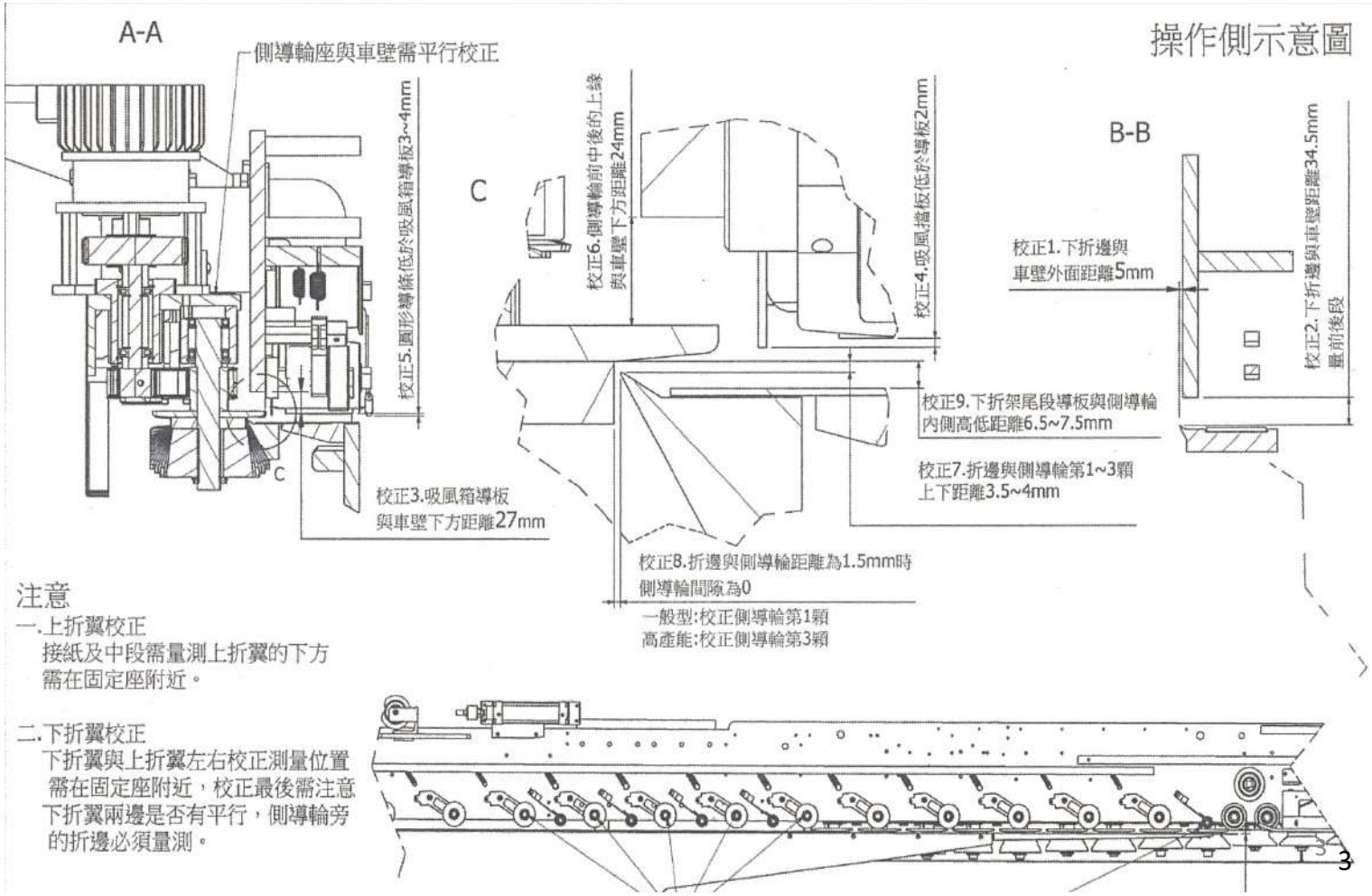
長聲工業股份有限公司
SUNRISE PACIFIC CO., LTD.

校正手冊

Model 機種型號：S-1000型選配裝置

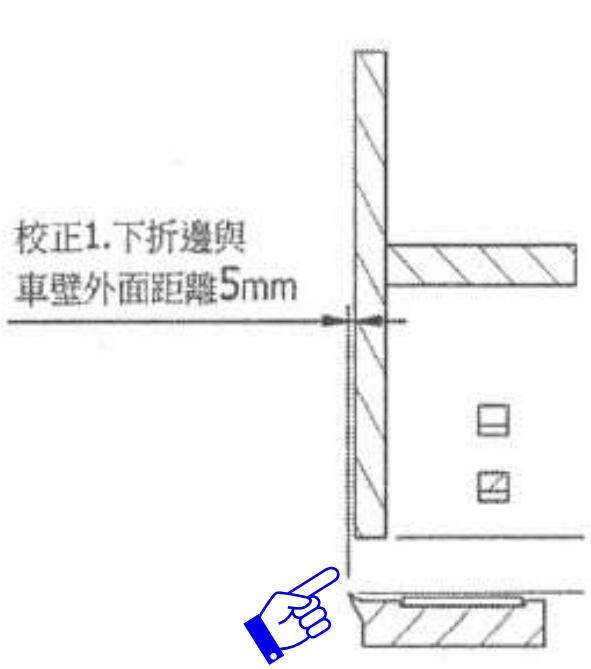
折翼六點校正
FFG Six-point Calibration

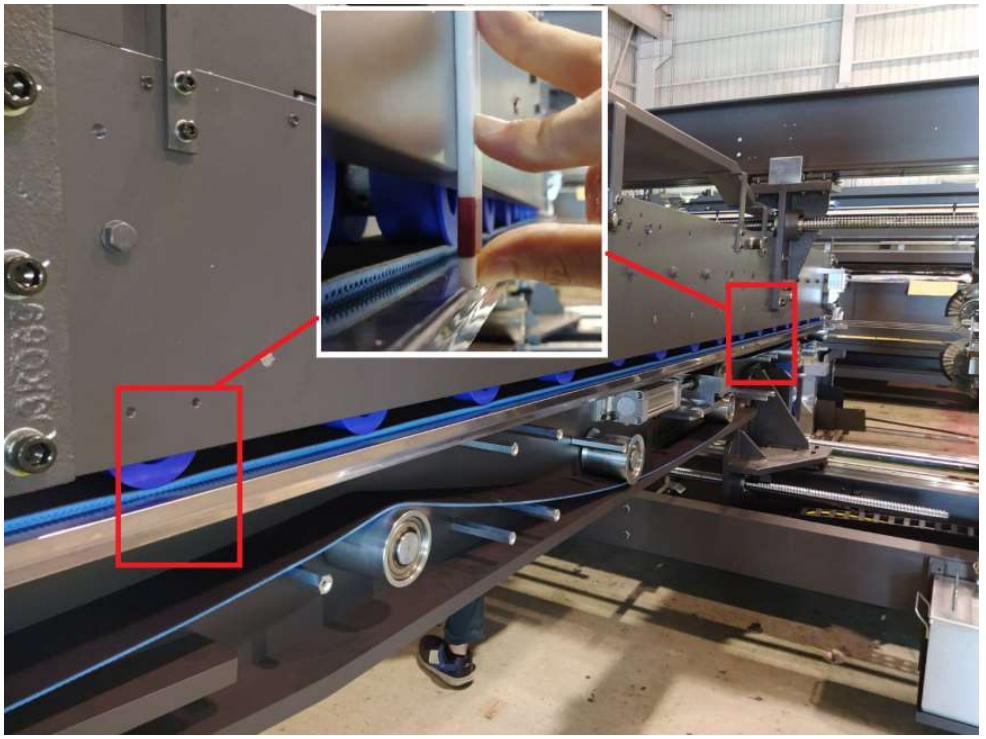
折翼六點校正
FFG Six-point Calibration



折翼六點校正
FFG Six-point Calibration

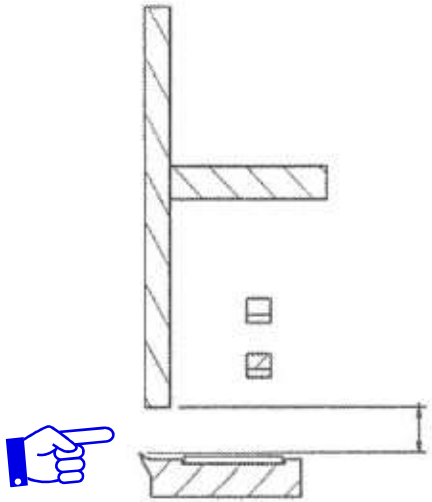
1.下折邊與車壁外面距離 5mm
Lower corner and outer wall distance 5mm



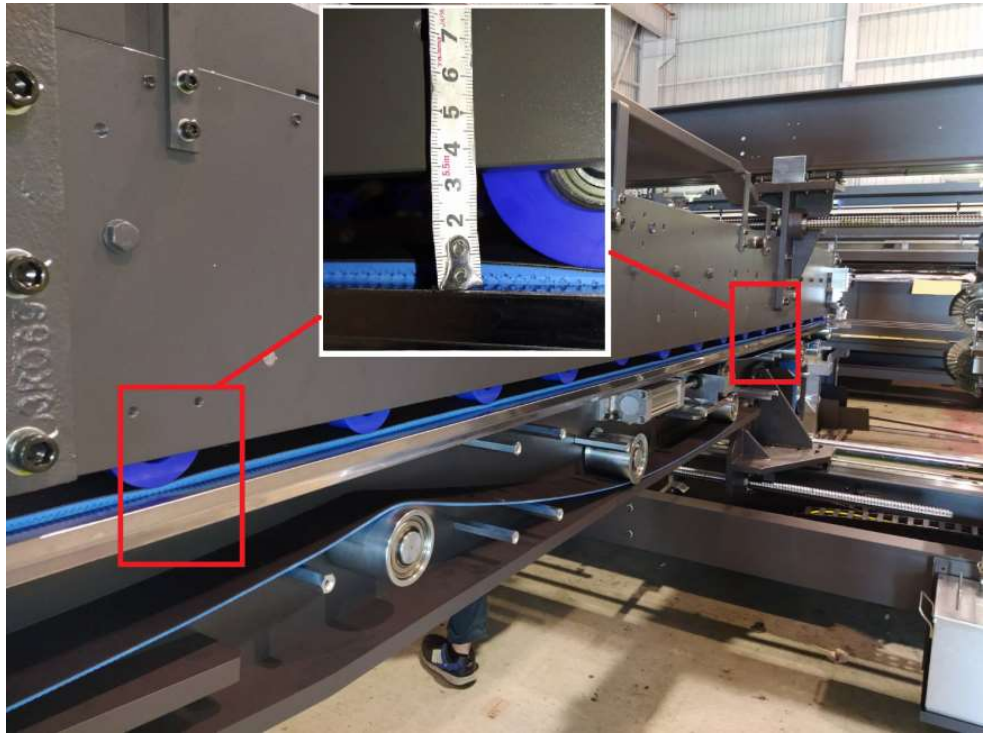


折翼六點校正
FFG Six-point Calibration

2.下折邊與車壁上下距離 34.5mm
Lower corner and outer wall up and down distance is 34.5mm

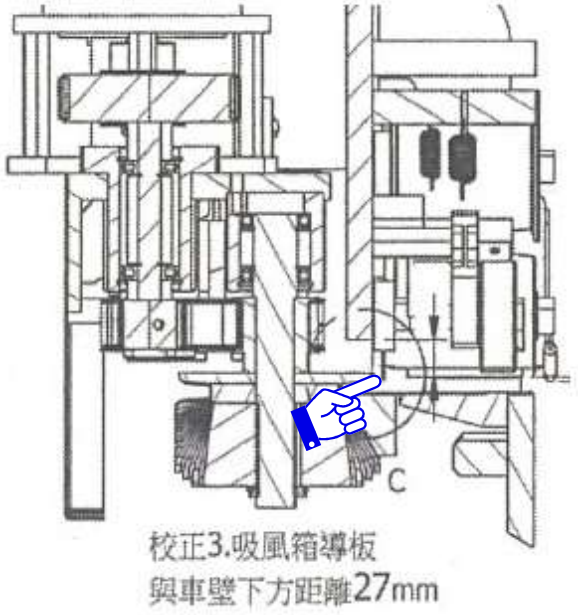


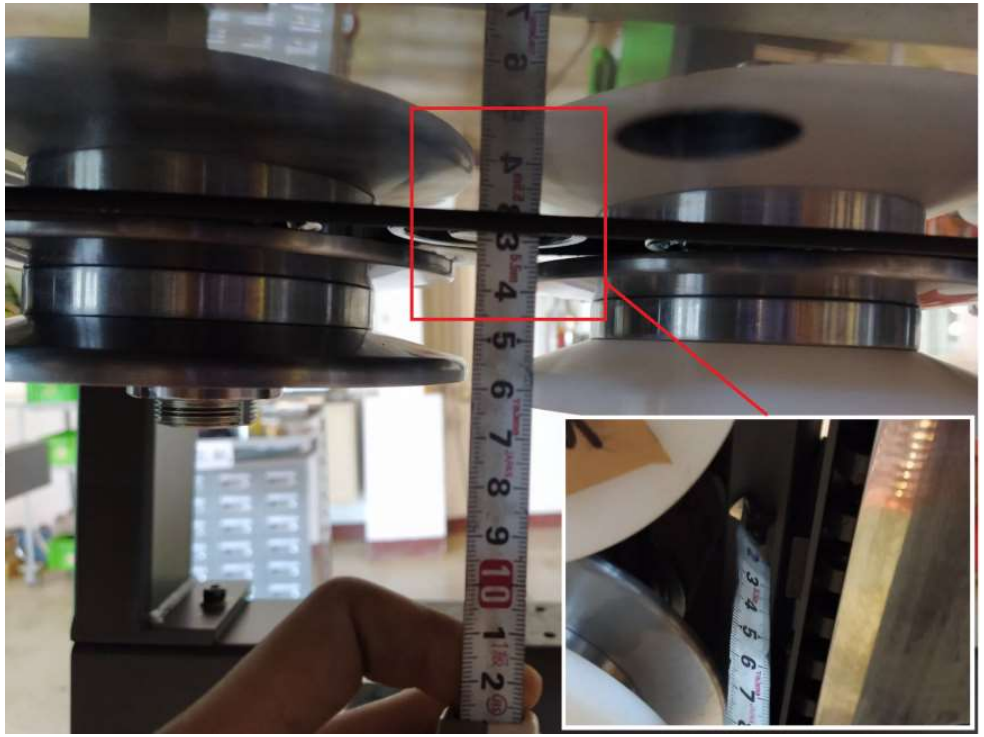
校正2.下折邊與車壁距離34.5mm
量前後段



折翼六點校正
FFG Six-point Calibration

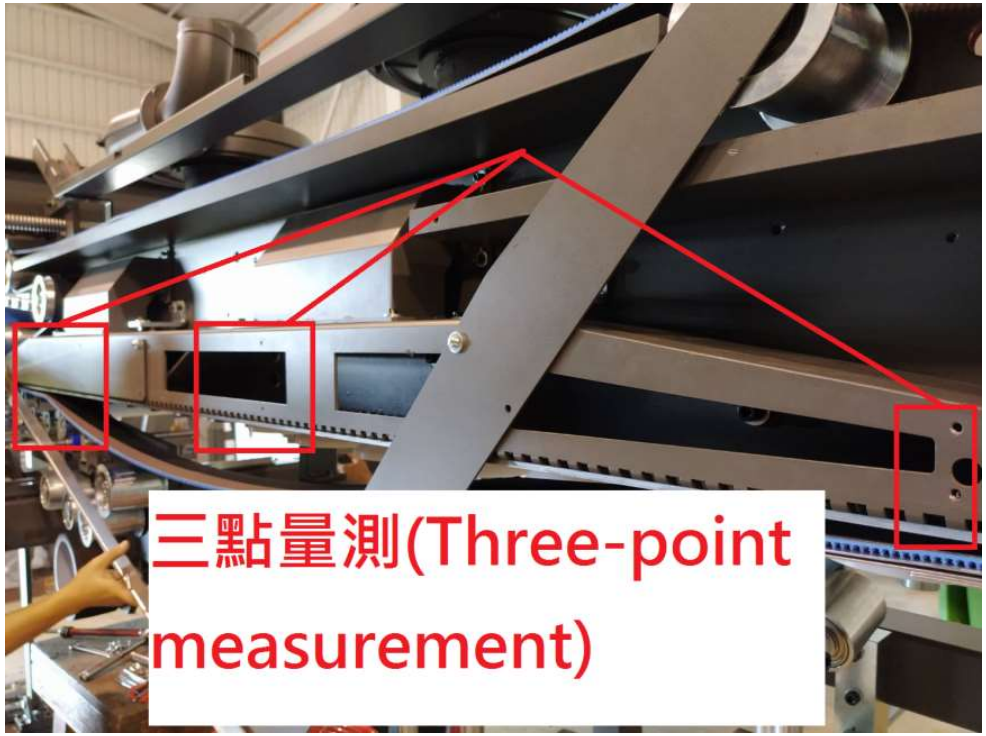
3.吸風箱導板與下車壁距離 27mm +2mm 檔板 = 29mm
Vacuum box guide plate and lower wall distance 27mm + 2mm plate = 29 mm





