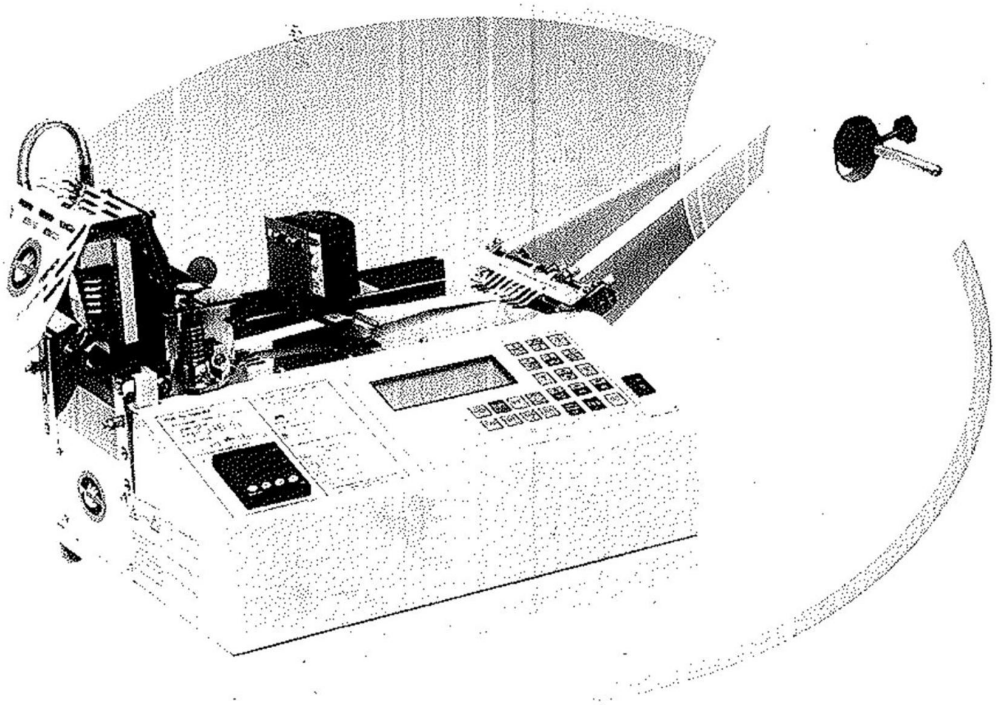
MAQ. CONTE FITS SS-120LR

AUTO CUTTING MACHINE

INSTRUCTION MANUAL



1. GENERAL DISCRIPTION

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 siza (L.W.H)
0.28KW	110mm	15mm-99999mm	100-120	110/230V 50/60Hz	560x415x400

3. USE ENVIROMENT

The machine should work under the normal temperature, if the environment temperature is more than 80℃, 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] ⇒ [SPEED 2] ⇒ [0 LENGTH CLEAR] ⇒ [SET]

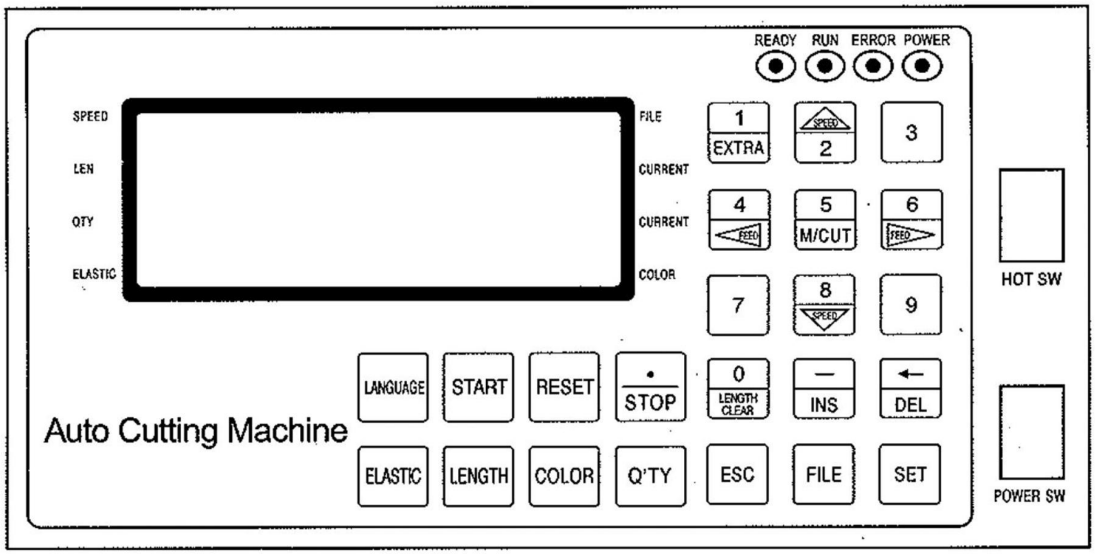
☆ Botton "0" has a double function of "0" and eraising current lengh

Set cutting quatity 50pcs.

☛ [Q'TY] ⇒ [5 M/CUT] ⇒ [0 LENGTH CLEAR] ⇒ [SET]

Press START botton to start the machine.

5. KEY FUNCTIONS



How sw　Use for hot cut

Power sw　Power

Clearance　Current length on display will back to "0"

1 EXTRA　Cut one more time

SPEED 2　Speed up (nomal speed 50%, max. speed 100%)

8 SPEED　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.

4 6　To move the roller manually for mounting the material on the machine or for feeding it forwards or backwards.

5 M/CUT　Moving knife only.

LANGUAGE　Language shift (Chinese/English)

START　To start the working after finish length and qautity setting

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

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

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

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

ELASTIC　Compensation use for the elastic material cutting

ESC　Resoring to normal condition in ERROR

FILE　Can save 9 files for you to select

COLOR　Infrared function

6. CAUTION

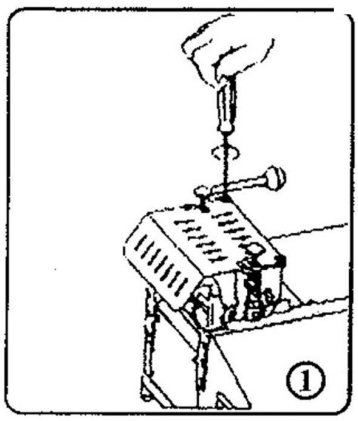
1. Before use,pls confirm the voltage and make ground (earth) connection.
2. Do not access hands or any object close to the working knife.
3. Cut off the eletricity before any adjustment (for safty) .
4. Pls do not take off any of the parts except for normal maintance.
5. Lubricate the machine every 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!

