

# 自動輸送式檢針機

Automatic Conveyor Needle Detecting Machine

(俗稱：金屬探測儀、測釘機)



使用維護說明書

Instruction on Use and Maintenance

## 有关安全使用上的注意事项

### Notes on Safety Use

#### 安全使用必须注意

Pay attention to Safety Use

- 在使用前，请认真阅读说明书，正确无误地使用。  
说明书请妥善保管，经常请作参考。如果说明书不慎遗失，请向本公司要求索取。  
Please read the instruction carefully so you can use it in a correct way before you use it.  
Please keep the instruction for reference. If it is lost, please contact our company for a new one.
- 为了确保安全，电源插头座必须有接地桩，防止静电或带电操作。千万注意不要插错电源。  
To ensure safety, power connector plug must have grounded to prevent static or electriferous operation. Be careful not to plug the wrong plug.

#### ● 操作时穿装的注意

Notes on Wear during Operation

领带、围巾（包括装饰围巾）等容易从身体上向下挂的东西禁止穿着。袖口、裙子下摆等请注意，慎防卷入输送带、O型带里去。禁止穿戴金属饰件、手表、磁卡、BP机，以免干扰影响检测。

Never wear Necktie, shawl (including decorative ones) and other things that easily droop. You should also pay attention to sleeve or skirt in case they get rolled into conveyer belt, O-type belt. Never wear metal decorations, watches, magcard, BP to prevent interference.

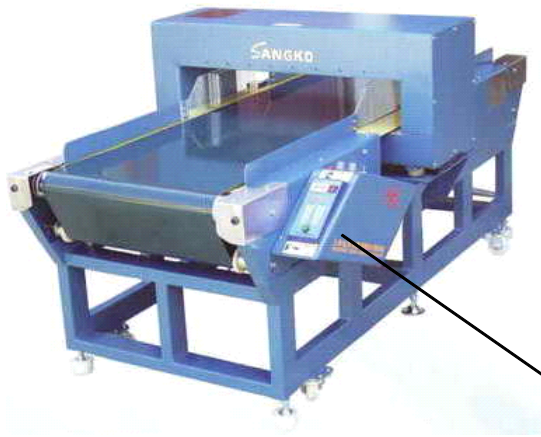
#### ● 清洁工作时的注意

Notes on Cleaning Work

下班时做好仪器清洁检查工作，首先关掉电源，电源插头要从插座处拔掉，清洁工作完毕，盖上布罩。

Please make sure the instrument clearing and checking work after work, first turn off the power, the plug should be plugged out. After the cleaning work, cover the instrument with cloth.

仪器外形功能示意 Structure and Names of Figuration



有关按键功能的设定, 请参见本说明书第 12 页。  
**About the Function Key settings, Please see Page 12.**

## 一、用途、特点 Usage & Features

### 用途 Usage

用于被服、羽绒制品（玩具）、食品、药品等产品的检铁、检针。对装饰在被服、玩具上的金属装饰品、拉链、纽扣等的退磁效果的检验。

It can be applied to detect needles or iron over quilts, clothes, eiderdown (including toys), food and medicine. It can also examine demagnetization effect of metal decorations, slide fasteners and fasteners on quilts, clothes and toys.

### 注意 Attention

A. 金属制的装饰品纽扣、拉链等在缝制前必须严格退磁，否则影响仪器正常检测。

A. Metal decorative fasteners or slide fasteners must be strictly demagnetized before it is sewn, or it will affect the normal instrument inspection.

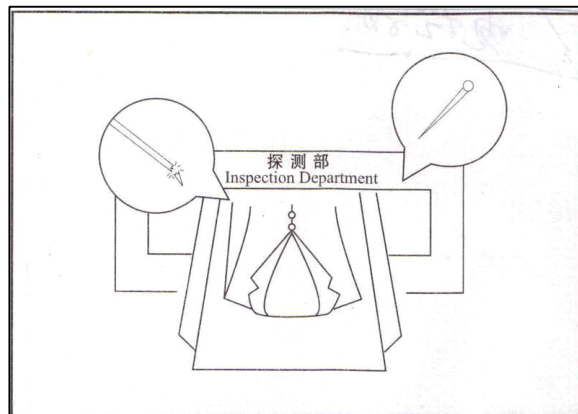
B. 缝制时使用的针、大头针等一定要是钢铁制品的磁性物质。纯不锈钢、纯铝、纯铜或塑料等非磁性金属制品是不会被检测到的。

B. The needle or pin used in sewing must be of magnetic steel or iron material. Pure stainless or aluminum or copper or plastic and other non-magnetic metal products won't be detected.

