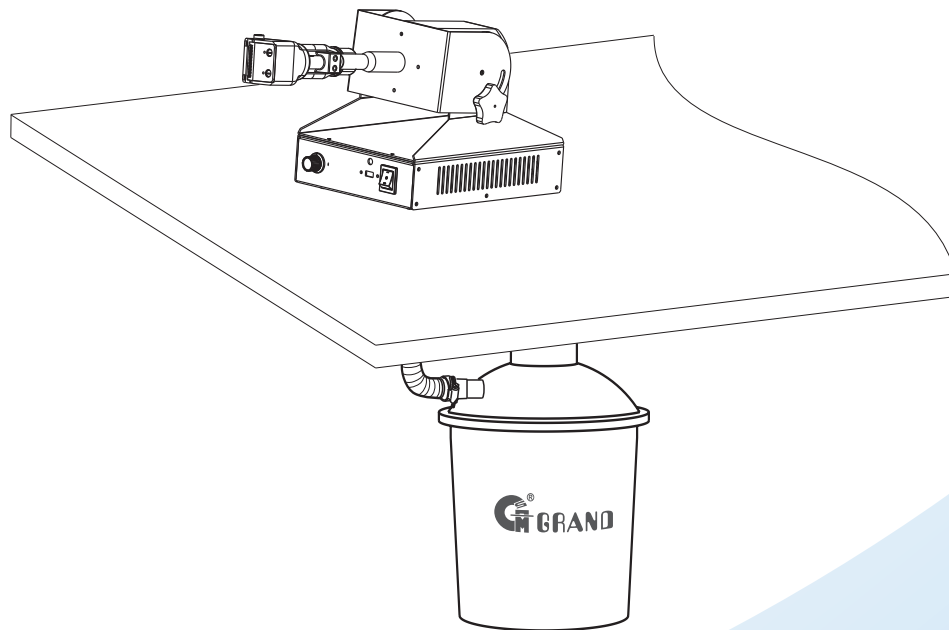




# MANUAL



## MODEL & DEVICES

**T20E - BL**

Cabinet Style Portable Thread Trimmer

*HIGH SPEED TRIMMER SERIES*

# Contents

## 目 录

1、 Application instruction .....	(1)
1)Clipper blade maintenance .....	(2~3)
2)Vacuumsuction motor maintenance .....	(4)
2、 General assembly drawing .....	(5)
3、 Suction assembly and suction accessory .....	(6)
4、 Clipper blade accessory and assembly .....	(7)
5、 Pedestal and Control box accessory assembly .....	(8~9)

# 1、Application instruction

## 剪线机使用说明

This serial product is one of necessary equipment specialized in garment industry, with its substitution for traditional manual clipper process and integration in clipper and thread-sucking process, as well as no any thread end remained, all these products are assumed to keep up all finished clothes and working environment quite clear and tidy to improve operation efficiency and mitigate worker's labor strength

This serial product features into high efficiency, smaller body, lower noise, lower electrical consumption, easier operation and without any maintenance etc; it may adjust air rate of clipper outlet, 95% clipper ratio per time; as well as clipper angle and gap shall be casually adjusted according to operation habit, within 3 inches as optimal clipper adjustment, in particular suitability for garment with such many thread heads, textile garment, one with its flexibility band, as well as jeans wear with comparatively bigger threads etc.

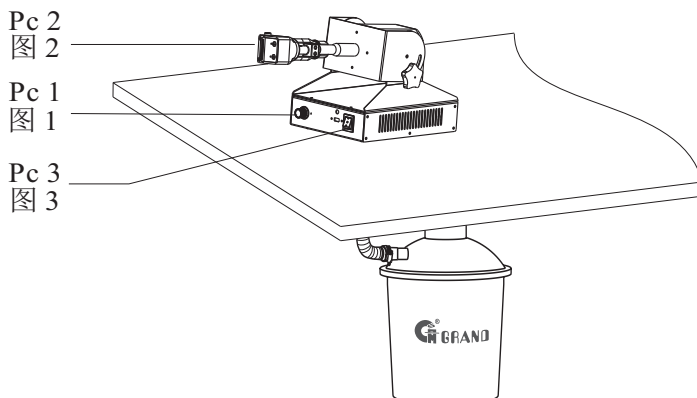
该系列产品是面向广大从事服装制衣业必用设备，把传统的手工剪线工序由该系列产品所代替，将剪线和吸线工序合为一体，不存在遗留线头，线尾现象，确保成衣及工作环境清洁，极大地提高了工作效率，减轻了工人的劳动强度。

