

MT 开卷机使用说明书

Operation Manual For MT Uncoiler Machine

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1. 前言 Foreword

感谢您使用我们的 MT 系列开卷机。机器之性能是否发挥，使用寿命是否持久，除机器本身须具备优良性能外，操作者对机器本身的结构及性能是否了解尤为重要我们建议您开始安装及使用操作机器之前，敬请先熟读本说明书，它将会提供您整套的使用及保养方法。因为只有正确操作与保养，才能使机器发挥最高效率。

Thank you for using our MT coil uncoilers. Whether the performance of the machine is exerted and the service life is long-lasting, in addition to the excellent performance of the machine itself, it is especially important for the operator to understand the structure and performance of the machine itself. We recommend that you read this manual before you start installing and using the machine. It will provide you with a complete set of methods of use and maintenance. Because only proper operation and maintenance can make the machine work at the highest efficiency.

本装置结合了新型的料卷开料功能。装在料卷架上的料卷是由控制机头速度的感应装置所控制，达到能配将材料按要求速度自动地、平稳地的同步送入下一个工作流程。各辅助装置的运转是以油压、空压或电机做为动力源。料

卷机采用悬臂式压料，及手摇或油压缸方式挟持铁圈，操作简单，保养容易，故障率低。

The device incorporates a new type of material roll opening function. The roll mounted on the roll holder is controlled by a sensing device that controls the speed of the head, so that it can be automatically and smoothly fed to the next work flow at the required speed. The operation of each auxiliary device is based on oil pressure, air pressure or electric motor. The reeling machine adopts cantilever type pressing material and hand or hydraulic cylinder to hold the iron ring, which is easy to operate, easy to maintain and low failure rate.

8. 安全标识 Safety instruction

为了更加清楚地理解应该遵守的注意事项，在本说明书以及本产品的警告铭牌上，分别使用了不同的安全标记。

In order to understand more clearly the precautions that should be observed, different safety symbols are used in this manual and on the warning plate of this product.



表示的是重大危险事故迫近的危险状态。

It represents a dangerous state in which a major dangerous accident is approaching.



警告

表示的是会发生重大事故的危險状态

Indicates a dangerous state in which a major accident will occur.



注意

表示的是会造成伤害的危險状态。

Indicates a dangerous state that can cause injury.

重要

表示的是如果进行了错误的损伤，有可能会损坏机械或缩短机械的寿命。

It means that if the wrong damage is made, it may damage the machine or shorten the life of the machine.

➤ 本公司不能预测出在所有环境下对机械进行运转操作、检修、保养时会发生的危險。

The company cannot predict the hazards that may occur during the operation, maintenance, and maintenance of machinery in all environments.

➤ 本书及本产品警告铭牌上记载的有关安全的注意事项并不是对安全内容的全部说明。

The safety precautions stated on the nameplate of this book and this product are not a complete description of the safety content.

➤ 在操作机械时，进行管理、运转操作、保养的人员也留意本说明书以外的事项。以防止人身事故等重大灾

难的发生和损坏产品，确保安全。

When operating the machine, personnel who perform management, operation, and maintenance should also pay attention to matters other than this manual. To prevent the occurrence of major disasters such as personal accidents and damage products, to ensure safety.



进行本说明书以外的运转操作、检修、保养时，有关安全上必要的注意事项安全由自己负责。

When performing operation, inspection, and maintenance other than this manual, it is your responsibility to be responsible for the safety precautions.

9. 产品规格 Product specification

表 4-1

型式 项 目 model	MT-200	MT-300	MT-400	MT-600	MT-800
材料厚度 Thickness (mm)	0.3-3.20	0.3-3.20	0.3-3.20	0.3-3.20	0.3-3.20
材料宽度 Width (mm)	50-200	50-300	50-400	100-600	100-800
开卷速度 Speed (m/min)	16	16	16	16	16
卷料重量 Coil weight (kg)	800	1000	1500	3000	5000
卷料内径 Coil.I.D (mm)	Φ 508	Φ 508	Φ 508	Φ 508	Φ 508

卷料外径 Coil.O.D (mm)	Φ 1200	Φ 1200	Φ 1400	Φ 1400	Φ 1400
料卷扩张 Expansion	油压式/手 摇式 Hydraulic	油压式/ 手摇式 Hydraulic	油压式/ 手摇式 Hydraulic	油压式/ 手摇式 Hydraulic	油压式/ 手摇式 Hydraulic
电源电压 Power (V)	380V	380V	380V	380V	380V

10. 5.调试与运行 Testing and running

1.将机器运至确切位置后，必须确定料架中心，其他配套设备及其冲床模具保持在同一材料中心线上

After transporting the machine to the exact position, the center of the rack must be determined. Other supporting equipment and its punching molds are kept on the same material center line.

2.电控部分测试 Electronic control part

2.1将电源线接入三相380V电源开关下口,确保供电负荷不少于5KVA.

Connect the power cable to the lower port of the three-phase 380V power switch to ensure that the power

supply load is not less than 5KVA.

2.2机器压料臂需要提供5Kgf/cm 的压缩空气,并保证气源气量充足

The machine press arm needs to supply 5Kgf/cm of compressed air and ensure sufficient air supply.

