JYDC Ⅱ-2 Electricity-Power Twin-Heads Eyeleting Machine

Operation Manual

1. Main Application:

The JYD series eyeleting machine are widely used for manufacture the hanging rings of hand bag and box; The bookbinding and layout of confidential or normal files, The counterfeit-proof bookbinding of certificates, cards or commodity packing. Manufacture the air hole or lacelock of clothing, leather goods, mattress, bags and boxes.

2. Main Features:

Available for continuous eyelets feeding. Easy operation, Feeding eyelets, puncture and bending edge all finished in one move. After binding, eyelets edge is smooth and good looking; locking strength is strong, not easy to tear out. This eyeleting machine use electric power in place of labor power. It save the operator work force and improve working efficiency greatly. The main electrical apparatus elements adopt imported advanced equipments. All electric parts are designed with short- circuit protection, overheating protection and overcurrent protection to ensure the machine security and reliable operation. JYDC Ⅱ-2 is improved on JYDC-2 model which got rid of the electromagnet and

clutch parts use the motor reducing gear to directly drive. By this way, it is decreased noise greatly. Meanwhile it is added counting, working speed control, single-continuous working control features. All improvements make the eyeleting machine smooth and stable performance.

3. Technical Specifications

Models	JYDCⅡ4-2	JYDCⅡ5.5-2
Binding Thickness(mm)	≤3	≤3
Eyelets Pore Diameter (mm)	4	5.5
Max stroke (mm)	165	165
Volume capacity of eyelets(piece)	1200	900
Power of motor（kw）	0.375	0.375
Speed（puncture/min）	≤55	≤55
Rated voltage	220V,50Hz	220V,50Hz

4. Structure Picture

Picture I、Picture II is the structure picture of this machine, The form bellow the picture list out all main parts name and code of this machine.

5. Adjustment.

According to the difference of thickness and material of goods for binding. Please make a few tests before widely use.

If need to adjust eyelets tightness. Please reference the Picture I、Picture II and follow the instruction to adjust the lower die: Screw off the lower die locking screw (Picture I item 6) then adjust the adjusting screw (Picture I item 5) to move the lower die to the proper location.

After above process, load the eyelets and make a few tests. When eyelets edge bending smooth and reliable then lock on the locking screw. The adjustment is finished.

