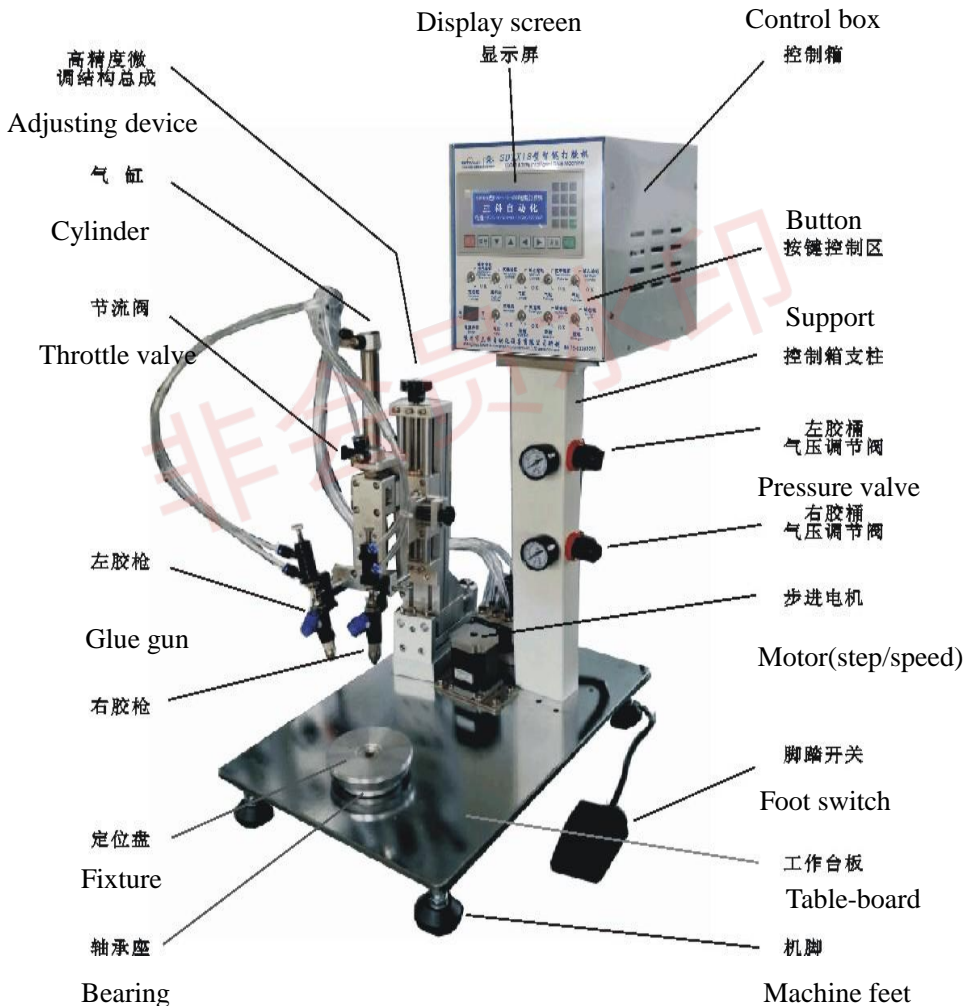


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1.2 结构说明(Structure description)

18型高精度智能打胶机结构图



控制器示意图 (Front and back)



1.3 型号及规格 (Mode and specification)

型号规格说明 Model and specification								
序号: (1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
NO:								
型号:(例) S	D	T	H	96型	220-1-2-400	220-1-2-400	220-1-2-400	打胶机
Code number								
说明: S厂标 D.打胶机 T.可接触控制 H.电子数控系统								
Explanation: Factory Standard								
A.自动绕线机 Automatic winding machine			K.接触器控制 Contacting control			X.特殊结构 Special structure		
B.喇叭标记打印机 Loudspeaker printer			J.继电器控制 Relay control			工作电压 working voltage		
C.充磁机 Magnetizing machine			Q.气缸控制 Air cylinder					
D.打胶机 Gluing machine			L.电磁控制 Electromagnetic control			工作点 working point		
E.冲铆机 Riveter								
F.打孔机 Hole-punching machine						设计时间 setting up time		
G.音频扫描信号发生器 Signal sounding machine								
I.螺焊机 SIHK220-1-330型螺焊机								
K.自动捞浆机(改装型)								
L.SLHK208型220-1-150电机定转子喷漆机								
M.吸尘器、吹尘器								
N.点焊机								
O.轮胎打胶机								

1.4 技术参数 (Technical parameters) :

