

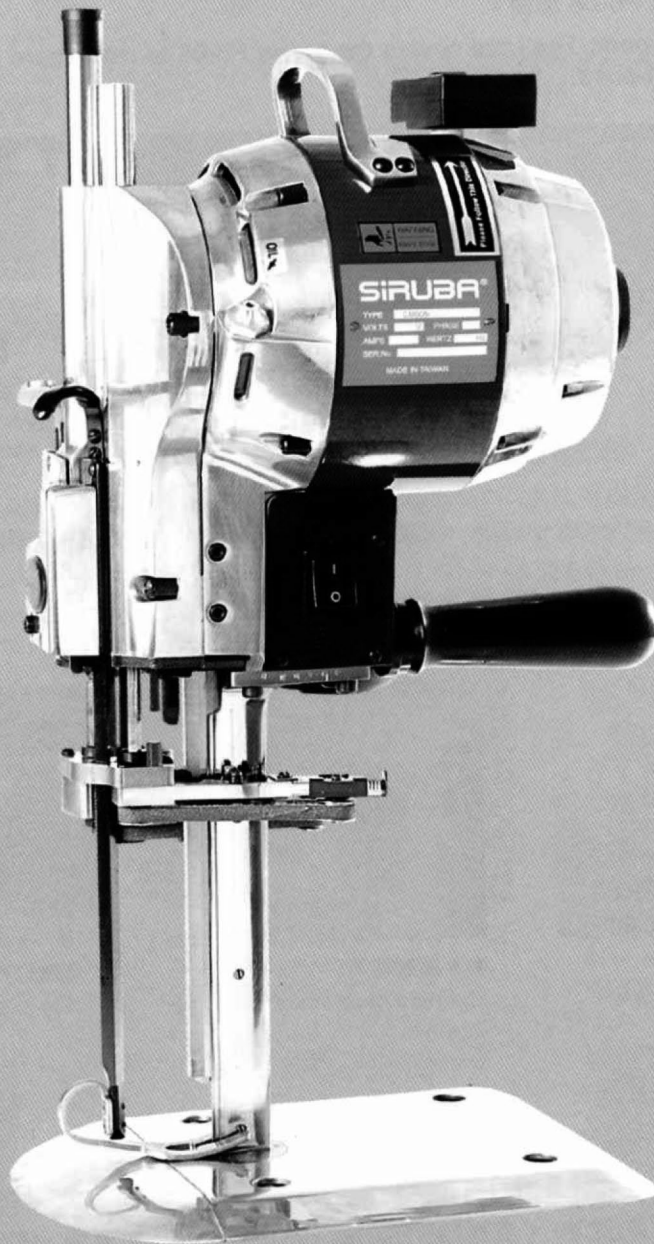
SIRUBA®

銀箭牌工業用裁剪機

INDUSTRIAL CUTTING MACHINE

CM006

使用說明與零件圖 INSTRUCTION AND PARTS LIST



CE

 高林股份有限公司
KAULIN MFG. CO., LTD.

1. 確定電源 Confirm the power source :

機器電源分為110v,220v,380v,50hz/60hz及1p3p等各式電源，三相機器請注意馬達轉向，順時針方向為正確方向，不對時，請對換其中兩條電源(接地線不可使用)。

Machine power supply supports the following types 110v, 220v, 380v (50hz/60hz). For the three-phase machines please watch for the spinning direction of motors, must be clockwise; if wrong, please exchange two cords among the three.(except the ground line).

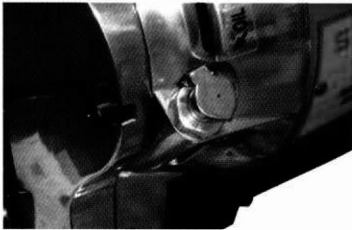
2. 機器啟動前 Before you switch on the machine remember to refill oil first :

A. 請先加油：a油杯 P4-10 (亦可打開磨刀裝置整組P5-13直接加油至滑塊P4-60及刀台P4-57)

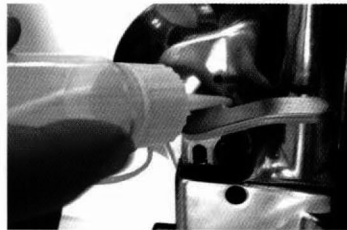
Use the P4-10 cup; or you can also open the knife-grinder assembly, P5-13, then refill directly into slider, P4-60, and blade plate, p4-57.

