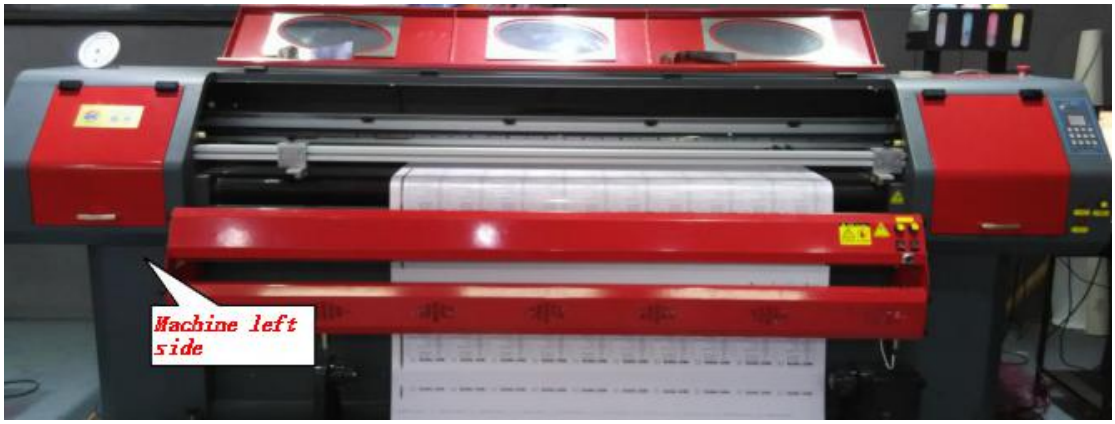
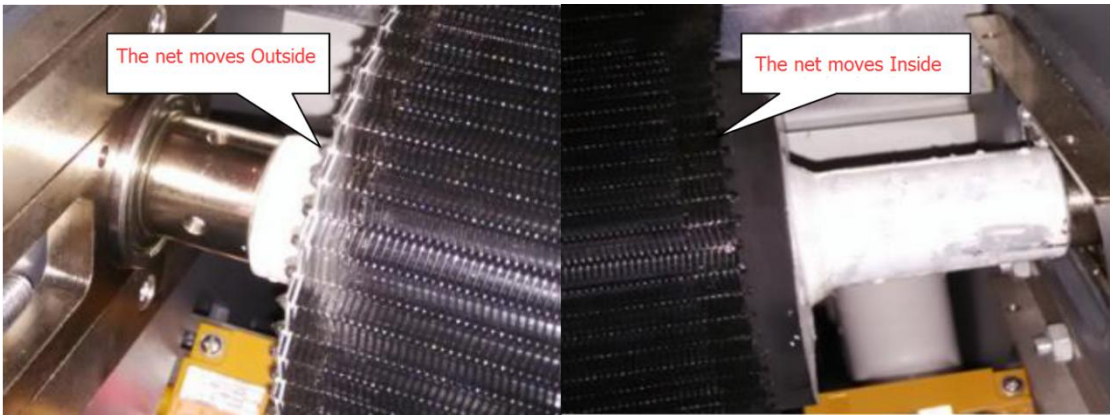
If the correcting system of belt machine is working properly, it can self-correcting when it feed the material, otherwise will affect the quality or cause serious deviation damaged the spares.

The following will introduce how to detect the correction system and the corresponding treatment.



1. The belt is not damaged no need to replace, but can't self-correcting, as the photo below:

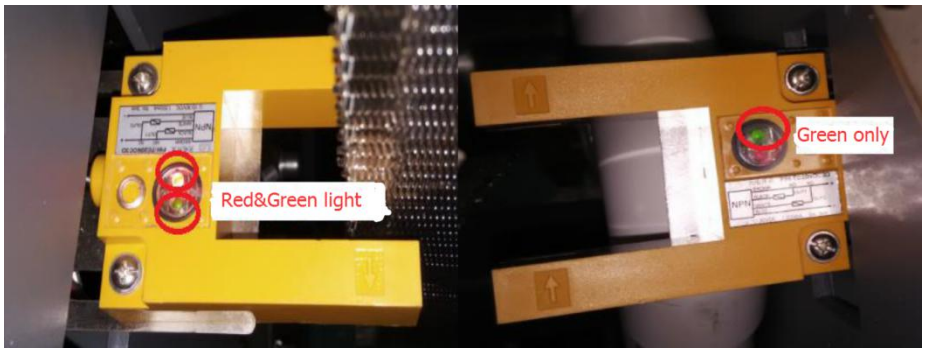


Detection steps:

1). Checking the U-type Optoelectronic,

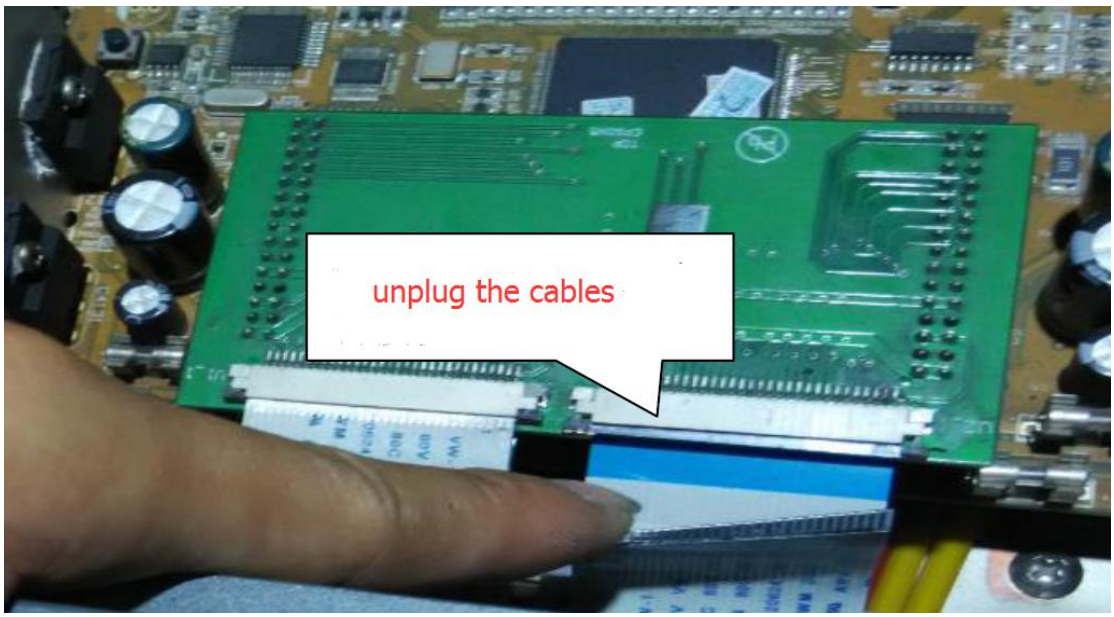
When the belt is twisted, check whether the U-type Optoelectronic switch on both sides of the back of the machine has a green light and a red light

(Where the network side to side, then the green light and red lights together), while the other U-type Optoelectronic switch only bright green light as photo ,If the status is not normal, first confirm the power U-type Optoelectronic switch, if the power no problem please change the U-type Optoelectronic switch.



