

[2014-10]

PNEUMATIC SOLE ATTACHING MACHINE



MOD:D-585C



温州德士隆科技有限公司
WENZHOU DSL TECH CO.,LTD.

机器编号: 出厂日期:

INTRODUCTION

绪 论

WENZHOU DSL TECH CO.,LTD. machines are designed and constructed in compliance with the most advanced standards to ensure performance excellence and absolute reliability.

This manual contains all the information required for correct machine installation, use and maintenance.

Read the manual carefully before carrying out any operations.

德士隆科技用最新的技术概念设计和生产机器，一保证产品的可靠性与高性能，本手册提供了正确的安装要求以及操作和维护说明。

我们建议您在开始对机器做任何操作之前，请仔细阅读本指导手册。

声明：厂家对不正确安装和使用机器所引起的人身和财产损失不负任何责任。

The pictures shown and information given in this manual are indicative only .

The manufacturer reserves the right to modify the machine for design or commercial purposes at any time without prior notification.

本手册中插图和说明完全是指导性的。

考虑到设计和市场的需要，厂家保留对机器进行改动的权力。这些都不会另行通知用户。

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1) 综述 GENERAL INFORMATION (Fig. 1)

注意：此压底机设计用于将鞋底和鞋面压合在一起。对于任何使用机器不当行为，生产厂商不负有责任。将机器用于其他任何用途都是不合理的，并且会对操作者和机器造成伤害。

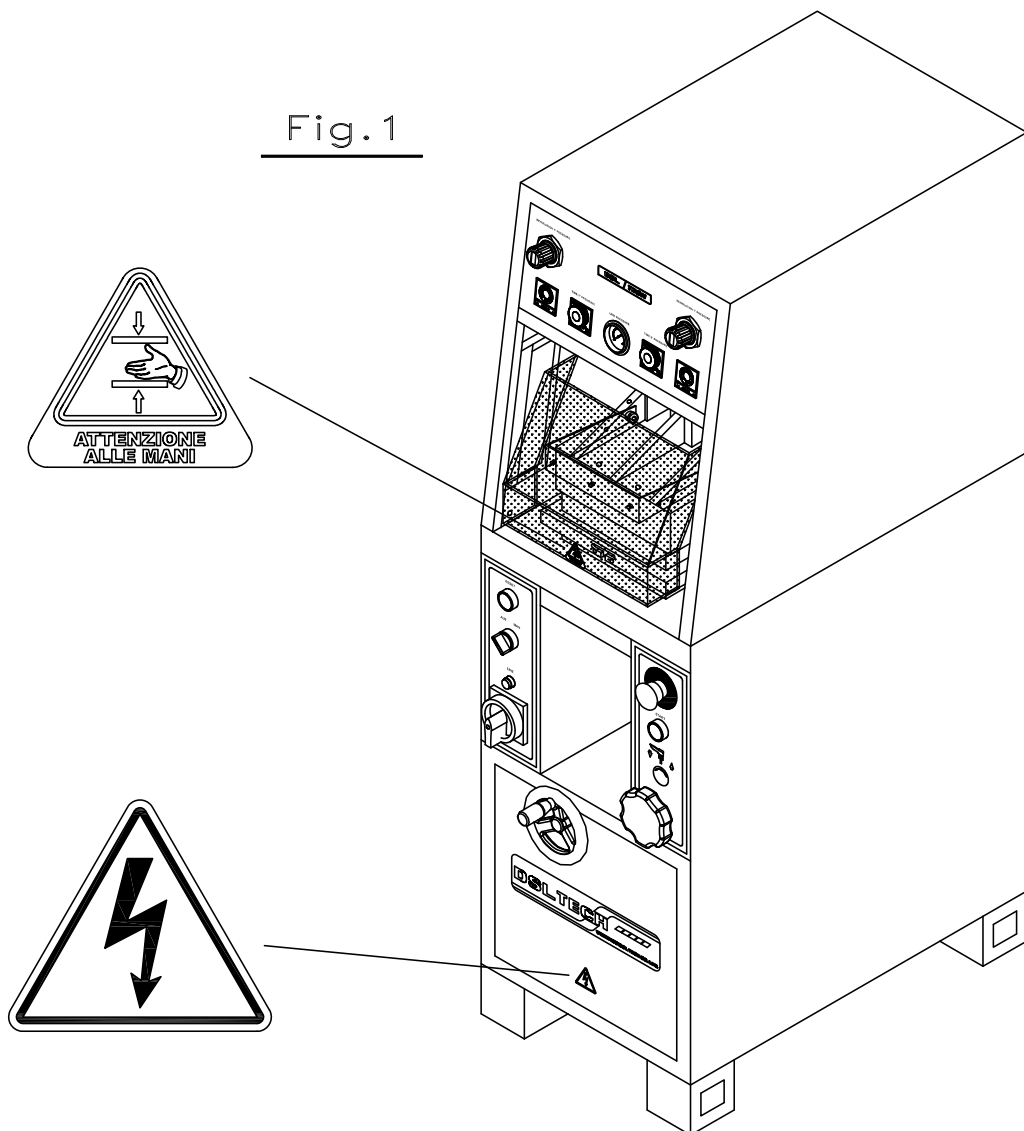
ATTENTION: The Soling Machine is designed to assemble soles and uppers. **The manufacturer declines all responsibility for any improper use of the machine.** Any other use is to be considered non-authorized and therefore dangerous for both the operator and for the operation of the machine.

操作者只需将鞋底和斜面放入机器，电子芯片会控制机器自动完成压合操作。

机器上都已经装有提示危险的标志，如图 1 所示：

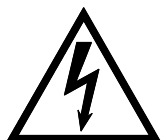
The operation of loading and unloading the sole-upper is manual. The assembly phase is managed automatically by an electronic board.

The machine is equipped with the following danger signs as shown in Fig.1:





危险：被挤压会粉碎。 **Mechanical hazard:** of getting crushed when pressing.



电路危险：操作会启动机器。 **Electrical hazard:** live machine

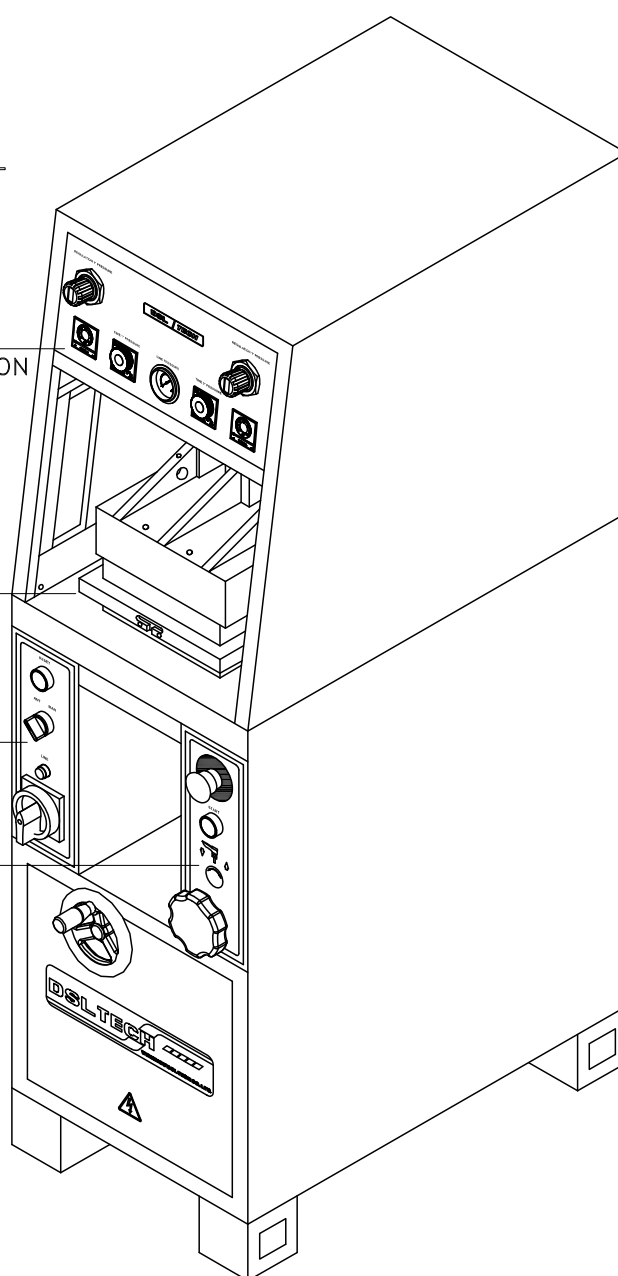
Fig.2

控制面板
PRESSURE/TIME REGULATION

鞋子的装卸台
LOAD/UNLOAD SHELF

调节面板(左)
STARTER

调节面板(右)
DRIVE



机器描述（图 2）

DESCRIPTION OF THE MACHINE (Fig.2)

在此提供一个术语表以便更好得识别为本说明书中涉及到的机器部件。

- 右侧：从机器前面看过去，右手边的这块面板。
- 左侧：从机器前面看过去，左手边的这块面板。
- 正面：控制面板。
- 后面：提供压缩空气和电流。
- 鞋子的装卸台：将鞋子嵌入进口用以压制。
- 控制面板：在机器正面的上方，面板上有控制按钮、压力表和调节旋钮。
- 调节面板：在机器正面的下方，面板上有控制按钮和调节旋钮。

图 2 显示了一些本机器的一些关键部位。

Here we give a glossary to be able to identify the machine components that will be mentioned in this manual.

- right side: panel on the right-hand side of the machine when viewed from the front;
- left side: panel on the left-hand side of the machine when viewed from the front;
- front side: control panel;
- rear side: compressed air and electricity supply;
- footwear loading-unloading deck: housing to insert the shoe to be assembled;
- control panel: pushbuttons, pressure gauges, regulators on the front side at the top;
- adjustment panel: pushbuttons and knobs on the front at the bottom of the machine.

Fig.2 shows the key areas of the Machine.

