

QMAXTM

Automatic Snap Fastening Machine

Operating Manual



Model: FT-300

Version 1.0

May 2011

AUTOMATIC SNAP BUTTON FASTENING MACHINE

OPERATING MANUAL

VERSION 1.0

MAY 2011

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ATTENTION:

Read carefully the user manual before use

ELECTRIC SAFETY NOTICE

To prevent fire or shock hazard, do not expose the unit to rain or moisture. To avoid electrical shock, do not open the control box or front panel. Refer servicing to qualified personnel only.

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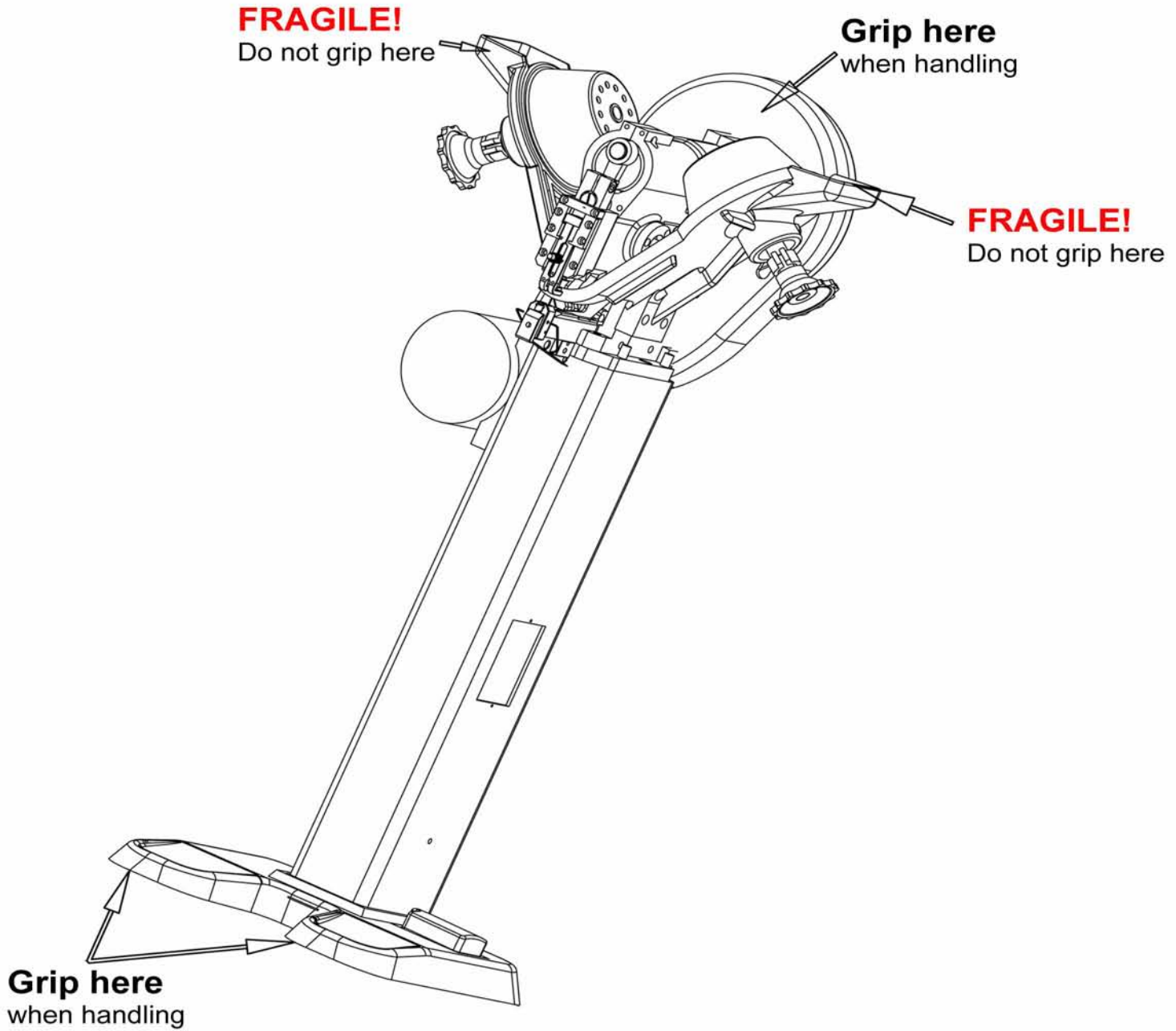
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Caution For Handling

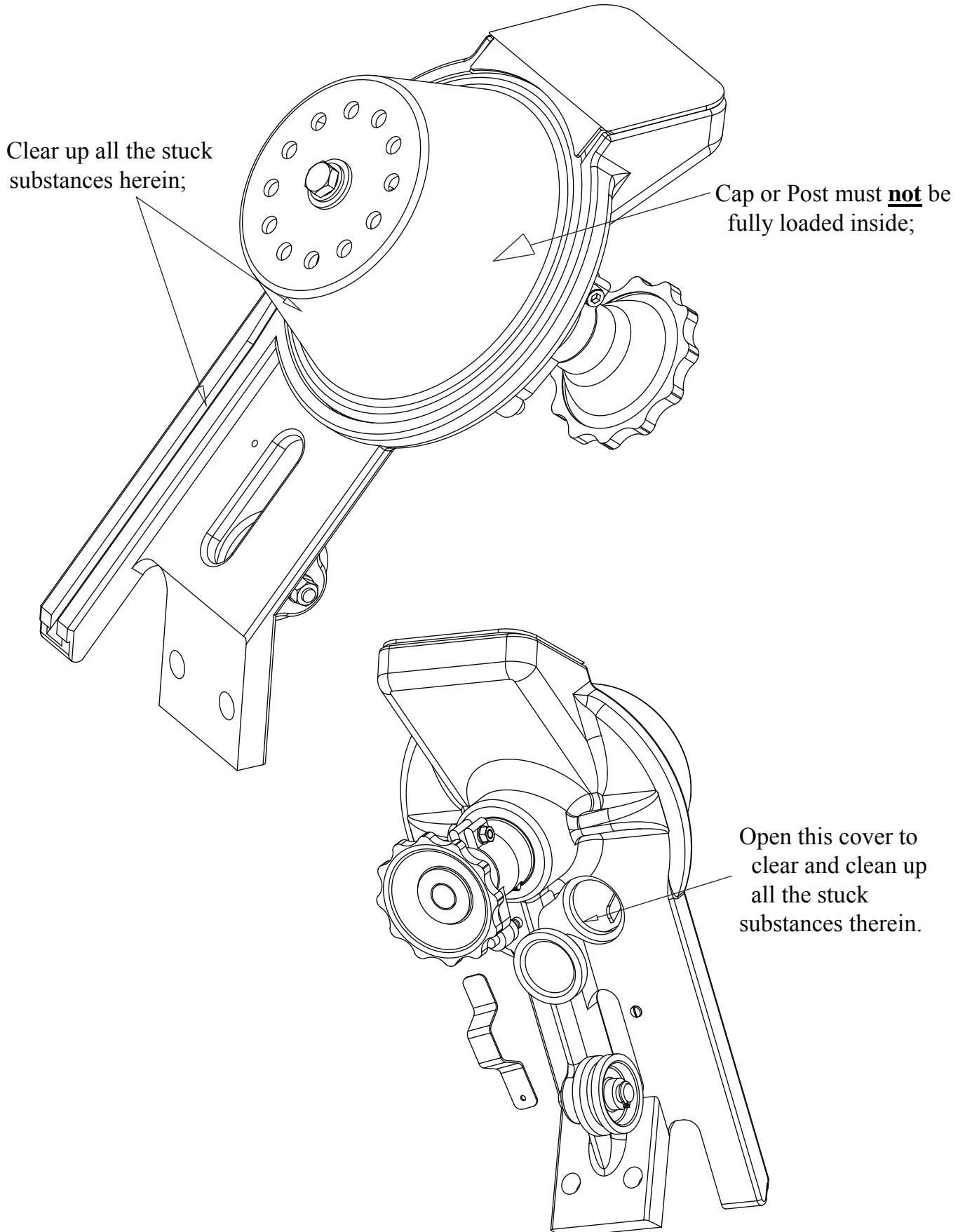


FT-300 Automatic Snap Button Fastening Machine

(Operating Hints Outline)

1). Clearing of Channel Parts

- to be clear and clean up daily as per below diagram for any possible trash or stuck substances inside the Channel in order to ensure the smooth operating process.

