



CD 600
CLOTH DRILL
鑽布機



PCD 600
POWERTEMP DRILL
電熱鑽布機

INSTRUCTION BOOK AND PARTS BOOK

使用說明書含零件冊

SU LEE MACHINE .CO.,LTD.

速利機械工業有限公司

1. SAFETY INSTRUCTIONS:

- a. Be sure machine is properly grounded.
- b. Use correct electrical wiring:
International:
1P+N+≐ Use 3 × 1.0mm² CEE(2)61
3P+≐ Use 4 × 1.0mm² CEE(2)61
- c. Keep cutting area clean and well lit.
- d. Keep visitors away from cutting area.
- e. Do not use drill in damp or wet location.
- f. Store drill in dry location.
- g. Keep drill clean and needles sharp for best and safest performance.
- h. Always disconnect drill when not in use, before servicing, and when changing needles.
- i. Remove wrench from chuck before starting motor.
- j. Avoid accidental starting by disconnecting electrical cord before carrying drill and making sure switch is off before connecting cord.
- k. Keep hands away from rotating needles.
- l. Do not touch Powrtemp needle guide when hot.

2. TO OPERATE:

Attach the connector to the terminal pins, The motor is operated by turning on the motor switch (cd116).

Place the machine on top of the lay of material to be drilled. To lower the drill needle into the material, loosen and drop the height clamp (cd106) and then slide the motor bracket (cd115) down the post(cd105). The drill needle enters and leaves the material by moving the motor bracket.

3. TO SET HEIGHT CLAMP:

Before drilling the cloth, adjust the height clamp (cd106) to limit the depth of drilling. Without the motor running, place the machine on the edge of the lay. Lower the motor bracket so that the lower tip of the needle enters the table (maximum 0.8mm). Then lock the height clamp at that point so that the needle will not go lower when in use.

NOTE: When drilling, heavy cardboard or plywood should be slipped under the bottom ply of the lay to prevent the needle from entering the table. This will preserve the surface of the table.

4. TO OPERATE HEATING OF POWRTEMP DRILL:

The needle is heated by turning the control knob (pcd204) for the heat control switch from "off" to "high" Wait about ten minutes for needle to heat fully, and then drill a sample block of material. If the heated needle scorches the fabric, turn the control knob to a lower position. When the control knob is in the "off" position, the drill can be used as a regular Cloth Drill.

5. TO CHANGE NEEDLE:

Chuck (cd131) holds the needle. The needle is locked or released by using the chuck wrench (cd132) to open or close the jaws of the chuck.

The needle guide (cd134) has different hole for different needle diameters. Important-the needle must pass through the hole of the needle guide to be in proper alignment. When changing to a needle of a different diameter, rotate the needle guide so that the matching hole.

The needle guide screw (cd135) on the Cloth Drill is a flat screw which can be turned by tool. However, the needle guide screw (cd135) for the Powrtemp Drill is a flat head screw which should only be turned with a screw driver in order to prevent burning of the fingers when the needle guide is hot.

When the needle is changed in the drill, the drill can be tilted back and held by tool or it can be laid on its back, the top of the post resting on the table, to prevent any damage to the brush caps (S105).

6. NEEDLES AVAILABLE:

a. Description:

There are three types of needles commonly available for drilling holes in cloth. They are the round point needle, the half cup needle, and the hollow needle. These needles are available in various diameters (listed below) for drilling different size holes. It is advisable to drill the smallest hole possible so as not to affect the finished garment. Try different needles to select the best one for your materials.

The round point needle is used in the Cloth Drill for closely woven materials as it spreads the threads but does not cut them. In the Powrtemp Drill the round point needle is always used with heat for drilling loosely woven materials as the needle opens the hole while the heat "sets" the threads so that the hole does not close up again.

The half cup needle cuts away material and is used on coarser woven fabrics which would not show the marking of the round point needle.

The hollow needle is generally used on loosely woven fabrics to cut out a hole in the material.