6. Operation.

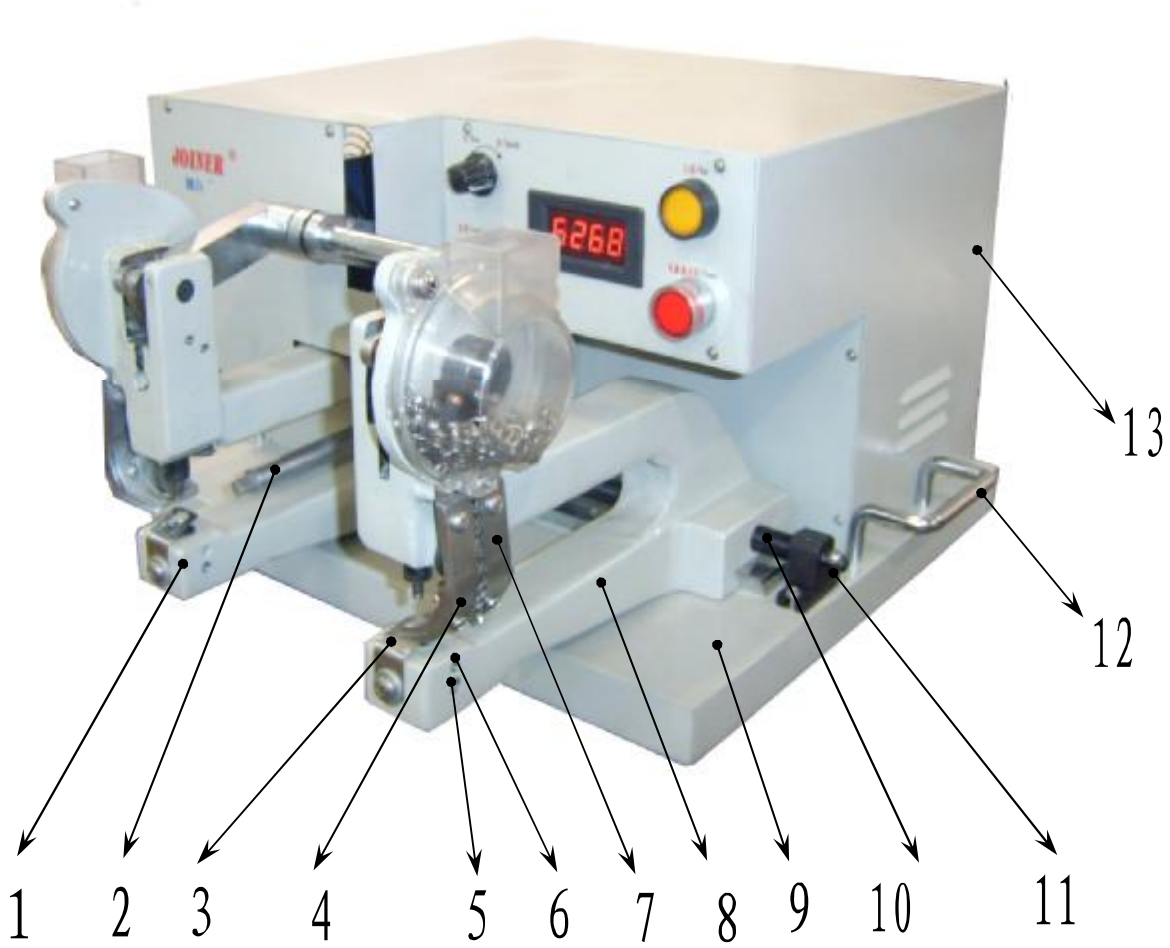
Load appropriate amount of eyelets in the cast (half full of the case) Pull flat leaf spring to the left. Turn on the power, Press the "run" bottom repeatedly (or kick the foot switch) to let eyelets roll in guide slot. Reserve a few eyelets in guide slot for blinding backup.

1.Paper Binding: Screw off the handlebar bolt on the base, adjust the horizontal axle along with axle to move the eyelets puncture location to a proper location; Adjust the distance between the two eyelets according to transverse plate graduation of scale. After location the paper screw on the thumb nut then blending.

2.Bags Binding: Screw off the handlebar bolt, adjust the horizontal axle to move the eyelets puncture at proper location according to bags mouth then screw on the handlebar bolt. Adjust the left and right baffle plate to make sure the eyelets puncture at the proper location according to bags' edge then screw on the thumb nut. After a few tests then it can

