

長聲工業股份有限公司  
**SUNRISE PACIFIC CO., LTD.**

校正手冊

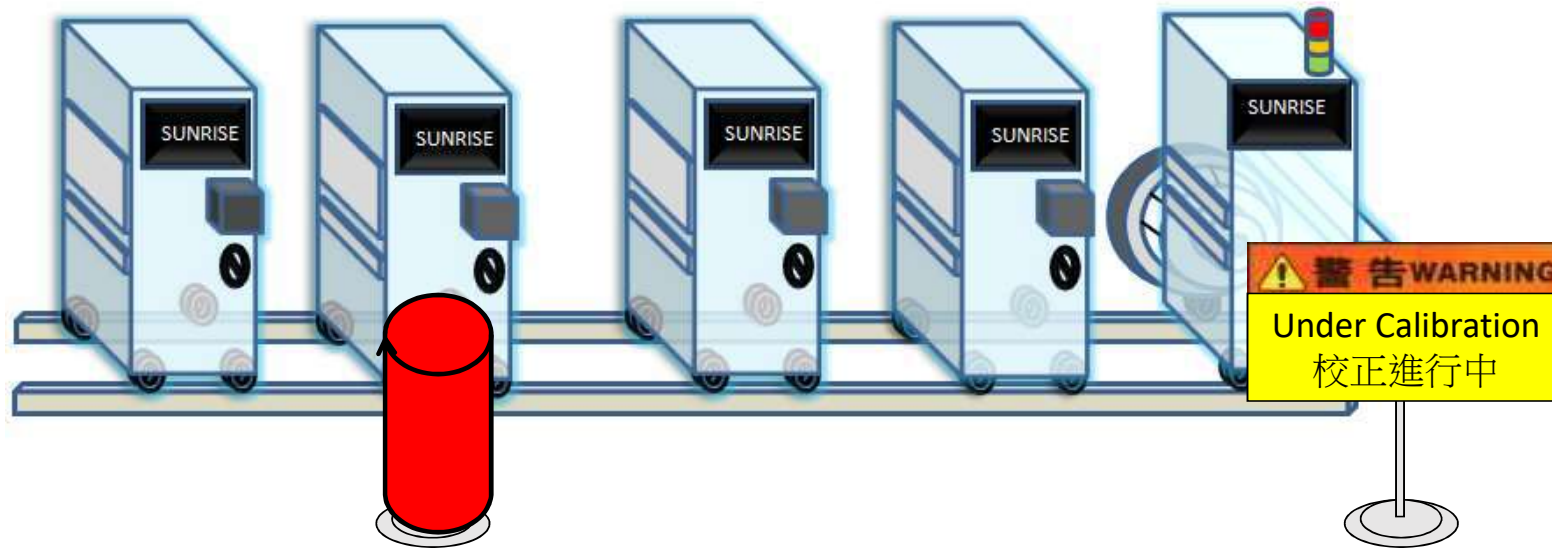
Model 機種型號：S-1000型 (S-1227系列)





# Safety Alert 安全注意

1. 進行機台校正時務須確認機台已完全停止運轉  
(Machine must stop)
2. 擺放警示牌，提醒非相關人員禁止觸碰機台  
(Place warning signs, non-related personnel are prohibited from touching the machine)
3. 擺放警示燈，以閃爍方式提醒非相關人員禁止觸碰機台  
(Place warning lights, non-related personnel are prohibited from touching the machine)





# 送紙、進紙輪及前檔板間隙校正 Feed Roll & Gate Gap Calibration

**Feed Roll**



**Gate**





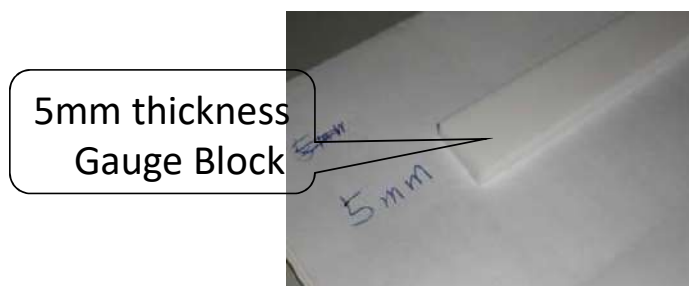
# 進紙輪間隙校正

## Feed Roll Gap Calibration

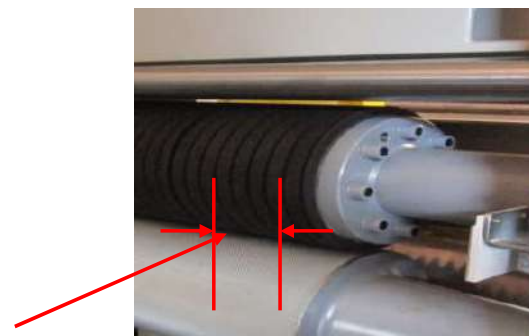
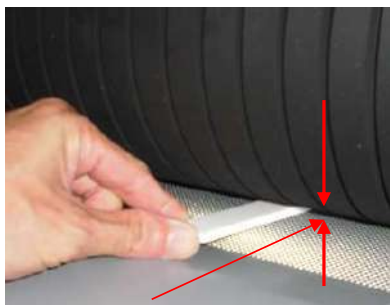


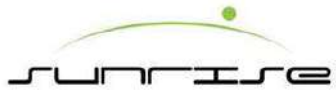
# 進紙輪間隙校正 Feed Roll Gap Calibration

1. 準備5mm厚薄規或內六角板手5mm ( Prepare a 5mm thickness gauge block (or 5mm allen key)



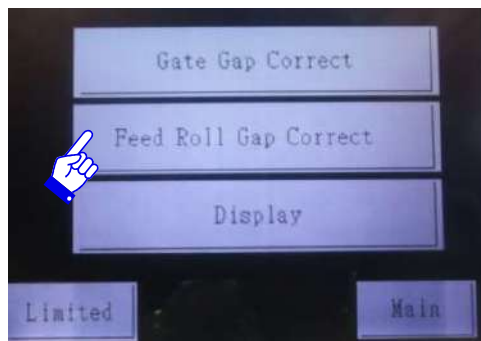
2. 調整到實際值是5mm。 (feed roll gap is adjusted to the actual value is 5mm)





# 進紙輪間隙校正 Feed Roll Gap Calibration

3. 接著到到人機(HMI)→參數設定(Parameter) (PW : 33850780) →進紙輪間隙設定(feed roll Gap correct) → 設定壓線破壞輪位置實際值(Set the actual value of the feed gap setting 5mm)



	0Initial	0.0	9	107	4.5	Pulse
1	32	0.5	10	115	5.0	100
2	47	1.0	11	129	6.0	Feed Roll Gap
3	58	1.5	12	145	7.0	4.4
4	68	2.0	13	162	8.0	Pulse Correct
5	75	2.5	14	183	9.0	0
6	84	3.0	15	205	10.0	Gap Correct
7	92	3.5				
8	100	4.0				



輸入5mm時的設定值：  
(Key in value of pulse setting 5mm)

EX : setting 115



# 進紙輪間隙校正

## Feed Roll Gap Calibration

4. 調整齒花盤至5mm後鎖上螺絲 ( adjust the dial scale to 5 mm, and tighten the screw )

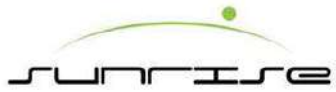




# 前檔板間隙校正

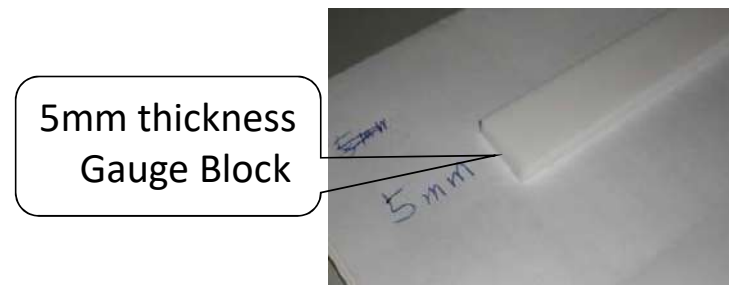
## Front Gate Gap Calibration





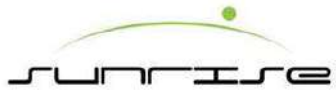
# 前檔板間隙校正 Front Gate Gap Calibration

1. 準備5mm厚薄規或內六角板手5mm (Prepare a 5mm thickness gauge block (or 5mm allen key))



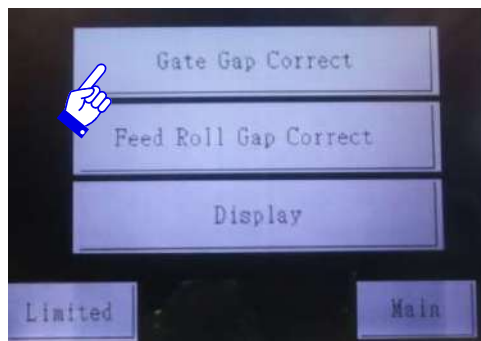
2. 調整到實際值是5mm。 (Front gate gap is adjusted to the actual value is 5mm)





# 前檔板間隙校正 Gate Gap Calibration

3. 接著到到入機(HMI)→參數設定(Parameter) (PW : 33850780) →前檔板間隙設定(Gate Gap correct) → 設定壓線破壞輪位置實際值(Set the actual value of the gate gap setting 5mm)



	Initial	0.0	9	107	4.5	Pulse
1	32	0.5	11	129	5.0	10.0
2	47	1.0	11	129	6.0	
3	58	1.5	12	145	7.0	
4	68	2.0	13	162	8.0	4.4
5	75	2.5	14	183	9.0	Pulse Correct
6	84	3.0	15	205	10.0	0
7	92	3.5				
8	100	4.0				

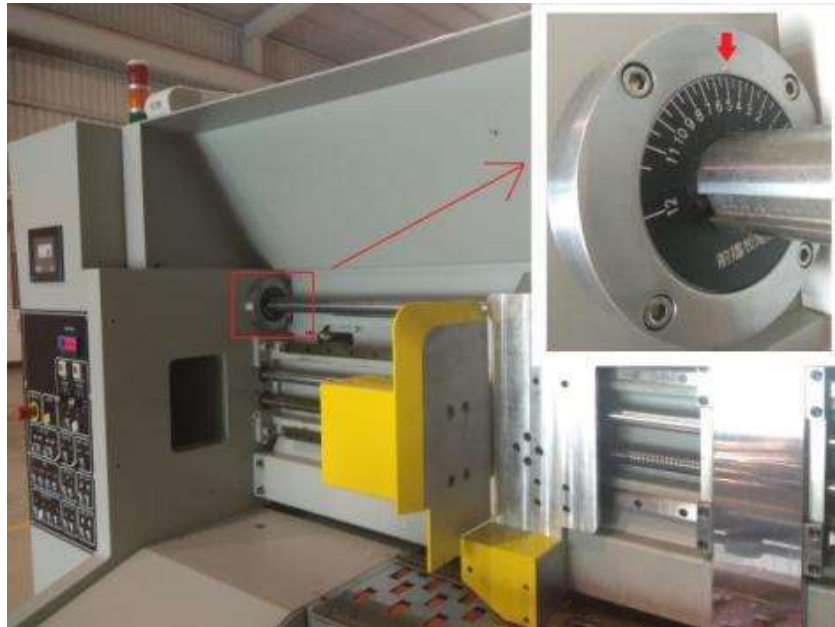


輸入5mm時的設定值：  
(Key in value of pulse setting 5mm)

EX : setting 112

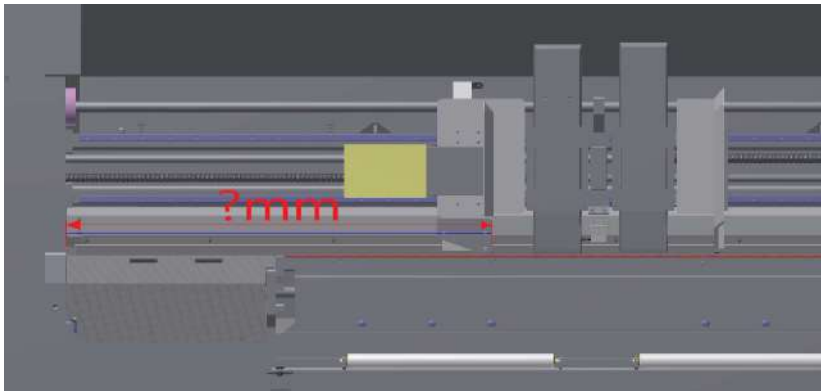
# 前檔板間隙校正 Gate Gap Calibration

4. 調整齒花盤至5mm後鎖上螺絲 ( adjust the dial scale to 5 mm, and tighten the screw )





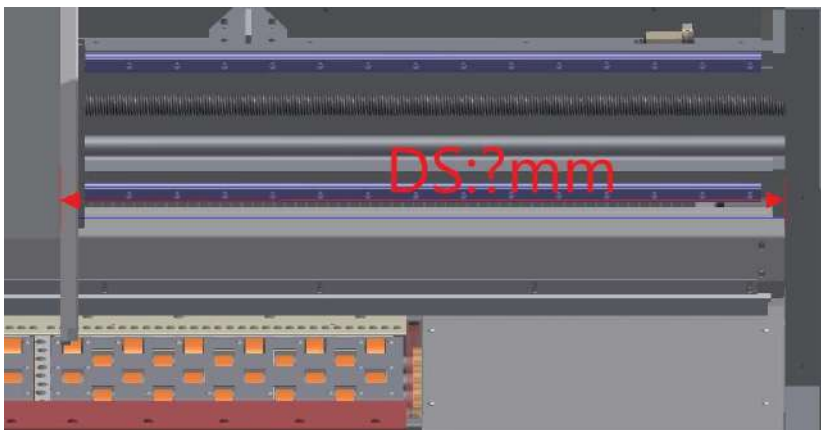
# 操作側 & 驅動側側拍板位置校正 Operation & Driver Side Guide Calibration



若機壁量測總長度為310cm (3100mm)時，其一半為  $(310/2) = 155 \text{ cm (1550mm)}$ ，注意這個數字只是機壁的中心線而並非機台的中心線。因此須在  $1550\text{mm} + 25\text{mm} = 1575\text{mm}$  才是真正的機台行紙中心線。

If Wall length total is 3100mm,so middle is 1550mm

1550mm is wall center , but real feeder center must plus 25mm 。 “1575mm”



從操作側內車壁量測至操作側擋板面尺寸為575mm時，操作側擋板位置為1000 ( $1575-575=1000$ )。

從驅動側內車壁量測至驅動側擋板面尺寸為525mm時，驅動側擋板位置為1000 ( $1525-525=1000$ )。



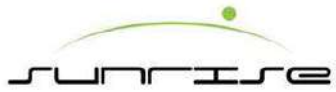
# 後擋板平行校正

## Back Stop Position Calibration



# 送紙後檔板平行校準 Back Stop Position Calibration





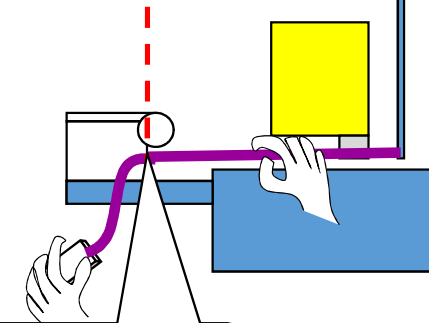
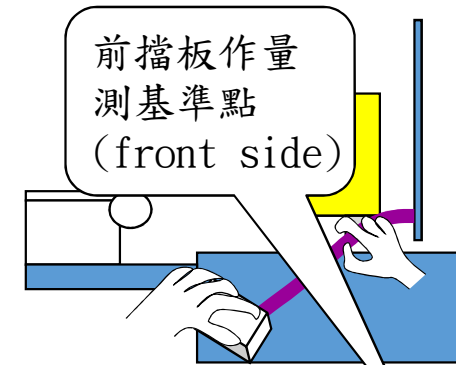
# 送紙後檔板平行校準 Back Stop Position Calibration

1. 準備一個卷尺來作距離量測。

Tape measure to measure distance



2. 量測實際距離 Actual measurement value





# 送紙後檔板平行校準

## Back Stop Position Calibration

3. 前檔板打開，直到可以量測兩側位置  
Open front gate , Until you can measure the position on both sides



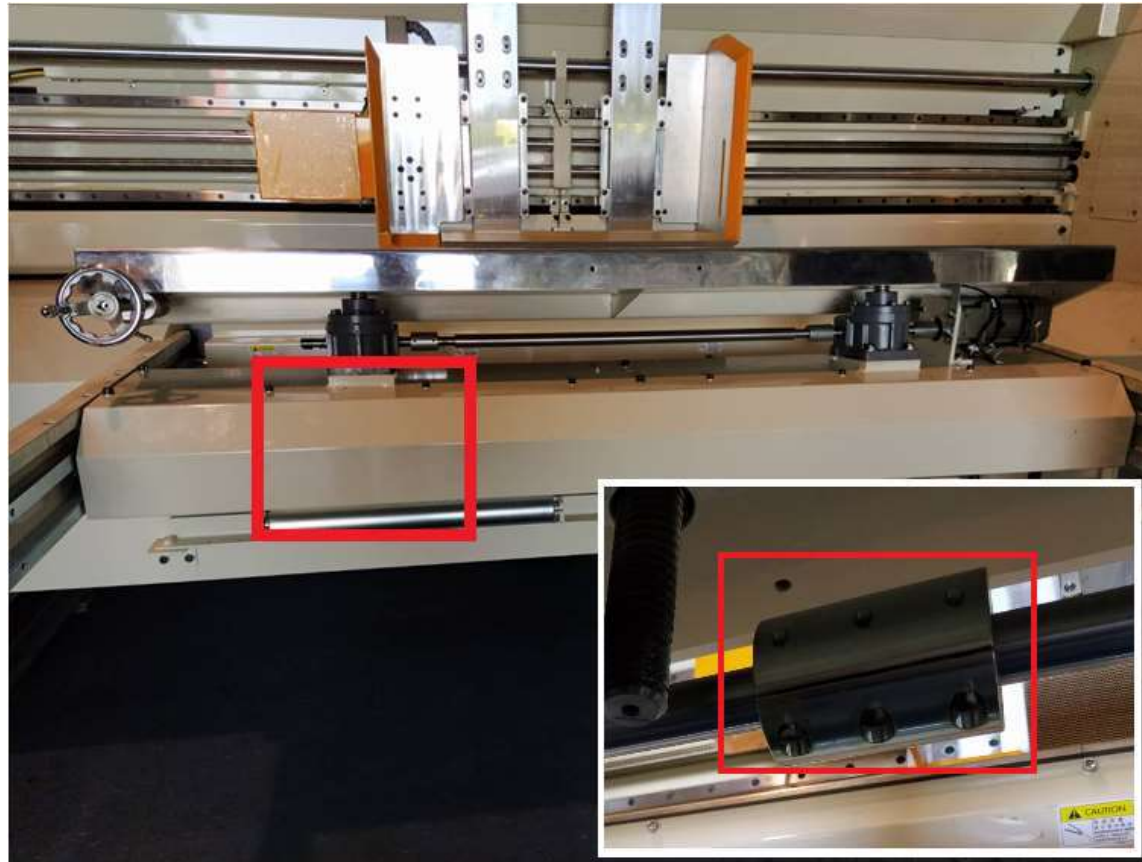




# 送紙後檔板平行校準

## Back Stop Position Calibration

4. 如果兩側有誤差，拆鬆聯軸器  
If there are errors on both sides, relax the coupling



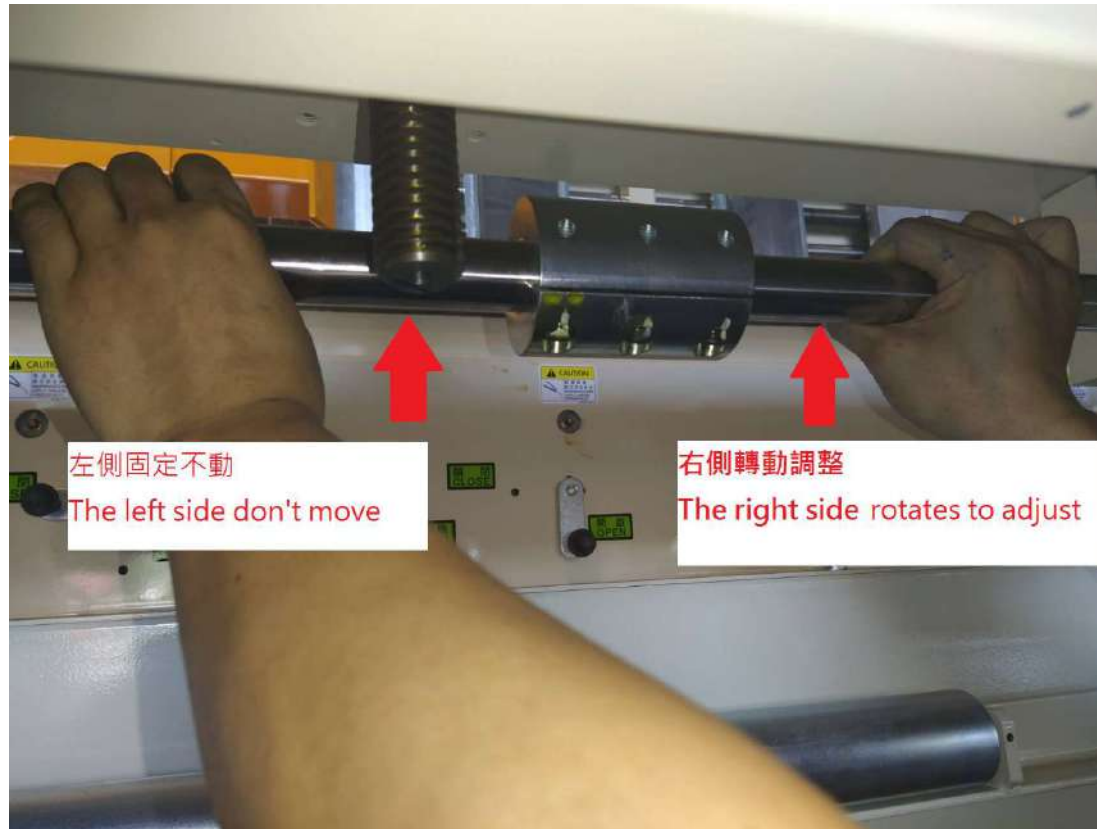


# 送紙後檔板平行校準

## Back Stop Position Calibration

5. 左側固定不動，右側轉軸轉動可調整後檔板前後，直到兩側數值平行

The left side does not move, the right shaft rotates to adjust the front and rear of back stop until the values on both sides are parallel



