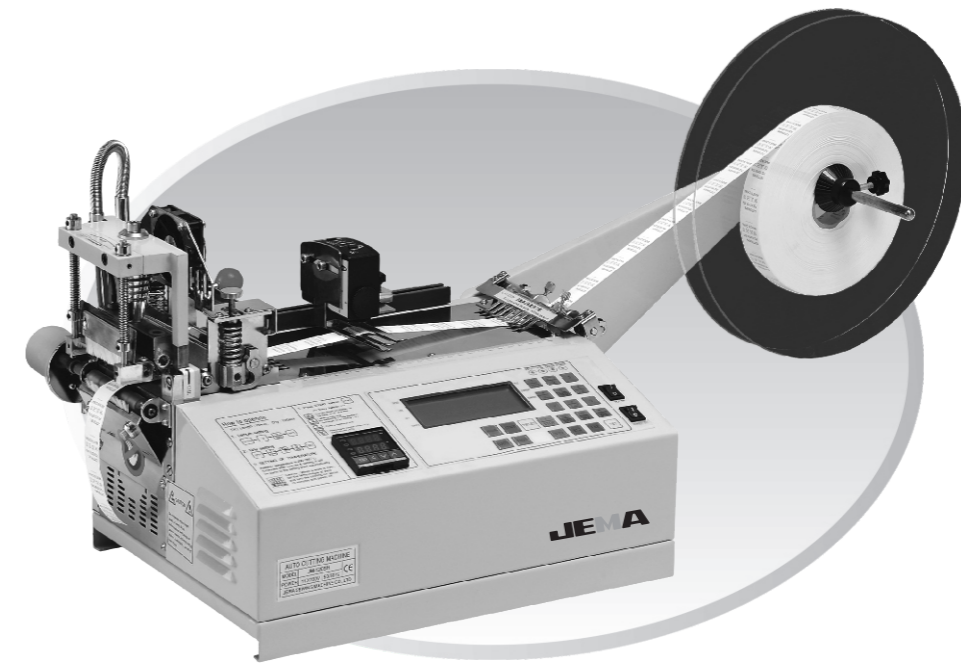


JEMA

全自动电脑切带机
AUTO CUTTING MACHINE

使用说明书
INSTRUCTION MANUAL



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1. GENERAL DISCRPTION

Auto cutting machine adopts electromechanical integrating technology, it automatically adjusts the length data through the input of computer program. Automatically cutting various straps of different sizes such as braided tape, Velcro tape, plastic tube, bootlace, plastic zipper, electrical wire, label, etc. All the data will be saved automatically before put off the switch. With features of high accuracy, high speed, easy operation and stop working without materials. It's an ideal machine for increasing efficiency, improving quality and saving labour.

2. SPECIFICATION

power	MAX. cutting width	cutting length	cutting speed (pcs/min)	voltage	packing size (L.W.H)
0.28KW	110mm	15mm-99999mm	70/120	110/230V 50/60Hz	560x415x400

3. USE ENVIROMENT

The machine should work under the normal temperature, if the environment temperature is more than 80°C, would influence the performance of the machine.

4. HOW TO OPERATE

How to operate (i.e., cutting length: 120mm, cutting quantity: 50pcs)

Put on the POWER SW.

Set cutting length 120mm.(press the following bottons in order.)

👉 LENGTH ⇒ [1] EXTRA ⇒ [2] ⇒ [0] ⇒ [SET]

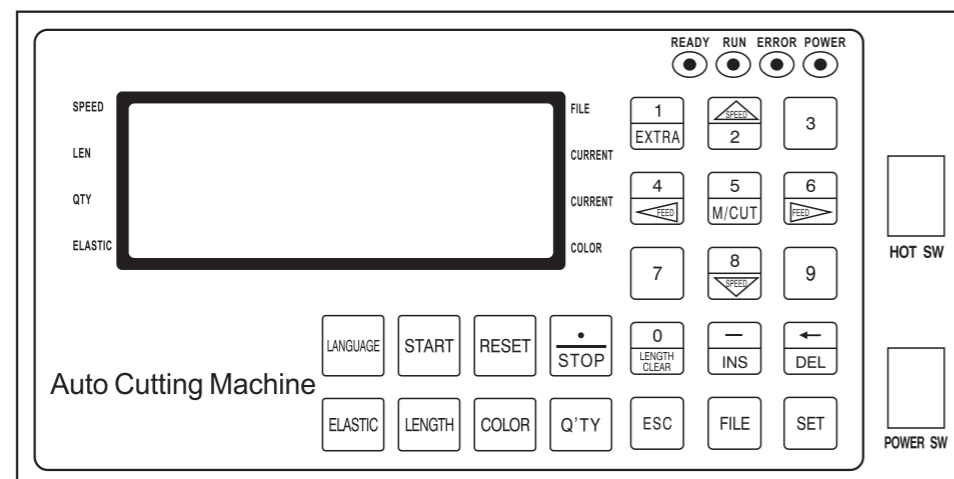
☆ Botton "0" has a double function of "0" and eraising current lengh

Set cutting qauty 50pcs.