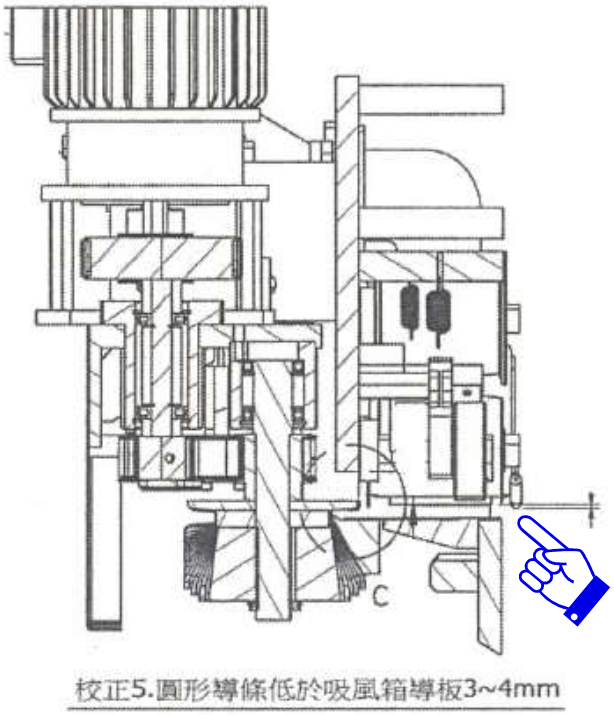
折翼六點校正
FFG Six-point Calibration

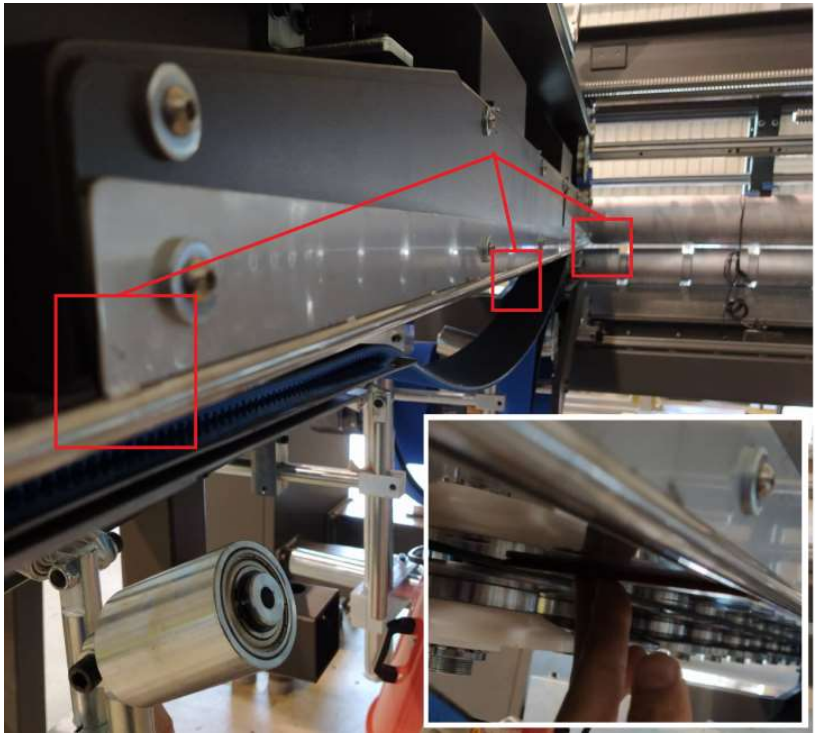
3.吸風箱導板與下車壁距離 27mm +2mm 檔板 = 29mm
Vacuum box guide plate and lower wall distance 27mm + 2mm plate = 29 mm



折翼六點校正
FFG Six-point Calibration

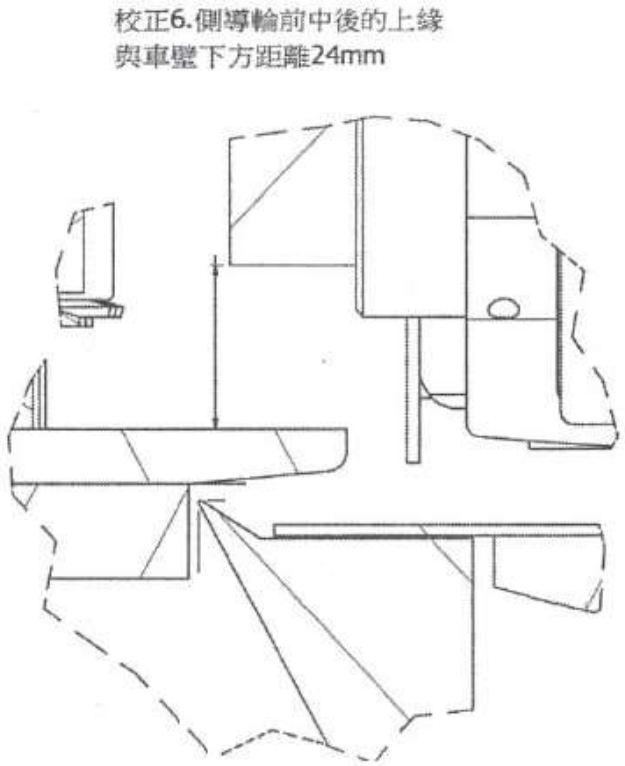
5.圓形導條低於吸封箱導板3~4mm
The circular guide bar is lower than vacuum box guide 3~4mm





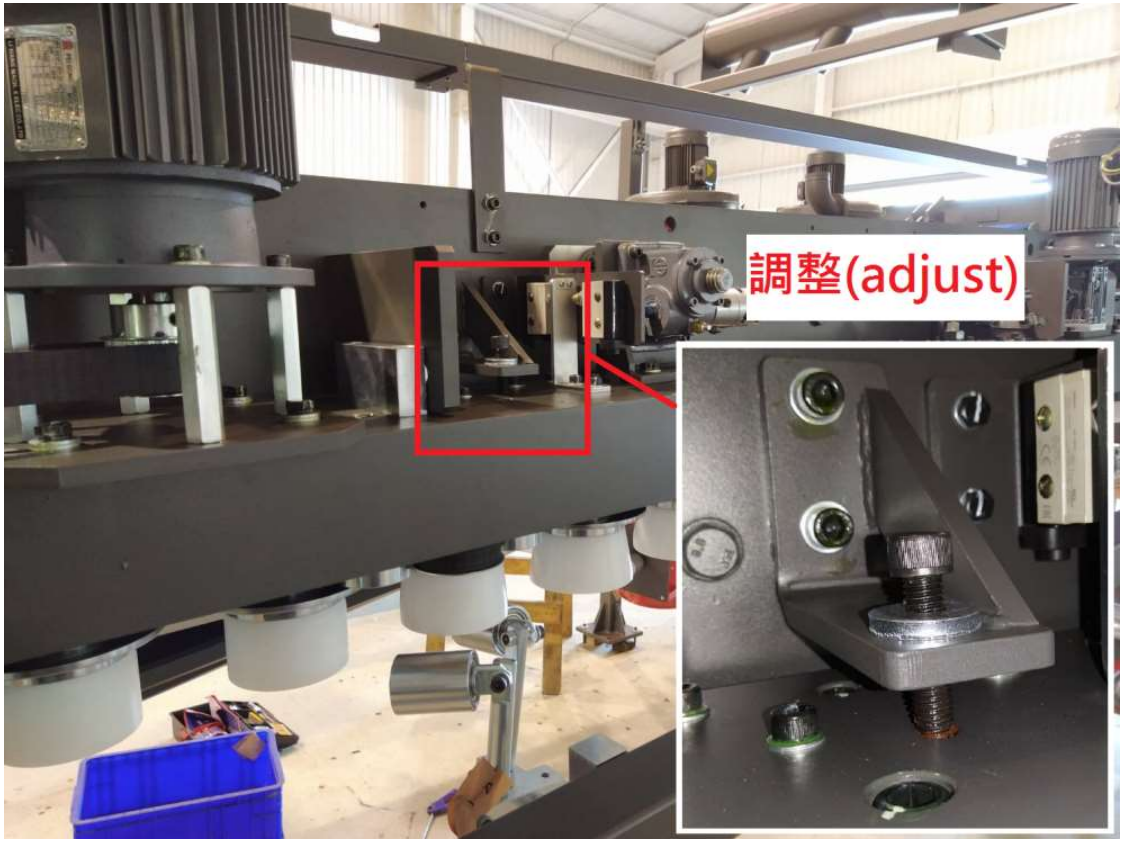
折翼六點校正
FFG Six-point Calibration

6.側導輪前中後的上緣與車壁下方距離 24mm
The upper edge of side guide wheel is 24 mm below the wall of the vehicle



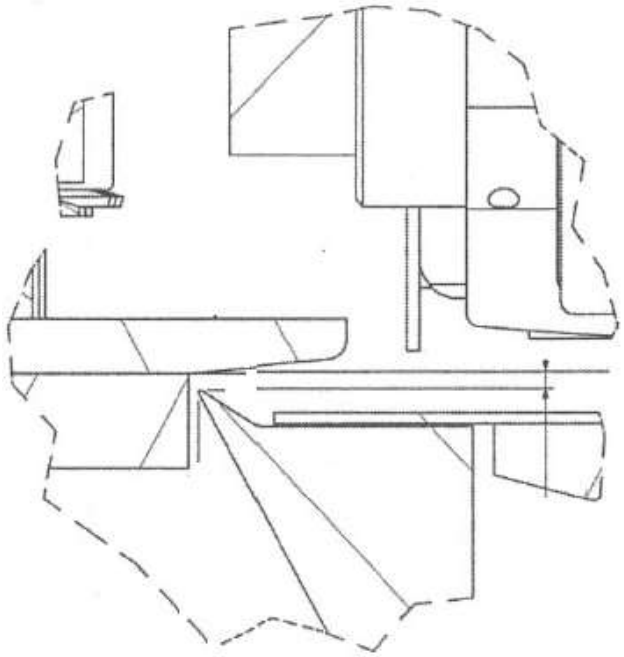
折翼六點校正
FFG Six-point Calibration

6.側導輪前中後的上緣與車壁下方距離 24mm
The upper edge of side guide wheel is 24 mm below the wall of the vehicle