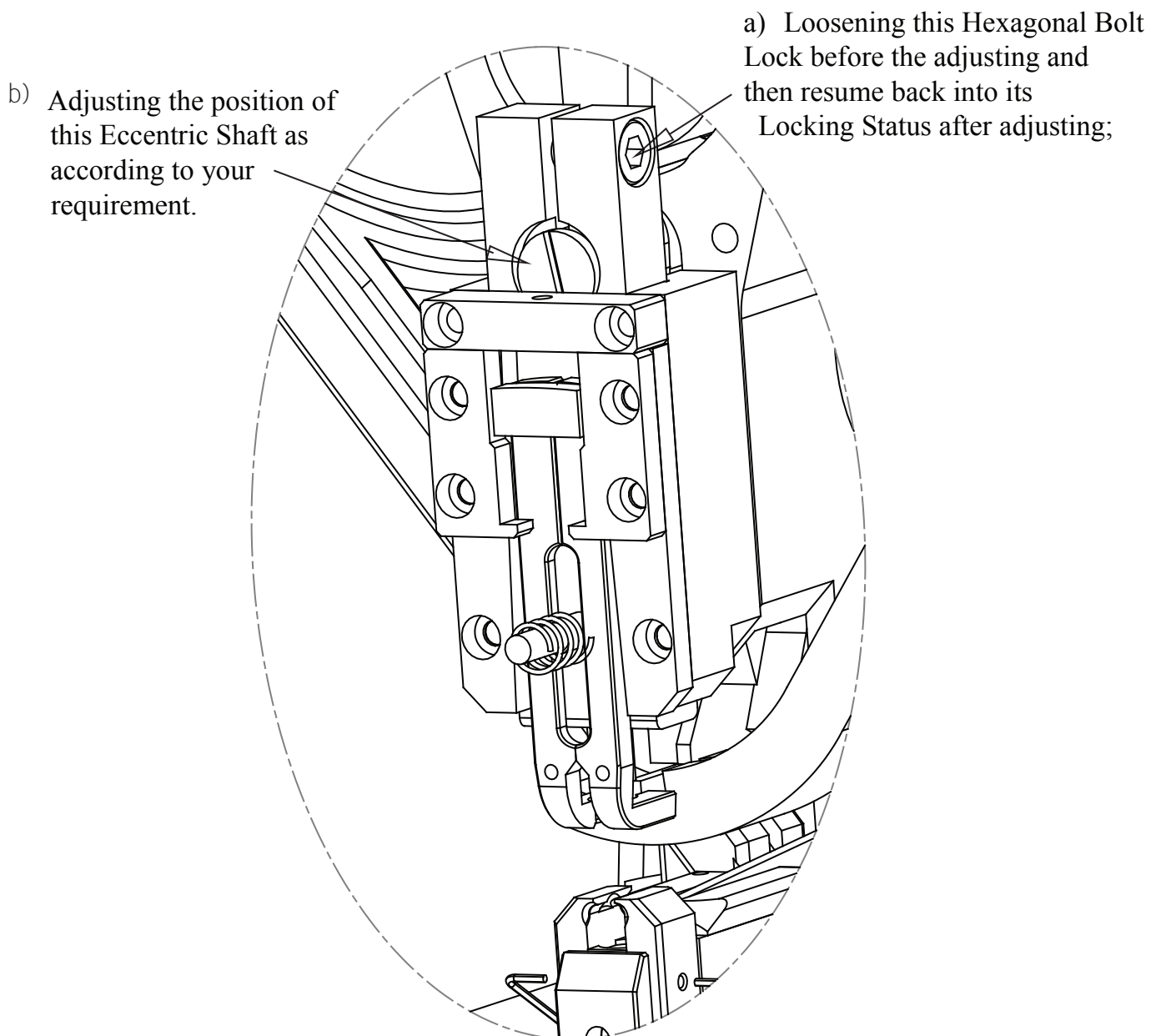


2). Adjusting and Testing of Snapping Tightness

adjusting as per below diagram, the coefficients of tightness can be easily adjusted according to different thickness of materials used as well as your required tightening performance;

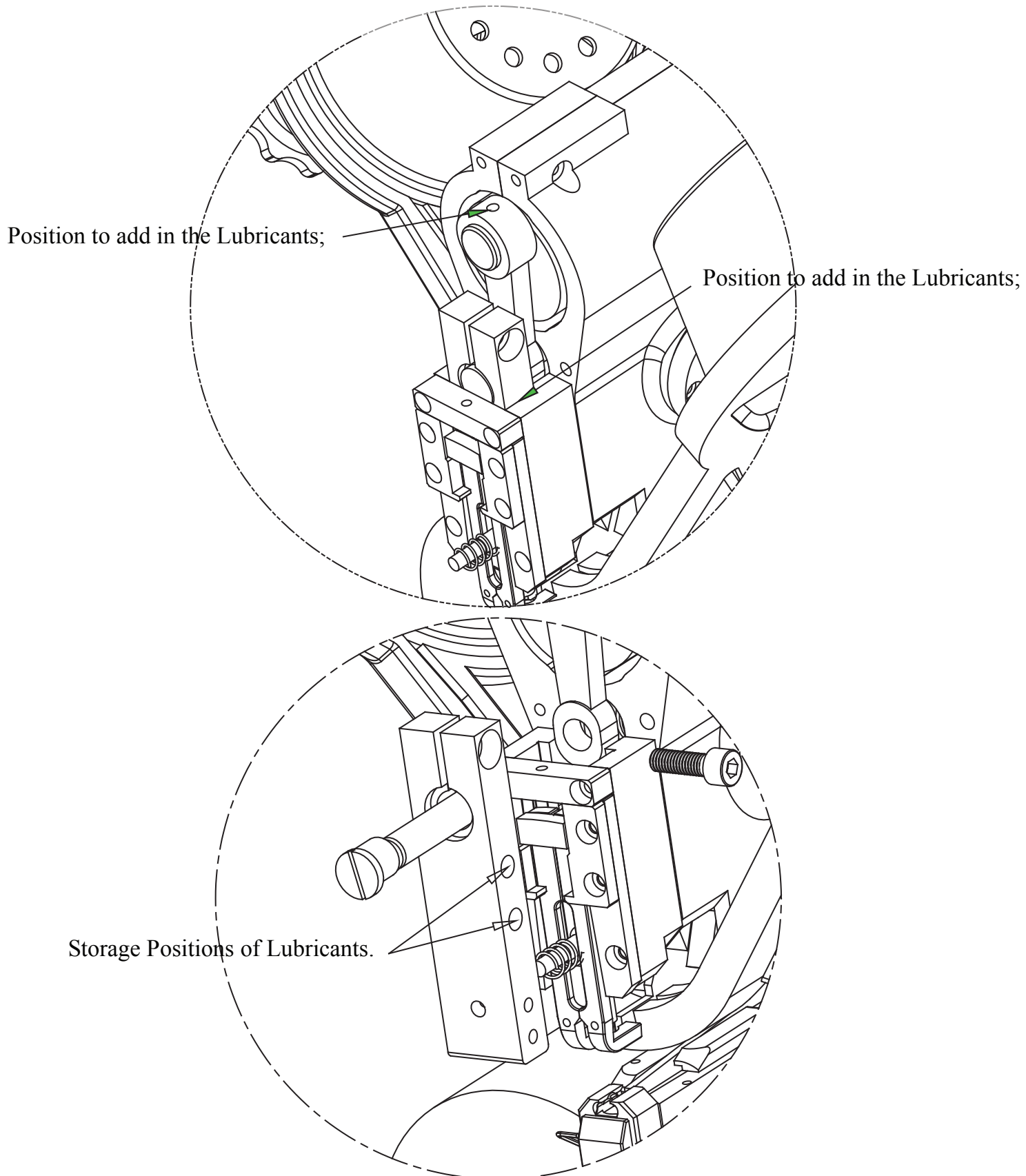
- it is suggested to adjust slowly by minimal just in order to avoid any unnecessary destruction towards the machinery itself;
- after the said tightness adjusting, pulling the revolving belt manually and slowly to stamp on and fasten the Snap Button for recognising trial in order to assure the prompt accuracy therein;
- resume into automatic status after accuracy assurance during the recognising trial.