1. 名称 SDTX18 型高精度智能打胶机
TYPE: SDTX18
2. 型号 220-1-3-400 (视具体机型而定, 详见规格型号说明)
MODEL: 220-1-3-400 (depend on the context)
3. 电源 AC220V
POWER: AC220V
4. 空气压力 0.4-0.8MPa/cm
AIR PRESSURE: 0.4-0.8MPa/cm
5. 气动元件 亚德客/SNS (可选配)
AIR-DRIVING COMPONENT: AiaTAC/SNS (Optional)
6. 控制器 OP320-BC
CONTROLLER OP320-BC
7. 外型尺寸 350*560*780mm
*SIZE 350*560*780mm*
8. 毛量 50Kg
WEIGHT 50Kg
9. 适用胶水 开姆洛克、硅胶、黑胶、青红胶 AB 胶等
APPLICABLE GLUE Chemlok, Silicon Sealant, black glue, AB glue
10. 胶枪数量 1-3 把 (可选)
GLUE GUN 1~3(Optional)

1.5 工作范围(Operating range)

本设备适用工件尺寸: $\leq \Phi 400\text{mm}$ 工件圆形涂胶 (可选配/定制其他尺寸规格) *Circle workpiece : $\leq \Phi 400\text{mm}$*

1.6 安全规定(Safety regulations)

1.6.1 使用前，检查机器的各部位紧固件。由于运输途中的震动，各连接部件的螺丝是否旋紧，线路是否脱落，各部位插件是否插紧，如有发现应及时加固修复。

Before use, check the fasteners of all parts of the machine. Due to the vibration during transportation, whether the screws of the connecting parts are tightened, whether the lines fall off, and whether the plug-ins of various parts are inserted tightly, if found, they should be reinforced and repaired in time.

1.6.2 本设备使用前必须可靠接地，请勿用手触摸电路板、注意安全用电。
The equipment must be reliably grounded before use. Do not touch the circuit board with your hands and pay attention to the safe use of electricity.

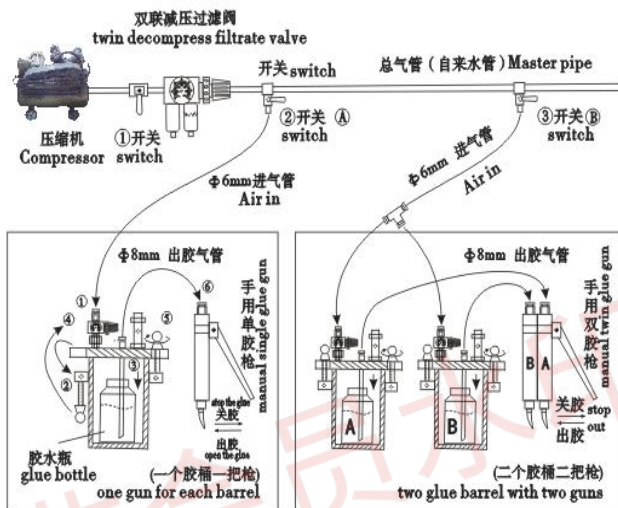
1.6.3 本机可安装在通风无污染，干燥的车间生产线上，或生产线旁的支架上。接好 0.4-0.8MPa/cm 气源的气管，然后插上 220V 电源。

The machine can be installed on the ventilation, pollution-free, dry workshop production line, or the support beside the production line. Connect the gas pipe of 0.4-0.8mpa/cm gas source, and then plug in the 220V power supply.

1.6.4 通电后，操作人员不能随便离开设备，用完后应断开电源。

After power on, the operator should not leave the equipment at will, and should disconnect the power supply after use.

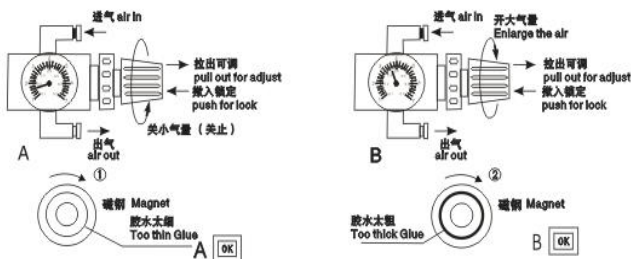
气路安装示意图-2 Air-flow sketch map-2



出胶量的气压调节 (供参考) Glue quantity control (Ref)

出胶量的多少, 可调节“减压阀”来完成, 气压调得越高, 出胶量越大如图中B-2。气压调得越低, 出胶量越小如图中A-1。

To adjust "Decompress valve" to control the Glue quantity "B-2" for more, A-1 for less.



