


# SW2001-20K Ultrasonic Generator

Frequency



19.82 KHz

Power

+

Turn

Test

-

0.0

+

Param

## Param setting

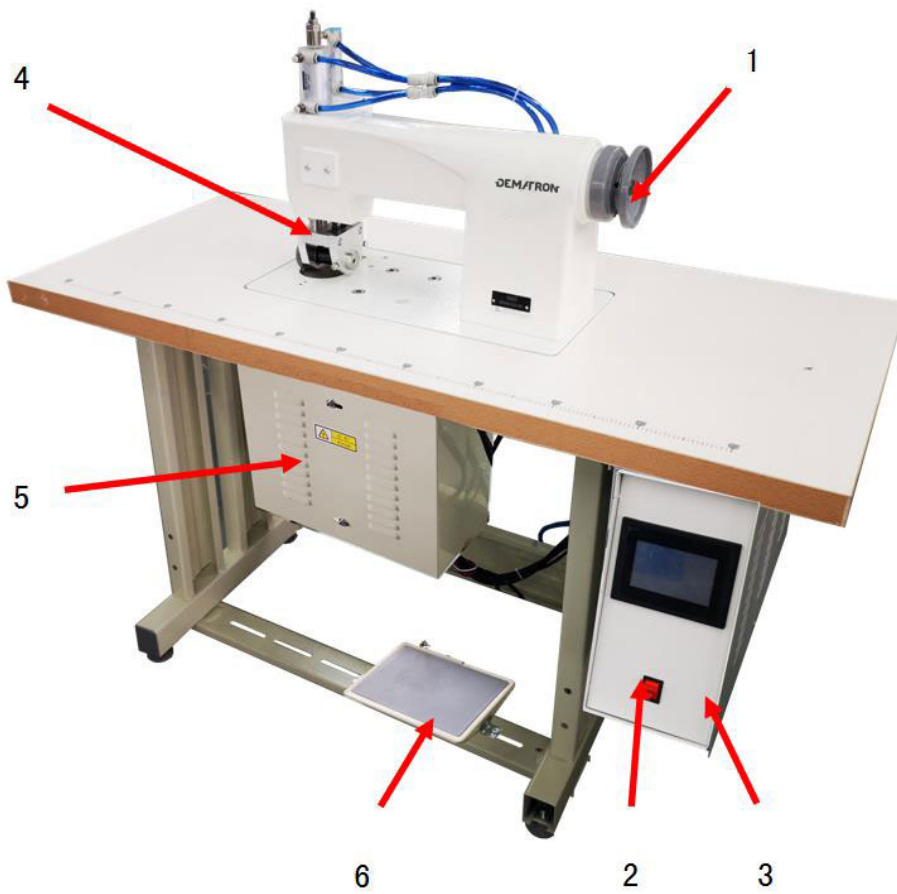


Work type	speed mode	1200	
<input type="checkbox"/> Single	<input checked="" type="checkbox"/> Double	<input type="checkbox"/> Constant	<input checked="" type="checkbox"/> Adjustable
Up moter	+	Down moter	+
	50		50
测试	-	测试	-

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## 1. Basic information of equipment



1: Machine head;

2: Power switch;

3 Control box;

4: Pattern wheel components;

5: Ultrasonic components;

6: Pedal;

## 2、 Technical parameters of the equipment

1	Machine head	Machine head
2	Voltage	0-2000V AC
3	Power	0-2000W (adjustable)
4	Frequency	20KHz
5	Power Supply	AC220V 50Hz
6	Pressure	0.3MPa
7	Frequency tracking	$\pm 0.5\text{Hz}$
8	Speed	0-16m/min
9	Temperature	+5°C~+50°C
10	Size	1200mmX500mmX1150mm
11	Weight	90KG

