ZOJE
中捷

# 圆刀削皮机 YXP-3

# LEATHER SKIVING MACHINE

# 使用说明书

# OPERATION MANUAL

中国·中捷缝纫机股份有限公司
ZOJE SEWING MACHINE CO., LTD.

## Ⅰ.Features and uses of the machine.

JS-801 Leather Skiving Machine with circular knife is suitable for edge-skiving and whole surface skiving of any kinds 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 is one of necessary equipments whick make above goods. garments, belts, gloves and sports goods etc. It is one of necessary equipments which make above goods.

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

## Ⅱ.Main Technical Specifications.

| | YXP-3 |
|---|---|
| rotating speed of main shaft (circular knife) | 1100-1200rpm |
| skiving width | 4-15mm |
| size of the machine head | 550×370×400mm |
| net weight of the machine head | 45kg |
| motor power | 370w |
| size of circular knife | ø117×54×ø114mm |

## 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 long hole of the frame beam, and fix it with screw. Then place the table and machine head and align their positions. Thighten all screws and nuts.

2.Cleaning grease dirt.

The machine are coated with anti-rust grease to prevint if from rusiting 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 machine

The machine may get strong shaking in the transport leading to loosening or shifting of its parts. Check the machine completely after cleaning it , Turn the helt pulley of the main shaft with hand and obscrve wheather the feeding wheel and the grinding wheel impact the edge of the circular knife or not, If there is any impact,adjust the machine according to the methods of this instruction book, make the feeding wheel and the 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 fum clockwise.(observe from the right of operator)

## 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 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 regring. 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.

JS-801:The circular knife adjustment consists of precise worm and worm wheel whick can make micro-adjusting by means of turning the adjusting handle of the knife. Turn 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 rotales when the machine works normally, so the edge of the knife can be regrund continually. Also can regrind it after the edge of the knife get dull. When turn the adjusting screw bar of the grinding wheel counter-clock wise, the grinding wheel closes to the dege of the knife and does grinding;turn the adjusting screw bar clackwise, the grinding wheel leaves the edge of the knife and stop grinding.(see Figure 3)

Caution: When grinding the edge of the knife, the grinding wheel should advance slowly to prevent the grinding wheel from impacting the edge of the knife, leading to destory the grinding wheel or the edge, even work accidents,

3. To adjust the beight and centre of the feeding wheel arc.

The feeding wheel has two functions, The main one is feeding material, anotheris grinding burrs of the inner side of the knife. The R centre of the feeding wheel should be identical with the R centre of the knife. This will do quite well to feeding 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 adjusting screw bar clockwise, on the cluntrary side, turn the adjusting screw bar counterclockwise 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.

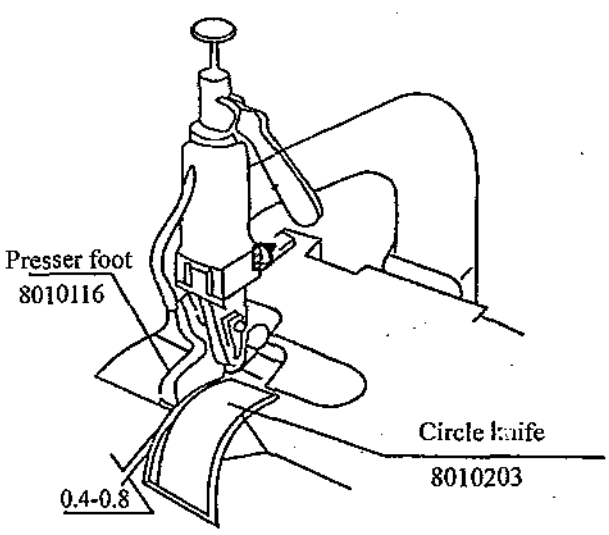
The outer diameter of the feeding wheel should connect the inner diameter of the knife. The big clearance between them will cause unsmooth feeding and poor quality skiving. The over interference will destroy the knife, The height of the feeding wheel is adjusted by means of loosening the adjusting nut, and turning the adjusting screw bar, turn clock wise to increase the height, turn counterclockwise to decrease the height, and tighten the height adjusting nut to adjust their connect.(Figure 3)

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 incerease 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 height adjusting screw bar. Turn it clock wise to decrease the height, turn it counterclockwise to increase the height.

