



長聲工業股份有限公司
SUNRISE PACIFIC CO., LTD.

保養手冊

Model 機種型號：S-1000 型





Maintenance, Cleaning & Lubrication

清潔保養與潤滑

- Before maintenance and cleaning the machine, please shut down and lock-off the machine to prevent any damage or personal injuries. 清潔保養之前先將電源關閉或安全開關動作確保工作安全。
- Check before turning or moving any section or part of the machine to prevent your workers' or your own hair or fingers from being trapped. 旋轉或移動時注意本身及工作夥伴的頭髮或手指被夾到。
- Because of narrow space, please wear the protective measure. (EX: helmets, goggles and earplugs.) And notice not to get hurt for hitting the machine. 因工作空間細小，操作人員須穿戴保護工具(如頭盔，保護眼鏡及耳塞)。同時須注意避免被機械打傷。
- Cleaning maintenance is dividend into three parts (daily clean-up, weekly clean-up, and monthly clean-up)
清潔保養區分為每日、每週、每月執行一次。
- Daily cleaning up and maintenance after working every day. 每日清潔保養請於每日工作完畢時進行。
- Please set sufficient time to do weekly clean-up and monthly clean-up. 每兩周及每月清潔保養請於每週安排充裕時間進行。
- Except cleaning and lubrication, please contact with maintenance personal if finding abrasion and strange sounds. 保養時除清潔、潤滑之外，如發現磨損或異聲時請通知維修人員處理。
- Please contact with the professor if operator can not confirm the correct ways to maintain. 如無法確認保養、維修方法請與專業人員聯絡。
- Please follow the direction to use lubrication correctly. 各部位請依指示位置、種類、週期正確使用潤滑油。

Cleaning Solvent Application Attention 機台清洗劑使用注意事項::

1. It is strictly prohibited to use Strong Acid (PH Value < 4) or Strong Alkali (PH > 10) cleaning solvent to clean the entirely machine (including inside and outside). Only the Neutral cleaning solvent (PH Value 5 ~ 9) suggests to use. Improperly using cleaning solvent to clean the machine may cause the machine seriously damage. 本機台所有部份在清洗時若須使用清潔劑來協助清洗，絕不能使用強酸(PH值4以下)或強鹼(PH值10以上)的清潔劑來清洗機台內與外。只可使用中性清潔劑(PH值5~9)，若不正當使用清潔劑來清洗會造成機台嚴重損壞。
2. For feeder unit (feeder roll, wheel thread), print unit (doctor blade, rubber roll and ink chamber), die cut unit (anvil roll) and all the rubber type components on the whole machine, it only suggests to use Neutral cleaning solvent (PH Value 5~9) for cleaning. 另外進紙部的進紙輪、橡膠輪，印刷部的刮刀、墨腔，模切的膠墊輪，及機台所有的橡膠類零組件只可使用中性清潔劑(PH值5~9)來清洗。

If the user does not know what kind of cleaning solvent can be used, it should consult Sunrise and wait for the professional instruction. 如對使用清洗劑有任何疑惑，請先行與長聲聯絡以便由專業人員作出指導。



Feeder Unit 送紙單元

Daily Clean Up 每日清潔

Item 項目部位	Detail 保養要點
Feeder roll box cleaning 進紙輪箱清潔	Wiping. 擦拭清除乾淨，保持無紙屑、雜物。
Feeder roll cleaning 進紙輪表面清潔	Wipe the cylinder (Don't grease to the rubber, It may cause the material damaged.) 橡膠部位不可擦油，避免造成材質損壞。
Filter for lead edge feeder 前緣進紙過濾網	Clean the filter. 清潔前緣進紙過濾網。
Fan in the electric cabinet 電器箱內散熱風扇	Clean the fan filter. 清潔散熱風扇過濾網
Examine each air compressortube 檢查各空壓管	Examine whether the air compressor is normal and no leaking. 關機狀態下確認空壓管正常，沒有漏氣現象。
Clean the machine attaching scraps 附著於機器之紙屑塵埃。	Wiping and clean the surrounding. 擦拭清除乾淨、機器周圍清掃乾淨。
Clean the rail 軌道清潔	Remove the object of tracking movement. 清除移動範圍內物品。
F.R.L (Filter, Regulator, Lubrication) 壓縮空氣調理組合(三點組合)	Release the filter water of air compressor 釋放篩檢程式積水 Examine whether the oil is under the lowest standard. 檢查潤滑油量低於下限時補充 Examine the air Pressure 4.5~6kg/cm ² . 檢查空氣壓力 4.5~6 kg/cm ²



Feeder Unit 送紙單元

Weekly Clean Up 每週清潔

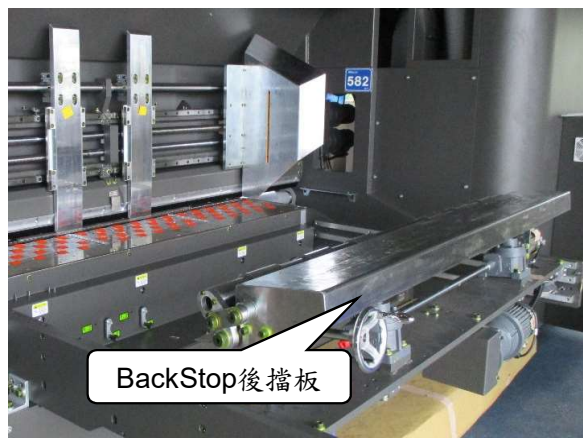
Item 項目部位	Detail 保養要點
Gear box at lead edge feeder 前緣進紙變速箱	Examine whether the coupling is normal. 各連軸器正常
Frame lock and lead screw 機器固定鎖及連結鎖連杆	Lubrication 注油潤滑
The chain driving the machine 機器移動驅動鏈條	Adjust the tension and replace chain when frayed. 調整緊度至驅動順暢為宜，鏈條磨損時需更換
Main driving belt 主機驅動皮帶	Adjust the tension and replace chain when frayed. Be sure the belt position is correct. 調整緊度至驅動順暢為宜，皮帶磨損時需更換。確認皮帶位置無偏移
Fixed shafts, lead screws at front gate and side guide 前、側擋板固定軸及螺杆	Wipe with grease. 擦拭、塗布潤滑油
Lead screw at backstop 後擋板移動螺杆	Wipe with grease. 擦拭、塗布潤滑油
Bearings for lead edge feeder 前緣進紙輪軸承	Lubrication 注油潤滑
Bearings for front gate 前緣隔離板各軸承	Lubrication 注油潤滑
Electric cabinet cleaning 電器箱清潔	Clean the dust with vacuum cleaner or air gun. 以吸塵器或氣電槍來清理控箱內之灰塵
Blower 風車	Clean the filter in blower. 風車紙塵濾網清潔
Pneumatic tube connector 氣缸管路接頭	Examine whether the pneumatic tube is leaking air or damaged. Replace it when damaged. 檢查是否有松脫漏氣或破損現象、破損時需更換



Feeder Unit 送紙單元

Monthly Clean Up 每月清潔

Item項目部位	Detail保養要點
Examine if there are scraps or obstructions in the blower. 檢查風車是否有紙屑、異物吸入	Clean when stuck. 吸入時需清潔
Up, down feeder bearing 上、下進紙輪軸承	Lubrication. 注油潤滑
Back stop position 後擋板位置	Examine whether the back stop is parallel with feeder roll. 後擋板位置與進紙輪平行
Clean the blower 風車葉片清潔	Clean the blower and obstructions. 清潔送風葉片的紙屑及異物
All screw check 所有螺絲檢查	Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage. 檢查螺絲是否有松脫或破損現象、如發現有松脫需立即收緊，若發現希破損時需立即更換。





Printer Unit 印刷單元

Daily Clean Up 每日清潔

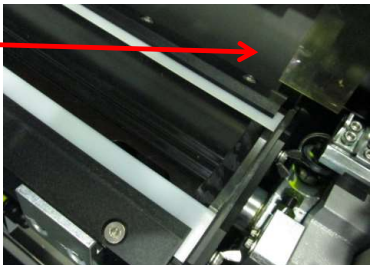
Item項目部位	Detail保養要點
Printer cylinder, impression roll 印刷輪、印壓輪	Wiping and cleaning 擦拭清潔
Clean the machine attaching the dust and scraps. 機器附著之紙屑、塵埃	Cleaning 清潔
Ink bucket frame 墨桶架	Cleaning after use 持清潔及用完後擦拭清潔





