



## OPERATION MANUAL

BAND LOOP CUTTER

MODEL **BK-20**

MORIMOTO MFG. CO., LTD.

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**1) Introduction:**

This manual provides necessary information and instructions for the maintenance of the Belt Loop Cutter Model BK-20.

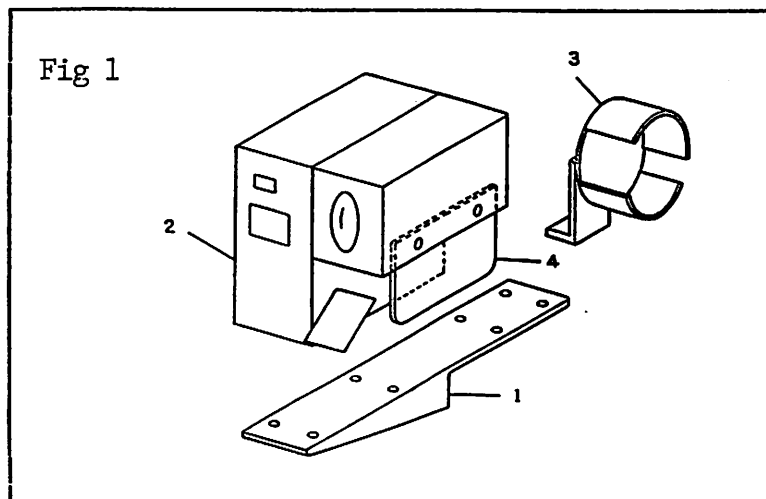
**Specifications:**

- 1) Input Power Supply: 100, 115-120, 200, 220-240 Volt AC Single Phase.
- 2) Motor Wattage: 25 Watts
- 3) Installation Method: Direct Mounting On The Sewing Machine Or On The Table Top.
- 4) Cutting Length: 50-150MM
- 5) Cutting Speed: 200 Times Per Minute (Interlocked With The Sewing Speed Of The Machine)
- 6) Maximum Width: 30MM
- 7) Count Display: 0-9,999

## II) Installation:

**Fig 1:**

1. Base
2. Main Body of BK-20
3. Tensioner
4. Safety Cover



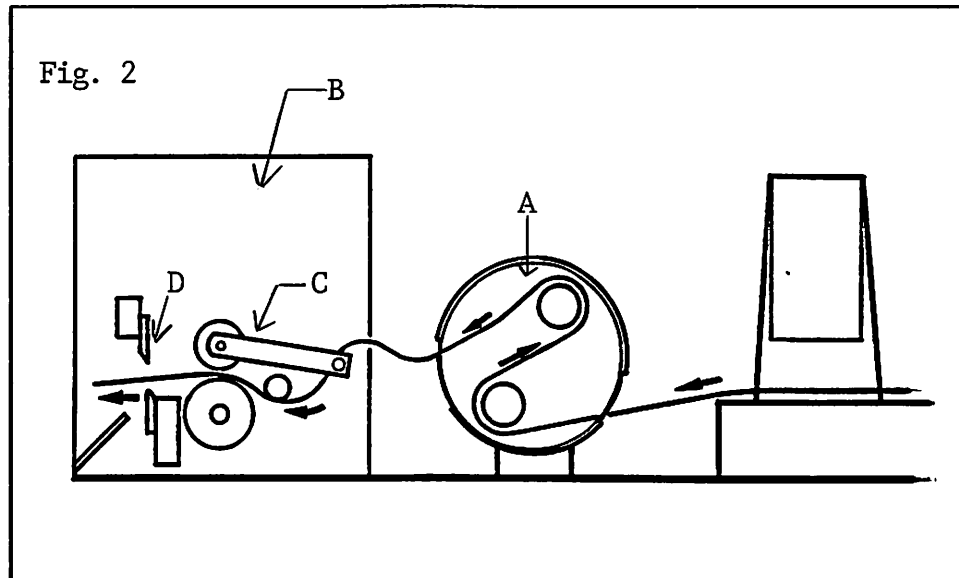
### Steps

1. Attach base (1) to the table stand with bolts and nuts provided.
2. Attach the main body of the BK-20 (2) and the tensioner (3) to the Base (1).
3. Attach the safety cover (4) to the main body of the BK-20 (2).
4. Connect the power supply cable.