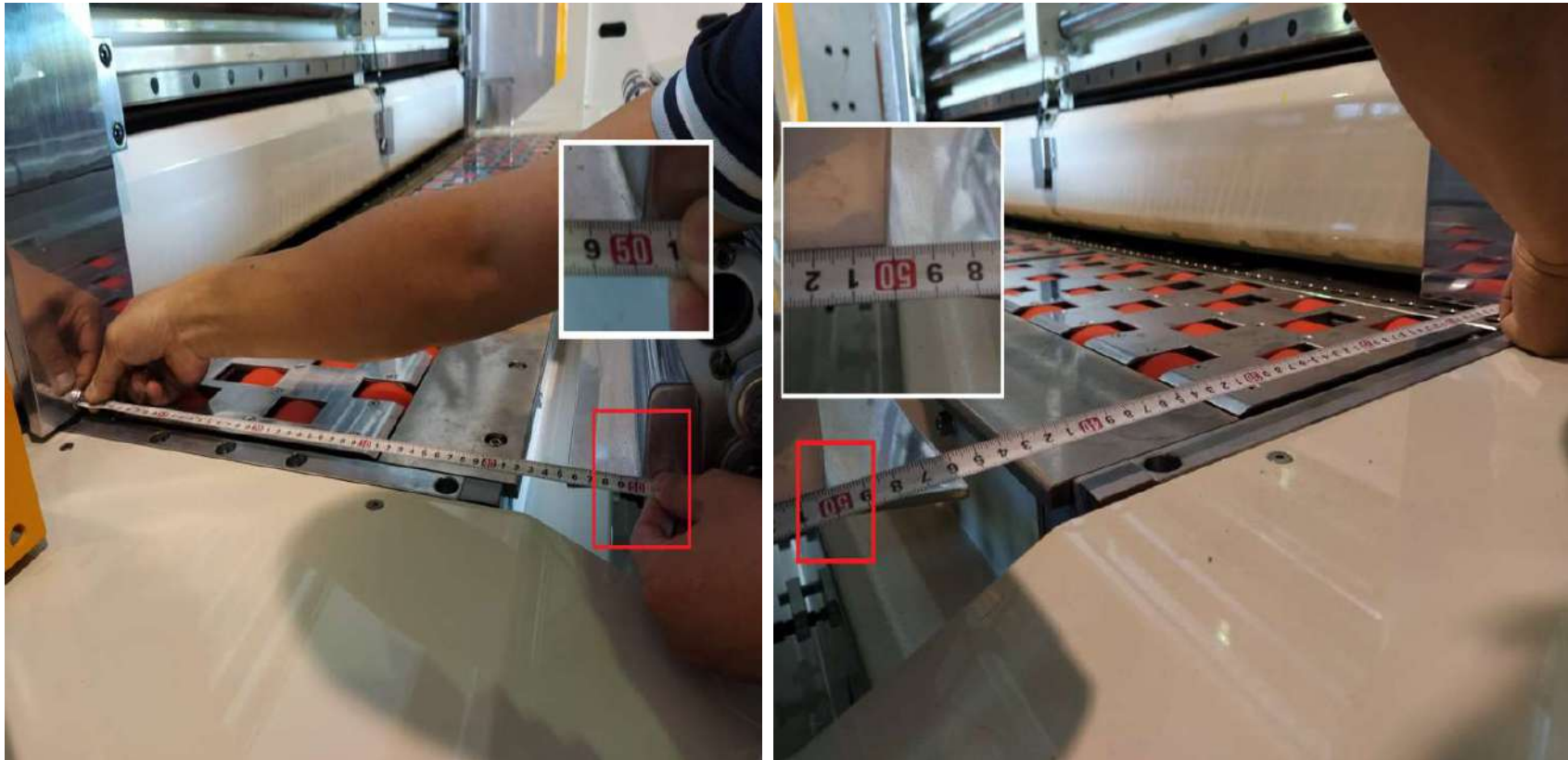


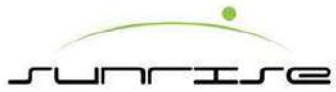
# 送紙後檔板平行校準

## Back Stop Position Calibration

6. 調整到正確位置後，鎖緊連軸器，並再次確認是否兩側平行

After adjusting to the correct position, lock the coupling and reconfirm whether the sides are parallel





# 送紙後檔板平行校準 Back Stop Position Calibration

7.接著到大人機(Main HMI)→參數設定(Parameter)→重設目前值position correct”

(PW : 33850780)→ 後檔板填入實際量測數值(back stop setting actual measurement value

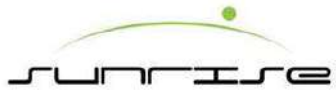


填入正確值  
(actual measurement value )

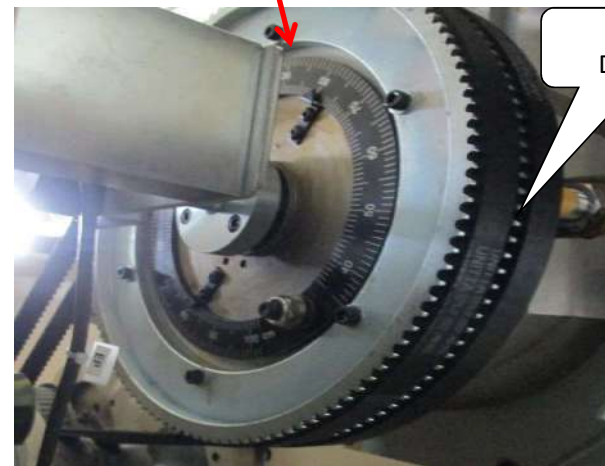
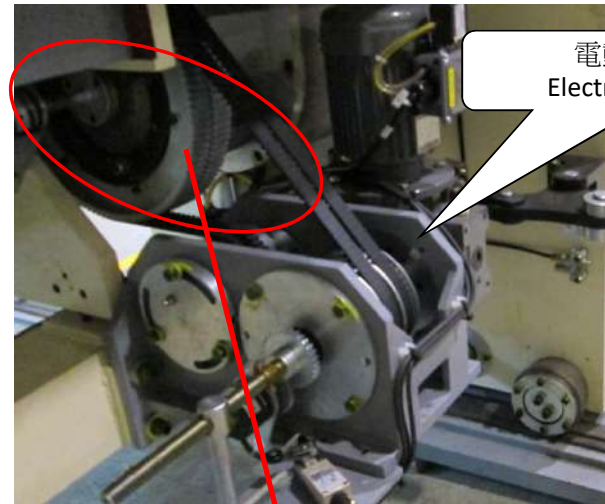


# 延伸量校正方式

## Electrical Extend Calibration



# 延伸量校正方式 Electrical Extend Calibration

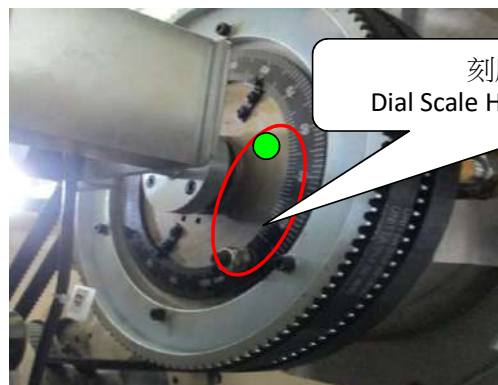




# 延伸量校正方式

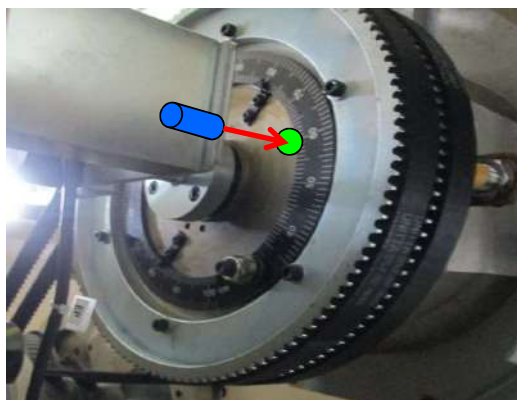
## Electrical Extend Calibration

1. 先按動面板上的延伸量按鈕“+”,或“-”,按動兩個刻度盤會同時開始轉動。  
Press the extend button “+”,or “-” so as to rotate both dial scale.

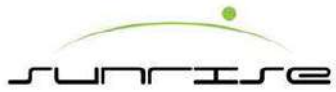


刻度盤孔道位置(參考)  
Dial Scale Hole Position (Reference Only)

2. Then the first step of setting finish. 反弓刻度盤會轉動到一定時,用一根膠管或鉛子筆插入刻度盤的孔道內. 若膠管或鉛子筆能順利貫穿兩個 刻度盤的孔道(參考下圖),初步調整完成  
When the dial scale rotate to certain distance, and use a rubber pipe or pencil t insert to the hole (see below illustration) .



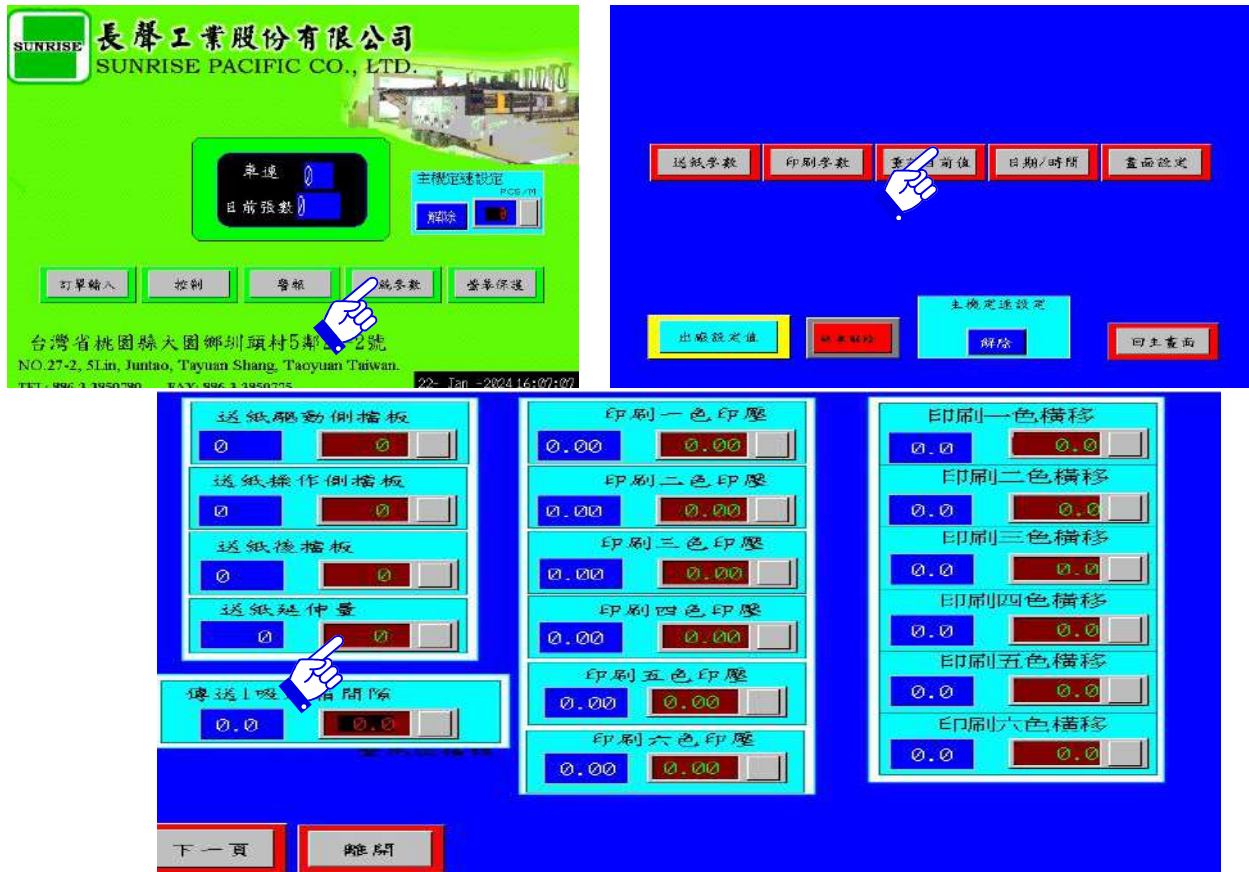
膠管或鉛子筆貫穿兩個刻度盤孔道  
Rubber pipe or pencil insert to  
the hole and can pass through dial scale



# 電動延伸量調整方式

## Electrical Extend Setting Method

3. 接著到大人機畫面，將延伸量畫面開出來，確認延伸量數值為500 (範圍498 ~ 502).  
Then go to the main HM, and bring out the extend screen refer below illustration.  
The extend position should show 500 (range 498 ~ 502).



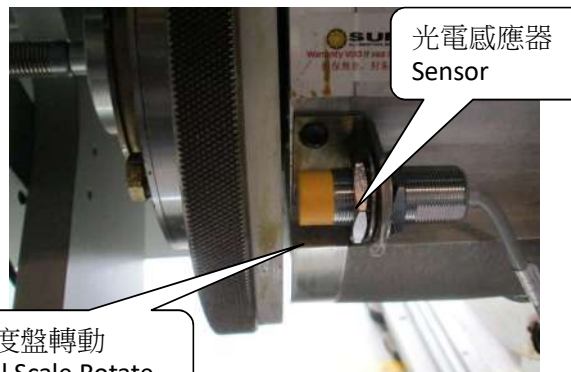
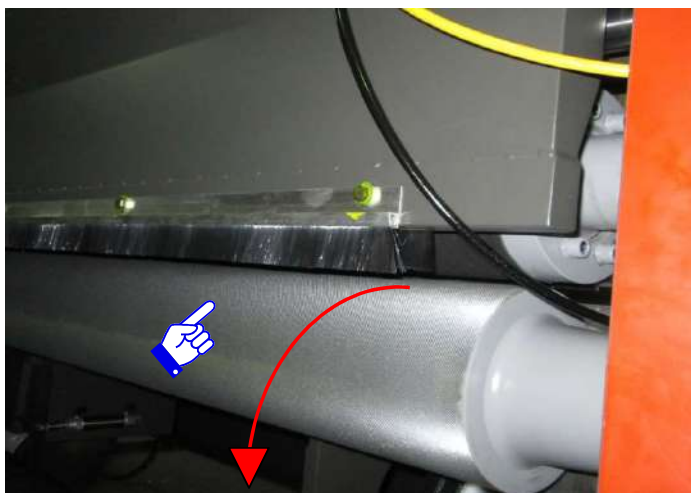




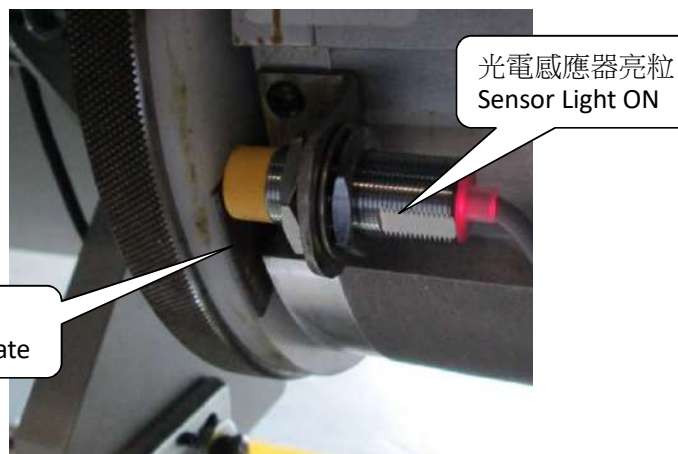
# 進紙輪方向調整

## Feed Roll Setting Method

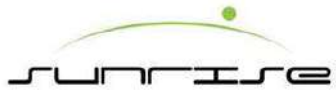
4. 接著用雙手轉動進紙輪. 此時刻度盤開始轉動, 轉動中直到刻度盤的鐵片出現. 此時該光電感應器便會亮燈起來  
Then, use both hand to rotate the feed roll until the iron plate appear and the sensor light is ON.



刻度盤轉動  
Dial Scale Rotate



刻度盤的鐵片  
Dial Scale Iron Plate



# 主相位譯碼器調整

## Main Register Encoder Setting

5. 接著用手轉動譯碼器。轉動直到將延伸量畫面內的大相位數值為"0" 便完成。  
Finally, rotate the encoder and check the extend screen again. When the Register column appear 0. It means the setting finish and set to zero.



