

Hi-Speed Carton Erector Manual

K30T

Operation Manual

User guide

This machine adopts cam mechanism, makes drive and control more stable, and easier to adjust it, its output is 30ctn/min, is the fastest and most stable case erector in Asia.

2014/2/11




Safety Precautions

(1) The types of warning labels

Please read this manual carefully before you install, use, maintain the machine.

Please confirm the equipment knowledge, safety precautions before you operate it.





This manual states any danger labels of potential danger during operating or maintaining the machine, and related protective measures.





NAME	LABEL	STATEMENT
DANGER		There is potential risk, if not avoided, may cause a serious injury.
WARNING		There is potential risk, if not avoided, may cause a serious injury.
CAUTION		There is potential risk, if not avoided, may cause a moderate injury.
NOTE	NOTE	NOTE is the additional words, to emphasize the key points.

Besides, the items of “caution” also will lead a serious problem. All words are important content with label of “WARNING”, please abide by that.

(2) SIGNS

To use correct signs, so that everybody can understand it at first sight.

Signs	meaning	signs	meaning
	General prohibition		Instruct the operators
	No touch		Must be grounding

	No split		Danger electric shock
	Be aware of fire		Caution hot

Notes for the operation



DANGER



1. Do not touch the inside parts of breaker, inverter, contactor, remote control receiver, servo amplifier, etc, in case of electric shock.



2. The terminal of manipulator control box, inverter, motor, servo amplifier and servo motor must be grounding.



3. In case of electric shock, please do inspection and wiring 5 minutes later after switch off the power.



4. Please do not damage the electric wires, in case of electric shock.



5. Please do not touch mechanic parts such as motors in case of injury.



CAUTION



1. Please use the servo motor and servo amplifier as per the drawing, in case of the fire or machine error.



2. Please keep machine away from water, corrosive gas, inflammable gas, in case of the fire or machine error.



3. Please do not touch motor, inverter, servo amplifier, servo motor, and other hot parts, in case of scald.



4. When the machine runs, please do not touch radiator, regenerative circuit and motors which at high temperature, in case of scald.

REQUIREMENT

● Emphasis:

Please read and abide by this manual before you operate or maintain the machine.

● User:

For all users who install, maintain and operate this machine.

● Application range:

Only be applicable for this hi-speed erector model.

● personnel:

The machine must be installed operated and maintained by professionals.

● Dangerous conditions

— 、 General safety instruction WARNING

● Operator safety is most important, please read this manual before maintain or inspect the machine.

● General safety instruction




Danger

In case of serious injury, please abide by:

- 1、 Two or more persons to do inspection or maintenance.
- 2、 Read and fully understand this operation manual.
- 4、 Read related technical document and this manual before you do regular inspection and maintenance.
- 5、 To stick the signs on the machine so that people can understand machine is being inspected and maintained. The sign in the breaker must be very obvious, in case of switch on the power by others.

- 6、 To stick emergency call at the working area.
- 7、 To press E-stop button in case of any emergency.
- 8、 Everybody must where the first-aid case and fire distinguisher are, in case any emergency happens.
- 9、 The machine must be switched off before inspect and maintain it.
If must inspect the machine when it runs, then need qualified person to do it.
- 10、 Be aware of the machine running parts, watch your hand.
- 11、 When maintain the machine, should have a warning board beside the machine, and switch off the general power supply; Don' t leave any tools on the machine after maintenance finished.
- 12、 Do not disassemble any parts when the machine is running, in case of injury.
- 13、 To carry any parts with weight of more than 25kg, please use special lifting equipment.
- 14、 Do not enter the non-safe area when move the heavy parts.
- 15、 The machine should be on anti-slippery floor, in case of the operator falls down.
- 16、 If need to maintain the machine on a ladder, then must have good security measures.
- 17、 When maintain the machine, must warn the people around the machine, for the sake of safety.
- 18、 Remind the people around the machine whenever maintain the machine.
- 19、 The operators should focus all attention on the maintenance, in case of any emergency.
- 20、 In the operation area, the light should be less the 300 lux.
- 21、 When open the safety doors, the machine must stop running; And double check the safety parts before restart the machine.

二、Safety instructions

The running or high-voltage parts of the machine may cause a serious injury, so, for the sake of  the security, must note the following:

危险-DANGER

- 1、 The machine must be grounded, and motors must be grounded too.
- 2、 Should release the pressure before maintain the pressure unit.
- 3、 Do not touch the rotating parts when the machine runs, in case of any damage or injury.

Notes: should stop the machine if it is running incorrectly. Then contact technical engineer to support the maintenance. Can not run the machine without the technical engineer's agreement.





CAUTION:

- 1、 Do not open the main electrical cabinet when the machine is power on.
- 2、 Be aware of the safety on the parts where there is a sign of “CAUTION” .

三、Machine safety signs

All following signs are warning signs.

 <p>6043 -ISO Burn Hazard</p>	 <p>Caution, Hot</p>
 <p>6010 -ISO Electrical Shock Electrocution (RECOMMENDED)</p>	 <p>Danger, Electric shock.</p>

 <p>1018 -ISO Hand Entanglement Rotating Rollers (Right)</p>	 <p>Mind your hand</p>
 <p>1052 -ISO Hand Entanglement Belt & Rollers (Upward)</p>	 <p>Be aware of the running parts</p>
 <p>6014 -ISO General Danger</p>	 <p>Caution</p>
 <p>5062 -ISO No Access For Unauthorized Persons</p>	 <p>No entry</p>
	 <p>To prevent slipping</p>

For PE terminals, especially the main wire, put on the sign of “PE” or



四、 Dangerous parts

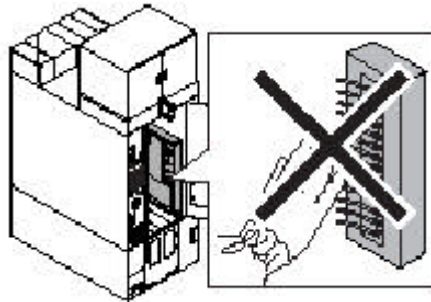
- 1、 high current circuit
 - AC380 & 220V circuits both are high current.
 - Should cut off the power supply first when the machine connect the outer power.
 - There are AC380V and 220V circuits on the machine, should switch off the power when maintain the machine.
 - Five minute later after switch off the power, then can maintain the high current parts, because capacitor discharging takes time. Contact one service engineer to support any main maintenance.

2、 high voltage

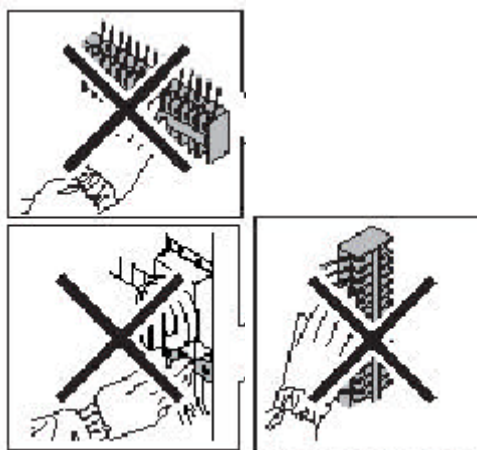
There are high voltage units on the machine, such as electric cabinet, so, must very careful during the maintenance for this part.



- Do not touch the terminal panel.
- It is very dangerous for the maintenance during the maintenance if the machine switch on. So, must switch off the machine, and lock the main switch.



The parts related with high voltage (electric cabinet, contribution box)



The terminal panels in electric cabinet.

- Do not touch the terminal panels in the electric cabinet and make sure switch off the power before maintain the machine.
- Do not touch the terminal panels in the wiring box and make sure switch off the power before maintain the machine.

3、 screw and bolt

In case of any injury, please keep away from variable frequency motor, servomotor and pneumatic parts.



If you touch any drive parts, or your hair, your sleeve or glove touch

the drive parts, may cause a serious body injury.

4、Moving parts.

- When the machine runs, keep away from case pushing block, moving fold and needles in the magazine, in case of any injury.

五、locking/unlocking program

Explanation for locking/unlocking program.

Its purpose is to prevent the operator from any injury by machine start unexpectedly. So, it is necessary during the maintenance.

The lock in this program is unique, exclusively for locking the 在 dangerous power supply.

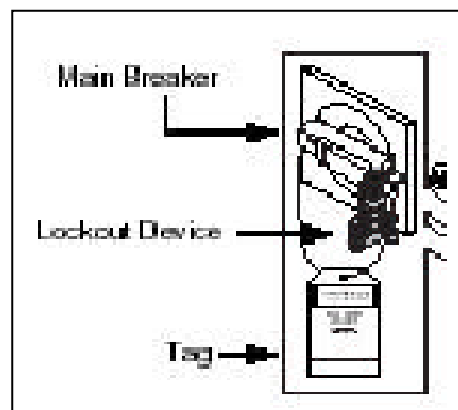


To switch off the machine and lock the program, in case of somebody start the machine unexpectedly.



- After unlock the program, double check people' s security before restart the machine.
- Everybody should have his own padlock to lock the machine when repair it, to avoid others starting the machine without the consent.

The picture of padlock of the main Switch as shown below:



Main switch location

六、 Requirement for the installation floor

1、 basic condition of the machine

- Power supply: 3AC/380V/50Hz;
- air pressure: >0.5Mpa;
- Workshop temperature should not higher than 45℃ , One day average temperature should not higher than 35℃ ;
- 24-hour works continuously, the machine and electric accessories should not overheat. E.g. running temperature cannot overheat.
- After installation, should leave enough space around the machine, for the normal production and maintenance.

2、 Environmental requirement

Operating temp	+5℃—+45℃
Transportation or storage temp.	–25℃—+55℃, if temp. is more than 70℃ , time should less than 24h
Elevation	Less than 1000m; if higher than 1000m, the motor rated power will decrease 1% in every 100m higher, the max. elevation is 4000m.
Humidity	At 40℃ , RH less than 50 % 。 If low temperature, then high RH is ok. (e.g. 20℃ , RH 90%)。
Atmosphere	Without inflammable, corrosive material and dusts.
Electromagnetic compatibility (EMC)	The EMC of the machine should be consistent, running correctly.
lighting	More than 300 lux

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PREFACE

Thanks a lot for using our Hi-speed Case Erector.

