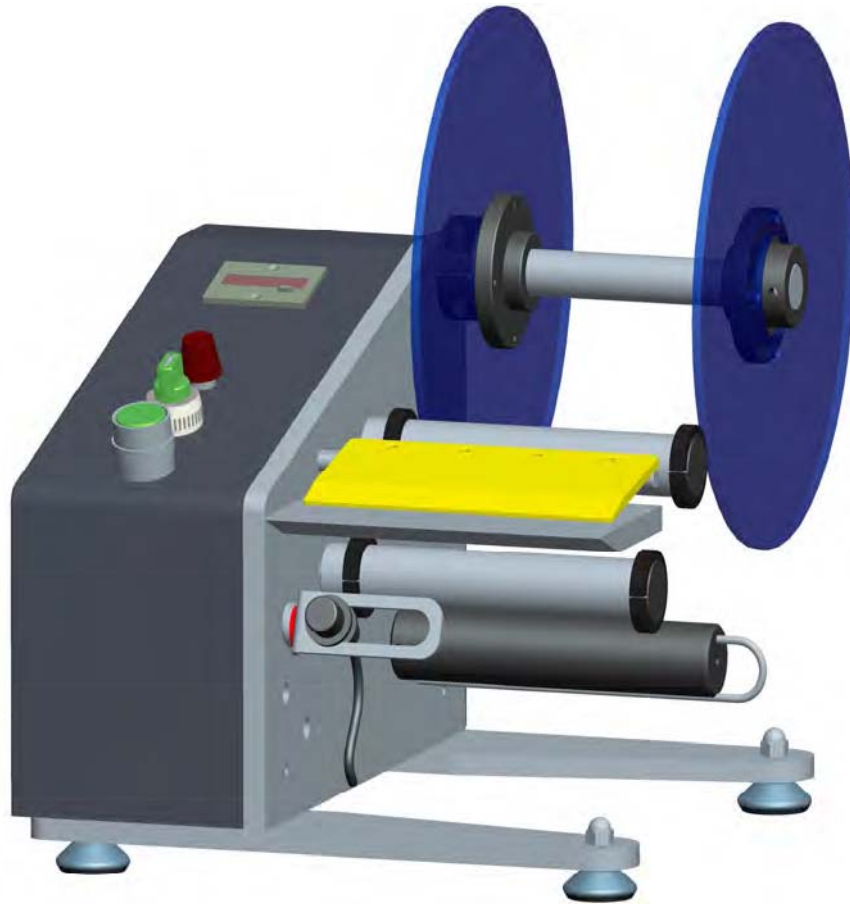


# 使用说明书

## User manual



设备名称：标签自动剥离机

Equipment Name: Label automatic peeling machine

设备型号：LM-37100

Equipment Model: LM-37100

## 一、产品介绍

### Equipment instruction

#### 1 概述

##### Description

标签剥离机，又称剥标机、剥标器、不干胶剥离机等，用于标签的自动剥离，剥离的标签被取用后，自动剥离下一张标签，提高工人取用标签效率，可一次性剥离多排标签。根据需要，可配置单头、两头或多头剥标头，进行不同控制。

Label peeling machine, another name peeling machine and peeling tool, anti-dry peeling machine, to be used for automatic stripping for labels, the peeled label is drawn ,automatically stripping the next label, improve the efficiency of workers drawn labels, multi-row labels may peel off one time. According to need, optional for a single head, two or multiple stripping heap for different control.

#### 2 适用范围：

##### Scope:

\* 适用标签：不干胶标签，不干胶膜，电子监管码，条形码等；

Applicable Label: anti-dry labels, anti-dry film, electronic supervision code, bar code, etc. ;

\* 适用产品：所有要求贴标签或膜的产品；

Applicable products: all the product that require labeling or filming;

\* 应用行业：广泛应用于食品、玩具、日化、电子、医药、五金、塑胶、印刷等行业；

Industry: Widely used in food, toys, cosmetics, electronics, pharmaceutical, metal, plastic, printing and other industries;

\* 应用实例：玩具流水线上贴标，食品包装盒流水线上贴标，电子产品流水线上贴标。

Application examples: Toy production line labeling, food packaging assembly line labeling, electronics assembly line labeling.

