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I. Features and uses of the machine

This Leather Skiving Machine with circular knife is suitable for edge-skiving and whole surface skiving of any kind of leather as well as plastic cloth, synthetic leather, felted wool and rubber for shoes, caps, bags, garments, belts, gloves and sports goods etc, it's one of the necessary equipments which make above goods.

The machine has features of stable performance, easy operation, high productivity and long life etc.

II, Main Technical Specifications.

Rotating speed of main shaft (circular knife)	3000-3500
Skiving width	4-50mm
Size of the machine head	580 × 390 × 410mm
Net weight of the machine head	40kgs
Motor power	370W
Size of circular knife	φ117 × 54 × φ34.1

III, To prepare for using

1, Assembling

The machine head, frame and motor etc. Are packed separately. First assemble the frame, then set the motor at the. Logn hole of the frame beam, and fix it with screw. Then place the table and machine head and align their position. Tighten all screws and nust.

2. Cleaning grease dirt.

The machine is coated with anti-rust grease to prevent it from rusting before packing. But it may be through long time storage and long way transport, the grease may become hardened or dust may accumulate on it. The grease on the surface of the machine must be cleaned with gasoline and clean soft cloth after unpacking.

3. Checking the machining.

The machine may get strong shaking in the transport leading to the loosening or shifting of its parts, Check the machine completely after cleaning if. Turn the belt pulley of the main shaft with hand and observe whether the feeding wheel and grinding wheel impact the edge of the circular knife or not. If there is any impact, adjust the machine according to the method of this instruction book, make the feeding wheel and grinding wheel keep a clearance with the edge of the knife.

4. Filling oil and testing

Before starting the machine, fill oil at oil holes and moving parts, let the machine run a few minutes for testing. The belt pulley of the main shaft should turn clockwise (observe from the right of the operator).

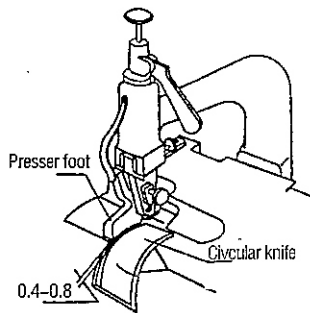


Figure 1

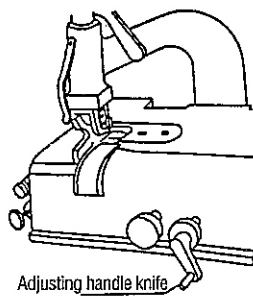


Figure 2

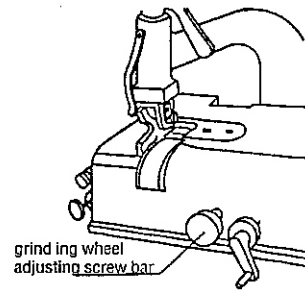


Figure 3

IV、 How to use and adjust the machine

1. To adjust the position of the circular knife.

The edge of the knife should keep a clearance about 0.4–0.8mm with the side of the presser foot.(Figure 1)This clearance is an important factor for assuring skiving quality.The edge of the knife will get dull through skiving, and need to regrind. After several times or long time regrinding, the relative position of the edge of the knife to the feeding grinding wheel and the side of presser foot will change, and can be made up by means of adjusting the axial position of the knife.

The circular knife adjustment consists of precise worm and worm wheel that can make micro Adjusting by means of turning the adjusting handle of the knife. Turn it clockwise to increase the clearance and turn it counterclockwise to decrease the clearance.(See figure 2)

2. To regrind the circular knife.

The grinding wheel of the knife rotates when the machine works normally, so the edge of the knife can be regrind continually. Also can regrind it after the edge of the knife gets dull. When turn the adjusting screw bar of the grinding wheel counter-clockwise, the grinding wheel closes to the edge of knife and does grinding;turn the the adjusting screw bar clockwise, the grinding wheel leaves the edge of the knife and stop grinding.(See Figure 3)

Caution: When grinding the edge of knife, the grinding wheel should advance slowly to prevet the grinding wheel from impacting the edge of the knife, leading to destroy the girnding wheel or the edge,even work accidents.