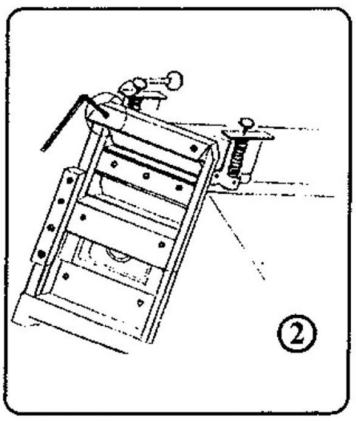
7. EXCHANGE OF KNIFE

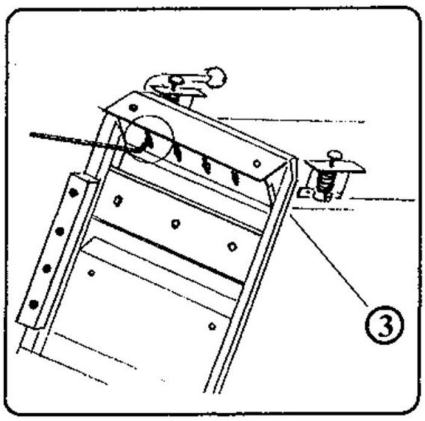
1.First of all, unscew 4 bolts on safely cap and take off the cap. take off anti-static device by 8mm-spanner for taking off upper knife. (see picture 1)

2.Uncrew 2 control bolts of upper knife by 2.5mm-wrench (don't take off)

3.Unscew 4 fixing bolts by 4mm-wrech and take off upper knife



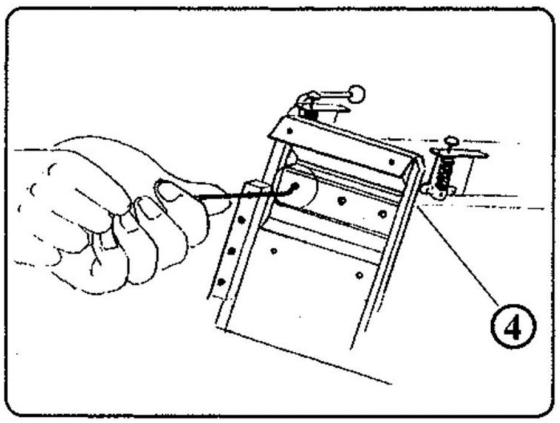


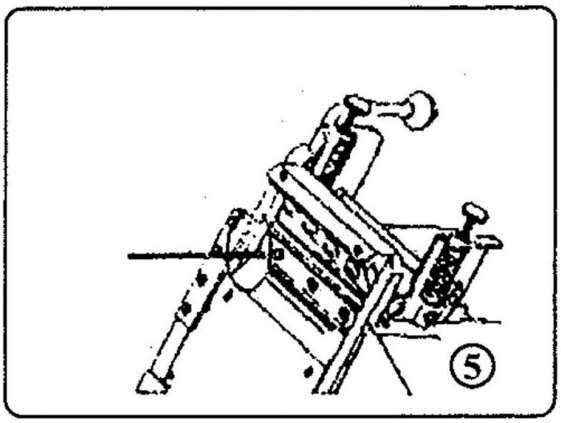


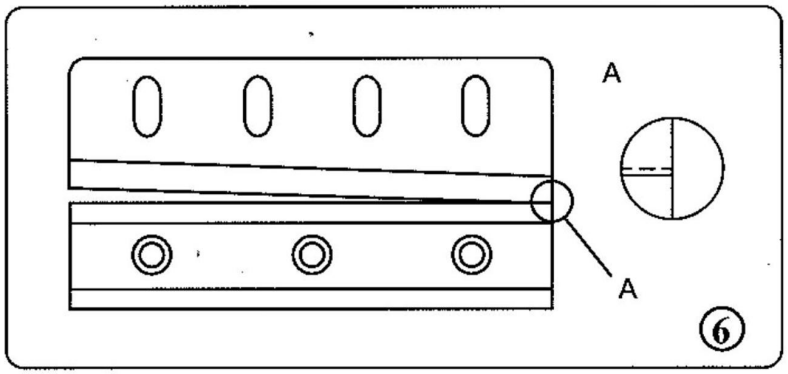
4.Unscrew 3 fixing bolts of lower knife by 4mm-wrech and take off lower knife.

5.Move up upper knife frame and install new upper knife and fix it but donnot fasten it firmly.

6.By soft touch of M/CUT botton, make the upper knife contacted to the lower knife plate.





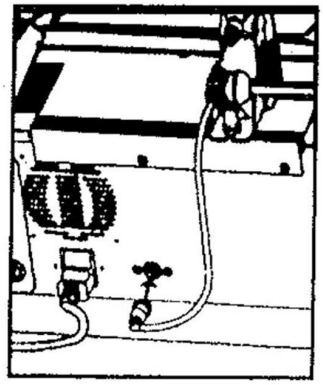


7.Check the lever between uper knife & lower knife plate with paper or tissue and adjust the gap.

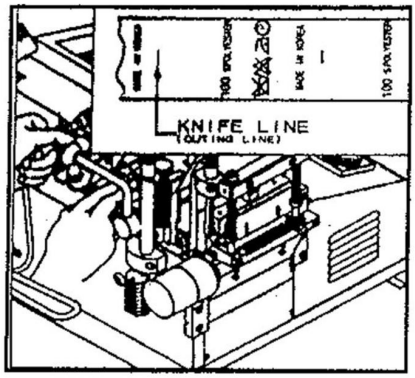
8.If cutting is normal, fasten the control bolts of upper knife firmly.

