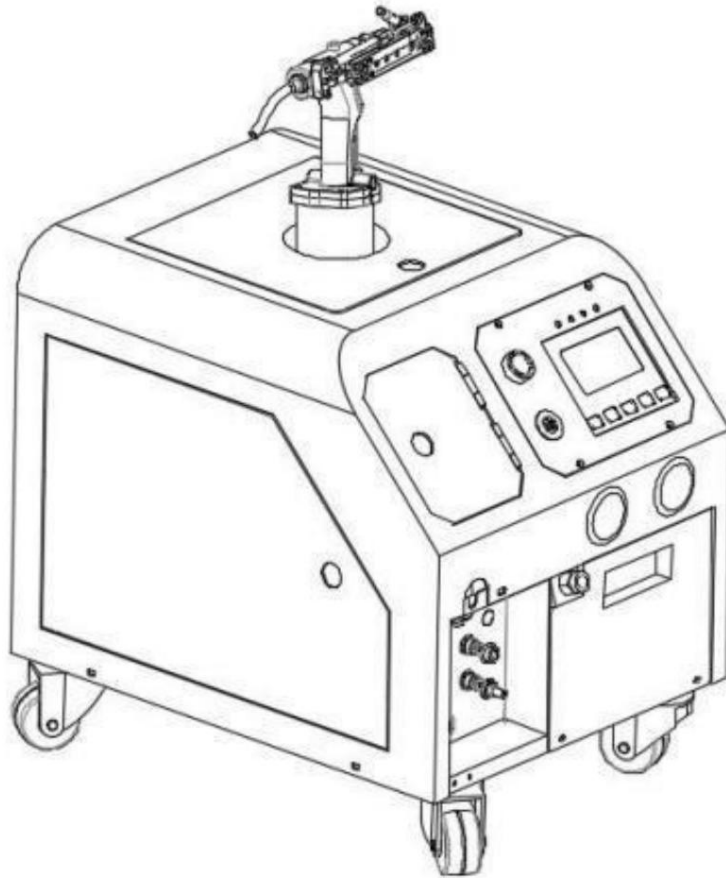


Southern Machinery Sales and Service Co., Ltd.



自动拉铆机 使用说明书

Please read this instruction manual carefully before using the product. This instruction manual contains service instructions. Please be sure to keep them properly.

尊敬的客户：

Thank you for choosing and using Xishilong products! Before use, please read this instruction manual carefully and pay special attention to safety precautions to ensure

Ensure correct operation and use.

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Product introduction
2 product features
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一、产品简介

Xishilong automatic riveting machine is composed of a host machine (automatic arrangement and feeding device) and a riveting gun assembly. working principle

The vibrating device automatically arranges and separates the rivets in order, and uses compressed air as power to push the rivets through the tube.

The pipeline is automatically transported to the nozzle of the rivet gun. Xishilong automatic riveting machine can upgrade traditional manual riveting operations to automated operations.

The use of combined robotic arms can achieve unmanned operation and double the work efficiency.

二、产品特点

Automatic alignment and automatic feeding
Strong versatility and flexible operation
Easy to understand, easy to learn, fast and efficient

Intelligent counting, early warning reminder
Stable operation and easy troubleshooting
Hands-free, clean and stain-free

三、安装说明

(一) 安装注意事项

1. Please be sure to install the machine according to the installation steps. Do not connect the power and air source before installing the rivet delivery pipe. Otherwise, the rivet pipe may shoot out rivets during installation and cause personal injury.
2. Make sure that the connected power supply is grounded, otherwise it may cause electric shock and cause personal injury.
3. Before connecting the power supply, please confirm again that the connected power supply is 220V, otherwise it may cause personal injury or the machine may be burned and cause a fire.
4. Please make sure that the surface on which the host is placed is stable, otherwise it may cause the machine to run unstable or tip over, causing personal injury or machine damage.
5. Before turning on the power, make sure there is no water in the compressed air pipe, otherwise it will affect the service life of the machine, and in severe cases, it may cause damage to the machine.
6. After the air source is connected, the cylinder on the rivet gun should be in a retracted state, otherwise it will cause failure of the rivet. The air inlet and outlet of the cylinder should be replaced. direction, so that the cylinder on the rivet gun is in a retracted state.

