



ZJ-933

变速自动切滚条机

AUTO PIPING STRIP CUTTING MACHINE

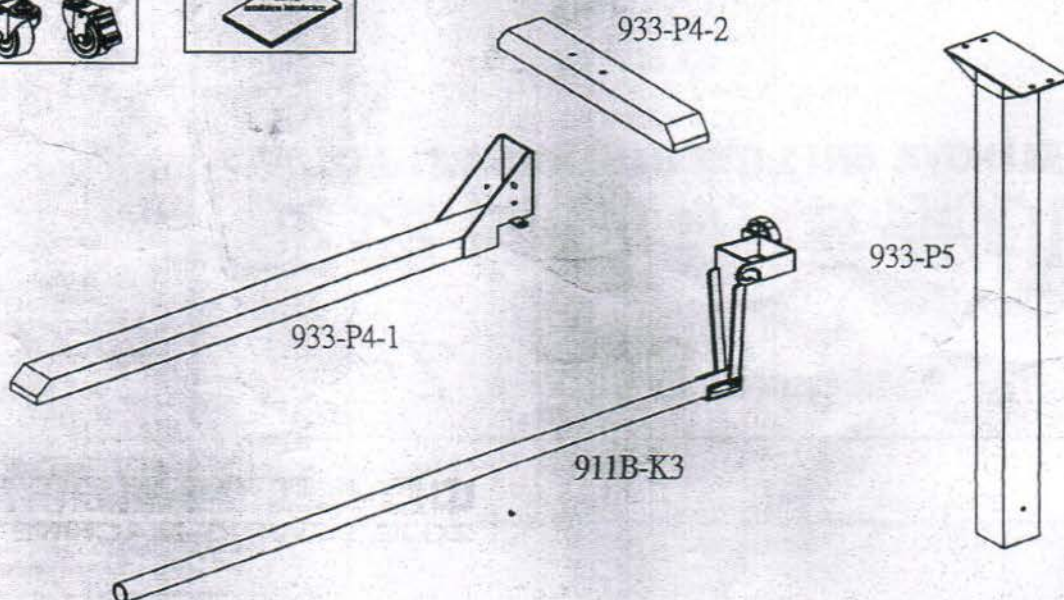
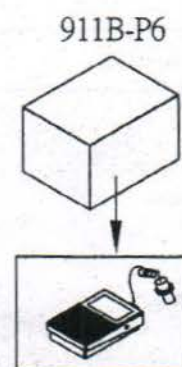
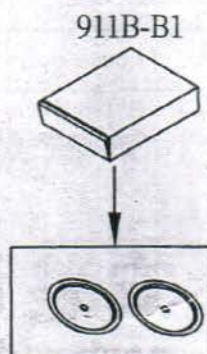
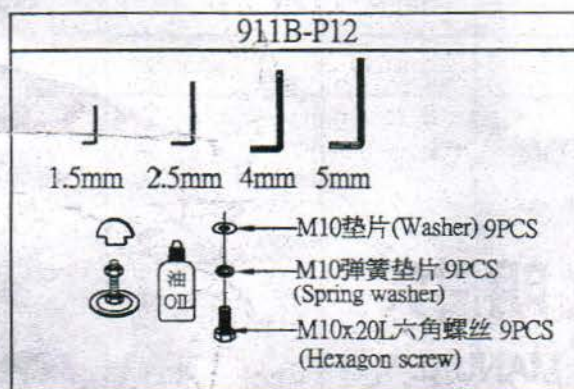
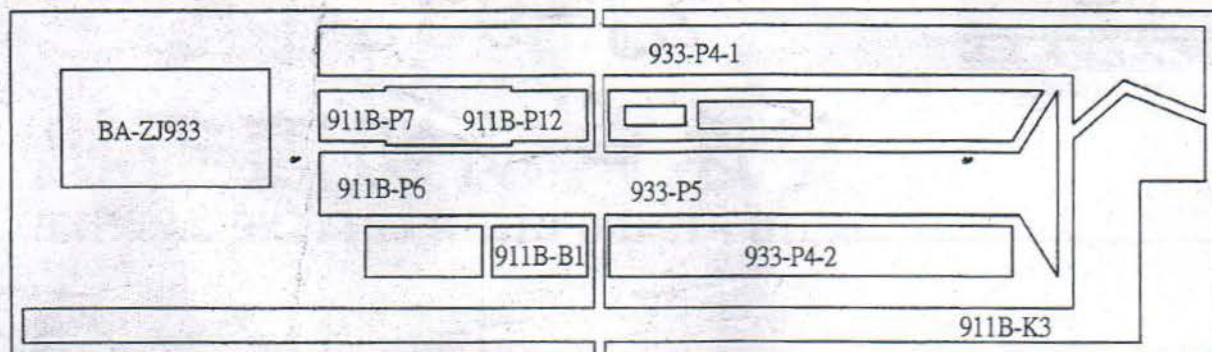
安装说明书

OPERATION MANUAL

中国·中捷缝纫机股份有限公司
ZOJE SEWING MACHINE CO., LTD.