8. HOW TO USE SENSOR

1.Put the label length into computer.
2.Press COLOR boton to open the sensor. Open in + direction when the backgroud is lighter and - direcion when is darker. (Note: first touch COLOR botton 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)

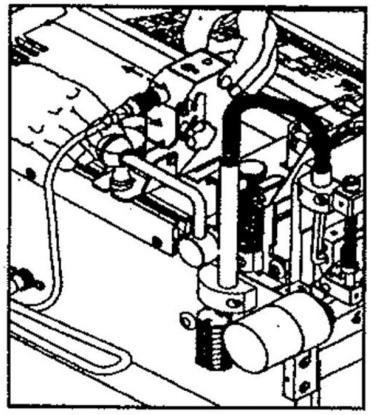


(picture 1)

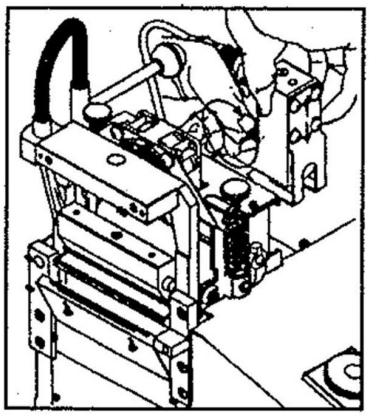


(picture 2)

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.)

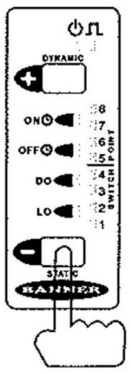


(picture 3)

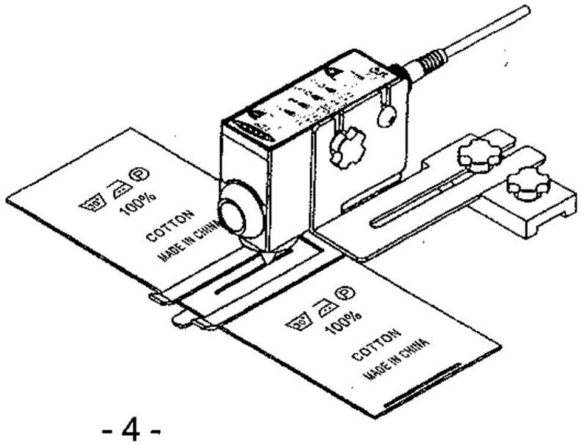


(picture 4)

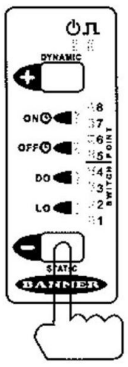
7.Focused the light on one of the marks (cutting lines or figure, letters) and press "-" button for more than 2 seconds, lamp "L/D" will blink and press "-" again. (picture 5)



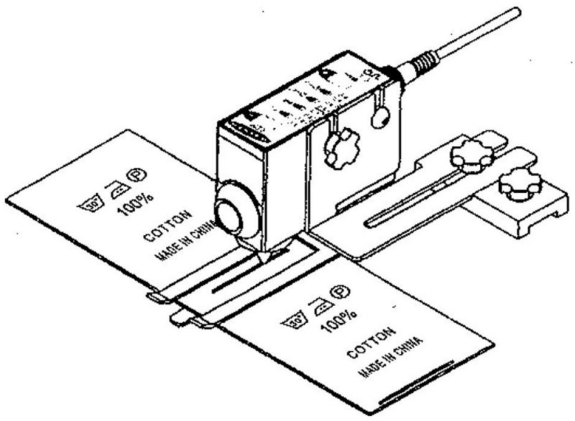
(picture 5)



8.Move the lightening point to the second mark of the label, press "-" botton.



(picture 6)



9.Press START botton

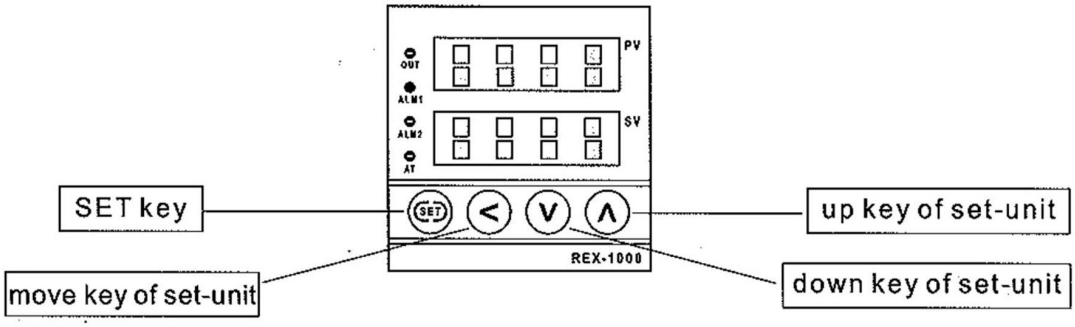
Troubles in cutting

-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:

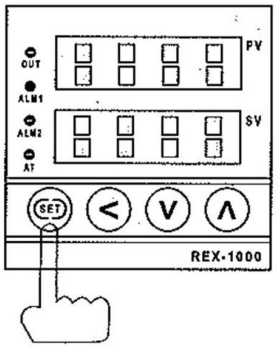
After setting the sensor, do not press DELAY, L/D botton, it may happen an error changing input data.

9. HOW TO USE TEMPERATURE-CONTROL REX-10000LL

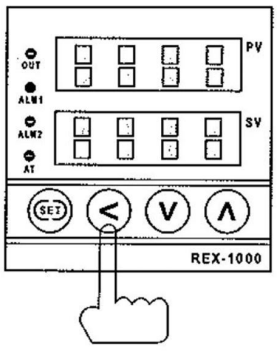


When you power on the controller, PV shows current room temperature and SV shows set temperature.
Recommendation is 130~150.
After turn on & set, within 10minutes, it reaches to set temperature.