👉 Q'TY ⇒ [5] M/CUT ⇒ [0] ⇒ [SET]

Press START botton to start the machine.

5. KEY FUNCTIONS



How sw Use for hot cut

Power sw Power



Current length on display will back to "0"



Cut one more time

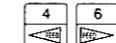


Speed up (normal speed 50%, max. speed 100%)



Speed down

*Speed up & down is possible in any time (operation or stop) and set-speed will not be Changed even through you press RESET botton or power off&on.



To move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.



Moving knife only.



Language shift (Chinese/English)



To start the working after finish length and qauty setting



All of current length and current quantity on display will back to "0"



To pause the working as well as a decimal point in the length setting



To insert new program between programs inputted already in time of program-input.



To delete the wrong program in time of program-input. (All things of the STEP will be deleted.)



Compensation use for the elastic material cutting



Resoring to normal condition in ERROR



Can save 9 files for you to select



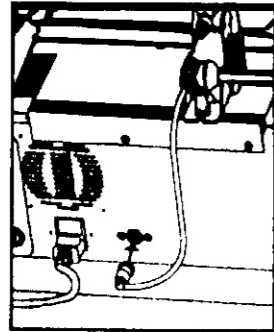
Infrared function

6. CAUTION

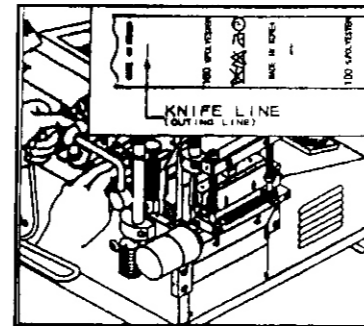
1. Before use,pls confirm the voltage and make ground (earth) connection. (Note: Ground cable must be grounded)
2. Do not access hands or any object close to the working knife.
3. Cut off the eletricity before any adjustment (for safty) .
4. Pls do not take off any of the parts except for normal maintance.
5. Lubricate the machine every time use the machine.
6. When the knife blade becomes dull, pls use it after griding with the grinding machine (pls do not let the unskilled person grind manually or install the knife blade)
7. Welcome to contact us for more information!

7. HOW TO USE SENSOR

1. Put the label length into computer.
2. Press COLOR button to open the sensor. Open in + direction when the background is lighter and - direction when is darker. (Note: first touch COLOR button always on + direction, second time is - direction)
3. Mount the sensor on the guide-rail and connect the jack of sensor into the connector of machine downside. (picture 1)
4. Locate the cutting line of label on the lower knife blade precisely & move the sensor close to the knife. (picture 2)

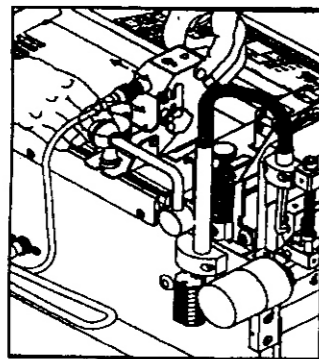


(picture 1)

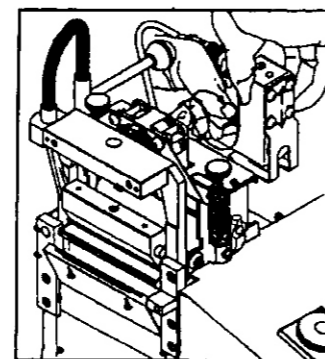


(picture 2)

5. Adjust the sensor with guide-control bolt for lightening the beam on the center of marking point. (picture 3)
6. By the height-control bolt of sensor, make the focused beam clear to be 1 shape. (picture 4) (note that it is supplied after adjustment of the height from the factory.)

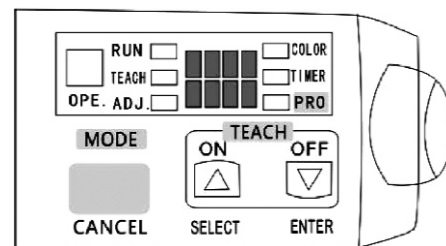


(picture 3)

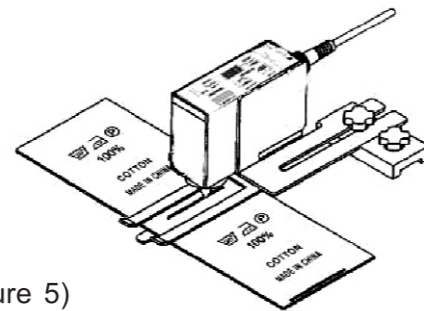


(picture 4)

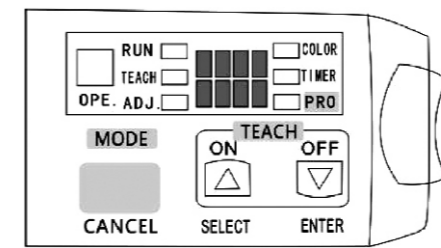
7. Move the lighting point to the blank area "no printing", Press key "MODE", then press key "ON".