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




Figurel

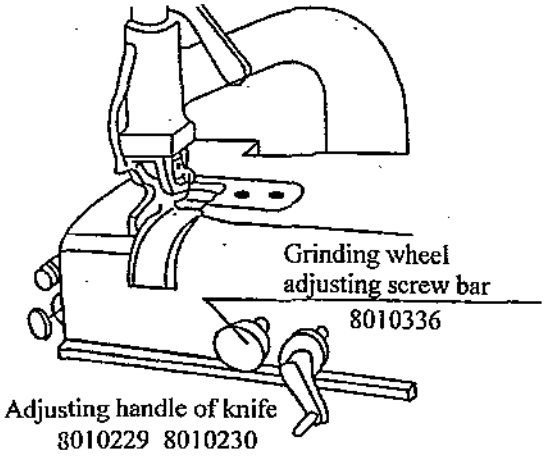



Figure2

To do big width and small angel edge-skiving, the angle between the presser foot and the circular knife should be small. On the contrary, 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 counterclock wise to decrease the angel.After the required angle is adjusted, retighten the adjusting nut.(see Figure 4)

5.To adjust the blocking board.

The blocking board takes a role of limiting the width of skiving. Move it to the operator to decrease

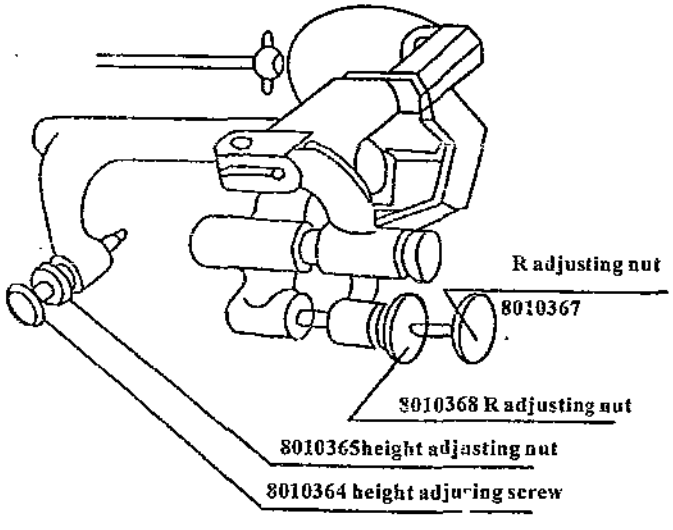



Figure 3

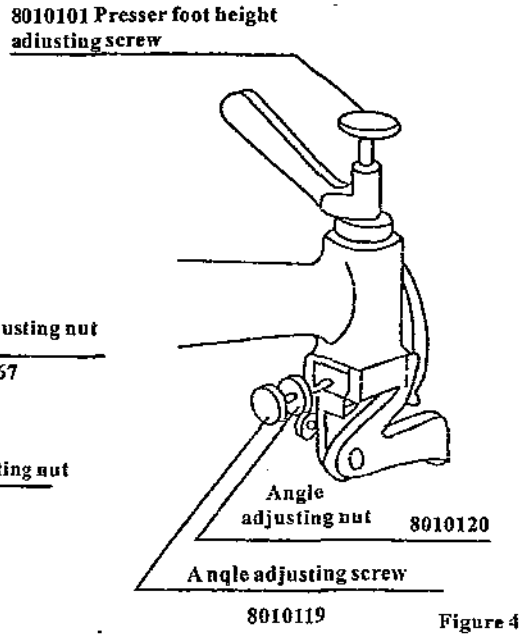



Figure 4

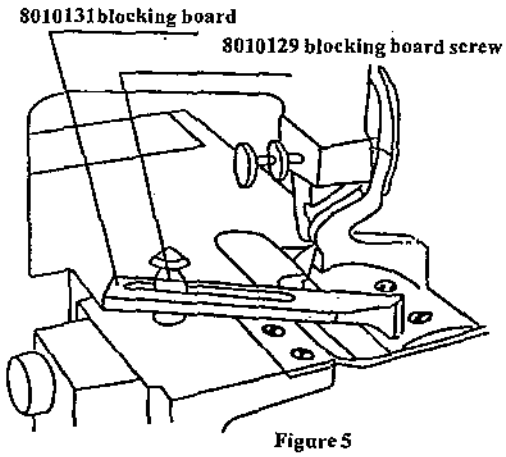



Figure 5

Figure 4

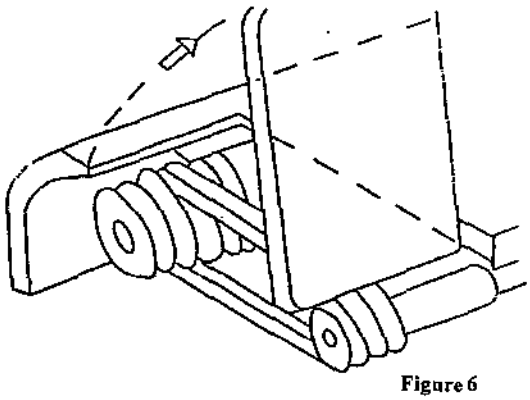


Figure 6

the width of skiving, under the countrary onditions. move it to another direction.The position of the blocking board is adjusted by the screw.(see Figure 5)

