使用手册

Manual Book

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➢ 功能描述 Function description

背涂胶由操作屏幕及电控、螺杆式胶机、刮刀装置、冷却系统、双平放封边条装置、 自动接封边条装置、封边条接头自动检测装置、自动收封边条装置构成。具有物联网功能，手机或电脑可远程查看设备生产状态及产量和设置加热温度等功能。整线具有一键运行功能，操作方便快捷。封边条涂胶的厚度，PLC 根据涂胶速度和宽度的变化， 自动控制保持恒定。

The back glue coating system consists of an operating screen and electronic control, a screw glue machine, a scraper device, a cooling system, a double flat edge strip device, an automatic edge strip connection device, an edge strip joint automatic detection device, and an automatic edge strip collection device. It has the function of Internet of Things, and a mobile phone or computer can remotely view the production status and output of the equipment and set the heating temperature. The entire line has a one-button operation function, which is convenient and fast to operate. The thickness of the edge strip glue coating is automatically controlled by the PLC to remain constant according to the changes in the glue coating speed and width.

➢ 使用前注意事项 Precautions before use

- 电源 220V 总功率5KW 。主电源建议使用4 平方以上铜线。设备必须可靠接地线。
- 需要涂胶的封边条必须要平整，两边厚度误差控制在 0.02mm 之内。

Power supply 220V, total power 5KW. It is recommended to use copper wire of 4 square or more for the main power supply. The equipment must be reliably grounded.

The edge banding strips to be glued must be flat, and the thickness error on both sides must be controlled within 0.02mm.

1 设备安装 Installation

1 安装前检查 Check before installation

1.1开箱检验 Unpacking inspection

1.1.1 打开包装后请检验是否是您选购的产品；After opening the package, please check whether it is the product you purchased;

1.1.2 检查产品在运输过程中是否损坏； Check whether the product is damaged during transportation;

1.1.3 对照清单清点各部件是否齐全，有无损坏；Check the list to see if all parts are complete and whether they are damaged;

1.1.4 如存在型号不符，缺少附件，请及时联系我们。If there are model inconsistencies or missing accessories, please contact us in time.

1.2 设备安装 Installation

1.2.1 设备安装必须是经过培训的人员或厂家人员。Equipment installation must be carried out by trained personnel

1.2.2 设备的安装分为，主机，放卷机和收卷机的设备连线及电器接线 。The installation of the equipment is divided into the equipment connection and electrical wiring of the main machine, unwinder and rewinder.

1.2.3 设备无需固定，但摆放需要平整。The equipment does not need to be fixed, but it needs to be placed flat.

1.2.4 接线的人员必须是专业的持证电气人员。The person doing the wiring must be a professional certified electrician.

1.2.5 连接必须正确，紧固，否则将会烧毁电器元件。The connection must be correct and tight, otherwise the electrical components will be burned.

1.2.6 电源线的连接：电源接入 220V 一火线、一零线、一地线，建议使用 3 芯 4 平方电缆，接到配电盘端子排上。Connection of power cord: The power supply is 220V with one live wire, one neutral wire and one ground wire. It is recommended to use a 3-core 4-square cable and connect it to the terminal block of the distribution board.

1.2.7 产品必须可靠接地，如果不接地将会造成以下后果：The machine must be grounded. Failure to do so will result in the following consequences:

1.2.7.1 设备将产生静电或遇到电网漏电时击伤人员，The equipment will generate static electricity or injure people when encountering grid leakage.

1.2.7.2 机器工作时造成测温热电阻击穿 The temperature measuring thermal resistor breaks down when the machine is working.

警　告!

在对本设备安装、连接、操作之前必须详细阅读本产品的使用说明书，严格按照本产品使用说明书的相关要求进行操作，否则可能会导致设备损坏，产品报废，甚至人身伤害。

- ◆ 必须经过专业的培训才能使用操作此设备。
- ◆ 设备在运行期间小心压轮夹手。

Caution!

Before installing, connecting, and operating this equipment, you must read the instruction manual of this product in detail and operate in strict accordance with the relevant requirements of the instruction manual. Otherwise, equipment damage, product scrapping, or even personal injury may result.

Professional training is required to use and operate this equipment.

Be careful of the pressure wheel pinching your hands during operation of the equipment.

Beware of electric shock while operating the equipment.