### 特点 Features

被检物只要放于输送带上被送到探测部，就能检测到有否断针或铁屑等物质。一旦发现，输送带就自动停止，报警并自动倒回。

A. Conveyor belt will bring the products to be detected to the inspection department so that broken needles or iron bits can be detected. Once detected, the conveyer belt will stop automatically and send out warnings and conversed automatically.



B. 不但能一件一件地进行检查，即使已捆绑好的和已包装（尼龙薄膜袋）好的也能检查。

B. It could check not only one by one but also the binded and packed (nylon filmy bag).

C. 因为检查部时桥式通道化的，从所检查物品的厚度（高度）来看，能检查的程度也有差异。制造商参照日本国提议，联合国通过备案的标准制造。

C. Because the inspection department is bridge channeled, so judging from the depth or height of the product to be detected, the checking can differ one from the other. Manufacturers has taken the standard proposed by Japan and approved by UN as reference.

## 二、有关机器的放置 Where to Place the Machine

### 准备 Preparation

#### 1、使用场所的选择和注意

##### Notes on Where to Place and Use the Machine

##### 1-1、抵抗振动

###### Anti-shakings

选择室内无振动的地方，最好是平整的水泥地面，磨石子的地面是最理想的选择。

Choose the place without shaking, flat cement floor or terrazzo is the best choice.

##### 1-2、金属制品对机器的影响

###### The impact of metal products on machines

离检出部一米以内的地方，千万不要堆放金属制的桌、椅、箱、货架等。缝纫机、裁剪机、载物机的运动要远离4米以上。

Don't pack tables, chairs, boxes and shelves of metal material within 1 meter. Sewing machine, cutting machine, carrying machines should operate about 4 meters away.

##### 1-3、电波障碍

###### Electric wave impact

检针器上顶部不得安装吊扇等其他通电运转物，高压变压器、高频包装机等容易产生强电磁场的要远离10米以上。还要避开汽车、电车经常驶过的路边等地方。

No sling fan or other rotating machines should be installed above needle detecting machine. High-pressure transformer, high-frequency packing machine can easily produce strong electromagnetic field and should be placed more than 10 meters away. Avoid places where cars and buses comes frequently.

##### 1-4、周围的环境条件

###### Environmental conditions around

请安放在温度和湿度变化小，以及灰尘少的地方。

Please place the machine where there are little temperature and humidity change as well as little dust.

##### 1-5、对其他物品的影响

###### Impact on other things

探测部处会产生强力磁性，所以手表、VCD卡片、信用卡、驾驶证、BP机、大哥大等容易受磁性影响的物品，绝对不要接近。

Inspection department produces strong magnetism, so watches, VCDs, credit cards, driving licenses, BPs and mobile phones that easily are affected by magnetism should be kept away.

## 2、电源的使用

### Power Usage

本仪器使用的是 220V±10V 50HZ 的单相电源，请配备带接地装置的单相插座，经常检查各连接部接触是否良好，防止似通非通因素引起的电机、电路系统的元件烧坏。

This instrument uses 220V±10V 50HZ unilateral power, so please equip with unilateral grounded socket. Frequently check whether the connection is good in case the connection problem leads to components of electric machine and electric circuits burning out.

## 3、移动时的注意

### Notes on Moving Machines

仪器需要更换地方（在不得已的情况下）作移动。短距离平面移动时，首先放下四只调节螺栓 M16 螺母，使万向轮离地，调整水平。远距离移动必须固定在平板或移动车上。

If you have to move the instruments, first you have to loosen the 4 adjustment bolts M16 nut, raise idler wheels, adjust the position on horizontal level if you want to move it in short distance and keep plane level. If you want to move it for long distance, you have to fix it on flat or moving vehicles.

**注 意：在移动时切勿推、拉主被动轴。**

Note: Don't push or pull shaft while moving.

