

ISO9001 认证



国家高新技术企业

清洁生产

JK-T801

User Guide

产品使用说明书

 **杰克缝纫机**
JACK SEWING MACHINE
| [HTTP://WWW.CHINAJACK.COM](http://www.chinajack.com) |

一、概述:

JK-T801型圆刀削皮机, 又称披皮机、披帮机, 具有削边、全表面削皮等功能, 适用于鞋帽、书包、服装、皮带、手套及运动器具等各类的皮革、塑料布、合成皮革、毡呢、橡胶布等的削边、削薄, 该机器是上述各类制品加工过程中的必要设备之一。

JK-T801型圆刀削皮机, 具有噪声低、性能稳定、操作方便、生产效率高和使用寿命长等优点。

二、主要技术规格:

主轴(圆刀)转速	1100~1200转/分
能削宽度	4~15毫米
机头外形尺寸	530 x 370 x 400毫米
机头净重	45 公斤
电动机功率	370 瓦
采用圆刀	φ117 x 54 x φ112毫米

三、使用前的准备工作:

1、安装

该机机头, 机架和电器等分别装箱, 因此首先应将机架组装, 然后将电机安装在机架中档的长孔处, 用螺钉连接, 再放上台板和机头, 并对好位置, 然后紧固各螺钉、螺母。

2、清洗油污

机器在装箱前为了防止机件生锈, 涂有防锈油脂, 装箱后可能有较长时间的储藏和长途运输, 造成油脂硬化或灰尘积聚, 为此, 开箱后必须将机件表面的防锈油脂用汽油和洁净的软布擦洗干净。

3、机器检查

机器在运输中可能受到强烈振动, 而使机件松动或移位, 所示在清洗油污后, 应作一次周密的检查, 用手转动主轴的皮带轮, 观察送料砂轮和磨刀砂轮有否与圆刀相碰擦, 若有则应按本说明书的有关办法予以调整, 使送料轮和磨刀砂轮与圆刀刃口有一定的间隙。检查各部位连接处是否松动, 各螺钉要求旋紧。

4、注油试车

机器在运转前对各处油孔和摩擦部位加注机油后, 开车数分钟予以试车, 主轴皮带轮的运转方向应为顺时针方向(从操作者右面视)

四、使用调整方法:

1、圆刀位置的调试

圆刀刃口与压脚侧面应保持一定的间隙, 这个间隙是保证削皮质量的一个重要因素。一般宜控制在0.4~0.8毫米(见图1)。圆刀经切削刃口变钝, 需要修磨, 经多次或一定时间的修磨后, 圆刀刃口与压脚侧面和送料砂轮的位置都会变化。

这就需要调节圆刀的轴向位置予以弥补。

2、修磨圆刀的方法

机器在正常使用时，磨刀平砂轮也在作旋转运转，因而可在机器正常使用的同时，对圆刀刃口作持续的修磨，也可待圆刀刃口变钝后进行修磨，修磨刀刃时，将磨刀砂轮调节螺杆逆时针方向旋转，磨刀平砂轮靠拢圆刀刃口，即停止修磨(见图2)，在修磨圆刀刃口时，磨刀砂轮应缓慢地进给。以免砂轮突然撞击刀刃，引起损坏砂轮或刀刃，甚至出现安全事故。

JK-T801型的圆刀调节采用精密的蜗轮蜗杆结构，通过圆刀调节手柄的转动可对圆刀作微量的调节，手柄顺时针向旋转，圆刀刃口与压脚侧面间隙大，手柄逆时针向旋转，圆刀刃口与压脚侧面间隙小(见图2)。

3、送料砂轮圆弧的高度及中心的调节

送料砂轮的主要功能是送料，另一功能是磨削圆刀内径的毛刺，送料砂轮的R中心与圆刀R中心相吻合。这样对送料及磨削圆刀内径都理想，如不在一个中心线上，应将R中心进行调整，调整的方法：扭松送料轮R的调节螺母，旋动送料砂轮R的调节螺杆，如圆刀内径与送料砂轮的右侧间隙大，则将R调节螺杆按逆时针方向旋动，反之，将R调节螺杆按顺时针方向旋动，直至送料砂轮R与圆刀内径的二侧间隙一致为止，最后扭紧R调节螺母。

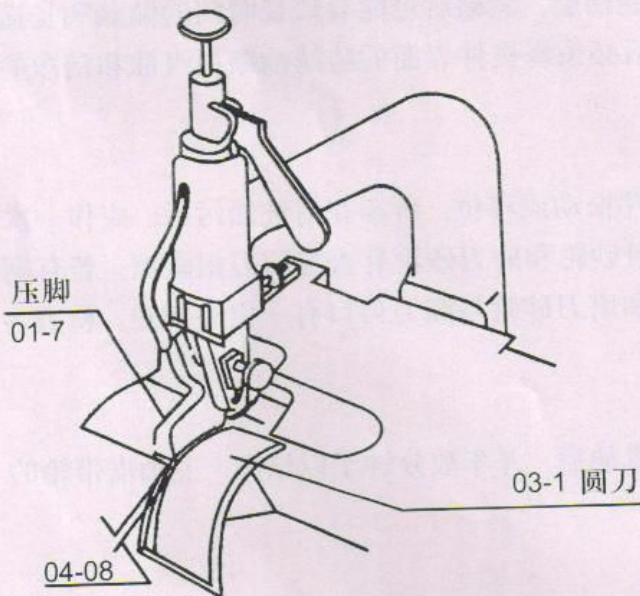


图1 (圆刀刃口与压脚侧面间隙图)