2 设备使用 Use of the machine

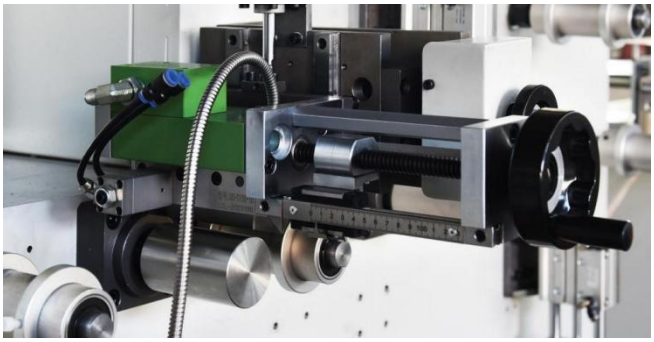
2.1 设备各部分介绍 Introduce of the parts

螺杆式胶机:采用 1.8kw 伺服电机直连单螺杆溶胶的方式；溶胶快速，胶水不黄变，换色方便，节省胶水和时间。

Screw glue machine: It adopts 1.8kw servo motor directly connected to single screw glue dissolving method; glue dissolving is fast, glue does not turn yellow, color changing is convenient, saving glue and time.

刮刀装置:采用进口钢材，涂胶均匀，涂胶口开合有刻度尺，整个刮刀具有上下和左右微调移动功能，涂胶控制精准。

Scraper device: Made of imported steel, glue coating is uniform, the glue coating port is opened and closed with a scale, the entire scraper has the function of fine-tuning up and down and left and right, and the glue coating is accurately controlled.

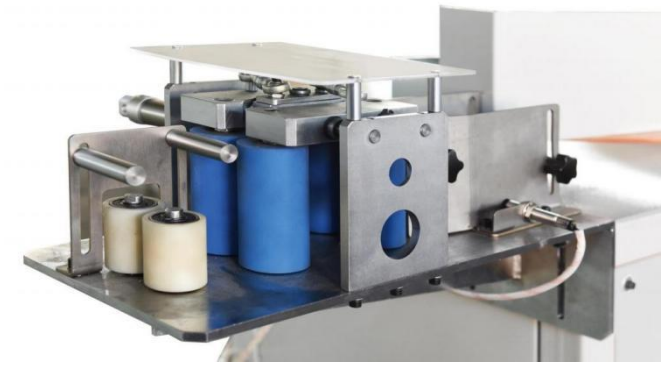


冷却系统:配有风冷和水冷两种冷却方式，提高冷却效率。

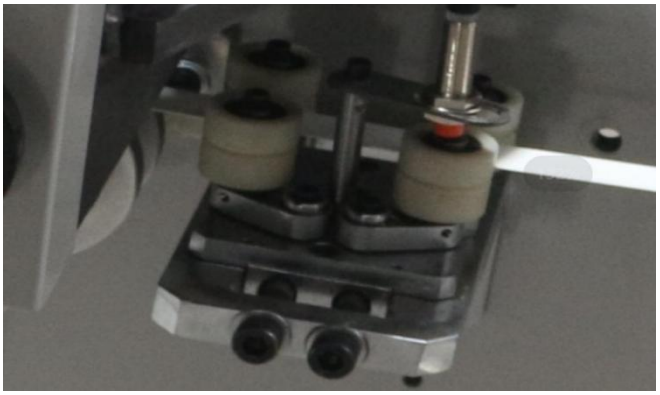
Cooling system: Equipped with two cooling methods, air cooling and water cooling, to improve cooling efficiency.

双平放封边条装置:多预留一个放封边条工位，提高工作效率。具有张力功能。
Double platform edge banding device: Reserve an extra station for placing edge banding strips to improve work efficiency. Has tension function.

自动接封边条装置:采用红外探头检测，可实现两卷封边条， 自动拼接，实现不停机连续生产。
Automatically connect edge banding device: Using infrared probe detection, two rolls of edge strips can be automatically spliced to achieve continuous production without stopping the machine.



封边条接头自动检测装置:采用红外探头检测接头位置，自动控制涂胶头抬升和复位，实现不停机连续生产。
Automatic detection device for edge strip joints: An infrared probe is used to detect the joint position and automatically control the lifting and resetting of the glue coating head to achieve continuous production without stopping the machine.



自动收封边条装置:伺服电机扭矩模式自动收卷， 自动检测接头， 自动裁断和收卷。
Automatic edge banding strip collection device: Servo motor torque mode automatically rewinds, automatically detects joints, and automatically cuts and rewinds.

