

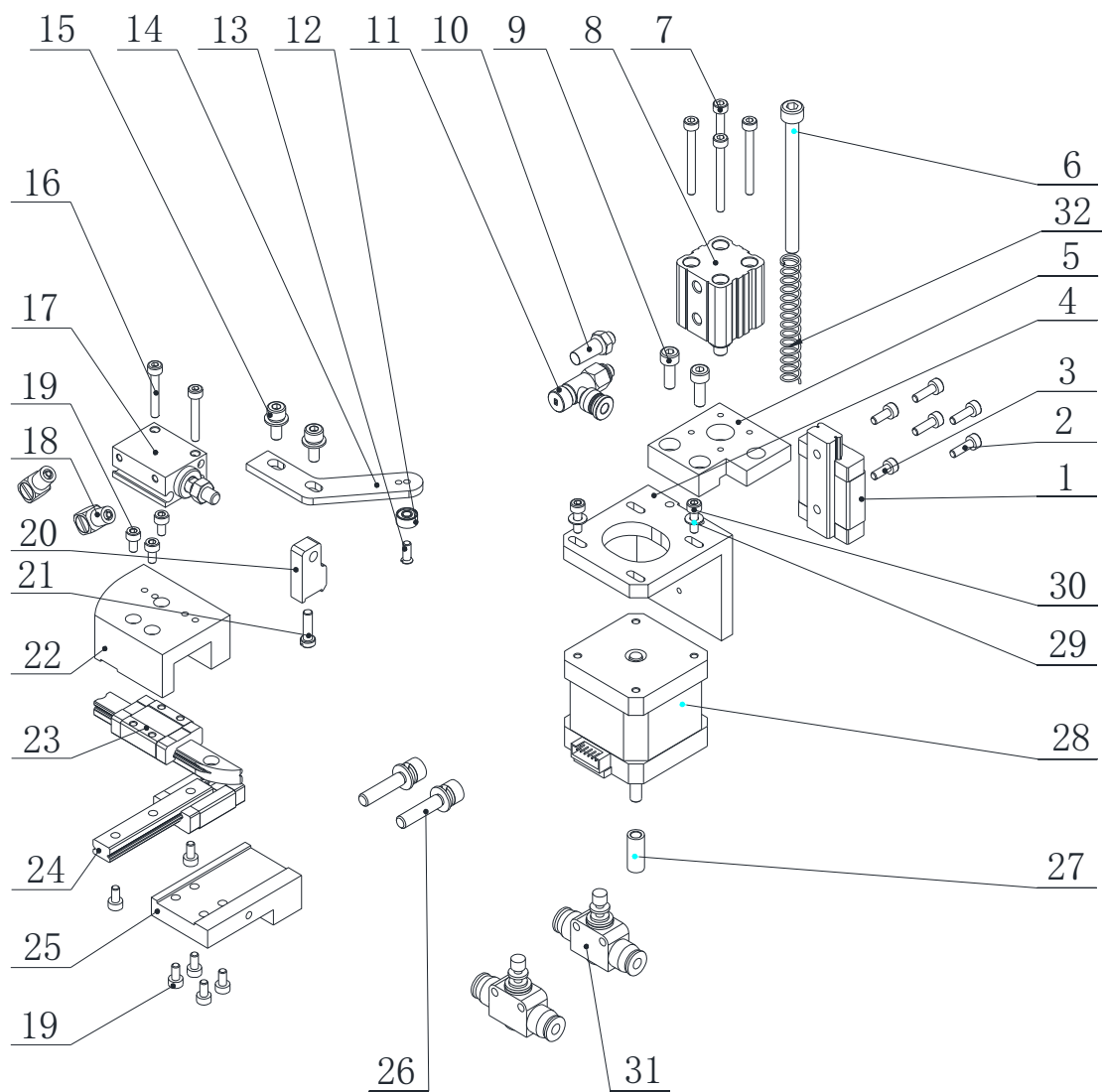
JK-T988A 自动送扣机

JK-T988A Button Auto-Feeding Machine

零件手册

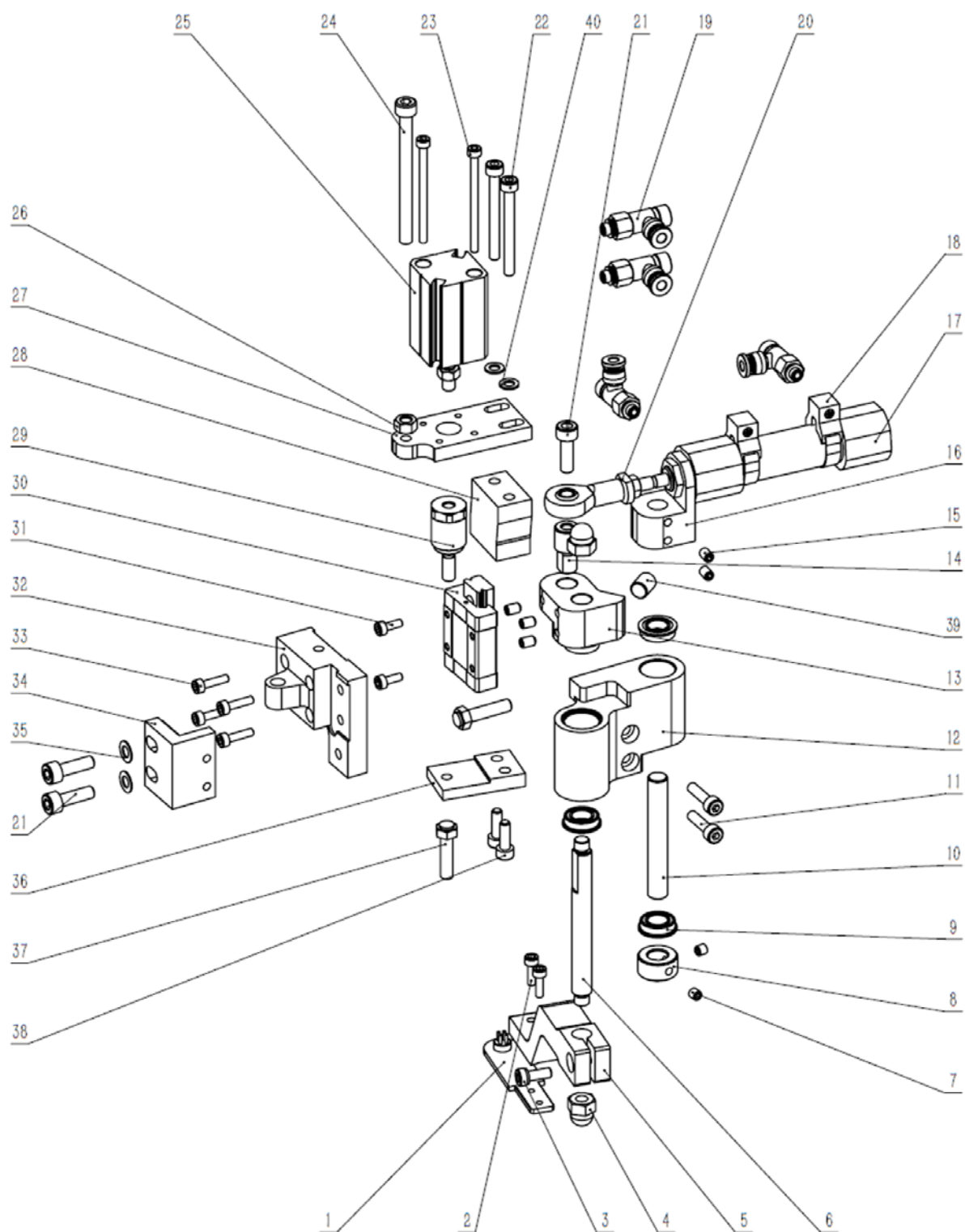
parts manual

1、 压扣部件/PRESS BUTTON COMPONENTS



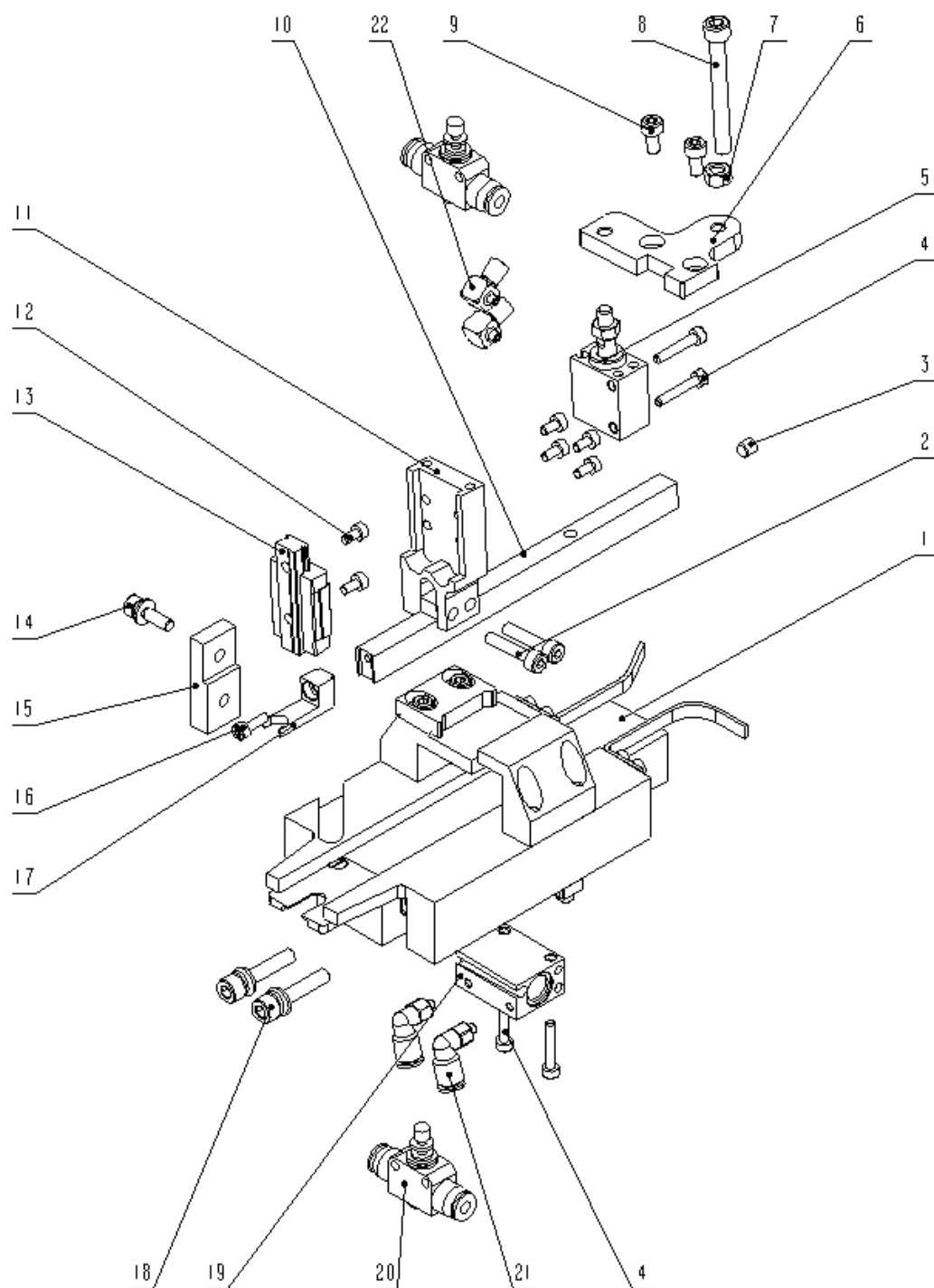
序号	公司件号	名称	DESCRIPTION	用量
1	140808001	线性导轨 12×43	Linear guide rail 12 × 43	2
2	S05052	内六角圆柱头螺钉 M3×10	Screw M3 ×10	4
3	S05094	内六角螺钉 M3×8	Screw M3 × 8	2
4	140801069	压扣电机安装板	Mounting plate of crimping motor	1
5	140801070	压扣气缸安装板	Crimping cylinder mounting plate	1
6	701S13022	内六角圆柱头螺钉 M5×45	Screw M5 × 45	1
7	S05599	内六角圆柱头螺钉 M3×30	Screw M3 × 30	4
8	140845001	压扣气缸	Cylinder ACQ12 ×10	1
9	S05133	内六角圆柱头螺钉 M4×12	Screw M4 × 12	2
10	140845005	消音器 BSLM5	Silencer bsIm5	1
11	41845231	接头 ASL4-M5	Speed governing connector ASL4-M5	1
12	140324003	微型轴承 693ZZ	Micro bearing 693zz	1
13	138S17301	开槽沉头螺钉 M3×8	Screw M3×8	1
