

KL—V6、 V9 SHAFT SLOTTING MACHINE

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ZHEJIANG KANGLI PLASTIC-COATING MACHINE CO.

The Chinese supplier and manufacturer of Casemaker, Gluing Laminator Machine, Box making machine, Cardboard Slotting Machine, Creasing & Cutting Machine, Surface Binding Machine. We also manufacture various PVC packages, rosewood and redwood boxes, and cartons.

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It is the special equipment of exquisite wooden box for gifts. Adopting the vacuum suction for workpiece, and pneumatic driving service platform, automatic and the lubrication, it operates steadily, reliably and effectively, and can complete slotting six or nine V-channels on **wooden board** in one shot.

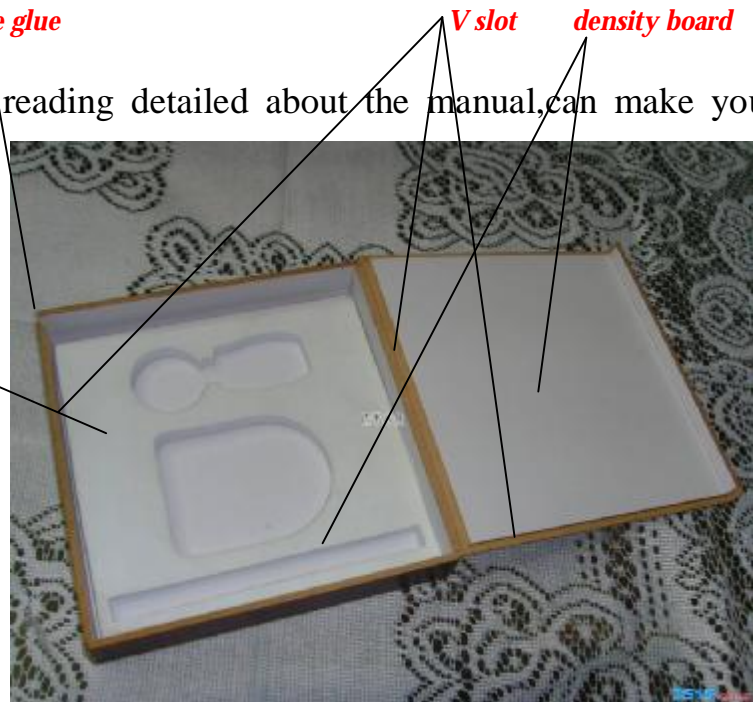
The V type groove machine of 6axles and 9 axles is specially designed to for slotting V type of packing box, it has following characteristics: high efficiency ,high accuracy and high rate of finished products, etc. It applies to the one-time molding of **density board and paperboard**.

First, welcome you to use the KL-V6,V9 Shaft Slotting Machine from our company production.

Before open the machine please reading detailed about the manual,can make you control the usage smoothly in the short date.

一. Outline

The V6、 V9 shaft Slotting Machine is produced to usher in the Taiwan technical,at first the machine applied to produce



advanced sound box and furnitures,improving and (**Wooden Box Packing**)

packing the need increment of the profession constantly along with the technique in recent years.The specialized design of my facture becomes to stick the noodles,paper packing box that sticks to face to open the slot to pvc,such as wine,smoke、 gift、 leather belt、 shoes、 medicine、 lighter and tea... etc. This Slotting machine design accuracy high, import from the abroad of lead the track to be apply in the work pedestal to move it with exclusively , work area is 1800 mm , length error margin ≤ 0.02 mm, function stability. Slotttingangle design precision, the pond panel is velvet. Just change the angle of the knife, can open the four, six and eight Capes packing box. This machine features design beauty, operation is convenient, that is current printing, packing essential advanced equipments of profession.

一、 Used range

The shaft Slottingmachine is suitable to adhibit with PVC cloth originally of density plank box and the paper box notching,and model with a knife,after slottingcan to produce various packing box.The suitable material is plank,thickness:2-5mm.