Printer Unit 印刷單元

Weekly Clean Up 每週清潔

Item項目部位	Detail保養要點
Anilox roll 著墨輪 	<p>Examine the anilox roll is cleaned , and separate to the correct position. 檢查著墨輪確認已清洗乾淨，並分離至定位。</p> <p>Clean with lotion.(Confirm to professor)清洗時可添加洗劑(洗劑請與專業人員確認)</p> <p>Use specialized Steel brush to clean the ceramic anilox roll. (Don't use hard steel brush) please confirm the kind of lotion with professor.陶瓷著墨輪(Ceramic Anilox)表面油墨附著物使用專用不銹鋼刷(切忌使用硬質鋼刷)，及專用清潔劑清洗(請與專業人員確認後才可使用)。</p>
Frame lock and connection screw 機器固定鎖及連結鎖連杆	Lubrication. 注油潤滑
Tighten rod shaft 絞版軸	Examine the rod shaft is cleaned and tightened. (Replace the spring when it can't be fix causing fray.) 清潔(磨損無法固定時需更換彈簧)
Ink tank 盛墨槽	Clean the dry ink. 清除油墨乾涸附著物
Ink pump, ink sensor, and filter. 墨泵、供墨檢知器、過濾網	<p>Clean the dry ink. 清除油墨乾涸附著物</p> <p>Examine whether the tube is leaking air or damaged. 檢查管路接頭是否有松脫漏氣或破損現象。</p>
All encoder 所有譯碼器	Examine whether the function is normal. 檢查功能正常
Pneumatic tube connector 氣缸管路接頭	Examine whether the pneumatic tube is leaking air or damaged. Replace it when damaged. 檢查是否有松脫漏氣或破損現象、破損時需更換。
The grease of gear box at driver side. 驅動側齒輪箱潤滑油	Examine whether the oil height is normal in gear box. 油位液面正常。
Vacuum transfer box lubrication 吸風傳送箱潤滑	Lubricate the gear of vacuum transfer box. 吸風傳送箱傳動軸軸承潤滑。



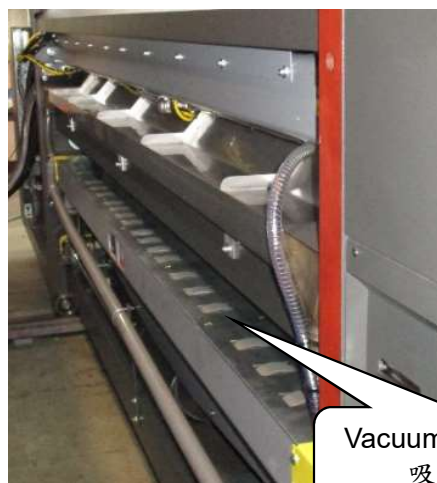
Printer Unit 印刷單元

Monthly Clean Up 每月清潔

Item項目部位	Detail保養要點
Printer cylinder, impression roll, transfer roll, and anilox roll bearings.印刷輪、印壓輪、導紙輪、著墨輪心軸軸承部位	Lubrication.注油潤滑
The blower of vacuum transfer吸風傳送風車	Clean the scraps.檢查有異物時將之清除。
Vacuum transfer box 吸風傳送箱	Clean.清潔
All screw check所有螺絲檢查	Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage.檢查螺絲是否有松脫或破損現象、如發現有松脫需立即收緊，若發現希破損時需立即更換。



Blower
吸風



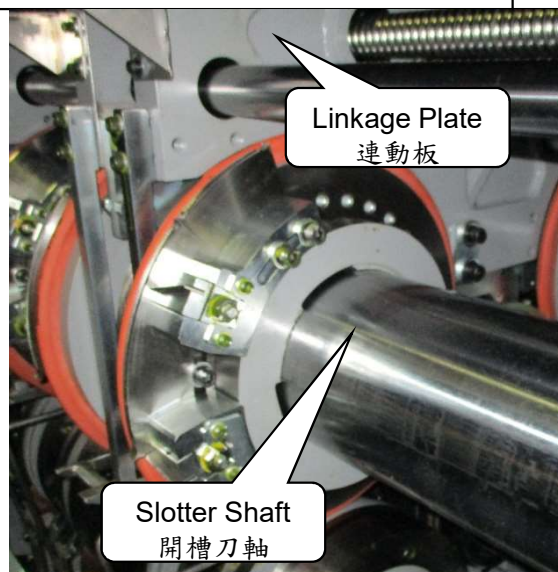
Vacuum Transfer Box
吸風傳送箱



Slotter Unit 開槽單元

Daily Clean Up 每日清潔

Item項目部位	Detail保養要點
The shaft of creaser, slotter and linkage plate 壓線輪軸、開槽刀軸、連動板軸表面	Wiping for cleaning 擦拭清潔
The machine attaching scraps and dust. 機器附著之紙屑、塵埃	Wiping for cleaning 擦拭清潔





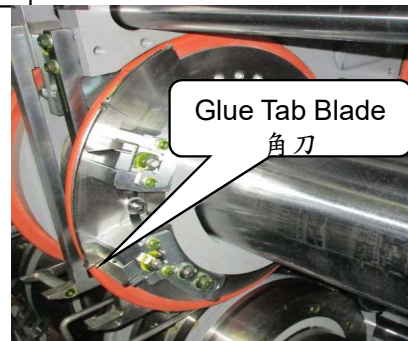
Slotter Unit 開槽單元

Weekly Clean Up 每週清潔

Item項目部位	Detail保養要點
Sliding rails of creaser ,slotter holder, and linkage plate 壓線輪座滑槽、開槽刀座滑槽、連動板	Wiping with grease. 擦拭、塗布潤滑油
Creaser, slotter holder and linkage holder 壓線輪、開槽刀座及連動板座	Lubrication and cleaning at shaft. 軸心配合位置清潔、潤滑
Adjusting gear at slotter 開槽刀位置調整齒輪	Lubrication塗布潤滑油
Cushion at glue tab blade 角刀緩衝膠墊	Replace when frayed.磨損時需更換
The fix screw at slotter and glue tab blade 角刀、開槽刀固定螺絲	Fix again when loosing and replace when frayed. 鬆脫時必須重新固定、磨損時需更換
The position of male and female slotter 上、下開槽刀對位	Ensure the position is correct.確認上下開槽刀對位正常
Pneumatic tube connector氣缸管路接頭	Examine whether it has air leakages or damages, replace when damaged. 檢查是否有鬆脫漏氣或破損現象、破損時需更換
Waste scraper去屑板	Examine whether the function is usual.去屑板功能正常



Waste Scraper
去屑板



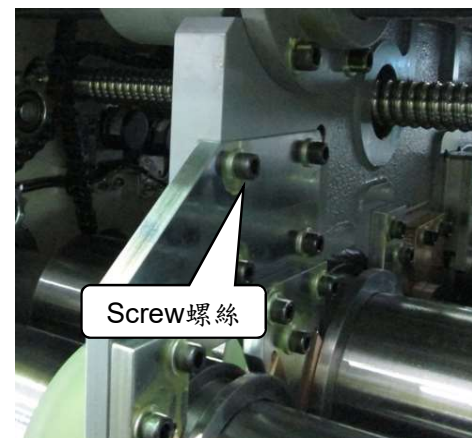
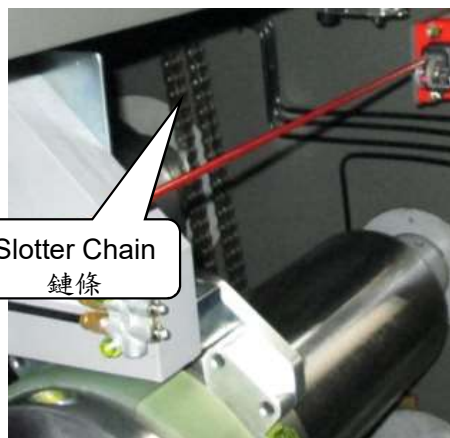
Glue Tab Blade
角刀



Slotter Unit 開槽單元

Monthly Clean Up 每月清潔

Item項目部位	Detail保養要點
Creaser shaft, slotter shaft and the bearings of linkage plate. 壓線輪軸、開槽刀軸、連動板軸軸承部位	Lubrication注油潤滑
The moving lead screws , chains of slotter and creaser.開槽刀、壓線輪移動螺桿及鏈條	Lubrication and fasten the chain when loosing.塗布潤滑油檢查鏈條過松時必須上緊
Examine the lead screws at knife holder刀座螺桿檢查	Adjust the gaps at lead screw holders and screw nuts.刀座螺桿、螺母餘隙檢查調整
All screw check所有螺絲檢查	Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage.檢查螺絲是否有松脫或破損現象、如發現有松脫需立即收緊，若發現有破損時需立即更換。





Die-Cutter Unit 模切單元

Daily Clean Up 每日清潔

Item項目部位	Detail保養要點
Machine cleaning 機器清潔	Clean the scraps. 附著紙塵清除
Gear box lubrication 齒輪箱潤滑	Fill the grease when the oil is insufficient. 潤滑油意液面正常，不足時加入潤滑油。

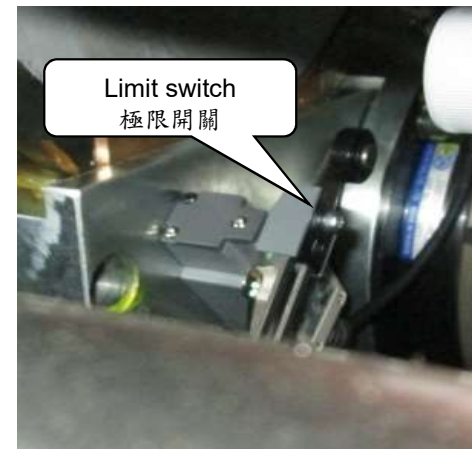
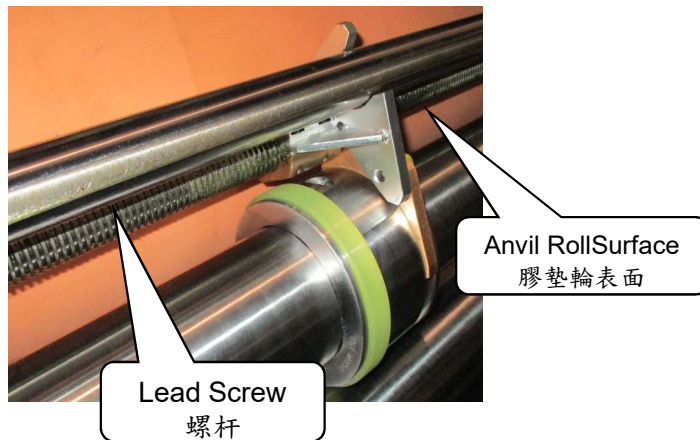