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. (picure 2)



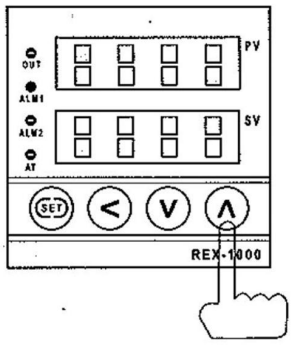
(picture 1)



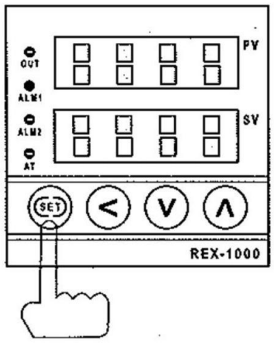
(picture 2)

3.Set desirous temperature by pressing ∧ and ∨ keys. Set-temperature will be increased by ∧ key and it will decreased by ∨ 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)



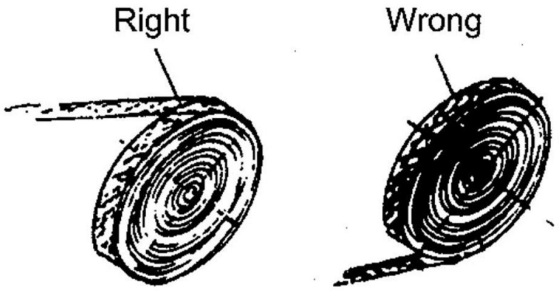
(picture 4)

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.

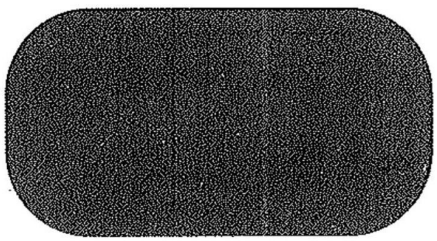


4.If you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200℃. Then loose the screw and turn off the control. And screw out completely after the knife is cool. (note that is hot and not burned youself)

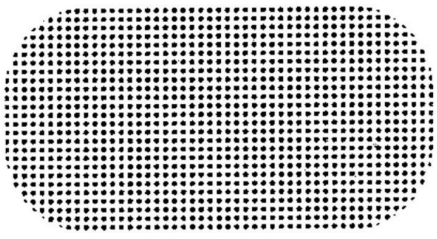
Caution:

-Do not cut two velcroes in the same time.

-When cut velcroes, pls make sure that the rough surface is upward.



the rough surface is upward
(correct)



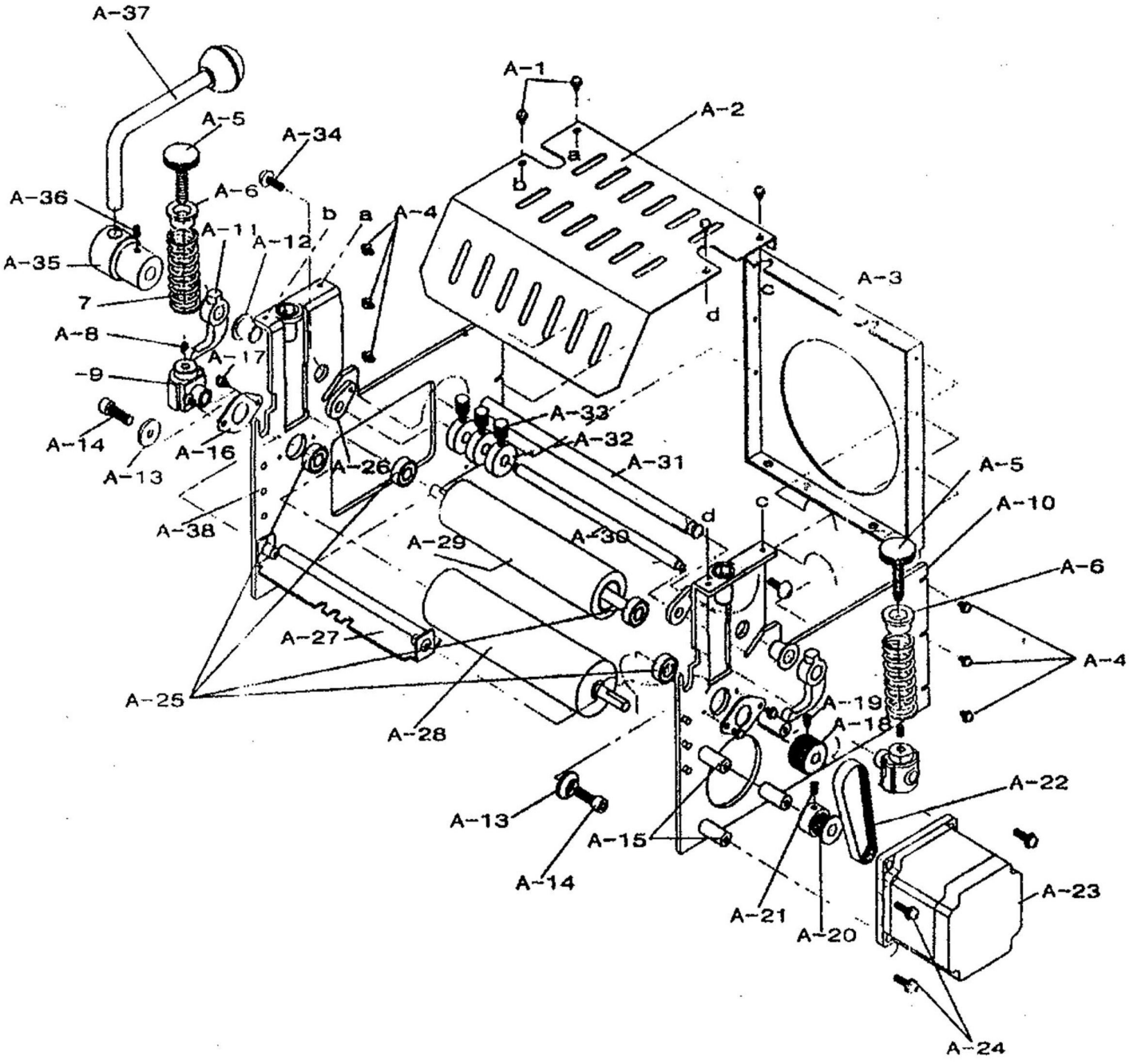
the rough surface is downward
(false)

10. TOUBLE SHOOING OF 120 SERIES

NO	TROUBLES		APPLICABEL MODEL	CAUSES & MEASURES
1	No power supply		All models	Check if electric cord is connected well
				Check if the fuse blows out or not
2	Power is on, But no work	Feed roller does not work	All models	Check if there is inserted any alien substance in roller
				If the display shows "sensor error" or any other error, put off SW for 10 seconds and put on again
				If still doesnot work, exchange the drive board.
		Knife does not work	All models	Check if pressure plates of upper knife are too much fastened or not. (cool: 20 &29, hot: 32&36)
		LCD display does not work	All models	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.(espcially between operation and MB board)
3	Material is no cut		Hot cutter	Check if temperature goes up to set-degree
				Check if knife blades are even.