● 工具及相关零件 Tool kits & parts

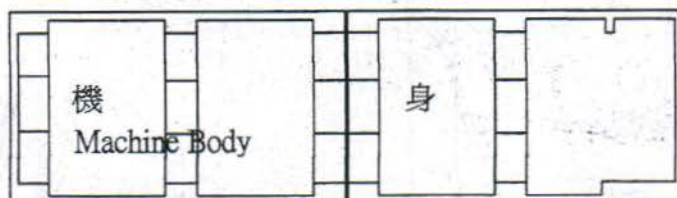
◎ 包装盒内位置標示 The position in the box



組 合 圖

ASSEMBLING CHART

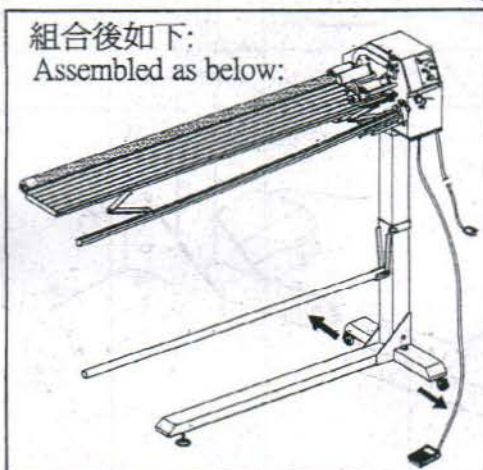
● 包裝盒內位置標示 The position in the box



此零件可供選購，具體請見附錄

This component can supply to select and purchase please refer to appendix for specifically request

組合後如下:
Assembled as below:

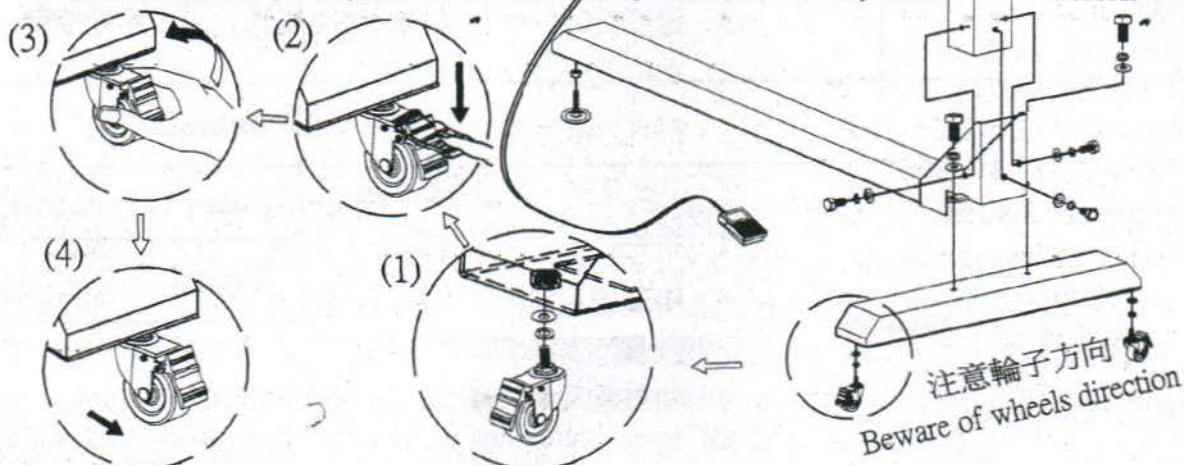


安裝輪子 Fix the wheels.

- (1)、按順序將零件裝上. Assemble the parts.
- (2)、先制車. Activate the brake.
- (3)、再用手鎖緊輪子. Use hand to fasten the wheels first.
- (4)、鎖緊輪子之後，輪子的方向必須朝外.

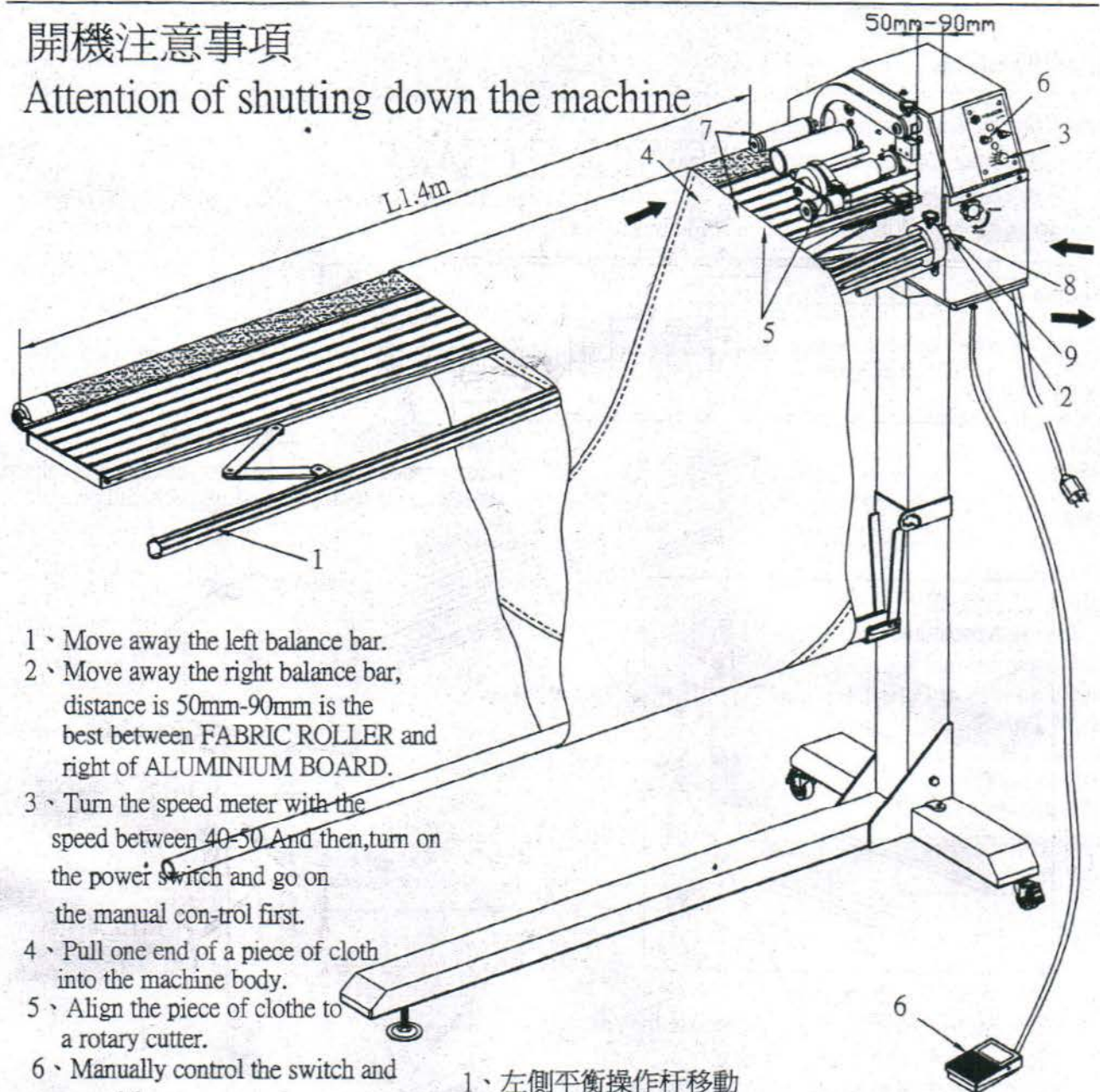
After fasten the wheels, beware of wheels direction.