该系列产品具有工效高，体积小，噪音低，耗电少，操作方便等特点，可以调节剪线口风速，一次剪线率为95%，根据操作习惯可任意调节剪线角度及距离，最适合剪3寸以内线头，特别适合线头较多的衣物、针织面料、梭织面料服装、带松紧的服装及线较粗的牛仔服装。

### 1)Application instruction

#### 使用说明

- 1.First, adjust the knob (pc 1) into lowest position, shack the spay oil and spay some oil toward the blade teeth(pc2)  
首先把调节旋钮调（图1）到最低档位，把润滑油摇晃数次对准刀头齿隙（图2）喷一下。
- 2.Turn on the power switch (pc3), Herein, total machine stays at Ready-For Operation.  
打开主机开关（图3）后，此时整机进入运动状态。
- 3.Adjust the wing speed according as the material. Herein, the machine has been into operation status.  
最后根据布料厚薄和布的粗细调节旋钮调节在适当位置（参考列表），此时整机进入工作状态。
- 4.Spray some oil to the blade teeth every one hour, adjust the suction knob to lowest position then spay the oil toward the teeth of blade, finally, clean the unwanted oil and continue to work  
使用前喷一次油，工作一小时必须加油一次，加油时将吸风量调到最低档，把油喷于齿隙间与上、下刀间隙，用布擦干净多余油污即可继续使用。
- 5.In case that remained thread is excessively longer or shorter after cutoff, damaged cloth or unsuited cutoff etc, please refer to adjustment for blade and maintenance for suction motor.  
如出现剪线后余线过长或过短，剪坏面料或剪不到线，请参考刀头调节和真空马达保养。
- 6.Dustproof cover was mounted below vacuum motor, its cleanup shall maintain one time per day, replace it if applicable; several-time use shall maintain after cleanup of dated one.  
真空电机下的防尘罩，每天清理一次，必要时更换防尘罩，旧罩清洁后可多次使用。



Spray Oil  
润滑油

## ◆Description of operation

### 操作使用方法

1. Move the blade head along with the trail of thread ends from left to right, whilst the thread ends are sucked into the teeth of blade and cut off.  
刀头顺成衣的线迹方向平行移动即可达到剪线目的。
2. In the light of laborer's habit, he/she can casually adjust the balancer to change the gap between blade head and operator so as to mitigate worker's labor strength.  
根据操作习惯，可任意调节刀头组对操作人员的高度，以减轻疲劳。
3. In the light of different cloth material, select different blade and suction speed so as not to damage any cloth material  
根据不同的面料选择不同的刀型和风速，以免对面料造成损伤。

## ◆Refer to the following form

列表如下作为参考

Fabric 面料	Pure Silk & wool 真丝面料、毛制面料	Knitted Fabric 针织面料、梭织面料	Tatting & Jeans 牛仔面料
Suction scale 吸气量刻度	2-3	4-6	7-9

## ◆Trimmer Clipper Maintenance

### 剪线刀的保养

1. Whilst re-installation for clipper blade, firstly assure the active blade tip and fixed blade are put together to the correct position exactly. Active blade tip is 0.64mm shorter than fixed one. Such adjustment only needs to release screw with spring washer and in parallel impel active blade.  
在重新安装剪线刀时，首先要确定剪线动刀尖与定刀尖的正确位置。动刀尖相对定刀尖的后退量为0.64mm，调整时松开弹簧片固定螺丝，平行推动活动刀片即可（图1）。
2. Whilst adjustment for clipper blade wing guard, please retain approximate 1.28mm gap between wing guard and clipper blade tip after completion of the blade installation; if the cloth is extremely thin, 0.64mm adjustment is also acceptable, such manner should avoid any damage of garment or over-lock thread whilst cutoff.  
在调节剪线刀头挡风片时，将剪线刀片安装之后，要将挡风片与剪线刀尖的距离调到大约1.28mm，如果布料特别薄，可调到0.64mm，这样不会剪破衣服和包缝线（图2）。
3. Blade tip and wing guard shall retain 0.5mm gap, that is to say, wing guard is 0.5mm higher than blade tip; however, garment or over-lock thread is easily damaged if they both are equal to each other at height; as for some comparatively thinner garment or requirement for over 2mm thread length after cut operation, the gap between wing guard and blade tip must be adjusted into comparative larger setup, herein, only release screw (see Diagram 3) and push down blade assembly until onto appropriate position, replace some thicker wing guard is also acceptable if available.  
刀尖与风量遮挡片的落差是0.5mm，即风量遮挡片应比刀尖高出0.5mm，如果风量片与刀尖平，容易剪破衣服和剪破包缝线，但如要面对一些比较薄的衣服，或要求剪线剩余多2mm以上的，则须把风量遮挡片与刀尖的落差调大，调整时只须松开（图3）所示螺丝，把整组刀头部分往下按到适当位置即可，亦可更换较厚的挡风片。

4. In case clipper blade is blunt, please release the screw tightened on the blade, review if any peculiar substance exists between blade and blade teeth, if some accumulative dirt completely exists which results in unsuitable position whilst thread head feeds into blade, must immediately clean up it completely; also review the stress of tension spring, first left hand holds on fixed blade, and then right thumb and first finger impel active blade, it is ok if feeling 3-3.5kg push force, otherwise, please rectify the spring pressure or replace new one.