14	140801072	挡扣调节杆	Catch adjusting lever	1
15	421S13012	螺钉 M4×10(带垫)	Screw M4 × 10 (with cushion)	2
16	S05991	内六角圆柱头螺钉 M3×20	Screw M3×20	2
17	140845017	气缸 MU10×15	Cylinder MU10×15	2
18	140836003	全金属微型管接头	Micro air pipe connector	2
19	421S13038	内六角圆柱头螺钉 M3×6	Screw M3×6	9
20	140801073	挡扣连接块	Buckle connecting block	1
21	401S11003	复合槽盘头螺钉 SM9/64"×40×7	screw SM9/64" ×40× 7	1
22	140801074	挡扣滑块座	Stopper slider seat	1
23	140808002	挡扣导轨 9×70	Linear rail 9 × 70	1
24	140808003	线性导轨 9×55	Linear guide 9 × 55	1
25	140801075	挡扣安装座	Retaining buckle mounting seat	1
26	403S13009	电机安装螺钉组件 M5×25	Screw assembly M5×25	2
27	140822001	压扣胶套(小)	Crimping rubber sleeve (small)	1
28	140833001	旋转电机	Rotating electrical machine	1
29	W01002	平垫圈 3	Flat washer 3	2
30	S05052	螺钉 M3×10	Screw M3 ×10	2
31	41845232	T形接管 KJT04	Throttle valve	2
32	140827001	压扣弹簧	Buckle spring	1