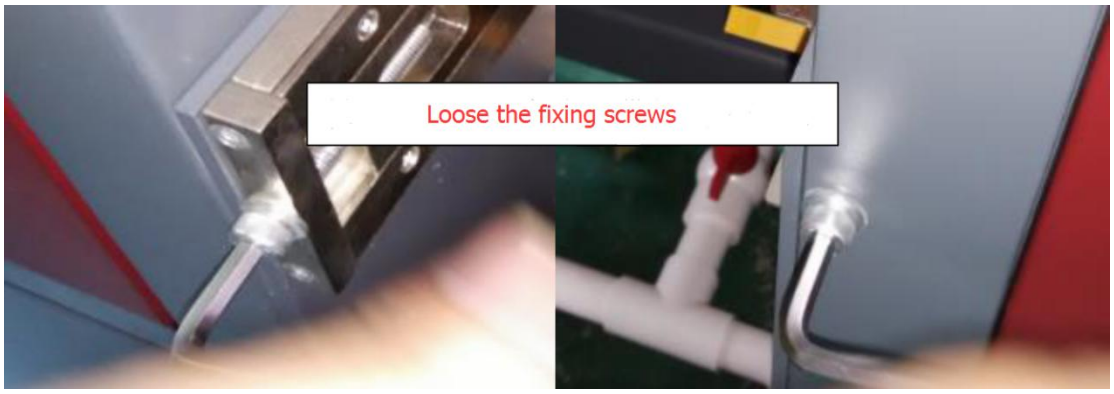
2). Turn off the machine power.

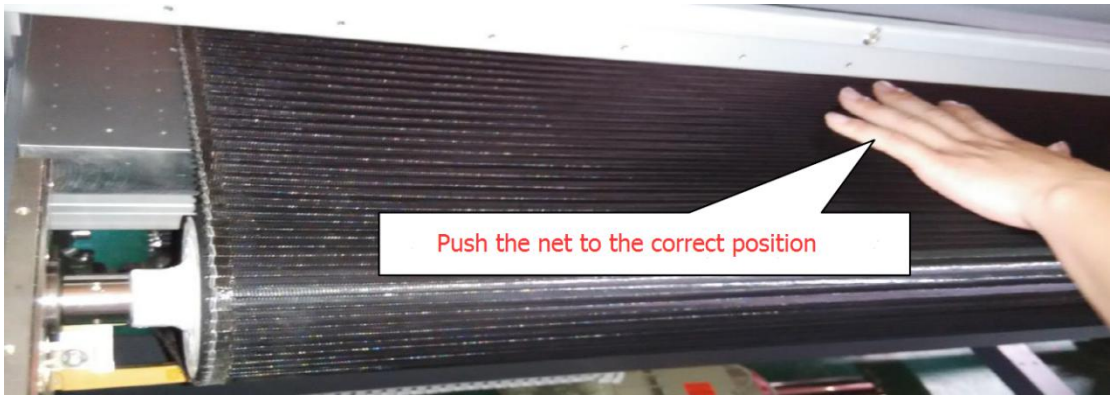
3). Pull out the head cable from head to transfer board one by one. (unplug the head cable can not be connected with the head board touch).

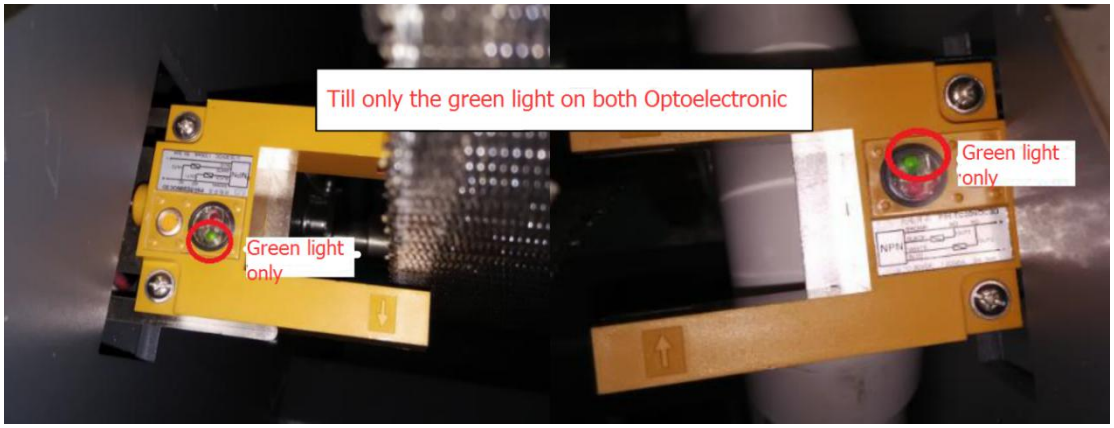


4). Turn on the machine power.

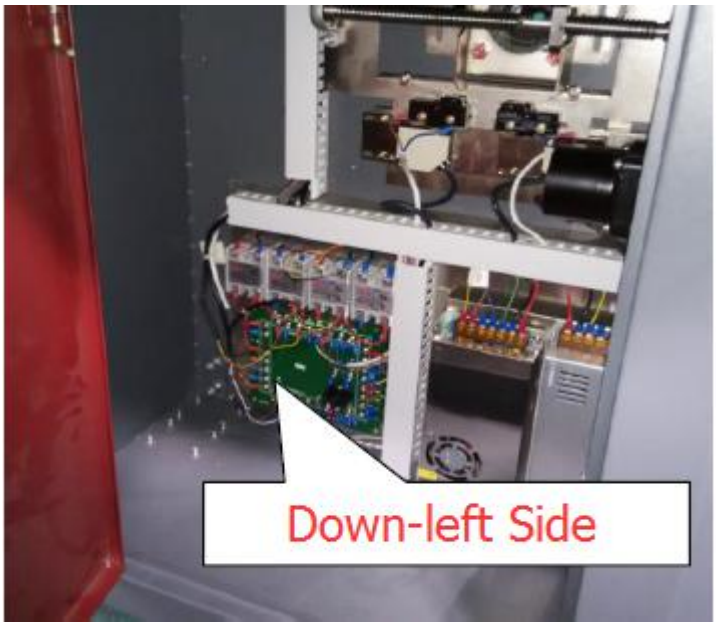
5). Loosened the fixed screw on the back of the machine (left and right) first, hand push the network with the opposite direction of the oblique way, straighten belt until both sides of the U-type Optoelectronic switch is only green light.



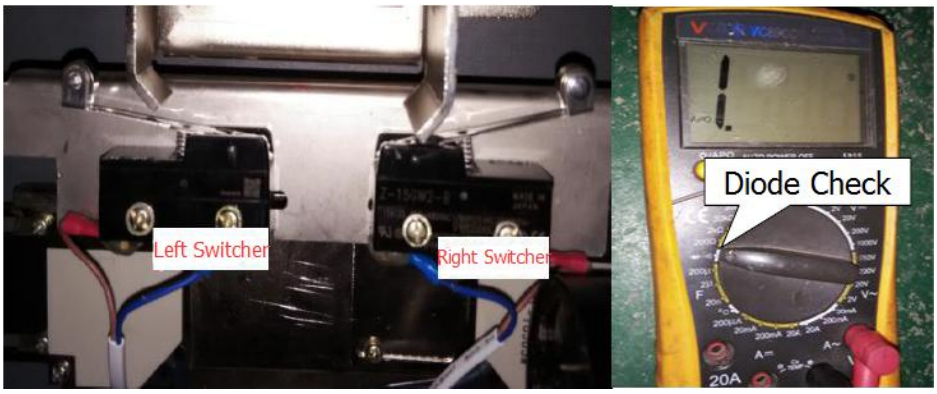




6). Turn off the machine power off again, and open the crate on the machine down-left side.



