

STRAP TYPE CUTTER
MODEL: HA-SZD700
-SZD900
-SZD1200

INSTRUCTION MANUAL

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Basic Illustration

We thank you for your purchase of our Strap Type Cutter.

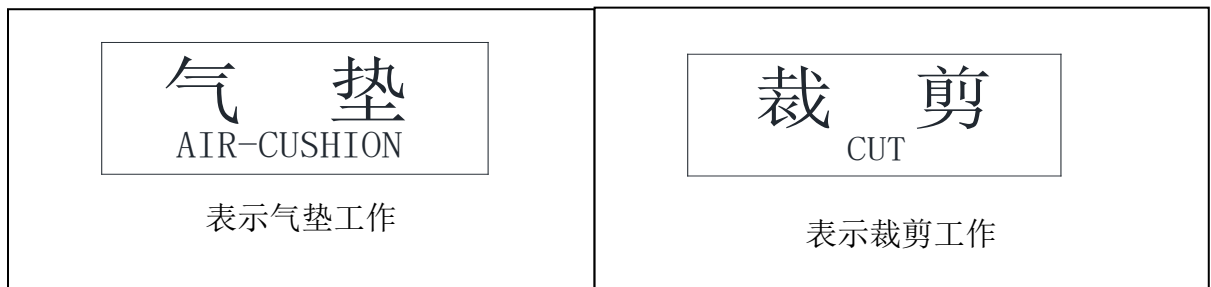
- 1、 This specification describes the safety warning, product features, technical parameters, structure features, installation, operation, maintenance and debar ways, etc.. In order to ensure that you are effectively using this machine, please refer to the manual carefully before use, and properly keep the instructions for use, for future reference.
- 2、 Non professionals are not allowed to electrical installation and repair.
- 3、 The machine noise less than 70 decibels
- 4、 This machine can use the forklift when transport process
- 5、 Before starting, check whether the power supply voltage and frequency same as nameplate, the power connection is reliable, bonding circuit is safety.
- 6、 Keep safty when use brand knife.
- 7、 The user must wear safety wire gloves to operate the machine

Description Of The Warning Label:

DANGER



ILLUMINATE



Summarization

HA-SZD700-1200 stype type cutter(picture 1) is a large efficient cutting machine for cloth and various material. Use of the rapid ribbon cutting knife, stacked to the thickness of the 150~200mm for cutting into pieces. Apply to large and medium-sized garment manufacturers cut cotton cloth, woollen, linen, silk, synthetic leather cutting and cutting, and also applies to small knitwear and clothing material cut.

Our company product of HA-SZD700 stype type cutter, With stable performance, simple structure, sturdiness and durability, and power consumption Province, low noise, the advantages of energy saving and environmental protection, welcomed by the overwhelming majority of users.

Characteristics

After the main motor of this drdecelerating through driven by one-rank V-type ,drive the driven- wheel(down-conveyer belt) under the drive-worktable , have this machine to gain the certain incision-speed , which the band-type cutter is installed and stretched tightly on the upper&down driven-wheel and right driven-wheel, impel the cutting-materious to move by the line which it is prescriptive to the cutting-parcel , and reach the purpose of needful cutting-parcel for incising. It is adjustable to the place of right driven-wheel, there is tension- adjust device in the back-side of the right driven-wheel, turn the adjust- handwheel that have the right driven-wheel to move in left (loose) or in right (splay), can adjust the degree tension of of band cutter to adapt different cutting-materious.

There are abrading-knife device and band-knife nip device.the abrading-knife is in the grinding wheel box for special installing, it make up of parts of fixed-axes,pulling-table base, brace,handle-stem,adjust-bolt, grinding wheel, spring ,etc. when finishing in the factory,it is proper adjustable that pulling-table base is in the place of fixed-axes, and also the open-close of the place of grinding wheel axes and the comparative place of pulling-table base.push the handle-stem for moving fore-and-aft to drive pulling-table base forward or backward by the transmission-power of brace, have the grinding wheel in the pulling-table base to lean against band knife-edge forward (or backward), have band knife between the grinding wheel to drive the grinding wheel for circumrotating by the high-speed-movement itself that engender grinding & paring movement between knife-edge and blade for sharp-cut blade that keep the band knife sharp-cut same as the fresh.

