

HASHIMA®

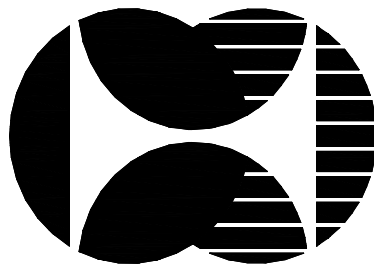
HP-1000LW

STRAIGHT LINEAR FUSING PRESS

直線式接着プレス

INSTRUCTION MANUAL

取扱説明書






HASHIMA(KUNSHAN) INDUSTRIAL EQUIPMENT CO.,LTD.

羽島(昆山)産業機器有限公司




ATTENTIONS TO BE PAID FOR SAFETY DON`T FAIL TO FULFILL

You should fulfill following explanations for the prevention of the user and the others from being hurt and the proprieties from being damaged.


We divide and explain you the degrees of peril and damage to be taken place when you will neglect the contents of the display and use the machine erroneously .


 DANGER	This display tells you contents that imagine" the imminence of the danger that might result in death or a serious injury " .
 WARNING	The display tells you contents that imagine" the possibility of death or a serious injury" .
 CAUTION	This display tells you the contents that imagine" the possibility of resulting in be to handicapped or material damages exclusively" .


We divide and explain you the contents you should fulfill in accordance with the following illustration (Following is an example of the illustrations).





	This illustration tells you the contents" that demand attention" you must pay.
	This illustration tells you the contents of" prohibition you should not do at all.
	This illustration tells you the contents of" enforcement" you should executive without fail.








 DANGER
--

Don' t get the children to use where the infants can make contact with.
 For fear of burn, electric shock and injury.

Never reform at all
 For fear of fire and injury due to unusual movement. Disassembly prohibited.

 WARNING

<p>Don' t disassemble and repair absolutely except the repair technician.</p>  <p>For fear off fire and injury due to unusual movement.</p> <p>Disassembly prohibited (Contact to the dealer for repair in the case of damage and troubles.)</p>	<p>Connect with the power source with ratio consumption suitable to the machine and don' t fail to ground.</p>  <p>Unusual heat might in fire or electric leak when you put the machine to use along with other apparatus. (Contact to the electric construction work shops nearest by.)</p>	<p>Disconnect the power source (the plug and installed breaker)out of the origin.</p>  <p>For fear of burn as well as electric shock and leak in fire.</p>
 <p>WARNING</p>		

<p>Please maintain the machine after cutting the power supply breaker, and falling the temperature of the machine.</p>  <p>It causes the burn and the injury.</p>	<p>Please don' t touch the machine and belt by your hand.</p>  <p>It causes the burn and the injury. Be careful enough when you touch the machine</p>	<p>Be careful enough when you insert the material.</p>  <p>It causes the burn and the injury because apart of clothing or body is sandwiched between machine parts. Be careful enough when you touch the machine.</p>
<p>Don' t mount nor put things on the main unit.</p>  <p>For fear of high temperature might result in burn and fire there is a possibility of falling down to be injured..</p>	<p>Install the machine on the robust or onto the floor horizontally.</p>  <p>For fear of overturning or falling down resulting in injury.</p>	<p>Don' t. Put things easy to burn around the machine.</p>  <p>For fear of causing fire and so on.</p>
 <p>CAUTION</p>		

Don' t install the machine to the site high humidity (For fear of causing electric leaks)
Don' t bend nor crush the power source cord. (For fear of electric shock and shortage, resulting in fire.)

When a manual handle is used it turns off power without fail. Moreover, a manual handle removes things except use and the hole cover is put without fail. (The manual handle rotates and there is rapidly injured fear.)

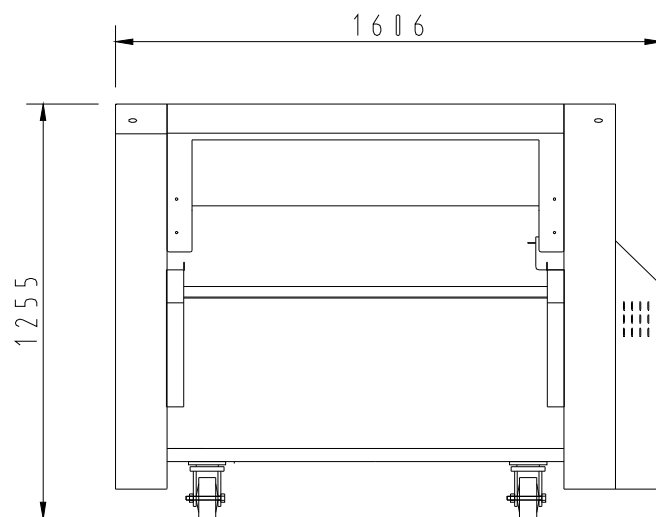
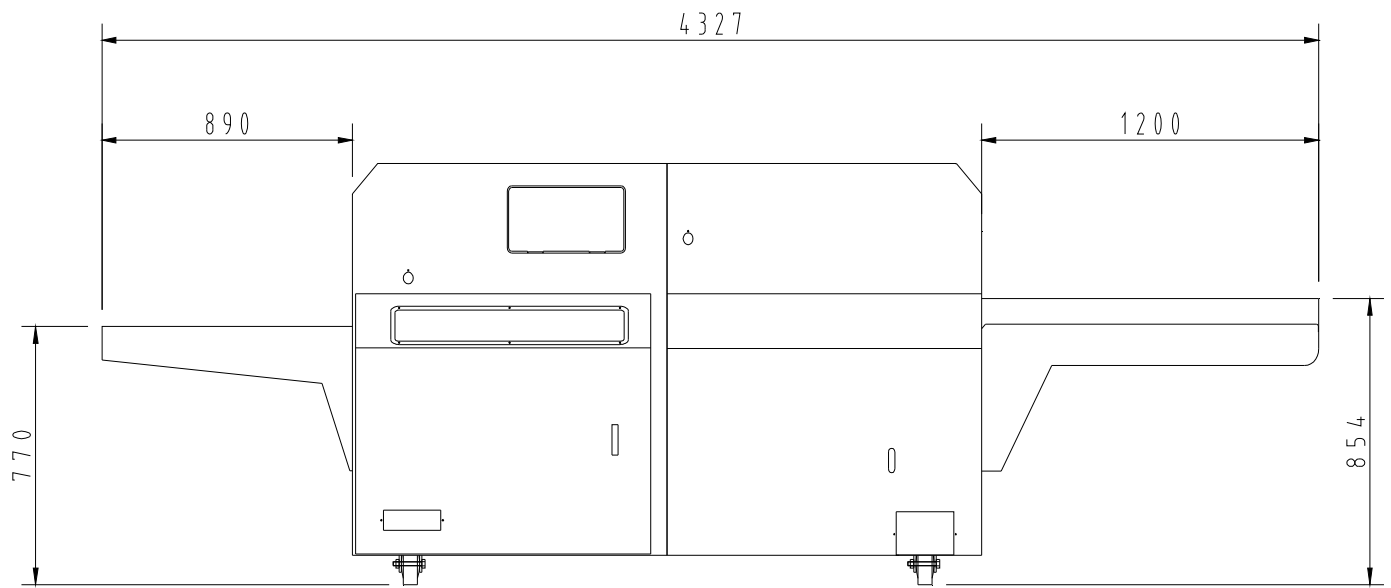
Don' t let the people go near by except operator.

ATTENTION
<ul style="list-style-type: none">◆ There is a thing that the cover becomes very hot depending on the use temperature because this machine is used according to the high temperature. Please note a burn and combustible clothes, etc. Enough.◆ Please confirm the thing that stops with the timer, and cut the power supply breaker after the end of work.◆ Please cut the power supply breaker without fail, and go in the state that the temperature of the machine gets cold then the material that caught under around the strip off device or scraper are removed. Moreover, when you take the finished material out of the exit, pay attention not to be caught in the strip off device.◆ Clean the belt with a well dried floor cloth when the operation is over. But, reduce the belt speed with sufficient attentions at the exit side of the finished material of the machine for fear of such accidents as burn and caught-in.◆ Please check the belt cleaner every day. Moreover, please refuel to each part once a month to prevent the accident occurs. You must keep the electric source off and be sure the machine is cool.◆ Please understand enough, and operate working of switches.◆ Please open space necessary for maintenance in surroundings of this machine.◆ The machine have emergency stop switch when the belt over moves left or right. Please take out the material with the manual handle of the attachment after it turns off power without fail when a material stops in the machine due to the emergency switch works or the power.

3. SPECIFICATIONS

MODEL	HP-1000LW
POWER SUPPLY	3P-380V
RATED OUTPUT	DRIVING MOTOR 400W
	BWP MOTOR 40W×2
	ROTARY STRIP OFF MOTOR 25W
HEATERPOWER	21.6Kw
BELT SPEED	12.7m/min (Max)
BELT WIDTH	1000mm
PRESSUR	5.0kg/cm ² (Max)
TEMPERATURE	200 °C (Max)
HEATING TIME	6.5~31sec
DIMENSIONS	4327 (L) × 1606 (W) × 1255 (H) mm
NET WEIGHT	About 1500kg

4、 DIMENSIONS :