送紙部			印刷部			開槽部		
進紙輪間隙	0.6	2.5	一色相位	222.9	969	開槽相位	223	970
驅動側擋板	567	563	一色印壓	3.00	3.00	紙箱高度	586	586
操作側擋板	654	658	二色相位	222.9	969	破環輪間隙	1.2	1.2
后擋板	563	569	二色印壓	2.00	2.00	壓線輪間隙	0.9	0.9
前擋板	0.7	3.0	三色相位	222.9	969	開槽刀間隙	4.6	4.0
Extension	500	563	三色印壓	1.00	1.00	刀1	365.0	365.0
Register	0		四色相位	222.9	969	刀2	666.0	666.0
			四色印壓	4.00	4.00	刀3	598.0	598.0
						刀4	256.0	256.0
						刀5	785.0	785.0

Control buttons: 排單 (Queue), 停止自動 (Stop Auto), 儲存訂單 (Save Order), 下一頁 (Next Page), 回主畫面 (Return to Main Screen)



# 送紙柵欄間隙校正方式 Grate Gap Calibration

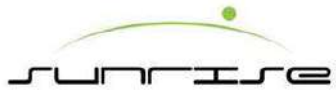


# 送紙柵欄間隙校正方式

## Grate Gap Calibration

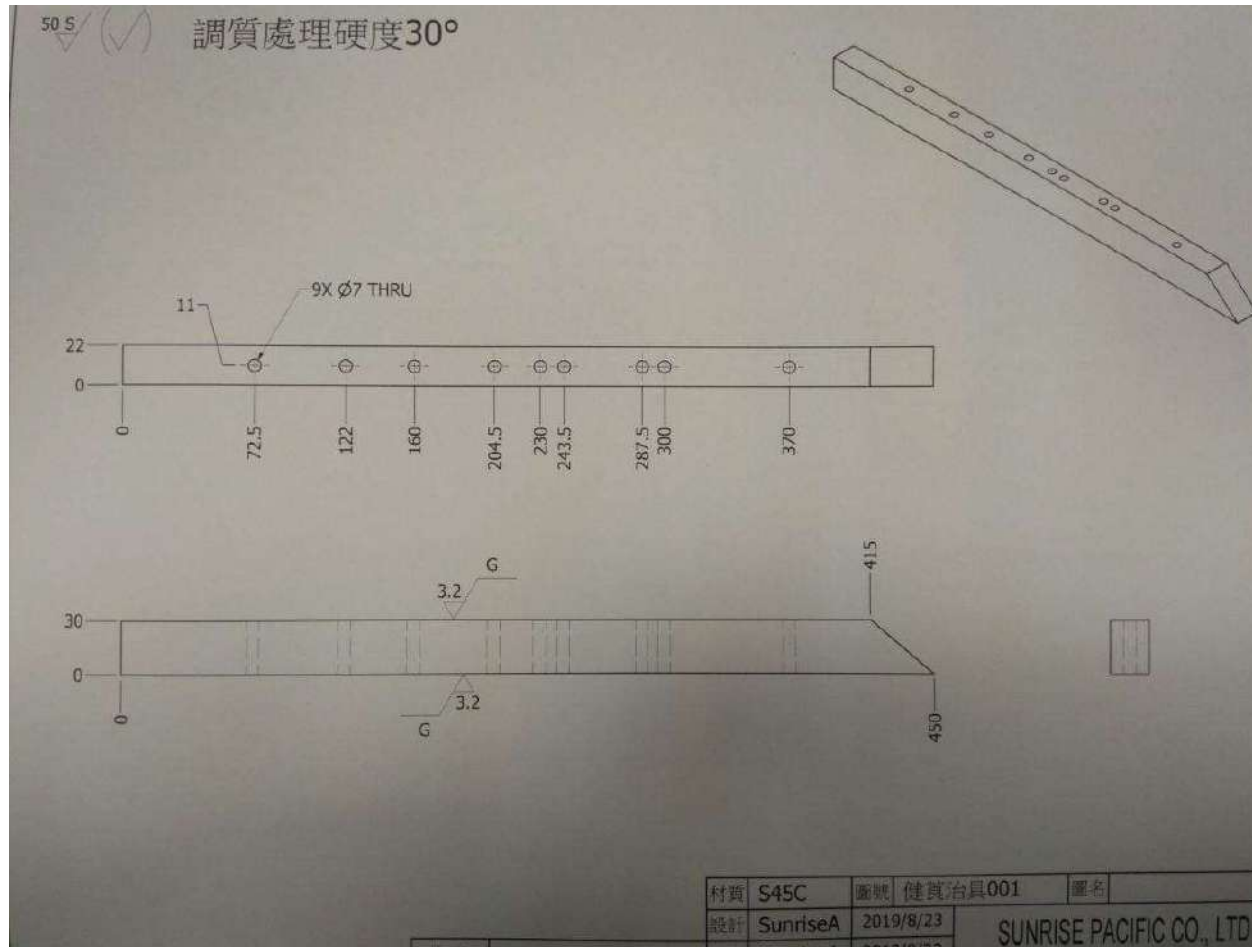
1. 準備0.4mm厚的厚薄規 ( Prepare a 0.4mm thickness gauge block )  
14mm內六角板手 ( 14mm thickness spanner )  
千分表 ( Indicator )

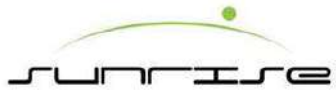




# 送紙柵欄間隙校正方式 Grate Gap Calibration

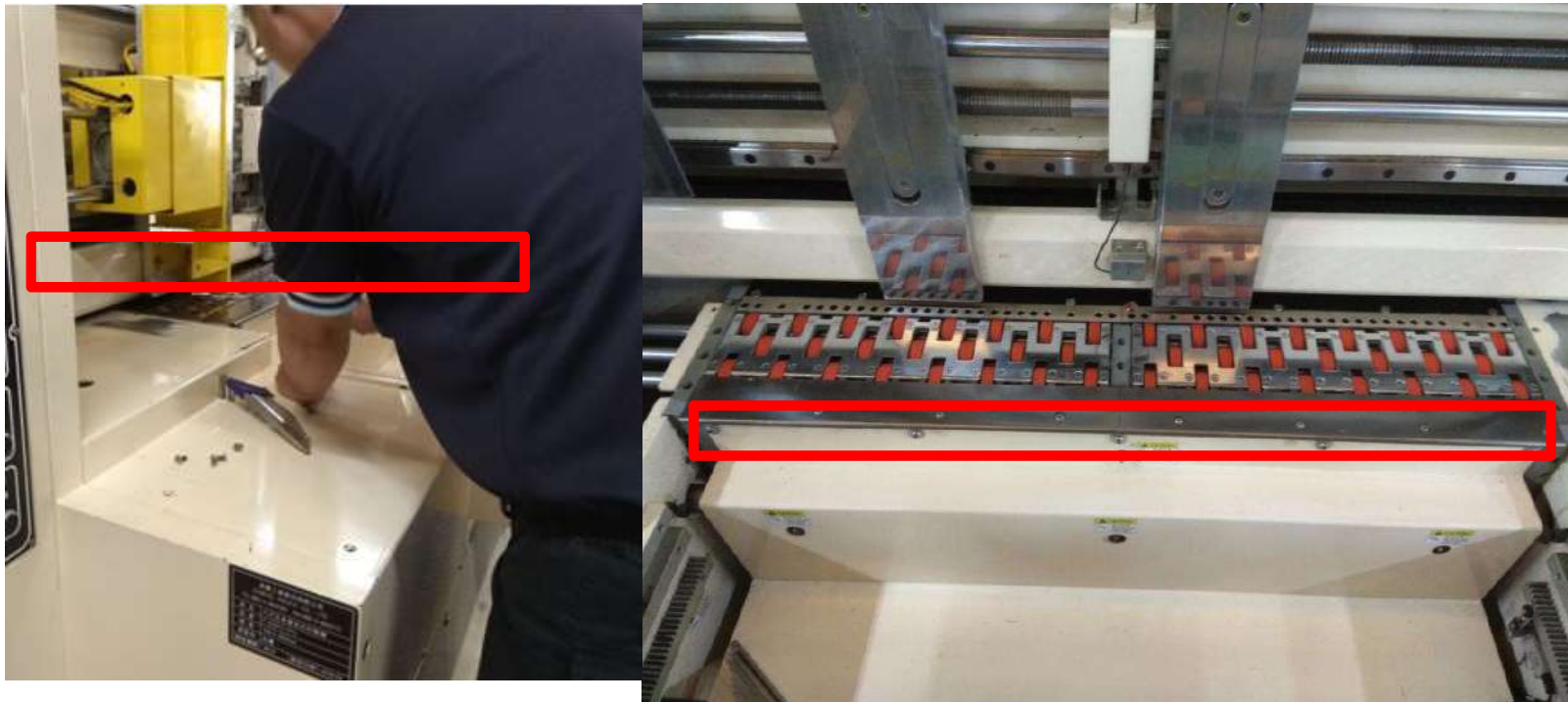
## 2. 校正治具( Calibration Jigs)





# 送紙柵欄間隙校正方式 Grate Gap Calibration

3. 拆除蓋板 (Remove the cover)

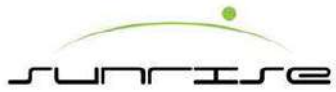




# 送紙柵欄間隙校正方式 Grate Gap Calibration

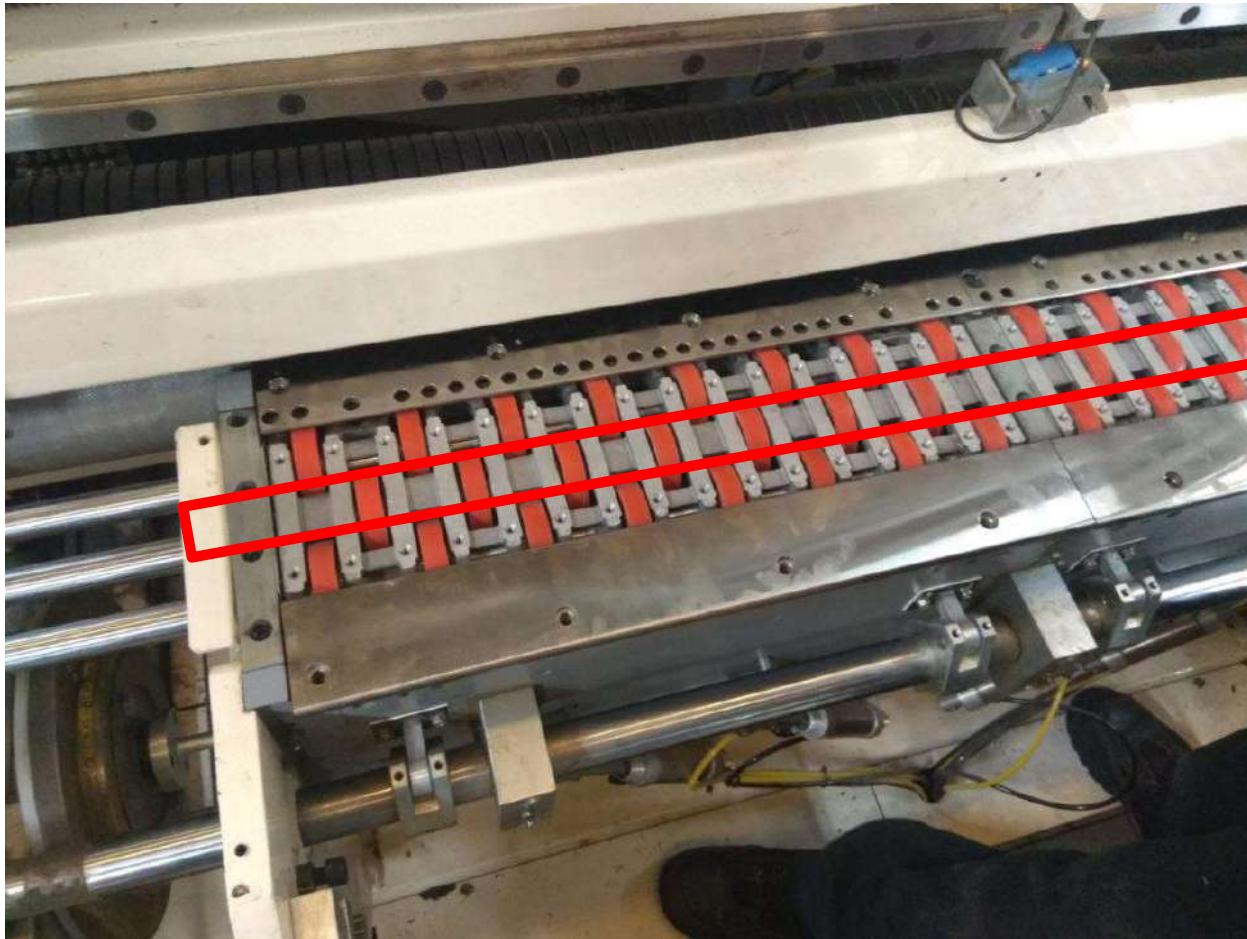
## 4. 拆除螺絲 (Remove the screw)



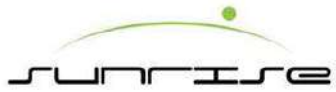


# 送紙柵欄間隙校正方式 Grate Gap Calibration

5. 拆除柵欄滑板 (Remove the cover)



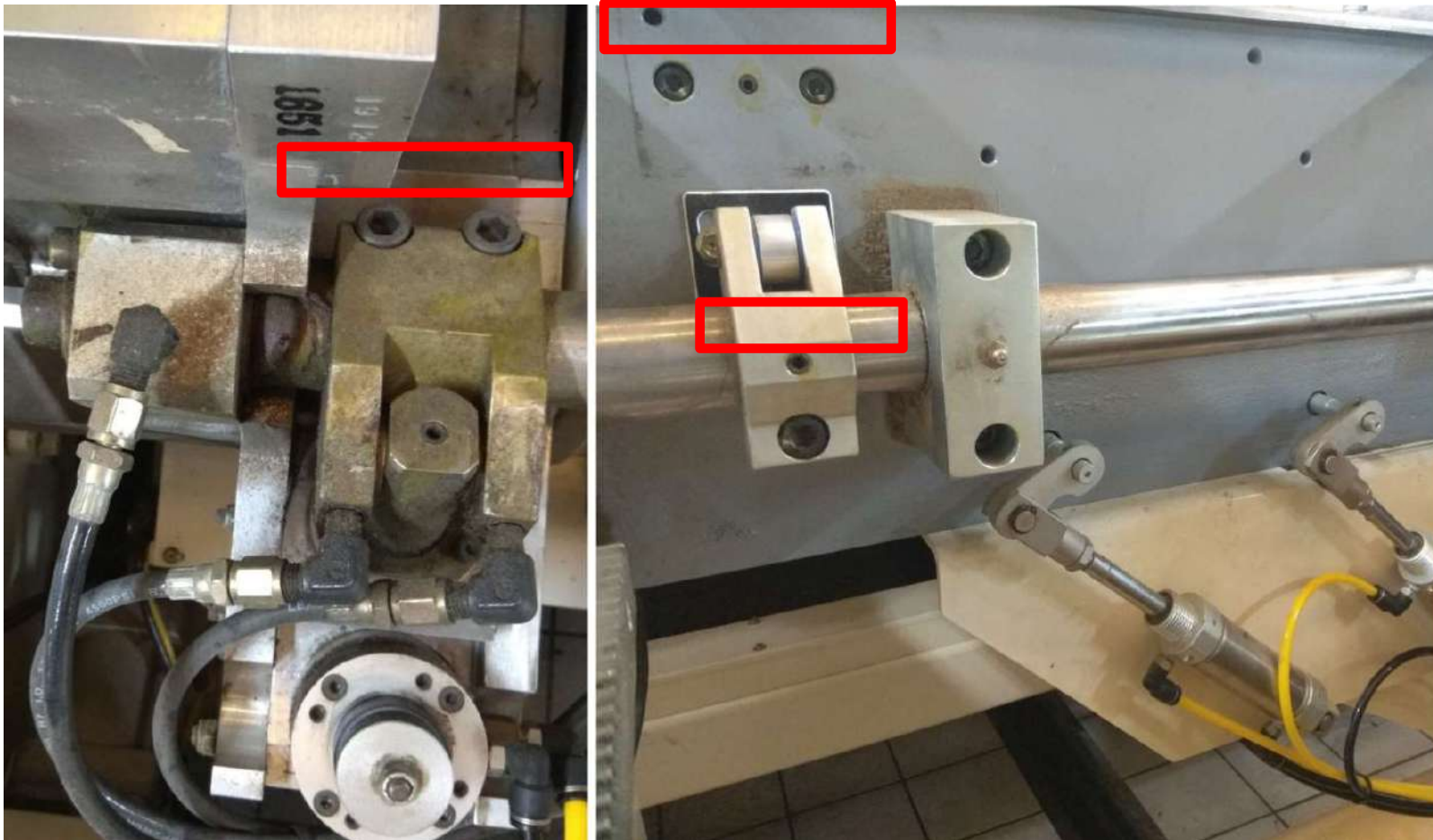


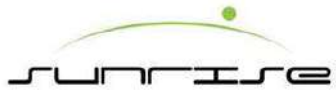


# 送紙柵欄間隙校正方式

## Grate Gap Calibration

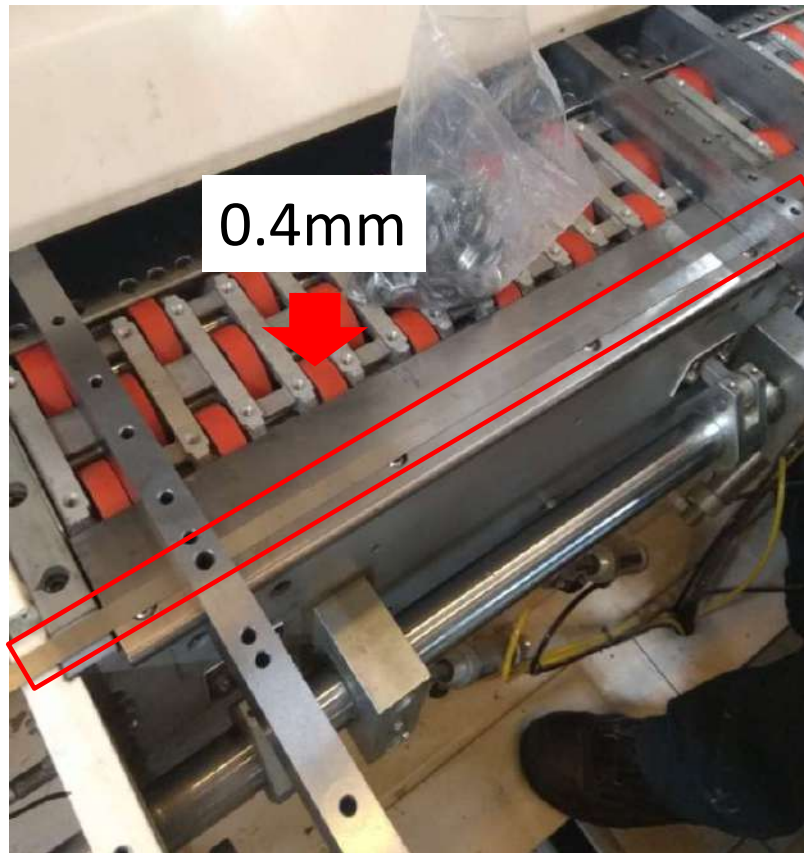
6. 放鬆出力軸固定螺絲 (loose output shaft screw)



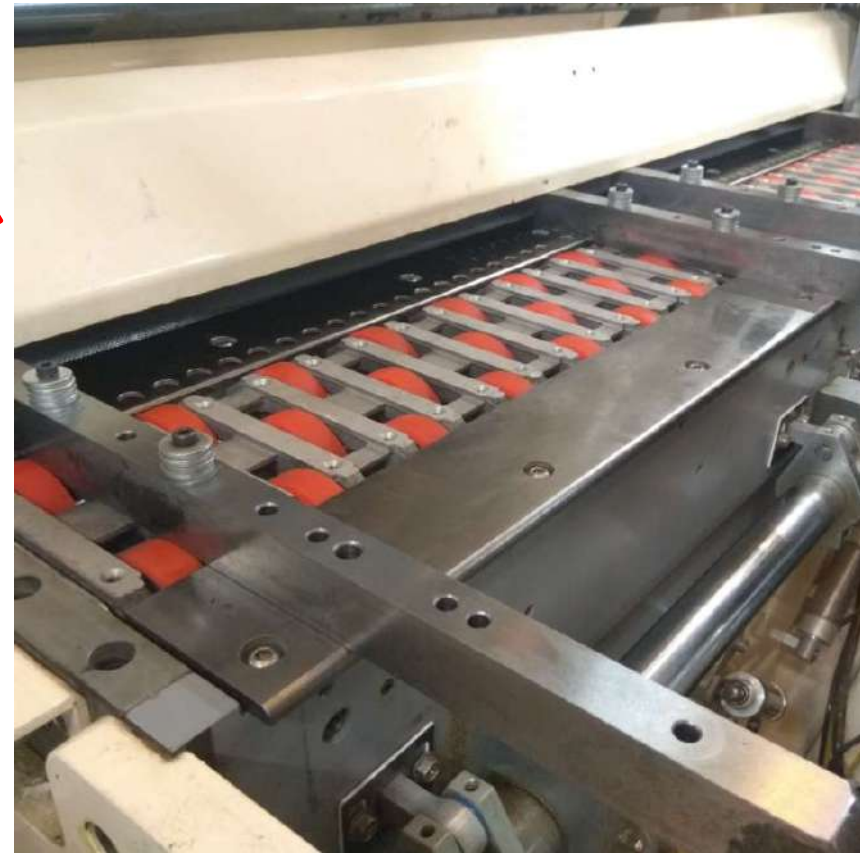


# 送紙柵欄間隙校正方式 Grate Gap Calibration

7. 確認機型及對應校正治具(Confirm the model and the corresponding the calibration Jigs )