B. 磨刀齒輪前蓋螺絲處 P6-08 加油。

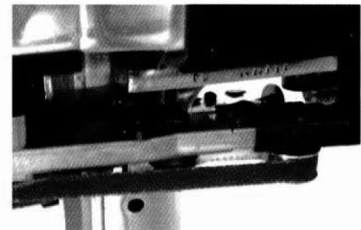
Knife-grinder wheel gear; The front covers the screw P6-08 to make sure to whet the knife bracket P7-17 at above fixed-point.



P4-10 油杯
P4-10 oil cup



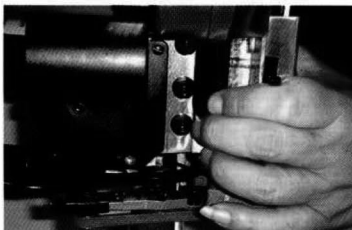
P6-08磨刀齒輪前
P6-08 knife-grinding gear



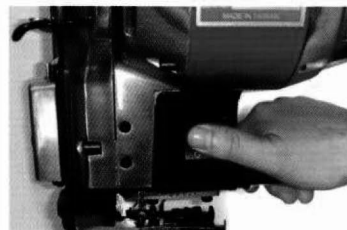
確定磨刀托架 P7-17 在上方定點
Confirm the knife holder, P7-17, is right on the above fixed point.

C. 左手往內按住磨刀橡膠輪把手P6-17，右手啟動電源，至機器馬達轉數達到全速。關閉電源再開電源，暖機作用數次，空轉約5-10分鐘，試磨刀，開始使用。(長時間未使用機器，動作亦同)

The left hand to inner press down to whet a handle knob in knife rubber P6-17, the right hand turns on the power supply, turn off the machine motor after spinning reaches the full speed. Repeat this procedure several times, for about 5~10 minutes, then try to whet the knife and start using the machine; Redo this procedure if you



左手往內按住P6-17把手
Left hand to inner press down the handle knobs P6-17



右手啟動電源
The right hand starts the power supply.



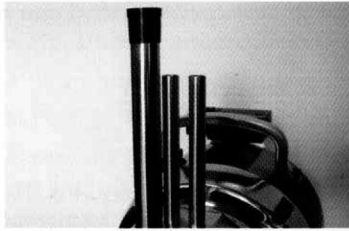
試磨刀
Try to whet the knife.

3. 直刀裁剪機基本常識 Common knowledge on Straight Knife Cutter :

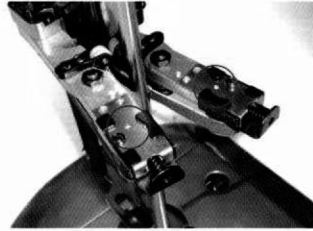
1. 機器保養：每日加機油，油杯及磨刀齒輪前蓋螺絲處，每星期大小管(大1小2)及左右後輪各加一滴油，磨刀托架座內每月加(黃油)。底盤輪不得加油，裁機請勿使用針車油，確記加油，但不得過量。

The machine maintenance: refill the engine oil, oil cup and the screw in front of the knife wheel gear cover everyday; for the tubes (1 big, 2 small) and rear wheels to fill a drop of oil each every week, refill

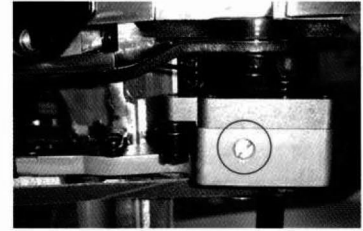
grease inside of knife bracket every month. The bedrock round can not refill oil, cutting the machine to please do not use needle oil on the cutters, remember to refill but can not be too much.