6. To adjust skiving speed.

The leather skiing machine with the circlar knife has three speeds to choose depending on operator skill and the skiving matitial. To adjust the speed, first open andtake a way belt cover, slide the beot into required skiving spped 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 skiving chips are stuck on the surface of the feeding wheel.weaken feeding friction force, lead to unsmooth feeding. Toresume normal feeding, the surface of the feeding wheel must be dressed with grinding wheel dresser. First removc 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 the feeding wheel and move left and right until the surface of the feeding whell become sharp.(see Figure 7)

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 tile grinding wheel dresser.(see Figure 8)

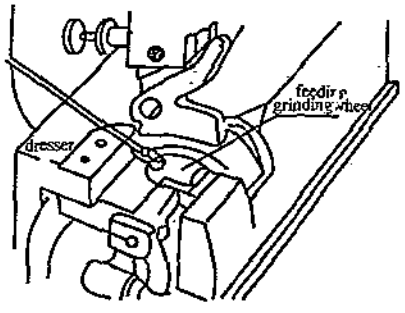



Figure7

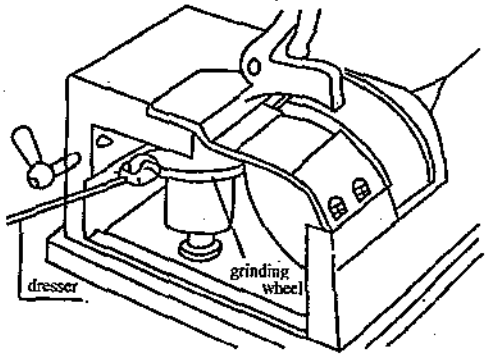
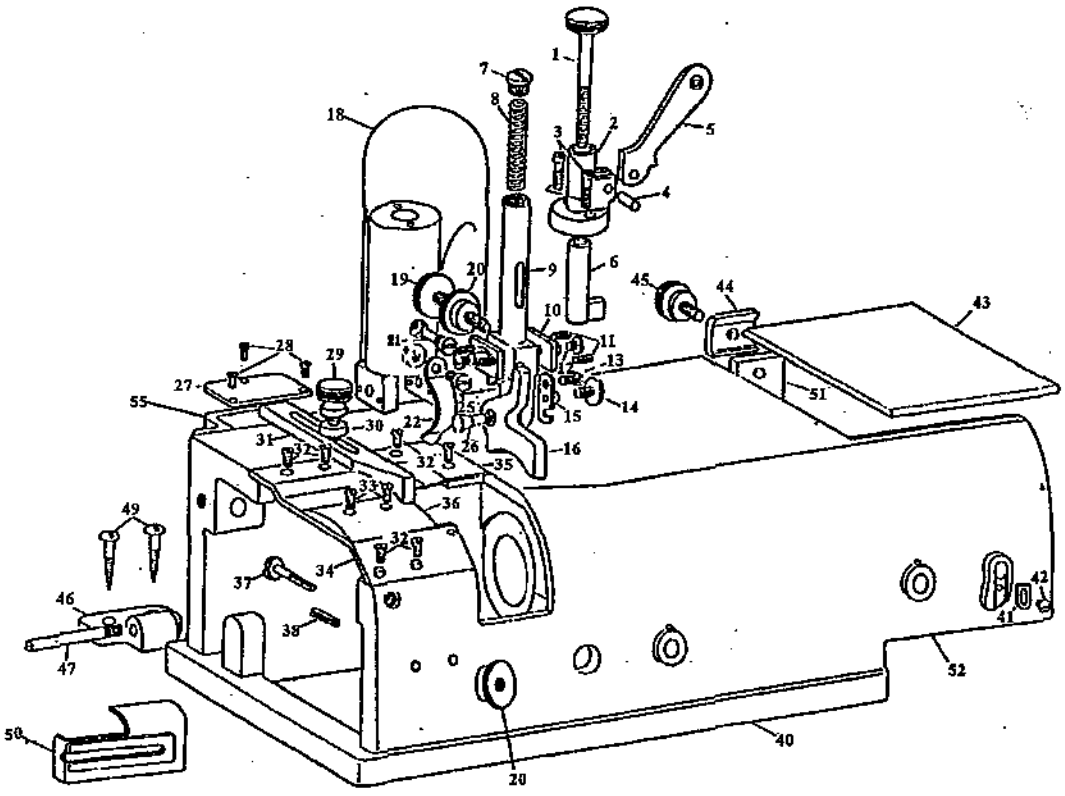