NO	TROUBLES		APPLICABEL MODEL	CAUSES & MEASURES
4	Material is cut onesidedly		All models	Check if blades are damaged or weared
				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.)
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	It cuts before the cutting line of label		Label	Move the sensor towards knife side as long as the difference by pushing.
7	It cuts after the cutting line of labels		Label	Move the sensor towards counter-knife side as long as the difference by pushing.
8	Error on LCD	MARK ERROR	Label	Trouble in MARK SENSOR
				Check if the sensor is connected well or not
				Check if the sensor is adjusted well or not
				Check if the input length is cord with the label length.
		CUTTING ERROR	All models	Troubles in cutting motor or counting sensor
				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. 2.Open the bottom cover of the knife, check if the sensor is loose or wrong positioned. 3.Open machine cover, check the SW of cutting sensor is right or not. If not, exchange it
				Check the cutting motor is right or not.
9	Operator feels electric curent in touch of machine		All models	Connect the earth cord (green) to any bolt of backside of machine.

SPARE PARTS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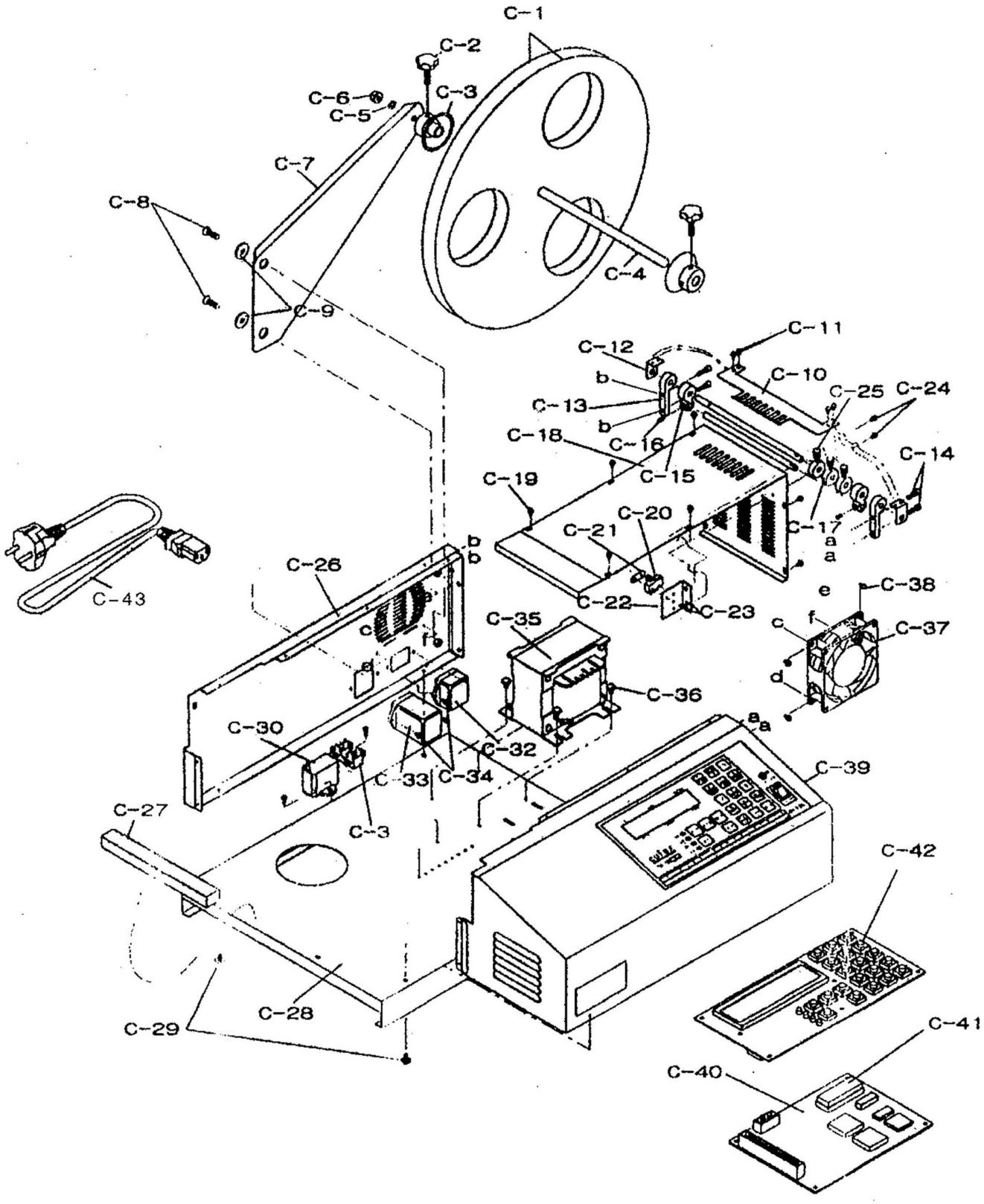
SPARE PARTS

Part No.	Decription	Part No.	Decription
A-1	clamping bolt (M3x5L)	A-21	detent screw (M3x5L)
A-2	knife safey cover	A-22	timing belt (MxL75)
A-3	space plate of roller bracket	A-23	stepping motor
A-4	clamping bolt (M3x5L)	A-24	clamping bolt (M4x15L)
A-5	pressure-control bolt	A-25	ball bearing (#696)
A-6	pressure-control spring cover	A-26	guide-clamping bracket
A-7	pressure-control spring	A-27	stopper
A-8	detent screw (M4x6L)	A-28	lower roller
A-9	slide block of upper roller	A-29	upper roller
A-10	right roller bracket	A-30	front-guide pin
A-11	slide lever	A-31	lever shaft
A-12	oilless	A-32	guide ring
A-13	clamping washer	A-33	knob bolt of guide ring
A-14	wrench bolt (M4x15L)	A-34	roud screw (M4x5L)
A-15	tie bar of stepping motor	A-35	lever bracket
A-16	bearing cover	A-36	detent screw (M5x5L)
A-17	clamping bolt (M3x5L)	A-37	lever
A-18	feed-timing gear	A-38	right roller bracket
A-19	detent screw (M4x6L)		
A-20	drive-timing gear		

