

GLOBAL



SK 109

Trimming machine for inner lining & sole

**INSTRUCTION / OPERATING MANUAL
PARTS MANUAL**

A. CAUTION

1.

Before wiring the machine to power sources, check whether the motor voltage/phase/wire connection are the local used. To change the voltage and turning direction, please follow the circuit diagram shown on the motor.

2.

For the direction of turn of the motor. Please refer to the red arrow head marked on the NO.27 grinding wheel cover at the rear of the machine.

B. SUPPLEMENT OF OIL

During operation, #40 lubricating oil should be added regularly through the red-marked places at the machine.

C. POSITION OF THE OPERATOR

1. The operator situate himself at the front of the machine

2. The work piece should move from right to left.

3. Referring to the condition of product trimming spew, keep a proper trimming angle with the upper cutter.

D. ADJUSTING POSITION OF PRESSING LEG NO.47

1. The work piece, stationed between pressing leg NO.47 and under cutter NO.93 should easily pass through during trimming of the product (such as shoe sole apews and its inner lining).

D. ADJUSTING POSITION OF PRESSING LEG NO.47

2. If the pressing leg NO.47 is too low, work piece would not be clean cut. If its too high, work piece would be badly cut off easily.

3. Turning screws NO.30, 31 to adjust the height of pressing leg NO.47.

After adjustment, tighten NO.31 screw cap

E. SHARPENING UPPER CUTTER NO.71

1. Release screw NO.48, move pressing leg NO.47 to the right.

2. Release screw NO.39, remove upper cutter plate NO.38 and upper cutter NO.71

3. Place upper cutter NO.71 on the grinding frame NO.37, located at the rear of the machine, with blade facing downward, constantly slightly touching grinding wheel NO.8. time of touch should be as short as possible to prevent burnt, water covered be added too.

4. After completion of grinding, use smooth grade stone to rid of the spew from the blade, the touching blade side of upper and under cutter should be grind level too.

5. Grinding frame NO.37 can be adjusted up-down, left-right to meet the angle of the upper cutter.

F. INSTALLATION OF UPPER CUTTER NO.71

1. Put upper cutter NO.71 into NO.36 cutter bar groove, to fix NO.38 upper cutter plate, slightly turning screw NO.39, then turn the plastic wheel NO.11 at the rear of the machine to allow cutter bar NO.36 to drop to its lowest point, adjusting the distance from the upper end angle of upper cutter NO.71 to the under cutter NO.39 is 0.5mm-1.0mm, then tighten screw NO.39.

