GLOBAL

CA 900

Instruction Manual

www.globalsew.com

info@globalsew.com

Ⅰ.Uses and characteristics.

1.It is suitable for cutting various kinds of cloth,sponge and leather.

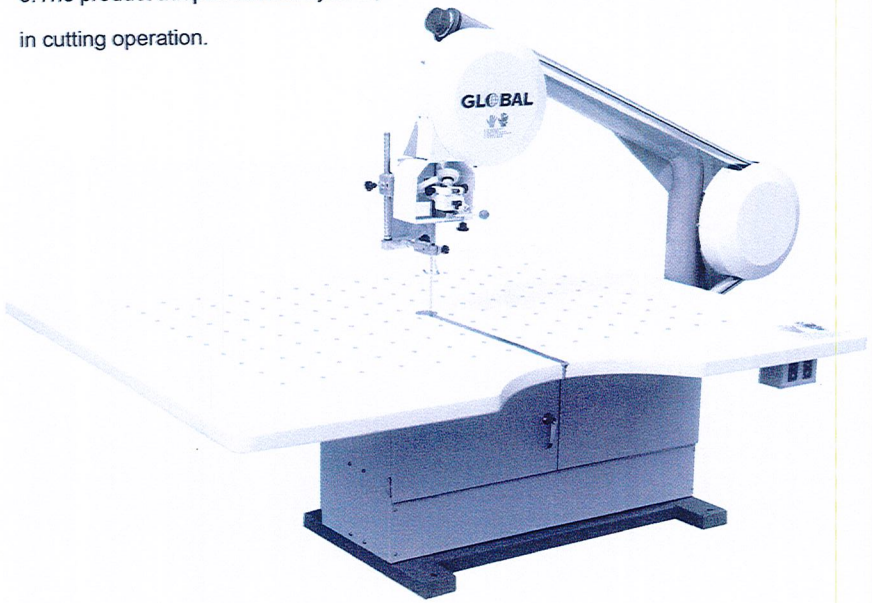
2.It is easy to operate.

3.The contacting parts of driving pulley and band knife are made of wear-resisting material, and thus resulting long service life and low noises.

4.Driving pulley adopts large diameter(Φ300mm)design to protect band knife from being broken.

5.Stepless speed adjusting by converter ,it is easy to change cutting speed.

6.The product adopts cushion system,and the material can be moved smoothly and flexibly in cutting operation.



Ⅱ.Description of all parts.(Fig.1,2,3)

NO.	Description
1	machine frame
2	long guard pipe
3	lower guard
3A	stroke
4	short guard pipe
5	digital keypad
6	switch box
6A	switch
7	height adjusting screw
8	machine support mounting pad
9	movable roller
10	front cover
11	machine support
12	metal plate of table
13	metal plate with holes
14	table support
15	cutting table
16	guide blpck
17	grinding wheel device
18	upper guard
18A	stroke
19	tension bar
20	tension box
20A	switch
21	converter
22	main motor
23	band knife
23A	stroke
24	blower
25	driving wheel

Stroke(3A.18A)adjusted on the inside of hoodshield(3.18)

Ⅲ.Installation.(Fig.4,5)

1. Align holes in table(3-1)with nuts(3-2)on machine support,then retighten screws(3-3)to lock nuts.

2. Loosen nut (9-2),turn screw 9 to set the table to required height.Then retighten nut.

3. Loosen nut (4-2),turn screw 4-1 of table support until the table rest on the support bar.Then re-tighten nut(4-2).

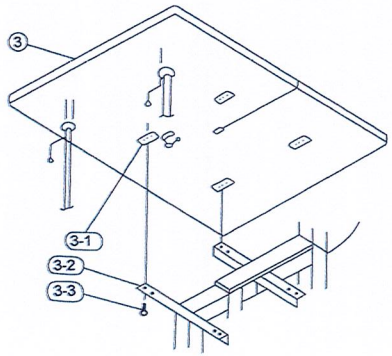


Fig.4

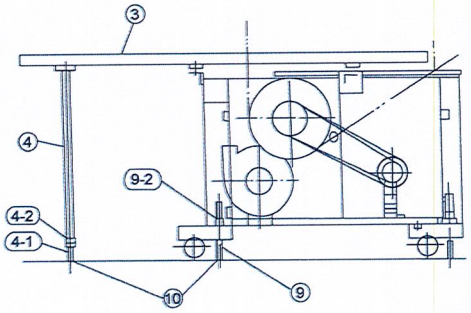


Fig.5

Ⅳ.Operation.