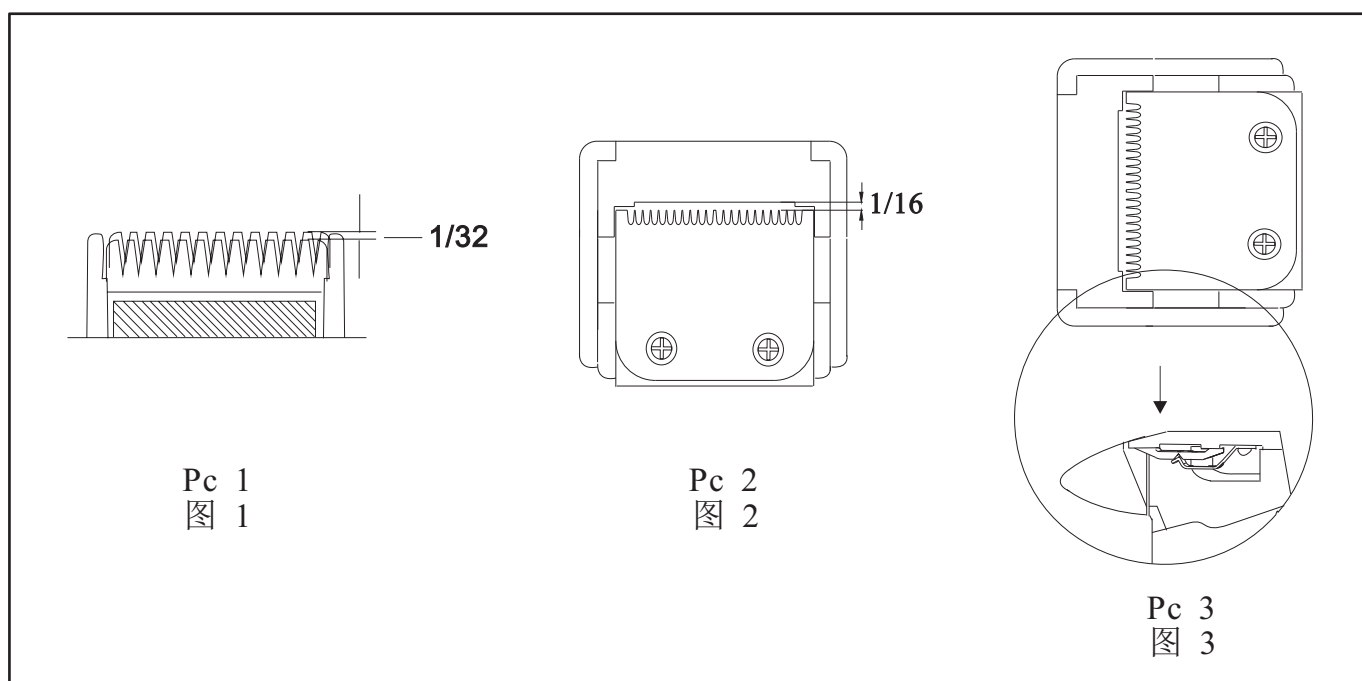
遇有剪线刀片不利时，请松开刀片固定螺丝，查看动刀片刀齿间有无脏物，如积满污垢，线头入不到刀齿应清除干净；检查弹簧片的压力，用左手拿着定刀片，右手的拇指和食指推动动刀片，感觉有3~3.5公斤的推力为正常，如压力不够，请重新调整弹簧片压力或更换弹簧片。

5. Once some special sound such as Dadada takes place on the blade head, please release the screw tightened on the blade, review the matching gap between eccentric block and fixed blade, immediately replace the eccentric block if too larger matching gap, whilst checking up if some axial gap exists, also immediately reset it if too larger clearance.

如果刀头有特别的“嗒嗒嗒”声音，请松开刀片固定螺丝，检查摆块与动刀的配合间隙，如配合太松则需更换摆块，同时检查摆块在轴向上有无间隙，如间隙过大需重新调整。

6. No use sewing machine oil or WD-40 instead of grand special thread trimmer oil since these kinds of oil shall shorten the life of blade, however, grand lubricant is one of composite oil with quiet fine, higher specification value, easier solubility to water and mobile viscosity, also beneficial for improvement for blade life.