※組裝不需任何工具，用手即可. Assemble by hands, needn't any tools.



開機注意事項

Attention of shutting down the machine



- 1、Move away the left balance bar.
- 2、Move away the right balance bar, distance is 50mm-90mm is the best between FABRIC ROLLER and right of ALUMINIUM BOARD.
- 3、Turn the speed meter with the speed between 40-50 And then, turn on the power switch and go on the manual con-trol first.

- 4、Pull one end of a piece of cloth into the machine body.
- 5、Align the piece of clothe to a rotary cutter.

- 6、Manually control the switch and a pedal.
- 7、roll the peice of cloth half circle and have 20mm of the peice of cloth rolled onto a roller.
- 8、If the peice of cloth rolls to slow, push the right balance bar 1cm inward and roll the piece of cloth one circle again.

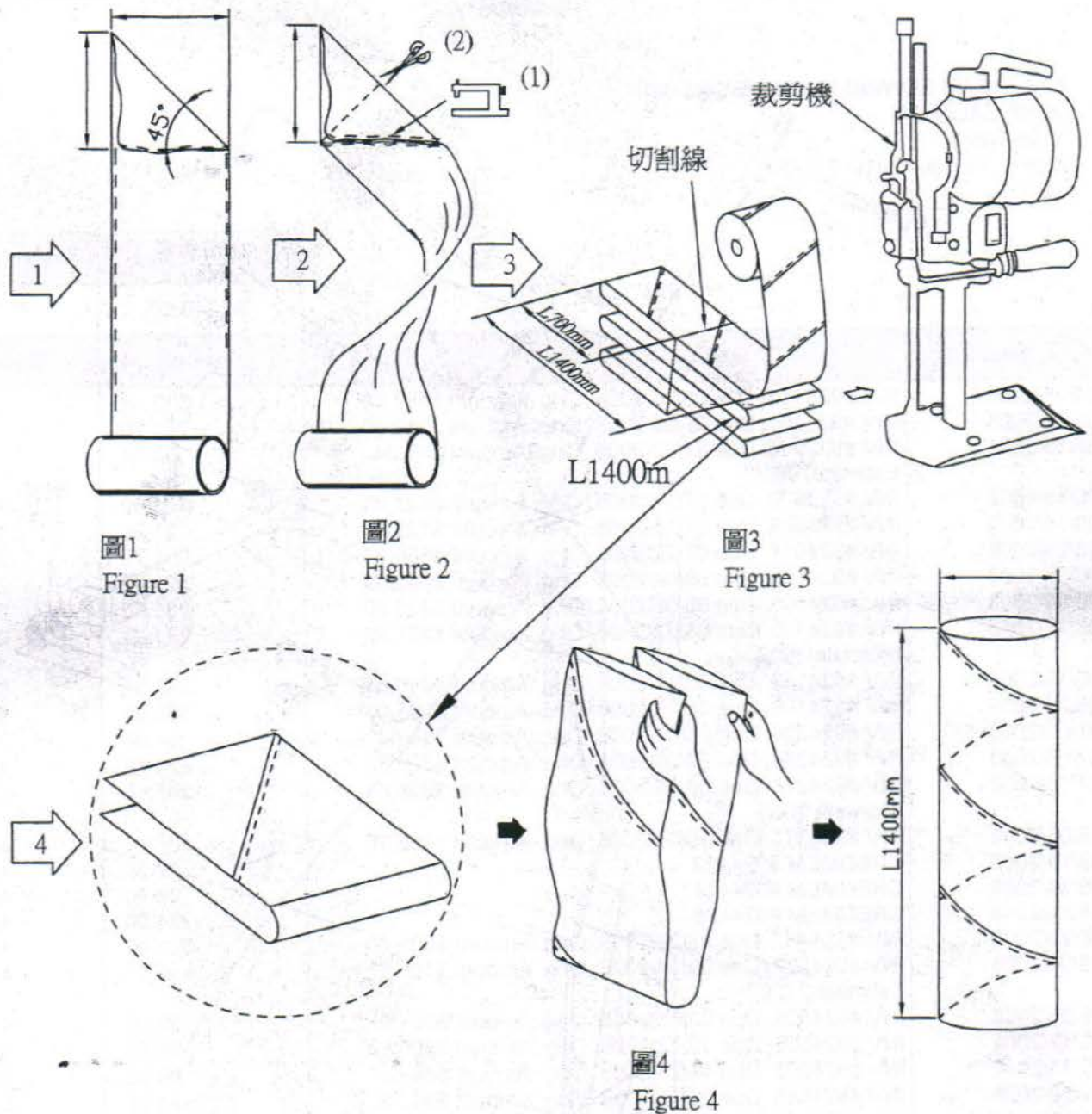
If the peice of cloth still does not roll inward, push the right balance bar inward slowly.

- 9、If the peice of cloth roll too fast, pull the right balance bar 10mm outward.

