



青工牌

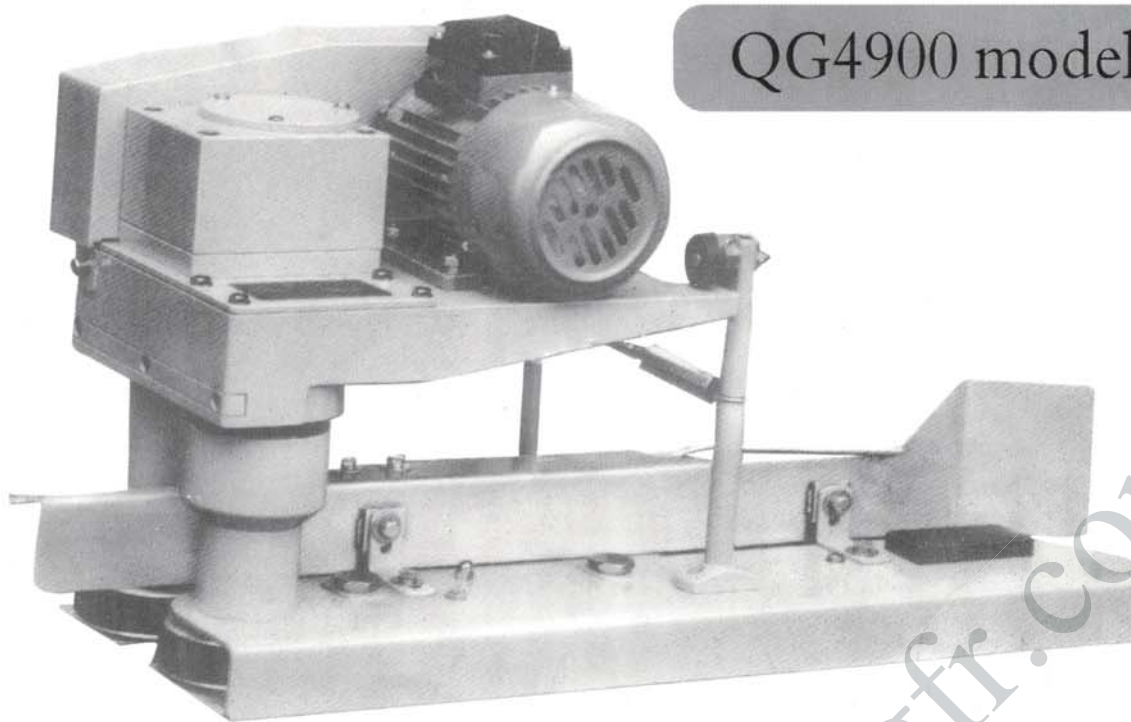
QingGong Brand

纸袋塑编袋卷边机使用说明书

Usage instruction of crimper for bags made in paper and plastic

QG4900型

QG4900 model



河北青工缝纫机有限公司

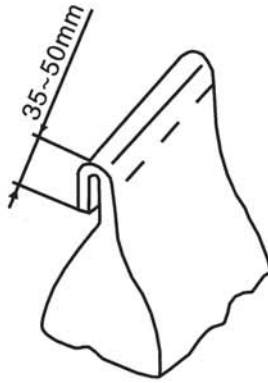
HeBei QingGong sewing machine Co.,Ltd

QG4900型

QG4900 model

塑料编织袋卷边机 Bag Feed-In Device

- 多项技术改进/ Multinomial Technical Improvement
- 调速范围大/ A Wide Range of Speed Adjustment
- 高品质卷边性能、机械性能/ Finest Quality in Folding and Operating
- 适用于塑料编织袋、纸袋的袋口卷边封包/ For Folding Bags Made of Plastic, Paper



主要技术参数 Technical Specifications

卷边宽度	(Folding Width)	35~50mm
送袋速度	(Feed-in Speed)	7~16m/min
电压/频率	(Voltage/Frenquency)	380V/50HZ
功 率	(Power)	180W
机器重量	(Weight)	32Kg
外形尺寸 {长X宽X高}	(Overall Size) (LXWXH)	710x240x370mm