## 4、固定的方法

### How to Fix the Machine

固定在平整的水泥地面上，用调节螺栓，使作为移动的 4 只方向小轮子离地面 1.5-3 公分，然后矫正水平，否则容易引起带子跑偏及误报警现象。

You have to fix it on flat cement floor and make 4 idler wheels by adjustment bolts 1.5-3 centimeters higher from the floor, and then you can rectify horizontal level. Or it is easily to cause belt slanting and consequent wrong warning problems.

## 5、清洁

### How to Clean the Machine

输送带表面和里面，接合部，通道探测部位，有时容易会有细小的金属粒片、灰尘及检测遗留物存在，容易引起机器误报警和发生撕裂输送带的现象。故请特别注意，输送带正、

反面必须保持长期清洁!

There might be some little metal grains, dusts and remains after check outside or inside conveyer belt, as well as in joint part and channel detection part, which will cause wrong warning and torn belt problems. Therefore, it is very important to keep the two sides of conveyer belts clean for a long time!

**注 意：** 做以上工作前，必须切断电源，拔下电源插头。

Note: You must cut the power and plug out before you do the cleaning work.

### 三、使用方法 How to Use the Machine

#### 使用 Use

1、操作该仪器的工作人员，操作时禁戴领带、围巾，留长发的女士必须把长发固定在工作帽内，防止垂下，禁戴手表及金属饰品。

The operation workers of this instrument should not wear necktie, shawl or keep long hair bound in work hat to prevent drooping, should no wear watch or metal decorations.

2、插上电源插头，必须插入 220V 带接地装置的专用插座内。

Plug in the special socket of 220V with grounded devices.

3、按红色电源开关（电箱右上角）。看红色信号灯，检查电源接触是否良好，无跳跃式一闪一闪，表示接触良好。

Press the red power button (upper right of the computer). Watch the red signal lamp to check if the power connection is good. The good connection is without twinkling.

4、接通电源后，电源指示灯亮，同时操作面板上各指示灯闪烁三次后，显示屏显示当前的时间，并进入待机状态。

Open the power switch, power indicator light on, while the screen lights of the operation panel after three flashing shows the current time. And go in the standby state.

5、检查灵敏度档位指示是否适合，一般检查用的日常档位时 8、9 档，如客商特殊需要的可调至 0-7 档或 10 档。非检查人员不得随意改动档位。

Check if the sensitivity position instruction is right. The normal position is around 8 to 9 for ordinary check. For special check asked by clients, you can adjust to 0-7 or 10. Non-checking staff shouldn't change it.

6、按启动/停止按钮，机器即时正常运转。再按启动/停止按钮，停机。

Press Start/Stop button and machine runs right, press the button again, machine stops.

7、仪器运转正常，延迟 2 秒钟时间（为延长仪器使用寿命，降低电流冲击，故设置延迟装置）后，用随机附上的标准检测块放到输送带上检测，检查仪器的检测性能，重复 2-3 次，并检查自动倒带距离是否在理想位置，如需调节，请参见 5-2 倒带时间的设定。

The machine runs well, after 2 seconds delay (the delay device is installed to prolong machine life term, lower electric shock) you can place the attached standard product to be detected on the conveyer belt for detecton to check the detecting function; you have to repeat 2-3 times and see if it is automatically reversed to the right position; if it need adjustment, presss the button beside power button in upper right part of the computer. Please notice 5-2 about the rewind time setting.

8、仪器检测性能正常后，把被检物品放到输送带上检测。

Once machine is detected all right, you can place the product to be detected on the conveyer belt for detection.

**注 意：被检物品要轻放到输送带上去，严禁重抛等不良操作方式。**

Note: Put the products gently, forbidding any heavy throwing act and other wrong ways.

如果被检物品被检出有异物，同时声光报警，输送带自动停止后倒回，操作者取下被检物，然后不必再启动，机器会自动运转，继续检测（在自动功能选中的情况下）。

另外请注意，被检出后取下的物品，应该找出磁性物（断针）后，再重复送检一次，有时不一定时一处断针。

检测完毕或下班时，按下运转按钮，关闭电源开关，拔掉电源插头。做好清洁工作，盖上布罩或尼龙罩。

标准检测块必须妥善保管。

If there are something detected out from the things, and the machine send out sound and light warning, the conveyer belt will stop automatically and reverse. The operator should take away the thing. There is no need to start again, the machine will run automatically and keep inspection (in the automatic function state).