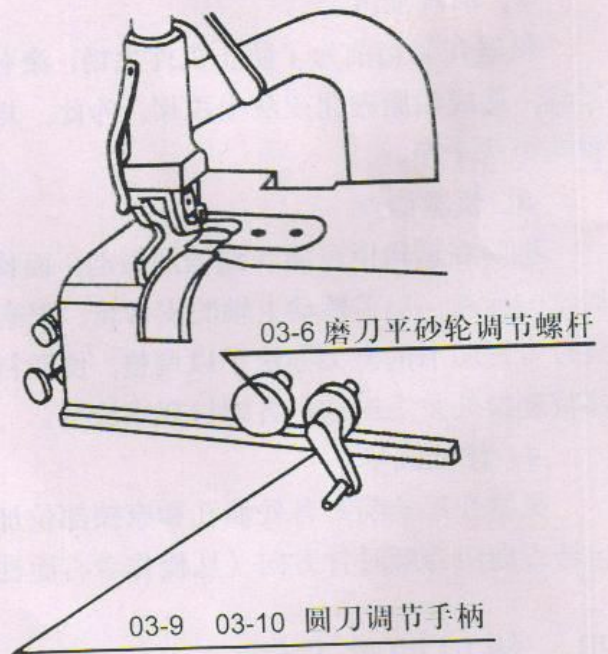
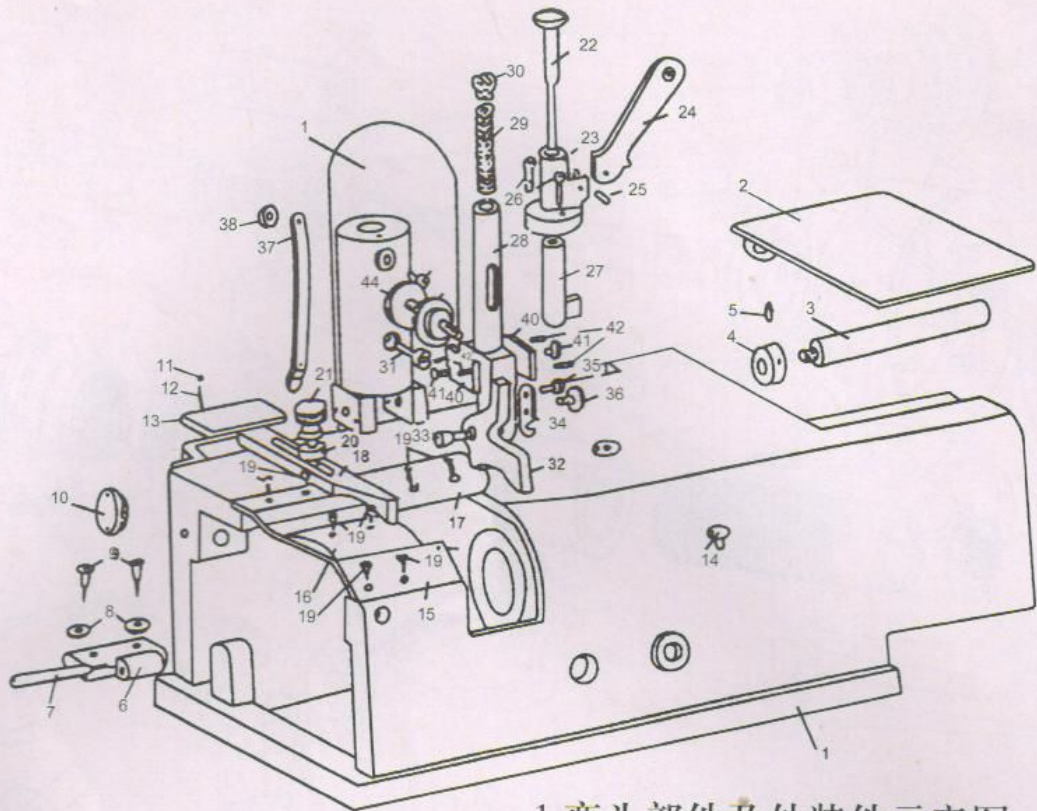
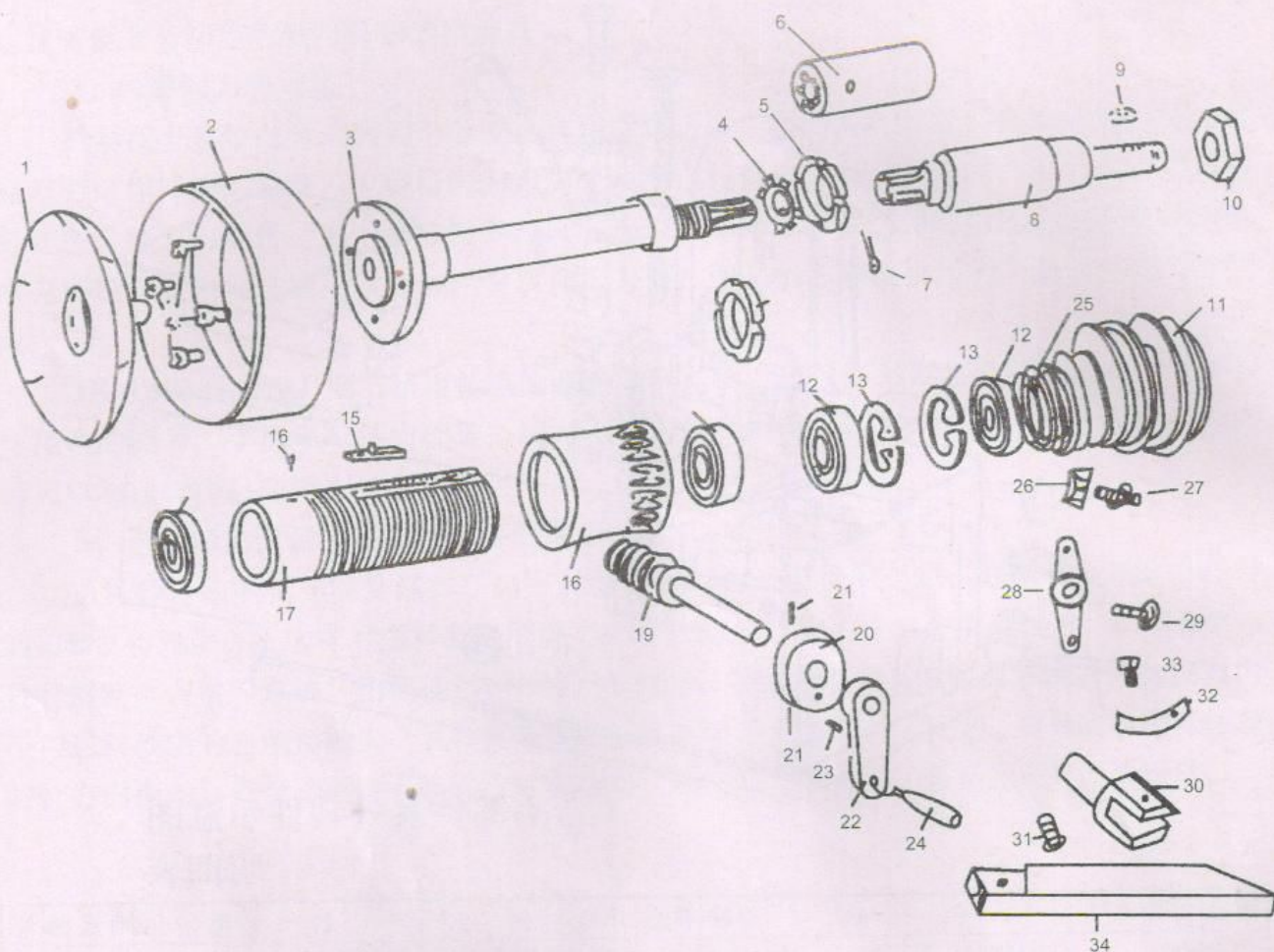