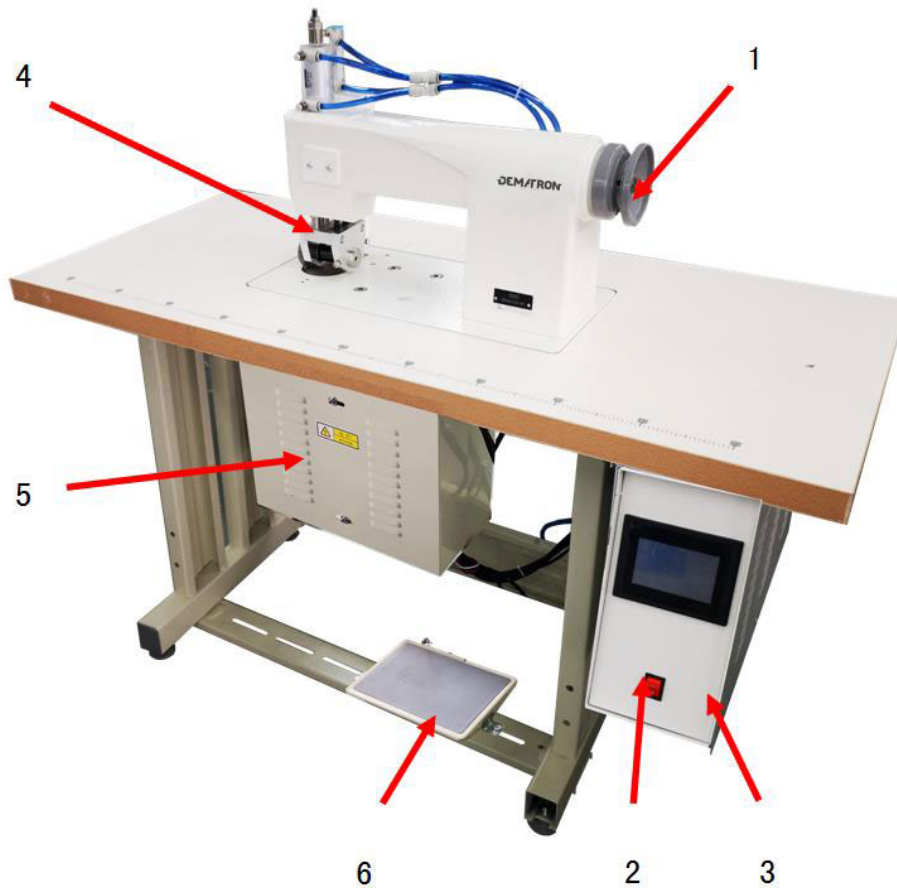
	<p>17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.</p>
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**\* important safety information:**

- ✓ improper operation of the machine may cause personal injury. Please read this instruction carefully and operate correctly before operation.
- ✓ Please ventilate the machine before it is officially powered on.
- ✓ do not turn on the internal parts of the electric cabinet or touch screen while the power is on.
- ✓ this machine should be used after receiving training or under special instruction to ensure the safety of the user.

## 4、 Key function description

### 4.1 .Function description of the button



(1) : Power switch: press the power switch to on, and the equipment is powered on and ventilated.

(2) : Pedal: the front foot pedal controls the sewing of the machine, and the rear foot pedal controls the lifting of the pressing wheel and the flower wheel.

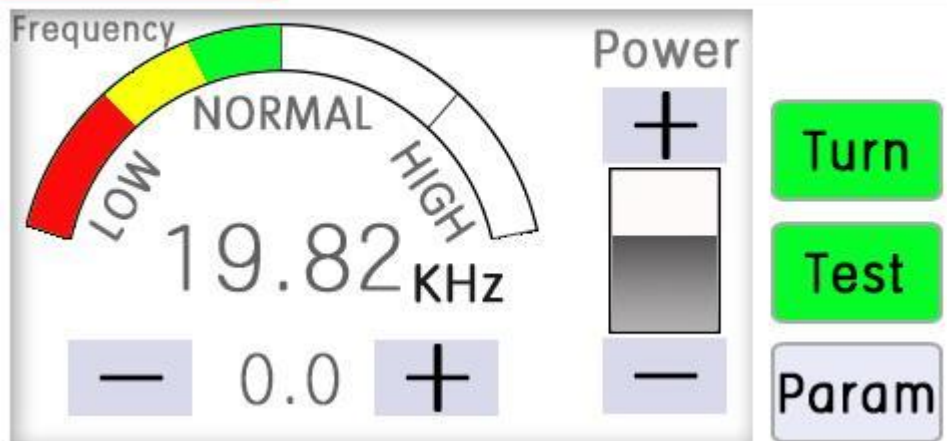
(3) : Touch screen

a. Power on interface:

b. Monitoring interface:

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## 5、 Operating instructions

### 5.1. Preparation before operation


- ✓ The machine head shall be in the stop state when the operator checks it
- ✓ Clean the sundries on the machine table to ensure that there are no sundries hindering the operation of the machine
- ✓ Check the pressure of the air pressure gauge to make it meet the use requirements of the machine