(二) 拉钉枪安装方法和步骤

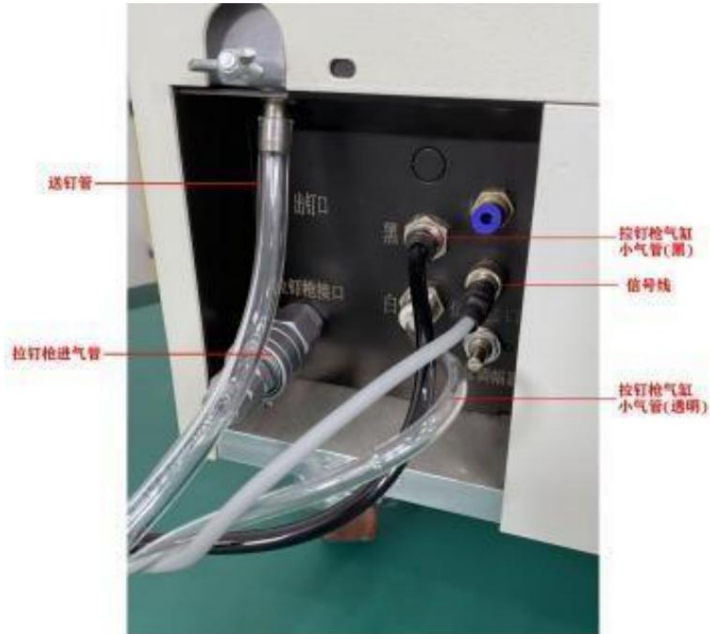
1. Take out the nail gun and place it flat on the workbench;

2. Find the pipeline package, which contains the nail feeding pipe, the nail gun air inlet pipe, the small air pipe of the nail gun cylinder (one black/transparent each), and the signal line.

(As shown in Figure 1), a complete set, this end of the casing line is called end A, and the other end is called end B. There is also a single transparent no-connection

The trachea in the head is called the caudal tube;

图一^A, 端图示:



3. Insert the nail feeding tube at end A into the nail feeding tube on the nozzle of the nail pulling gun; the air inlet pipe of the nail pulling gun is connected to the main air inlet pipe of the nail pulling gun; The small air pipe of the cylinder (black) is connected to the black air inlet elbow, and the small air pipe (white) of the nail gun cylinder is connected to the white air inlet elbow; The number line terminal is connected to the signal port of the nail gun;
4. The tail nail tube (transparent) is connected to the nail puller screw sleeve (as shown in Figure 2);

图二:

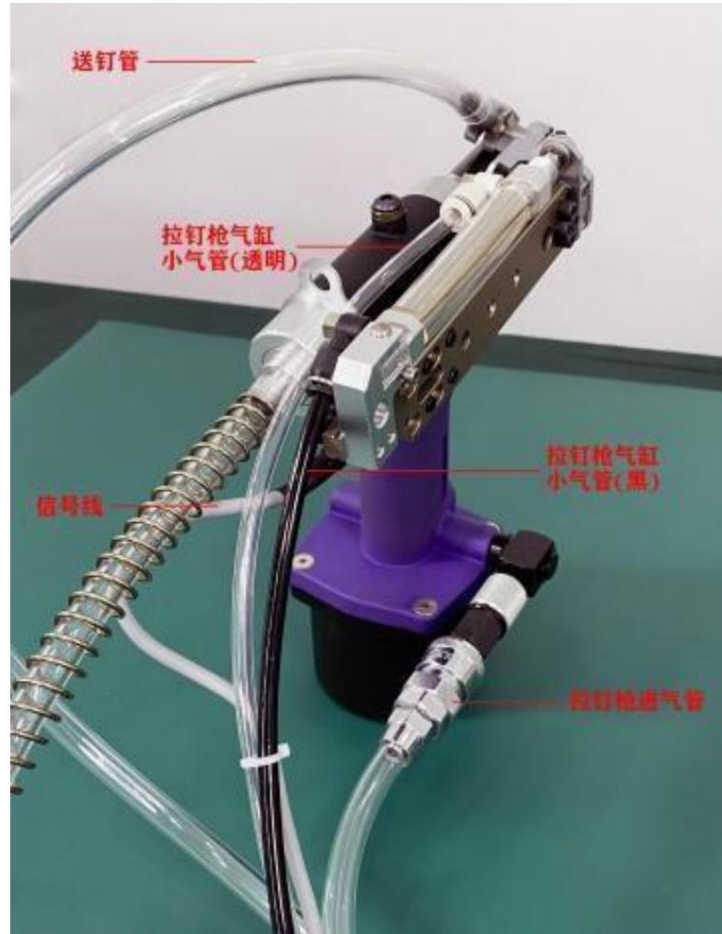


1. Take out the main unit and place it on a flat ground or stable working platform.

(三) 主机安装方法和步骤

2. End B of the nail feeding pipeline (as shown in Figure 3) is connected to the host in turn;

图三:



3. The B end of the nail feeding tube is connected to the nail outlet of the host; the air inlet pipe of the riveting gun is connected to the air source output interface of the host; the small air pipe of the riveting gun is black

Connect the gun cylinder air source connector (black) and the small white air pipe to the gun cylinder air source connector (white) in turn; the signal line is connected to the three-core aviation

