



青工牌

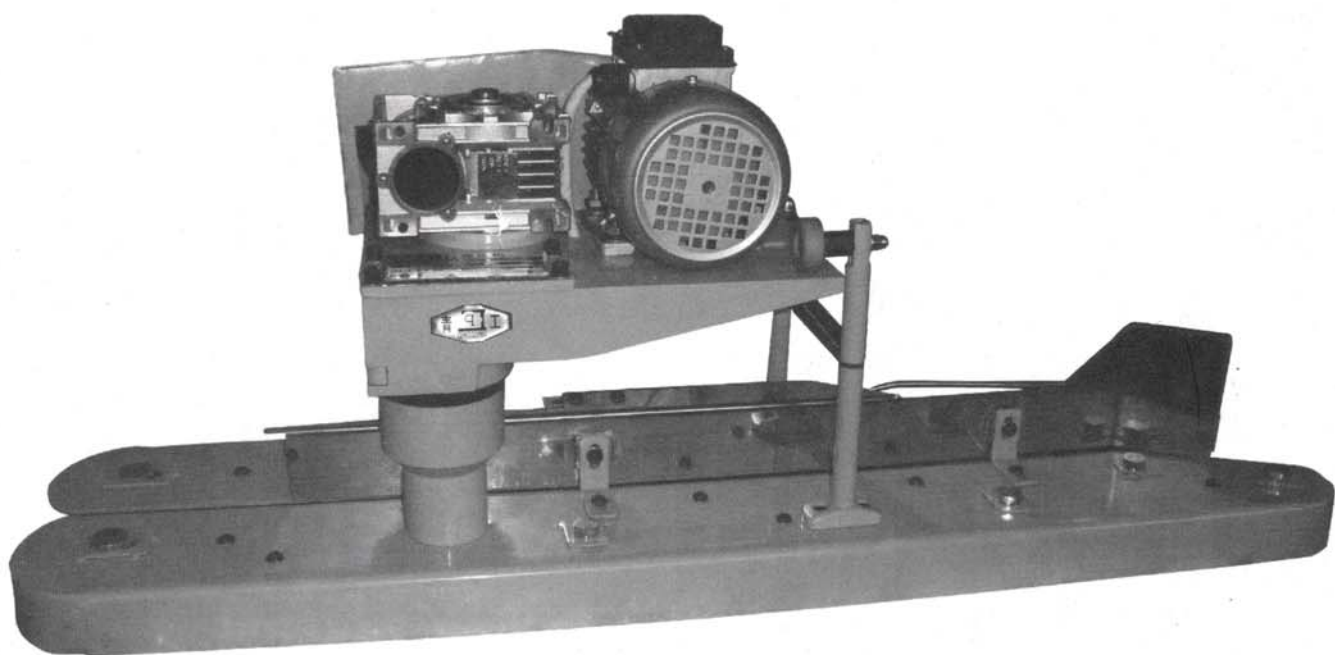
QingGong Brand

纸袋塑编袋卷边机使用说明书

Usage instruction of crimper for bags made in paper and plastic

QG6900型

QG6900 model



河北青工缝纫机有限公司

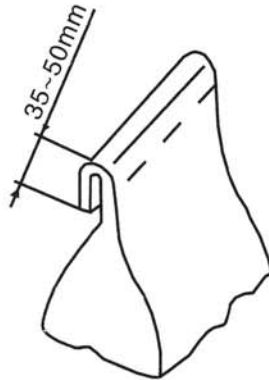
HeBei QingGong sewing machine Co.,Ltd

QG6900型

QG6900 model

塑料编织袋卷边机 Bag Feed-In Device

- 多项技术改进/ Multinomial Technical Improvement
- 调速范围大/ A Wide Range of Speed Adjustment
- 高品质卷边性能、机械性能/ Finest Quality in Folding and Operating
- 适用于塑料编织袋、纸袋的袋口卷边封包/ For Folding Bags Made of Plastic, Paper



主要技术参数 Technical Specifications

卷边宽度 (Folding Width)	35~50mm
送袋速度 (Feed-in Speed)	7~16m/min
电压/频率 (Voltage/Frequency)	380V/50HZ
功率 (Power)	180W
机器重量 (Weight)	48Kg
外形尺寸 (Overall Size) {长X宽X高} (LXWXH)	920x240x370mm