图2 (JK-T801型圆刀轴向位置调节图)



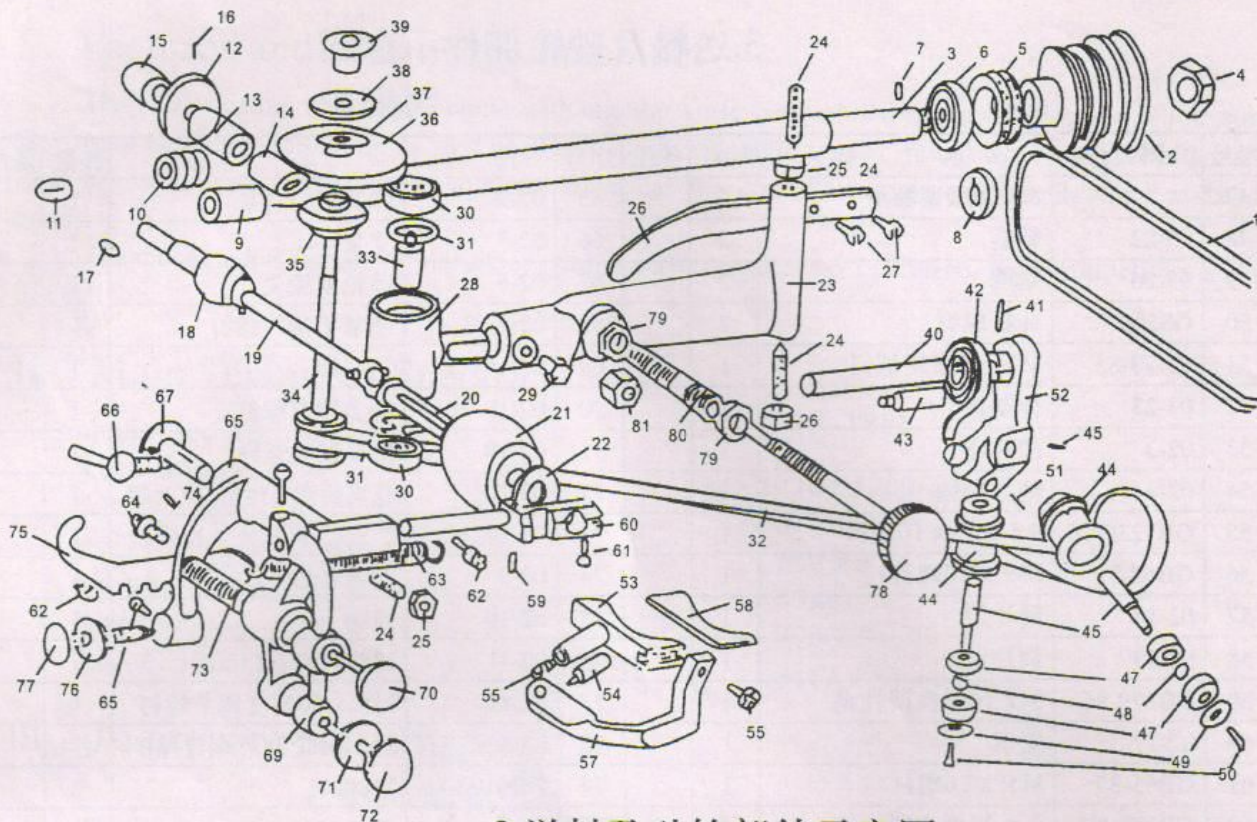
1.弯头部件及外装件示意图
 明细表

序号	图号	名称	件数	备注	序号	图号	名称	件数	备注
1	06-1	箱体	1		24	01-5	压簧手柄	1	
2	06-15	盖板	1		25	GB117-86	5 × 22圆锥销	1	
3	06-13	箱体右侧杆	1		26	GB65-85	M4 × 14螺钉	2	
4	06-4	定位套	1		27	01-2	可调压套	1	
5	GB75-85	开槽平端紧定螺钉	2		28	01-10	升降架	1	
6	06-11	支架	2		29		1.8 × 10 × 60压簧	1	
7	06-12	支架螺钉	4		30	01-6	螺塞	1	
8	GB97.1-85	平垫圈	4		31	01-14	螺钉	1	
9	GB845-85	ST8 × 20盖头自攻螺钉	1		32	01-7	压脚	1	
10	04-9	盖螺母	1		33	01-9	压销	1	
11		φ5钢珠	1		34	01-11	压板	1	
12		0.5 × 4 × 20压簧	1		35	GB818-85	M5 × 10螺钉	1	
13	04-11	蜗轮箱盖板	1		36	01-12	压板螺钉	1	
14	06-10	油限盖板	1		37	01-16	弹簧片	1	
15	06-3	盖板	1		38	GB95-85	弹簧片垫圈φ6	1	
16	06-2	压板	1		39	GB65-85	M6 × 10螺钉	1	
17	06-9	圆刀盖板	1		40	01-8	塞块	2	
18	06-4	靠板	1		41	GB65-85	M5 × 10螺钉	2	
19	GS269	针板螺钉	8		42	GB73-85	开槽平端紧定螺钉	4	
20	06-6	靠板垫圈	1		43	01-13	压脚调节螺钉	1	
21	06-7	靠板螺钉	1		44	01-15	压脚调节螺母	1	
22	01-1	升降调节螺钉	1		45				
23	01-3	压套	1		46				



2.刀轴部件及马达传动示意图
明细表

序号	图号	名称	件数	备注	序号	图号	名称	件数	备注
1	03-2	刀衬	1		19	03-8	大蜗杆	1	
2	03-1 ✓	圆刀	1		20	03-11	蜗杆捏手	1	
3	03-2	刀轴	1		21	GB73-85	M5 × 6开槽紧定螺钉	2	
4	GB858-88	止动垫圈20	1		22	03-9	捏手座	1	
5	03-14	刀轴套锁紧螺母	1		23	GB119-86	3 × 12园柱销	1	
6	03-15	传动套	1		24	03-10	捏手柄	1	
7	GB91-86	3 × 40开口销	1		25	07-1	离合器	1	
8	03-21	传动轴	1		26	07-2	拨块	1	
9	GB1096-79	5 × 16平键	1		27	07-3	拨销	1	
10	GB6172-86	M16螺母	1		28	07-4	拨杆	1	
11	03-19	皮带轮	1		29		螺钉M6 × 14	1	
12	GB276-82	180104轴承	4		30	07-5	拨轴	1	
13	GB893.1-86	孔用弹性挡圈40A	2		31	07-6	销钉	1	
14	03-14	圆螺母	1		32	07-7	弹簧片	1	
15	03-30	定位键	1		33		螺钉M5 × 6	1	
16	GB75-85	M4 × 6园柱端紧定螺钉	1		34	07-8	拨柄	1	
17	03-13	螺杆	1		35	07-9	拨叉定位座	1	
18	03-7	大蜗轮	1						