二、 Main technical variables:

Type	KL-V9	KL-V6
Number of main axis	9 stalks	6 stalks
Turns of main axis	7600 turns	7600 turns
Kni f axis inside direct	φ22mm	φ22mm
Kni fe axis outside direct	φ110mm	φ110mm
Motor power of the kni fe axis	9*0.75kw	6*0.75kw
Work area	1400*960mm	970*600mm
Work forming depth	3000mm	1800mm
Eddy spi ri t pumps power	2.2kw	2.2kw
Di mensi on	3000*2100*1800mm	2000*1800*1800mm
Wei ght	3000kg	2000kg

三、 Structure introduction

This machine mainly compose from the main machine, the moved work set, the

up beam and drag along the plank, the knife stalk total system, the eddy spirit pump, the vacuum filters system, auto adding oil, the air pump, the absorbs dust device, electric appliances control system...etc. to constitute automatically.

(1) Main machine: This machine originally install precisely after lead an adoption of track iron casting allow to adjust the quality processing accurate, the machine fructify, stability.

(2) The moved work set: moulding deal with whole aluminum piece, through grinding come to the highest stambl e after the front-panel gum passes match. The work set thin bore adopts eddy pump to adsorb and adsorb the work piece firmly at work the set face, and notching.

(3) The beam、drag along the plank: From the horizontal beam that the iron casting cast into, drag along the plank to give to hang on the horizontal beam, the drag plank to move along with the silk pole, make knife-head move to the need to notchine station.



blade of slotting

(4) The knife stalk total system: Install fixedly on the drag plank and dragging along the plank to arouse under the silk pole, the seat that the knife head positions need to fix in the work piece up. Axle-bearing all adopts import NSK of Japanese.

(5) The vacuum filter system and the automatically add oil system, the

eddy spirit pump, the air pump and the absorbs dust device : The eddy spirit pump is used to slotting after the work set was been adsorbed. The air pump is a conjunction to carry on the work pedestal in front and back to move in the air cylinder, exercise is in orde to the slotting function. The absorb dust device is to absorb the ash inhales the calico sack. The automatically add oil system is to encourage for orbit, can make the work-set easily to move.

(6) The electric control system: Control the knife stalk, air pump, air cylinder, and used for the work-set to move .

五、 Install and debugging

1, Machine must install on the strong、tough and flat ground , and adjust the bottom feet even, make lead track work set to face to adjust to the level .

2, Connect the power supply 、 eddy spirit air pump and pipe of air pump, power supply should credibility connect a ground of line, should to add the lubricant or lubricate fat.

3, To stick one layer PVC cloth or papers in work set facing with the glue, make the processed work organ under a hole for the purpose the eddy air pump better to adsorb .

4, Moved the knife stalk to the work piece needed , mix up the size of the slotting with 100 watches of cent, hand -wheel on the drag plank

make the knife head to get down to the work set between in the 0.14-0.18 mm. Use the Chinese foot or the PVC small piece cloth to adjustment.

5, Put the work piece on the work-seat, and to start the eddy air pump, after check the work piece if hav to be adsorb by the vacuum.

六, Operation

1, After the whole adjustments complete, put the work piece on the work-set, start the eddy air pump, the feet trample to the switch, start the knife head that is need to notching, then let the feet out the switch, will absorb the work piece, work-set will takes a stroll back and forth automatically, finish notching.

2, order into the work set, if is not satisfactory can order to back, but should to order slowly, strictlying forbid to make the work order the head set.

3, About the moved speed of the work set can compose in the one-way reduce expenses and in the valve adjustment single air cylinder, must match with while adjust in front and back the route of travel switch adjusts together.

七, maintenance and maintain

1, The work set and the electric tank must keep clean. In order to prevent the dust enter to the electric shock the cabinet inside result in

the electric appliances break the road.

2, The knife stalk should to add the lubrication fat periodically, and the air tank should to encourage periodically .