3. To adjust height and center of the feeding wheel arc.

The feeding wheel has two functions. The main one is feeding material,another grinding

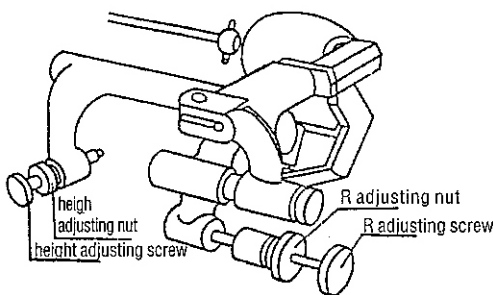


Figure 4

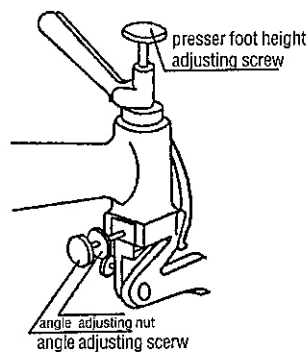


Figure 5

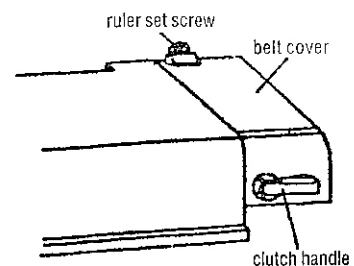


Figure 6

burrs of the inner side of the knife. The R center of the feeding wheel should be identical with the R center of the knife. This will do great good to the material and grinding the knife. The R centres should be adjusted if they are not on the same axis. The method is: loosen the R adjusting nut of feeding wheel, turn the R adjusting screw bar of feeding wheel when the clearance is big between the inner diameter of the knife and the right side of feeding wheel. Turn the adjusted by means of loosening the adjusting nut, and turning the adjusting screw bar clockwise, on the contrary side, turn the adjusting screw bar counter-clockwise until the clearance is consistent between the feeding wheel R and both sides of the inner diameter of the knife. Then retighten the adjusting nut R.

The outer diameter of the feeding wheel should connect the inner diameter of the knife. The big clearance between them will cause unsmooth feeding and poor quality skiving. The over interference will destroy the knife. The height of the feeding wheel is adjusting screw bar, turn clockwise to increase the height, turn counter-clockwise to decrease the height, and tighten the height adjusting nut to adjust their connect. (Figure 4)

4. To adjust the height and angle of the presser foot.

(a). To adjust the height of the presser foot.

To do heavy leather skiving or small volume skiving, it is to increase the height of the presser foot. And to do light leather skiving or big volume skiving, it is to decrease the height of the presser foot. The height of the presser foot is adjusted by means of adjusting the presser foot adjusting screw bar. Turn it clockwise to decrease the height, turn it counterclockwise to increase the height.

(b). To adjust the angle of the presser foot.

To do big width and small angle edge skiving, the angle between the presser foot and the circular knife should be small. Under the contrary conditions. The angle should be big. The height of the angle is adjusted by means of loosening the angle-adjusting nut of the presser foot and turning the angle adjusting screw bar. Turn it clockwise to increase the angle. And turn it counter-clockwise to decrease the angle. After the required angle is adjusted, retighten the adjusting nut. (See Figure 5)

5. To adjust the blocking board.

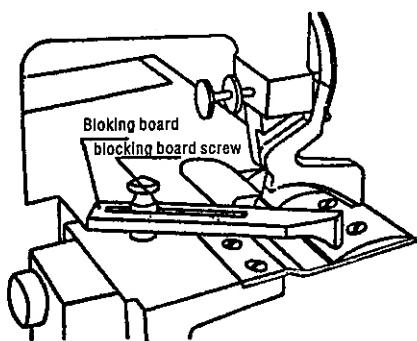


Figure 7

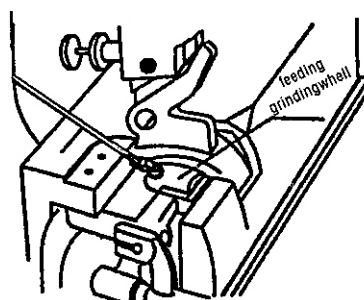


Figure 8

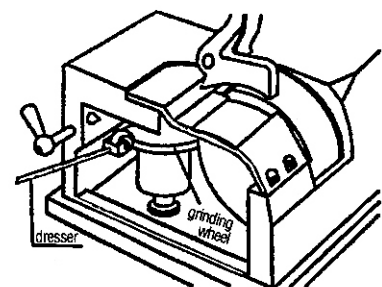


Figure 9

The blocking board takes a role of limiting the width of skiving. Move it to the operator to decrease the width of skiving, under the contrary conditions, move it to another direction. The position of the blocking board is adjusted by the screw. (See Figure 7)

6.To adjust skiving speed.

