

HIGHLEAD

YXP-18

圆刀销皮机
Skiving machine

使用说明书
Instruction Manual
零件样本
Parts Catalog

SHANGHAI BIAOZHUN HAILING SEWING MACHINERY CO., LTD.

削皮機使用說明

一、用途

本機為皮革製品的必備設備、廣泛用於皮鞋、皮衣、皮袋、皮帶和皮手套等的各種天然革、PU革零件之折邊的邊緣坡口和均勻修薄加工。

二、特點

- 1、本機設計精巧、結構緊湊；調節靈活，使用方便；性能優良。
- 2、採用低噪音精密軸承，零件製作精細，整機噪音低。
- 3、備有磨刀裝置。磨刀由離合器手柄控制、操作簡單、節省能耗。
- 4、設有平皮帶自動張緊裝置，轉動安全可靠。
- 5、附有自動除屑裝置。
- 6、易損件更換方便。

三、主要技術參數

- 1、電機：功率. 370—550W；轉速. 1400rpm
- 2、圓刀規格：Φ118×Φ114×54 (mm)
- 3、圓刀轉速：1270rpm
- 4、圓刀軸向位移：30 (mm)
- 5、送料輪轉速：62、99、132rpm
- 6、送料輪速度：9274、14766、19688mm/min
- 7、削皮寬度：10—50mm
- 8、磨刀砂輪：Φ70×Φ20×8 (mm)
- 9、噪音：小於 60dB (A)
- 10、整機重量：40kg

四、安裝、使用與調整

1、安裝

本機經過嚴格測試檢驗，出廠時處於完好狀態，一經安裝妥當便可正常工作。安裝時，請安裝好機架台板，再用後鈕固定銷、後鈕座 (G167, G168) 將機器安裝在台板上、然後裝上符合要求的電機，配上三角皮帶，正式使用前應先通電試機，當確認圓刀轉向正確 (從刀端方向看，圓刀順時針方向旋轉) 整機運轉正常後方可投入使用。

2、使用與調整

1) 根據皮革加工所要求的厚度不同，對壓腳(B26)的高度進行調整，當皮革需要均勻減薄時，請使用壓腳A；當皮革要求坡口時，請使用壓腳B；當皮革要求折角時，請使用壓腳C；削皮寬度，用定規(G6)控制。

2) 當需要提高或降低送料速度時，可通過改變三角皮帶在皮帶輪上的位置來實現。

3) 送料輪與圓刀の間隙由螺絲(E126)和(B33)調節；調節(B33)可使送料輪與圓刀在各處の間隙均勻；調節(E126)可使送料輪與圓刀の間隙減小或增加，送料輪不得與圓刀相碰。

4) 圓刀刃不鋒利時，可操縱離合把手(C88)帶動磨刀砂輪架使砂輪轉動，轉動石軸調螺絲(D116)刃磨刀口。

5) 圓刀磨損後，擰松螺帽(D115)，可轉動刀片調球把(C72)使刀軸向左移動，圓刀刃口與壓板在平面的距離保持在0.1~0.5為宜。然後擰緊螺帽(D115)方可正常工作。

6) 使用隨機工具(G165)，調整(推或拉)刀片盤組(C41)在圓刀內的軸向位置，可獲得要求的拋屑效果。

五、維護

1、操作使用前，應檢查機件是否完整，各轉動部位是否轉動靈活；

2、定期對各運轉部位加注潤滑油；

3、圓刀使用磨損後，應及時修磨；

4、發現運轉異常或雜訊突然增大，應立即停機檢查；機件磨損後應及時修理、更換；保持機器清潔。

General Description and Instruction

I . Application

This machine is special equipment for making of leather goods. It is widely used for the shaping of slope edge and the even skiving of various parts for leather material and PU material goods such as leather shoes, gloves, bags, wallet, belt and suitcase, etc.

II . Features

1. Rational design, compact in structure, easy operation, simple adjustment and good performance.
2. Low noise level because of adoption of low noise precision bearings and making at utmost care.
3. With knife sharpener. Driven through clutch level, easy operation and saving on energy.
4. With automatic belt stretcher, safety and reliability in driving.
5. With automatic of spare parts.
6. Easy replacement cleaning.

III. Main Specifications

1. Motor: 370—550W, 1400rpm
2. Knife size: $\Phi 118 \times \Phi 114 \times 52(\text{mm})$
3. Knife speed: 1270rpm
4. Knife axial displacement: 30mm
5. Feed wheel speed: 62, 99, 132rpm
6. Feeding speed: 9247, 14766, 19688mm / min
7. Skiving width: 10—50mm
8. Abrasive wheel size: $\Phi 70 \times \Phi 16 \times 8(\text{mm})$
9. Noise level: < 60 dB (A)
10. Weight: 40kg

IV. Installation and adjustment

1. Installation

When it's being installed, first assemble the stand and work table, then fix the machine on the table by two pairs of hinge, lastly fix the desired motor on the rear side of the table and fit up V. belt. Before being put into operation, it must be trial operated and it is certain that the turn direction of the knife is correct (seeing knife rightwards it turns clockwise) and the machine functions normally.

2. Adjustment

It is necessary to make some adjustments according to the skiving requirements.

1) When the desired skiving thick of the parts for leather goods varies, please adjust the height of presser foot (B26) correspondingly. In the case of even skiving and slope skiving, please respectively use presser foot A and presser foot B; and when a U shape skiving is required, please use presser foot C. Skiving width can be adjusted through the ruler (G6) .

2) When it is necessary to change the feeding speed, please change the position of the V. belt on the belt pulley.

3) The clearance between the feed wheel and the knife can be adjusted by turning the handles (E126&B33). When equal or different clearance along the knife edge is required, please turn the handle (B33). Turning the handle (E126) makes the clearance equally decreased or increased. Be sure that feed wheel can't collide with knife.