3, Every week , open the vacuum percolation box, clear the dust .

4, The eddy air pump, air pump need to add oil according the introduction to maintain.

5, The vacuum need to clear in time, in order to prevent the dust stops the vacuum entrance influence to absorb the dust.

6, the knife head usually uses would change bluntness naturely , changed the knife head to whet in a flat surface with 60-80 , until is sharp , if have angle needn' t to grind , also can send to return to our factory, then whet with the sharp tool

7, The bearings of the work-set will make the steel ball off over a long period of time meeting the ball bearing shed dismantles after shed off the conjunction work set screw, put the work set out. open the cover of the side of bearings, make up deficiencies the ball bearing, plus the lubricant. Re- install the work pedestal up, adjust the peacetime and must use the 100 cent watch settles on the horizontal beam form head arrives the work set, pushing work in front and back by hand, using a mat of red copper even, adjust error margin to the 0.02-0.05 mms as far as possible in, solid tight screw, then can open .

8, Air pump uses 3-5 days each time, should to put out the water from the air container , in order to prevent to burn loop.

八, safe regulation

1, before use the machine please detailed reading the introduction book , According the right request usage and support the machine .

2, should to use the electricity safety , if the electric wire damage Please stop to use, should replace in time.

3, when operate, about the all protect cover can not open, behind of the machine forbid the person stand.

4, check each parts periodically, if found the excrescent voice should check to fix in time to insure the normal operation of the machine.

5, the horizontal beam side silk pole enters to back, to notice the length

silk pole(already have the mark) and the drag plank can't push forward to the middle because of the short silk pole, so the short silk pole drags along the plank up to can't move inside entering to go to have to stop; already have to limit a device on the silk pole, strong line to

will damage the mother of inside shake .

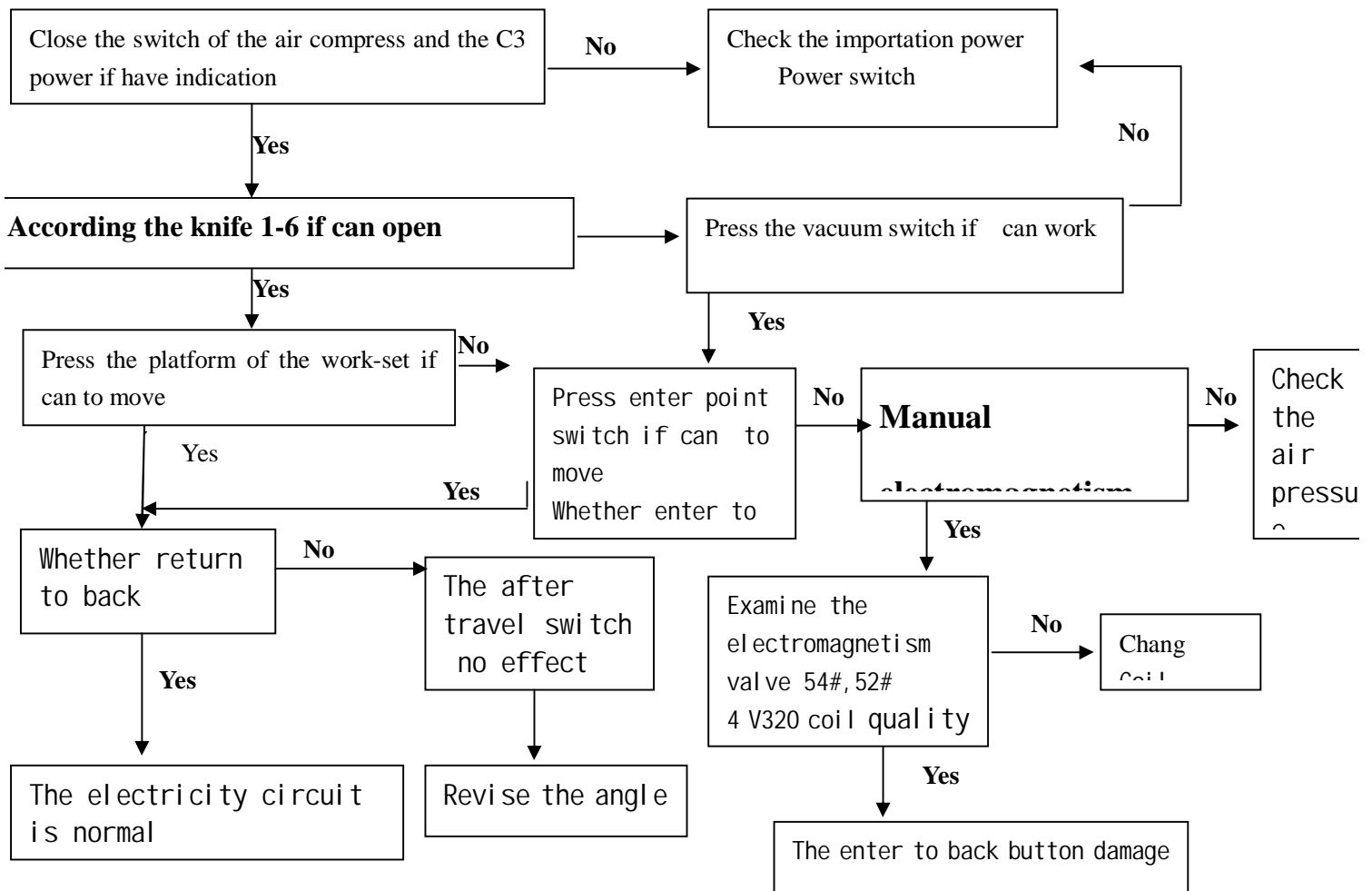
6, When exchange the knife or replace of the knife , should stop all power , and loosen to open according to the positive .