Die-Cutter Unit 模切單元

Weekly Clean Up 每周清潔

Item項目部位	Detail保養要點
Limit switch 極限開關	Examine each function of switch is normal. 各部位極限開關功能正常
Lateral screw for pull wheel拉紙輪橫移螺杆	Lubrication. 塗布潤滑油
Anvil roll surface flatness膠墊輪表面平整	Keep anvil roll surface flatness. If the outer diameter found uneven flatness, it must repair it. 膠輪表面保持平整，外徑不平整時需修平。
Anvil roll left right moving膠墊輪左右橫移	Left right moving must be normal moving 左右橫移功能正常





Die-Cutter Unit 模切單元

Monthly Clean Up 每月清潔

Item項目部位	Detail保養要點
Pull wheel shaft, die cut cylinder, anvil roll bearings. 拉紙輪軸、刀輪、膠墊輪軸承	Lubrication. 注油潤滑。
Speed compensation transmission box 膠墊輪速度補償傳動箱。	Fill the grease when the oil is insufficient. 速度補償傳動箱潤滑油液位正常。
All screw check 所有螺絲檢查	Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage. 檢查螺絲是否有松脫或破損現象、如發現有松脫需立即收緊，若發現有破損時需立即更換。





Stacker Unit 堆疊單元

Daily Clean Up 每日清潔

Item項目部位	Detail保養要點
Clean the machine attaching the dust and scraps.清除機臺上的紙塵	Clean the scraps.附著紙塵清除
Receiving Arm Check接紙臂檢查	Check the receiving arm smoothly move up and down.確認接紙臂上升及下降無異常發生。
Air compressor壓縮空氣機壓力	Examine the air Pressure4.5~6 kg/cm ² 檢查壓縮空氣壓力保持4.5~6kg/cm ² 。



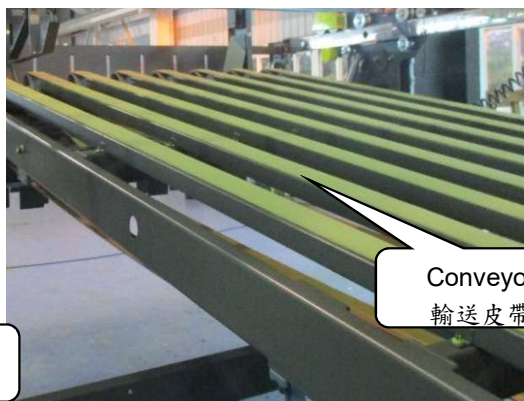
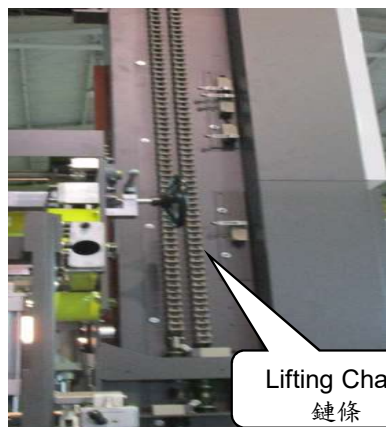
Receiving Arm
接紙臂



Stacker Unit 堆疊單元

Weekly Clean Up 每周清潔



Item項目部位	Detail保養要點
Conveyor輸送皮帶	Examine the tension of belts and replace when frayed.檢查輸送皮帶過松時必須上緊、磨損時需更新。
Examine the safety lock is normal檢查安全鎖定位正常	Examine whether the safe lock cylinder, tube connector and magnetic switch are normal.檢查安全鎖定位氣缸、管路接頭及磁簧開關完整及動作正常確保安全。
Lifting chain and sliding roll lubrication升降鏈條及滑輪塗布潤滑油	Examine the tension of lifting chain and sliding roll .Replace when damaged.檢查升降鏈條及滑輪過松時必須上緊、磨損時需更新。
Wheel, belt roll ,and fix shaft.輪軸、皮帶輪固定軸承注油潤滑	Lubrication潤滑不足須補足潤滑油





Stacker Unit 堆疊單元

Monthly Clean Up 每月清潔

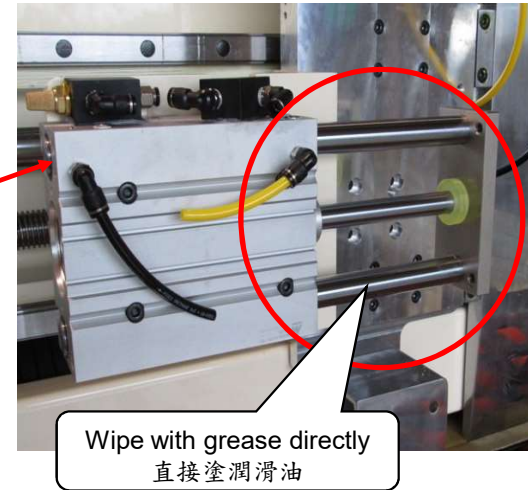
Item項目部位	Detail保養要點
Wheel, belt roll ,and fix shaft.輪軸、皮帶輪 固定軸承注油潤滑。	Lubrication潤滑不足須補足潤滑油
Gear reducer減速機馬達	Fill the grease when the oil is insufficient.檢查減速機馬達潤滑油量不足時補充。
Counter weight chainlubrication 配重塊鏈條塗布潤滑油	Examine whether the counter weight chain is complete, fix again when losing and replace when damaged. 配重塊鏈條塗布潤滑油
Squaring側拍	 <ol style="list-style-type: none"> 1.Lubrication潤滑不足須補足潤滑油 2. Examine whether the move smoothly and repair when abnormal.檢查側拍是否活動暢順，若有異常請作出維修。
Holder暫存板	 <ol style="list-style-type: none"> 1. Examine whether the holder move smoothly and repair when abnormal.檢查暫存板是否活動暢順，若有異常請作出維修。

Squaring Patting Maintenance

側拍機構清潔保養

Maintenance Item 保養項目

- ◆ There is no grease point at this instrument, please wipe with grease directly to three main steadies. 在此機構中無潤滑點，請直接將潤滑油塗在三根主支撐杆。請將油直接潤滑螺杆與軌條。



Lead Edge Feeder Gearbox - Cleaning & Maintenance 1

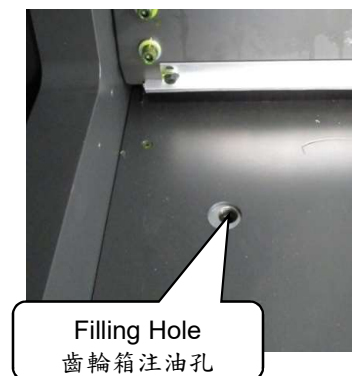
前緣送紙齒輪箱清潔保養 步驟 1

Maintenance Items 保養項目

- ◆ The gear box (inside of operation side) must be filled with oil to the correct level.
將齒輪箱注油到正確的高度(操作側)。
- ◆ Inspect the oil quantity regularly, top up with new oil when it is too low.
定期檢視油量，不足時補充。
- ◆ The oil must be taken out after the machine has run for 2500 hours (or 300 days) and replaced with new oil.
當機械運轉2500小時後(或300天)，請務必將油更換新油。

Caution 要點說明

- ◆ The oil must be topped up before running, otherwise the machine may be damaged.
避免機械損壞，運轉前請將油加滿。
- ◆ The quantity of oil must be between the upper and lower limits. Do not go over the upper or below the lower limit.
油量不可高於上限也不可低於下限。
- ◆ The viscosity of the oil should be ISO 60~ ISO 70.
使用黏度指數ISO 60~ISO70潤滑油。



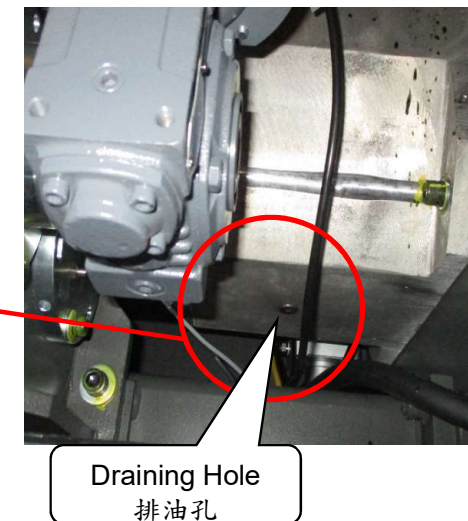
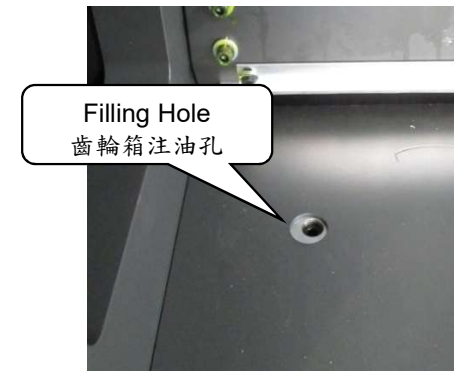