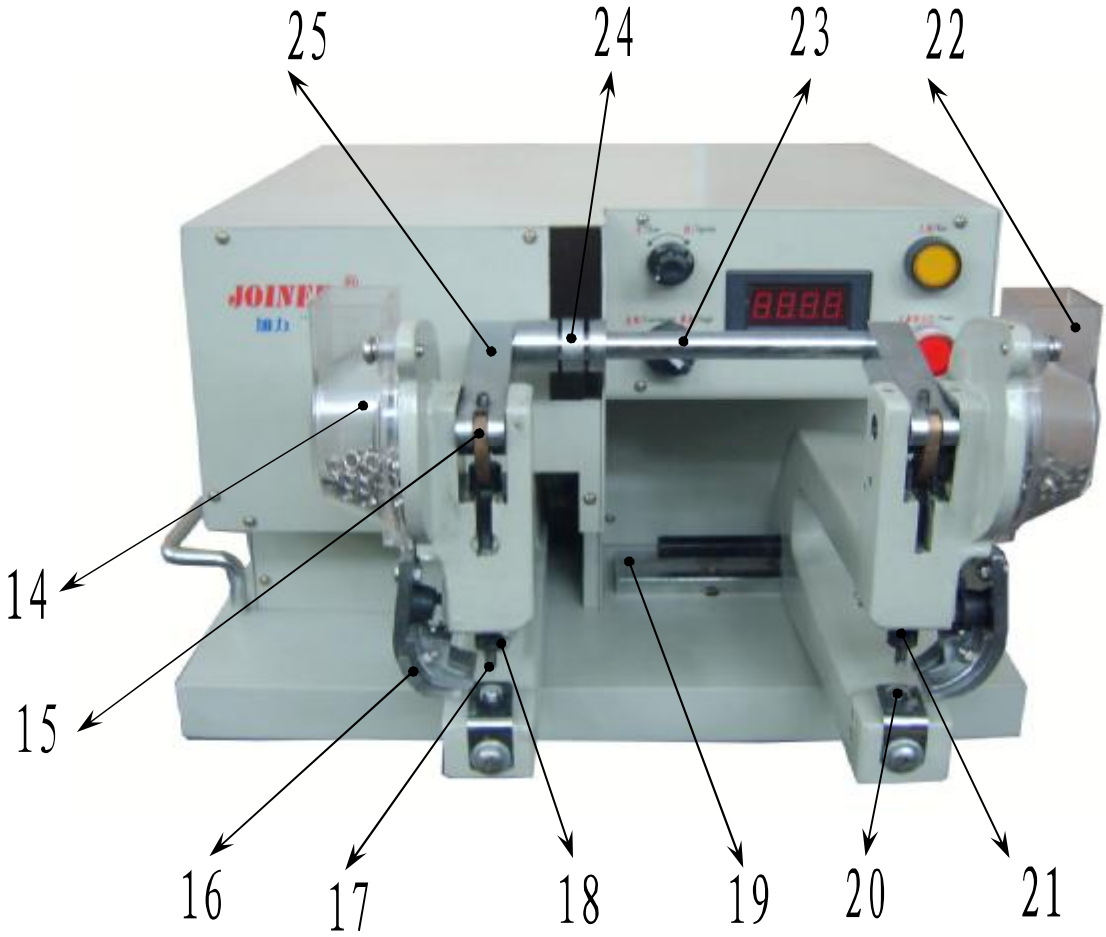
be mass binding.

3.Clothing,Belts and Shoes Binding: Pull back the horizontal axle, After location the proper eyelets puncture location then screw on the handlebar bolt then blending.



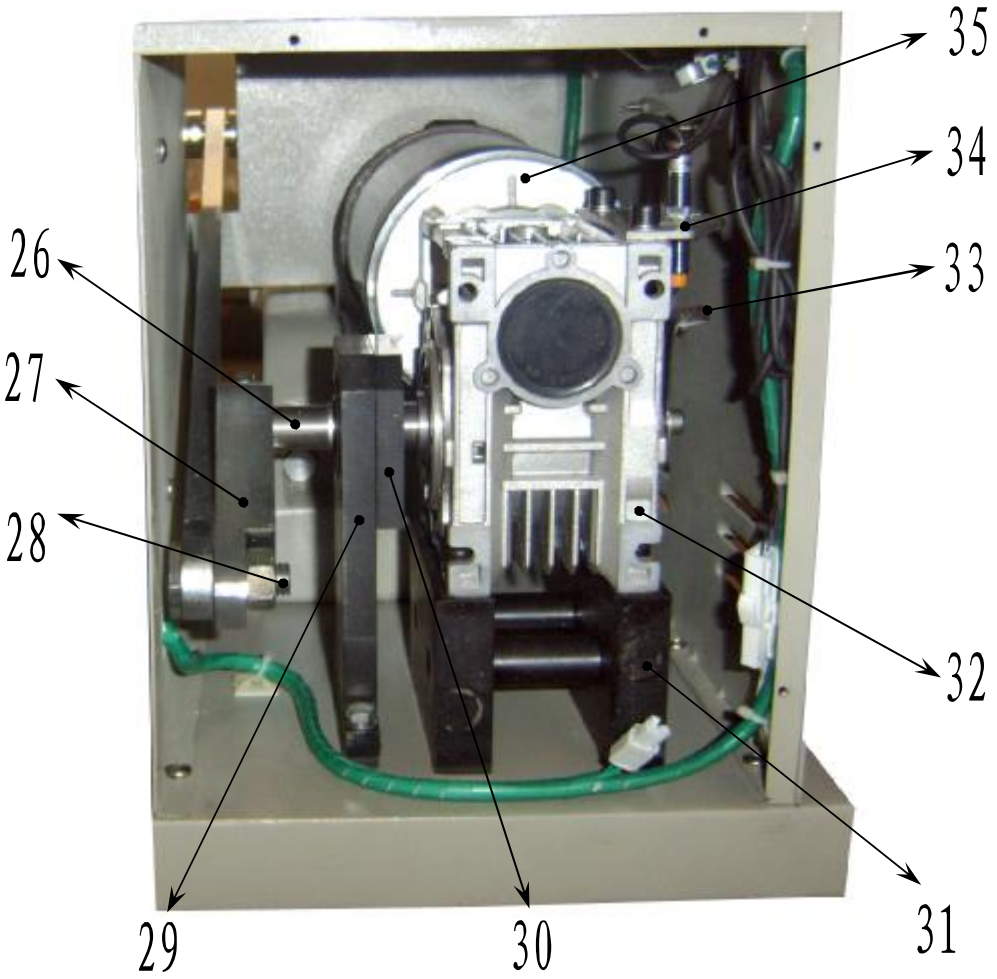
Serial Number	Code	Name
1	JYS 0-9-1	Left lower die base
2	JYSC 0-1-2	Horizontal axle
3	JYS 0-9-12	Spring plate
4	JYS 0-2-3	Left side guide plate
5	(GB77-85)	Lower die adjusting screw
6	(GB71-85)	Lower die locking screw
7	JYS 0-2-2	Right side guide plate
8	JYS-2 0-4-9	Right lower die base
9	JYDC Ⅱ-2 0-1	Machine base
10	JYDC Ⅱ-2 0-11	Screw mandrel
11	JYS-2 0-4-6	Support saddle
12	JYDC Ⅱ-2 0-2	Handlebar
13	JYDC Ⅱ-2 0-13	Machine Cover