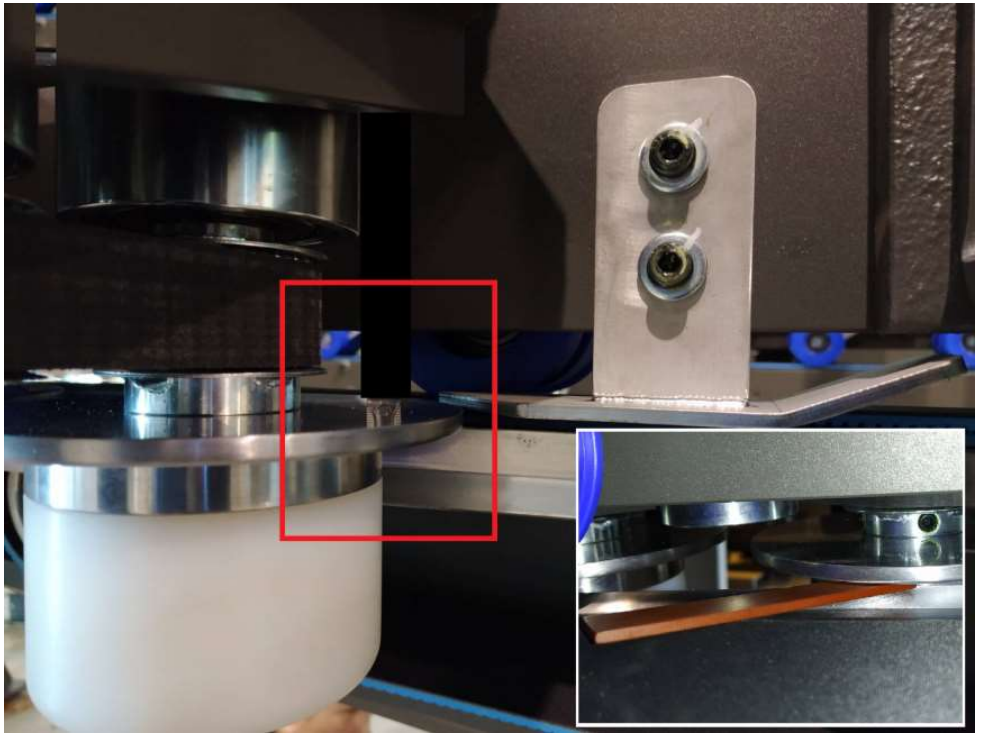


折翼六點校正
FFG Six-point Calibration

7.折邊與側導輪1~3顆上下距離 3.5~4 mm
Corner and side guide wheel 1~3 distances is 3.5~4 mm

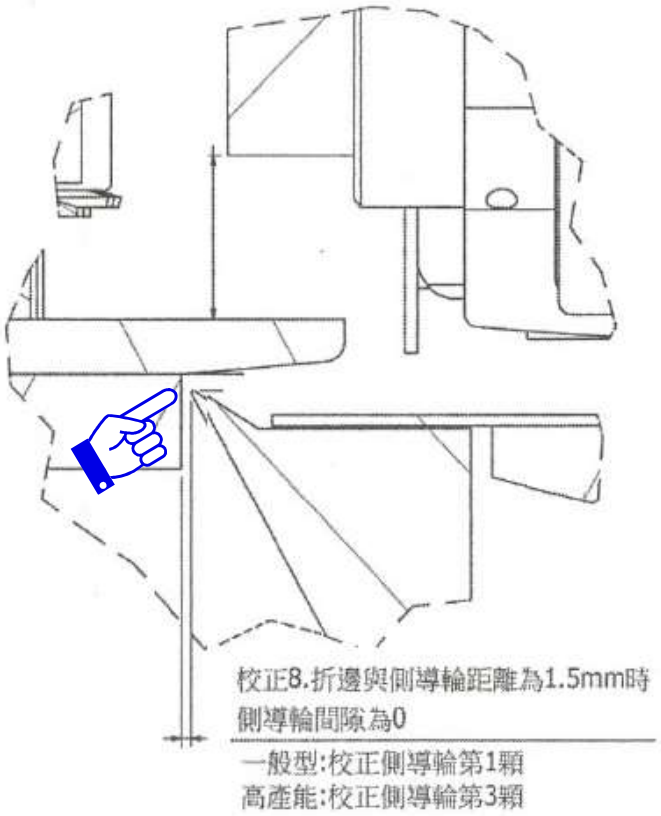


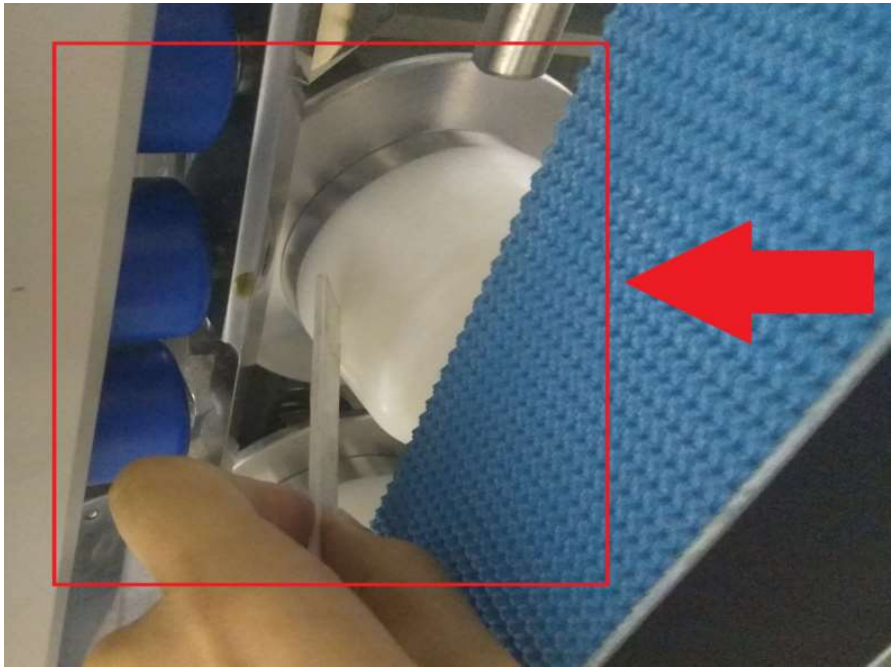
校正7.折邊與側導輪第1~3顆
上下距離3.5~4mm



折翼六點校正
FFG Six-point Calibration

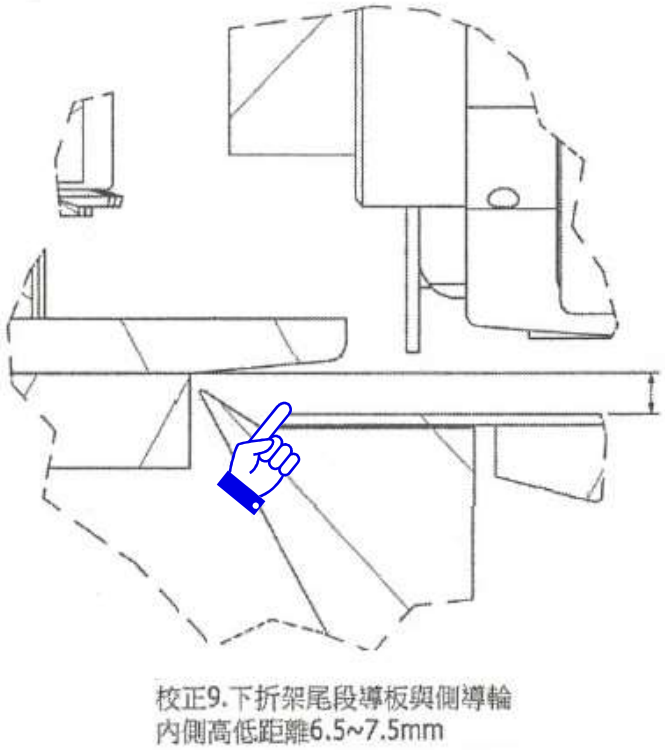
8.折邊與側導輪距離 1.5 時設定 ” 0 ”
Corner and side guide wheel 1~3 up and down distances 1.5 mm set “0”

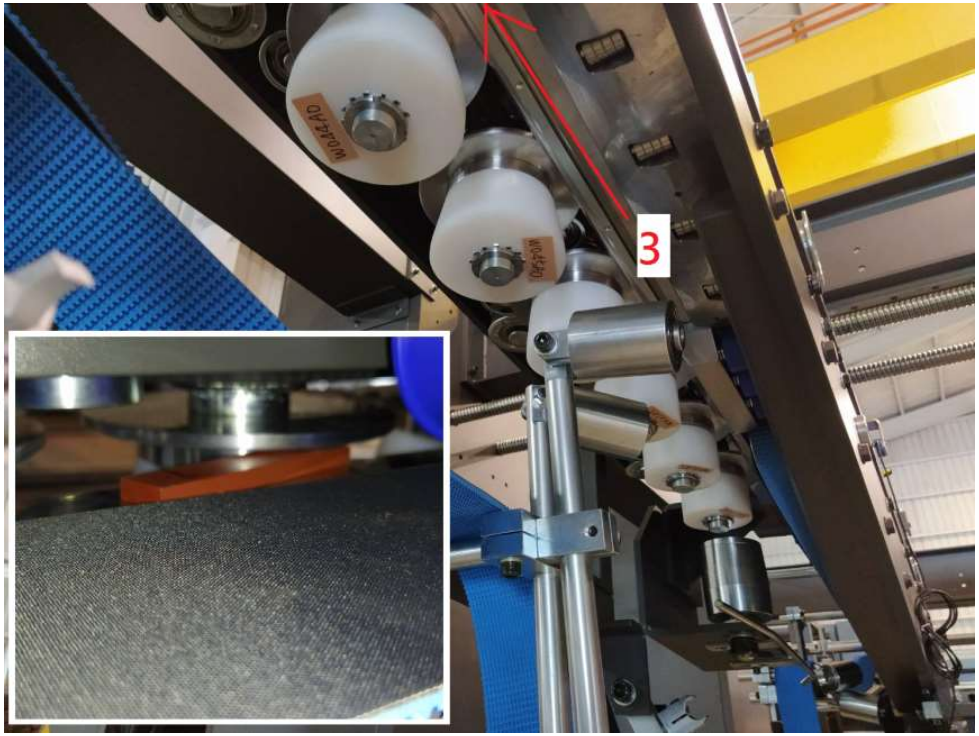




折翼六點校正
FFG Six-point Calibration

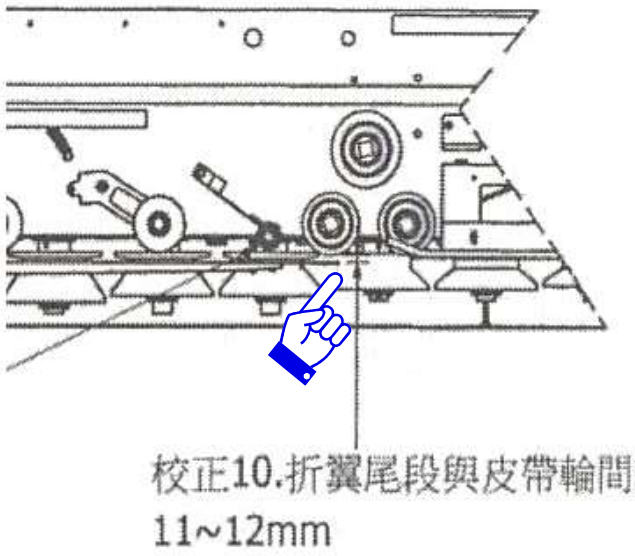
9.下折架尾段導板與側導輪內側高低距離 6.5~7.5mm
Low side guide plate and side guide wheel distances is 6.5~7.5 mm

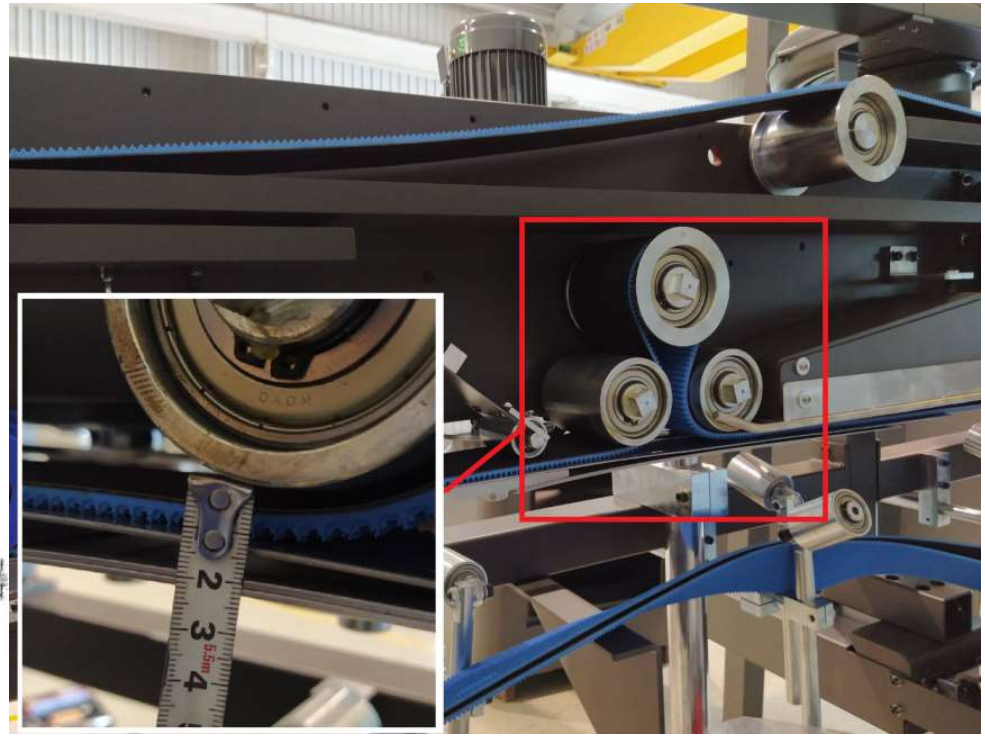




折翼六點校正
FFG Six-point Calibration

10.折翼尾段與皮帶輪間隙 11~12mm
Last side guide plate and pulley distances is 11~12 mm





折翼咬紙輪間隙校正方式
Press Roll Gap Calibration

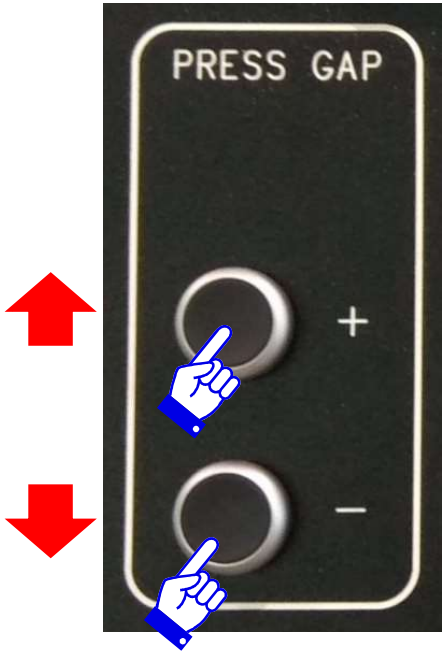
折翼咬紙輪間隙校正方式
Press Roll Gap Calibration

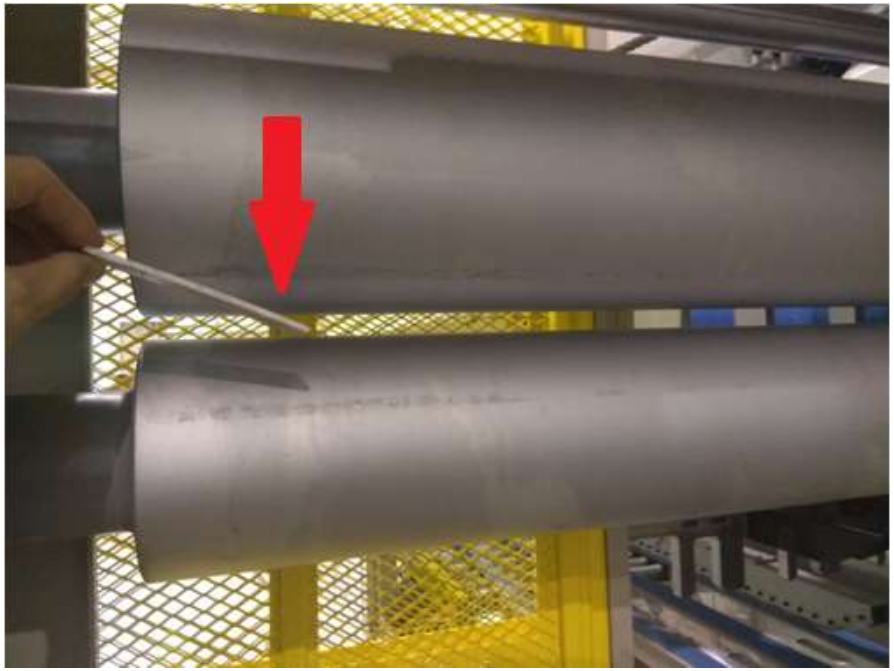
折翼咬紙輪間隙校正方式
Press Roll Gap Calibration

1. 準備一個5 mm厚的厚薄規

   Prepare a 5mm thickness gauge block (or 5mm thickness spanner)

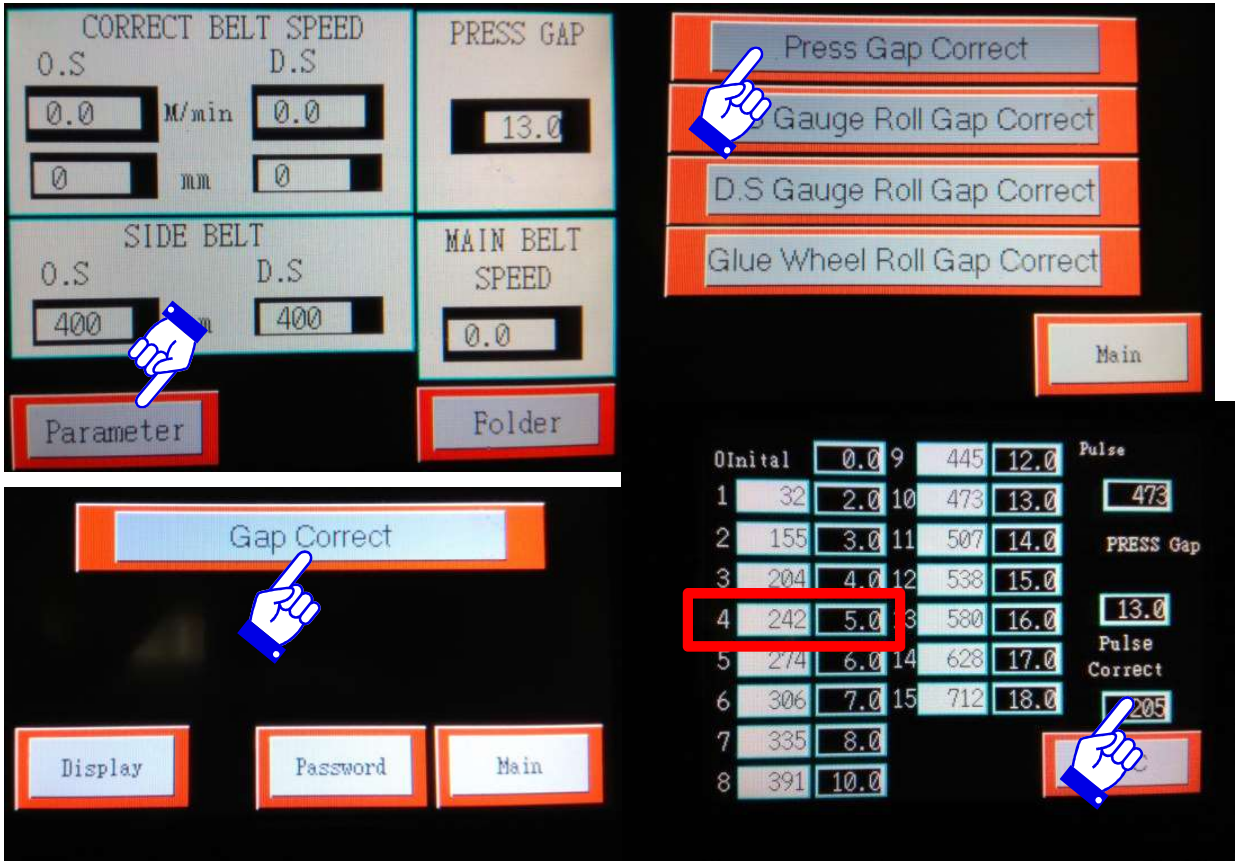
2.調整到實際值是5mm。 .(Glue Wheel Roll GAP is adjusted to the actual value is 5mm)





折翼咬紙輪間隙校正方式
Press Roll Gap Calibration

5. 接著到到人機(HMI)→參數設定(Parameter) (PW：33850780) →重設目前值(Gap correct)
→ 設定咬紙輪位置實際值(Set the actual value of the Press gap setting 5mm)



