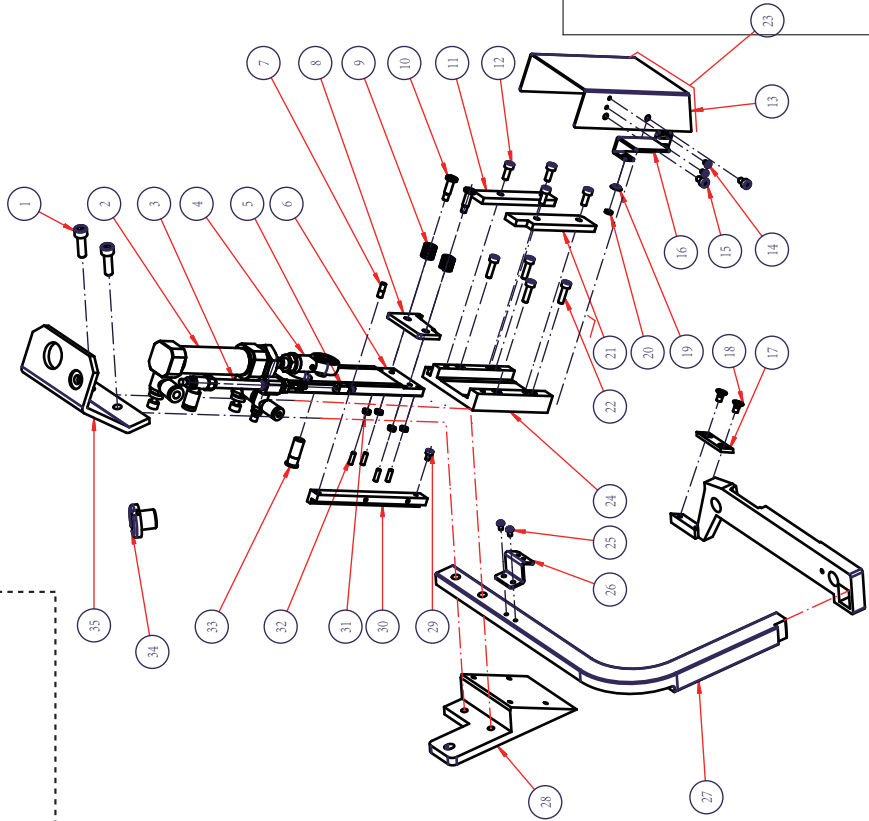
VF2500 Parts List

VF2500PLFE-000
抬压脚组



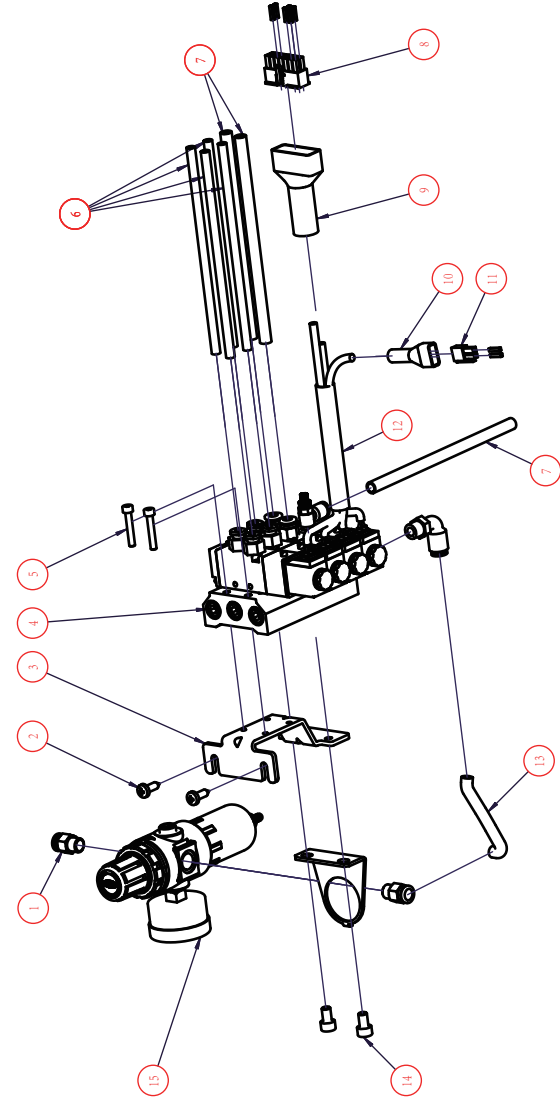
序号 REF.NO.	品号 PART NO.	数量 QTY
①	AS14-01	2
②	MF-2525-U	1
③	V/C2700PLFE-001	1
④	GB/T70.1-M6*16-12.9-FH	2
⑤	C858PLFE-001	1
⑥	GB/T97.1-6-140HV-FH	2
⑦	GB/T93-6-65Mn-FH	2
⑧	GB/T6187.2-M10*1.25-8-Zn-8	1