1. 概略说明

1. Introduction

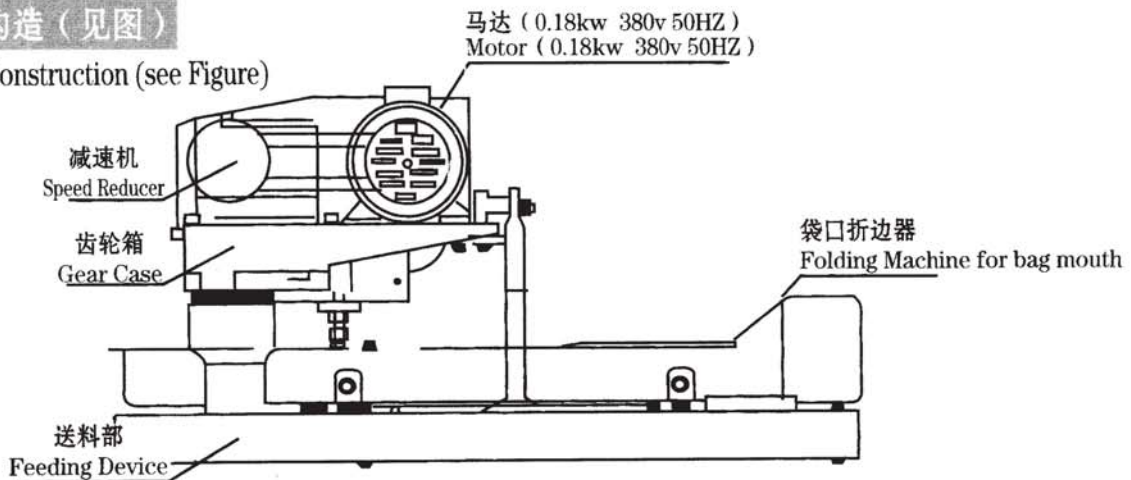
本设备是把编织袋的袋口折边，用缝纫机缝合的装置。经该机折边后封缝包装袋能极大的提高包装牢度，有效地防止散包、漏包现象。
This is a kind of device that can hem the bag mouth of woven bag, and stitched by sewing machine. Using the device, we can remarkably improve packaging fastness, effectively avoid bales off and leaking packages.

主要技术参数 Main Technical Parameter

折边宽度 Folding Width	35-50mm
送袋速度 Feed-in Speed	7-16m/min
电压/频率 Voltage/Frequency	380V/50HZ
功率 Power	180W
机器重量 Weight	48Kg
外形尺寸 (长X宽X高) Physical dimension (LxWxH)	920X240X370mm

2. 构造 (见图)

2. Construction (see Figure)



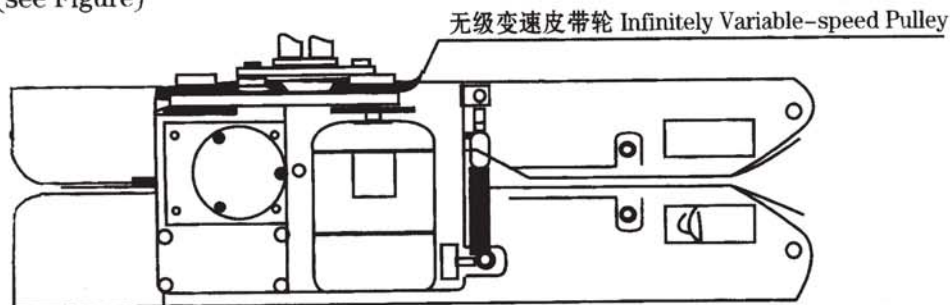
3. 各部的调整方法

3. Adjusting Method

(1) 送袋速度的调整

由专用马达和减速机的无级变速皮带轮开闭进行速度调整。如拧紧马达无级变速轮。同时松开减速机无级变速轮会使速度加快，反之，速度变慢。请调整到与承载袋的输送机的速度一致。请注意：若速度不一致，则袋会倾斜。(见图)

(1) adjusting method of Feed-in speed The speed can be adjusted by turning on/off the infinitely variable-speed pulley of the special Motor and Speed Reducer. For example, tightening the infinitely variable-speed pulley of Motor, and loosening the one of the Speed Reducer could make the speed faster, whereas, it would be lower. Please keep the speed consistent with the conveyer. Note, if the speed is not identical, the bag will slope. (see Figure)