#### 3 产品优点：

##### Advantages:

\* 剥离的标签平整、不起皱

labels peeled flat, without wrinkling

\* 工人取标便捷，提高产线贴标效率；

Workers take the label easy, improve production line labeling efficiency;

\*具有标签计数功能，出标长度调整功能；

With label counting function, the standard length adjustment function;

#### 4 技术参数：

##### Technical parameters:

- 出标速度：60张/分钟（与标签长度有关）；

The label speed: 60 / min (with the length of the label);

- 适用标签尺寸： $8 \leq \text{宽度} \leq 150\text{mm}$ ,  $15\text{mm} \leq \text{长度}$ ；

Applicable Label Size:  $8 \leq \text{width} \leq 150\text{mm}$ ,  $15\text{mm} \leq \text{length}$ ;

- 整机尺寸：约  $420 \times 380 \times 380\text{mm}$ （长 $\times$ 宽 $\times$ 高）；

Dimension: about  $420 \times 380 \times 380\text{mm}$  (L  $\times$  W  $\times$  H);

- 适用电源：220V 50/60HZ；

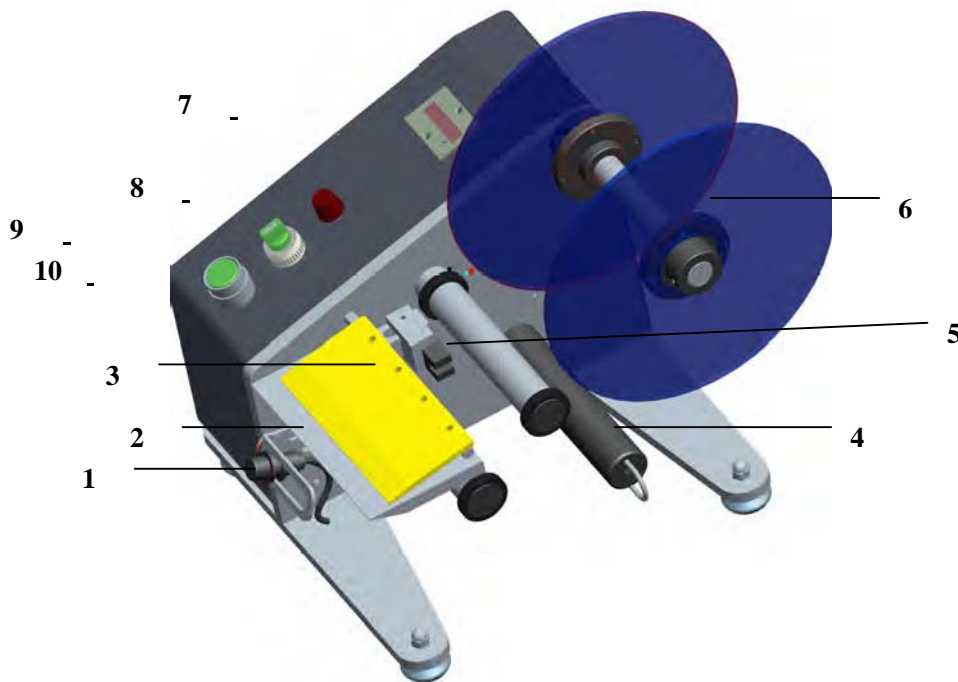
Power supply: 220V 50/60HZ;

- 整机重量：12Kg。

Total weight: 12Kg.

## 二、 机构介绍

### Structure



1、启动电眼：用于感应拿标签的手，感应后机器会自动运行一个标签间距；

Start electric eye: by sensing the hand when taking label, the induction machine will automatically run a label spacing;

2、剥标板：用于将标签剥离；

Label peeling board: used for label peeling; 3、压紧机构：用于将标签张紧，保证标签的张力，顺利剥离；

Hold-down mechanism: for tensioning the label to ensure that the label tension smooth release;

4、底纸回收机构：电机直接带动，提供剥标机动力，同时回收底纸；

Back paper recycling facility: motor directly drives and provides label peeling power, recycle the back paper at the same time as well.