3.送料及砂轮部件示意图
明细表

序号	图号	名称	件数	备注	序号	图号	名称	件数	备注
1		500 三角皮带	1		24	02-22	M8 × 32锥形紧定螺钉	2	
2	04-1	小皮带轮	1		25	GB6172-86	M8六角螺母	2	
3	04-5	长传动轴	1		26	05-1	片簧	1	
4	GB6172-86	M12 × 1.25六角螺母	1		27	GB5781-86	M6 × 12螺钉	2	
5	04-3	压紧螺母	1		28	05-5	磨刀砂轮座	1	
6	GB276-64	180202轴承	1		29	GB5781-86	M8 × 16螺钉	1	
7	GB879-86	4 × 8弹性园柱销	1		30	GB276-82	1800101轴承	2	
8	04-2	衬圈	1		31	GB893.2-86	B28孔用挡圈	2	
9	04-6	轴套	1		32		平皮带1.5 × 9.5	1	
10	04-7	蜗杆	1		33	05-4	衬圈	1	
11	GB1096-79	3 × 16平键	1		34	05-2	带轮轴	1	
12	04-13	蜗轮	1		35	05-6	砂轮套	1	
13	04-15	轴套	1		36	GB2489-84	φ70 × 8 × φ16平砂轮	1	
14	04-15	轴套	1		37	05-7	砂轮垫片	2	
15	04-12	轴套	1		38	05-8	砂轮垫圈	1	
16	GB73-85	M4 × 8紧定螺钉	1		39	05-9	(M8-左) 螺母	1	
17	GB1096-79	3 × 12平键	1		40	GB119-86	12 × 75园柱销	1	
18	04-14	蜗轮轴	1		41	GB879-86	3 × 16弹性园柱销	1	
19	04-16	万向传动轴	1		42	03-25	平面蜗弹簧	1	
20	02-2	砂轮轴	1		43	GB878-86	8 × 20螺纹园柱销	1	
21	02-23	鼓形砂轮	1		44	03-27	砂轮	2	
22	02-1	砂轮套	1		45	GB73-85	M5 × 6紧定螺钉	1	
23	05-10	砂轮支架	1		46	03-24	滚轮油	2	

3.送料及砂轮部件示意图 明细表

序号	图号	名称	件数	备注	序号	图号	名称	件数	备注
47		80026微型轴承	4		65	02-9	弹簧挂钉(长)	1	
48	03-22	轴套	2		66	02-5	支架	1	
49	03-26	垫圈	2		67	02-6	砂轮架顶尖	1	
50	GS269	针板螺钉	2		68	02-7、8	锁紧手柄、螺钉	各1	
51	GB73-85	M5 x 6紧定螺钉	1		69	02-16	送料架	1	
52	03-23	传动臂	1		70	02-19	拉力调节螺钉	1	
53	02-3	刮片座	1		71	02-18	M6调节螺母	1	
54	02-4	刮片座轴	1		72	02-20	送料轮调节螺钉M6 x 65	1	
55	GB1239-76	0.5 x 9 x 10压簧	1		73	02-21	2 x 12 x 49平头拉簧	1	
56	GB65-85	M5 x 10螺钉	1		74	02-9	弹簧挂钉	1	
57	02-14	刮片架	1		75	02-10	拉钩	1	
58	02-13	刮片	1		76	02-11	M8螺母	1	
59	GB879-86	3 x 14弹性园柱销	1		77	02-12	M8 x 60高度调节螺钉	1	
60	02-17	支承	1		78	03-5 03-6	磨刀砂轮调节螺钉捏手	各1	
61	GB65-85	M5 x 10螺钉	1		79	GB6172-86	M8螺母	2	
62	GB878-8.6	8 x 20螺纹园柱销	1		80	03-4	螺杆	1	
63	02-24	1.2 x 10 x 90拉伸弹簧	1		81	03-50	螺杆锁紧螺母	1	
64	02-15	弹簧接头A,B	各1		82				

I . Features and uses of the machine.

JK-T801 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 which make above goods.

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

II . Main Technical Specifications.

	JK-T801
rotating speed of main shaft (circular knife)	1100-1200rpm
skiving width	4-15mm
size of the machine head	550 x 370 x 400mm
net weight of the machine head	45kg
motor power	370w
size of circular knife	ø117 x 54 x ø112

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. Tighten all screws and nuts.

2. Cleaning grease dirt.

The machine are 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 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 belt pulley of the main shaft with hand and observe whether 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 turn 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 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.

JK-T801: The circular knife adjustment consists of precise worm and worm wheel which 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 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 adge, even work accidents.

