

# GLOBAL

**PFA - 03**

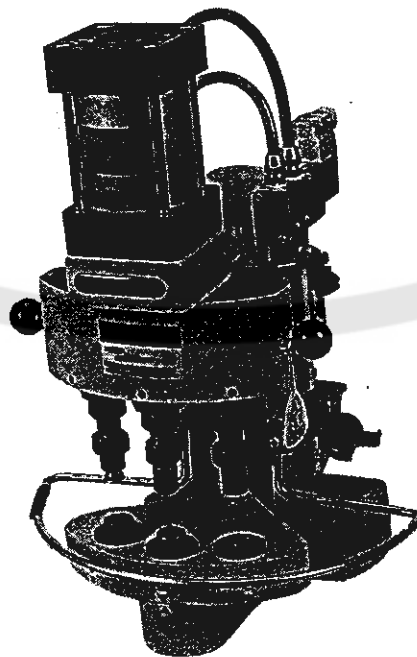
**PFA - 12**

**PFA SERIES PNEUMATIC MULTI-HEAD BUTTON  
ATTACHING MACHINE**

## **INSTRUCTION MANUAL**

**Environment-protecting Energy-saving  
Secure Efficient  
headmost of Button Nailing Machine**

**Foremost  
Patent**



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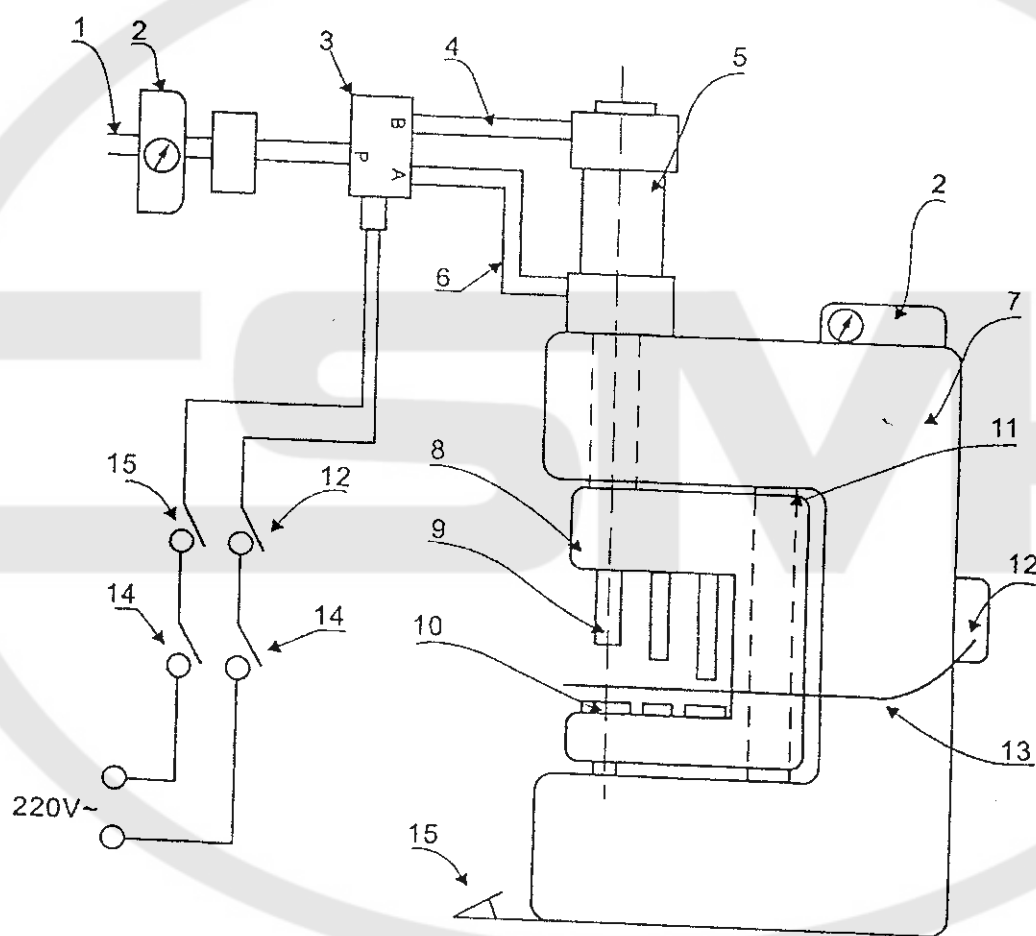
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## ATTENTIONS

- 1 . Reading carefully before operating;
- 2 . No step on the footboard while installing button;
- 3 . After operating or when suspending,  
power off and cut off the air-fountainhead;
- 4 . The product is protected by Chinese National Patent;  
Patent Number: 200320108090.3.

Attached Figure



- |                      |                         |                           |                         |
|----------------------|-------------------------|---------------------------|-------------------------|
| 1 . Air-fountainhead | 2 . Decompressing-valve | 3 . Electromagnetic valve | 4 . Air-conducting pipe |
| 5 . Air cylinder     | 6 . Air-conducting pipe | 7 . Machine body          | 8 . Revolving part      |
| 9 . Stretch head     | 10 . Stretch mold       | 11 . Revolving axle       | 12 . Security switch    |
| 13 . Bumper bar      | 14 . Chief valve        | 15 . Footboard            |                         |

### Uses:

PFA Series Pneumatic Multi-head Button Nailing Machine is applicable for all sorts of clothing (like knit coat, down jacket, jeans) shoes, hats, plastics, canvas, leather etc. The product can be installed with several sets of heads and molds and can be easily shifted, which is designed for nailing different button dimensions. With adjusting the decompressing-valve, special buttons or clothing of different thickness are also suitable. The button is nailed firmly and the colour on plating layer will not be damaged. It conforms with high quality requirements.

### Main parameters & Model instruction:

Working atmospheric pressure : 0~0.8Mpa

Frequency : 45times / min

Power voltage : 220V

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① ② ③ ④

- |                 |   |
|-----------------|---|
| 1. Factory name | 3. Number of stretch heads & molds(01-12) |
| 2. Pneumatic    | 4. Diameter of air cylinder (63.80.100)   |

### Structure Summary:

As the figure shows, put through the air-fountainhead 1, regulate the decompressing-valve 2, power on, close the chief valve 14 and press the bumper bar 13 to put through the security switch 12. Now buttons can be installed onto the stretch mold. Then step on the footboard 15, the electromagnetic valve 3 starts working, and the air-compressing container B moves into the upper part of air cylinder 5 with the air-conducting pipe 4. The axle of air cylinder moves down with the stretch head 9 to match together to the stretch mold 10. Then buttons are nailed and kept with pressure. After all the above has done, relax the footboard or the bumper bar to break off the security switch, power off. The electromagnetic valve is ready for re-start. The air-compressing container A moves into the lower part of air

cylinder with the air-conducting pipe 6 . Then raise the axle of air cylinder and the stretch axle is ready for another Working procedure.

If the customer demands other types of button, just change the set of stretch head and mold.

### Operation & Adjustment:

Operation : Shift to suitable gear → Install buttons → Put clothing in correct place → Press the bumper bar → Step on the footboard .

Adjustment for the space between stretch head and mold: Screw the mold bar till its top → Power on & put through the air-fountainhead → Press the bumper bar & step on the footboard → Screw the mold bar to suitable position → screw the connecting nut tightly.

Adjustment for the atmospheric pressure : Put through the air-fountainhead → suitably adjust the decompress → valve (usually 0.4 -0.6MPa)

### The attachment

- 1 . One piece of qualified certification,
- 2 . One operation manual,
- 3 . One machine shelf.