With the rapid development of automation industry, the output of automatic production lines have become higher and higher: Filling machine, Case Packer, Wrapping Machine, and so on, their speed become faster and faster. Under such circumstances, we developed our hi-speed carton erector.

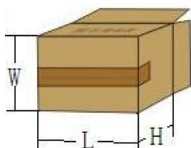
This Hi-speed Carton Erector' s output is 30 ctn/min, can save 本 4-6 manpower; the magazine can load 70-100 cartons (depends on the carton thickness), the carton magazine is horizontal type, we can load the cartons into it anytime, and there is an auto pre-warning system, remind the operators to add the cartons. The machine adopted CAM drive system, main power controlled by one motor, meantime, the integrated drive system makes machine' s operation and adjustment easy and simple, and machine running more stable, and there is an alarm system for the abnormal cartons in the magazine.

This hi-speed carton erector has been tested many times on site, we have our own patents for machine shape, structure and safety system, it is popular in our users.

This manual illustrates the machine structure, operation instruction, and notes for the operation. So as to use the machine properly, to prolong its working life. Please read the manual carefully before operation, and make sure this manual is in the end-user's hand, the technical changes at any time without prior notice.

一、Machine Attributes

1.1 Main Parameters

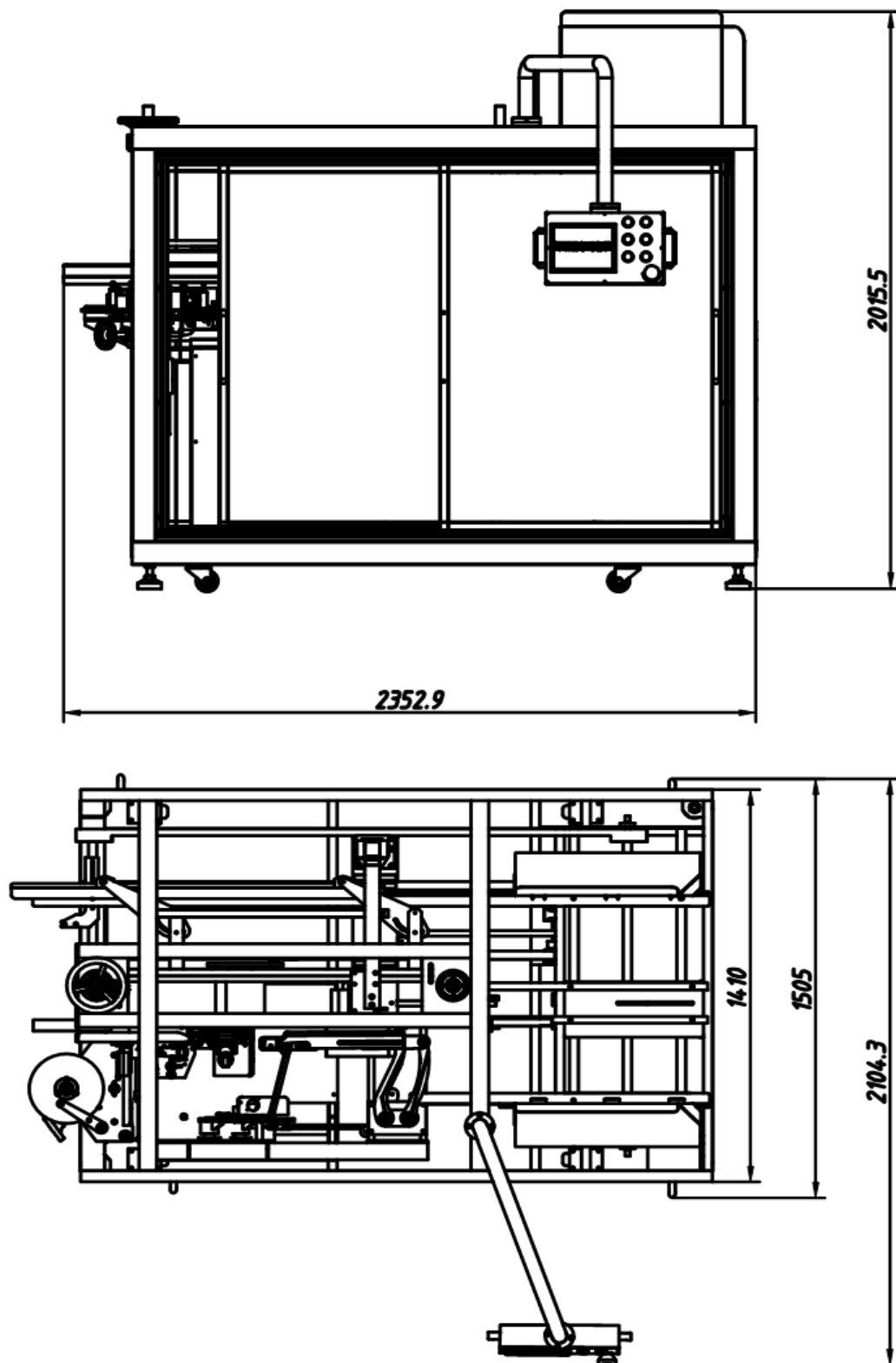
Speed	30ctn/min(Max. 35ctn/min)	
Magazine volume	App. 70 cartons(800mm)	
Taping method	50W tape I -type taping	
Power (1kw)	Main motor power	750W
	Power supply	AC 380V(AC 220V) 3ø 746W
	Air switch	20A
Air pressure	0.5-0.7MPa	
Air compressor power	3HP	
Air consumption	App. 300L/min	
Erecting size	 L=240-510mm W=190-400mm H=120-400mm	

1.2 Basic function

- Operation guide in the menu, amend parameter in the software, easy to learn and convenient to operate it.
- Password control, prevent any wrong operation.
- Switching power supply, ensures systematic anti jamming capability
- Multipolar errors control and alarm function.
- Can set regular inspection function
- Complete data record, print and communication interfaces.
- Contactless output control solenoid valve, ensures the working

life of relay, to satisfy high frequency running requirement.

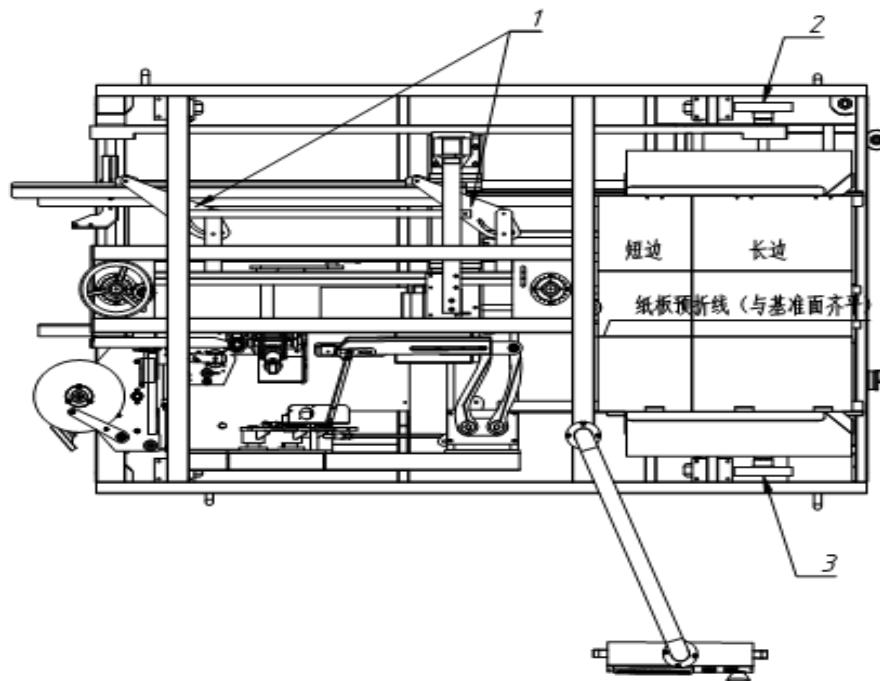
1.3 Main Overall Dimension



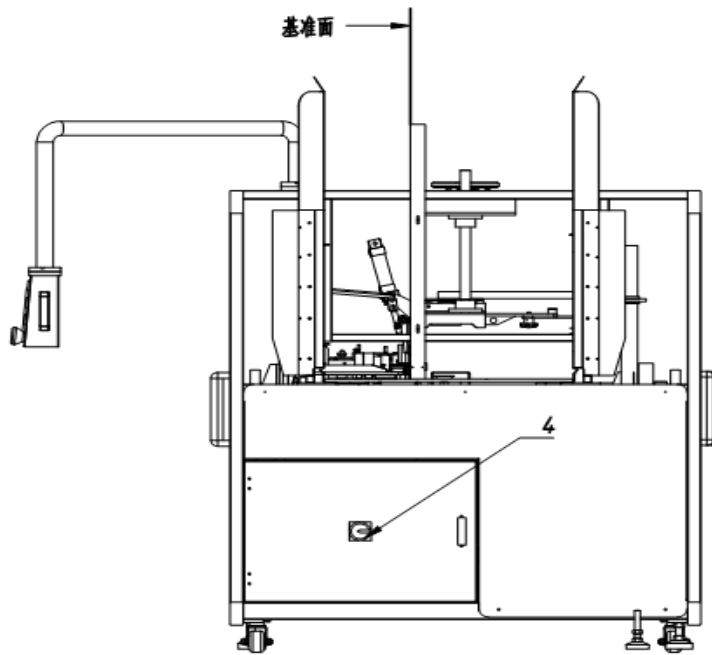
二、 Name of machine parts and operation instructions.