What's more, you should take away the product and find out the magnetic matter (broken needle). You have to inspect again in case there are more than one broken needles.

After inspection or work, remember to press run button, turn off power, plug out. Do the cleaning work and cover the machine with cloth or nylon cover.

The standard product for detection should be kept in proper place.

## 四、日常检点和保护 Daily Maintenance & Protection

### 1、为了更好地使用 For better use

1-1、责任者要用正确的方法指导操作者，并熟悉本说明书。

The one in charge should teach the operators correct operation ways and make them familiarize the instructions.

1-2、缝针必须是钢铁制品。

Sewing needles must be of steel material.

1-3、缝制过程中发现断针，一定要找出后再更换新针，不要放松制度。

If any broken needle is detected during sewing, you must find it out and change new needle. Never loose the regulation.

1-4、装饰用的（包括纽扣、拉链）金属制品，一定要彻底退磁（取磁）后再缝制上去。

The metal decorations (including buttons and slide fasteners) must be completely demagnetized before it is sewn.

### 2、如果无断针及铁片是否也能报警？

Is it possible that it sends out warnings without broken needles or irons pieces?

有

Yes

2-1、未经退磁（取磁）或虽经退磁（取磁）但未尽的金属制纽扣、拉链排列较密，也能检出报警。

The closely-arranged metal buttons or slide fasteners might be not well demagnetized and can be detected and incur warning.

2-2、剪刀（包括机用刀）磨刀后的铁粉末，深色划粉粘在衣服上，这些也能被检出报警，所以裁剪刀磨刀后要特别注意处理干净。

Scissors (including those for machine use) may leave metal powder after grinding together with deep-colored chalk power on clothes, which can also be detected and incur warning. Therefore scissors should be kept clean after grinding.

2-3、粘上油污的被检物，容易吸附金属粉末，也会被检出报警。

The product with smear can easily absorb metal powder, which can be detected and incur warning.

2-4、金属的锈末粘在检查物上也能检出报警。

Product with adhibited metal rust can be detected and incur warning.

2-5、带有铁质的深色染料，使染色布带有铁质，也能检出报警，故送染合同文本须注明。

Deep-colored dyestuff with iron component can stain the dyed cloth with iron, which can be detected and incur warning. Therefore contracts concerning dyeing should give clear indication of such problems.

### 3、检查、保护 Inspection and Protection

3-1、仪器运转、检查细看是否有浮动移位现象，如有说明四只调节螺栓脚有松动，重新调节水平后固定。

During running, you should check carefully if it floats away. If so, it means the 4 adjustment bolts is loosened and you should readjust it on horizontal level before fixing.

3-2、仪器周围 4 米内有无金属制品在运动。

To check if there are metal matter operating within 4 meters away from the machine.

3-3、空载检查，轴等旋转部分是否发出异常声音，如有，用清洁的布或毛巾揩清洁，在轴承、调节螺栓和轴的穿接部滴上 2-3 滴缝纫机油。

To check without load, to see if shaft and other rotating part send out strange sounds, if so, clean with clean cloth or towel and lubricate the shaft and the connection between adjustment bolts and shafts with 2-3 sewing machine oil.

3-4、检查空载时有否性能不稳定，感应度指示灯跳闪现象，严重的可能引起误报警，请检查以下工作：

To check once unloaded whether it is unstable and if the sensibility signal lamp twinkles. In serious case, it will send wrong warning. Please do the following check:

3-4-1、检查通道探出部上下表面有否金属物吸附，并用清洁毛巾挤掉水渍后仔细地揩拭干净。

To check if the channel part which outstands has stained with metal. Please clean with clean and dehydrated clean towel.

3-4-2、检查输送带上有否污物或金属片、粉末，如果仍未发现明显物体，要用清洁湿毛巾认真地正、反二面重复擦洗几次！注意切断电源后进行！

To check if there are stains or metal pieces, powder on conveyer belt. If nothing obvious, you can carefully scrub and wash the two sides with clean wet towel! Remember to cut the power before you do the cleaning.

