

Heavy Duty Table Stitching Machine

Operating Manual

Brief introduction:

This heavy duty stitching machine adopt hard alloy steel, high speed tool steel, alloy mould steel, alloy structure steel, etc.... Treated with heat processing technology, like vacuum quenching, etc...

I. Characteristics:

1. High stitching speed (288 times stitching per minute)
2. Don't damage the paper board
3. Rotary connecting bar equipped with pin bearing, don't need to add machine oil
4. All spare parts are durable
5. One stitching machine can stitch 5-ply, 7-ply, 9-ply and 12-ply heavy duty box
6. Bottom mould can adjust with three different position, easy for adjusting
7. Gap between stitching head and holding arm is big, easy to put the box into stitching position
8. Bevel gear can disassemble easily (can take the long shaft out from the back side of the machine)

II. Specification

Model	HTDX-1700	HTDX-2200
Arm length	1700mm	2200mm
Board thickness	12-20mm	12-20mm
Stitching method	Single nail	Single nail
Wire model	17# (high strength)	17# (high strength)
Working speed	280 times/min	280 times/min
Power	0.37KW	0.37KW
Machine weight	750KG	950KG
Dimension	2200x770x1500mm	2700x770x1500mm

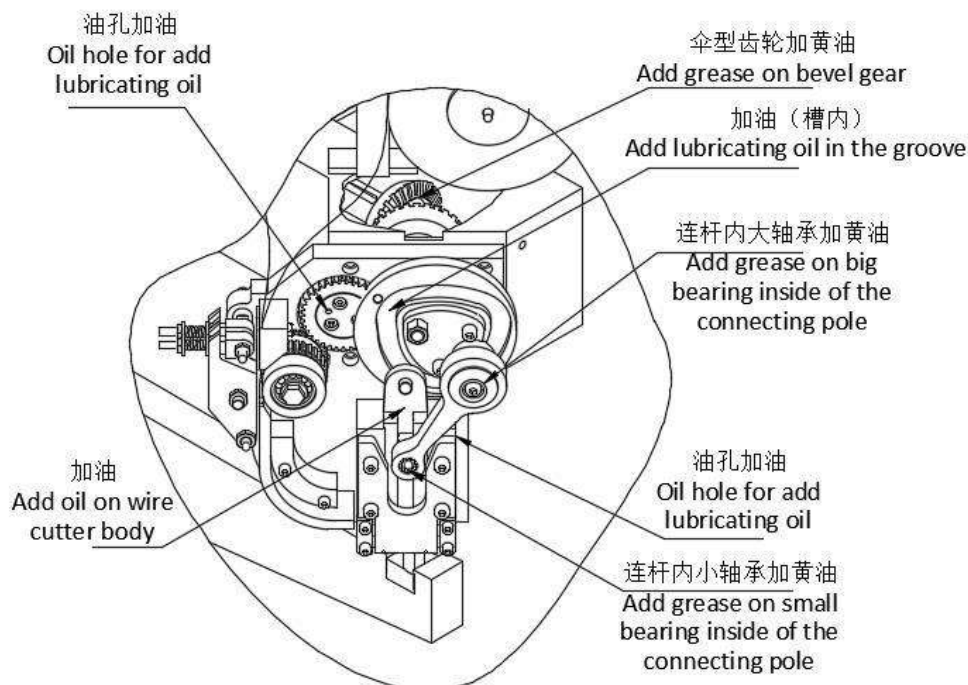
III. Installation and safety operating

1. Not allowed to use paper reel forklift to unload the stitching machine
2. Make sure bottom base is keep a good horizontal level
3. Make sure already connected the earth line before connect the power cable. Power must use the leakage protection device, to prevent operator getting electric shocking
4. Any tools or other thing is not allowed to put on the machine
5. Don't touch machine when machine is working. Must need to stop the machine when need to put the stitching wire.
6. When find broken nails or other thing left on bottom mould, need to stop the machine and clear it.

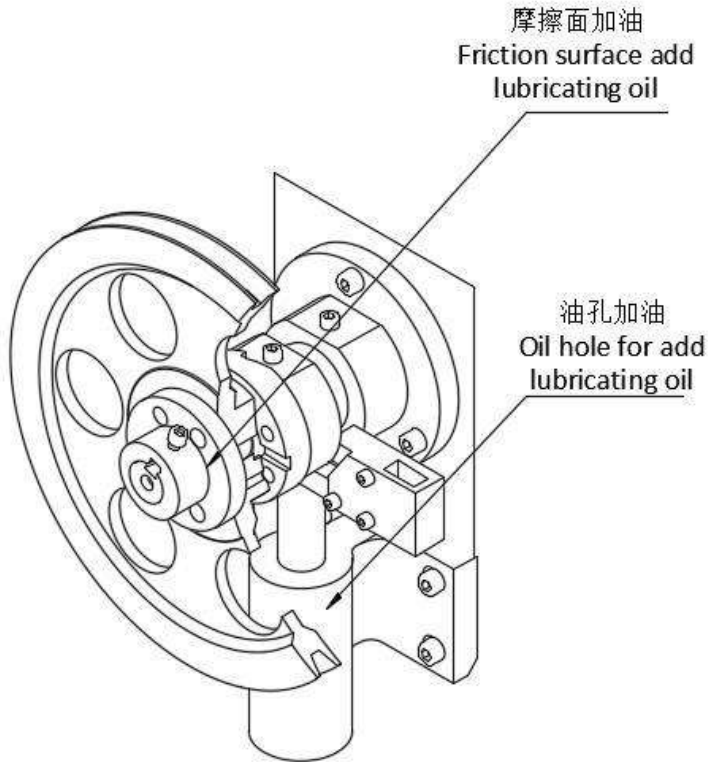
IV. Lubrication and maintenance

1. Must need to use 7# machine oil
2. Add lubricating oil once a day as per below Picture 1 and Picture 2
3. Connecting pole, Intermediate gear, wire pressing wheel all use needle bearing. Clean the three parts once every 6 months and add grease (Calcium base ester)

Picture 1:



Picture 2:



V. Regular problem and solution

1. Stitching head jammed or cannot stop well

If stitching head cannot stop well, it probably will be jammed soon.

