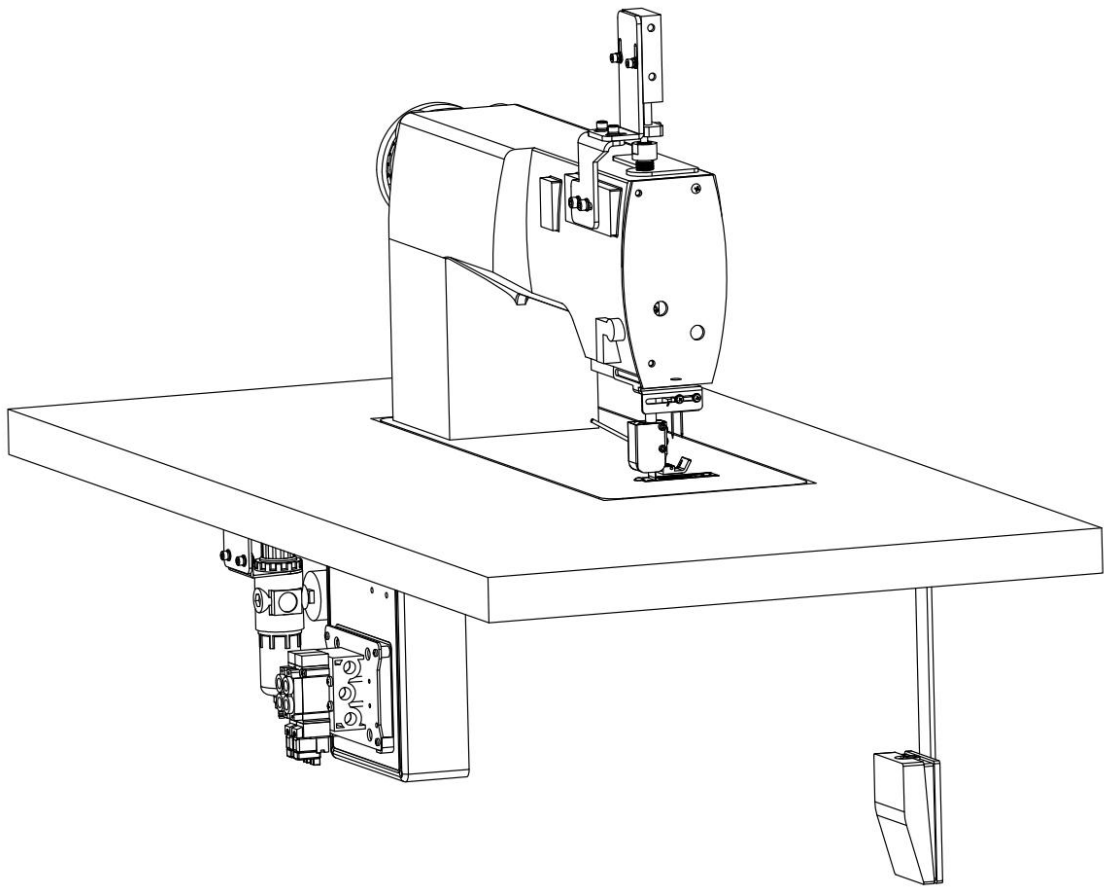


# SXSTAR<sup>®</sup>

## TC-8420/3528 双针车/人字车自动切刀装置说明书

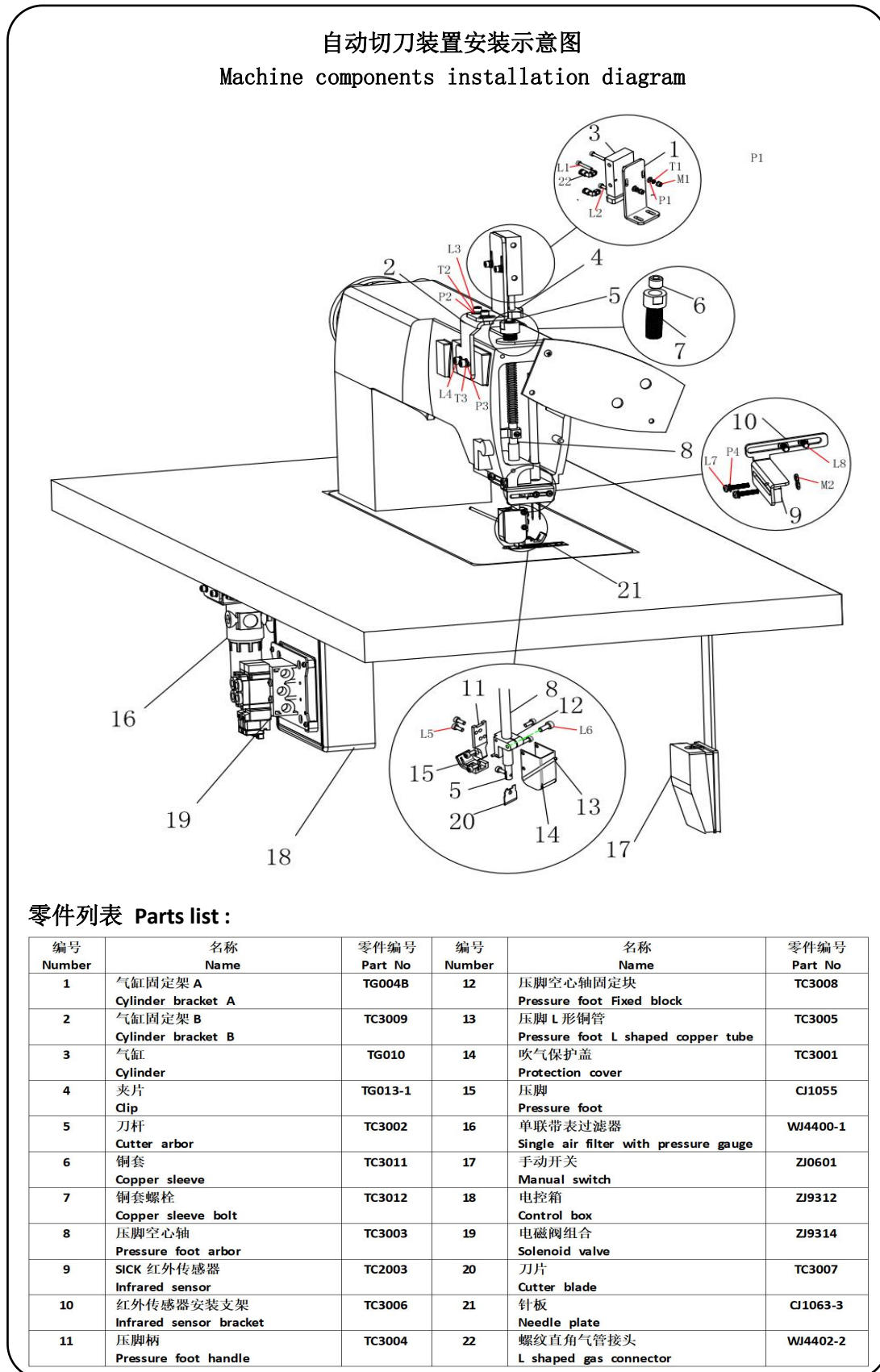
### USER MANUAL



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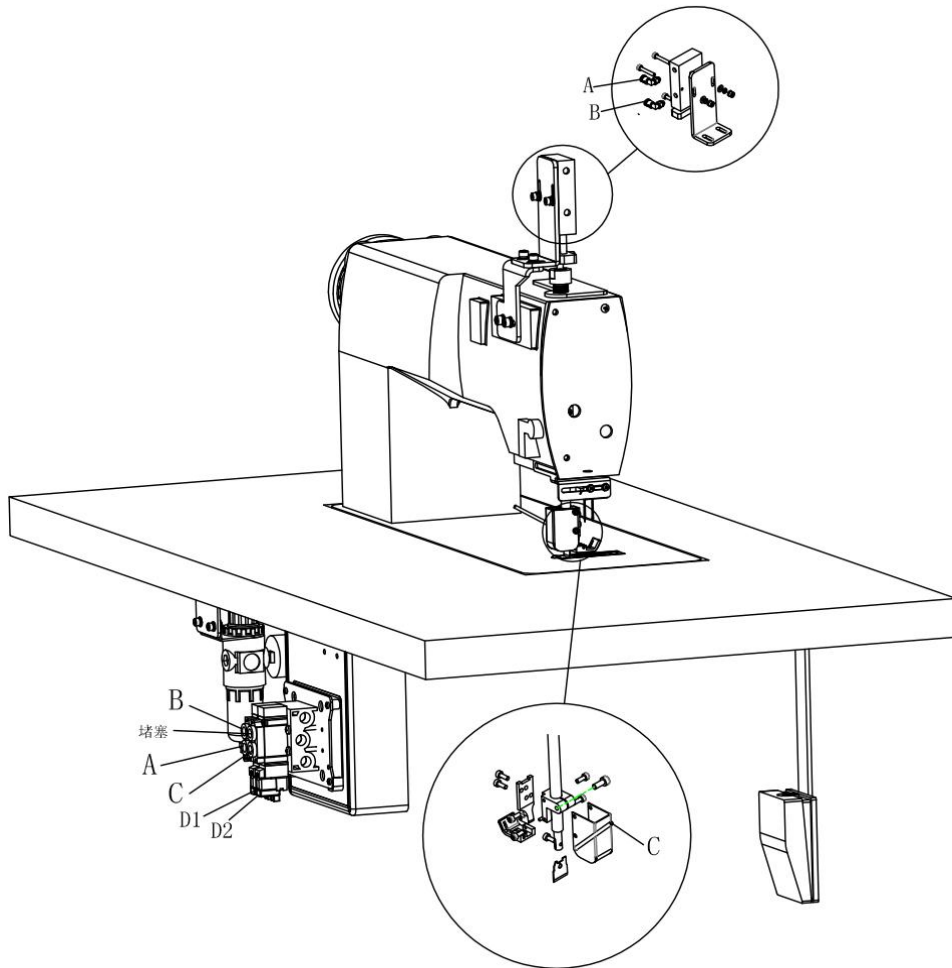
一、安装图示  
Installation diagram



零件列表 Parts list :

编号 Number	名称 Name	零件编号 Part No	数量(个) Quality	编号 Number	名称 Name	零件编号 Part No	数量(个) Quality
L1	M4X30 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1044	2	L7	M4X16 扁头十字螺丝 Phillips Flat Head Screw	LS6022	2
L2	M4X10 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1005	1	P1	Φ4 垫片 Pad	DQ1015	2
L3	M5X10 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1010A	2	P2	Φ5 垫片 Pad	DQ1016	2
L4	M5X10 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1010A	2	P3	Φ5 垫片 Pad	DQ1016	2
L5	M3X8 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1002	9	P4	Φ3 垫片 Pad	DQ1001	2
L6	M4X10 杯头内六角螺丝 HEX SOCKET CAP SCREWS	LS1005	1	T1	Φ4 弹介 Spring washer	TJ1008	2
				T2	Φ5 弹介 Spring washer	TJ1009	2
				T3	Φ5 弹介 Spring washer	TJ1009	2
				M1	M4 自锁螺母(带胶) Self locking nut	LM1021	2
				M2	M3 六角螺母 Hexagon nut	LM1010	2