The band-knife nip device is under the abrading-knife device. Screw

loosely the firmly bolt with nip-stem to adjust the nip device and protection- clasp, keep the precise direction of band knife to have it to prevent breaking off in the course of cutting working.

The characteristic of this machine also have the air floating function. Start the fan (burble- air pump)on the machine base, feed the high-pressure air into the air-room in the working table,it can form the air floating between the table and cutting materious,because the gravitation of cutting materious by itself can press the ball-bearing in the nozzle which there are in equality- rank 200 pcs of nozzle in the working table, reduce the friction between the cutting materious and working table, so the up&down layer of cutting materious do not easily lean the direction for improving the precision of cutting and also reduing labour' intension of working!

Main Technique Parameter:

Model	HA-SZD700	HA-SZD900	HA-SZD1200
Available width of right-side of band kinfe (mm)	700	900	1200
Height of cutting(mm)	180	180	200
Spray air pressure(kPa)	12	12	17
The power of motor of cutting machine(kW)	0.75	0.75	0.75
The power of fan(kW)	0.25	0.37	0.55
The spped of band knife line(m/min)	14; 15; 16.4	14; 15; 16.4	14; 15; 16.4
Band specification(mm)	0.45×10×3500	0.45×10×3860	0.45×10×4560
V-type belt specification (mm)	A-1067	A-1219	A-1549
Working table specification(mm)	1200×1400	1500×1800	1500×2400
Outline size(mm)	1920×1200×1614	2340×1500×1620	2950×1500×1665
Weight(kg)	~190	~203	~300

Machine Picture And Instruction



PICTURE1: HA-SZD700/900 STRAP TYPE CUTTER

1:protection cover (upper driven wheel); 2: abrading-knife device ; 3: handle-stem ; 4:band kinfe nip device
5: band knife ; 6:air floating working table ; 7: assist-supporting stick ;
8 : down box (down driven wheel,motor,etc) ; 9:multi-wheel ; 10: protection cover (right driven wheel)
11:tension adjust handwheel ; 12:switch ; 13: bottom screw