- 1、左側平衡操作杆移動
- 2、右側平衡操作杆移動,保持滾布棒與鋁合金板右端的距離為50mm-90mm為最佳
- 3、速度表轉於40-50之間,開啓電源,先以手動控制
- 4、布拉進機身
- 5、布與刀輪對齊
- 6、手動開關,配合腳踏板控制
- 7、布先繞半圈,已有20mm之布匹,先捲入卷筒上
- 8、如布進入太慢時,右側平衡杆往內推進10mm,布再繞一圈,如布再不進入往內慢慢推
- 9、如布進入太快時,右側平衡杆往外拉出10mm

45度橫條平織布裁切法.

45° twill woven fabrics cut method.



A、準備布匹。 Prepare fabric.

B、依圖1沿著虛線折成45度。 Fold up the dotted line into 45°.

C、(1)完成B步驟後縫合箭頭指向的虛線。(2)縫合後剪掉虛線上的三角形。

(1)Complete the step B;stitch up the dotted line which pointed by an arrowhead.

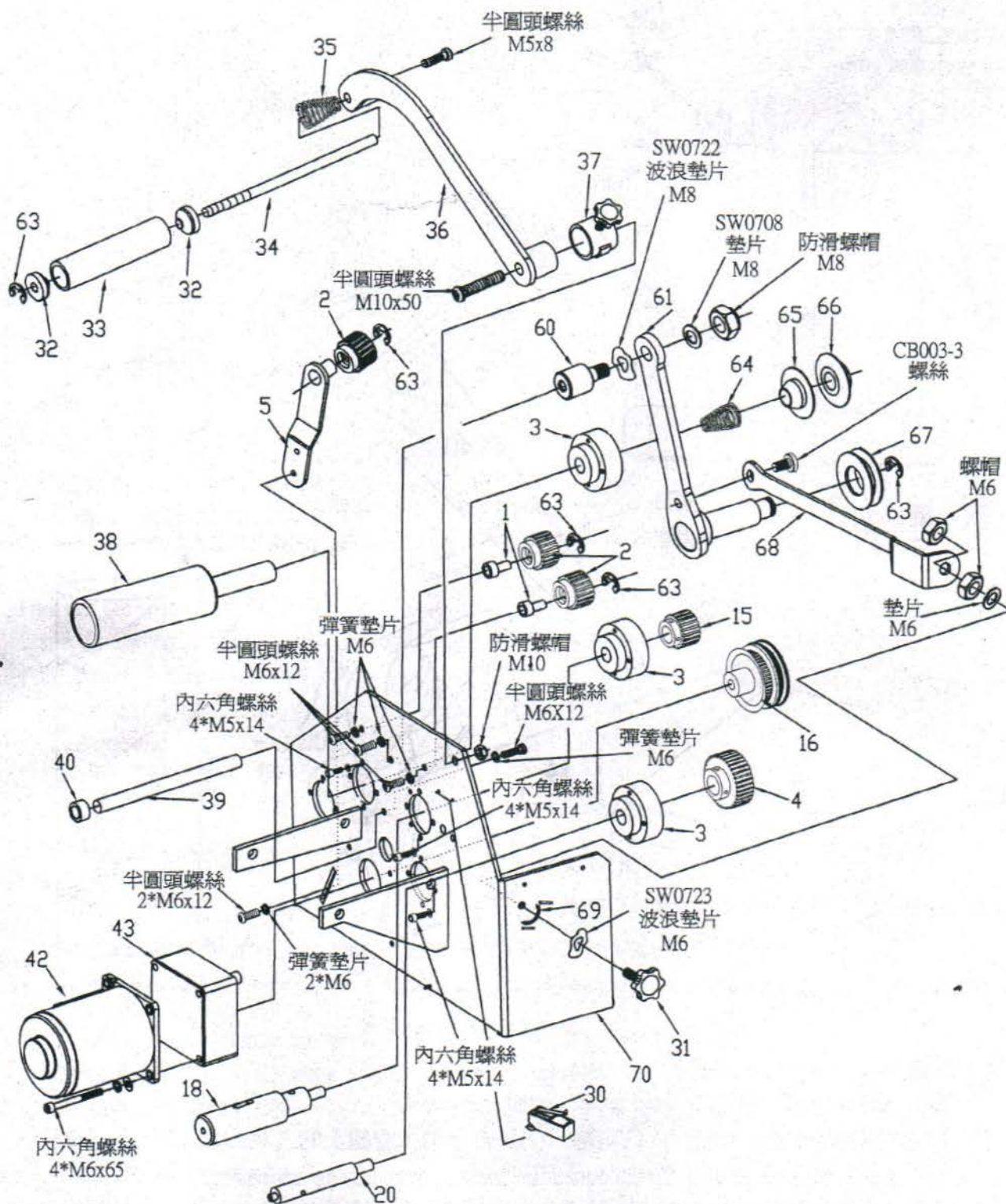
(2)After stitched up then cut the triangle form above the dotted line which pointed by a scissors.

D、將布條以每1400mm對折，用材切機從布條中間切斷如圖3，即成為圖4等長的圓筒布條。

Fold up the strip of cloth in every 1400 mm then use the machine to cut the line from the middle of cloth showed as figure 3 then it will become same length in every cylinder of cloth.