1.Depends on thickness of materials,rotate rotary button to adjust guide block and protection device to the lowest position(Fig.6).

2.Turn on the band knife and blower with switches in boxes located at the right side beneath the table on.

3.Press down the material to cut with hands,and make it contact with band knife.Move the material all around to achieve the desired forms.

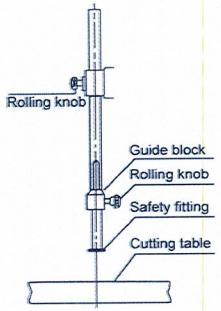


Fig.6

Notice:

1. Take care of the band knife in operation.

2. Do preparing for the next cutting process only with the machine turner off.

Ⅴ.Grinding.

1.Grinding the knife when the knife becomes dull and the blade is dirty.

2.As shown in Fig.7,pull the grinder lever to start grinding.

3.If the grinding wheel is unable to reach the band knife after pulling the grinder lever,then loosen the nut,and turn the wing screw to make the mat move forward a little way (Fig.8).

Notice: Only a little way should be moved,or the band knife will be pressed by the grinding wheel,it is impossible to grind the knife.

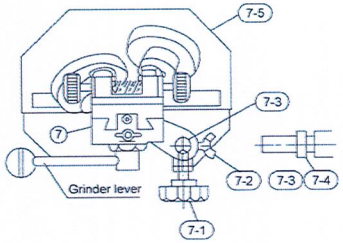


Fig.7

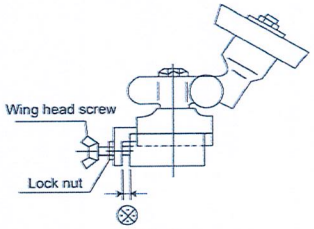


Fig.8

4. If the blade is ground unevenly as shown in Fig.9,then adjust the two grinding wheels left or right by turning the two knurled screws (7-6) shown in Fig.10.The arrows in Fig.9 indicate the moving direction of the grinding wheels.

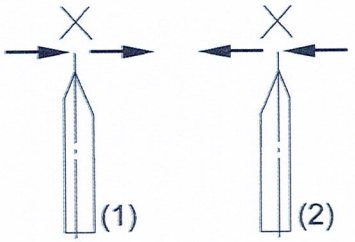


Fig.9

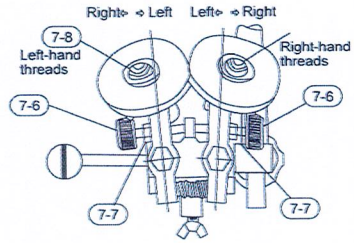


Fig.10

5. Generally,the angle between two blades should be small for thin materials,and the angle should be big for heavy materials.Referto Fig.10 for details,and the small arrow indicates the moving direction of two grinding wheels.