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

←EX：setting 242

折翼位置校正方式
Glue Position Calibration

折翼位置校正方式
Glue Position Calibration

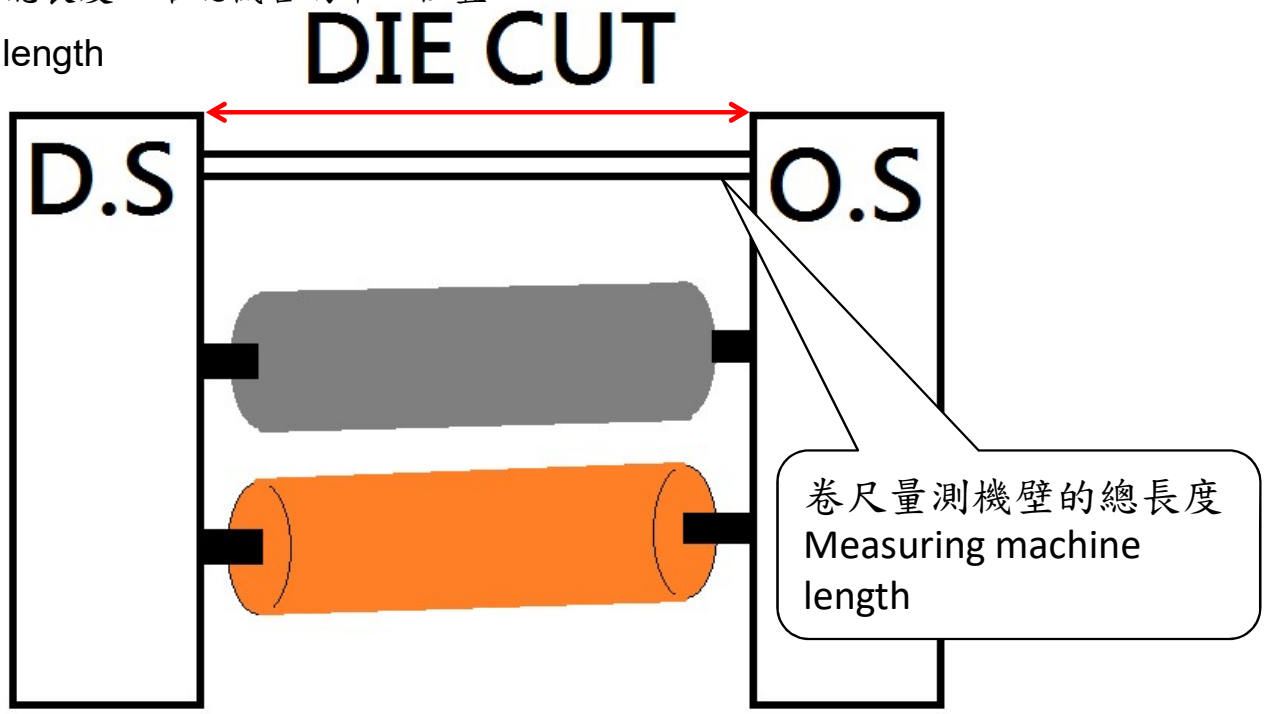
折翼位置校正方式
Glue Position Calibration

1. 準備一個卷尺來作距離量測。

   Tape measure to measure distance

2. 先行量測模切機壁的總長度以確認機台的中心位置

   Measuring machine length

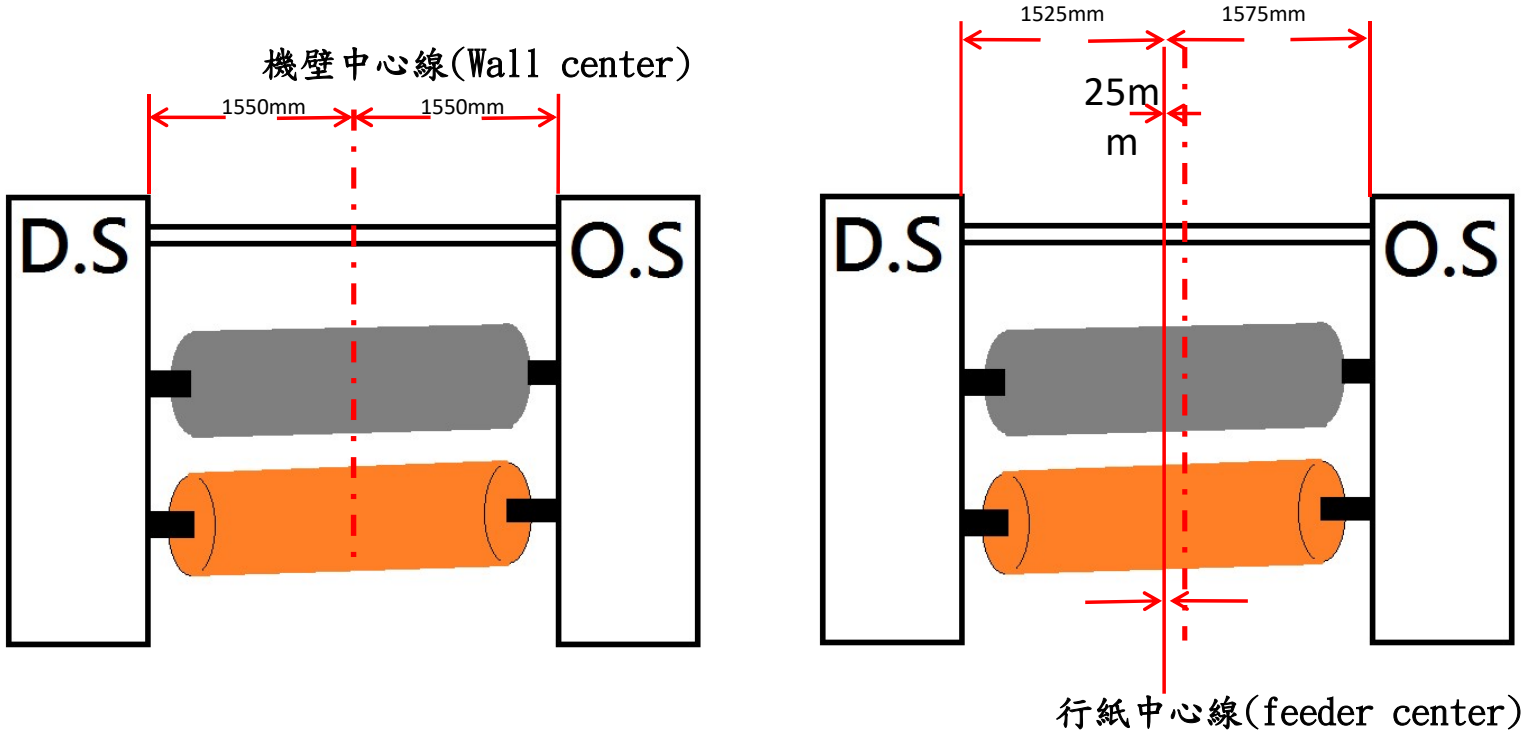


折翼位置校正方式
Glue Position Calibration

3. 若機壁量測總長度為310cm (3100mm)時，其一半為 (310/2) = 155 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1550mm + 25mm = 1575mm才是真正的機台行紙中心線。

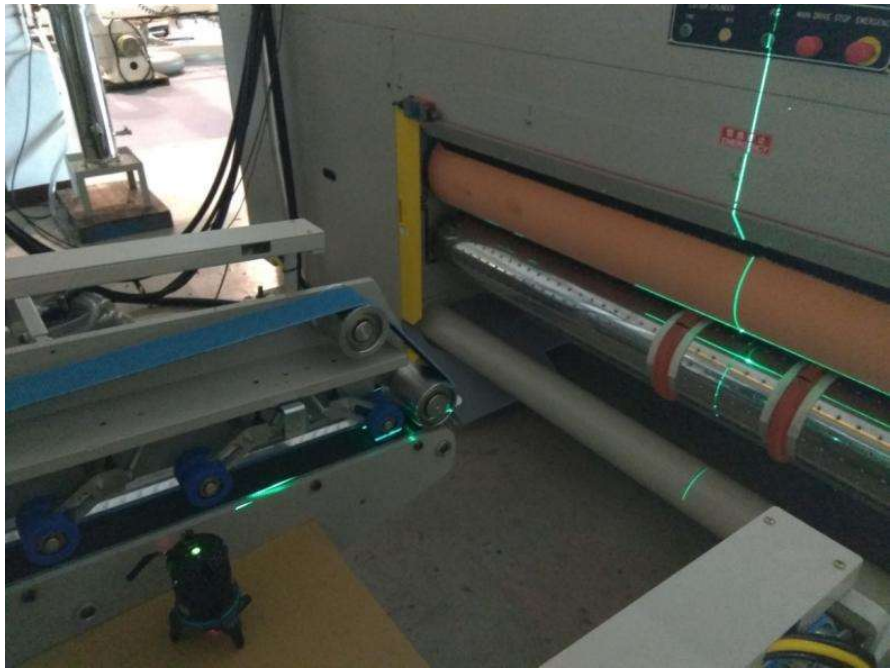
If Wall length total is 3100mm,so middle is 1550mm

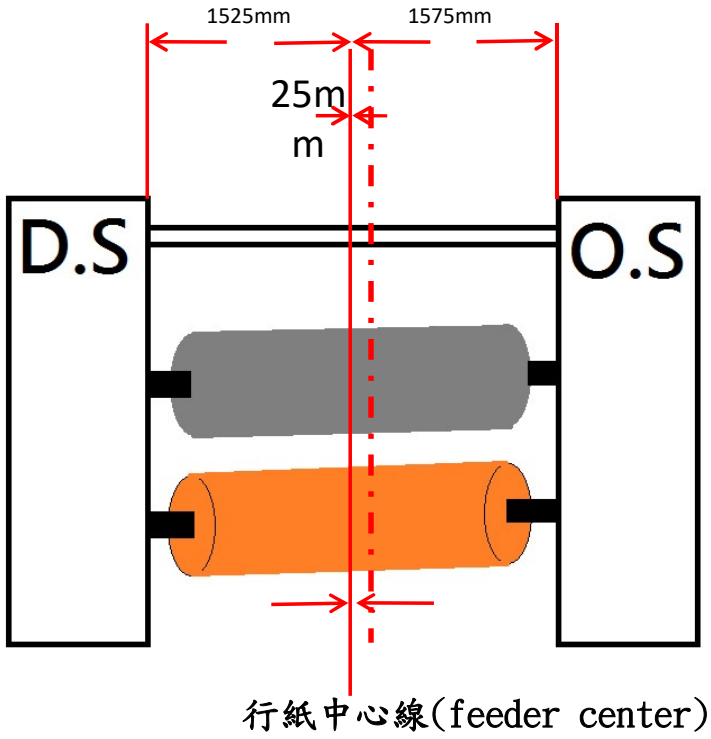
1550mm is wall center , but real feeder center must plus 25mm 。 ""1575mm""



開槽刀位置校正
Slotting Knife Position Calibration

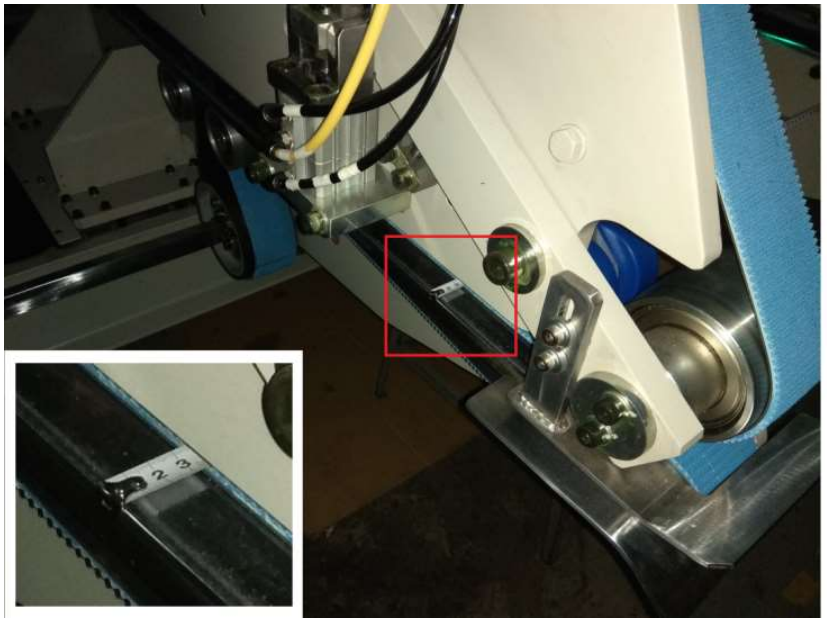
4. 使用墨線儀對準行機台行紙中心線 (use crossline laser to align center line of the machine)





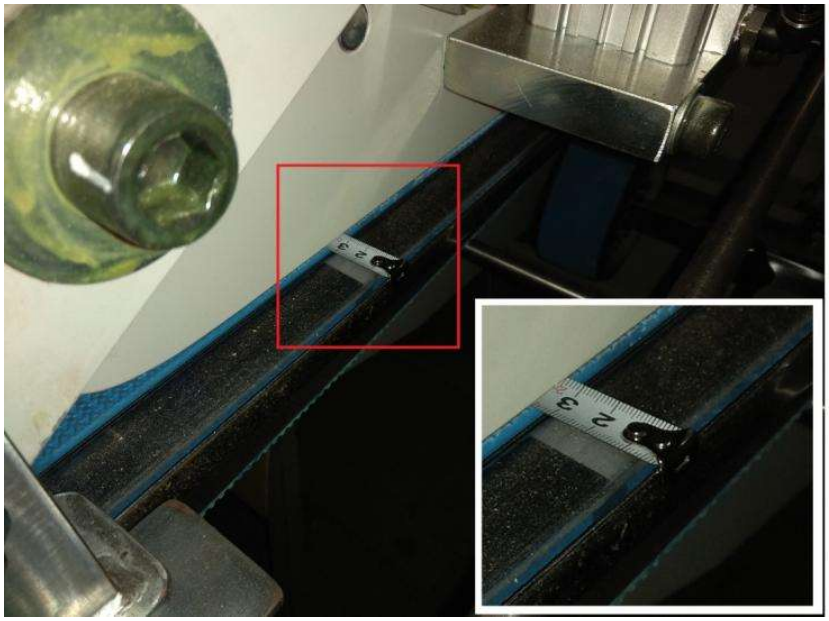
折翼位置校正方式
Glue Position Calibration

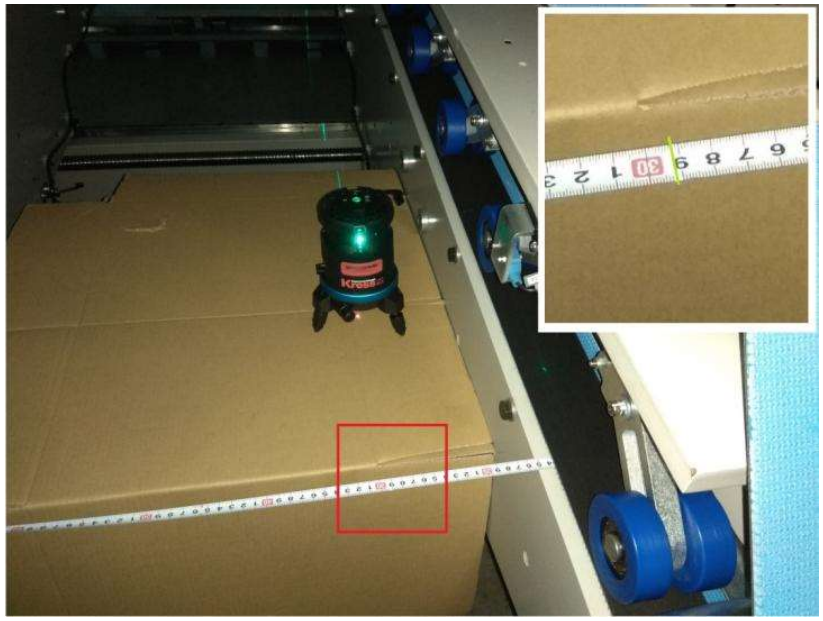
5. 使用捲尺量測操作側數值 (Use the tape measure to measure the operator side value)



折翼位置校正方式
Glue Position Calibration

5. 使用捲尺量測操作側數值 (Use the tape measure to measure the driver side value)





折翼位置校正方式
Glue 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)→設定操作側與驅動側位置實際值(Set the actual value of the operator side and driver side position)

折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

1. 準備一個5 mm厚的厚薄規

   Prepare a 5mm thickness gauge block (or 5mm thickness spanner)