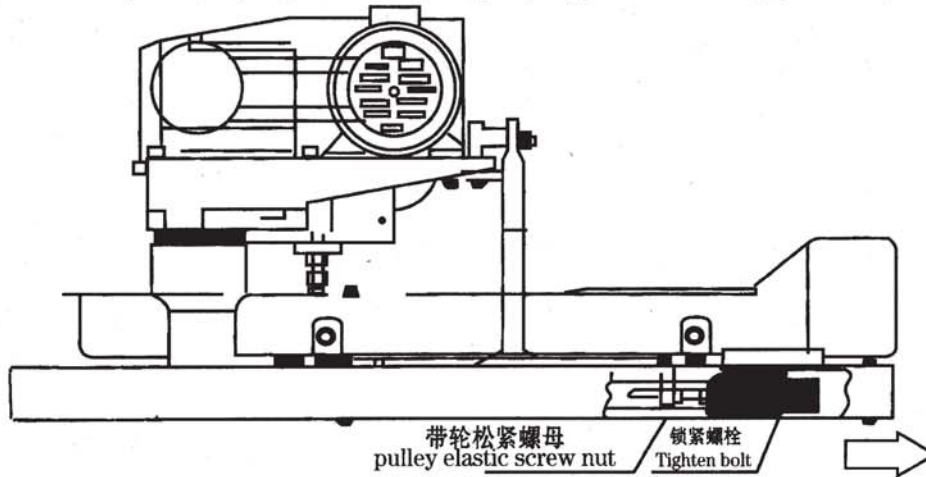
(2) 送袋链条的绷紧调整

(2) Conveyer Belt Adjustment

沿着长孔，把出口侧的皮带轮朝箭头(→)方向移动，请松开锁紧螺栓，调整带轮松紧螺母，使链条绷紧。不绷紧链条，会引起脱落，所以请注意。

(见图)

Along the long hole, move the pulley (portal side) towards the arrow direction. Please loosen the tightened belt, adjust the elasticity nut of pulley to tighten it. If not tightening the pulley, it would fall off. So pay attention. (See Figure)

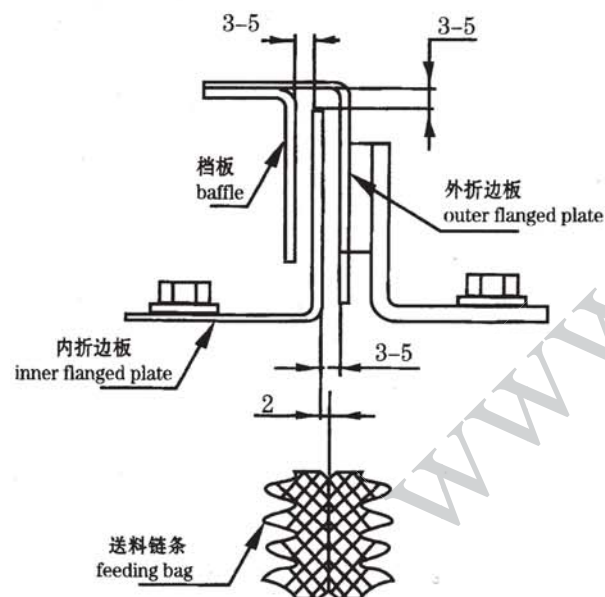


(3) 折边板的调整

(3) Flanged Plate Adjustment

折边板的调整因袋的厚度，所装货物的袋硬软而不同。为了让袋顺利通过，请调整好内折边板及外折边板之间的间隔。(见图)