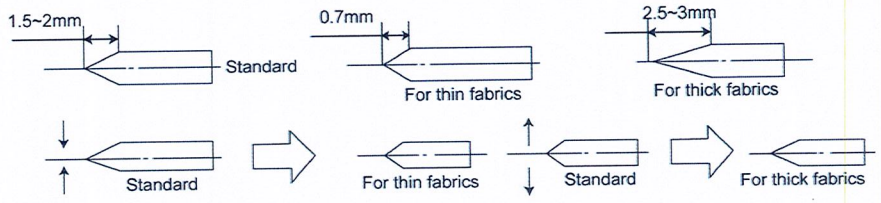


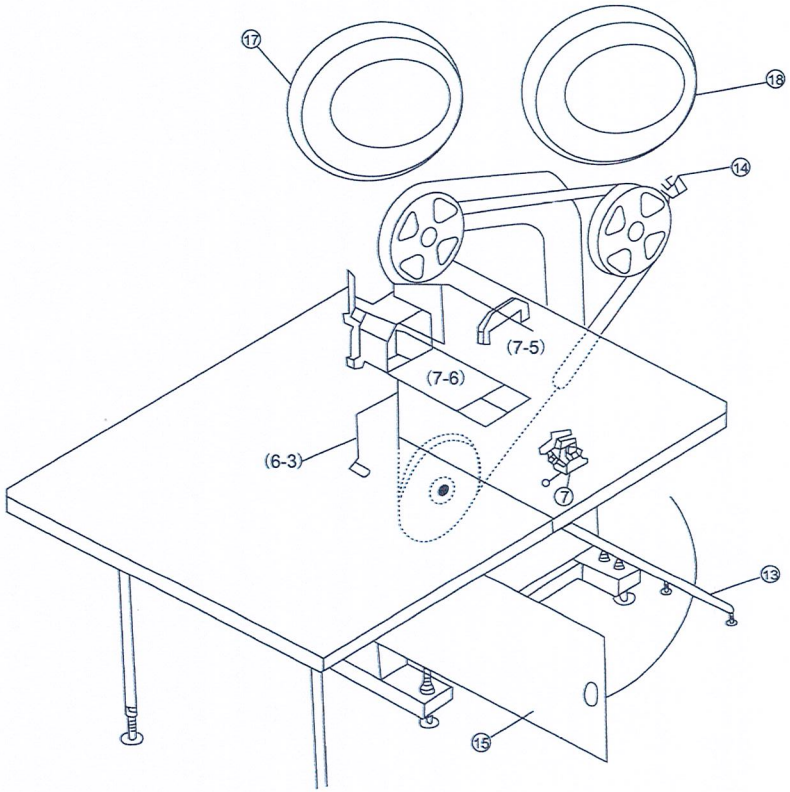
Fig.11

6. The worn grinding wheels can be used continuously by moving them closely.

7. If the knife is not ground though the grinding wheels has been adjusted correctly.The gringding wheels are worn out and should be replaced.Loosen nuts shown in Fig.10 to replace.

VI.Replacement of the band knife

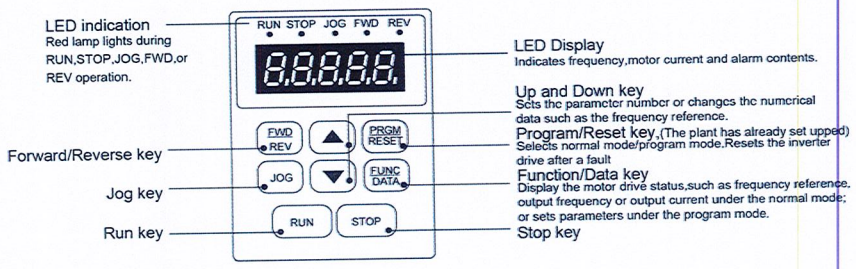
1. The knife should be replaced when the width of the knife is reduced to smaller than 5 mm by several times ground.
2. Remove two round guard covers 17 and 18(Fig.12)on the machine frame.
3. Remove front cover,guide block and protection device of the grinding device
4. Loosen the wing nut beneath the machine table to pull out strip plate 13.
5. Rotate the tension bar 19(Fig.2)to make the band knife loose for replacing.



VII .LC-A05E/LC-A10E Digital keypad operation

1. Description and Function of the Digital Keypad

When delivered from the factory ,the digtal keypad module is mounted on the front panel of the AC drive.This module has two parts： a display panel and a keypad.The display panel allows the uesr to program the AC drive,as well as view the different operating parameters.The keypad is the user interface to the AC motor drive.Refer to the following figure for a description of the different parts.



PRGM RESET

Program/Reset

The plant has already set upped,according to this key , it is invalid.