4) When knife is blunt, set the clutch leveler at work position, and then turn the screw (D116) slowly to grind the knife.

5) After the knife is worn, move the knife axis leftwards slightly by turning the knob. The proper distance between the right surface of the presser foot and the knife edge is 0.1—0.5mm.

6) Through pushing or pulling the cleaner (C41) by accessory (G165), the axial position of cleaner in the knife can be adjusted and the desired cleaning result for different material scrap can be got.

V. Maintenance

1. Before operation, be sure the machine is in a good condition.

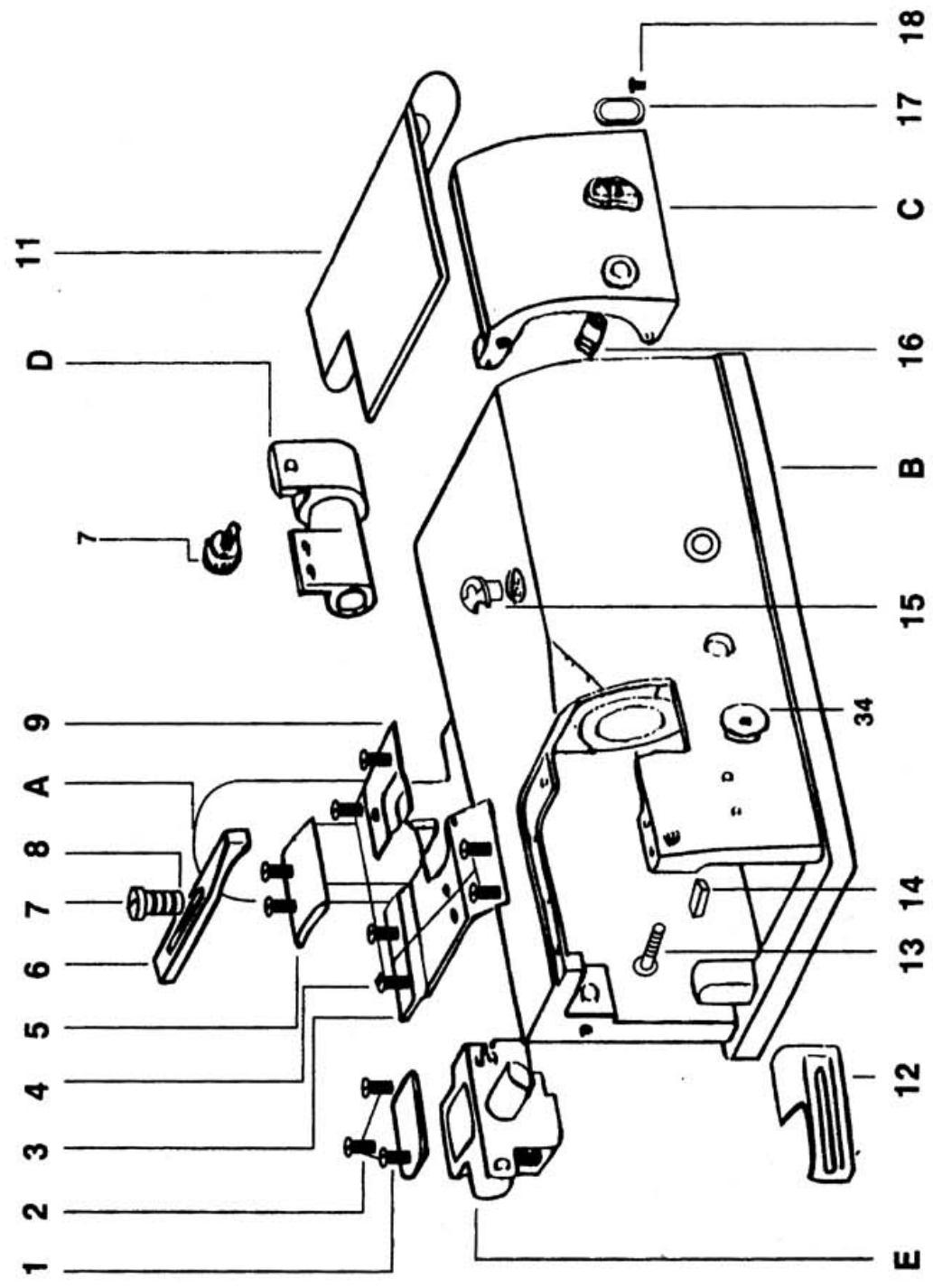
2. Periodically feed oil on the moving parts.

3. Sharpen the knife when it is blunt.

4. If there is abnormal noise or bard running of the machine, it must be stopped and checked at once. If necessary, please have it repaired by a qualified technician. Don't go into operation until the machine has arrived at the good condition.

