

# **HIKER ENTERPRISES LTD.**

1750 Brimley Road, Scarborough, Ontario, Canada M1P 4X7  
Telephone: (416) 299-0765 Fax: (416) 299-4563

## **MICRO COMPUTER BELT CUTTING MACHINE**

Model: HM-105 A

# **OPERATION MANUAL**

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## 1. INTRODUCTION:



We, *Hwa Hung Ming Enterprises Co., Ltd.*, has been designing and manufacturing the micro computer belt cutting machine for years. Those belt cutting machines were manufactured by our company all adopted the micro computer controlling system, step motor, reducing speed motor and etc. new component, and the angles of the JS-208 machines can adjust as you like it through our design. Those are convenient to operate and more precise for cutting. The feeding speed is very quickly and the speed can reach 80000 mm/min or more over. The feeding length can be setted by digital, the least length is 1mm and the longest can be reached 99999mm. The actual operating quantity can be indicated by the digital indicator also. The machines are also installed the micro and cutting blade switch for convenient to operate. The upper press roller adopts urilic roller, long life for machine, and the material not to slide. Especially suitable for leather, plastics, shoes-making, wardrobe, electronic texture, handicraft and etc., career to use.

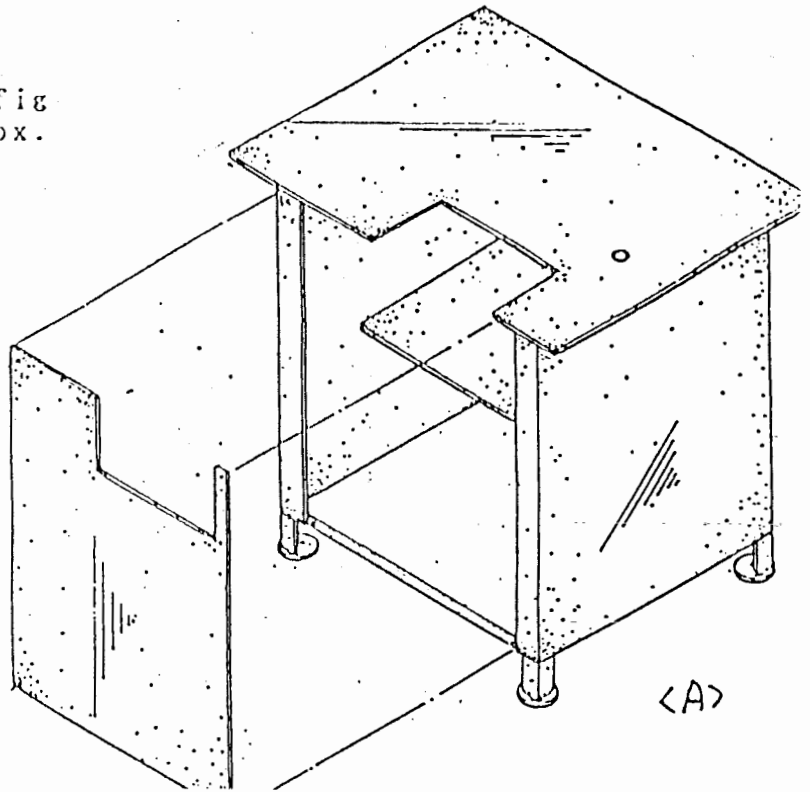
2. (1) MACHINE SIZE: L: 650mm  
W: 980mm  
H: 1280mm