5. OUTSIDE MAIN PARTS



1. WORK TABLE

14. CIRCUIT BREAKER

2. RIGHT COVER

15. ADJUSTER

3. EMERGENCY SWITCH

4. FRONT COVER

5. EMERGENCY SWITCH

6. UPPER COVER

7. REAR COVER

8. EMERGENCY HANDLE HOLE

9. REAR CONVEYOR

10. OPERATION PANEL

11. WIRING BOX COVER

12. KNOB

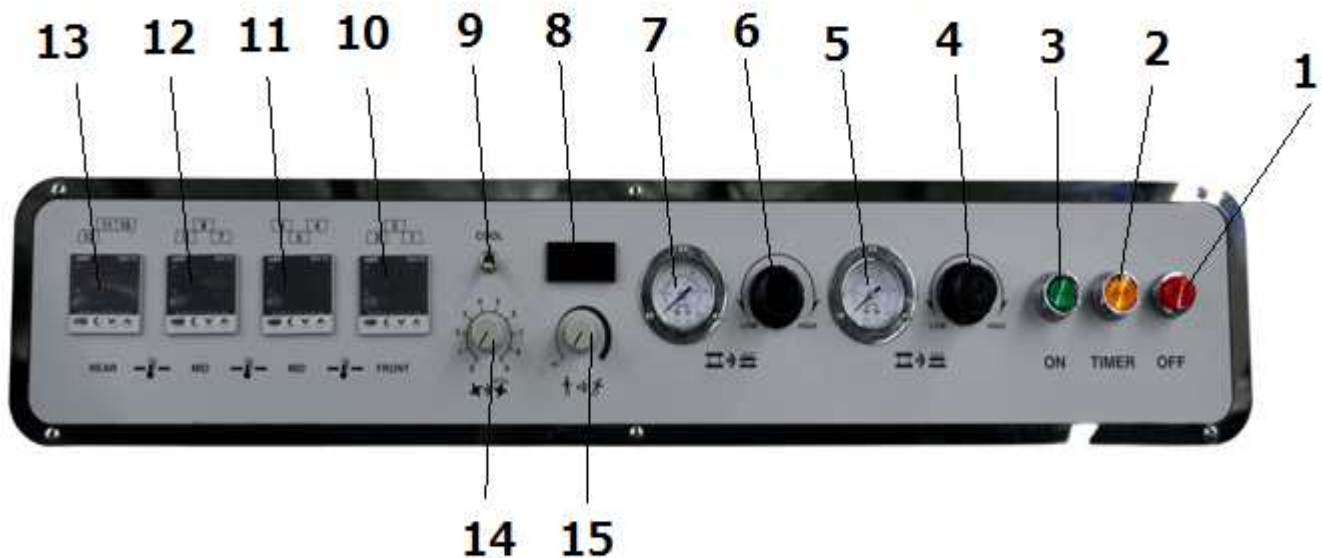
13. LEFT COVER

6. INSTALLATION INSTRUCTION

※ This machine have the weight of about 1500kg, install to the strong location on the floor .

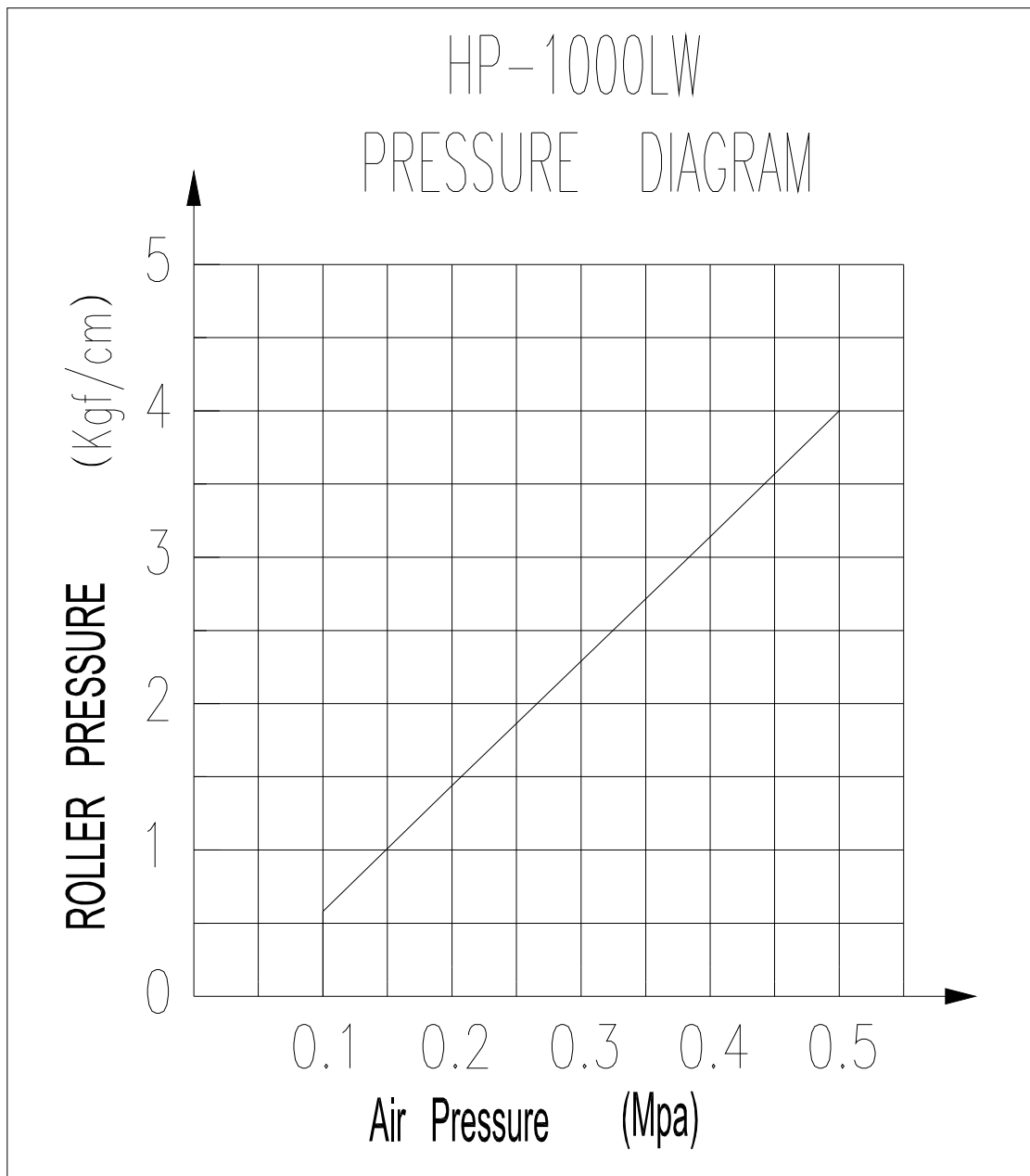
1. Decide the installation place of the machine.
2. Install the working table on machine front side .
3. Level the machine precisely with a level meter, adjusting the adjusting bolts. Put the level on the work table for front side leveling, and put the level on the power pressure roller for rear side leveling.
4. Don' t fail to take the plastic film off cleaner of the Teflon belt, which is covered with the plastic film before you connect the power source.

7. OPERATION METHOD



- | | |
|-------------------------|-------------------------------------|
| 1. STOP SWITCH | 13. THRMOSTAT(4) |
| 2. TIMER SWITCH | 14. ROTARY STRIP OFF SPEED ADJUSTER |
| 3. START SWITCH | 15. BELT SPEED ADJUSTER |
| 4. FRONT PRESSURE KNOB | |
| 5. FRONT PRESSURE METER | |
| 6. REAR PRESSURE KNOB | |
| 7. REAR PRESSURE METER | |
| 8. HEATING TIME | |
| 9. COOLING FAN SWITCH | |
| 10. THRMOSTAT (1) | |
| 11. THRMOSTAT(2) | |
| 12. THRMOSTAT(3) | |

○ PRESSUER DIAGRAM



1. Turn on the circuit breaker switch on the left under cover of the machine.
2. Turn on the power switch (push button switch)
 - ※ The push button of the switch will light up.
 - ※ The motor runs simultaneously.
3. Set the necessity temperature of thermostat.
Temperature (130 degree) will goes up about 30 minutes.

- 4 . Turn the dial of the fusing timer, and set to the proper fusing time.
※ The fusing time ranges from 6.5 sec, minimum to 35sec.
5. Turn the pressure knob on the operation panel, and set to the proper pressure level. Usually, enough pressure for fusing is given at the position 0.1~0.3Mpa. The pressure is adjustable within a range from 0Mpa minimum to 4.0Mpa maximum.
6. If the machine is equipped with the strip-off device, turn the dial of the strip-off speed controller to set the position to a little faster than the running speed of the Teflon belt.
7. Please push the timer switch After finishing of work. The actual temperature of the thermostat will go down. When the actual temperature of the thermostat goes down to 90℃, the power will automatically turn off.
8. When the time switch has terminated, set the power source breaker to OFF.

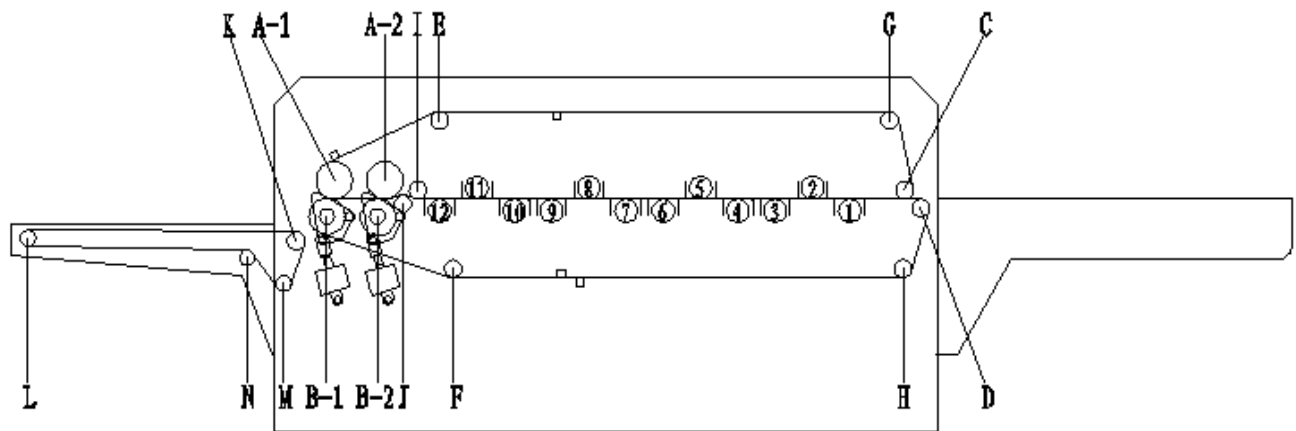
8. NOTE

- Setting combinations of the temperature, pressure and heating time for fusing interlinings are made according to interlining and fabric materials used.
Check carefully proper fusing condition (temperature, pressure and heating time.)
- Although, the belt is coated with Teflon to insure heat-proof, it is breakable by cutlery or broken pieces of metals. Be extra-careful not to put needles, ball point pens or scissors in the belt.
- Do not place the interlinings upside down on the belt, or the products may be caught in the tension roller for the upper belt.
- If there is excessive interlining, the products may be caught in the tension roller for the lower belt even when the interlining is properly placed on the belt.
- Replace the cloth of the cleaner with a new one before it gets dirty.
- It is very hard to remove the resins adhered to the belt, but it can be cleaned up easily with HASHIMA NEW CLEAN.
- Lubricates the bearings and gears every one or two months.
- Ensure for safety that the covers and others are normally provided with, as the interior of the machine is under condition of very high temperature and high voltage. Don' t use machine when the covers are open. It is dangerous.