3-4-3、输送带是否跑偏，因长期运转及有时检查物偏边投放和仪器水平倾斜后容易引起带子跑偏现象，如有此现象，就用手轻轻扶入中心，但必须二头同时进行，否则无效，调正四角固定脚，使其平衡。或请懂行的人员用随机附的内六角扳手调节一下被动轴，注意旋转角度很小。

To check if conveyer belt get slanted. Due to long time operation and sometimes things to be detected is placed slanted or machine itself is not in horizontal level, conveyer belt might get slanted. If so, you can correct it to the center and be careful that both ends is corrected in the same time, or it won't run correctly. You can adjust the 4 fixing feet to make it balance. Or ask an expert to adjust the driven shaft with the attached inner hexagon spanner, the angle of rotation should be small.

3-5、检针仪器上面严禁堆放物品或坐人。

Don't pack things or sitting on the machine.

3-6、停用时，为了不让灰尘、金属粉末飘沾上去，请用塑料罩或布罩盖好。

During use, please cover the machine with nylon or cloth cover to prevent dust or metal powder get into the machine.

## 五、按键功能的参数设定方法 How to Set the Function Key

1、按功能设置键，进入年、月、日、时间、倒带时间的设置，首先按一下功能设置键，显示屏显示“Y200X”，其中X不断在闪烁表示请选择，X实际上是某一数字如“5”“2”“3”。请您按上下箭头选择年份，选好后按功能设置键确定，这样年份就设定完成了。此时显示屏显示“daabb”，并且“aa”在不断闪烁表示请选择，同样“aabb”实际显示的都是数字，“aa”表示月份如“01”“03”，您同样按灵敏度上下箭头选择月份，选好后按功能设置键确定，这样月份就设定完成了。此时显示屏上“bb”在闪烁……这样依次类推设定好日期和时间。

Press Function keys, enter the year, month, day, time, rewind time settings, first click Function keys, the display shows "Y200X", in which X constantly flashing means to select, X is actually a figure such as the "5" "2" "3". Click on the arrow keys from top to bottom of the year choice, after selected click Function keys to confirm, the year on the set complete. At this time display shows "daabb", and "aa" constantly flashing means to select, "aabb" show the same actual figures, "aa" said the month as "01" "03", also click on the same sensitivity up or down arrows to select the month, after selected click Function keys to confirm, the month completed the set. At this point screen "bb" in the twinkling…… And the like to set the date and time.

2、倒带时间的设定：按功能设定键到显示屏显示“n=x.y”，同样“x.y”也是某一数字如“1.6”“1.8”。例“1.8”表示倒带时间1.8秒。“x.y”闪烁等您选择，按灵敏度上下箭头选择，每按一次加或减0.2秒倒带时间，选定后按功能设置键确定。

Rewind time settings: press the Function keys, the display shows "n = x.y", "x.y" also means a figure, such as "1.6" "1.8." For example, "1.8" said the rewind time is 1.8 seconds. "X.y" flashing, and so you choose, the choice of the sensitivity up or down arrows, each time plus or minus 0.2 seconds, after selected click Function keys to confirm.

3、打印的设定：同样按功能设置键到显示屏显示“P=C或P=E”，并不断闪烁，此时按打印键就会把检测结果打印出来。“P=C”表示打印中文、“P=E”表示打印英文，按功能设置键到显示“P=C或P=E”时，按灵敏度的上下键可以选择。

Print settings: the same Function keys to the display shows "P = C or P = E", and constantly flashing, press the print button at this time test results will be printed. "P = C" that means the Chinese print, "P = E" that print in English, press Function keys to display "P = C or P = E", according to the sensitivity arrow keys can choose from top to bottom.

4、检测标准设定，同样按功能设置键到显示F=0.5、或F=0.8……此时按上下键选择检测标准，例F=1.0表示该机的检测标准为 $F_e = \phi 1.0$ 的钢珠大小。从F=0.5到 $F_e = 4.0$ 共十一级可供不同检测需要设定。

Testing standards settings: by the same Function keys to display  $F = 0.5$ , or  $F = 0.8 \dots \dots$ . At this time press arrow keys from top to bottom to select the testing standards,  $F = 1.0$  means that the testing standards of the machine is  $F_e = \phi 1.0$  of the steel ball. From the  $F = 0.5$  to  $F_e = 4.0$  for a total of 11 detections supplied for different needs.