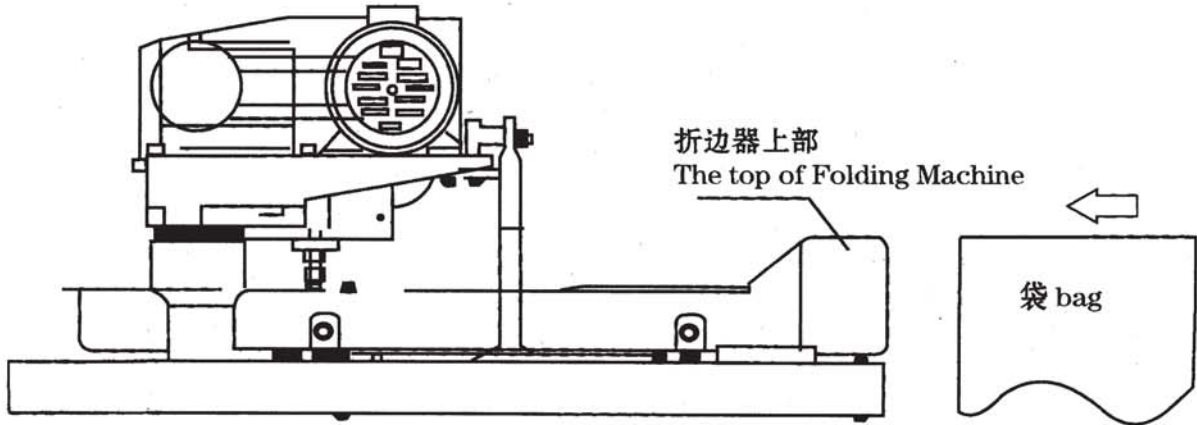
The adjustment method of flanged plate is various, depend on the bag thickness and loaded goods's bag rigidity. To insure the bag feeding well, adjust the distance between inner and outer flanged plate properly. (See Figure)



(4) 折边器与袋高度的调整

在折边器上部对齐袋品，水平送过去，约或折50mm（见图）

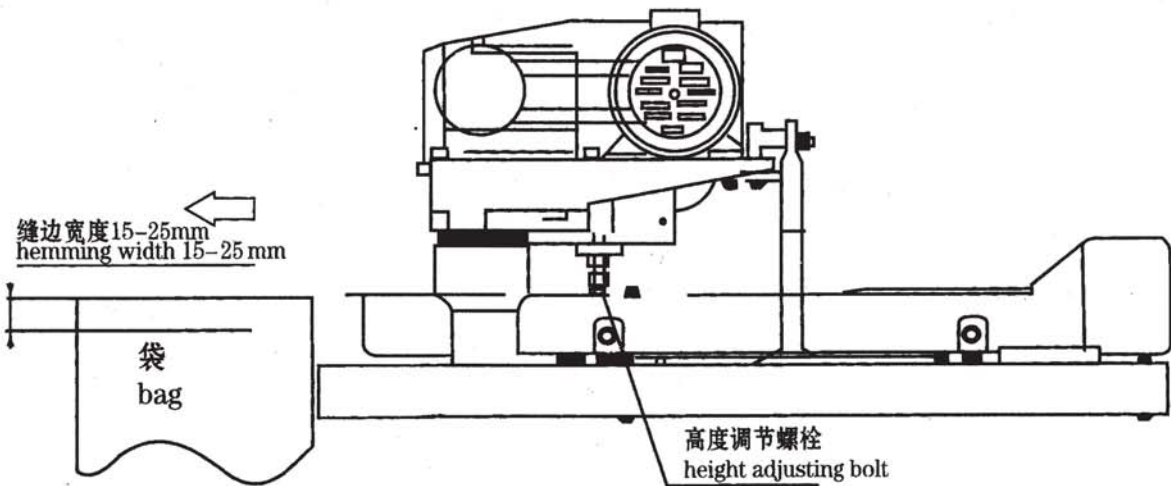
(4) Folding Machine and Bag Height Adjustment At the top of Folding Machine, keep the bag align, deliver it horizontally, and fold it about 50mm (see figure)