2.1 name of machine parts

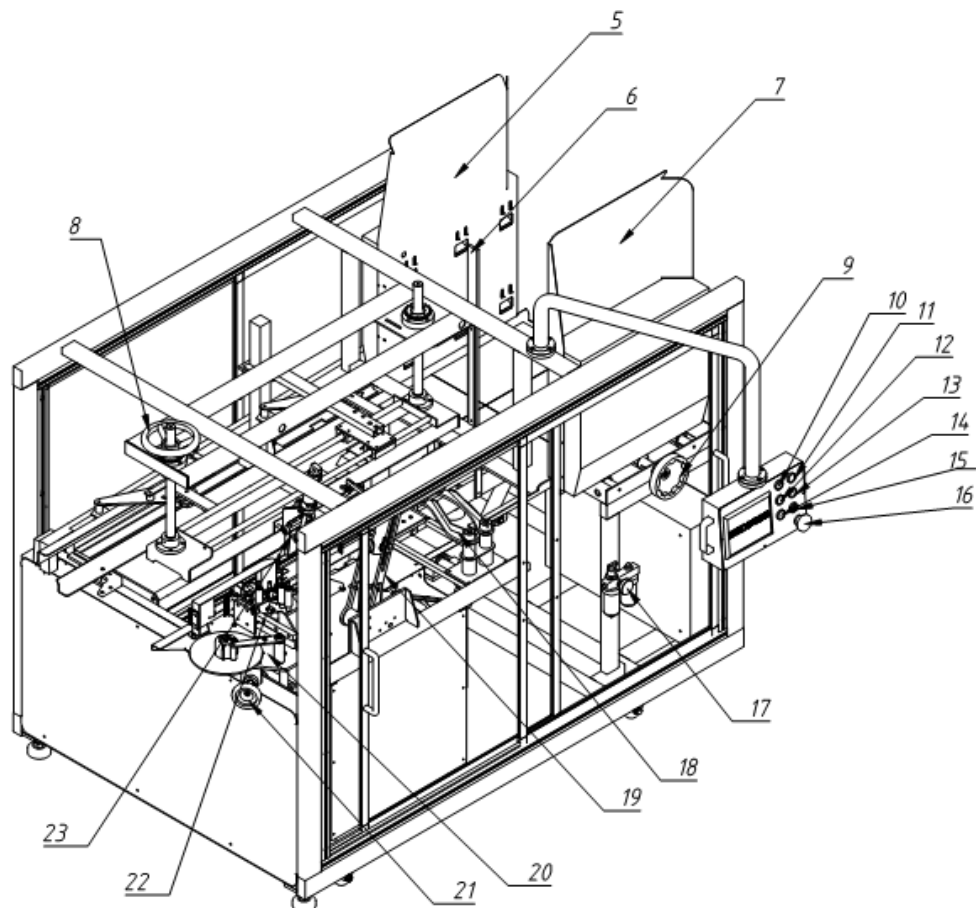
(1) front view



(2) right view



(3) axonometric drawing



1. Right upper backplate of case feeding
2. Case width adjusting hand wheel
3. Case height adjusting hand wheel

4. Power switch
5. Magazine(right)
6. Datum plate
7. Magazine(left)
8. Case forming width adjusting hand wheel
9. Case width adjusting hand wheel
10. Start button
11. Reset button
12. Inching button
13. Stop button
14. Left safety door indicator
15. Right safety door indicator
16. Emergency stop button
17. Air source switch
18. Back flap folding parts
19. Case erecting parts
20. Baseboard of tape head
21. Tape head height adjusting hand wheel
22. Front flap folding parts
23. Upper flap folding parts
24. Lower flap folding parts

2.2 Machine Operation Instructions

1. To start the machine

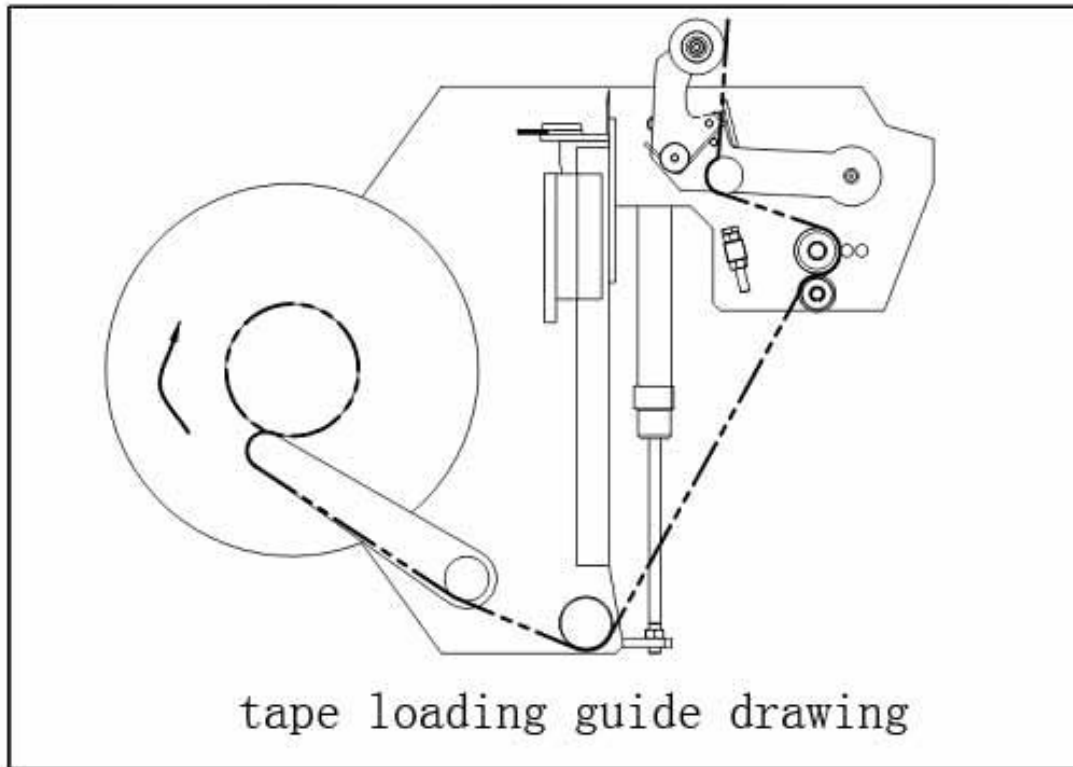
Rotate 4 (see above image, below) power switch to “ON” , slide 17 air source switch, air pressure keep at 0.5MP or more. The green indicator is lighting when machine runs.

- 2.Preparations (adjusting for the different cartons)

- a、 Adjust 6 datum plate according to the thickness of cartons, make sure one carton can pass through it completely, other cartons will fully got stuck on the datum plate.
- b、 Rotate hand wheel 3 to make cardboard’ s folding line aligns at 6 datum plate.

- c、 Rotate hand wheel 2 to make magazine' s width 1-2 mm bigger than that of cardboard.
- d、 Manually fold one carton and put it on the exit of erected cartons, which is at the end of machine, then rotate hand wheel 8 pressing plate at a suitable position.
2-3mm higher than the carton(according to the carton width),mark down the measurement, it helps you to find the correct height in the shortest time.
- e. hold down the carton side with the right-up pressing plate by adjusting the hand wheel 1---remember to make it loosen at the right way, not too tight.
- f. adjust the hand wheel 19, make the sucker on the dead plate 2~3cm higher than the pressing board driven by the hand wheel 8. Remember to mark down the measurement to make it on the right height in the short time.
- g. keep the carton sealing line on the middle of the Rubber Roller on the tape head by adjusting the hand wheel 21.
- h. push bottom 11,loading the cartons into the magazine, push the small-step-moving bottom 12 to form one carton firstly. Check and adjust the carton Marginal Adaptation to make it fit for the machine and reached the highest packing speed.
- i. Push bottom 10 to make it working continually.

2.3 loading the tape method



one. TROUBLE SHOOTING

1. when the tape running away and cannot stick on the carton (Red indicating light on)

Reason:

1. Tape may get stuck too tight
2. Tape quality problem---not sticky (overdue)
3. The reset spring broken
4. Loading the tape in the wrong way

Trouble shooting ways:

1. Loosen the pressing spring on the tape wheel
2. Replace the new tape
3. Replace the new reset spring
4. Check and change the correct tape loading way

2. FAIL TO DETECT AND GET THE CORRUGATED CARTONS TO FORM THEM (RED INDICATING LIGHT ON)

Reason:

1. Air-pressure is not good enough
2. Too much water in the gas storage
3. The vacuum filter gets stuck
4. Carton material is not good
5. There're broken holes on the carton where should binding on the machine
6. The position-sucker, the carton forming sucker broken, or 取 the

switchover valve broken.

7. Load the cartons on the opposite way

Trouble shooting:

1. Check the air-pressure
2. Release the water into the gas magazine on time to keep it working well
3. Clear the vacuum filter on time
4. Use better quality cartons
5. Change the binding way of the cartons
6. Inform the after-sale service to replace the new spare parts
7. Load the cartons in the correct way

3. THE MACHINE DOESNOT WORK WHEN YOU PUSSH THE START BUTTOM

REASONS:

1. There' s something get stuck on the machine where to form the new carton
2. Left and right safety door are opened(yellow indicating light on)
3. There' s dust on the sensor
4. The motor is over charge(red indicating light on)

TROUBLE SHOOTING WAY:

1. Move away everything get stucked and re-push the start buttom
2. Cloese the doors and restart the machine
3. Clear the sensor and restart the machine
4. Check if there' s something getting stuck on the conveyor system, if not, please contact our after-sale serviceto help