5、按启动/停止键启动机器，根据需要按功能设定键选择“b”或“c”型，显示屏左边会显示您选择的状态。若被检物高度小于 2cm 时请一定选“b”型，否则机器误以为没有被检物，将不会报警工作，切记。若被检物高度大于 2cm 选“b”或“c”型均可。按计数切换依次选择“合格”“检出”“总数”，并有相应指示灯点亮。

Press Start/Stop key to run the machine, as required press Function button to select "b" or "c"-type, the screen will show you choose on the left side of the state. If the height of the product to be detected less than 2 cm, please select "b" type, or the machine will take it as nothing for mistake, the alarm will not work. If the height is more than 2 cm, both "b" or "c"-type can be selected. Counting by switching select "qualified" and "checkout" and "total" and the corresponding indicator light up.

6、计数的清零：在待机状态下按动计数切换键选择好需要清除的对象，按住计数切换键不放，等到显示屏上数字开始闪烁后放开，然后再按一下计数切换键就清除了该选项。

Clear the count: in the standby state, press the count switch key to clear the target, hold the count switch key, wait until the figures begin flashing on the screen, then release, click count switch again to eliminate it.

7、自动/手动键的使用：该键是选择全自动启动和手动启动。在自动状态下，报警输送带返回后能自动启动，无需再按启动键。

The use of Automatic/Manual key: the key is to choose start automatic or manual start. In automatic mode, once detected, the conveyer belt will stop automatically and reverse automatically, it's no need to press the start key again.

8、位置显示能准确显示断针的大致位置，方便工人能快速用小型手持式检针器找出断针。

Location broken needles accurately, so workers can quickly find out the broken needles by using small hand-held needle detector.

9、在自动状态下，机器特设有保护电路，十分钟内无被检物将自动停机进入待机状态、起到节电和延长机器使用寿命。在手动状态下无此功能，需要人工关闭。

In automatic mode, the machine possesses protection circuit, without the product to be detected within 10 minutes, it will automatically go into standby status, which can save power and prolong machine life term. In the manual state, the machine needs to manually shut off.

## 六、技术标准和原理 Technical Specification & Working Principle

### 特定标准 Special Standard

对于检针仪器的生产技术、质量标准，国内尚属空白。因此，技监部门无依据对生产企业进行监督检查。在此情况下，我司本着对市场、客商负责的原则，根据多年实践数据，并参照日本国立法检测标准，我们起草起草发布了生产制造检针仪器的企业标准，送地区技监局审批备案，批号为：Q/SS001—1999。

In terms of the production technology and quality inspection standard for needle detecting machine, no research has been carried out in this field. Therefore, Technical Inspection Department doesn't have the set regulations when examining and checking production plants. Under such circumstance, the company, to take responsibility for customers, has drafted the enterprise standard for needle-detecting machine producing companies with our long years of working experience and Japanese national legislation on inspection standard for reference for approval of Regional Technical Inspection Bureau as well as set the record with the NO: Q/SS001—1999.

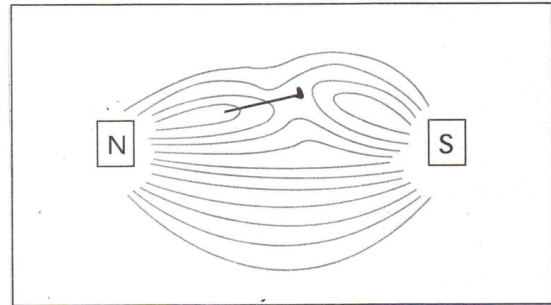
### 基本技术参数 Basic Technical Parameter

项 目 Project	ZS-600A	ZS-600B	ZS-600C	ZS-600D	ZS-600E	ZS-600F	客户定制 Customized
额定电压 Rated Voltage	AC220V 50HZ ± 10%						
耗功率 (W) Power (W)	<150W						
检测宽度 (mm) Detection Width (mm)	600						
检测高度 (mm) Detection Height (mm)	100-130	150-180	200-220	250	300	350-400	
检测能力 (铁球Φmm) Detection Capacity (Iron Ball Φmm)	Φ1.2Fe	Φ1.5Fe	Φ2.0Fe	Φ2.5Fe	Φ3.0Fe	Φ3.5Fe	
连续速度 (m/min) Continuous Velocity (m/min)	24						
外形尺寸 (长*宽*高) mm Measure (Length*Width*Height)mm	1800*1050 *900	1800*1050 *950	1800*1050 *1000	1800*1050 *1050	1800*1050 *1100	1800*1050 *1200	
重量 (kg) Weight (kg)	220	225	230	235	240	280	