Connect the head to the three-core connector of the host; Finally, on the lower left side of the rear side of the chassis, the external air source air inlet pipe is connected to the host air source connector, and the power cord

Plug it into the power connector and turn on the main power switch (as shown in Figure 4);

图四:



4. Connect the power supply and air source, and the machine installation is completed.

(四) 安全操作注意事项 ⚠

1. Make sure the voltage used is 220V. Any high or low electricity will cause damage to the machine and even cause injury to personnel.
2. Do not turn on the power before the rivet tube is connected to the rivet gun joint, otherwise the rivet tube may shoot out rivets and hit personnel.
cause some damages.
3. Do not pull out the rivet tube from the connector of the rivet gun before turning off the power, otherwise the rivet tube may shoot out the rivet.
Injury to personnel.
4. During work, it is prohibited to block the nail separator with fingers or other objects, otherwise it may cause injury to the fingers or damage the machine.
5. During work, it is forbidden to use hands or other objects to pry the vibration plate, so as not to affect the stability of the vibration plate's operation.
6. During work, it is prohibited to block the movement of the nail gun cylinder with your hands or other objects, so as not to affect the accuracy of the movable gun nozzle or damage the cylinder.

四、使用说明

(一) 主机初装调试

After installation, the machine needs to be debugged because it is being used for the first time.

1. Since the machines are all customized, the parameters in the display screen generally do not need to be adjusted separately. If adjustments are needed, please refer to the parameter adjustment described below.

whole method.

2. Adjustment of air pressure: Under normal circumstances, the air pressure does not need to be adjusted. For example, if the cap diameter of the rivet is changed during customization, the air pressure needs to be adjusted.

When adjusting the air pressure, you can open the door on the right side of the chassis, rotate the air pressure regulating valve, and increase the air pressure clockwise or decrease the air pressure counterclockwise. The normal air pressure

It is suitable to be between 1.0-3kgf/cm².

3. If the cylinder of the nail gun cannot be extended and recovered normally, you can adjust the air pressure regulating valve in the left door until it can operate normally.

4. Adjustment of vibration force: If it is found that the rivet feeding speed on the vibration plate is too slow, the vibration plate adjustment knob (amplitude modulator) can be adjusted to

It can feed materials normally. Please note that the vibration force should not be too large. Generally, the vibration force does not need to be adjusted.

(二) 使用方法

1. Turn on the power and connect the air source.

2. Pour the applicable rivets into the vibrating plate. The quantity is preferably less than 1000-2000 PCS. The quantity is determined according to the size of the rivets.

3. First turn on the air inlet switch of the nail gun.

4. For the first rivet pulling operation, pull the trigger on the rivet gun. The machine will run once and separate a rivet into the rivet gun.

inside the tube. Pull the trigger on the rivet gun again, and the machine will deliver a rivet to the nozzle of the rivet gun.

5. After ensuring that there is a rivet on the nozzle of the rivet gun, hold the rivet gun with one hand and support the workpiece to be riveted with the other hand, and align the rivet hole with the rivet.

Just do the nailing work.

6. After each rivet is pulled, before your finger is loosened from the trigger of the rivet gun, you should quickly move the rivet gun about 7cm away from the workpiece and then release the trigger.

After releasing the trigger, the machine will automatically transport a rivet to the nozzle of the rivet gun, waiting for the next rivet operation.

(三) 参数调整方法

Setting key----Press and hold for 3 seconds, the numbers on the interface will flash, and the setting parameters can be changed; click once, and the flashing numbers will change to a new line or confirm.

(No more flashing); when there is an alarm sound, click once to clear the alarm sound.

Left key----1. When you press and hold "Left", the nail pusher moves to the right and stops at the right position. Press and hold again to return it to its original state.

When modifying parameters (numbers shine), click once and the shining numbers will shift one position to the left.

Up key----1. Press and hold the "Up" key for 3 seconds to flip the screen to the next interface; when modifying parameters (numbers flash), click once.

The value increases from 0 to 9, and will reset to 0 after reaching 9.

Press and hold for 3 seconds to turn the screen; press and hold for another 3 seconds to turn the screen again.

Clear key----Click once to reset the set quantity to zero; press and hold for 3 seconds to reset the production total to zero.