(Precaution: Switch **Off** the Electricity Power before manual adjusting and recognising trial)



3). Nourishing of Lubricants

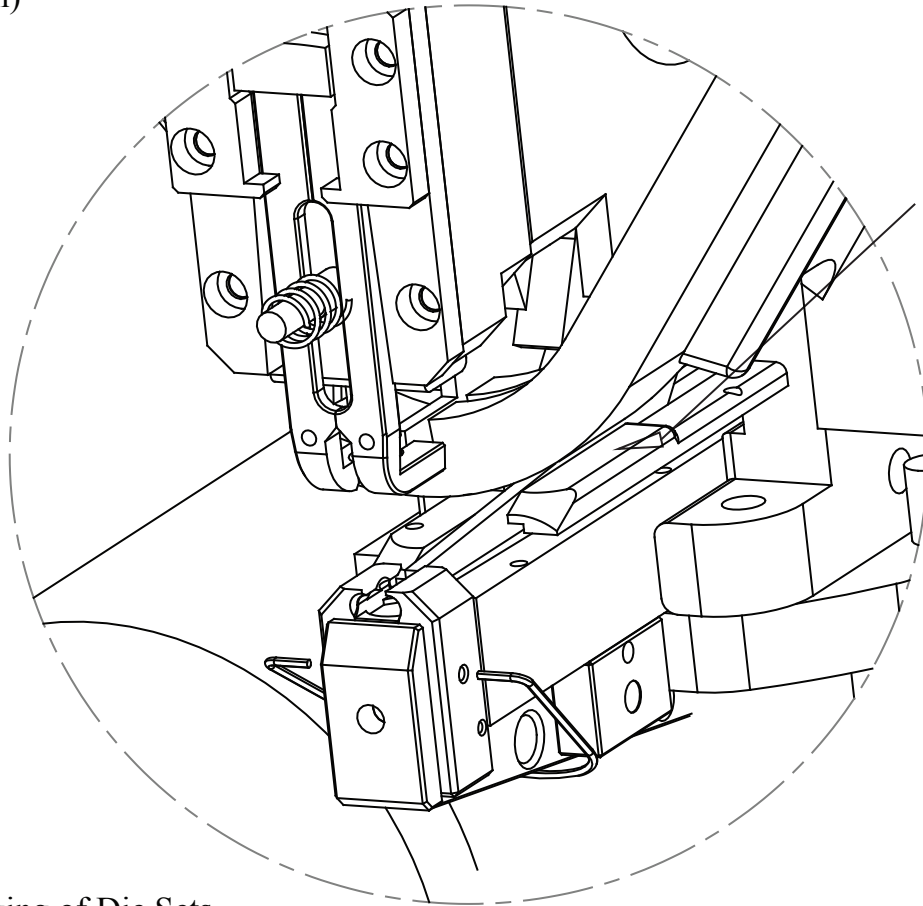
lubricating as per below diagram, it is advised to conduct Nourishing and Lubricating weekly in order to ensure the proper lifespan of machinery, the nominated Lubricants should be lasting for High Temperature Tolerating and Grinding Tolerating Grade.



4). Handling of Button Jamming

resolving the stuck Snap Button /s as per below diagram once if the said jamming thus occurred; Loosening the Pressing Plate firstly and then pulling the Revolving Belt Wheel slowly by manual in order to get out of the stuck Snap Button/s.

(Precaution: Switch **Off** the Electricity Power before manual resolving of any stuck Snap Button)

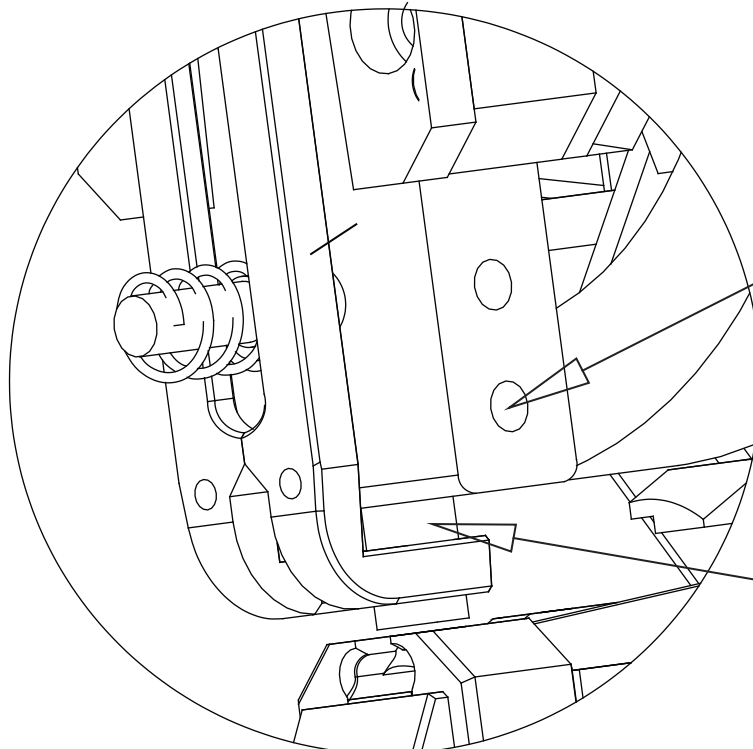


Pulling up this Pressing Plate and clear up the stuck Snap Button/s therein.

5). Changing of Die Sets

changing the Die Sets as per below diagram once if the said Die Sets had been damaged or worn out after being used for a long period.

(Precaution: Switch **Off** the Electricity Power before changing of Die Sets)



Loosening this Bolt Lock to proceed the changing of Die Sets;

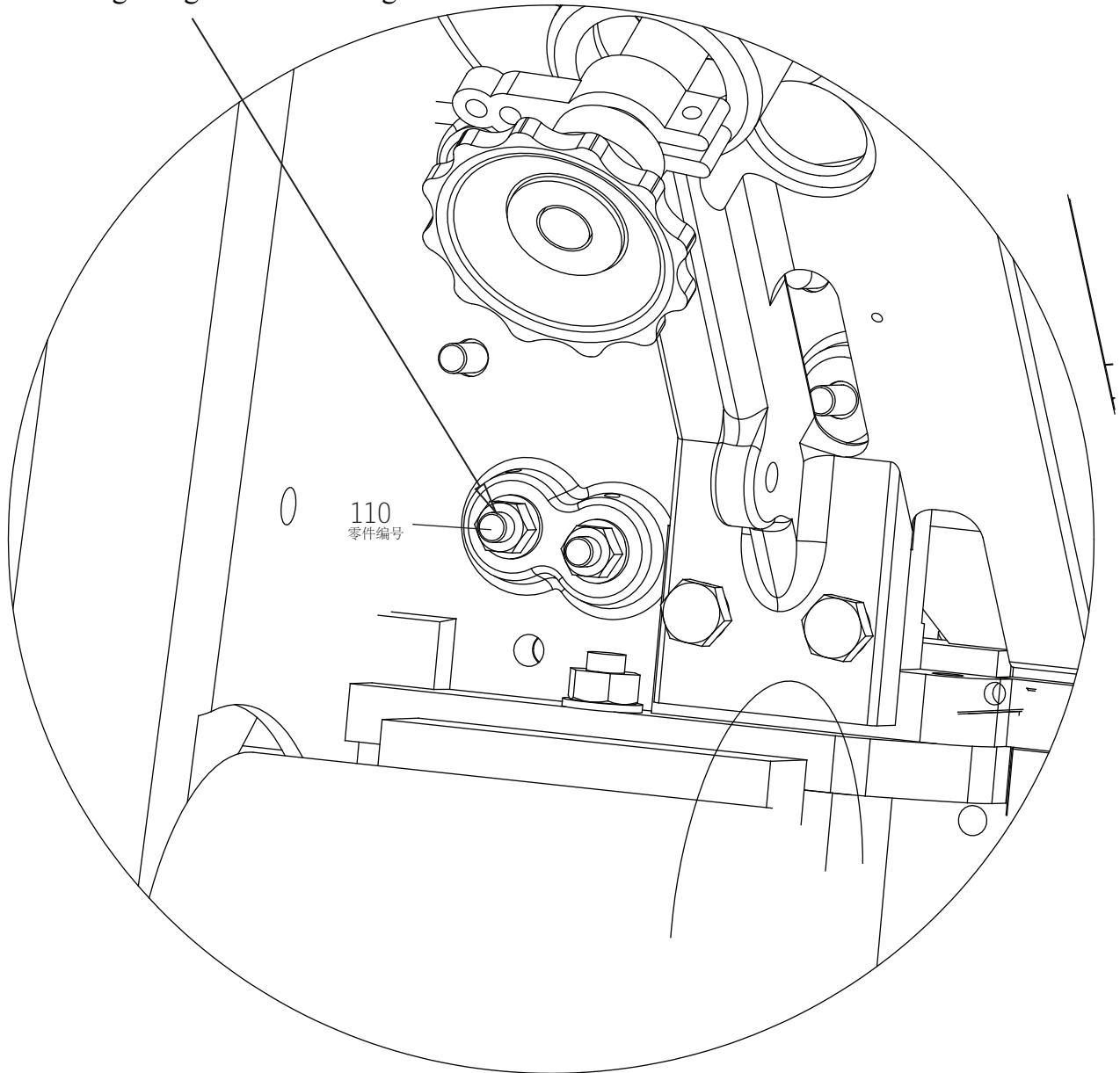
Position of Die Sets

6). Adjusting the Stroking Range of Pushing Handle

adjusting the instant accuracy of precised stacking position for Stud and Socket as below diagram once if they are not stacking correctly at the desired and accurate position.