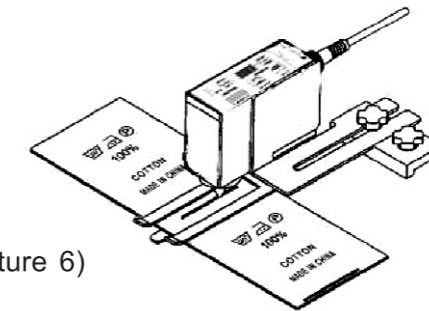
(picture 5)



8. Move the lighting point to the printed area or marker area (easy distinguish color the best).



(picture 6)



9. Press the RESET button to restore the system.
10. Press "RESET" or "0", then press "START" to working.

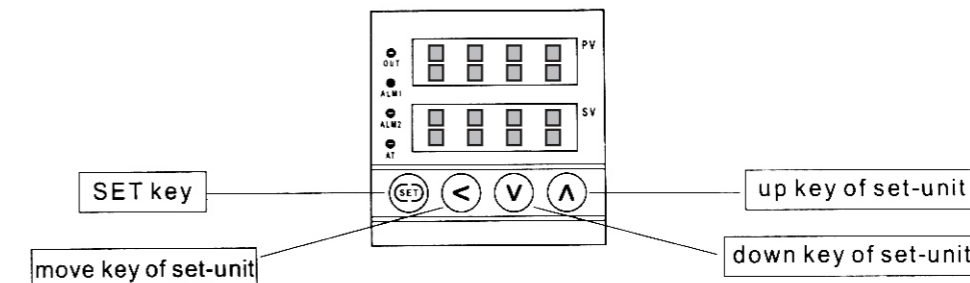
Troubles in cutting

- Check if you adjust sensor after cutting line of label on the knife blade.
- Move the sensor forwards and backwards.
- Check sensitivity & height of the sensor.
- Check the cut speed (normal 50%)

Caution:

After setting the sensor, do not press DELAY, L/D button, it may happen an error changing input data.

8. HOW TO USE TEMPERATURE-CONTROL

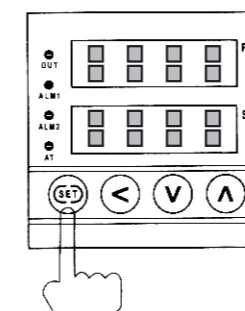


When you power on the controller, PV shows current room temperature and SV shows set temperature.

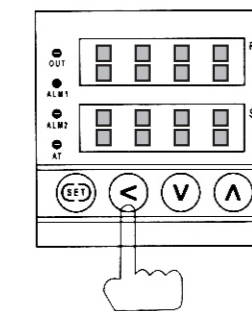
Recommendation is 130~150.

After turn on & set, within 10 minutes, it reaches to set temperature.

1. You can enter set mode by pressing SET key, you may see one cipher blinks, it means it can be changed. (picture 1)
2. By pressing < key, you can move between numbers of four ciphers. (picture 2)

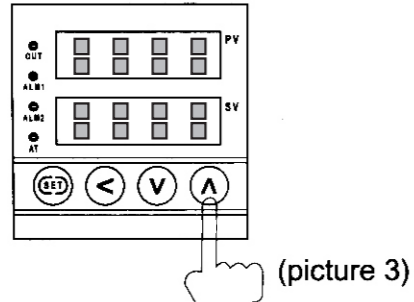


(picture 1)

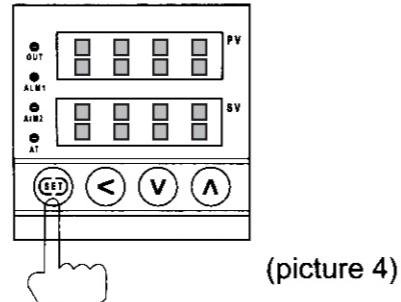


(picture 2)

3. Set desired temperature by pressing \wedge and \vee keys. Set-temperature will be increased by \wedge key and it will decreased by \vee key. (picture 3)
4. After finishing setting, press SET key once more. then, it stops blinking. And the controller will return to auto-turning mode. (picture 4)



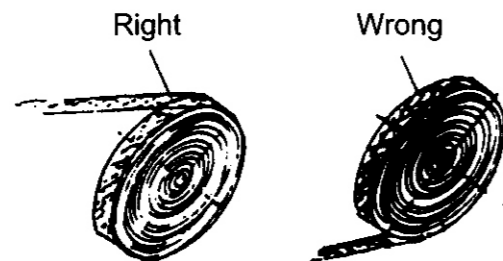
(picture 3)



(picture 4)