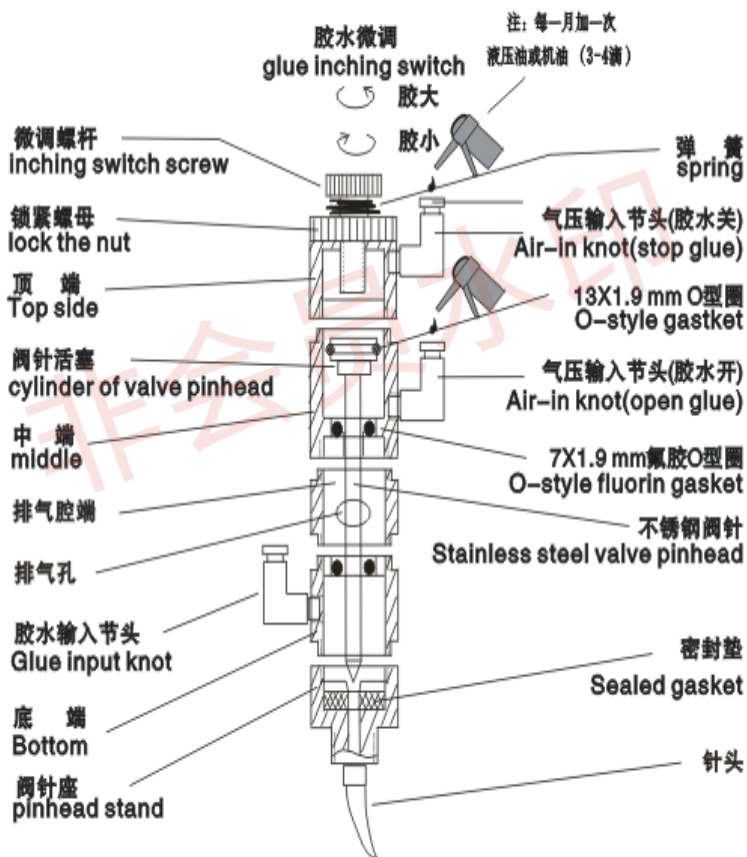
例0.2MPa/cm气压, 气压越低胶水量越少。
small Air-pressure few Glue

例0.4MPa/cm气压, 气压越高胶水量越多。
Bigger Air-pressure more Glue

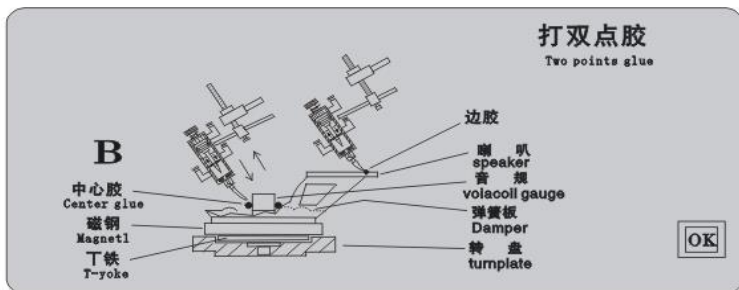
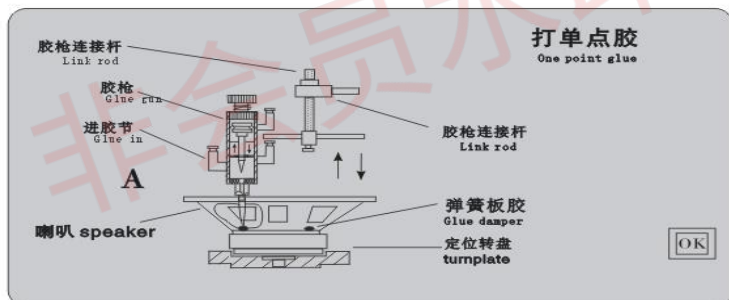
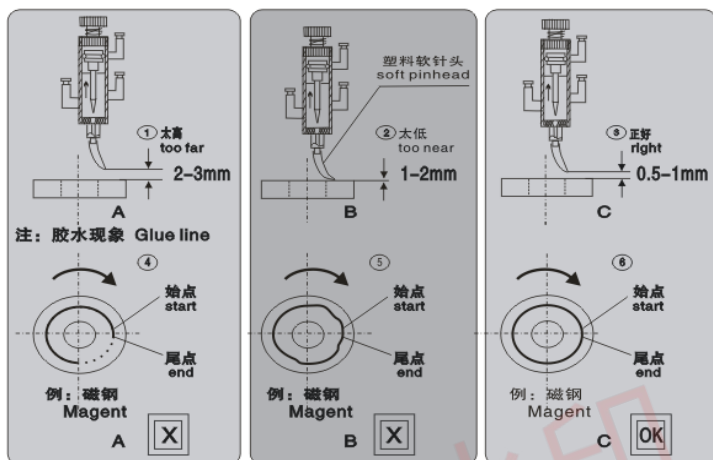
1.8 关于胶枪 (About the glue gun)