7, when operation the machine , the attention should concentration, the body should to stand or sits steady. When the machine is working , the hand, head can' t stretches into the machine , in order to prevent accident hurt, when the work piece not put good, can not start the feet to step the switch.

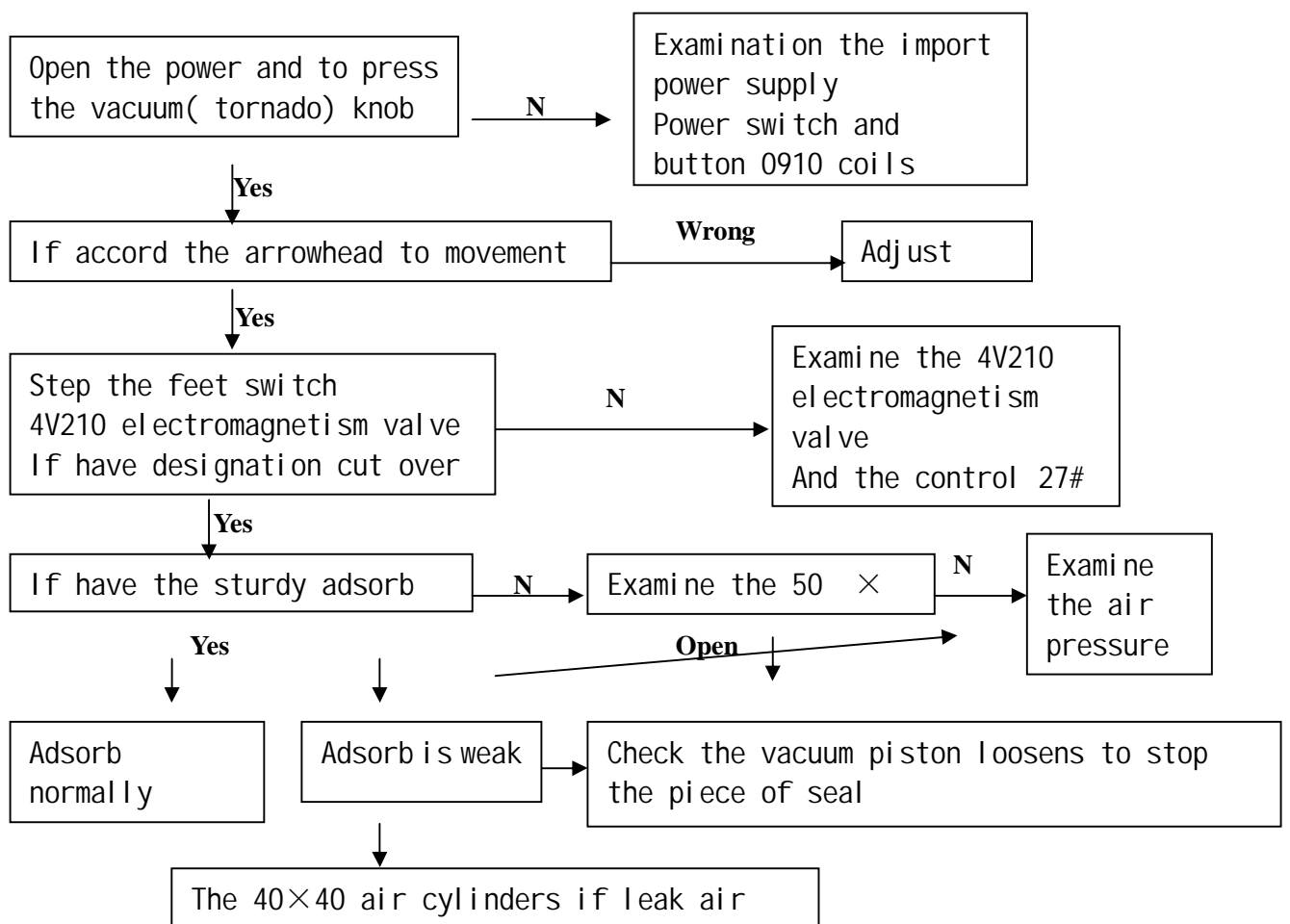
8, keep the environment to sweep, should to clear the machine after take off. The workplace no smoking , in order to prevent inflammable materials.

9, before leaving the machine , must wait the machine steady certainly , and close the power supply.

SlottingMaching Electricity Examination Process attach 1



The examination process of the vacuum adsorb Attach 2



The key-point of the slotting machine breaks down to examine Attach 3

- 1#, If have the electricity explain the power supply to transport.
- 3#, If have the electricity explain power supply control-line have already open.
- 41#, If have the electricity to explain that the total knife have already open to connect.
- 10#, If have the electricity explain vacuum have already open to connect.
- 11#, If have the electricity explain work pedestal at wait for.
- 27#, If have the electricity explain vacuum have work.
- 35#, If have the electricity explain air have already open.
- 52#, If have the electricity explain terrace to move behind.
- 54#, If have the electricity explain terrace to move before.

Note: Read the electric circuit principle diagram

The familiar break down and expel method of the slotting Attach 4

Obstacle	Cause	Check and the elimination way
Work-set can't work	Total knife not open	Open the total knife
	The electromagnetism valve(54) coil damage	Exchange the coil
	The knob damage of the enter point moved	Exchange the button
	The SQ1 travel switch non-arrival not reach	Move to back trie again
The work pedestal move once stop headway	The knob damage of the enter point moved	Exchange the button
	Button damage	Exchange the button
Work sets can't return	The SQ1 travel switch position angle is partial to move	Revise the position angle
The vacuum adsorb not to live or no(the electrical engineering can operation)	The vacuum passage stop(50 × 50) the air cylinder damage	Repair and exchange
	The air passage seals completely the turn(air cylinders 40 × 40)	Exchange
	The connector leak air	Tight solid or repair

Note: Pressing examination process can't solve the breakdown again, please contact with our technique department. Tel: 0086-577-63017009