4. THE MACHINE KEEP MAKING NOISE AND THE YELLOW INDICATING LIGHT
KEEP ON WHEN THE MACHINE IS WORKING

REASONS: there's lack of cartons in the magazine

Trouble shooting way: loading more cartons into the magazine

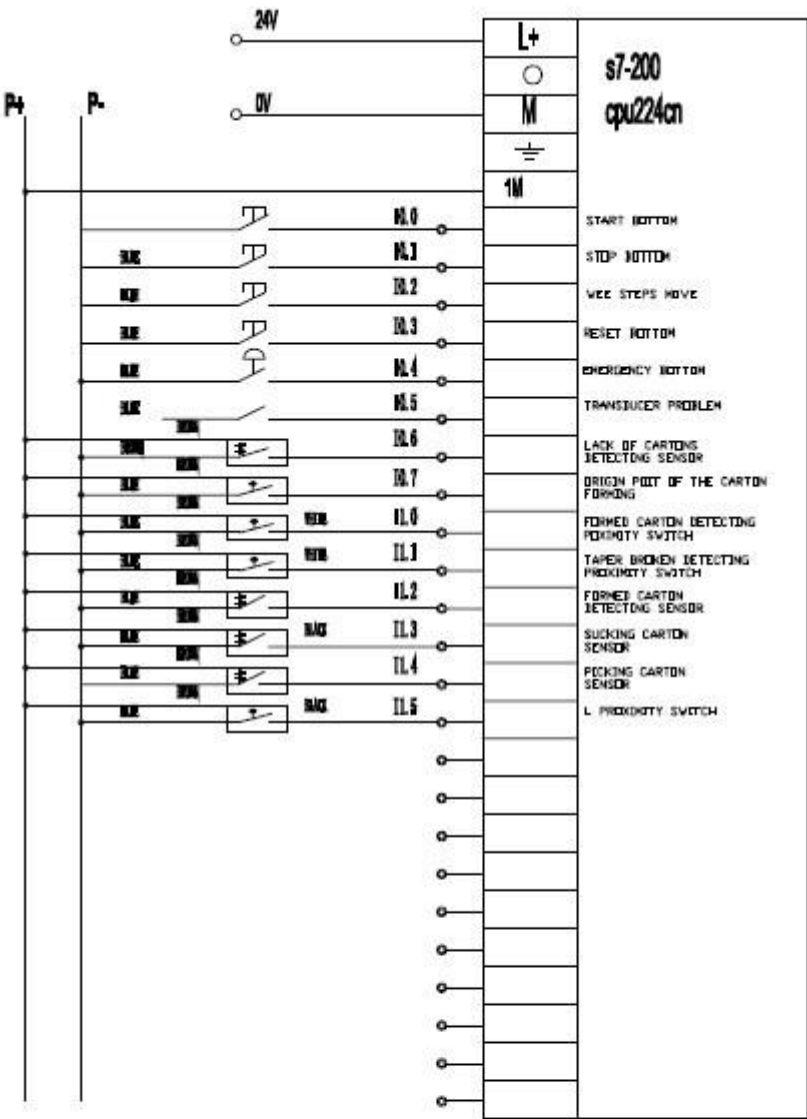
三、 MACHINE MAINTAINANCE

1. There's the vacuum system adopted on the high speed carton erector. In this case, it is easy to accumulate the dust into the vacuum parts. When you found the machine sucking the cartons slower, please check and clean the vacuum filter parts to keep it working well again. It would be much better to keep cleaning this part everyday to make it working well and long life service.

2. before starting the machine, please check if there's air leaking happening on the cylinder. You'd better operate the machine manually to see if every part is working smoothly and stably to finish one continual working day.

3. checking the leading screw parts and spray the lubricating oil on time by one experienced operator. Add NO.2 or NO.3 Lithium base grease will be good enough.。

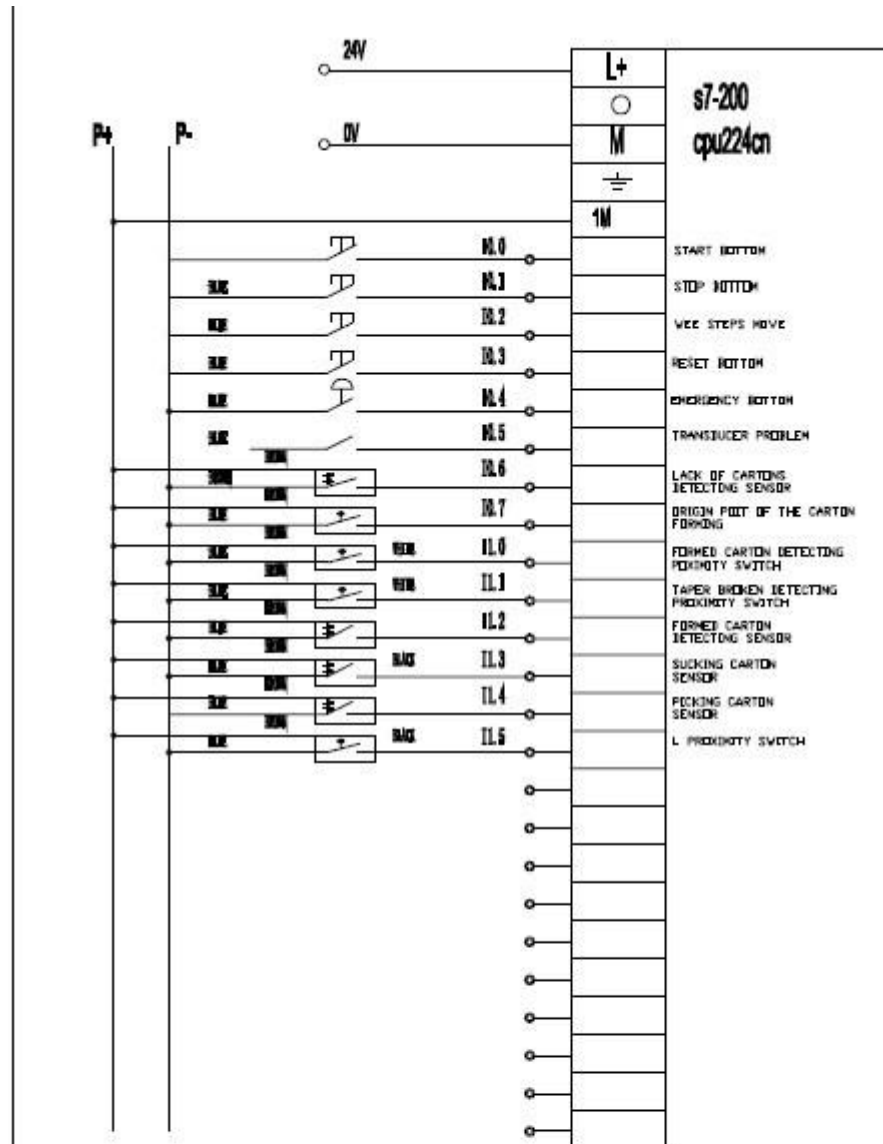
5.2 PLCCONTROL CIRCUIT DIAGRAM (INPUT MAIN DRAWING)



MAIN PLC INPUT POINT

				PLC circuit diagram				30CTN/MIN CIRCUIT DIAGRAM			
REV	REVISION	DATE	SIGN	REMARK				QTY	WGT	SCALE	
0001	00000001							1			
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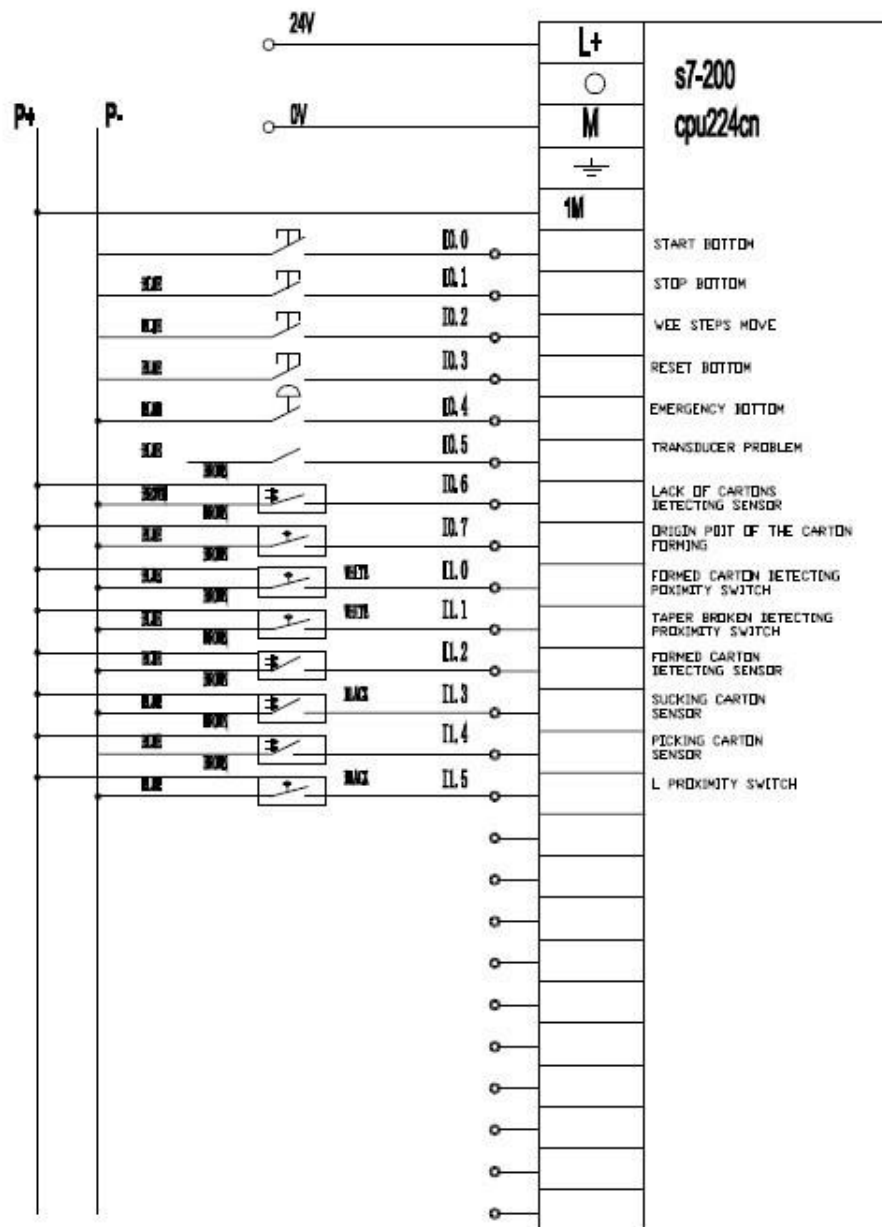
5.3 PLC CONTROL CIRCUIT DIAGRAM (OUTPUT DRAWING)



MAIN PLC INPUT POINT

PLC circuit diagram				30CTN/MIN CIRCUIT DIAGRAM			
REV	DATE	SIGN	DATE	REMARK	QTY	WGT	SCALE
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0100		0100					