(5) 袋口缝边调整

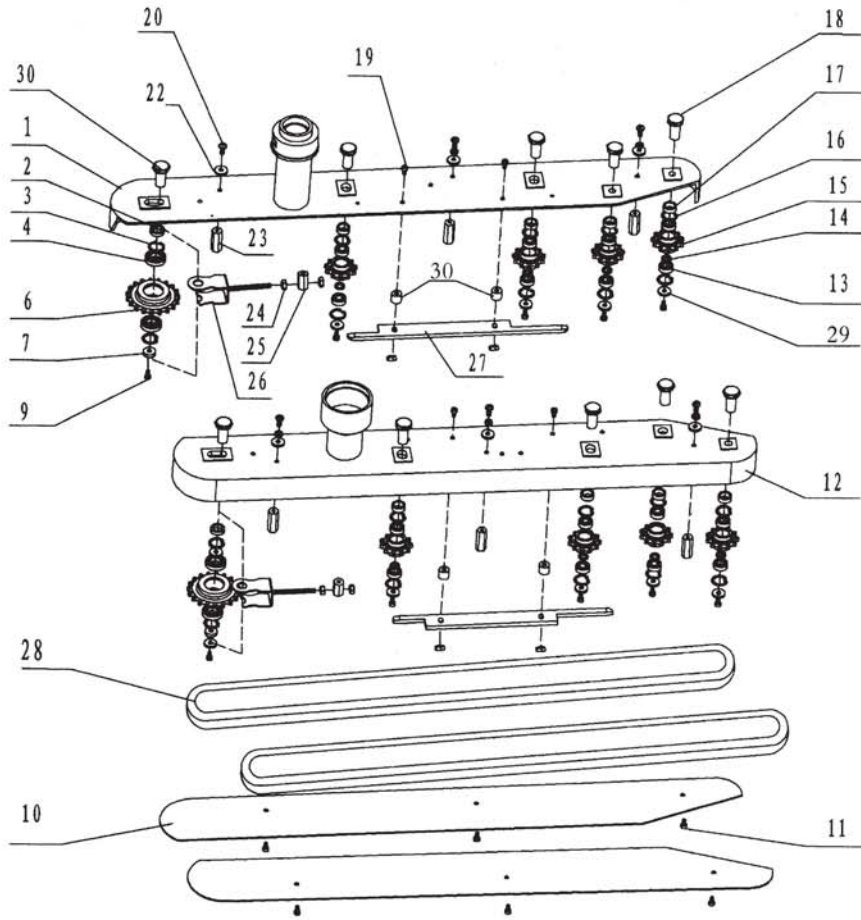
袋口缝边宽度的调整，请松开安装板螺栓，适当调整如图所指的高度调节螺栓，并锁紧螺母及安装板螺栓即可。（见图）

5) Bag Mouth Sewing Adjustment If you want adjust the bag mouth hemming width, release mounting plate bolt, appropriately adjust height adjusting bolt (as shown in the figure), and locking up the nut and mounting panel bolt.(see Figure)