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

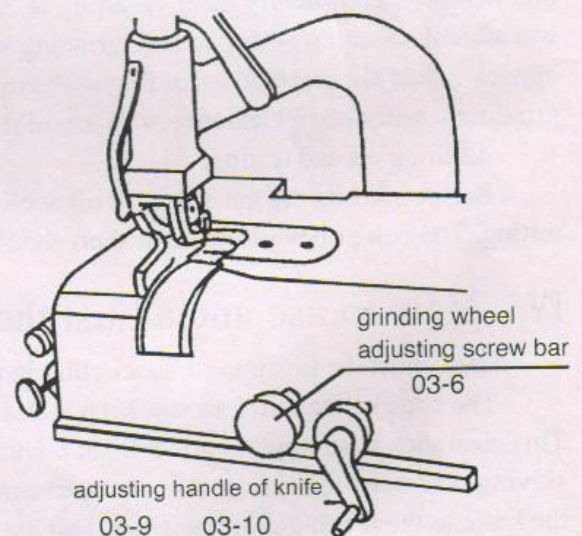
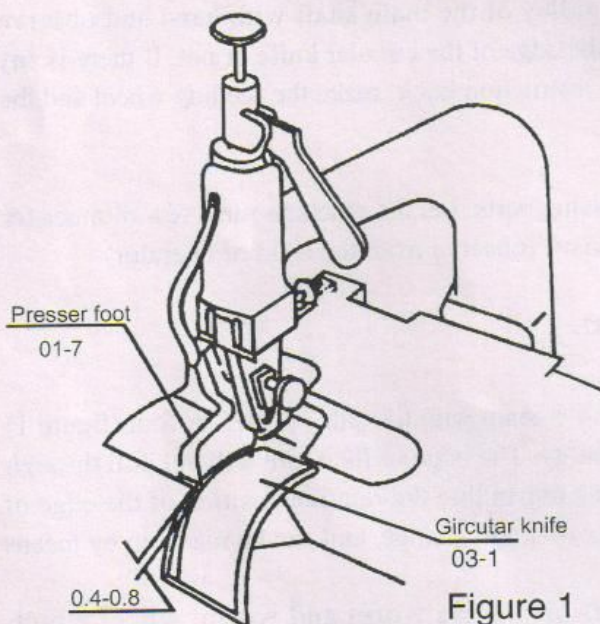
The feeding wheel has two functions. The main one is feeding material, anotheris grinding burrs of the inner side of the knife. The R centre of the feeding wheel should be indentcal with the R centre of the knife. This will do great good to feeding the material and grinding the knife. The R centres should 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 countrary 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 clockwise 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 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 counter clockwise 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 counterclock wise to decrease the angle, 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 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 5)