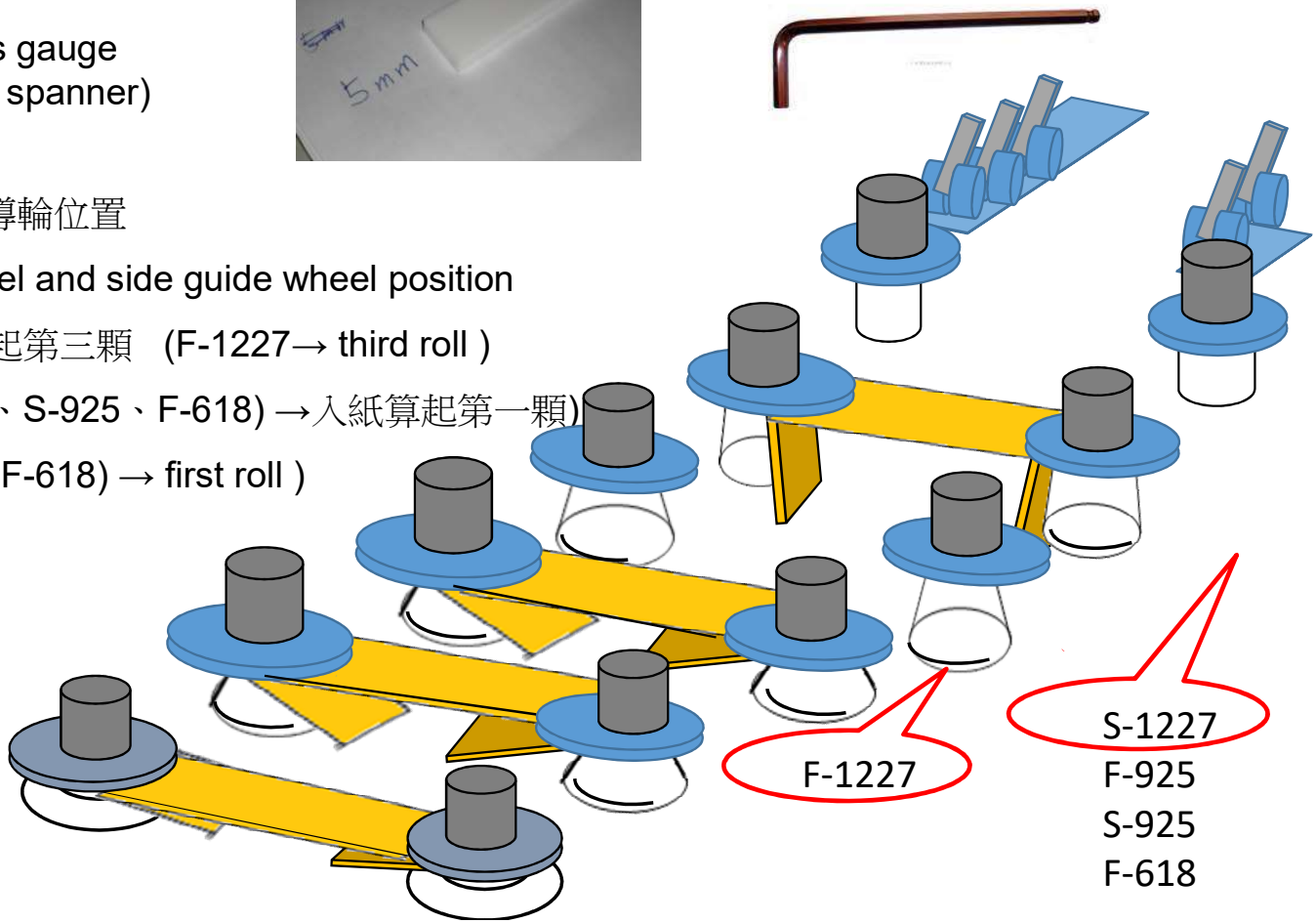
2. 確認須校正機台型號的側導輪位置

   Confirm the machine model and side guide wheel position

   ●高產能 F-1227→入紙算起第三顆 (F-1227→ third roll)

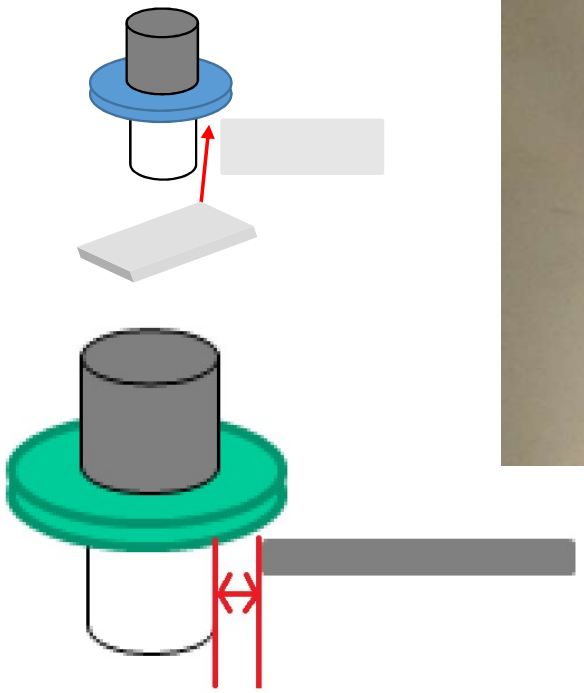
   ●一般型 (S-1227、F-925、S-925、F-618) →入紙算起第一顆)

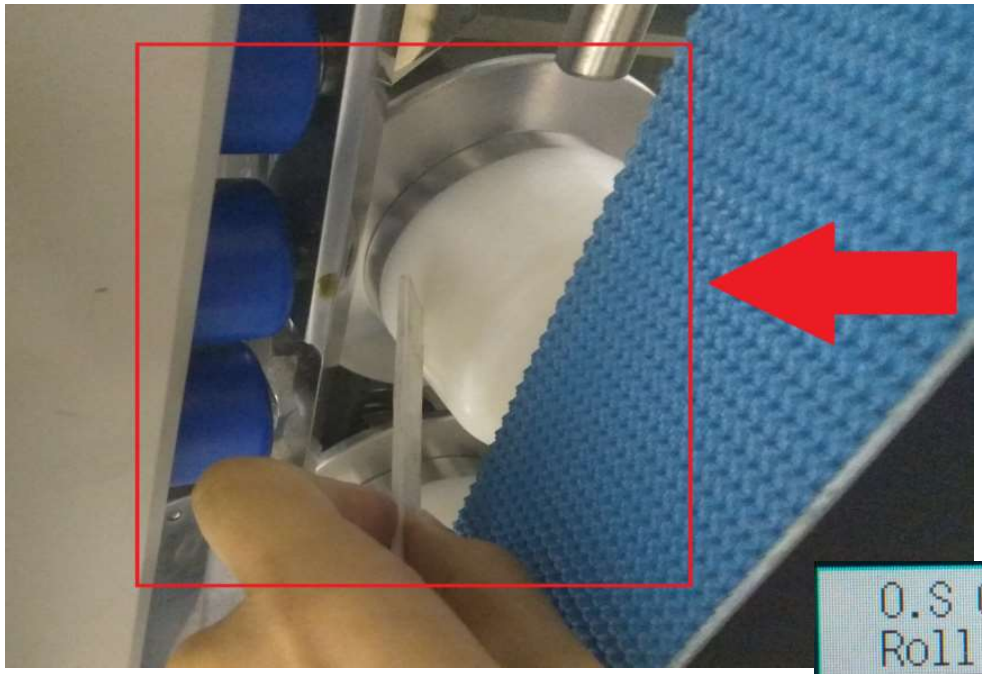
   (S-1227、F-925、S-925、F-618) → first roll)



折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

3. 操作側調整到實際值是5mm。 (Operator side is adjusted to the actual value is 5mm)



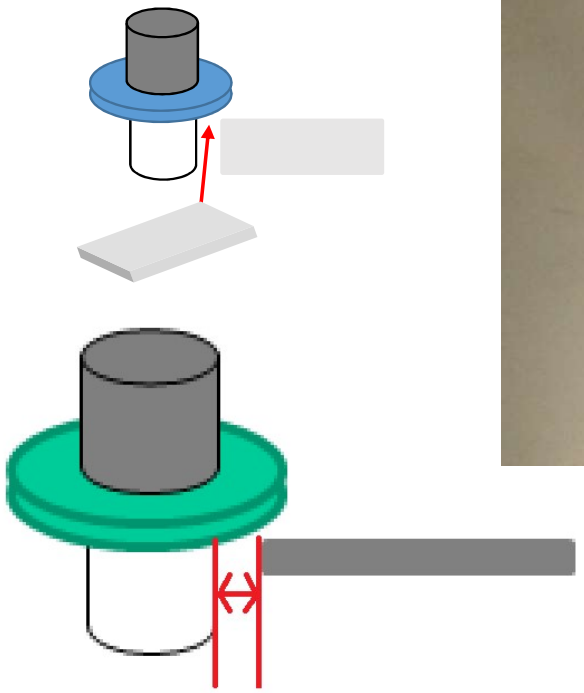


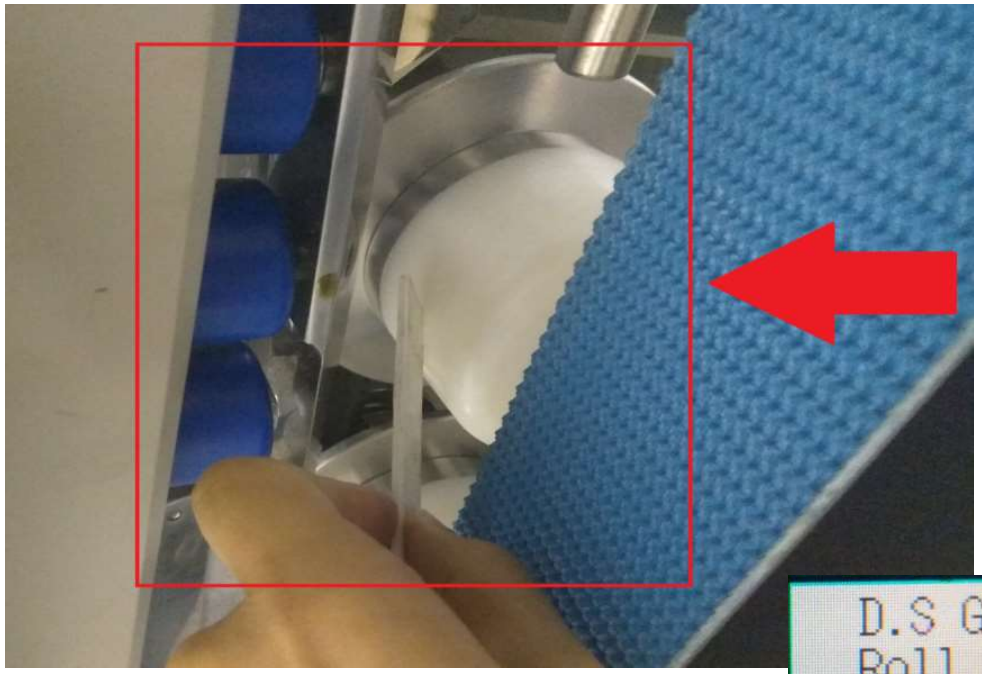
“ - ” 縮小 (gap small)

“ + ” 放大 (gap big)

折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

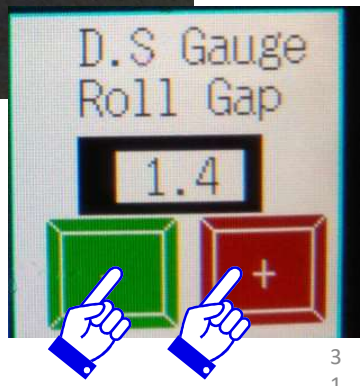
4. 驅動側調整到實際值是5mm。 (driver side is adjusted to the actual value is 5mm)





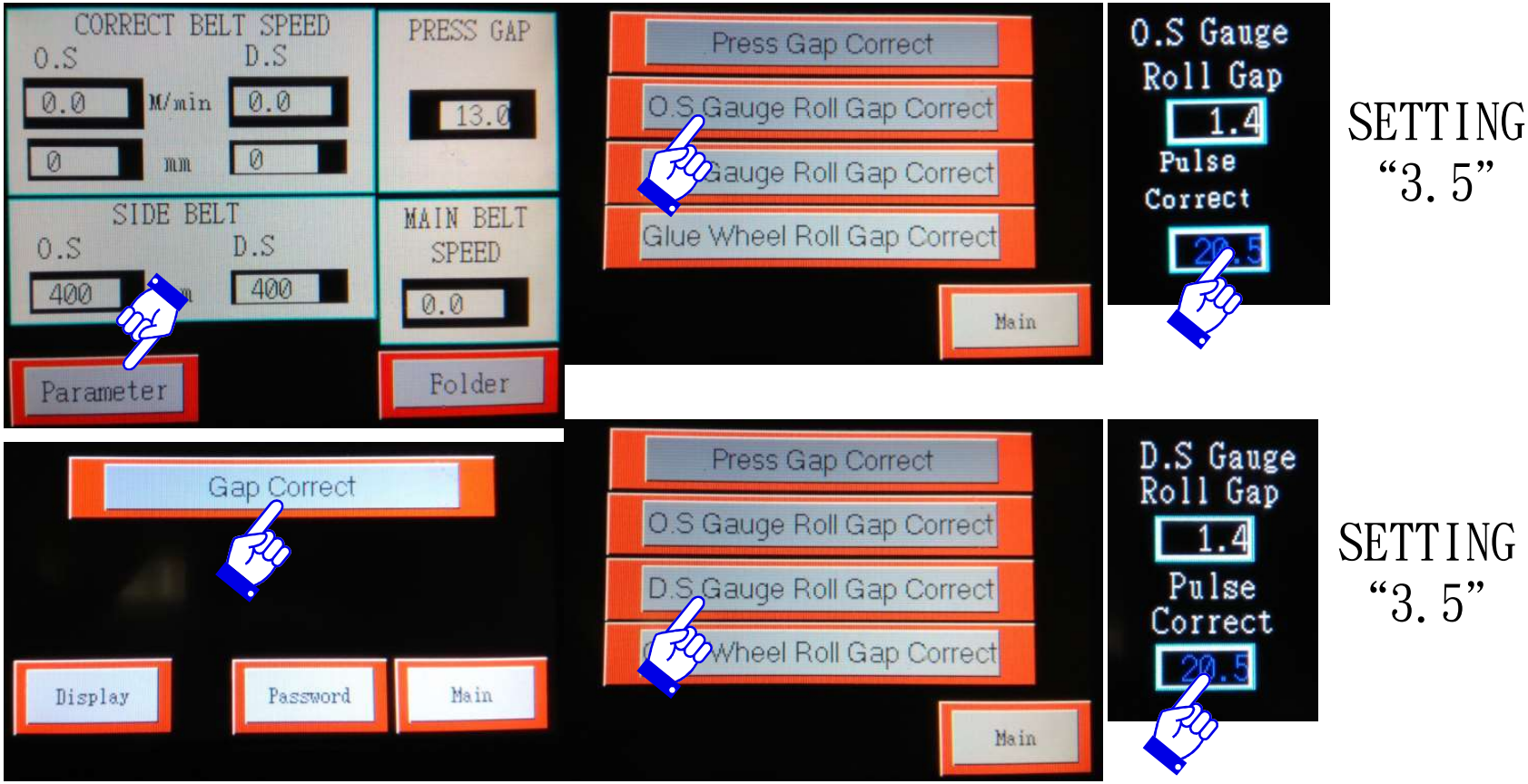
“ - ” 縮小 (gap small)

“ + ” 放大 (gap big)



折翼側導輪間隙校正方式
Gauge Roll Gap Calibration

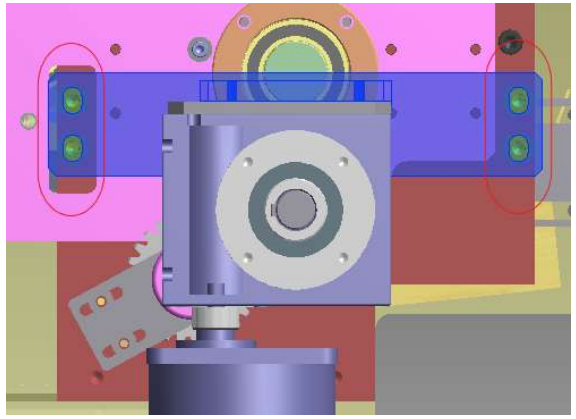
5. 接著到到人機(HMI)→參數設定(Parameter) (PW：33850780) →重設目前值(Gap correct) → 設定操作側與驅動側位置實際值(Set the actual value of the operator side and driver side gap setting “3.5”)