Attention to be paid when using manual handle.

The machine is equipped with the emergency stop function in response to warping of the belt. Moreover, it is possible to unload the finished fabric within the machine using the accessory manual handle., when the machine has stopped due to an electric failure and so on. But disconnect the power source from its origin, when using the manual handle as it is very dangerous. When you resume to drive the machine, ensure the reasons why it has stopped and make sure of safety before inputting the power source.

9. INNER COMPONENTS



A-1	upper pressure roller (REAR)	L	rear conveyor end roller
A-2	upper pressure roller (FRONT)	N	rear conveyor roller
B-1	lower pressure roller (REAR)	M	rear conveyor belt tension roller
B-2	lower pressure roller (FRONT)		
C	front pull-in roller		
D	front pull-in roller		
E	upper tension roller		
F	lower tension roller		
G	BWP roller (UPPER)		
H	BWP roller (LOWER)		
I	anti puckering roller		
J	anti-puckering roller (adjustable)		
K	rear conveyor driving roller		

10. BELT CLEANER POSITION

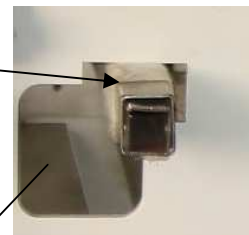
※ Exchange the belt cleaner for a new one when the heat on the machine unit is cooled enough, as it is dangerous. Set the original power source to OFF.

1. The cleaner 1 has been set at a position touching the upper belt rear side.
2. The cleaner 2 has been set at upper belt inside. Open the lid of left side cover.
3. The cleaner 3,4 has been set at lower belt out side and inside. Open the wiring cover.
4. Do not wind too much cloth on cleaner pipe.



Cleaner 1

Cleaner 2





Upper cleaner
lid

Cleaner 3

Cleaner 4

How to belt exchange

1. Make space for maintenance around the machine.
2. Take out upper cover, front cover, rear cover, left side cover, right side cover.



upper
cover

front cover

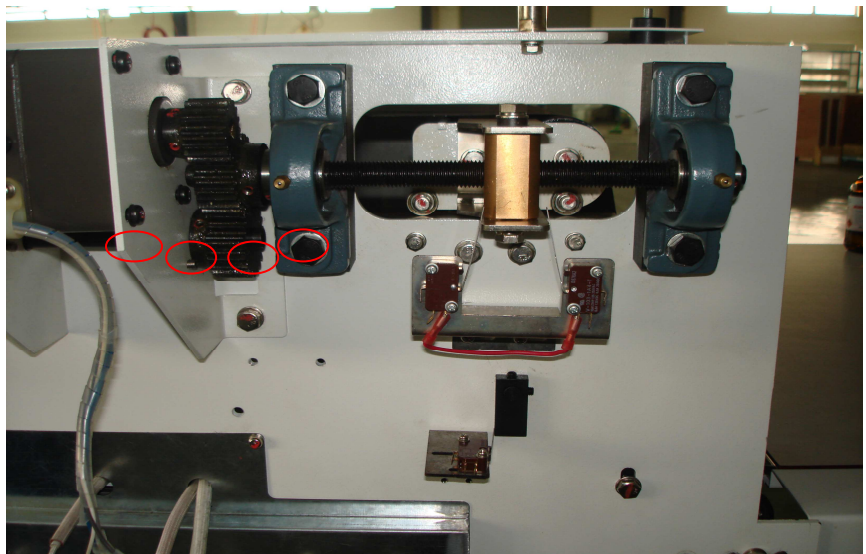
right side cover

3. After take out upper cover, remove insulation cover.

Insulation cover

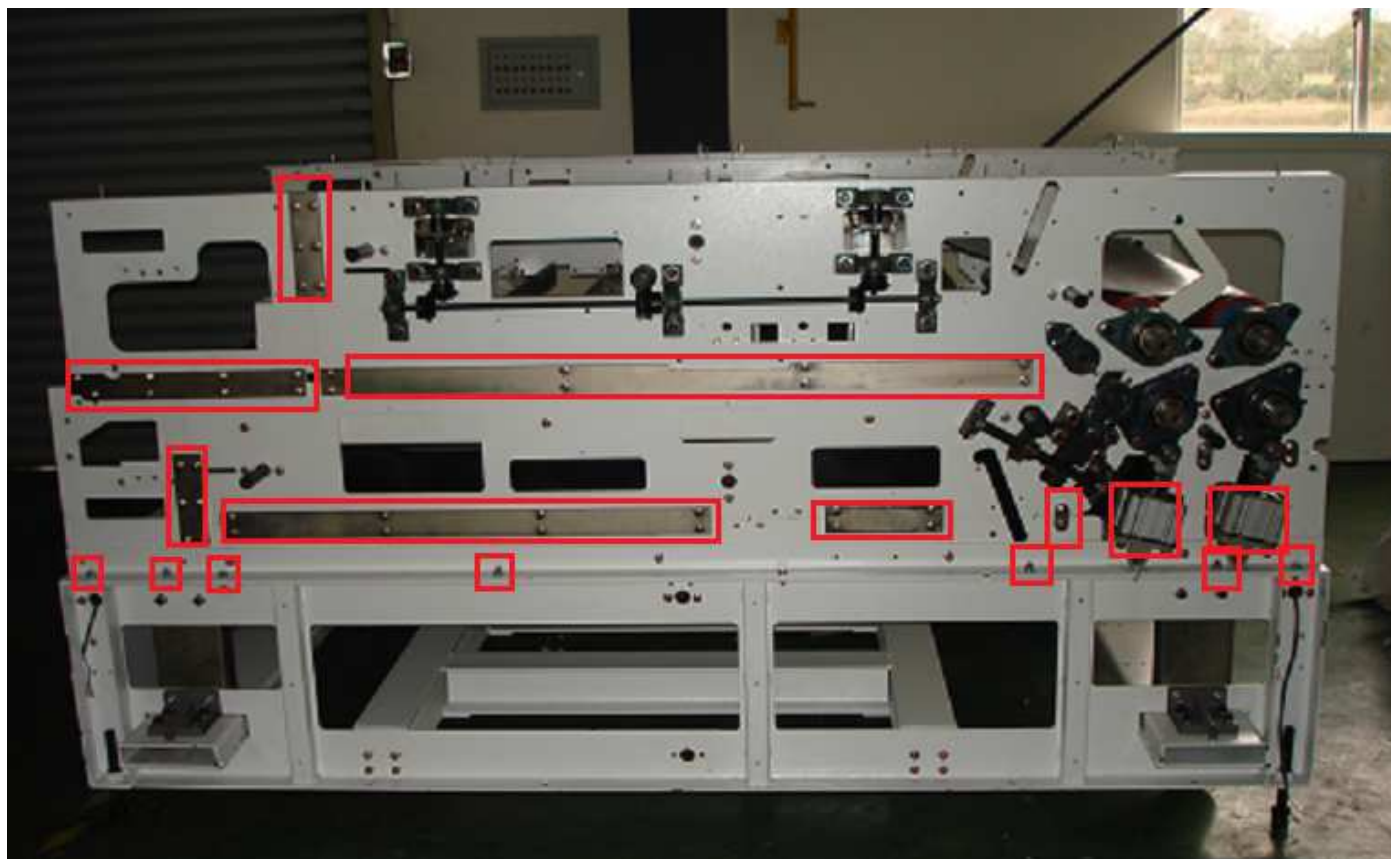


4. Take out fixing plate, upper cover fixing plate, frame fixing holder.
5. Loosen tension roller set screw.
6. After loosen belt tension, take out tension roller.



7. Set to pressure to 0.

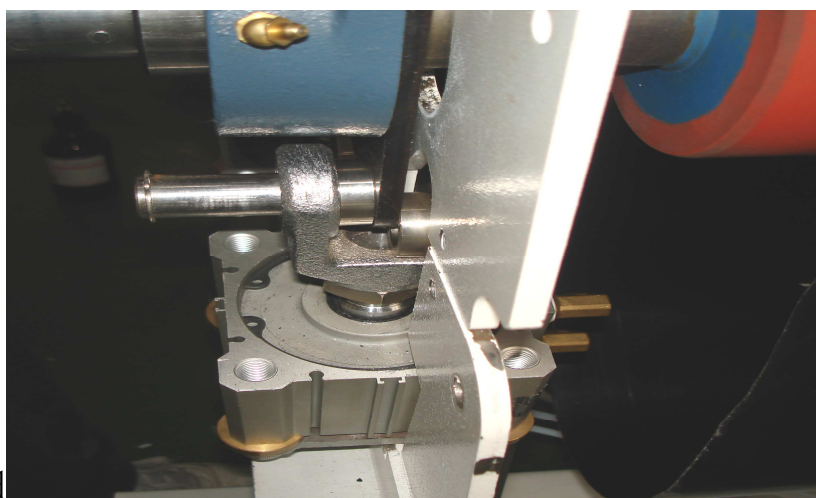
8. Take out upper frame and lower frame (8 position), take out belt warping prevention roller.



9.