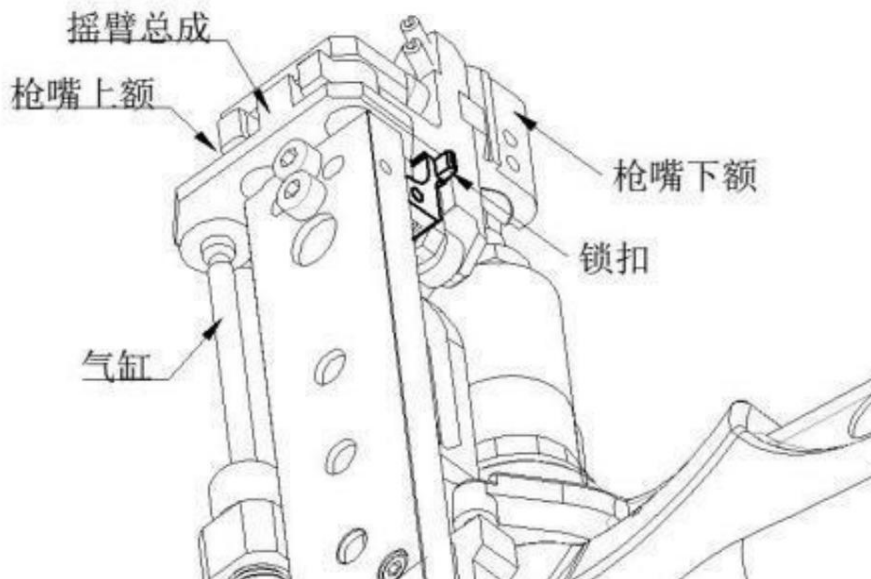
Test button - click once, the machine will move once and transport a rivet to the nozzle of the rivet gun, without increasing the total production.

(四) 使用注意事项

五、清洁保养

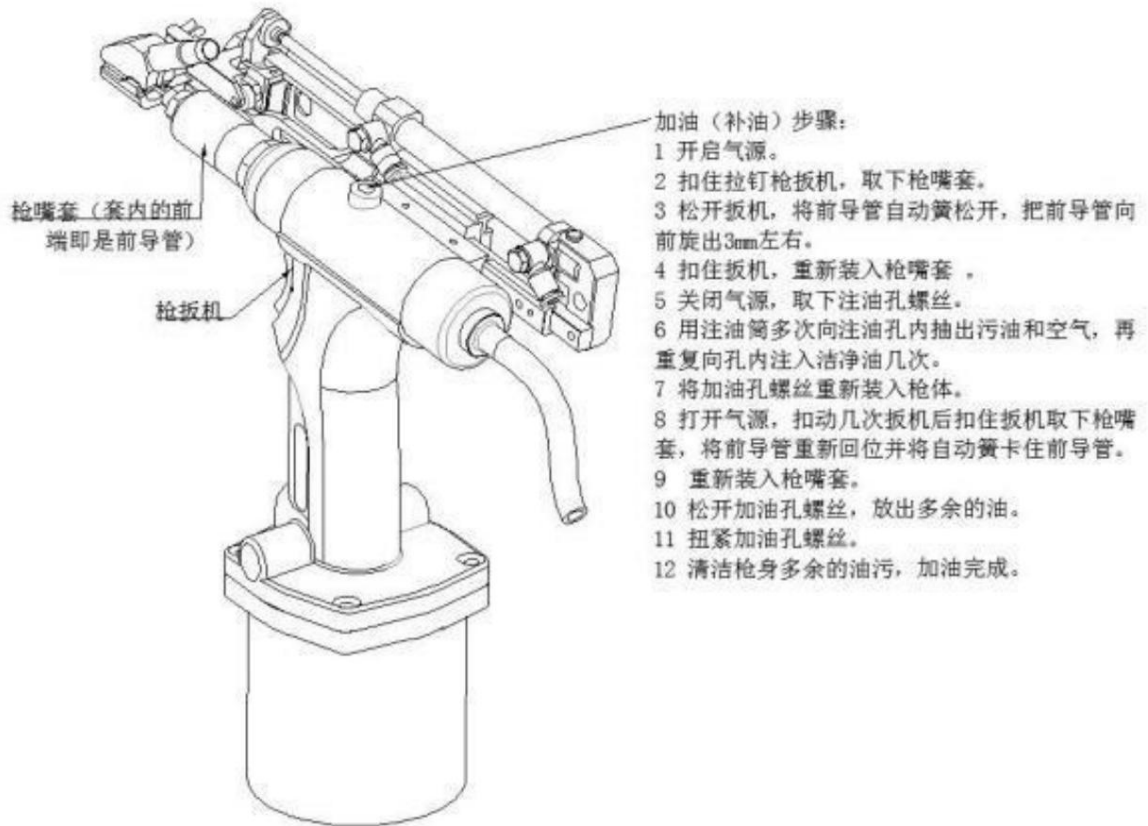
1. Because the movable nozzle performs telescopic movement driven by the cylinder and installs rivets into the nozzle of the rivet gun, it is prohibited to tap the product or work surface with the movable nozzle of the rivet gun to avoid affecting the movable gun. The movement accuracy of the nozzle reduces the stability of the movable nozzle operation.
2. Do not limit the telescopic movement of the cylinder and the movable nozzle with your hands or other objects. The movable nozzle requires sufficient operating space so that the nozzle can automatically load and pull rivets stably.
3. Do not bend or bundle the rivet delivery pipe, otherwise the rivets will get stuck at the bend or bundle during transportation.
4. Do not throw the broken rivet head into the vibrating plate to avoid jamming the vibrating plate.
5. If you find that a rivet is stuck in the movable nozzle, you can hold the trigger of the rivet gun for a long time (do not let go after more than 1.5 seconds), and the cylinder will