5.4 PLC CONTROL CIRCUIT DIAGRAM (DRIVING CIRCUIT DRAWING)



MAIN PLC INPUT POINT

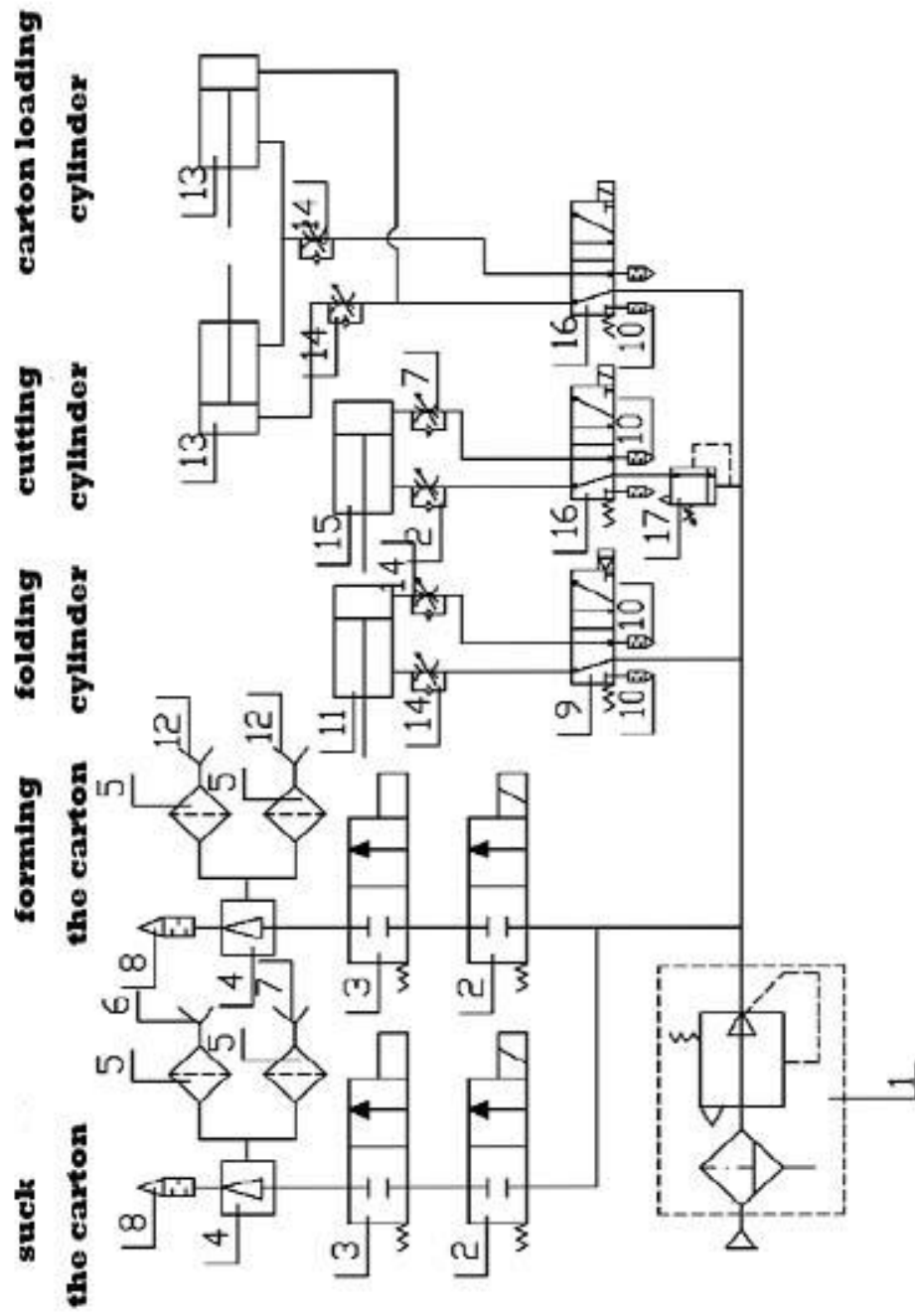
5.5 ELECTRICITY BOX LAYOUT

NO.	BRAND	NAME	MODEL	QTY	DEMO
1	SIMENS	PLC	6ES7 214-2AD23-0XB8	1	
2	SIMENS	PANEL	6AV6 648-0AC11-3AX0	1	
3	MITSUBISHI	TRANSDUCER	FR-D720S-1.5K-CHT	1	
4		PLC AND WIRES FOR THE PANEL		1	

5	SIMENS	PLC	6ES7 223-1BH22-0XA8	1	
6		BRAKE AND CLUTCH	CDF0S6AA DC24V	1	
7	LEUZE	SENSOR SWITHC	318K/N-100.11	2	
8	IDEC	RELAY	RM2S-UL 24V	10	
10	SCHNEIDER	BRAKER	OSMC32N3C16 3P 16A	1	
11	SCHNEIDER	BRAKER	OSMC32N1C10 10A 1P	1	
12	SCHNEIDER	BRAKER	OSMC32N1C5 5A 1P	1	
13	TAYEE	CAM SWTICH	LW42B2-1824/LF01	1	
14	IDEC	E-STOP	YW1B-V4E01R (KEEP OFF)	2	
15	IDEC	START BUTTOM	YW1B-M1E-10/G (KEEP ON)	1	
16		FUSE HOLDER	RT28N-32X	2	
17		FUSE	10A 1 个 5A 1 个	1	
18	IDEC	INDICATING LIGHT-RED	YW1L-1BUQ4R	1	
19	SCHNEIDER	POWER SWITCH	ABL2REM24020	1	
20	LEUZE	SENSOR SWITCH	HRTR 3B/2.7	4	
21	SICK	PROXIMITY SWITCH	1ME12-04NNSZW2K	5	
24	QLIGHT	TRI-COLOUR LIGHT	ST452LF-BZ-3-24V-YGR	1	
25	IDEC	STOP BUTTOM	YW1B-M1E-101S	2	BLUE KEEPS ON
26	IDEC	STOP BUTTOM	YW1B-M1E-101R	2	RED KEEPS ON
27	SMC	PRESSING BUTTTOM	ISE30A-01-N-L	1	
28	IDEC	STOP BUTTOM	YW1B-M1E-10Y	2	YELLOW KEEPS ON