5. Keep the machine clean.

A 本體部份 ARM BED AND ITS ACCESSORIES

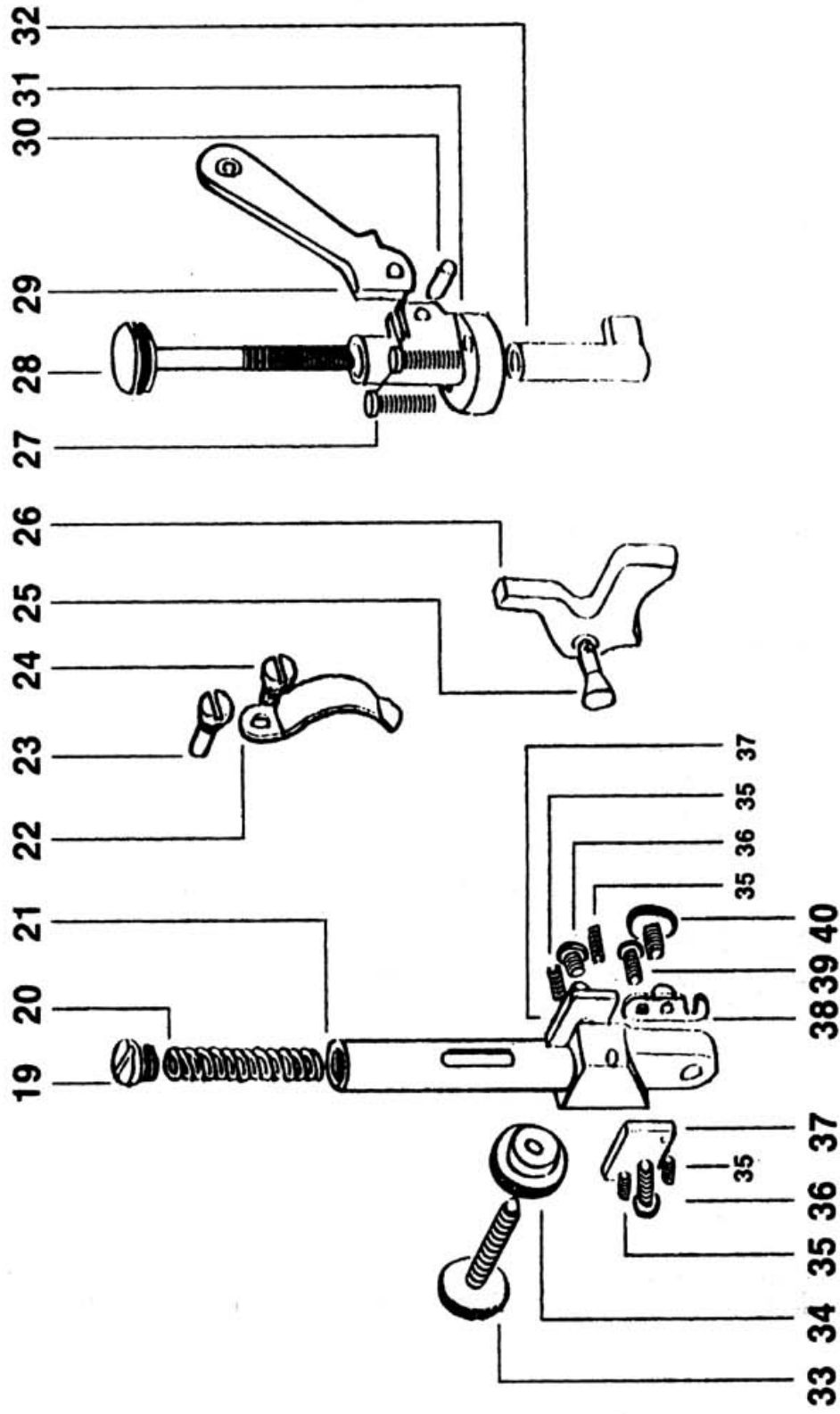


A. 本體部份 ARM BED AND ITS ACCESSORIES

零件號碼 Part No.	零件名稱 Name Part	件數 QTY	備注 REMARKS
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A	彎管	1	Bent Pipe
B	底座	1	Foundatidn
C	皮帶外蓋	1	Belt Cover Plate
D	橫軸後襯套	1	Transmission Shaft
E	齒輪箱	1	Worm Gear Box
1	齒輪箱蓋	1	Worm Gear Box
2	螺絲	3	Screw (9/64-40*7.5)
3	滑板A	1	Slide Plate A
4	螺絲	8	Screw (11/64-40*7)
5	滑板C	1	Slide Plate C
6	定規	1	Ruler
7	螺絲 (段付)	2	Screw (M6 *1.0*17)
8	平墊圈	1	Washer
9	滑板B	1	Slide Plate B
11	皮帶上蓋	1	Belt Cover lid
12	切屑擋板	1	Waste Feeder Metals
13	螺絲 (段付)	1	Screw (15/64-28*31)
14	彈簧銷	1	Spring Pin
15	油塞蓋	1	Oil Bung Cap
16	離合套管	1	Clutch Pipe
17	離合止塊	1	Clutch Control Block
18	螺絲	2	Screw (9/64-40*10)