胶枪结构图

Configuration of Glue gun

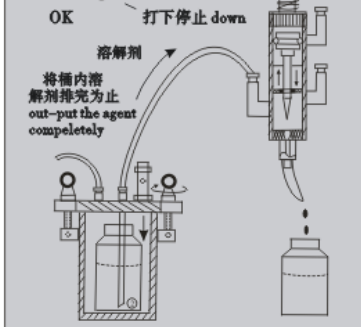
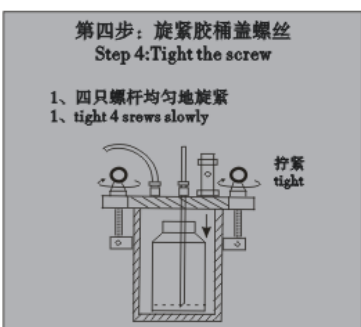
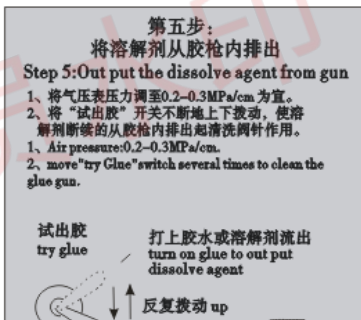
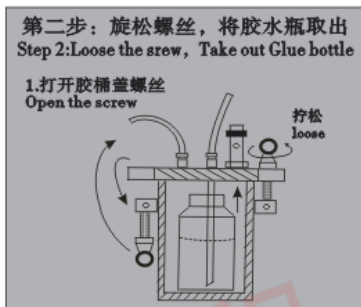
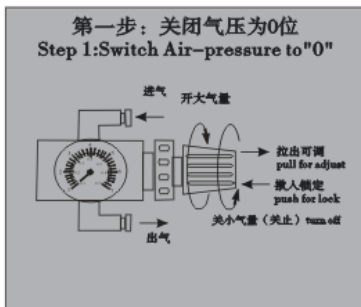


注：调试状况 Adjust conditon



胶枪清洗的方法 cleaning & protecting gluing gun

注：清洗时，按下列方法进行。
as following steps.



第二章 操作使用说明(Operating instructions)

2.1 简易操作流程(Simple operation process)

2.1.1 打开电源开关，上电后显示屏亮；

Turn on the power switch and the display will light up after power on

2.1.2 打开气源的进气阀门，打开的同时调节减压阀确认空气压力在正常范围内；

Open the air inlet valve of the air source, and adjust the pressure reducing valve at the same time to confirm that the air pressure is within the normal range

2.1.3 关机时，关闭电源、清洁胶枪、工作台面。

Turn off the power, clean the glue gun and the worktable

2.2 文本屏操作说明(About the plc)

2.2.1 控制箱面板钮子开关使用说明(About the buttons)：(图一 Pic-1) 钮子开关分三个档位操作，拨至上端档位（试***）实现单个功能的手动操作。拨至中间档位（停）单个功能输出关闭。拨至下端档位（OK）为正常运行状态（正常运行时所有钮子开关**必须拨至下端档位**）。

The button switch is operated in three gears, and the manual operation of single function is realized by shifting to the upper gear (Trial). Turn to the middle gear (stop) and the single function output is off. Set to the lower gear (OK) for normal operation (all button switches must be set to the lower gear during normal operation)



(图一 Pic-1)

2.2.2 开机画面：设备上电后自动切换到（图二）。

Power on screen: automatically switch to (Pic-2) after the device is powered on.



(图二 Pic-2)

2.2.3 系统监控页 1：显示开机画面 5 秒后自动切换到（图三）。

（图三）显示当前产量计数，显示当前使用文件。

按操作板“清零”按钮可归零当前产量计数。

按操作面板数字“1”按钮实现自动运行、功能同时指示灯亮。

按操作面板数字“2”实现电机正反转切换，反转时指示灯亮。

按操作面板数字“3”启动自动滴胶功能，（功能说明详见 P22），同时指示灯亮

System monitoring page 1: the boot screen is displayed and automatically switched to (Pic- 3) after 5 seconds.

(Pic- 3) shows the current production count and the current used files.

Press the "clear" button on the operation board to reset the current output count.

Press the number "1" button on the operation panel to realize automatic operation, and the function indicator lights up at the same time.

Press the number "2" on the operation panel to realize the forward and reverse switching of the motor, and the indicator light will be on when reversing.