6. To adjust skiving speed.

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

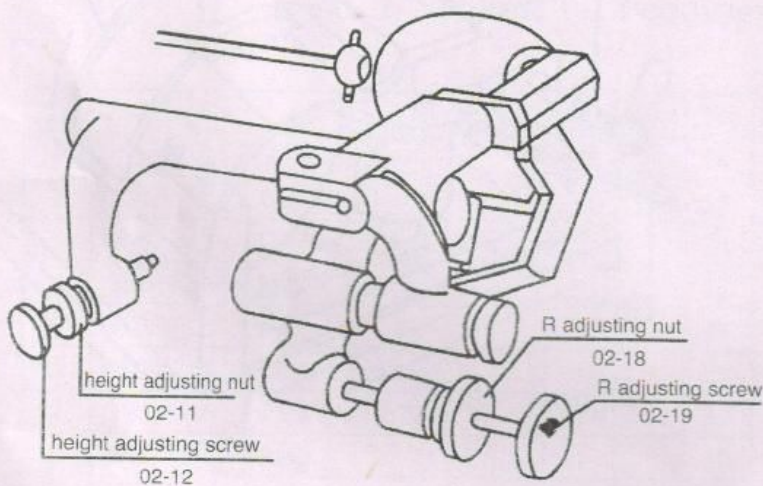


Figure 3

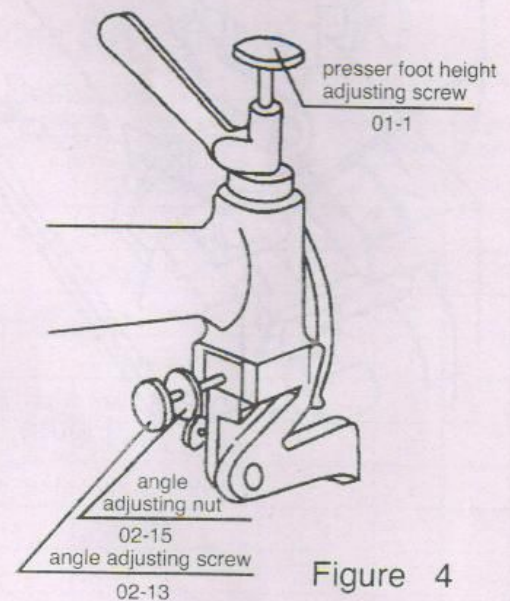


Figure 4

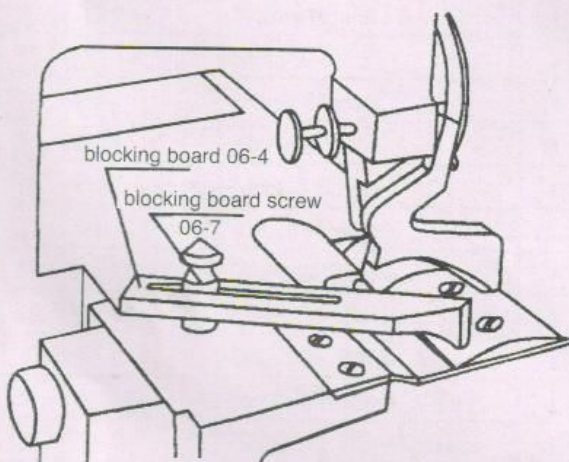


Figure 5

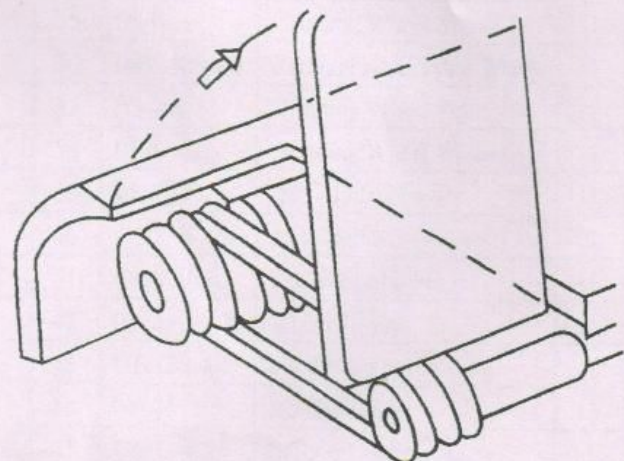


Figure 6

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. 