切勿用衣车线油或WD-40代替剪线机油。因为这类油会令刀片的使用寿命减低，而百川牌润滑油是十分幼细，皂化值很高，易溶于水，运动黏度很高的合成油，能有效帮助提高刀片的使用寿命。



#### ◆Remarks 注意事项

Clipper blades to be used continuously after six months may be blunt, please go to our dealers to sharpen the blades or buy new one.

剪线刀片连续使用六个月后，可能不锋利，请到购买经销商处将钝刀片交予经销商回厂重磨，或购买新刀片。

## ◆ Suction motor maintenance 直流马达使用说明

Suction motor has been to high pressure resistance before factory shipment, which is durable to 1200V and with thermal protection device. Once temperature exceeds 120℃, the motor shall be automatic shutdown, and restart it after temperature lowers to normal one, such operation become more safe and reliable.

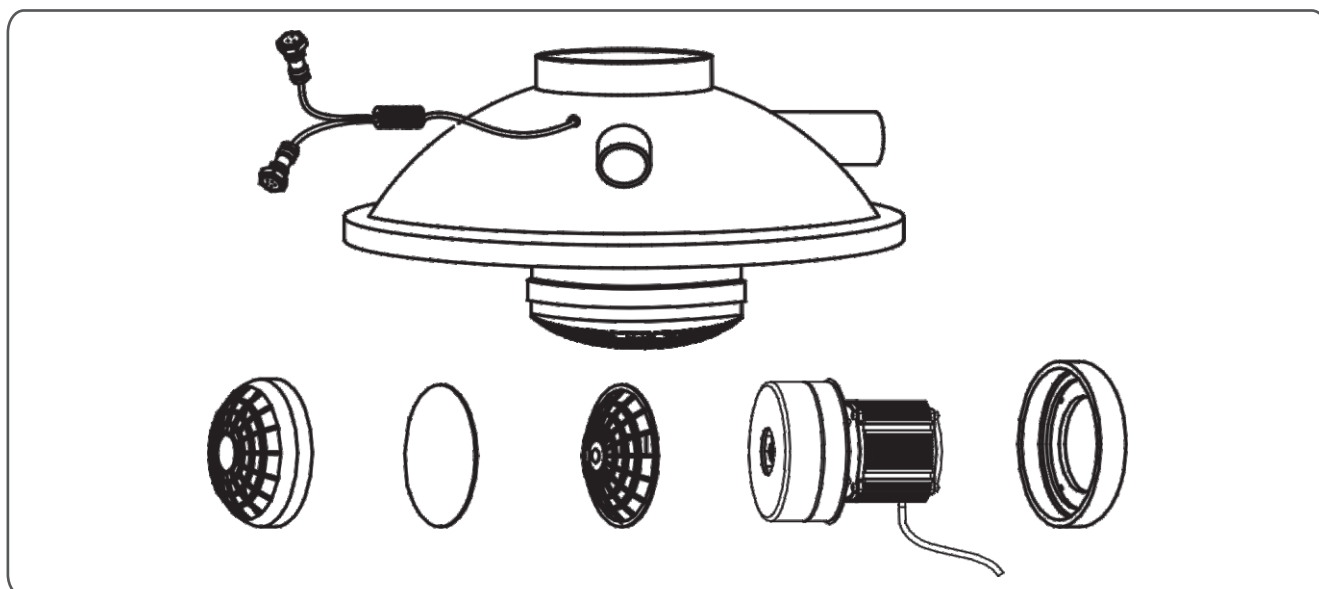
If not enough suction force exists in suction motor whilst use, first check up if air speed adjustment knob is at appropriate position, then check up plastic barrel and barrel cover is at better cover position, finally check up if the barrel is too filled with thread end and if dustproof cover accumulated too much thread end or dust.

Must clean up plastic barrel once a day, and better cover up it once its better cleanup after operator affirm that dustproof cover is at normal status.