The trigger will automatically extend. At this time, pull the lower forehead of the movable gun nozzle to clean out the rivets in the gun nozzle. Release the trigger and the movable gun nozzle will automatically
Return to retracted position. Never pull the trigger multiple times to cause the machine to feed rivets to the nozzle of the rivet gun multiple times, causing the nozzle of the rivet gun to become clogged.
In severe cases, the machine will become stuck and unable to operate.
6. If it is found that there is a blockage in the nozzle hole of the nail gun, the remaining nail chips in the nozzle hole of the nail gun should be cleaned in time.
7. When transporting, please clean the rivets in the track first or push the nail pusher away from the track to avoid pulling the rivets into the machine by mistake.
Causes stuck nails.
8. When using a rocker arm assembly with a self-locking function, if you want to open the upper and lower forehead of the gun mouth, you must first pull out the lock on the rocker arm assembly, and then the upper and lower forehead of the gun mouth can be opened (there is no need to pull the lock when closing).



1. Clean the vibration plate regularly to ensure that the inside of the vibration plate is clean. It is recommended that when there are no rivets in the vibration plate, use a high-pressure air gun to remove the vibration plate.
Blow out the residue inside, clean the vibration plate surface with a clean cloth, and clean it once a week.
2. Clean the inside of the rivet gun mouth regularly, usually once a day or every other day.
3. Add 68# anti-wear hydraulic oil to the nail gun regularly (the filling steps are as shown below). The specific interval depends on the model of the gun or the frequency of use.
Certainly.

六、常见问题 如图所示：



4. Refueling method: The refueling method will be different for different models of rivet guns. Please refer to the refueling video provided for details.

5. Clean the rivet track regularly to ensure that the rivet runs smoothly in the track. It is recommended to clean it once a week.

6. Clean the nail feeding system regularly to ensure smooth operation of the nail feeding system. It is recommended to clean the moving parts with a high-pressure gun once a week.

7. Clean the outer surface of the chassis regularly.

8. Please turn off the power after get off work every day or when not in use.

现象	检查内容	解决方法
The power switch indicator light does not light up	Check whether the power is connected and whether the switch is on. Plug in the power supply and turn on the power switch.	
	Check whether the fuse in the power switch is blown and replace the fuse.	
The indicator light is on and the screen is not on. The indicator light on the electronic board in the host is not on.		1 Check whether the circuit before and after the switching power supply is connected
		2 Check whether the switching power supply is burned out

		3 Check whether the power terminal of the electronic board is plugged in properly
	The indicator light on the electronic board in the host is on and the screen is not on.	The electronic board is broken. Replace the electronic board.
Host alarm	There are no rivets in the vibrating plate bin. Add the rivets to the vibrating plate.	
	There are rivets inside the vibration plate	Are there any special-shaped nails stuck in the vibrating plate track that prevent the nails from passing through? If so, just remove the special-shaped rivets.
The nail separator separates nails but does not come out.	The nail pusher has special-shaped rivets stuck in it.	Press and hold the "Left" button, the push cover will automatically open to the right, loosen the butterfly screw, remove the nail connector, clear the rivets, and then press and hold to the left to restore.
The host produces nails but the nozzle of the gun does not nail.	The rivet tube is bent and deformed or the bundle is too tight. Loosen the bundle or	replace the rivet tube.
Staples stuck in the mouth of the rivet gun	The rivet is weak when it enters the mouth of the gun.	The diameter of the rivet cap is inappropriate. Use a suitable rivet instead.
		Increase the pressure regulating valve in the right door to increase the nail supply air pressure or lengthen the blowing time.
	The pull nail enters the gun mouth too hard	1. The diameter of the rivet cap is inappropriate. Use a suitable rivet instead.
		2. Turn down the nail supply air pressure of the pressure regulating valve in the right door or shorten the blowing time.
	The rivet is skewed, resting on or across the mouth of the rivet gun, or the rivet falls off	1. The tension spring has insufficient tension and cannot return the upper part of the gun muzzle. Replace the spring.
		2. The diameter of the rivet cap has become larger and is stuck between the upper and lower forehead of the gun. Replace the rivet.
3. The nail feeding tube pulls the forehead of the gun nozzle so that the forehead cannot return to its original position. Just rotate the nail feeding tube to the right a little.		
The rivet cannot fit into the mouth of the gun	The muzzle hole is blocked	Clear the nozzle hole or replace the nozzle.
	The rivet rod is not aligned with the nozzle hole	1. Lack of oil, the stroke is shortened, and the expansion pin cannot fully open the claw piece. Refuel.
		2. The expansion pin spring becomes short due to fatigue and the spring needs to be replaced.
		3. The big return spring is broken and cannot drive the mechanism to open the claw piece. Replace it.
		4. There is iron filing residue in the forehead groove under the gun nozzle, and the residue needs to be removed.
		5. The upper and lower forehead of the gun nozzle are displaced and need to be returned to the factory for repair.
	Rivet rod bent	Check the quality of the rivets and replace them.
	Pull rivets become shorter	1. The nail feeding pressure is high. After the nail is fed, the core pull and the rivet cap are loosened, making the core pull shorter and unable to fit into the gun nozzle. Replace the nail.
2. The rivet tail rod has become shorter and cannot fit into the gun mouth. It needs to be returned to the factory to replace the ejector rod.		