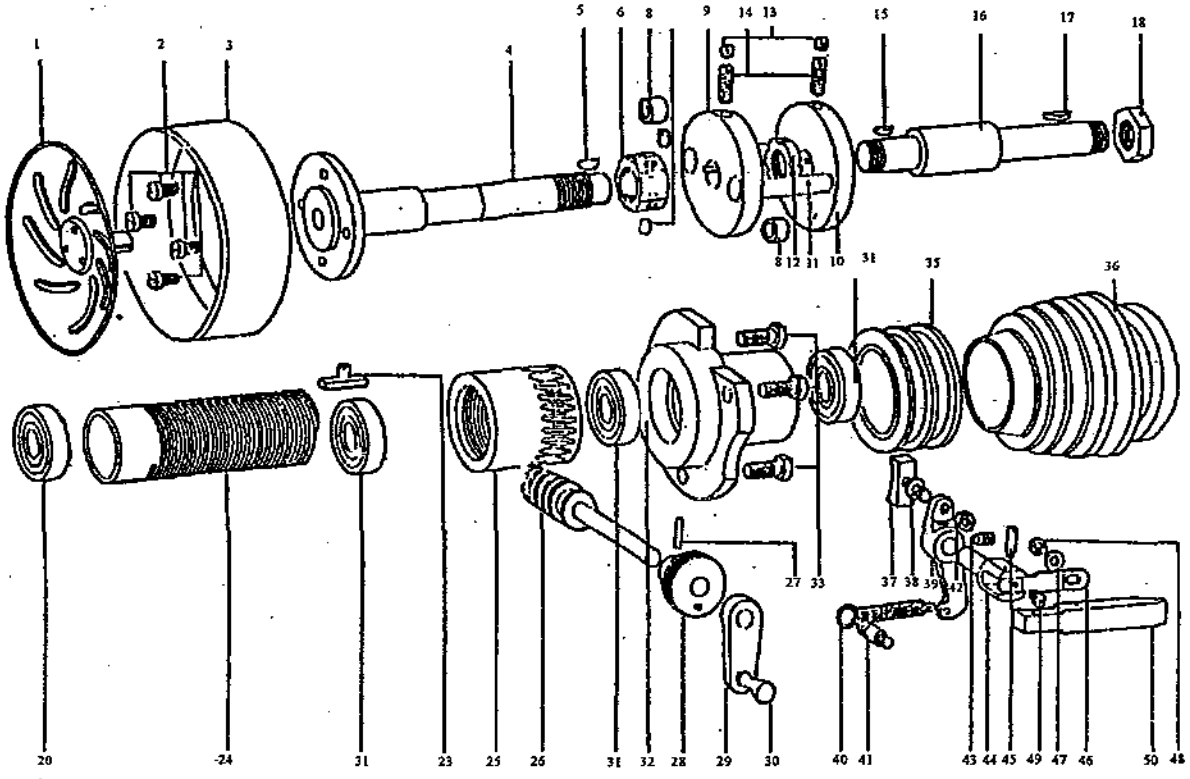

Figure8



## 1. PRESSER FOOT AND OUTER ATTA CHMENTS

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 1 | 8010101 | Presser bar adjusting screw | 1 | |
| 2 | 8010102 | Presser bar lifter bracket | 1 | |
| 3 | 8010103 | Presser bar lifter bracket screws | 2 | |
| 4 | 8010104 | Presser bar lifter pin | 1 | |
| 5 | 8010105 | Presser bar lifter | 1 | |
| 6 | 8010106 | Presser bar lifter lever | 1 | |
| 7 | 8010107 | Presser bar cover screw | 1 | |
| 8 | 8010108 | Presser bar spring | 1 | |
| 9 | 8010109 | Presser bar | 1 | |
| 10 | 8010110 | Presser foot side plates | 2 | |
| 11 | 8010111 | Presser foot side plates adj screws | 4 | |
| 12 | 8010112 | Presser foot side plates screws | 2 | |
| 13 | 8010113 | Presser foot shaft hook metal hinge screw | 1 | |
| 14 | 8010114 | Presser foot shaft hoot metal set screw | 1 | |
| 15 | 8010115 | Presser foot shaft hook metal | 1 | |
| 16 | 8010116 | Presser foot 40mm | 1 | |
| 18 | 8010118 | Arm | 1 | |
| 19 | 8010119 | Presser foot adjusting screw | 1 | |