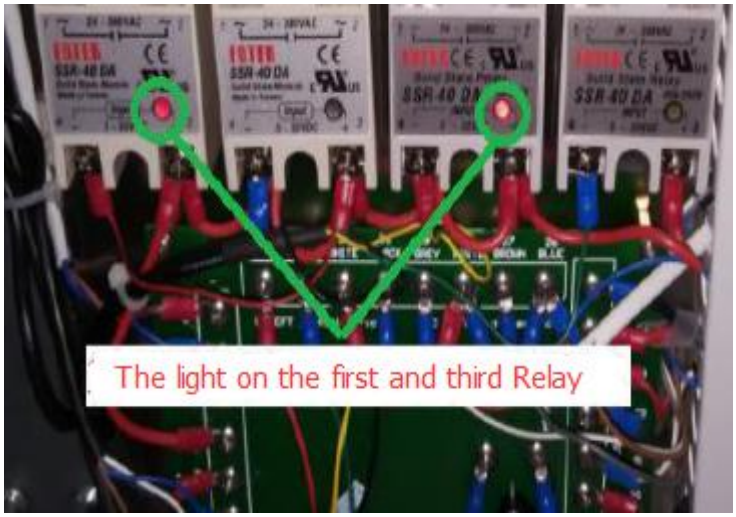
7). Check 220v Contact Switcher.



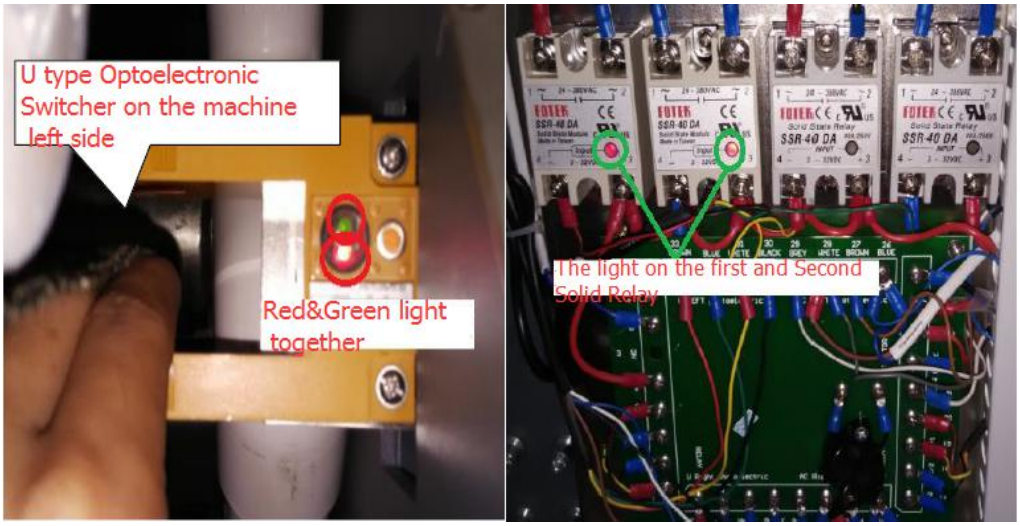
The 2 contact points on the Left Contact Switcher are corresponding to the 26, 28 points on the Circuit Board, the 2 contact points on the Right Contact Switcher are corresponding to the 14, 16 points on the Circuit Board. If we check the 26 and 28, 14 and 16 with the Multimeter, It's ok to hear the "beep beep" sounds, otherwise it has problems, we need to check whether the wires are loose or not, or need to change these contact switchers.

8). Alternating Current Solid Relay checking

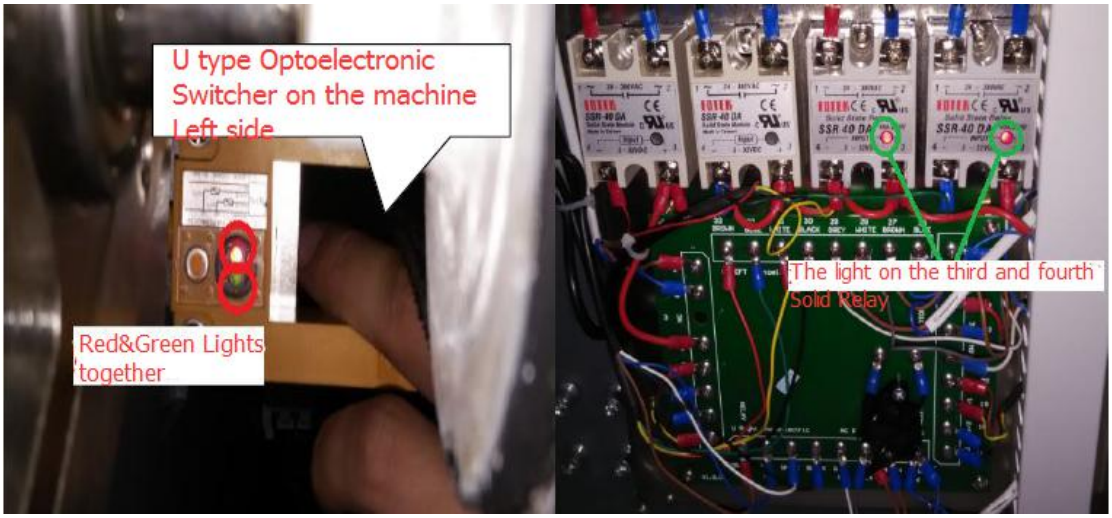
A: When the net is normal(No deviation), the red light on the first and third Solid Relay should be lightened(It means the first and third Solid Relay is working well.)



B: Using little thing go through the U-type Optoelectronic Switcher on the machine left side, Only the light on the first and second Solid Relay working. (It means the first and second Solid Relay is working.)

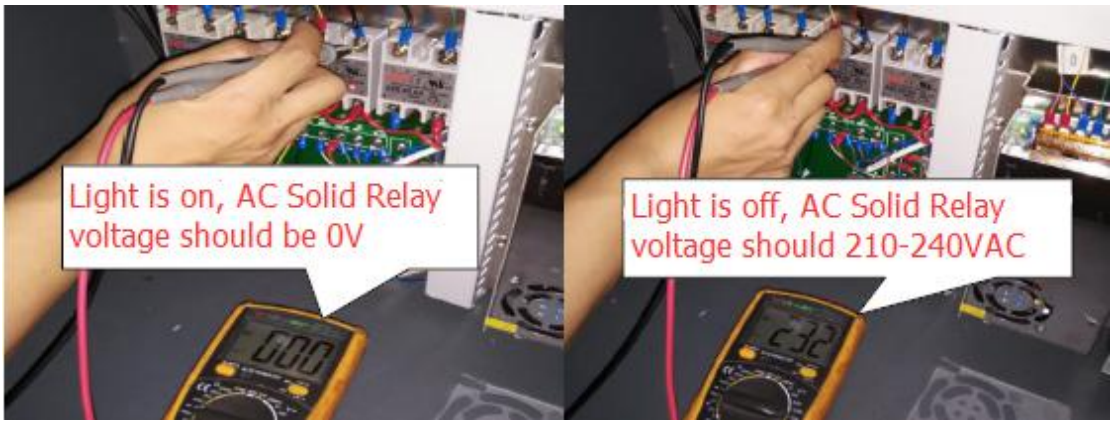


C: Using little thing goes through the U-type Optoelectronic Switcher on the machine right side, Only the light on the third and fourth Solid Relay working. (It means the third and fourth Solid Relay is working.)