Fault clearance

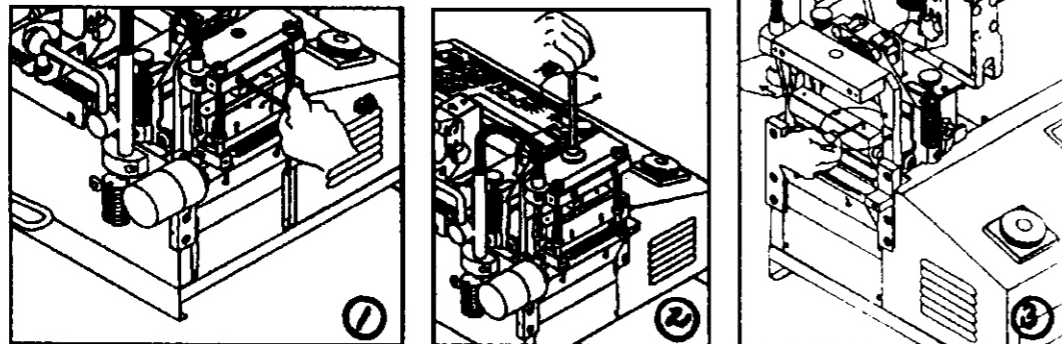
1. Check the connection if the temperature does not work.
2. Increase the temperature if the cut unsealed
3. Pls wait the temperature reaches to the set temperature before working and with right material putting.



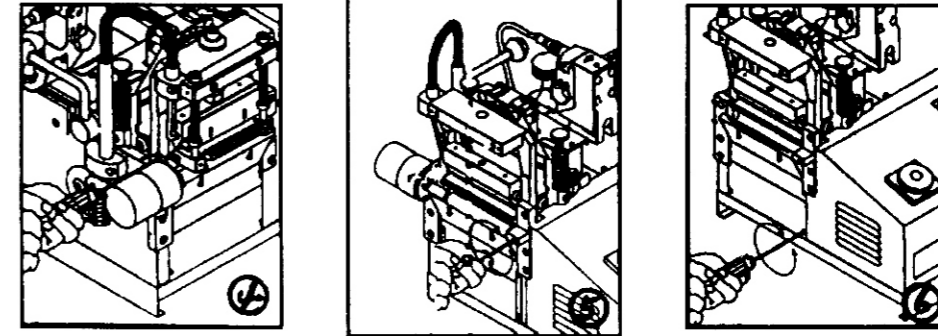
4. If you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200°C. Then loose the screw and turn off the control. And screw out completely after the knife is cool. (note that is hot and not burned yourself)

9. EXCHANGE OF KNIFE

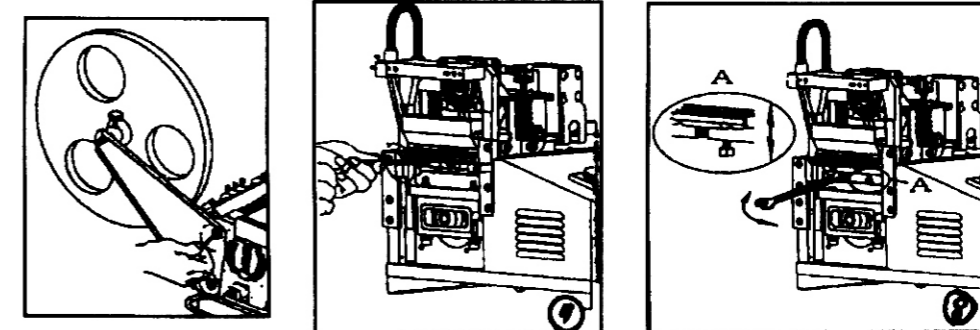
1. First of all, move up the upper knife to top level and power off and take off the presser of upper knife after unscrewing 2 bolts by 4mm-wrench.
2. Take off the upper knife frame by 6mm-wrench.
3. Take off the heater after unscrewing the fixing bolt by 2.5mm-wrench.



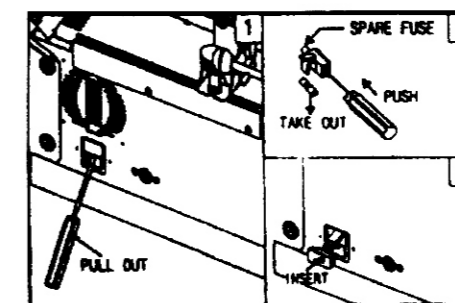
4. If necessary to exchange the lower knife plate, unscrew bolts of the front feeding motor.
5. Unscrew bolts of the front feeding roller and take off the motor & the roller.
6. Take off the cap by unscrewing bolts.



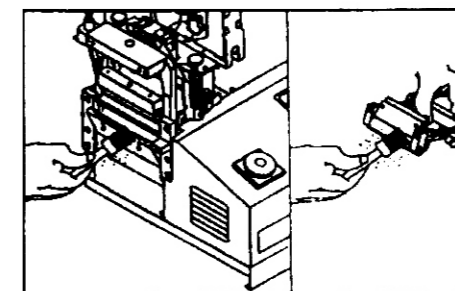
7. Unscrew 3 fixing bolts by 7mm-wrench and take off the lower knife plate.
8. If no cutting or one sided cutting, make the upper knife contacted to the lower knife plate and check the level between upper knife & lower knife plate and power off & adjust gap or pressure by 7mm-spanner.



EXCHANGE OF FUSE: Take off the power plug and exchange as picture.



CLEANING OF ANTI-STATIC BRUSH: If anti-static device does not work, clean the anti-static brush by other brush.