10. Take out frame joint plate (9 position)

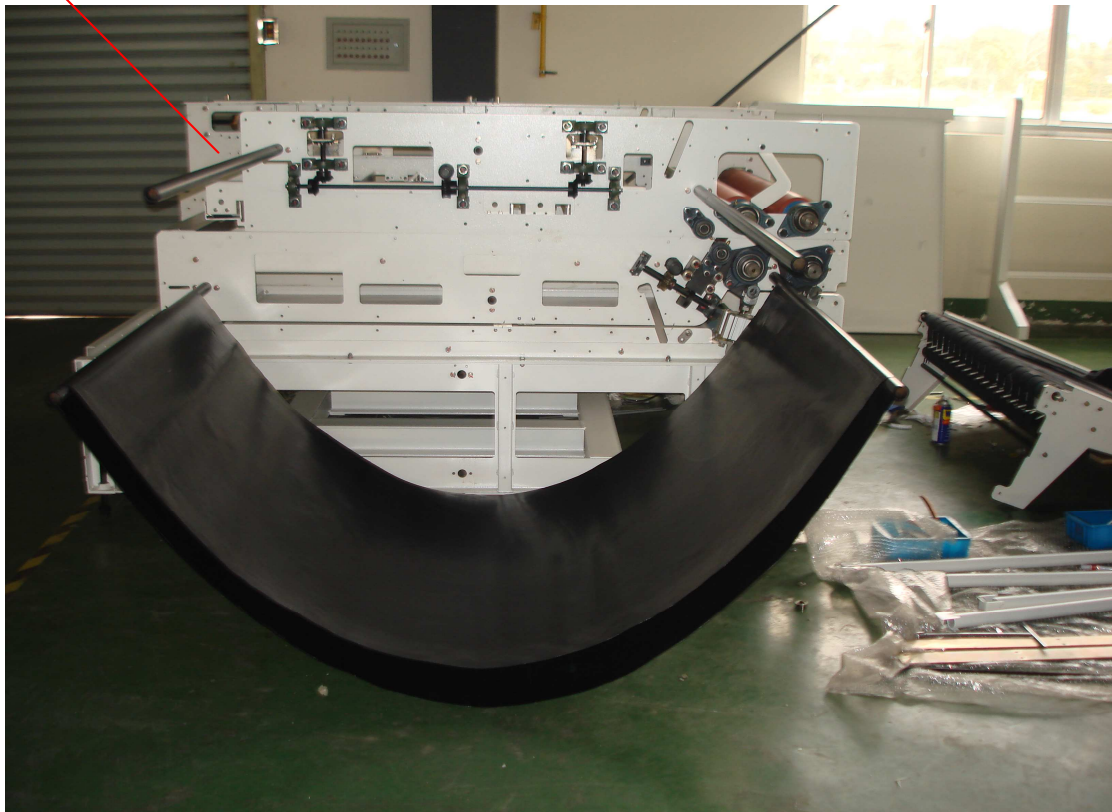
11. Take out connecting screw of base frame and lower frame. (8position)



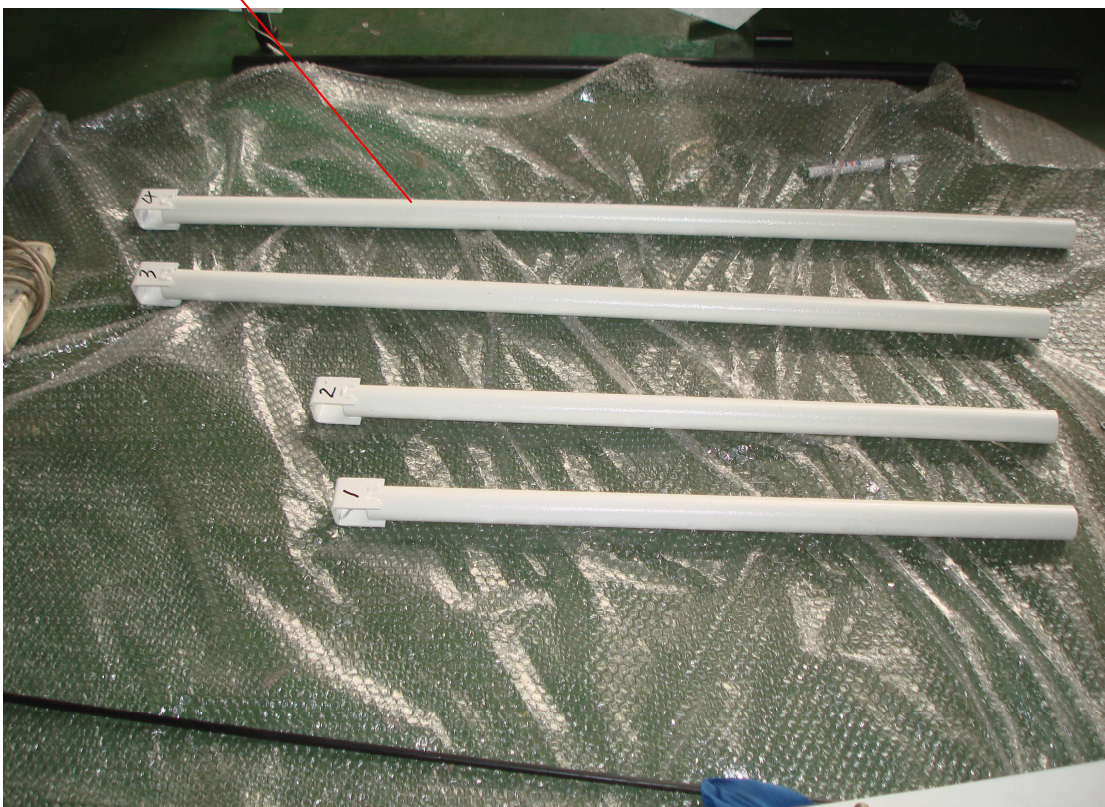
air cylinder connecting rod

12. Take out right air cylinder connecting rod. (2 position)

belt exchange pipe



belt exchange pipe stand



13. Long pipe stand is for upper belt exchange, short pipe stand is for lower belt

exchange

14after set belt exchange pipe and pipe stand, take out Teflon belt from space between upper frame and lower frame.

NOTE

When the belt is pulled out, be careful not to let the belt touch the belt warping prevention limit switch.

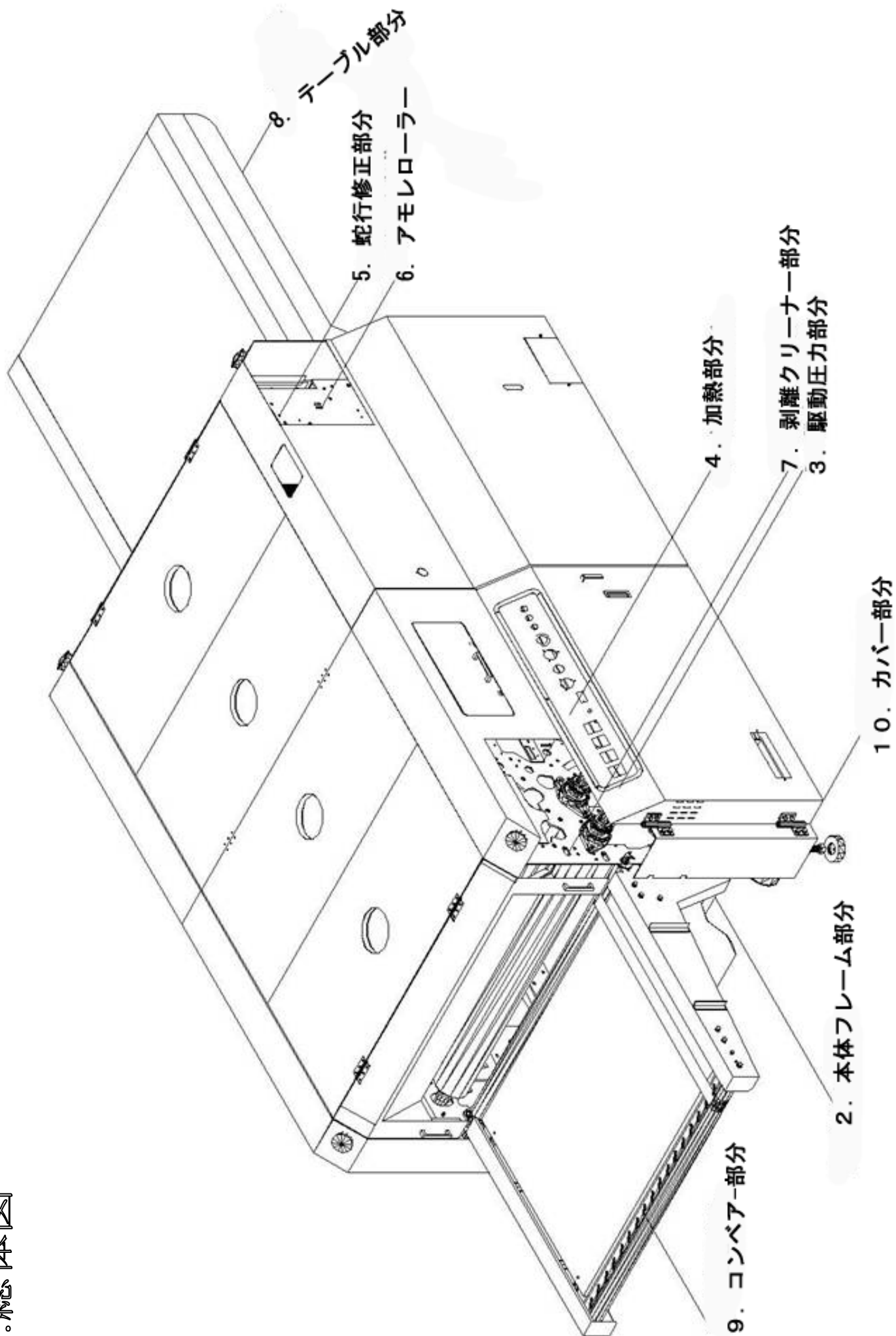
There are setting marks on the frames. To assemble the machine , be sure to fit the marks, then fasten the bolt for the frames.

After the belt replaced with new one, set the both left and right side tension springs at the same times. After completion of assembling, set the belt speed at 35seconds. And await until the belt makes slow 2 rounds rotation.