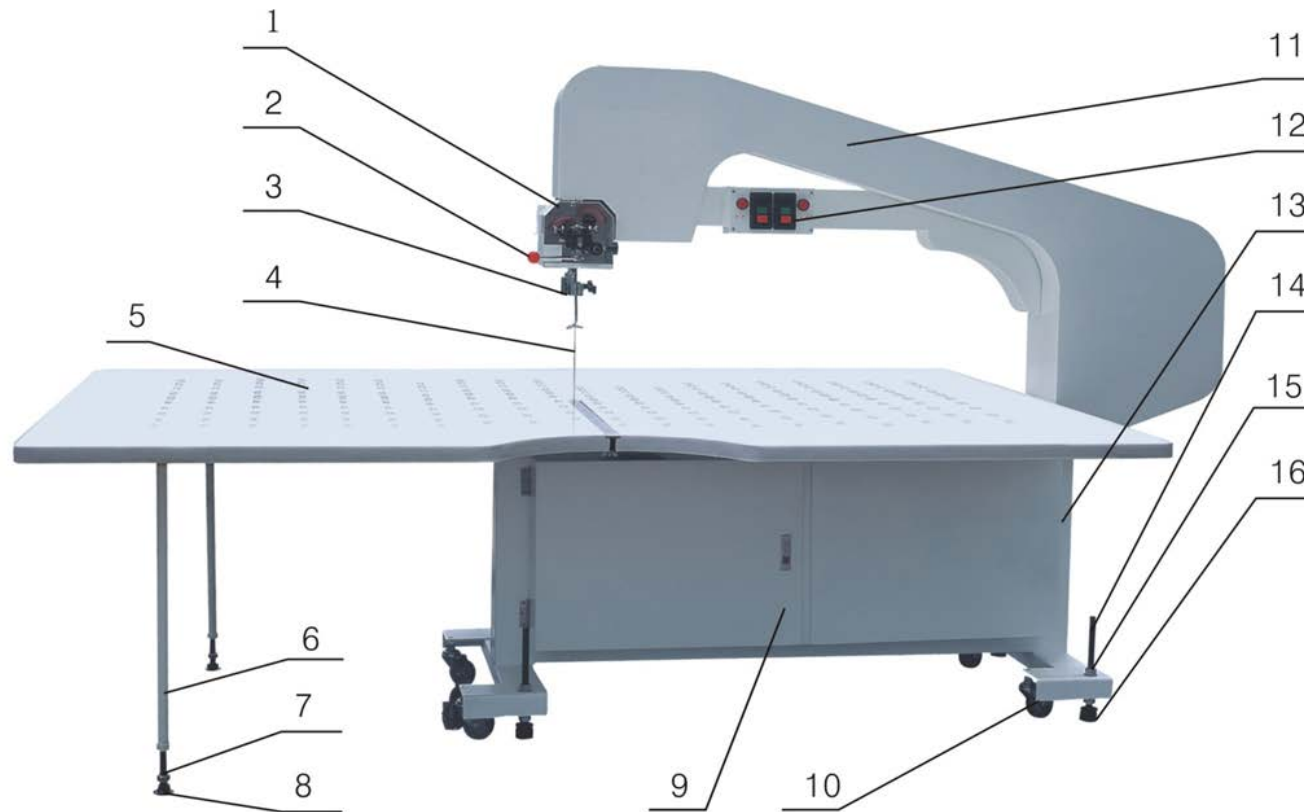
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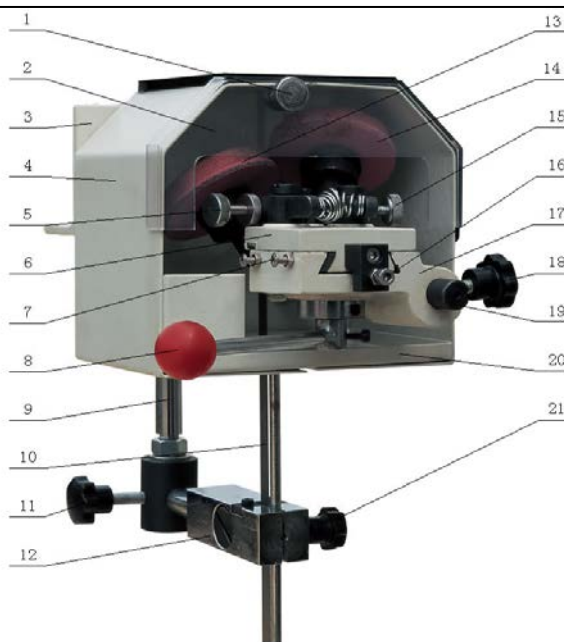
HA-SZD1200 STRAP TYPE CUTTER

1、 abrading-knife device; 2、 handle-stem; 3、 band knife nip device; 4、 band knife; 5、 air floating working table;
 6、 assist-supporting stick; 7、 locknut; 8、 adjusting staff; 9、 down box (down driven wheel,motor,etc); 10、 wheel; 11、 protection
 cover ; 12、 switch; 13、 Underframe; 14、 adjusting supporter; 15、 locknut; 16、 bottom screw



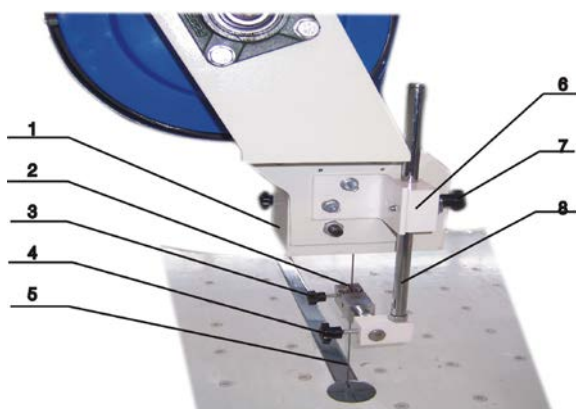
- 1、 right drive wheel bearing box
- 2、 right drive wheel and shield
- 3、 handwheel