5.6 SPARE PARTS OF THE ELECTRICITY BOX

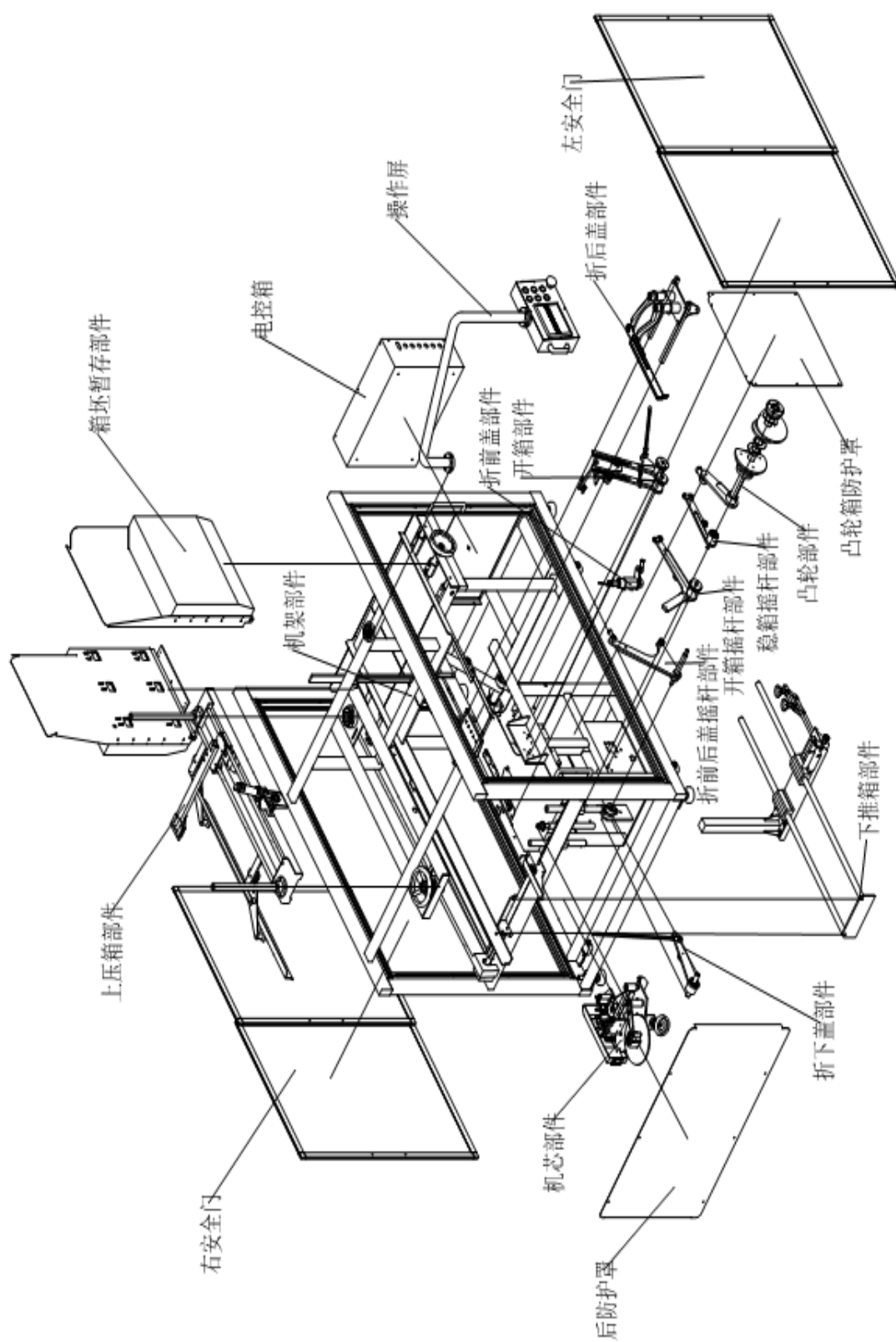
五、PNEUMATIC PARTS



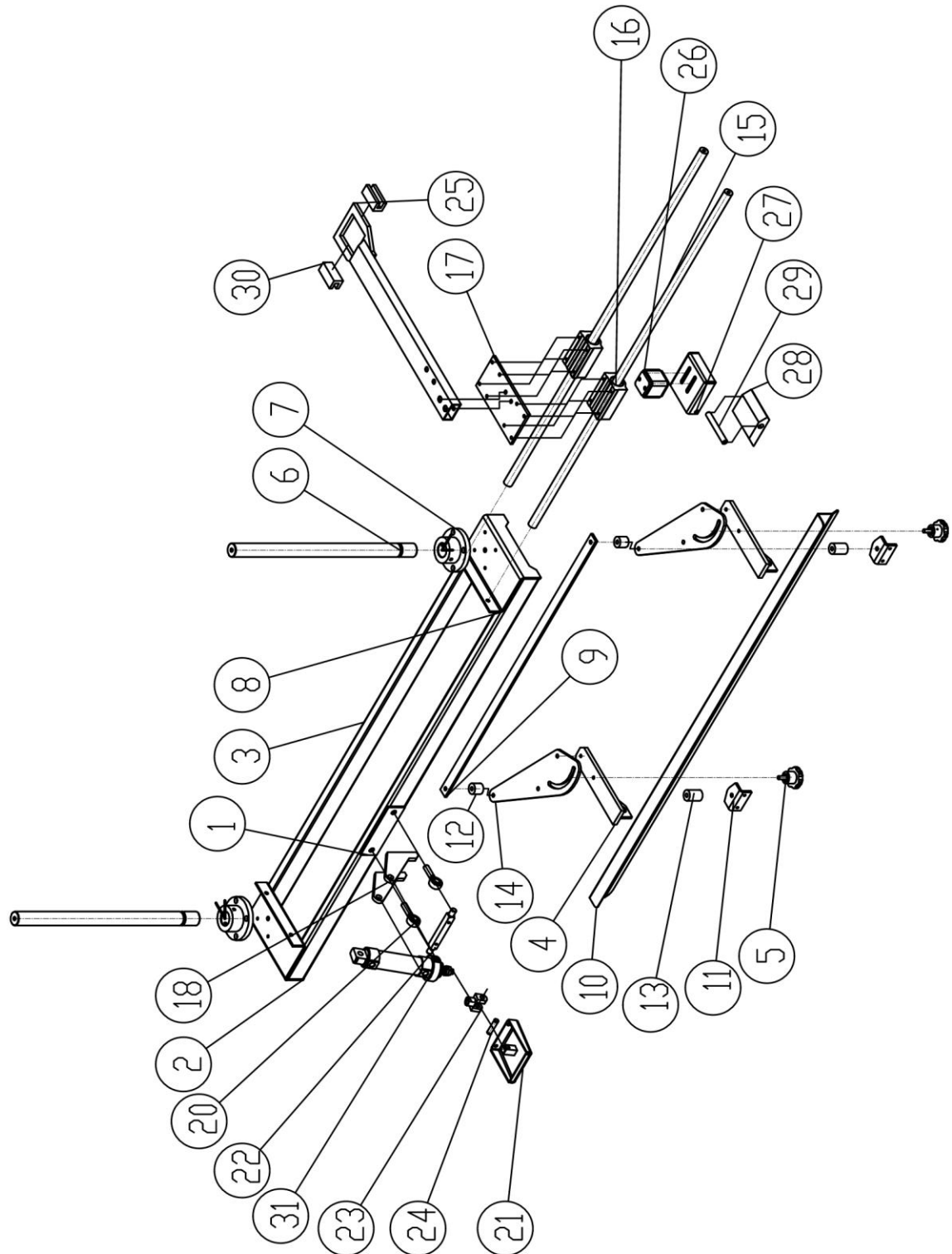
NO.	NAME	MODEL			QTY	DEMO
1	AIRING PARTS	AC30A-03DG			1	SMC
2	VALVE	VX210MG			2	SMC (with installation attached)
3	Tri-way links mechanical valve	VM230-02-01S			2	SMC
4	Vacuum generator	SEJ-20HS			3	SANWO (Korea)
5	Vacuum filter	VF-3			4	CONVUM (Janpan)
6	Vacuum sucker	PFYK-50N			2	CONVUM (Janpan)
7	Vacuum sucker	PJYK-50N			2	CONVUM (Janpan)
8	silencer	PT1/4'			1	SMC
9	Five-way links mechanical valve	VFM350-02-01S			1	SMC
10	silencer	PT1/8'			6	SMC
11	cylinder	CG1UA40-75			1	SMC (with earing axle)

12	Vacuum sucker	PJYK-70N			4	CONVUM (Janpan)
13	cylinder	DAI-40M40CBP			2	HINAKA (Twaiwan, Chi na and Janpan)
14	One-way throttle valve	1/8' -Dia. 8			4	SMC
15	cylinder	DIC-20M120+PPV			1	HINAKA (Twaiwan, Chi na and Janpan)
16	Magnetic valve	SY5120-5GD-01			2	SMC
17	Adjusting valve (with meter)	1/4'			1	SMC

六、APPOSE: MAIN PARTS DRWAING SAPERATE



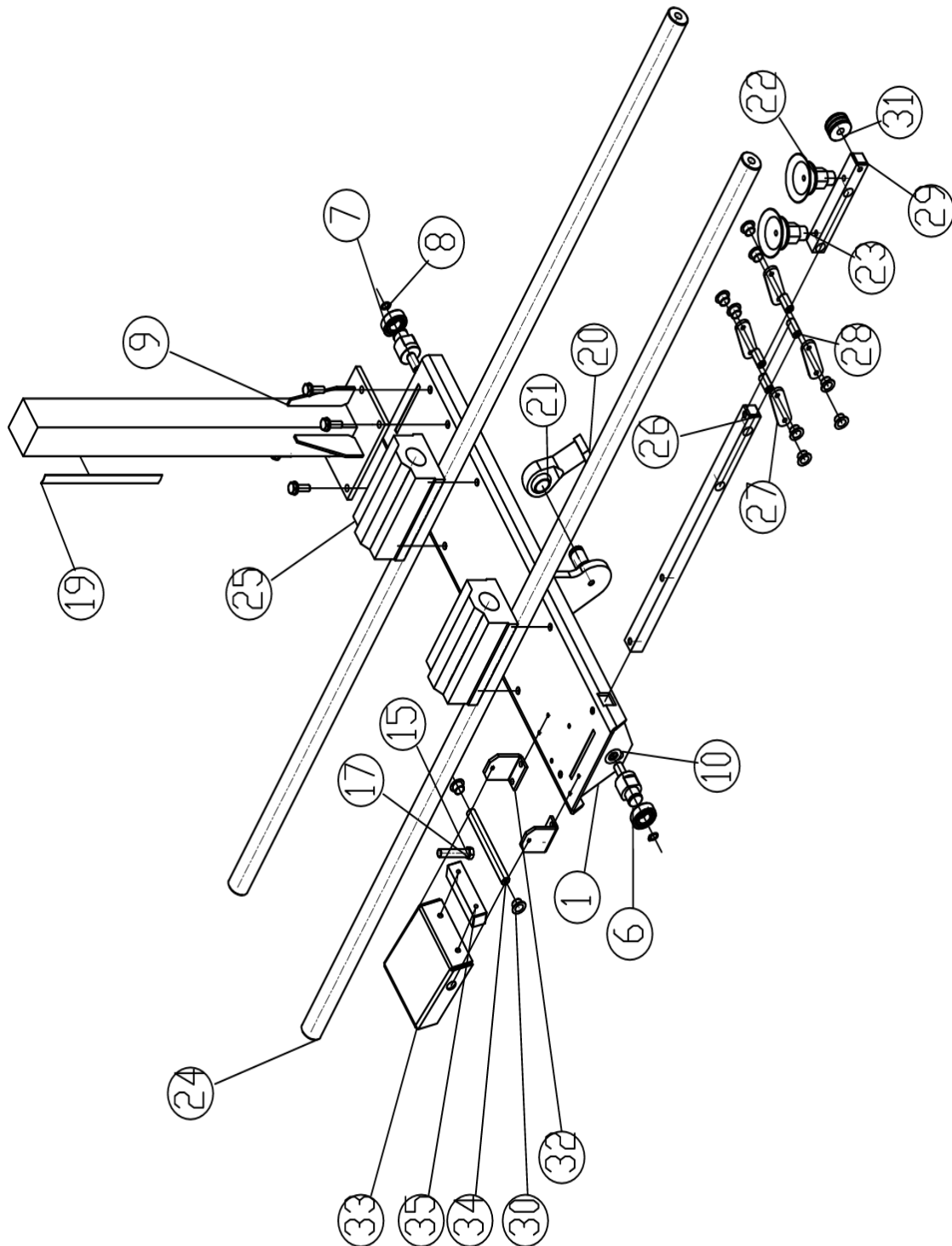
7.1 Assembly drawing and parts list of top pressing carton component



No.	Part No.	Description	Qty
1	K30T-2001-01 connecting pipe		1
2	K30T-2001-02 connecting plate		1
3	K30T-2001-03 connecting pipe 2		1
4	K30T-KF3A-4101-03AA Adjusting carton height rack	Adjusting carton height rack	2
5	K30T-Star type handle		2
6	K30T-KF3A-4106 Pressing carton moving lead screw	Pressing carton moving lead screw	2
7	K30T-KF3A-4105AA Pressing carton moving flange	Pressing carton moving flange	2
8	K30T-2001-04 connecting plate 2		1
9	Top lip synchronizing bar	Top lip synchronizing bar	1
10	K30T-7002 Top baffle	-	1
11	K30T-KF3A-4122AA Top lip mounting plate	Top lip mounting plate	2
12	K30T-KF3A-4125 Top lip synchronizing bar gasket A	lip synchronizing bar gasket	2
13	K30T-KF3A-4123 Top lip gasket A	Top lip gasket	2
14	K30T-KF3A-4124 Top lip adjusting plate	Top lip adjusting plate	2
15	K30T-2002 Top guide bar		2
16	LMA20LUU		2
17	K30T-2003 Top sliding block connecting plate		1
18	K30T-2001-05 Cylinder mounting plate		4
19	12 rod end main body		2