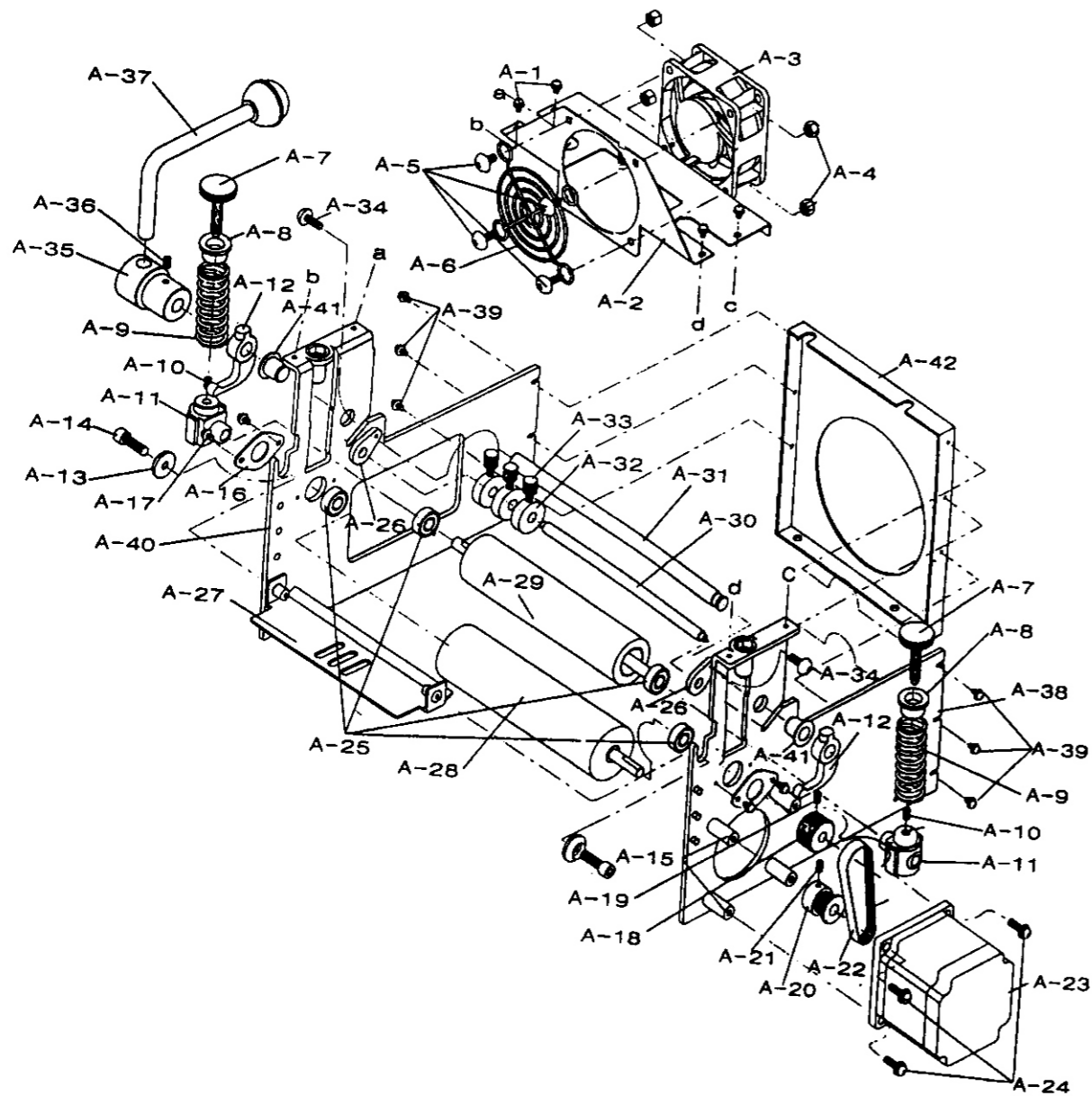


10. TROUBLE SHOOTING OF 120 SERIES

NO	TROUBLES	APPLICABEL MODEL	CAUSES & MEASURES
1	No power supply	All models	<p>Check if electric cord is connected well</p> <p>Check if the fuse blows out or not</p>
2	Power is on, But no work	All models	<p>Check if there is inserted any alien substance in roller</p> <p>If the display shows "sensor error" or any other error, put off SW for 10 seconds and put on again</p> <p>If still doesnot work, exchange the drive board.</p>
			<p>Knife does not work</p> <p>All models</p> <p>Check if pressure plates of upper knife are too much fastened or not. (cool: 20 & 29, hot: 32&36)</p>
			<p>LCD display does not work</p> <p>All models</p> <p>Check if the temperature is too high with over-time working, switch off the machine for seconds, if still doesn't after sevral times' trying. Pls opening the cover and check the connection.(espically between operation and MB board)</p>
3	Material is no cut	Hot cutter	<p>Check if temperature goes up to set-degree</p> <p>Check if knife blades are even.</p>