大小管 P6-06/05
Size tube P6-06/05 in knife bracket



左右後輪 P7-39/40
Left & right rear wheel, P7-39/40



磨刀托架座 P7-16
What a P7-16

每日使用後利用工具P9-2清除刀削 (P8-02) 雜物，每星期利用空壓機清除機器表面棉絮及打開前小蓋 P5-32清除鳳梨心P5-09前雜物。

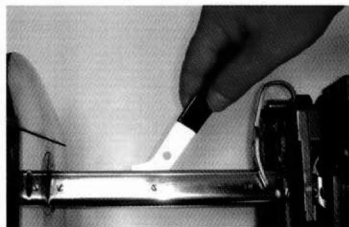
Make use of the tool clearance P9-2 knife to pare the miscellaneous articles (P8-02) or objects after the usage everyday; and use an air compressor to clean the machine every week. Machine surface waste cotton and open the ex miscellaneous articles or objects in small cover in front clearance P5-32 pineapple heart P5-09.

2. 確定刀片裝上並鎖緊P4-59，無刀片時請勿磨刀，磨刀時不可關閉電源

Make sure the blade is installed well and screw P4-59 tightly. Please do not whet the knife, without the razor blade installed. Do not turn off the power while whetting the knife.

3. 刀片不利時請按磨刀把手 (前蓋上方P5-16) 磨刀，普通鋼約1-2次，高速鋼約7-8次，磨刀卡住時請把磨刀卡筭 (P5-23)，往上提(前蓋左側)，再按磨刀把手即可。

When the blade becomes dull: Press the handle knob P5-16 to whet the knife; Try it about 1-2 times for common steel, about 7-8 times for high speed steel. If the knife get stocked then please take the quoin (P5-23) and lift upwards, (the front covers the left side), Press again to whet knife handle knob then.



清除刀削雜物
clearance knife pares blade packs up also lock



確定刀片裝上並鎖緊
The Certain that the razor lift the quoin upwards



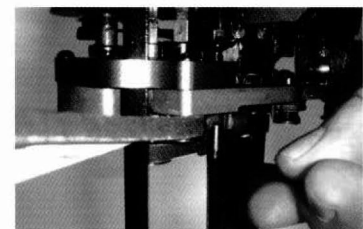
磨刀卡住時卡筭往上提
If the knife stocked, then the odds objects



打開大管內螺絲
Release the screw inside the big tube.



刀片最底部調整
The bottom the adjustment inside the screw razor blade.



刀刃調整
The knife blade adjustment.

4. 刀片角度調整 Blade angle adjustments :

I. 刀片最底部調整(砂帶位置太高刀尖磨不到，太低會把刀尖磨成斜形)

Adjustment of razor blade bottom (the sand bring the too high point of a knife in position and can not whet, too low Will whet the point of a knife circular)

II. 調整方式：把磨刀托架P7-17放在最上方定點，打開大管塑膠套P5-01，拿插削插入大管P6-06孔內固定住鳳梨心，打開螺絲P5-02插入工具P9-07，順時針方向轉一圈磨刀裝置提高1/32吋，逆時針時下降，依所需高度調整，調好後鎖緊螺絲，退回插削取出工具試磨，(刀片底部磨上顏色)

Adjustment method: take to whet the knife bracket P7-17 to put in the topmost and square fixed-point; Open to take care of the plastics a P5-01 greatly, take to insert to pare to insert into the big tube holes P6-06ses to live the pineapple heart fixedly; Opening the screw P5-02 inserts into the tool P9-07, clockwise turn a the turn whets the knife to equip the exaltation; 1/32 inches of, go against the hour hand to decline at present, adjust according to the height needed, lock the tight screw after tuning up, send back; Insert to pare to take out the tool to try to whet,(the razor blade bottom whet to apply color);

III. 標準位置：把磨刀托架放至最低位置時，刀片下死點要在砂帶上方，依布類調整刀刃寬度。

When standard position in pair of whet the knife bracket to put to the lowest position, razor blade next the dead center want to bring in the sand above; The knife blade adjusts.