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 the feeding wheel and move left and right until the surface of the feeding wheel 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 the grinding wheel dresser. (see Figure 8)

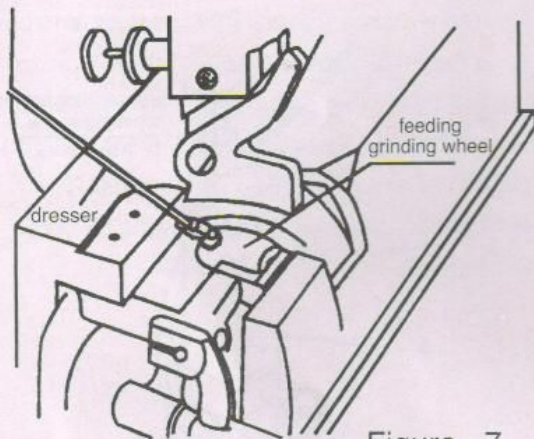


Figure 7

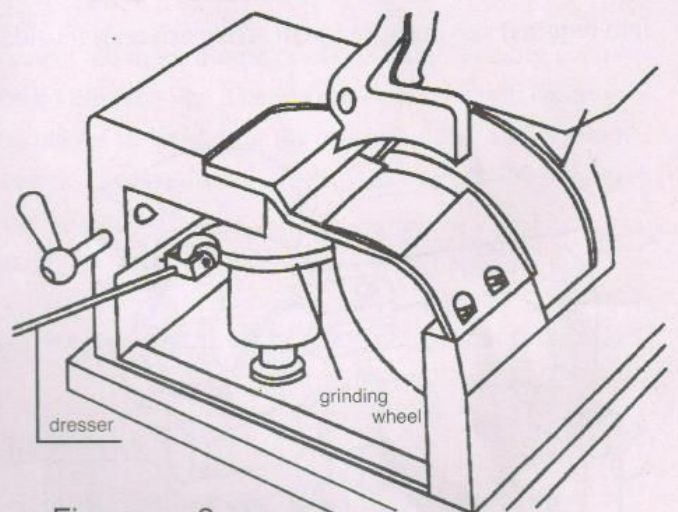
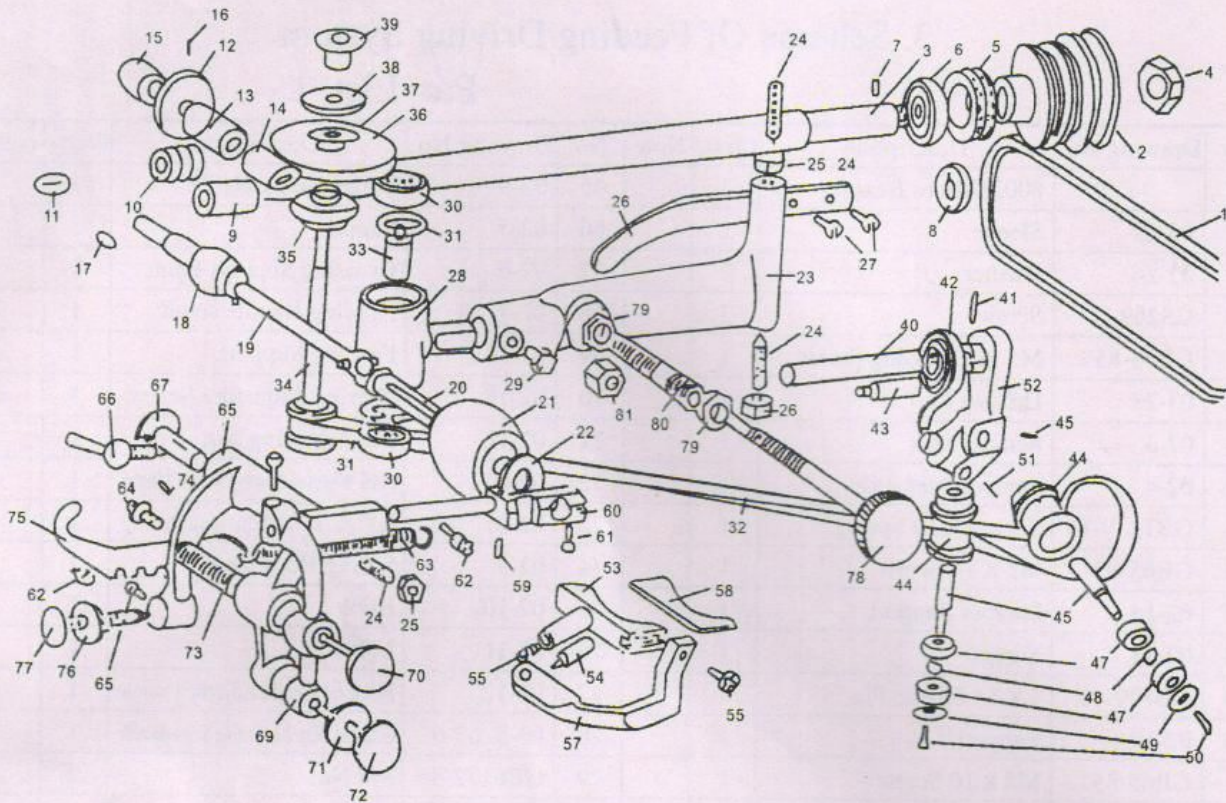


