

接入三根线

Connect three wires



加入液压油

加至图中所示70的位置左右即可

Add hydraulic oil until it reaches approximately 70 as shown in the image.

打开电源开关

Turn on the power switch





打开急停开关

Turn on the emergency stop switch



按下油泵启动看电机正转反转

Press the oil pump start button and observe the motor's forward and reverse rotation.



顺时针即为正转

逆时针为反转

假如是反转，需要关闭电源

将接入的三根线

调换其中任意两根的位置即可

Clockwise is forward rotation. Counterclockwise is reverse rotation. To rotate in reverse, turn off the power. Swap the positions of any two of the three wires.



按下油泵启动机器开始运行

Press the oil pump to start the machine and it will begin running.



在机器上放上要合缝的风管，  
注意风管要靠紧机器（如图所示）

Place the air duct that needs to be fitted onto the machine,  
ensuring the duct is flush against the machine (as shown in  
the picture).



系统页面切换至自动模式，  
按下“Run”键机器开始运行

The system page switches to automatic mode. Press the "Run" button to start the machine.



踩下脚踏开关,

机器自动夹紧风管后, 开始合缝工作

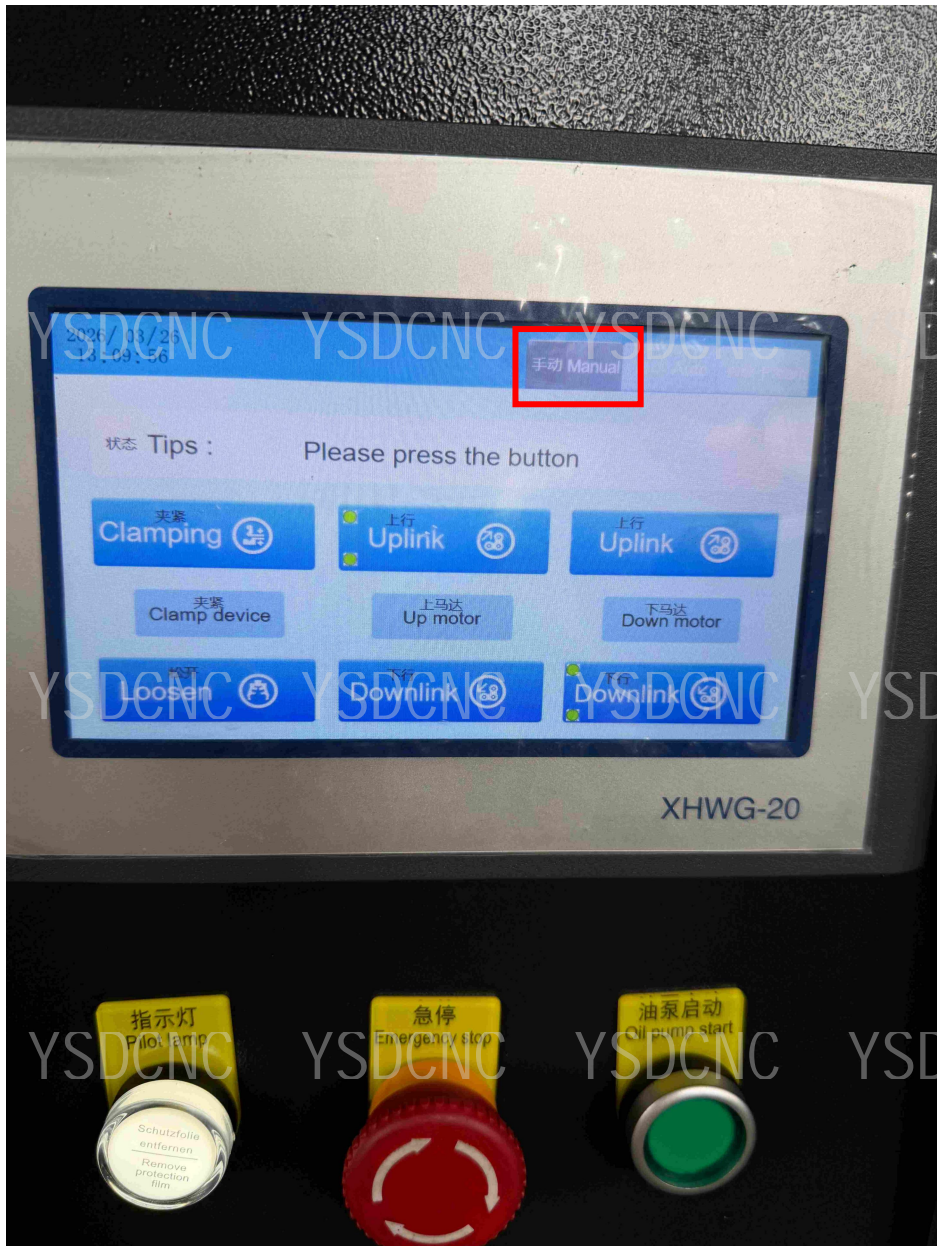
After pressing the foot switch, the machine automatically clamps the air duct and begins the sealing process.