百川牌无刷电机在出厂之前经过耐高压处理，能通过1200V高压，具有热保护装置，当温度超过90。C时，会自动停机，待温度降低后可重新开机使用安全可靠。

若在使用中发现吸力不够，首先检查风速调节旋钮是否调至适当位置，然后检查胶桶与桶盖是否盖好，再检查软管内是否有线头或杂物堵塞，软管是否破裂穿孔，最后检查检查是否桶内线头太满，防尘罩上吸附太多线头或灰尘。

塑料桶必须每天清理一次，清理后盖上前必须先确认防尘罩的完好状态，因防尘罩的损坏或脱落，容易使线头吸入直流马达内致直流马达烧坏。



## Accessory: 附件图

180  
Oil box  
油盒

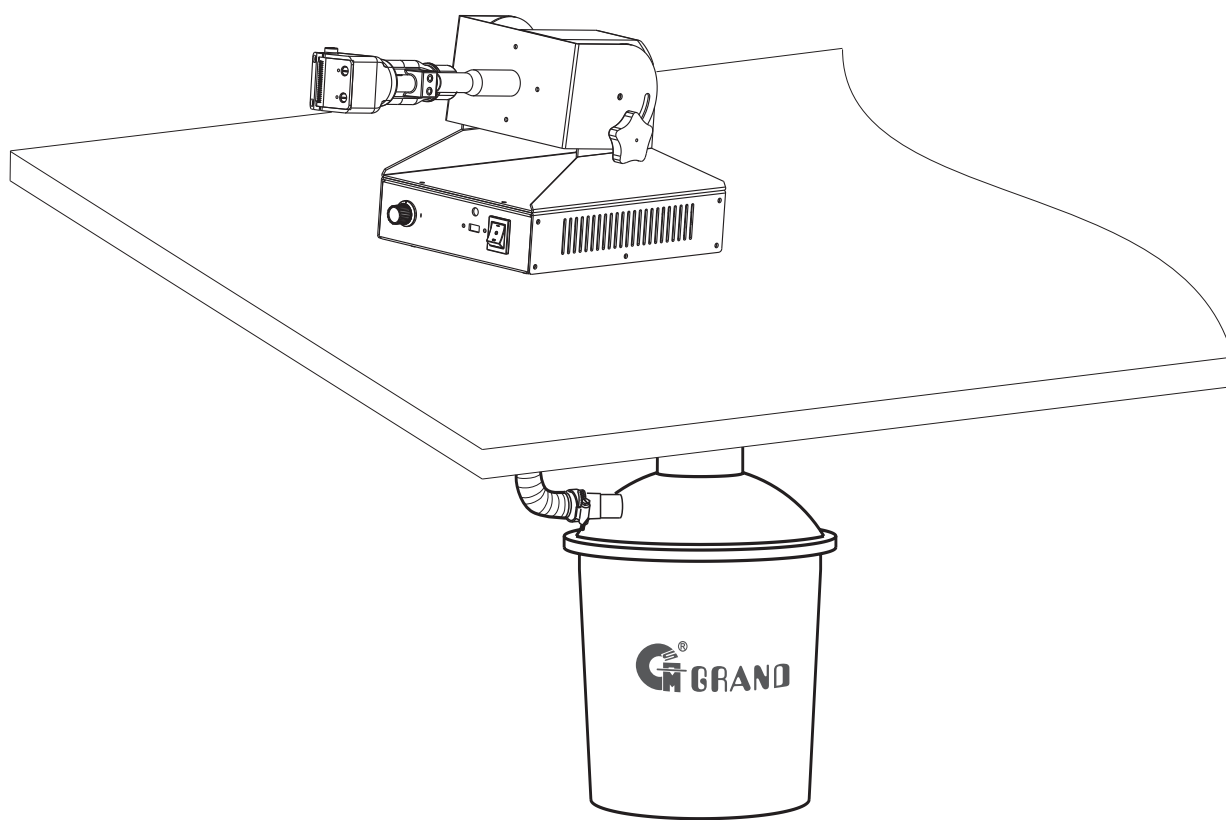


Tools  
辅助工具



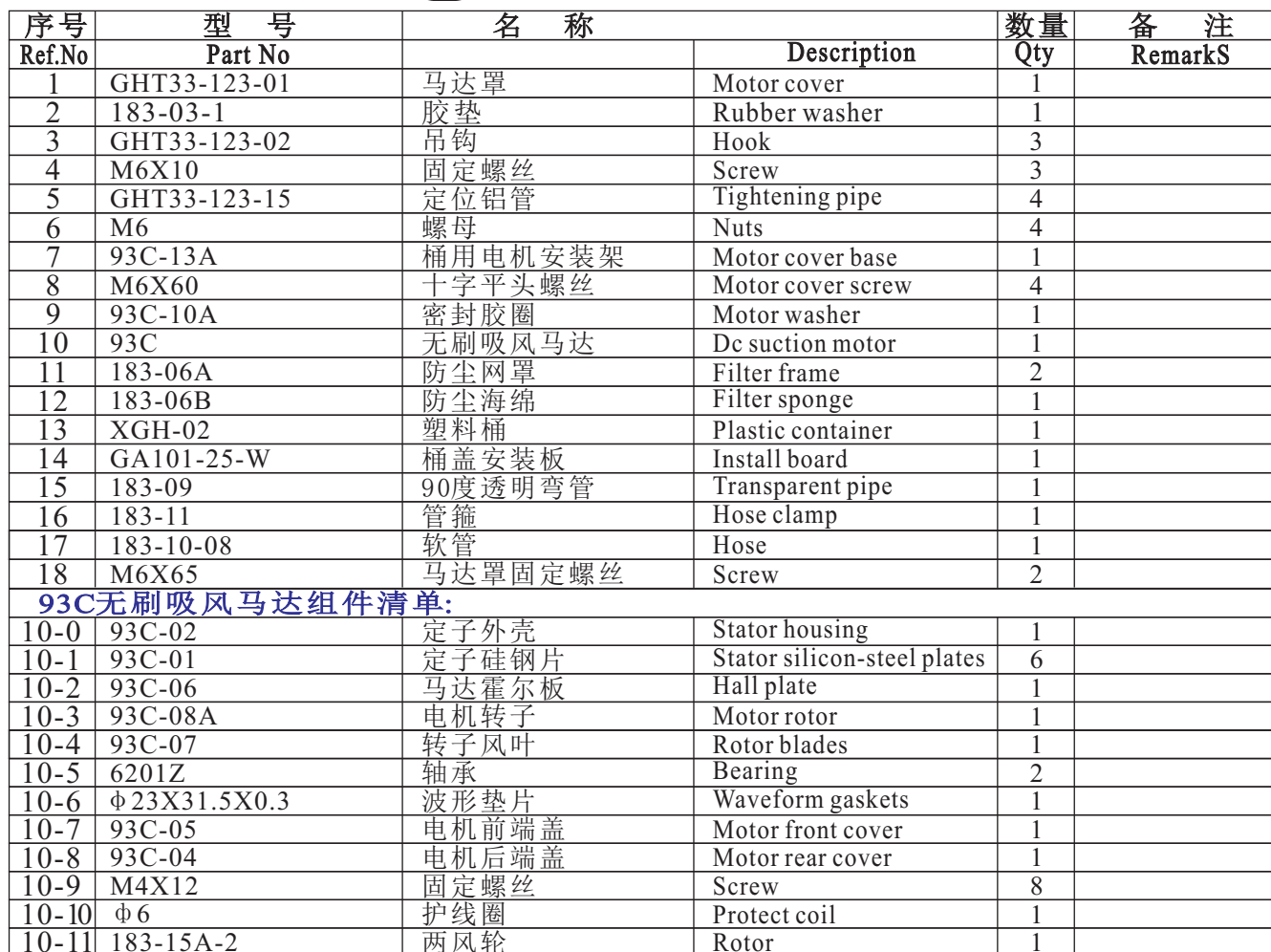