20	12 rod end bearing ball		2
21	K30T-2004 Top folding plate		1
22	K30T-2005Top folding plate back shaft		1
23	Y-type connector		1
24	Elbow joint axis pin		1
25	K30T-3002 Top pushing carton platform		1
26	K30T--KF3A-3112 Top pushing carton setting block	Top pushing carton setting block	1
27	K30T--KF3A-3113AA Top pushing carton fixed seat	Top pushing carton fixed seat	1
28	K30T--KF3A-3115 Top pushing carton plate	Top pushing carton plate	1
29	K30T--KF3A-3114 Top pushing carton plate axle	Top pushing carton plate axle	1
30	K30T-2006 Pushing carton bumper block		2
31	DSNU_40_75_PPV		1
32	3763_M38x1_5		1
33	DSNU_40_75_PPV		1
34	DIN_439_B__M12x1_25_F_		2

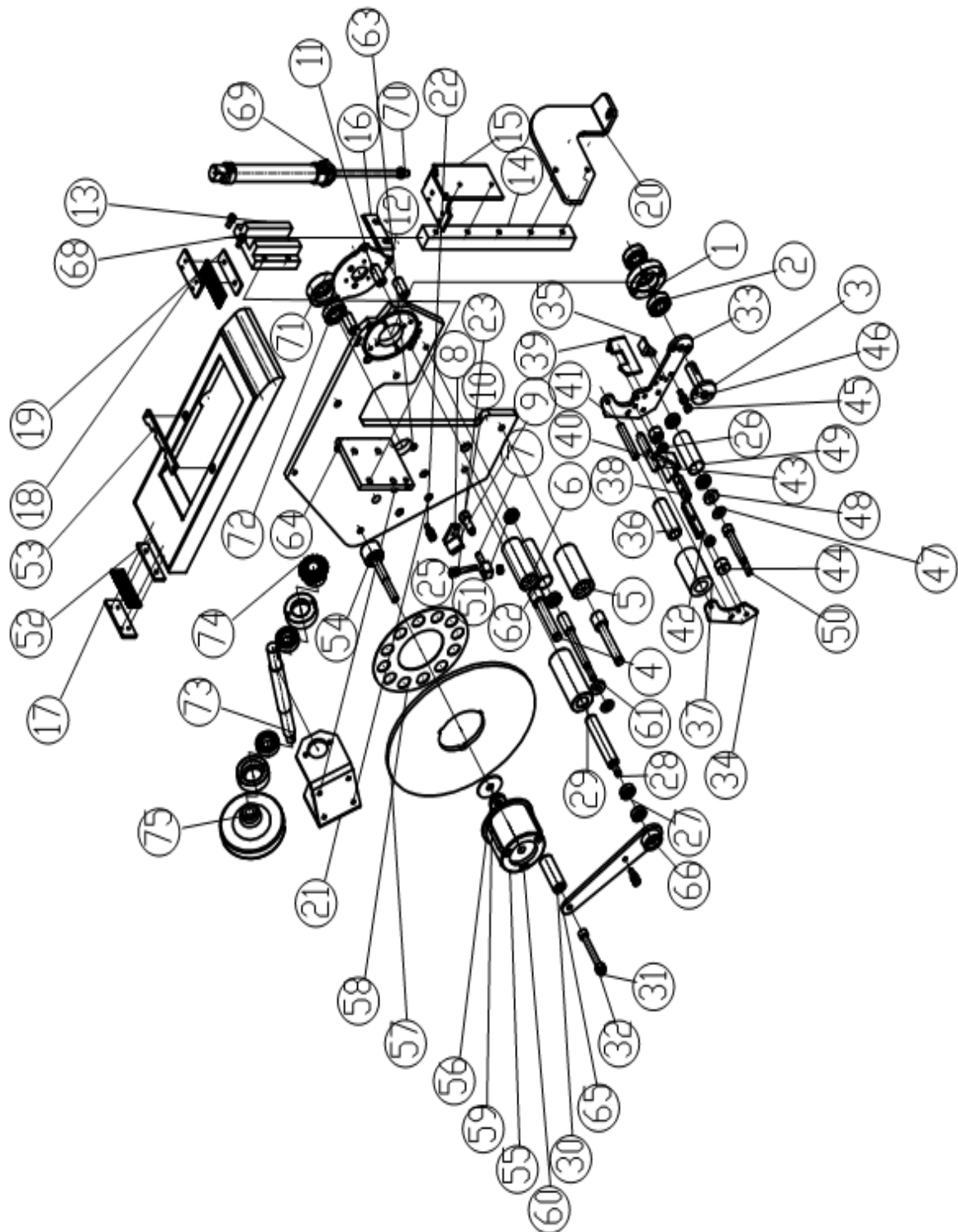
7.2 Assembly drawing and parts list of bottom carton moving component



No.	Part No.	Description	Qty
1	K30T-3101	Bottom pushing carton platform	1
2	K30T- Bottom pushing carton supporting seat	Bottom pushing carton supporting seat	2
3	K30T-3103	Axis pin	1
4	K30T-3105	Bottom pushing carton plate	1
5	K30T-3106	Counter weight	1
6	K30T-3107	Roller	2
7	Rolling bearings 6003 GB 276-94		2
8	circlips for shaft		2
9	K30T- connecting rod	connecting rod	1
10	GB_FASTENER_WASHER_PWNA 12		2
11	spring lock washers--normal type gb		1
12	GB_FASTENER_NUT_SNAB1 M12-N		1
13	GB_FASTENER_WASHER_PWNA 8		6
14	GB_FASTENER_WASHER_SW 8		2
15	GB_FASTENER_NUT_SNAB1 M8-C		1
16	GB_FASTENER_BOLT_HHBFTC M8X25-C		4
17	K30T-Pushing carton pipe		1
18	hexagon socket head cap screws		2
19	K30T- scaleplate —		1
20	JF20 rod end main body		1

21	JF20 rod end bearing ball		1
22	189315_ESS_60_SU		2
23	189211_ESH_HB_5_G		2
24	K30T-3001bottom carton pushing guide rod		2
25	SC30WUU linear bearing		2
26	K30T-fixed major axis		1
27	K30T- block connecting plate		4
28	K30T- connecting shaft		4
29	K30T- Sucker installation axle		1
30	K30T- Axis Guide B		10
31	K30T- nylon wheel		1
32	K30T-carton pushing mounting plate		2
33	K30T- carton pushing plate 2		1
34	K30T- carton pushing plate axle		1
35	K30T-Weight block		1

7.3 Assembly drawing and parts list of tape head



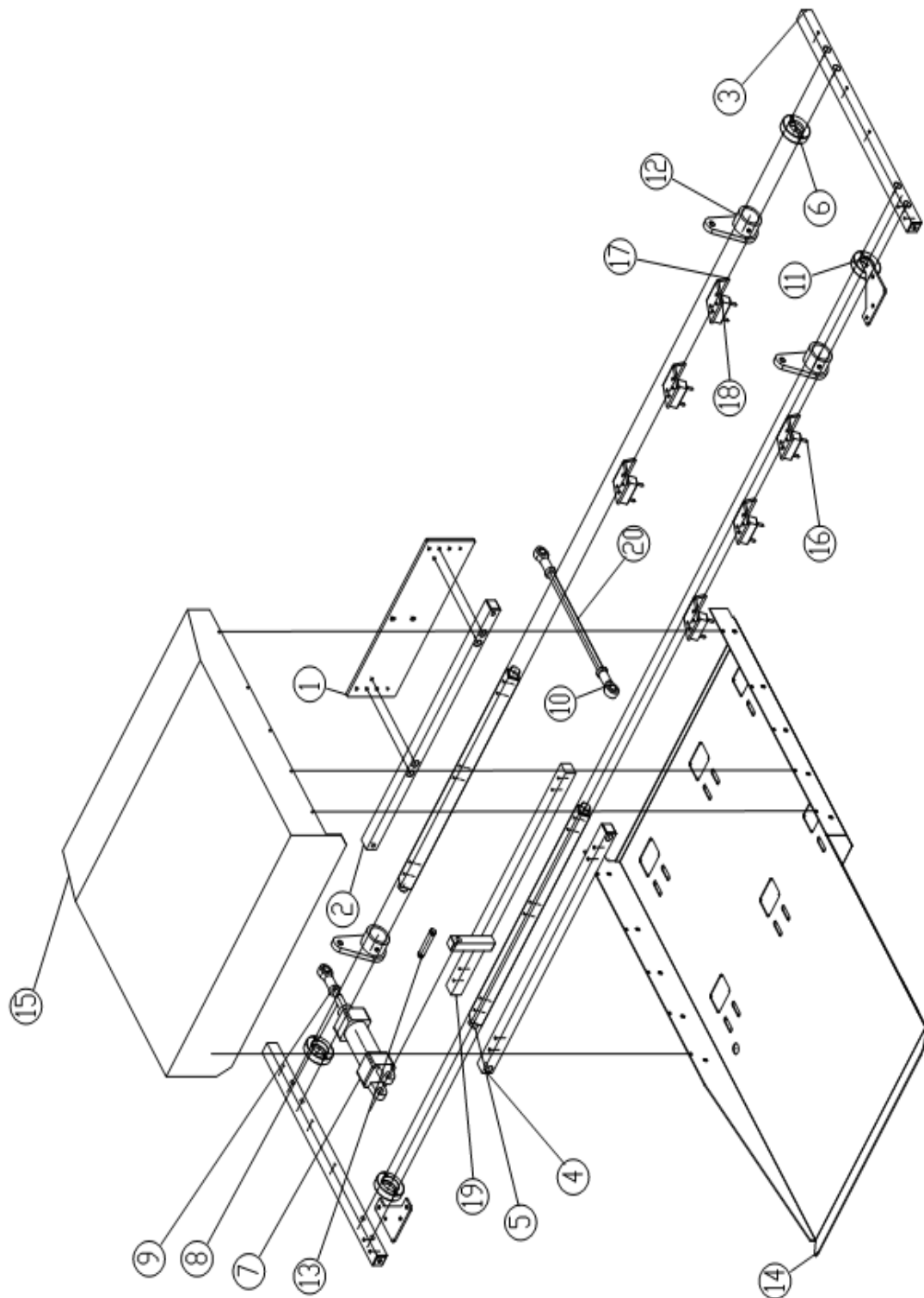
No.	Part No.	Description	Qty
1	K30T-6000braking bearing block		1
2	Rolling bearings 6202 GB 276-94		2
3	K30T-6000 braking Installation axle		1
4	K30T-6000 tape setting shaft B		2
5	K30T-6000tape setting B		1
6	K30T-6000 tape setting D		1
7	K30T-6000 square Short screw		1
8	K30T-6000 protection block		1
9	K30T-6000 protection gommures		1
10	K30T-6000 stuck spring shaft		1
11	K30T-6000 Cushion column		3
12	K30T-6000 braking mounting plate		1
13	K30T-6000HGW25CA		1
14	K30T-6000280 (HG25) guide rail		1
15	K30T-6000moving Brush mounting plate		1
16	K30T-6000 Blade		1
17	K30T-6000 Brush clamping piece A		2
18	K30T-6000Brush A		2
19	K30T-6000Brush bulkhead		2
20	K30T-6000Cylinder dragging plate		1
21	K30T-6000 mounting plate of moving handle		1