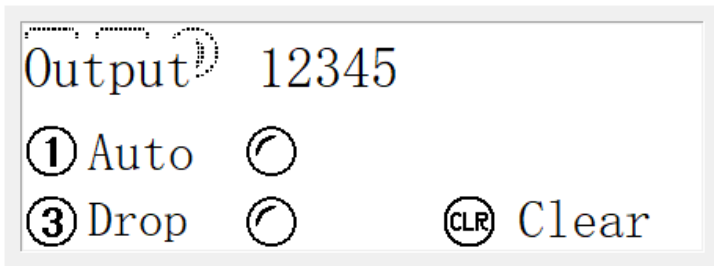
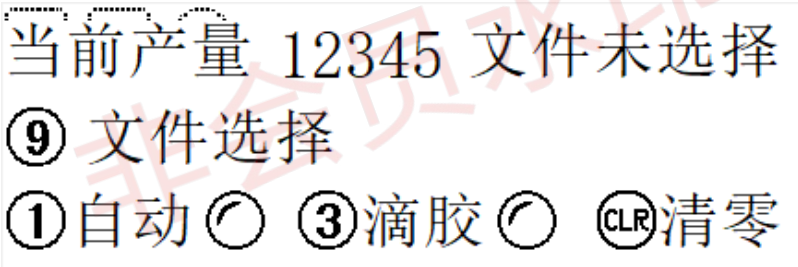
Press the number "3" on the operation panel to start the automatic glue dropping function (see P22 for function description), and the indicator light is on at the same time

*关于自动滴胶功能：

适用于 AB（青红胶）涂胶场合，通过设置自动滴胶功能，设备在不运作

的时候按一定间隔时间、自动滴出一定量的 AB 胶，将可能已经起化学反应将要固化的 AB 胶排出混合管，起到了自动防呆、有效防止 AB 胶堵塞的作用。

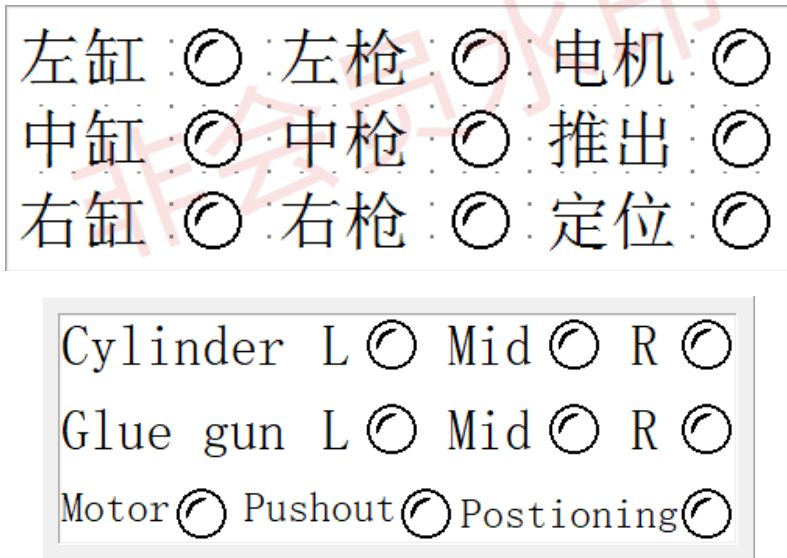
**About automatic glue dropping function:
It is suitable for ab (cyan red glue) gluing occasions. By setting the automatic glue dropping function, the equipment automatically drips a certain amount of AB glue at a certain interval when it is not in operation, and discharges the AB glue that may have had a chemical reaction and will be solidified out of the mixing pipe, which plays the role of automatic anti stupidity and effective prevention of AB glue blockage.*



(图三 Pic- 3)

2.2.4 系统监控页 2: 在当前画面（系统监控页 1）点动操作面板“√”键进入（图四）。该画面为状态显示画面，正常运行时设备在动作过程中该画面对应功能指示灯亮。在自动运行过程中也可以在该画面监控设备动作状态。

System monitoring page 2: in the current screen (system monitoring page 1), click the "√" key on the operation panel to enter (Pic-4). This screen is a status display screen. During normal operation, the corresponding function indicator of this screen is on. In the process of automatic operation, the action state of the equipment can also be monitored on this screen.



(图四 Pic- 4)

2.2.5 参数设置页 1: 在当前画面（系统监控页 2）点动操作面板“√”键

进入（图五）。点动操作板“设置”按钮，画面“左枪出胶”数值输入区光标常亮，此时可以在操作板数字键直接输入数值。也可以点动“ \wedge ”“ \vee ”增减数值，每次点动数值变化为 1。设置好“左枪出胶”后点动操作板“设置”按钮向下切换到“中枪出胶”数值输入区光标常亮，可以修改当前参数，修改完成后再按“设置”修改“右枪出胶”参数，当前画面参数设置完整后点动操作板“确认”键光标灭、当前画面参数设置完成。

Parameter setting page 1: click " \vee " key of operation panel in the current screen (system monitoring page 2) to enter (Fig. 5). Click the "setting" button of the operating board, and the cursor in the input area of "left gun glue out" will be on. At this time, the value can be directly input in the number key of the operating board. You can also click " \vee " to increase or decrease the value, and the value of each point motion can change to 1. After setting "left gun glue out", click "setting" button of the operation board to switch down to the "middle gun glue out" value input area, the cursor will always be on. You can modify the current parameters. After the modification is completed, press "setting" to modify the "right gun glue out" parameter. After the current screen parameter is set completely, click "confirm" key of the operation board to turn off the cursor and the current screen parameter setting is completed.