随机器提供的配件

随机器提供如下配件：

- 1 个铝制插入式固定板
- 1 套小号弹力衬垫支架
- 1 套大号弹力衬垫支架
- 1 个 n.1 嵌入式橡胶
- 1 个 n.2 嵌入式橡胶
- 1 个 n.3 嵌入式橡胶
- 1 个加厚式大号橡胶

ACCESSORIES SUPPLIED WITH THE MACHINE

The machine is provided with the following accessories:

- ✓ 1 Aluminium insert-holder plate.
- ✓ 1 Sliding pad holder assembly, small type.
- ✓ 1 Sliding pad holder assembly, large type.
- ✓ 1 Rubber insert n. 1
- ✓ 1 Rubber insert n. 2
- ✓ 1 Rubber insert n. 3
- ✓ 1 Large rubber pad, thick type

2) 机器运输 HANDLING THE MACHINE (Fig.3)

本机器需要用敞蓬叉车进行运输。

本机器重心在距离地面 100cm 高处。

注意：一旦机器重心被提高，如果没有人扶好，机器可能会发生侧倒。

- 要将本机器抬起以及放置到地面上必须要用特定的提升设备。

如果机器已经安装好需要进行搬动的，请按以下步骤进行操作：

- a) 断开空气连接。
- b) 断开电线电缆。
- c) 小心搬运机器，将机器用提供的固定配件(A)将机器固定在合适的托架上。
- d) 将托盘托起移动机器。如在搬运过程中有需要对机器进行保护的话，如(B)所示用尼龙和木板保护机器。

The machine can be handled with a forklift truck.

The machine's centre of gravity is approximately 100 cm off the bearing surface.

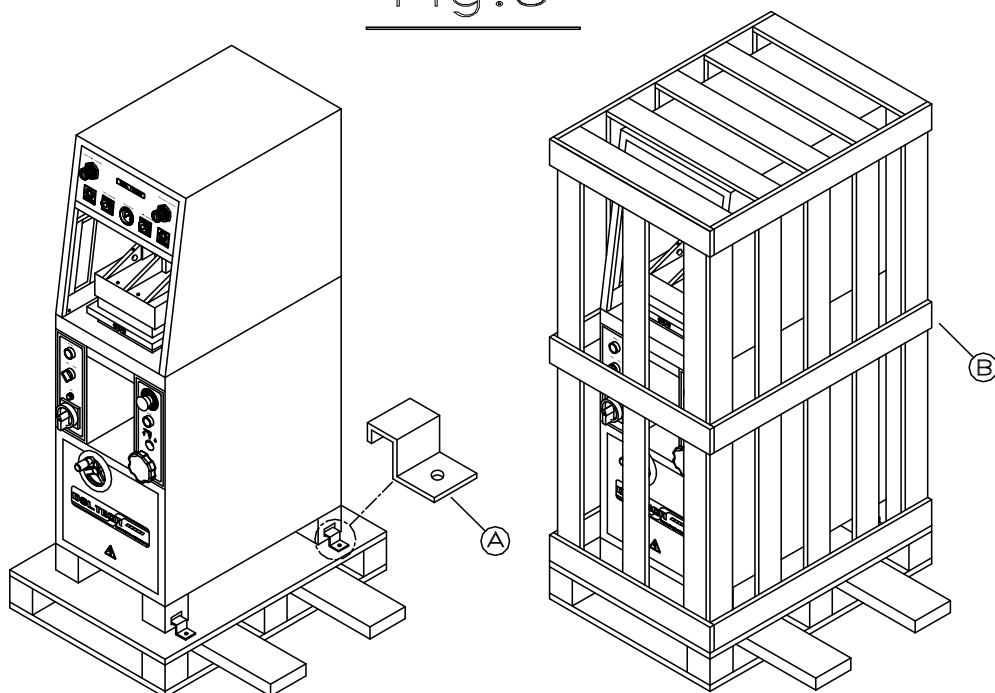
Attention: Since the machine's centre of gravity is high up, it could cause the machine to tip over if it is not handled with care.

- Raise the machine and put it down on the floor using specific lifting equipment.

If the machine is to be moved after it has already been installed, proceed as follows:

- a) Disconnect the air connection.
- b) Disconnect the electric cable.
- c) Move the machine carefully; place it on a suitable pallet and secure it with the brackets (A) supplied.
- d) Lift the pallet with the machine and move it. If it is necessary to protect the machine during transport, use nylon and a wooden cage (B).

Fig.3



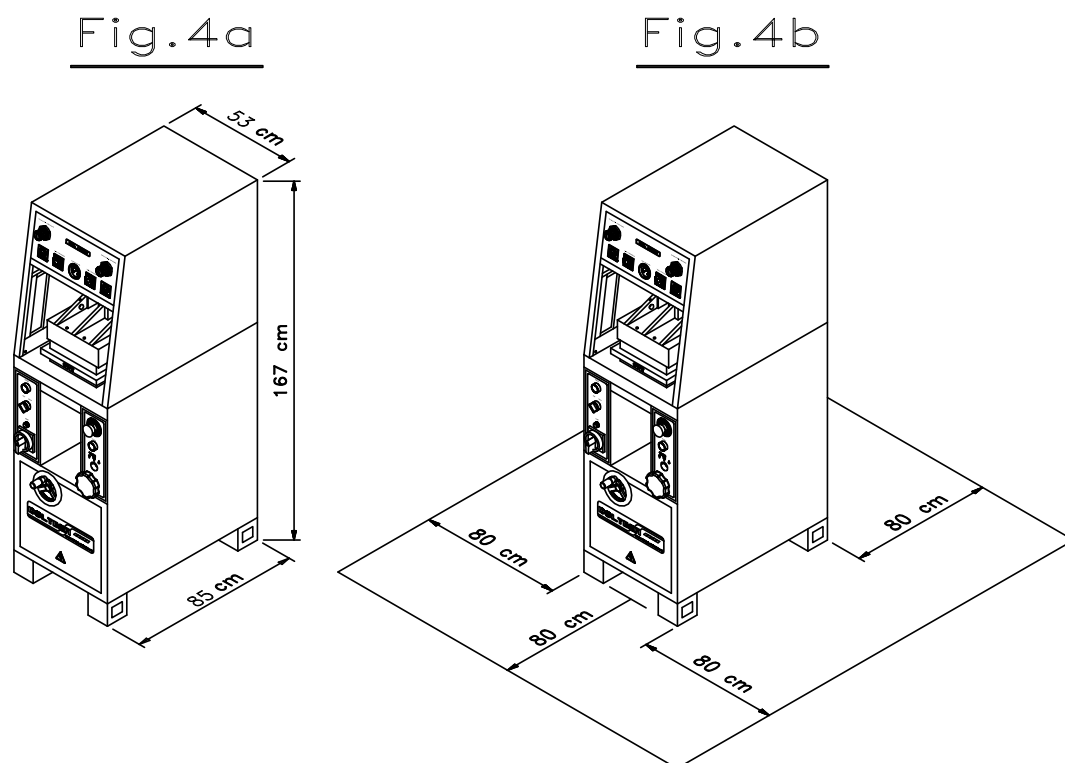
3) 机器外型尺寸与放置要求 (图 4a-4b)

MACHINE OVERALL DIMENSIONS AND POSITIONING (Fig. 4 a – 4 b)

机器所放置的地面必须能承受机器的重量；地面必须平整，能对机器提供稳定的支持。
在机器四周要留出大约 80cm 的空间作为通道。(图 4b)

The supporting surface must be able to withstand the weight of the machine; it must be flat and even so as to ensure a stable support.

Leave a clear space of approximately 80 cm. to the side of the machine to provide access to the sides (Fig.4 b).



4) 准备工作 PRELIMINARY OPERATIONS

- 1) 必须要有专职人员操作这台机器，以免发生意外。
- 2) 安全起见，为避免模板损坏，不要在机器里面或者上面插入或放置任何尖利的物品。
- 3) 检查气管承受压（推荐使用 7bar）
- 4) 检查电路和压缩气体的连接是否正确并符合标准。

- 1) It is important for the machine operator to have only one job so as to avoid any possible accidents.
- 2) For safety, in the event of the diaphragm breaking, do not insert or put any sharp objects into or on the machine.
- 3) Check the line pressure (7 bar recommended).
- 4) Check that the connections to the electricity and compressed air systems have been made in compliance with current standards.

5) 电-气路连接 ELECTRICAL - PNEUMATIC CONNECTIONS

电路连接（图 5） ELECTRICAL CONNECTION (Fig. 5)

- 由于不兼容的缘故，本机器提供的电源线不带插头。
- 将脸部与工作区域保持安全的距离，以免发生意外。
- 当机器运行的时候，机箱是可以打开的。如果发现机箱是开着的，必须立刻切断电路和压缩气体的供应，以免发生危险。

在进行电路连接之前，请确认电线电压符合图表的数据牌上所标示（图 5）。

将机器的电源线（2 条电线+地线）连接到主电源上。机器必须接到一个有效的接地线上，必须遵守电工安全规范接线。

在开始接线之前，请将主开关关闭，转至 0-OFF（图 5）。

- Due to incompatibility, the machine is supplied without the plug fitted on the power line.
- It is important to keep your face at a safe distance from the work zone.
- The machine's casings can be opened while the machine is running. If they are opened it is vital to disconnect the compressed air and electricity supply first.

Before making the electrical connection, check that the line voltage corresponds to the voltage stated on the machine's data plate (Fig.5).

Connect the machine's power cable (2 wires + earth) to the electric mains supply. The machine must be connected to an efficient earth socket. Always observe relevant electrical safety regulations.

Before connecting, turn the main switch onto 0-OFF (Fig.5).

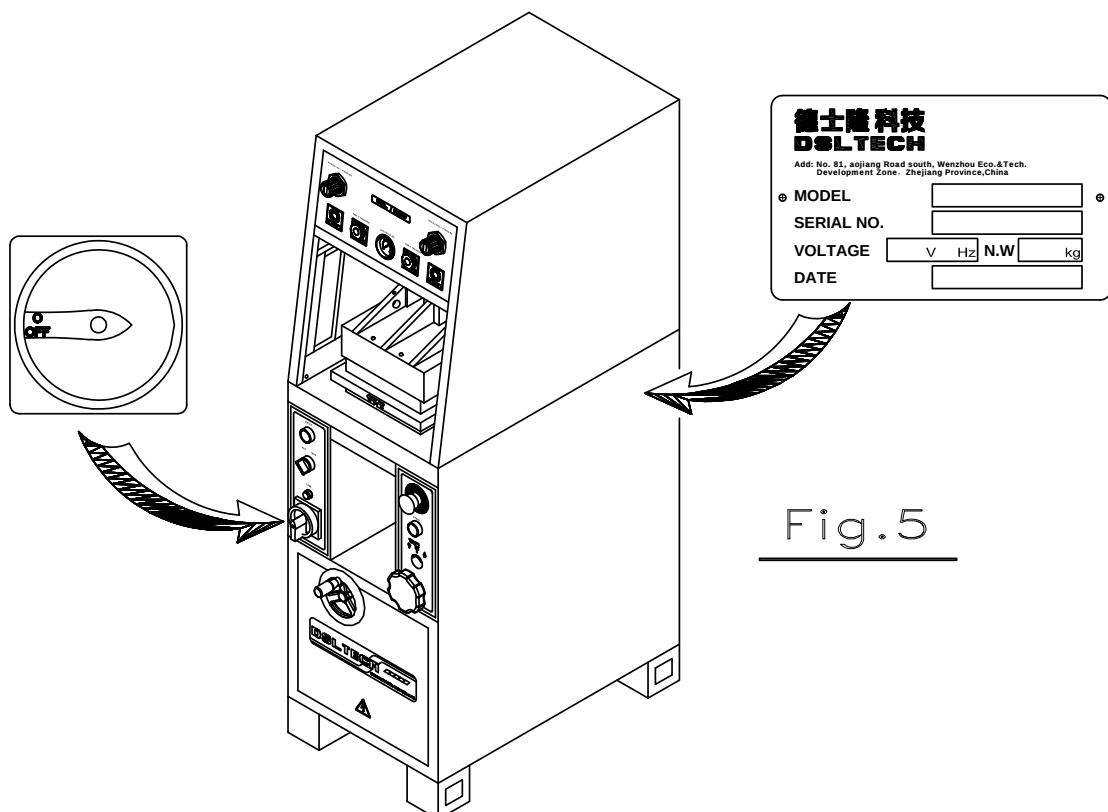


Fig.5

气路连接（图 6） PNEUMATIC CONNECTION (Fig. 6)