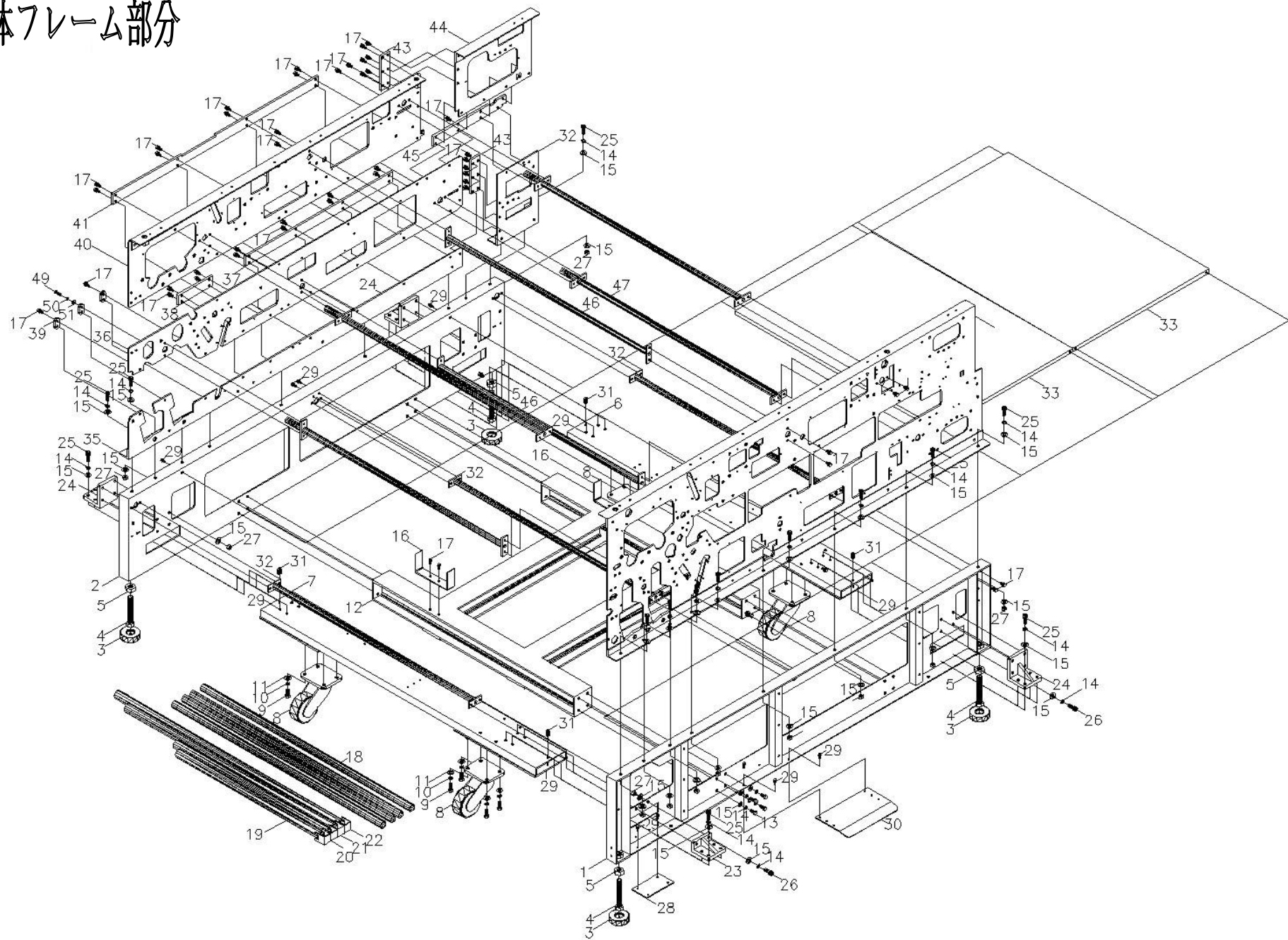
PARTS LIST

1. WHOLE BODY
2. MAIN FRAME PART
3. DRIVING AND PRESSURE PART
4. HEATENIN PART
5. BELT WARPING PREVENTION PART
6. ANTI PUCKERING ROLLER PART
7. CLEANER PART
8. TABLE PART
9. REAR CONVEYOR PART
10. COVER PART
11. ELECTRIC PART

