

**THREE-HEADS DIRECT DRIVE BUTTON
ATTACHINE MACHINE**



Thank you for using our series of Button attaching machine. In order to use this machines safely and skillfully, please read the instructions in detail and strictly observe the operating rules.

Catalog

1. Product characteristics
2. Matters needing attention
3. Technical parameter
4. Installation steps
5. Operational instructions
6. Warranty
7. Parts list

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I. The button attaching machine has the following characteristics:

(1) Security:

The machine does not start and alarm when the hand is in the range of the mould.

However, safety is only relative. The machine should not be operated without adjusting the safe operating distance between the moulds.

(2) Quality:

A. Small vibration, high precision button.

B. Machine assembly and processing accuracy is high, concentricity is good, to the greatest extent to ensure that the button.

C. The base is made of alloy material, the U-shaped mouth is not easy to deform, and the machine has high durability.

(3) Efficiency:

A. The machine starts quickly.

B. The machine has large operating space and is more suitable for buttoning operation of large workpieces.

C. The machine has the function of automatically adjusting the stroke of the die, so that you can adjust and push buttons more conveniently and quickly.

(4) Environmental protection:

A. Low noise during the whole machine working and standby to improve worker's comfortable operating environment.

B. The power consumption of this machine is low. It saves 50% to 80% of the electricity compared with the ordinary button-puncher. With this machine, you can save about 800 kilowatt-hours per year in your original power consumption.

II. Attention:

1. Only after professional training can the machine be operated.
2. This machine is single-phase three-wire system. It must be grounded three-hole socket. working voltage :AC110V-AC220V
3. There is high voltage in the control system of this machine. Non-professionals are forbidden to open the control system (even in the case of power failure) in order to avoid electric shock accident.
4. The power supply must be turned off when the machine replaces the mould.
5. It is not allowed to operate the machine without adjusting the mould and safe operating distance.
6. It is not allowed to work under the condition of dismantling the protective ring; it is not allowed to pull the protective ring by hand.
7. This machine must add lubricating oil regularly (usually white oil for clothes and cars).
8. Maintenance precautions:
 - A, refueling: In general, refueling once a week, refueling position in the stamping core shaft.

B. Clean the machine every day and keep good ventilation and heat dissipation.

C. The maximum working frequency of the motor system is 60 times per minute. If the frequency exceeds this, we must pay attention to the temperature of the motor. If the temperature of the servo motor rises too high, we must stop and rest, otherwise the servo motor system will be damaged.

III.technical parameter

Performance technical parameters:

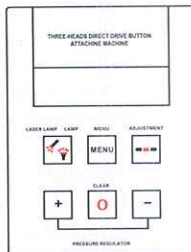
Working Power: Brushless Servo Motor

Operating Voltage: AC110-AC220V

Stamping pressure: 1500Kg

Protection mode: self-contained detection ring

Working itinerary: 55mm



- 1、 Power switch
- 2、 Indicator cursor and LED, two lights have four combinations, each press to switch a state.
- 3、 Gear and Speed (-) Keys
- 4、 Gear and impulse (+) buttons
- 5、 Adjustment: Whenever a die is rotated, the adjusting key must be pressed, the 10-foot step on the start switch, the 0:1:press the zero-clearing key, the center axis will automatically go down, the position of the lower die will be detected, and the current stroke pressure gear will be remembered.
- 6、 Zero-clearing, long count by zero-clearing
- 7、 Counter: Six-digit digital tube. The highest count is 99999 (the counter uses 510 digits, memory once every 50 times).
- 8、 Pressure and impulse display (note: 1000 to 5000 impulse pressure 0 to 100).
Long press settings enter settings pressure and speed, S1000 represents speed, P000 represents pressure, press + or - key adjustment, the greater the value, the greater the pressure or speed, the shorter press settings key exit.

When the machine is in factory, according to the routine operation habits, the tightness of the starting foot has been adjusted. If the factory needs to adjust, it can adjust the handle according to the foot tightness as shown in the figure.

The starting pedal of this machine is reset by pulling spring. The adjusting screw is tightened by clockwise rotation and loosened by counterclockwise rotation. The machine has adjusted its tightness when it leaves the factory.