另件明细表附图

See also list attached figure

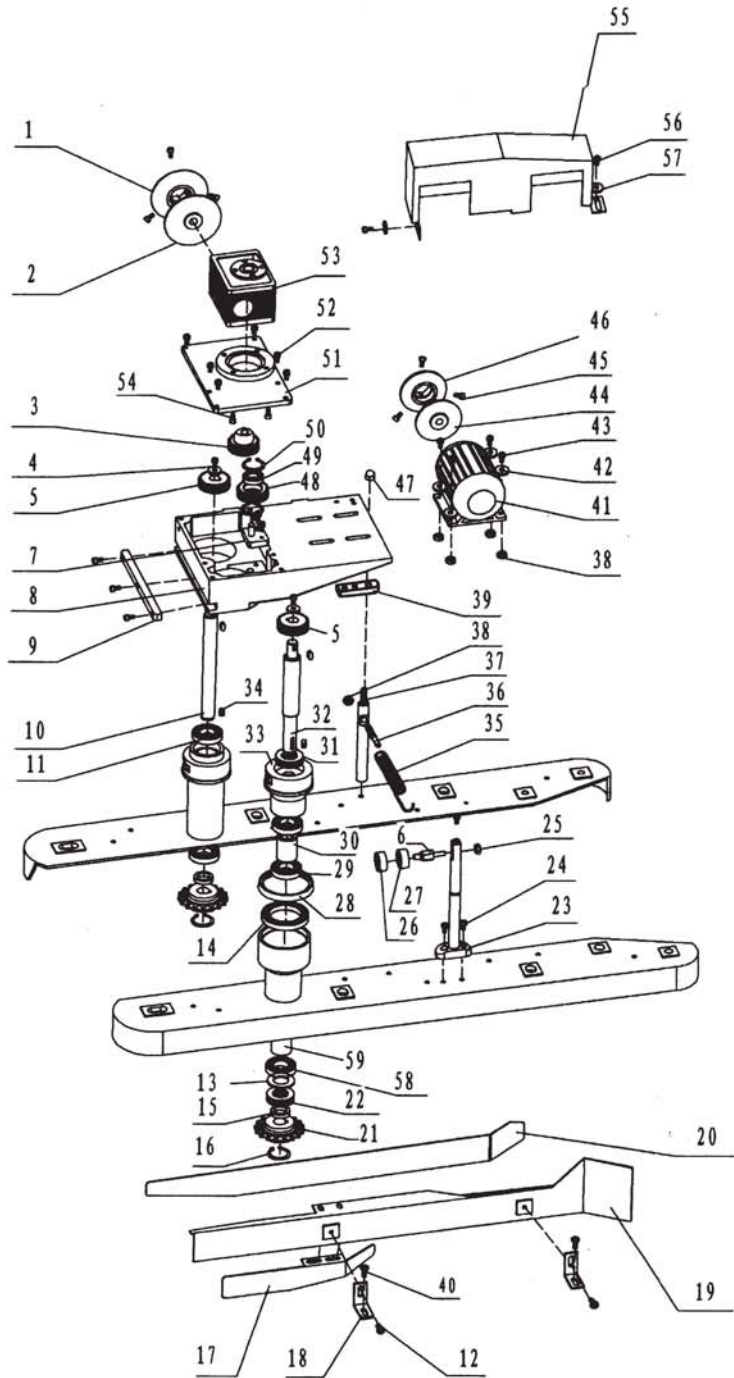


16		孔用挡圈22 GB893.1-86	16	32			
15	LT-05	小从动轮	8	31			
14	LT-06	轴承垫圈	8	30	LT-02	压紧板垫圈	8
13		球轴承629002	16	29	LT-08	小齿轮螺丝垫	8
12	JB-23L	活动盖板	1	28		专用链条	2
11		圆帽螺钉M6x10	6	27	LT-01/01B	大链条压紧/小链条压紧板	2/2
10	LT-03	盖板底盖	2	26	JB-44	松紧调节叉	2
9		螺丝M6x12	20	25	JB-43	松紧叉立柱	2
8				24		螺母M6	14
7	JB-46	大被动轮垫圈2	2	23	JB-32	底盖固定柱	6
6	LT-04	从动轮	2	22		平垫Φ6	6
5				21			
4		球轴承6002	4	20		圆帽螺钉M6x12	6
3		孔用挡圈32 GB893.1-86	4	19		圆帽螺钉M6x35	8
2	JB-45	大被动轮垫圈1	2	18	LT-07	小从动轮轴	8
1	JB-18L	固定盖板	1	17	LT-09	小齿轮垫圈	8
序号	图号	名称	数量	序号	图号	名称	数量

另件明细表附图

See also list attached figure

55	JB-35	防护罩	1
54		内六角螺钉M6x16	4
53		减速器	1
52		内六角螺钉M6x20	6
51	JB-03	下箱体上盖	1
50		轴用挡圈10	1
49		球轴承6200	1
48	JB-07	辅助齿轮	1
47		球帽螺母M8	1
46	JB-47A	电机皮带轮A	1
45		内六角螺钉M5x12	6
44	JB-48A	电机皮带轮B	1
43		六角螺钉M8x25	4
42		Φ8平垫	4
41		电机	1
40		圆帽螺钉M6x10	4
39	JB-09	下箱体固定板	1
38		M8螺母	5
37	JB-41	拉簧杆2	1
36	JB-40	拉簧调节螺丝	1
35	JB-39	拉簧	1
34		平键	4
33	JB-12	立轴套	1
32	JB-08	立轴1	1
31		推力球轴承51105	1
30	JB-50	立轴1套	1
29		球轴承6005	2
28	JB-13	油封	1
27		球轴承608	1
26	JB-38	滑动轴承套	1
25		M6螺母	1
24		内六角螺钉M6x15	2
23	JB-36	拉簧杆1	1
22		推力球轴承51104	1
21	LT-10	主动链轮	2
20	JB-19	送料挡板2	1
19	JB-21	送料挡板1	1
18	JB-22	送料挡板固定块	1
17	JB-20	小送料挡板	1
16		轴用挡圈20	2
15	JB-30	立轴2垫圈	1
14		滚珠轴承6811	1
13	JB-29	立轴1轴承盖	1
12		螺钉M6x5	2
11		球轴承6004	2
10	JB-06	立轴2	1
9	JB-42	下箱体固定块	1
8	JB-10	下箱体	1
7	JB-11	介轮架组件	1
6	JB-37	滑动轴承轴	1
5	JB-05	齿轮	2
4	JB-04	垫圈	2
3	JB-49	变速箱外齿轮	1
2	JB-48B	减速机皮带轮B	1
1	JB-47A	减速机皮带轮A	1
序号	图号	名称	数量



61							
60							
59	JB-14	立柱套内套	1				
58		球轴承6004	1				
57		平垫Φ6	2				
56		内六角螺钉M6x10	2				
序号	图号	名称	数量	序号	图号	名称	数量