2、 送扣部件/ SEND BUTTON COMPONENTS



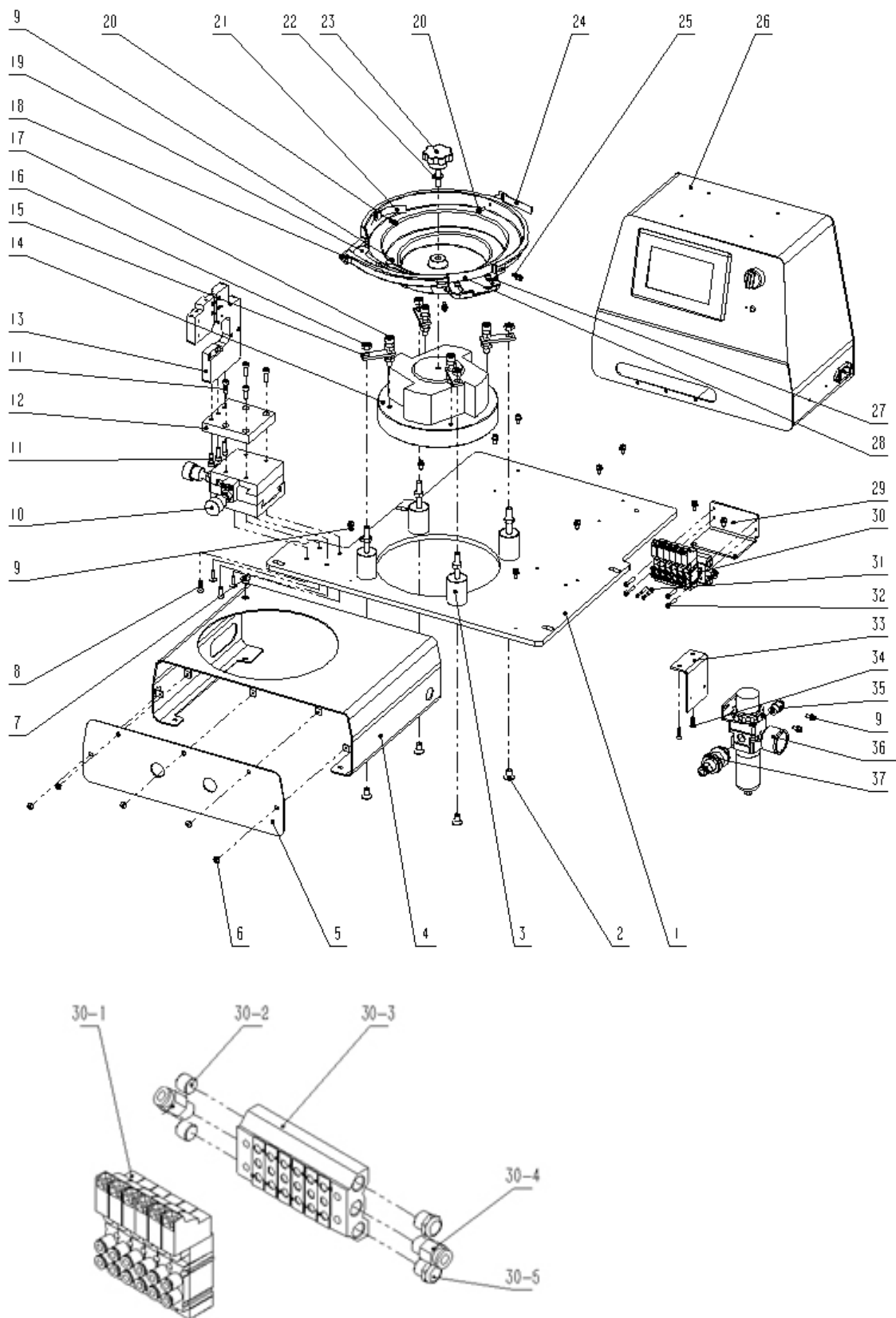
序号	公司件号	名称	DESCRIPTION	用量
1	140816030	一体四眼送扣爪 1.2×2.4	Integrated four eye buckle feeding claw 1.2 × 2.4	1
2	S05052	内六角圆柱头螺钉 M3×10	screw M3 × 10	2
3	413S13017	内六角圆柱头螺钉 M4×10	screw M4 × 10	1
4	417S16301	圆头螺母 M6×5	Round head NUT M6 × 5	2
5	140801076	送扣转臂	Turnbuckle feeding arm	1
6	140803001	送扣转动轴	Thread feeding rotating shaft	1
7	S10007	内六角凹端紧定螺钉 M4X4	screw m4x4	2
8	42108007	挡圈	Retaining ring	1
9	140824001	轴承 MFL148ZZ	Bearing mfl148zz	4
10	140826003	连接轴	Connecting shaft	1
11	S05118	内六角螺钉 M4×16(滚花)	Hexagon socket screw M4 × 16 (knurled)	2
12	140801077	送扣臂支座	Buckle feeding arm support	1
13	140801015	旋转曲柄	Rotating crank	1
14	140826002	连接销	Connecting pin	1
15	421S14005	螺钉 M4×6	Screw M4 × 6	5
16	140801010	旋转送料曲柄	Rotating feed crank	1
17	140845006	气缸	Cylinder	1
18	141730028	传感器固定绑带	Sensor fixing strap	2
19	41845231	接头 ASL4-M5	Speed governing connector ASL4-M5	4
20	4030500500	连接曲柄	Connecting the crank	1
21	S05124	螺钉 M5×16(滚花)	Screw M5 × 16 (knurled)	2
22	S05065	螺钉 M4×40	Screw M4 × 40	2
23	S05270	内六角平头螺钉 M3×40	Screw M3 × 40	2
24	L01863	内六角圆柱头螺钉 M5×60	Screw M5 × 60	1
25	140845003	摆臂上下气缸	Upper and lower cylinders of swing arm	1
26	N01004	六角螺母 M5	Hex nut M5	2
27	140801078	压扣气缸安装板	Crimping cylinder mounting plate	1
28	140801079	送扣上下垫块	Feeding buckle upper and lower cushion blocks	1
29	4250400600	大压脚气缸连接器组件	Large presser foot cylinder coupler assembly	1
30	140808001	线性导轨 12×43	Linear guide rail 12 × 43	1
31	S05094	内六角螺钉 M3×8	Screw M3 × 8	2
32	140801080	送扣上下滑块座	Upper and lower slider seats for buckle feeding	1
33	421S13060	内六角圆柱头螺钉 m3×12	Screw m3×12	4
34	140801081	送扣臂连接块	Connecting block of feeding arm	1
35	42328601	垫圈 5	Washer 5	2
36	140801082	送扣下限位板	Lower limit plate of buckle feeding	1
37	1408NS20003	止动螺栓 M5×20	Stop bolt M5×20	2
38	S05133	内六角圆柱头螺钉 M4×12	screw M4 × 12	2
39	140822003	限位块	Stop block	1
40	41328023	垫圈 4	Washer 4	2