IV. 刀刃調整，標準磨刀角度(薄料時右斜角要大於左斜角，1: 2/3，)；刀刃標準為1.8mm:1.2mm亦可(中厚物刀刃標準2.0mm:2.0mm)

the standard whets the knife angle(thin anticipate the right oblique angle is wanted to be big in left oblique angle,1: 2/3,); The knife blade is standard for the 1.8 mms:1.2 mms also can(win the thick thing knife blade the standard 2.0 mms:2.0mms); Adjust the knife blade width according to cloth,

V. 調整方式：取出工具P9-08插入蹄鐵，往後調整斜角愈大，往前調整斜角愈小。

Adjustment method, take out the tool P9-08 to insert into the hoof iron, hereafter; The adjustment oblique angle is more big, adjusting the more small, in oblique angle toward the front.

5. 更換刀片 Change the razor blade :

I. 先把裁機打橫(開關向上)平放於桌上，將馬達後蓋螺絲P2-31往內壓，按順時針方向轉動，刀片鎖刀螺絲P4-59轉動至磨刀托架上方，插入鎖刀扳手P9-03往逆時針方向轉動，即可取出刀片，

To take to cut the machine to beat first horizontal (the switch heading ups) place levelly in the table, cover the screw after the motor; P2-31 to inside press, press clockwise turn to move, the razor blade locks the knife screw P4-59 to turn to move to go to whet the knife; The bracket is above, inserting into the lock knife plank hand P9-03 to go against the hour hand direction to turn to move, can immediately take out the razor blade,

II. 裝上刀片後，盡量往上頂(刀片較短者不可)及向刀削方向拉緊，鎖上鎖刀螺絲，再按馬達後蓋螺絲往內壓轉動刀片，查看刀片在刀削中是否平順，

After packing the razor blade, as far as possible and upwards crest(shorter in razor blade can't) and pare the direction to tense to knife, lock; Lock the knife screw, then cover the screw after pressing motor to inside press to turn to fight with weapons the slice, look into the razor blade to pare in the knife; Medium whether favoring,

III. 裝上新砂帶，使用前試磨砂帶，(換刀片時請清理刀削內雜物)

Pack the new sand to bring, the usage tried to whet the sand to bring the before. (While changing the knife the slice please tidy up the knife to pare inside the miscellaneous articles or objects)



馬達後蓋螺絲
Cover the screw afte the motor



砂帶及刀片種類
The sand brings and razor blade category



更換砂帶
Changing the sand band brings

6. 更換砂帶 Changing the sand band :

- I. 裁剪布料不同時，請使用不同砂帶，厚布使用80 #砂帶，一般請使用100#砂帶，薄布使用120#砂帶

To cut the cloth different, please use the different sand to bring, the thick cloth uses 80# sand to bring, Please generally to use 100# sand to bring, the thin cloth uses 120# sand to bring the cloth of thin,

- II. 布料薄，刀刀光亮，布料厚，刀刀可粗，塑膠類使用波刀使用細砂帶。

The knife blade is shining, The cloth is thick, the knife blade is thick, a knife in plastics usage uses the thin sand to bring the.

- III. 更換砂帶動作，把磨刀托架上之後輪P7-39/40往前按，取出砂帶換上新品，把砂帶安裝於前後輪間，經蹄鐵P7-27/32及刀片中間。

Method to change the sand band: take to whet the knife bracket up after a P7-39/40, presses toward the front, taking out the sand to bring to change. Ascend the new article, bring the sand to install in front and back round, through the hoof iron P7-27/32 and razor blades in the center.