For S-1227、F-925、S-925、S-1628

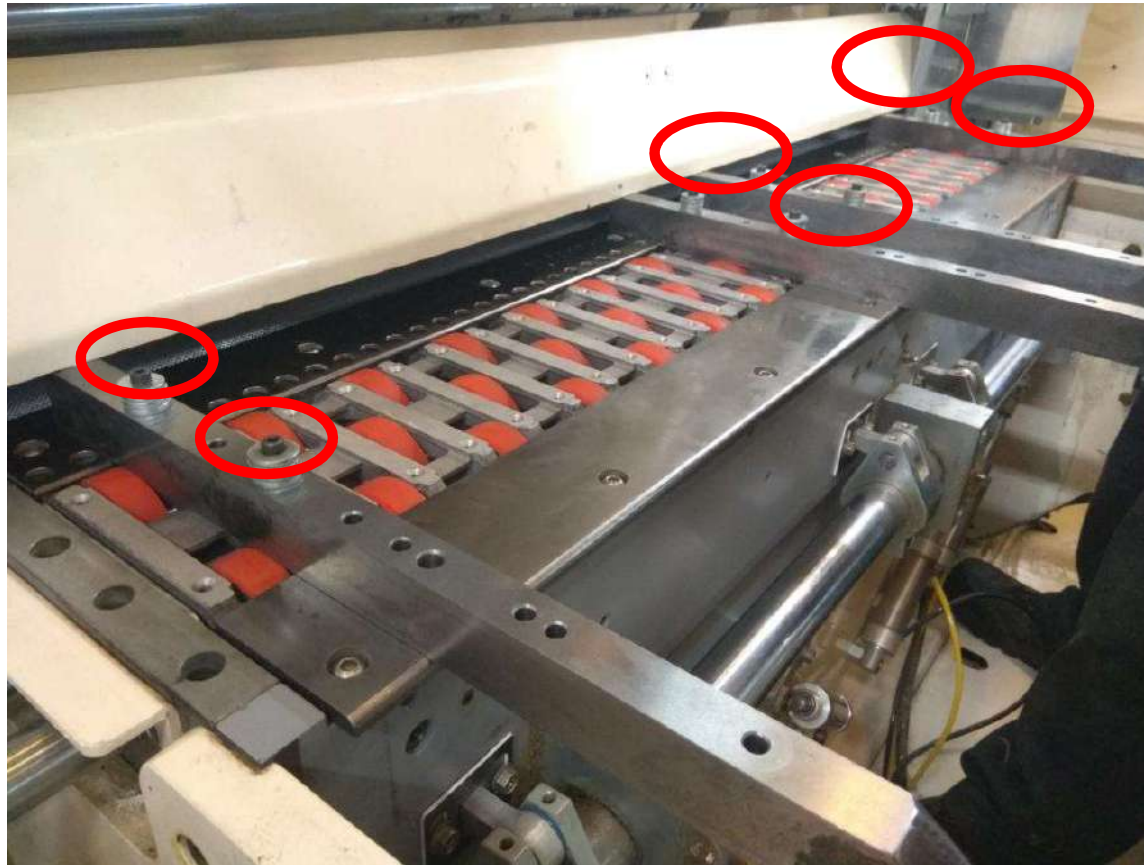


For F-618



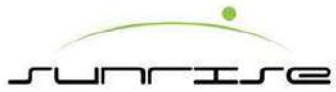
# 送紙柵欄間隙校正方式 Grate Gap Calibration

8. 柵欄兩側平均的鎖上螺絲 (Average locking screw on both sides of the fence)



M5\*45(+1 thick washer) or  
M5\*55(+3 thick washer)

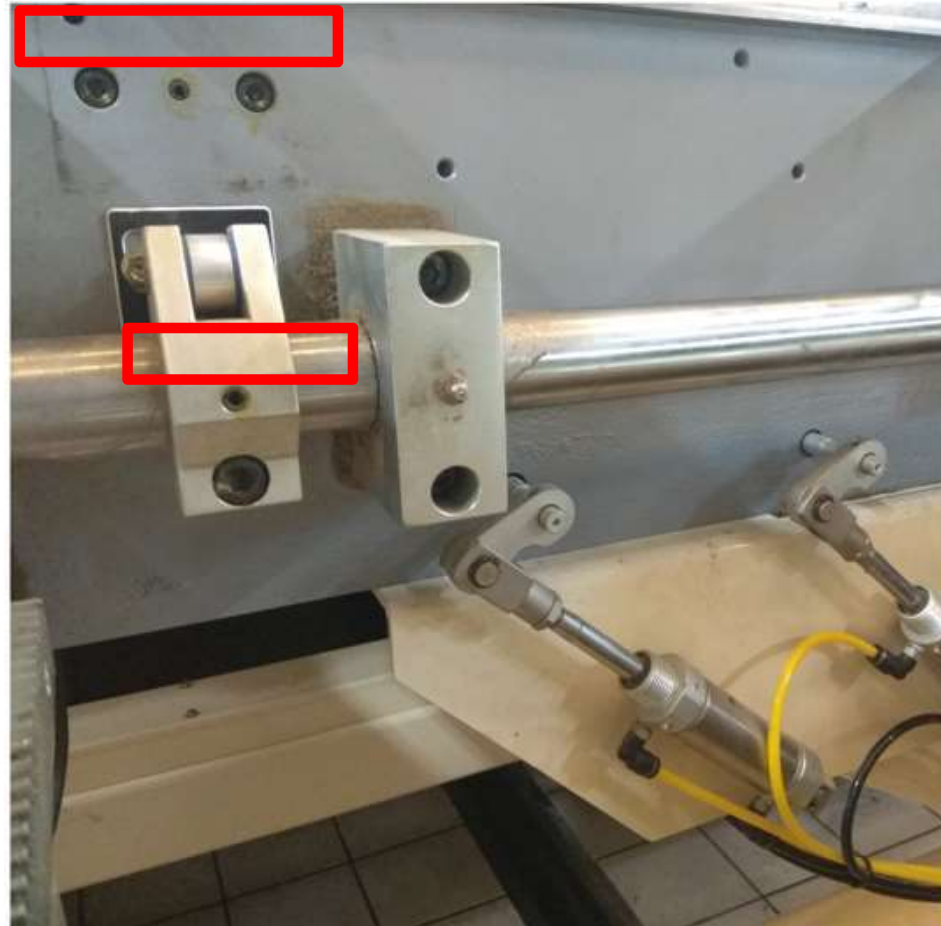




# 送紙柵欄間隙校正方式 Grate Gap Calibration

9. 治具螺絲鎖緊後，鎖上出力軸螺絲 (locking calibration jigs screw and output shaft screw)

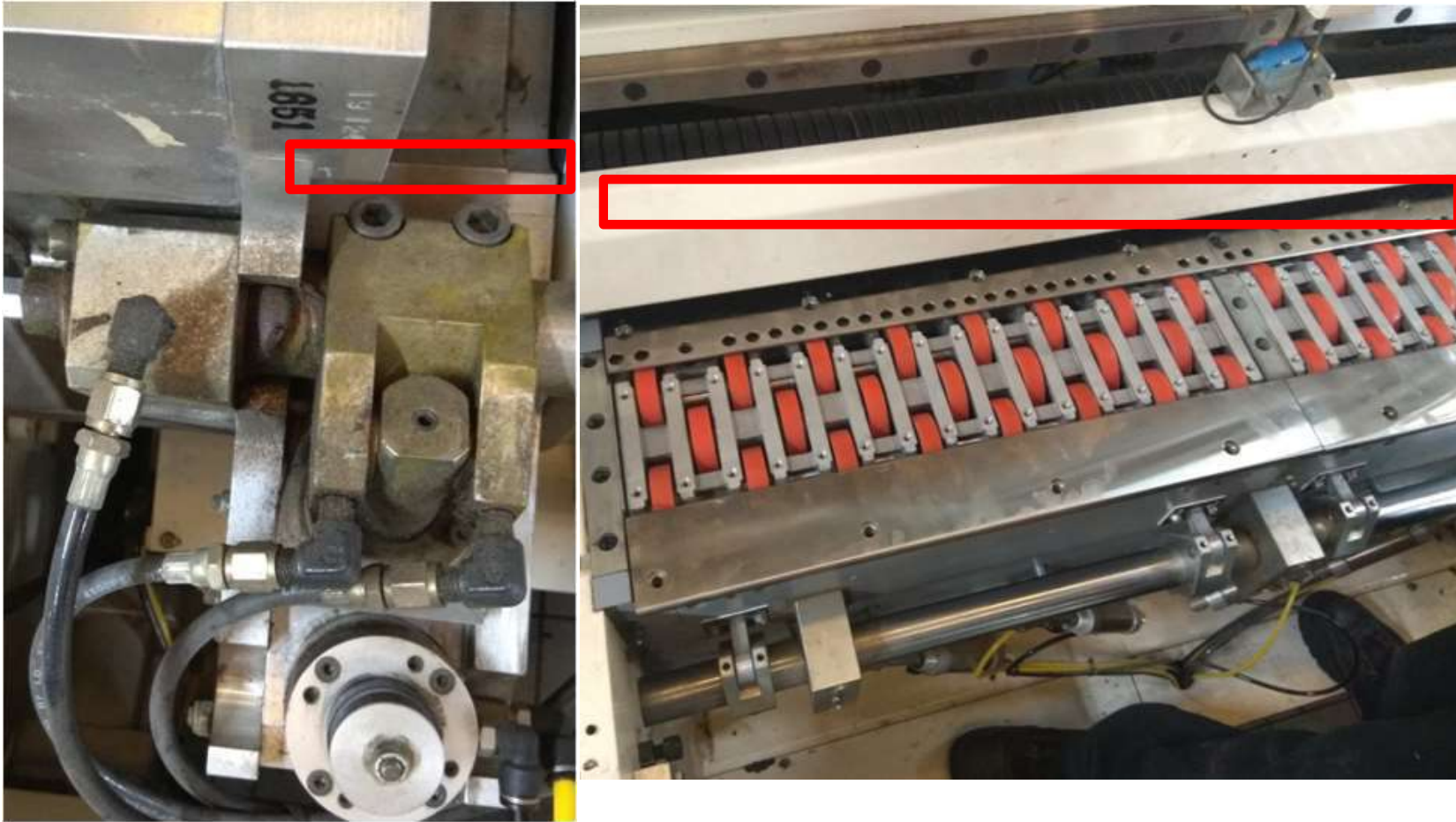
手動壓著固定板後再鎖螺絲  
(Manually press the fixing plate  
and then lock the screw) ↓





# 送紙柵欄間隙校正方式 Grate Gap Calibration

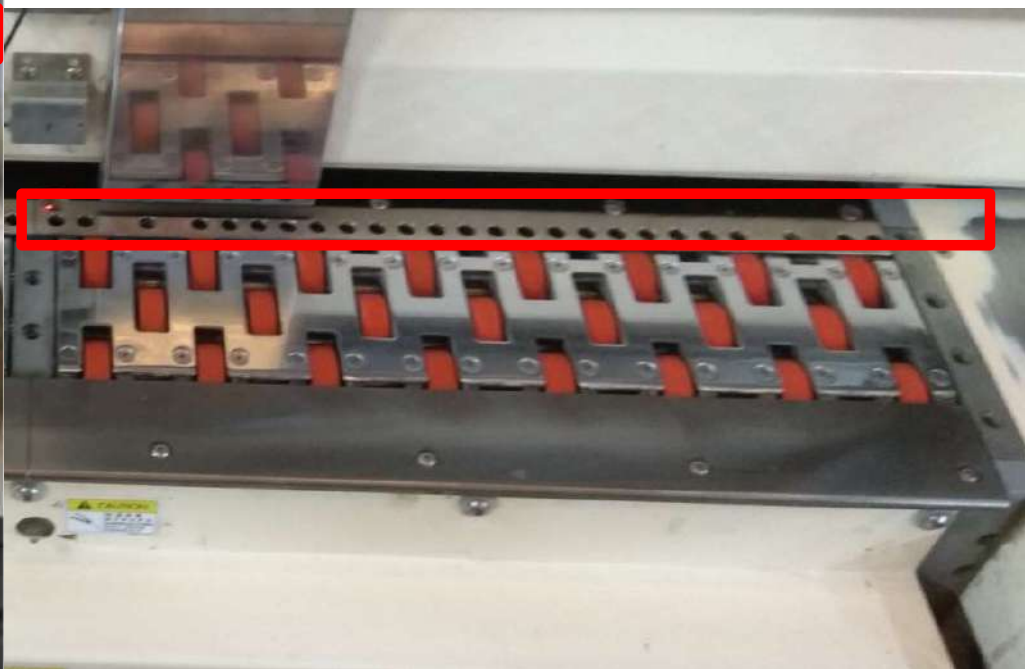
10. 鎖上出力軸螺絲，並拆除治具 (Lock the output shaft screw and remove the Jigs)





# 送紙柵欄間隙校正方式 Grate Gap Calibration

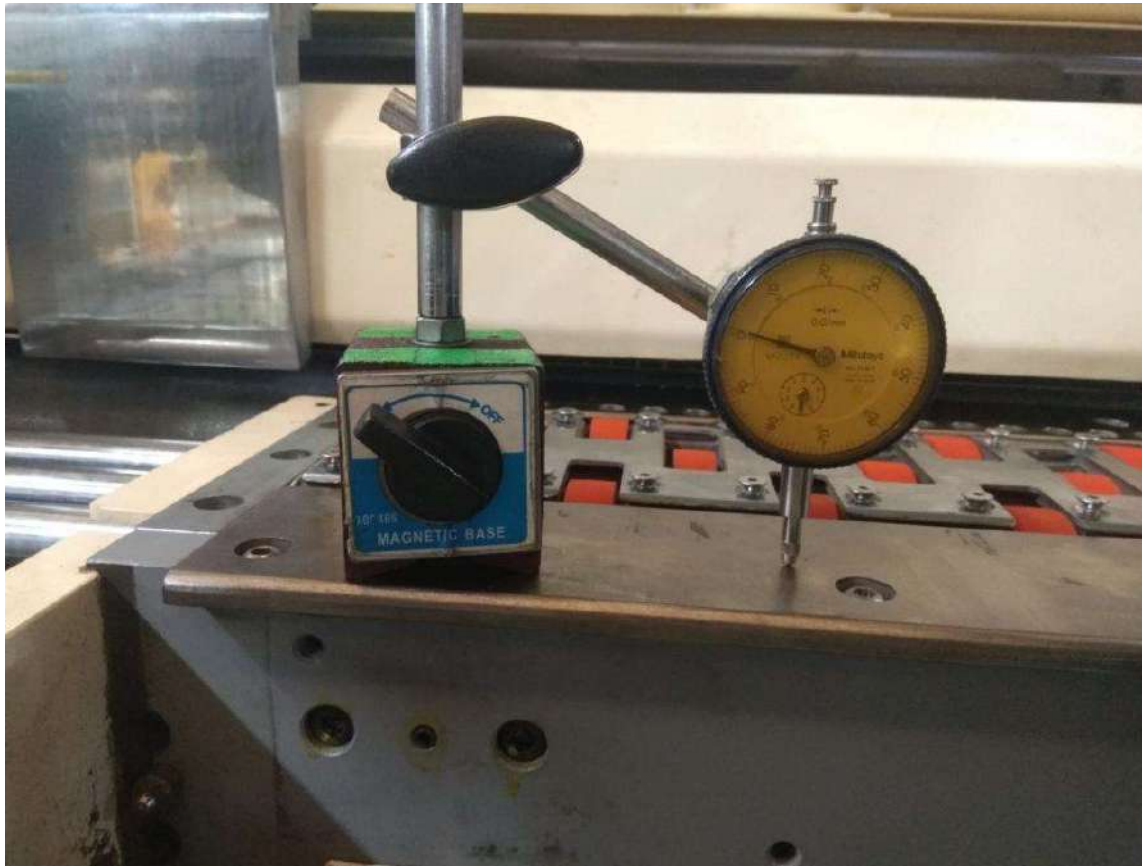
11. 放鬆出力軸螺絲，鎖回滑板(lock output shaft screw, locking the cover)



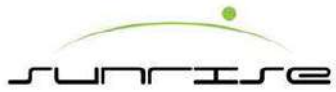


# 送紙柵欄間隙校正方式 Grate Gap Calibration

12. 使用千分表並以平台當原點校準為0 (use Indicator to calibration cover setting 0)

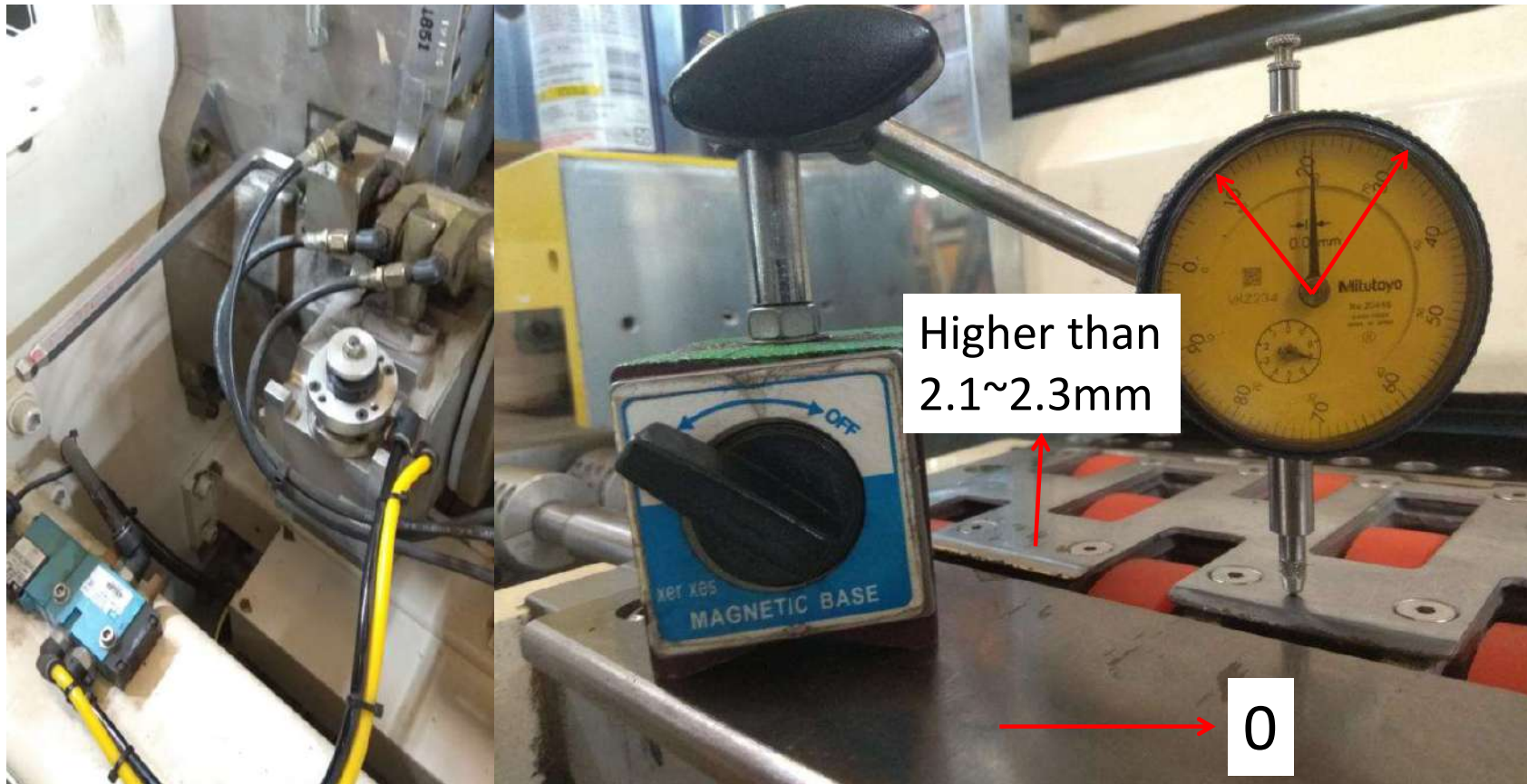


Setting "0"