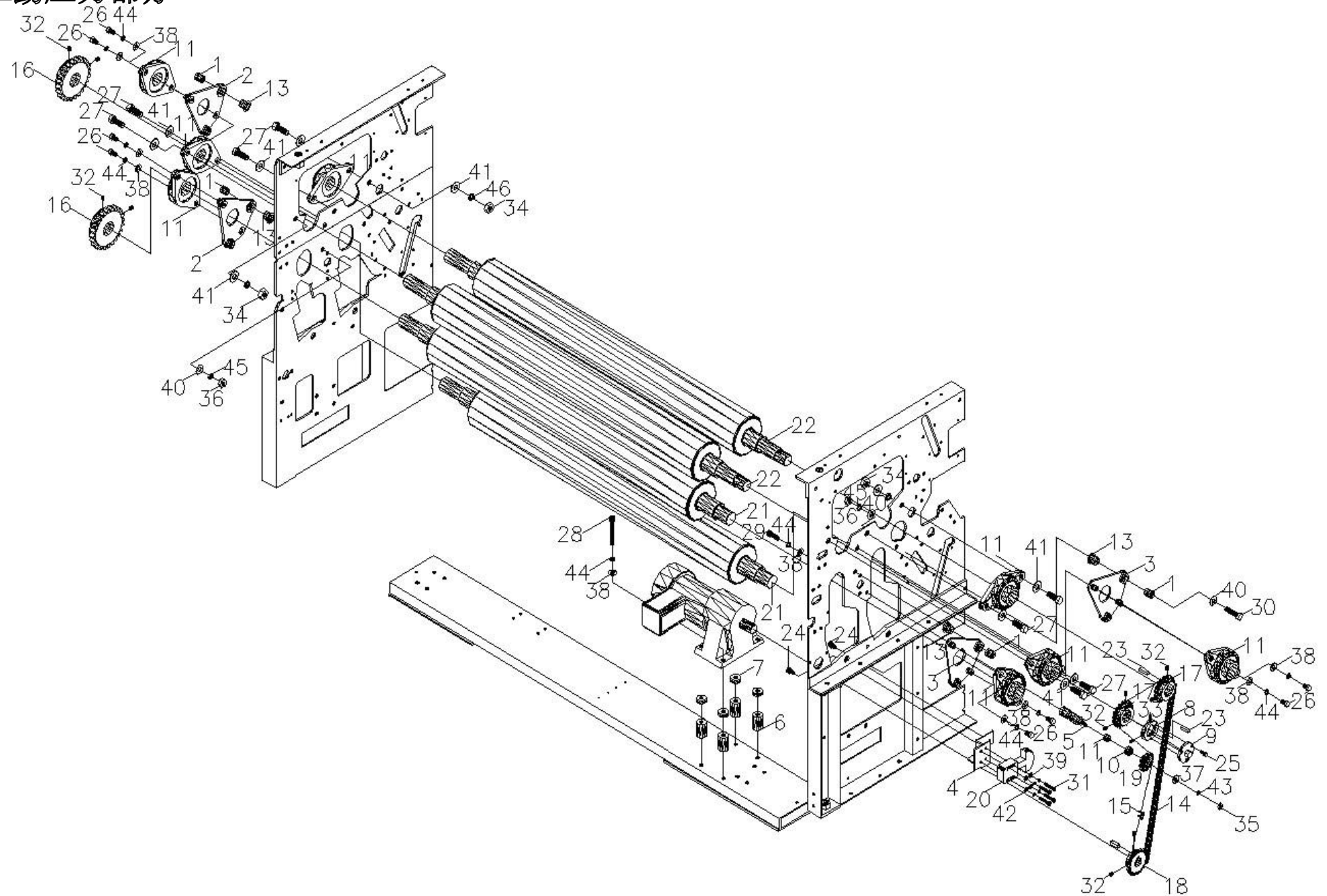
1. 総体図



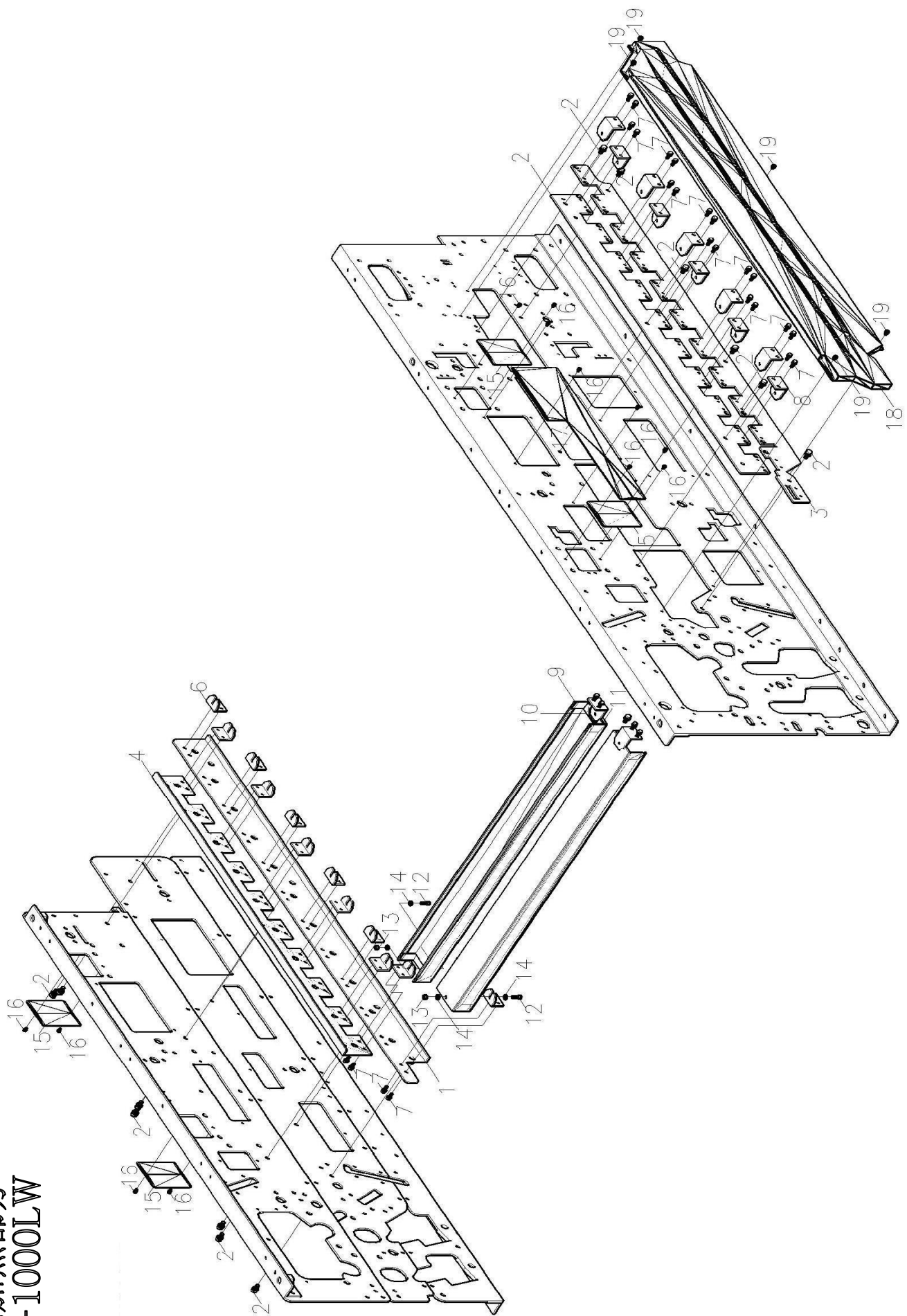
2. 本体フレーム部分



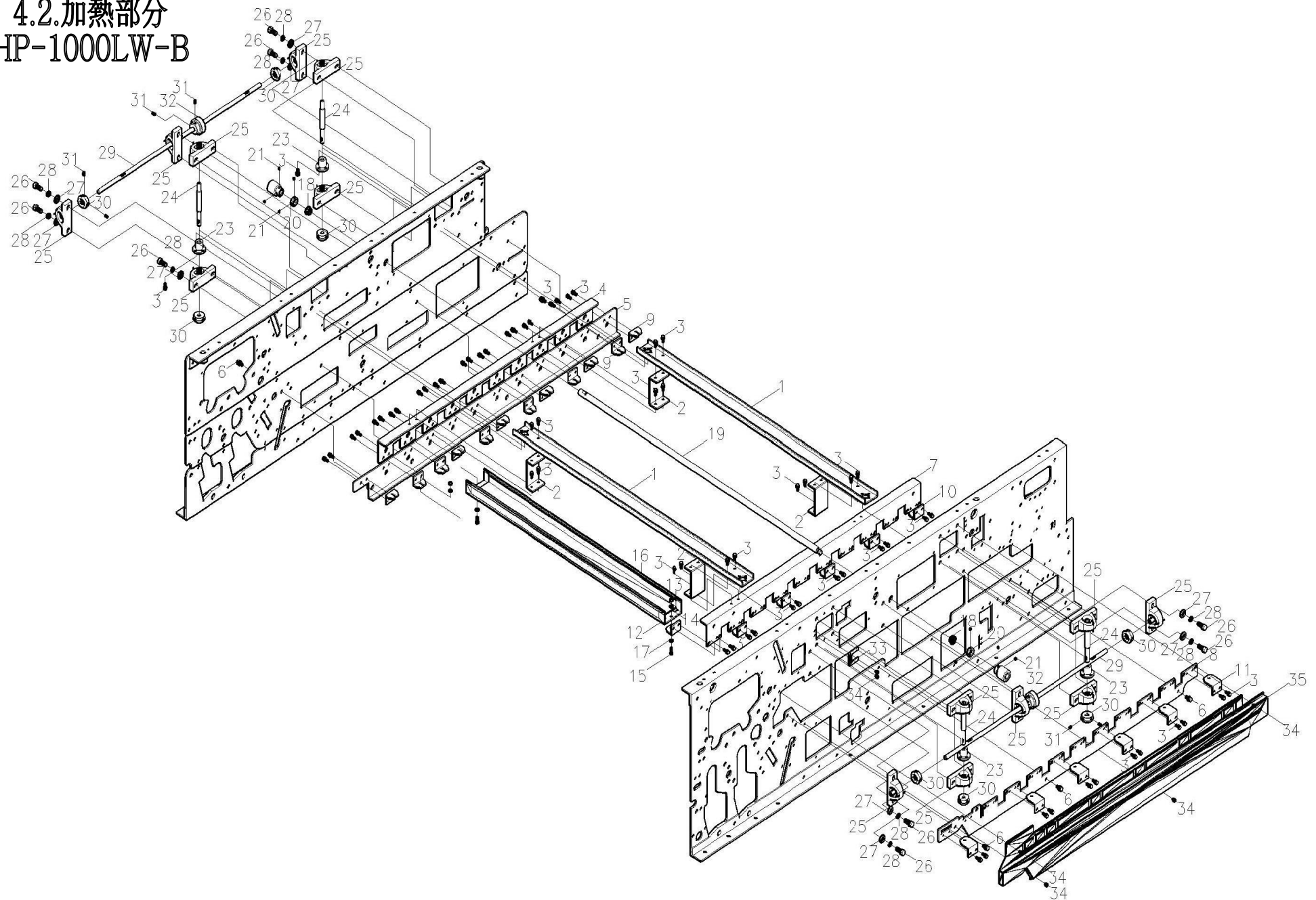
3. 驅動压力部分



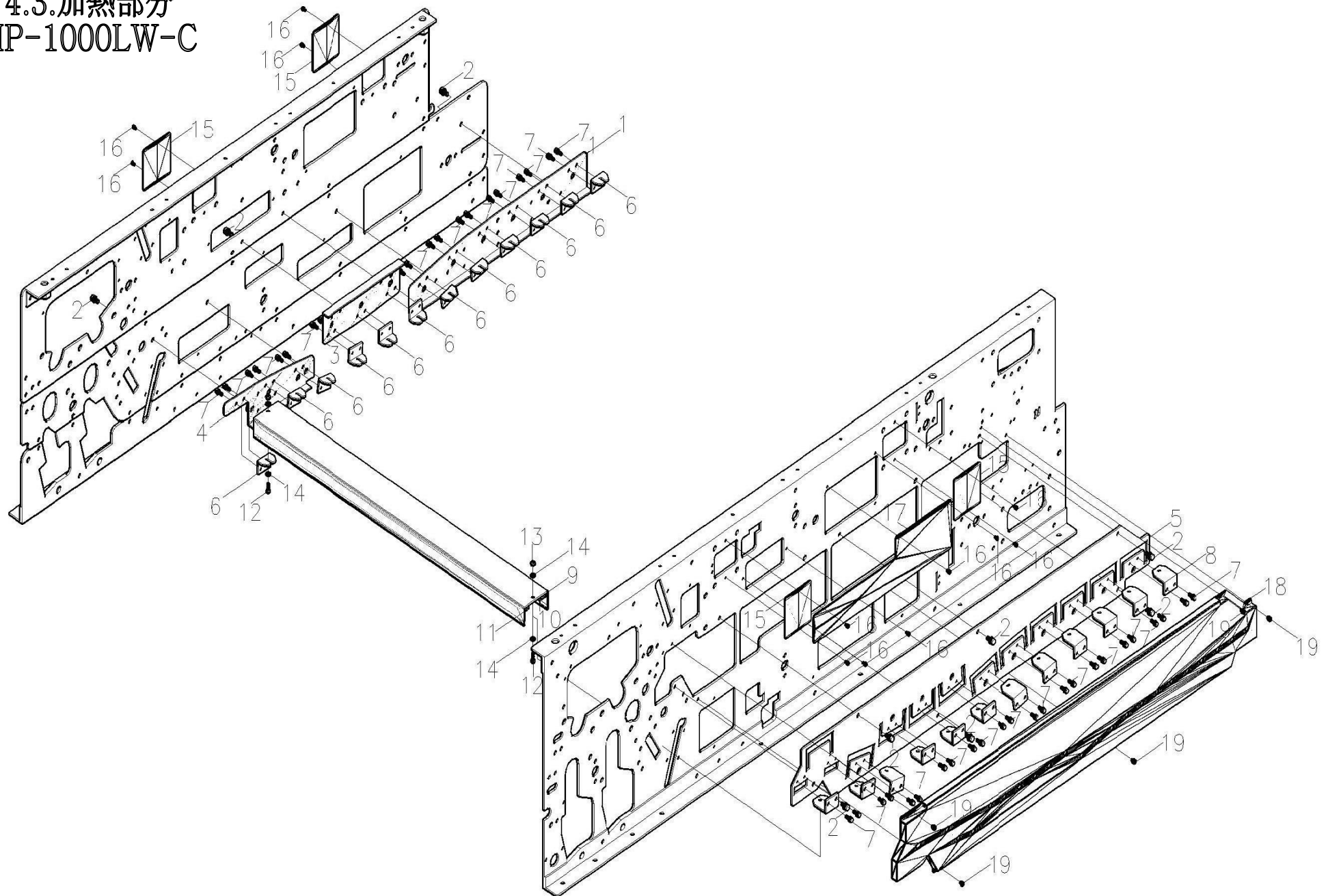