糊輪間隙校正
Glue Wheel Gap Calibration

圖1

圖2

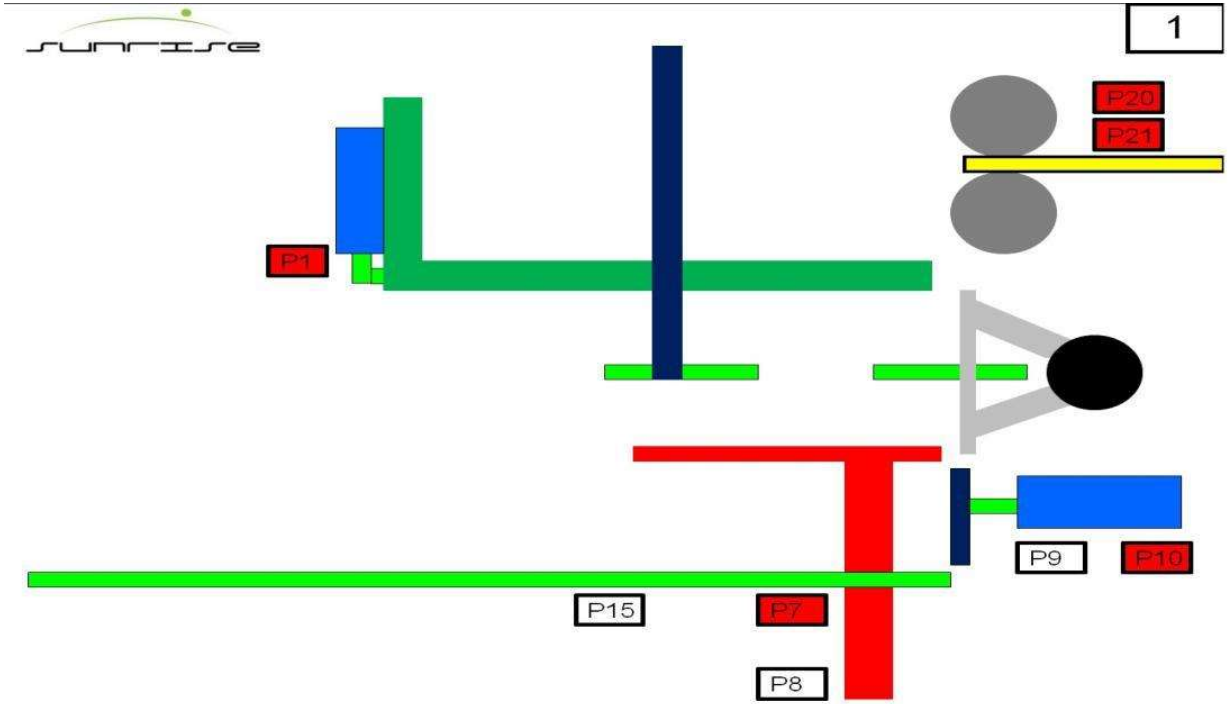


1.利用厚薄規量測糊輪間隙(圖1)最小值0.5mm（此時是偏心最小）
2.若偏心走到最小時，間隙數值大於0.5mm。將糊輪間隙馬達固鎖螺絲放鬆，利用馬達板長條孔(圖2)調整糊輪位置使間隙調整為0.5mm
3.最小值校正完成後各間係數值利用厚薄規依序校正。

長聲工業股份有限公司
SUNRISE PACIFIC CO., LTD.

Calibration Instruction Manual

Machine Model # S-1227



後檔板位置校正
Back Stop Position Calibration

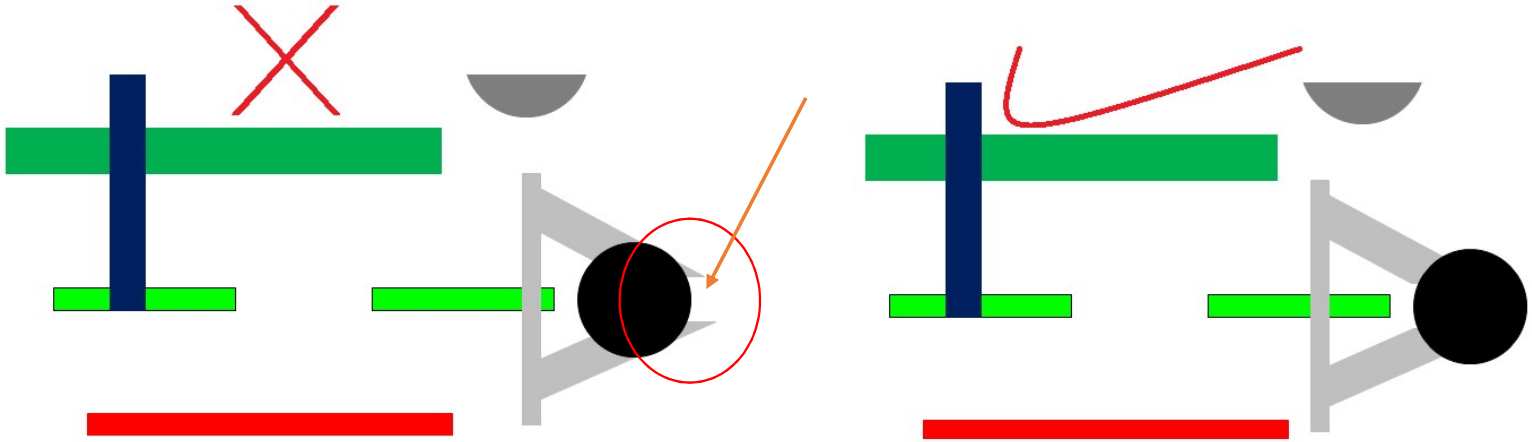
後檔板位置校正
Back Stop Position Calibration

1. 準備一個卷尺來作距離量測。

   Tape measure to measure distance

2. 轉動軸心，使拍板在最前方

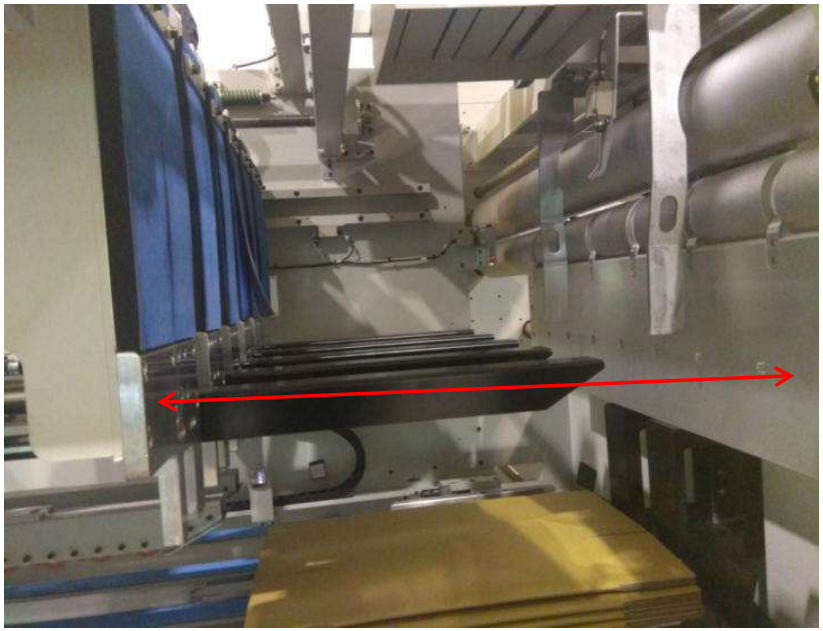
   Rotate the shaft so that the clapper is at the forefront

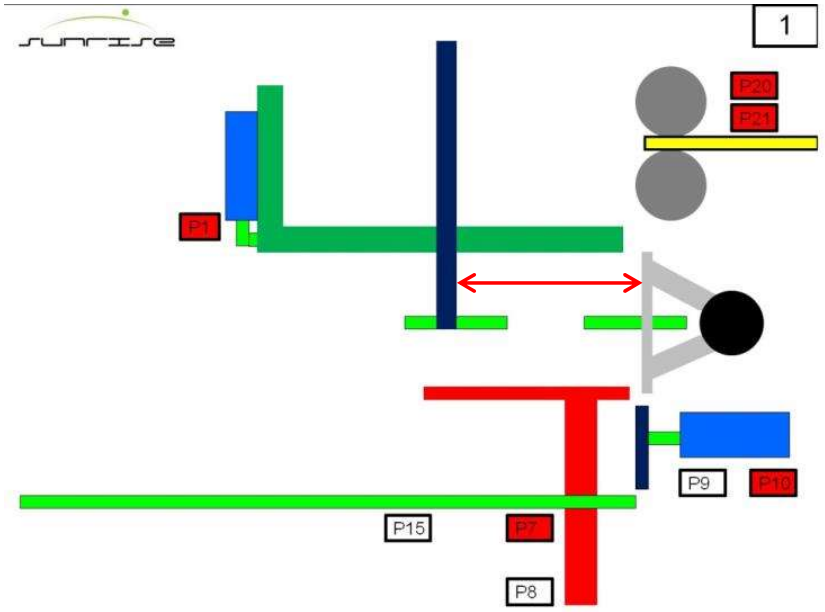


後檔板位置校正
Back Stop Position Calibration

3. 使用捲尺量測實際數值。

Use a tape measure to measure actual values

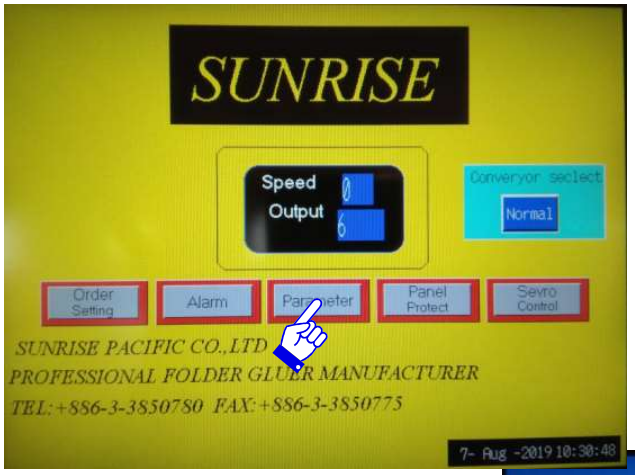


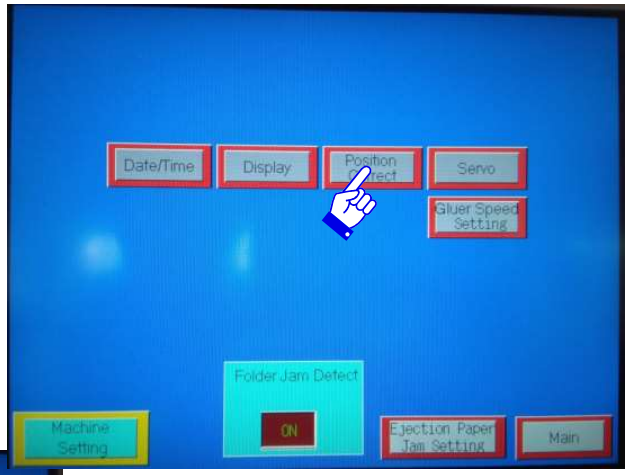


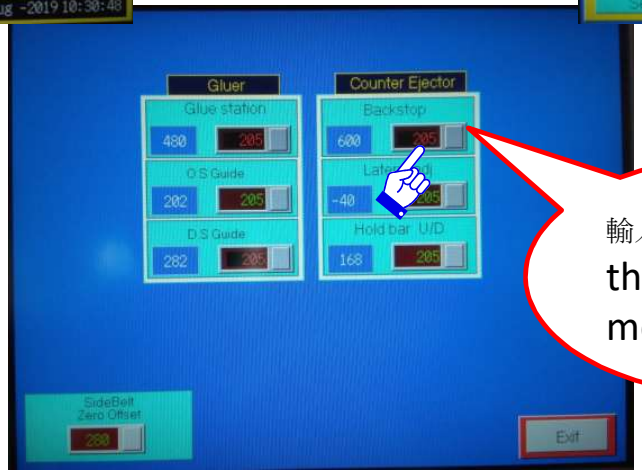
後檔板位置校正

Back Stop Position Calibration

4.接著到大人機(Main HMI)→參數設定(Parameter)→重設目前值(position correct)→後檔板(back stop)→ 設定實際量測的試數值(Set the actual measured value)







輸入實際量測值(Set the actual measured value)

横移位置校正
Lateral Position Calibration

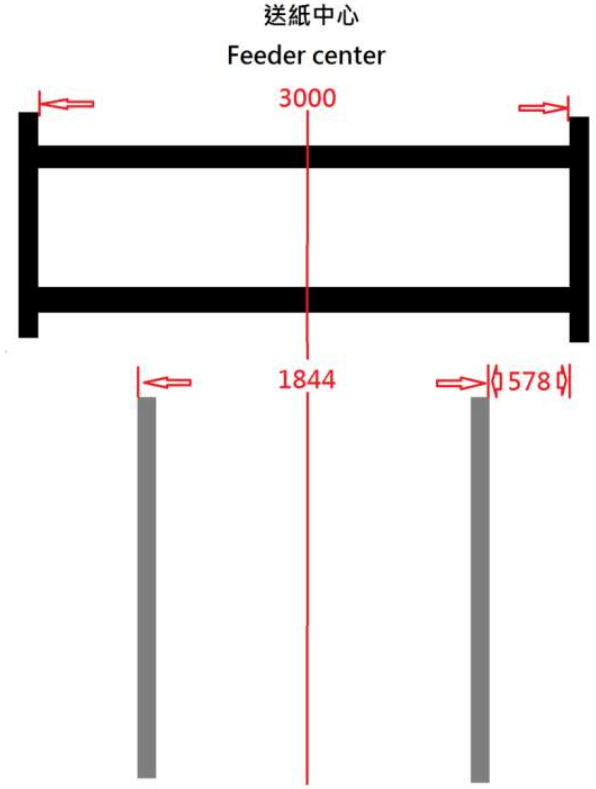
橫移位置校正
Lateral Position Calibration

1. 準備一個卷尺來作距離量測。

   Tape measure to measure distance

2. 移動橫移，使車壁移動到中心點

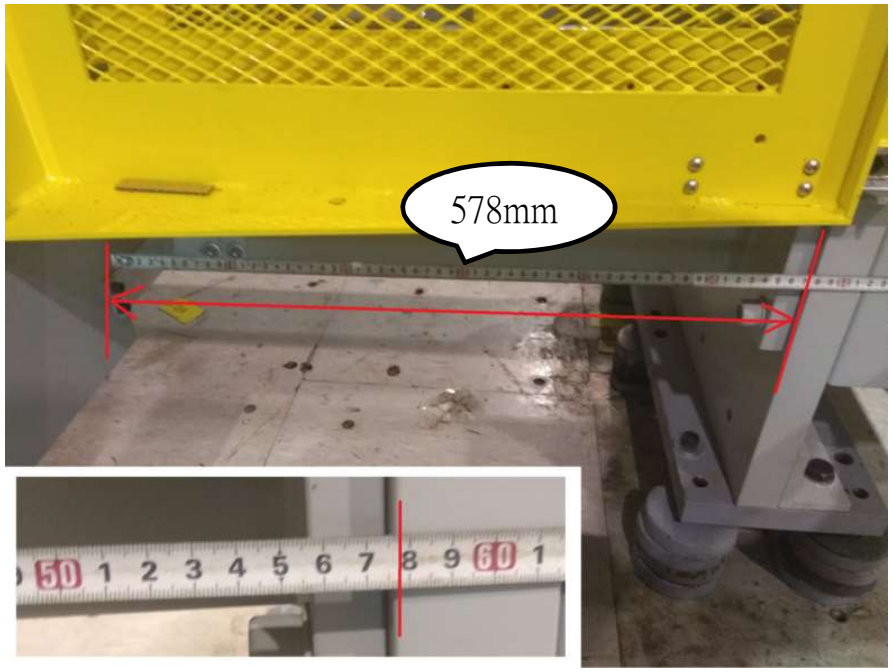
   Move lateral to move the wall to the center