# 售后之如何根据客户的 管道高度调节轮子

How to adjust the wheels according to  
the customer's pipe height in after-sales service



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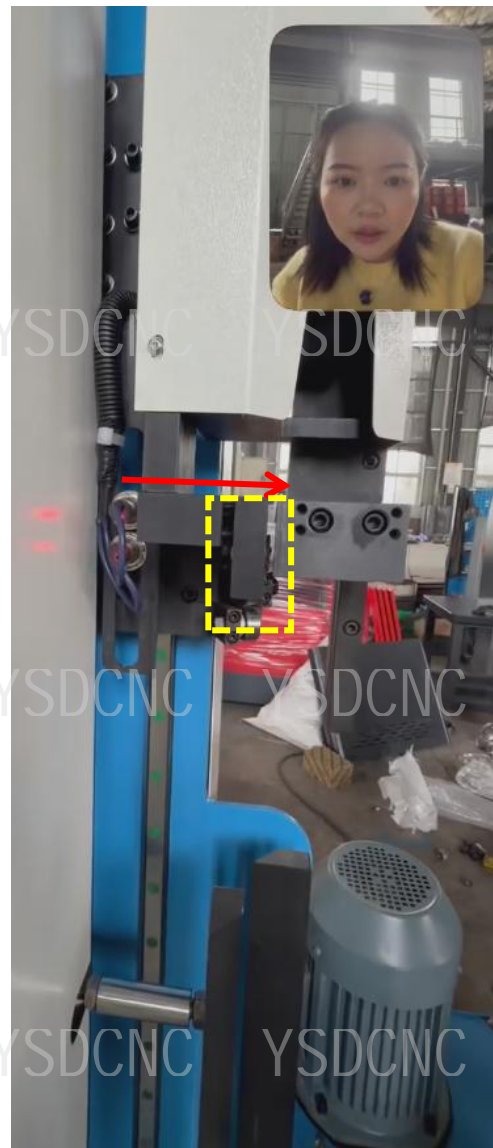


调节轮子时，系统页面切换至手动模式

(调整完成后才可以切换为自动模式)

When adjusting the wheels, the system interface switches to manual mode.

(You can switch back to automatic mode only after the adjustment is complete.)



## 调节轮子的高度和管子的高度匹配

根据要合缝的风管工件高度，  
转动手柄，控制夹紧工具的上下位置，  
使风管的最上方与“靠山”位置齐平  
(黄色圈内为“靠山”)

**Adjust the height of the wheels to  
match the height of the pipe.**

Based on the height of the ductwork to  
be joined,

rotate the handle to control the vertical  
position of the clamping tool,

so that the top of the duct is flush with  
the "backrest" position

(The yellow circle indicates the  
"backrest")