FUNC DATA

Function/Data

Displays information on the AC drive status such as the reference frequency,output frequency,or output current in the normal mode.Whie the drive is in the Prohram Mode,press this key once to display the current parameters.After changing the parameters,press this key again to store the new parameters.

FWD REV

Forward/Reverse

Used to toggle between forward and reverse operation.

Pressing this key will cause the motor to ramp down to 0 Hz and then ramp up to the preset speed in the opposite direction.By defaut,the digital keypad controls the AC drive forward/reverse operation.To control the forward /reverse operation via the control terminal block,change the Pr.01 parameter to "d0001" or"d0002".

JOG

JOG

Used to start the AC drive ,then run at the jog frequency as set by the parameter specified under Pr.23 [Jog Frequency].

RUN

RUN

Used to start the AC drive operation.This key has no effect when the drive is set to terminal run.

STOP

STOP

Used to stop the AC drive operation.

▲

▼

Up/Down

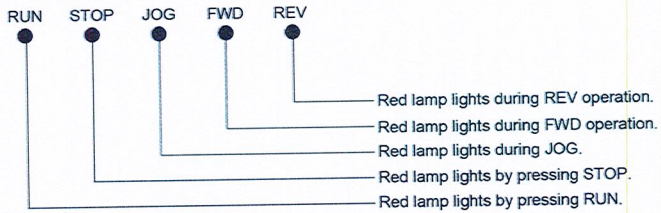
Press the Up or Down button to change parameter settings.These keys may also be used to scroll through different operating values or parameters.

Note:Pressing the ▲ or ▼ button momentarily changes the parameter settings in increments.Press and hold down either of these keys to rapidly run through the possible settings.

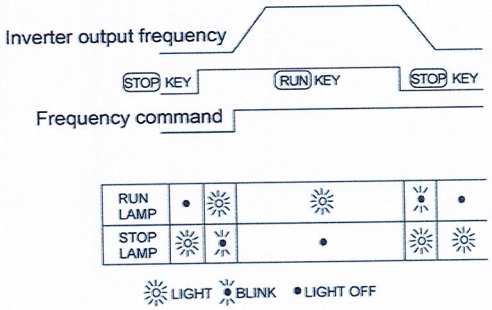
•Explanation of Displayed Messages

Display Message	Description
F 60.0	Displays the AC drive output frequency controlled by the Maximun Output Frequency(Pr.03),Jog Frequency(Pr.16),or by the Multi-Function Input Terminals (Pr.39-41).If the frequency source originates from the Digital keypad,the user can use either the ▲ or ▼ key to set the frequency.
H 88.8	Displays the output frequency present at terminalsU,V,and W.
u888.8	Displays the custom unit(V), where V=H×Pr.65
c888.8	Displays the internal counter value(C).
A 8.8	Displays the output current present at terminalsU,V,and W.
Pr.-88	Displays the specified parameter number.The actual parameter value may be displayed by pressing the FUNC DATA key.
d888.8	Displays actual value stored within the specified parameter. Press the FUNC DATA key to store the value of the specified parameter.
-End-	The display will read end (as show)for approximately 1 second if the input has been accepted.After a parameter value has been set,the new value is automatically stored in memory.To modify an entry,use ▲ or ▼ key,then press the FUNC DATA key.