1. 概略说明

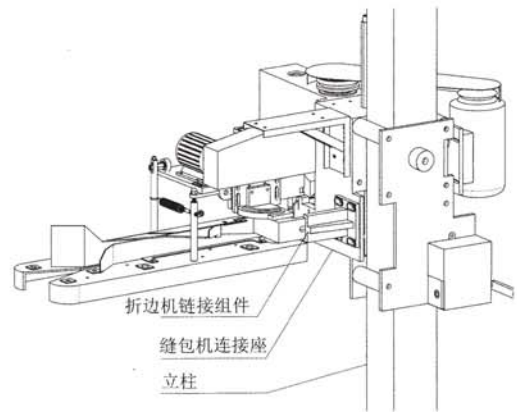
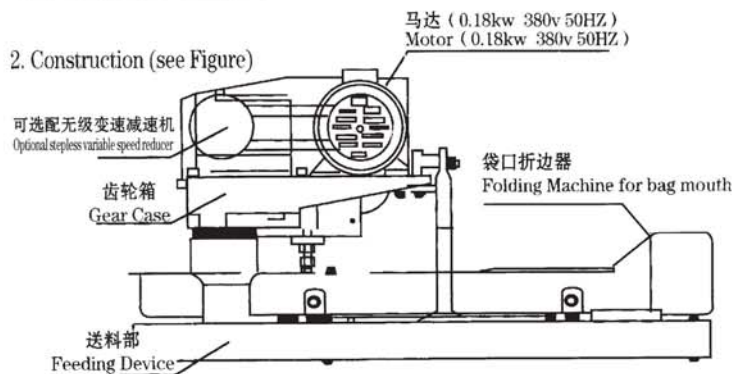
1. Introduction

本设备是把编织袋的袋口折边，用缝纫机缝合的装置。经该机折边后封缝包装袋能极大的提高包装牢度，有效地防止散包、漏包现象。
This is a kind of device that can hem the bag mouth of woven bag, and stitched by sewing machine. Using the device, we can remarkably improve packaging fastness, effectively avoid bales off and leaking packages.

主要技术参数 Main Technical Parameter

折边宽度 Folding Width	35-50mm
送袋速度 Feed-in Speed	7-16m/min
电压/频率 Voltage/Frequency	380V/50HZ
功率 Power	180W
机器重量 Weight	32Kg
外形尺寸 (长X宽X高) Physical dimension (LxWxH)	710X240X370mm

2. 构造与安装



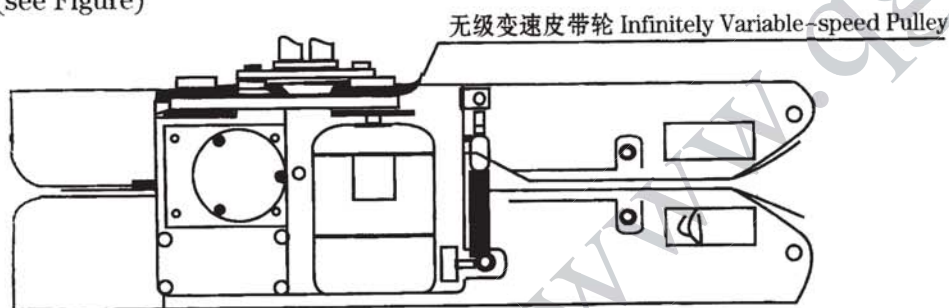
3. 各部的调整方法

3. Adjusting Method

(1) 送袋速度的调整

由专用马达和减速机的无级变速皮带轮开闭进行速度调整。如拧紧马达无级变速轮。同时松开减速机无级变速轮会使速度加快，反之，速度变慢。请调整到与承载袋的输送机的速度一致。请注意：若速度不一致，则袋会倾斜。（见图）

(1) adjusting method of Feed-in speed The speed can be adjusted by turning on/off the infinitely variable-speed pulley of the special Motor and Speed Reducer. For example, tightening the infinitely variable-speed pulley of Motor, and loosening the one of the Speed Reducer could make the speed faster, whereas, it would be lower. Please keep the speed consistent with the conveyer. Note, if the speed is not identical, the bag will slope. (see Figure)