VF2500PTKB-000
切刀刀组



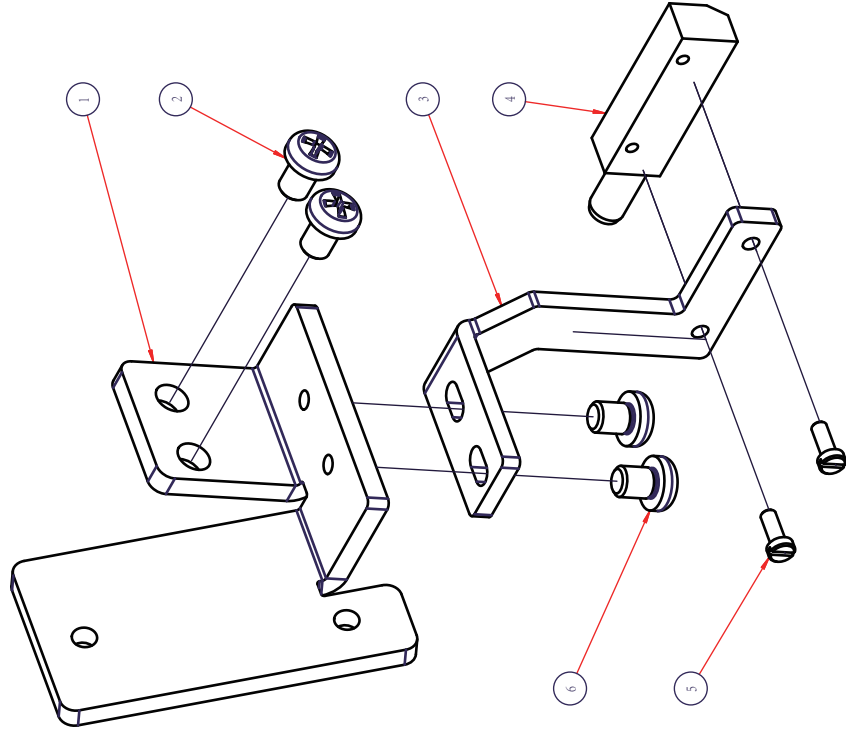
序号 REF.NO	品号 PART.NO.	数量 QTY
1	VF2500PTKB-11	1
2	TE1S97	1
3	VF2500PTKB-13	1
4	GB/T777-M3*10-45H-FH	4
5	GB/T6170-M3-8-FH	4
6	VF2500PTKB-4	1
7	GB/T70.1-M3*5-12.9-FH	1
8	VF2500PTKB-20	1
9	VF2500PTKB-1	1
10	VF2500PTKB-10	1
11	GB/T823-M3*5-4.8-FH	2
12	VF2500PTKB-2	1
13	TE4559	1
14	GB/T70.1-M4*14-12.9-FH	4
15	VF2500PTKB-6	1
16	P/M600ETT-008-003	1
17	P/M600ETT-008-002	1
18	TE800	2
19	VF2500PTKB-8	1
20	VF2500PTKB-21	1
21	GB/T70.1-M4*6-12.9-FH	2
22	GB/T823-M3*4-4.8-FH	2
23	VF2500PTKB-7	1
24	GB/T70.1-M4*10-12.9-FH	4
25	VF2500PTKB-5	1
26	VF2500PTKB-16	2
27	VF2500PTKB-17	1
28	VF2500PTKB-9	1
29	VF2500PTKB-24	1
30	VF2500PTKB-3	1
31	VF2500PTKB-22	1
32	F-M0812SU	1
33	PB-6*30-R	1
34	MF-20*40-U	1
35	GB/T70.1-M6*20-12.9-FH	2

VF2500PTKB-002
气源处理器



序号 REF.NO	品号 PART.NO.	数量 QTY
1	AFR2000-M	1
2	GB/T70.1-M6*10-12.9-FH	2
3	TE3140-2	1
4	TE3430	1
5	HX42000-2R(S557)	1
6	TE1724	1
7	TE1725	1
8	HX42000-14R(S557)	1
9	KE973-5-2	3
10	TE3140-6	4
11	GB/T70.1-M4*25-12.9-FH	2
12	TE3705B	1
13	M/TKUT-006-1	1
14	GB/T845-ST4.8*16-Zh-B	2
15	APC8-02	2

VF2500TKB-001
吹气组



序号 REF.NO.	品号 PART.NO.	数量 QTY
①	SM331	2
②	T803	2
③	VF2500TKB-34	1
④	VF2500TKB-32	1
⑤	0070184P	2
⑥	VF2500TKB-26A	1