Figure 8



3. Scheme Of Feeding Driving System
Part List 1.

No.	Drawing No.	Description	Quantity	Note	No.	Drawing No.	Description	Quantity	Note
1		500Ruber Belt	1		24	02-22	M8x 32Holding Screw	2	
2	04-1	Beh Wheel	1		25	GB6172-86	M8 Nut	2	
3	04-5	Driving Shaft	1		26	05-1	Elastic Plate	1	
4	GB6172-86	M12 x 1.25 Nut	1		27	GB5781-86	M6x12 Screw	2	
5	04-3	Nut	1		28	05-5	Grinding Wheel Seal	1	
6	GB276-64	180202 Bearing	1		29	GB5781-86	M8 x 16 Screw	2	
7	GB879-86	4 x 8 Elastic Pin	1		30	GB276-82	1800101 Bearing	2	
8	04-2	Ring	1		31	GB893.2-86	B28 Stop Ring	1	
9	04-6	Sleeve	1		32		Plate Belt	1	
10	04-7	Worm	1		33	05-4	Ring	1	
11	GB1098-79	3 x 16 Key	1		34	05-2	Belt Wheel Axis	1	
12	04-13	Worm Wheel	1		35	05-6	Grinding Wheel Sleeve	1	
13	04-15	Sleceve	1		36	GB2489-84	ø70x8xøPlate Grinding Wheel	1	
14	04-15	Guide Sleeve	1		37	05-7	Grinding Wheel Skid	2	
15	04-12	Slcecev	1		38	05-8	Grinding Wheel Washer	1	
16	GB73-85	M4 x 8 Screw	1		39	05-9	(M8 - Left) Nut	1	
17	GB1096-79	3 x 12 Key	1		40	GB119-86	12 x 75 Pin	1	
18	04-14	Worm Wheel Axis	1		41	GB879-86	3 x 16 Elastic Pin	1	
19	14-16	Universal Driving Shaft	1		42	03-25	Worm Spring	1	
20	02-2	Grinding Wheel Axis	1		43	GB878-86	8 x 20 Screw Pin	1	
21	02-23	Drum Grinding Wheel	1		44	03-27	Rotting Wheel	2	
22	02-1	Grinding Wheel Sleece	1		45	GB73-85	M5 x 6 Holding Screw	1	
23	05-10	Surport	1		46	03-84	Rotting Wheel Axis	2	

3. Scheme Of Feeding Driving System Part List 1.

No.	Drawing No.	Description	Quantity	Note	No.	Drawing No.	Description	Quantity	Note
47		80026Micro Bearing	4		65	02-9	Spring Hook Nail	1	
48	03-22	Sleeve	2		66	02-5	Support	1	
49	03-26	Washer	2		67	02-6	Grinding Support Point	1	
50	GS269	Screw	2		68	02-7, 8	Holding Handle,screw	1	
51	GB73-85	M5 x 6 Holding Screw	1		69	02-16	Feeding Support	1	
52	03-23	Driving Rod	1		70	02-19	Tension Adjusting Screw	1	
53	02-3	Scraper Seat	1		71	02-18	M6 Adjusting Nut	1	
54	02-4	Scraper Sear Axis	1		72	02-20	Feed Wheel Adjusting Screw M6x65	1	
55	GB1239-76	0.5 x 9 x 10 Spring	1		73	02-21	2 x 12 x 49 Tension Spring	1	
56	GB65-85	M5 x 10 Screw	1		74	02-9	Spring Hook Nail	1	
57	02-14	Scraper Support	1		75	02-10	Hook	1	
58	02-13	Scraper	1		76	02-11	M8 Nut	1	
59	GB879-86	3 x 14 Elastic Pin	1		77	02-12	M8 x 60 Height Adjusting Screw	1	
60	02-17	Support	1		78	03-5 03-6	Grinding Wheel Adjusting Screw Handle	1	
61	GB65-85	M5 x 10 Screw	1		79	GB6172-86	M8 Nut	2	
62	GB878-86	8 x 20 Pin	1		80	03-4	Stud	1	
63	02-24	1.2 x 10 x 90 Tension Spring	1		81	03-50	Stud Hloding Nut	1	
64	02-15	Spring Joint A.B	1		82				