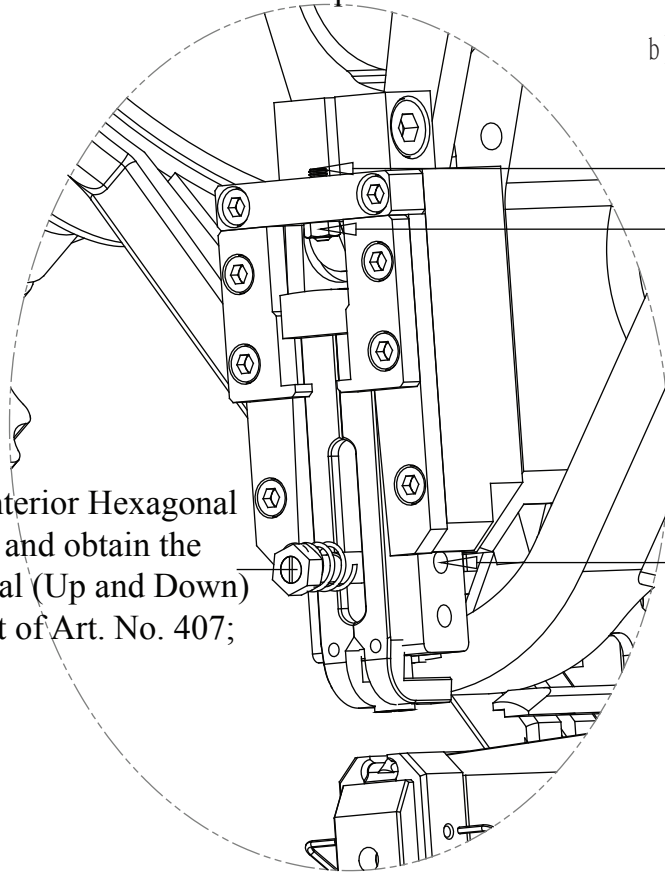
(Precaution: Switch **Off** the Electricity Power before manual adjusting the Stroking Range of Pushing Handle)

- a) Loosening this Hexagonal Nut firstly, and rotating the Eccentric Shaft slightly to adjust the Stroking Range of the Pushing Handle.



7). Adjusting of Upper Clipping Stabilizer (Art. No. 407)

adjusting the instant accuracy of precised stacking position and tightness as below diagram once if the Stud and Socket are found of **not** stacking tightly or being stacked at their centralized and accurate position.



b) Rotating this Interior Hexagonal Bolt to attempt and obtain the Minimal Vertical (Up and Down) Adjusted Effect of Art. No. 407;

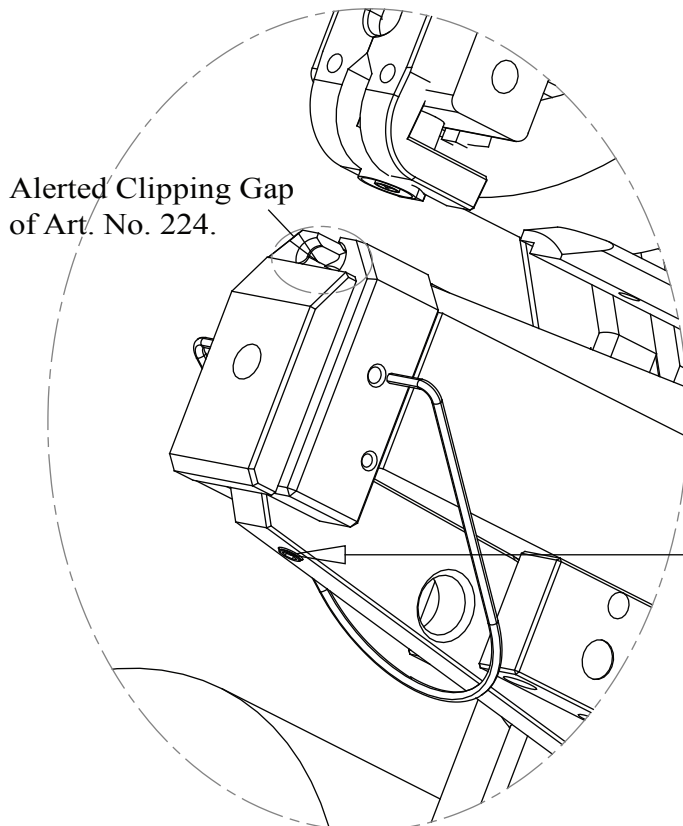
a) Loosening this Bolt before the Adjusting and resume back into Locking Status after the said Adjustment;

d) Rotating this Interior Hexagonal Bolt to attempt and obtain the Minimal Vertical (Up and Down) Adjusted Effect of Art. No. 407;

c) Loosening this Bolt before the Adjusting and resume back into Locking Status after the said Adjustment;

8). Adjusting of Lower Clipping Stabilizer (Art. No. 224)

adjusting the instant accuracy of precised stacking position and tightness as below diagram once if the Cap and Post are found of **not** stacking tightly or being stacked at their centralized and accurate position.

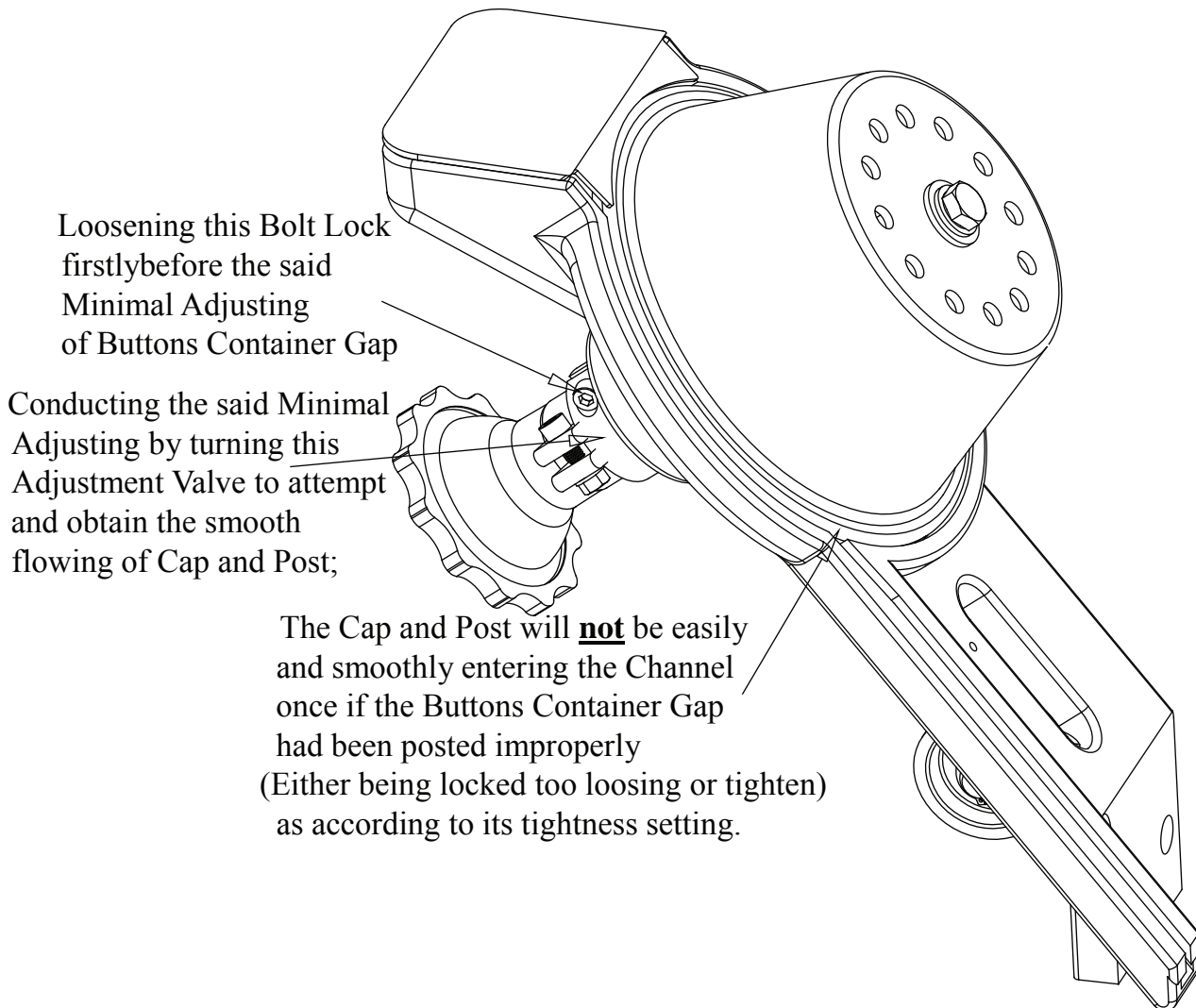


Alerted Clipping Gap of Art. No. 224.