IV. Installation steps

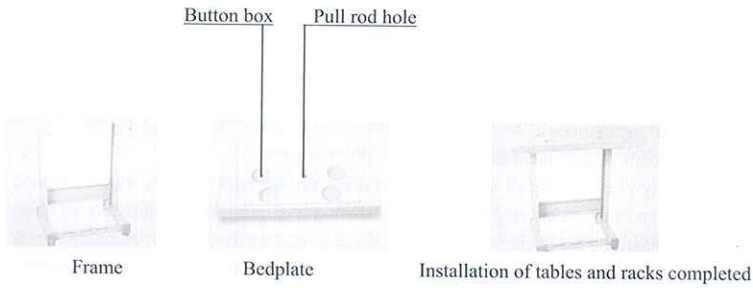
Installation steps of fastener are the same

1. Safety precautions

- 1) The machine needs to be installed by professionals.
- 2) Ensure that the power supply is grounded safely and meets the voltage range of the unit.

2. Installation steps: The whole machine is composed of frame, table, head, etc.

- 1) Installation rack board: take the rack and assemble the rack with special screw. Place the board on the rack and fix it with wooden screw.



- 2) Installation Head: Remove the Head from the packing box, align it with the pull rod hole, and fix it on the table with wooden screw.

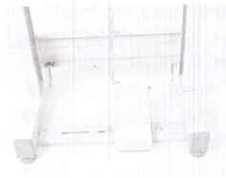


Nose

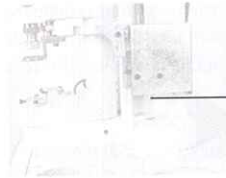


Head Installation Completed

3) Installation of foot pedal and tug: the foot pedal is fixed on the right side of the frame footplate with a screw, the tug is screwed in the pull rod nut on the right side of the machine head, and then connected with a special screw. (Note: Installation of pedal, tie rod should ensure that the position of tie rod is perpendicular to the foot pedal, and the foot pedal should be easily and naturally stepped down.)



Pedal installation completed



Pull rod nut

Installation of tie rod completed

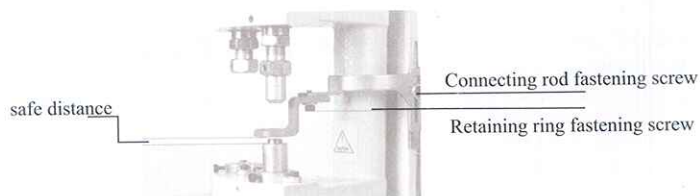
V. Operational Instructions

1. Safety Principle of the Machine:

The safety principle of this series of direct drive nailing machine is to set the distance from the bottom of the safety ring to the edge of the lower die according to different working conditions. Generally, the thickness of the work piece is the standard, and the retaining ring is the starting position until now. When the finger is within the scope of the lower die, step on the starting pedal and pull down the safety guard ring. Because of the existence of the finger, the guard ring can not reach the starting position. The control system will automatically alarm, and the machine can not start, so as to achieve the purpose of safety control.

2. The adjusting method of the die and safety distance of the machine:

1) Install the upper and lower die on the machine, fix it with a hexagonal wrench, and screw the adjusting screw of the upper die sleeve upward to the highest position. Press the adjusting key foot, press the start switch to appear (01), press the zero-clearing key, press the upper die to come back and adjust the mode by one key.



2) Turn off the power switch of the machine and install the safety guard ring. The nail buckler is equipped with safety guard ring. After stepping on the foot starter plate and pulling down the safety guard ring, adjust the connecting degree of the guard ring. The distance between the edge of the lower die and the bottom of the guard ring is generally based on the thickness of the workpiece. The standard distance is the safe distance (but it must not exceed the thickness of the finger). If the lower die used is a soft spring die, because the soft spring has yielding property, the spring should be pressed down to the bottom, with the lowest edge of the die after pressing the spring as the standard safety point.

Be careful:①After setting the safe distance, we must tighten the fastening screw of the retaining ring and the connecting rod of the retaining ring, so as to prevent the change of the safe distance, fail to perform the function of safety protection and cause unsafe factors.