左枪出胶：指左枪开始出胶到停止出胶所用的时间。

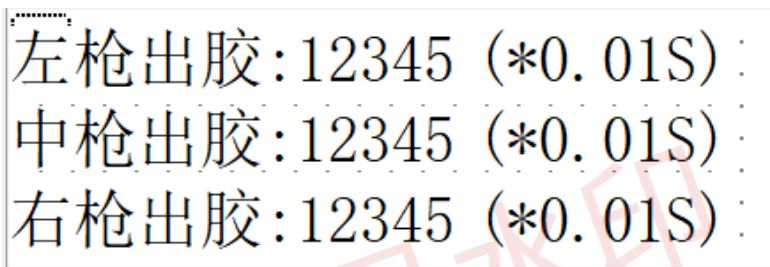
Left gun glue out: refers to the time from the beginning of glue out to the stop of glue out.

中枪出胶：指中枪开始出胶到停止出胶所用的时间。

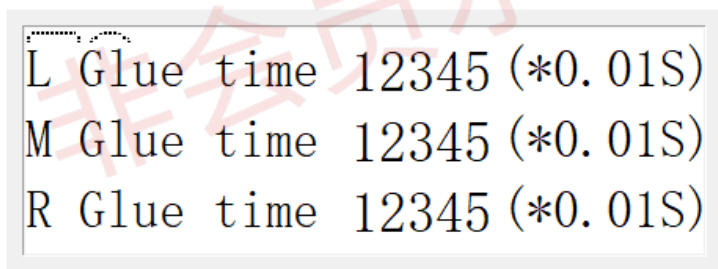
Shot out glue: refers to the time from the start of shot out glue to the stop of shot out glue.

右枪出胶：指右枪开始出胶到停止出胶所用的时间。

Glue out of right gun: refers to the time from the beginning of glue out to the stop of glue out of right gun.



```
左枪出胶:12345 (*0.01S):  
中枪出胶:12345 (*0.01S):  
右枪出胶:12345 (*0.01S):
```



```
L Glue time 12345 (*0.01S)  
M Glue time 12345 (*0.01S)  
R Glue time 12345 (*0.01S)
```

(图五 Pic-5)

2.2.6 参数设置页 2：在当前画面（参数设置页 1）点动操作面板“√”键进入（图六）。该画面为参数设置画面，设置方式与（参数设置页 1）画面相同。

Parameter setting page 2: in the current screen (parameter setting page 1), click the “√” key on the operation panel to enter (Fig.

6). This screen is a parameter setting screen, and the setting mode is the same as that of (parameter setting page 1).

胶枪前延：指胶枪延迟出胶的时间，设备启动后开始计时到达设定时间后胶枪开始出胶。

Glue delay: refers to the delay time of glue gun. After the equipment is started, the time starts to count. After reaching the set time, the glue gun starts to discharge glue.

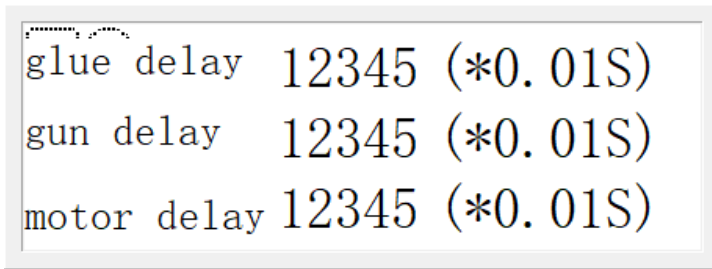
枪上后延：当左中右三胶枪到达设定时间停止出胶后，“枪上后延”开始计时到达设定时间胶枪上升。

Gun delay: when the left, middle and right three glue guns reach the set time and stop discharging glue, "gun up and down delay" starts to count, and the glue gun rises at the set time.

电机后延：当左中右三胶枪到达设定时间停止出胶后，“电机后延”开始计时到达设定时间电机停止转动。

Motor delay: when the left, middle and right three glue guns reach the set time and stop discharging glue, "motor delay" starts timing, and the motor stops rotating when it reaches the set time.