Rotating this Bolt to obtain the Adjusted Clipping Gap Distance of Art. No. 224;

9). Adjusting of Buttons Container Gap

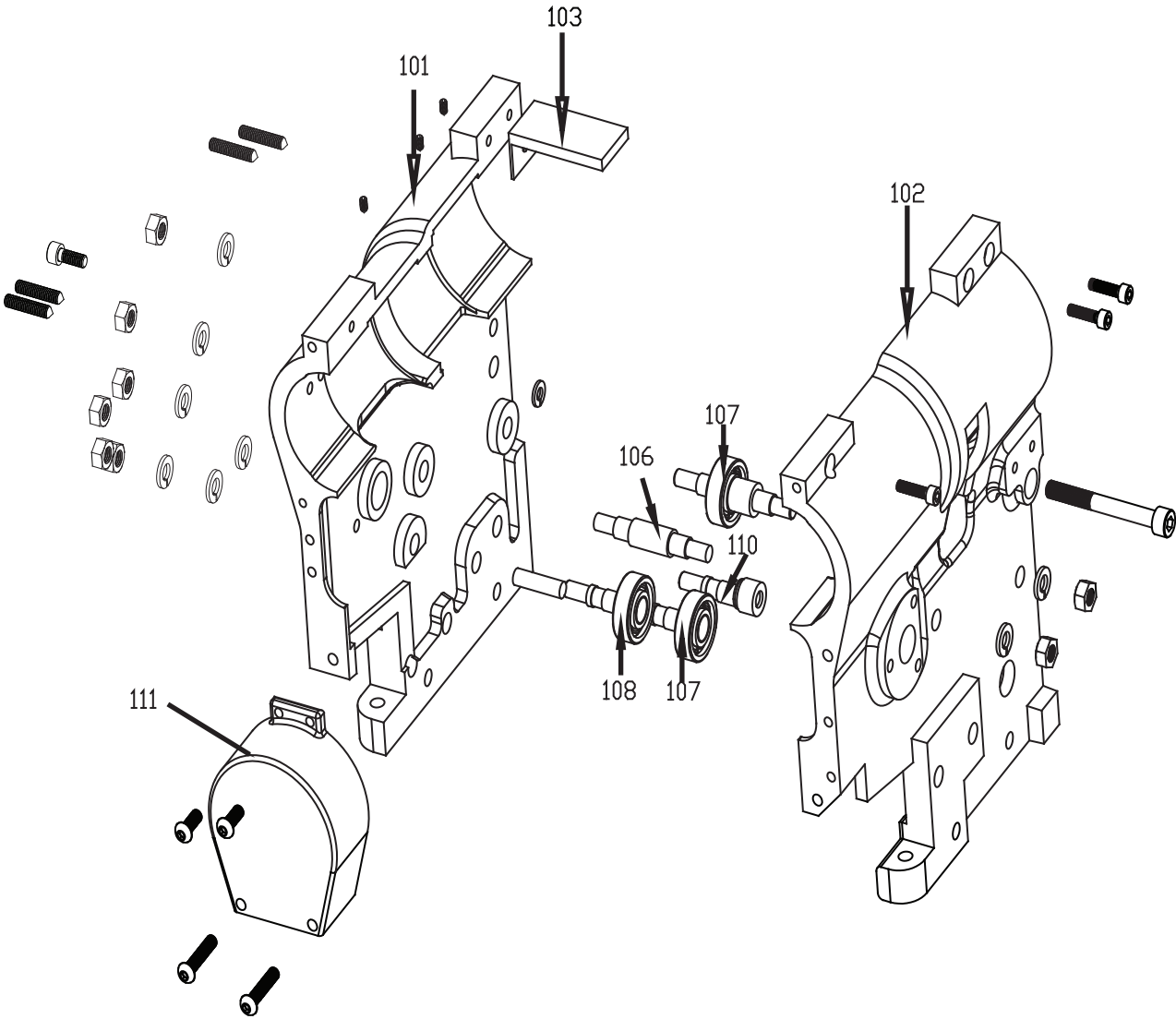
adjusting the Buttons Container Gap setting once if the Cap or Post are found of **not** entering into the Channel easily and smoothly; Loosening the Bolt Lock firstly and then turning the Minimal Adjusting Valve to attempt and obtain the smooth flowing of Cap and Post into the Channel.



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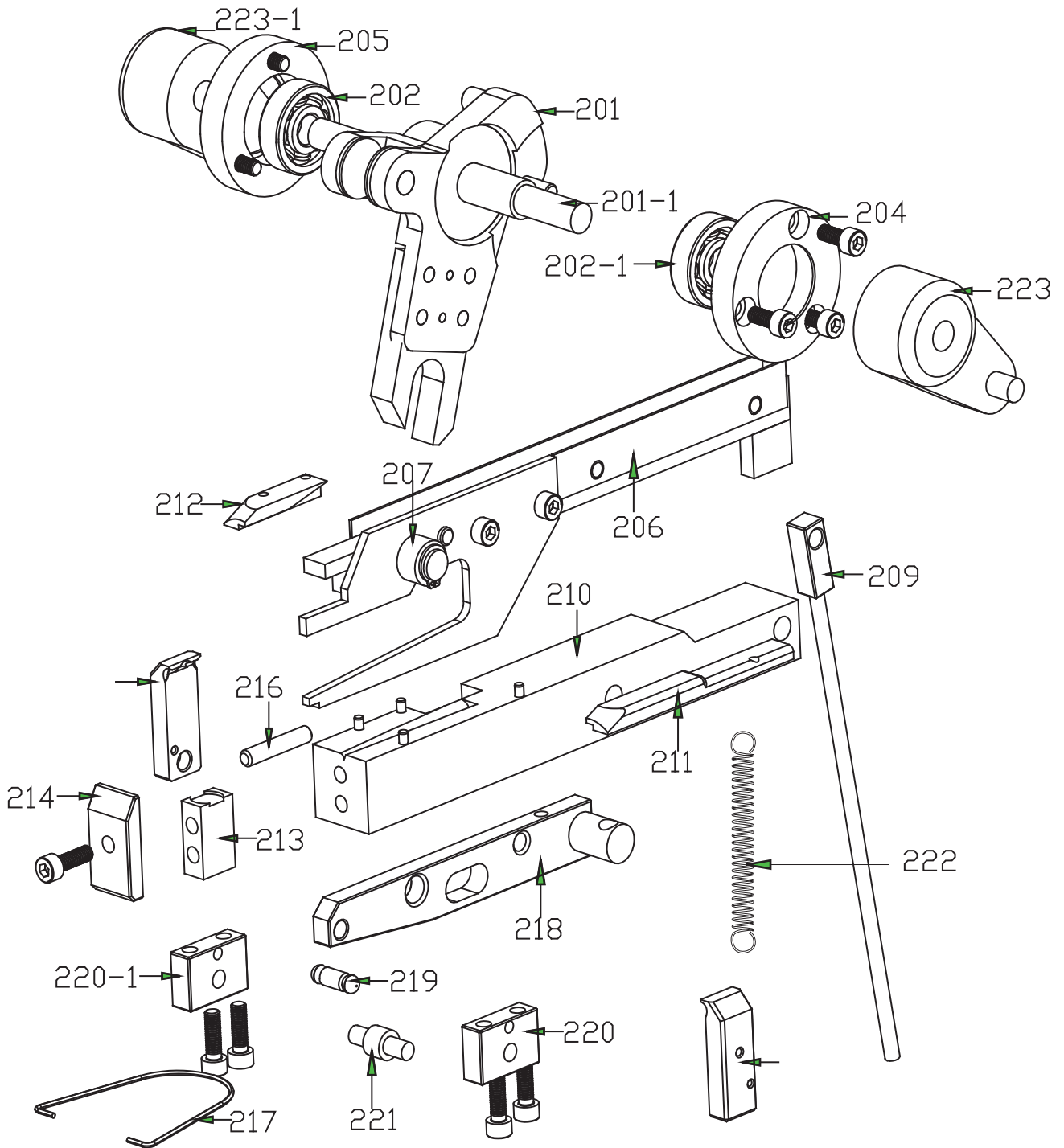
(Articles and Parts Serials)