The leather skiving machine with the circular knife has two or three speeds to choose depending on the operator skill and the skiving material. To adjust the speed, first open or take away belt cover, slide the belt into the required skiving speed with screw driver, right side is low speed and left is high speed. (See Figure 6)

V. To dress the grinding wheel.

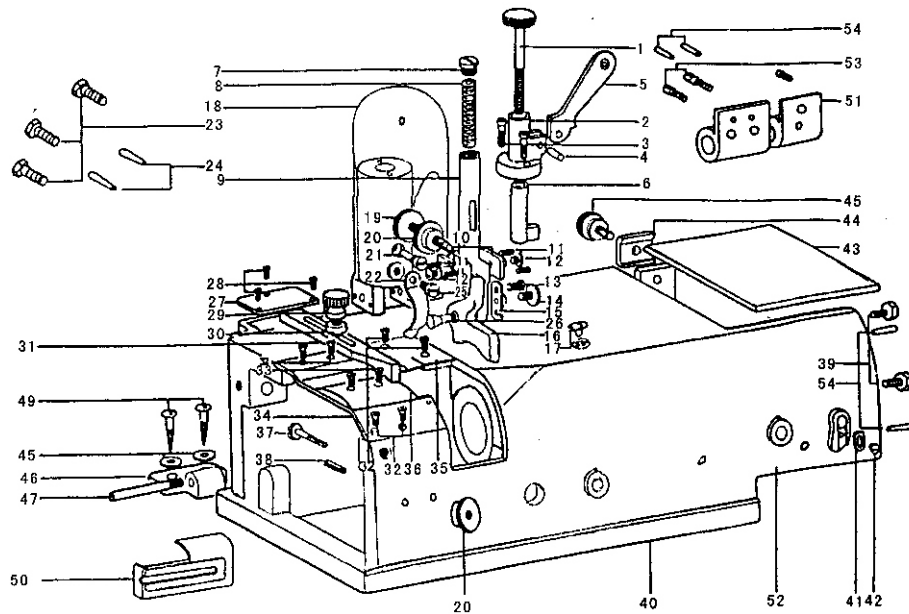
1 .To dress the feeding grinding wheel.

After long time use, various kinds of the skiving chips are stuck on the surface of the feeding wheel, weaken feeding friction force, lead to unsmooth feeding. To resume normal feeding, the surface of the feeding wheel must be dressed with grinding wheel dresser. First remove the feeding sliding plate to let the feeding wheel lie bare, switch on the machine, aim the dresser at the feeding wheel. The teeth of the dresser rotate with feeding wheel and move left and right. Until the surface of the feeding wheel become sharp. (See Figure 9)

2.To dress the grinding wheel

After regrinding the edge of the knife several times, grinding chips of metal and the grinding wheel are stuck on its surface, weaken grinding speed and quality. So its surface must be dressed with the grinding wheel dresser.