2.2 设备参数 Technical Parameters

2.2.1 电压 AC220v， 功率 5KW， 频率 50/60HZ。

Voltage: AC220v Power: 5KW Frequency: 50/60HZ

2.2.2 设备尺寸:根据客户配置变化；

Boundary dimensions: can be customized

2.2.3 涂胶速度：5—50M/min；Gluing speed: 5-50m/min

2.2.4 涂胶宽度：宽度为 15mm-80mm，涂胶厚度 0.06-0.30mm。

Gluing width: 15-80mm Gluing thickness: 0.06-0.3mm

2.2.5 加热范围：0—245℃， **（根据用户使用的胶自行设定加热温度）**

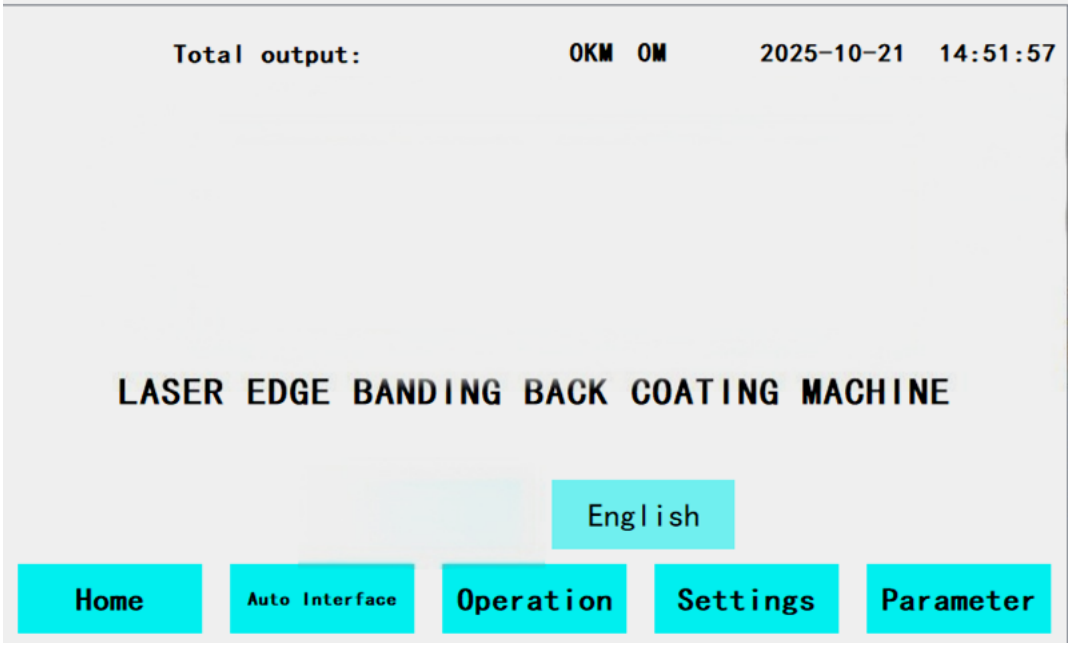
Heating range: 0-245℃ (the heating temperature can be set according to the glue used by the user)

2.2.6 气动压力: 0.4-0.7Mpa Pneumatic pressure: 0.4-0.7Mpa

2.3触摸屏面板使用说明 Touch screen panel instructions

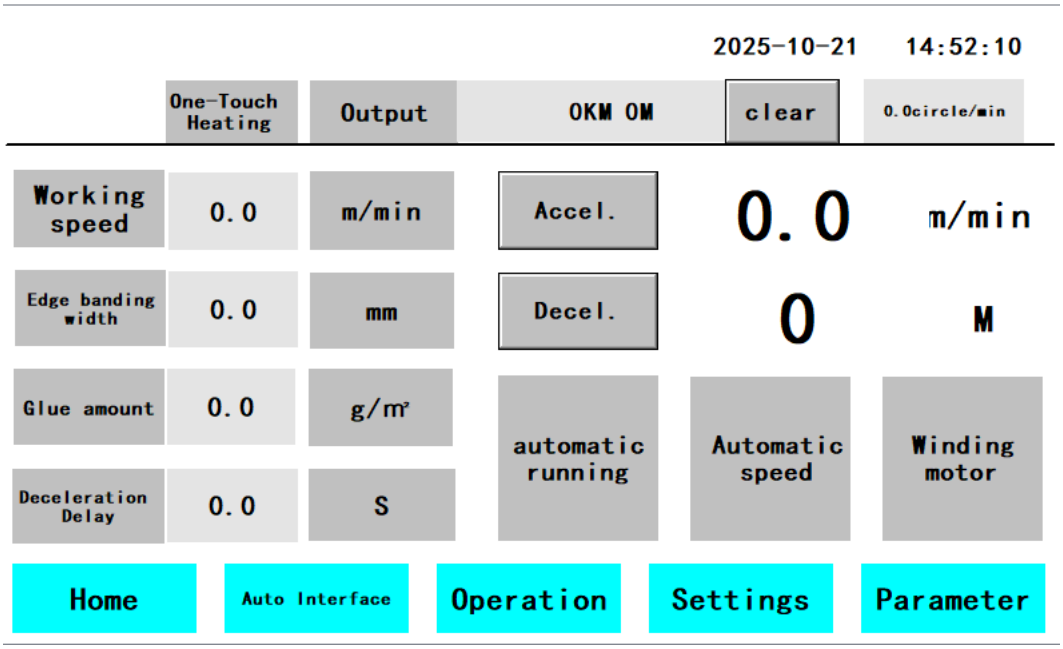
2.3.1 主画面说明：

Main screen description:



2.3.2 控制画面 Control screen

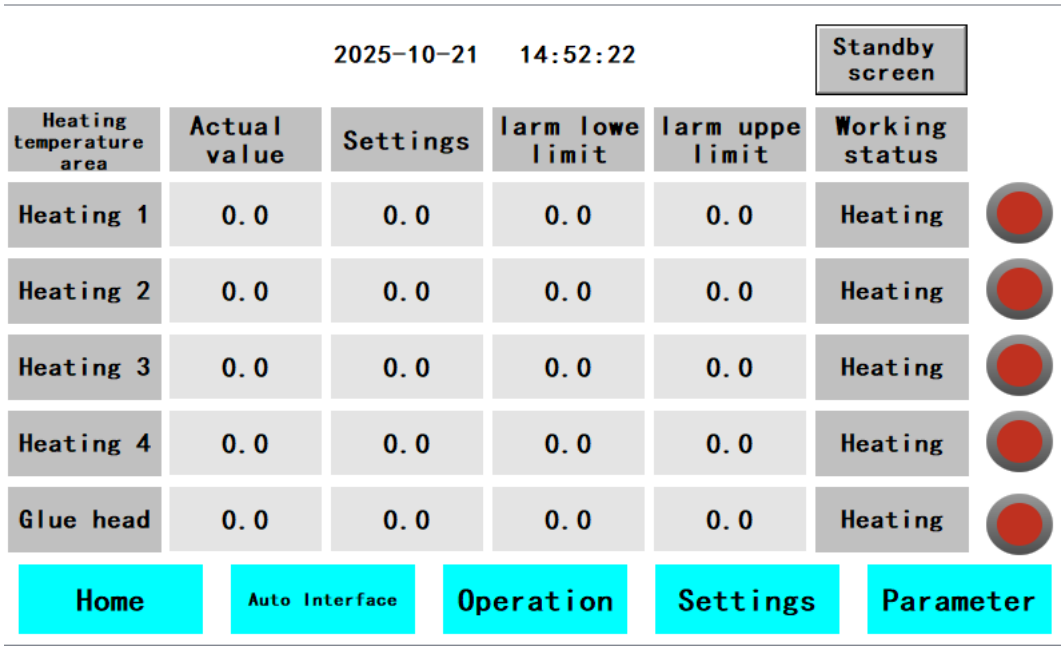
生产速度、封边条宽度、涂胶量可调整， 自定运行一键生产。The production speed, edge banding width and glue application amount can be adjusted, and one-click production can be customized.



2.3.3 胶机设置画面 Setting Screen

加热分位，加热一、加热二、加热三、加热四、胶头加热。根据不同胶水设置温度。

Heating positions: heating one, heating two, heating three, heating four, heating of glue head. Set the temperature according to different glues.



2.3.4 参数画面 Parameter screen

系统参数画面，每个功能都有具有延时，可根据实际生产调整。

In the system parameter screen, each function has a delay, which can be adjusted according to actual production.


2025-10-21 14:52:17
One-Touch Heating
Output
OKM OM
clear
0.0circle/min
Working speed
0.0
m/min
Accel.
Host operation
Fan cooling
Edge banding width
0.0
mm
Decel.
lighting
Cylinder down pressure
Glue amount
0.0
g/m²
automatic running
Glue machine working
Tightening motor
Glue coating thickness
0.01mm
Glue head down pressure
Winding motor
Home
Auto Interface
Operation
Settings
Parameter
Auto Parameters
Automatic connection
Lifting distance
0.0
Tightening motor delay
0.0
S
Host operation
Air gun socket
Coefficient of tightening torque
0.0
Air gun socket delay
0.0
S
Lifting distance
0.0
MM
Glue machine operation delay
0.0
S
Cylinder down pressure
Tightening motor
Coefficient of glue pump motor
0.0
circ
Delay of glue head pressing down
0.0
S
Cooling valve
Winding motor
Operation delay
0.0
S
Release delay of connection
0.0
S
Glue machine working
Fan cooling
Rewinding motor delay
0.0
S
Delayed rise of glue head
0.0
S
Glue head down pressure
Connector detection
Glue delay shutdown
0.0
S
Delayed pressing of glue head
0.0
S
Probe connector inspection
Automatic gluing
Head Delay Glue
0.0
S
Glue delay shutdown
0.0
S
Home
Auto Interface
Operation
Settings
Parameter
Accel/Decel Rate
0.0
M
Acceleration Delay
0.0
S
Deceleration Delay
0.0
S
Acceleration Max Speed
0.0
M
Deceleration Max Speed
0.0
M
Home
Auto Interface
Operation
Settings
Parameter

3故障检修 Troubleshooting

3.1 螺杆胶机伺服报警 Screw glue machine servo motor alarm:

故障判断：点击操作画面胶机运行伺服电机不运转，伺服控制器显示 ERR13。

解决方法: 按下急停按钮 20 秒钟，等伺服电机充分断电再按总启动按钮就可以解决。

故障原因：加热温度过低，导致胶水不完全融化，造成伺服电机过载保护。

Fault judgment: Click the operation screen to run the servo motor of the glue machine, the machine does not run, and the servo motor controller displays ERR13.