Lead Edge Feeder Gearbox - Cleaning & Maintenance 2

前緣送紙齒輪箱清潔保養 步驟2

Procedures 換油程式

- ◆ The oil must be taken out after the machine has run for 2500 hours (or 300 days) and replaced with new oil
確認舊油量已經運轉2500小時(300天)。
- ◆ Remove the set screw under the gear box to remove all the used oil.
拆除下方止付螺絲來將油卸載乾淨。
- ◆ After remove all the used oil and plug back the set screw.
卸完油後以剛才的反順序裝回止付螺絲
- ◆ Then, fill in the new oil to the standard level.
接著倒入新的油到應有的標準量。



Lead Edge Feed Wheel Box Cleaning & Maintenance

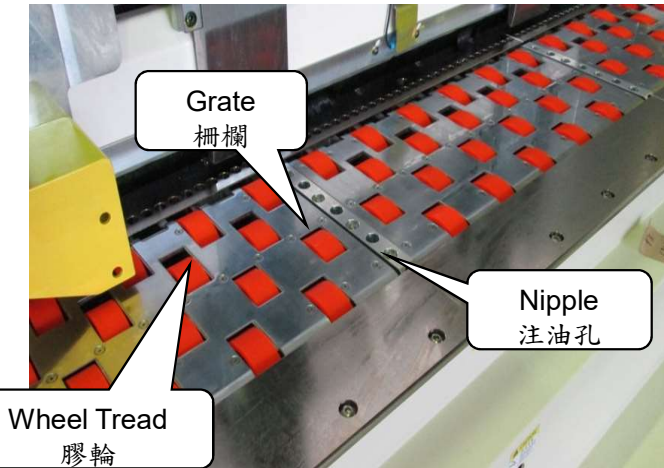
前緣送紙膠輪清潔保養

Maintenance Items 保養項目

- ◆ Grease must be added regularly to each grease nipple on the feed shafts.
定期在送紙軸注油孔注油保養。
- ◆ The wheels tread must be replaced when worn out.
請于膠輪磨損時更換。
- ◆ Grease must be added regularly to each grease nipple in each grate section.
定期注油在每一個柵欄部位的注油孔。

Caution 要點說明

- ◆ If a wheel tread needs replacing, all the wheels must be changed to keep the same contact height across the table. 如果膠輪需要更換，所有的輪子也必需一併更換以確保行紙高度相同。
- ◆ After replacing the wheels tread, check that the wheels are in the proper position, otherwise the feed will not be corrected. 再更換膠輪後，請注意是否在正確的位置，以免進紙歪斜。
- ◆ The grate link spring (raise/lower) must be replaced if worn out or broken 若發現柵欄內的伸降彈簧磨損時請更換。



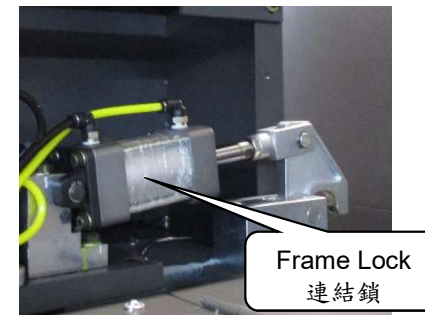
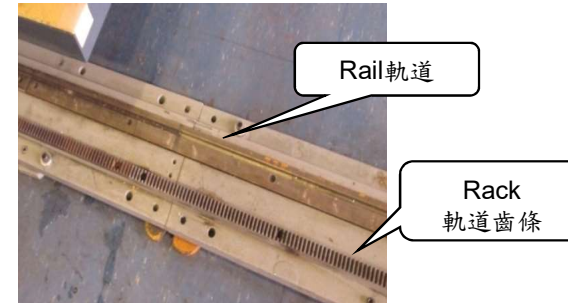
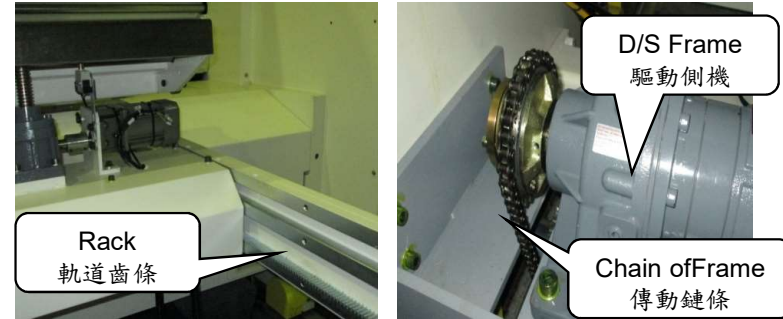
Frame Movement 機器移動傳動

Maintenance Items 保養項目

- ◆ Clean & lubricate with oil to the gear and chain of rear guide.
後擋板移動齒輪及齒條擦拭、塗布潤滑油
- ◆ Clean & lubricate with oil to the gear and chain of frame movement.
機器移動齒輪及齒條擦拭、塗布潤滑油。
- ◆ Inspect the chain tension. 定期檢查傳動鏈條鬆緊度及塗布潤滑油脂。
- ◆ Remove the dirt from the runway channels. 清理軌道雜物。
- ◆ Clean and lubricate with oil to the machine fixing locks.
機器固定鎖連杆擦拭、注油潤滑。
- ◆ Clean and spread oil on machine connecting locks.
機器連結鎖擦拭、注油潤滑。

Caution 要點說明

- ◆ If the frame cannot move or causes sliding, tighten the torque limiter.
機器無法確實移動產生滑動時調整皮帶緊度。



All Units 所有單元

Individual Shaft Cleaning & Maintenance 各軸清潔保養

Maintenance Items 保養項目

- ◆ Lubricate all roll shafts and bearings. 潤滑所有輪軸及培林。
- ◆ Lubricate motor shafts and bearings. 潤滑所有馬達軸心與培林。
- ◆ Wipe grease to adjust the shaft and drive gear. 將調整軸與驅動齒輪直接上油潤滑。

Caution 要點說明

- ◆ Use grease gun to fill the grease nipples. 2/3 strokes of the grease gun only. 有裝置潤滑油脂注入口部位，以黃油槍灌注。
- ◆ Before lubricating with grease, clean all parts with a cloth first. 以毛刷塗布潤滑油脂之前請先用擦拭布清潔。



Grease Nipple
注油孔





All Units 所有單元 Gear Box Cleaning & Maintenance 1 齒輪箱清潔保養1

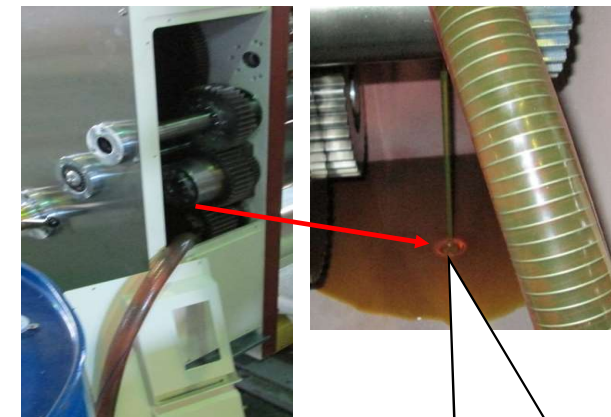
保養項目 Maintenance Items

- ◆ Oil must be added to the drive train of each unit (operation side).傳動齒輪箱(操作側外側) 加注潤滑機油。
- ◆ Check the quantity of oil regularly.檢查潤滑油量低於下限時補充油量。
- ◆ The oil needs replacing after running 2500 hours or 300 days.潤滑機油每運轉2500小時(或300天) 必需泄除，更換新油。
- ◆ Check the oil return pump is working correctly. (Returning the oil to the feed unit).檢查回油正常(超過液面潤滑油回送至進紙單元).



Caution 要點說明

- ◆ It must contain enough oil when running.運轉前必需要 加油，否則不可啟動。
- ◆ The quantity of oil must be between the upper and lower limits.油量注滿視鏡上下限之間，不要太多或太少。
- ◆ The viscosity of the oil should be ISO 40~ ISO 50.
- ◆ 使用黏度指數ISO 40~ISO50潤滑油。