1、PRESSER FOOT AND OUTER ATTACHMENTS

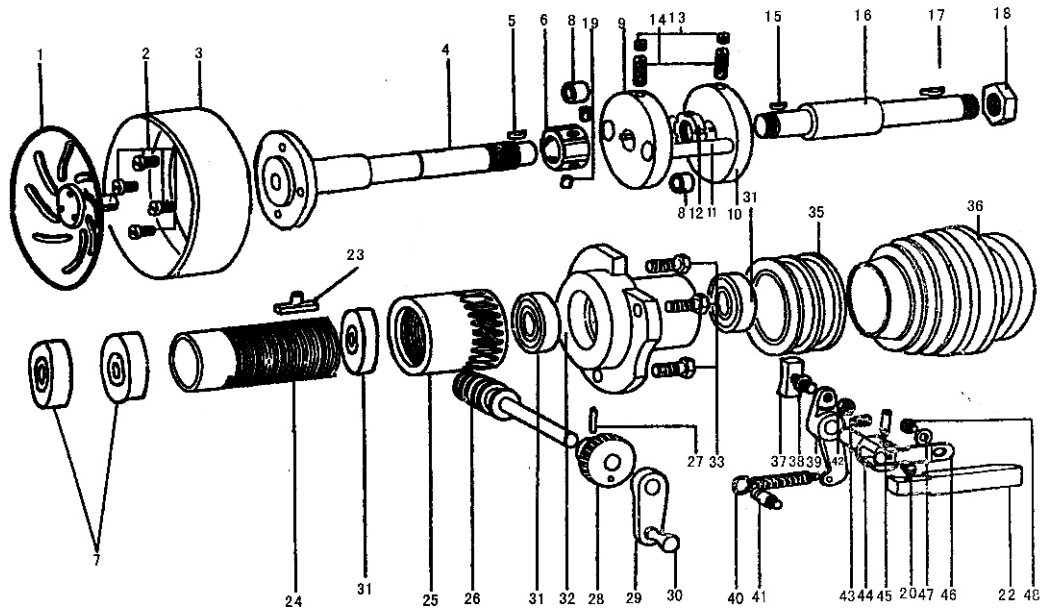


图一

Item	Part No.	Description	Qty
1	801-1-1	Presser bar adjusting screw	1
2	801-1-2	Press bar lifter bracket	1
3	801-1-3	Presser bar lifter rbracket screws	2
4	801-1-4	Press bar lifer pin	1
5	801-1-5	Presser bar lifter	1
6	801-1-6	Presser bar lifter lever	1
7	801-1-7	Presser bar cover screw	1
8	801-1-8	Presser bar spring	1
9	801-1-9	Presser bar	1
10	801-1-10	Presser foot side plates	2
11	801-1-11	Presser footside platesadjusting screw	4
12	801-1-12	Presser footside plate screw	1
13	801-1-13	Prsser foot shaft hook metal hing screw	1
14	801-1-14	Prsser foot shaft hook metal set screw	1
15	801-1-15	Prsser foot shaft hook metal	1
16	801-1-16	Presser foot	1
17	801-1-17	Oil cap	1
18	801-1-18	Arm	1
19	801-1-19	Presser foot adjusting screw	1
20	801-1-20	Presser foot adjustable screw nuts	2
21	801-1-21	Presser bar spring pin	1
22	801-1-22	Presser foot spring	1
23	801-1-23	Inner heaxagon screw	1
24	801-1-24	Tape pin	1
25	801-1-25	Presser foot spring screw	1
26	801-1-26	Presser foot shaft	1
27	801-1-27	Worm chamber plate	1

Item	Part No.	Description	Qty
28	801-1-28	Flat screw	1
29	801-1-29	Ruler set screw	1
30	801-1-30	Ruler set screw washer	1
31	801-1-31	Ruler	1
32	801-1-32	Slide plate screws	6
33	801-1-33	Slide plate screws	2
34	801-1-34	Slide plate A	1
35	801-1-35	Slide plate B	1
36	801-1-36	Slide plate C	1
37	801-1-37	Waste feeder screw	1
38	801-1-38	Waste feeder stop pin	1
39	801-1-39	Hexagon slotted screw(base plate)	2
40	801-1-40	Bed	1
41	801-1-41	Belt cover plate	1
42	801-1-42	Belt cover plate screw	1
43	801-1-43	Belt cover lid	1
44	801-1-44	Belt cover lid spopper	1
45	801-1-45	Ruler set screws	1
46	801-1-46	Hinges	1
47	801-1-47	Hinges pins	2
48	801-1-48	Hinge set screw washers	2
49	801-1-49	Hinge set screws	4
50	801-1-50	Waste feeder metals(set)	4
51	801-1-51	Transnission shaft	1
52	801-1-52	Base plate	1
53	801-1-53	Set screw(transmission shaft)	2
54	801-1-53	Tape pin	4

2、KNIFE AND RELATED PARTS



图二

Item	Part No.	Description	Qty
1	801-2-1	Leather peeler cover	1
2	801-2-2	Knife ste screws	4
3	801-2-3	Knife	1
4	801-2-4	Knife shaft	1
5	801-2-5	Knife shaft key	1
6	801-2-6	Knife shaft nuts	2
7	801-2-7	Bearing	1
8	801-2-8	Rubber bushings	2
9	801-2-9	Pulley shaft flange holder	1
10	801-2-10	Pulley shaft flange	1
11	801-2-11	Flange shafts	2
12	801-2-12	Pulley shaft flange nut	1
13	801-2-13	Pulley shaft flange screw(b)	2
14	801-2-14	Pulley shaft flange screw(a)	2
15	801-2-15	Pulley shaft dey(small)	1
16	801-2-16	Pulley shaft	1
17	801-2-17	Pulley shaft key(large)	1
18	801-2-18	Hexagonalnut(a)	1
19	801-2-19	Knife shaft keg screws	2
20	801-2-20	Cluch lever spring screw	1
22	801-2-22	Clutch lever	1
23	801-2-23	Knife shaft lead pipe dey	1
24	801-2-24	Knife shaft lead pipe	1