### 111) BELT LOOP SETTING:

Fig 2:

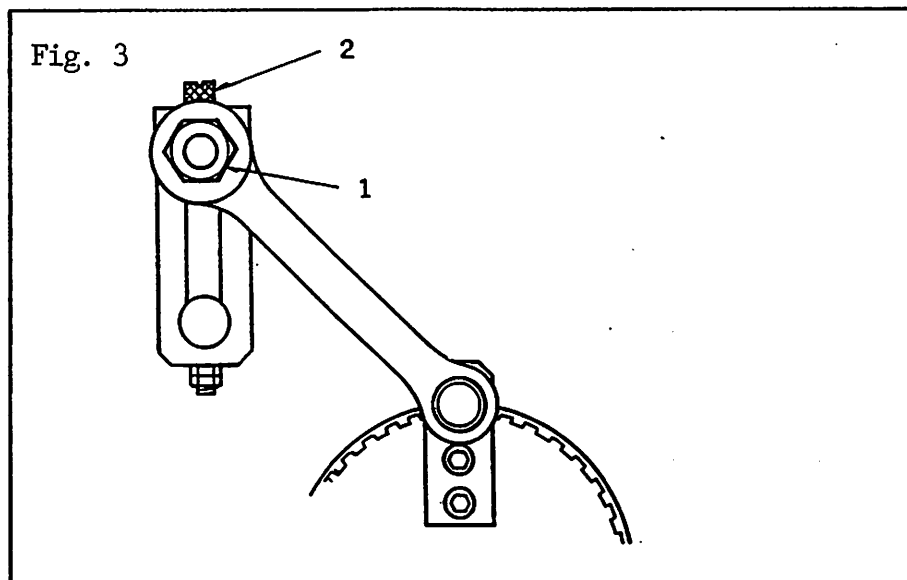
1. Before turning the BK-20 Belt Loop Cutter on sew approximately 4-5 feet of belt loop.
2. Manually feed the belt loop through the tensioner unit (A) and through the BK-20 unit (B). **Note:** Make sure that there is tension on the loop inside the tensioner.
3. Set the guide roller (C) so that the belt loop is fed into the center of the knife (D).



**Note:** Make sure to follow diagram exactly when feeding the belt loop through the tensioner and into the BK-20 unit. Failure to operate the unit without properly feeding the material through the tensioner will result in continuous operation of the unit.

### III) OPERATION:

1. Turn the sewing machine power supply on.
2. Turn the BK-20 power supply on. **Note:** The BK-20 has a built in safety feature that will not allow the unit to operate if the front cover is not completely shut, or if there is too much tension on the belt loop inside the tensioner.
3. To adjust the length of the belt loop it is necessary that you first turn the power to the BK-20 off. Then refer to Fig 3 and loosen nut (#1) and turn the adjusting pin (#2) to adjust to the desired length. Tighten the nut. **Note:** To increase the length of the belt loop turn the pin to the right. To decrease the length of the belt loop turn the pin to the left.
4. Begin Sewing, the BK-20 will now cut the loop at the desired length at a maximum speed of 200 times per minute.
5. Set the counter to zero for accurate display.



**VI) MACHINE SPEED SETTING:**

Use the examples below to figure out the correct way to set the speed of the BK-20 Belt Loop Cutter Unit (Shown as "R") so that the speed will be below the recommended maximum of 200.

**EXAMPLES:**

$$\begin{array}{rcl} \text{Sewing Pitch} & \times & \text{Machine Speed} = \text{sewing Length} \\ 3\text{MM} & \times & 4,000\text{SPM} = 12,000 \end{array}$$

$$\begin{array}{rcl} \text{Sewing Length/Cutting Length} & = & \text{BK-20 Speed} \\ 12,000/60 & = & 200(\text{R}) \end{array}$$