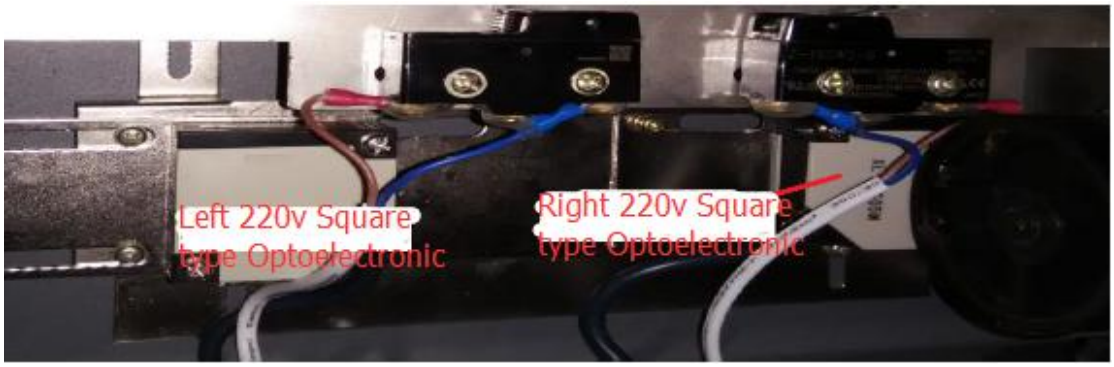
D: Turn the Multimeter to the 200V DC, through the voltage from Alternating Current Solid Relay DC control site to judge whether the Relay works or not: Take 3rd Reley as example, When this Relay works, its light is on, and its control site's voltage should be 22-24VDC; When this Relay don't work, its light is off, and its control site's voltage should be 0VDC. Other 3 relays should be checked with the same method to measure the voltage from the DC control site. If the voltage is abnormal, its corresponding U-type Optoelectronic has problem(The 2nd and 3rd Relay's DC control site is controlled by the left side U-type Optoelectronic, The 1st and 4th Relay's DC control site is controlled by the Right side U-type Optoelectronic), If the Voltage is normal but the light is abnormal, the Relay has problems.

E: Turn the Multimeter to 750 AC, through the voltage from Alternating Current Solid Relay AC control site to judge whether the Relay works or not: Take 3rd Reley as example, When this Relay works, its light is on, and its control site's voltage should be 0VAC; When this Relay don't work, its light is off, and its control site's voltage should be 210-240VAC. Other 3 relays should be checked with the same method to measure the voltage from the DC control site. If the voltage is abnormal, the Motor for adjusting the deviation will be influenced. For example, When the AC Relay don't work, this AC site's voltage is about 110VAC, the motor for adjusting the deviation will make a sound "ka ka", we should check the wires whether it connects well or not, And if we sure the wires are well connected, We should replace the AC Solid Relay.

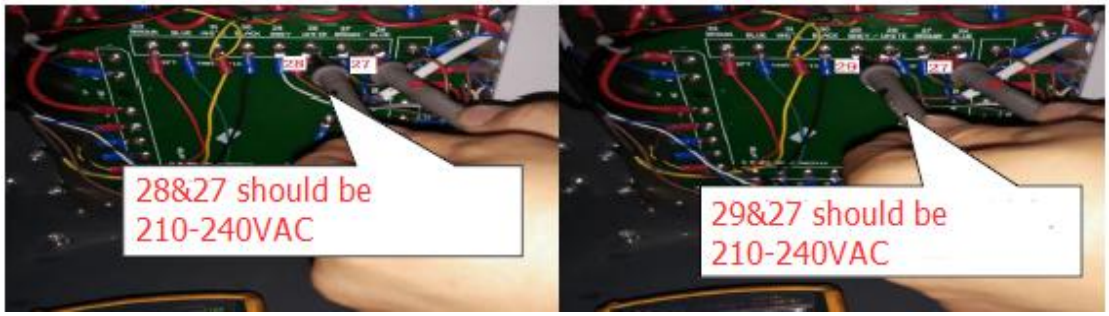


9). Checking the motor for adjusting the deviation, adjust deviation board and the square type Optoelectronic

A: Using a little thing goes through the U-type Optoelectronic which on the machine left side, and see whether the motor spinning or not, if it don't spin, check the 220v square type Optoelectronic related voltages.

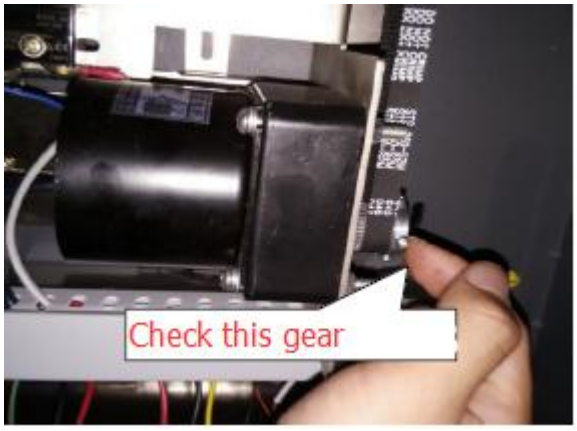


The 26&27, 28&27, 29&27 on the board, these 3 voltages should be 210-240VAC(The 220V square type Optoelectronic should not at working situation, its red light should be off when we measure the voltages), if the voltage is not in 210-240VAC, the 220v square Optoelectronic on the machine left side has problems, it will make the motor for adjusting deviation don't work.

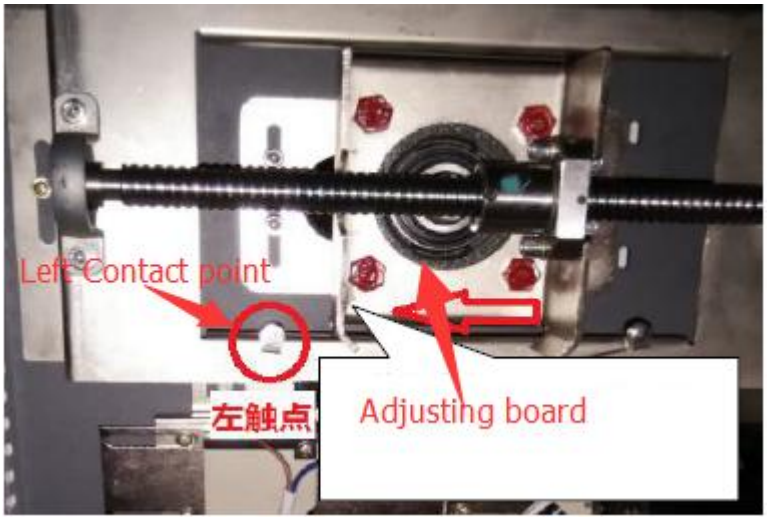


Notice: If the 220V Square type Optoelectronic related voltage checking normally, and we finished the checking(Left side U-type Optoelectronic voltage, AC Solid Relay voltage, Contact switcher), the Motor for adjusting deviation still can't work, then need to replace the Capacitance on the Motor and Motor for adjusting the deviation.