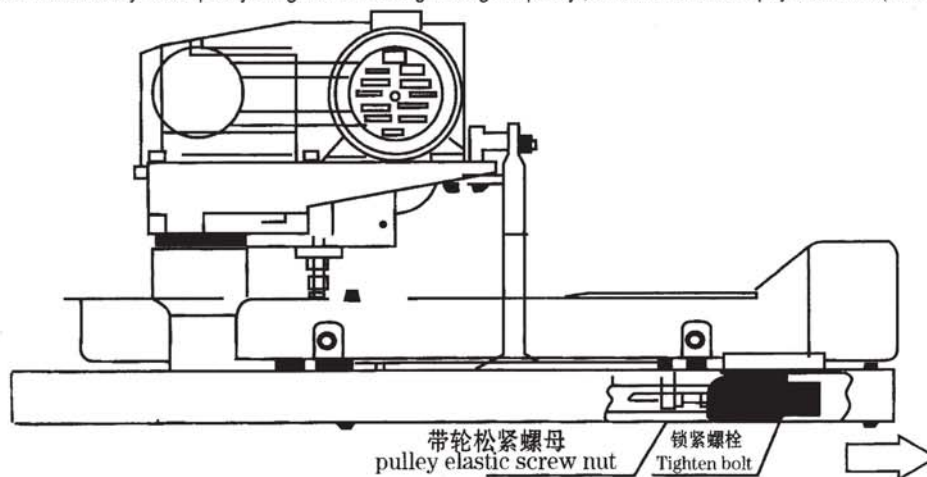
(2) 送袋链条的绷紧调整

(2) Conveyer Belt Adjustment

沿着长孔，把出口侧的皮带轮朝箭头(→)方向移动，请松开锁紧螺栓，调整带轮松紧螺母，使皮带绷紧。不绷紧皮带，会引起脱落，所以请注意。

(见图)

Along the long hole, move the pulley (portal side) towards the arrow direction. Please loosen the tightened belt, adjust the elasticity nut of pulley to tighten it. If not tightening the pulley, it would fall off. So pay attention. (See Figure)

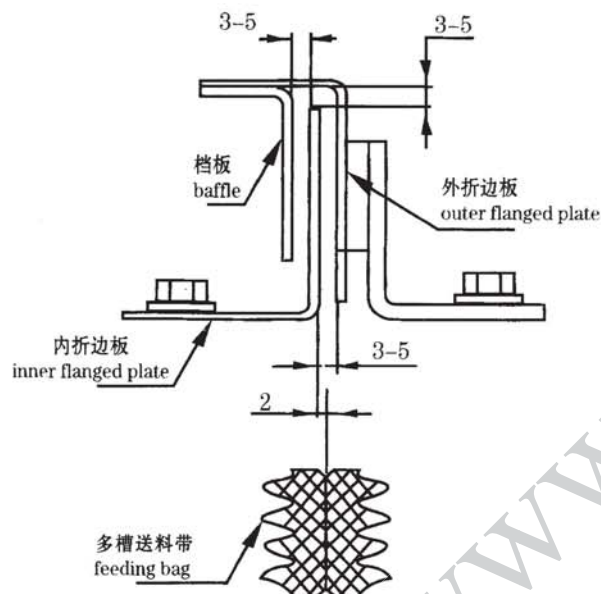


(3) 折边板的调整

(3) Flanged Plate Adjustment

折边板的调整因袋的厚度，所装货物的袋硬软而不同。为了让袋顺利通过，请调整好内折边板及外折边板之间的间隔。(见图)