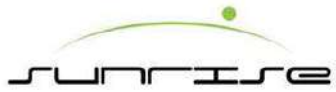


# 送紙柵欄間隙校正方式 Grate Gap Calibration

12. 使用14mm內六角板手，使柵欄高於前平台2.1~2.3mm (use allen key 14mm, then grate is higher than the front platform 2.1~2.3 mm )

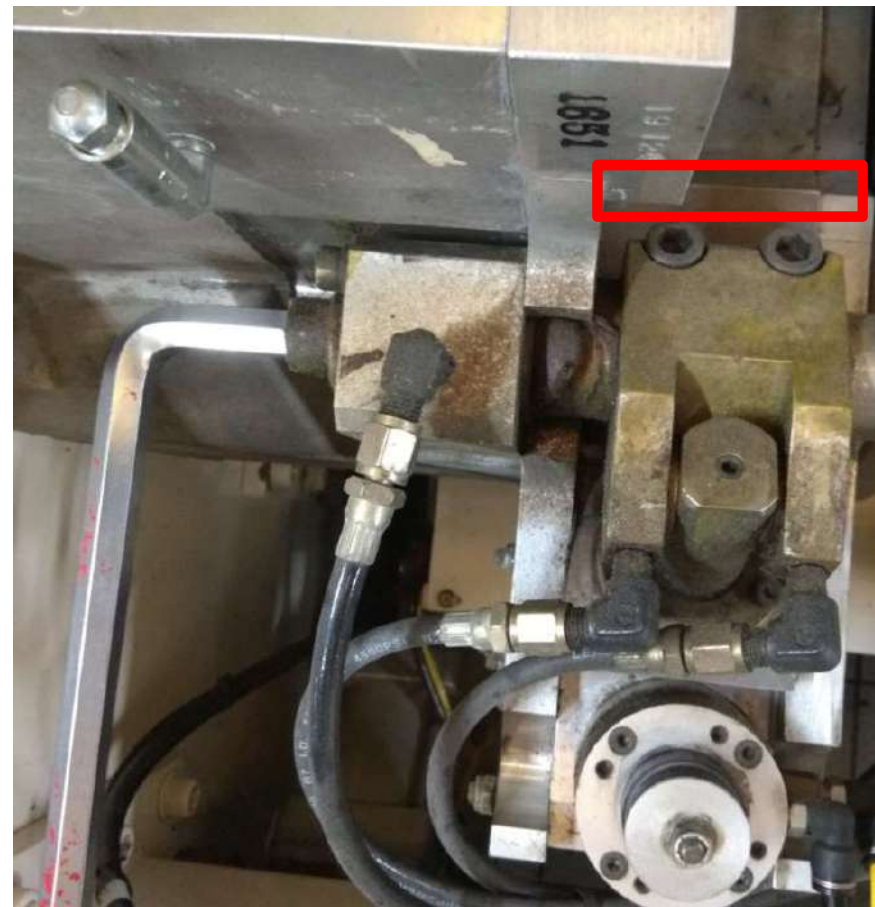






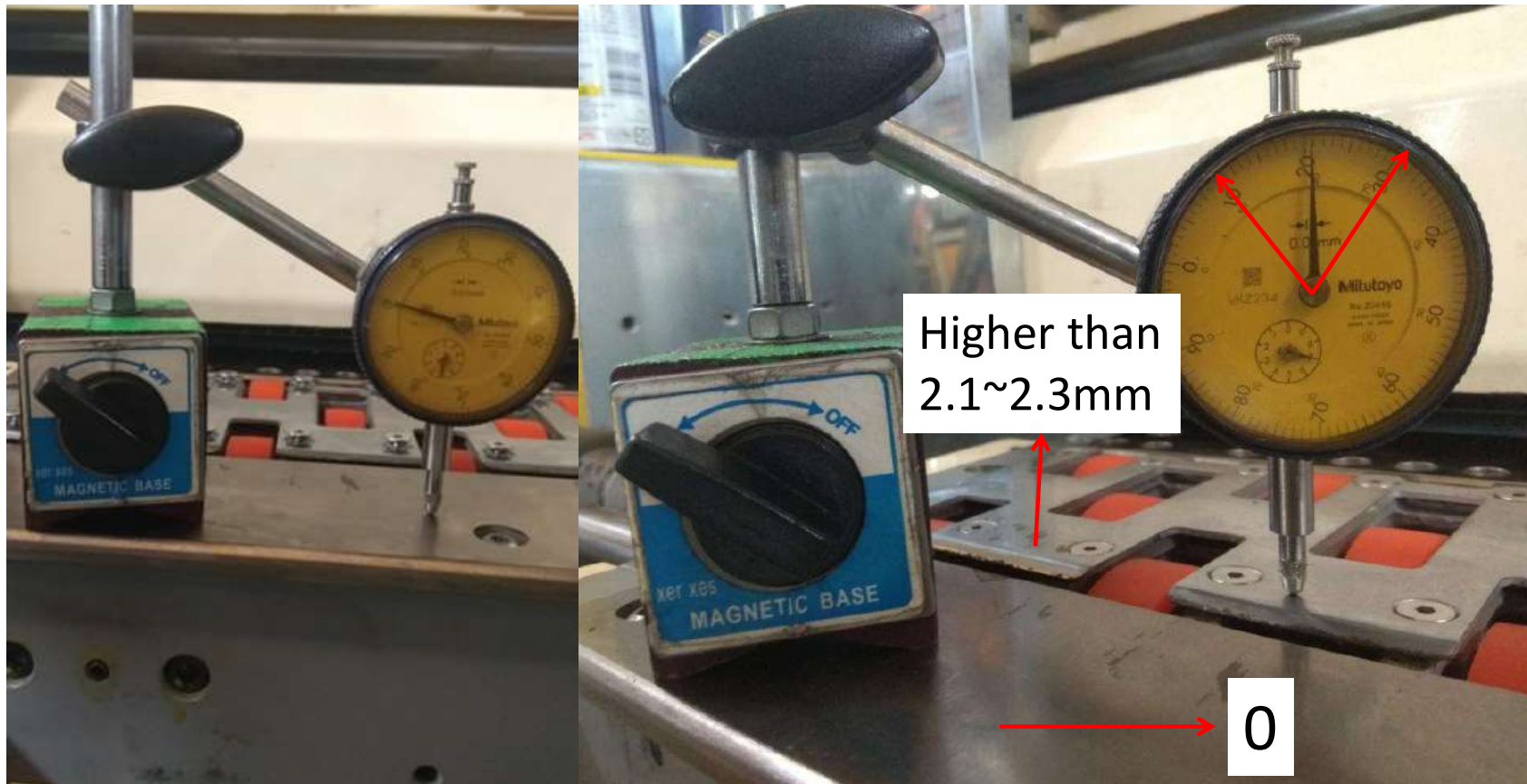
# 送紙柵欄間隙校正方式 Grate Gap Calibration

13. 鎖上出力軸螺絲( locking output shaft screw )



# 送紙柵欄間隙校正方式 Grate Gap Calibration

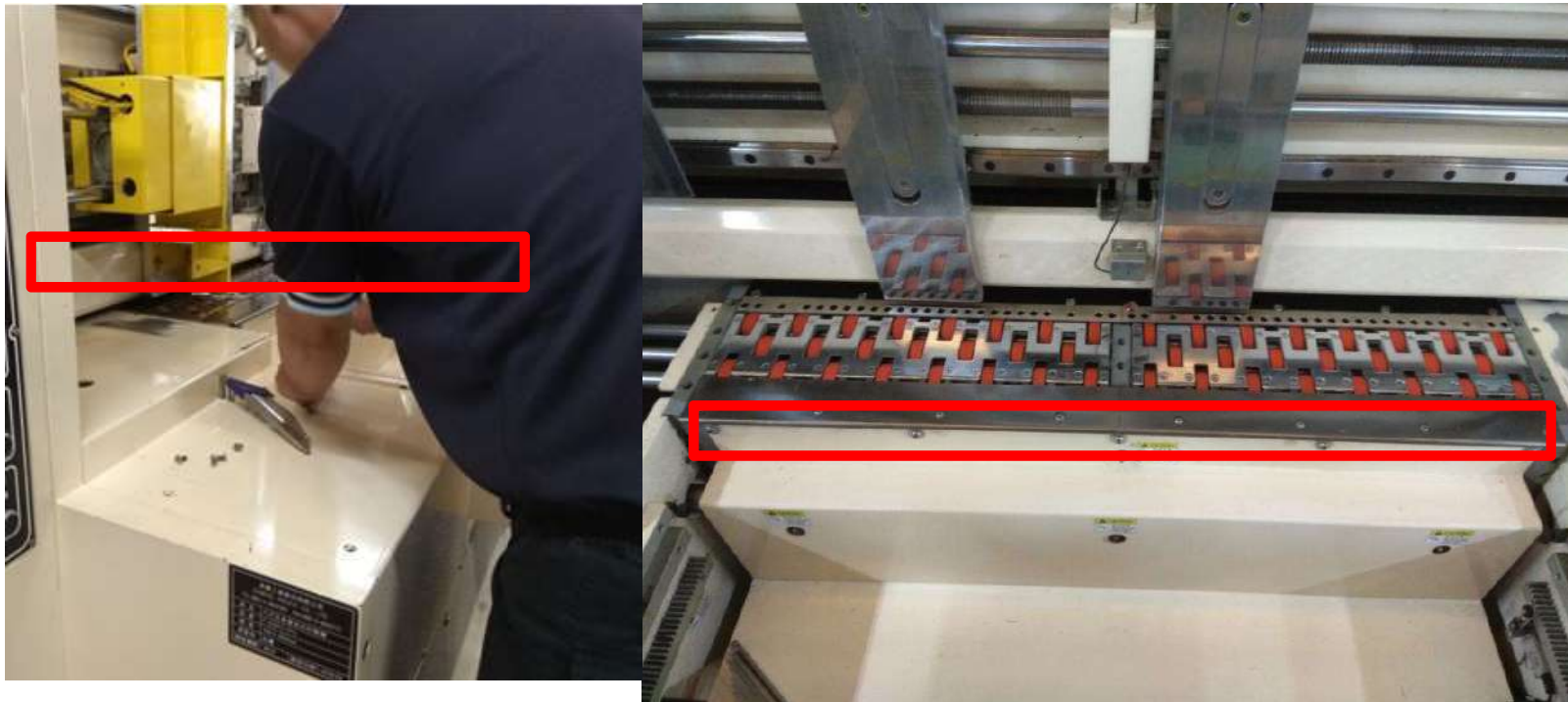
14. 再次確認柵欄需高於前平台2.1~2.3mm (check fence is higher than the front platform 2.1~2.3 mm )

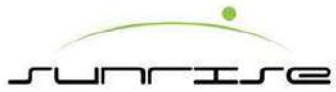




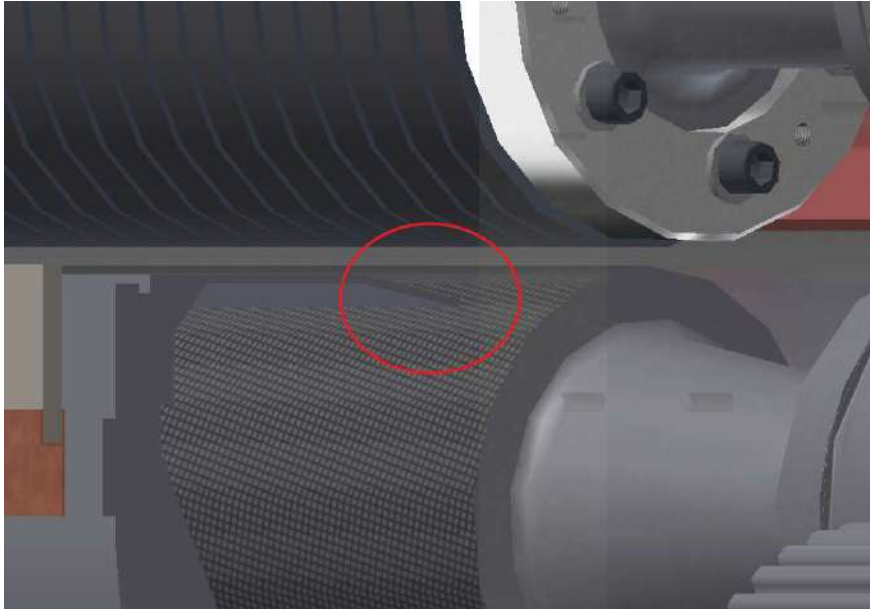
# 送紙柵欄間隙校正方式 Grate Gap Calibration

15. 復原蓋板 (recovery the cover)





## 送紙除塵箱校正



1. 除塵箱上方平面比下進紙輪最高點略低(0.5-1mm)
2. 除塵箱下折導板處與下進紙輪間隙1-2mm(紅圈處)
3. 除塵箱毛刷高於箱體0.5mm



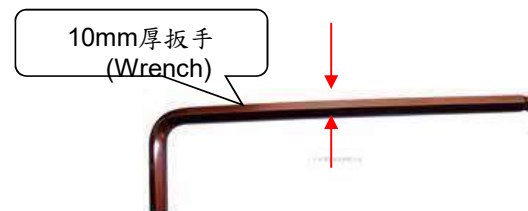
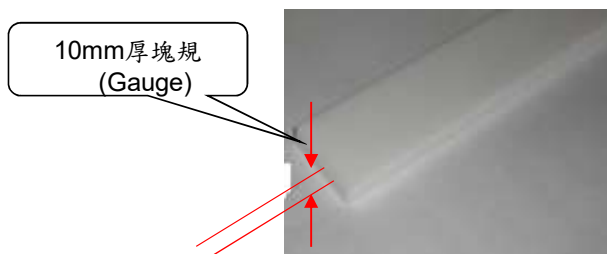
# 印壓間隙校正準備

## Impression Gap Pre-calibration

### 校正前準備 Pre-Calibration

1. 操作人員先行準備二塊10mm厚的塊規或扳手。

Operator should prepare two pieces of 10mm thickness gauge or wrench



2. 校正前先將印刷輪用乾布加以清潔，以免異物影響校正效果。

It should use a dry cloth to completely clean the print cylinder before calibration. The purpose is to avoid foreign material affect the calibration.



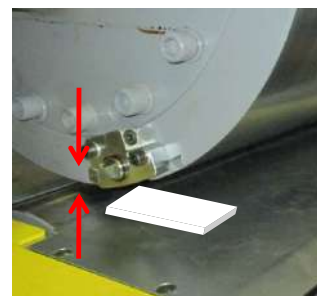


# 印壓間隙校正 Impression Gap Calibration

3. 將該兩塊(10mm)的塊規(或扳手)分別插入於印刷輪與印壓輪之間間隙內(左右兩側)。  
Insert two 10mm gauge or wrench between the print cylinder and impression roll (both sides the print cylinder).

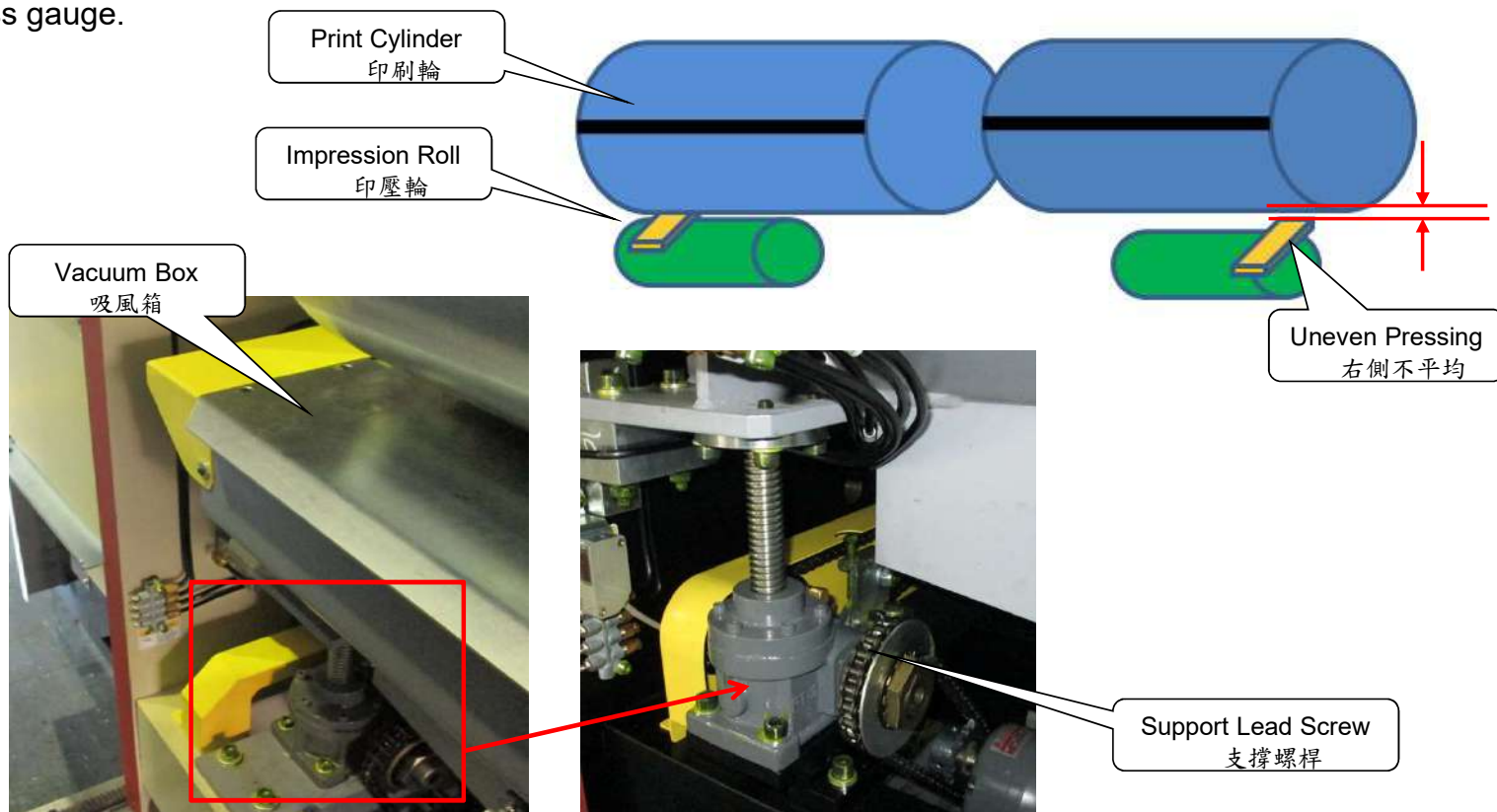


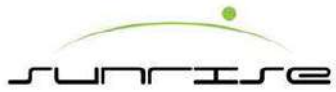
4. 去接著到印刷控制面板上的”印壓”鍵，利用”+”或”-”去將吸風箱調整上升或下降，待印刷輪與印壓輪剛好平均壓到該兩塊10mm塊規或扳手。  
Go to the printing panel, and use the impression ”+” or ”-” to adjust the vacuum box up and down until both side evenly touch the 10 mm thickness gauge.



# 印壓間隙校正 Impression Gap Calibration

5. 如果調整後發現兩側有高低不平均時，操作人員須到吸風箱下面的支撐螺桿來調整，務須保持兩側平均與塊規或扳手面接觸。  
If found both side uneven, it can adjust the support lead screw under the vacuum box until both sides evenly touch the thickness gauge.

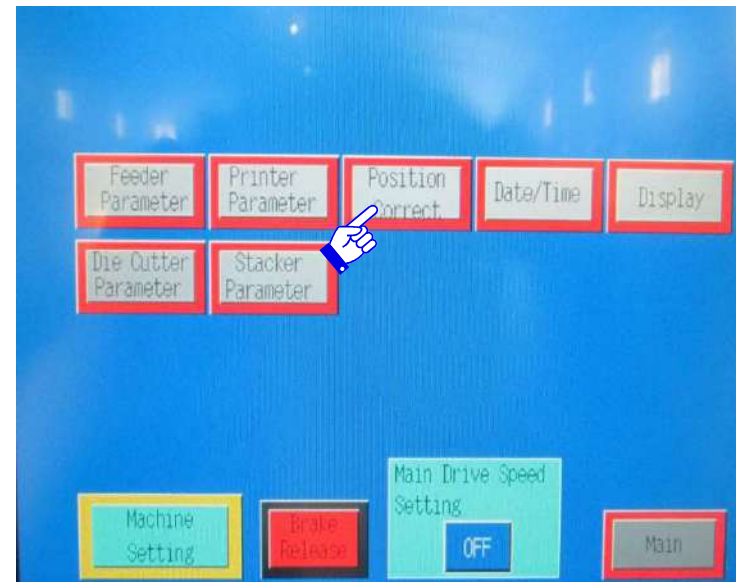




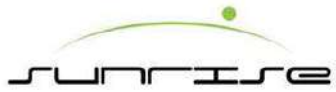
# 印壓間隙校正 Impression Gap Calibration

6.當校正前各項確認無誤後，接著到大人機點選”系統參數”，點選後進入系統參數頁。接著點選”重設目前值”。

After finish all the pre-calibration checking, go to the main HM and press the “**Parameter**” key. Then, it will directly go to the parameter setting page. Also press the “**Position Correct**”.