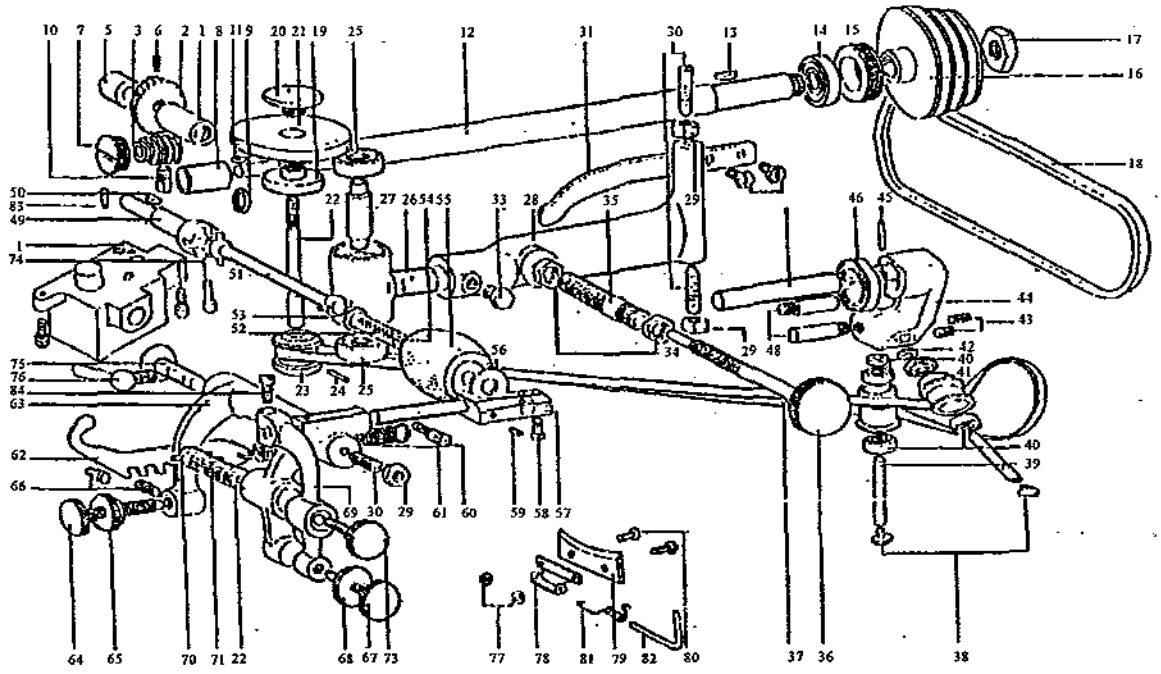
| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 20 | 8010120 | Presser foot adjusting screw nuts | 2 | |
| 21 | 8010121 | Presser bar spring ping | 1 | |
| 22 | 8010122 | Presser foot spring | 1 | |
| 25 | 8010125 | Presser foot spring screw | 1 | |
| 26 | 8010126 | Presser foot shaft | 1 | |
| 27 | 8010127 | Worm chambar plate | 1 | |
| 28 | 8010128 | Fiat screw | 1 | |
| 29 | 8010129 | Ruler set screw | 1 | |
| 30 | 8010130 | Ruler set screw washer | 1 | |
| 31 | 8010131 | Worm chambar plate | 1 | |
| 32 | 8010132 | Slide plate screws | 6 | |
| 33 | 8010133 | Slide plate screws | 2 | |
| 34 | 8010134 | Slide plate A | 1 | |
| 35 | 8010135 | Slide plate B | 1 | |
| 36 | 8010136 | Slide plate C | 1 | |
| 37 | 8010137 | Waster feeder screw | 1 | |
| 38 | 8010138 | Waster feeder stop pin | 1 | |
| 40 | 8010140 | Bad | 1 | |
| 41 | 8010141 | Belt cover plate | 1 | |
| 42 | 8010142 | Belt cover plate screw | 1 | |
| 43 | 8010143 | Belt cover lid | 1 | |
| | 8010143-1 | Belt cover lid | 1 | |
| 44 | 8010144 | Belt cover lid stopper | 1 | |
| 45 | 8010129 | Ruler set screw | 1 | |
| | 8010129-1 | Ruler set screw | 1 | |
| 46 | 8010146 | Hinges | 2 | |
| 47 | 8010147 | Hinges pins | 2 | |
| 49 | 8010149 | Hinges set screw | 4 | |
| 50 | 8010150 | Waste feeder metals | 1 | |
| 51 | 8010151 | Transmission shaft | 1 | |
| 52 | 8010152 | Base plate | 1 | |