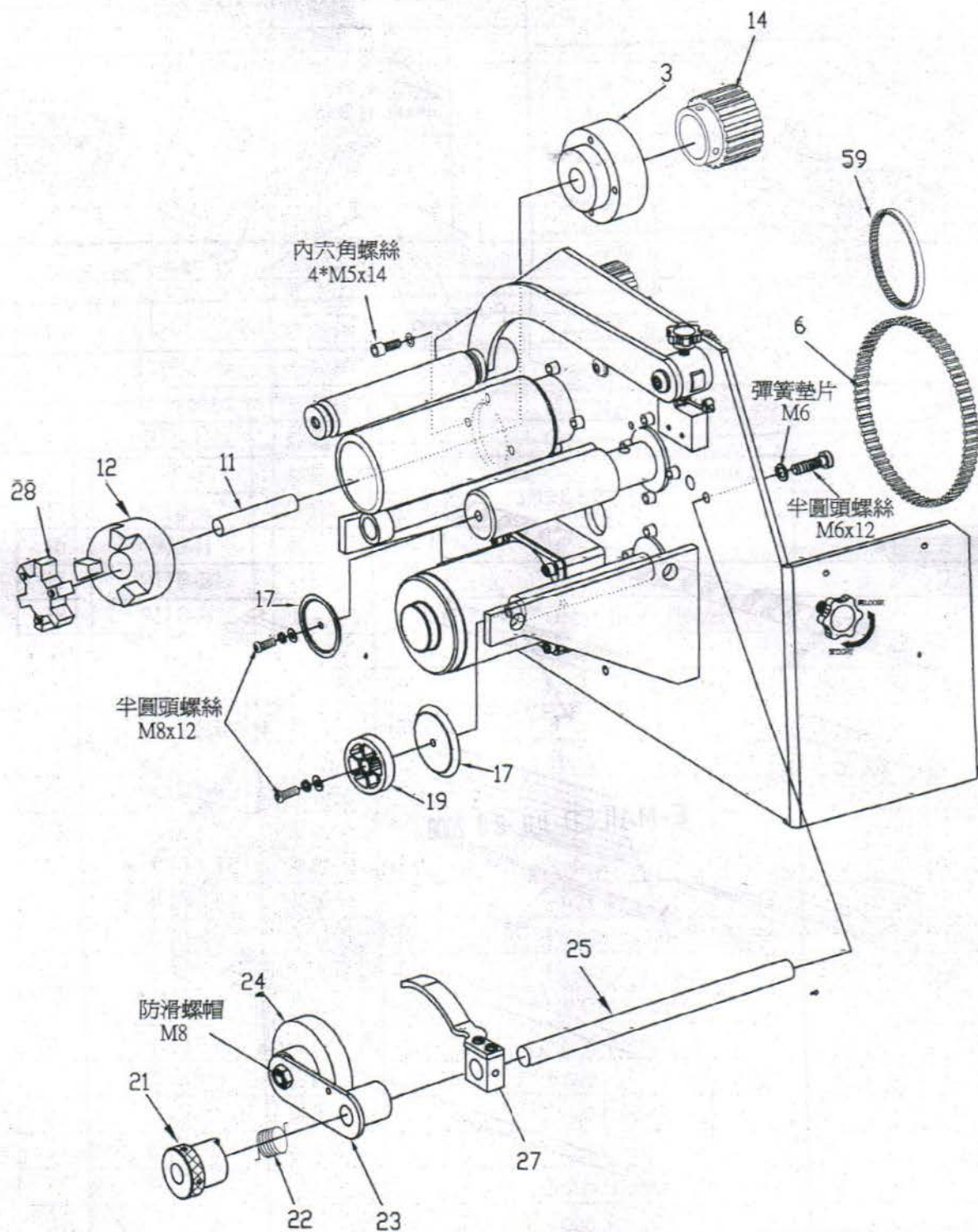
ZJ-933零件分析圖表

ZJ-933 Parts Diagram



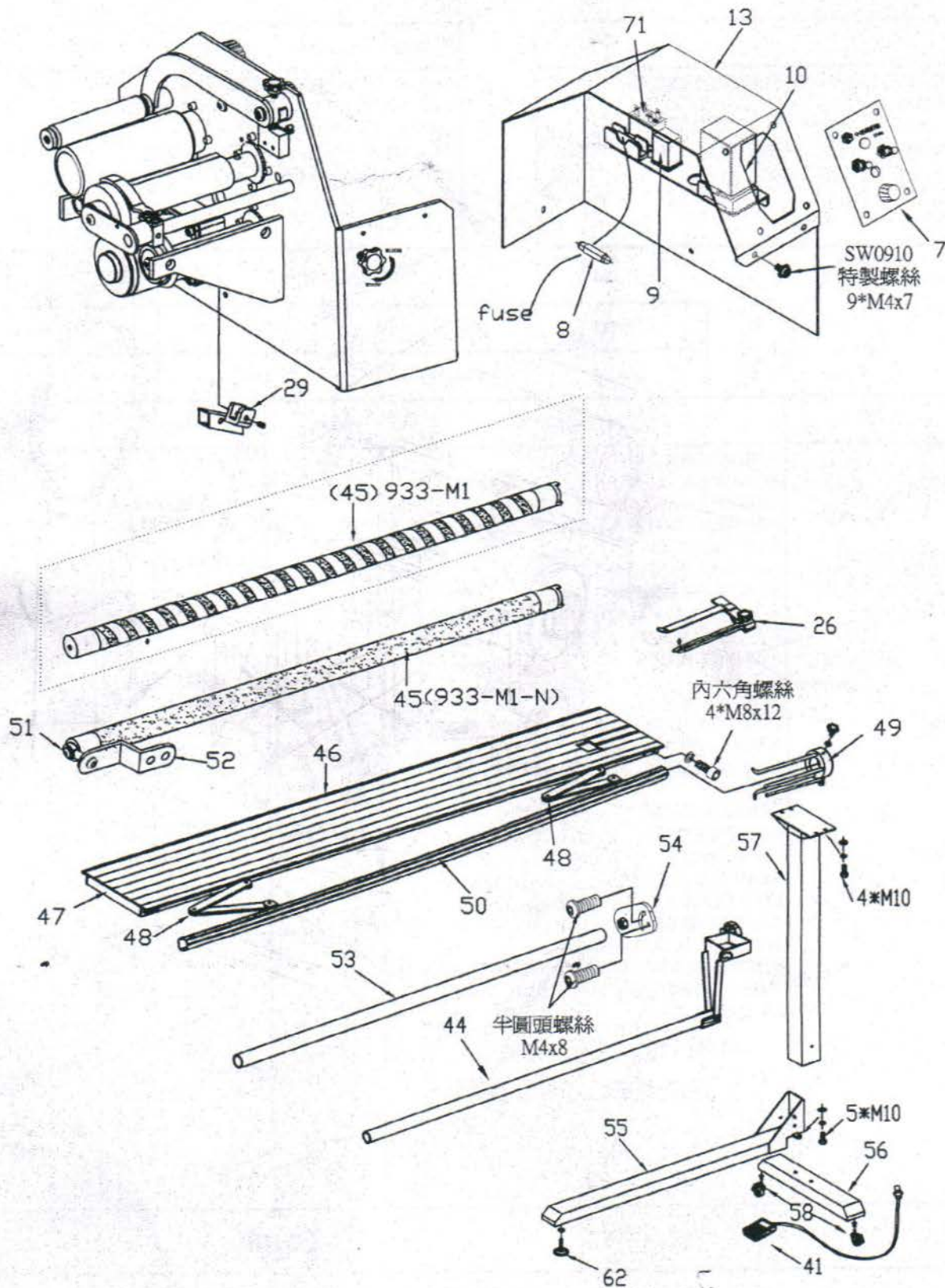
ZJ-933零件分析圖表
ZJ-933 Parts,Diagram

ZJ-933 Parts Diagram



ZJ-933零件分析圖表

ZJ-933 Parts Diagram



ZJ-933零件分析圖表

ZJ-933 Parts Diagram

序 號 Ref.No.	物料編號 Part.No.	名 稱 Description	單位用量 Amt.Req.
1	911B-A1	齒輪軸心 Gear Axle	2
2	911B-A2a	培林齒輪1543 Gear's Bearing 1543	3
3	911B-A3	培林座 Bearing Seat	4
4	911B-A4b	下刀架齒輪1544 Gear's Bearing 1544	1
5	933-A5	皮帶調節座 Belt Adjuster Seat	1
6	933-A6-1	皮帶 Timing Belt 310DXL	1
7	933-A7	面板 Control Panel	1
8	911B-A8	玻璃保險絲3A Fuse	1
9	911B-A9	繼電器 Relay 3.5Ux60Wx5G	1
10	911B-A10	馬達控制器SS22 Speed Controller	1
11	911B-A4a	齒輪棒 Gear Stick	1
12	911B-M1d	三角連接頭(有洞) Three Feet Connector	1
13	933-AD	外蓋 Casing	1
14	933-F	齒輪21齒 Gear's Bearing 21	1
15	911B-A2	鎖螺絲齒輪1542 Screw's Gear 1542	2
16	933-H	馬達用齒輪 Motor's Gear	1
17	911B-B1	刀片組 Knives Set	2
18	911B-B2	上刀架 Upper Knife Holder	1
19	933-B3	刀墊 Knife Cushion	1
20	911B-B4	下刀架 Lower Knife Holder	1
21	911B-C1	調整白銀套筒 Adjuster Sleeve	1
22	911B-C2	保護刀組用彈簧 Spring	1
23	911B-C3	壓布輪桿(L8121) Roller's Shaft	1
24	911B-C4	壓布輪 Roller	1
25	911B-C5	保護刀組用軸心棒 Roller's Axle	1
26	911B-C6	調整尺 Ruler	1
27	911B-C7	保護刀座組 Protection Cover's Seat	1
28	911B-C8	六角塑膠 Hexagon Rubber	1
29	911B-C9	油箱 Oil Container	1
30	911B-A16	微動開關 Micro Switch	1
31	933-A1	旋鈕 Knob	1
32	911B-E1	錐型套環 Cone Plug	2