SPARE PARTS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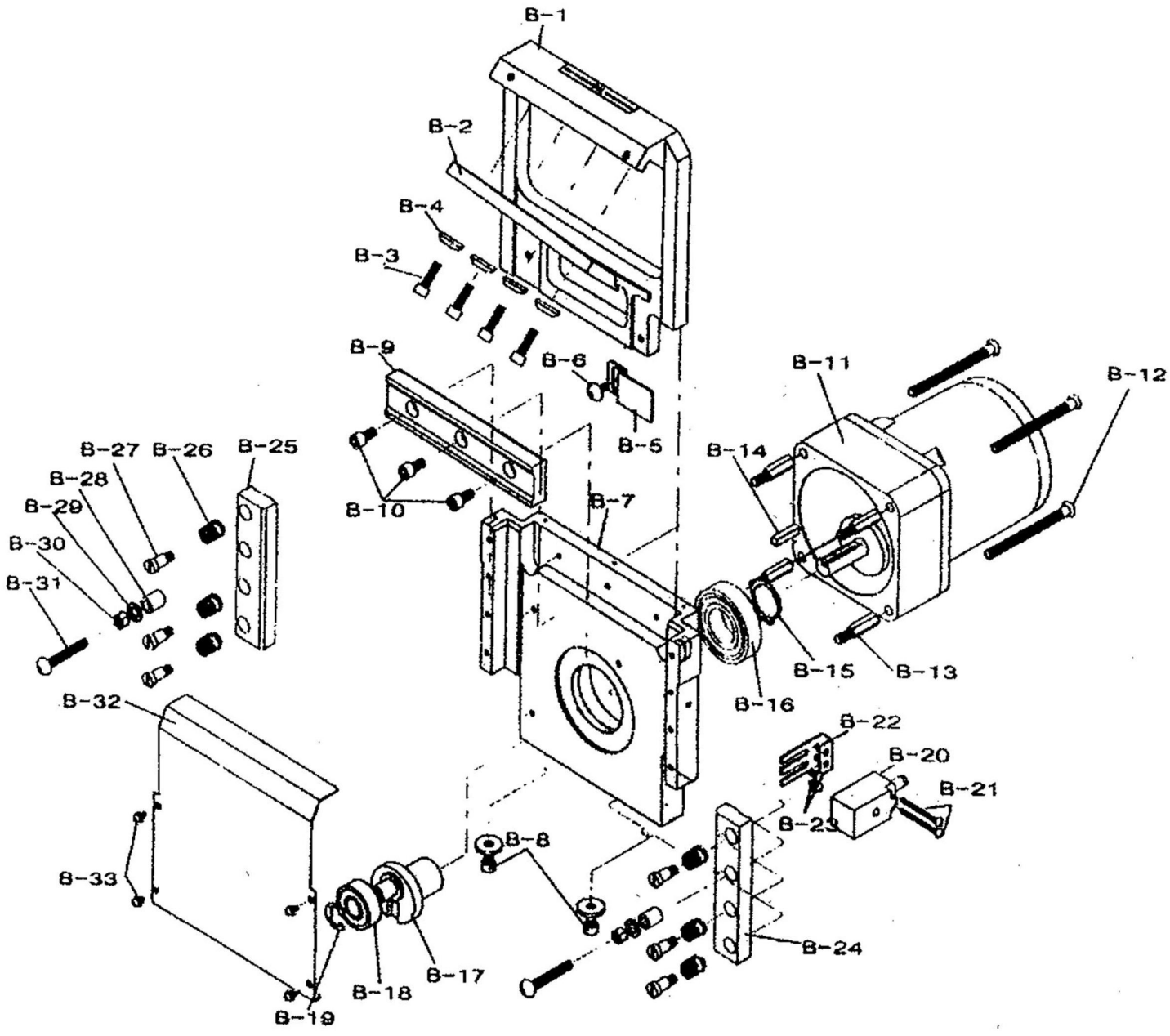
C-43

SPARE PARTS

Part No.	Decription	Part No.	Decription
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		