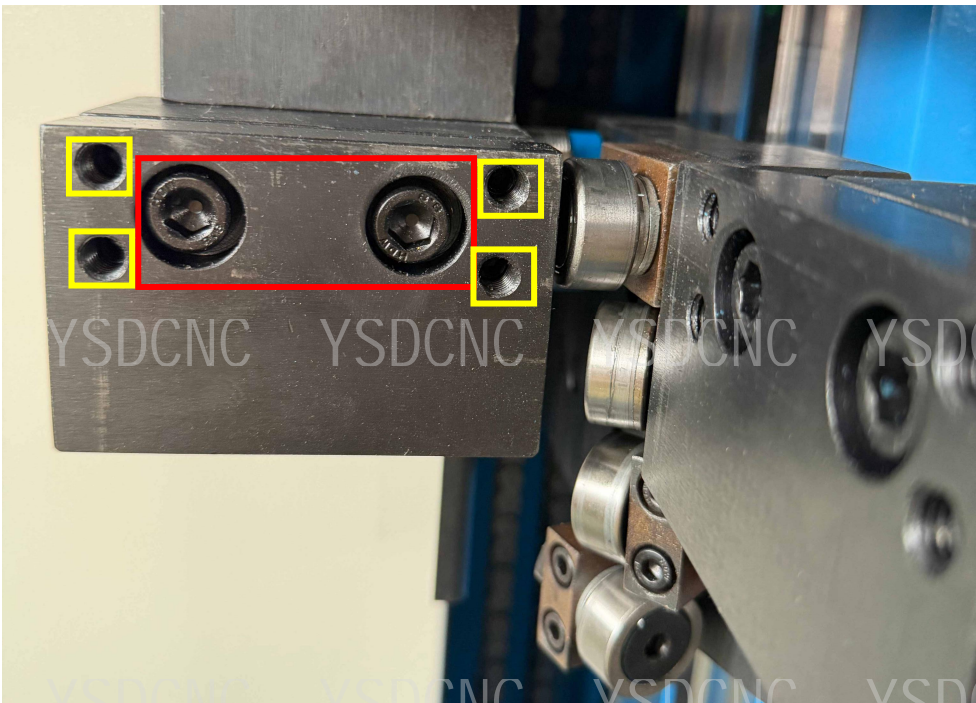
## 风管合缝出来有缝隙?

根据要合缝的风管工件高度,  
以及板材厚度来调节轮子的高低或前后,  
否则合缝出来的风管会有缝隙,  
(如图所示) 轮子和合缝的面有缝隙

## Gaps appear after ductwork joining?

Adjust the height or position of the wheels according to the height of the ductwork to be joined, and the thickness of the sheet metal.

Otherwise, gaps will appear after joining,  
(as shown in the picture) There is a gap between the wheels and the joining surface.



## “靠山”需要向后调整

- 1.先将图中红色方框里的两个大圈螺丝拧松
- 2.再将黄色方框里的四个定位螺丝各往左旋调整半圈
- 3.再拧紧红色方框里的大圈螺丝，这样整个“靠山”都往后调整完成了
- 4.图中机器上下两个位置的“靠山”都要调整

The "backrest" needs to be adjusted backward:

1. First, loosen the two large screws in the red box in the picture.
2. Then, turn each of the four positioning screws in the yellow box half a turn to the left.
3. Tighten the large screws in the red box. This completes the backward adjustment of the entire "backrest".
4. The "backrest" at both the top and bottom positions of the machine in the picture needs to be adjusted.