Solution: Press the emergency stop button for 20 seconds, wait for the servo motor to be fully powered off, and then press the main start button to solve the problem.

Cause of the fault: The heating temperature is too low, resulting in incomplete melting of the glue, causing the servo motor to overload protection.

4维护保养 Maintenance

4.1 电气设备尘土定期清扫（必须停电清扫）Dust on electrical equipment should be

cleaned regularly (power must be turned off for cleaning).

4.1.1 配电盘清扫：打开操机面第一块围板，漏出出配电盘，清理杂物，用强风机吹掉上

面的尘土。

周期：半年一次。Cleaning of the switchboard: Open the first panel of the operating surface, expose the switchboard, clean up the debris, and use a strong fan to blow off the dust on it. Cycle: once every six months.

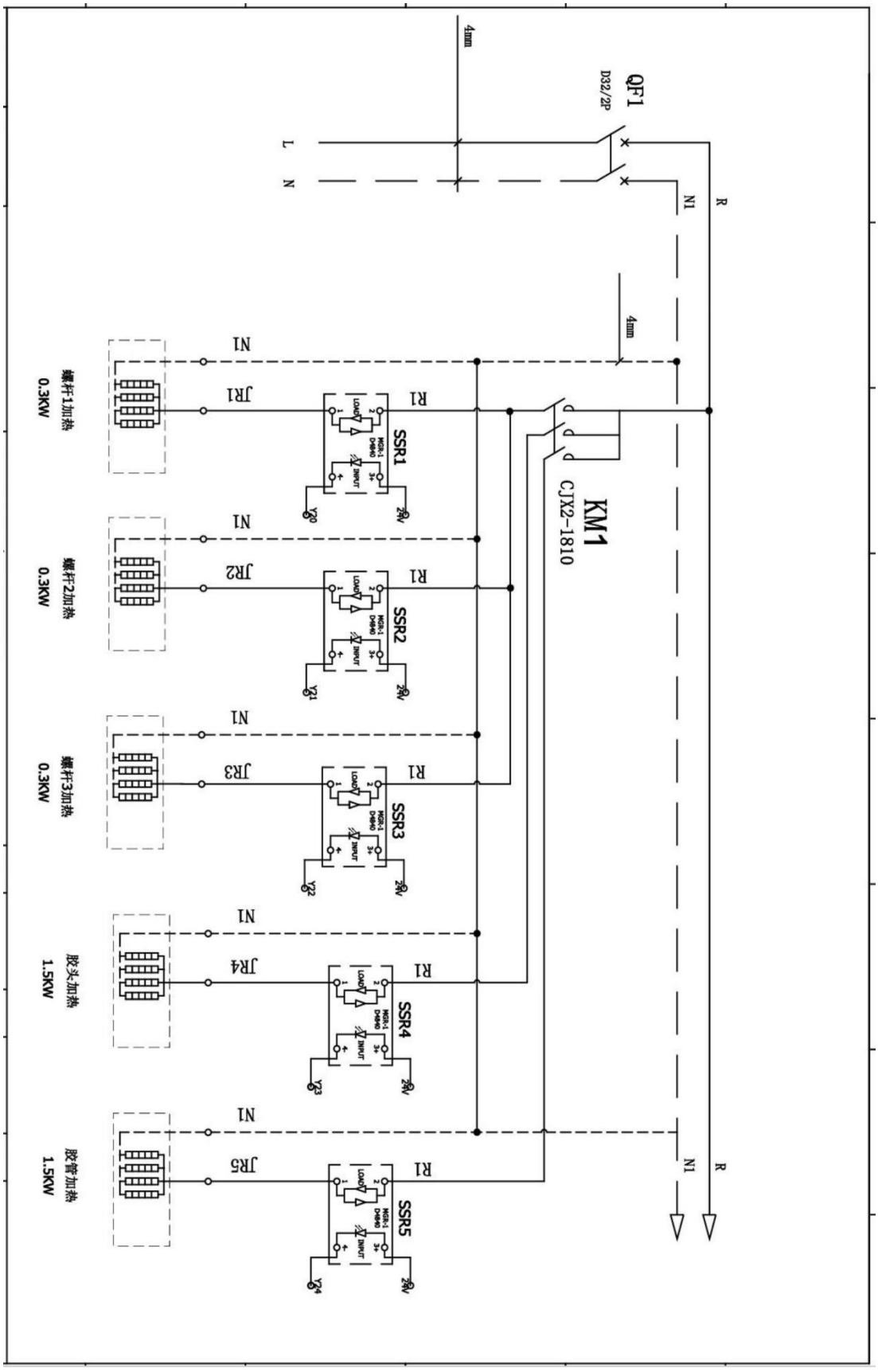
4.1.2 设备内部空间清扫：打开第二块及以后的围板，用强风机吹掉上面的尘土。

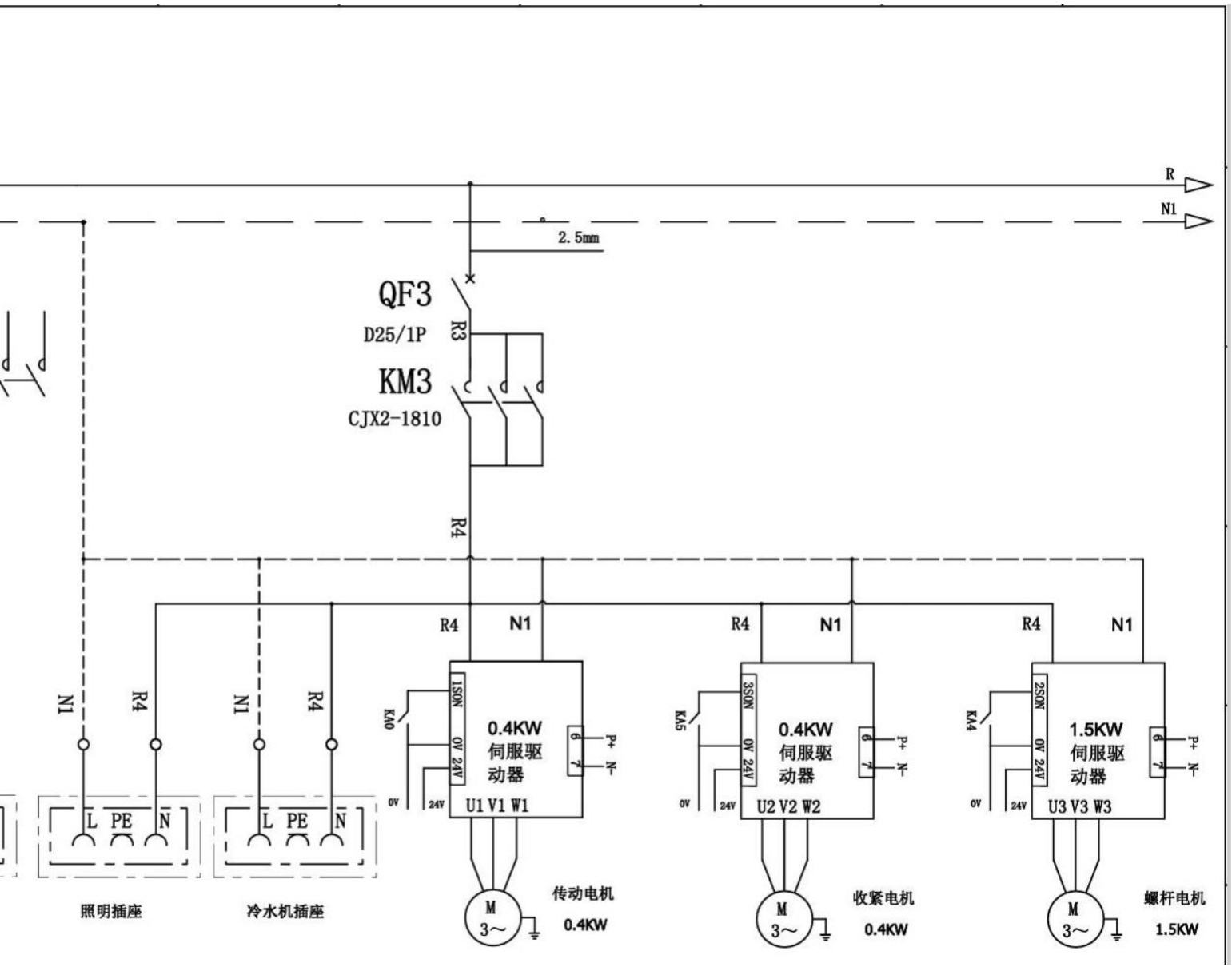
周期： 半 年 一 次 。

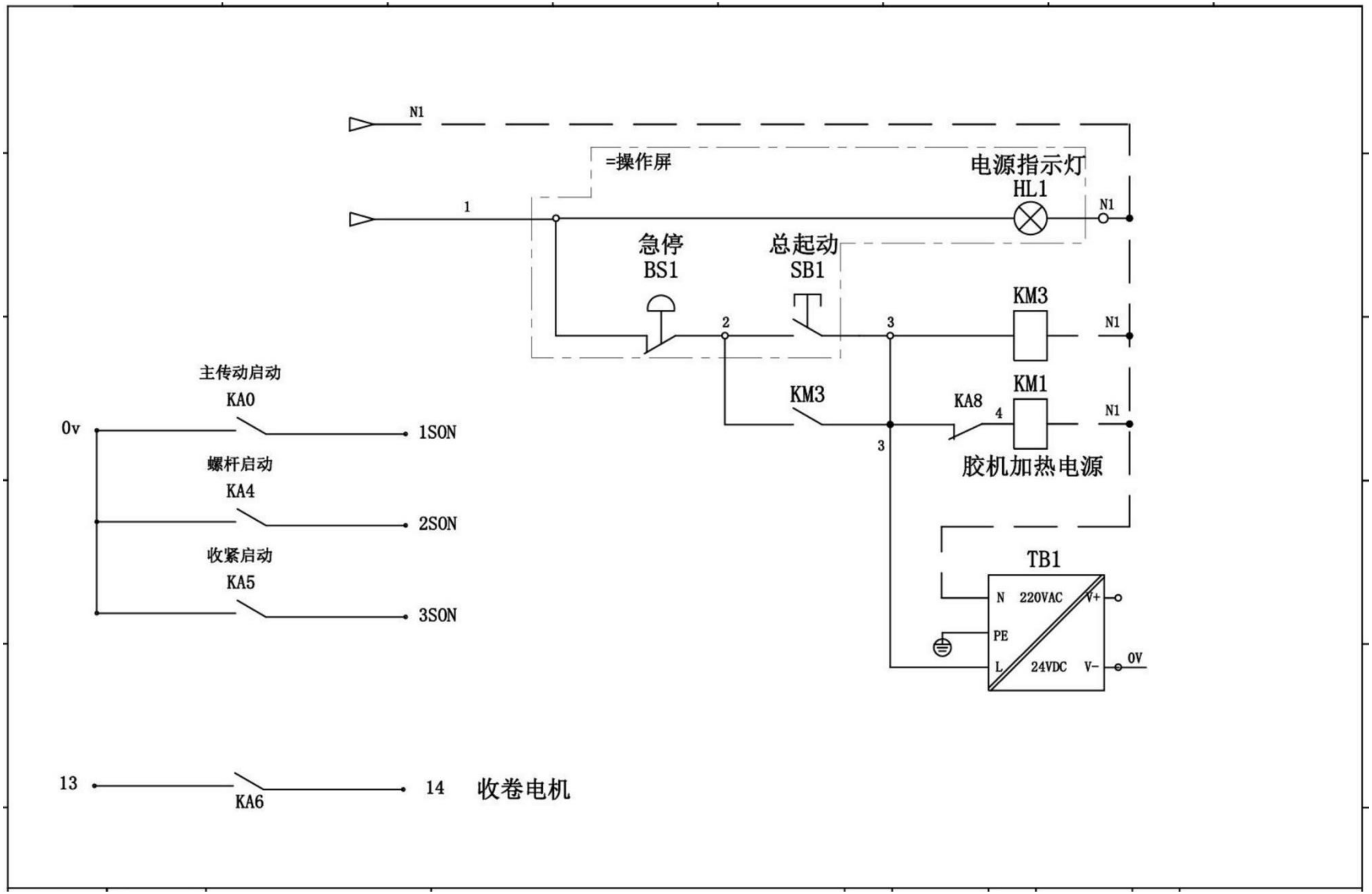
Cleaning the internal space of the equipment: Open the second and subsequent enclosures and use a strong fan to blow away the dust on them. Period: Once every six months.