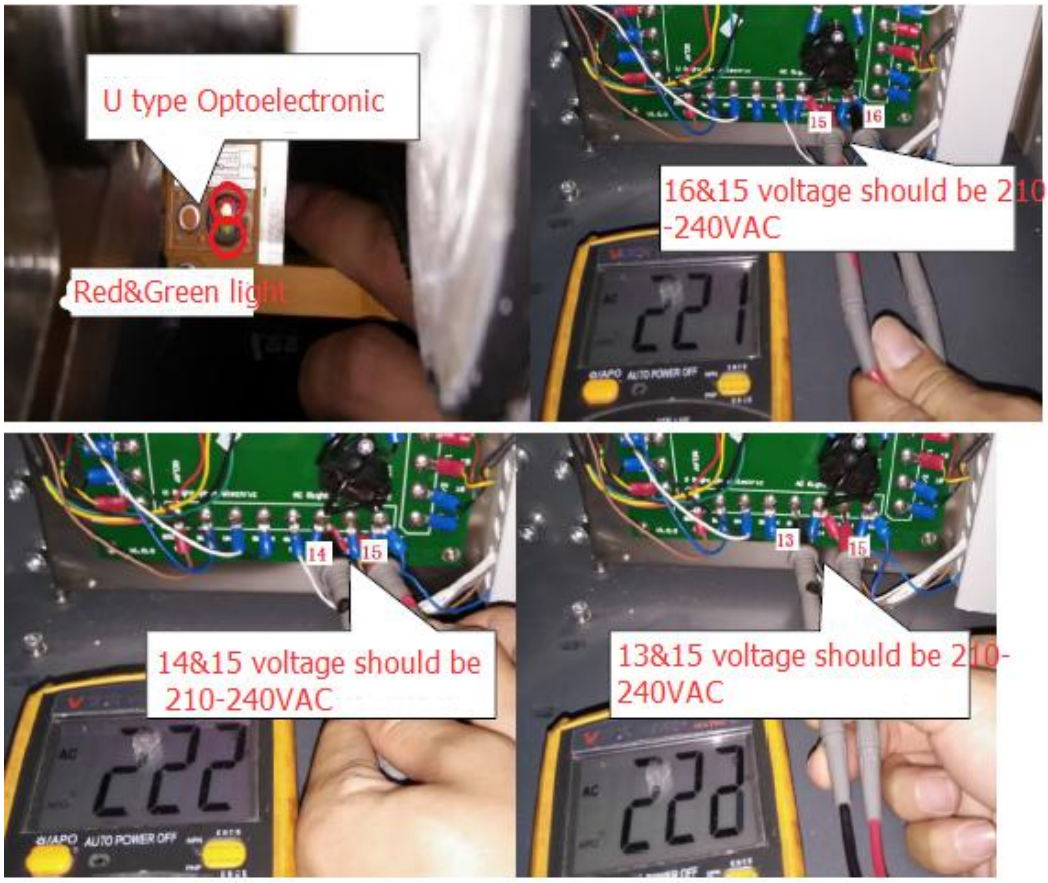
B: Checking whether this gear looses or not, if it looses, it should be tightened.



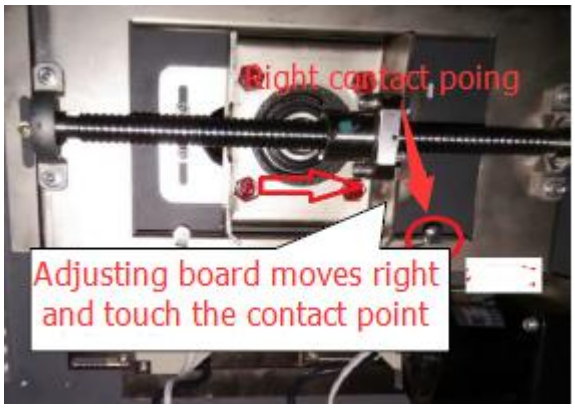
C: Checking whether the adjusting board moved left by the motor or not(If no move, Check the gear), when the adjusting board touch the contact point, the motor should be stopped(if no stop, this left contact point has problems)



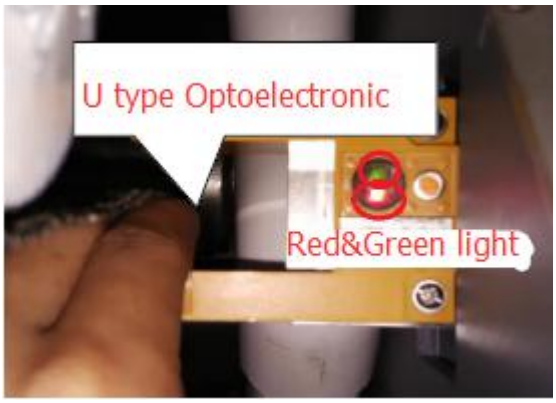
D: Using a little thing over the U-type Optoelectronic on the machine right side, Checking whether the motor can make the adjusting board moved right or not, if it can't move right, check the 220v square type Optoelectronic related voltages, the voltages of 16&15, 14&15, 13&15 on the board should be 210v-240VAC(The 220V square type Optoelectronic should not at working situation, its red light should be off when we measure the voltages), if the voltage is not in 210-240VAC, the 220v square Optoelectronic on the machine right side has problems, it will make the motor for adjusting deviation don't work.

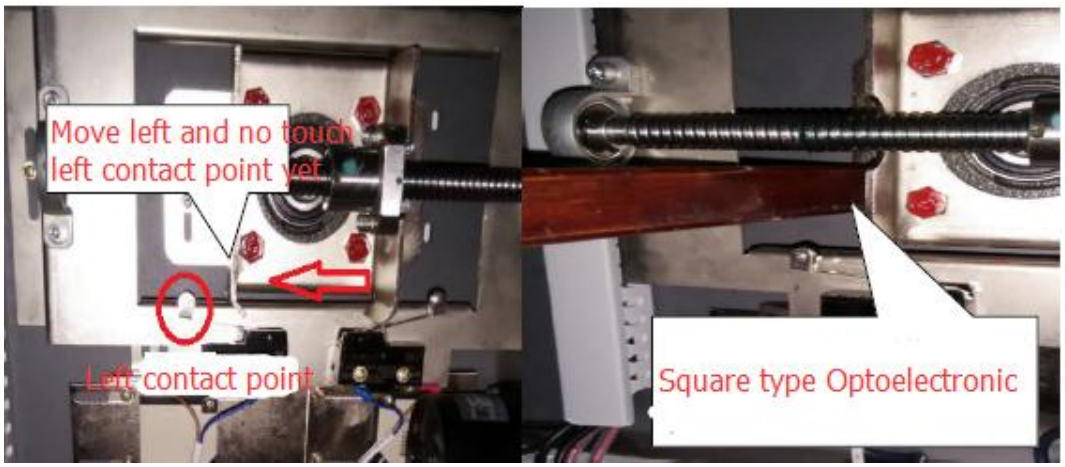


E: When the adjusting board touches the contact point on the machine right side, the motor should be stopped(if not, the right side contact point switcher has problems.)