气管连接示意图  
Air Hose Diagram

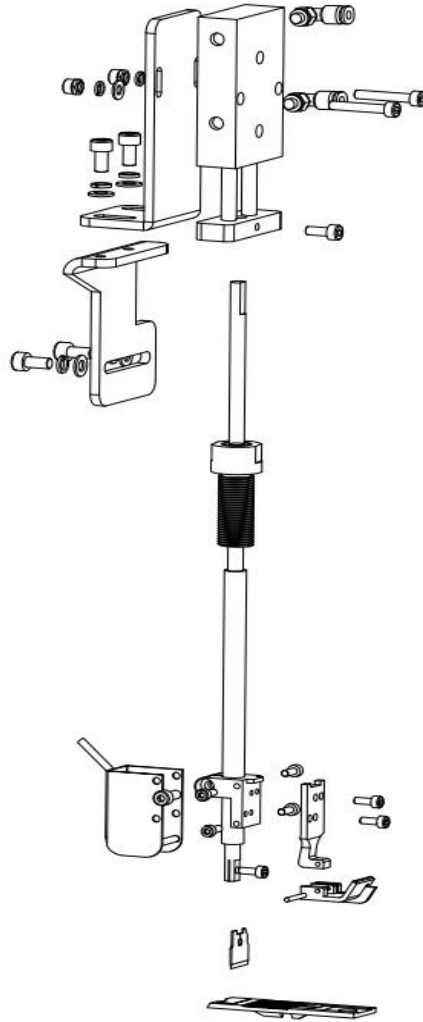


注：相同编号的气管接头用气管连接起来，D1 接 1 号电磁阀信号线，D2 接 2 号电磁阀信号线

Note: Air hose Connect according to the serial number, D1 connect with solenoid valve control line NO.1, D2 connect with solenoid valve control line NO.2

压脚杆气缸连接安装示意图

Presser foot and cylinder installation diagram



## 二、操作说明

### Operation guide

系统提供两种自动工作模式，前切/后切模式和固定长度切模式，用户可以通过修改系统参数“ChkSw”选择其中一种自动工作模式，“ChkSw”设置为 ON 时，表示前切/后切模式，“ChkSw”设置为 OFF 时表示固定长度切模式，设置方法请参考系统参数设置说明

System provide two work mode for use, Start&End cut mode and fixed-length cut mode. user can select mode by changing the system parameter “ChkSw”, when “ChkSw” is set to ON, the Start&End cut mode is selected, otherwise, the fixed-length cut mode is selected. refer to the system parameter setting guide.

#### 1. 前切/后切模式操作说明

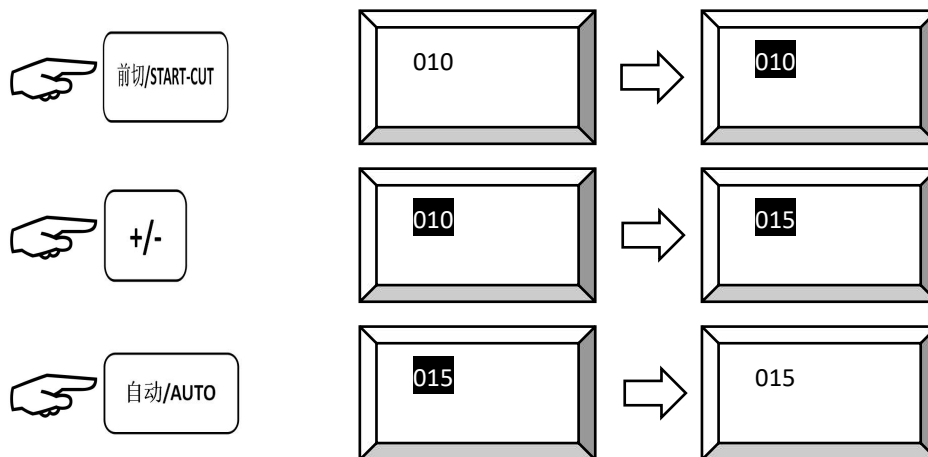
##### Start/End cut mode operation

前切/后切模式需要搭配布料检测传感器使用，使用该模式需要将系统参数中的“ChkSw”设置为 ON，设置方法参考系统参数设置说明

Material detection sensor is require when work on Start/End cut mode, and parameter “ChkSw” should be set to ON. Refer to the system parameter setting

**1.1. 前切:** 布料检测传感器检测到布料进入时，系统开始执行车缝针数计数，当车缝针数满足前切针数设定时，自动执行一次切刀动作，前切针数设置方法如下图所示

Start cut : when material detection sensor turn into valid, system start counting the sewing stitch, as long as the sewing stitch counting reach to the setting, cutter will work for one time. Start cut stitch setting guide is shown below.