F. INSTALLATION OF UPPER CUTTER NO.71

- 2. Return pressing leg NO.47 to its position, and tighten screw NO.48.**

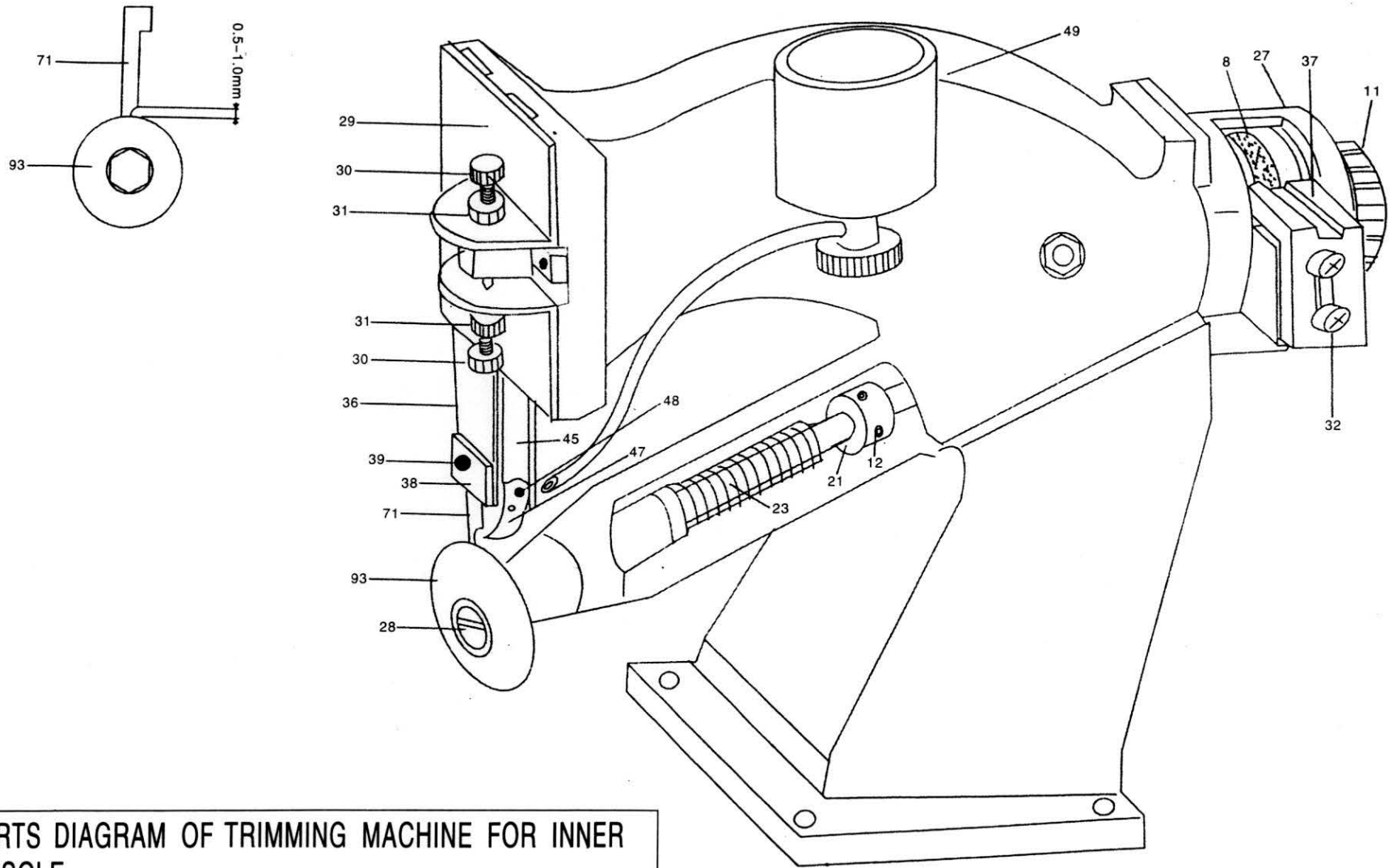
Tuning the plastic wheel NO.11 at the rear of the machine by hand to check if it turn smoothly or not.If it is smoothly then swich on the motor.