<p>After the nails are installed into the gun nozzle, the nail suction tube is blocked by spraying out, causing the air to blow out of the gun nozzle.</p>		<ol style="list-style-type: none"> 1 Clear or replace the nail guide tube or Pu tube of the nail gun 2. The solder joint of the expansion pin falls off. Replace the expansion pin. 3. The waste nail bucket is clogged. Clean the waste nails.
<p>The tail pin is blocked in the mouth of the gun and the claws of the jaw are not opened or not opened enough.</p>		<ol style="list-style-type: none"> 1. Iron slag is blocked in the claw chamber, causing the claws to be unable to move. clean 2 The nail gun has too much oil, and the stroke is not enough to open the claws. Put the oil. 3. The large nail-retracting spring is weak, causing the gun piston to fail to reset. Replace the spring.
<p>The tail nail is blocked in the gun. The tail nail of the gun is blocked in the nail withdrawal tube of the gun.</p>		<ol style="list-style-type: none"> 1. There is too much residue in the gun nozzle or claw piece, and the negative pressure air will suck the residue to the nail withdrawal tube and block the tail nail rod. Just clean out the tail pin. 2. The nail withdrawal tube is too small and can easily get stuck on the tail nail rod. Replace the nail withdrawal tube. 3. The rivet is long, the rivet body is too thin, and the pulled-out tail nail rod has a curved hook. Replace rivets.
<p>Nail gun does not pull nails</p>	<p>The piston of the nail gun does not move (no sound). 1 The reversing valve is stuck.</p> <p>The piston moves but does not pull the nail</p>	<p>Use your fingers to seal the three small air outlets and pull the trigger several times.</p> <ol style="list-style-type: none"> 2 The air piston is broken, replace the air piston O-ring or return it to the factory for repair. 1 The claw piece is worn or damaged, and the gun operates but does not pull the nail. Replace the claw piece. 2. The large nail retracting spring is broken. Replace the large nail retracting spring. 3 There is debris in the claw piece, causing the claw piece to not move.
<p>Pull the trigger to determine problems with the rivet gun and machine</p>	<ol style="list-style-type: none"> 1. If the machine responds but the gun does not, pull out the gas tube of the gun and pull the trigger. If there is ventilation in the gas tube, there is no problem with the machine but there is a problem with the gun. If the trachea is not ventilated, there is nothing wrong with the gun but with the machine. 2. The gun responds, but the machine nail splitter does not move. 	<ol style="list-style-type: none"> 1 Check whether the gun cylinder is damaged or stuck. Replace cylinder 2. Pull out the air pipe of the cylinder on the gun and push the cylinder to see if it can expand and contract freely. If not, the slide rail is damaged or something is stuck in the rocker arm of the gun. 3. If there is a problem with the machine, you can check the throttle valve of the solenoid valve or contact maintenance personnel. 1. If there is a problem with the solenoid valve of the machine, please contact maintenance personnel. 2. The nail separator jams the nails and clears the rivets in the nail separator.

		3 The control board is broken, replace the electronic board.
		1 The sensor light changes, and the brown wire of the signal line may be in poor contact.
		2 If the sensor light does not change, it may be that the terminal block of the signal line is not connected properly. If the connection is not good or the signal line is broken, replace the signal line.
		3. The distance between the trigger and the sensor is too far or too close. Adjust the sensor position.
	3 Neither the machine nor the gun responded.	