## 2、 General assembly drawing

### 组装示意图





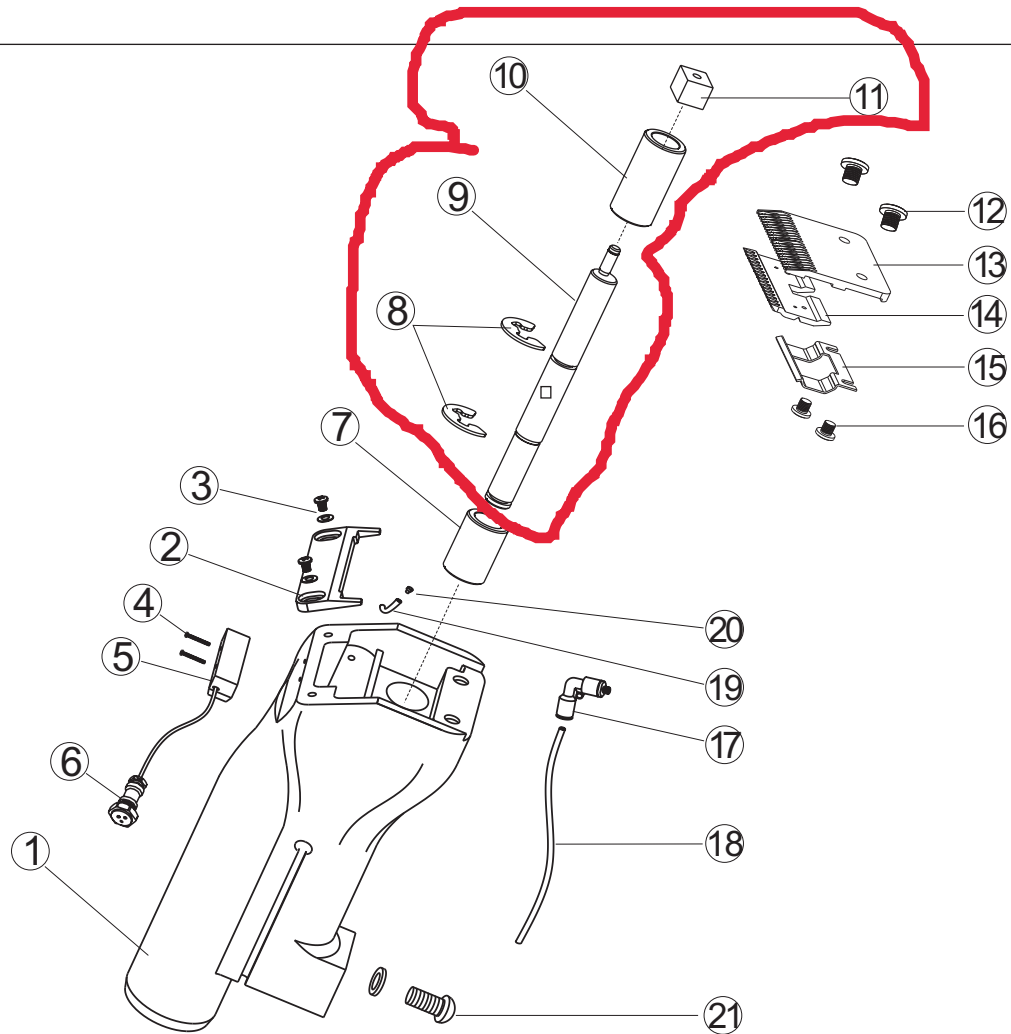
### 无刷吸线组件图





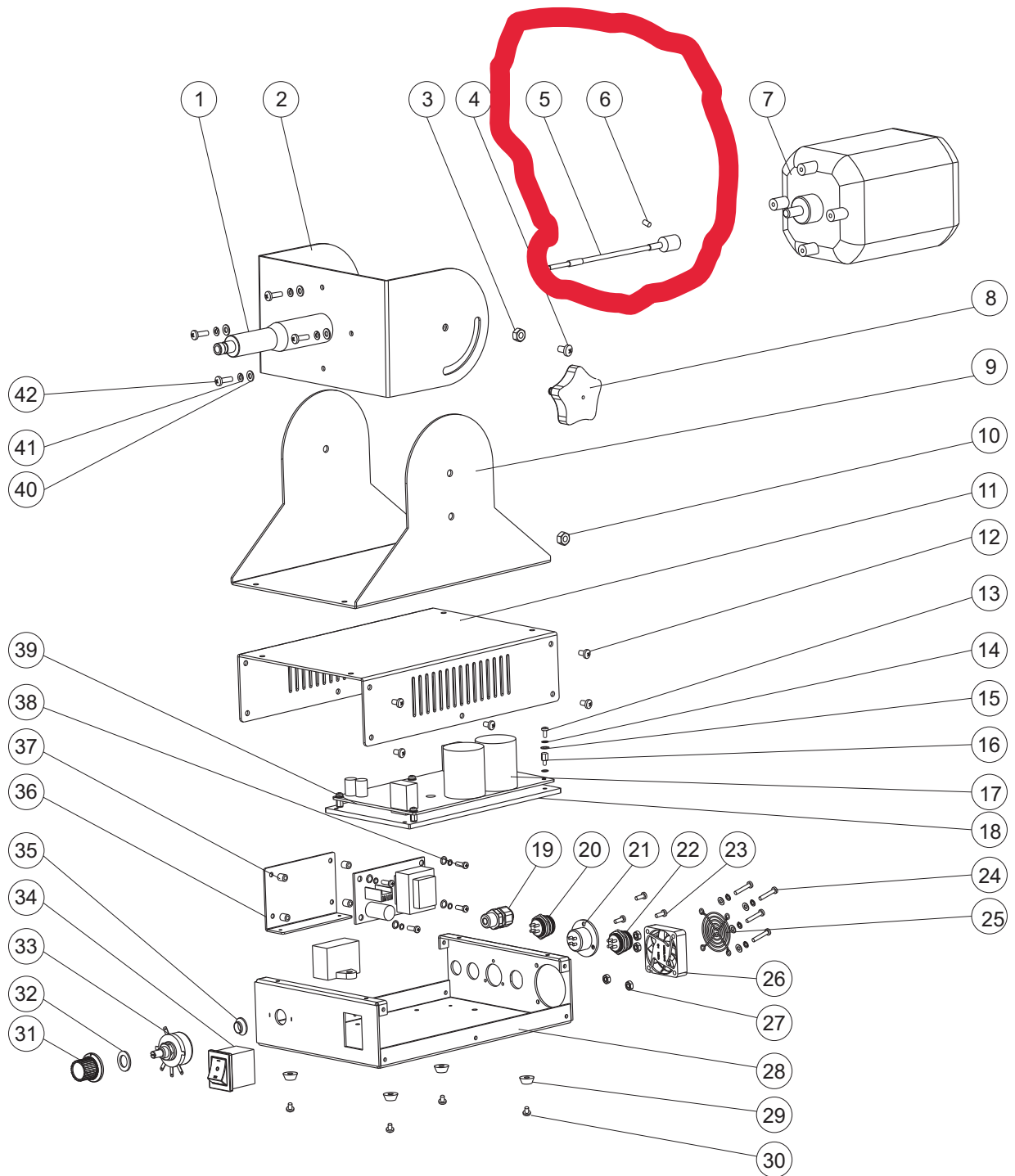
#### 4、Clipper blade accessory and assembly