3、 纽扣传送部件/ BUTTON TRANSFER COMPONENTS



序号	公司件号	名称	DESCRIPTION	用量
1	14080901000	送扣轨道组件	Feed rail assembly	1
2	S05119	内六角圆柱头螺钉 M4×20)	screw M4 × 20	2
3	207s11042	内六角平端紧定螺钉 M5×5	Screw M5×5	1
4	S05991	内六角圆柱头螺钉 M3×20	screw M3×20	4
5	140845018	气缸 MU10×10B	Cylinder mu10 × 10B	1
6	140801086	测扣连接板	Measuring buckle connecting plate	1
7	N01004	六角螺母 M5	Hex nut M5	1
8	421S13046	内六角圆柱头螺钉 M5×45	screw M5 × 45	1
9	421S13035	内六角螺钉 M4×8	Hexagon socket head screw M4×8	2
10	140801084	送扣上挡条	Send and buckle the retaining strip	1
11	140801085	上挡条固定座	Upper retaining strip fixing seat	1
12	421S13038	内六角圆柱头螺钉 M3×6	Screw M3×6	6
13	140808004	线性导轨 9×40	Linear guide9×40	1
14	417S30034	内六角圆柱头螺钉 M4×10	Screw M4×10	1
15	140801100	轨道气缸连接板	Rail cylinder connecting plate	1
16	S05052	内六角圆柱头螺钉 M3×10	screw M3×10	1
17	140801024	送扣座(小)	Buckle feeding seat (small)	1
18	403S13009	电机安装螺钉组件 M5×25	Screw assembly M5×25	2
19	140845017	气缸 MU10×15	Cylinder mu10 × fifteen	2
20	41845232	T 形接管 KJT04	throttle valve	2
21	140836001	L 型气管接头	L-type air pipe connector	2
22	140836003	全金属微型管接头	Micro air pipe connector	2
22	41845231	接头 ASL4-M5	Speed governing connector ASL4-M5	1

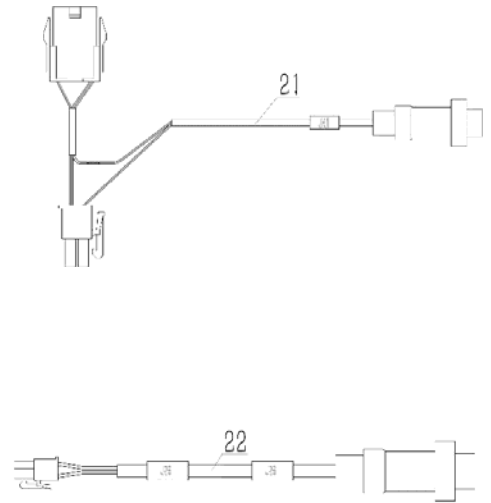
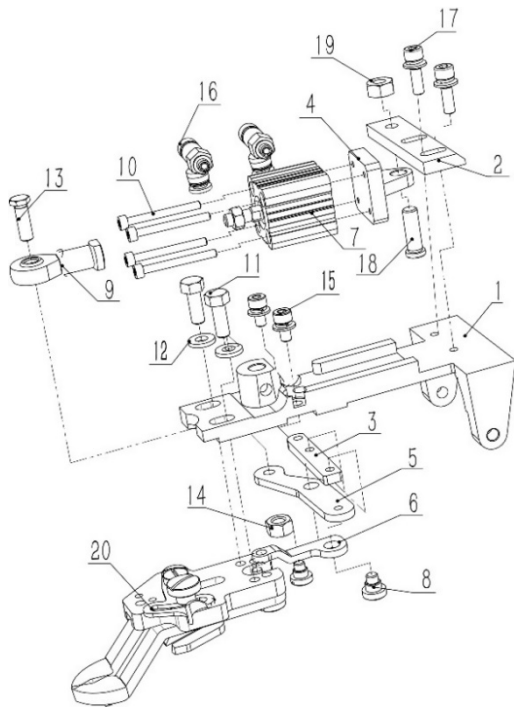
4、 电控柜及振动盘部件/ Electric control cabinet and vibration panel COMPONENTS