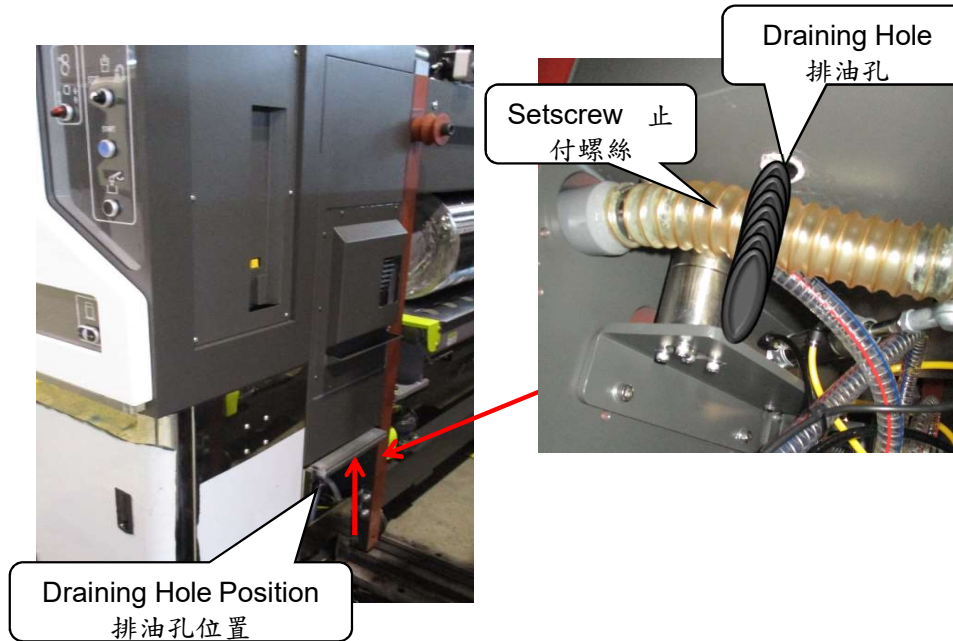


All Units 所有單元

Gear Box Cleaning & Maintenance 2 齒輪箱清潔保養2

Oil Replacing Procedure 換油程式

- ◆ Confirm used lubricant oil has run over 2500 hours (300 days) 確認舊油量已經運轉2500小時(300天)。
- ◆ Remove the set screw and drain out all the used lubricant oil (Each Unit). 拆除下方止付螺絲來將油卸載乾淨。(每一單元)
- ◆ Put back the set screw after drain out the used lubricant oil. 卸完油後以剛才的反順序裝回止付螺絲。
- ◆ Then fill in the new lubricant oil to standard level. 接著倒入新的油到應有的標準量。

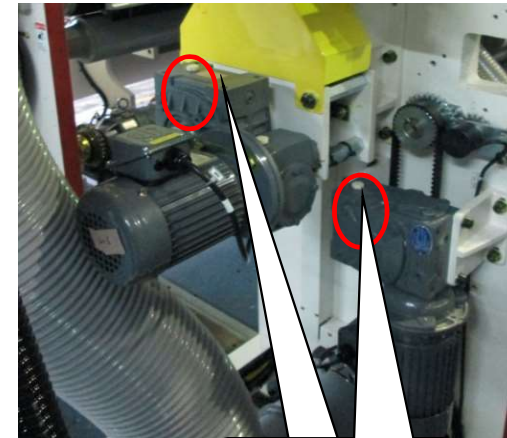


All Units 所有單元

Reducer Motor Maintenance 減速機馬達保養

Reducer Motor Lubricant Grease Check 減速馬達油量檢測

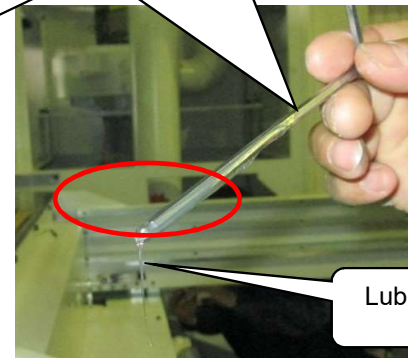
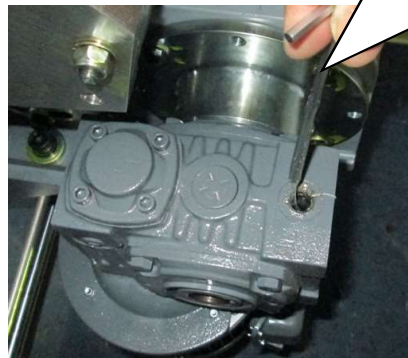
- ◆ Reducer motor has changed to use lubricant grease instead of yellow oil for motor lubrication. Lubricant grease is very durable, and replace it once per year or over 15000 hrs. 減速馬達已改用油脂來取代黃油，而油脂非常耐用，約一年或15000小時才須要添加一次。
- ◆ Operator only need to open the filling hole plug top on the reducer motor, and use a spanner or wood strip to insert inside the filling hole for checking the lubricant grease level whether sufficient or not. 操作人員將減速機馬達的油蓋打開，開啟後用板手或長木條放到油孔內檢測油脂狀況以確定是否需要加油脂來潤滑減速機馬達。
- ◆ If the lubricant grease is sufficient, the spanner or the wood strip should occupy the grease, oppositely, it must add the grease in it. 若油脂充足，板手或長木條會沾到油脂；相反則須加入油脂來潤滑減速機馬達。



Filling Hole Plug
油封蓋

Spanner or Wood Strip for Checking
板手或長木條做油脂檢測

Filling Hole Plug
油封蓋



Lubricant Grease
油脂

Printer 印刷

Vacuum Blower & Vacuum Box 吸風風車及吸風箱

Maintenance Items 保養項目

- ◆ Clean the filter & vacuum box regularly to ensure the vacuum box is kept free and maintains enough air volume. 定期清潔風車、吸風箱及集塵袋內部紙屑，保持管路暢通和足夠吸力。

Caution 要點說明

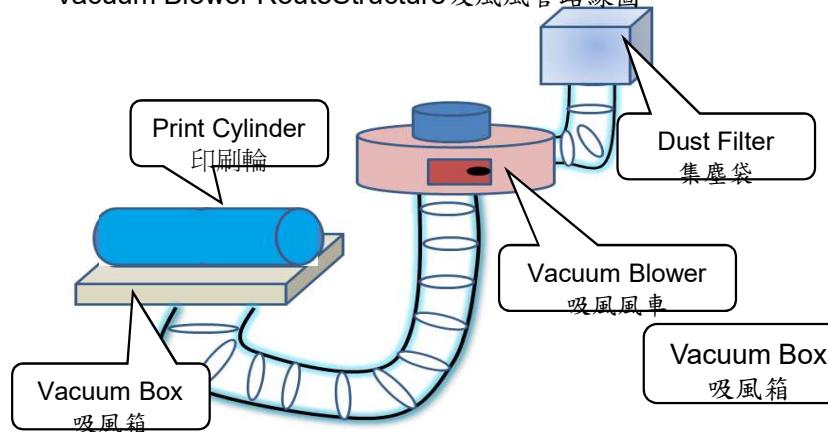
- ◆ Before cleaning the blower, turn off the power to prevent any injuries or damage. 清潔風車前必需先行確認電源已切斷，避免危及人員安全。
- ◆ After cleaning the blower, the inspection door must be closed before the machine can run. 風車清潔完成清潔口必需關閉妥當方可啟動運轉。



Vacuum Blower
吸風風車

Blower Tube
風管

Vacuum Blower Route Structure 吸風風管路線圖



Vacuum Box
吸風箱

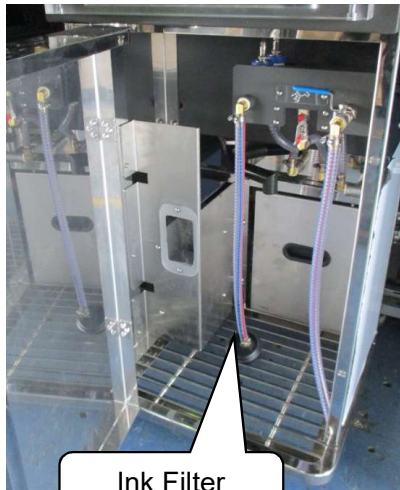
Printer 印刷

Ink Supply System Cleaning & Maintenance

供墨系統清潔保養

Maintenance Items 保養項目

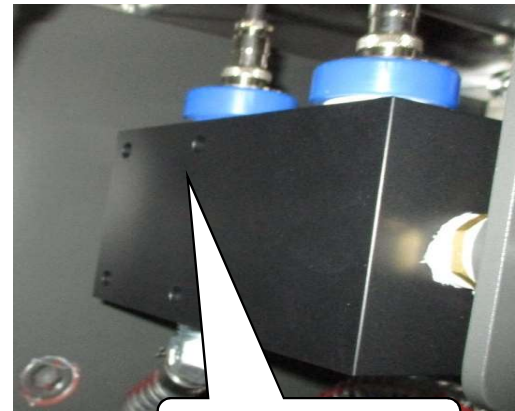
- ◆ Clean the ink supply filter and examine whether the filter is damaged. 墨泵濾網清洗、檢查是否破損。
- ◆ Clean the dry ink attachments in ink tank. 盛墨槽清除油墨乾涸附著物。
- ◆ Clean the dry ink attachments of ink supply sensor, grease the coupling. 供墨檢知器清除油墨乾涸附著物。連軸器塗布潤滑油脂。
- ◆ Adjust when the gap in coupling of anilox roll is larger than 1mm. 著墨輪連軸器間隙超過1mm以上時必要調整。



Ink Filter
供墨泵濾網



Ink Supply Pump
供墨幫浦



Ink Supply Detector
供墨檢知器



Printer 印刷

Vacuum Box, Belt, Lead Screw Cleaning & Maintenance

吸風箱、皮帶及螺桿清潔與保養

Maintenance Items 保養項目

- ◆ Adjust the timing belt 調整時規皮帶彈性。
- ◆ Lubricate the elevated lead screw, also adjust the shaft and rail. 塗布潤滑油在升降螺桿, 調整軸, 與滑軌上。
- ◆ Regular check the tension between the feed roll and impression roll. 定期檢查進紙輪與印壓輪之時規皮帶彈性。
- ◆ Clean the scrap on the vacuum box 清除在吸風箱上的紙屑。



Caution 要點說明

- ◆ Need secure the timing belt if found loosen. 時規皮帶松掉時必須調緊。
- ◆ Replace the timing belt if found frayed. 規皮帶磨損時必須更換。