.....
胶枪前延:12345 (*0.01S):
枪上后延:12345 (*0.01S):
电机后延:12345 (*0.01S):



(图六 Pic-6)

2.2.7 参数设置页 3: 在当前画面 (参数设置页 2), 点动操作面板 “√” 键进入 (图七)。该画面为参数设置画面, 设置方式与 “参数设置页 1” 画面相同。

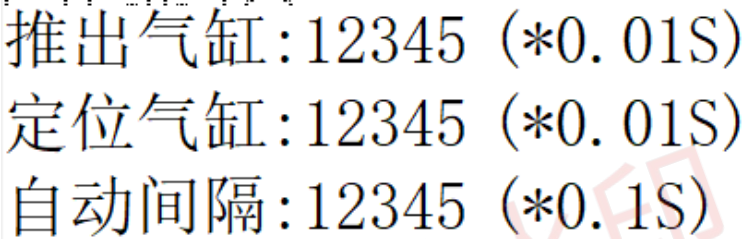
Parameter setting page 3: in the current screen (parameter setting page 2), click the “√” key on the operation panel to enter (Figure 7). This screen is a parameter setting screen, and the setting mode is the same as that of “parameter setting page 1”.

推出气缸 (适用机型: 双头四点向前/左推下): 当胶枪上升、电机停止转动后推出气缸动作, “推出气缸” 开始计时到达设定时间后推出气缸复位。

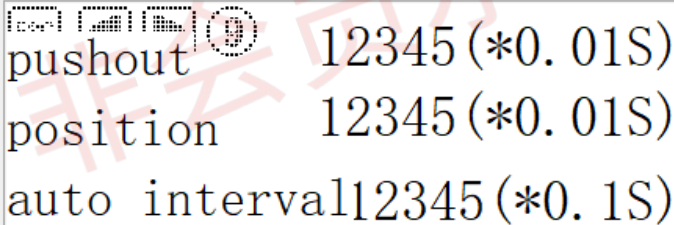
定位气缸 (适用机型: 双头四点向左推下): 当 “推出气缸” 到达设定时间后定位气缸缩回, “定位气缸” 开始计时到达设定时间后定位气缸伸出。

Push out the cylinder (applicable model: double head four point forward / left push down): when the glue gun rises and the motor stops rotating, push out the cylinder action, “push out the cylinder” starts to count, and when it reaches the set time, push out the cylinder to reset.

Positioning cylinder (applicable model: double head four point push down to the left): when the "push out cylinder" reaches the set time, the positioning cylinder retracts, the "positioning cylinder" starts timing, and the positioning cylinder extends after reaching the set time.



推出气缸:12345 (*0.01S)
定位气缸:12345 (*0.01S)
自动间隔:12345 (*0.1S)



pushout 12345 (*0.01S)
position 12345 (*0.01S)
auto interval 12345 (*0.1S)

(图七 Pic-7)

2.2.8 参数设置页 4: 在当前画面 (参数设置页 3), 点动操作面板 “V” 键进入 (图八)。该画面为参数设置画面, 设置方式与 “参数设置页 1” 画面相同。

Parameter setting page 4: in the current screen (parameter setting page 3), click the "V" key on the operation panel to enter (Figure

8). This screen is a parameter setting screen, and the setting mode is the same as that of "parameter setting page 1".

自动间隔：当“自动”功能启动完成一次打胶后，“自动间隔”开始计时到达设定时间后再次开始打胶，持续循环至关闭“自动”功能。

Automatic interval: when the "automatic" function is started and once glue is finished, the "automatic interval" starts to count and reaches the set time of the meter, and starts to glue again, and continues to cycle to turn off the "automatic" function.

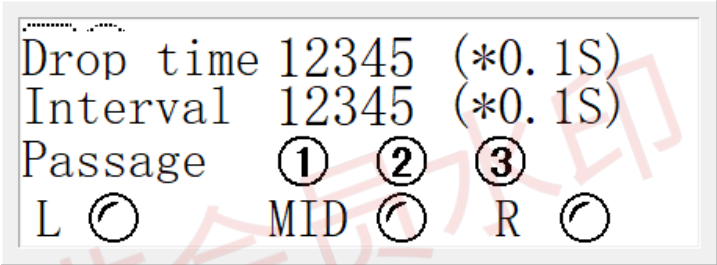
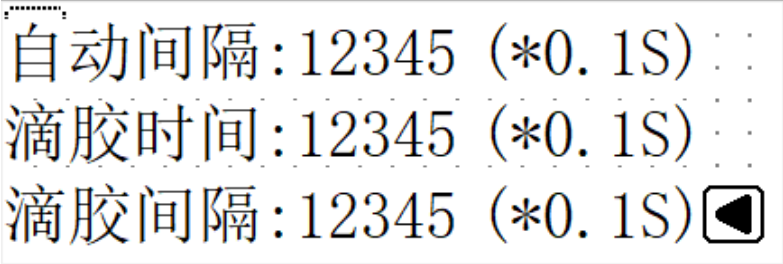
滴胶时间：（启动自动滴胶功能时有效）当“自动滴胶”功能启动后，达到滴胶间隔设备的时间后胶枪开始出胶，“滴胶时间”开始计时到达设定时间后停止出胶。

Glue dropping time: (effective when the automatic glue dropping function is started) when the "automatic glue dropping" function is started, the glue gun starts to discharge glue after reaching the time of glue dropping interval equipment, and the glue dropping time starts to count, and stops to discharge glue after reaching the set time.