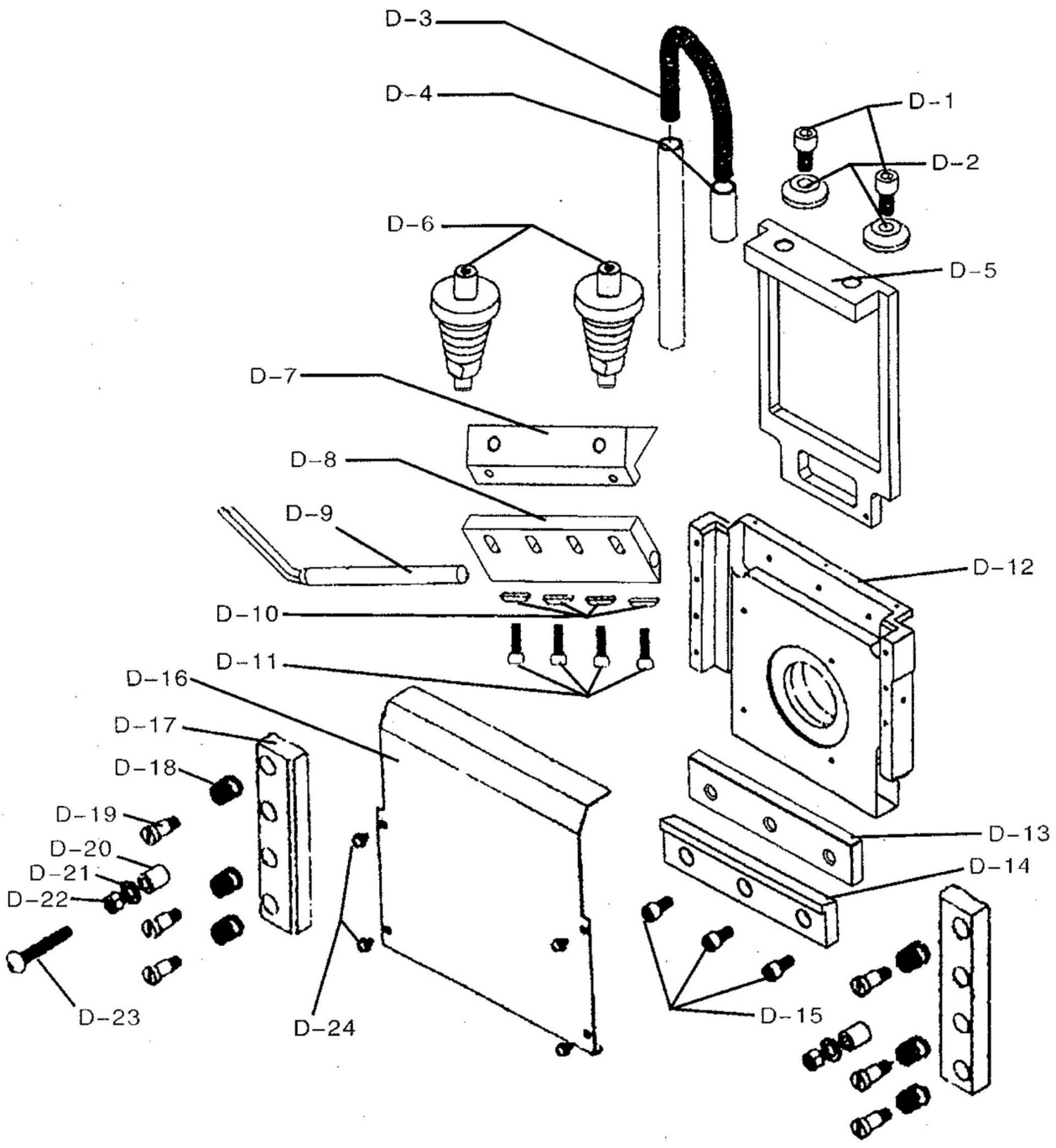
(COLD) SPARE PARTS



(COLD) SPARE PARTS

Part No.	Decription	Part No.	Decription
B-1	upper knife case	B-21	clamping bolt (M3x20L)
B-2	upper knife case	B-22	clamping bracket
B-3	wrench bolt (M5x15L)	B-23	clamping bolt (M3x15L)
B-4	neck washer	B-24	right pressure plate
B-5	couting-sensor bracket	B-25	left pressure plate
B-6	clamping bolt (M4x6L)	B-26	pressure spring
B-7	lower knife case	B-27	clamping bolt of pressure plate
B-8	wrench bolt (M5x15L)	B-28	urethane bush
B-9	lower knife	B-29	tesion-control washer
B-10	wrench bolt (M5x10L)	B-30	tension-control nut
B-11	motor+reduction gear	B-31	clamping bolt (M5x30L)
B-12	clamping bolt (M5x42L)	B-32	front cover
B-13	motor supporter	B-33	clamping bolt (M3x5L)
B-14	motor key		
B-15	snap ring		
B-16	ball bearing (#6004)		
B-17	crank bundle		
B-18	ball bearing (#6000)		
B-19	E-ring		
B-20	couting sensor		