Elevated Lead Screw
升降螺桿



Printer 印刷

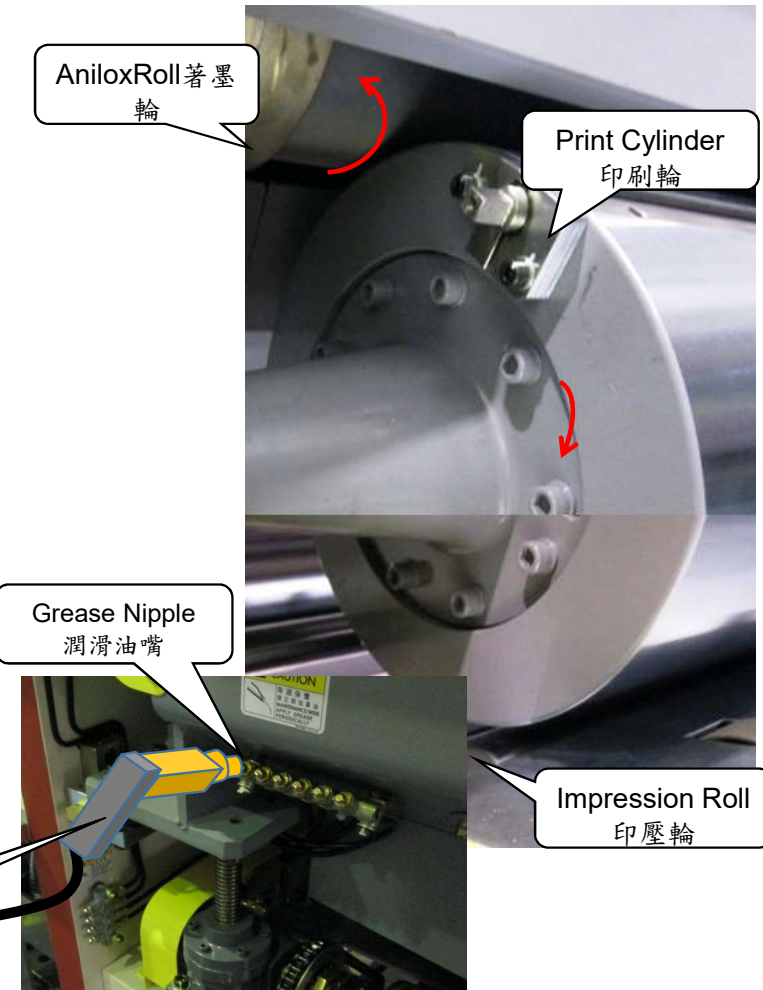
Cylinder Cleaning 印刷軸面清潔

Maintenance Items 保養項目

- ◆ Clean the surface of the print cylinder and impression roll. 印刷輪、印壓輪表面擦拭。
- ◆ Lubricate the printer cylinder, impression roll, and shaft of anilox roll. 印刷輪、印壓輪、著墨輪軸心及軸承注油潤滑。
- ◆ Lubricate with oil the print cylinder, lateral adjustment shaft and the coupling of the anilox roll. 印刷輪橫移螺桿、著墨輪連軸器塗布潤滑油

Caution 要點說明

- ◆ The anilox roll coupling must be replaced if it is seriously worn out. 檢查看著墨輪連軸器磨損過多時需更換。
- ◆ Use a grease gun to fill the grease nipples. 有裝置潤滑油嘴部位，以黃油槍灌注。
- ◆ Use a cloth to clean the area before applying any lubrication product. 以毛刷塗布潤滑油脂之前請先用擦拭布清潔。



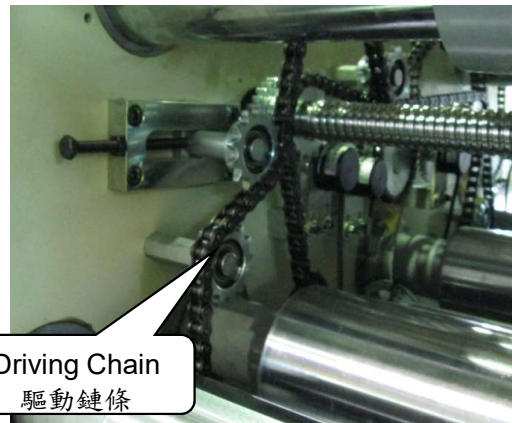


Slotter 開槽

Lateral Lead Screw & Driving Chain 橫移螺桿與驅動鏈條

Maintenance Items 保養項目

- ◆ Daily clean the slotter paper scrap 每天清潔在開槽單元附近的紙屑。
- ◆ Monthly apply the grease to lubricant the gear and driving chain. 每月清潔和上油保養齒輪與驅動鏈條。
- ◆ Monthly apply the grease to lubricant the lateral lead screw. 每月清潔及上油保養橫移螺桿。



Die Cutter 模切

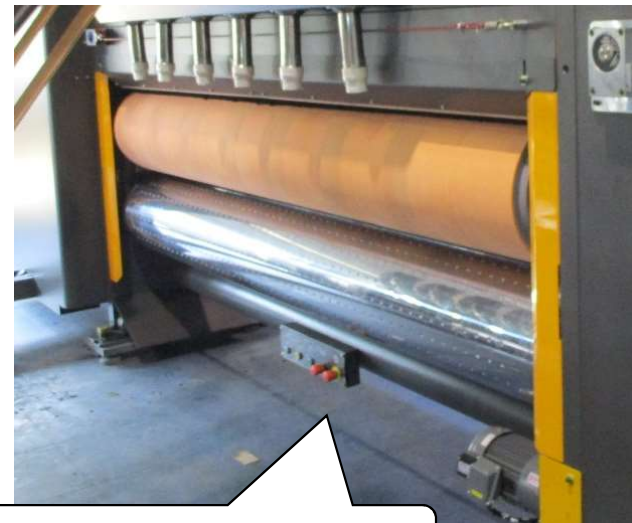
Lead Screw And Chain Drive Cleaning 橫移螺桿與驅動鏈條

Maintenance Items 保養項目

- ◆ Clean the scrap around the Die Cutter daily. 每天清潔在模切單元附近的紙屑。
- ◆ Clean & lubricate with oil to the gear and chain monthly. 每月清潔和上油保養齒輪與驅動鏈條。
- ◆ Clean & lubricate with oil to the lead screw monthly. 每月清潔及上油保養橫移螺桿。



Lead Screw
螺桿



Keep the floor clean after work
工作結束後須保持地板清潔

Air Compressor Maintenance (F.R.L)

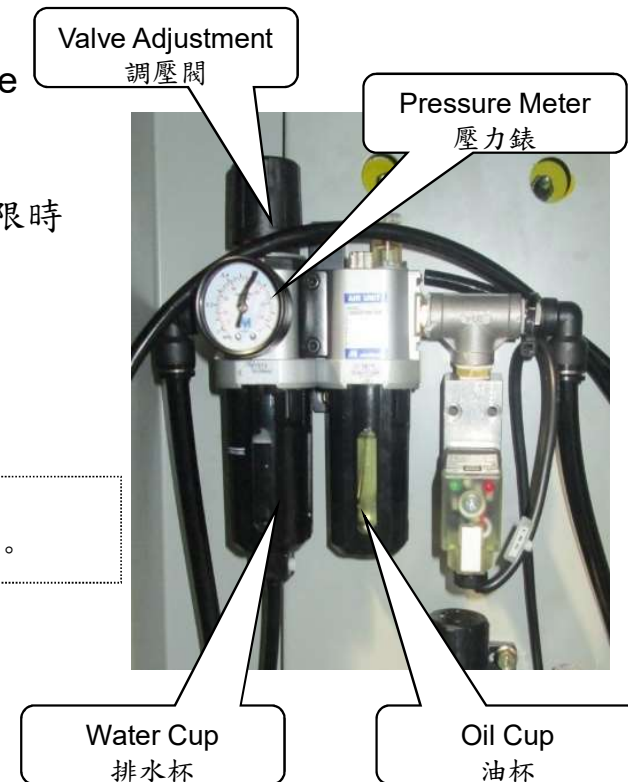
壓縮空氣清潔保養(三點組合)

Maintenance Items保養項目

- ◆ Drain the water from the water filter cup if water level up to the draining line.水位升高到排水線時，釋放排水杯內積水。
- ◆ If the oil is below the lower limit, fill it up.檢查潤滑油量低於下限時補充。
- ◆ Inspect the air pressure: about $4.5\sim 6\text{kg}/\text{cm}^2$.檢查空氣壓力 $4.5\sim 6\text{kg}/\text{cm}^2$ 。