滴胶间隔：（启动自动滴胶功能时有效）“自动滴胶”功能为启动状态下，两次自动滴胶动作之间的停顿时间及自动滴胶功能启动后到胶枪开始出胶间的停顿时间，持续循环至关闭“自动滴胶”功能。

Glue dropping interval: (effective when the automatic glue dropping function is started) "automatic glue dropping" function refers to the pause time between two automatic glue dropping actions and the pause time between the automatic glue dropping function and the glue gun when the automatic glue dropping function is started. It

continues to cycle until the "automatic glue dropping" function is turned off.



2.2.9 屏保画面：操作板 3 分钟无按键动作自动切换至屏保画面（图十二），在屏保换面按任意键切换至原先画面。

Screensaver screen: the operation panel automatically switches to the screensaver screen (Fig. 12) without any key action for 3 minutes. Press any key on the screen to switch to the original screen.

there is blockage caused by garbage and carbon in the front of the gun mouth. Make sure to use it in a clean state.

3. 1. 2 压力罐确认密封良好、气压没有超过规定的安全范围。

Confirm that the pressure tank is well sealed and the air pressure does not exceed the specified safety range

3. 1. 3 电源导线等连接部件，以及机器的紧固是否完好。

Whether the power wire and other connecting parts, as well as the fastening of the machine are in good condition

3.2 维护和保养 (Maintenance)

3. 2. 1 每日检查胶枪、压力表的状态，确认是否完好

Check the status of glue gun and pressure gauge every day to confirm whether they are in good condition

3. 2. 2 每月检查电磁阀

Check the solenoid valve every month

3. 2. 3 每月检查电线接头是否松脱或接触不良

Monthly check the wire connector for loose or poor contact

3. 2. 4 每半年清洁马达

Clean the motor every six months

3.3 润滑 (Lubrication)

运动部件需要定期加润滑油

The moving parts need to be lubricated regularly

第四章 机械故障对策 (Mechanical failure Countermeasures)

故障情况	原因	对策
整机不工作 <i>The whole machine does not work</i>	1、电源未接通或者接触不良； 2、熔断丝已烧断； 1. The power supply is not connected or the contact is poor; 2. The fuse is burnt out;	1、接通电源； 2、更换同规格的保险丝； 1. Turn on the power supply; 2. Replace the fuse of the same specification;
电机不动作 <i>Motor does not work</i>	1、电机皮带盘或者转盘卡死； 2、“试电机”钮子开关失灵或接插件导电不良； 3、微电脑故障 1. Motor pulley or turntable is stuck; 2. "Test motor" button switch failure or poor conductivity of connector; 3. control box fault	1、排除故障； 2、更换钮子开关，插紧接插件； 3、返厂维修； 1. Troubleshooting; 2. Replace the button switch and plug in the connector; 3. Return to factory for maintenance;

<p>胶枪阀针运动 失灵 (气缸上下失 灵)</p> <p><i>Movement failure of valve needle of glue gun of glue gun (cylinder up and down failure)</i></p>	<p>1、胶枪阀针受胶水固化难以运 动； 2、“试出胶”(“试上下”)钮子 开关失灵或接插件导电不良； 3、电磁阀失灵； 4、微电脑故障；</p> <p><i>1. The valve needle of glue gun is difficult to move due to glue solidification; 2. "Test out glue" ("test up and down") button switch failure or poor conductivity of connector; 3. Solenoid valve failure; 4. Microcomputer failure;</i></p>	<p>1、请洗胶枪阀针，再加 点机油； 2、更换钮子开关，插紧 接插件； 3、更换电磁阀； 4、返厂维修；</p> <p><i>1. Please wash the needle of glue gun and add some oil; 2. Replace the button switch and plug in the connector; 3. Replace the solenoid valve; 4. Return to factory for maintenance;</i></p>
<p>电磁阀出现滴 滴叫声</p> <p><i>There is a drip sound in the solenoid valve</i></p>	<p>1、电网电压过低； 2、电磁阀内占有染物质；</p> <p><i>1. The grid voltage is too low; 2. The electromagnetic valve contains pollutants;</i></p>	<p>1、待电压上升能自动 解除； 2、清洗电磁阀(擦干后 加上机油)；</p> <p><i>1. When the voltage rises, it can be released automatically; 2. Clean the solenoid valve (add oil after wiping dry);</i></p>
<p>电磁阀消声长</p>	<p>1、电磁阀内占有染物质；</p>	<p>清洗电磁阀，擦干后加点</p>