七、技术参数

model	RC-6800S	Dimensions	440*350*420mm
Nail gun	LMQ-30T	Input voltage	220V
low electrical voltage	24V	working pressure	3-6 kgf/c ²
Material tube length	2.5 Rice left and right	Machine weight	46.5KG
Nail feeding speed	60 capsules/Min or more <small>superior</small>	Silo capacity	2000~3000 capsules
Rated air pressure	1 MPa	rated power	350W
riveting speed	1.2-1.5 seconds/grain	Nail withdrawal tube length	1.8 meters

八、装箱单

Part Name	Host (tower)	Nail gun (set)	tool (set)	spring (strip)	Intake pipe (strip)	power cable (strip)	manual (Book)	Hydraulic Oil (bottle)
quantity	1	1	1	1	1	1	1	1

九、服务与保修

(一) 售后服务

1. Xishilong adheres to the "customer-centered" family service concept and provides customers with professional customer services. Open for 24 hours

Nanny hotline: Mr. Li 13532322736. We provide 12-hour door-to-door service within the province and 24-hour door-to-door service outside the province.

2. Our company responds to customers' service needs 24 hours a day and formulates solutions to problems within 30 minutes.

3. In order to meet the service needs of customers, we provide professional one-to-one service.

4. In addition to providing user technical services, the company's service center is also responsible for accepting and collecting user complaint information to ensure that the questions raised by users

Questions and requests can be handled in a timely manner, and the handling status can be tracked and verified. At the same time, user files can be established to record product usage.

Provide a basis for future product quality improvements. We will continue to work hard and strive for excellence to provide customers with the most satisfactory products and services.

(二) 质量保证

Based on the date of production of the product, our company provides quality assurance for the products produced: 1.

One-week replacement: Within one week from the date of purchase, if it is detected by our company that it is a product quality problem (no damage to the appearance), our company will not issue any warranty

Replace the product with one of the same model.

2. One-year warranty: Within one year from the date of purchase, if quality problems occur during normal use, the host can enjoy free warranty service and

Lifetime maintenance service.

3. Accessories other than the main unit are wearing parts and are not covered by the warranty.

(三) 保修说明

After purchasing the equipment, please unbox it and inspect it to confirm that the functions are normal and accessories are complete, and complete the warranty card.

A. Warranty services can be provided under the following conditions within the warranty scope, and parts cost, freight, and door-to-door service will be charged:

1. Machine damage caused by improper use, misoperation, or human factors.

2. If the product is not authorized, users must repair, disassemble and modify it by themselves.

3. Equipment damage caused by natural disasters.

4. Damage caused by failure to use, maintain and maintain the product in accordance with the instructions for use.

5. The appearance of the product is seriously damaged, the product-related logos have been replaced, painted or torn, and the warranty card and invoice cannot be provided.

For machines that have exceeded the warranty period, our company will still enthusiastically provide services and charge reasonably according to the specified price.

1. Return to the factory for repair: You are responsible for the return freight, replacement parts, and maintenance man-hours.

2. Door-to-door maintenance: door-to-door service fee, replacement parts cost, and maintenance man-hour fee.

3. Self-repair: Customers can purchase replacement parts by themselves according to our guidance. They only need to pay for the accessories without any other fees.