把成型轮子向下移动，方便调节限位开关

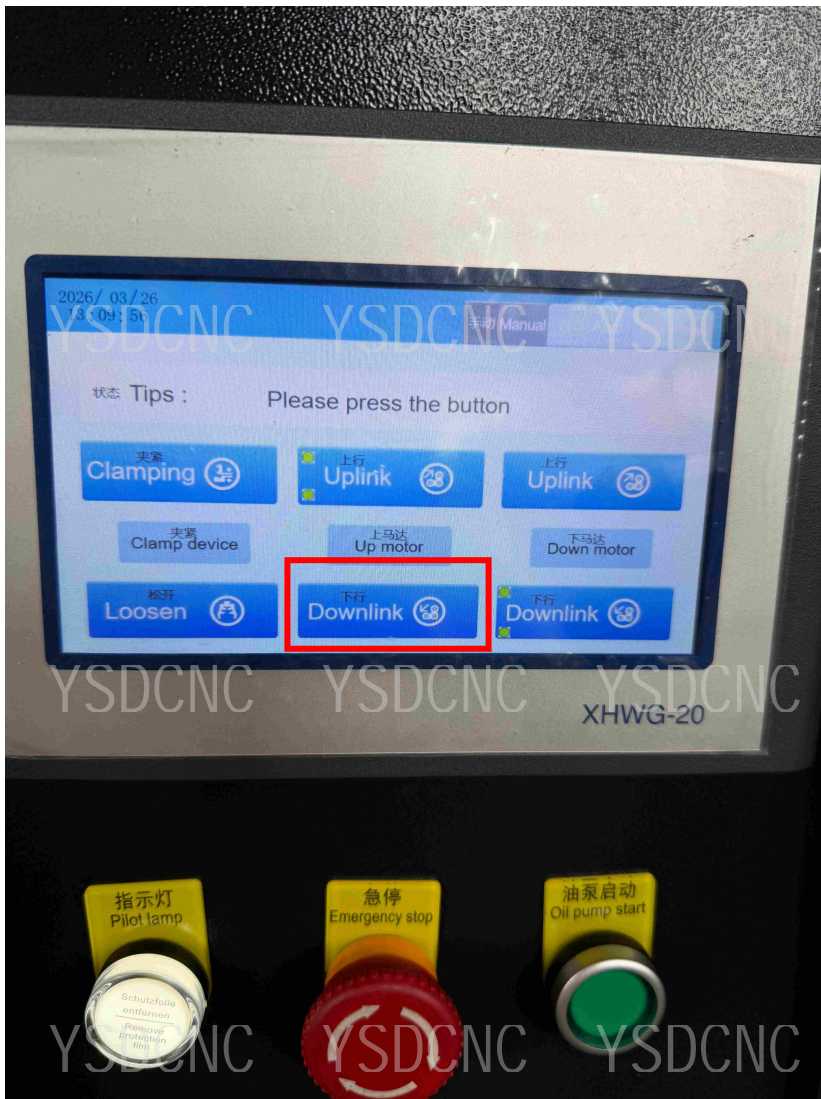
点击系统的下行键:Downlink，成型轮子向下移动

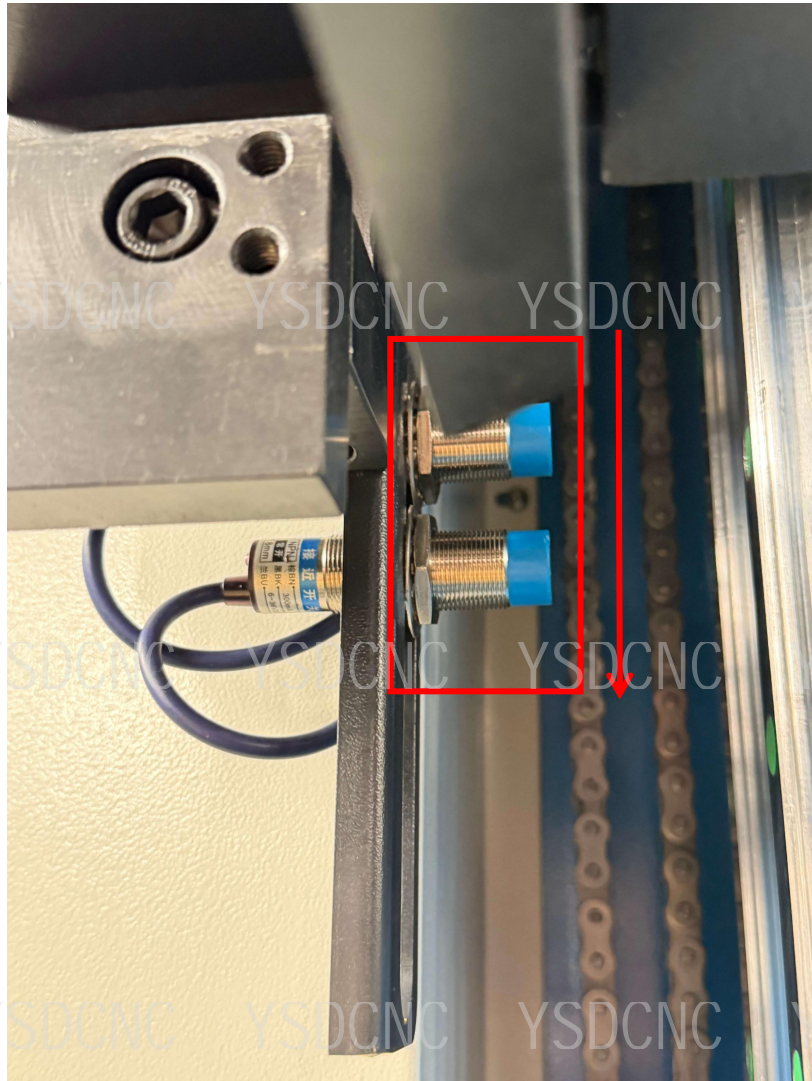
(如图所示)

Move the forming wheel downwards to facilitate adjusting the limit switch.

Click the system's down arrow key (Downlink) to move the forming wheel downwards.

(As shown in the image)





同时需要调整机器上方的限位开关和减速开关，  
要与“靠山”齐平，  
拧开开关的螺丝向下移动调整位置

At the same time, the limit switches and deceleration switches on top of the machine need to be adjusted.

They should be aligned with the "backrest".

Unscrew the switch screws and move them downwards to adjust their positions.



调整限位开关和减速开关，  
要与“靠山”齐平，  
左图为未调整时，  
右图调整完成，限位开关和“靠山”在同一水平线上

Adjust the limit switches and deceleration switches,  
to align them with the "backrest".  
The left image shows the switches before adjustment,  
the right image shows the adjusted switches and the "backrest" on the same horizontal line.