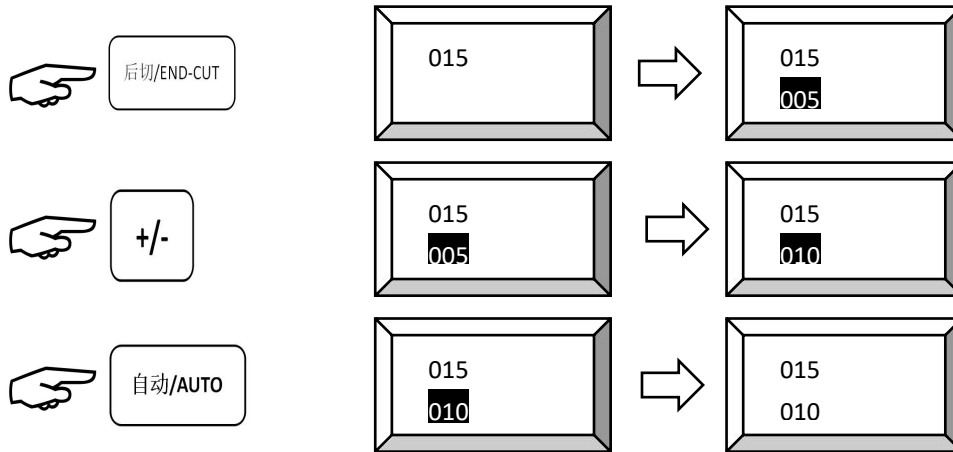


前切图示 Start cut sample:



**1.2.后切:** 布料检测传感器检测到布料离开时,系统开始执行车缝针数计数,当车缝针数满足后切针数设定时,自动执行一次切刀动作。后切针数设置方法如下图所示

End cut : when material detection sensor turn into invalid,system strat counting the sewing stitch,as long as the sewing stitch counting reach to the setting,cutter will work for one time.End cut stitch setting guide is shown below.



**后切图示 End cut sample:**

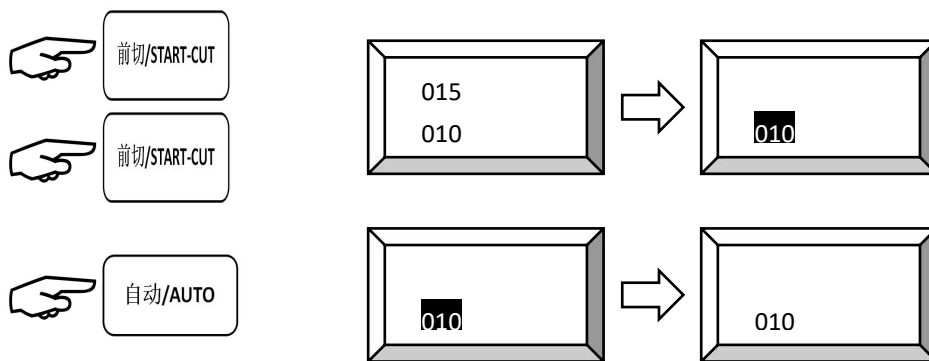


前切/后切功能可以组合使用,也可以单独使用,当需要单独使用前切或者后切时,可以通过双击“前切”或者“后切”按键取消相应的功能。设置方法如下图所示

Start cut or End cut function can be used independently or in combination , user can cancel one of them by double click “START-CUT” key or “END-CUT” key,the setting guide is shown below