1). External Casings

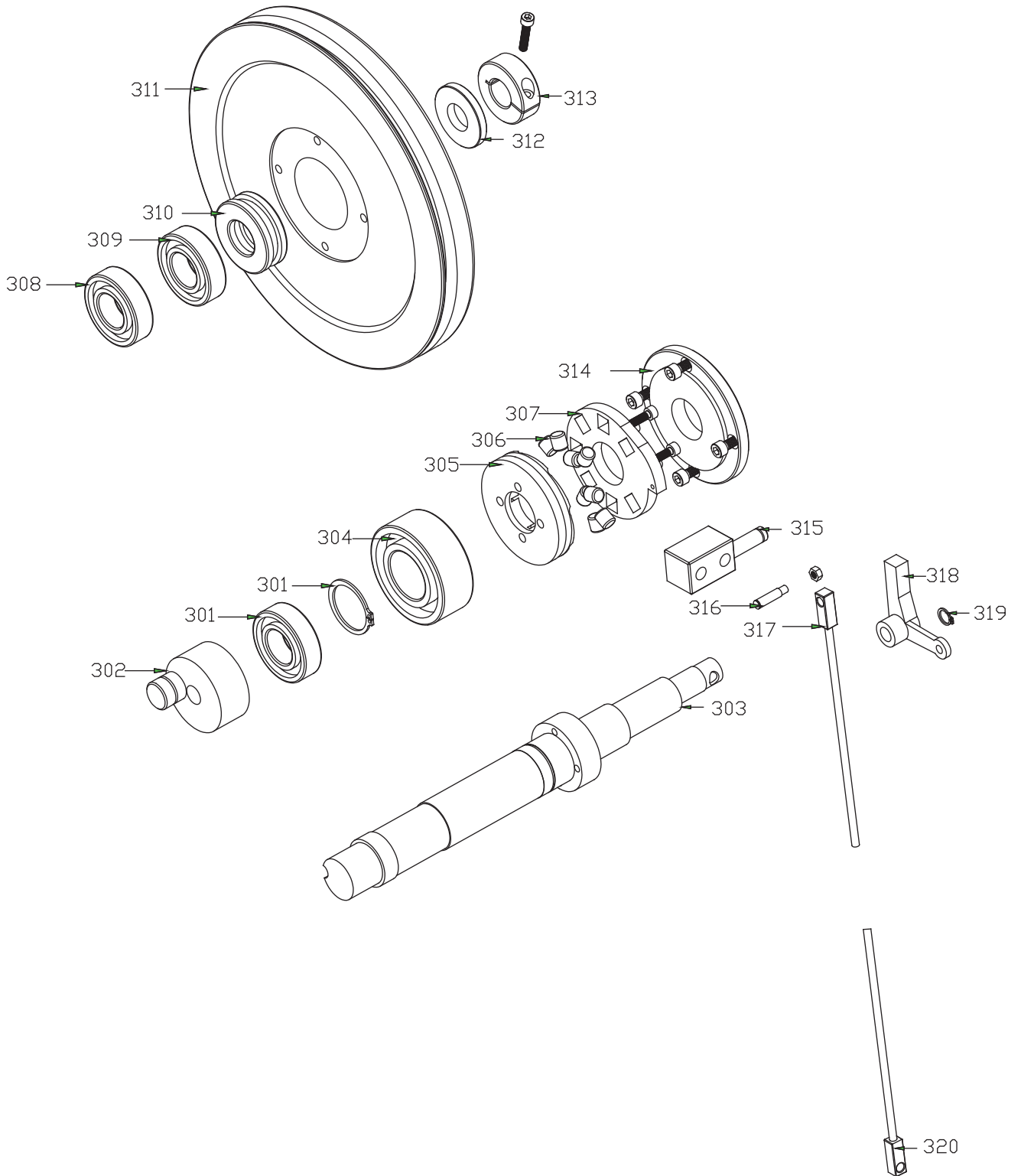


2). Dynamic Power Transforming Shafts and Partitions

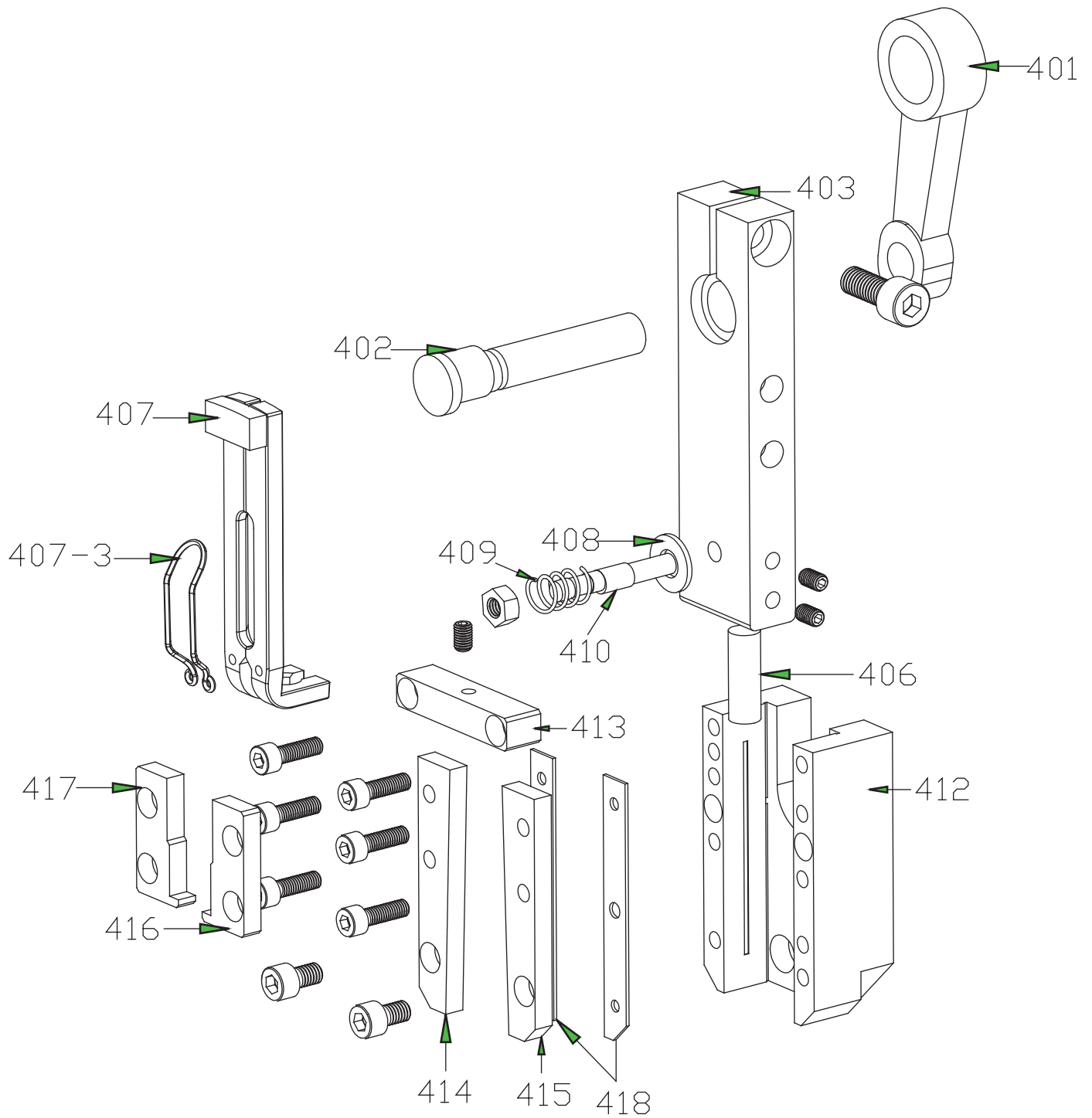
- this partition had been accountable for the Transforming of Dynamic Power.