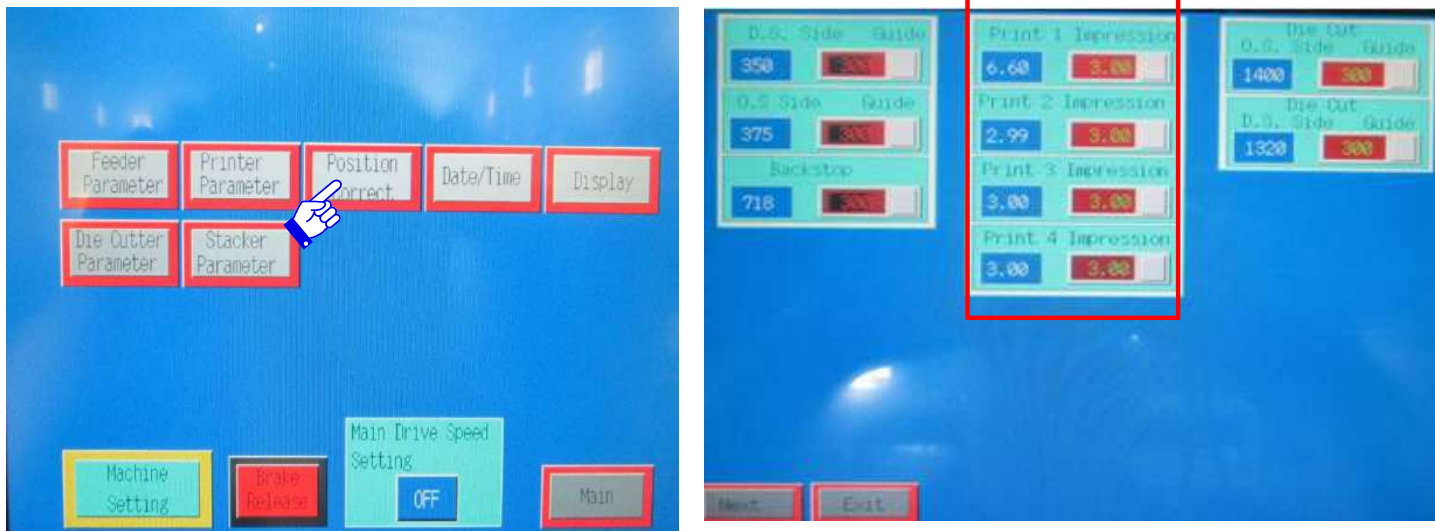




# 印壓間隙校正 Impression Gap Calibration

7.點選重設目前值後即出現印刷壓調整畫面

After press the **Position Correct** key, it will directly go to the adjustment page.





# 印壓間隙校正

## Impression Gap Calibration

8. 右手邊為“設定值”，此時操作人員可任意點選一個設定值欄及填入數價“3”，此時所有的設定值欄都會同時轉成“3”。
- The right hand side represents the **“SETTING VALUE”**, operator can select any one item to key in “3”. Then, all the setting value items will also change to “3”.



9. 而左邊為“顯示值”，但不會與“設定值”同步顯示相同數價。所出現的數值為對應數值，校正完成。

The left hand side represent the **“PRESENT VALUE”**, this present value **WILL NOT** follow the setting value to change the same number. It only displays the relative value. The calibration is done.



# 版壓間隙校正 Anilox Gap Calibration

## 操作程式 Procedure

版壓間隙教導共分23項，而內部可為左右兩邊，左邊空格輸入當時間隙所顯示之解碼器之值，右邊空格輸入實際間隙

Anilox Gap Correct has 23 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.

右邊部份分為三個值，脈波數值，版壓間隙教導，和脈波校正。在輸入完左邊之空格後，操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

After filling in all 23 sets of column, operator can fill in the present value of encoder in "Pulse Correct". It will display the Pulse and Rubber Gap on the above two columns. Gap correct is finished when the two are correct.

起始值	0.00	0	0.00	脈波數值
0	0.00	0	0.00	0
2	0.00	1	0.00	版壓
3	0.00	2	0.00	0.00
4	0.00	3	0.00	脈波校正
5	0.00	4	0.00	0
6	0.00	5	0.00	
7	0.00	6	0.00	下一頁
8	0.00	7	0.00	間隙教導

Encoder value 解碼器值    Real Gap 實際間隙值

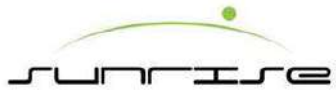


# 版壓間隙校正 Anilox Gap Calibration

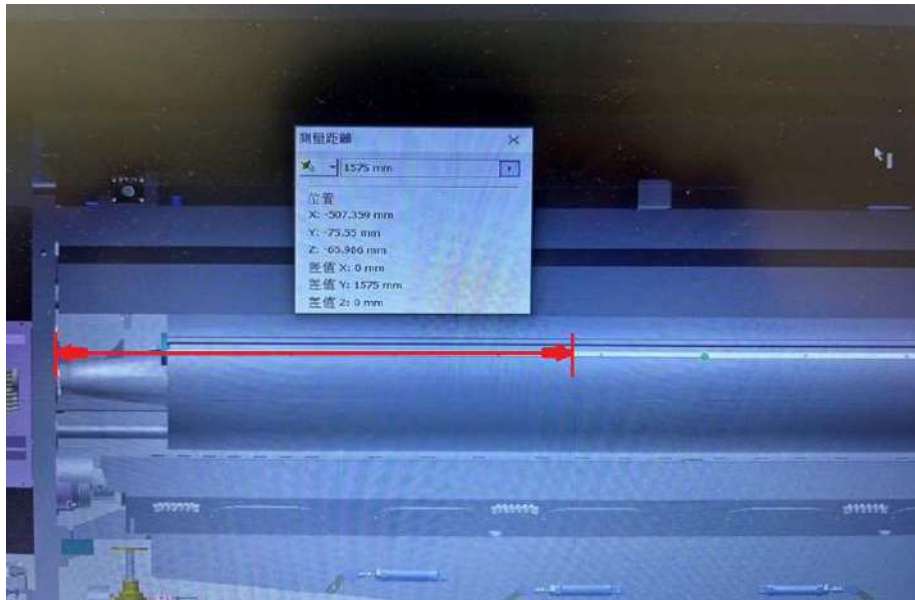
9. 印刷輥(外徑__mm)	V	7.2 mm(含版紙厚度) 3.94印版+3.05襯墊+0.2版紙	-	5.1 mm(含版紙厚度) 2.84印版+2.03襯墊+0.2版紙	-	6.1 mm(含版紙厚度)
	-	(無)包覆R-bak(不選購)	V	(有)包覆R-bak(選購) 厚度 mm		
	O	手動式絞版(絞版軸)	-	電動式絞版(絞版軸)	-	彈性膠條固定(勾版槽)
	V	全版版溝(掛版方式) 1250mm(50規格版紙長度)	V	(無)半版版溝(掛版方式)	-	(有)半版版溝(掛版方式) 版紙長度__mm 3.94印版+3.05襯墊+0.2版紙 (含掛版條及半版塞條)

根據印版規格選用厚薄規量測印刷輪與著墨輪間隙





# 橫移校正



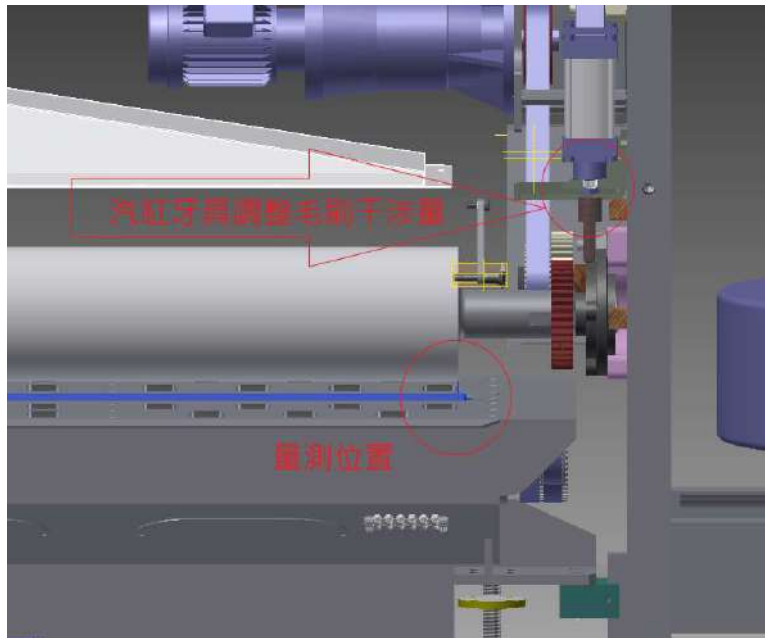
若機壁量測總長度為310cm (3100mm)時，其一半為  $(310/2) = 155 \text{ cm} (1550\text{mm})$ ，**注意這個數字只是機壁的中心線而並非機台的中心線**。因此須在  $1550\text{mm} + 25\text{mm} = 1575\text{mm}$  才是真正的機台行紙中心線。

量測操作側車壁內側至印刷輪中心線距離等同行紙中心線時，將橫移數值設為0

If Wall length total is 3100mm,so middle is 1550mm

1550mm is wall center , but real feeder center must plus 25mm 。 “1575mm”

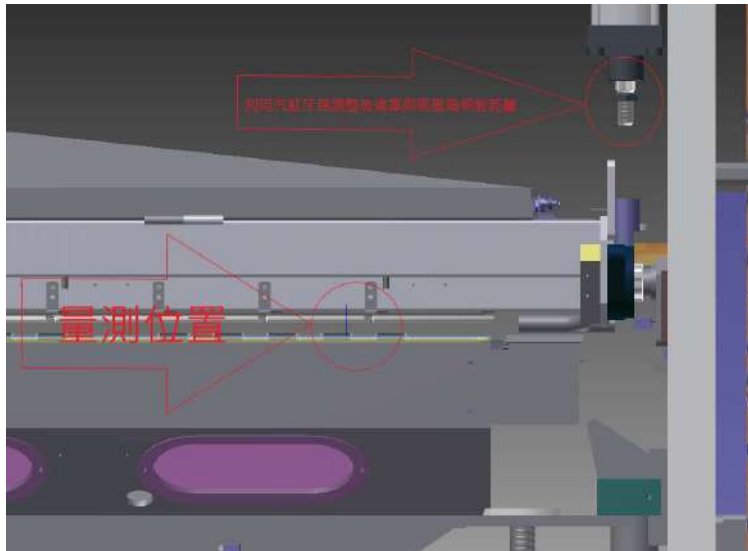
## 除塵毛刷輪校正



- 1.將印壓間隙調整至3（印壓需先校正完成）
- 2.利用電磁閥強制毛刷伸縮汽缸伸出
- 3.將B楞紙板放置在吸風箱與毛刷輪中間
- 4.調整汽缸牙距使毛刷輪輕接觸紙板



## 紅外線乾燥箱體位置校正



- 1.將印壓間隙調整至3（印壓需先校正完成）
- 2.利用電磁閥使紅外線箱體伸縮汽缸強制伸出
- 3.調整汽缸牙距將箱體玻璃罩與吸風箱封板間距調整至50mm



# 開槽刀位置校正

## Slotting Knife Position Calibration





# 開槽刀位置校正

## Slotting Knife Position Calibration

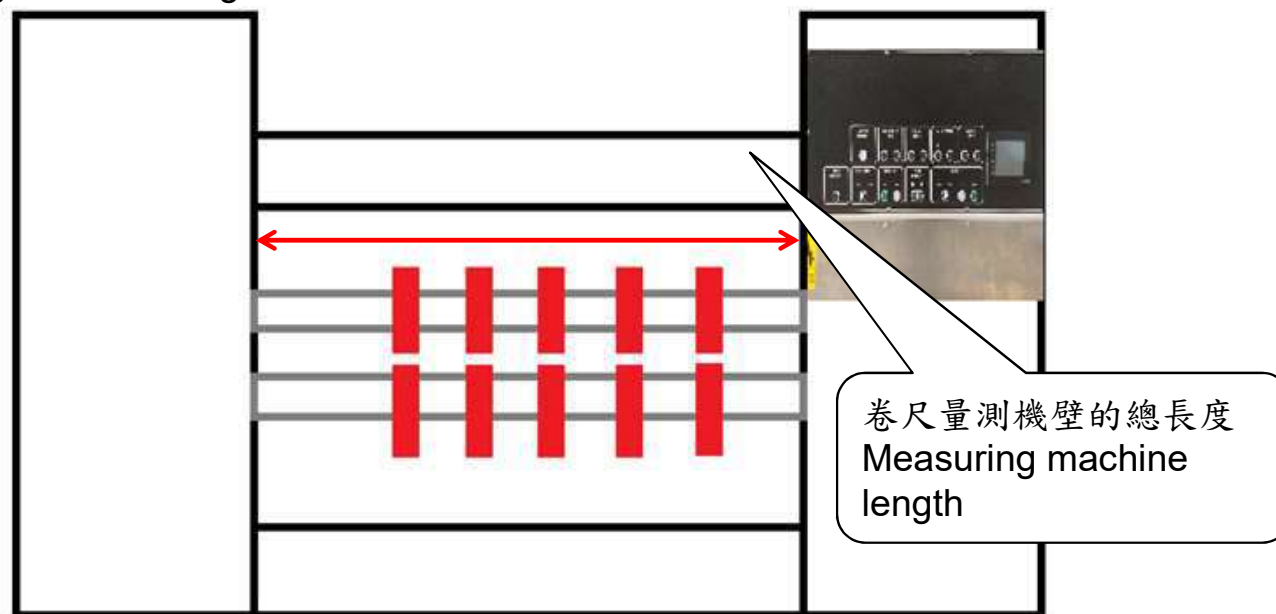
1. 準備一個卷尺來作距離量測。

Tape measure to measure distance



2. 先行量測開槽機壁的總長度以確認機台的中心位置

Measuring machine length



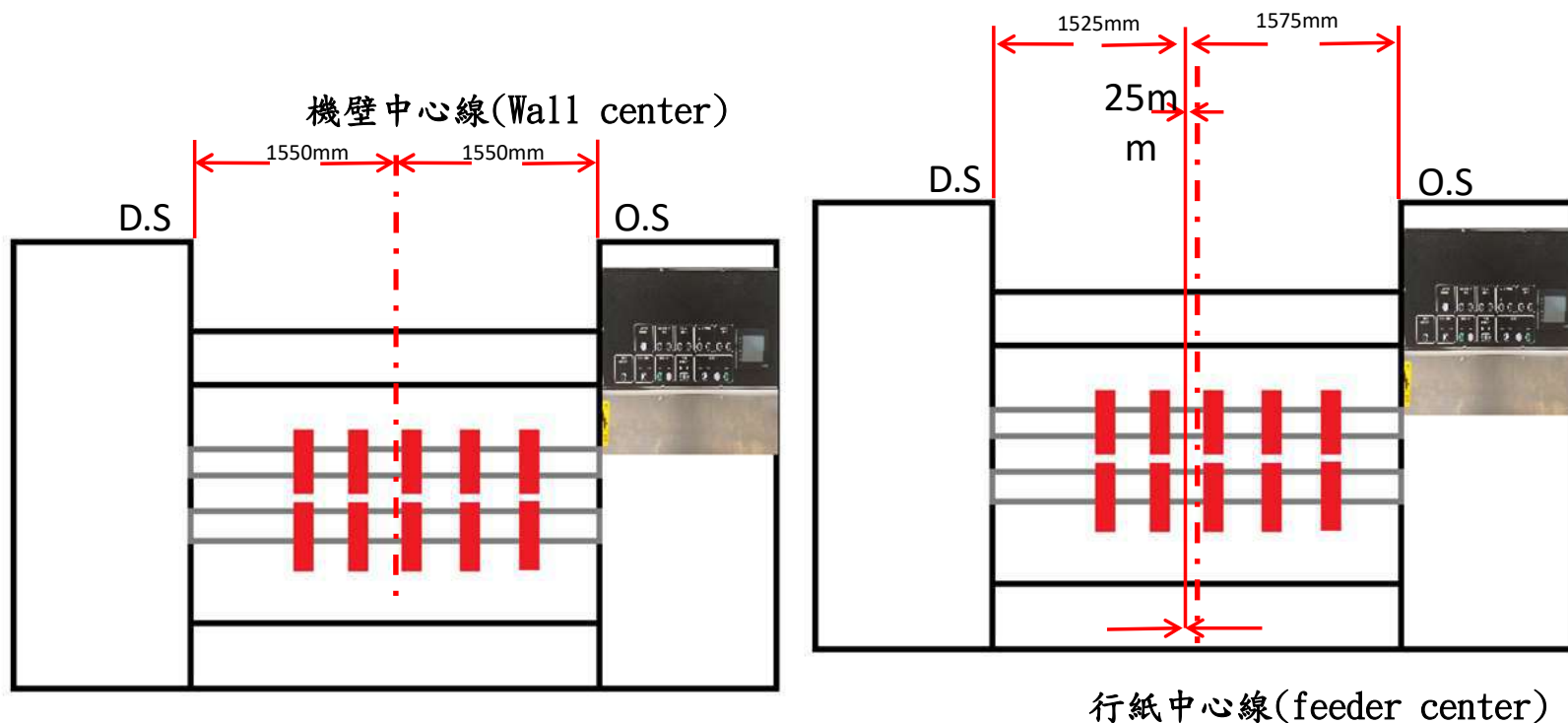


# 開槽刀位置校正 Slotting Knife Position Calibration

3. 若機壁量測總長度為310cm (3100mm)時，其一半為  $(310/2) = 155 \text{ cm}$  (1550mm)，**注意這個數字只是機壁的中心線而並非機台的中心線**。因此須在  $1550\text{mm} + 25\text{mm} = 1575\text{mm}$  才是真正的機台行紙中心線。

If Wall length total is 3100mm,so middle is 1550mm

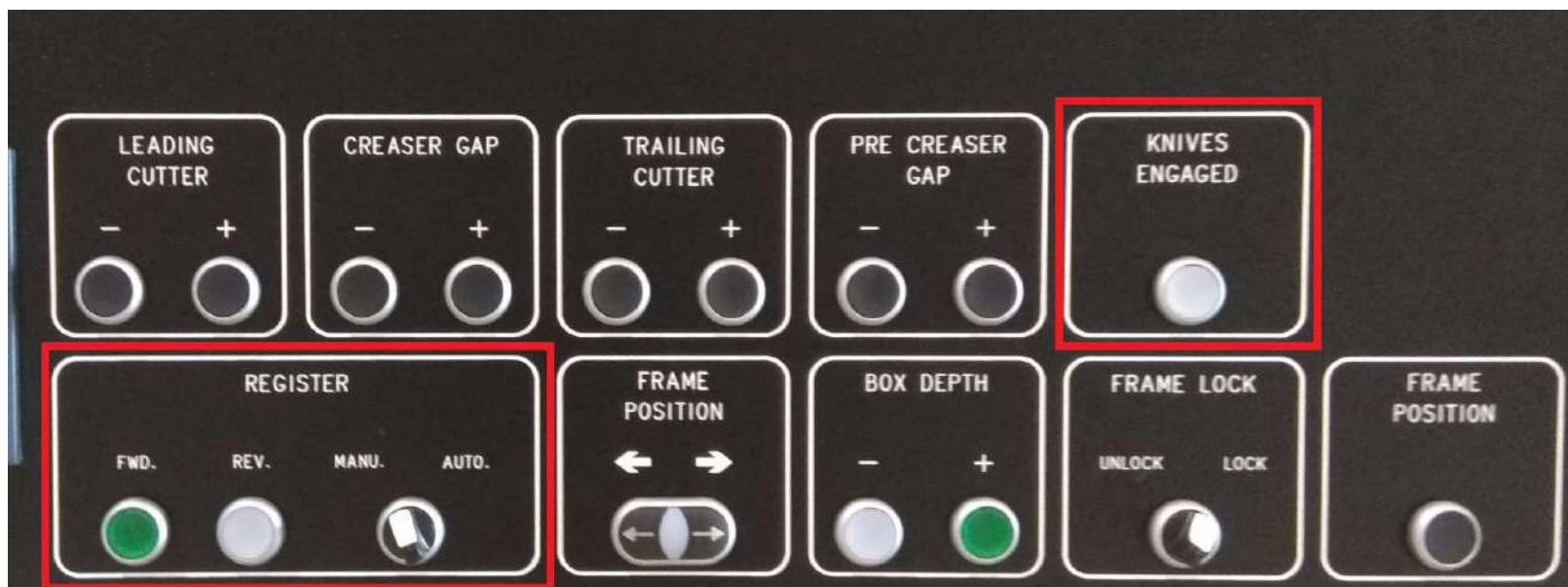
1550mm is wall center , but real feeder center must plus 25mm 。 “1575mm”