- 气路必须正确连接，并且要先确认跟机器特有的系统相兼容。
- **The pneumatic connection must be made correctly, after checking the compatibility of the machine with the characteristics of the system.**

连接气路之前，请将主开关关闭，转至 0-OFF（图 6）。空气的最大压强为 8 bar，将主管道连接到机器后部的总接口（A）：这个管子已经过鉴定可承受最大的气压为 10 bar，内壁最小直径为 8 mm（图 6）。

Before connecting, turn the main switch onto 0-OFF (Fig.6). The maximum mains pressure is 8 bar; connect the mains pipe to the union (A) on the rear side of the machine: this pipe is type-approved for a maximum pressure of 10 bar and a minimum inside diameter of 8 mm (Fig.6).

由于电路气路的违规连接而造成的一切后果，德士隆科技不负有任何责任。

WENZHOU DSL TECH Co., Ltd. declines all responsibility deriving from non-observance of the current regulations for electrical and pneumatic connections.

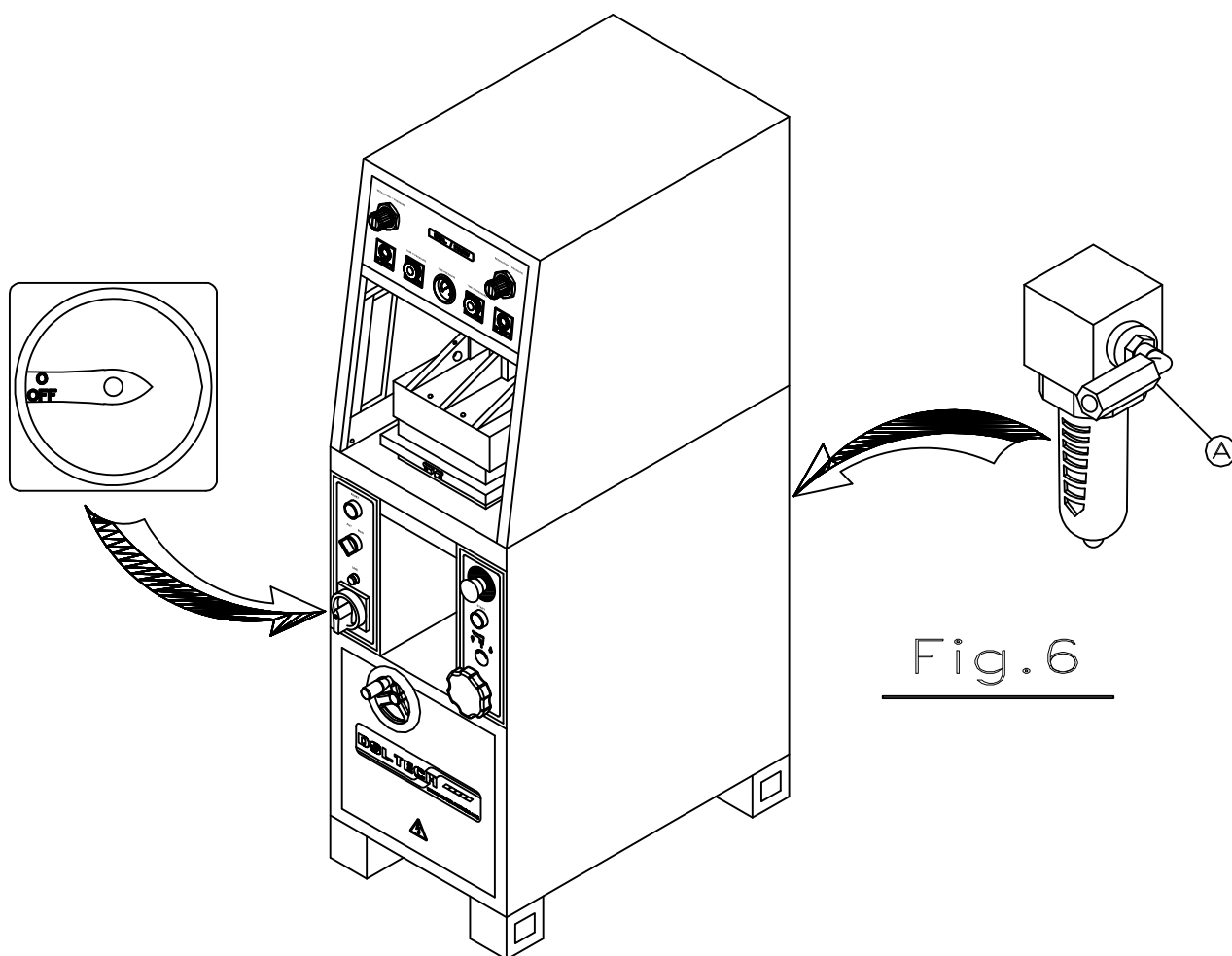


Fig.6

6) 操作步骤 OPERATION

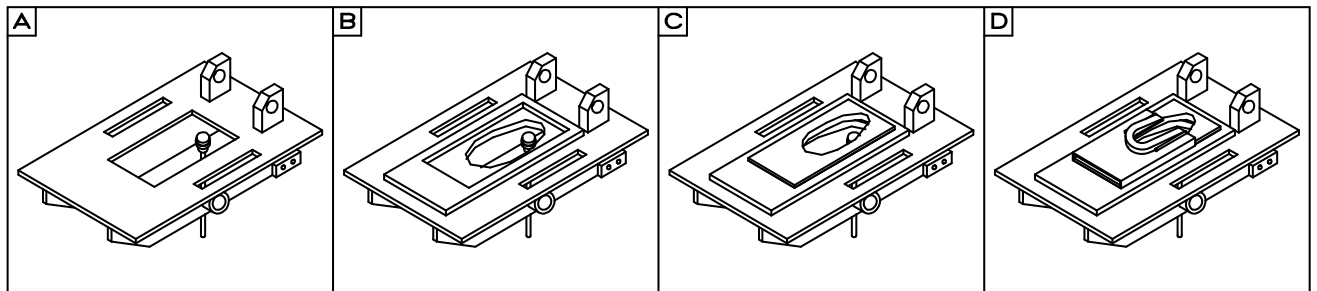
先按照第 4 点对机器进行初步检查，然后按照以下步骤操作：

- a) 将主开关打开，旋开至 1-ON，见 12 页（9）。
- b) 按下启动开关，见 12 页（6）。
- c) 设置 AUT-MAN 选项，选 MAN，见 12（7）。
- d) 按照 12（1）在调节面板上调整第一压强至推荐压强 4 bar。
- e) 按照 12 页（3）将第一次加压时间设置为 10''。
- f) 按照 12 页（2）在调节面板上将第二压调整至推荐压强 5 bar。
- g) 按照 12 页（5）将第二次加压时间设置为 10''。
- h) 按照 12 页（12）将突起的调节杆（用于发现鞋子）逆时针旋转。
- i) 如图 7 所示，在机器内有一凹陷处（A），安装一铝制金属板（B），上面覆盖一嵌入橡胶（C），用一固定衬垫固定（D）。

Make the preliminary checks (chap.4) and proceed as stated here:

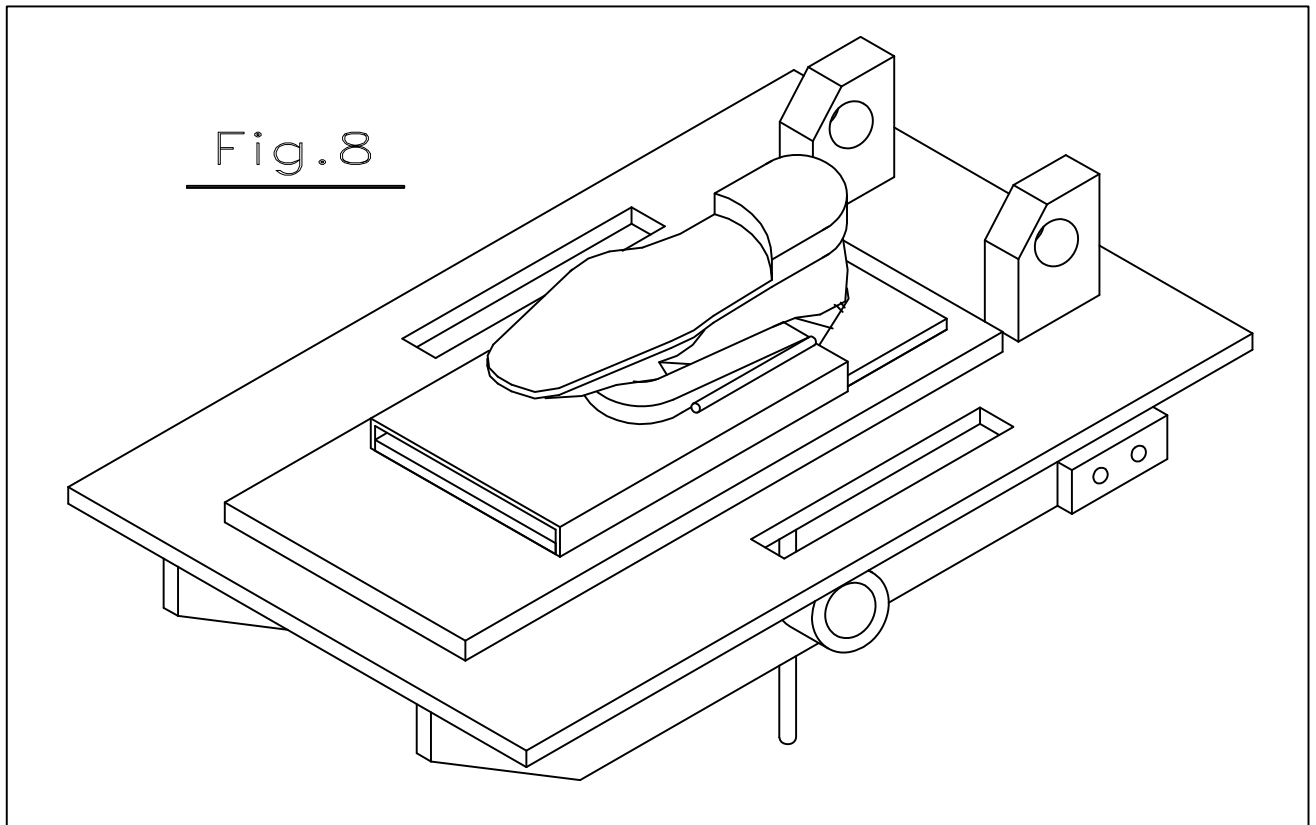
- a) Switch on the machine by turning the main switch, see 9 page12, onto 1-on;
- b) Press the reset button, see 6 page12;
- c) Set the AUT-MAN selector, see 7 page12 onto MAN;
- d) Adjust the 1st pressure using the regulator 1 page12 of the adjustment panel on the recommended position of 4 bar
- e) Set the 1st pressure time on the recommended setting of 10'', see 3 page12;
- f) Adjust the 2nd pressure using the regulator 2 page12 of the adjustment panel on the recommended position of 5 bar
- g) Set the 2nd pressure time on the recommended setting of 10'', see 5 page12;
- h) Turn the adjustment knob (that detects shoes) anticlockwise, see 12 page12.
- i) See Fig.7, in the machine recess (A), install the aluminium plate (B), and the rubber insert (C), with the pad holder (D).