4.1.加熱部分 HP-1000LW



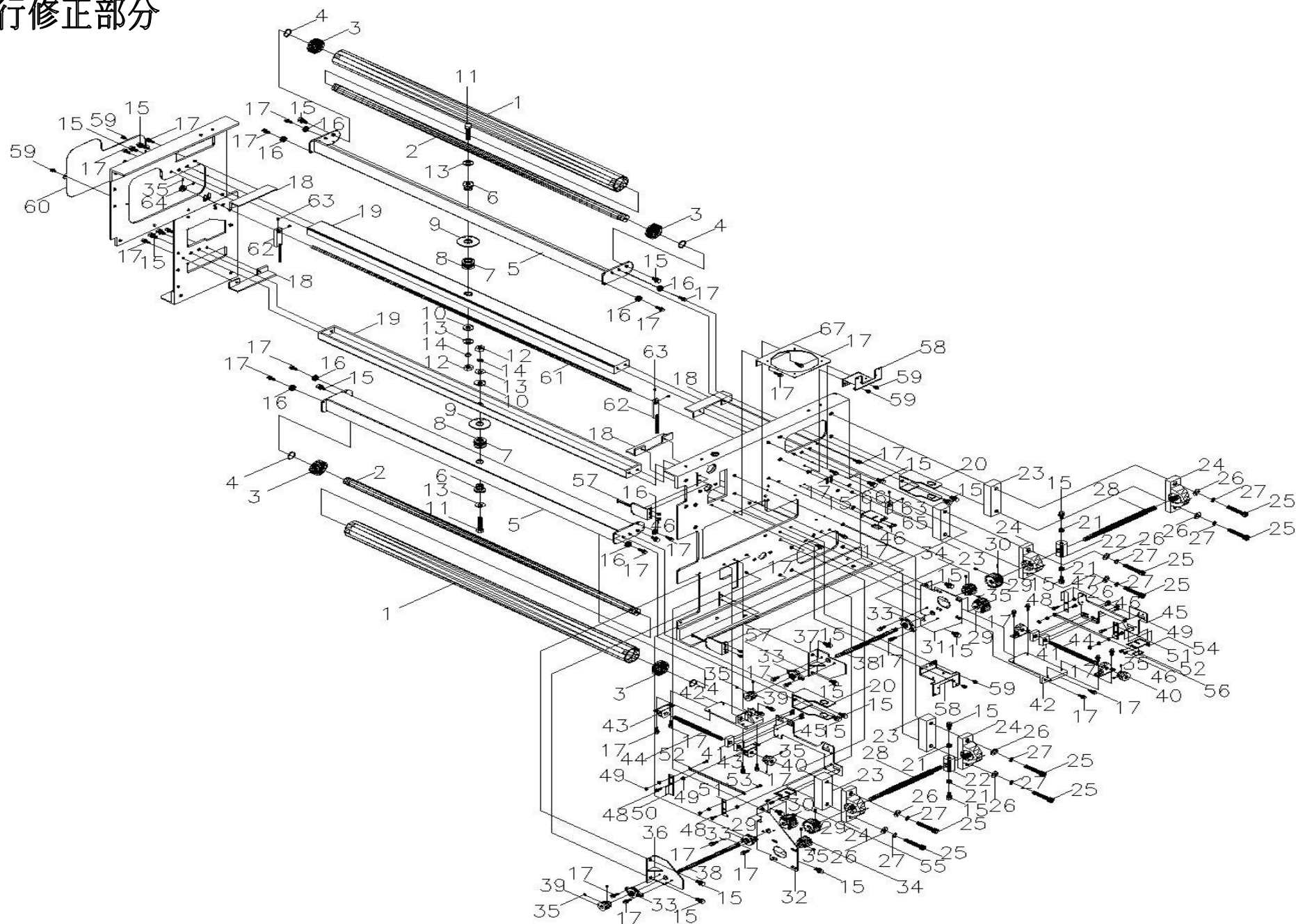
4.2.加熱部分 HP-1000LW-B



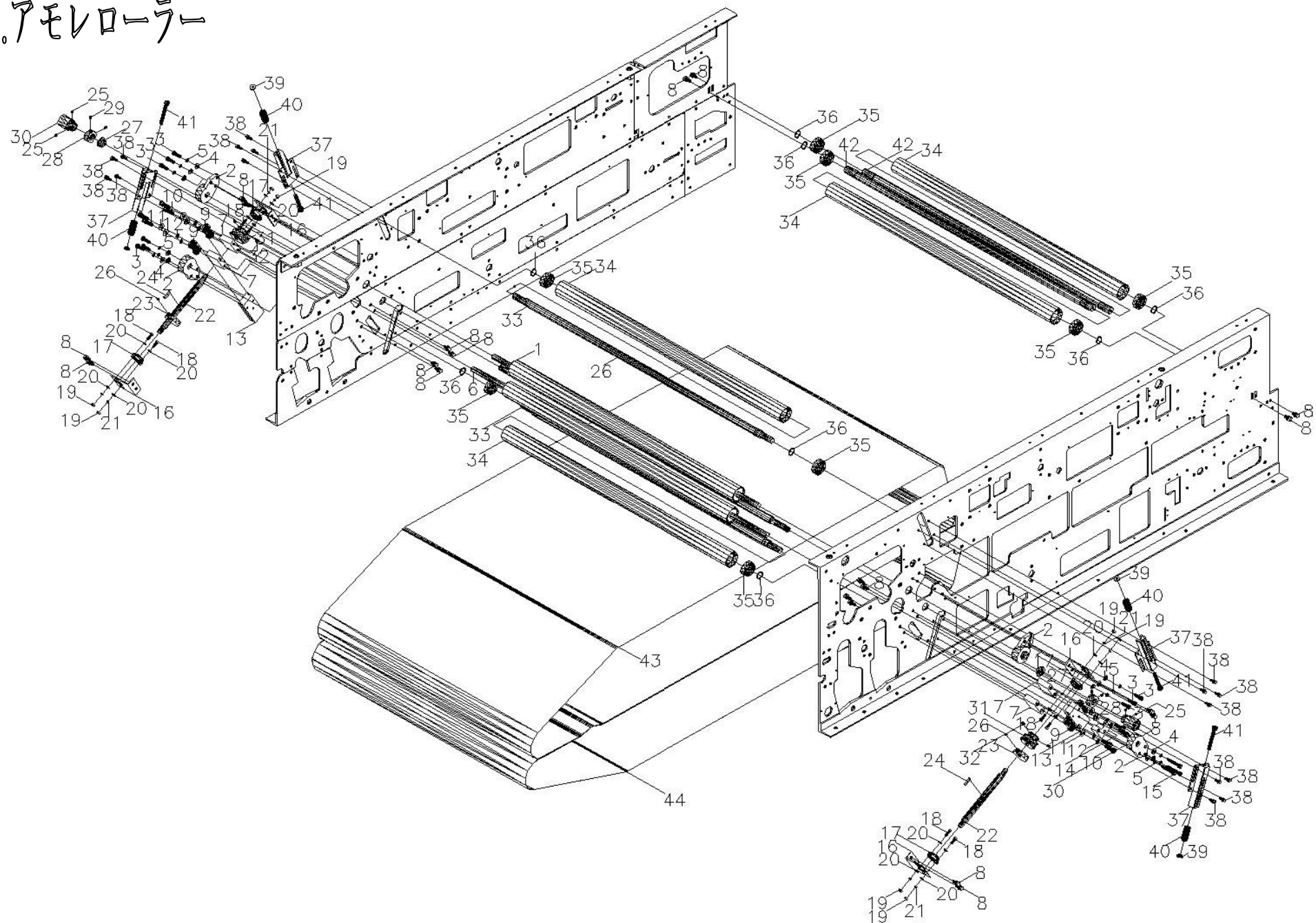
4.3.加熱部分 HP-1000LW-C



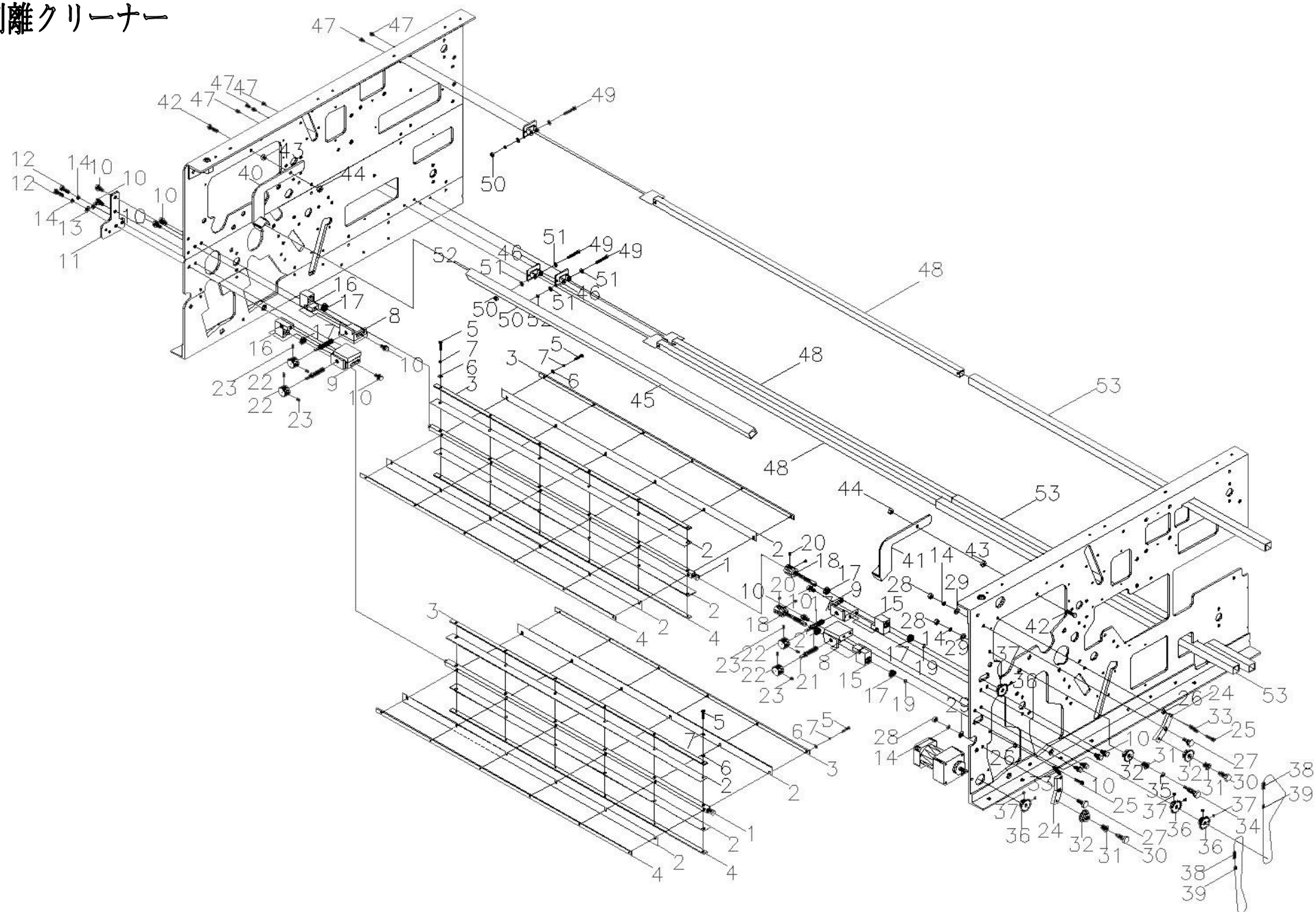
5.蛇行修正部分