NO	TROUBLES	APPLICABEL MODEL	CAUSES & MEASURES
4	Material is cut onesidedly	All models	<p>Check if blades are damaged or weared</p> <p>After making both knives close each other by M/CUT botton and check if they are even or not. (if they are not, adjust them by bolts.)</p>
5	Cut-length is different from set-length	All models	Test cutting after loosening materail from the reel by hand or attaching feeding device.
6	Cutting lengthh is discrepant	All models	<p>1.Lower the delivery speed.</p> <p>2.Loose the roll-hanger wheel.</p>
7	It cuts before the cutting line of label	Label	Move the sensor towards knife side as long as the difference by pushing.
8	It cuts after the cutting line of labels	Label	Move the sensor towards counter-knife side as long as the difference by pushing.
9	Error on LCD	MARK ERROR	<p>Trouble in MARK SENSOR</p> <p>Check if the sensor is connected well or not</p> <p>Check if the sensor is adjusted well or not</p> <p>Check if the input length is cord with the label length.</p>
		CUTTING ERROR	<p>Troubles in cutting motor or counting sensor</p> <p>1.Turn on the machine and press the 5 botton, check if the knife can be moved or not. if not, the knife may locked.</p> <p>2.Open the bottom cover of the knife, check if the sensor is loose or wrong positioned.</p> <p>3.Open machine cover, check the SW of cutting sensor is right or not. If not, exchange it</p> <p>Check the cutting motor is right or not.</p>
10	Operator feels electric curent in touch of machine	All models	Connect the earth cord (green) to any bolt of backside of machine.