Fig.7



检查 CHECK:

- 在内嵌的橡胶和鞋之间必须没有空隙，如果有，请重新放置嵌入的橡胶。
- 请将固定衬垫（如图 8）插入鞋子的下方并检查鞋子与金属板是否平行。
- **Between the rubber insert and the shoe there must be no gaps. If this is not so, replace the rubber insert.**
- **Put the pad holder (Fig.8) under the shoe and check that the sole is parallel to the plate.**



- 转动调节器，见 12（12），顺时针转动直到启动按钮亮起，见 12 页（11）。
- **Turn the shoe detection knob, see 12 page12 clockwise until the start button, see 11 page12 lights up.**

现在机器已经可以开始运转了。

The machine is ready for its work cycle.

机器运转 WORK CYCLE FUNCTIONS

本机器可以分手动和自动两种运转模式。

The machine can work in MANUAL or AUTOMATIC mode.

手动模式 MANUAL MODE

- 设置 AUT-MAN 选项，选 MAN，见 12 页（7）。
- 搭配鞋底和鞋面，将它们分别放入各自的位置。
- 确认鞋面和凹陷的橡胶之间没有空隙，以免损坏橡胶。
- 按下启动按钮，见 12（11）。
- 等待铃声响起，仓门完全打开，将鞋子卸下。
- **Check that the AUT-MAN selector, see 7 page12 is on MAN.**
- **Join the sole and upper, and put them in the work zone.**
- **Check that there are no gaps between the upper and the rubber insert to prevent breakage of the rubber.**
- **Press the START button, see 11 page12**
- **Wait for the bell to open completely before unloading the assembled shoe.**

自动模式 AUTOMATIC MODE

- 设置 AUT-MAN 选项，选 AUT，见 12（7）。
- 搭配鞋底和鞋面，将它们分别放入各自的位置。
- 确认鞋面和凹陷的橡胶之间没有空隙，以免损坏橡胶。
- 一旦操作者的手离开工作仓，传感器将检测出工作仓中没有其他东西，启动运转机器。
- 等待铃声响起，仓门完全打开，将鞋子卸下。
- **Check that the AUT-MAN selector, see 7 page 12 is on AUT.**
- **Join the sole and upper, and put them in the work zone.**
- **Check that there are no gaps between the upper and the rubber insert to prevent breakage of the rubber.**
- **As soon as you remove your hands from the work zone, the sensor will detect nothing in the work area and will start up the work cycle.**
- **Wait for the bell to open completely before unloading the assembled shoe.**

7) 控制装置功能（图 9） CONTROL DEVICE OPERATION (Fig.9)

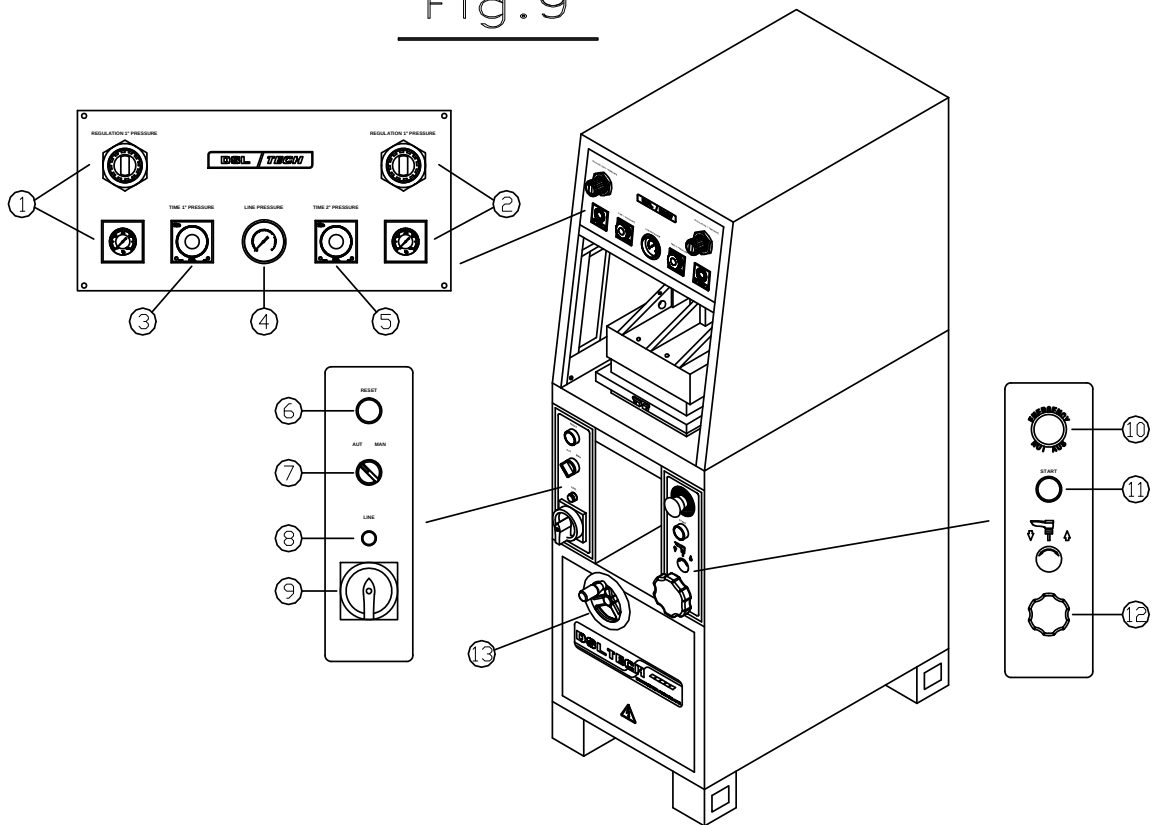
控制装置具体如下：

- 压强调节器 1（1）：调压表用以调节第一次压底时的压强。
- 定时器 1（3）：调节齿轮 1，可将压制时间调整为 0-30''。
- 压强调节器 2（2）：调压表用以调节第二次压底时的压强。
- 定时器 2（5）：调节齿轮 2，可将压制时间调整为 0-30''。
- 管道气压压强表（4）：用于测量管道中提供的压缩气体的压强。
- 紧急按钮（10）：红色蘑菇头制动按钮。
- AUT-MAN（7）：选择机器的手动或者自动运行模式。
- 重置按钮（6）：绿色指示按钮用于机器重新设置并开始运行。
- 电源主开关（9）：用于机器电源的开和关，其指示灯（8）亮起则表示电源接通。
- 启动按钮（11）：绿色指示按钮用于启动机器运行并检验鞋子是否正确嵌入压底仓。
- 调节手轮（12），调整鞋子在压底仓中的位置。
- 手轮（13），用于调节压制方式。

The control panel contains:

- 1st pressure adjustment (1): pressure regulator with pressure gauge for the 1st pressing station.
- 1st pressure time (3): timer adjustable up to 30'' to adjust the pressure set on the reduction gear (1).
- 2nd pressure adjustment (2): pressure regulator with pressure gauge for the 2nd pressing station.
- 2nd pressure time (5): timer adjustable up to 30'' to adjust the pressure set on the reduction gear (2).
- line pressure (4): pressure gauge indicating the pressure of the compressed air supply.
- emergency (10): red mushroom-head detent button.
- AUT-MAN (7): selector to set the cycle mode on automatic or manual.
- reset (6): luminous green button to reset the machine and start the cycle.
- main switch (9): to switch the machine on and off, with its indicator light (8) signalling power on.
- start (11): luminous green button to start the cycle and check the shoe is correctly inserted in the housing.
- rod knob (12): regulator for positioning the shoe in the housing.
- handle (13) of regulation run of press.

Fig.9



8) 保养 MAINTENANCE PROCEDURES

所有的保养工作开始之前，必须确认关闭主电源开关，并且切断电流供应。

All maintenance operations must be performed with the machine switched off and disconnected from the power supply.

日保养：推荐每天工作结束后对机器进行清理。

Every day: it is recommended to clean the machine after work.

替换第一次和第二次压力的隔膜（图 10）

REPLACING FIRST AND SECOND PRESSING DIAPHRAGMS (Fig. 10)

准备工作：

- 关闭机器，将主开关旋至 0=OFF。（见 14 页图 10）
- 切断机器的供电和供气线路。
- 松开图 10 所示 2 颗螺丝（1）。
- 打开上盖。

Preliminary operations:

- Switch off the machine, turning the main switch (ref.10 page 14) onto 0=OFF.
- Disconnect the machine from the electric and pneumatic mains.
- Undo the 2 screws (1) Fig.10.
- Open the top cover.

第一压力隔膜更换步骤:

- 用套索将压底仓罩上提。
- 用随机提供的扳手，松开图 10 中的结构（2）上的螺丝。
- 打开结构（2），取出隔膜。
- 彻底清洁第二个压力仓。
- 放置好新的隔膜。
- 用螺丝将结构（2）固定安装。

Procedure to replace the first pressure diaphragm:

- Raise the bell, using the toggle.
- Using the wrench supplied with the machine, undo the screws of the frame (2) Fig.10.
- Take off the frame and remove the diaphragm.
- Thoroughly clean the second pressure chamber.
- Secure the new diaphragm.
- Secure the frame with its screws.