### 5.2. Operation process description

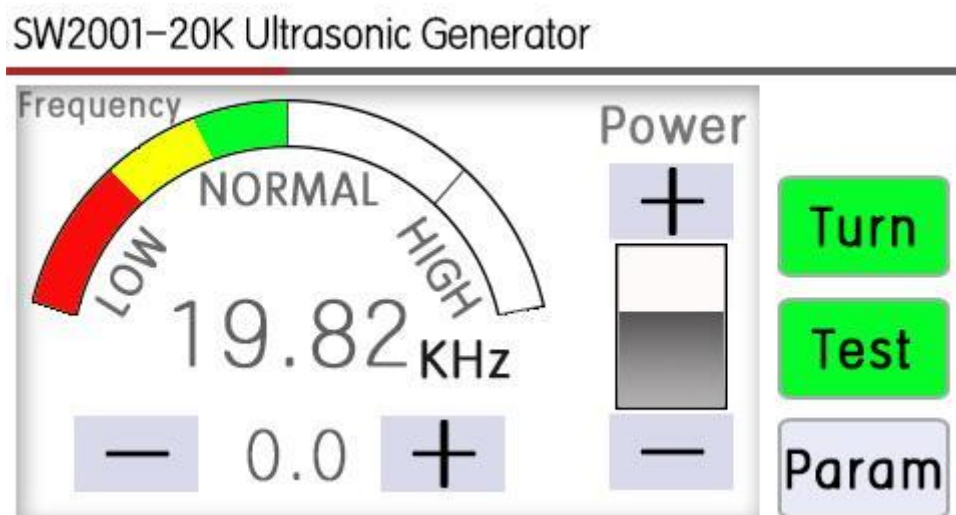
#### 5.2.1 Boot device


Press 4.1-(1) power switch to ON , Power on the device.

#### 5.2.2 Motor detection

Click  4.1 - (3) - B touch screen monitoring interface button, The upper and lower motors rotate at the same time, and the machine is normal.

#### 5.2.3 Ultrasonic testing



Click  4.1 - (3) - B touch screen monitoring interface, The frequency is within the normal range, the machine is normal,



### 5.2.4 Sewing

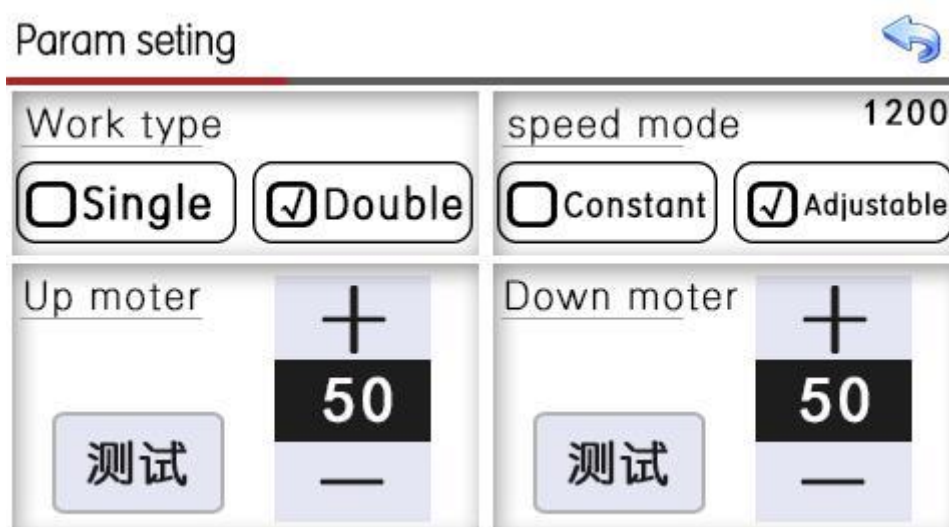
Place the cloth piece in the sewing area and press Four point one -(2) The right foot pedal in, the machine starts to sew, release the foot pedal and the machine stops.


### 5.2.5 Shutdown

After operation, press the power switch to the off position, and the equipment will be shut down.

## 6、 Debugging method

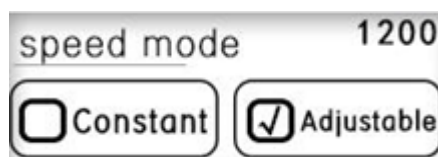
### 6.1. Model selection



Click  the button of 4.1 - (3) - B touch screen monitoring interface, Pop up the interface shown in the figure above, and select dual motor



### 6.2. Speed regulation mode



Select constant speed sewing or adjustable speed sewing in parameter setting interface

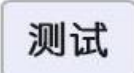
Constant: Front pedal motor rotates at a fixed speed;

Adjustable: The rotation speed of motor increases with the increase of pedal force.

### 6.3. Wheel speed adjustment



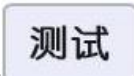
Click on the parameter setting interface, Push button

to adjust the speed of upper motor, Speed range 10% - 100%, Click  Button speed measurement.