PICTURE2: BAND KNIFE TENSILITY ADJUSTMENT DEVICE



- 1.watching-mirror fixed bolt;
- 2.safety watching-mirror;3.fixed foot-hoof of grinding wheel;4.grinding wheel box;5.adjusting bolt and screw-nut of bracket of leftgrinding wheel;
- 6.pullingtable;7.adjusting bolt and screw-nut of iron- plug of pulling-table
- 8.inlet-knife handle-stem;9.rise-fall stick of band knife nip device;10.band knife
- 11.screw-nut of front&back direction of band knife nip device;12.band knife nip device
- 13.left grinding wheel;14.right grinding wheel
- 15.adjusting bolt and screw-nut of bracket of right right grinding wheel
- 16.point adjusting bolt and screw-nut of pulling-table;17.pulling table base
- 18.screw bolt of pulling-table base;19.fixed axes;20.grinding-bit tray of grinding wheel box
- 21.screw bolt of protection clasp

PICTURE3: ABRADING-KINFE DEVICE AND HAND-KNIFE NIP DEVICE



- 1.abrading-knife device and grinding wheel box
- 2. band knife nip device
- 3. screw bolt of protection clasp
- 4. screw-nut of front&back direction of guide implement
- 5. band knife
- 6. band knife nip device seat
- 7. screw-nut of up&down direction of guide implement
- 8. regulate pole of up&down direction of guide implement

PICTURE4: HAND-KNIFE NIP DEVICE REGULATE ORGAN

Installation Way:

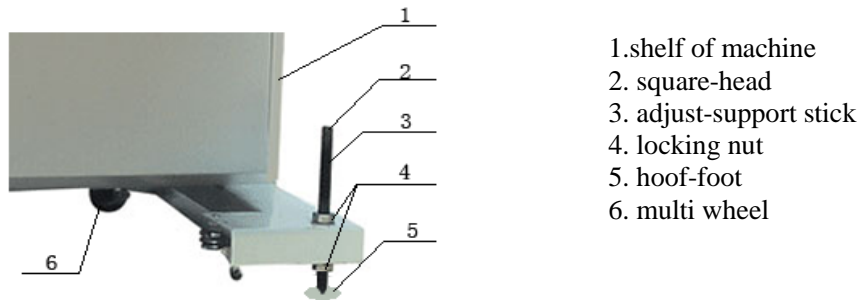
1、 setout : there are 4 multi-wheel and 4adjust-support stick on the 4 angle in the botttom of machine shelf in this machine.(picture5)

(1)setout on the installation place by pushing the machine.

(2)loosen the two locking nut of each adjust-support stick with spanner,turn and adjust square-head apex of adjust-support stick to have the hoof-foot to support on the ground, which the hoof-foot support the down-body of whole machine.

(3)gradully adjust height which the 4 angle support, have the working table to adjust the necessary height that is so close the stste of horizon-line.

(4)finishing the adjuston, re-screw tightly the locking nut on the each screw-stick



PICTURE 5: ADJUST SUPPORT

2、 installation of working table(picture 6)

(1)take out the working table from packing box, first disassemble the table-clamp-board in the middle of table that first revolve loosely butterfly-nut, then disassemble the table-clamp-board.

(2)have the working table to lay aside on the shelf of machine that have the bolt of fixed base of the bottom board to install in the 4 piece of corresponding hole of shelf of machine.

(3)have the nut of 4 piece of fixed base in the working tabkle(fixed the direction when finishing that in factory) to osculate the machine at the same timefor the uprightness between table and band knife, and make it exact between the band knife and circular slot-board of band knife (in before, back,left and right)

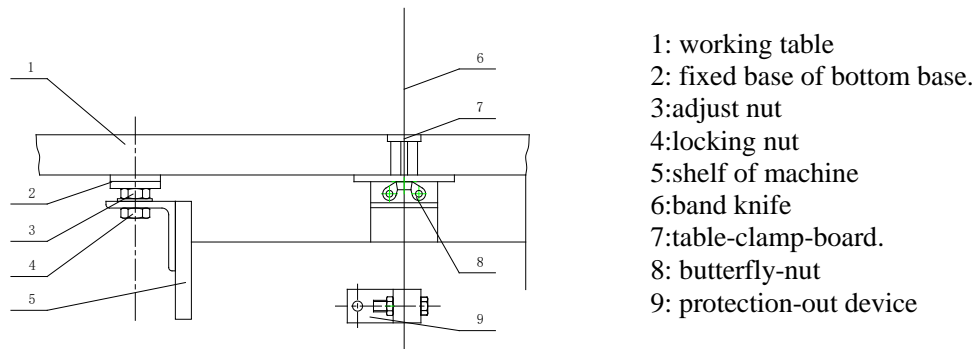
(4)take out 4 piece of gasket and locking nut to place it into the bolt in the bottom board of base and screw tightly to make the table fixed.