7. 調整磨刀托架中心點 Adjust the knife bracket central point :

- I. 把磨刀托架移至適當位置，打開刀柱後導板P7-07，鬆開托架安定器P7-12(左右)

Pair of to whet the knife bracket to move to the appropriate position, leading after opening the knife column; Plank P7-07, loosen to open the bracket to stabilize the machine P7-12 (or so),

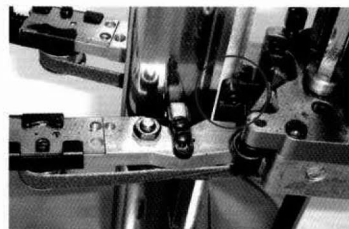
- II. 取出蹄鐵磨刀托架上方螺絲P7-35(左右)插上工具P9-09(工具前端與刀柱微微接觸)，將安定器與刀柱微微接觸，鎖緊安定器，兩邊，取出工具裝上螺母，鎖緊刀柱後導板，將磨刀托架移至最上方。

Take out the hoof iron to whet the knife bracket above; The silk P7-35 (or so) puts on the tool P9-09 (tool head and knife column tiny and tiny contact), will stabilize the machine; And knife column tiny and tiny contact.

Lock the tight stability machine, both sides, take out the tool to pack the screw hat, lock the tight knife; Lead the plank after the column, will whet the knife bracket to move to the topmost and square.



調整磨刀托架
adjustment whets the knife
bracket



左蹄鐵上方螺絲調整
Left hoof iron above the screw
adjustment



更換磨刀橡膠輪
changes to whet the knife rubber
round

8. 砂帶跳帶調整 Whet the knife bracket at above :

磨刀托架在上方時，夾臂P6-35會把左右蹄鐵分開，另左蹄鐵(大)上方螺絲P7-25應與刀片緊緊接觸，距離太遠會跳帶，蹄鐵螺絲P7-24應鎖緊，以防止蹄鐵移動。

Clip the arm P6-35 and will separate the or so hoof iron. Another left hoof iron (big) Above the screw P7-25 should is tight with razor blade to get in touch with tightly, the distance will jump to bring the hoof iron screw too far; The P7-24 should lock tightly, in order to prevent the hoof iron moves.

9. 更換磨刀橡膠輪 Change to whet a: in knife rubber :

更換磨刀橡膠輪，鬆開面具螺絲(4顆)及刀柱後導板螺絲，取出整組磨刀裝置，半按磨刀把手P5-16，將四角心P6-03/04轉為正平面，插入把手固定四角心，取出工具按住磨刀橡膠輪，往順時針方向取出磨刀橡膠輪，換上新品，按反方向動作裝回整組磨刀裝置即可。

- I. To lead the plank screw after loosening open the mask screw(4) and knife columns, take out whole The set whets the knife device,
- II. The half presses to whet the knife handle knob P5-16, turning four Cape heart P6-03/04ses as the positive flat surface,
- III. Inserting into the handle knob fixes four Cape hearts, taking out the tool to press down to whet the knife rubber round,
- IV. To clockwise take Pay to whet the knife rubber round, make replace with a new part, press opposite side action to pack to return to whole set to whet the knife to equip then

10. 裁機故障及維修方法 When the cutting machine breaks down and maintenance method :

Symptom :	Causes & Resolutions :
The motor does not work. (with humming noise)	<ol style="list-style-type: none"> 1. Cover the screw P2-31 after the motor to inside press, can't turn to move the hour: The knife pares inside have the miscellaneous articles or objects (Have the humming noise a hour) processing method: the clearance knife pares the miscellaneous articles or objects(usually is to stick to the gum quality thing) Or the knife a P4-57 and a P4-60s choked to death: processing method: Maintain or replace with a new part. 2. Can turn to move: hull inside the motor contain miscellaneous articles or objects processing method: clearance miscellaneous articles or objects, Starting the switch (platinum) P2-19 wears away Processing method: the platinum part brings to whet with the sand even, adjust to play Reed or replace with a new part. Leaving the heart switch(flying saucer) P2-21 wears away Processing method: adjust the spring coil slice, or replace with a new part.
The motor does not work. (without humming noise)	<ol style="list-style-type: none"> 1. The motor can't turn to move 1.Did not connect the power supply: processing method: put on the power supply. 2. Switch damages P4-16s: processing method: change the switch. 3. Get in touch with bad: electric wire and cut the machine plug P3-01/02 copper stick damage Processing method: replace with a new part.
The motor parking is nasty to stop or making strange noise	<ol style="list-style-type: none"> 1. Whet a P7-17 in knife not at position: Processing method: whet the knife to put to the fixed position
The machine emits smoke.	<ol style="list-style-type: none"> 1. Start bad: processing method: maintain to start the switch P2-19/21 2. The switch contact is bad. processing method: change new 3. The motor coil is damp: processing method: dry
The razor blade bottom splits.	<ol style="list-style-type: none"> 1. The knife pares inside have the miscellaneous articles or objects: processing method: the clearance knife pares the miscellaneous articles or objects inside the P8-02 The razor blade is sharp please use carefully(our company fully protects the gloves to sell medium, security check essential)
The motor does not start smoothly.	<ol style="list-style-type: none"> 1. Whetting the knife equips too below: processing method: take to whet the knife device to push to the fixed position (with humming noise) 2. Motor inner part contain miscellaneous articles or objects: processing method: internal miscellaneous articles or objects in clearance motor 3. The knife pares inside have the miscellaneous articles or objects: processing method: the clearance knife pares the miscellaneous articles or objects or changes the new article