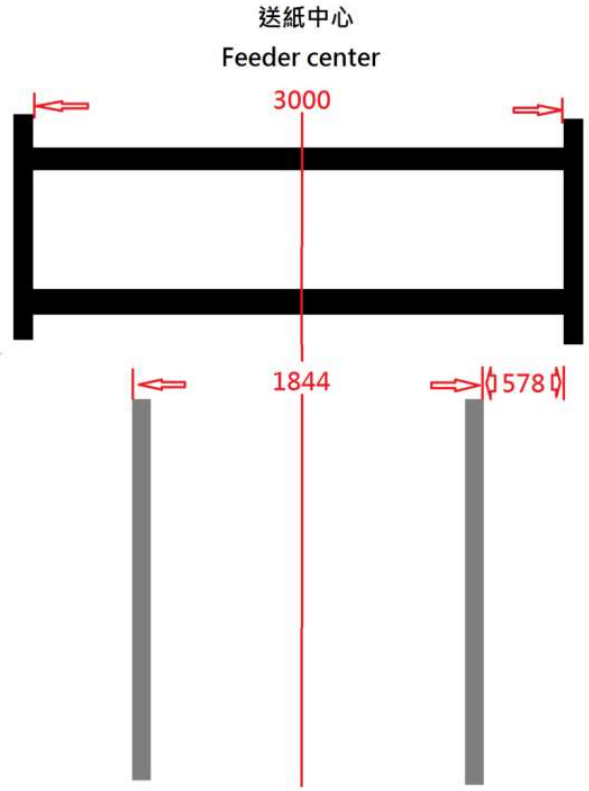


橫移位置校正
Lateral Position Calibration

3. 使用捲尺量測實際數值。

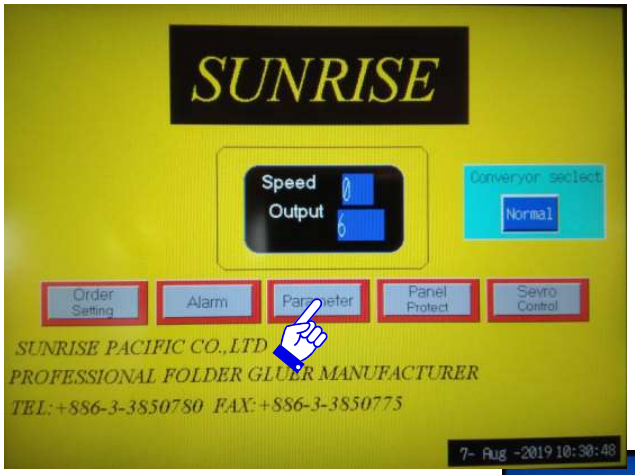
Use a tape measure to measure actual values

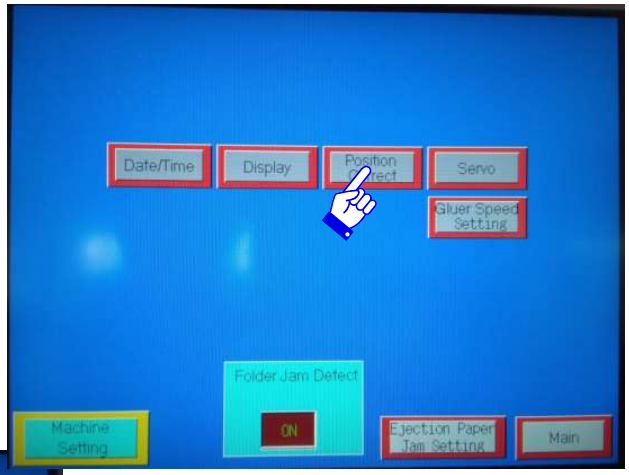


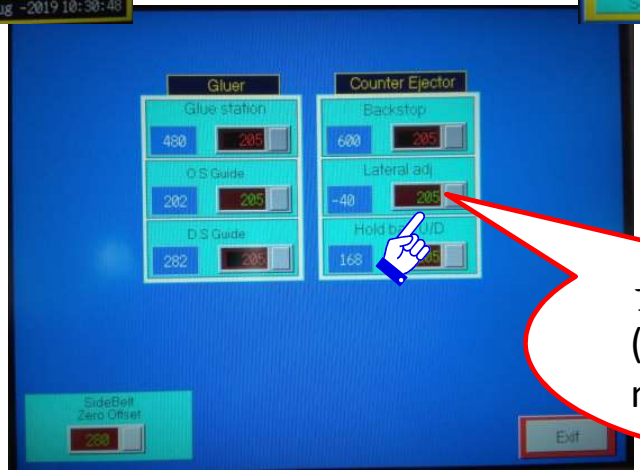


橫移位置校正
Lateral Position Calibration

4.接著到大人機(Main HMI)→參數設定(Parameter)→重設目前值(position correct)→橫移調整(Lateral adj)→ 量測578mm時設定”0” (Set "0" when measuring 578mm)







量測578mm時設定”0”
(Set "0" when measuring 578mm)

壓紙輪位置校正
Hold Bar Position Calibration

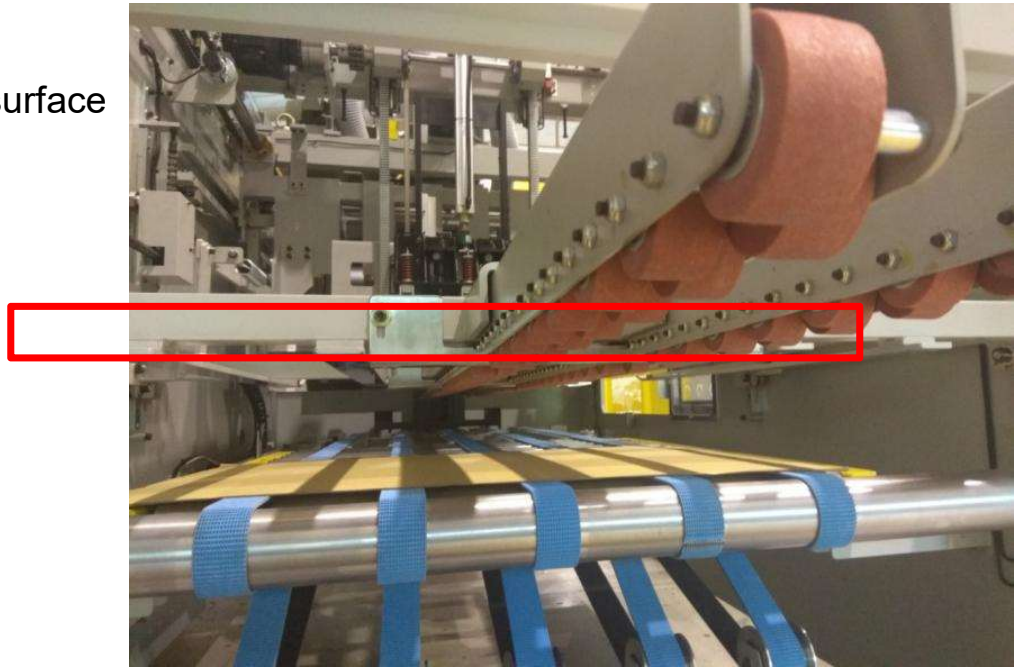
壓紙輪位置校正
Hold Bar Position Calibration

1. 準備一個卷尺來作距離量測。

Tape measure to measure distance

2. 放置平整紙板在皮帶面上

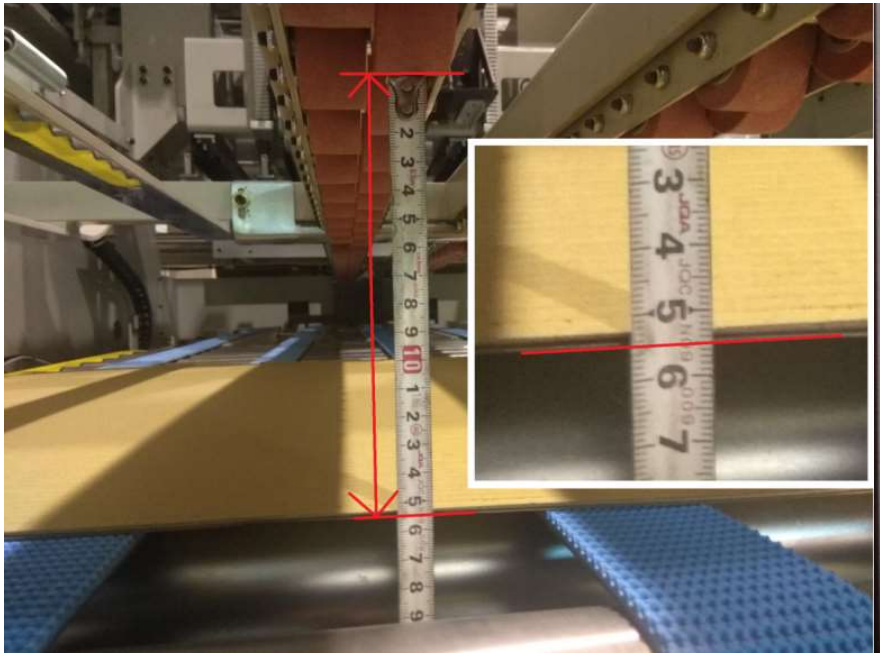
Place flat paper board on the belt surface

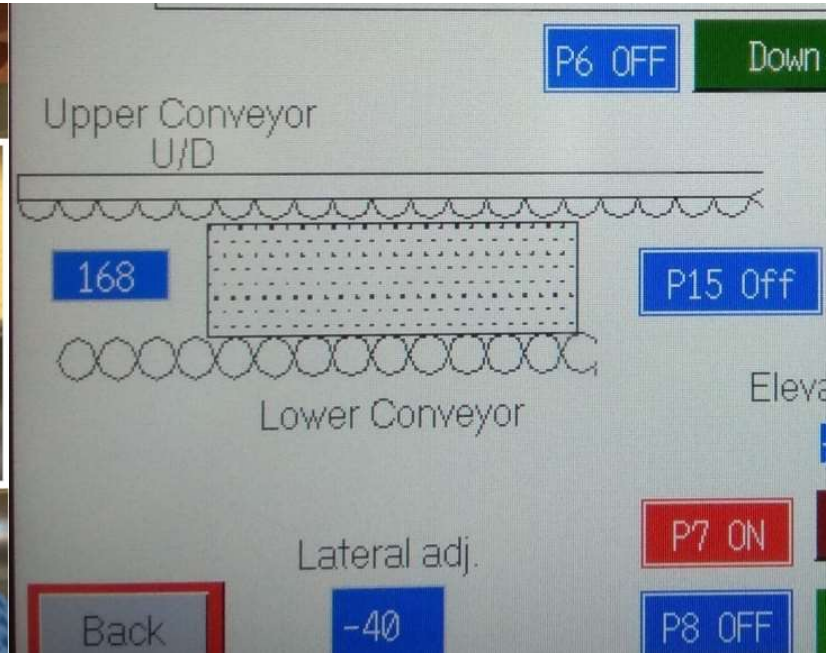


壓紙輪位置校正
Hold Bar Position Calibration

3. 使用捲尺量測實際數值。

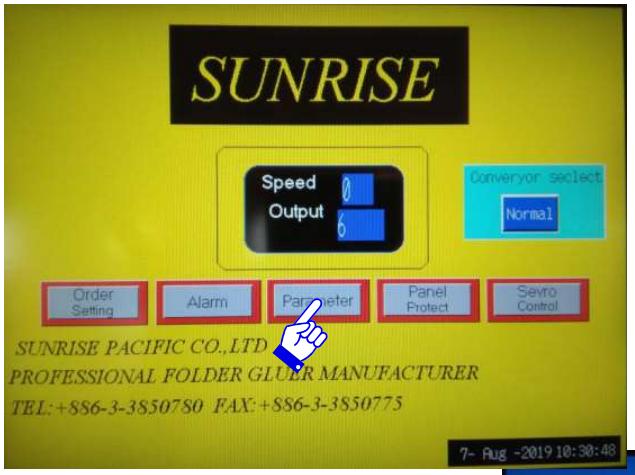
   Use a tape measure to measure actual values

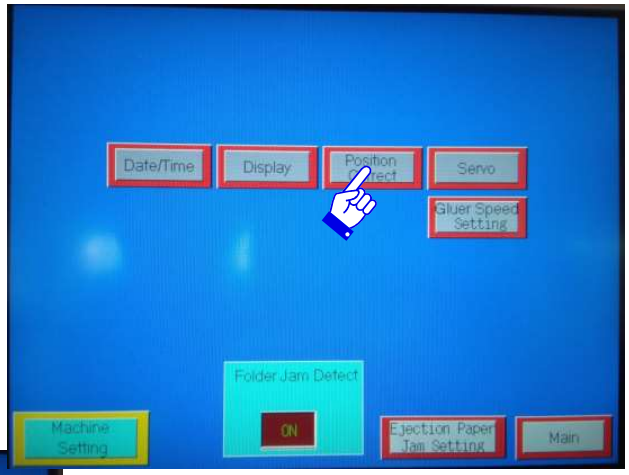


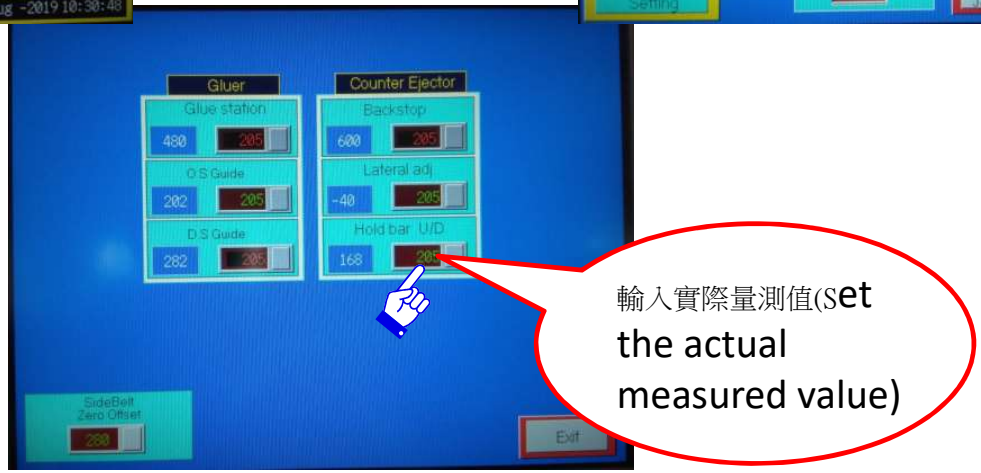


壓紙輪位置校正
Hold Bar Position Calibration

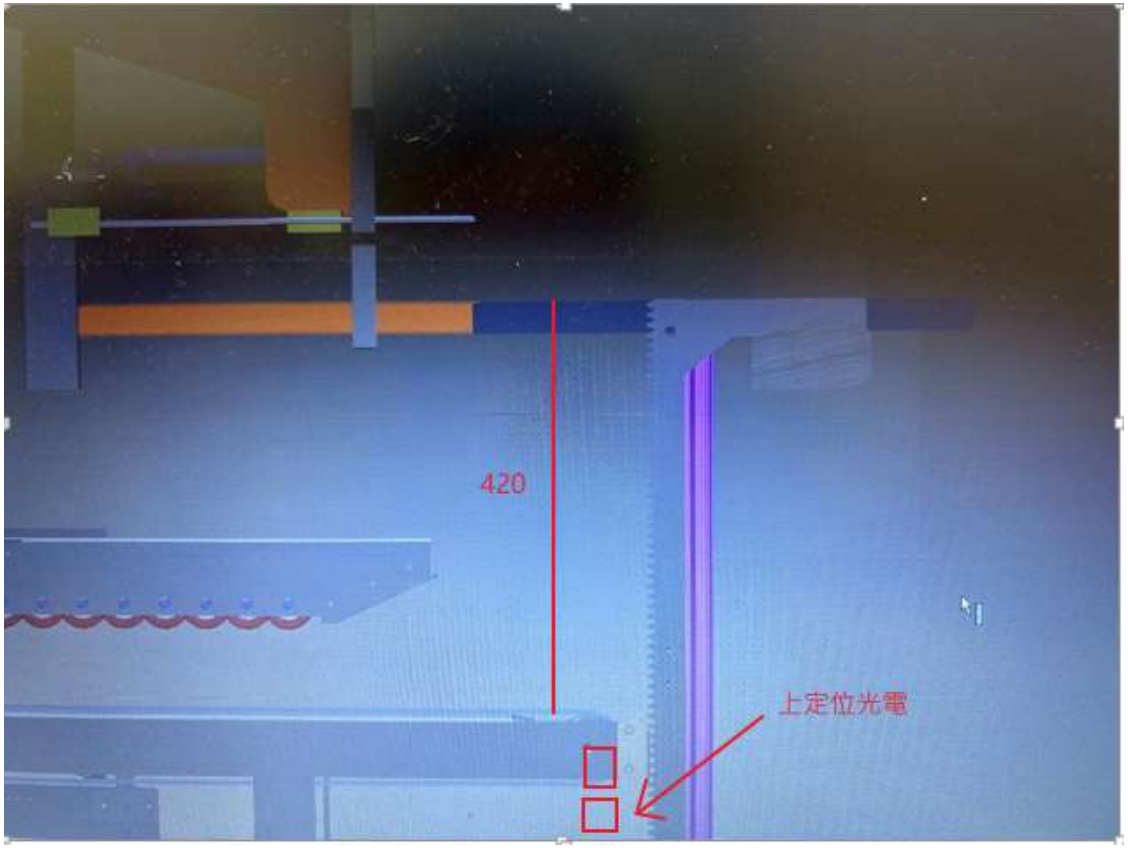
4.接著到大人機(Main HMI)→參數設定(Parameter)→重設目前值(position correct)→橫移調整(Lateral adj)→設定實際量測的試數值(Set the actual measured value)