Synthetic materials, such as nylon, often fuse when being drilled with an ordinary needle. It is recommended that the needle be reversed and a flat be ground at a 45° angle on the blunt end of the needle. This "chisel" edge will drill the synthetic material without fusing.

b. Diameter sizes:

Φ 1.0mm, Φ 1.5mm, Φ 2.0mm Φ 2.5mm Φ 3.0mm

c. Needle lengths:

Nominal length	Overall length
6"	24cm
8"	29cm
10"	34cm

d. Part numbers of needles available:

Type	Dia. size	Lengths		
		6"	8"	10"
Round point	1	610R	810R	110R
	1.5	615R	815R	115R
	2	620R	820R	120R
	2.5	625R	825R	125R
Half Cup	3	630R	830R	130R
	2	620C	820C	120C
	2.5	625C	825C	125C
Hollow	3	630C	830C	130C
	2.5	625H	825H	125H
	3	630H	830H	130H

7. CARE AND MAINTENANCE:

Wipe post (cd105) clean occasionally with a dry rag. This will insure that the motor bracket(cd115) will slide up and down the post easily. Do not oil as it will collect dirt.

The copper commutator on the armature (cd142) should be cleaned of carbon once a year.

To change the carbon brush and spring (S104) unscrew the brush cap (S105) and remove the brush.

1、安全指導說明：

- a、 確認機器正確的接地。
- b、 使用符合規格的電線：
國際標準：
1P+N+≡Use3×1.0mm² CEE(2)61
3P+≡ Use4×1.0mm² CEE(2)61
- c、 保持裁剪區域清潔和明亮。
- d、 保持參訪者遠離裁剪區。
- e、 請勿在潮濕的地方使用本機。
- f、 請將本機存放於干燥的區域。
- g、 保持本機的清潔和鑽針的銳利使之維持在最好和最安全的狀態。
- h、 當不使用、保養維修或更換鑽針時必須要切斷本機電源。
- i、 起動馬達之前必須先將鑽夾鎖匙取下。
- j、 避免意外的發生，首先要確定機器不使用移放時，切斷電源和插接電源之前確認開關是關閉狀態。
- k、 手保持遠離轉動中的鑽針。
- l、 當鑽針加熱、鑽針導套部件高熱時，請勿碰觸。

2、使用說明：

插上電源線，由開關(cd116)控制馬達運轉。

將機器放在被鑽物品上方表面位置後鑽孔。鑽針壓下鑽入布料內，鬆開和降下高度夾扣(cd106)，手握馬達托架(cd115)順著柱子(cd105)下壓滑下。鑽針進入和離開布料由此法控制操作。

3、設定高度夾扣：

鑽布之前，調整高度夾扣(cd106)到鑽布的最底層。馬達不轉，機器放在邊緣位置。壓下馬達托架使針尖進入裁床桌(最大 0.8mm)，然後鎖緊高度夾扣，即可定下鑽布深度，所以當開始使用時將不會使鑽針鑽得太深。

注解：當鑽孔時，厚紙板或三合板放入鑽孔處的底面可防止鑽針鑽入裁床。如此將可保護裁床表面。

4、電熱加熱操作指示：

加熱鑽針時將加熱器(pcd204)從“off”關轉至“high”高溫。等待約 10 分鐘，使鑽針達到最高溫，然後試鑽，如果加熱鑽針燒焦布料，將加熱器溫度調低。當加熱器關閉時，就如一般鑽布機使用。

5、更換鑽針：

夾頭(cd131)固定鑽針，夾頭鎖緊或鬆開鑽針時使用夾頭鎖匙(cd132)來打開或鎖上鑽針。鑽針導套(cd134)有不同尺寸孔徑配合不同尺寸鑽針。必須要相互配合使用。更換導套時先將固定螺絲(cd135)旋鬆

1mm 即可取出更換導套。

注意：當導套高溫時，請勿拆裝，以免燙傷。

6、可用的鑽針：

a、說明：

鑽布孔時通常有三種規格的鑽針。它們是：圓針型鑽針、半杯型鑽針和圓穴孔型鑽針。這些針各有不同的直徑適用於鑽出不同尺寸的孔徑。鑽最小的孔對最後做衣服時不一定適合。請試用不同的鑽針，然後選擇最適合的使用。