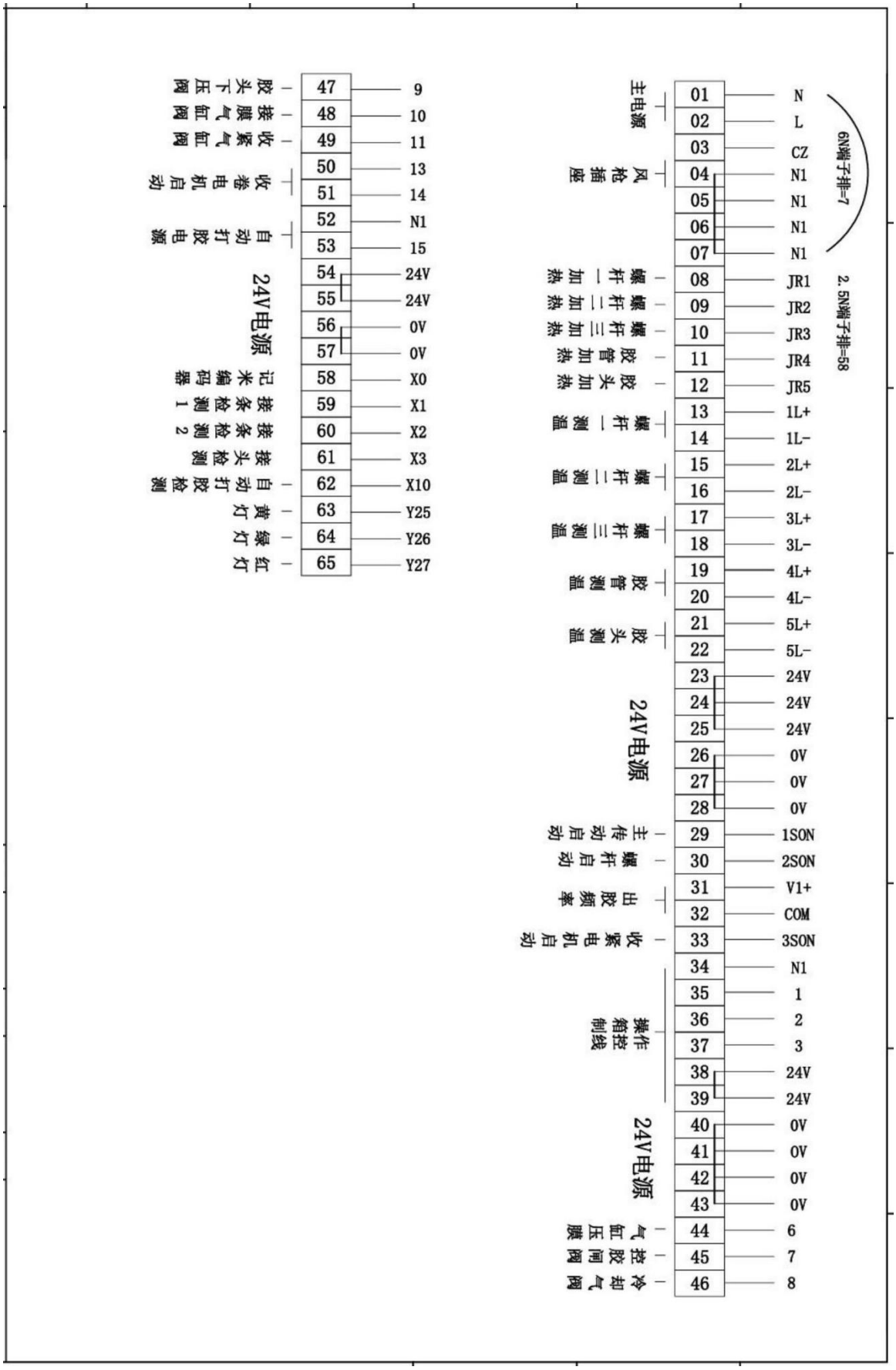
4.2 润滑保养 Lubrication maintenance

5电路图 Circuit Diagram




R
N1
2.5mm
QF3
D25/1P
R3
KM3
CJX2-1810
R4
N1
R4
N1
R4
N1
R4
N1
KA0
1SON
0V
24V
0V
24V
0.4KW
伺服驱
动器
U1 V1 W1
P+
N-
KA5
3SON
0V
24V
0V
24V
0.4KW
伺服驱
动器
U2 V2 W2
P+
N-
KA4
2SON
0V
24V
0V
24V
1.5KW
伺服驱
动器
U3 V3 W3
P+
N-
L
PE
N
L
PE
N
照明插座
冷水机插座
M
3～
传动电机
0.4KW
M
3～
收紧电机
0.4KW
M
3～
螺杆电机
1.5KW


N1
=操作屏
电源指示灯
HL1
1
N1
急停
BS1
总起动
SB1
KM3
2
3
N1
主传动启动
KA0
KM3
KM1
KA8
4
N1
0v
1SON
螺杆启动
KA4
3
胶机加热电源
2SON
收紧启动
KA5
TB1
N
220VAC
V+
3SON
PE
L
24VDC
V-
0V
13
14
收卷电机
KA6


6N端子排=7
2.5N端子排=58
主电源
01 N
02 L
03 CZ
风枪插座
04 N1
05 N1
06 N1
07 N1
螺杆一加热
08 JR1
螺杆二加热
09 JR2
螺杆三加热
10 JR3
胶管加热
11 JR4
胶头加热
12 JR5
螺杆一测温
13 1L+
14 1L-
螺杆二测温
15 2L+
16 2L-
螺杆三测温
17 3L+
18 3L-
胶管测温
19 4L+
20 4L-
胶头测温
21 5L+
22 5L-
24V电源
23 24V
24 24V
25 24V
26 0V
27 0V
28 0V
主传动启动
29 1SON
螺杆启动
30 2SON
出胶频率
31 V1+
32 COM
收紧电机启动
33 3SON
操作箱控制线
34 N1
35 1
36 2
37 3
38 24V
39 24V
24V电源
40 0V
41 0V
42 0V
43 0V
气缸压膜
44 6
控制阀
45 7
冷却气阀
46 8
胶头下压阀
47 9
接膜气缸阀
48 10
收紧气缸阀
49 11
收卷电机启动
50 13
51 14
自动打胶电源
52 N1
53 15
24V电源
54 24V
55 24V
56 0V
57 0V
记米编码器
58 X0
接条检测1
59 X1
接条检测2
60 X2
接头检测
61 X3
自动打胶检测
62 X10
黄灯
63 Y25
绿灯
64 Y26
红灯
65 Y27