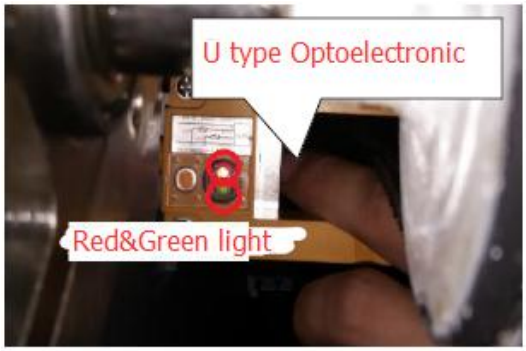


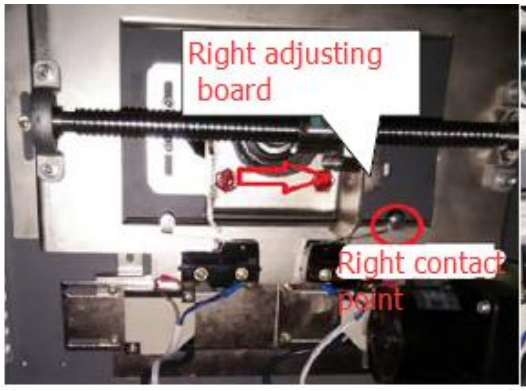
F: Using a little thing again goes through the U-type Optoelectronic on the machine left side, before the adjusting board touches the left contact point, using a little thing over the square type Optoelectronic, the motor and the adjusting board should be stopped, if it still moves left, this 220v square type Optoelectronic on the machine left side has problems.

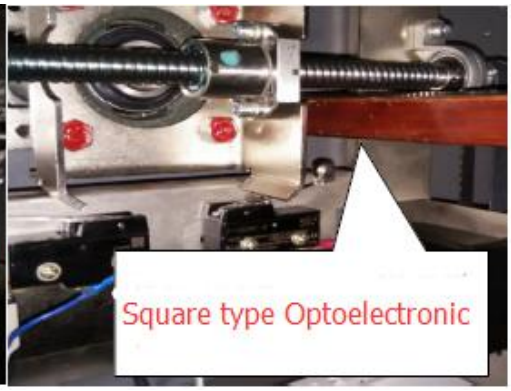




G: Using a little thing again goes through U-type Optoelectronic on the machine left side, before the adjusting board touches the right side contact point, using a little thing again goes through the 220v square type Optoelectronic, the motor and the adjusting board should be stopped, if it moves on, the 220v square type Optoelectronic has problems.

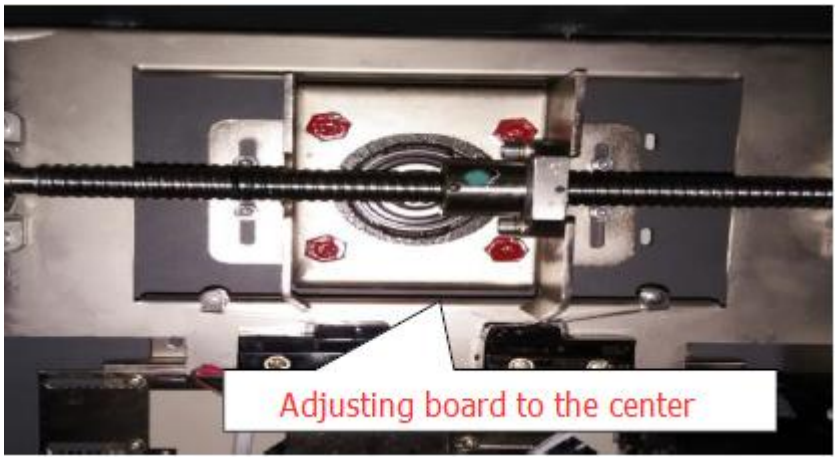




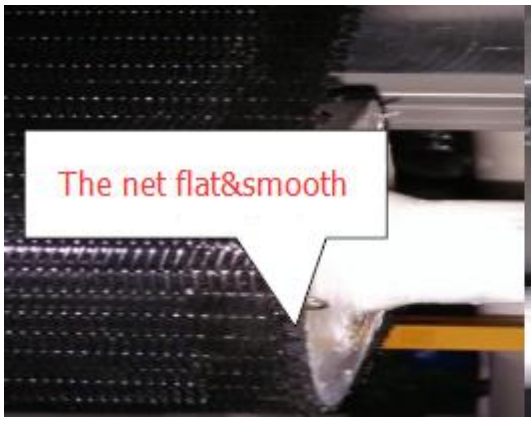


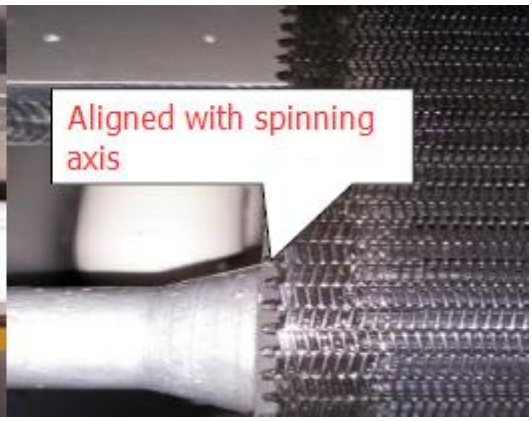
10). After the adjusting deviation system function is ok,

A: Put the adjusting board at the center of the Left&Right contact point,



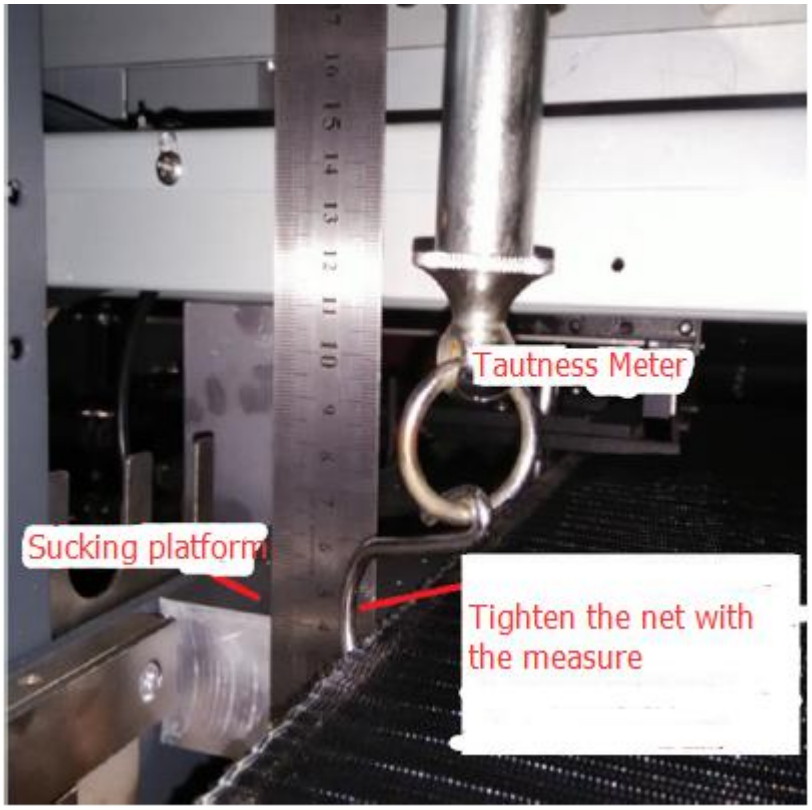
B: Let the net flat&smooth, and meanwhile the edge of the net should be aligned with the spinning axis.