序号	公司件号	名称	DESCRIPTION	用量
1	930000843	安装底板	Install the base plate	1
2	1408NS30005	内六角沉头螺钉 M8×14	screw M8 × 14	4
3	140822004	橡胶减震垫	Rubber cushion	4
4	930000840	送扣装置罩组件	Buckle feeding device cover assembly	1
5	930000841	送扣装置罩前面板	Front panel of buckle feeding device cover	1
6	421S10022	十字半圆头螺钉 M4×5.5	Screw M4×5.5	5
7	41322012	橡胶塞	Rubber stopper	1
8	417S17852	内六角沉头螺钉 M5×16	Screw M5×16	4
9	421S13012	螺钉 M4×10(带垫)	Screw M4 × 10 (with cushion)	13
10	14080108700	送扣调节模组	Button feeding adjustment module	1
11	S05124	螺钉 M5×16(滚花)	Screw M5 × 16 (knurled)	7
12	140801088	送扣组件安装板	Mounting plate of buckle feeding assembly	1
13	140801089	送扣组件支撑板	Support plate of buckle feeding assembly	1
14	140830001	振动器	Vibrator	1
15	140812005	连接板	Connecting plate	4
16	N01011	螺母 M8	Nut M8	16
17	S05076	内六角螺钉 M8×40	Hexagon socket screw M8 × 40	4
18	930000844	振动盘	Vibrating plate	1
19	140812028	压扣板	Crimping plate	1
20	S17899	内六角圆头螺钉 M4×10	screw M4 ×10	2
21	140816018	限位板	Stop plate	1
22	40228002	止推垫圈	Thrust washer	1
23	1408NS30004	梅花手柄螺钉 M8×35	Torx handle screw M8 × thirty-five	1
24	140816033	限位板（小）	Stop plate (small)	1
25	417S30034	螺钉 M4×14(带垫)	Screw M4 × 14 (with cushion)	4
26		电控组件	Electronic control assembly	1
27	140812007	筛选板	Filter board	1
28	140812009	挡板	Baffle	1
29	140812006	阀板安装板	Valve plate mounting plate	1
30		电磁阀组件	Solenoid valve assembly	1
30-1	140845008	电磁阀	Solenoid valve	6
30-2	140345004	堵头 X-ABP01	Plug	2
30-3	141730021	连阀座 7V0500M6F	Valve seat	1
30-4	141845029	直接头 PC601	Tracheal joint	2
30-5	40728003	消声器 BSLM-01	Muffler	2
31	42122001	快换插头 KQ2P-04	Quick change plug	2
32	S05119	内六角圆柱头螺钉 M4×20	Screw M4×20	4
33	140812025	气源处理器安装板	Air source treatment mounting plate	1
34	403S30020	十字槽沉头自攻螺钉	Screws ST3.8×20	2
35	40736018	螺纹直通 APC6-02	Thread straight apc6-02	1
36	141845004	气源处理元件 AW20-B	Air source processing element AW20-B	1
37	42130096	手动开关 VHK3	Manually switch VHK3	1