接紙台零點校正



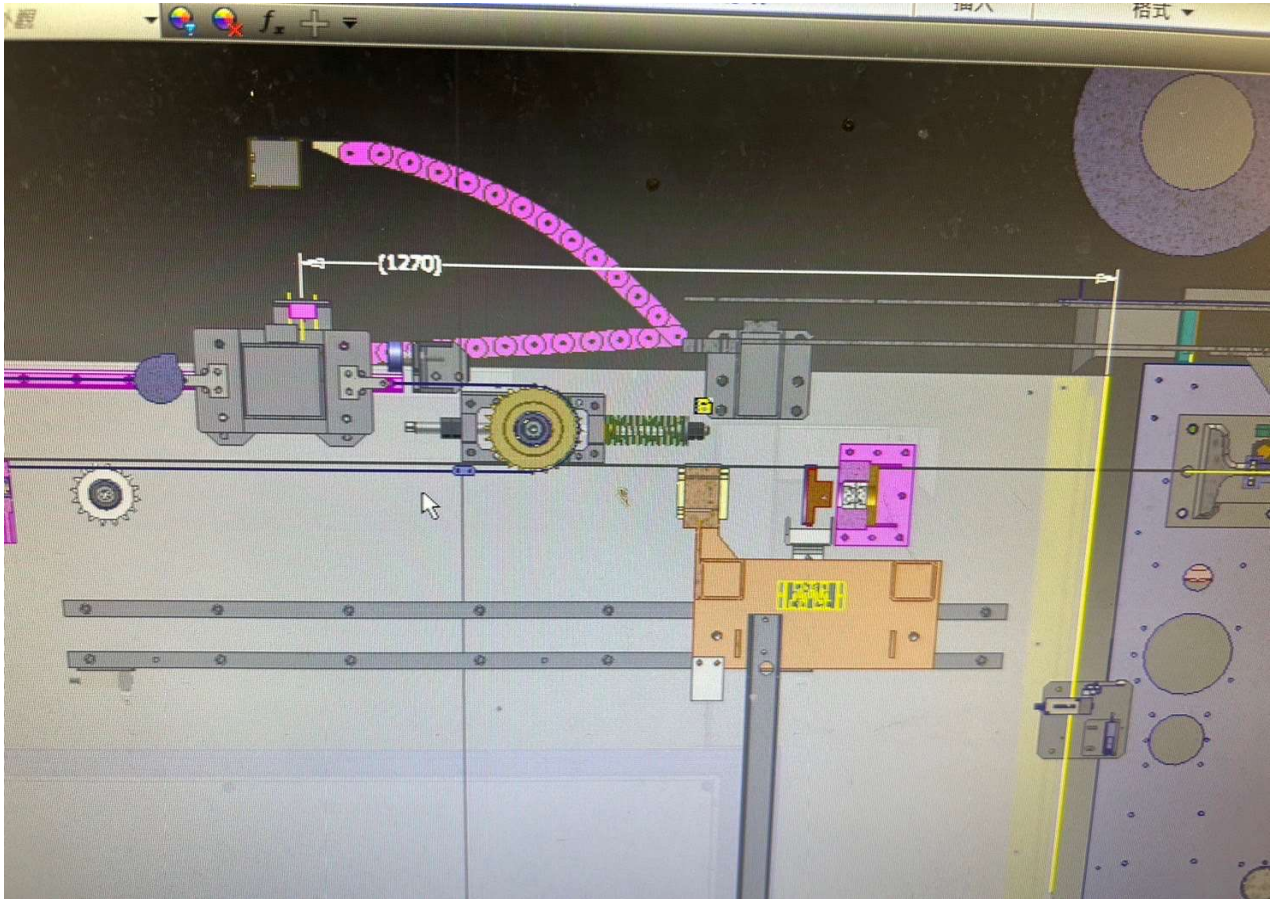
1.接紙台以排出皮帶為起點往上420mm為零點，此時接紙台上定位光電on

2.下定位則略低於排出皮帶面1~2mm下定位光電on

Mini 375
傳統型 420
高產能 420

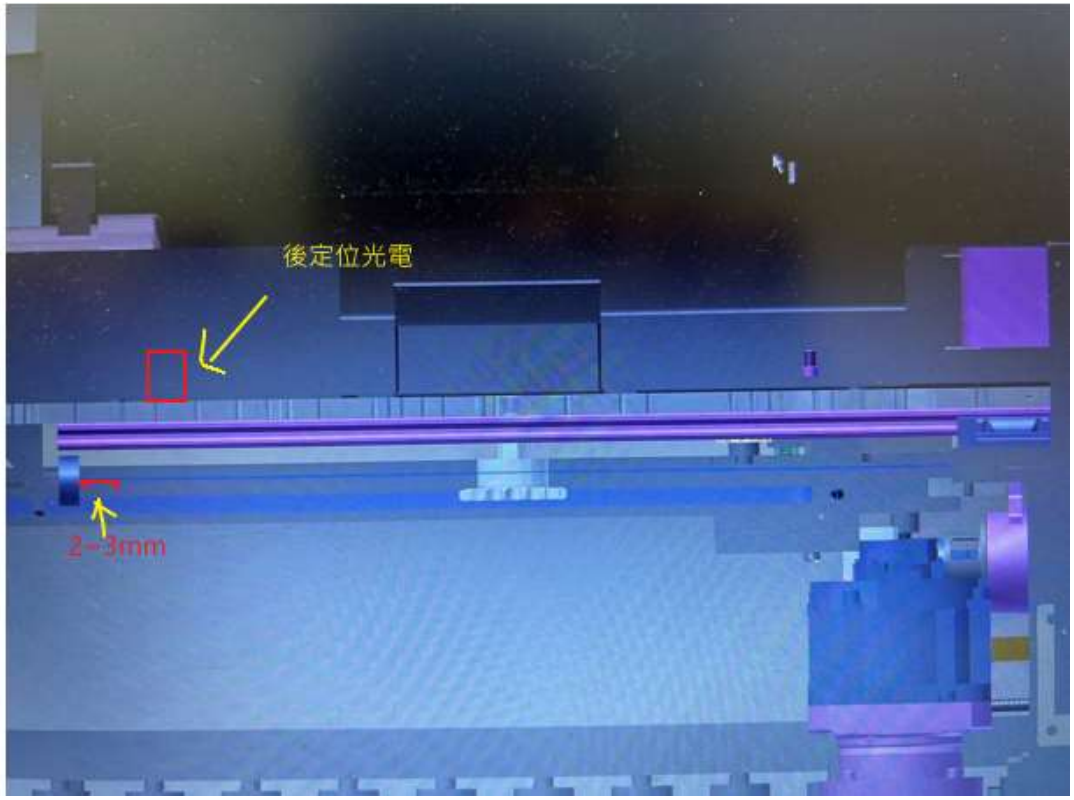
分紙桿校正

分紙桿前後原點定位校正



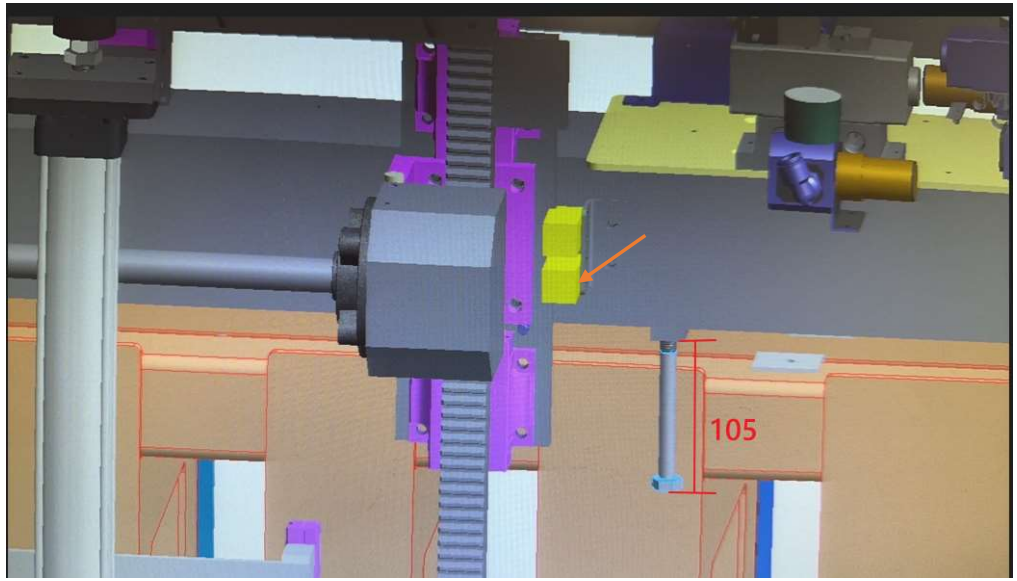
如圖往後拉至1270位置
為分紙桿0點位置

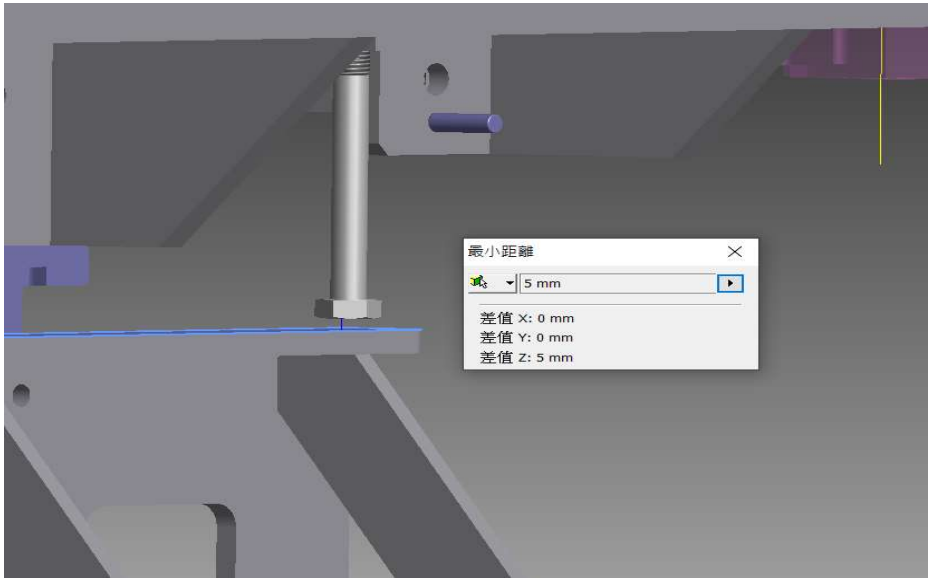
分紙桿前後原點定位校正



1.退至防撞膠墊，以不撞擊防撞膠墊讓2~3mm校準後定位零點位置

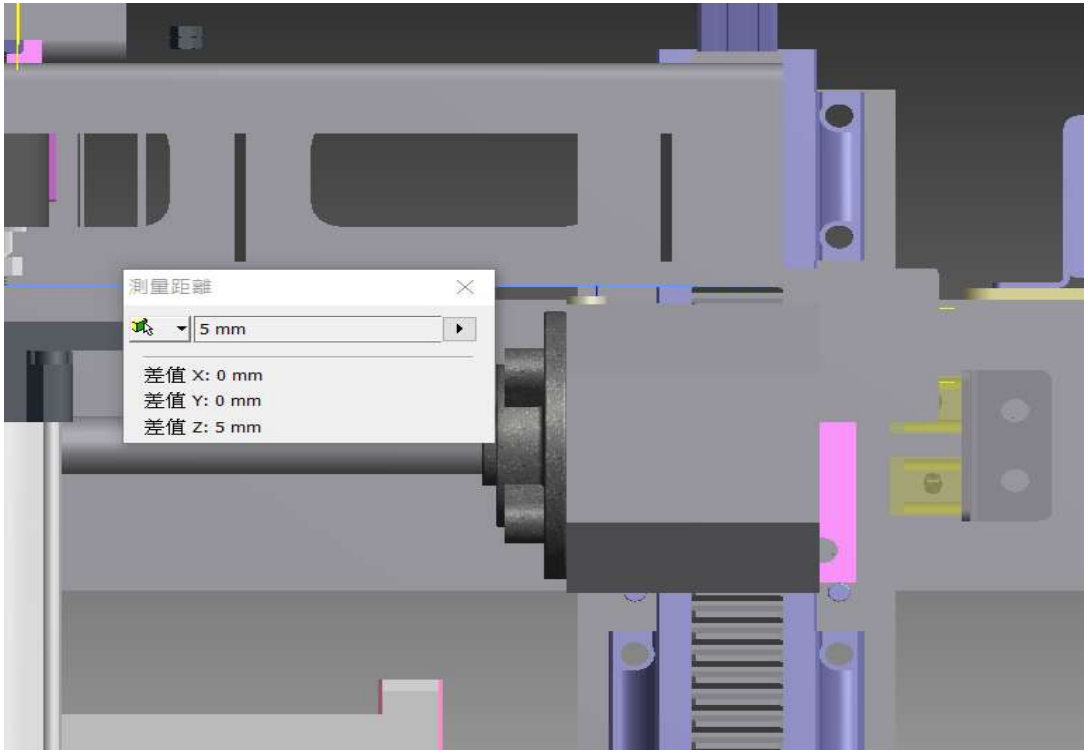
分紙桿上(零點)定位



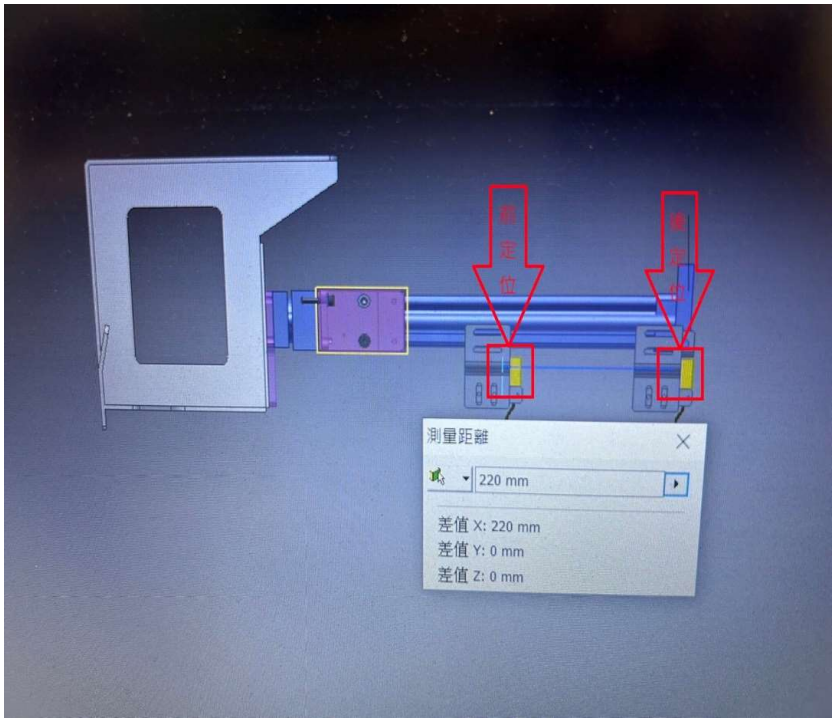


1.檔點螺絲105MM 預留5MM 位置為上定位位置

分紙桿下定位



推紙桿校正



1.推板汽缸完全收回時，調整後定位光電固定座位置使光電剛好作動。
2.後定位光電位置調整完後，調整前定位光電位置與後定位光電間距220mm。(需量測光電同一側位置)