G. ADJUSTING SPRING POWER OF UNDER CUTTER NO.93

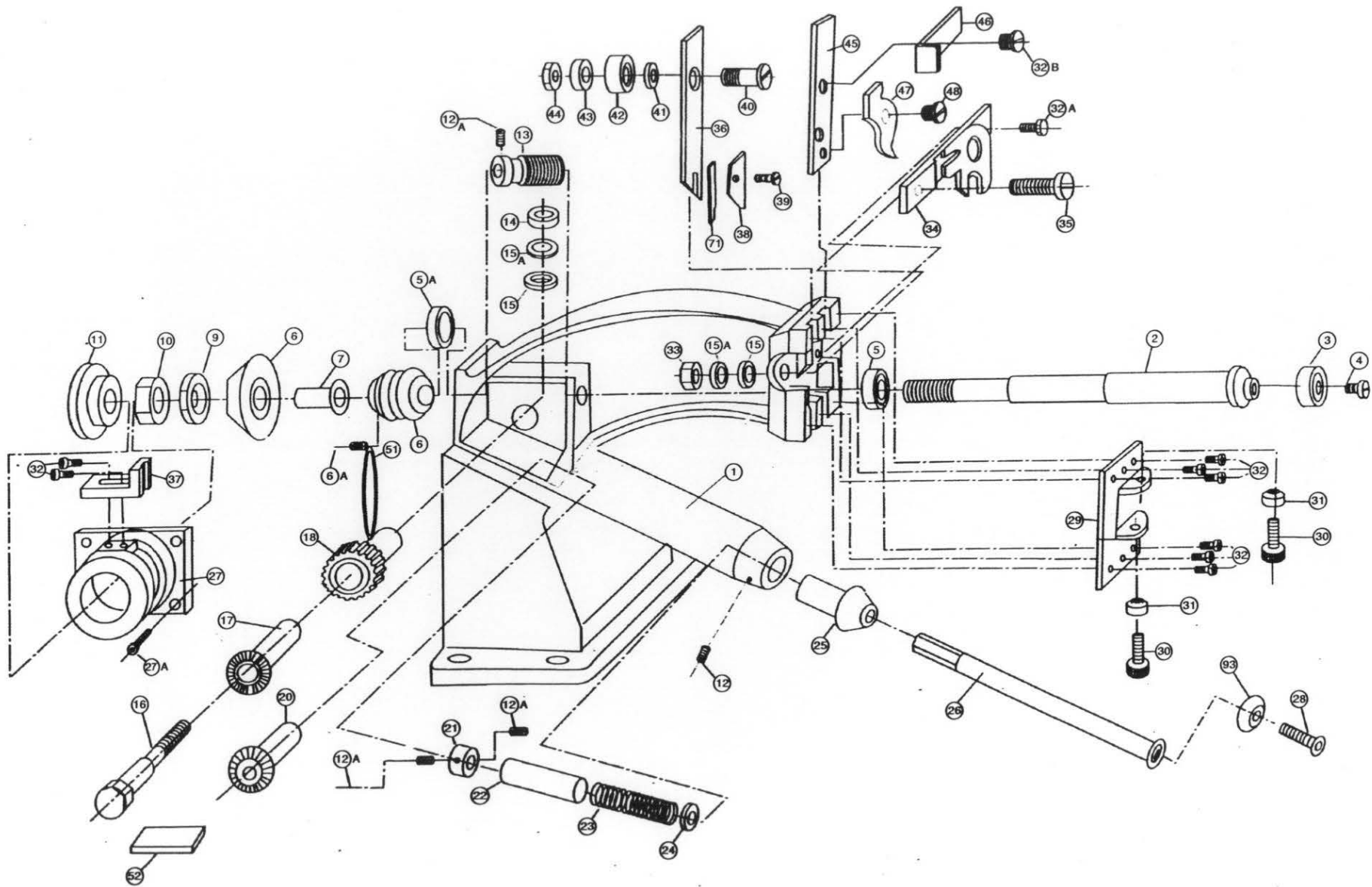
Loosen screws NO.12, lower iron ring NO.21, then tighten screws NO.12, thus a strong spring Power for under cutter NO.93, otherwise weak.

H. CHANGING THE TRANSMISSION BELT

In the case transmission belt was broken. loosen the plastic NO.11, take off the belt covers and grinding wheel covers, thus change the transmission belt.