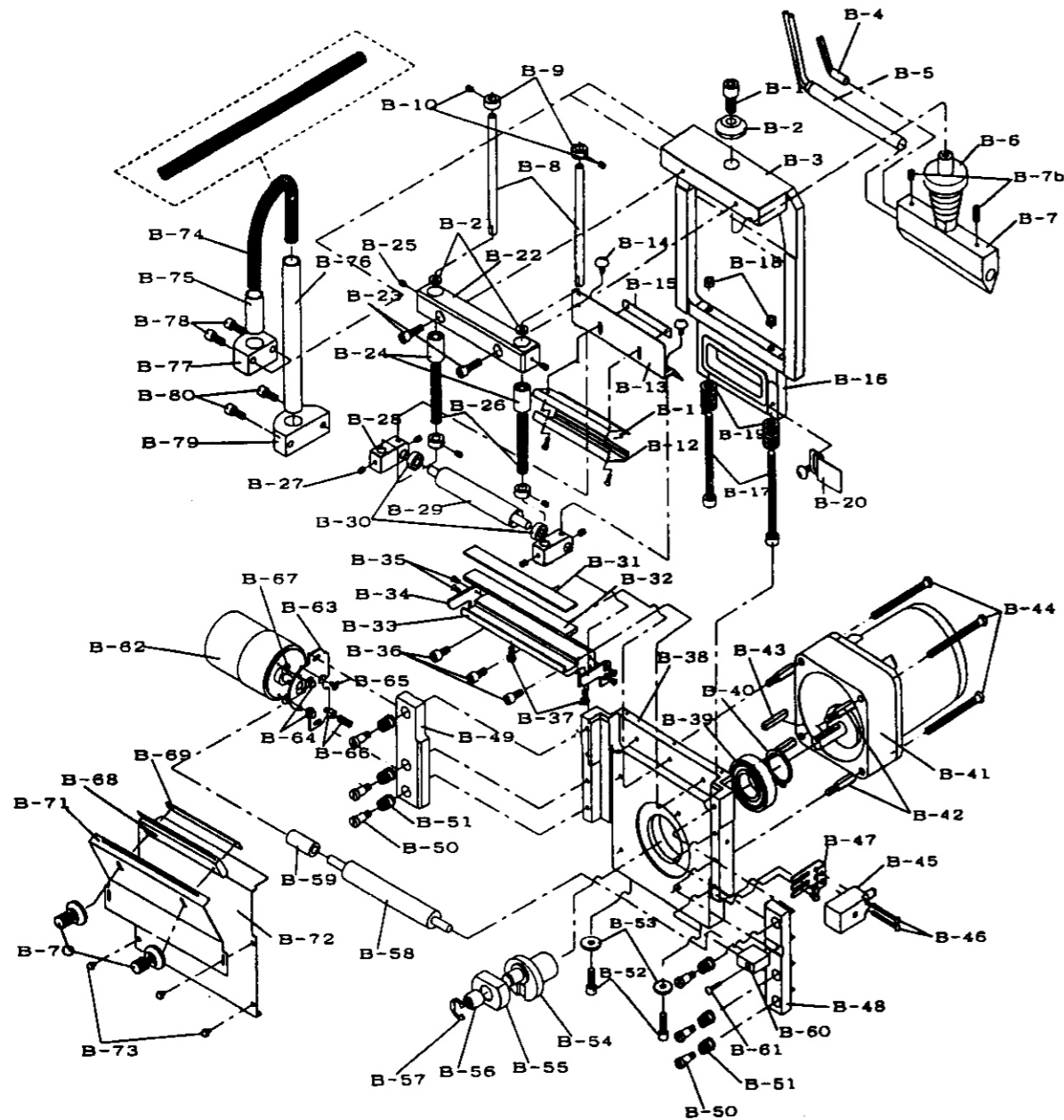
SPARE PARTS



SPARE PARTS

Part No.	Description	Part No.	Description
A-1	Clamping Bolt(M3x5L)	A-24	Clamping Bolt(M5x15L)
A-2	Upper Cap of Cooling Fan	A-25	Ball Bearing(#696)
A-3	Cooling Fan(Small)	A-26	Guide-clamping Bracket
A-4	Check Nut(M4)	A-27	Stopper
A-5	Clamping Bolt(M4x20L)	A-28	Lower Roller
A-6	Safety-grill of Cooling Fan	A-29	Upper Roller
A-7	Pressure-control Bolt	A-30	Front-guide Pin
A-8	Pressure-control Spring Cover	A-31	Lever Shaft
A-9	Pressure-control Spring	A-32	Guide Ring
A-10	Detent Screw(M5x6L)	A-33	Knob Bolt of Guide Ring
A-11	Slide Block of Upper Roller	A-34	Round Screw(M4x6L)
A-12	Slide Lever	A-35	Lever Bracket
A-13	Clamping Washer	A-36	Clamping Bolt(M5x5L)
A-14	Wrench Bolt(M4x15L)	A-37	Lever
A-15	Tie Bar of Stepping Motor	A-38	Right Roller Bracket
A-16	Bearing Cover	A-39	Clamping Bolt(M3x5L)
A-17	Clamping Bolt(M3x5L)	A-40	Left Roller Bracket
A-18	Feed-timing Gear(MXL30T)	A-41	Oilless
A-19	Detent Screw(M4x6L)	A-42	Space Plate of Roller Bracket
A-20	Drive-timing Gear(MXL20T)		
A-21	Detent Screw(M4x6L)		
A-22	Timing Belt(MXL75)		
A-23	Stepping Motor		