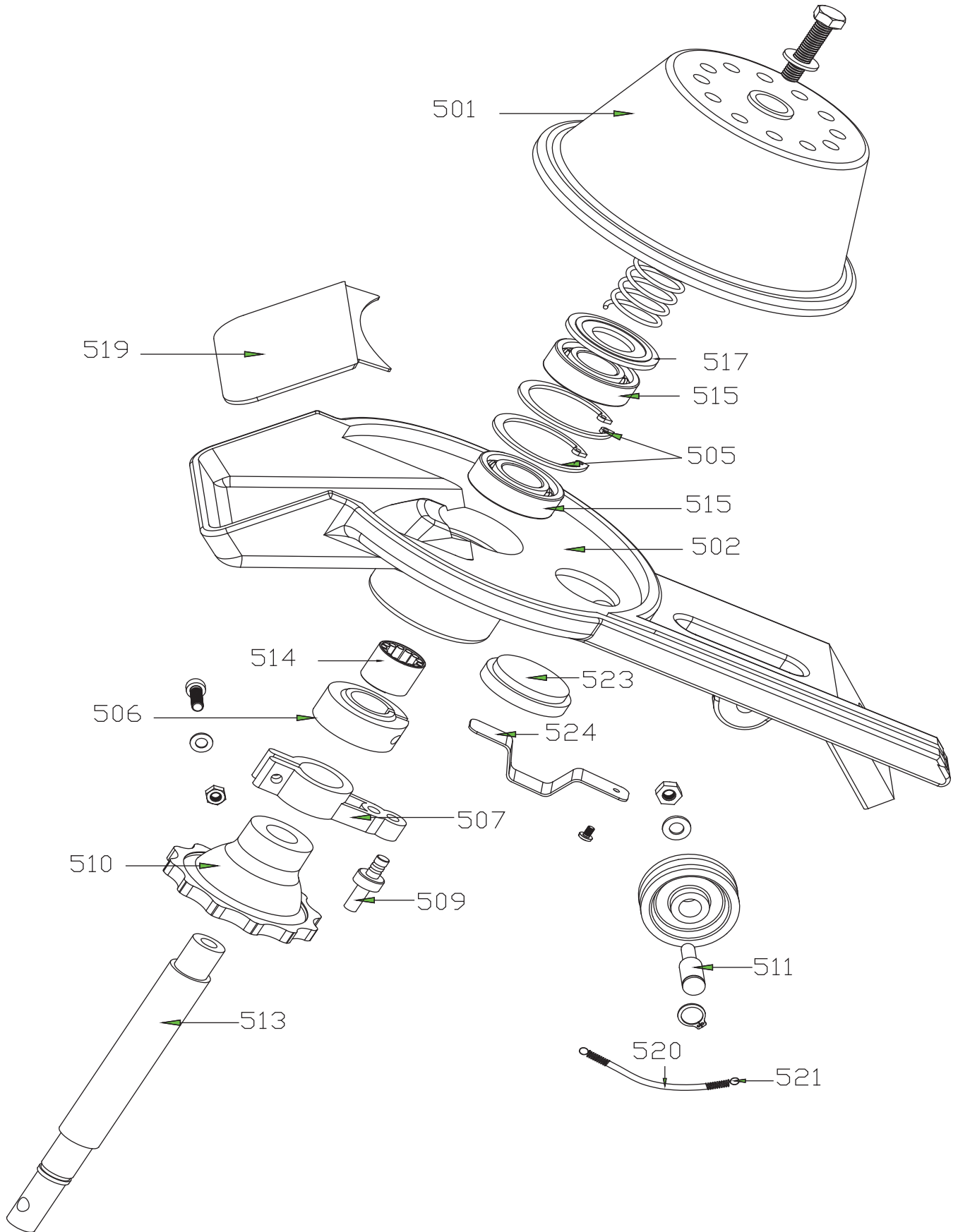
3). Main Shaft and its Partitions



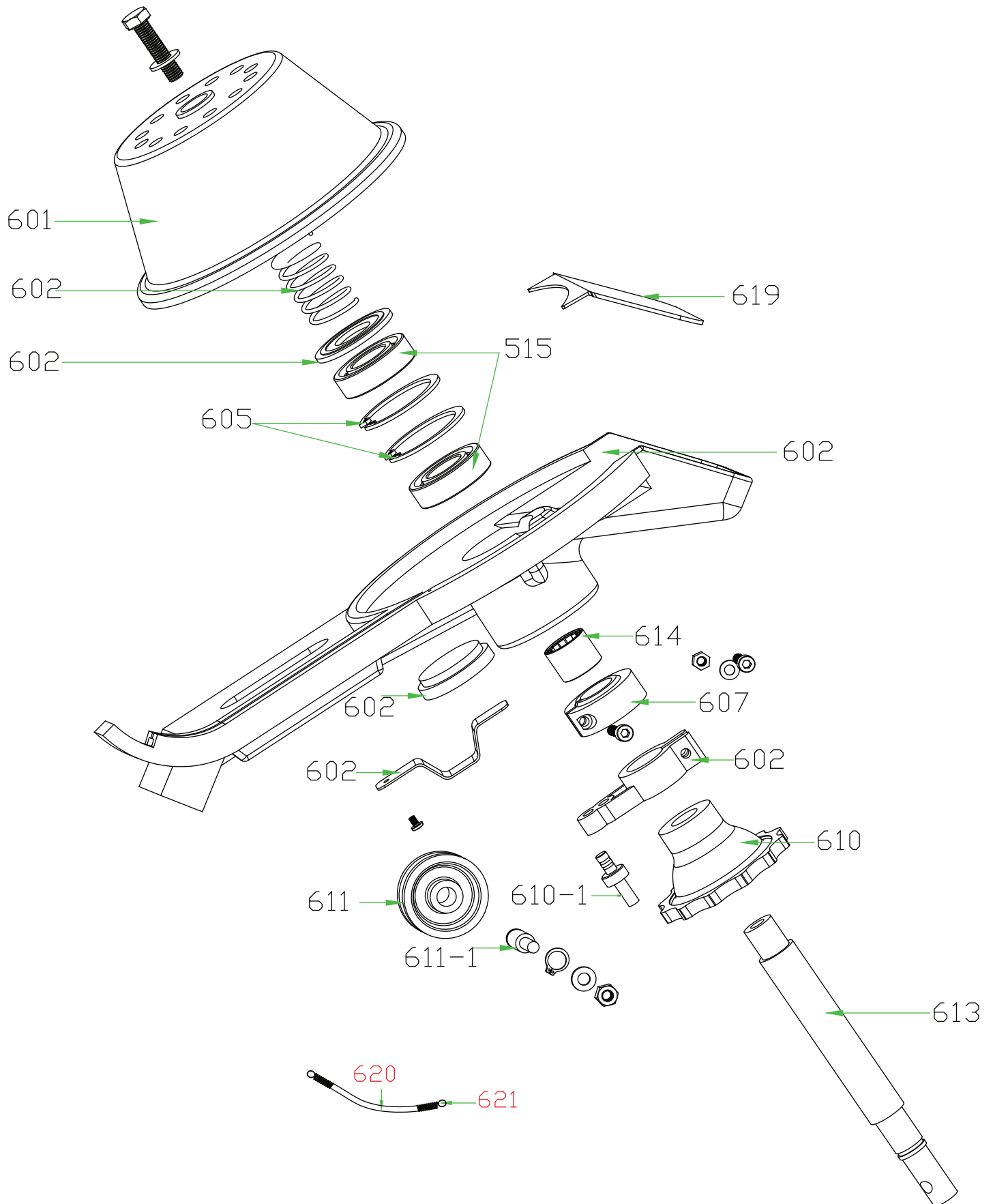
4). Die Sets and Hammer



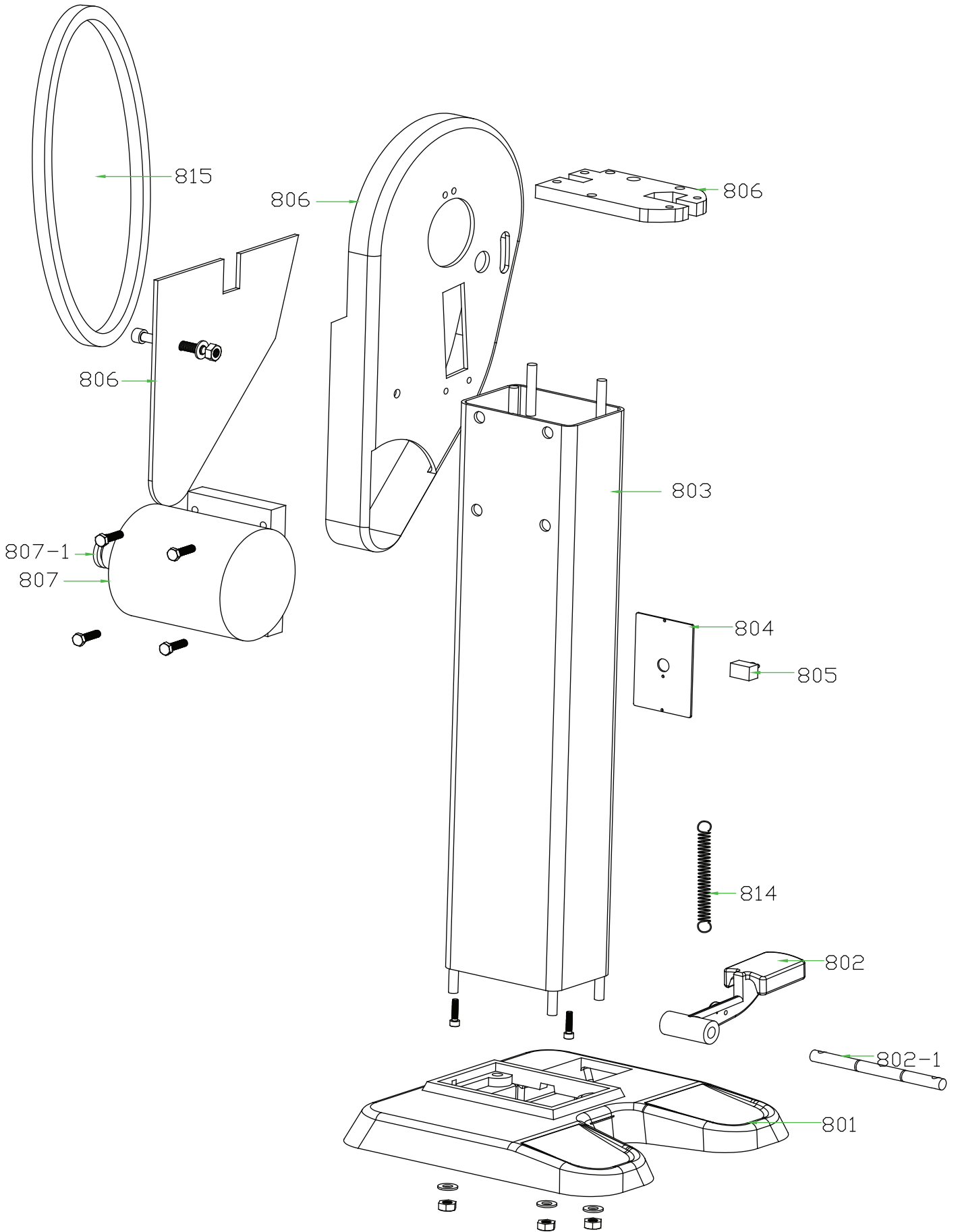
5). Cap and Post Channel



6). Stud and Socket Channel



7). Stand and Base Fixtures



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(Annex One - Articles and Parts Serials Conversion Tables)

1). External Casings

<u>Art. Serial</u>	<u>Parts Descriptions</u>
101	External Casing A
102	External Casing B
103	Decelerator
104	Dusting Insulator
106	External Casings Fixture
107	Pushing Handle Fixing and Rotating Shaft A
108	Pushing Handle Fixing and Rotating Shaft B
109	Pushing Handle Fixing and Rotating Shaft C
110/110-1	Pushing Handle Front and Rear Fixing Shaft / Uni-Plastic Plate
111	Die Sets Cover

2). Dynamic Power Transforming Shafts and Partitions

<u>Art. Serial</u>	<u>Parts Descriptions</u>
201	Dynamic Power Transforming System Main Body Dynamic Power Transforming Shaft Dynamic Power Transforming Shaft Rolling Gear Dynamic Power Transforming Shaft Pulling Stick A Dynamic Power Transforming Shaft Pulling Stick B Dynamic Power Transforming Device
201-1	Dynamic Power Backward Spring
202	Dynamic Power Rolling Shaft
203	Dynamic Power Resetting Spring
204	Dynamic Power Shaft Fixing Ring A
205	Dynamic Power Shaft Fixing Ring B
206-1	Pushing Handle Main Body
206-2	Pushing Handle Fixing Plate A
206-3	Pushing Handle Fixing Plate B
206-4	Pushing Handle Grasping Stick
207	Grasping Stick Outer Ring
208	Pushing Handle Fixture Ring
209	Cap Backward Pulling Stick
210	Pushing Handle Base
211	Pushing Handle Pressing Plate A
211-1	
212	Pushing Handle Pressing Plate B
212-1	
213	Die Sets Base

214	Die Sets Base Insulating Plate
215	Die Sets Base Fixture Plate
216	Die Sets Base Stick
217	Die Sets Base V-Shape Spring
218	Die Sets Base Backward Setting Main Body
219	Die Sets Base Backward Setting Stick
220	Die Sets Base Backward Setting Fixture Piece
221	Die Sets Base Backward Setting Fixture Rod
222	Die Sets Base Backward Setting Spring
223	Die Sets Base Pulling Device
223-1	Die Sets Base Pulling Device

3). Main Shaft and its Partitions

<u>Art. Serial</u>	<u>Parts Descriptions</u>
301	Main Shaft cover
302	Main Shaft Body A
303	Main Shaft
304	Main Shaft Body B
305	Clutching Plate
306	Clutching Bead
307	Clutching Fixture Plate
308	Main Shaft Body C
309	Main Shaft Body D
310	Main Shaft Body E
311	Rolling Belt Driving Wheel
312	Rolling Belt Driving Wheel Insulating Plate
313	Main Shaft Adjusting Valve
314	Clutch Pressing Board
315	Clutch Structural Framing Rod
316	Clutch Structural Framing Bar
317	Clutch Upper Pulling Wire
318	Clutch Body
319	Clutch Spring
320	Clutch Lower Pulling Wire

4). Stamping Mold and Hammer

<u>Art. Serial</u>	<u>Parts Descriptions</u>
401	Power Transforming Joint Rod