B 押脚機構 PRESSER FOOT MECHANISM

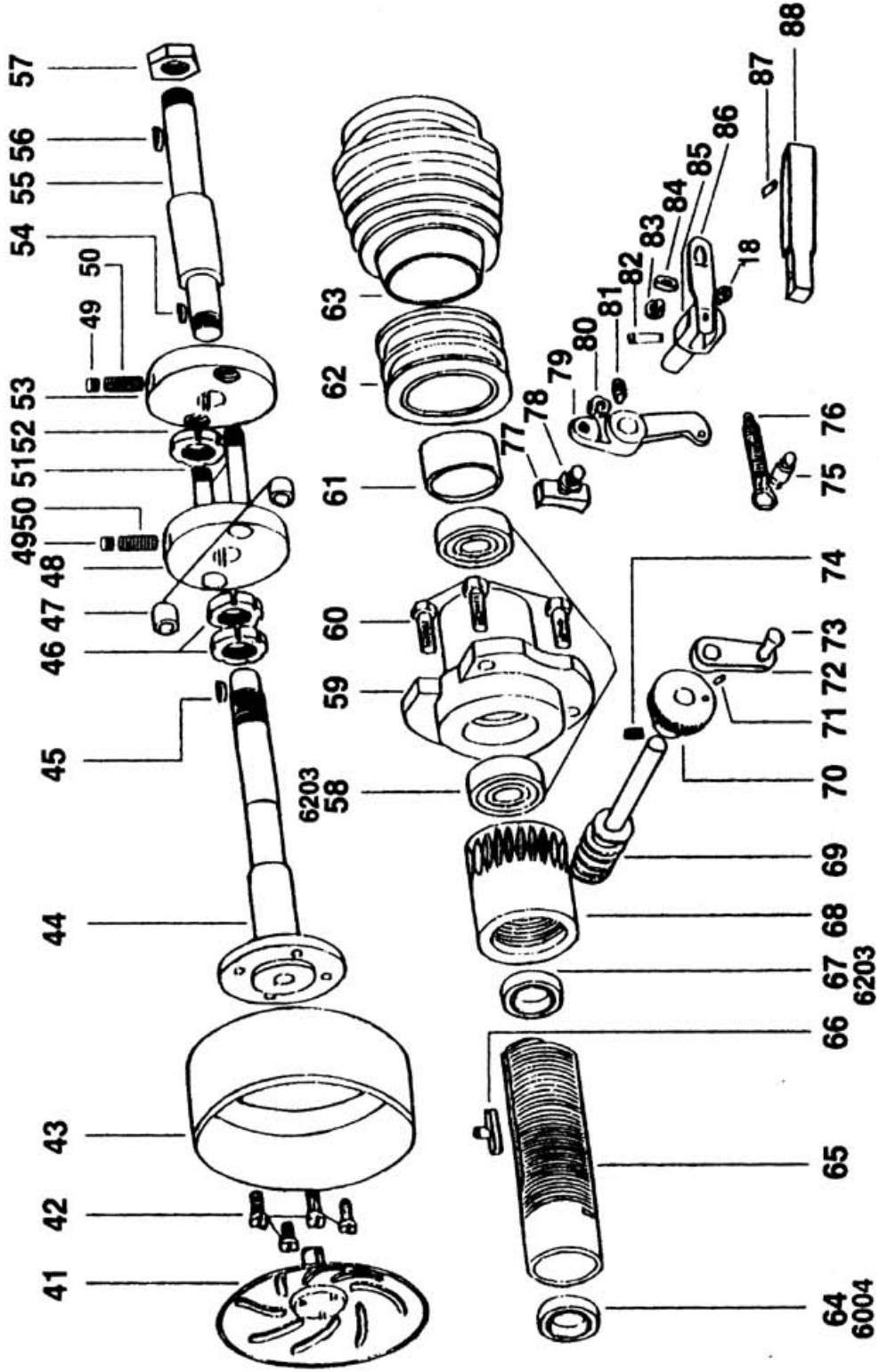


B. 押腳機構 PRESSER FOOT MECHANISM

零件號碼 Part No.	零件名稱 Name Part	件數 Q'TY	備注 REMARKS
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19	螺絲	Screw (1/2-28*13.5)	1
20	壓縮彈簧	Presser Bar Spring	1
21	押桿	Presser Bar	1
22	押腳彈板	Presser Bar Spring	1
23	螺絲 (段付)	Screw (15/64-28*23)	1
24	螺絲 (段付)	Screw (3/16-32)	1
25	押腳軸	Presser Foot Shaft	1
26	押腳	Presser Foot	1
27	螺絲	Screw (3/16-28*15)	2
28	螺絲 (段付)	Screw (15/64-28)	1
29	押桿提桿	Presser Bar Lifter	1
30	平行銷	Pin	1
31	押桿托架	Presser Bar Lifter Bracket	1
32	押桿托桿	Presser Bar Lifter Lever	1
33	螺絲	Screw (15/64-28)	2
34	螺絲	Nut (15/64-28*12)	3
35	螺絲	Screw (9/64-40*10)	4
36	螺絲	Screw (3/16-28*5.4)	2
37	押桿止板	Presser Foot Side Plates	2
38	押腳止鉤	Presser Foot Shaft Hook Metal	1
39	螺絲 (段付)	Screw (3/16-28)	1
40	螺絲	Screw (M5*0.8*17)	1