(5)install the table-clamp-board and screw tightly the butterfly-nut. If do not install the band knife, should finishin installation of that before the step.

(6) Connect the air hose of the fan and wind-duct joints which below platen.

(7) Since the switch box will be used in the attack screw fixation plate lower right

Note: the uprightness between table and band knife is most important in order to guarantee the quantity of cutting materials. If the installation is not by precise require that do not guarantee the quality of cutting materials.



PICTURE 6: INSTALLATION OF WORKING TABLE

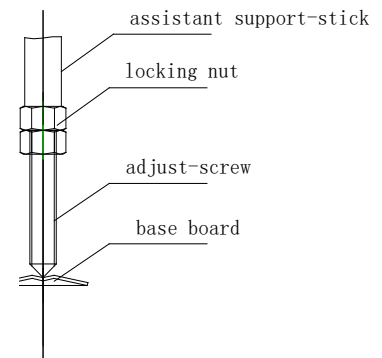
3、 Installation of assistant support-stick (picture 7)

(1) revolve loosely the locking nut of discreteness of f assistant support-stick.

(2) Rotation adjustment screw with wrenches to adjust the internal screw fastening all supporting bar, it's highly appropriate to shorten.

(3) force the bolt to revolve and enter under working table, make the assistant support-stick with flange and working table fixed.

(4) Will regulate the screw at the bottom of the cone angle plate centre, using wrenches to adjust screw fastening, shoring it good plate maintain standards. Finally at the end of an appropriate adjustment will screw and pin supporting bar, and with locking nut



PICTURE 7: ASSISTANT SUPPORT-STICK

4、 installation of electrical source wire

(1) put the electrical source wire to connect with isolation switch which is 3phase, 380v (own by customer), and connect with the protection- earth-wire.

(2) after being electricity, press the "sartup" of "cutting" button, checkout whether it is correct that the direction of band knife move downwards to the circumvolving-direction of motor (band knife). If the opposite direction, should cut off the power-supply and make the circumvolving-direction corect by exchanging tie-in of arbitrary the two phase-wire (front line).

5、 installation of band knife:

(1)circlemove and take out the bolt above the safety waching-mirror, disassemble the transparent safety-mirror.

(2)screw loosely the tension-bolt with cross circle-tool of bolt,disassemble orientation-protection-cover of fixed axes in the right-down direction of grinding wheel box.

(3)screw loosely tension-bolt with rubber-wood handle-wheel, take out and get the pilling-table and grinding wheel discreteness in the abrading-knife device.

(4)take out abrading-bits tray in the bottom of grinding wheel box.

(5)loose locking nut on the handle-wheel screw of right driven wheel tension-device of protection-cover,then revolve the handle wheel for loosing tension-device(move leftwords)

(6)if the installation being to the table clamp-board on the working table,etc,should d disassemble these accessorys , then restore that until the installation of band knife being.

(7)screw loosely the tension bolt with rubber-wood wheel under the band knife nip device ,,first take out protection-clasp of protection-blade under the nip device.

(8)lift the protection-cover to install the band knife on the 3 piece of driven-wheel.

(9)revolve the the rubber and wood wheel of the band knife tension device, properly tighten the band knife to make the tension strength of band knife to keep state in order. Note;if the tension strength of band knife is too strong or too weak, it will make the band knife to rupture eaasly or to deviate form driven-wheel.

(10)renew gradully from (8) to (1) by the above approach of opposite procedure.

6、 installation and debugging of abrading-knife device:

When it is in factory, the it is already to the : installation and debugging of abrading-knife device.if the user want to install the band knife by oneself, already tell clearly the way to installioand procedure. The following is the way of debugging.