5、 钮钳部件（373GR）/ Electric control cabinet and vibration

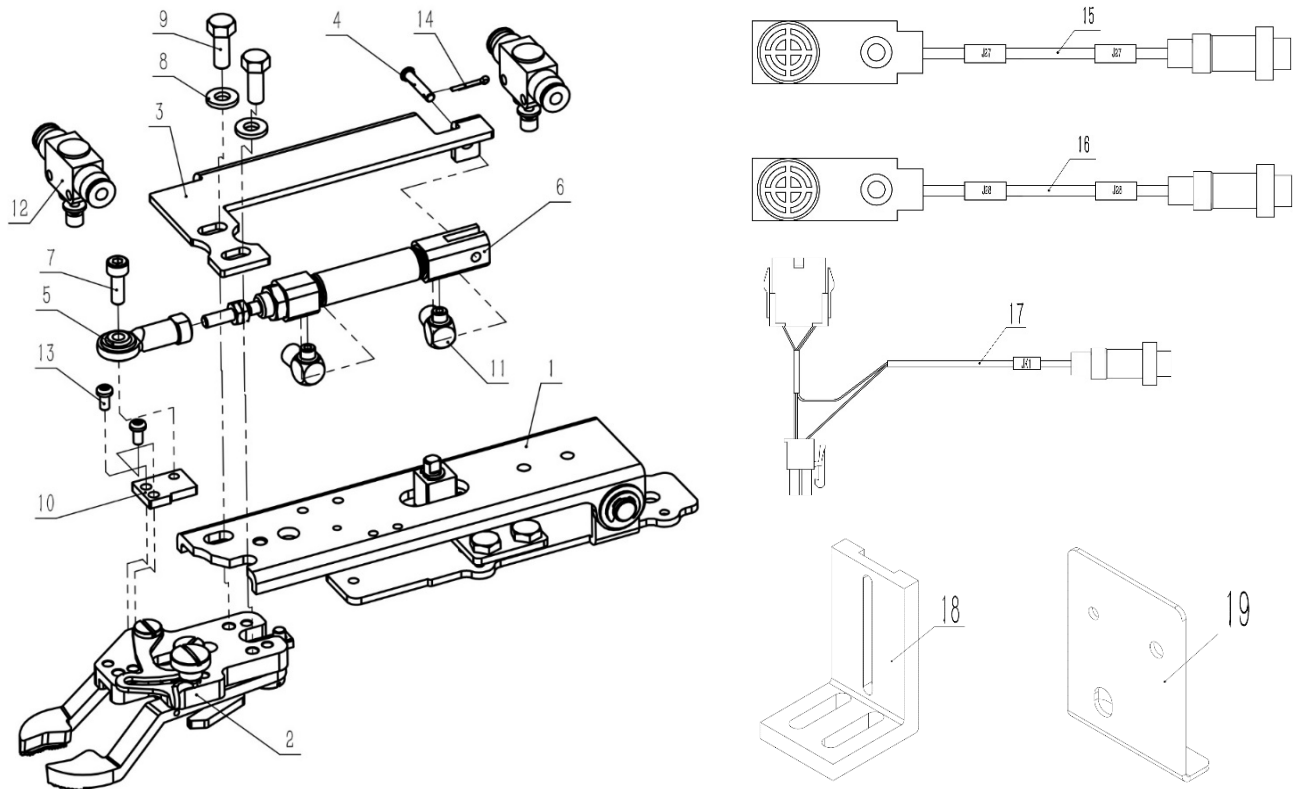
panel COMPONENTS（373GR）



序号	公司件号	名称	DESCRIPTION	用量
1	930000851	钮钳座	Toggle clamp holder	1
2	140801033	气缸安装板	Cylinder mounting plate	1
3	140812020	夹扣支撑板	Clamp support plate	1
4	140801032	气缸安装座	Cylinder mounting seat	1
5	140812021	连接杠杆	Connecting lever	1
6	140812022	钮钳连杆	Toggle clamp connecting rod	1
7	140845001	压扣气缸	Button pressure cylinder	1
8	1408NS30006	开槽圆柱头轴位螺钉	Slotted cylindrical head shaft screws	2
9	4030500500	连接曲柄	Connecting the crank	1
10	S05599	内六角圆柱头螺钉 M3×30	Hexagon socket cylindrical head screw M3×30	4
11	409S12001	六角头螺栓	Hexagon head bolt	2
12	40928001	垫圈	The gasket	2
13	L01002	六角头螺栓 M5×8	Hexagon head bolt M5×8	1
14	1421NS16002	六角螺母 M5	Hex nut M5	1
15	421S13035	螺钉 M4×8	Screw M4×8	2
15	W01001	垫圈	The gasket	2
16	41845231	接头 ASL4-M5	Speed governing connector ASL4-M5	2
17	417S30034	螺钉组件 M4×14	Screw assembly M4×14	2
18	141824014	轴位螺钉 M6	Axial screw M6	1
19	N01007	六角螺母 M6	Hexagon nut M6	1
20	14081603900	钮夹组件	Button clip component	1
21	195430032	脚踏保护信号线(外接)	Pedal protection signal cable (external)	1
22	195430029	送扣信号线组件(外接)	Buckle signal cable assembly (external)	1

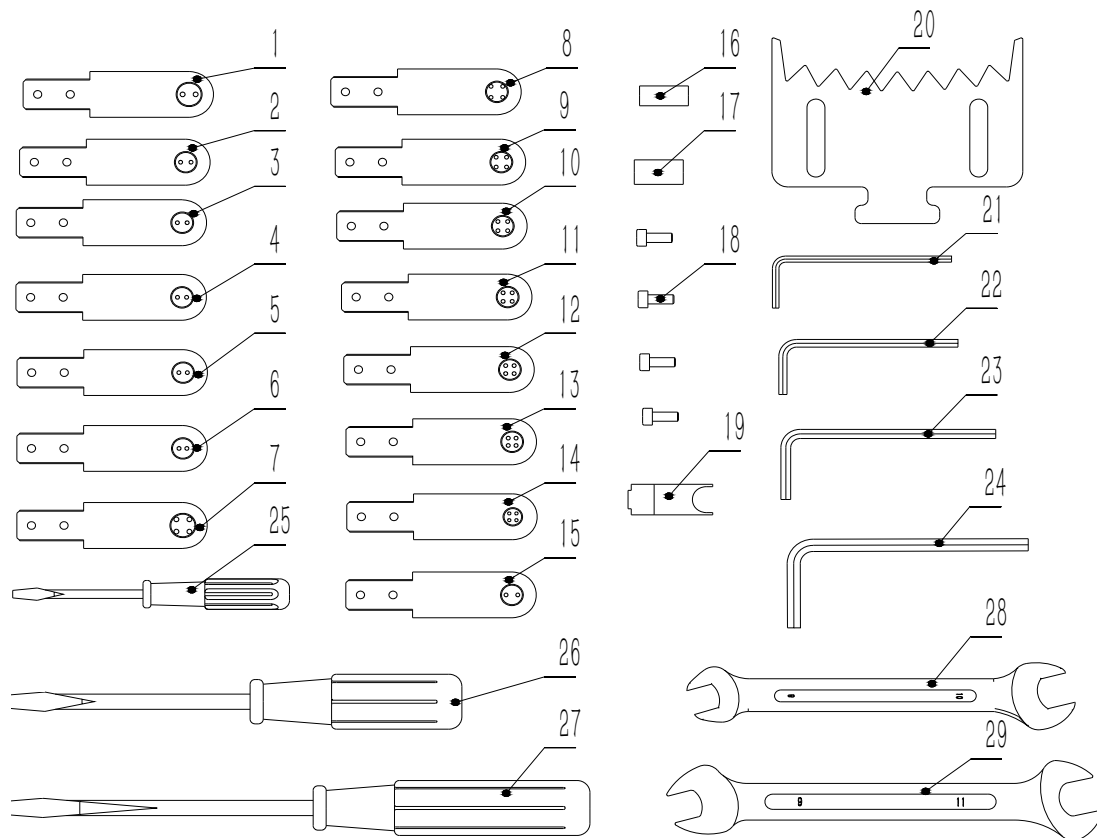
6、钮钳部件（1903GR） / Electric control cabinet and vibration