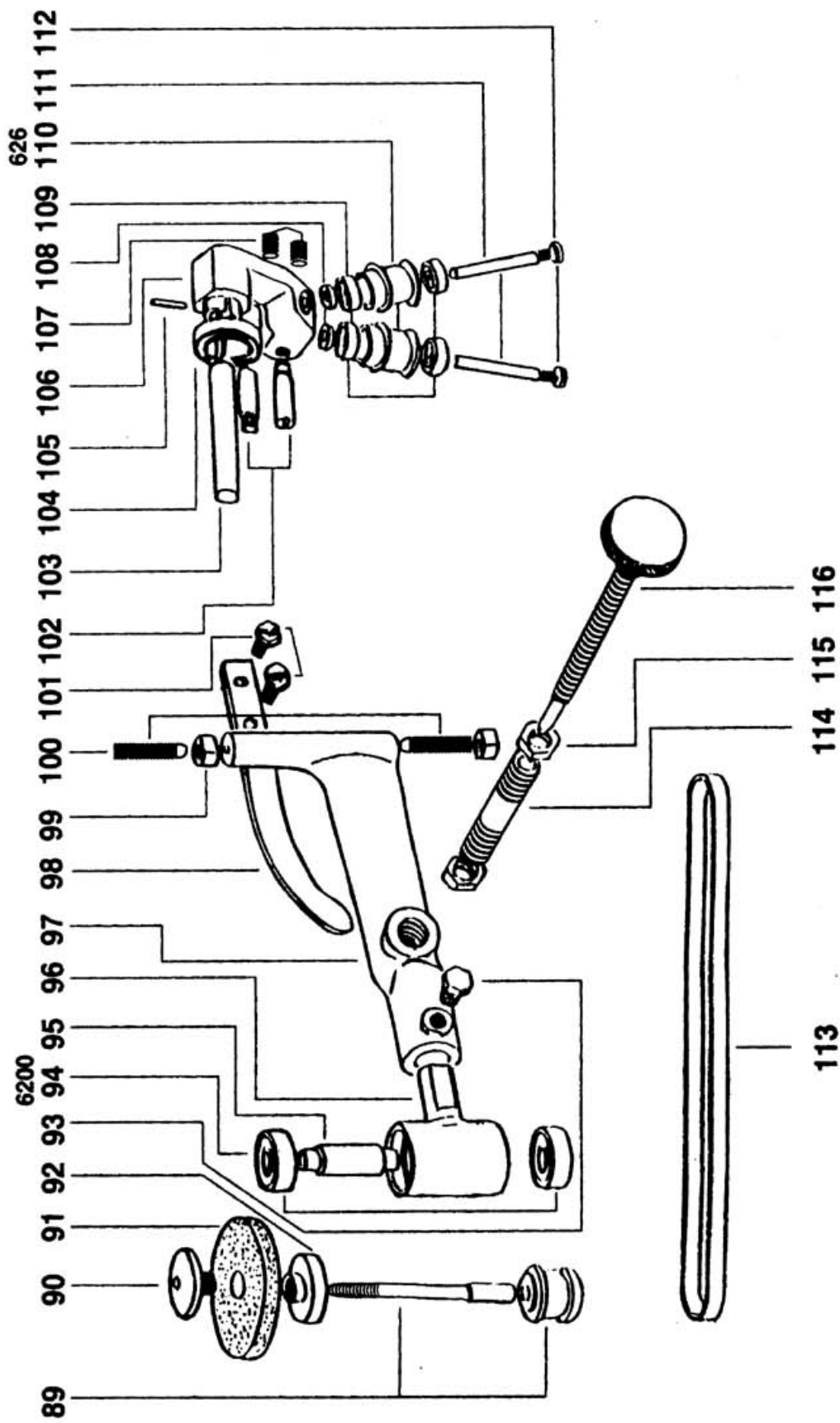
C 刀軸機構 KNIFE SHAFT MECHANISM



C. 刀軸機構 KNIFE SHAFT MECHANISM

號碼	零件名稱	Name Part	件數	備注	號碼	零件名稱	Name Part	件數	備注
Part No.			Q'TY		Part No.			Q'TY	
41	刀片盤組	Knife Inner Cover	1		65	刀軸套筒	Knife Shaft Lead Pipe	1	
42	螺絲	Screw (15/64*28*10)	4		66	刀軸套筒鍵	Knife Shaft Lead Pipe Key	1	
43	刀片	Knife	1		67	滾珠軸承	Ball Bearing (6203)	1	
44	刀軸	Knife Shaft	1		68	刀軸管鋼齒	Knife Shaft Lead Pipe Gear	1	
45	半圓鍵	Knife Shaft Key	2		69	刀軸蝸桿	Knife Shaft Worm	1	
46	防鬆螺帽	Nut (M17*1.5)	2		70	刀片調球	Knife Adjusting Knob	1	
47	塑膠襯套	Rubber Bushings	2		71	平行銷	Pin	1	
48	聯結板 (左)	Pulley Shaft Flange holeder	1		72	刀片調球把	Knife Adjusting Handle	1	
49	螺絲	Screw (9/32-28*4.5)	2		73	刀片調把手	Knife Adjusting Handle knob	1	
50	螺絲	Screw (9/32-28*19)	2		74	內六角螺絲	Screw(11/64*40*5)	1	
51	固定軸 (段付)	Flange Shaft (5/16*24*18)	2		75	螺絲 (段附)	Screw(15/64-28*8)	1	
52	螺帽	Nut (M16*1.5x7)	1		76	離合伸彈簧	Clutch Spring	1	
53	聯結板 (右)	Pulley Shaft Flange	1		77	滑動塊	Clutch Slide Block	1	
54	半圓鍵	Pulley Shaft Key (Small)	1		78	螺絲 (段附)	Screw (1/4-40*12)	1	
55	後軸軸心	Pulley Shaft	1		79	離合器臂	Clutch Arm	1	
56	半圓鍵	Pulley Shaft Key (Large)	2		80	螺帽	Nut (1/4-40*4)	1	
57	螺帽	Nut (M16*1.5x7)	1		81	內六角螺絲	Screw (15/64-28*11)	1	
58	滾珠軸承	Pulley Shaft Bearings (6203)	2		82	螺絲	Screw (9/64-40*3)	1	
59	套管	Pulley Shaft Metal	1		83	螺絲 (段附)	Screw (9/64-40*4)	1	
60	螺絲	Screw (5/16-24*13)	3		84	華司	Washer	1	
61	含油軸承	Clutch Bushing	1		85	離合把軸	Clutch Lever Shaft	1	
62	離合器	Clutch	1		86	離合彈片	Clutch Lever Spring	1	
63	皮帶輪	Pulley	1		87	平行削	Pin	1	
64	滾珠軸承	Ball Bearing (6004)	2		88	離合器把手	Clutch Lever	1	