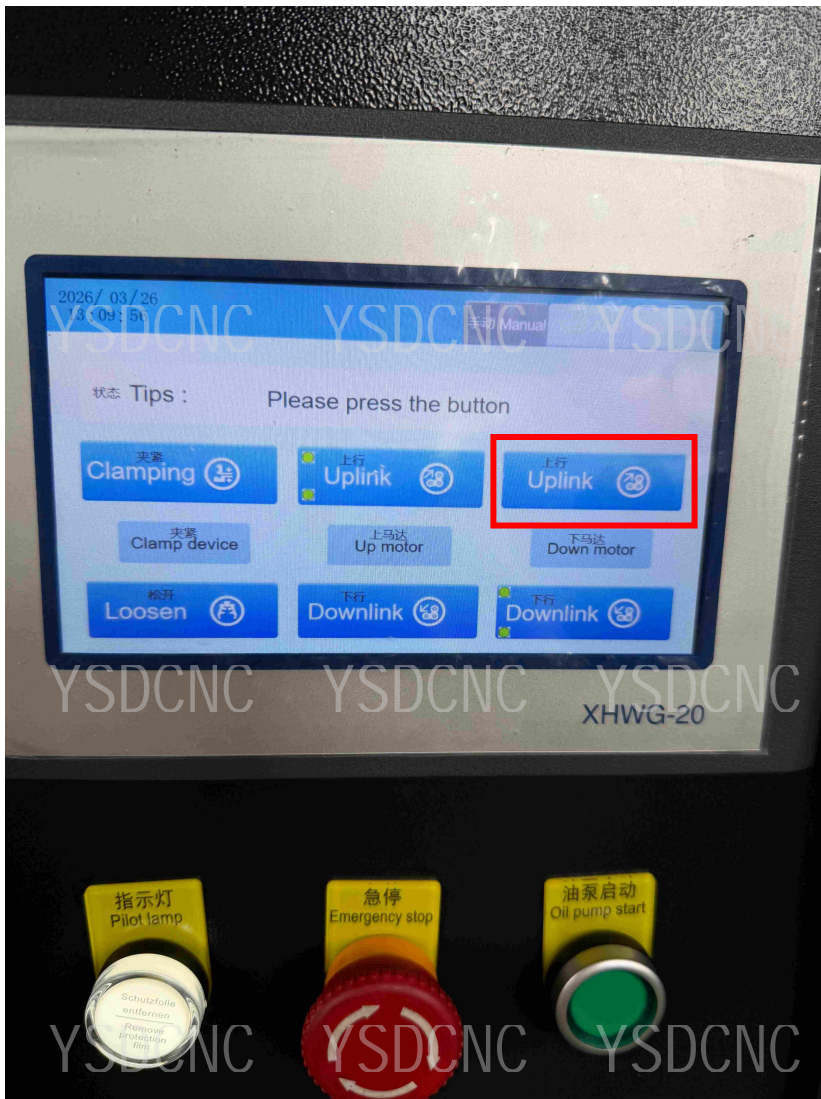
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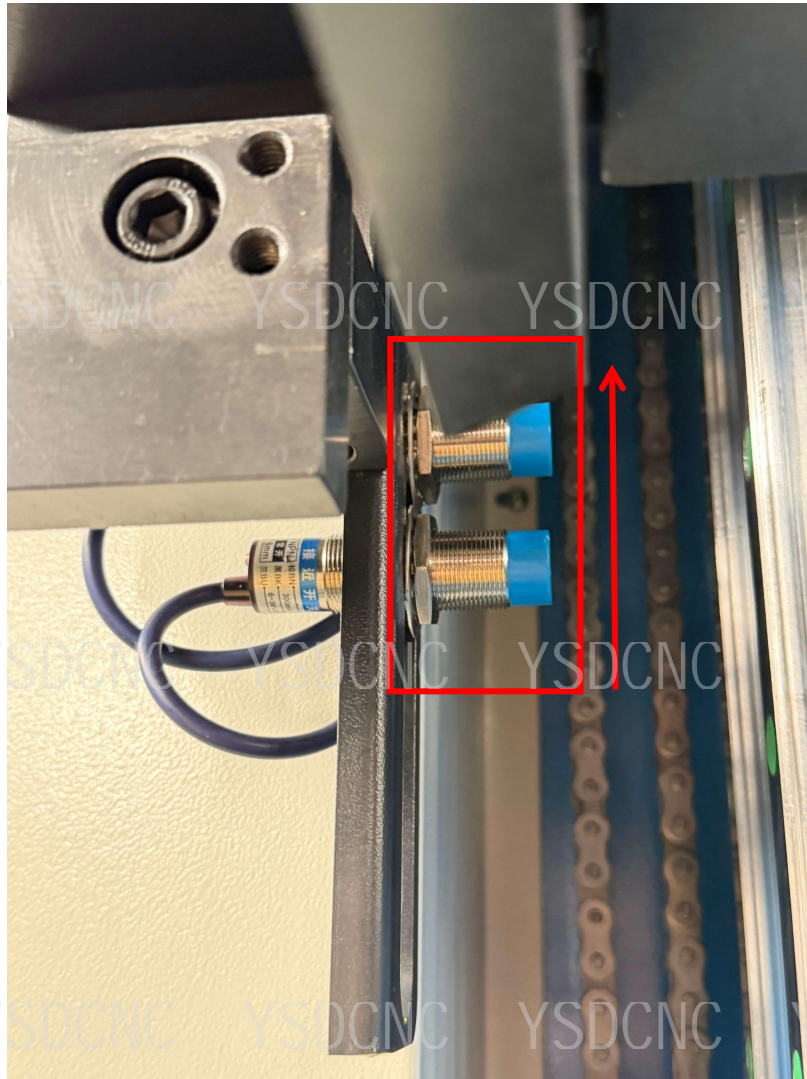
把成型轮子向上移动，方便调节限位开关  
点击系统的上行键:Uplink，成型轮子向上移动  
(如图所示)

Move the forming wheel upwards to facilitate adjusting the limit switch.