一般圓針型鑽針使用於緊密的編織布料，就是擴大纖維但不割斷纖維。加熱後的圓針型鑽針通常適用於寬鬆的編織物，就是鑽針將孔打開並燙開，使孔邊纖維不再閉合。

半杯型鑽針切斷所鑽材料和使用在粗劣的編織布料，在材料上鑽掉一個洞。

人造材料，尤其是尼龍，使用普通的鑽針鑽孔時經常會融掉。建議將鑽針尖端磨成 45°角平面。這種型狀端面在鑽人造材料時就不會燒焦。

b、鑽針直徑尺寸：

Ø1mm; Ø1.5mm; Ø2mm; Ø2.5mm; Ø3mm

c、鑽針長度：

名義長度	實際長度
6"	24cm
8"	29cm
10"	34cm

d、鑽針規格編號：

型 狀	直 徑	長 度		
		6"	8"	10"
圓針型	1	610R	810R	110R
	1.5	615R	815R	115R
	2	620R	820R	120R
	2.5	625R	825R	125R
	3	630R	830R	130R
半杯型	2	620C	820C	120C
	2.5	625C	825C	125C
	3	630C	830C	130C
圓穴孔型	2.5	625H	825H	125H
	3	630H	830H	130H

7、保管與保養：

柱子(cd105)有時使用干布清潔。這樣可確保馬達托架(cd115)在柱子上滑動時更容易。不可使用機油否則會更髒。

轉子上的整流子(cd142)，碳刷部份每年必需清理一次。

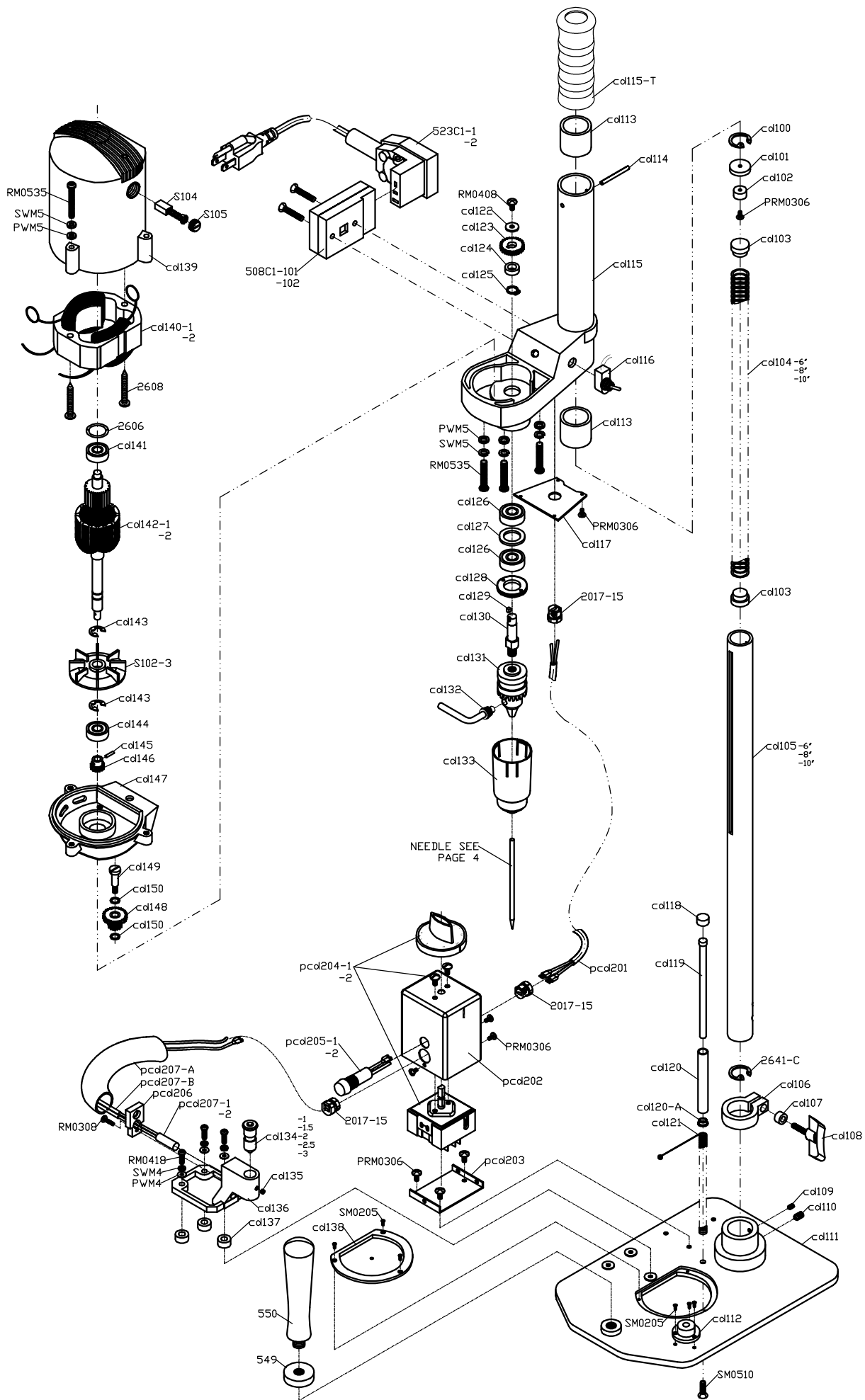
更換碳刷(S104)時，只要旋開碳刷蓋(S105)取出碳刷，換新即可。左右必須同時更換。