33	911B-E2	捲布筒 Fabric Reel	1
34	911B-E4	捲布器軸心 Fabric Reel's Axle	1
35	911B-E5	錐型彈簧 Cone Spring	1
36	933-E6	連桿 Link Shaft	1
37	911B-E7	固定扣環 Retaining Ring	1
38	933-G	捲布軸 Fabric Reel's Axle	1

ZJ-933零件分析圖表

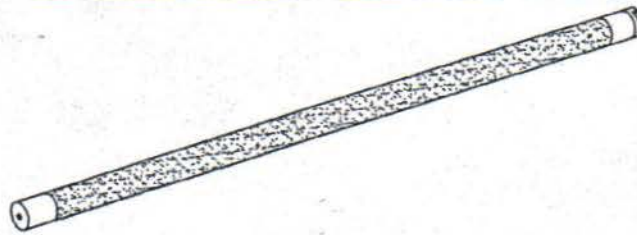
ZJ-933 Parts Diagram

序 號 Ref.No.	物料編號 Part.No.	名 稱 Description	單位用量 Amt.Req.
39	911B-H2	軸 Axle	1
40	911B-H1	短軸調整環 Short Axle Adjusting Ring	1
41	911B-P6	腳踏開關組 Pedal Switch	1
42	933-J1	馬達 Motor	1
43	933-J2	齒輪箱 Gear Box	1
44	911B-K3	置布器 Fabric Pressure Adjuster	1
45	參考P.11	滾布棒 Fabric Roller	1
46	911B-M2	鋁合金板 Aluminium Board	1
47	911B-M3	支撐檔片 Support Plate	1
48	911B-M4	翅膀 Fabric Adjuster's Rod Joint	2
49	911B-M5	整布器 Fabric Adjuster	1
50	933-M6	整布棒 Fabric Adjuster	1
51	VC2700E-UTE02	魚眼軸承 Fabric Roller's Bearing	1
52	911B-M8	連接片 Connector Piece	1
53	911B-M9	整布座支撐桿 Fabric Board Supporter Rod	1
54	911B-M10	調節片 Adjuster Piece	1
55	933-P4-1	腳架 P4-1 Stand	1
56	933-P4-2	腳架 P4-2 Stand	1
57	933-P5	腳架 P5 Stand	1
58	911B-P7	腳輪 Wheel	2
59	933-A6-2	皮帶 Timing Belt 6Y4x35	1
60	933-D-1	固定軸 Fix Axle	1
61	933-D	調節桿 Adjuster Shaft	1
62	911B-P11	腳墊螺絲 Staff Screw	1
63	E-7	E型墊片 E-Type Washer	5
64	SUN-05	彈簧 Spring	1
65	933-A-2	活動輪 Moving Bearing	1
66	933-A-1	固定輪 Fix Bearing	1
67	933-C	調節輪 Adjuster Bearing	1
68	933-D-3	連接桿 Connector Shaft	1
69	933-T	透明貼標 Clear Tape	1
70	933-AC	外殼 Crust	1
71	933-A9	電容器 Capacitor	1