## 2.Knife and belated parts

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 1 | 8010201 | Leather peeler covet | 1 | |
| 2 | 8010202 | Knife set screws | 4 | |
| 3 | 8010203 | Knife | 1 | |
| 4 | 8010204 | Knife shaft | 1 | |
| 5 | 8010205 | Knife shaft key | 1 | |
| 6 | 8010206 | Knife shaft nuts | 2 | |
| 7 | 8010207 | Screw | 1 | |
| 8 | 8010208 | Pubber bushings | 1 | |
| 9 | 8010209 | Pulley shaft flange holder(Left) | 1 | |
| 10 | 8010210 | Pulley shaft flange holder(right) | 1 | |
| 11 | 8010211 | Pulley shaft | 2 | |
| 12 | 8010212 | Pulley shaft flange nut | 1 | |
| 13 | 8010213 | Screw | 2 | |
| 14 | 8010214 | Nut | 2 | |
| 15 | 8010215 | Pulley shaft shaft key(small) | 1 | |
| 16 | 8010216 | Pulley shaft | 1 | |
| 17 | 8010217 | Pulley shaft key(large) | 1 | |
| 18 | 8010218 | Hexagongal nut(A) | 1 | |

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 20 | 8010220 | Trust bearing | 2 | |
| 23 | 8010223 | Kinfe shaft lead pipe key | 1 | |
| 24 | 8010224 | Knife shaft lead pipe | 1 | |
| 25 | 8010225 | Knife shaft worm wheel | 1 | |
| 26 | 8010226 | Knife shaft worm | 1 | |
| 27 | 8010227 | Screw | 2 | |
| 28 | 8010228 | Knife adjusting knob | 1 | |
| 29 | 8010229 | Knife adjusting handle | 1 | |
| 30 | 8010230 | Knife adjusting handle knod | 1 | |
| 31 | 8010231 | Pulley shaft bearings | 2 | |
| 32 | 8010232 | Pulley shaft metal | 1 | |
| 33 | 8010233 | Pulley shaft metal screws | 3 | |
| 35 | 8010235 | Clutch | 1 | |
| 36 | 8010236 | Pulley | 1 | |
| 37 | 8010237 | Clutch slide block | 1 | |
| 38 | 8010238 | Clutch slide block screw | 1 | |
| 39 | 8010239 | Clutch arm | 1 | |
| 40 | 8010240 | Clutch arm Clutch spring | 1 | |
| 41 | 8010241 | Clutch spring hook | 1 | |
| 42 | 8010242 | Clutch slide block screw nut | 1 | |
| 43 | 8010243 | Clutch lever screw | 1 | |
| 44 | 8010244 | Clutch lever shaft | 1 | |
| 45 | 8010245 | Clutch arm screw | 1 | |
| 46 | 8010246 | Clutch lever spring | 1 | |
| 47 | 8010247 | Clutch lever spring waser | 1 | |
| 48 | 8010248 | Clutch lever spring hinge screw | 1 | |
| 49 | 8010249 | Clutch lever spring screw | 1 | |
| 50 | 8010250 | Clutch lever | 1 | |