panel COMPONENTS（1903GR）



序号	公司件号	名称	DESCRIPTION	用量
1	4052800300	爪脚提升板组件	Claw foot lift plate assembly	1
2	14081601900	钮夹组件	Button clip component	1
3	140812024	气缸安装板	Cylinder mounting plate	1
4	140826004	支撑销	Support pin	1
5	140845004	鱼眼型气缸接头 M4	Fisheye cylinder connector M4	1
6	140845009	气缸	cylinder	1
7	S05133	内六角圆柱头螺钉 M4×12	Hexagon socket head screws M4x12	1
8	40928001	垫圈	The gasket	2
9	409S12001	六角头螺栓	Hexagon head bolt	2
10	140812023	气缸连接板	Cylinder connecting plate	1
11	42230519	微型接头 M-5HLH-4	Miniature connector M-5HLH-4	2
12	41845232	T形接管 KJT04	T-pipe KJT04	2
13	403S11020	十字槽圆柱头螺钉 M3×6	Screws M3×6	2
14	P05007	开口销 1.6×8	1.6×8 cotter pin	1
15	195430041	压脚信号线(外接)	Pressure pin signal cable (external)	1
16	195430034	剪线信号线(外接)	Cutting signal cable (external)	1
17	195430050	脚踏保护信号线(1903 外接)	Pedal protection signal line (1903 external connection)	1
18	140812027	传感器安装架 2(1903GR)	Sensor mounting bracket 2 (1903GR)	1
19	140812026	传感器安装架 1(1903GR)	Sensor mounting bracket 1 (1903GR)	1

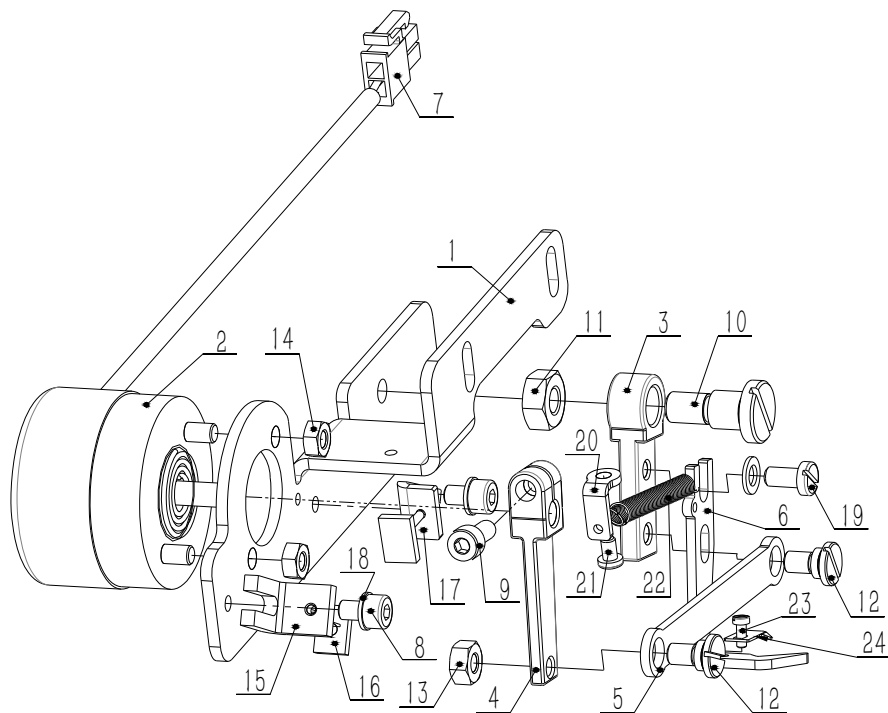
7、附件/ The attachment



序号	公司件号	名称	DESCRIPTION	数量
1	140816017	一体二眼送扣爪 1.5×4.0	One body two eyes delivery claw 1.5×4.0	1
2	140816019	一体二眼送扣爪 1.2×3.2	One body two eyes delivery claw 1.2×3.2	1
3	140816020	一体二眼送扣爪 1.2×3.0	One body two eyes delivery claw 1.2×3.0	1
4	140816021	一体二眼送扣爪 1.2×2.8	One body two eyes delivery claw 1.2×2.8	1
5	140816022	一体二眼送扣爪 1.2×2.6	One body two eyes delivery claw 1.2×2.6	1
6	140816023	一体二眼送扣爪 1.0×2.4	One body two eyes delivery claw 1.0×2.4	1
7	140816024	一体四眼送扣爪 1.5×4	One body four eyes delivery claw 1.5×4	1
8	140816025	一体四眼送扣爪 1.2×3.6	One body four eyes delivery claw 1.2×3.6	1
9	140816026	一体四眼送扣爪 1.2×3.2	One body four eyes delivery claw 1.2×3.2	1
10	140816027	一体四眼送扣爪 1.2×3.0	One-piece four-eye delivery claw 1.2×3.0	1
11	140816028	一体四眼送扣爪 1.2×2.8	One body four eyes delivery claw 1.2×2.8	1
12	140816029	一体四眼送扣爪 1.2×2.6	One body four eyes delivery claw 1.2×2.6	1
13	140816030	一体四眼送扣爪 1.0×2.4	One body four eyes delivery claw 1.0×2.4	1
14	140816031	一体四眼送扣爪 1×2.2	One body four eyes delivery claw 1×2.2	1
15	140816032	一体二眼送扣爪 1.2×3.6	One body two eyes delivery claw 1.2×3.6	1
16	140822001	压扣胶套(小)	Pressing rubber sleeve (small)	5
17	140822002	压扣胶套(大)	Buckle rubber sleeve (large)	5
18	S05052	内六角螺钉 M3×10	Hexagon socket screw M3×10	4
19	140801029	送扣座	To clinch	1
20	140812029	筛选板(大)	Screening plate (large)	1
21	20131046	内六角扳手 2mm	Inner hexagon wrench 2mm	1