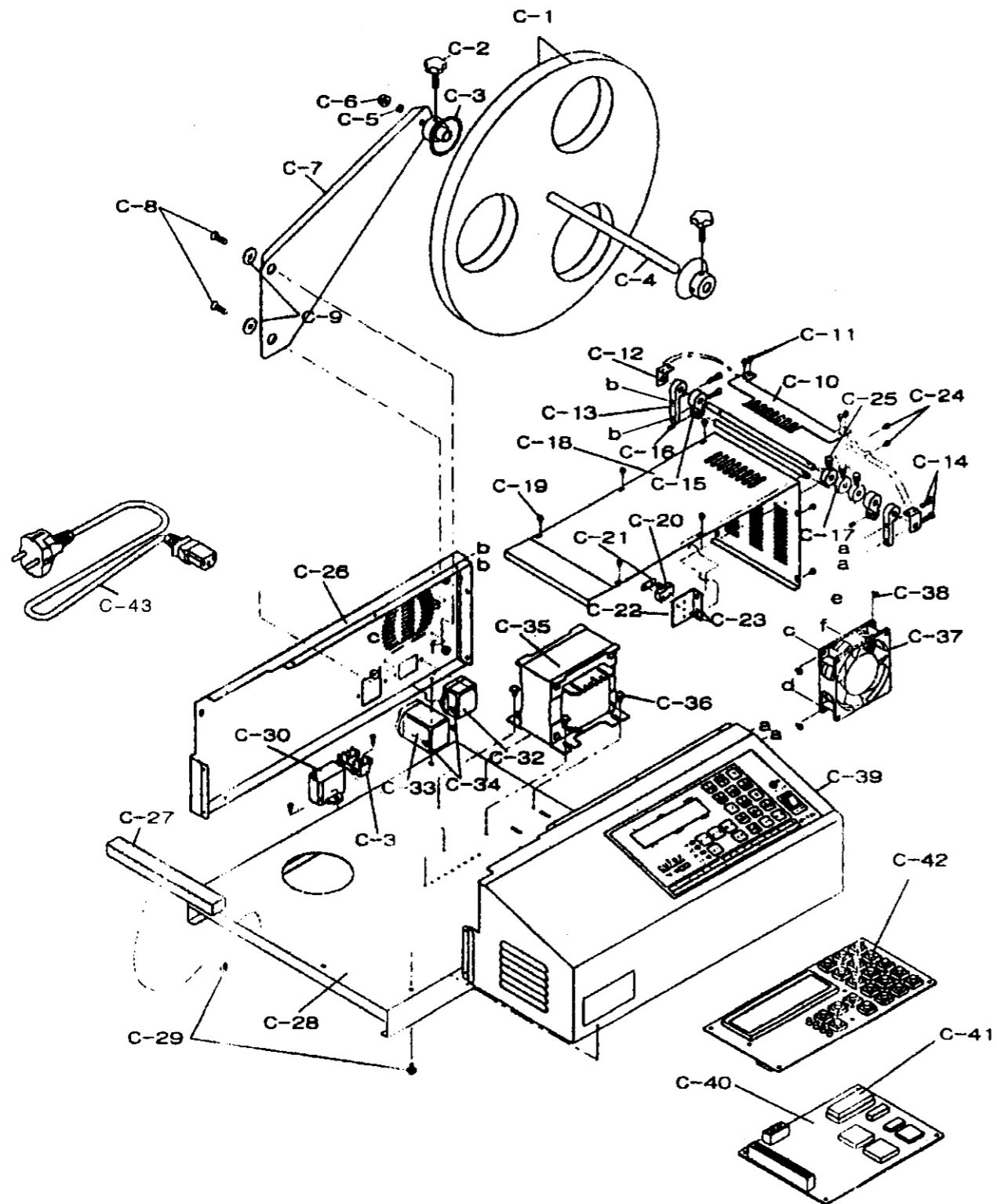
SPARE PARTS



SPARE PARTS

Part No.	Description	Part No.	Description
B-1	Clamping Bolt (M8x28L)	B-42	Motor Supporter
B-2	Neck Washer of Hot-knife Bracket	B-44	Clamping Bolt (M5x42L)
B-3	Upper Knife Case	B-45	Counting Sensor
B-4	Heat Sensor	B-46	Clamping Bolt (M3x20L)
B-5	Heater	B-47	Clamping Bracket
B-6	Hot-Knife Bracket	B-48	Right Pressure Plate
B-7	Hot-Knife	B-49	Left Pressure Plate
B-7b	Detent Screw	B-50	Clamping Bolt of Pressure Plate
B-8	Vertical Axle	B-51	Pressure Spring
B-9	Shaft Ring	B-52	Wrench Bolt (M5x15L)
B-11	Anti-static Brush	B-53	Neck Washer
B-12	Brush Cap	B-54	Crank Bundle
B-13	Pressing Plate Cover	B-55	Cam #6000
B-14	Clamping Bolt (M3x6L)	B-57	E-Ring
B-15	Control-plate Nut	B-58	Front Feeding Roller
B-16	Slide Ram	B-59	Front Feeding Sub-roller
B-20	Counting-sensor Bracket	B-60	Roller Shaft Bracket
B-21	Shaft Rubber-bushing	B-61	Clamping Bolt (M3x5L)
B-22	LM Guide	B-62	DC Motor
B-23	Wrench Bolt (M5x20L)	B-63	DC Motor Bracket
B-24	LM Bearing	B-64	Clamping Bolt (M3x4L)
B-25	Detent Screw (M4x6L)	B-65	Flat-head Bolt (M3x4L)
B-26	Vertical Axle Ring	B-66	Vertical Control Nut
B-27	Detent Screw (M4x6L)	B-68	Anti-static Brush
B-28	Roller-clamping Bracket	B-69	Plate-nut of Height-Control
B-29	Pressing Roller	B-70	Height-control Bolt
B-30	Ball Bearing (#696)	B-71	Front Bracket
B-31	Heating Plate	B-72	Front Cover
B-32	Silicon Plate	B-73	Clamping Bolt (M3x4L)
B-33	Heating Plate Bracket	B-74	Heater Wiring Spring
B-34	Bracket Side Cover	B-75	Heater Wiring Pipe (1)
B-35	Flat-head Bolt (M3 x 8L)	B-76	Heater Wiring Pipe (2)
B-36	Wrench Bolt (M5x15L)	B-77	Upper Pipe Bracket
B-37	Hexagon-head Bolt (M4x8L)	B-78	Wrench Bolt (M4x6L)
B-38	Lower Knife Case	B-79	Lower Pipe Bracket
B-39	Ball Bearing (#6004)	B-80	Wrench Bolt (M4x6L)
B-40	Snap Ring		
B-41	Motor + Reduction Gear		

SPARE PARTS



SPARE PARTS

Part No.	Description	Part No.	Description
C-1	roll-hanger wheel	C-23	clamping bolt (M2x10L)
C-2	clamping bolt of holder	C-24	clamping bolt (M3x5L)
C-3	holder	C-25	knob bolt
C-4	roll-hanger shaft	C-26	back cover
C-5	roll-hanger shaft washer	C-27	sponge
C-6	check nut (M6)	C-28	base
C-7	roll-hanger	C-29	clamping bolt (M4x10L)
C-8	flat-head bolt (M6x15L)	C-30	condenser
C-9	neck washer of roll-hanger	C-31	terminal
C-10	existence detector	C-32	AC connector (OUT-PUT)
C-11	clamping bolt (M3x15L)	C-33	AC connector (IN-PUT)
C-12	clamping bracket	C-34	clamping bolt (M3x5L)
C-13	rear guide-pin bracket	C-35	transformer
C-14	wrench bolt (M4x15L)	C-36	clamping bolt (M4x6L)
C-15	rear tension-guide block	C-37	cooling fan
C-16	detent screw (M4x6L)	C-38	clamping bolt (M3x5L)
C-17	guide ring	C-39	control cover
C-18	upper guide plate	C-40	control circuit board (MB)
C-19	clamping bolt (M3x5L)	C-41	ROM
C-20	micro limit switch	C-42	operation board
C-21	plate-nut	C-43	out connect plug
C-22	limit switch bracket		