5、停止电眼：用于检测标签的间距工艺孔；

Stop electric eye: used to detect the label gap hole; 6、料盘：安放卷装的标签

。

Tray: Put the label roll. 7、计数器：用于记录已用标签数，可按（黑色）归零按钮，重新计数；

Counter: used to record the number of labels have been used, pressing to the (black) reset button to re-count;

8、速度旋钮：用于调节剥标速度，顺时针加快，逆时针减慢；

Speed knob: used to adjust the stripping target speed, accelerate clockwise, counterclockwise slows down;

9、选择开关：分手动和自动两个档，分别控制点动和自动出标；

Selector Switch: manual and automatic two switches. Control jog and automatic labeling; 10、点动按钮：在手动状态下，点动开关可控制剥标动作。

Jog buttons: In manual mode, jog switch will control label peeling action.

### 三、 技术原理

#### Technical principles

##### 1. 电控原理

##### Electric control principle

在自动状态下，启动电眼感应到物体（注意：用手感应一下使电机启动即可，手感应的的时间不要太短，

也不要过长)，就会启动电机，将标签剥离。然后通过停止电眼感应到标签的工艺孔，输出信号给继电器，将转动的电机电源切断，电机停止。在手动状态下，按点动开关，电机转动；松开点动开关，电机停止。

In automatic mode, the electric eye sensor detects the object (note: use hand to launch the motor by sensor detecting, the time should not too short, but also not too long), it will start the motor, the label peeled off. Then by stopping the electric eye sensor to label craft hole, the output signal to the relay, the motor will turn the power off, the motor stops. In manual mode, press the jog switch, motor rotation; loosen jog switch, the motor stops.

## 2 · 机械原理

### Mechanical principles

电机直接带动标签底纸，标签缠绕路径中经过剥标板，两端标签形成 R 角，标签与底纸分离，进行剥标。

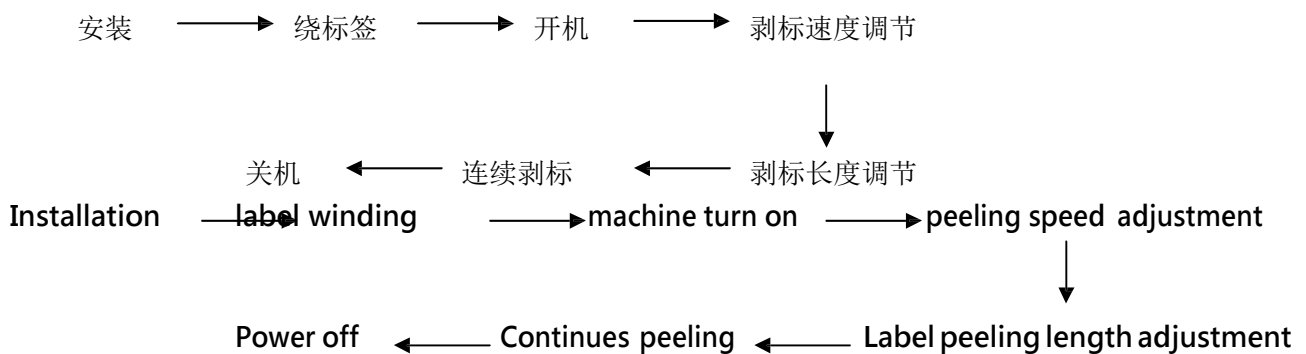
Motor direct drive label backing paper, labels, winding path through the peeling board, R angle formed at both ends tags, labels and backing paper separator for peeling.

## 四、 操作部分

### Operation section

#### 1 · 操作步骤

##### Procedure



剥标长度的调节 · 可以通过移动停止电眼的位置来达到

Adjustment of the peeling length, by moving the position of the electric stop eye to achieve 2