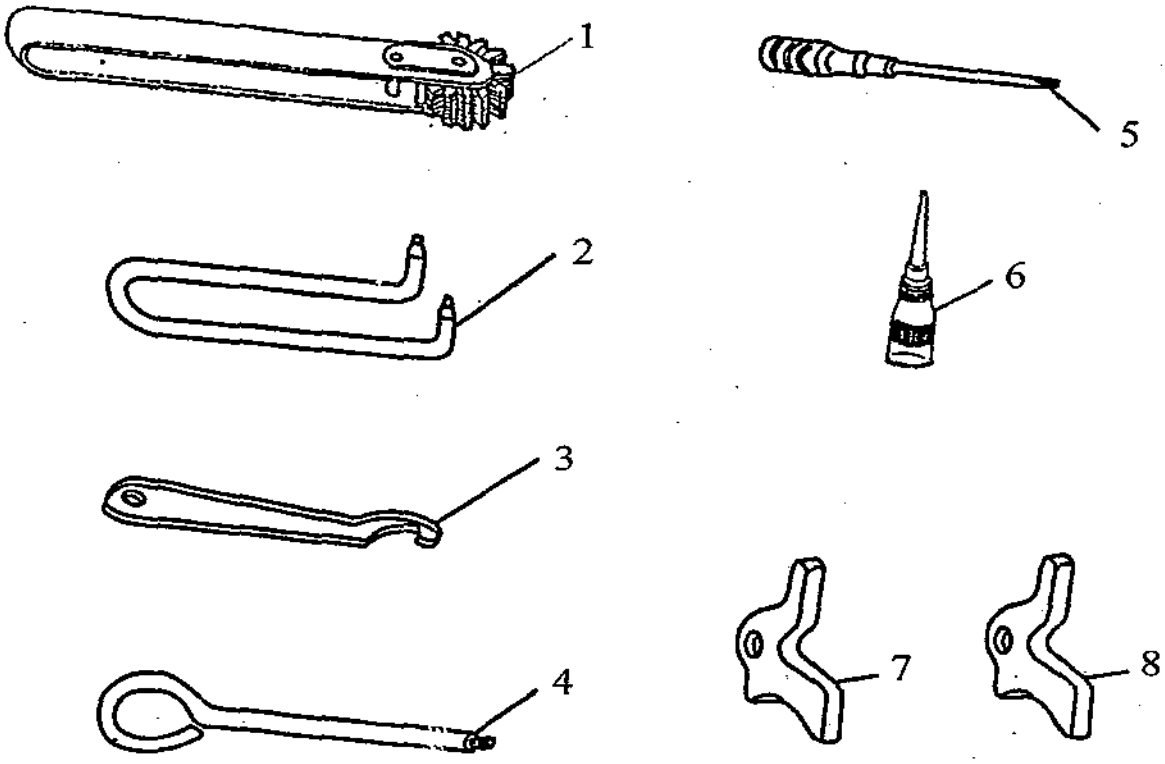


## 3.GRINDSTONE AND ROLLER ATED PARTS

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 1 | 8010301 | Worm wheel box | 1 | |
| 2 | 8010302 | Main shaft worm gear wheel | 1 | |
| 3 | 8010303 | Main shaft worm gear | 1 | |
| 4 | 8010304 | Roller driving shaft metal | 1 | |
| 5 | 8010305 | Roller driving shaft metal | 1 | |
| 6 | 8010306 | Main shaft worm gear wheel screw | 1 | |
| 7 | 8010307 | Main shaft worm gear chambar cove screw | 1 | |
| 8 | 8010308 | Main shaft front bushing | 1 | |
| 10 | 8010310 | Main shaft worm gear chamer screw | 1 | |
| 11 | 8010311 | Main shaft key | 1 | |
| 12 | 8010312 | Main shaft | 1 | |
| 13 | 8010313 | Main shaft key | 1 | |
| 14 | 8010314 | Main shaft bearing | 1 | |
| 15 | 8010315 | Main shaft deaning holder screw | 1 | |
| 16 | 8010316 | Main shaft pulley | 1 | |
| 17 | 8010317 | Hexagonal nut | 1 | |
| 18 | 8010318 | Main shaft belt | 1 | |
| 19 | 8010319 | Grindtone set screw | 1 | |
| 20 | 8010320 | Grindtone set screw nut | 1 | |
| 21 | 8010321 | Grindtone | 1 | |
| 22 | 8010322 | Grindtone shaft | 1 | |
| 23 | 8010323 | Grindtone shaft pulley | 1 | |