②When operating, it is absolutely not allowed to put finger on the die to test punch. Find a stick or non-metallic object that is similar to the thickness of the workpiece but must be less than the thickness of the finger. Place it on the lower die, step on the foot start plate, and if the upper die is to be rushed down, adjust the safe distance again, otherwise it can be operated.

3) The height of the lower die of the fastener in the same turntable must be equal or similar, not too different. Because the safety retaining ring is the same, only one start distance can be set, and the shortest start distance of the lower die is the maximum, which may not play the role of safety protection, and there are unsafe factors.

Be careful:①In the operation of the nailing machine, the turntable is switched from one die to another. The first step is about half the distance of the pedal starter plate, then swing the turntable to the position, and then loosen the pedal starter plate.

②When installing buttons on the upper and lower dies, it is necessary to operate at the bottom of the safety guard ring, let alone step on the foot pedal, so as to prevent unsafe factors.

Reminder:

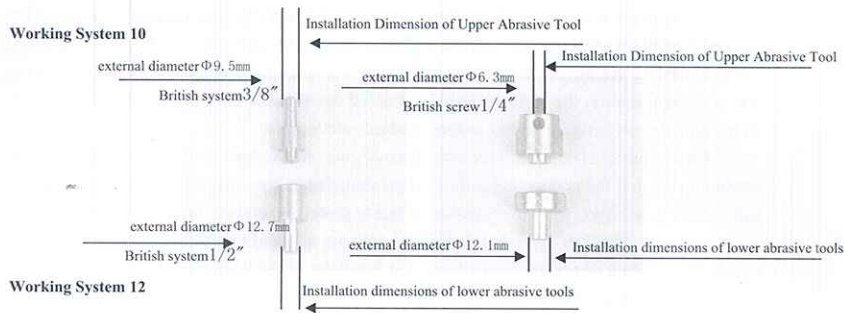
Because the working voltage and power plug used in different countries are different, and the installation size of button die is different, for the convenience of users, please choose the right machine when ordering.

1. Working Voltage and Power Plug: Working Voltage is divided into AC220V, AC110V, Power Plug is divided into three flat shanking head, European plug and American plug, etc. (Domestic working voltage is AC220V, Power Plug is three flat plug.)

2. Installation Dimensions of Button Mould: According to the installation dimensions provided by users, the corresponding upper and lower die sleeves are matched. Generally, there are several installation dimensions as follows: (For reference)

Installation Dimension of Upper Abrasive Tool	Φ 10mm	Φ 7mm	Φ 9. 5mm (3/8")	Φ 9. 5mm (3/8")	M6 thread	M8 thread	5/16" thread (Φ 7. 9mm)	1/4" thread (Φ 6. 3mm)
Installation dimensions of lower abrasive tools	Φ 12mm	Φ 19mm	Φ 9. 5mm (3/8")	Φ 12. 7mm (1/2")	Φ 12mm	Φ 19mm	3/4" (Φ 19mm)	Φ 12. 1mm

3. Button upper and lower die drawings:



VI. Warranty Notes

1. All users who purchase button-mounting machine products enjoy a one-year free warranty service. (Except for vulnerable parts). Distributors should send (or fax) the product warranty card to our company for archiving within one month from the date of purchase. Overdue is considered to be an automatic waiver of warranty rights and interests.

2. One-year warranty service refers to the company's products, which are manufactured within one year of purchase. The company will provide free maintenance for quality problems or damage under normal use. In any of the following cases, repair is provided only at a fee.