Picture I（A）



Serial Number	Code	Name
14	JYS 0-9-2	Left side eyelets case
15	JYD 0-3-28	Bend plate
16	JYS 0-2-6	Block plate
17	JYS 0-4-1	Mandrel
18	JYS 0-9-3	Upper die
19	JYDC Ⅱ-2 0-12	Adjusting base
20	JYS 0-9-4	Lower die
21	JYS 0-1-4	Principal axis
22	JYS-2 0-4-8	Right side eyelets case
23	JYDC Ⅱ-2 0-7	Drive rod
24	JYDC Ⅱ-2 0-6	connecting bar
25	JYDC Ⅱ-2 0-2	Arm Rod

Picture I（B）

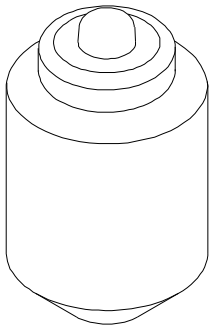
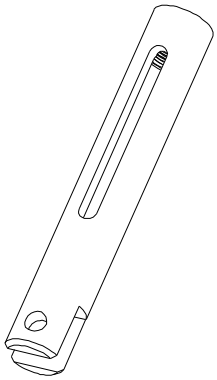
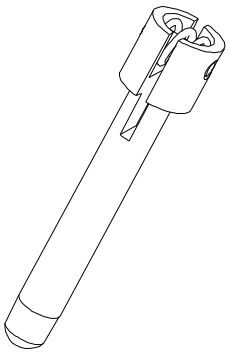
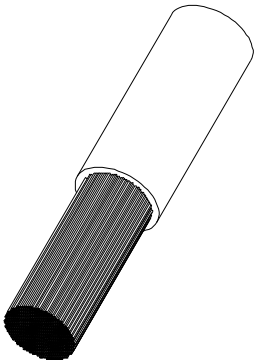
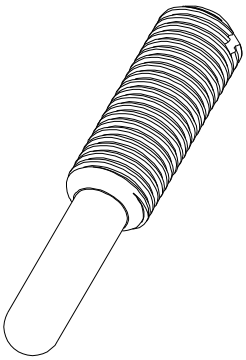
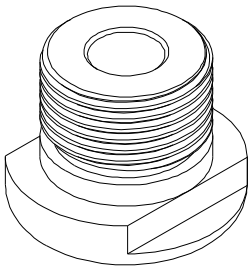
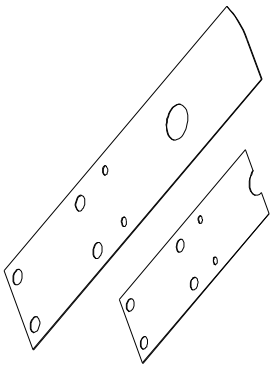
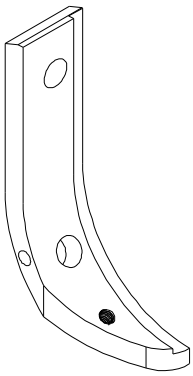
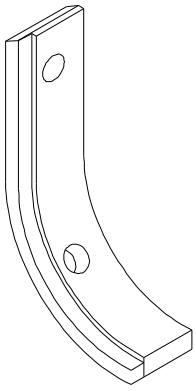
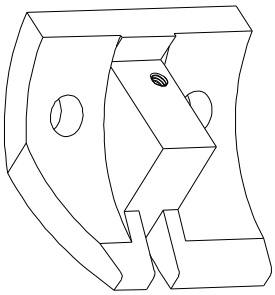
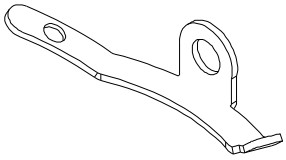
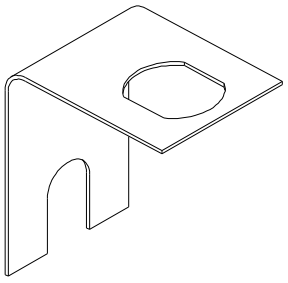