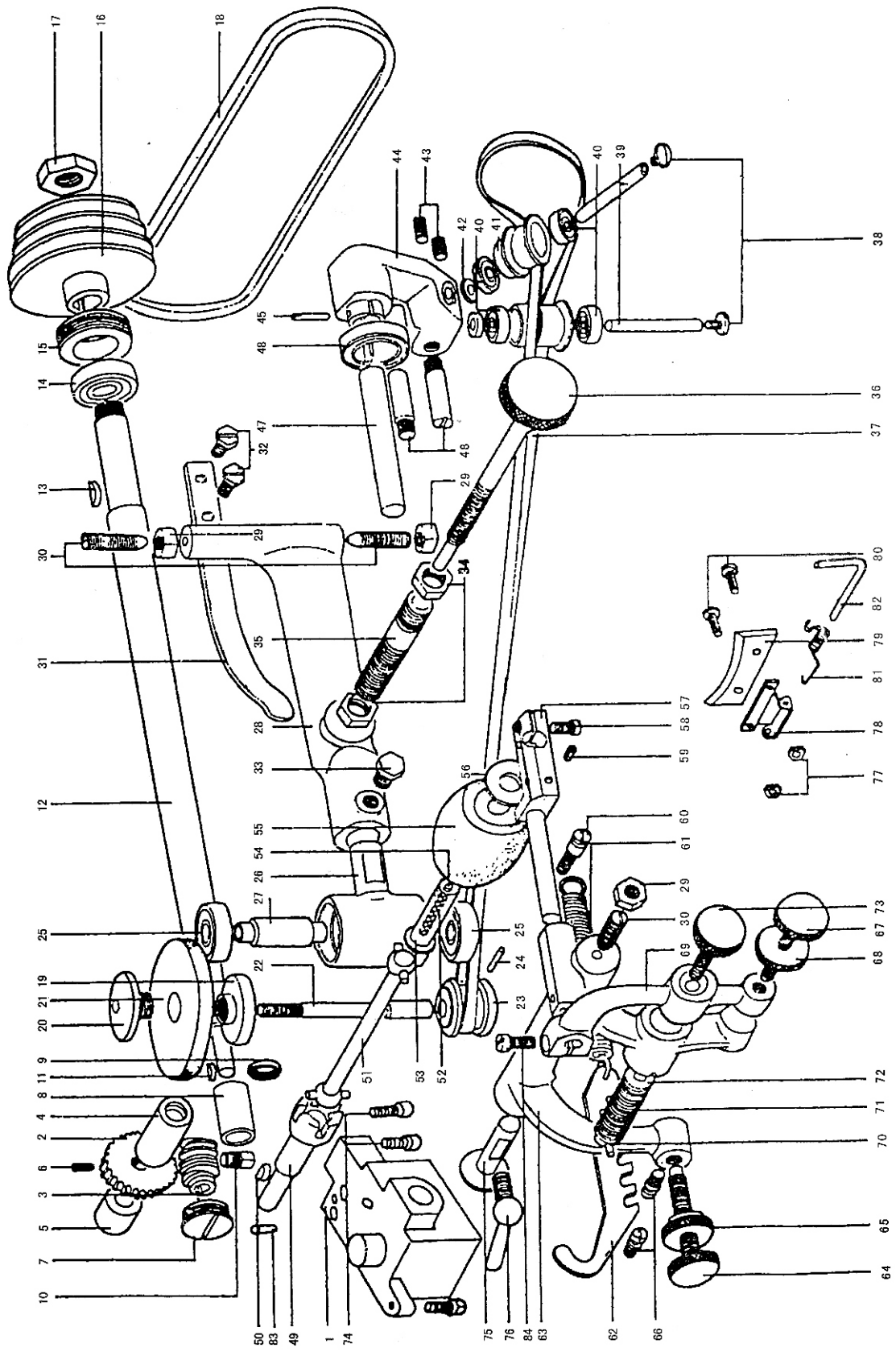
Item	Part No.	Description	Qty
25	801-2-25	Knife shaft worm wheel	
26	801-2-26	Knife shaft worm	
27	801-2-27	Tape pin	1
28	801-2-28	Knife adjusting knob	1
29	801-2-29	Knife adjusting handle	1
30	801-2-30	Knife adjusting handle knob	1
31	801-2-31	Pulley shaft bearings	3
32	801-2-32	Pulley shaft metal	1
33	801-2-33	Pulley shaft metal screws	1
35	801-2-35	Clutch	1
36	801-2-36	Pulley	1
37	801-2-37	Clutch side block	1
38	801-2-38	Clutch side block screw	1
39	801-2-39	Clutch arm	1
40	801-2-40	Clutch spring	1
41	801-2-41	Clutch spring hook	1
42	801-2-42	Clutch side block screw nut	1
43	801-2-43	Clutch lever screw	1
44	801-2-44	Clutch lever shaft	1
45	801-2-45	Clutch arm screw	1
46	801-2-46	Clutch arm spring	1
47	801-2-47	Clutch lever spring waser	1
48	801-2-48	Clutch lever spring hinge screw	1