D 磨刀機構 KNIFE GRINDING MECHANISM



D. 磨刀機構 KNIFE GRINDING MECHANISM

零件號碼 零件名稱

Name Part

件數

備注

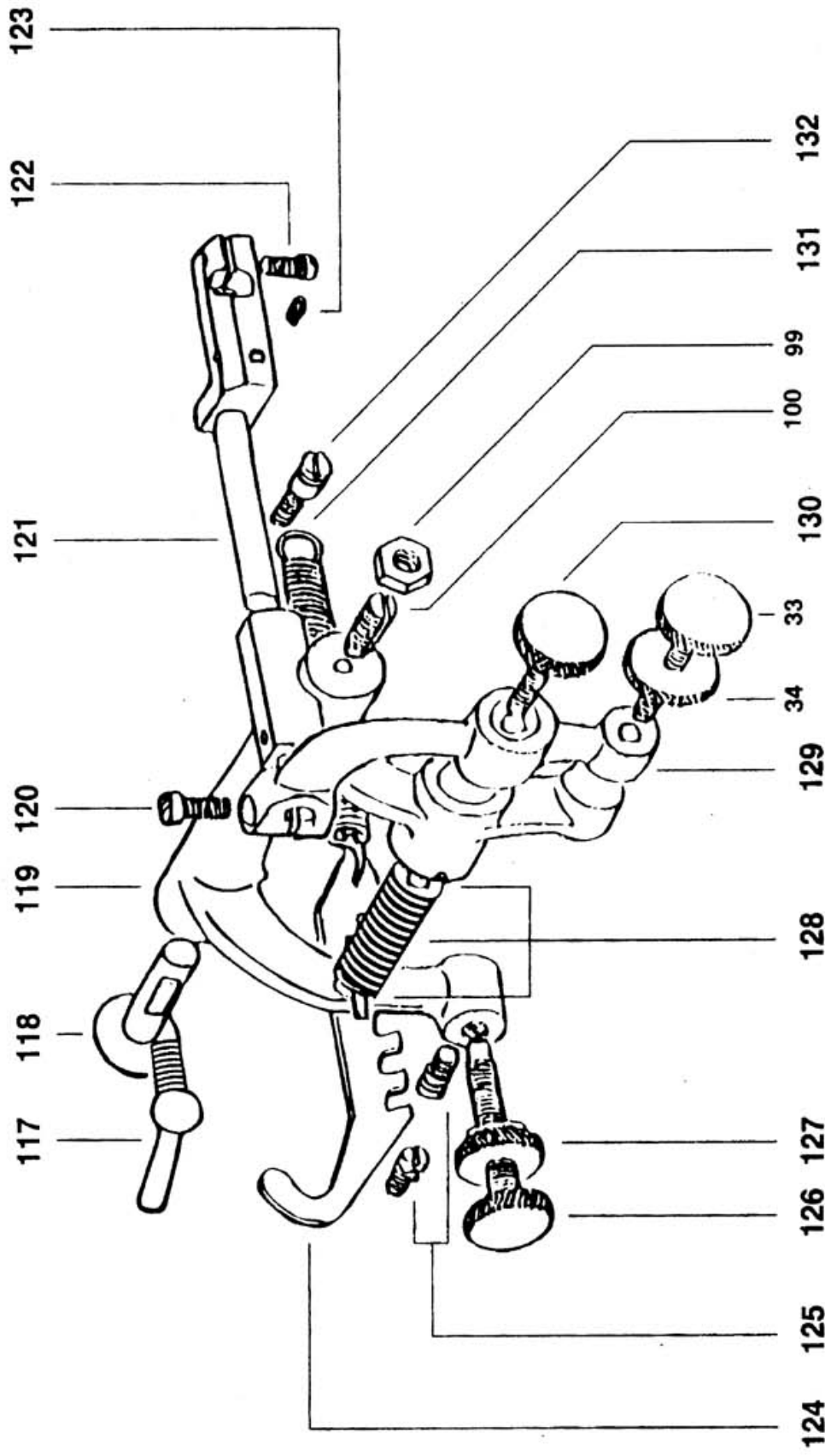
Part No.

Q'TY

REMARKS

89	磨刀石軸 (段付)	Grindstone Shaft (9/32*28)反才	1	
90	磨刀螺絲	Grindstone Set Screw (1/2*28)	1	
91	磨刀石	Grindstone	1	
92	磨石螺帽	Grindstone Set Nut (1/2*28)	1	
93	螺絲	Screw (5/16-24*13)	1	
94	滾珠承軸	Pulley Shaft Bearings (6200)	2	
95	磨石軸柱	Grindstone Shaft Bearing Holding Roller	1	
96	磨石軸架	Grindstone Shaft Becket	1	
97	磨石軸臂	Grindstone Shaft Becket Arm	1	
98	磨石臂彈簧	Grindstone Shaft Becket Arm Spring	1	
99	螺帽	Nut (5/16-24*7)	3	
100	螺絲	Screw (5/16-24*32)	3	
101	螺絲	Screw (15/64-28*14)	2	
102	螺絲 (段付)	Screw (5/16-24*8)	2	
103	皮帶定位架	Belt Guide Bracket Shaft	1	
104	皮帶架彈簧	Belt Guide Bracket Spring	1	
105	推拔銷	Taper Pin	1	
106	皮帶定位架	Belt Guide Bracket	1	
107	螺絲	Screw (15/64-28*8)	3	
108	平墊圈	Washer	2	
109	滾珠承軸	Pulley Shaft Bearings (626)	4	
110	平皮帶輪	Belt Guide Pulleys	2	
111	皮帶輪軸	Belt Guide Pulleys Shaft	2	
112	螺絲	Screw (11/64-40*5.5)	2	
113	內皮帶	Grindstone Shaft Belt	1	
114	調整槽 (中段付)	Grindstone Adjusting Screw Pipe (1/2*28*91)	1	
115	螺帽	Nut (1/2-28*7)	3	
116	石軸調整螺絲	Grindstone Adjusting Screw	1	