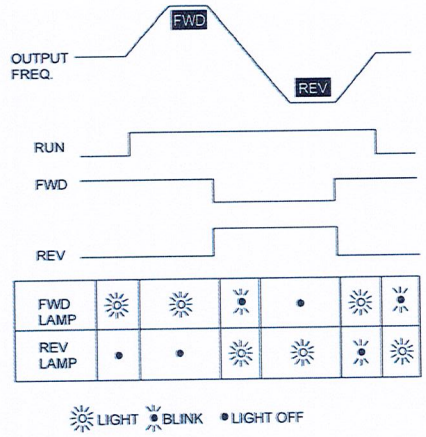
•Explanation of the LED Indicators



RUN or STOP lamp indication is defined by the following operation



FWD or REV lamp changes indication is defined by the following operation

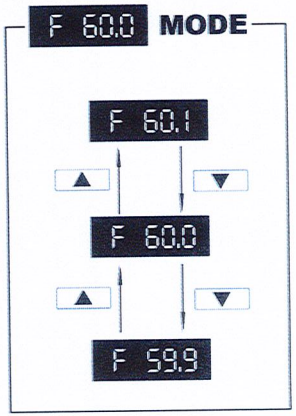


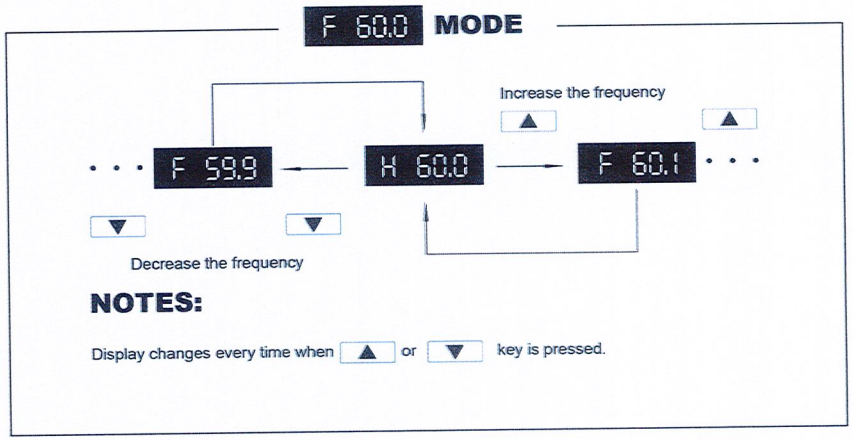
2. Digital Keypad Operating Mondes&Programming Steps

Pressing the RUN key after power on will cause the AC drive to operate at 60Hz, which is the factory default setting.Use the STOP key to halt operation.

•To change the operating ferquency,proceed as follows:

The operating frequency may be changed in either the "TOP" or "RUN"mode.





Ⅷ.Main technical specifications:

Model		CA900	
operating table(mm)		1500×1800	
Max. cutting thickness	180		
effective arm length(mm)		900	
band knife dimension		3860×10×0.45	
speed regulator	Stepless speed adjusting by converter		
main motor	380V	750V	1400r/min
blower	380V	180V	2800r/min

Ⅸ.Cleaning and caring.

1. Unplug form outlet when it is not being operated for a long period of time.
2. Do not operate and disconnect the power supply when it is thundering.
3. Remove wastes and rests from the machine at regular intervals.
4. Each time the knife is ground,remove grit from the grit tray.
5. Fill the machine at regular intervals.

Ⅹ.Accessory.

Double wrench 17-19 1 piece Internal hexagon wrench3,4,5mm each 1 piece Band knife 2 pieces

Double wrench 10-12 1 piece Grindingwheel 2 piece Oil pan 1 piece

TROUBLESHOOTING:

Malfunction	Reason	Remedy
Machine vibrating	1.Dynamic equilibrium of band pulley is bad.	1.Correct.
	2.The joint of band knife is not filed smooth, and is thicker than its original.	2.File smooth to keep ite original thickness.
Excessive noise	1.The fit of driving shaft and bearing is so loose that the bearing is not rotating when the driving shaft rotates.	1.Replace shaft and bearing.
	2.The band knifeis not locating centrically when passing through every part.	2.Adjust band knife to be placed in the midde.
Band knife breakage	1.The joint is tempered too hard.	1.Tempering again according to welding instruction.
	2.Two ends of thejoint are not vertical and balanced.	2.The joint should be vertical and parallel.
	3.The self-dipped opening of the joint is excessive big or small.	3.The opening should be about 4.5mm.
The band knife comes apart	1.The welding of band knife is not vertical.	1.The welding should be vertical and parallel.
	2.The three band pullcys are not in the same plane.	2.Correctthe parallelism of the three pulleys.
	3.The rubber of the band knife pulley is aging and come off.	3.Replace the pulley.
The material is not cut vertically	1.The table and the pulley are not installed vertically.	1.Adjust the set screw to make them vertically.