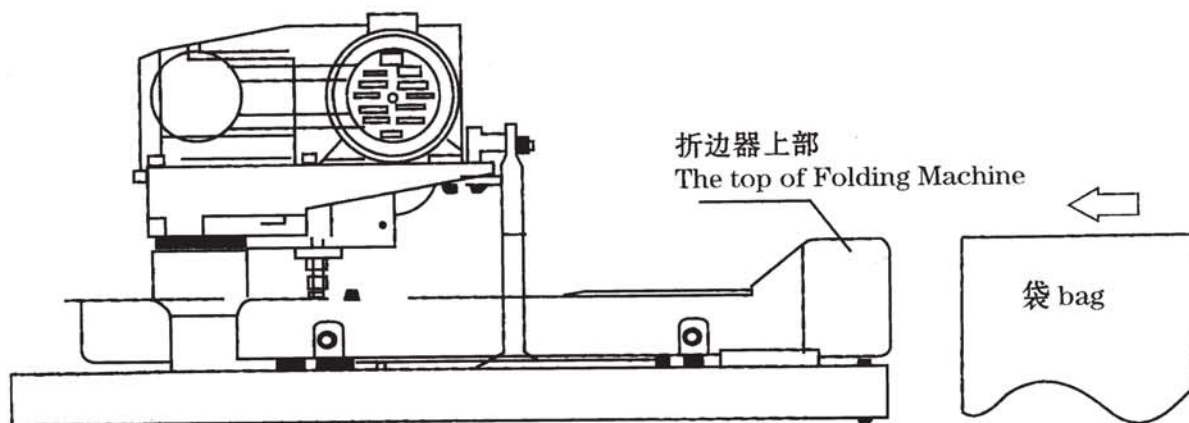
The adjustment method of flanged plate is various, depend on the bag thickness and loaded goods's bag rigidity. To insure the bag feeding well, adjust the distance between inner and outer flanged plate properly. (See Figure)



(4) 折边器与袋高度的调整

在折边器上部对齐袋品，水平送过去，约或折50mm（见图）

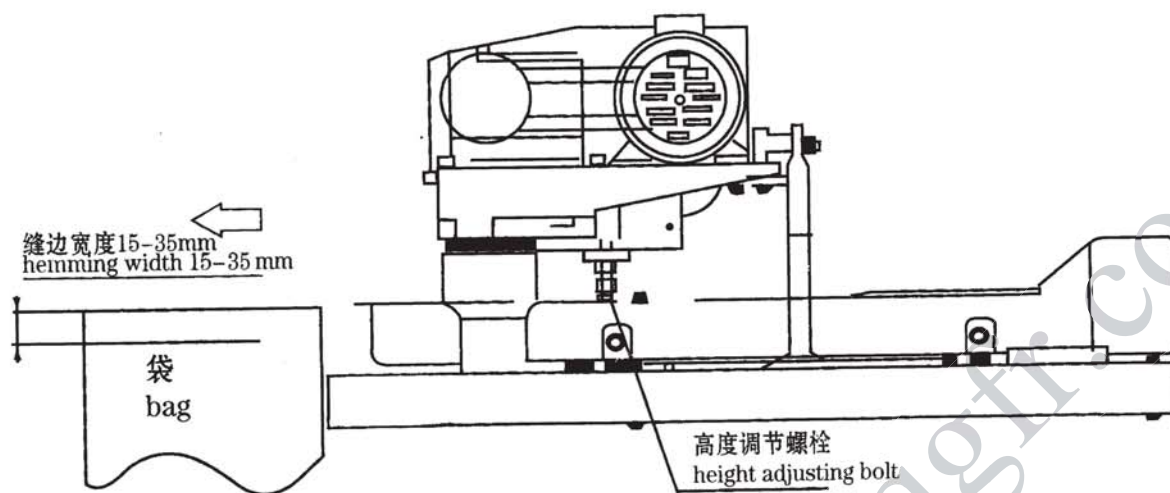
- (4) Folding Machine and Bag Height Adjustment At the top of Folding Machine, keep the bag align, deliver it horizontally, and fold it about 50mm (see figure)



(5) 袋口缝纫调整

袋口缝边宽度的调整，请松开安装板螺栓，适当调整如图所指的高度调节螺栓，并锁紧螺母及安装板螺栓即可。（见图）

- 5) Bag Mouth Sewing Adjustment If you want adjust the bag mouth hemming width, release mounting plate bolt, appropriately adjust height adjusting bolt (as shown in the figure), and locking up the nut and mounting panel bolt.(see Figure)