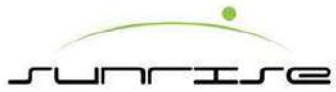




# 開槽刀位置校正 Slotting Knife Position Calibration

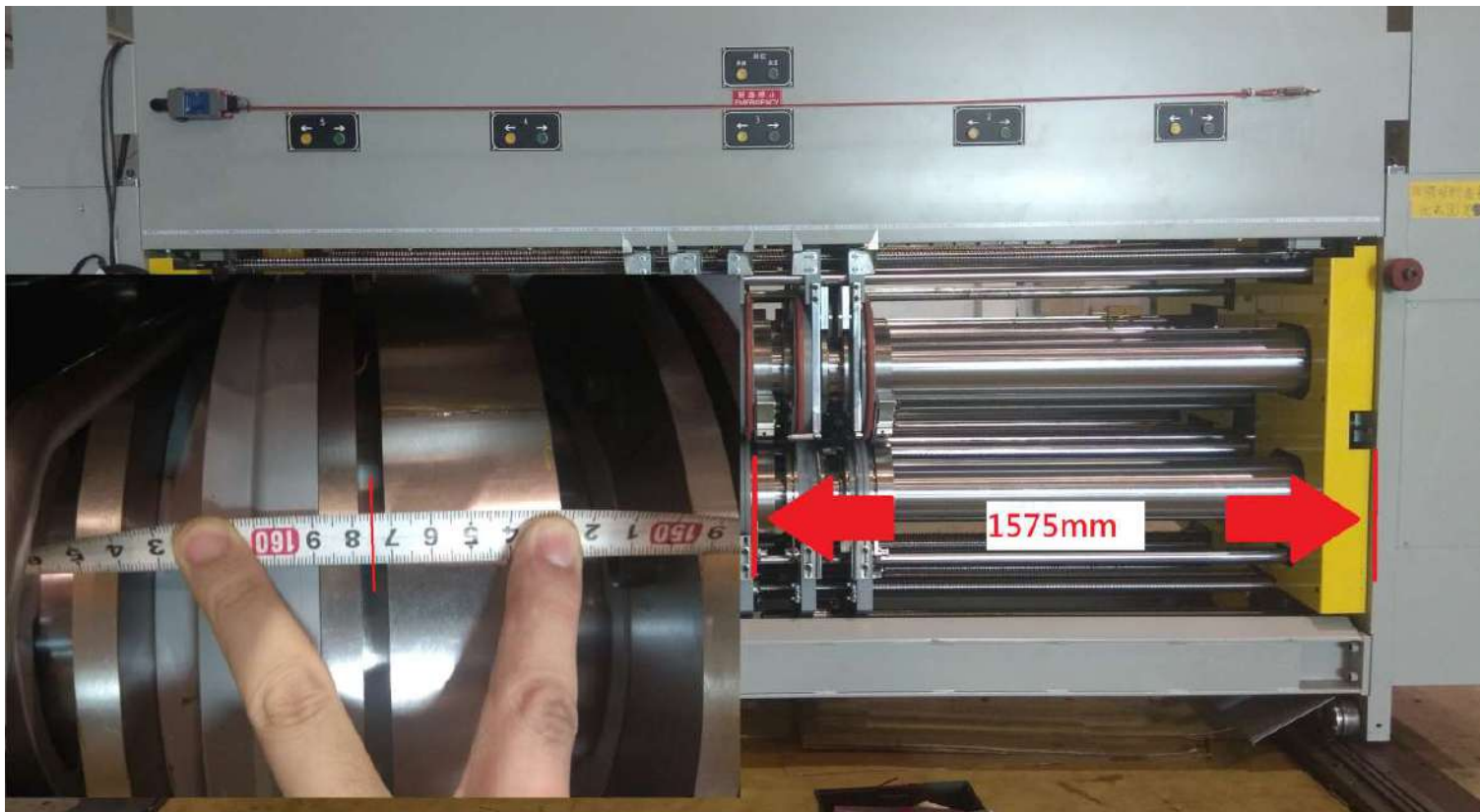
4. 刀嚙合，並且轉相位轉手動 (push Knives engaged and register turn to Manual )





# 開槽刀位置校正 Slotting Knife Position Calibration

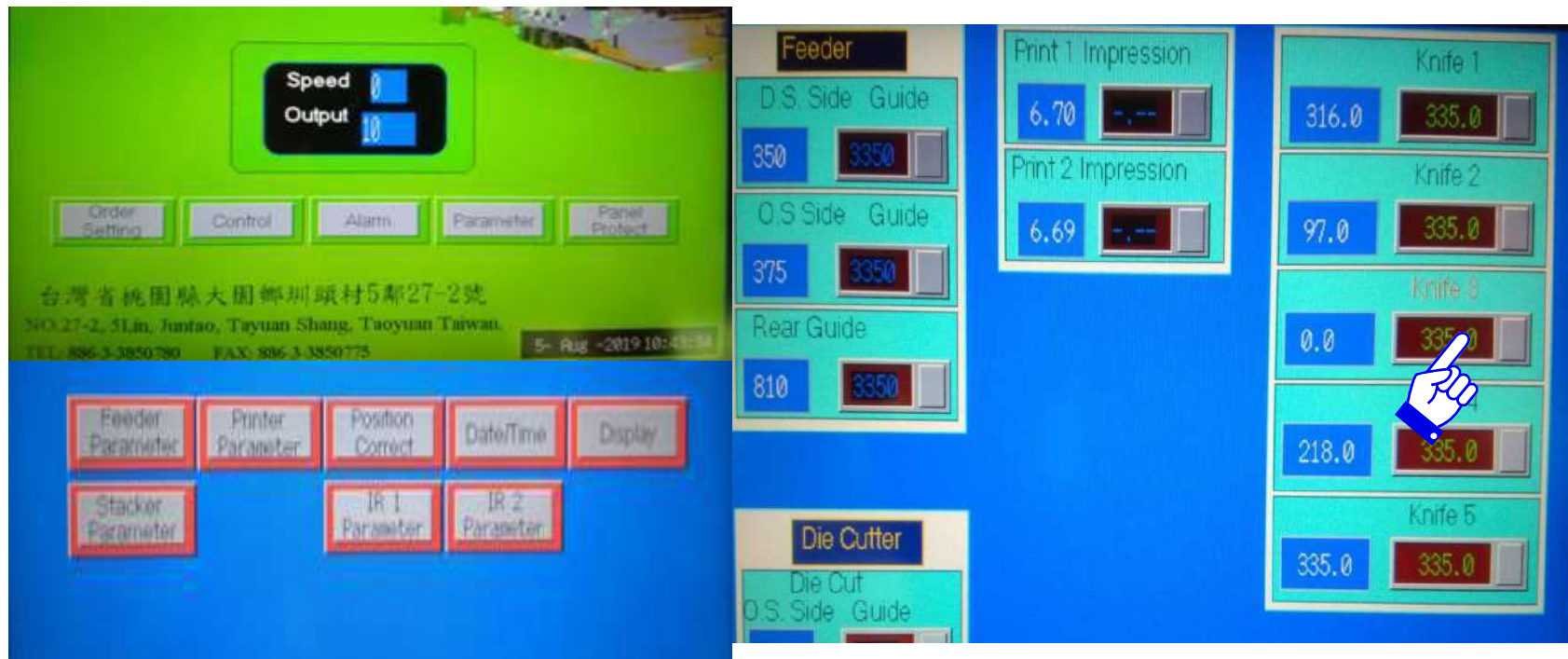
5. 移動三刀位置到校正值1575mm (move Knife 3 position to calibration value 1575mm)





# 開槽刀位置校正 Slotting Knife Position Calibration

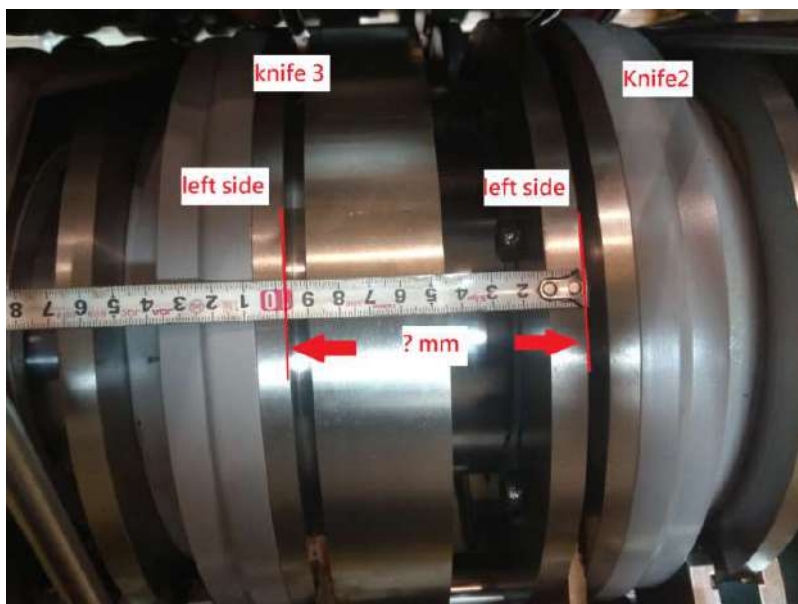
6. 接著到大人機(Main HMI)→參數設定(Parameter)→重設目前值position correct”  
(PW : 33850780)→開槽刀三設定零(knife 3 set “0”)





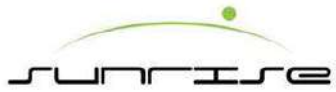
# 開槽刀位置校正 Slotting Knife Position Calibration

7. 三刀不移動當零點，量測二刀位置，並以量測值當設定  
(knife 3 not move and set 0 , check knife 2 position ,and set the measured value)



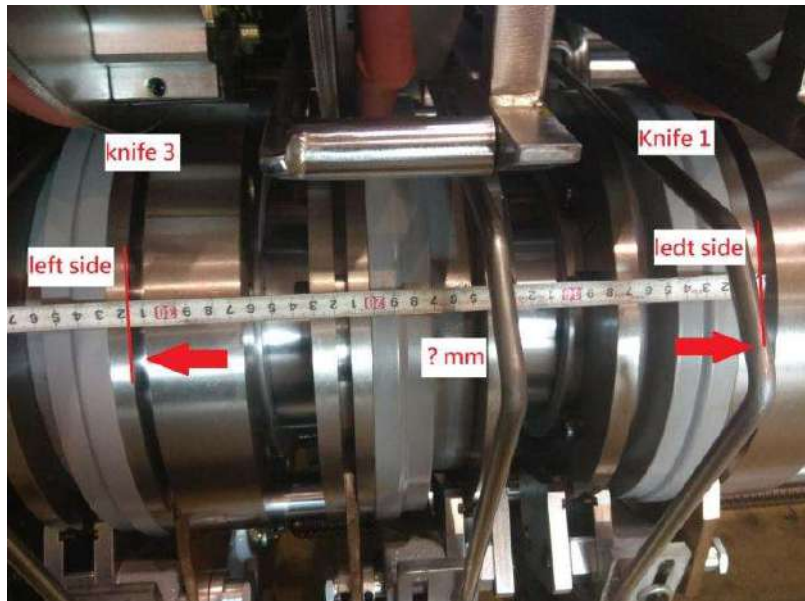
↑ EX : knife 2 set 97mm





# 開槽刀位置校正 Slotting Knife Position Calibration

8. 三刀不移動當零點，量測一刀位置，並以量測值當設定  
(knife 3 not move and set 0 , check knife 1 position ,and set the measured value)



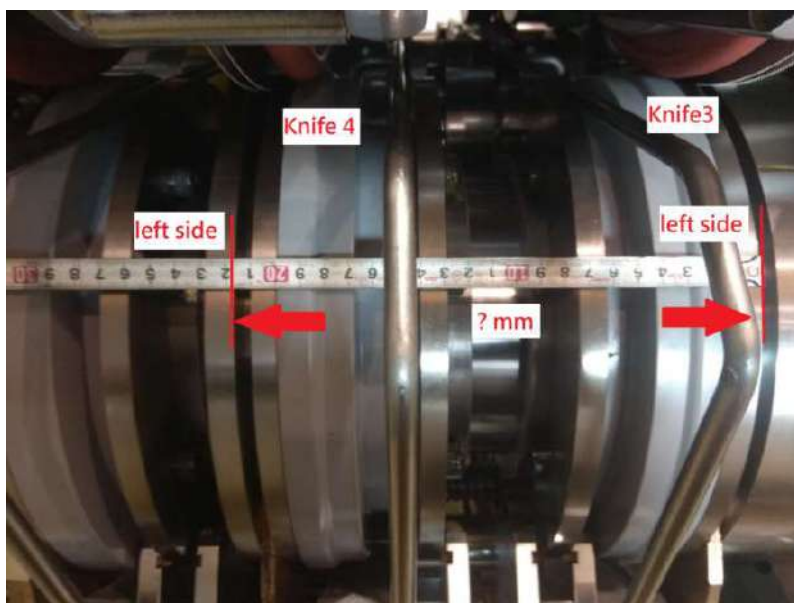
↑ EX : knife 1 set 316 mm





# 開槽刀位置校正 Slotting Knife Position Calibration

9. 三刀不移動當零點，量測四刀位置，並以量測值當設定  
(knife 3 not move and set 0 , check knife 4 position ,and set the measured value)



↑ EX : knife 4 set 218 mm

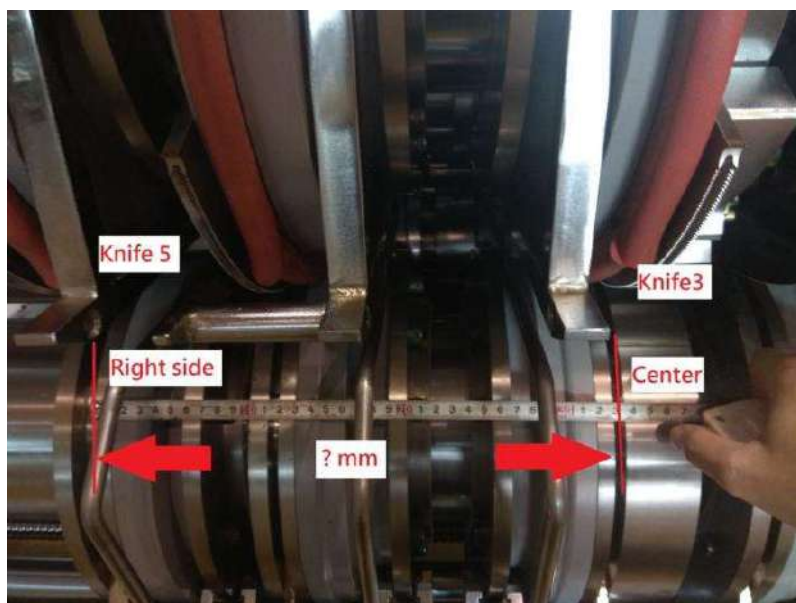






# 開槽刀位置校正 Slotting Knife Position Calibration

10.三刀不移動當零點，量測五刀位置，並以量測值當設定  
(knife 3 not move and set 0 ,check knife 5 position ,and set the measured value)



↑ EX : knife 5 set 335 mm





# 開槽刀位置校正 Slotting Knife Position Calibration

11. 調整紙針位置與實際設定值相同，並鎖緊  
(Adjust the pointer position to the same value as the actual setting and lock it)





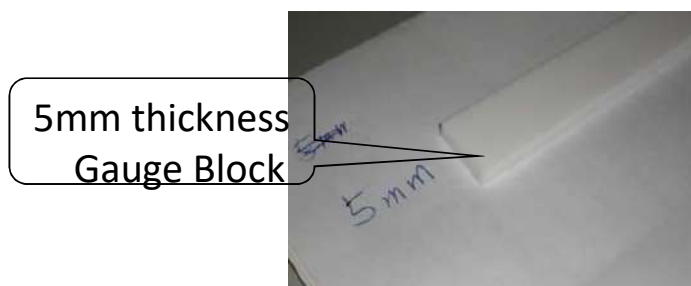
# 壓線 & 破壞間隙校正 Pre-creaser & Creaser Gap Calibration



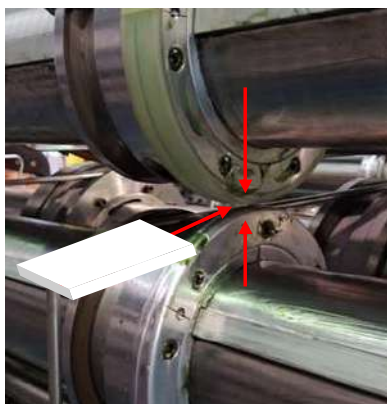


# 壓線 & 破壞間隙校正 Pre-creaser & Creaser Gap Calibration

1. 準備5mm厚薄規或內六角板手5mm ( Prepare a 5mm thickness gauge block (or 5mm allen key)



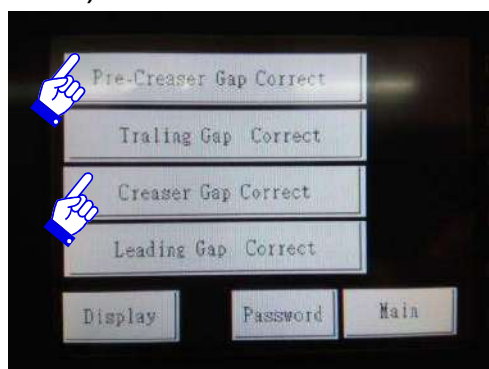
2. 調整到實際值是5mm。 (Pull collar gap is adjusted to the actual value is 5mm)





# 壓線 & 破壞間隙校正 Pre-creaser & Creaser Gap Calibration

3. 接著到到入機(HMI)→參數設定(Parameter) (PW : 33850780) →咬紙輪間隙設定(pre creaser and creaser Gap correct) → 設定壓線破壞輪位置實際值(Set the actual value of the pre crease and creaser gap setting 5mm)



0	Initial	-1.0	9	150	3.0	Pulse
1	49	-0.5	10	161	3.5	195
2	70	-0.1	11	172	4.0	Creaser Gap
3	71	0.0	12	182	4.5	3.5
4	87	0.5	13	194	5.0	Pulse Correct
5	102	1.0	14	205	5.5	0
6	114	1.5	15	217	6.0	Creaser Gap
7	127	2.0	16	230	6.5	Creaser Gap
8	138	2.5	17	242	7.0	Creaser Gap



輸入5mm時的設定值：  
(Key in value of pulse setting 5mm)

EX : setting 194



# 壓線 & 破壞間隙校正 Pre-creaser & Creaser Gap Calibration

4.調整齒花盤至5mm後鎖上螺絲 ( adjust the dial scale to 5 mm, and tighten the screw )





# 前刀間隙校正 Leading Knife Gap Calibration

## 操作程式 Procedure

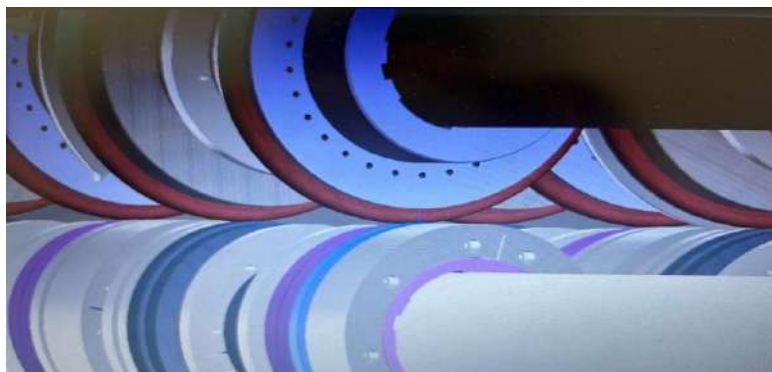
前刀間隙教導2共分17項，而內部可為左右兩邊，左邊空格輸入當時間隙所顯示之解碼器之值，右邊空格輸入實際間隙

Leading Gap Correct has 17 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.