The motor does not start smoothly.	<ol style="list-style-type: none"> 4. Internal oil hardening in bearings: processing method: warm machine or replace with a new part. 5. The usage oil is not appropriate: processing method: use 30# lubricant 6. The electric voltage is too low: processing method: quantity electric voltage 7. The electric wire is wrong or too long: processing method: change the electric cord.
The machine starts the voice big	<ol style="list-style-type: none"> 1. A P4-57 in knife or knife a heart P4-56s exhaust: Processing method: maintain or replace with a new part. 2. A P4-60 exhausts: processing method: maintain or replace with a new part. 3. Bearings P4-47 or bearings heart damages P4-46s: processing method: replace with a new part.
The machine vibrates too greatly	<ol style="list-style-type: none"> 1. The knife set or knife set hearts exhaust: processing method: maintain or replace with a new part. 2. Connecting the bar P4-50 exhausts: processing method: replace with a new part. 3. A P8-14 in bottom wears away: processing method: replace with a new part. 4. Bearings or bearings heart damage: processing method: replace with a new part.
The machine stops the fore shock to move	<ol style="list-style-type: none"> 1. The razor blade pack too low: processing method: pack the razor blade method according to the standard. 2. A bedrock in bottom leaves to cut the plank is too high: processing method: change the bottom round
Whetting the knife device cans not lets go	<ol style="list-style-type: none"> 1. Whetting a P6-24 in knife rubber wears away: processing method: maintain or replace with a new part. 2. Whetting the knife rubber round is stained with the oil: processing method: wipe to sweep 3. Spring coil damages P6-27s: processing method: processing method: replace with a new part.
Whetting the knife device falls in	<ol style="list-style-type: none"> 1. Whetting the knife equip to have no butter inside the wheel gear and the stalk of s: processing method: add the butter
Whetting the knife voice adds high	<ol style="list-style-type: none"> 1. Whetting the knife rubber round transforms: processing method: replace with a new part. 2. The wheel gear P6-14/16/42 wears away: processing method: replace with a new part. 3. Should refill oil to refill oil, size tube and back round: processing method: refill oil
Clip the cloth	<ol style="list-style-type: none"> 1. Knife tongue damages P8-04s: processing method: replace with a new part. 2. Lose to whet the knife function: processing method: adjust to whet the knife to equip 3. The bubble cotton clips the cloth: processing method: add paper every 5 layer bubble cottonses
The razor blade slices not next	<ol style="list-style-type: none"> 1. The sand brings to wear away: processing method: change the sand to bring 2. The sand brings to touch not go to: processing method: adjust screw 3. The razor blade to whet to the bottom: processing method: change the razor blade 4. Whet the knife angle inaccuracy: processing method: adjust the hoof iron 5. Knife under carry to wear away the inaccuracy: processing method: adjust the pineapple heart the height
Pressing the feet P5-44 can't let go of	<ol style="list-style-type: none"> 1. Inner part contain miscellaneous articles or objects: processing method: clearance miscellaneous articles or objects 2. Press the feet column flection: processing method: adjust to press the feet column or replace with a new part.