402	Power Transforming Eccentric Shaft
403	Sliding Plate
403-1	Sliding Plate Fixture Stick
406	Die Sets
407	Stud and Socket Fixture A
407-1	Stud and Socket Fixture B

407-2	Stud and Socket Fixture C
407-3	Stud and Socket Fixtures Linking Spring
408	Stud and Socket Fixtures Insulating Plate
409	Stud and Socket Fixtures Spring
410	Stud and Socket Eccentric Shaft
412	Sliding Track
413	Sliding Plate Fixture A
414	Sliding Plate Fixture B
415	Sliding Plate Fixture C
416	Sliding Plate Fixture D
417	Sliding Plate Fixture E
418	Sliding Plate Insulating Binder

5). Top and Bottom Button/s Tracking System

<u>Art. Serial</u>	<u>Parts Descriptions</u>
501	Cap and Post Flowing Bowl
502	Cap and Post Flowing Track
505	Channel Clipping Spring
506	Channel Adjusting Valve
507	Channel Directional Shafting Body
508	Channel Directional Shaft
509	Channel Pulling Stick
510	Channel Handle
511	Channel Rolling Wheel Stick
512	Channel Rolling Wheel
513	Channel Shaft
514/515	Channel Shaft Body
516	Channel Spring
517	Channel Spring Insulating Plate
518	Channel Spring Jacket
519	Channel Cover
520	Channel Pulling Wire
521	Channel Pulling Wire Spring
522	Channel Transforming Pulling Device
522-1	Channel Transforming Pulling Stick
523	Channel Main Body Stopper
524	Channel Main Body Stopper Insulating Plate

6). Stud and Socket Channel

<u>Art. Serial</u>	<u>Parts Descriptions</u>
601	Stud and Socket Flowing Bowl
602	Stud and Socket Flowing Track
605	Channel Clipping Spring
606	Channel Adjusting Valve

7). Stand and Base Fixtures

<u>Art. Serial</u>	<u>Parts Descriptions</u>
701	Base Housing
702	Foot Stepping Control Plate
702-1	Foot Stepping Control Plate Shaft
703	Pyramid Shape Structural Framing
704	Switch Fixture Plate
705	Switch Control
706	Stamping Mold Base
707	Electrical Motor
707-1	Electrical Motor Rolling Belt Wheel Cover
708	Rolling Belt Wheel Cover
709	Rolling Belt Outer Plastic Cover
710	Foot Stepping Control Cover
711	Foot Stepping Control Plate Spring Stick
712	Clutch Pulling Wire
713	Clutch Turning Stick
714	Clutch Resetting Spring
715	Rolling Belt

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(Annex Two - Common Replacement Parts Table)

1). Common Replacement Parts Table

<u>Art. Serial</u>	<u>Parts Descriptions</u>
110-1	Uni-Plastic Plate
201-1	Dynamic Power Backward Spring
203	Dynamic Power Resetting Spring
217	Die Sets Base V-Shape Spring
222	Die Sets Base Backward Setting Spring
406	Die Sets
407-3	Stud and Socket Fixtures Linking Spring
409	Stud and Socket Fixtures Spring
512	Channel Rolling Wheel
516	Channel Spring
520	Channel Pulling Wire
521	Channel Pulling Wire Spring
616	Channel Spring
620	Channel Pulling Wire
621	Channel Pulling Wire Spring
814	Clutch Resetting Spring
815	Rolling Belt

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