Caution要點說明

- ◆ The viscosity of the oil should be ISO 30.使用黏度指數ISOVG32潤滑油。

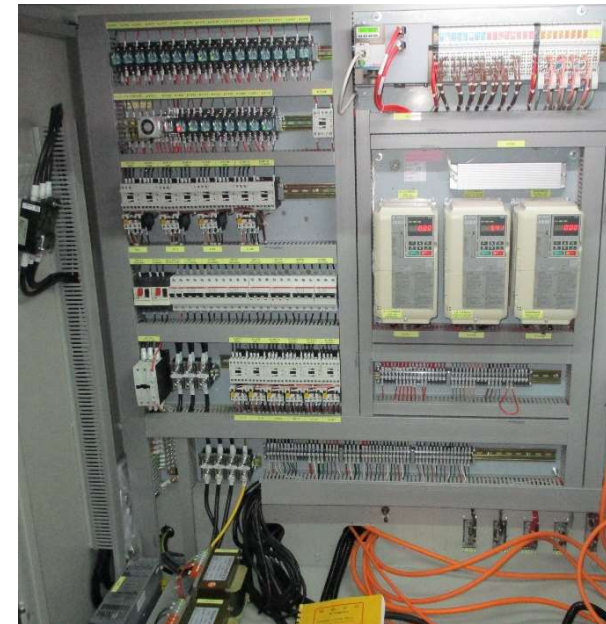


Electrical Cabinet Cleaning & Maintenance

電控箱清潔保養

Maintenance Items保養項目

- ◆ Weekly check the electrical cabinet such as PLC, Inverter, Resistor connected point whether loosen or any abnormal status.每週檢查電控箱內的主要電控制項如繼電器、變頻器、電阻等接觸點是否有鬆脫或異常狀況出現。
- ◆ Regular check all the connected wire whether worn out.定期檢查所有電線是否有損壞出現。
- ◆ Weekly use the air gun to blow out all the dust inside the cabinet.每週用氣槍將電控箱內的落塵吹走。



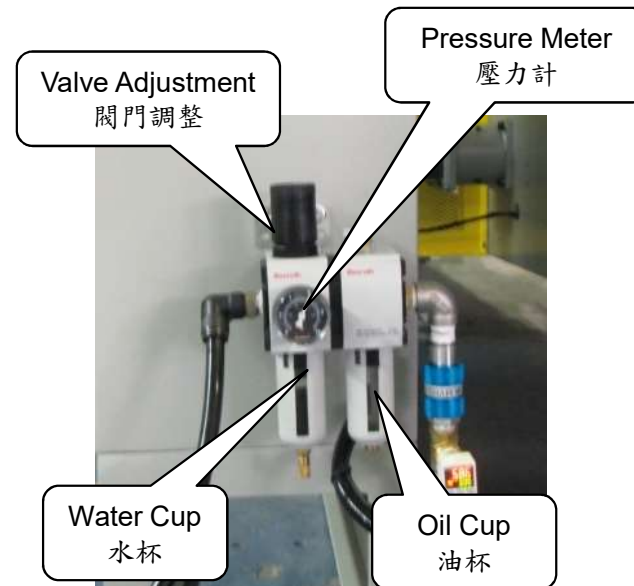


Folder Gluer Cleaning & Maintenance

糊箱機清潔及保養

Daily Inspection每日檢查

- ◆ Examine the barometric pressure is enough or not. If the pressure is insufficient, the machine can't work. (See the following drawing) Standard pressure: 6Mpa.檢查氣壓是否充足，如果氣壓在不充足的情況下，機器無法運作(見下圖)。標準氣壓為:6Mpa
- ◆ Please release the barometric pressure at side after running, prevent extruding the belt for a long time. It may cause the belt loose and interfere the cardboard. (See the following drawing)工作完畢後將空氣排出以防止皮帶長時間被擠壓。因而造成皮帶鬆弛而干擾紙板運作(見下圖)。

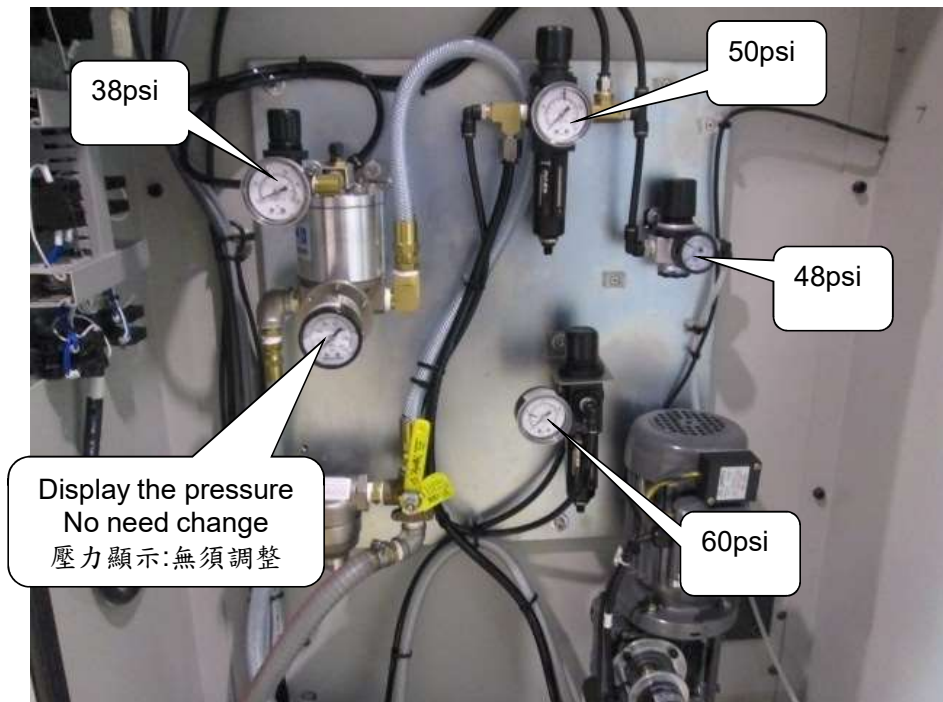


Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Pressure Setting 壓力設定

Daily Inspection 每日檢查

- ◆ Pressure setting inspection (See the following drawing) 壓力設定檢查.(見下圖) —Operator can adjust as need.
若須要操作者須作調整。

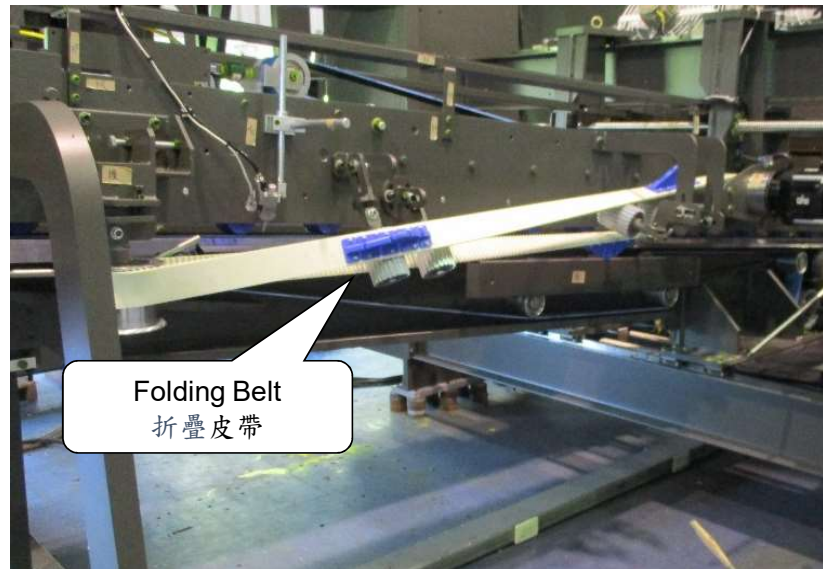


Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Folding Belt 折疊皮帶

Daily inspection 每日檢查

- ◆ Keep the path clean, make sure the folding part is at the correct location 保持動線清潔及確認折迭部份在正確的位置上。
- ◆ Examine whether the lock for belt is loose or not. 檢查皮帶扣是否有鬆弛。
- ◆ Examine whether the folding rod is at the correct location and the end face touching the cardboard is smooth or not. 檢查折紙桿是否在正確位置，而尾端接紙是否暢順。

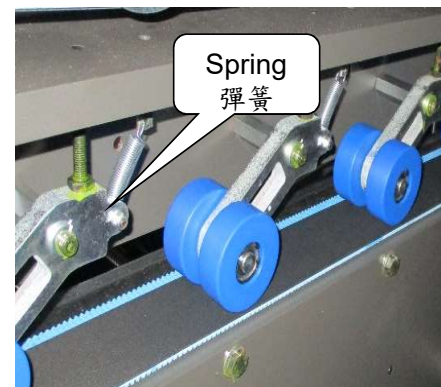
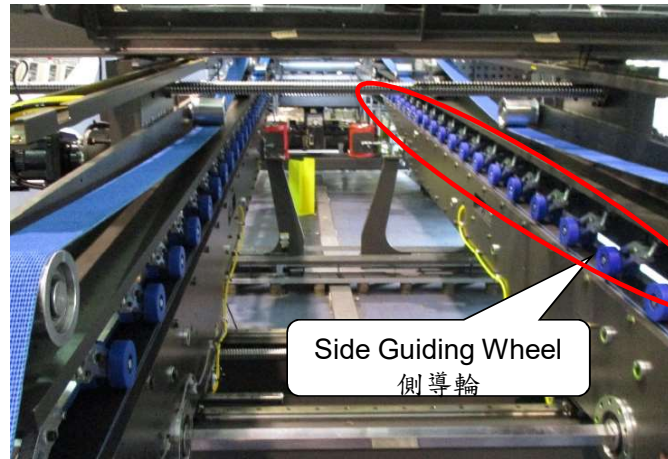


Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Side Guiding Wheel 側導輪

Daily Inspection 每日檢查

- ◆ Examine whether the spring of guiding wheel is damaged or not (See the following drawing) 檢查側導輪的彈簧是否有破損(見下圖)。
- ◆ Examine whether the guiding wheel are damaged or not. 檢查側導輪是否有破損。
- ◆ Run 1 minute with 30pcs/min, and examine whether the machine is normal or not. 測試運作一分鐘以每分鐘30張速度來測試,測試中檢查是否機器是否運作正常。



Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養 Rail Track And Lead Screw 鐵軌及螺桿

Daily Inspection 每日檢查

- ◆ After the work finished, clean all stations, in particular the linear rail track and lead screw
工作完畢後須將場地清潔特別是線性鐵軌及螺桿。
- ◆ Keep the lead screw clean at each part every day. 每天保持螺桿各部份清潔。
- ◆ Clean the track and lead screw before changing the order every time. 每次換單生產前都須確認螺桿清潔。

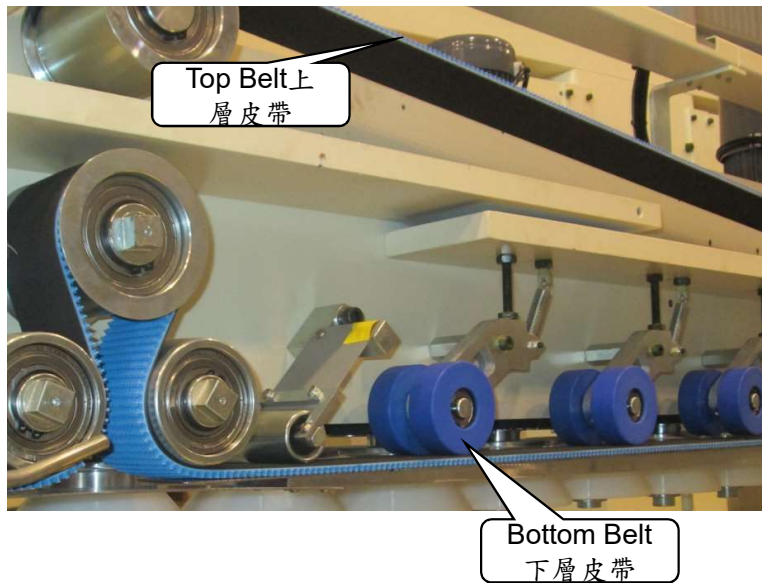


Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Belt 皮帶、Electric Cabinet 電控箱

Weekly Inspection 每週檢查

- ◆ Examine whether the belt is adjusted or not, don't tighten too much. (See the following drawing)
檢查皮帶是否已作調整，及確認皮帶不可太緊。(見下圖)
- ◆ Clean the electrical cabinet with pneumatic gun weekly. (Make sure whether the air is dry in the pneumatic gun)
每週用空氣槍去清潔電控箱(噴氣前須確認噴出的空氣沒含水份)。



Electric Cabinet 電控箱

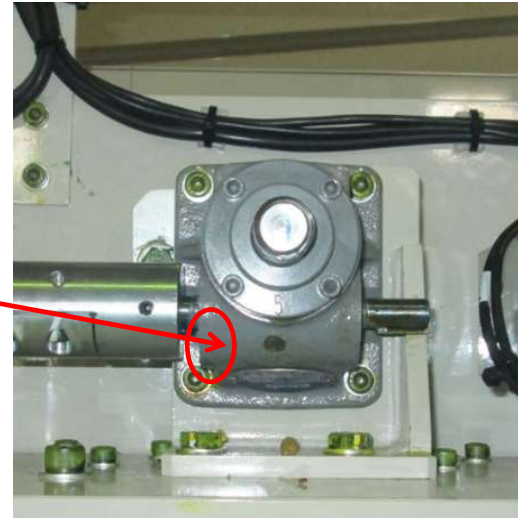


Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Grease Point 潤滑點

Weekly Inspection 每週檢查

- ◆ Lubricate the grease points weekly. 每週加黃油來潤滑



Folder Gluer Cleaning & Maintenance 糊箱機清潔及保養

Screw Check 螺絲檢查

Monthly Inspection 每月檢查

- ◆ Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage.

檢查螺絲是否有鬆脫或破損現象、如發現有鬆脫需立即收緊，若發現有破損時需立即更換。



Counter Cleaning & Maintenance 計數部清潔及保養

Belt 皮帶

Daily Inspection 每日檢查

- ◆ Before starting, examine whether there are foreign matters interfering beside the switch of belts.
每天運作前須檢查是否有異常會干擾皮帶旁邊的開關。



Conveyor Belt
皮帶

Counter Cleaning & Maintenance 計數部清潔及保養

Shaft 軸

Weekly Inspection 每週檢查

- ◆ Lubricate the grease points at driver side for counter.
計數部驅動側潤滑點須加潤滑劑。

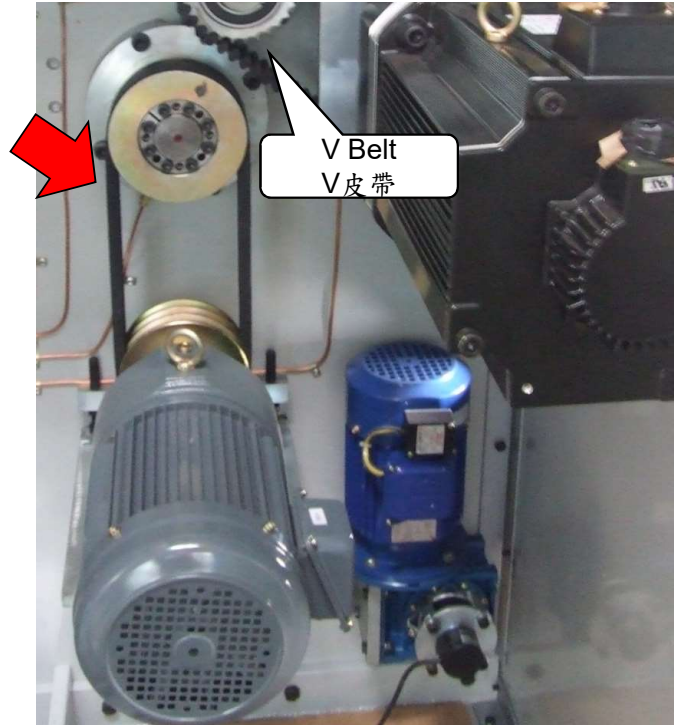


Counter Cleaning & Maintenance 計數部清潔及保養

V Belt 皮帶

Monthly Inspection 每月檢查

- ◆ Adjust and examine the V belt at motor every half year. (See the following drawing)
每半年調整及檢查馬達上的V皮帶。

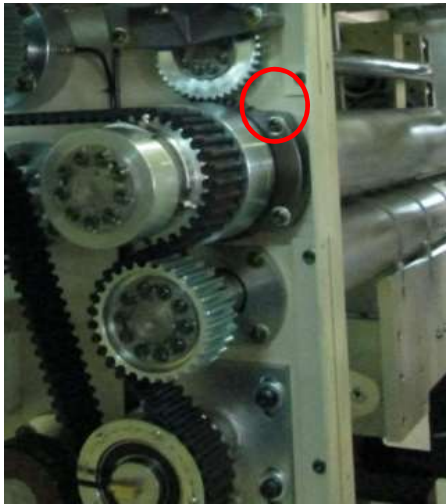


Counter Cleaning & Maintenance 計數部清潔及保養

All Screw Check 所有螺絲檢查

Monthly Inspection 每月檢查

- ◆ Examine all the screws whether loosen or damaged. If found the screw loosen, it must tighten it, replace it when found damage. 檢查螺絲是否有鬆脫或破損現象、如發現有鬆脫需立即收緊，若發現有破損時需立即更換。





Oil Type And Quantity

油品型號與油量

Oil Type 型號	Brand (Suggested) 品牌(建議)		Application 應用單元	Oil Change Time Schedule 油品更換時間
	Mobil	Shell		
Gear Oil 齒輪油	1. MOBILGEAR XP 220 2. MOBILUBE 220	OMALA HD 220	Main gearbox 主要齒輪箱 – Feeder/ Printer/ Slotter/ Die Cutter Units 進紙/印 刷/開槽/模切 單元	6 months fill oil up to middle of oil 6個月一 次注油至油鏡中線
Gear Oil 齒輪油	3. MOBILGEAR 600 XP220 4. MOBILUBE GX 80W-90		Sun Automation – Lead Edge Feed transmission gear box 前緣進紙齒輪箱	6 months fill oil up to middle of oil 6個月一 次注油至油鏡中線
Hydraulic Oil 液壓油	MOBILDTE 24	TELLUS 32	1. Hydraulic Cylinder 液壓缸 – Die Cutter Unit 模切 單元 2. Pneumatic F.R.L. (Filters, Regulators, Lubricators) Unit 氣壓 F.R.L. 三點組合(過濾, 調節, 潤滑)	Top up to 80% 注油 至80%
Gear Oil 齒輪油	MOBILGEAR 634	OMALA 460	Worm gear reducer 齒輪減速機	Top up to 80% 注油 至80%
Grease 黃油	MOBILUX EP0	ALVANIA EP R0	Small gear reducers 減速機之齒輪	Top up when insufficient 注油當油 量不足時
Grease 黃油	MOBILUX EP2 MOBILGREASE 77	ALVANIA EP 2	Grease nipples - Bearings 潤滑點 – 培林	Top up when insufficient 注油 當油量不足時

According to the information from supplier, the above oil can work normally till -10°C. We suggest you to find a suitable supplier locally and have their suggestion to select one kind of suitable oil to use. 根據供應商的資訊，以上油品可以在-10°C下正常工作。我們建議客戶可以找當地油品供應商，以便找一款合適當地環境使用的機油。