Two status about stitching head not stop well

A. When stop, wire cutter cannot return to zero point, big wheel crush the clutch key;

B. When stop, wire cutter always keep a part out of wire cutter cover, reduce stitching speed;

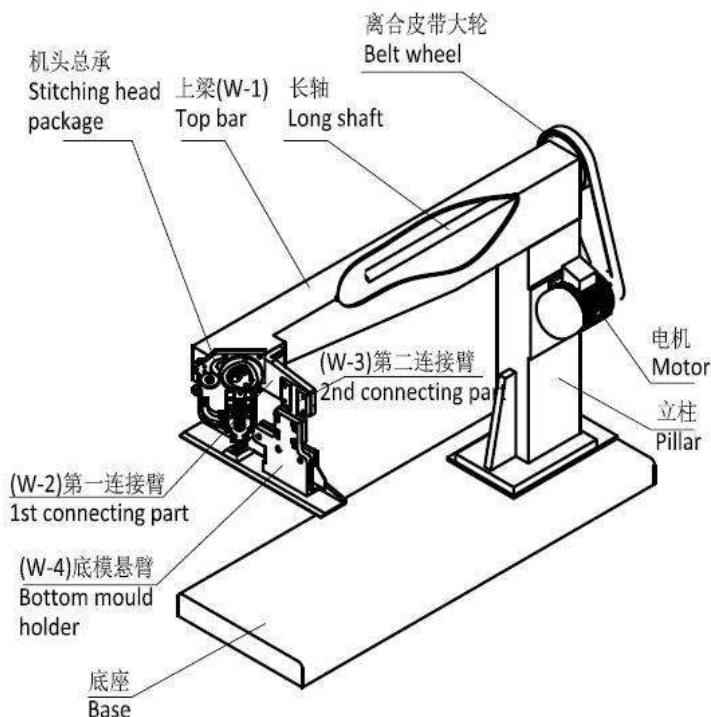
Above two status means stitching head not stop well. Reason: the sliding parts and clutch part are with dirt. Need to clean it and add lubricating oil.

2. No parts damaged, but cannot do good stitching or get broken nails. In such case, need to check the wire channel with dirt or not. Can clean the wire channel with kerosene or petrol. Please check below picture for reference:

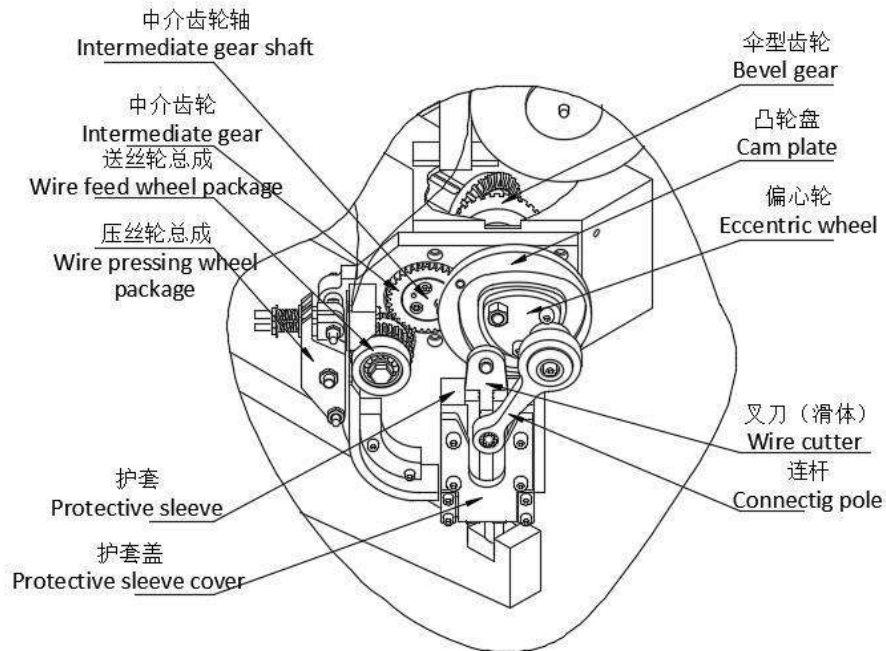
3. No any part damaged, but always get broken nails and all the broken nails size are similar. In such case, probably because there is some broken nails in the Wire Bending Channel of the Wire Bending Pole. Need to clean it.
4. No any part damaged, but always get long straight nail. In such case, there must be some dirt between Wire Bending Pole and its sleeve. Need to clean it with lubricating oil from the groove behind the stitching head.
5. Wire pressing wheel don't use too strong spring, otherwise may cause wire jammed.
6. If no any part damaged, customer should never disassemble the stitching head by themselves. If find broken nails, find nail cannot stitch the board completely, please first consider the wire spool jammed or not

VI. Stitching machine structure shown as Picture 3, stitching head structure shown as picture 4 and clutch structure and parts shown as picture 5.

Picture 3:



Picture 4:



Picture 5:

