



OPERATION INSTRUCTION OF SEMI-AUTOMATIC STITCHING MACHINE

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Operation instruction of semi-automatic stitching machine

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With the continuous development of packaging technology, the appearance requirements of corrugated boxes are getting higher and higher, such as exquisite printing patterns, neat and bright nail line sealing. Therefore, automatic/semi-automatic stitching machines are also widely used in Carton field. Compared with the manual box stitching machine, the automatic/semi-automatic stitching machine not only has high production efficiency, but also has a uniform and beautiful nail spacing. The main difference between the automatic stitching machine and the semi-automatic stitching machine is the automation of paper feeding. The paper feeding of the automatic stitching machine is that the paper feeding device folds the cardboard and sends it into the box stitching section for stitching box; while the semi-automatic manually folds and feeds the cardboard. Semi-automatic box stitching machines generally have a horizontal structure, and are divided into two types, single-piece and double-piece stitching machines. The structure of the two-piece box stitching machine is more complicated and full of functions. It can nail single-piece cartons and two-piece forming cartons.

01

START-UP PREPARATION

THE PREPARATION PROCESS BEFORE STITCHING BOX:

Adjust the position of the main baffle according to the flap of the carton; adjust the position of the left and right baffles and the positions of the upper and lower stitching heads. Pay attention that the left and right baffles cannot be clamped too tightly. The cardboard should be inserted and pulled out smoothly; touch screen after mechanical adjustment Computer settings:

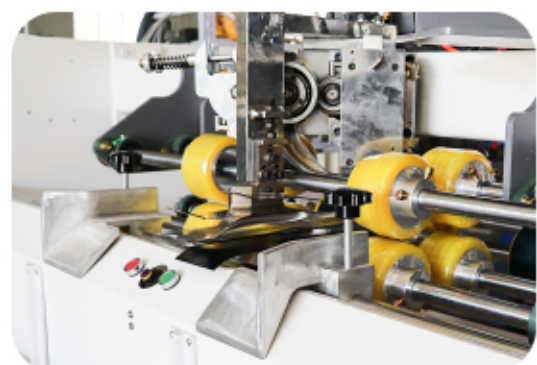
Carton height = original carton height - 40mm

Number of nails in carton

Carton nail distance

Whether to strengthen nails and other setting work

Single-piece and dual-piece options

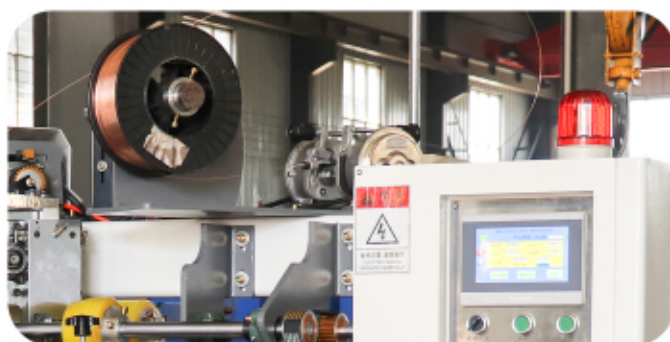


1. Check whether the power cord and plug of the equipment are in good condition to prevent hidden circuit hazards.
 2. The order requires that the flat wire be prepared, and galvanized or copper-plated low carbon steel flat wire should be used, and there should be no defects such as rust spots, peeling layers, and cracks.
 3. Install the nail wire according to the requirements and fix the nail plate.
 4. Prepare the workbench and adjust its height and distance.
 5. Plug in the power plug, start the circuit switch, turn on the pedal switch of the control valve, and check the operation of the machine.
 6. Receive the printed or die-cut semi-finished products according to the requirements of the order and place them on the workbench correctly.
 7. Pay attention to methods when turning the board, try to avoid the crease, strictly control the cardboard bumps and breaks, and pay attention to protect the safety of operator . Generally, the three-layer box 50 sheets each time, and the five-layer box 20-30 sheets each time. .
- After all the above tasks finished, the stitching work can be carried out.

02

TUNING AND TESTING

1. Adjust the distance between the three-layer, five-layer, and seven-layer lower mold and the tool holder in time according to the cardboard.
2. The nail distance is uniform and the position is accurate when nailing, the domestically selling box single nail distance W60mm, double nail distance W80mm, exporting box single nail distance W55mm, double nail distance W75mm, the distance between the first and the end nails and the crimping line is 13 ± 7 mm. W4mm, small box W3mm, the carton is shaped squarely, the flap is not broken, and the tongue of the inner paper is not damaged.



3. The flat wire is well formed, the nail hole has no burrs, no folded nails, warped nails, non-turning nails, and no oil stains on the carton.
4. After nailing, the carton should not have obvious indentation , prevent damage. If the above phenomenon is found, the machine pressure should be adjusted in time, and the carton should be treated with water.
5. Put waste paper on the ground and stack the formed cartons neatly on the left side .
6. For the double nailing box, place a waste cardboard under the machine table to prevent it from touching the ground or damaging the cardboard during turning.

03

THE OPERATION OF THE MACHINE

1. After completing the above process, first inspect the finished product and fill in the first inspection record.
2. If defective products are found in the first inspection, promptly explain the reasons to the on-site quality control and the team leader and seek solutions.

04

STOPPING OPERATION

1. When finished work, turn off the power and air valve.
2. When replacing the nail wire, turn off the power and air valve.
3. Turn off the power and air valve when cleaning up the oil on the carton to eliminate the machine failure.

05

PRODUCTION SAFETY REGULATIONS FOR OPERATOR

1. When the machine is in normal operation, keep vigorous energy and be in a highly concentrated state. Looking around, laughing and chatting is strictly prohibited.
2. When nailing the carton with lid and bottom, change the position of the hand in time.
3. When waxing the control clutch to increase the friction, pay attention to the waxing after the power is turned off.
4. In the process of cleaning objects and turning over the cardboard, master the strength and methods to prevent bruises and stumbling
5. The wires are strictly prohibited from contacting the moving parts of the equipment.
6. When maintaining and servicing the machine, you must first cut off the power supply, prohibit disassembling parts at will, and report for repairs if hidden dangers are found.

06

REPAIR AND MAINTENANCE PROCEDURES

1. Clean up the dirt on all parts of the machine before off work and keep the clutch in an idling state.
2. Add oil for maintenance before starting the machine, and the amount of oil is based on the non-dirty carton.
3. Do not add oil to the clutch and nail wire to prevent slippage of the clutch and the nail wire and affect the work.
4. Check whether the screws at the joints are loose, especially if the head of the rotating rod is damaged, report for repair in time.
5. For maintenance or normal maintenance, the corresponding logo should be shown and the repair report should be filled in in time.