3. GRINDSTONE AND ROLLER RELATED PARTS

Ltem	Part No.	Description	Qty
1	801-3-1	Warm wheel box	1
2	801-3-2	Main shft worm gear wheel	1
3	801-3-3	Main shft worm gear	1
4	801-3-4	Roller diving shaft meal(1)	1
5	801-3-5	Roller diving shaft metal(2)	1
6	801-3-6	Main shft worm gear wheel screw	1
7	801-3-7	Main shft worm gear wheel chamber cover screw	1
8	801-3-8	Main shaft front bushing	1
9	801-3-9	Main shaft worm gear chamber oil seal	1
10	801-3-10	Main shaft worm gear chamber screw	1
11	801-3-11	Main shaft key(1)	1
12	801-3-12	Main shaft	1
13	801-3-13	Main shaft key(2)	1
14	801-3-14	Main shaft bearing	1
15	801-3-15	Main shaft deaning holder screw	1
16	801-3-16	Main shaft pulley	1
17	801-3-17	Hexagonal unt B	1
18	801-3-18	Main shaft belt	1
19	801-3-19	Grindstone set screw	1
20	801-3-20	Grindstone set screw unt	1
21	801-3-21	Grindstone	1
22	801-3-22	Grindstone shaft	1
23	801-3-23	Grindstone shaft pulley	1
24	801-3-24	Grindstone shaft pulley taper pin	1
25	801-3-25	Grindstone shaft bearing	2
26	801-3-26	Grindstone shaft bracket	1
27	801-3-27	Grindstone shaft bearing roller	1
28	801-3-28	Grindstone shaft bracket arm	1
29	801-3-29	Grindstone shaft bracket arm center screw nat	3
30	801-3-30	Grindstone shaft bracket arm ceter screws	3
31	801-3-31	Grindstone shaft bracket arm spring	1
32	801-3-32	Grindstone shaft bracket arm spring screws	2
33	801-3-33	Grindstone shaft bracket screw	1
34	801-3-34	Grindstone adjusting screw pipe nuts	1
35	801-3-35	Grindsone adjusting screw pipe	1
36	801-3-36	Grindstone adjusting screw	1
37	801-3-37	Grindstone shaft belt	1
38	801-3-38	Belt guide pulley screws	2
39	801-3-39	Belt guid pulley shafts	2
40	801-3-40	Belt guid pulley bearing	4
41	801-3-41	Belt guid pulleys	2
42	801-3-42	Belt guid pulley washers	2

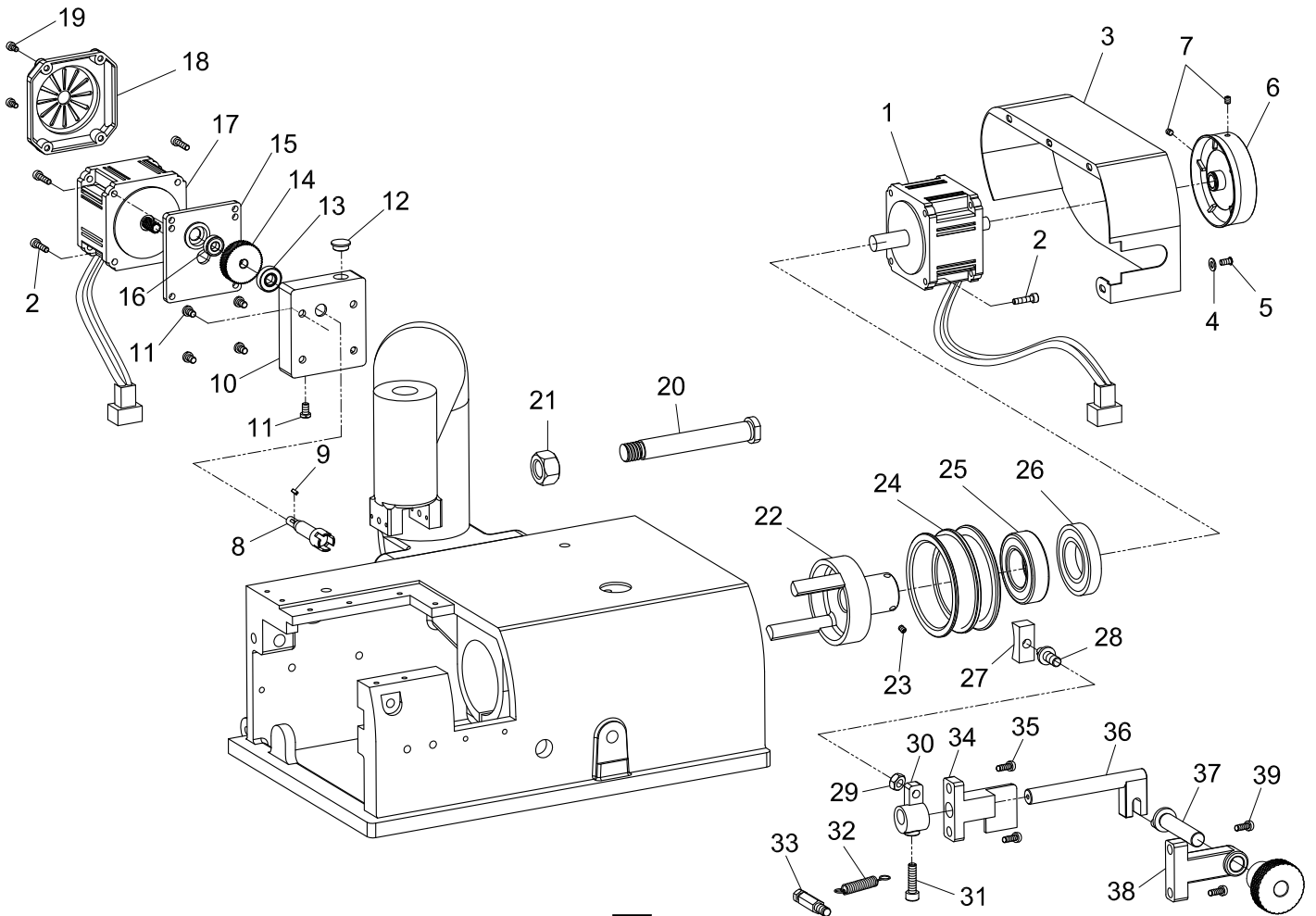