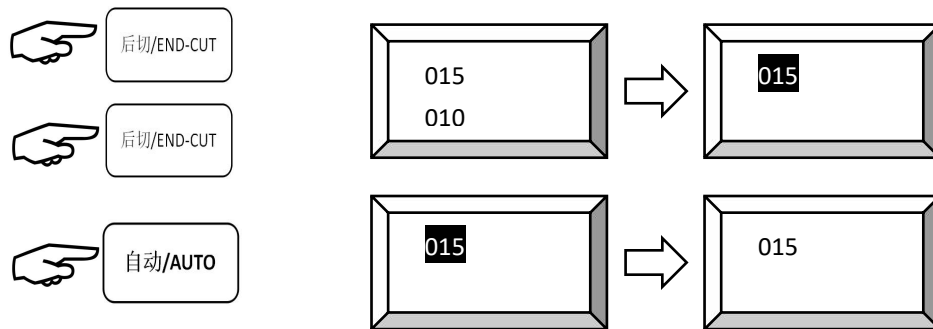
**a.关闭前切功能, 单独使用后切功能**

**Cancel Start cut function , Using End cut function only**



**b.关闭后切功能，单独使用前切功能**

**Cancel End cut function ,Using Start cut function only**



**2. 固定长度切模式操作说明**

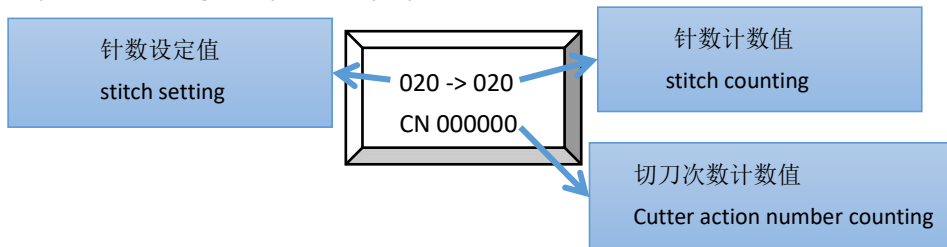
**Fixed-length cut mode operation**

固定长度切功能不需要使用布料检测传感器，使用该模式时需要将系统参数中的“ChkSw”设置为 OFF，设置方法参考系统参数设置说明

It's not need to use material detection sensor when work on fixed-length cut mode,and the system parameter “ChkSw” should be set to OFF.Refer to system parameter setting

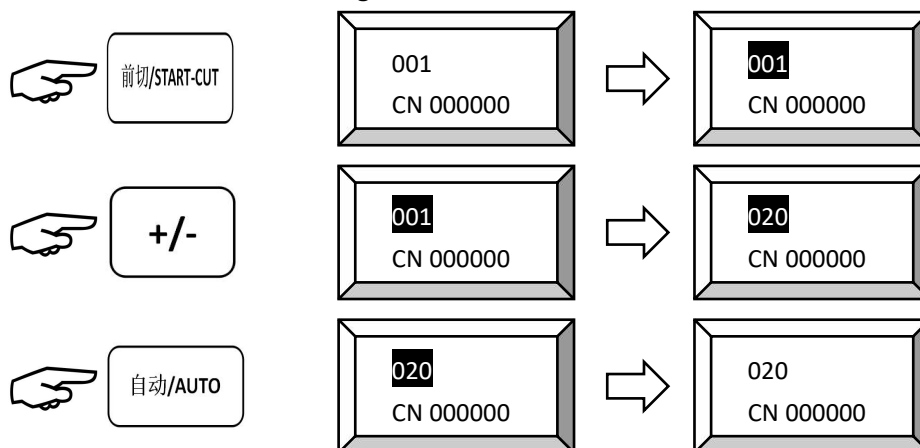
**固定长度切模式:** 通过设定好针数，系统循环执行固定长度切断动作，工作时面板如下图所示

Fixed lenth cut function: it's not need to use material detection sensor, user can set the fixed lenth stitch, and the cutter will work for one time when the sewing stitch counting is reach up to the setting, the panel display is shown below.