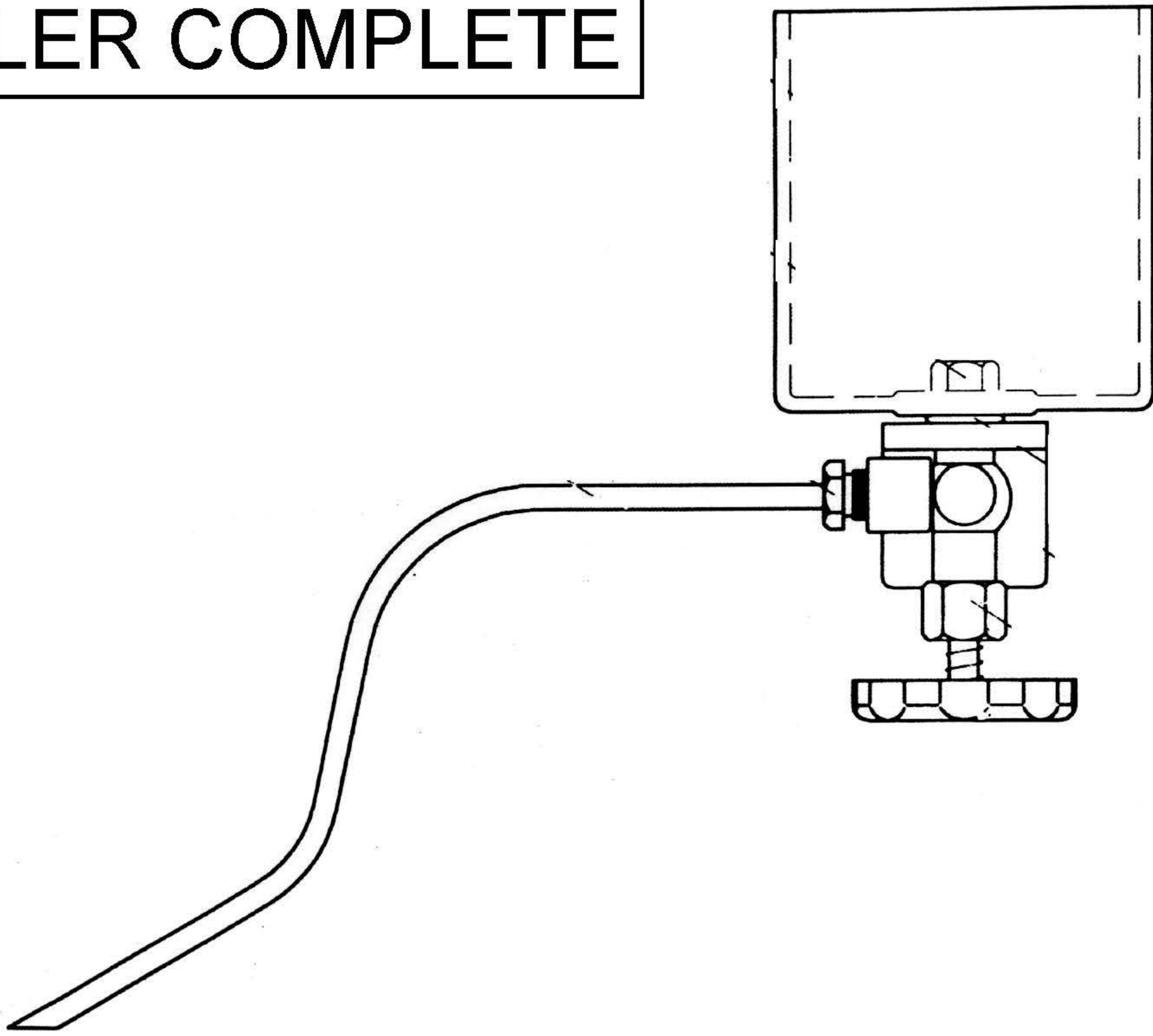


THE PARTS DIAGRAM OF TRIMMING MACHINE FOR INNER LINING&SOLE



REF.NO	PARTNO.	DESCRIPTION	Qty
1	1	Bed	1
2	2	Top shaft	1
3	3	Bearings	1
4	4	Screw	1
5	5	Bearings	1
6	5A	Bearings	1
7	6	Leather belt round	1
8	6A	Screw	1
9	7	Grindstone screw(right)	1
10	8	Grindstone	1
11	9	Grindstone screw(left)	1
12	10	Hexagonal nut	1
13	11	Hand wheel	1
14	12	Screw	1
15	12A	Screw	2
16	12B	Screw	1
17	13	Worm gear	1
18	14	Nut	6
19	15	Washer	10
20	15A	Spring washer	2
21	16	Worm gear shaft	1
22	17	Gear	1
23	18	Worm gear	1
24	20	Gear	1
25	21	Tight turn	1
26	22	Spring coil set	1
27	23	Spring	1
28	24	Washer	1
29	25	Copper set	1
30	26	Bottom shaft	1
31	27	Cover	1
32	27A	Screw	4
33	28	Screw	1
34	29	Side cover	1
35	30	Adjusting screw	2
36	31	Adjusting screw nut	2
37	32	Screw	8
38	32A	Screw	1
39	32B	Screw	1
40	33	Nut	1
41	34	Plank	1
42	35	Screw	1
43	36	Top knife pole	1
44	37	Whetting the knife fixs	1
45	38	Knife clips	1
46	39	Screw	1
47	40	Screw	1
48	41	Bushing	1
49	42	Bearings	1
50	43	Washer	1
51	44	Nut	1
52	45	Press the feet pole	1
53	46	Limit & piece	1
54	47	Presser the feet	1
55	48	Screw	1
56	49	Canteen	1
57	51	Leather belt	1
58	52	Oil rock	1
59	71	Top knife	1
60	93	Bottom knife	1

OILER COMPLETE



accessoires

REF.NO	DESCRIPTION	QTY
1	Oiler complete	1
2	Wrench	1
3	Hexagonal wrench key	1
4	Belt	1
5	Knife	1
6	Bottom knife	1
7	Screw	4
8	Instruction manual	1