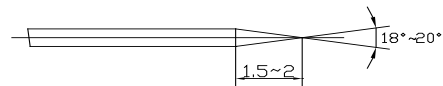
(1)pull the handle-stem to have the pulling table with grinding wheel to move onwards in order to have the grinding whee to osculate the band knife that can abrade the blade properly.when handle-stem can't have the grinding whee to not osculate properly the most close place, then should loose the locking nut of inner hexangular bolt on the frontal baffle of pulling, it is proper to adjust the inner hexangular bolt approaching easily band knife and grinding blade . at last , screw tightly the locking nut.

(2) if pulling the handle-stem and have the pulling board to reach the inner place , do not grinding the knife , should adjust the two place of protecting-cover on the place-axes (fixed axes) of pulling board, that loose the locking nut on inner & outer the two protecting-cover with crossing-bolt revolve-tools, properly adjust its place inwards(or out

outwards) to have pulling-board to be I proper place. At last screw the pulling-board with locking-bolt.

(3)should put properly the blade in the middle with the wedge of 18 degree –20 degree and symmetry of left and right, the length (the touching place between grinding wheel and brand knife)of wedge is about 1.5mm (picture 6). If symmetry of sparkle is, which happen on the grinding between left and right grinding wheel, indicate the abrading of knife is normal. This angle is most important, it can have the blade to gain the shape effect. Proofreading the angle of two grinding wheel,, should loose each pices of locking nut of adjusting-bolt on the supporting- bracket of grading wheel(each of left and right, on number 5 and 15 on the picture 2),adjust properly the orientation and angel of two left and right grading wheel by screwing nip-stem of rolling-bolt by hand to have properly symmetry of blade is. At last screw the locking-nut tithtly.

(4)as the growth of using time, the band knife is abrading gradually, it is necessary to adjust and push gradully the place of grading wheel inwards, the procedure of adjusting is by 1 step to 3 step. At last , put the opposite place of grading wheel and band knife to be in proper place of blade. This can either have the band knife keep sharp state , or have the band knife to reach the longest life for preventing the effect which it is too fast to abrading even breaking off.



PICTURE8:THE BLADE OF BAND KNIFE

(5)it is not long to the distance which the cutting materials is close band kinfe nip device and protecting-clasp, generally properly less than 5mm.

(6) Band kinfe nip device and protection from the hook above the distance between the cutting should not be too general to ≤ 5 mm suitable.

(7) When the thick-cut fabric and if nylon canvas fabrics such as tenacity, but also adjusted accordingly Daidao the tension of the strip more stretched even tighter, so that would be more sharp for band knife.

Using Way:

After finishing installation and necessary debugging , should start the machine:

Press ON of red button on the cutting switch, the band knife start run. Oppositely, to OFF to indicate stop.put the cutting material on the working table, then press ON of air floating , the fan start run to spry the air flow to form air floating. Indicate the cutting work is on.

1、 adjustment of band knife line speed:

(1) Different cutting materials and different speed to this. There is a tower-type belt wheel of installation in the motor and driven wheel, which have 3 kind of different speed, the corresponding point is 11.0, 12.25, 13.35m/sec. it can change place of V-type belt on the belt wheel to change the speed of the band knife line.

(2) when cutting the chymistry –fibre materious ,such as nylon, the speed of band knife should be the lowest kind of speed(about 11m/sec).it is necessary to reduce (loose)the tension degree of band knife, or add some silicon-oil and olefin to improve the cutting-quality. Prevent the cutting materials to melt and adhibit, even can't cutting!

(3) to the common calico, should choose middle degree speed, about 12.25m/sec(V-type belt in the middle of groove). If use more faster speed to cut, the faster speed is better.

(4) when cutting thick materials and nylon baggage , canvas, which belong to tough materials, it is necessary to adjust the tension-degree to have steel belt spread more tightly , thus, the band knife is more shaper!

2、 Common maintenance :

(1) lubricate: there are 4 pices of axes of driven wheel of band knife (ball axes of outer sphere with square-type base), which is separately the two end of up and right driven wheel axes. There is a oil-nozzle on square-type base, should immit II industrial lithium-lubricate grease stipulated accordance with SY/412 < lithium-lubricate grease> every half year. The immit-amount is not enough , usually 70% filled in inner-antrum of axes-support.

(2) maintenance : clean the dust attached the machine once a week, in abrading-knife device, the inner grinding wheel should be keep clean, at least clean the dusty once a week. Note: clean out the rubbish in the abrading-plate of grinding wheel and keep cleanness.