PARTS LIST

零件明細

PART NO. 零件編號	DESCRIPTION 品名	PART NO. 零件編號	DESCRIPTION 品名		
cd100	Retaining Ring For Spring	升降彈簧扣環	cd139	Motor Cover	馬達殼
cd101	Washer	華司	cd140-1	Stator 100~120 volts	100~120伏定子
cd102	Rubber Washer	橡膠墊	cd140-2	Stator 220~240 volts	220~240伏定子
cd103	Plug For Post Spring	升降彈簧端蓋	cd141	Bearing 608zz	608ZZ軸承
cd104-6"	Post Spring	6"升降彈簧	cd142-1	Armature 100~120 volts	100~120伏轉子
cd104-8"	Post Spring	8"升降彈簧	cd142-2	Armature 220~240 volts	220~240伏轉子
cd104-10"	Post Spring	10"升降彈簧	cd143	Retaining Ring	扣環
cd105-6"	Post-6"	6"柱子	cd144	Bearing 6000zz	6000ZZ軸承
cd105-8"	Post-8"	8"柱子	cd145	Rollpin	彈簧銷
cd105-10"	Post-10"	10"柱子	cd146	Pinion, 15T	小齒輪15T
cd106	Height Clamp	高度定位夾	cd147	Bottom Housing only, Motor	馬達底蓋
cd107	Washer	華司	cd148	Gear, 28/15T	齒輪28/15T
cd108	Screw, Height Clamp	定位夾螺絲	cd149	Gear Shaft for 28/15T	28/15T齒輪軸
cd109	Screw M4*5 Set	固定螺絲M4*5	2606	O Ring	O型環
cd110	Screw M6*10 Set	固定螺絲M6*10	2608	Screw For Stator	定子固定螺絲
cd111	Base Plate	底盤	2641-C	Retaining Ring	扣環
cd112	Level	水平儀	S102-B	Fan	風葉
cd113	Bushing, Motor Bracket	馬達托架軸襯	S104	Carbon Brush	碳刷
cd114	Rollpin	彈簧銷	S105	Brush Cap	碳刷蓋
cd115	Motor Bracket	馬達托架	549	Handle Lock Nut	手把鎖緊螺母
cd116	Switch	開關	550	Handle	手把
cd117	Switch Cover	開關蓋	PRM0306	Screw M3*6	扁丸頭螺絲M3*6
cd118	Shaft Cover Cap	導管蓋	RM0408	Screw M4*8	丸頭螺絲M4*8
cd119	Needle Guide Spring Shaft	導引簧軸	RM0418	Screw M4*18	丸頭螺絲M4*18
cd120	Shaft Cover	導管	RM0535	Screw M5*35	丸頭螺絲M5*35
cd121	Needle Guide Spring	導引簧	SM0205	Screw M2*5	沉頭螺絲M2*5
cd122	Washer	華司	SM0510	Screw M5*10	沉頭螺絲M5*10
cd123	Gear 28T	28T齒輪	SWM4	Spring Washer M4	M4彈簧華司
cd124	Washer	華司	SWM5	Spring Washer M5	M5彈簧華司
cd125	Retaining Ring	扣環	PWM5	Plate Washer M5	M5平華司
cd126	Ball Bearing 629	629ZZ軸承	508C1-101	110V. 1Ø. Socket	單相110伏插座組