22	GB_FASTENER_BOLT_HHBFTC M6X20-N		2
23	GB_HEXAGON_TYPE13 M6 Normal Style-N		4
24	GB_HEXAGON_TYPE13 M8 Normal Style-N		1
25	GB_FASTENER_BOLT_HHBFTC M6X40-N		1
26	Rolling bearings 619-6 GB 276-94		2
27	Rolling bearings 608 GB 276-94		2
28	K30T-6000 tape setting shaft A		1
29	K30T-6000 tape setting A		1
30	K30T-6000 nylon cover55		1
31	ISO 4762 M8 x 70 --- 70N		1
32	Hexagon Nut ISO - 4034 - M8 - N		1
33	K30T-6000 bonding mounting plate B		1
34	K30T-6000 bonding mounting plate A		1
35	K30T-6000 baffle plate		1
36	K30T-6000 Rubber inner sleeve		1
37	K30T-6000 Rubber roller		1
38	K30T-6000 square axle A		1
39	K30T-6000 slotted plate		1
40	K30T-6000 blendboard		1
41	K30T-6000 Fixed axle		1
42	K30T-6000 Fixed axle for block		1
43	K30T-6000 Fixed block		1

44	K30T-6000 bearing block		2
45	GB_FASTENER_BOLT_HHBC M6X30-N		1
46	GB_FASTENER_NUT_SNC1 M6-N		1
47	K30T-6000 chucking gasket		2
48	K30T-6000 nylon gasket		2
49	K30T-6000 tape setting E		1
50	K30T-6000 tape setting shaft E		1
51	Rolling bearings 61900 GB 276-94		4
52	K30T-6000Carton baffle		1
53	K30T-6000Tape baffle		1
54	K30T-6000 Tape installation axle		1
55	K30T-6000Tape installation cover		1
56	K30T-6000 locknut M10		1
57	K30T-6000 Perspex sheet		1
58	K30T-6000SUS tape base plate		1
59	K30T-6000gasket 40		1
60	K30T-6000Spring prepreg		3
61	K30T-6000 tape setting shaftC		1
62	K30T-6000 tape setting C		1
63	K30T-6000 Tape head baseplate		1
64	K30T-6001-2 mounting plate of linear bearing		1
65	K30T-6000 rotary swing arm A		1

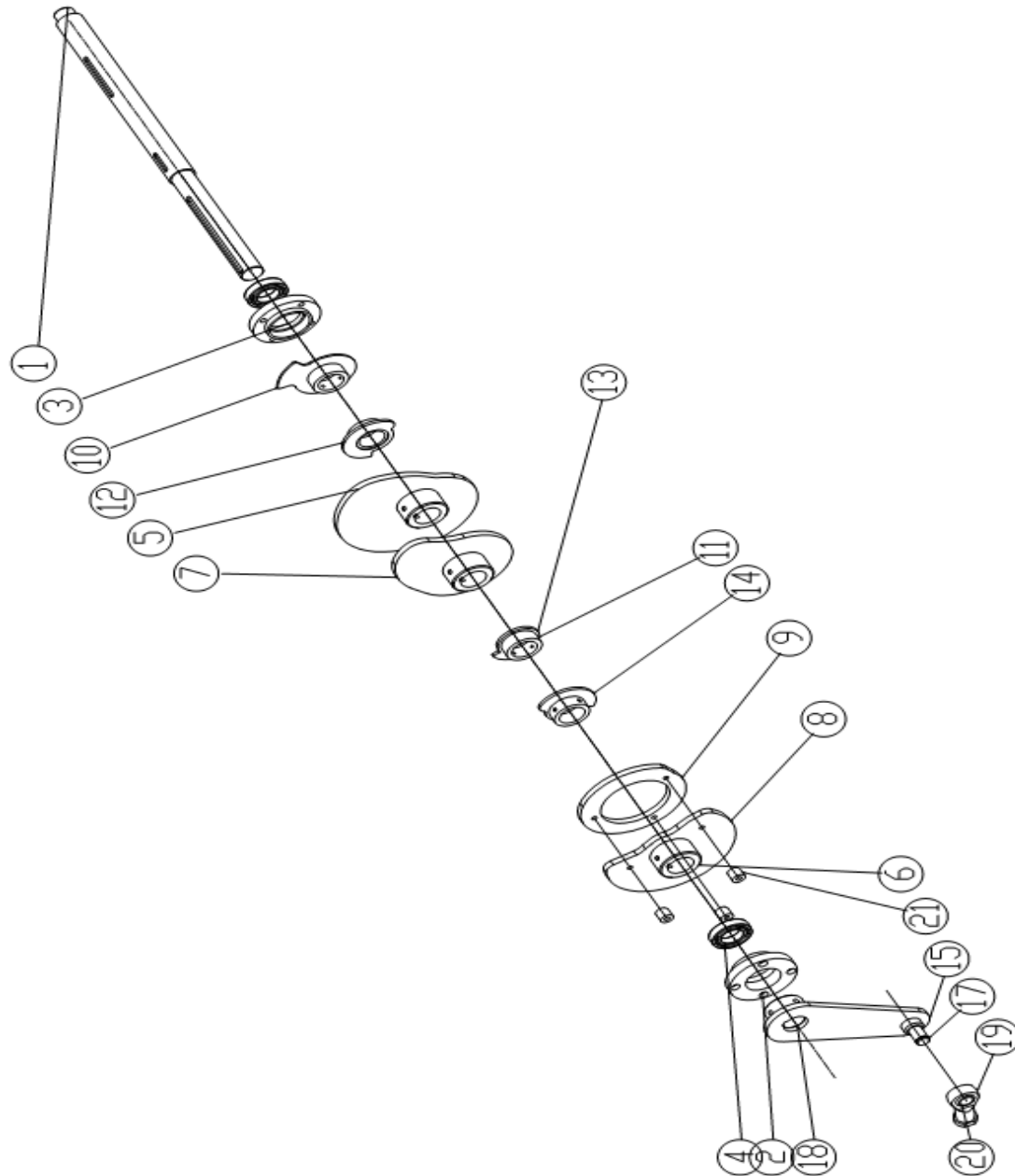
66	K30T-6000 rotary swing arm coverA		1
67	K30T-6000 general flat key		1
68	GB_FASTENER_SCREWS_HSHCS M6X12-N		2
69	DIC-20M120+PPVcylinder wall		1
70	DIC-20M120+PPVcylinder bar		1
71	K30T-DON'T CHANGE KF3A-2020 bearing block	bearing block	3
72	Rolling bearings 6003 GB 276-94		3
73	K30T-5003 handwheel shaft	handwheel shaft	1
74	K30T-5006 orthogonal bevel gear	orthogonal bevel gear	1
75	Inner undular handle12x100		1

7.4 Assembly drawing and parts list of store carton component



No.	Part No.	Description	Qty
1	K30T-5013 base plate		1
2	K30T-5001 Bottom bar		1
3	K30T-5002 Left and right bar		2
4	K30T-5003 top bar(change)		1
5	K30T-5004 Centre bar		2
6	K30T-5005bearing block		4
7	DAI40-40cylinder wall		1
8	DAI40-40cylinder bar		1
9	DON'T CHANGE JF12 rod end main body		3
10	DON'T CHANGE JF12 rod end main ball		3
11	K30T-5006 connecting plate		2
12	K30T-5009 Cylinder driving block		3
13	K30T-5010 Cylinder pin		1
14	K30T-5011 stop carton plate		1
15	K30T-5012 Carton protective cover		1
16	K30T-50XX steel nail		12
17	K30T-5007 carton holding block		6
18	K30T-5008 steel nail installation block		6
19	K30T-5003 Top bar		1
20	connecting rod		1

7.5 Assembly drawing and parts list carton format component



No.	Part No.	Description	Qty
1	K30T-4404	cam shaft	1
2	K30T-4401	left bearing block	1
3	K30T-4402	right bearing block	1
4	Rolling bearings 6007 GB 276-94		2
5	K30T-4412	Erecting cam	1
6	K30T-4414	convex plate of cam	3
7	K30T-4410	front & back folding cam	1
8	K30T-4411	bottom folding cam	1
9	K30T-4409	Fixed cam	1
10	K30T-4425	detection cam	1
11	Cam cover		4
12	K30T-4423	Carton taking cam	1
13	K30T-4424	Cam of cutter	1
14	K30T-4422	Fixed small cam	1
15	K30T-4403	Driving tumbler	1
16	K30T-4406	Driving tumbler rib plate	1
17	K30T-4406	Driving tumbler rod end seat	1
18	K30T-4405	Driving tumbler convex plate	1
19	DON'T CHANGE JF20	rod end main body	1
20	DON'T CHANGE JF20	rod end main ball	1
21	K30T-4421	cushion block of cam	3