右邊部份分為三個值，脈波數值，前刀間隙教導，和脈波校正。在輸入完左邊之空格後，操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

After filling in all 17 sets of column, operator can fill in the present value of encoder in "Pulse Correct". It will display the Pulse and Leading Gap on the above two columns. Gap correct is finished when the two are corrected.

S1000TV 實際間隙值:18.4 尺花對2  
S1000BV 實際間隙值:18.4 尺花對2  
925固定式 實際間隙值:13.15 尺花對2  
2000型 實際間隙值:16.15 尺花對4



0 起始值	Encoder Value	Real Gap	Pulse Value
0.0	0.0	0.0	0
1 0	0.0	10 0	0.0
2 0	0.0	11 0	0.0
3 0	0.0	12 0	0.0
4 0	0.0	13 0	0.0
5 0	0.0	14 0	0.0
6 0	0.0	15 0	0.0
7 0	0.0	16 0	0.0
8 0	0.0	17 0	0.0

Encoder Value解碼器值 Real Gap實際間隙值



# 後刀間隙校正 Trailing Knife Gap Calibration

## Procedure操作程式

後刀間隙教導2共分17項，而內部可為左右兩邊，左邊空格輸入當時間隙所顯示之解碼器之值，右邊空格輸入實際間隙

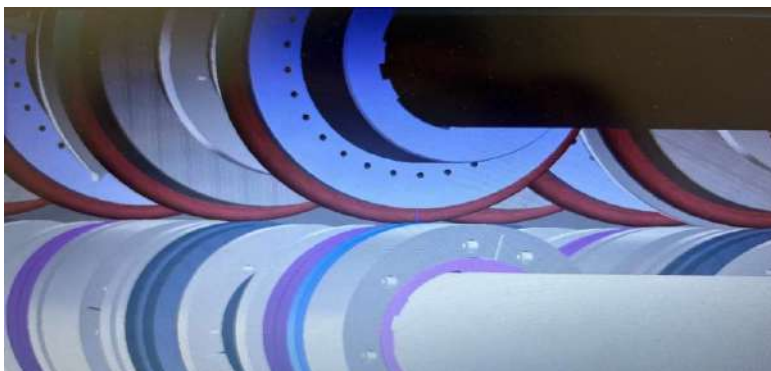
Trailing Gap Correct has 17 sets of columns. Each set is divided into left and right.

Operator has to fill in the encoder value in the left column and actual gap in right column.

右邊部份分為三個值，脈波數值，後刀間隙教導，和脈波校正。在輸入完左邊之空格後，操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

After filling in all 17 sets of column, operator can fill in the present value of encoder in "Pulse Correct". It will display the Pulse and Trailing Gap on the above two columns. Gap correct is finished when the two are corrected.

S1000TV 實際間隙值:18.4 尺花對2  
S1000BV 實際間隙值:18.4 尺花對2  
925固定式 實際間隙值:13.15 尺花對2  
2000型 實際間隙值:16.15 尺花對4



0	起始值	0.0	9	0	0.0	脈波數值
1	0	0.0	10	0	0.0	0
2	0	0.0	11	0	0.0	刀座間隙 2
3	0	0.0	12	0	0.0	0.0
4	0	0.0	13	0	0.0	脈波校正
5	0	0.0	14	0	0.0	0
6	0	0.0	15	0	0.0	
7	0	0.0	16	0	0.0	
8	0	0.0	17	0	0.0	間隙教導

Encoder Value解碼器值    Real Gap實際間隙值





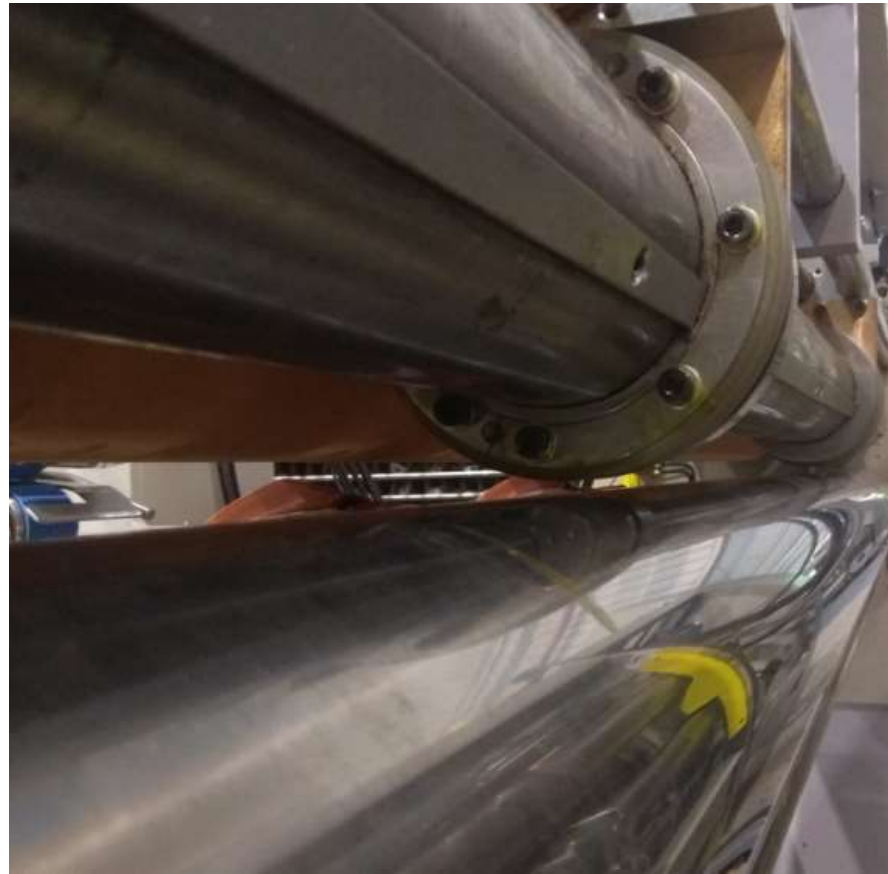
## 角刀校正

- 1.刀座間隙調整至3.2
- 2.利用相位調整使角刀片與下刀規垂直(利用光影判斷，兩側縫隙平均分配時)
- 3.利用偏心調整軸使角刀片接觸下刀規後鎖固螺母。





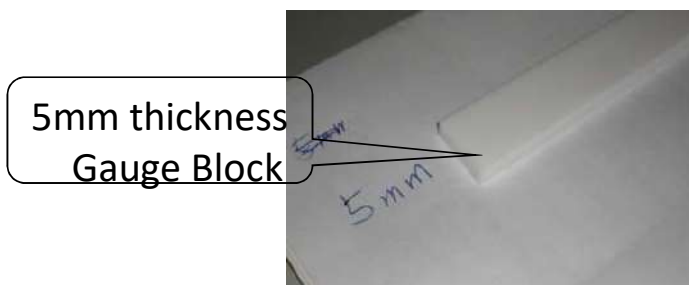
# 咬紙輪間隙校正 Pull Collar Gap Calibration



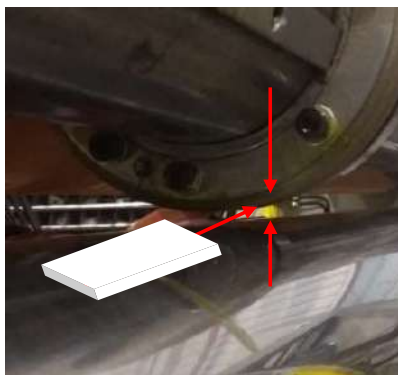


# 咬紙輪間隙校正 Pull Collar Gap Calibration

1. 準備5mm厚薄規或內六角板手5mm ( Prepare a 5mm thickness gauge block (or 5mm allen key)



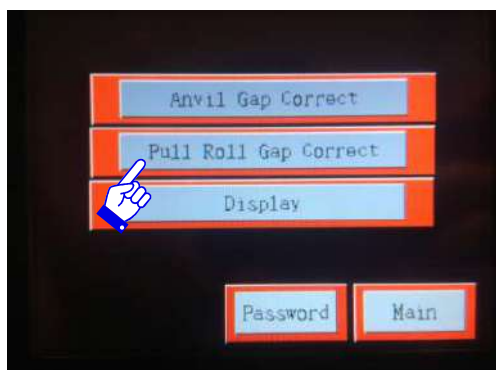
2. 調整到實際值是5mm。 (Pull collar gap is adjusted to the actual value is 5mm)





# 咬紙輪間隙校正 Pull Collar Gap Calibration

3. 接著到到人機(HMI)→參數設定(Parameter) (PW : 33850780) →咬紙輪間隙設定(Pull roll Gap correct) → 設定咬紙輪位置實際值(Set the actual value of the Pull collar gap setting 5mm)



輸入5mm時的設定值：  
(Key in value of pulse setting 5mm)

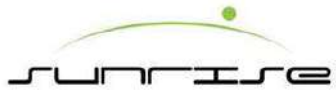
EX : setting 124



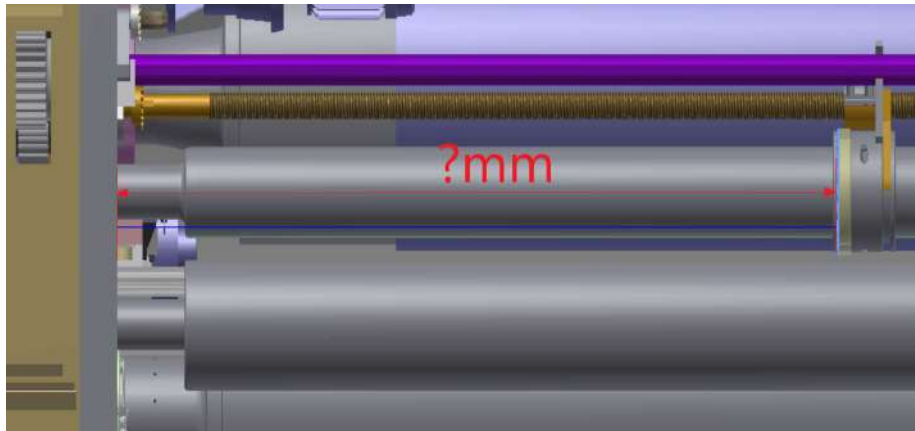
# 咬紙輪間隙校正 Pull Collar Gap Calibration

4.調整齒花盤至5mm後鎖上螺絲 ( adjust the dial scale to 5 mm, and tighten the screw )





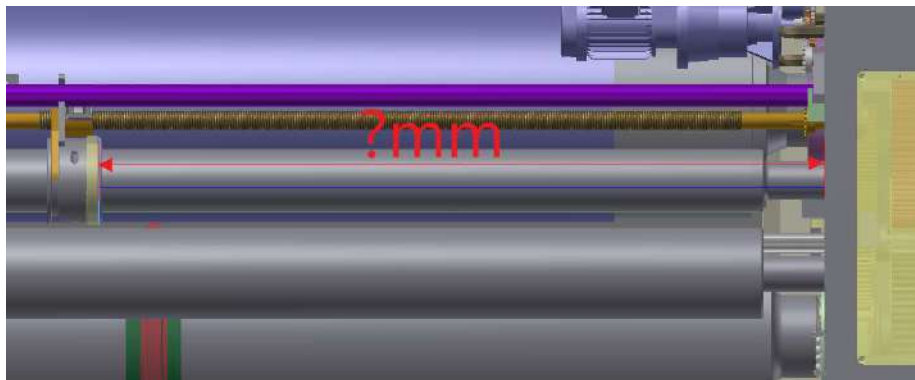
# 咬紙輪間隙校正 Pull Collar Position Calibration



若機壁量測總長度為310cm (3100mm)時，其一半為  $(310/2) = 155 \text{ cm (1550mm)}$ ，注意這個數字只是機壁的中心線而並非機台的中心線。因此須在  $1550\text{mm} + 25\text{mm} = 1575\text{mm}$  才是真正的機台行紙中心線。

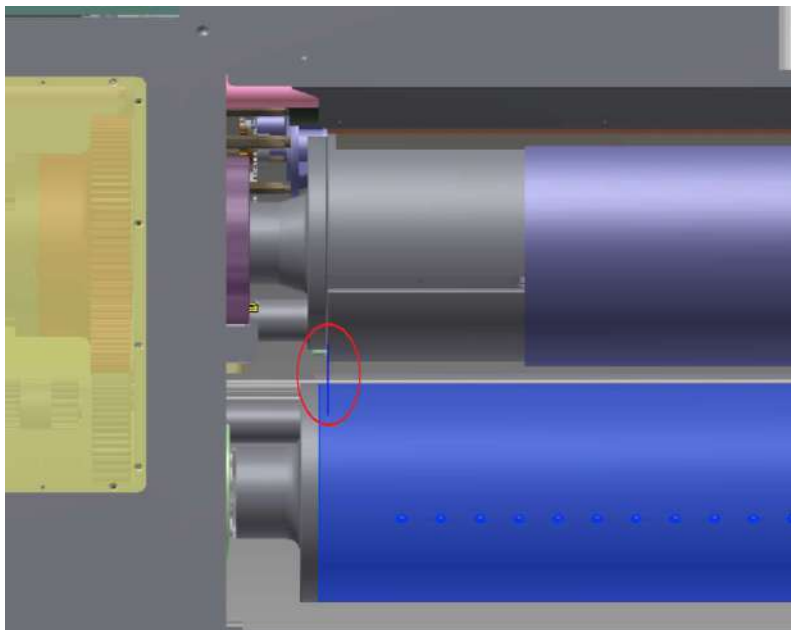
If Wall length total is 3100mm, so middle is 1550mm

1550mm is wall center, but real feeder center must plus 25mm。 “1575mm”



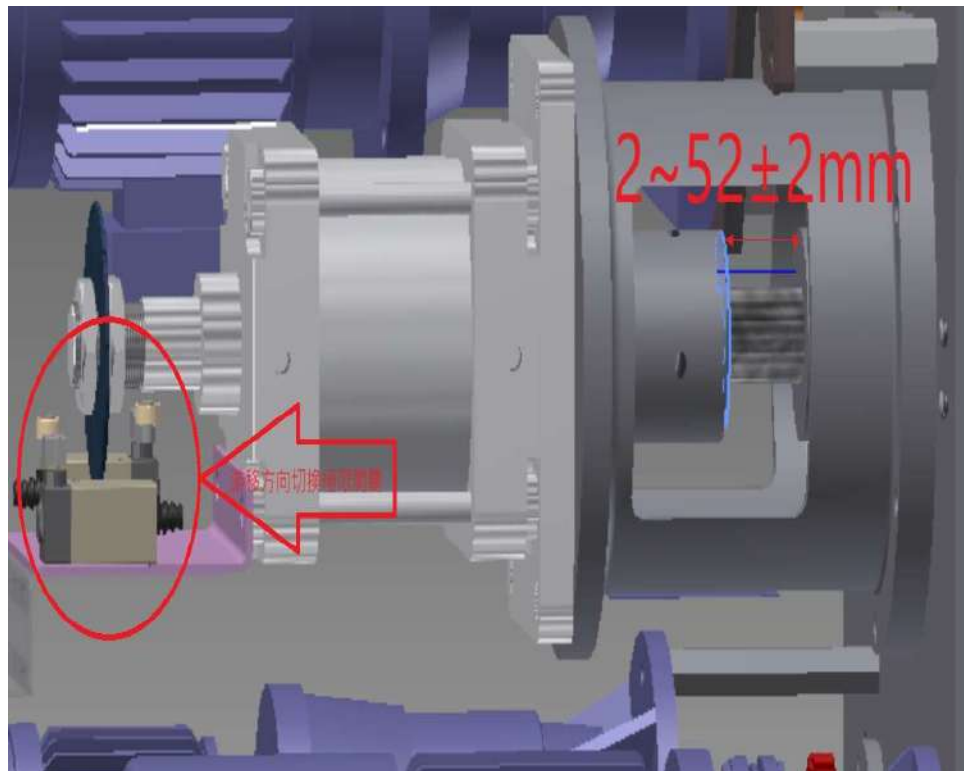
從操作側內車壁量測至操作側咬紙輪輪面外側尺寸為575mm時，操作側咬紙輪位置為1000 ( $1575-575=1000$ )。  
從驅動側內車壁量測至驅動側咬紙輪輪面外側尺寸為525mm時，驅動側咬紙輪位置為1000 ( $1525-525=1000$ )

## 膠墊輪間隙校正



1. 移除操驅兩側外側膠墊
2. 量測膠墊輪本體與刀輪本體間距35mm時，將膠墊輪間隙設置為0  
(偏心軸承座窄邊朝出紙側)
3. 量測膠墊輪本體與刀輪本體間距26mm時，將膠墊輪間隙設置為-7.5(最小極限開關為保護功用，碰觸擋點螺絲但不作動)
4. 量測膠墊輪本體與刀輪本體間距42mm時，將膠墊輪間隙設置為7.5(最大極限開關為保護和修膠定位功用，碰觸擋點螺絲且作動)

# 膠墊輪游移校正

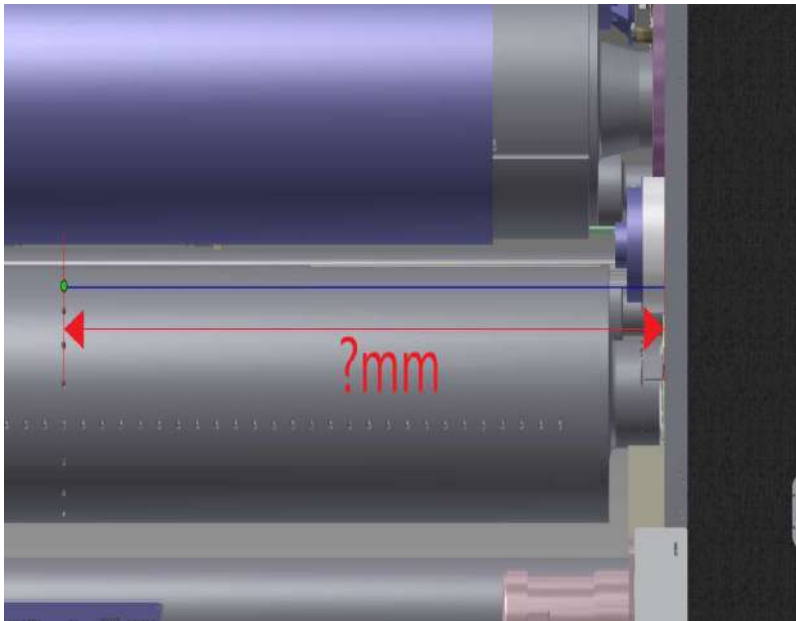


1. 啟動修膠功能使膠墊輪游移功能作動
2. 利用極限開關擺臂調整游移方向切換時機
3. 膠墊輪游移至操作側極限位置為連軸器與固定座間距**2mm**
4. 膠墊輪游移至驅動側極限位置為聯軸器與固定座間距**52±2mm**





## 刀輪橫移校正



若機壁量測總長度為310cm (3100mm)時，其一半為  $(310/2) = 155 \text{ cm (1550mm)}$ ，注意這個數字只是機壁的中心線而並非機台的中心線。因此須在  $1550\text{mm} + 25\text{mm} = 1575\text{mm}$  才是真正的機台行紙中心線。

If Wall length total is 3100mm,so middle is 1550mm

1550mm is wall center , but real feeder center must plus 25mm 。 “1575mm”

量測操作側內車壁至刀輪中心線鋼印尺寸為1575mm時，將刀輪橫移設定為0(手動刀輪則將轉盤長短指針同時對準刻度0)