## 原理 Working Principle

在静磁界中，一旦被断针或铁质物体通过，引起磁场被切，磁场波动信号经放大后，导致电力冲击，指令声光报警。

In static magnetic field, the broken needle or iron matter pass and it will cause magnetic field confusion. The magnetic wave signal is magnified, which leads to electric shock, and thus sound warning.



## 七、常见故障与排除方法 Problems & Solutions

故障现象 Phenomenon	原因 Cause	排除方法 Solution
<p>C 型状态下：开机后，感应度红色信号灯跳动闪亮。</p> <p>B 型状态下：不放物品，开机后会报警停机。</p> <p>Under Type C: After starting, sentivity red signal lamp flashes.</p> <p>Under Type B: Without load, the machine send out warning and stop running after starting.</p>	<p>1、外界干扰</p> <p>2、输送带脏物</p> <p>1. Outside Interference</p> <p>2. Dunghill on conveyer belt</p>	<p>1、观察周围，上下有无铁制品移动（如吊扇），新安装设备离机太近。</p> <p>2、参照说明书，机器上的标贴清洗输送带。</p> <p>1.Check if there are iron matters (sling fan for instance) moving around, or newly installed equipment is too near and beyond the safety distance.</p> <p>2.Refer to the instruction as well as the mark on the machine, and clean the conveyer belt.</p>
<p>开机后有响声出现。</p> <p>There are strange sounds after starting</p>	<p>紧固件松动，润滑不良。</p> <p>Parts loosened and parts need to be lubricated</p>	<p>1、电机紧定罗柱用十字起子紧固。</p> <p>2、皮带防偏滚轮加少许缝纫机油。</p> <p>To prevent belt slanting, add some sewing machine oil to the idler wheel.</p>
<p>通电后机器不能启动。</p> <p>Can't start the machine after turning on the power.</p>	<p>1、电源接触不良</p> <p>2、按钮、电机、电容损坏</p> <p>3、电源电压过低</p> <p>Bad connection. There are something wrong with pushbutton, motor and capacitor.</p> <p>Power supply voltage is low.</p>	<p>检查电源接插是否良好，更换按钮、电机、电容。</p> <p>To check if the power connection is ok, change pushbutton, motor and capacitor.</p>
<p>报警声发出后，机器继续运转，不停机。</p> <p>After machine sends out warnings, the machine continue to run without stop.</p>	<p>1、继电器故障</p> <p>2、信号报警系统故障</p> <p>3、电源电压过低</p> <p>Relay failure. Signal warning system failure. Power supply voltage is low</p>	<p>1、打开电箱盖，两只继电器对调试机，更换继电器。</p> <p>2、通知供应商售后服务处请求排除。</p> <p>1. Lift the box lid, try to exchange the two relays, or change relay</p> <p>2. Inform supplier aftermarket service for help</p>
<p>C 型状态下：开机运转后，感应度红色信号灯持续点亮不灭，并且放置检测块测试无反应。</p> <p>Under Type C: After starting, sentivity red signal lamps keep on, and have no reaction when put products on.</p>	<p>1、轴承磁化</p> <p>2、信号感应电路控制系统故障</p> <p>1. The shaft is magnetized.</p> <p>2. Signal sensing circuit control system failure</p>	<p>1、更换轴承</p> <p>2、通知经销商</p> <p>1. Change the shaft.</p> <p>2. Inform the supplier.</p>
<p>机器一切正常，有些检品能通过，有些检品则不能通过。</p> <p>The machine is ok but some product can pass inspection while some others fail.</p>	<p>原材料中带铁分子成分过浓。</p> <p>There is too much iron molecule in raw materials.</p>	<p>1、根据检测标准下限，降低机器灵敏度。</p> <p>2、减少输送带上投放数量。</p> <p>Lower the machine sensitivity in terms of the floor level of inspection.Reduce the number of products to be inspected on the conveyer belt.</p>