cd127	Spacer	隔片	508C1-102	220V. 1Ø. Socket	單相220伏插座組
cd128	Bearing Lock	軸承固定蓋	523C1-1	110V Cable Set	110伏電源線組
cd129	Key, Gear	齒輪鍵	523C1-2	220V Cable Set	220伏電源線組
cd130	Ghuck Shaft,3/8Thd	夾頭軸	For Power Cloth Drill		電加熱鑽布機零件
cd131	Chuck	夾頭	pcd201	Cable	電源線
cd132	Key, Chuck	夾頭鎖匙	pcd202	Box For Control Switch	控制開關盒
cd133	Shield Cover	夾頭護蓋	pcd203	Box seat For Control Switch	控制開關盒座
cd134-1	Needle Guide-1.0mm hole	Ø1.0mm鑽針導套	pcd204-1	Switch, Heat Control Set -120 volts	電熱控制開關組120伏
cd134-1.5	Needle Guide-1.5mm hole	Ø1.5mm鑽針導套	pcd204-2	Switch, Heat Control Set -220 volts	電熱控制開關組220伏
cd134-2	Needle Guide-2.0mm hole	Ø2.0mm鑽針導套	pcd205-1	Pilot Light - 120 volts	120伏指示燈
cd134-2.5	Needle Guide-2.5mm hole	Ø2.5mm鑽針導套	pcd205-2	Pilot Light - 220 volts	220伏指示燈
cd134-3	Needle Guide-3.0mm hole	Ø3.0mm鑽針導套	pcd206	Heating Element Cover	發熱器封蓋
cd135	Screw M4*4 Set	固定螺絲M4*4	pcd207-1	Heating Element for 120 V	120伏發熱器
cd136	Needle Bracket	針導套托架	pcd207-2	Heating Element for 220 V	220伏發熱器
cd137	Heat insulation washer	隔熱墊	2017-15	Strain Relief	電源線扣
cd138	Pointer Plate	定點膠盤	RM0308	Screw M3*8	丸頭螺絲M3*8

When Ordering Parts By PART NUMBER and DESCRIPTION
訂購零件時請依零件編號和品名訂購



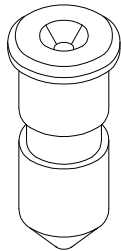
OPTION PARTS:

選購配件:

NEEDLE SIZE:

鑽針尺寸:

 ROUND POINT DRILL NEEDLE 圓針型鑽針	DIA. 直徑	Lengths			
		6"	8"	10"	
	4	640R	840R	140R	
 HALF CUP DRILL NEEDLE 半杯型鑽針	DIA. 直徑	Lengths			
		6"	8"	10"	
	4	640C	840C	140C	
 HOLLOW DRILL NEEDLE 圓穴孔型鑽針	DIA. 直徑	Lengths			
		6"	8"	10"	
	4	640H	840H	140H	
		5	650R	850R	150R
		5	650C	850C	150C
		5	650H	850H	150H



NEEDLE GUIDE
鑽針導套

CD134-4 Needle Guide 4.0mm Hole
ø4.0 鑽針導套

CD134-5 Needle Guide 5.0mm Hole
ø5.0 鑽針導套

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