第二压力隔膜更换步骤:

- 切断压缩空气管
- 用随机提供的扳手，松开图 10 中的结构（2）上的螺丝。
- 彻底清洁第二个压力仓。
- 放置好新的隔膜。
- 用螺丝将结构（2）固定安装。
- 重新接好压缩空气管。

Procedure to replace the second pressure diaphragm:

- Disconnect the air pressure pipe.
- Using the wrench supplied with the machine, undo the screws of the frame (2) Fig.10.
- Thoroughly clean the second pressure chamber.
- Secure the new diaphragm.
- Secure the frame with its screws.
- Reconnect the air pressure pipe.

结束工作:

- 盖拢上盖。
- 拧紧图 10 所示 2 颗螺丝（1）
- 重新接好机器的供电和供气线路。
- 打开电源主开关开始运做。

Concluding operations.

- Close the top cover.
- Screw on the 2 screws (1) Fig.10.
- Reconnect the machine to the electric and pneumatic mains.
- Switch on the machine and start the cycle.

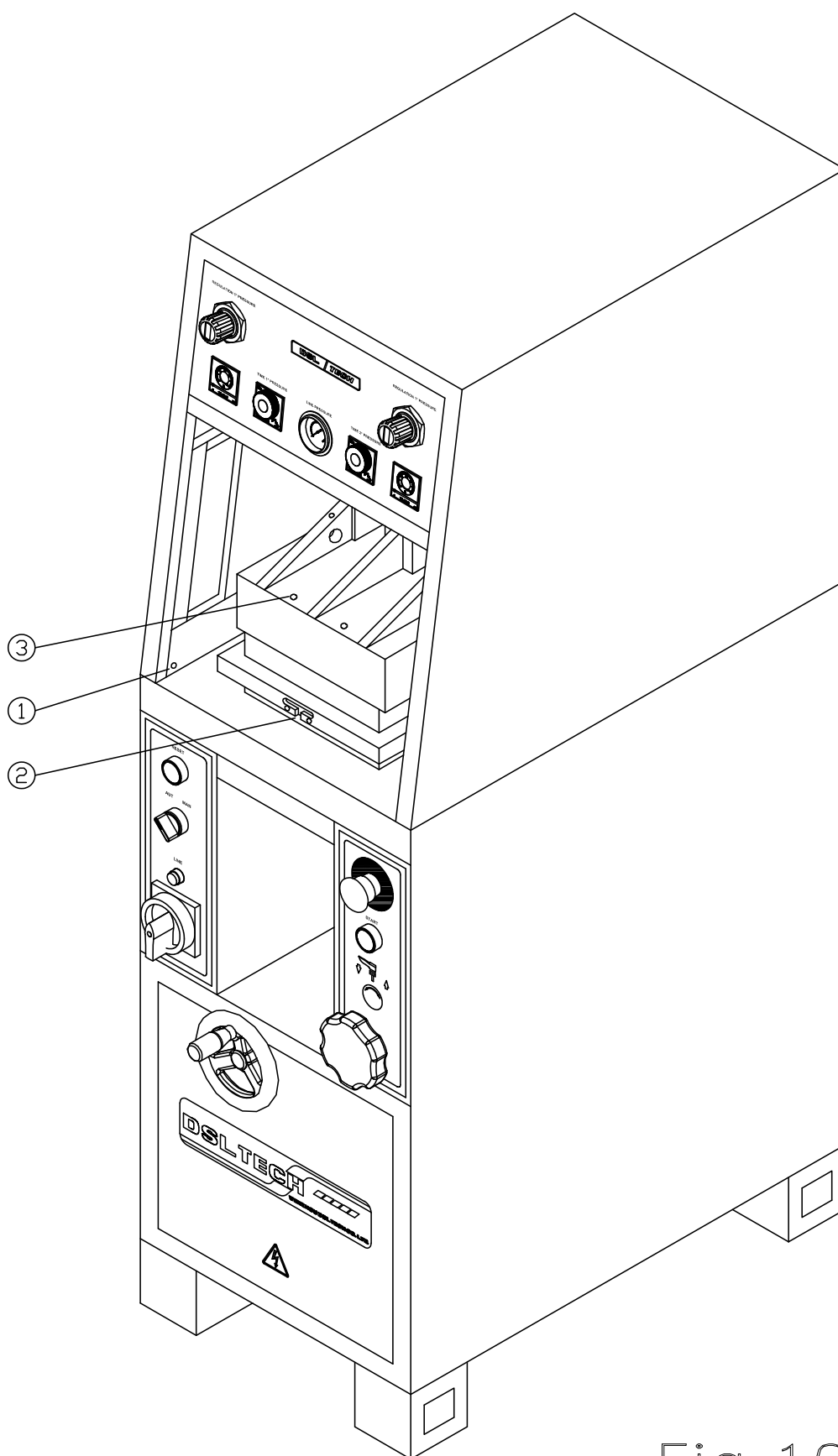


Fig.10

9) 常见问题与解决方法 TROUBLESHOOTING

PROBLEM 问题	CAUSE 原因	REMEDY 解决方法
当机器的主电源开关旋至位置“1”，机器的电源指示灯不亮。 When the main switch is in position “1”, the power indicator light on the machine fails to illuminate.	- R1 保险丝有问题 - S1 保险丝有问题 - 02 保险丝有问题 - Faulty fuse R1 - Faulty fuse S1 - Faulty fuse 02	- 更换保险丝 - Renew the fuses
按下“重置”按钮，机器开关无法开启。 On pressing the “reset” button the machine fails to switch on.	- 无电源供应 - 左侧的保护性微动开关有问题 (05 线) - 保护外套开启 - No supply - Left casing microswitch faulty (wire 05) - Casing open	- 检查供应电源的保险丝和电压 - 重新更换微动开关 - Check the supply fuse and voltage - Renew the microswitch
按下“重置”按钮，机器开关开启，但松开后按钮又关闭。 On pressing the “reset” button the machine switches on, but switches off when it is released.	- 电源供应不正确 - 电流接触器不合适 - Incorrect power supply - Faulty contactor	- 检查供应电源电压 - 更换电流接触器 - Check the supply voltage from the line - Renew the contactor
电源正常供应并且开启重置按钮，机器没有吸力。 The machine makes no suction even though it is powered and the “reset” button is on.	- 保险丝 S3 有问题 - 保险丝 02 有问题 - Faulty fuse S3 - Faulty fuse 02	- 更换保险丝 - Renew the fuses
警告铃声一直响没有停顿 Bell suction continues without stopping.	- 紧急按钮出错或者被按下 - 微动开关防护装置出错 (04 线) - Emergency button faulty or pressed - Perspex guard microswitch faulty (wire 4)	- 更换紧急按钮，如果开关只是被按下，只需松开开关即可 - 更换有机开关防护装置 - Renew the emergency button or release it if it is pressed - Renew the guard microswitch
无论机器是在自动或者手动模式下，将鞋子插入后，开启机器的指示灯一直不亮。 Whether the machine is in automatic or manual mode, after inserting the shoe, the start indicator light fails to come on.	- 调节杆弹簧坏了 - 传感器出错 - 按钮的指示灯坏了 - S3 保险丝有问题 - Column spring broken - Faulty sensor - Faulty button lamp - Blown fuse S3	- 更换弹簧 - 更换传感器 - 更换指示灯 - 更换 S3 保险丝 - Renew the spring - Renew the sensor - Renew the lamp - Renew the fuse S3

PROBLEM <i>问题</i>	CAUSE <i>原因</i>	REMEDY <i>解决方法</i>
压底仓罩在盖下后立即上升 The bell rises up immediately after coming down.	- 时间设置为 T=0 - 鞋子传感器被覆盖 - RH 轮微动开关出错（5 线）或者设置得太远 - Timers set to T=0 - Shoe sensor blind - RH wheel microswitch faulty (wire 5) or set too far back	- 调整时间设置 - 当压底仓罩盖下时，检查传感器是否被鞋子覆盖了 - 将微动开关轮拿近，如果轮子坏了就重新更换。 - Adjust the timers - When the bell is coming down, check that the shoe does not make the sensor blind - Move the wheel microswitch nearer to the operator or renew it if faulty
压底仓罩盖下，但是不压底 The bell comes down but does not press.	- 右手边用来关闭仓罩压底的微动开关按钮不正确或损坏。 - Right-hand button microswitch for closing the bell not pressed correctly or faulty	更换微动开关（6 线）或者检查操作人员是否错误操作仓罩的控制杆 Renew the microswitch (wire 6) or make sure that the bell levers do not interfere with its operation
压底完成后，仓罩不上抬。 The bell fails to rise once the press cycle has ended.	- 两根真空管其中一根出现故障导致仓罩内仍有压强 - 压底按钮出错 - Pressure remains in the bell diaphragms due to malfunctioning of one of the two vacuum valves - Faulty pressure switch	- 更换真空管 - 更换压底按钮 - Renew the vacuum valve - Renew the pressure switch