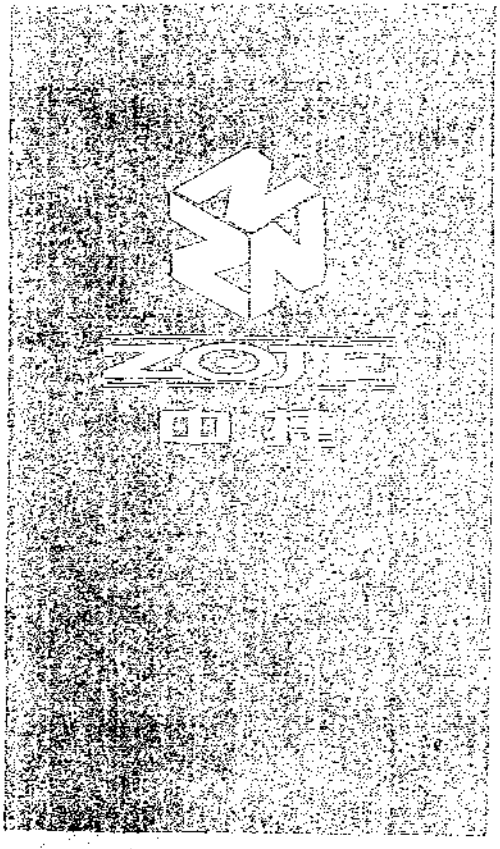
| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 24 | 8010324 | Grindtone shaft pulley taper pin | 1 | |
| 25 | 8010325 | Grindtone shaft bearings | 2 | |
| 26 | 8010326 | Grindtone shaft bracket | 1 | |
| 27 | 8010327 | Grindtone shaft bearing roller | 1 | |
| 28 | 8010328 | Grindtone shaft bracket | 1 | |
| 29 | 8010329 | Bracket arm center screw nuts | 3 | |
| 30 | 8010330 | Bracket arm center screws | 3 | |
| 31 | 8010331 | Grindtone shaft bracket arm spring | 1 | |
| 32 | 8010332 | Grindtone shaft bracket amsping screws | 2 | |
| 33 | 8010333 | Grindtone shaft bracket screw | 1 | |
| 34 | 8010334 | Grindtone adjusting screw pipe nuts | 2 | |
| 35 | 8010335 | Grindtone adjusting screw pipe | 1 | |
| 36 | 8010336 | Grindtone adjusting screw | 1 | |
| 37 | 8010337 | Grindtone shaft belt | 1 | |
| 38 | 8010338 | Belt guide pulley screws | 2 | |
| 39 | 8010339 | Belt guide pulley shafts | 2 | |
| 40 | 8010340 | Belt guide pulley bearings | 4 | |
| 41 | 8010341 | Belt guide pulleys | 2 | |
| 42 | 8010342 | Belt guide pulleys washers | 2 | |
| 43 | 8010343 | Belt guide pulley shaft screws | 2 | |
| 44 | 8010344 | Belt guide bracket | 1 | |
| 45 | 8010345 | Belt guide bracket taper pin | 1 | |
| 46 | 8010346 | Belt guide bracket spring | 1 | |
| 47 | 8010347 | Belt guide bracket shaft | 1 | |
| 48 | 8010348 | Belt guide bracket rurning stoppers | 2 | |
| 49 | 8010349 | Roller driving shaft | 1 | |
| 50 | 8010350 | Roller driving shaft key | 1 | |
| 51 | 8010351 | Roller driving shaft joint | 1 | |
| 52 | 8010352 | Roller shaft oil wick | 1 | |
| 53 | 8010353 | Roller shaft | 1 | |
| 54 | 8010354 | Roller shaft oil seal plug | 1 | |
| 55 | 8010355 | Roller | 1 | |
| 56 | 8010356 | Roller washer | 1 | |
| 57 | 8010357 | Roller bracket | 1 | |
| 58 | 8010358 | Rollershaft screw | 1 | |
| 59 | 8010359 | Waste clear metal shaft screw | 1 | |
| 60 | 8010360 | Roller bracket arm spring hooks(2) | 1 | |
| 61 | 8010361 | Roller bracket arm spring | 1 | |
| 62 | 8010362 | Roller bracet arm spring hooks metal | 1 | |
| 63 | 8010363 | Roller bracket arm | 1 | |
| 64 | 8010364 | Roller bracket arm adjusting screw | 1 | |
| 65 | 8010365 | Roller bracket arm adjusting screw nut | 1 | |
| 66 | 8010366 | Roller brackct arm sprign hooks(1) | 2 | |

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 67 | 8010367 | Arm adjusting screw | 1 | |
| 68 | 8010368 | Arm adjusting screw nut | 1 | |
| 69 | 8010369 | Roller bracket turning arm | 1 | |
| 70 | 8010370 | Roller bracket turning arm spring stopper | 1 | |
| 71 | 8010371 | Roller bracket turning arm spring | 1 | |
| 72 | 8010372 | Turning arm spring adjusting nut | 1 | |
| 73 | 8010373 | Turing arm spring adjusting screw | 3 | |
| 74 | 8010374 | sct screw | 3 | |
| 75 | 8010375 | Roller bracket arm center pin | 1 | |
| 76 | 8010376 | Roller bracket arm center pin screw | 1 | |
| 77 | 8010377 | Waste clear metnal leather nuts | 2 | |
| 78 | 8010378 | Waste clear metal | 1 | |
| 79 | 8010379 | Waste clear metal leather | 2 | |
| 80 | 8010380 | Waste clear metal leather screws | 2 | |
| 81 | 8010381 | Waste clear metal leather spring | 1 | |
| 82 | 8010382 | Waste clear metal leather shaft | 1 | |
| 83 | 8010383 | Tape pin | 1 | |
| 84 | 8010383 | Roller shaft screw | 1 | |




## 4.ACCESSORIES

| Item | Part No. | Name of Part | Quan | Remarks |
|---|---|---|---|---|
| 1 | 8010401 | Grindstone diresser | 1 | |
| 2 | 8010402 | Grindstone nut spanner | 1 | |
| 3 | 8010403 | Knifshaft spanner | 1 | |
| 4 | 8010404 | Knife inner cover remover | 1 | |
| 5 | 8010405 | Driver(large) | 1 | |
| 6 | 8010406 | Oiler | 1 | |
| 7 | 8010407 | Presesr foot 30mm | 1 | 1-16B |
| 8 | 8010408 | Presest foot 20mm | 1 | 1-16C |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |



中国·中捷缝纫机股份有限公司

ZOJE SEWING MACHINE CO., LTD.

ADD:CHANGYI ZONE,YUHUAN,ZHEJIANG,317604,CHINA
TEL:0086-576-87257716