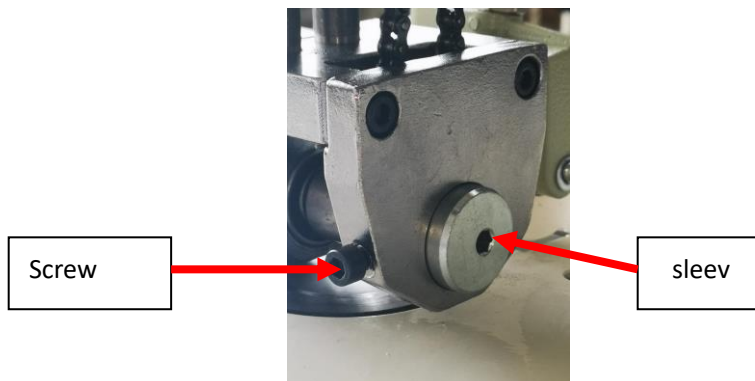
### 6.4. Speed adjustment of welding head



Click on the parameter setting interface, Motor speed

under button adjustment, speed range 10% - 100%, Click  Button speed measurement.

### 6.5. Wheel angle adjustment



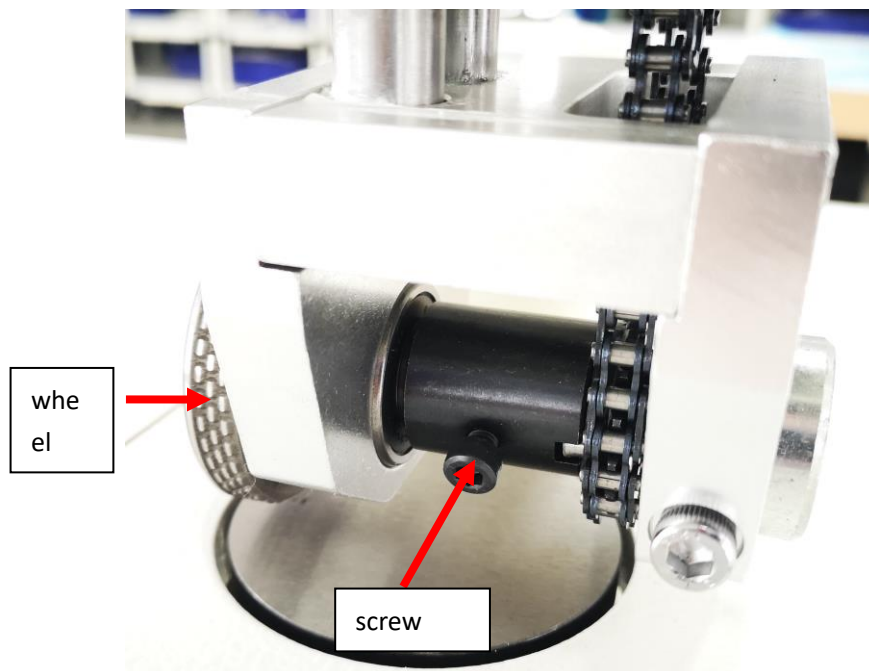
Loosen the fixing screw and rotate the eccentric sleeve to adjust the angle between the flower wheel and the welding head, so as to ensure that the thickness of each pressing edge of the flower wheel is equal.

## 6.6. Adjustment of depth of wheel



Loosen the fixing nut, rotate the limit sleeve, adjust the stroke of the cylinder, and change the indentation depth of the flower wheel.

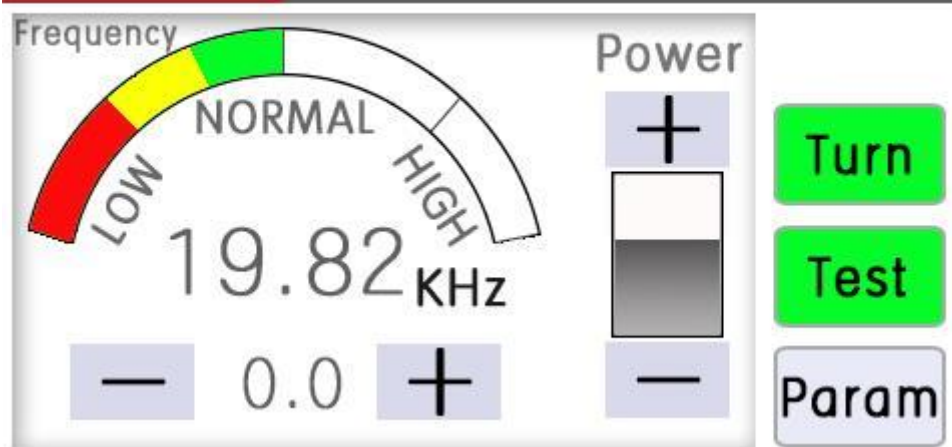
## 6.7. Wheel replacement



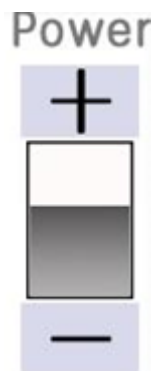
- 4) Remove the fixing screw and take out the wheel;
- 5) Insert the new wheel to be replaced into the bearing and tighten the fixing screw;
- 6) Adjust the angle of the wheel according to step 6.5, and the mold replacement is completed.