Ltem	Part No.	Description	Qty
43	801-3-43	Belt guide pulleg shaft surews	3
44	801-3-44	Belt guide bracket	1
45	801-3-45	Belt guide bracket	1
46	801-3-46	Belt guide bracket string	1
47	801-3-47	elt guide bracket shaft	1
48	801-3-48	Belt guide bracket turing stoppers	2
49	801-3-49	Roller drivring shaft	1
50	801-3-50	Roller driving shaft key	1
51	801-3-51	Roller driving shaft joint	1
52	801-3-52	Roller shaft oik wick	1
53	801-3-53	Roller shaft	1
54	801-3-54	Roller shaft oil seal plug	1
55	801-3-55	Roller	1
56	801-3-56	Roller washer	1
57	801-3-57	Roller bracket	1
58	801-3-58	Roller shaft screw	1
59	801-3-59	Waste clear metal shaft screw	1
60	801-3-60	Roller bracket arm spring hooks(2)	1
61	801-3-61	Roller bracket arm spring	1
62	801-3-62	Roller bracket arm spring hooks metal	1
63	801-3-63	Roller bracket arm	1
64	801-3-64	Roller bracket arm adjusting screw	1
65	801-3-65	Roller bracket arm adjusting screw	1
66	801-3-66	Roller bracket arm spring hooks(1)	2
67	801-1-19	Roller bracket turning arm adjusting screw	1
68	801-1-20	Roller bracket turning arm adjusting screw nut	1
69	801-3-70	Roller bracket turning arm	1
70	801-3-71	Roller bracket turning arm spring stopper	1
71	801-3-72A	Roller bracket rurning arm spring	1
72	801-3-72B	Roller bracket turning arm spring adjusting nut	1
73	801-3-73	Roller bracket turning arm spring adjusting screw	1
74	801-1-53	Set screw	1
75	801-3-75	Roller bracket arm center pin	1
76	801-3-76	Roller bracket arm cmter pin screw	1
77	801-3-77	Waste cler metal leather unts	2
78	801-3-78	Waste clear metal	1
79	801-3-79	Waste clear metal leather	1
80	801-3-80	Waste clear metal leather screws	2
81	801-3-81	Waste clear metal spring	1
82	801-3-82	Waste clear metal shaft	1
83	801-3-83	Tape pin	1
84	801-3-84	Roller shaft screw	1