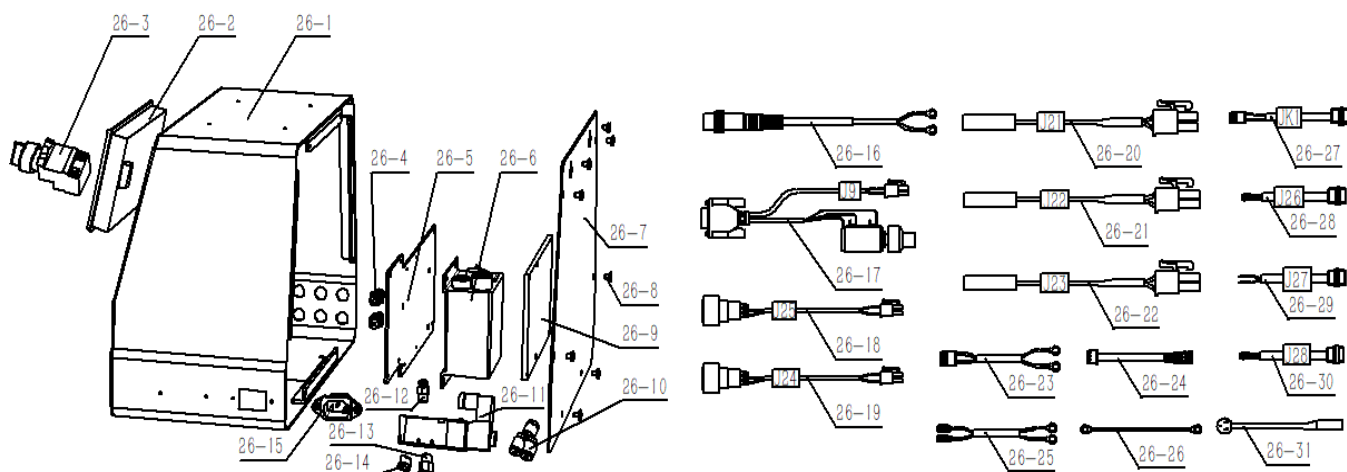
22	30131010	内六角扳手 2.5mm	Inner hexagon wrench 2.5mm	1
23	30131012	内六角扳手 3mm	Inner hexagon wrench 3mm	1
24	20131047	内六角扳手 4mm	Inner hexagon wrench 4mm	1
25	10131004	螺丝刀(小)	Screwdriver (small)	1
26	10131003	螺丝刀(中)	Screwdriver (middle)	1
27	10131002	螺丝刀(大)	Screwdriver (large)	1
28	30131006	双开口扳手(8-10mm)	Double open end wrench (8-10mm)	1
29	40931025	扳手(9mm-11mm)	Wrench (9 mm to 11 mm)	1

8、扫线器（14093001100）/ Wire sweeper（14093001100）



序号	公司件号	名称	DESCRIPTION	数量
1	14093001100-01	扫线安装板	Sweep the cable mounting plate	1
2	14093001100-02	电磁铁	electromagnet	1
3	14093001100-03	摆臂	Swing arm	1
4	14093001100-04	转动臂	Rotate the arm	1
5	14093001100-05	连杆	Connecting rod	1
6	14093001100-06	扫线板	Sweep line board	1
7	14093001100-12	二芯插头	Two core plug	1
8	S05115	内六角圆柱头螺钉 M4×6	Hexagon socket Head Screws M4×6	2
9	S05058	内六角圆柱头螺钉 M4×10	Hexagon socket Head Screws M4×10	1
10	409S20014	开槽圆柱头轴位螺钉	Slotted cylindrical head shaft screws	1
11	409S16008	六角螺母 SM1/4×24	Hexagonal nut SM1/4×24	1
12	14093001100-07	开槽轴位螺钉	Slotted shaft screws	2
13	409S16018	六角螺母 SM11/64×40	Hexagonal nut SM11/64×40	1
14	N01110	六角螺母 M4	Hexagon nut M4	2
15	14233001500-05	限位块	Limit block	1
16	14233001500-06	缓冲橡胶	Buffer rubber	2
17	14093001100-11	右限位支架	Right limit bracket	1
18	41328023	垫圈	The gasket	3
19	S01068	开槽圆柱头螺钉 M4×8	Slotted cylindrical head screws M4×8	1
20	14093001100-08	拉簧座	Tension spring seat	1
21	1211NS13002	螺钉 M3×4.5	screws M3×4.5	1
22	14093001100-10	拉簧	Tension spring	1
23	S01197	开槽圆柱头螺钉 M2×5	Slotted cylindrical head screw M2×5	1
24	14093001100-09	勾线板	Cancel the plate	1

4-26. 电控组件/ Electronic control assembly



序号	公司件号	名称	DESCRIPTION	用量
26-1	930000837	电控柜外壳组件	Electric control cabinet shell components	1
26-2	195430026	屏幕	screen	1
26-3	195444031	电源开关	power switch	1
26-4	195445001	隔板直通对插 4-4	Bulkhead straight plug-in 4-4	2
26-5	140812016	电控柜电路板固定板	Electric control cabinet circuit board fixing plate	1
26-6	140830002	振动送料控制器	Vibration feeding controller	1
26-7	930000838	电控柜后盖板	Rear cover plate of electric control cabinet	1
26-8	421S10022	十字半圆头螺钉	Cross half round head screw	8
26-9	195400096	电路板	Circuit board	1
26-10	140736004	气管接头	Tracheal joint	2
26-11	41845212	电磁阀	Solenoid valve	1
26-12	41845222	螺纹直通 APC4-01	Thread straight APC4-01	2
26-13	141845029	直接头 PC601	Direct head PC601	1
26-14	40728003	消音器 BSLM-01	Silencer BSLM-01	2
26-15	195430043	品字插座	Pinzi socket	1
26-16	195400103	振动盘驱动器电源线	Vibration disk driver power cord	1
26-17	195430035	振动盘驱动器控制线	Vibration disk driver control line	1
26-18	195430037	补扣按键连接线	Supplementary button connection line	1
26-19	195430036	复位按键连接线	Reset button connection line	1
26-20	195430058	传感器连接线-1 (J21)	Sensor Connection Wire-1	1
26-21	195430059	传感器连接线-2 (J22)	Sensor Connection Wire-2	1
26-22	195430060	传感器连接线-3 (J23)	Sensor Connection Wire-3	1
26-23	195430038	电路板电源线	Circuit board power cord	1
26-24	195430052	串口屏连接线	Serial screen connection cable	1
26-25	195400105	PE 线	PE line	1
26-26	199300442	外接导线	External conductor	1
26-27	195430031	脚踏保护信号线(内接)	Foot protection signal wire (internal connection)	1
26-28	195430028	送扣信号线组件(内接)	Buckle signal wire assembly (internal connection)	1
26-29	195430040	压脚信号线(内接)	Presser foot signal line (internal connection)	1
26-30	195430033	剪线信号线(内接)	Cut signal wire (internal connection)	1
26-31	195430044	电源线	power cord	1