(3) adjuston : in time adjust the speed, degree of tension of band knife by different quality of cutting material , height of cutting of circs, etc., and adjust properly the abrading device to keep the band knife sharp as the fresh, it is also necessary to adjust properly the weight and direction of band knife nip device. To keep the cutting machine most state to high efficiency of working , effective quality of working and long of using life, the way of adjusting is above telling.

(4) the nozzle of working table should be cleaned necessarily in order to block for reducing the function of air floating.

3、 Safety notice:

(1) when installation of band knife , ples cut off the power, should operate with stainless steel-net glove-cover for preventing hurt the hand.

(2) it is not overpass 5 second for abrading time, and exit the grinding wheel for preventing the faster of abrading- tamper of band knife.

(3) should put the band knife nip device and protecting-clasp on the working table when the machine is off.

(4)when the abrading- tamper of band knife is under 7mm , should replace the new band knife.

Common Malfunction And Debar Ways

Malfunction phenomenon	Reasons	Debar way
The motor don't move	The press-button switch not turn-on	back-check, repair. Or replace it
	The power supply 's link have a malfunction	back-check the switch ' connection and rework it
	The motor have a malfunction	back-check, repair. Or replace it
The band knife part	The band knife 's tensility is too big	Adjust the tensility of the band knife
	The band knife is not tartness	The band knife to be abrade use appropriate grinding wheel
	The band knife is to be fray	Replace new grinding wheel or band knife
The knife-edge of band knife is wavilness	The tensility of the band knife is not enough	Adjust the tensility of the band knife
	The grinding wheel is to be librate	Replace new grinding wheel
	The oriented axletree is not adjust well	Adjust the clearance between the strap knife and the oriented axletree
The band knife is brush off from the transmission wheel	the tensility of the strap knife is not enough	Adjust the tensility of the strap knife
	The burthen of cutter is too big	Adjust appropriate burthen of cutter
	There are cloth dust between the strap knife and the transmission wheel	Clear up the cloth dust
The band knife is fore-and-aft wiggle	The weld of band knife is not unknit	newly weld the band knife
	The rubber of bandp knife is broken	Replace the transmission wheel
The band knife is	The tensility of the band	Adjust the tensility

wiggle around	knife is not enough	of the band knife
	There are cloth dust between the band knife and the transmission wheel	Clear up the cloth dust
	The metal strip knife-edge 's point of view is not very well	Adjust the point of view and newly abrade the strap knife
The cutter is not very good	The band knife pace is too slow	Improve the pacing
	Beyond the burthen to cut	Adjust the burthen of cutter
	The knife-edge milling is not good	Newly abrade the strap knife
	The point of view of strap knife edge is not good	Adjust the point of view and newly abrade the band knife
The enginery is wiggle	The enginery is not install in the horizontal place	Adjust The enginery place
	the three-cornered adhesive tape is to fray	Replace the three-cornered adhesive tape

Machine Packing List

Model: HA-SZD700/900/1200

Name: Strap Type Cutter

The cartons should be packed with the following items:

NO.	NAME	UNIT	QUANTITY
1	Packing list	SHEET	1
2	HA-SZD700/900/1200 Strap Type Cutter	SET	1
3	Operating Instruction	PIECE	1
4	Manufacturer Certificate	PIECE	1
5	Product Quality Information Feedback Sheet	SHEET	1
6	Warranty Card	SHEET	1
7	Parts box list,Include:	BOX	1
7.1	Steel 0.45×10×3500 (3860、4560) mm	PIECE	1
7.2	Sharp PA120#Φ69×Φ66×Φ8×13mm	PIECE	2
7.3	Two Head Wrench 8—10mm	PIECE	1
7.4	Two Head Wrench 12—14mm	PIECE	1
7.5	Two Head Wrench 17—19mm	PIECE	1
7.6	Inner Six Angle Wrench 5mm	PIECE	1
7.7	Inner Six Angle Wrench 8mm	PIECE	1
7.8	Cross Shape screwdrivers100X6mm	PIECE	1
7.9	Self Tapping Screw 4.2X15	PIECE	1

Packing Inspector: _____

Packer: _____

Packing Date: Year Month Day