C: Tighten the fixing screws on both side gradually, let the net tightens.

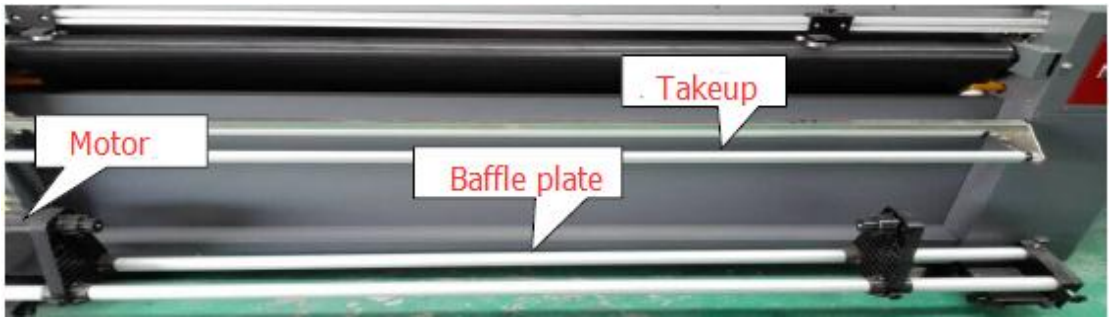
D: On the process of tighten the net, using a tautness meter with 1KG(0.98Cattle) to liftup, and now using a rule to measure the gap between the net and the sucking platform is about 3mm, it means the net is ok. And meanwhile the net should be aligned with the spinning axis.



2. The net is broken, replace the new net first.

1). Turn off the machine

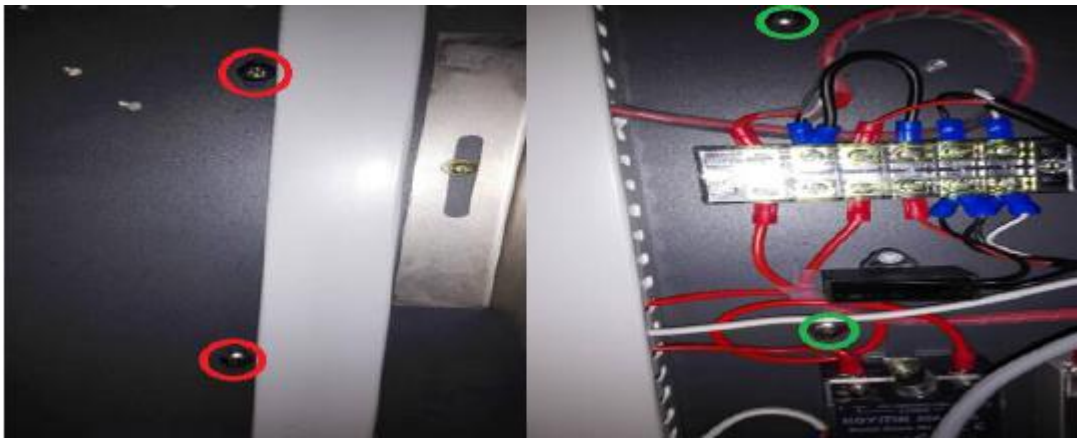
2). Remove the takup system, motor&baffle plate back of the machine