Click the system's Uplink button to move the forming wheel upwards.

(As shown in the picture)



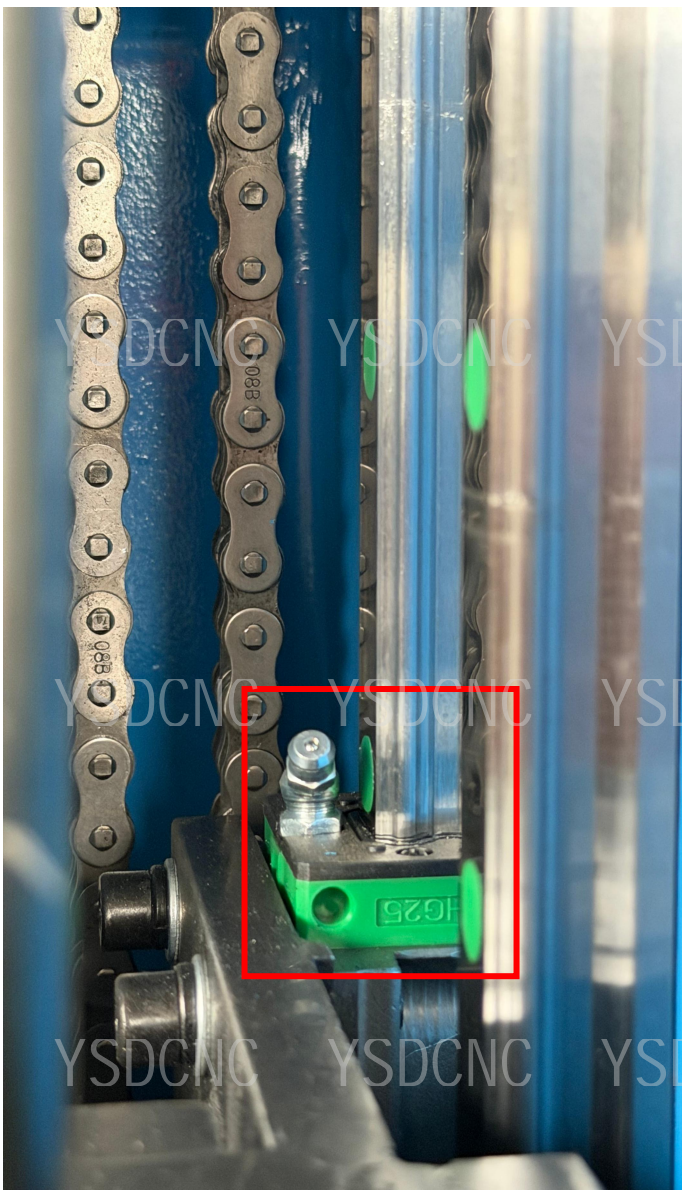


同时需要调整机器下方的限位开关和减速开关，  
要与“靠山”齐平，  
拧开开关的螺丝向上移动调整位置

At the same time, the limit switches and deceleration switches at the bottom of the machine need to be adjusted.

They should be aligned with the "backrest".

Unscrew the switch screws and move them upwards to adjust their positions.



左图中所圈出的绿色位置，在导轨上能看见的就定期加机油润滑防锈

右图所示为机器的导轨，两条都要定期完整的刷机油或者防锈油润滑防锈

The green circle in the left image indicates the visible sections of the guide rail; these require regular lubrication with machine oil for rust prevention.

The right image shows the machine's guide rails; both rails need regular and thorough application of machine oil or rust-preventive oil for lubrication and rust prevention.