10)配件定货指导 ORDERING SPARE PARTS

为了使备用件能及时到货，请按照下列内容提示：

- 零件的数量
- 以下图表列的部件代码
- 机器型号
- 机器序列号和机器电压等级

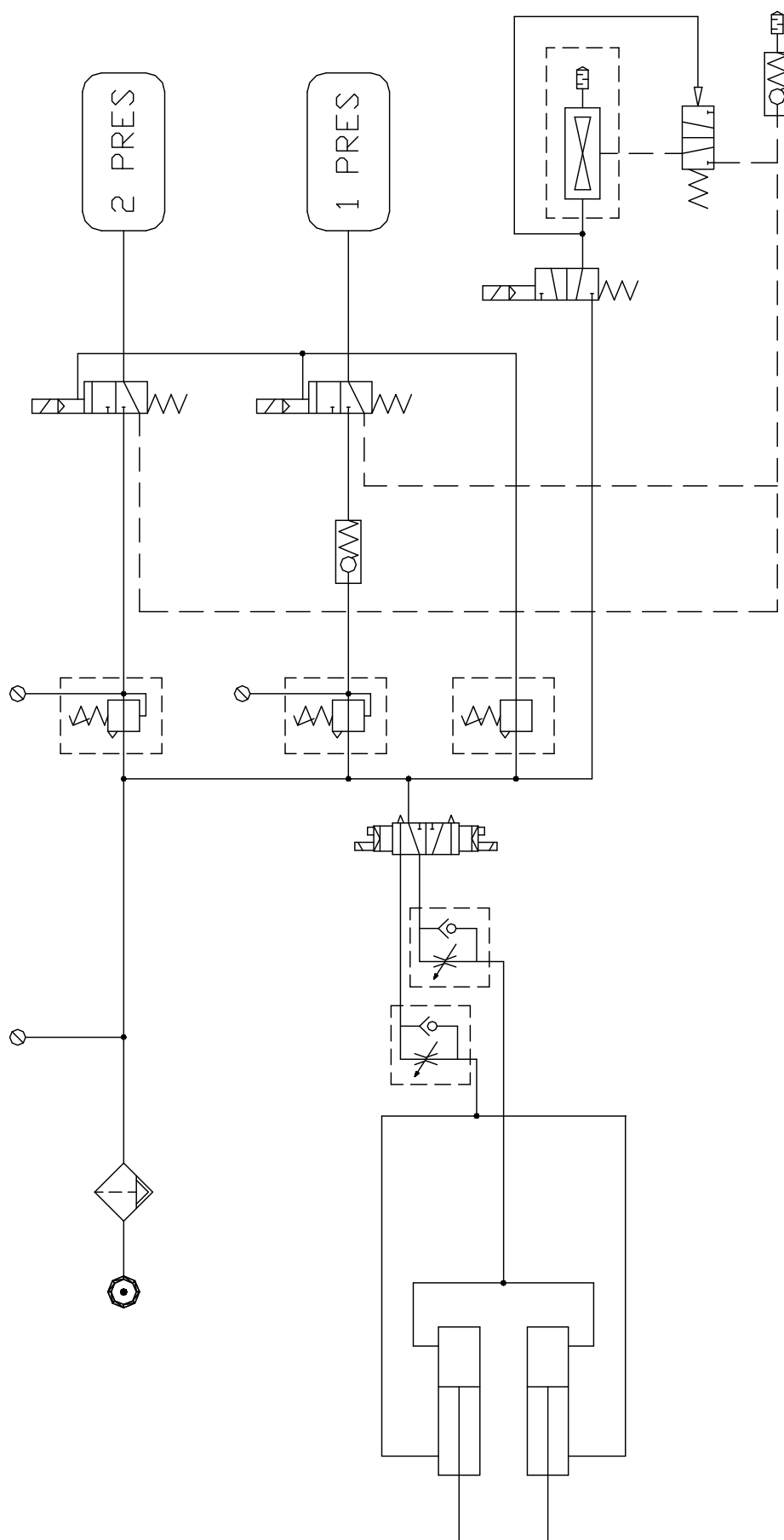
For prompt delivery of spare parts, the following information is required:

- Quantity of pieces;
- Piece identification code, marked on the following tables;
- Machine model;
- Serial number and voltage of the machine.

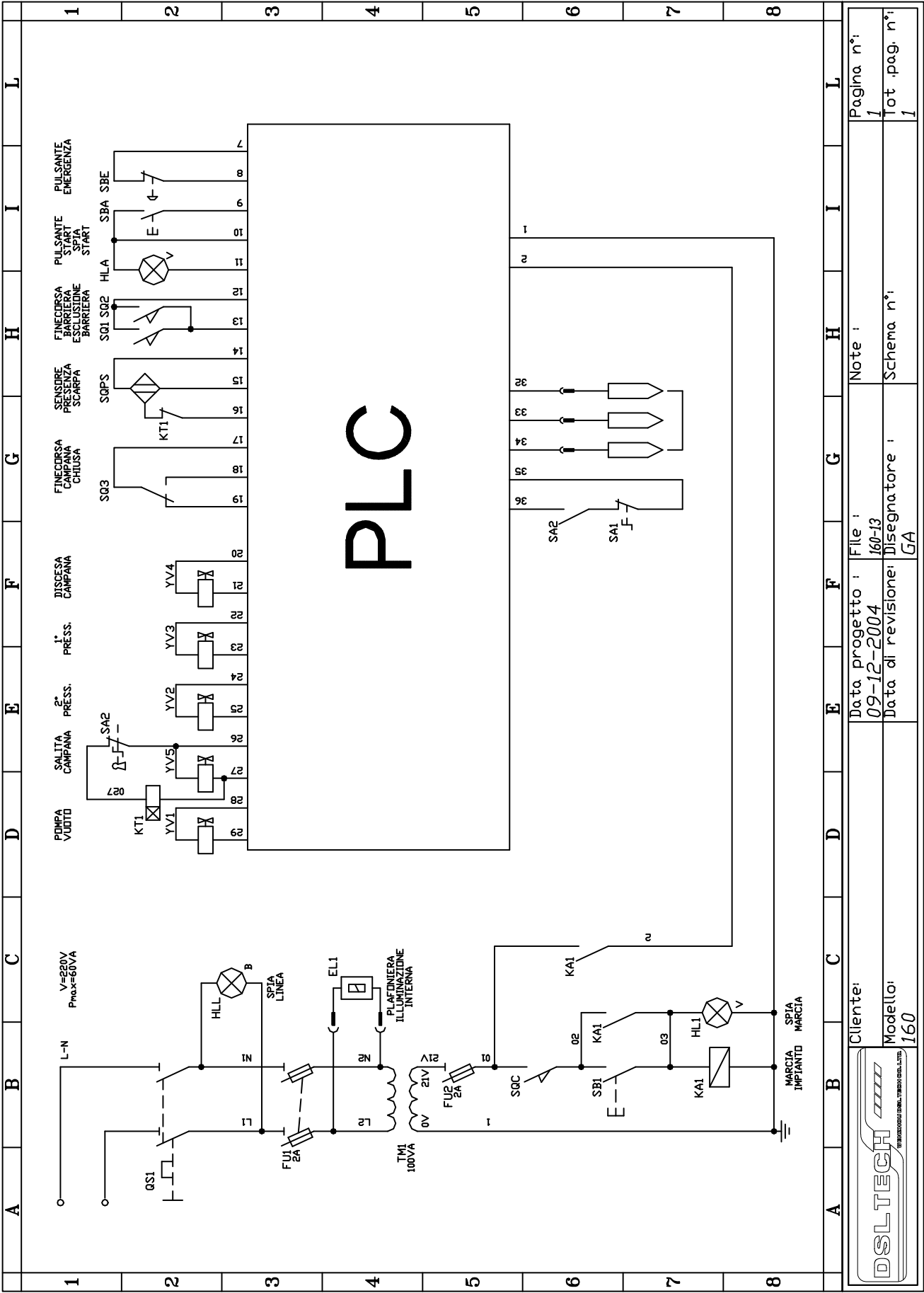
11) 机器规格 MACHINE SPECIFICATIONS

description 描述	values 规格
总功率 Total power	0.15 kW
净重 Net weight	240 kg
毛重 Gross weight with crate	330 kg
尺寸 Dimensions:	
长 Depth	90cm
宽 Width	50cm
高 Height	168cm
7 bar 压缩空气消耗量 Compressed air consumption 7 bar	55 NL/min