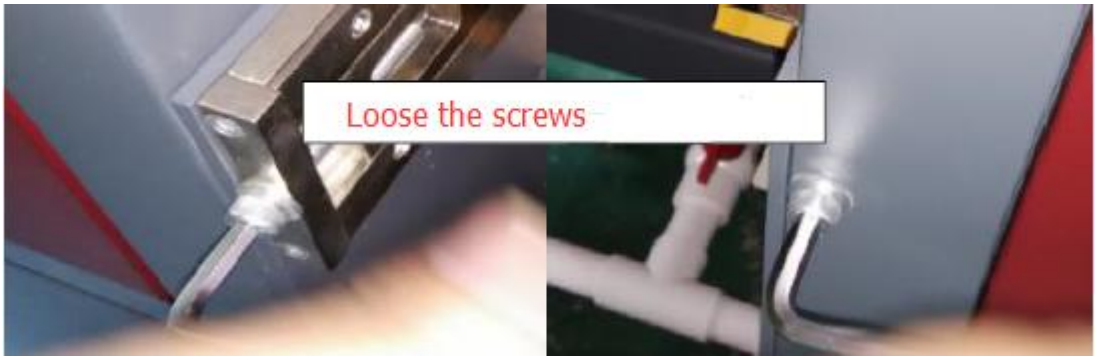
A: Remove the takeup

B: Remove the motor

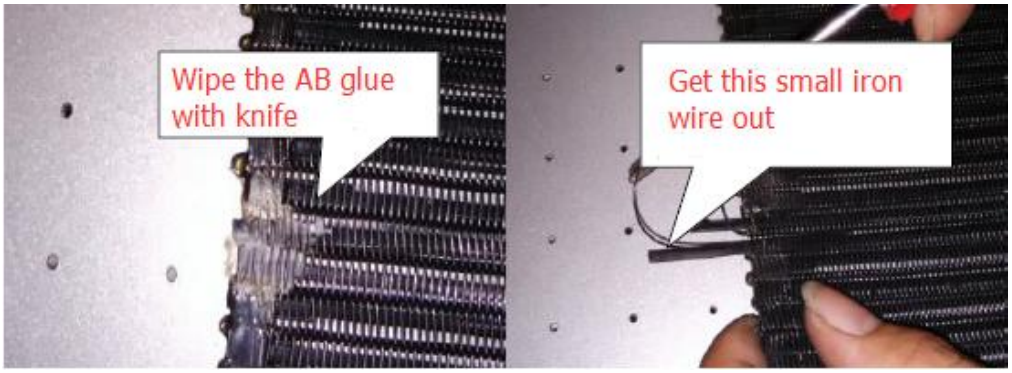
C: Remove the baffle plate



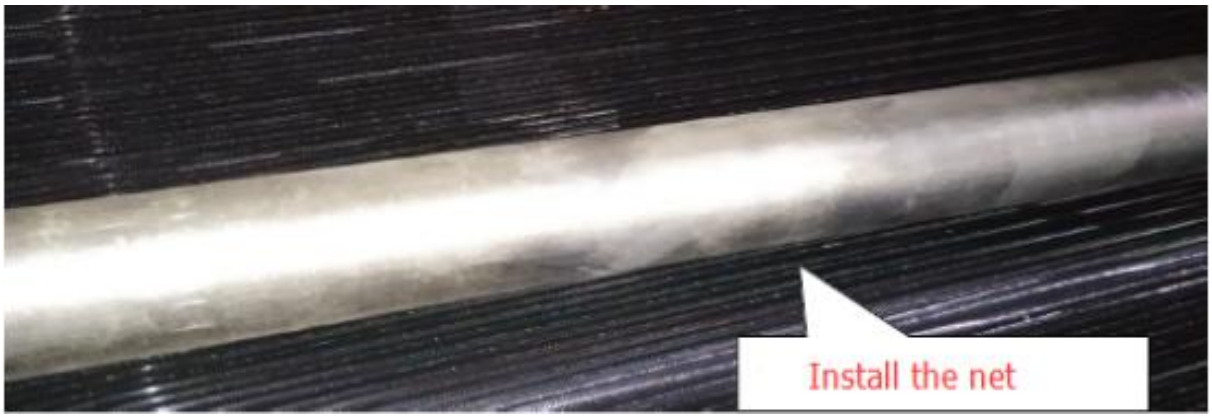
3). Loose the fixing screws on both sides



4). Remove the broken net



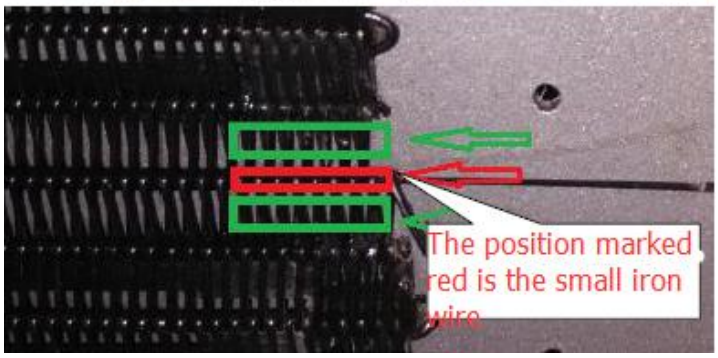
5). Install the new net.

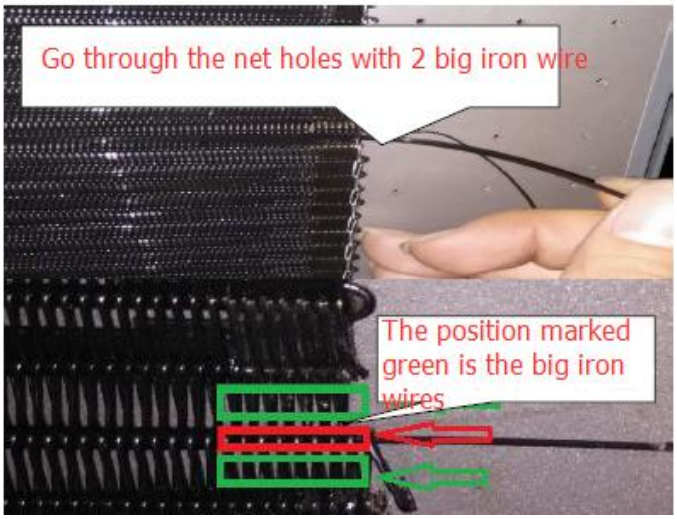


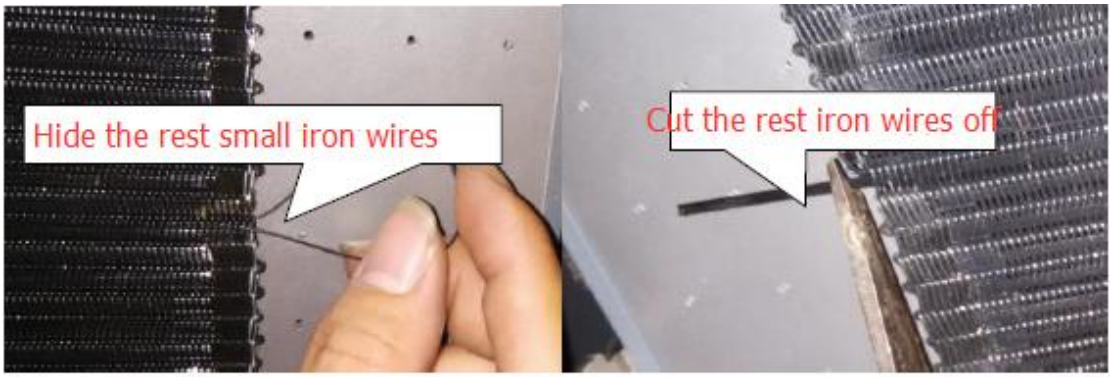

Spread the net on
the platform

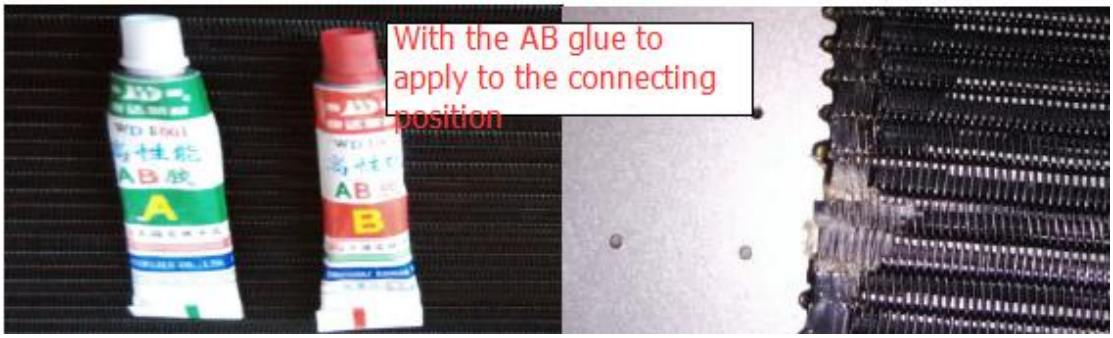

Tighten the edge of
the net holes
Tighten the net holes
gradually


Go through the net holes with
a small iron wire


The position marked
red is the small iron
wire

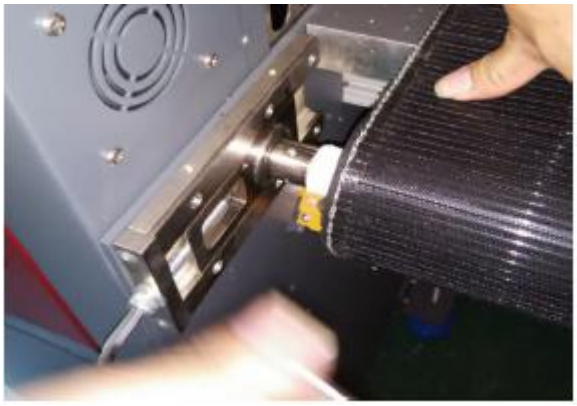

Go through the net holes with 2 big iron wire
The position marked
green is the big iron
wires





6). Install the Motor, takeup &Baffle plate.

7). After about 20 minutes till the AB glue is dried, keep the net flat&smooth, tighten the fixing screws on the machine both sides.



8). Then according to the first situation to adjust the net.