#### 刀头组件图



序号	型 号	名 称	数量	备 注
Ref.No	Part No	Description	Qty	RemarkS
1	GHT33-121-01	刀头座	1	
2	181-11	风量调整片	1	
3	M3X6	风量调整片螺丝	2	
4	M2.5X16	感应器盒螺丝	2	
5	GHT-33-121-06	感应器盒	1	
6	GX-16-3P	航空插座（3芯）	1	
7	181-07-22	短含油轴承	1	
8	181-08B	偏心轴开口卡	2	
9	181-08	偏心驱动轴	1	
10	181-07-32	长含油轴承	1	
11	124C	滑块	1	
12	M5X8	刀头固定螺丝	2	
13	277/242/500	定刀片	1	
14	277/242/500	动刀片	1	
15	130-3	弹簧片	1	
16	M3X5	定动刀片固定螺丝	2	
17	GAT22-121-02	直角接头	1	
18	φ4X2.5mm	P U 管	1	
19	GT22-01-05	喷油弯管	1	
20	GT22-01-04	喷油嘴	1	
21	M5X10	刀头座固定螺丝	1	

## 5、Pedestal and Control box accessory assembly 底座及控制盒组件图(一)



## 5、Pedestal and Control box accessory assembly

### 底座及控制盒组件图(二)

序号	型 号	名 称	数量	备 注
Ref.No	Part No	Description	Qty	RemarkS
1	T20E-BL-08	刀头固定柱与电机安装板焊接组件	1	
2	T20E-BL-09	安装底板与M6焊接螺母焊接组件	1	
3	T20E-BL-07	软轴	1	
4	M3*3	内六角紧定螺丝	1	
5	M6	防松螺母	2	
6	φ9-4.2X5	空心柱	4	
7	JXDJ	剪线电机	1	
8	M6*12	十字扁头螺丝	2	
9	M6*12	五星调节把手	1	
10	T20E-BL-04	控制盒上盖	1	
11	T20E-BL-06	固定片	4	
12	M4*6	十字扁头螺丝	21	
13	M3*6	十字圆头螺丝	16	
14	Bz0449	φ3弹垫圈	25	
15	Bz0430	φ3Xφ6X0.5平垫	22	
16	GT22-02-12	无刷自动注油板	1	
17	GT22-12-08	铜柱	9	
18	183-13	电线护圈	1	
19	GT36-012	保险座	1	
20	GX-19-4P	四芯航空插座	1	
21	GX-19-3P	三芯航空插座	1	
22	GX-16-4P	四芯航空插座	1	
23	M3*6	十字平头螺丝	6	
24	GX-16-5P	五芯航空插座	1	
25	M3*20	十字圆头螺丝	4	
26	Dj00228	风扇网	1	
27	Dj00227	风扇	1	
28	M3	外六角螺母	1	
29	Lj00036	胶脚	4	
30	T20E-BL-05	控制盒下盖	4	
31	AC250V/16A	二档位船型开关	1	
32	184-02φ5	LED指示灯套管	1	
33	250V/3A	拨动开关（大）	1	
34	A-3	调节旋扭	1	
35	Lj05059	绝缘垫片	1	
36	Lj05058	电位器垫片	1	
37	4.7K/2W+5%	电位器	1	
38	GT22-12-07-1-V1	PCB板固定散热片	1	
39	GT22-12-07-2	芯片散热片	1	
40	BLD-750-220-IPM	无刷吸风驱动板	1	
41	Bz0115	M4*16十字扁头螺丝	4	
42	Bz0451	φ4弹垫圈	4	
43	Bz0432	φ4Xφ8X0.8平垫圈	4	
44	EI48-12V	变压器	1	
45	CBB61 2.5UF/450VAC	变容	1	



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