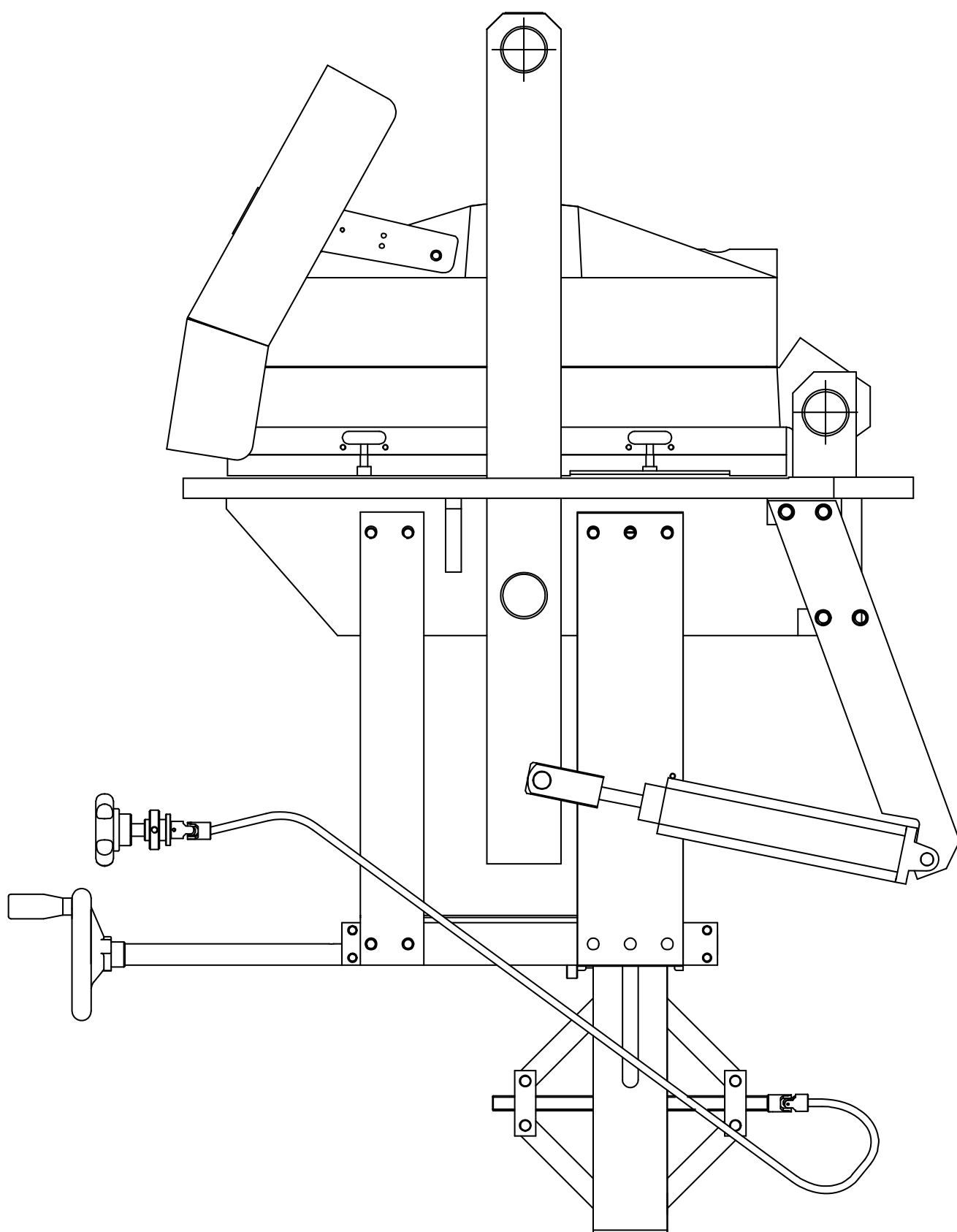
12) 气路连接 PNEUMATIC DIAGRAM



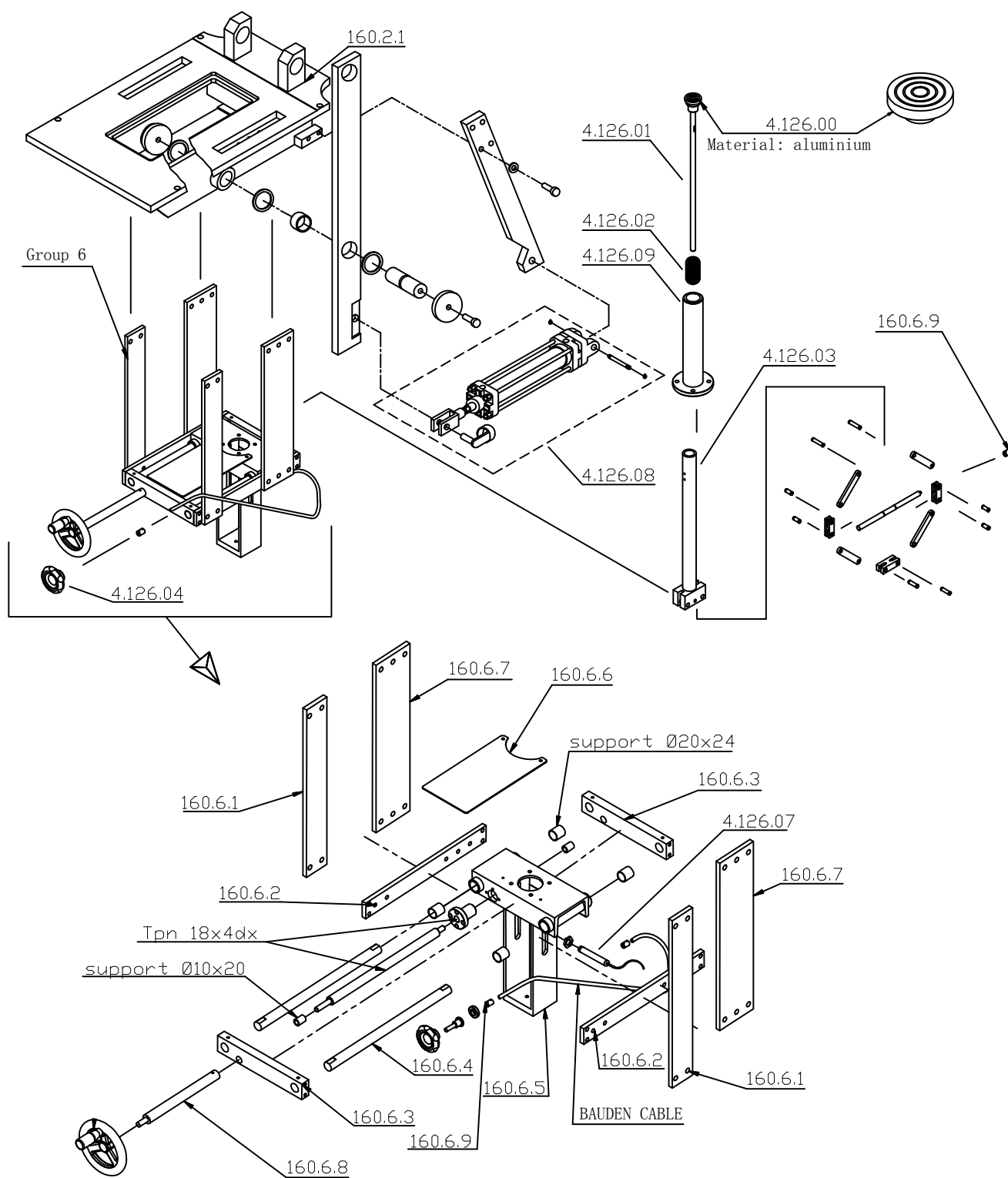
13) 配线图 WIRING DIAGRAM



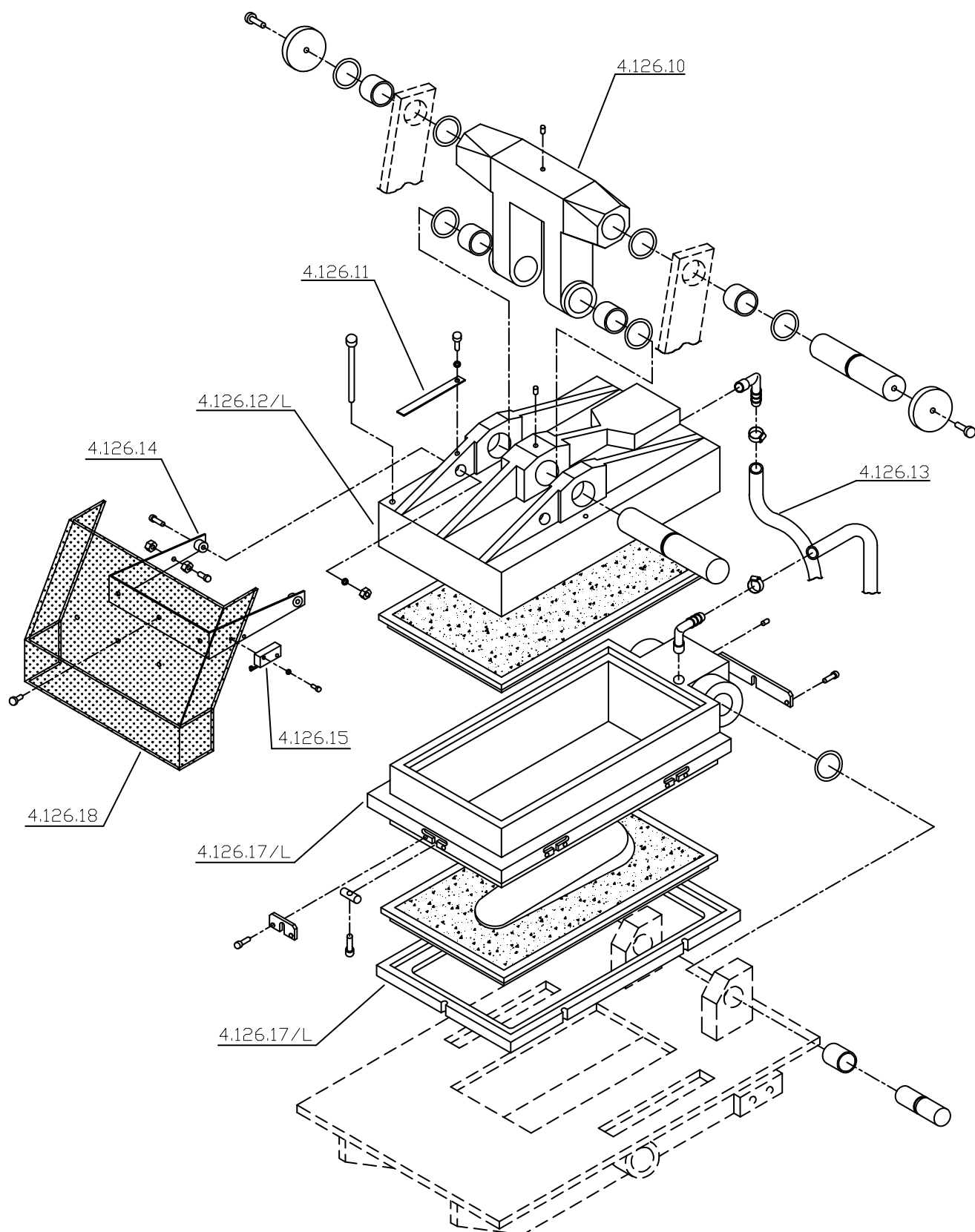
14) 配件图 SPARE PARTS TABLES



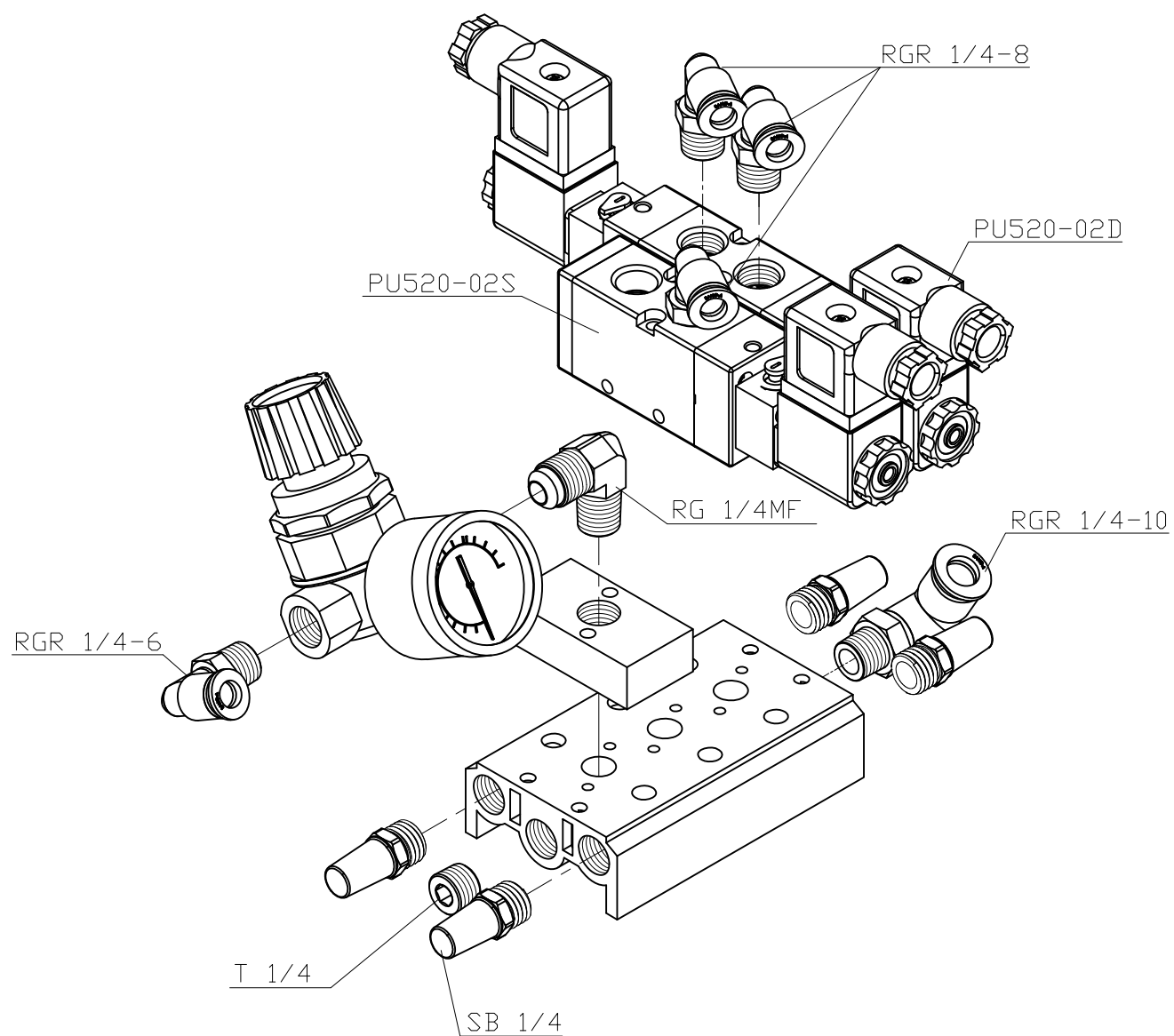
14) 配件图 SPARE PARTS TABLES



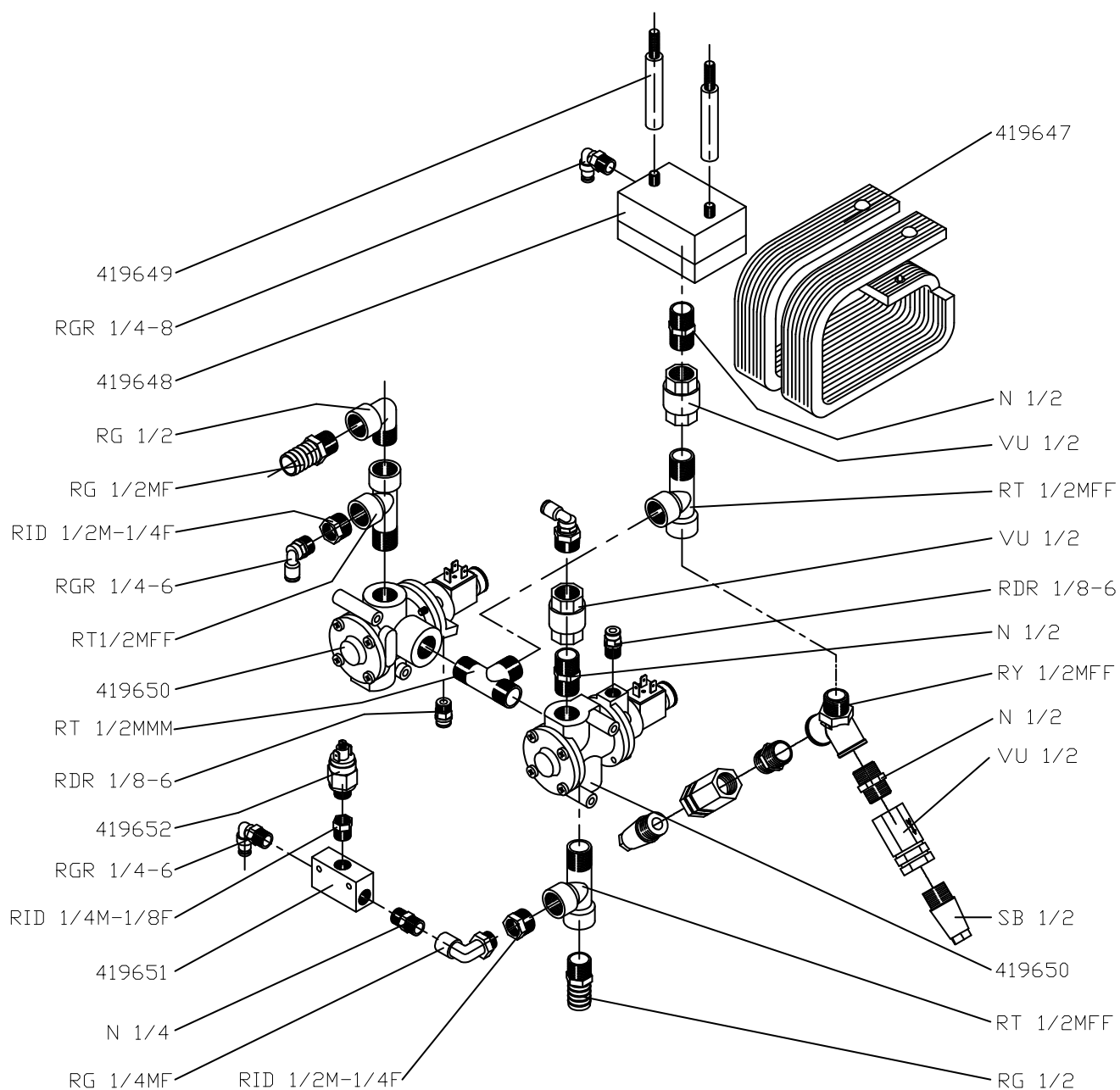
14) 配件图 SPARE PARTS TABLES



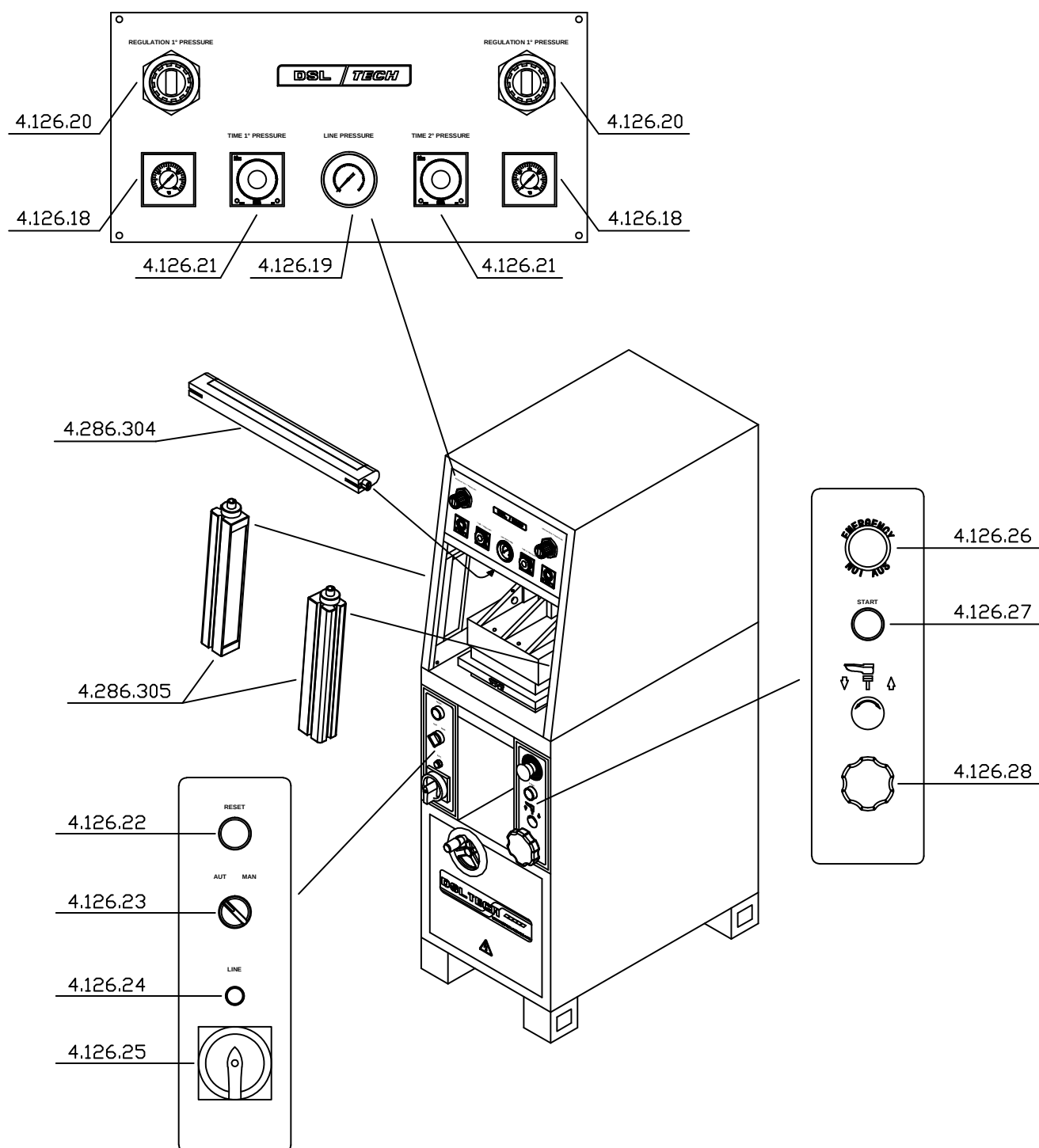
14) SPARE PARTS TABLES



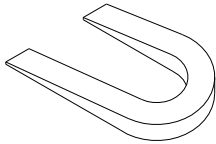
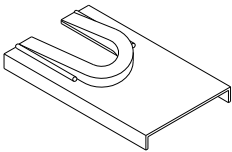
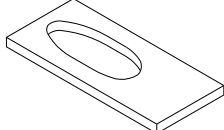
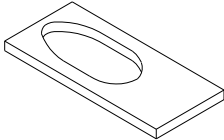
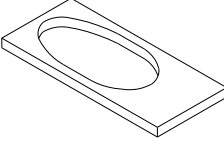