Serial Number	Code	Name
26	JYDC Ⅱ-2 0-3	Gear Rod
27	JYDC Ⅱ-2 0-5	Crank
28	JYD Ⅱ 0-14	Crank shaft
29	JYD Ⅱ 0-11	Shaft block
30	JYDC Ⅱ-2 0-4	Connecting plate
31	JYD Ⅱ 0-5	Gear reducer supporting plate
32	（FCNDK40）	Gear reducer
33	JYD Ⅱ 0-10	Plate Sensor
34	JYD Ⅱ 0-19	Proximity switch supporting plate
35	（110ZYT152）	Electrical motor

Picture II

7. Wearing Parts

Please check the list Ⅰabout the wearing parts attached in this list

			
Lower die	Principal axis	Mandrel assy	Brush assy
			
Adjusting screw	Upper die	Long and short plate spring	Right side guide plate
			
Left side guide plate	Guide slot base	Block plate	Spring plate

List Ⅰ Wearing parts picture and name list

8. Regular Failure And Obviate Method

Fault	Causes of Fault	Obviate method
Eyelets do not come out	1、Eyelets adjoin blocking; 2、Damaged Eyelets; 3、Eyelets size do not suitable for the specification; 4、Brush loose and shift; 5、Eyelets case slot wear out。	1、Select eyelets, do not use dirt or sticky eyelets; 2、Do not use damaged eyelets; 3、Using the standard eyelets; 4、Ensure the top of the brush to the middle of plate is 24-27mm. 5、Change the eyelets case
Eyelets feeding not smoothly	1、The width of guide slot is discord ; Exit of eyelets case is not in the middle; 2、Brush can not brush eyelets to the proper location。	1、Adjust the guide plate to ensure the width of the slot is coinciding. 2、Adjust the brush top to ensure the proper location。
Eyelets do not fix on the Mandrel	1. The location of blocking plate is not correct; 2. The Mandrel is too loose。	1.Adjust the blocking plate to touch the eyelets cylindrical surface 1/2 point。 2.Enlarge the mandrel open slot
After punch eyelets not bending the edge	1、The distance between upper and lower die is not correct; 2、Strength is not correct; 3、Things for binding is not thick。	1、Adjust the distance between upper and lower die according the manual; 2、Operate carefully and Press with proper strength 3、Decrease the thickness of things for binding.
No relative movement between upper die and mandrel	1. The mandrel is out of shape; 2. Locking screw is damaged。	1. Change the mandrel according the manual 2. Change the locking screw.
The eyelet bending is not smooth	1、 The distance between upper and lower die is not correct ; 2、Eyelets quality is not good.	1、Adjust the distance between upper and lower die according the manual ; 2、Use the good quality eyelets.

List II Regular failure and obviate method

In order the customer easily use this machine, especially explain two regular failures and obviate methods.