發生狀況	故障原因及處理方式
馬達無法轉動 (有嗡嗡聲時)	1. 馬達後蓋螺絲P2-31往內壓，無法轉動時:刀削內有雜物或刀台P4-57及滑塊P4-60卡死 處理方式:清除刀削雜物(通常為黏膠物質) 處理方式:維修或換新品 2. 可以轉動:馬達內殼有雜物 處理方式:清除雜物 啟動開關(白金)P2-19磨損 處理方式:白金部份用砂帶磨平，調整彈簧片，或更換新品 離心開關(飛碟)P2-21磨損 處理方式:調整彈簧片，或更換新品
馬達無法轉動 (無嗡嗡聲時)	1. 未接電源:處理方式:插上電源 2. 開關P4-16損壞 處理方式:更換開關 3. 接觸不良:電線及裁機插頭P3-01/02銅棒損壞 處理方式:換新品
馬達停車急停或有怪聲	1. 磨刀座P7-17不在定位 處理方式:磨刀座放至定位
機器冒煙	1. 啟動不良 處理方式:維修啟動開關P2-19/21 2. 開關接觸不良 處理方式:換新 3. 馬達線圈潮濕 處理方式:烘乾 4. 馬達起動線損毀 處理方式:換馬達線圈
刀片底部斷裂	1. 刀削內有雜物 處理方式:清除刀削P8-02內雜物 刀片鋒利請小心使用(本公司備有保護手套出售中,安全檢查必備)
馬達啟動不良 (轉速不正常)	1. 磨刀裝置太下面 處理方式:把磨刀裝置推至定位 2. 馬達內部有雜物 處理方式:清除馬達內部雜物 3. 刀削內有雜物 處理方式:清除刀削雜物或換新品 4. 軸承內部油硬化 處理方式:暖機或換新品 5. 使用油不當 處理方式:使用30#潤滑油 6. 電壓太低 處理方式:量電壓 7. 電線太細或太長 處理方式:更換電線
機器啟動聲音大	1. 刀台P4-57或刀台心P4-56損耗 處理方式:維修或換新品 2. 滑塊P4-60損耗 處理方式:維修或換新品 3. 軸承P4-47或軸承心P4-46損壞 處理方式:換新品
機器震動太大	1. 刀台或刀台心損耗 處理方式:維修或換新品 2. 連桿P4-50損耗 處理方式:換新品 3. 底輪P8-14磨損 處理方式:換新品 4. 軸承或軸承心損壞 處理方式:換新品
機器停止前震動	1. 刀片裝的太低 處理方式:按標準裝刀片方法 2. 底輪底盤離裁板面太高 處理方式:更換底輪
磨刀裝置放不下	1. 磨刀橡膠輪P6-24磨損 處理方式:維修或更換新 2. 磨刀橡膠輪沾到油 處理方式:擦拭清潔 3. 彈簧P6-27損壞 處理方式:更換新品
磨刀裝置落下	1. 磨刀裝置內齒輪和螺軸無黃油 處理方式:加黃油
磨刀聲音加高	1. 磨刀橡膠輪變形 處理方式:更換新品 2. 齒輪P6-14/16/42磨損 處理方式:更換新品 3. 應加油處加油，大小管及後輪 處理方式:加油
夾布	1. 刀舌P8-04損壞 處理方式:更換新品 2. 失去磨刀作用 處理方式:調整磨刀裝置 3. 泡棉夾布 處理方式:每5層泡棉加一張紙
刀片不利	1. 砂帶磨損 處理方式:更換砂帶 2. 砂帶碰不到 處理方式:調整螺絲 3. 刀片已磨至底部 處理方式:更換刀片 4. 磨刀角度不正確 處理方式:調整蹄鐵 5. 刀片下端磨損不正確 處理方式:調整鳳梨心高度
壓腳P5-44無法放下	1. 內部有雜物 處理方式:清除雜 2. 壓腳柱彎曲 處理方式:調整壓腳柱或更換新品