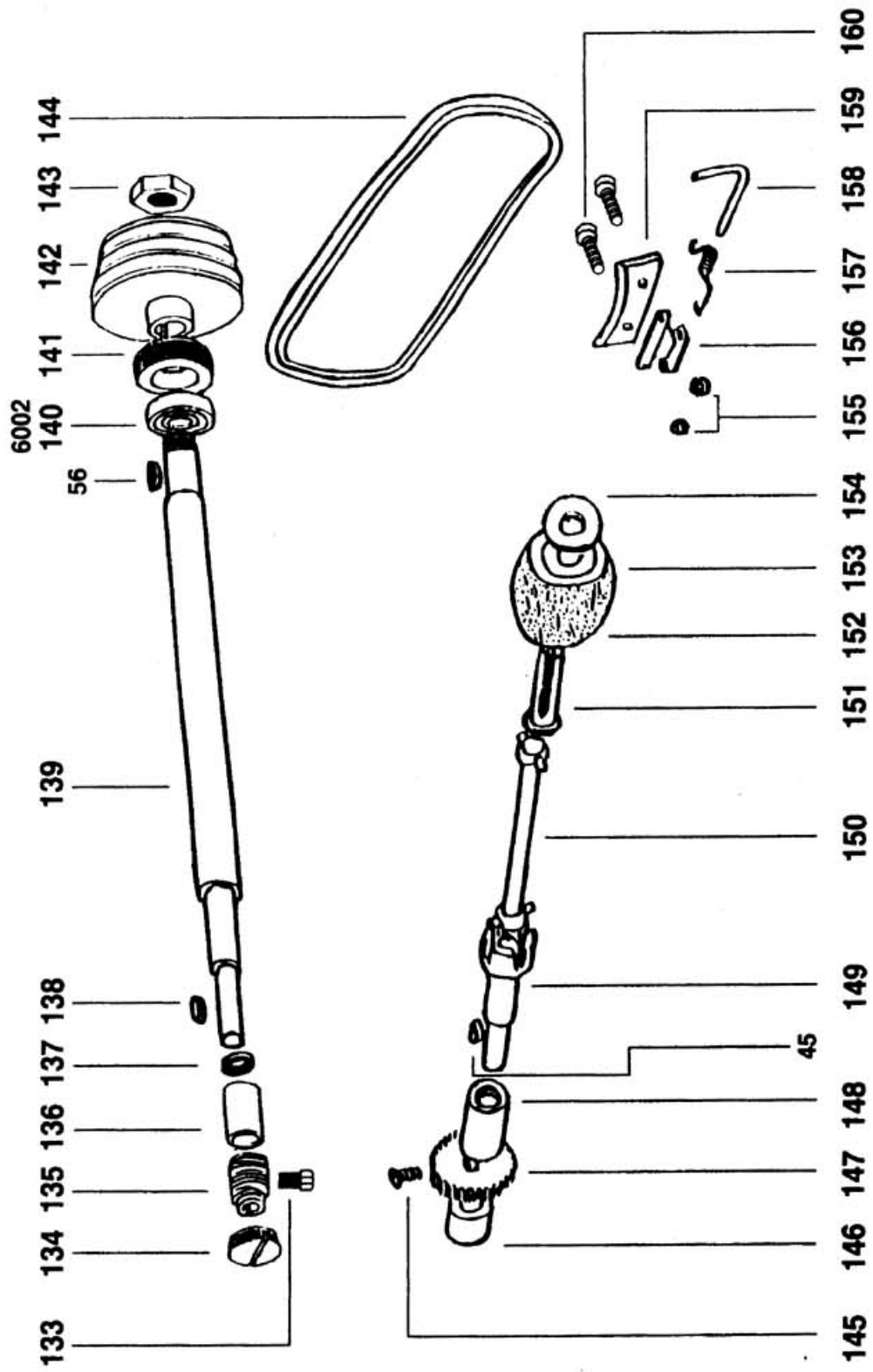
E 送料調整機構 FEED REGULATING MECHANISM



E. 送料調整機構 FEED REGULATING MECHANISM

零件號碼 Part No.	零件名稱 Name Part	件數 Q'TY	備注 REMARKS
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117	固定螺絲	1	Roller Bracket Arm Center Pin Screw(5/16*24*15)
118	托架臂梢	1	Roller Bracket Arm Center Pin
119	托架臂	1	Roller Bracket Arm
120	螺絲	1	Screw (15/64-28*14)
121	滾輪托架	1	Roller Bracket
122	螺絲	1	Screw (15/64-28*9)
123	螺絲	1	Screw (11/64-40*5)
124	拉伸掛鉤	1	Roller Bracket Arm Spring Hook Metal
125	螺絲 (段付)	2	Screw (15/64-28*6)
126	螺絲	1	Screw (5/16-24)
127	螺帽	1	Nut (5/16-24*11)
128	拉伸彈簧組	1	Roller Bracket Turning Arm Spring
129	托架轉臂	1	Roller Bracket Turning Arm
130	螺絲	1	Screw (15/64-28)
131	拉伸彈簧	1	Roller Bracket Arm Spring
132	螺絲 (段付)	1	Screw (15/64-28*8)