Failure 1: Failure in eyelets feeding;

According to picture to disassemble the eyelets case, 1) Check damaged eyelets block in the exit or not, If there is please move it out; 2) Check the brush wear out or not. If it is please change it.

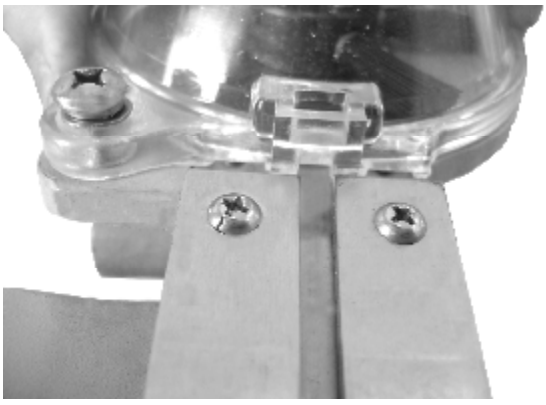
Assemble the eyelets case please ensure the exit match with the guide slot (Picture Ⅳ), screw on the spring plate and pull it out gently (Picture Ⅴ), let the blocking plate over the mandrel (Do not pull the spring plate too strong in case of distortion), shake the handlebar gently to let eyelets feed in the guide slot.

(Attention: when switch handlebar or kick the foot pedal do not over power. Do not let the upper die and lower die collide)。

Failure 2: Eyelets do not fix on mandrel.

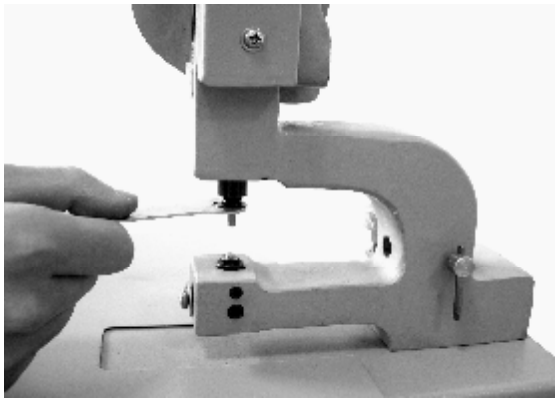
1) Adjust the blocking plate location to let eyelets fix on mandrel naturally; 2) Adjust mandrel: Use the wrench which attached with machine to disassemble the upper die (PictureⅥ), Pull out the mandrel (Picture Ⅶ)、Reset the open slot of mandrel (PictureⅧ), then assemble it back。

Picture Ⅲ



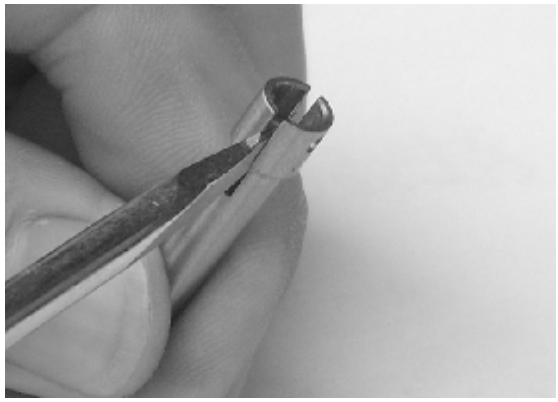
Picture Ⅳ

Picture V



Picture VI

Picture VII



Picture VIII

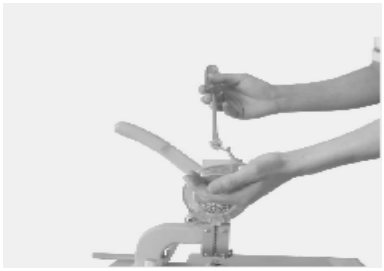
9. Change Specification

This machine can fix in with Φ4mm or Φ5.5mm two different size eyelets. There are two sets of spare parts to match with different size of eyelets. One set fixed on machine. Another was attached with machine. If need to change kindly follow the instruction bellow：

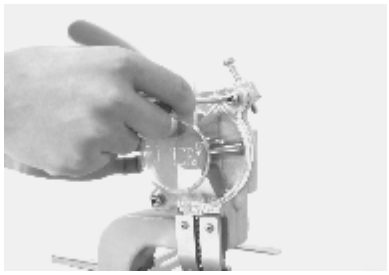
A: Change spare parts disassembling process：