C. Special instructions:

1. Our company is not responsible for any property or personal damage caused by improper use.

2. All compensation shall not exceed the total value of the product.

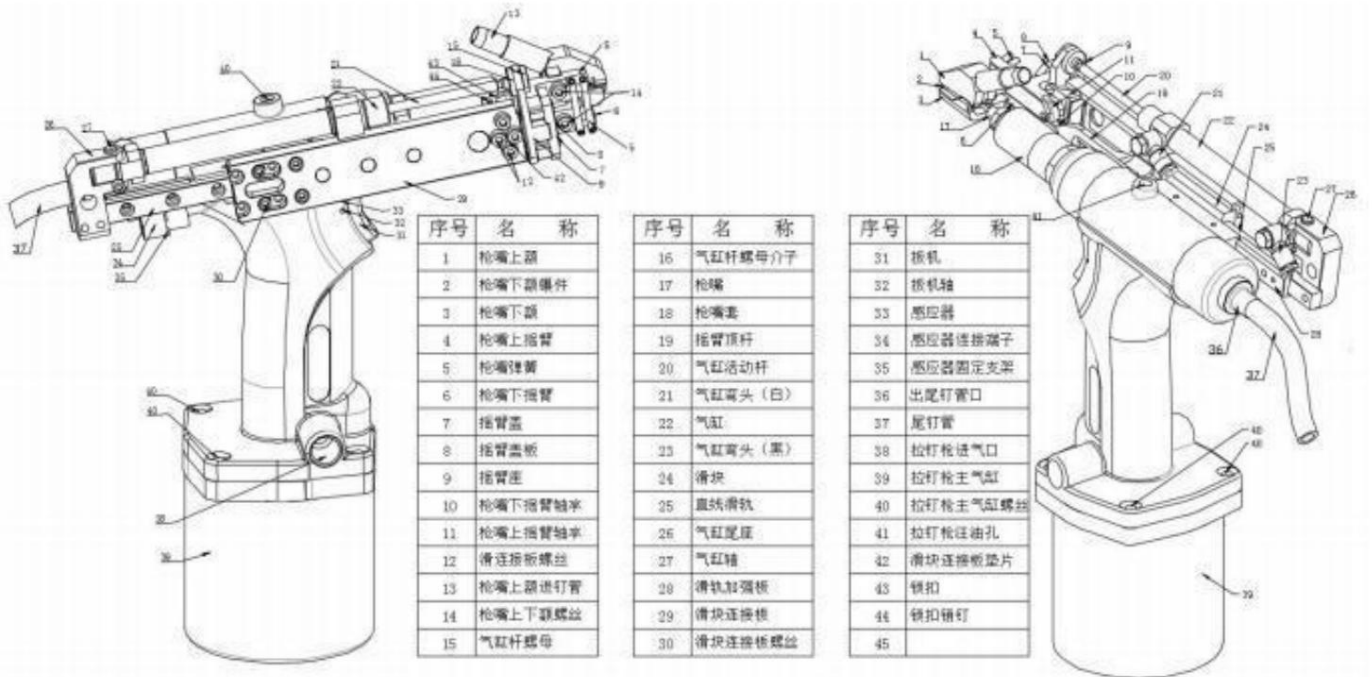
(四) 易损件清单

3. All accessories except the main unit are wearing parts. Nail gun wearing parts list

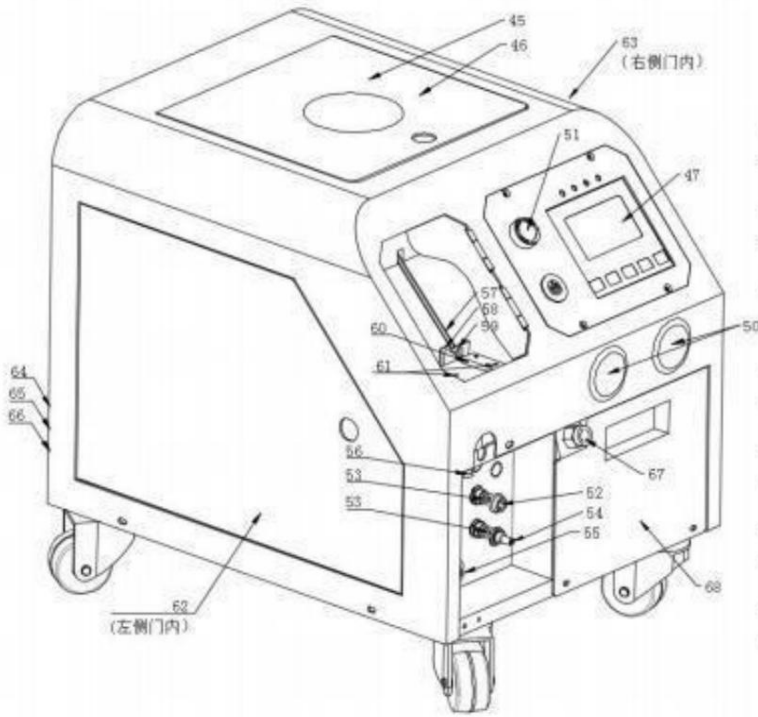
serial number	Accessory name	quantity	unit	Warranty
1	Mount the muzzle	1	individual	12 months
2	rivet nozzles	1	individual	12 months
3	springs	1	strip	12 months
4	Lower gun nozzle adjustment block	1	individual	12 months
5	Bearing lock plate	1	individual	12 months
6	arm fixing blocks	1	individual	12 months
7	Cylinder fixing block	1	individual	12 months
8	pneumatic connector	1	individual	12 months

十、产品结构

(一) 拉钉枪零件目录



(二) 主机零件目录



序号	名称
45	振动盘料斗盖
46	振动盘
47	控制面板
48	电源指示灯
49	电源开关
50	气压表
51	蜂鸣器
52	拉钉枪信号线端子
53	拉钉枪气管接头
54	振动盘调幅器
55	拉钉枪供气接头
56	分钉器出钉管

序号	名称
57	分钉器轨道
58	分钉器右刀
59	分钉器左刀
60	分钉器盖板
61	分钉器螺丝
62	气缸压力调压阀
63	送钉压力调压阀
64	保险盒及指示灯
65	总电源接头
66	气源接头
67	尾钉插管
68	尾钉收集箱

Welcome inquiry

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3. Know more our team: <https://cn.linkedin.com/in/smtsupplier>
4. Welcome to our factory in Shenzhen China
5. Google: automatic tin soldering
6. Looking forward to your email: info@smthelp.com