#### · 安装

##### Installation

按照装箱单提示，安装好贴标机；如整机包装，无需装箱单。安装完成后，整机放置在流水线指定位置。

注意将标签穿过停止电眼的槽内，且确保电眼的工作正常。

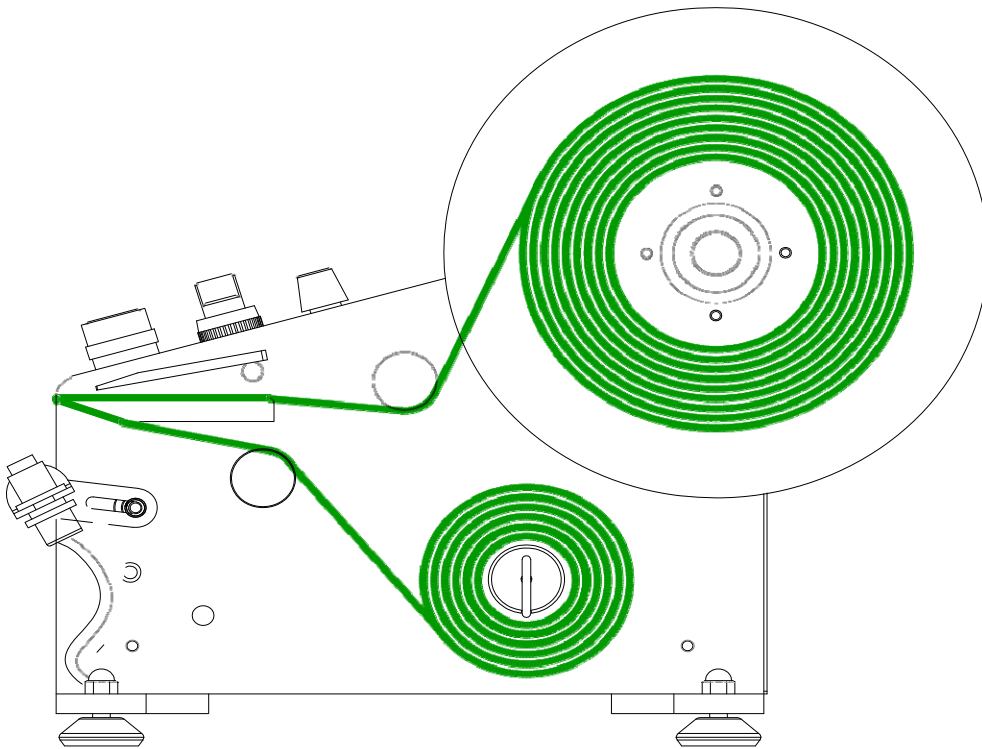
In according with the tips of packing list to install labeling machine well; complete machine package, without packing list. After installation was completed, placed the machine in the productionline specified location. Note that put the label through the slot of electric eye, and ensure that the electric eye working properly.

### 3 · 绕标签

#### Labeling winding

3.1 按照以下标签绕行图绕行标签。

Following the below way to wing the label



3.2 松开料盘的 7 字把手，取下外侧料盘，放入标卷，标签头部朝向剥标板位置。上好标卷后，锁紧料盘 7 字把手。注意不要将卷标夹得太紧，以用手能拖动为宜。在标签较薄的时候，可以适当将压力增加，以确保标签的张力。

Loosen the material tray handle 7, remove the outer trays, place label roll, the label head will direct the peeling plate position. After the label roll was placed, locking trays 7 characters handle. Be careful not to too tight to label, it is better to drag easily by hand. When the label is thin, the pressure may be appropriately increased to ensure the tension of the label.

3.3 标签绕行到收料机构，来回扯动标签，纠正标签。

Tags detour to rewinding mechanism, pulling back and forth label, correct label.

3.4 收料部分，拔出插销，套入底纸，用插销夹紧。

Rewinding part, pull out the plug, detour back paper, clamping with plug.

3.5 绕好标签后，移动压标胶片到标签上部，调整限位圈，压紧标签，锁紧五星握轮。

After label winding well, the film moves to the label pressure standard upper limit adjustment ring, pressed labels, star grip locking wheel.

#### **4 · 开机**

##### **Machine turn on**

4.1 扳动选择开关到手动档，打开剥标机后部的开关。

Pull the selector switch to manual position; open the rear switch of the peeling machine.

4.2 调节电眼到剥标板前缘，电眼头部离剥标板前缘 5~25mm 左右。以能顺利感应到手为宜。

Adjust electric eyes to the front edge of the peeled standard plate, electric eye away from the front edge of peeling head plate about 5 ~ 25mm or so. Smooth induction by hand is appropriate.

4.3 扳动选择开关到自动档，标签自动剥离，停止电眼检测到工艺孔后，停止剥标。

Flip the selector switch to the automatic transmission, label automatic stripping, stop electric eye to label hole detection process, stop peeling.

#### **5 · 剥标速度调节**

##### **Stripping speed adjustment**

撕一张标签，根据个人操作习惯，扭转调速旋钮调整速度到合适状态。较薄的标签应该尽量将速度放低，以保证标签的顺利剥离

Tear a label, based on individual operating habits, reversing speed control button to adjust the speed to the appropriate state. Thinner label should along with lower speed to ensure the smoothly label peeling.