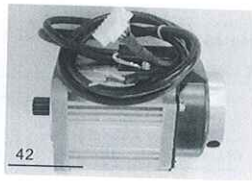
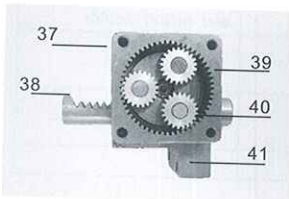
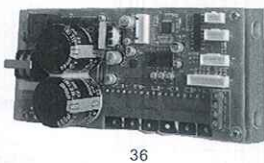
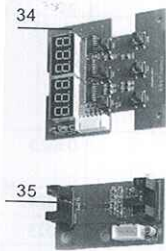
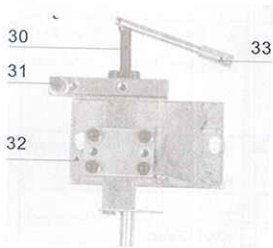
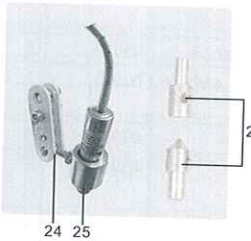
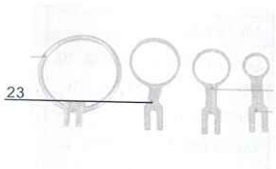
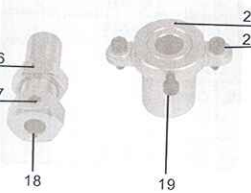
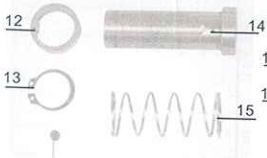
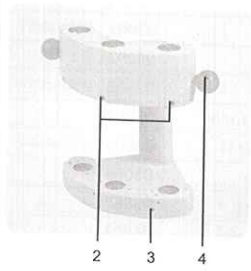
A. The product is damaged by the user's unqualified use. For example: man-made destruction, not according to machine use Explain the use, etc.

B. Failure to send or fax back the product warranty card within the required time.

C. Damage caused by unauthorized disassembly by users (including parts defect).

3. The fragile parts are guaranteed for three months. For example: rubber seals, screw, spring, die sleeve. Laser positioning lamp, auxiliary lighting lamp and other vulnerable parts.

VIII sample parts



Serial numbe	Part Name	Parts Coding	Number	Remarks
1	Machine rack	03001	1	
2	Die sleeve screw	03002	3	M6*6mm
3	turntable	03003	1	
4	Rotary Disk Ball Handle	03004	2	
5	Rotary disc bearing	03005	1	
6	Turntable top axle	03006	1	
7	Rotary disc bearing	03007	1	
8	Lower shaft of turntable	03008	1	
9	Turntable positioning pin	03009	2	
10	Location pin spring	03010	2	Φ10*26mm
11	Location pin screw	03011	2	M12*8mm
12	Die sleeve	03012	3	
13	Stamping Die Shaft Clamp Spring	03013	3	
14	Die Shaft	03014	3	
15	Die Shaft Spring	03015	3	Φ26*60mm
16	Locking nut for upper die sleeve	03016	3	
17	Locking screw for upper die	03017	3	M6*6mm
18	Upper die sleeve adjusting screw	03018	3	Customized according to user's die installation size
19	Lower die locking screw	03019	3	M4*15mm
20	Lower die sleeve	03020	3	Customized according to user's die installation size
21	Lower die sleeve fastening screw	03021	6	M4*12mm
22	Power Plug Wire	03022	1	A: Tripod Flat Plug B: European Plug C: American Plug
23	Protective ring	03023	1	Inner diameter of protective ring30mm
24	Positioning lamp bracket	03024	1	
25	Laser positioning lamp	03025	1	M5*12mm
26	3mm Punching die	03026	1	Customizable punching and button moulds
27	Protective ring connecting rod fastening screw	03027	1	
28	01 protective ring connecting rod	03028	1	
29	02 protective ring connecting	03029	1	

	rod			
30	Pullback spring	03030	1	Φ7.5*35mm
31	Protective ring fastening screw	03031	1	M5*12mm
32	Protective Ring Connection Assembly	03032	1	
33	Tension spring adjusting rod	03033	1	E:m6*80mm F:m6*50mm
34	operation panel	03034	1	
35	Photoelectric switch	03035	1	
36	Main board (868) with radiator	03036	1	
37	Internal gear	03037	1	
38	Spur gear shaft	03038	1	
39	Planetary axle	03039	1	
40	Solar Wheel	03040	1	
41	Three-head direct drive gear seat	03041	1	
42	Servo Motor (550W)	03042	1	

Be careful:

①When ordering machine parts, please indicate machine type, part code and quantity.

②When ordering parts of power supply for foreign users, please indicate the power supply voltage used by the machine.

	rod			
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