1) Move all eyelets out of the case with help from magnetic tool ；（Picture A—1）
2) Use the screwdriver to screw off the two M6 bolt which connecting the case between machine. Take off the case ；（Picture A—2）

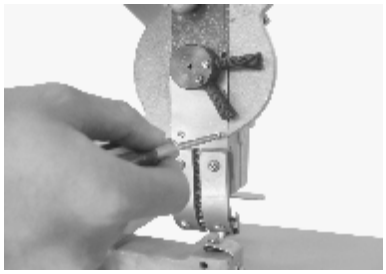
3) Use the screwdriver to screw off the two M3 bolt on machine，then screw off the spring plate assy pullback spring M3 bolt，Take off the spring plate assy；（picture A—3、picture A—4）
4) Use the wrench to take off the upper and lower die（picture A—5）
5) Use the pinchers to pull out the mandrel ,pay attention to the strength （picture A-6）
6) Use the screw to disassemble the spring plate ；（Picture A—7）



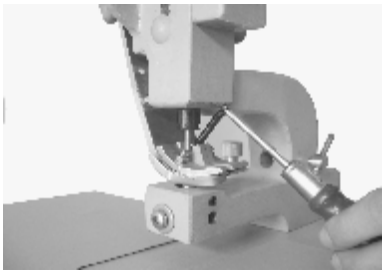
A-1



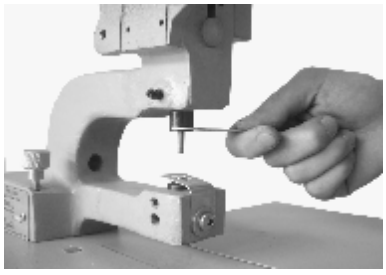
A-2



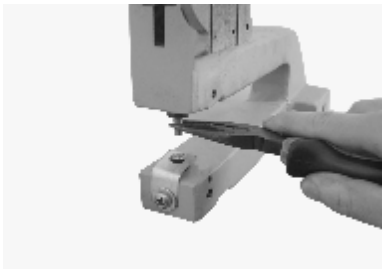
A-3



A-4

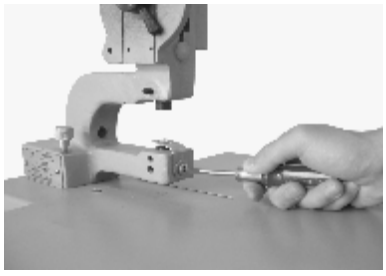


A-5



A-6

7) Use 3MM inner hexagon spanner to loose the locking screw；（Picture A—8）
8) Take out the lower die .If it is too tight, it can be took out by tools。（Picture A—9）
9) Load in the right size eyelets in the case then it can be operated.



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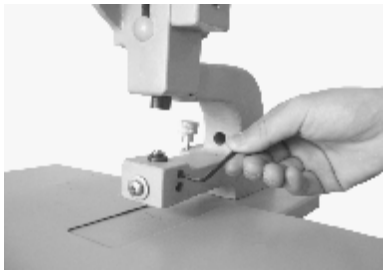

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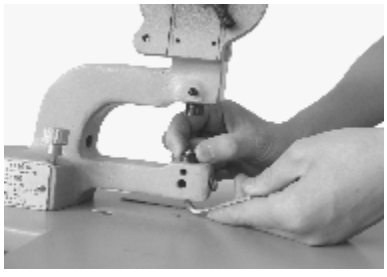
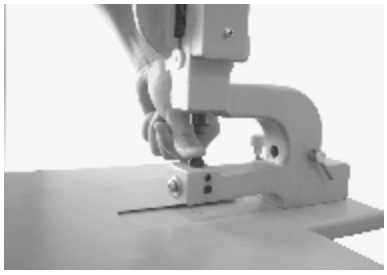