79	JB-50	立轴工套	Vertical shaft Industrial Ferrule	1
78	JB-49	变速箱外齿轮	Gearbox Outer Gear	1
77	JB-48	皮带轮 I	Belt Pulley I	2
76	JB-47	皮带轮 II	Belt Pulley II	2
75	JB-46	大被动物垫卷II	Big Driven Pulley Pad Roll II	2
74		6002K5	6002K5	12
73		32GB893-76	32GB893-76	12
72	JB-45	大被动物垫卷I	Big Driven Pulley Pad Roll I	2
71	JB-44	大被动物松紧调节叉	Big Driven Pulley Elastic Adjusting Fork	2
70		M6 螺母	M6 screw nut	1
69	JB-43	松紧叉立柱	Elastic Fork Vertical Column	2
68	JB-42	下箱体定位块	lower box locating block	1
67		M6 螺钉	M6 screw	3
66		M8 螺母	M8 screw nut	1
65	JB-41	拉王杆II	Pull Rod II	1
64	JB-40	拉王调节螺丝	Pull Rod adjusting screw	1
63	JB-39	弹王	spring	1
62	JB-38	滑动轴承套	sliding bearing alloy	1
61		608RS 轴承	608 RS bearing	1
60	JB-37	M6 螺	M6 screw	1
59		拉杆I	Pull Rod I	2
58	JB-36	M6 螺母	M6 screw nut	1
57		M8 螺丝	M8 screw	1
56		电机	Motor	1
55		M8 螺丝	M8 screw	1
54		M6 螺丝	M6 screw	4
53	JB-35	M6 螺母	M6 screw nut	1
52		防护罩	Shield	3
51		M6 螺丝	M6 screw	4
50		M6 螺丝	M6 screw	8
49	JB-34	M6 螺母	M6 screw nut	1
48	JB-33	活动底盖	movable bottom cover	1
47	JB-32	底盖	bottom cover	4
46		底盖固定柱	bottom cover fixed column	2
45	JB-31	20GB94-76	20GB94-76	2
44	JB-30	大皮带轮	Big pulley	2/1
43		垫卷 (包括立轴II) 二种	Pad Roll (include vertical shaft II) two kinds	1
42	JB-29	51104 轴承	51104 bearing	1
41		立轴工轴轴承盖	vertical shaft industrial bearing cap	3
40	中皮带轮内装配	6004-2 轴承	6004-2 bearing	
39	JB-28	程序 72、75 外与大被动物相同	The exterior of program 72, 75 same to the big driven pulley	
38	JB-27	小皮带轮	Small Pulley	4
37	JB-26	中皮带轮	Mid pulley	4
36		中皮带轮卷	Mid-pulley Roll	2
35	JB-25	皮	belt	2
34	JB-24	大被动物皮带轮	Big Driven Pulley	
33	JB-23	塑料	Plastics	1
32	JB-22	活动盖板	movable cover pole	2
31	JB-21	送料挡板固定块	Feed-in baffle fixed block	1
30	JB-20	送料挡板I	Feed-in baffle I	1
29	JB-19	小送料挡板	small feed-in baffle	1
28	JB-18	送料挡板II固定盖级	Feed-in baffle II fixed cover pole	1
27	JB-17	皮带轮轴	Pulley Shaft	6
26	JB-16	小皮带轮铜套	small pulley copper ferrule	2
25	JB-15	小皮带轮偏心套	small pulley side-pocket ferrule	2
24		68112 轴承	68112 bearing	1
23	JB-14	立柱内套	Vertical column inner-ferrule	1
22		6005 轴承 R5	6005 bearing R5	2
21	JB-13	油封	Oil seal	1
20	JB-12	立柱套	Vertical column ferrule	1
19	JB-11	介轮架	middle gear frame	1
18	JB-10	下箱体	lower box	1
17	JB-09	个箱体固定板	lower box fixed plate	1
16		M8 螺母	M8 screw nut	1
15	JB-08	立轴 I	vertical shaft I	1
14		51105 压力轴承	51105 pressure bearing	1
13		6200RS 轴承	6200RS bearing	1
12	JB-07	辅助齿轮	auxiliary gear	1
11		10GB894-76	10GB894-76	1
10	JB-06	立轴 II	vertical shaft II	1
9	JB-05	齿轮	gear	2
8	JB-04	垫卷二种	pad roll (two kinds)	6/4
7		M8 螺丝	M8 screw	2
6	JB-03	下箱体上盖	lower box upper-cover	1
5		M6 螺丝	M6 screw	6
4	JB-02	变速箱	Gearbox	1
3	JB-01	变速箱上盖	gearbox Upper-cover	1
2		M8 螺丝	M8 screw	4
1		M5 螺丝	M5 screw	3
序号	图 号	名 称		数量
No	Figure No.	Name		Quantity

零件明细表附图

See also list attached figure