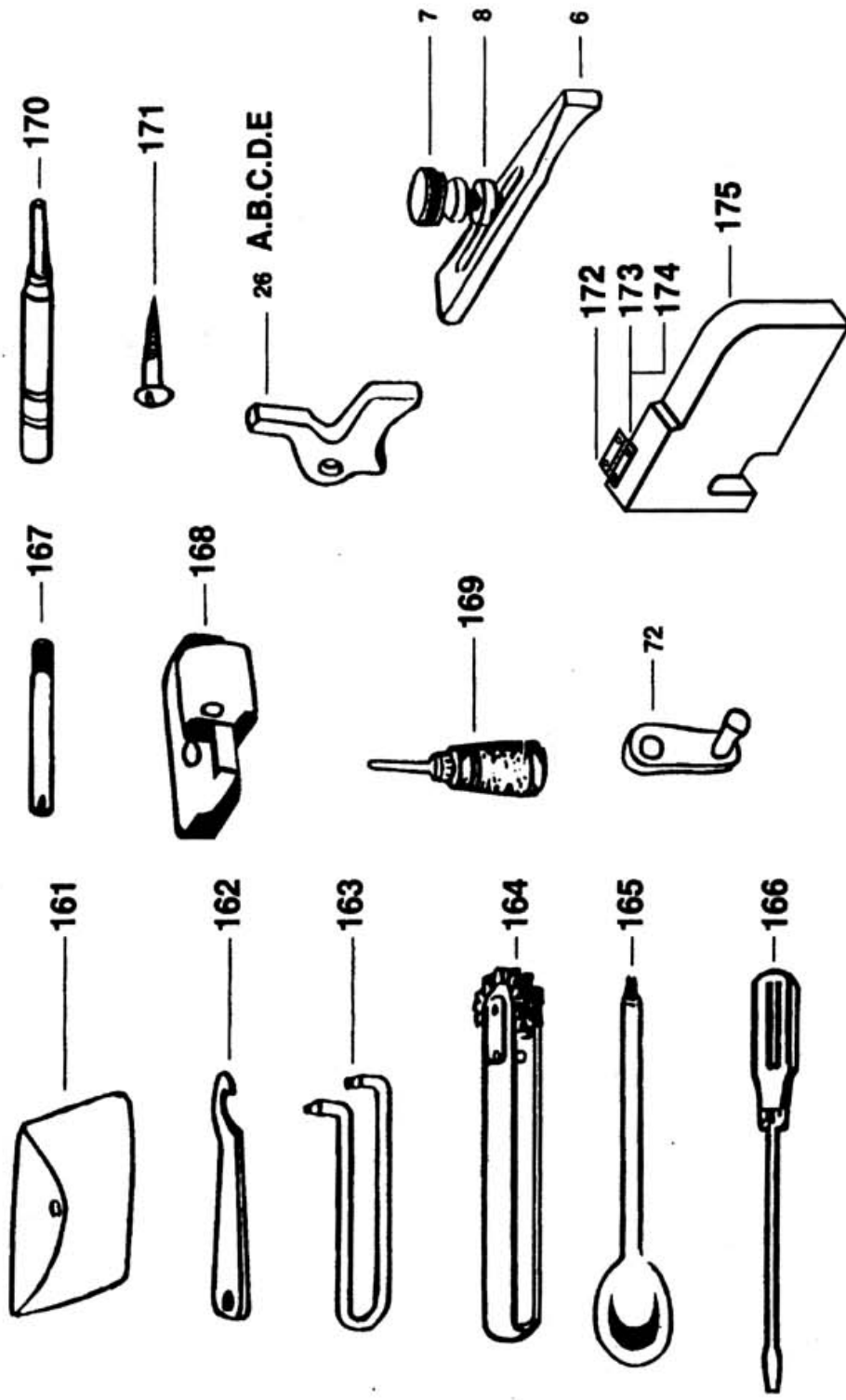


F. 送料機構 FEEDING MECHANISM

零件號碼 Part No.	零件名稱 Name Part	件數 Q'TY	備注 REMARKS
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133	螺絲	Screw (3/8*28)	1
134	螺絲	Screw (M24*1.0*7)	1
135	橫軸齒輪	Main Shaft Worm Gear	1
136	前軸套管	Main Shaft Front Bushing	1
137	油塞	Oil Cover	1
138	半圓形鍵	Knife Shaft Key	1
139	橫軸	Main Shaft	1
140	滾珠軸承	Pulley Shaft Bearings (6002)	1
141	押緊螺絲	Main Shaft Bearing Holder Screw(M36*1.5)	1
142	皮帶輪	Main Shaft Pulley	1
143	螺帽	Nut (M14*1.5*8)	1
144	三角皮帶	Main Shaft Belt	1
145	螺絲	Screw (9/64-40*8.5)	1
146	齒輪套管 (2)	Roller Driving Shaft Metel (2)	1
147	鋼輪	Main Shaft Worm Gear Wheel	1
148	齒輪套管 (1)	Roller Driving Shaft Metel (1)	1
149	滾輪軸	Roller Driving Shaft	1
150	金光棒	Roller Driving Shaft Join	1
151	滾輪軸	Roller Shaft	1
152	鵝卵石	Eggstone	1
153	蛋石內軸	Roller	1
154	平墊圈	Roller Washer	1
155	螺帽	Nut (9/64-40*3)	2
156	消除止板	Waste Clear Metal	1
157	彈簧	Waste Clear Metal Spring	1
158	固定軸	Waste Clear Metal Shaft	1
159	清除板	Waste Clear Metal Leather	1
160	螺絲	Screw (9/64-40*10)	2


G 附件 ACCESSORIES



G. 附件 ACCESSORIES AND ITS ACCESSORIES

零件號碼 Part No.	零件名稱 Name Part	件數 Q'TY	備注 REMARKS
161	工具袋 ----- Accessory Bag -----	1	
162	刀螺帽板手 ----- Knife Shaft Spanner -----	1	
163	磨刀石起子 ----- Grindstone Nut Spanner -----	1	
164	磨刀修平器 ----- Grindstone D dresser -----	1	
165	刀片蓋棒 ----- Knife L inner Cover Remove -----	1	
166	螺絲起子 (大) ----- Driver (Large) -----	1	
167	後鈕固定銷 ----- Hinge Pins -----	2	
168	後鈕座 ----- Hinges -----	2	
169	油壺 (中) ----- Oiler (Middle) -----	1	
170	磨刀石棒組 ----- Bar Type GrindStone -----	1	
171	木螺絲 ----- Screw (5.5*25) -----	4	
72	刀片調把手 ----- Knife Adjusting Handle -----	1	
26	押板 ----- Pulley Shaft Flange Screws -----	1	
7	螺絲 ----- Screw (M6*1.0*17) -----	1	
8	平墊圈 ----- Washer -----	1	
6	定規 ----- Ruler -----	1	
172	铰链 ----- Hinges -----	1	
173	螺絲 ----- Screw -----	2	
174	平墊圈 ----- Washer -----	2	
175	防护罩 ----- Cover -----	1	

H 特別配件組 SPECIAL PARTS

		REMARKS 備注
		X SPECIFICATION
26A	55	选配 options
26B	50	机器上 on the machine
26C	40	选配 options
26D	30	选配 options
26E	25	附件内 In the accessories

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The description covered in this manual is subject to change for improvement of the commodity without notice

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