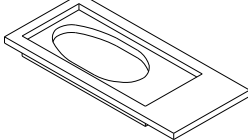
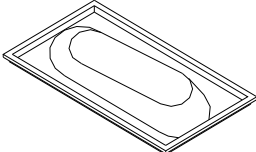
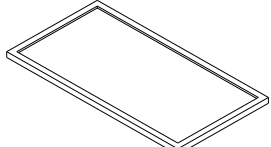
14)配件图 SPARE PARTS TABLES



14) SPARE PARTS TABLES



14)配件图 SPARE PARTS TABLES

	小衬垫 Small Pad 6438 大衬垫 Large Pad 6437 鞋面大衬垫Upper Large Pad 8279
	带托盘小衬垫 Small Pad With Plate 6395 带托盘大衬垫 Large Pad With Plate 6396 带托盘鞋面大衬垫 Upper Large Pad With Plate 6397
	内嵌式橡胶Rubber Insert Num. 29-35 4550
	内嵌式橡胶Rubber Insert Num. 36-41 4551
	内嵌式橡胶Rubber Insert Num. 42-46 4552
	支撑板 Plate Support 6401
	第一次压制突起橡胶配件 1st pressure convex rubber part 6402/L
	第二次压制橡胶配件 2nd PRESSURE RUBBER PART 6409/L