**a.固定长度切针数设置**

**Fixed lenth cut stitch setting**



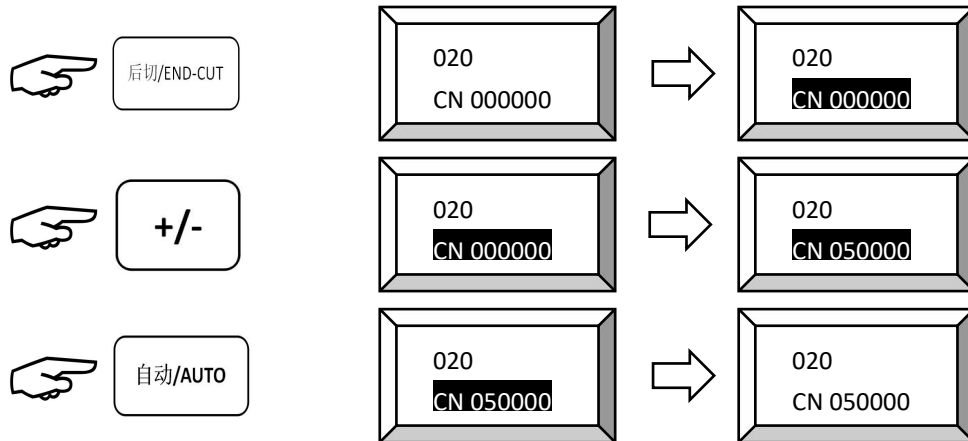


### b. 切刀执行次数限制设置

#### Cutter maximum action number setting

(\*注: 当最大切刀次数设定为零时, 不限制切刀次数, 如果最大切刀次数大于零, 则当切刀计数值达到最大切刀次数时, 系统将停止自动切刀动作)

(\*Note: if the maximum value is set to zero, the cutter is not limited to the number of times, else when the cutter action number counter reach up to the maximum Times, the cutter will be stopped)



#### 固定长度切图示 Fixed-length cut sample:

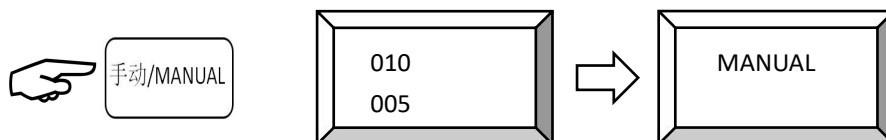


### 3. 手动模式

#### Manual mode operation

手动模式下, 按下膝动开关可以执行一次切刀动作  
Cutting by press knee switch

单击“手动”按键可以进入手动模式  
press MANUAL button enter manual mode



### 三、系统参数设置

#### System parameter setting

1.开机时长按“自动”按钮进入系统参数设置页面

Keep the “AUTO” key press down when power on,then system will enter the system parameter setting page

2.参数设置页面下单击“自动”按钮可以进行参数切换

In the system parameter setting page,“AUTO” key is used for parameter switch

3.通过单击“+/-”按钮可以对参数数值进行修改

Modify the parameter value by press “+” or “-” key

4.单击“手动”退出参数设置页面，跳转到手动模式

User can exit the parameter setting page by press “MANUAL” key

5.系统目前支持的参数如下表所示

The system parameter table is shown below

参数名称 Parameter	最大值 Max	最小值 Min	建议值 reference
CutTime (切刀闭合时间) Cutter work time	999ms	20ms	100ms
SwTime (膝动开关响应时间) Knee switch response time	999ms	30ms	50ms
ChkTime (布料检测传感器反应时间) Material detect sensor response time	999ms	0ms	30ms
ChkSw (前后切功能开关) Switch between start/end cut and fixed-length cut	ON	OFF	ON
CutSw (面板切刀控制开关) Panel manual cutter switch	ON	OFF	OFF