●選購品--滾布棒

．Optional--Fabric Roller

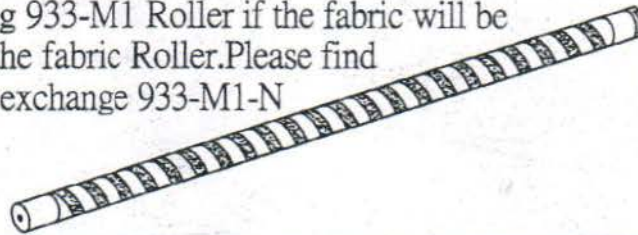
一、933-M1-N



二、933-M1

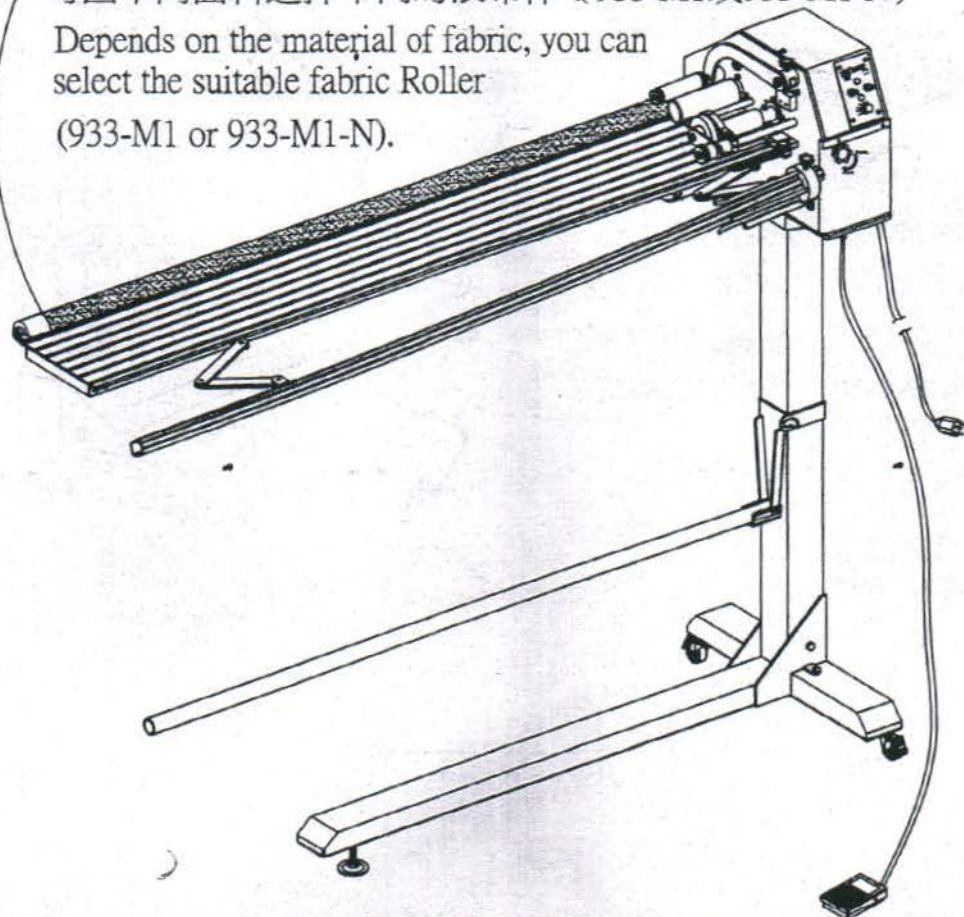
使用933-M1-N，遇到布料難捲入滾布棒時，可找當地經銷商更換使用933-M1

When you are using 933-M1 Roller if the fabric will be hard roll up with the fabric Roller. Please find our local agent to exchange 933-M1-N instead 933-M1.