3. GRINDSTONE AND ROLLER RELATED PARTS



图三

4、马达控制系统



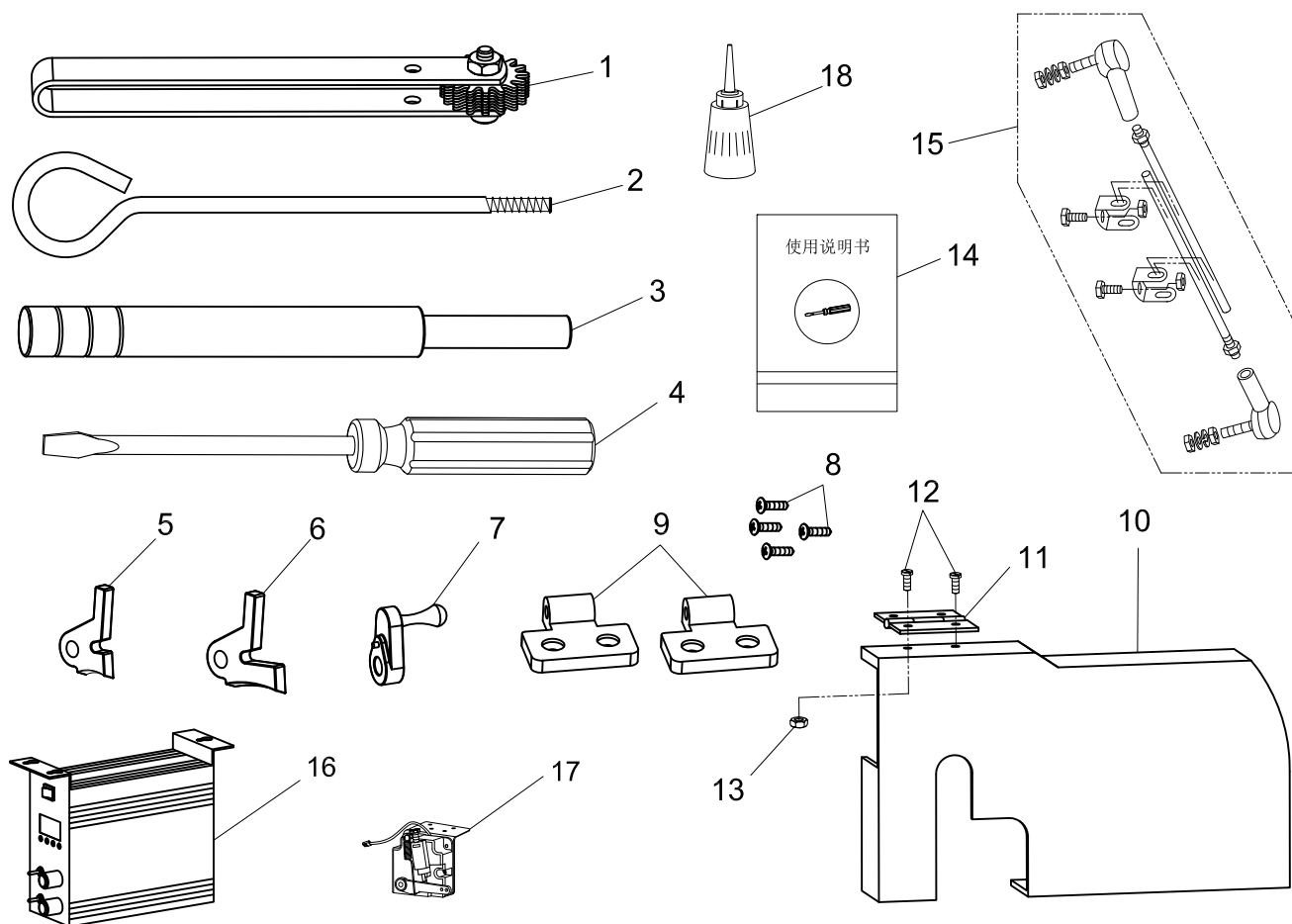
图四

序号	图号	名称	数量
1	801-4-1	Spindle motor	1
2	801-4-2	Screw M5 L=20	8
3	801-4-3	Housing	1
4	801-4-4	Gaskrt M5	4
5	801-4-5	Screw M5 L=10	4
6	801-4-6	Hsndwheel	1
7	801-4-7	Screw M5 L=6	2
8	801-4-8	Transmission shaft	1
9	801-4-9	Woodruff key	1
10	801-4-10	Gear case	1
11	801-4-11	Screw M5 L=2015/64x28	5
12	801-4-12	Rubber plug	1
13	801-4-13	Bearing	1
14	801-4-14	Gear	1
15	801-4-15	Gear case plate	1
16	801-4-16	Bearing	1
17	801-4-17	Feed motor	1
18	801-4-18	Motor cover	1
19	801-4-19	Screw M4 L=10	2
20	801-4-20	Bridge belt shaft	1

序号	图号	名称	数量
21	801-4-21	Nut	1
22	801-4-22	COUPLING	1
23	801-4-23	Screw M5 L=6	3
24	801-4-24	Clutch	1
25	801-4-25	Bearing	1
26	801-4-26	Bearing	1
27	801-4-27	Gommures	1
28	801-4-28	Screw	1
29	801-4-29	Nut	1
30	801-4-30	Shift fork seat	1
31	801-4-31	Screw	1
32	801-4-32	Spring	1
33	801-4-33	Spring post	1
34	801-4-34	Soleplate	1
35	801-4-35	Screw	2
36	801-4-36	Actusting shaft	1
37	801-4-37	Eccentric shaft	1
38	801-4-38	Eccentric shaft Soleplate	1
39	801-4-39	Screw	2



5、ACCESSORIES



图五

序号	图号	名称	数量
1	801-5-1	Grinding wheel dresser	1
2	801-5-2	Knife cover remover	1
3	801-5-3	Sand stick	1
4	801-5-4	Slot type screwdriver	1
5	801-5-5	Presser foot (20mm)	1
6	801-5-6	Presser foot (40mm)	1
7	801-5-7	Knife crank	1
8	801-5-8	Wood screw	4
9	801-5-9	Head hinge	2
10	801-5-10	Plastic housing	1

序号	图号	名称	数量
11	801-5-11	1.5 Inch hinge	1
12	801-5-12	Screw M3	2
13	801-5-13	Nut M3	2
14	801-5-14	Specification	1
15	801-5-15	Tie rod assembly	1
16	801-5-16	Electrical control box	1
17	801-5-17	Speed controller	1
18	801-5-18	Cadger	1