2.3检查电源接线正确无误,打开电源开关,电源指示灯亮,把自动/手动开关旋到手动位置,实验各机台运转情况,无异常反映,打到自动位置,仔细观察有无异常现象.

Check the power supply wiring is correct, turn on the power switch, the power indicator light is on, turn the automatic / manual switch to the manual position, test the operation of each machine, no abnormal reflection, hit the automatic position, carefully observe whether there is any abnormal phenomenon.

11. 6. 保养检查 Maintenance check

时间 Time	须要维护项目 Need to maintain items	维护机种 Maintenance model	维护表单 Maintenance form
每周 Week	1) 主轴轴承 Spindle bearing 2) 加满油至三点组合（气动夹料） Fill up the oil to the three-point combination (pneumatic clamp) 3) 检查油压液压水平 Check the hydraulic pressure level		
每月 Every month	1) 检查油箱液压水平（有油压扩张） Check the hydraulic level of the tank (with oil pressure expansion) 2) 检查料卷传动链条的张力 Check the tension of the coil drive chain 3) 料卷专动链条油 Roller special chain oil 4) 束紧钮 Tighten button		

<p>每季</p>	<p>1) 检查刹车片 Check the brake pads</p> <p>2) 检查油压系统（有油压扩张） Check the oil pressure system (with oil pressure expansion)</p> <p>3) 检查与清洁电源箱的灰尘 Check and clean the dust of the power box</p> <p>4) 检查主要的滤器是否有附着灰尘 Check if the main filter has dust attached</p>		
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目的： Purpose

● 对二合一机台例行性的保养是非常重要的且是必备的保养步骤。 Routine maintenance of the 2in1 machine is very important and an essential maintenance step.

1) 本公司所制作的机器需要注意到完全及有效的维修操作，一个适时的维修与监控规划能够增加安全性，产能效率不适当的维修会造成浪费时间（当在等待零件更换或维修人员抵达时）无效率的操作，低产能且增加意

外的风险。

The machines produced by the company need to pay attention to complete and effective maintenance operations. A timely maintenance and monitoring plan can increase safety. Inefficient maintenance of production capacity can result in wasted time (when waiting for parts replacement or maintenance personnel to arrive) Time) Inefficient operation, low productivity and increased risk of accidents.

- 2) 此操作手册所提的部分包含明确的保养步骤及安全说明，在机器进行保养动作前，先重复阅读此部分，保养的步骤是以发生的频率来做（包括、每周、每月、每季、...等），所有的保养步骤必须提供在此手册。

The parts mentioned in this operation manual contain clear maintenance procedures and safety instructions. Repeat this section before the machine performs maintenance operations. The maintenance steps are performed at the frequency of occurrence (including, weekly, monthly, Every season, ..., etc.), all maintenance procedures must be provided in this manual.

- 3) 虽然没有人喜欢纸上工作，但这是一个正确文件以决定保养日志是实在的记录保存。

Although no one likes to work on paper, this is a correct

document to determine the maintenance log is a real record save.

- 4) 在进行保养步骤时，机器的保养装置通常会被移动，且对其他人造成潜在的风险在所有机器上，在保养时必须坚持安全第一的精神。同时 每一台机器做保养，注意安全，并将风险及伤害降至最低。

When performing maintenance procedures, the maintenance equipment of the machine is usually moved and poses a potential risk to other people. On all machines, the spirit of safety must be adhered to during maintenance. At the same time, each machine is maintained, paying attention to safety and minimizing risks and injuries.

12. 故障排除 Troubleshooting

送料精度不良 Poor feed accuracy		
故障现象 Fault phenomenon	故障原因 cause of issue	排除方法 Method of exclusion
没有任何动作 指示灯不亮 No action indicator is off	电源不正常 Power is not working properly	检查电路 Check circuit
	保险管烧坏 Insurance tube burned out	更换新品 Replacement of new products
	电源开关坏 Power switch is broken	更换新品 Replacement of new products
电插头灯 亮但没有 任何动作 The electric plug light	控制电路板坏 Control board is bad	送修或更换新品 Send or replace new products
	正反转选择开关坏 Positive and negative	更换新品 Replacement of new products

is on but there is no action	selection switch is broken	
	接触器坏 Contactor is bad	更换新品 Replacement of new products
	电机烧坏 Motor burnout	更换新品 Replacement of new products
手动正常 自动 没反应 Manual normal automatic no response	控制电路板坏 Control board is bad	送修或更换新品 Send or replace new products
	接触器电阻过大 Contactor resistance is overtake	查接地是否良好,材料 是否和感应架接触良好 Check if the grounding is good and the material is in good contact with the sensor uncoiler 检查感应线接插部份是否 接触良好,有无断线 Check if the sensing wire connector is in good contact and there is no wire breakage.
自动能启 动但不能	控制电路板坏 Control board is	更换新品 Replacement of new products

停止	bad	
Automatic ally starts but can't stop	停止电极无信号反 馈 Stop electrode without signal feedback	检查电极其边线是否良好 Check if the electrode has a good edge
	启动电极接地 Start electrode ground	查找接地点 Find the grounding point
只有正转 无反转或 只有反转 无正转 Only forward without reversal or only reverse without forward	正转或反转接触 器坏 Forward or reverse contactor is broken	更换新品 Replacement of new products
	开关损坏 Switch damage	更换新品 Replacement of new products