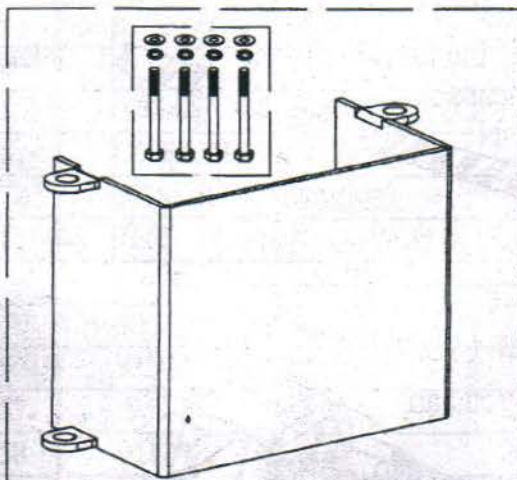


可因不同面料選擇不同的滾布棒（933-M1或933-M1-N）

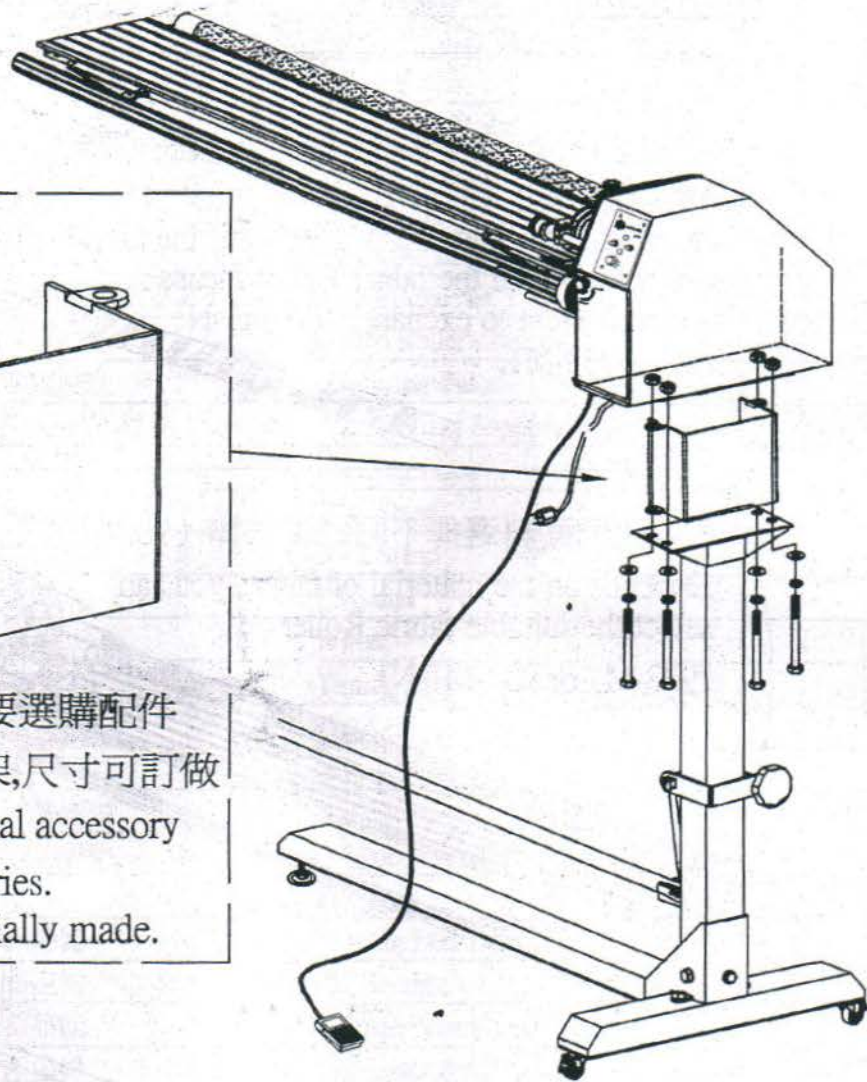
Depends on the material of fabric, you can select the suitable fabric Roller (933-M1 or 933-M1-N).



●選購品--增高架
Optional--Height Enhancer



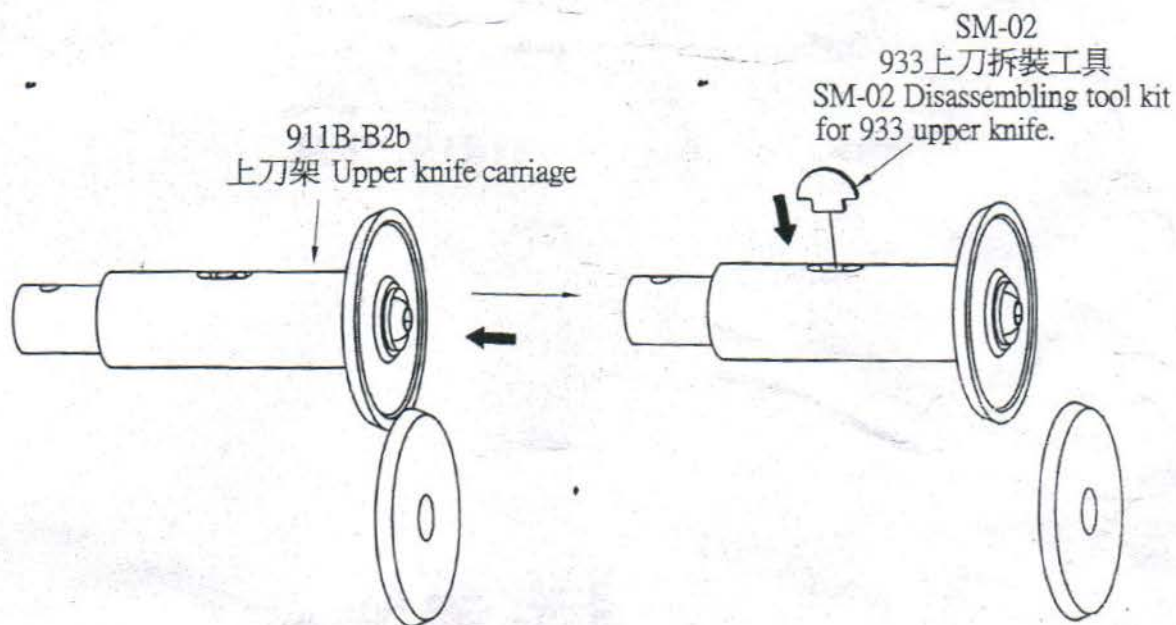
可根據您的需要選購配件
911B/933增高架,尺寸可訂做
This is an optional accessory
for 911B/933 series.
Size can be specially made.



● 附錄--933上刀拆裝工具的使用方法

Appendix--The way to disassemble the upper knife of 933

- 1、用手推動上刀架至最頂端，使上下兩塊刀片分離，將SM-02(933上刀拆裝工具)放入孔中卡緊
- 1、Push the upper knife carriage to the very bottom to separate upper & down knives. Insert the tool kit to the slot as shown in the map.



- 2、將十字起子套入孔中固定，再將六角扳手套入內六角螺絲，雙手用力即可鎖緊或放鬆螺絲(裝上或取下B1刀片)
- 2、Insert the screw driver into the hole to fix. Use Allen Key to tighten/loosen the hexagonal bolt. (For assembling/disassembling B1 knife set)