发生状况	故障原因及处理方式
马达无法转动 (有嗡嗡声时) 马达无法转动 (无嗡嗡声时) 马达停车急停或有怪声	1. 马达后盖螺丝P2-31往内压, 无法转动时: 刀削内有杂物或刀台P4-57及滑块P4-60卡死 处理方式: 清除刀削杂物(通常为黏胶物质) 处理方式: 维修或换新品 2. 可以转动: 马达内壳有杂物 处理方式: 清除杂物 启动开关(白金)P2-19磨损 处理方式: 白金部份用砂带磨平, 调整弹簧片, 或更换新品 离心开关(飞碟)P2-21磨损 处理方式: 调整弹簧片, 或更换新品 3. 未接电源 处理方式: 插上电源 2. 开关P4-16损坏 处理方式: 更换开关 3. 接触不良: 电线及裁机插头P3-01/02铜棒损坏 处理方式: 换新品 1. 磨刀座P7-17不在定位 处理方式: 磨刀座放至定位
机器冒烟	1. 启动不良 处理方式: 维修启动开关P2-19/21 2. 开关接触不良 处理方式: 换新 3. 马达线圈潮湿 处理方式: 烘干 4. 马达激活线损毁 处理方式: 换马达线圈
刀片底部断裂	1. 刀削内有杂物 处理方式: 清除刀削P8-02内杂物 刀片锋利请小心使用(本公司备有保护手套出售中, 安全检查必备)
马达启动不良 (转速不正常)	1. 磨刀装置太下面 处理方式: 把磨刀装置推至定位 2. 马达内部有杂物 处理方式: 清除马达内部杂物 3. 刀削内有杂物 处理方式: 清除刀削杂物或换新品 4. 轴承内部油硬化 处理方式: 暖机或换新品 5. 使用油不当 处理方式: 使用30#润滑油 6. 电压太低 处理方式: 量电压 7. 电线太细或太长 处理方式: 更换电线
机器启动声音大	1. 刀台P4-57或刀台心P4-56损耗 处理方式: 维修或换新品 2. 滑块P4-60损耗 处理方式: 维修或换新品 3. 轴承P4-47或轴承P4-46损坏 处理方式: 换新品
机器震动太大	1. 刀台或刀台心损耗 处理方式: 维修或换新品 2. 连杆P4-50损耗 处理方式: 换新品 3. 底轮P8-14磨损 处理方式: 换新品 4. 轴承或轴承心损坏 处理方式: 换新品
机器停止前震动	1. 刀片装的太低 处理方式: 按标准装刀片方法 2. 底轮底盘离裁板面太高 处理方式: 更换底轮
磨刀装置放不下	1. 磨刀橡胶轮P6-24磨损 处理方式: 维修或更换新品 2. 磨刀橡胶轮沾到油 处理方式: 擦拭清洁 3. 弹簧P6-27损坏 处理方式: 更换新品
磨刀装置落下	1. 磨刀装置内齿轮和螺轴无黄油 处理方式: 加黄油
磨刀声音加高	1. 磨刀橡胶轮变形 处理方式: 更换新品 2. 齿轮P6-14/16/42磨损 处理方式: 更换新品 3. 应加油处加油, 大小管及后轮 处理方式: 加油
夹布	1. 刀舌P8-04损坏 处理方式: 更换新品 2. 失去磨刀作用 处理方式: 调整磨刀装置 3. 泡棉夹布 处理方式: 每5层泡棉加一张纸
刀片不利	1. 砂带磨损 处理方式: 更换砂带 2. 砂带碰不到 处理方式: 调整螺丝 3. 刀片已磨至底部 处理方式: 更换刀片 4. 磨刀角度不正确 处理方式: 调整蹄铁 5. 刀片下端磨损不正确 处理方式: 调整菠萝心高度
压脚P5-44无法放下	1. 内部有杂物 处理方式: 清除杂物 2. 压脚柱弯曲 处理方式: 调整压脚柱或更换新品



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