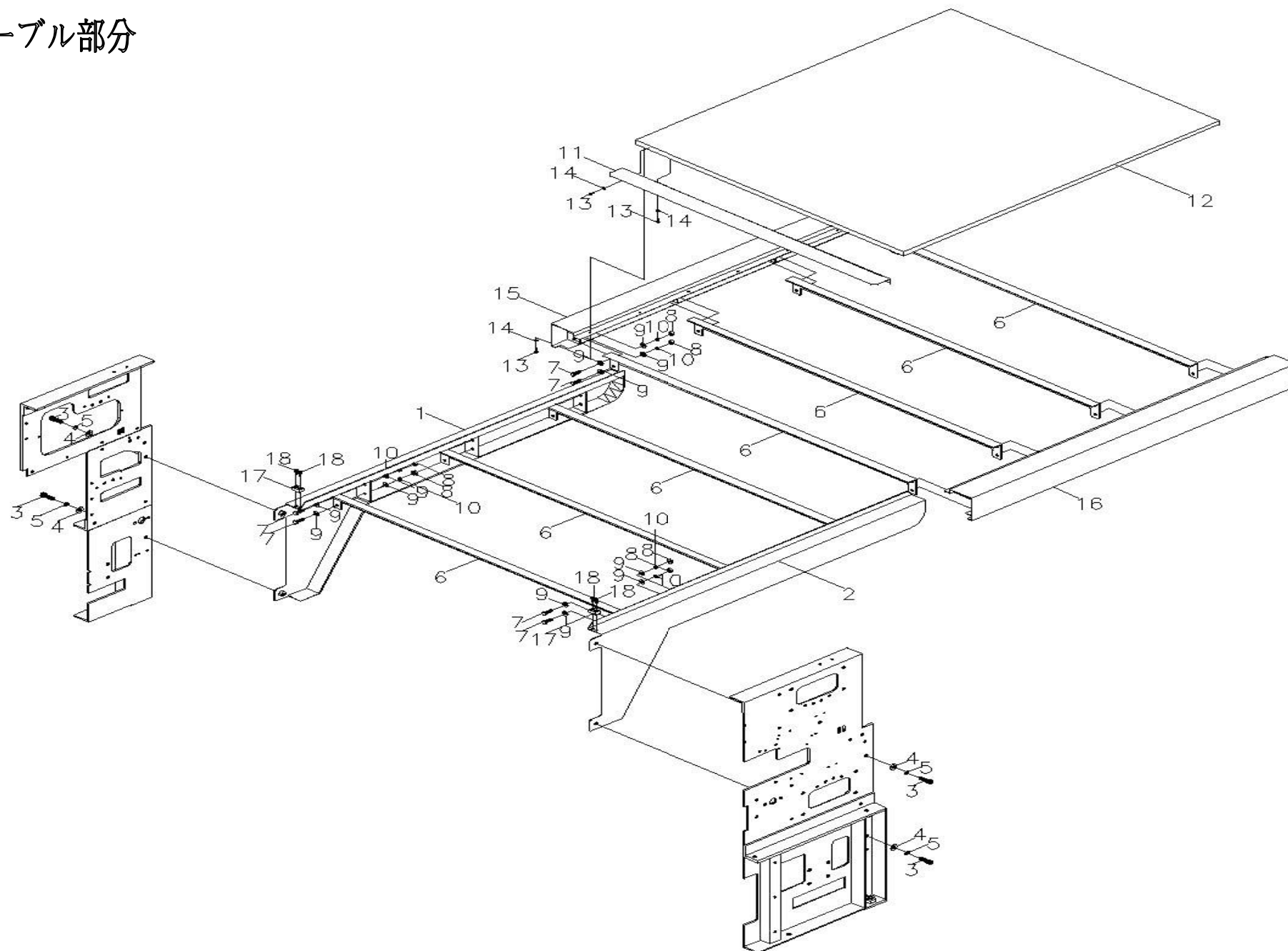
6.アモレローラー



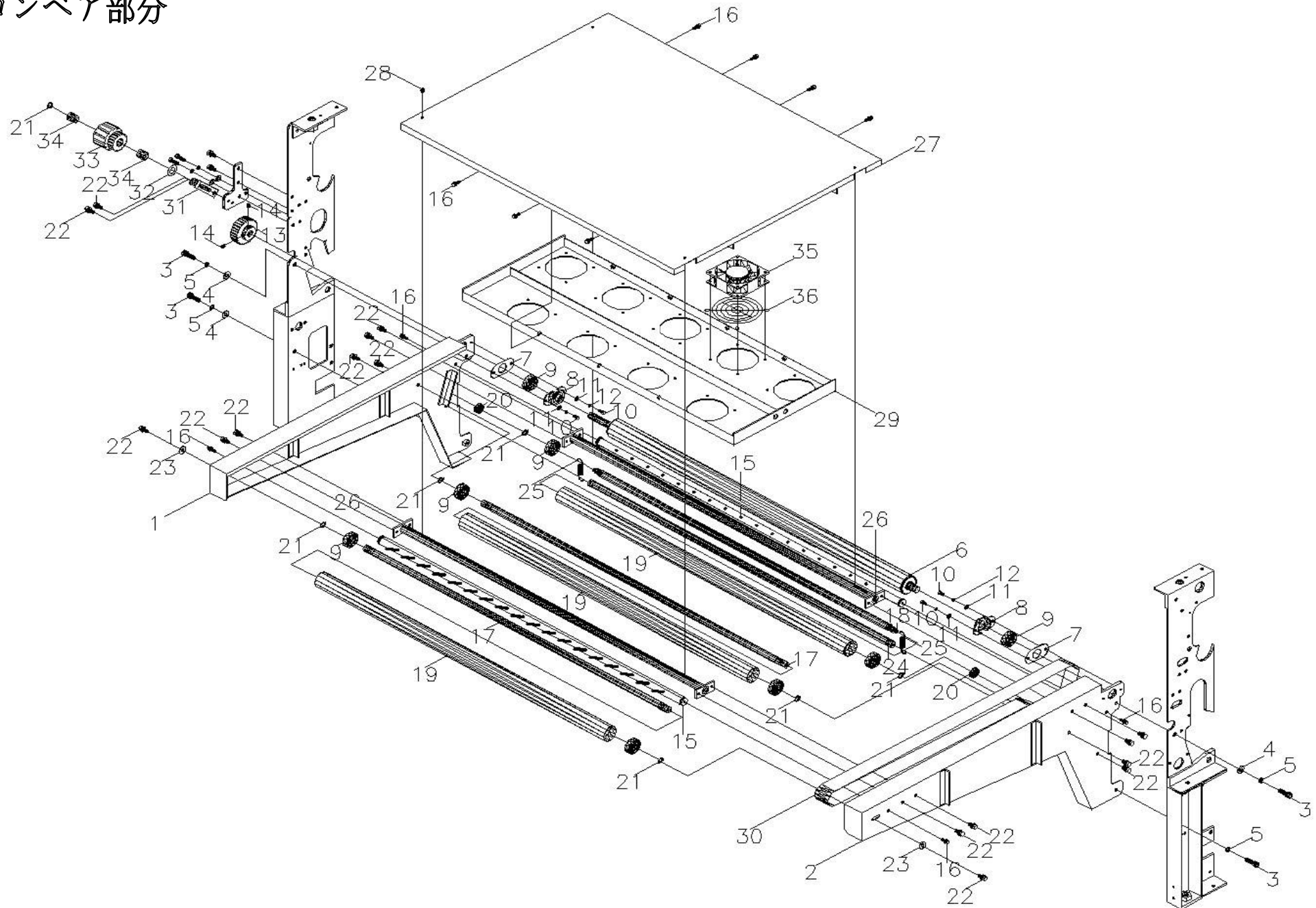
7.剥離クリーナー



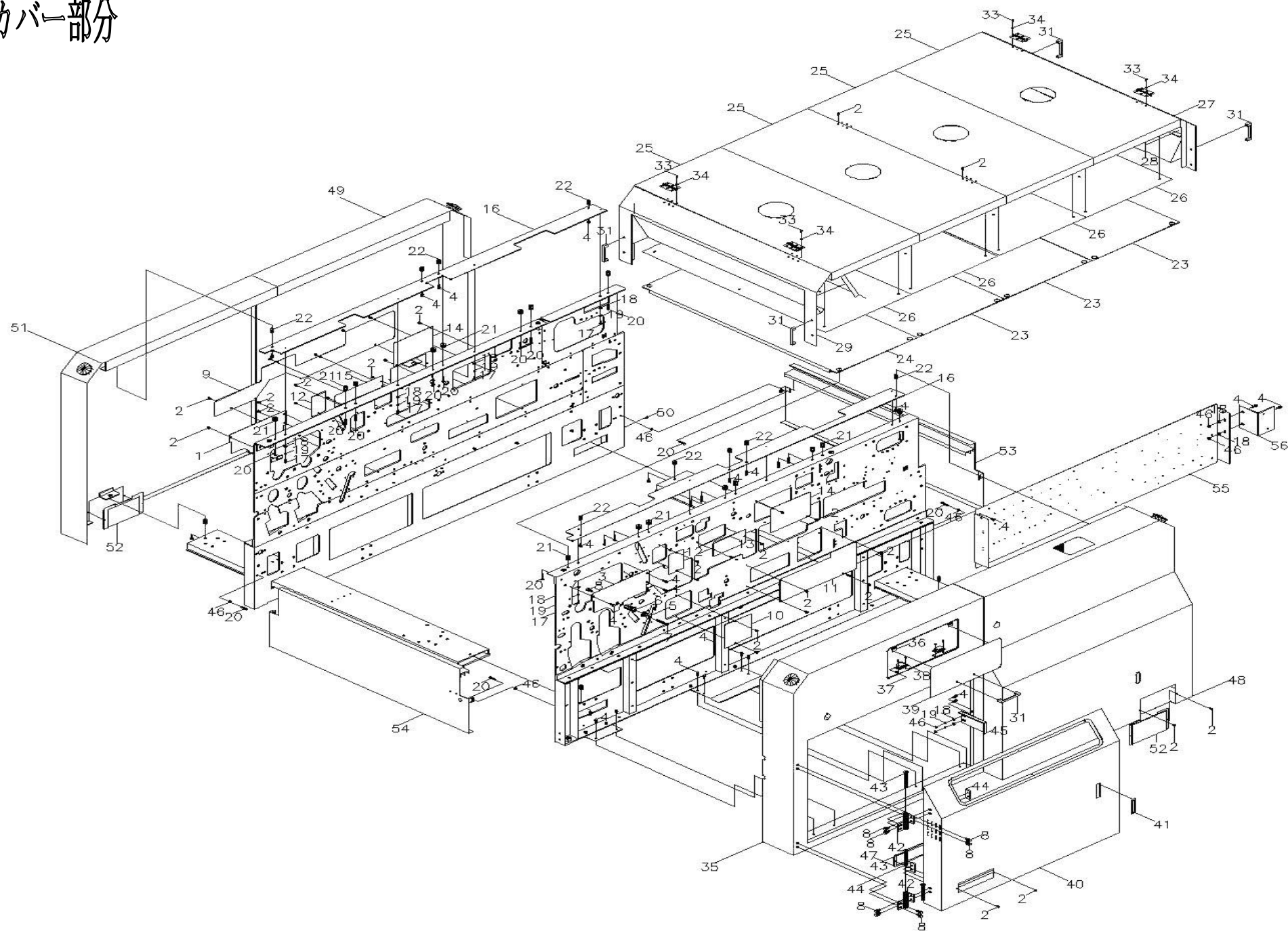
8. テーブル部分



9.コンベア部分



10.カバー部分



11.電装部分