## 6.8. Ultrasonic adjustment

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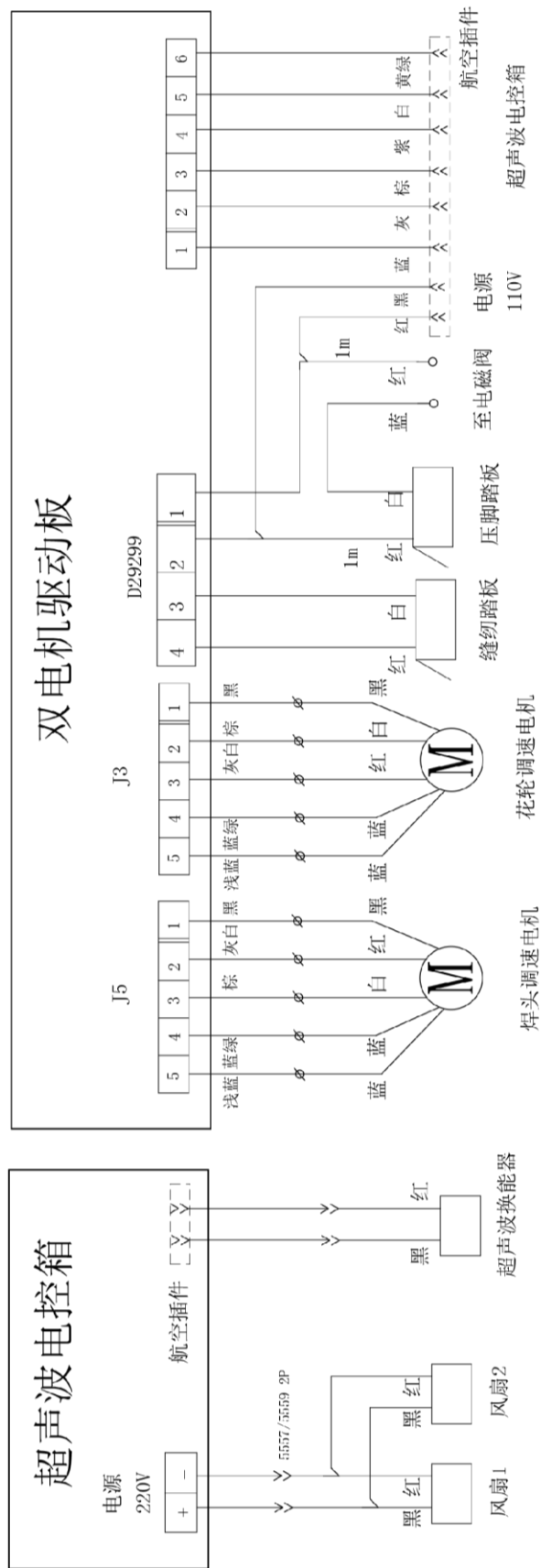


High or low frequency, Click  0.0 , Adjust frequency,



High or low power, Click , Regulated power.

## 7、Electrical wiring





## 8、 Optional device

Support customization of wheel and pattern

## 9、 Common problems and Solutions

9.1. See the table below for common problems and Solutions

Phenomenon		Cause analysis	Solutions
Uneven left and right edge pressing of wheel		The wheel is not vertical to the welding head	according to 6.5 Step to adjust the flower wheel angle
Shallow or deep impression of wheel		mall or large cylinder stroke	according to 6.6 Step adjust cylinder stroke

## 10、 Daily maintenance requirements

10.1. See the following table for the list and requirements of equipment maintenance

NO	Project	Frequency				Requirement
		Daily	Weekly	Monthly	Half year	
1	Dust removal	√				Remove dust from equipment surface and parts
2	Clean up oil		√			Clean the oil stain on the platform
8	Air pipe interface			√		The air pipe interface is tight without air leakage
13	Slide				√	Check the lubrication of sliding parts and add lubricant if necessary
14	Electric control box				√	Cooling fan operates normally, clean dust in time