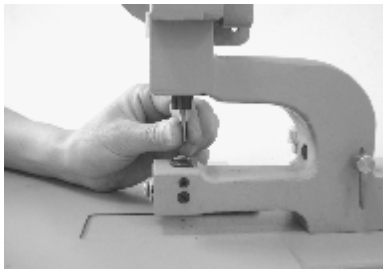
A-9

B: Change spare parts assembling process ：

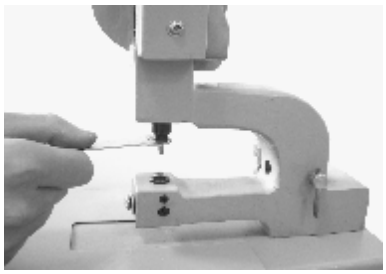
1) Set lower die in the base. Do not lock it on waiting for adjustment;（Picture B—1）
2) Fix the mandrel in mandrel hole，Pay attention to do not deflection;（Picture B—2）
3) Screw the upper die in to mandrel hole the screw it on;（Picture B—3）
4) Connect the pullback spring with machine then screw on the two M3 bolt. Not tight wait for adjustment.
5) Adjust the spring plate location to let the slot match with mandrel. Let the mandrel right in the middle of the slot（Picture B—4）Not tend to one side（Picture B—5）Then screw on M3 bolt（Picture B—6）;



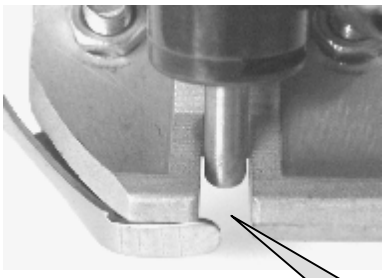
B-1



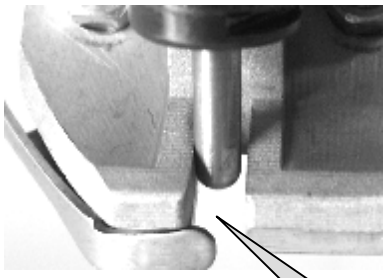
B-2



B-3



B-4



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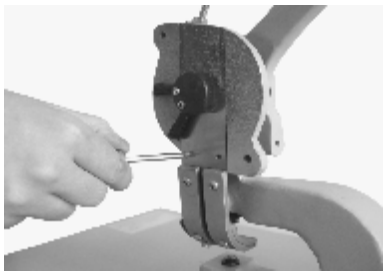
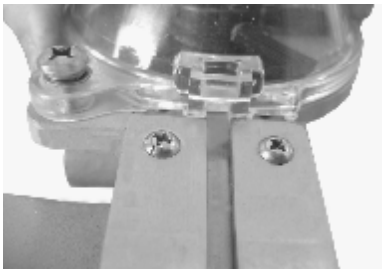
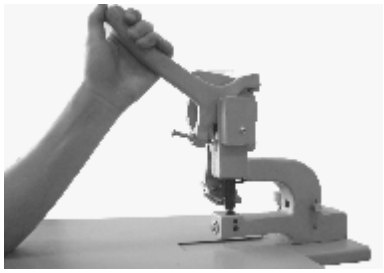


B-6

6) Screw on the two M6 bolt which connecting the case with machine，Pay attention to the exit of case match with the guide slot;（Picture B—7）
7) Press the arm to the bottom（Picture B—8），Then use screwdriver to screw on the locking screw，make the upper and lower die joint;（Picture B—9）
8) Screw on the lower die locking screw then fix on the plate spring;
9) Loading the right size eyelets then it can be operated.



B-7



B-8

B-9

10. Attentions:

1) All machines have already been set up before leave factory. Except upper and lower die clearance need to adjust. Does not disassembling the machine if there is no need.

2) Before operation please drop one drop of lubricating oil at the oil hole. All movement parts need lubricating oil but pay attention to the oil may dirt the things for binding.

3) Strictly prohibit put hands between upper and lower die.

4) When there are no things for binding, Please do not operate the machine.

5) Please load the eyelets size match with the machine model.

11. Special Note

1) Be sure to use the eyelets supported by our company. Do not use damaged or disqualification eyelets.

2) In order to keep the brush long time use. Please load the eyelets half full of the case in case of too many eyelets make the brush easily wear out.

3) Do not overexert when eyelets puncture in case of the machine damage.

4) During the operation, please check the screw regularly in case of some bolts loose。

5) Specifications are subject to change without notice for further improvement