#### **6 · 剥标长度调节**

##### **Label stripping length adjustment**

移动停止电眼前后位置，标签送出。根据个人操作习惯，调节标签剥离长度到合适的状态，锁紧电眼。

Move to stop the front and forth position of the electric eye, label sent out. the label sent out. according to personal operation habits, adjust label stripping length to the appropriate state, locking electric eye.



## 7·连续剥标

### Continuous Peeling

按 2~6 步调整以后，剥标机处于工作状态。往侧边撕开标签，第二张标签自动剥离，按此规律连续剥标、贴标，计数器记录剥标数目。如果剥标机不能正常停止，极有可能是停止电眼的检测不能正对标签的检测工艺孔，移动到检测位置即可。

Following the 2 to 6 steps to adjust, the peeling machine is in working condition. To the side to torn label, the second label auto peel, follow the regular pattern to peel and label continually. counter records the number of label peeling quantity. If the peeling machine does not stop normally, most likely is the electric stop testing eye can not over against the label craft hole for detection, move to the detection position.

## 8·操作要领

### Operating essentials

8.1 可根据个人操作习惯决定剥标速度、电眼与剥标板边缘距离和出标长度。

According to personal operation habit decided the striping speed, the electric eye and the label peeling plate edge distance and the length of the label send out.

8.2 对于透明标签，电眼与剥标板边缘距离尽可能小，提高电眼检测灵敏度。

For transparent label, electric eye and stripping plate edge distance as small as possible to improve the electric eye detection sensitivity.

8.3 对于容易下垂的软性标签，减短剥标长度方便操作。

For easy drooping soft label, shorten the label out length for convenient operation.

8.4 压紧机构压住标签后端，剥标顺畅性差，可调长剥标长度至压紧胶片没压住标签。

Hold-down mechanism hold the back-end labels tightly, label peeling poor smooth, adjustable long length to compress the film dispenser not suppress labels.

8.5 收料机构底纸直径加大，容易影响剥标长度，对短小标签影响大。可从收料机构前端剪断底纸，拔出插销，拿出整个收料的转轴，快速移除底纸，之后重新装好收料机构再行工

Winding mechanism to increase the diameter of the backing paper, easily affect peeling lengths, a great impact on the short labels. Can clip the back paper from the receiving mechanism, pull out the plug, take out the whole rewinding shaft, quickly remove the backing paper, and then re-installed rewinding agency.

## 五、常见故障

## Troubleshooting

故障	原因	解决办法
连续出标 Straight out of label	电眼调节不合适，检测不到标签 Electric eye adjustment is inappropriate, label undetectable	减短电眼与标签的距离 Shorten the distance between the label and electric eye
	电眼不适用（透明标签） Electric eye NA (transparent label)	更换专用电眼 Replace dedicated eye
	电眼损坏 Electric eye damage	更换电眼 Replace electric eye
计数失灵 Counting failure	计数器线路松脱，表现为计数器不亮 Counter circuits loose, the symptom counter does not shine	重接线路 Reconnection line
	计数器坏，表现无数显 Counter bad, the symptom is no display	更换计数器 Replace Counter
	延时继电器坏 Delay relay bad	更换延时继电器 Replace the delay relay.
无法剥标 Unable peeling	底纸厚，标签薄 back paper thick, labels thin	调慢剥标速度 Slow the peeling speed
	底纸撕裂，标签与底纸粘连 The back paper torn, label with backing paper adhesions	更换合格标签/调慢剥标速度 Replacement of qualified label / slow down peeling speed
No peeling	电眼损坏 Electric eye damage	更换电眼 Replace electric eye
	继电器损坏 Relay damage	更换继电器 replace delay

## 五、 产品维护和保养

### Product care and maintenance

1, 清洗各机构，使用酒精清洗需要清理的机械部分；

Cleaning agencies, need to be cleaned using alcohol to clean the mechanical parts;

2 清理电器箱，使用商用中性清洗液

Clean electrical box, using a commercially neutral cleaning solution 3

， 注意事项：勿使用对机械表面有损伤的清洗工具；勿使用酸性清洗液；

Do not use cleaning tools which may damage mechanical surface., Do not use erosive plastic container.