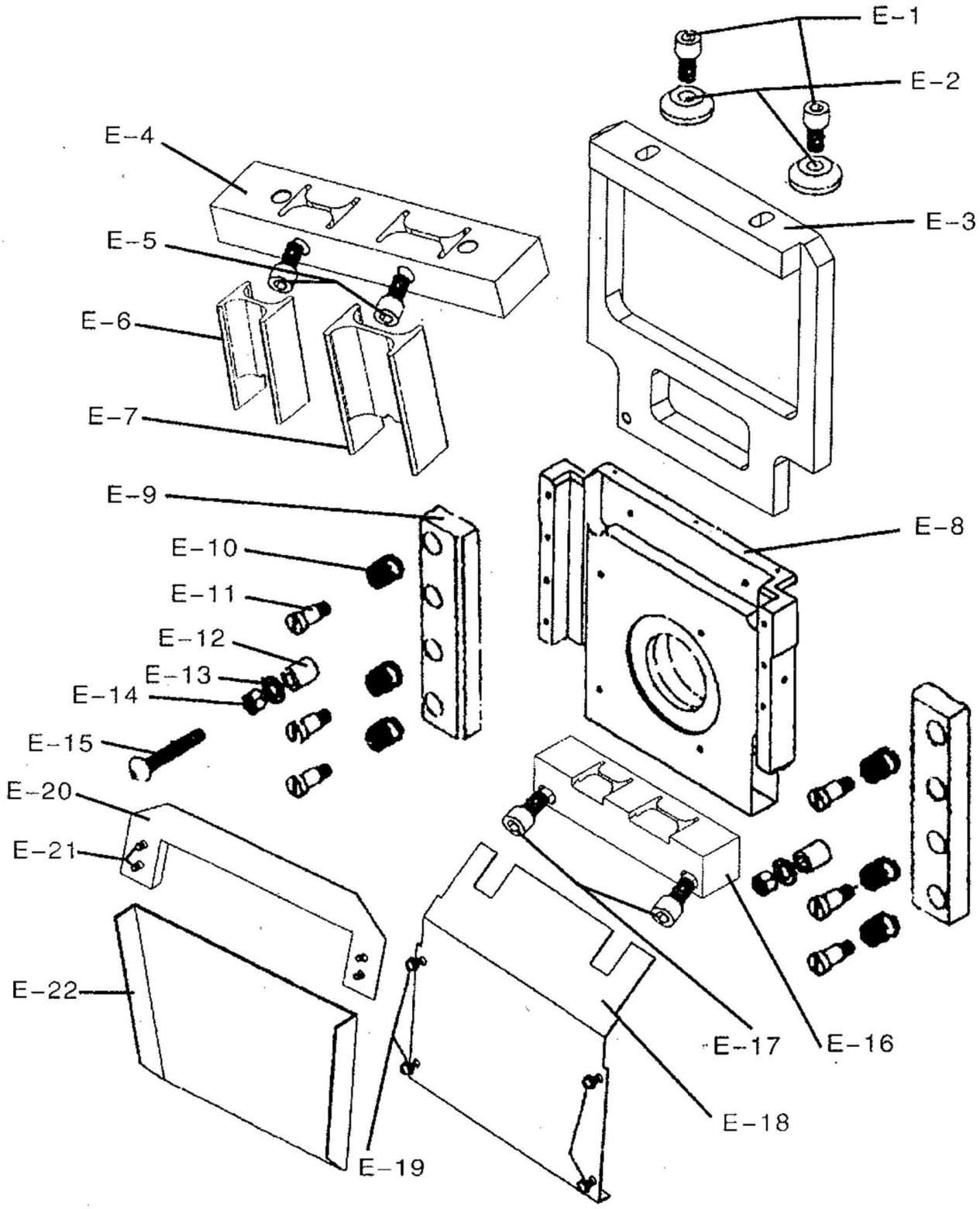
(COLD & HOT) SPARE PARTS



(COLD & HOT) SPARE PARTS

Part No.	Decription	Part No.	Decription
D-1	bolt M8x28	D-21	washer
D-2	washer	D-22	but
D-3	heating spring	D-23	bolt M5x30
D-4	heating spring	D-24	bolt M3x5
D-5	upper knife holder		
D-6	knife holder		
D-7	knife fixed block		
D-8	upper knife		
D-9	heating tube		
D-10	washer		
D-11	bolt M5x15		
D-12	lower knife holder		
D-13	lower knife packing block		
D-14	lower knife		
D-15	bolt M5x15		
D-16	bed plate		
D-17	guide way plate		
D-18	spring		
D-19	T-shape bolt		
D-20	pressing sleeve		

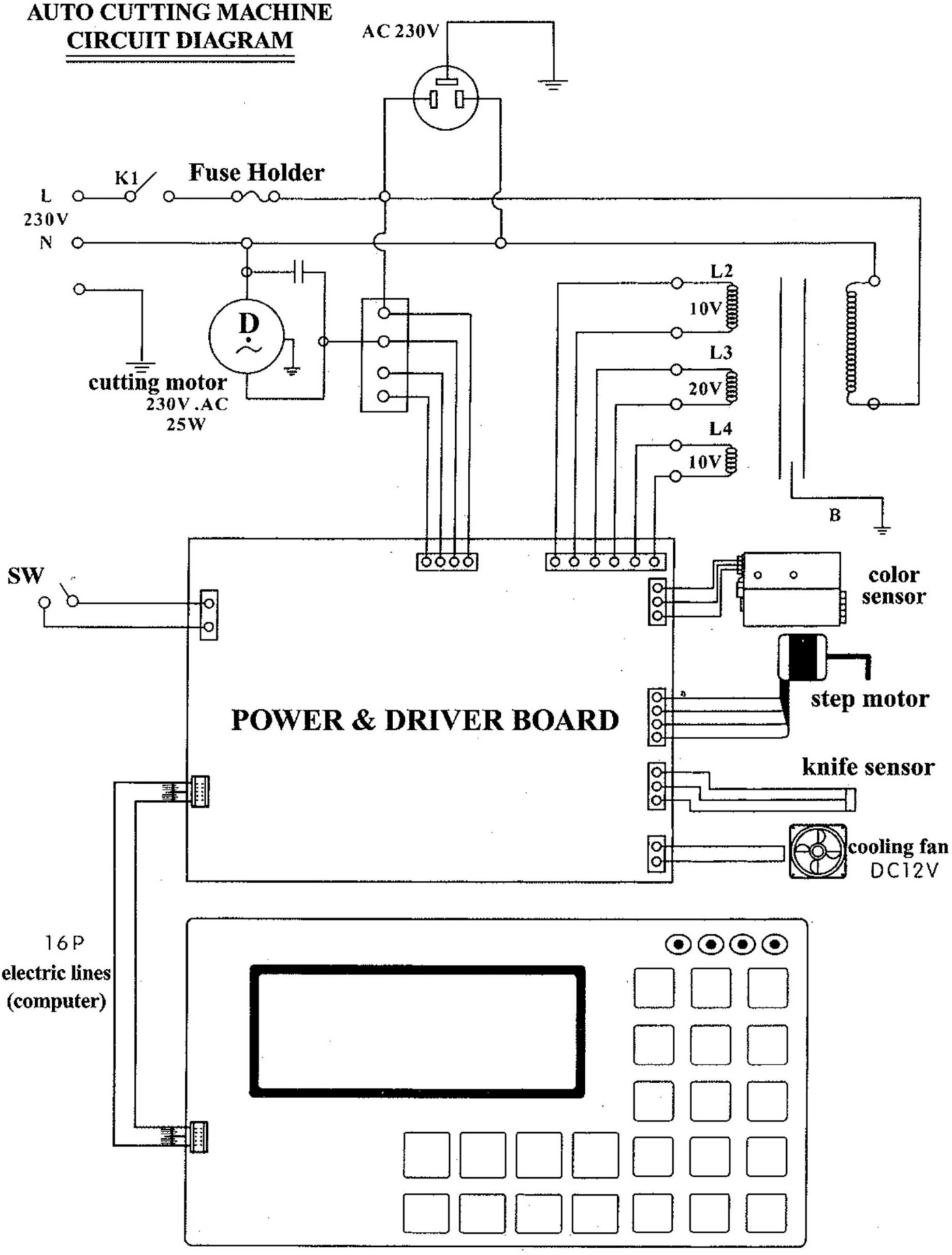
ROUD SPARE PARTS



ROUD SPARE PARTS

Part No.	Decription	Part No.	Decription
E-1	bolt M6x30	E-21	bolt M3x5
E-2	washer	E-22	material guid plate
E-3	upper knife holder		
E-4	upper cutting die soleplate		
E-5	bolt M6x12		
E-6	upper cutting die (1.5/1.0)		
E-7	upper cutting die (2.0/2.5)		
E-8	lower knife holder		
E-9	guide way plate		
E-10	spring		
E-11	T-shape bolt		
E-12	pressing sleeve		
E-13	washer		
E-14	nut		
E-15	bolt M5x30		
E-16	lower cutting die		
E-17	bolt M6x32		
E-18	front cover		
E-19	bolt M3x5		
E-20	baffle		

AUTO CUTTING MACHINE CIRCUIT DIAGRAM



BUTTON & DISPLAY