(2) MACHINE WEIGHT: 137KGS

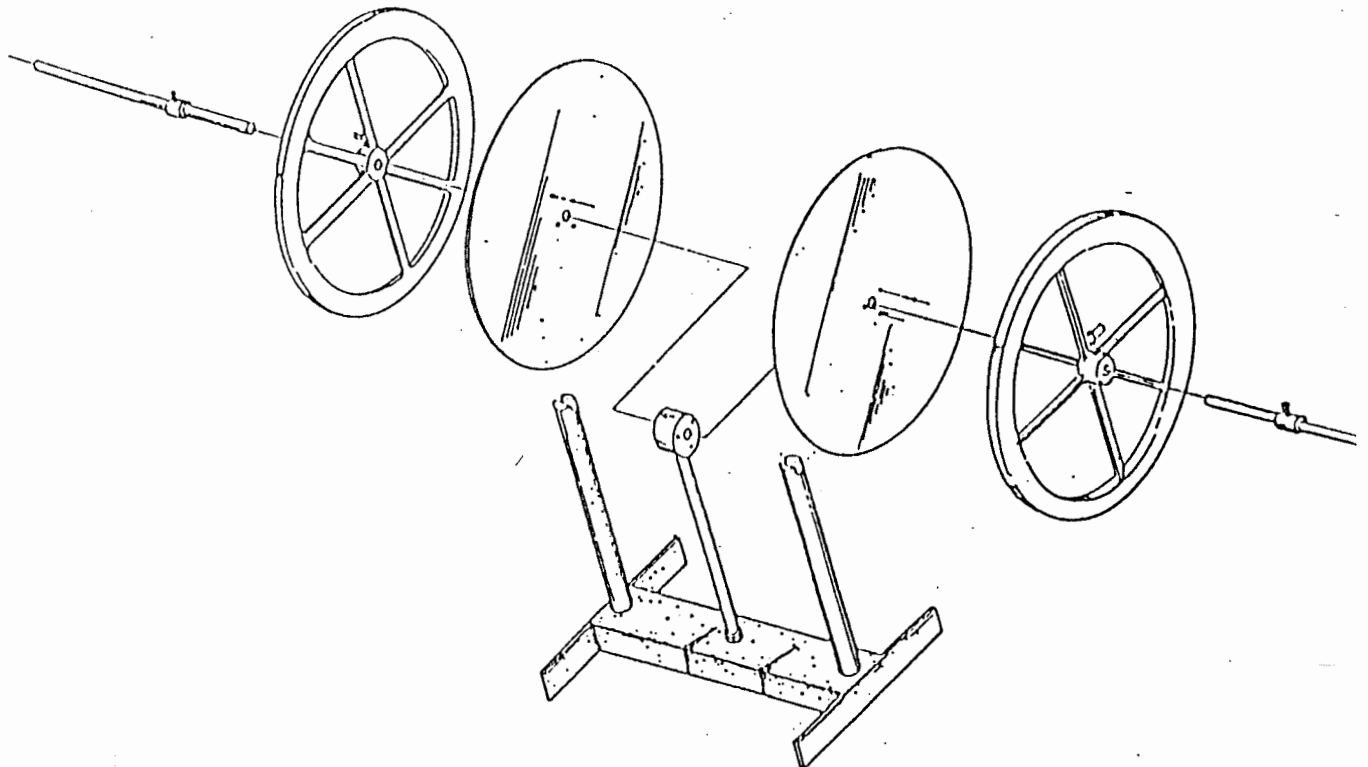
- (3) PACKING SIZE:116X64X150CM
- (4) G.W OF PACKING:185KGS

3. STEPS OF DISASSEMBLY:

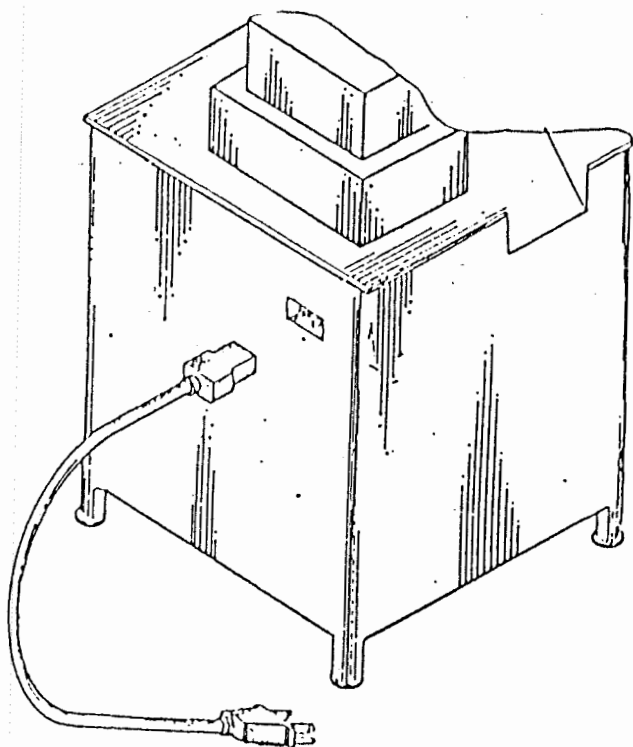
- (1) Open the rear box cover. as fig
- (2) Take out the things in the box.
- (3) Close the rear box cover.  
[From (1) to (3) as fig(A)]



- (4) Cleaning the protection oil on the machine.
- (5) Assembly the feeding rack. as fig:



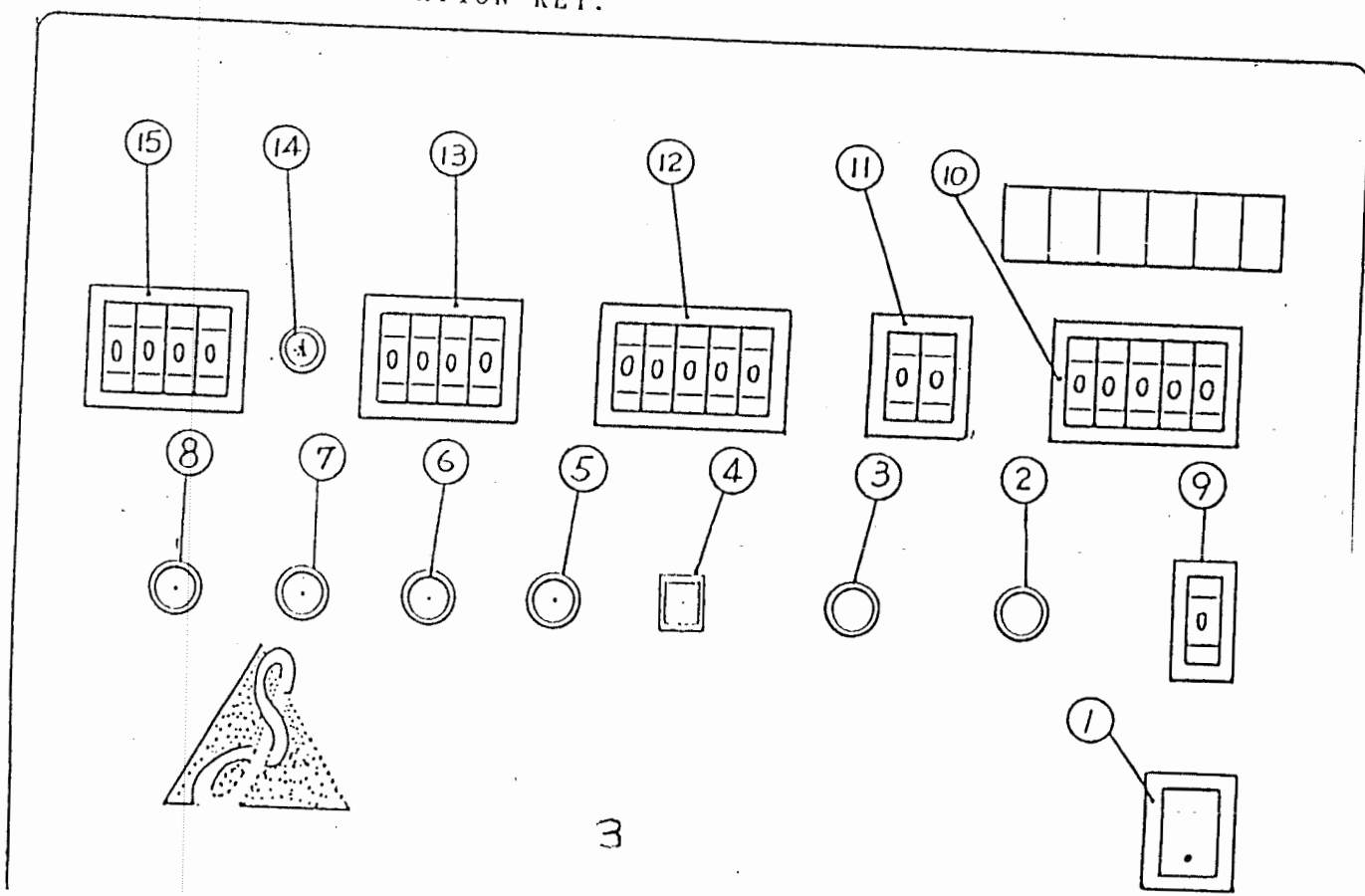
- (6) Plug the power line (notice the voltage as the machine mentioned) as fig (C).
- (7) Test running.
- (8) Normal operating be waited the machine is in normal condition.



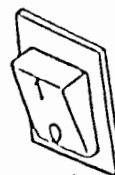
<C>

- 1 -

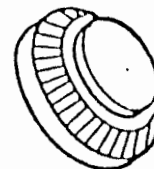
#### 4. INTRODUCTION OF THE OPERATION KEY.



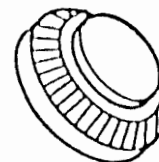
- (1) POWER BUTTON  
Press on the power on and light on.  
Press off the power off and the light off.



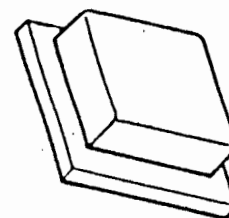
- (2) RESTORE ZERO BUTTON  
Push the restore zero button, the digital counter will be restore to zero.



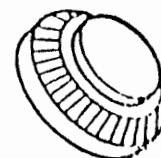
- (3) MICRO SWITCH  
Press the micro switch and the feeding roller slow forward, and press off the switch the feeding roller stops.



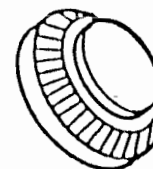
- (4) START BUTTON  
Push the button, the operation begins.



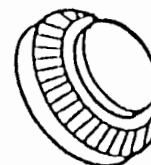
- (5) STOP BUTTON  
Press the stop button, the action be stopped as the cutting blade restore to its original position.



- (6) CUTTING BLADE BUTTON  
Press the cutting blade button, the cutting blade will cutting automatically, if you push the button continuously, the cutting action will be continuously also.

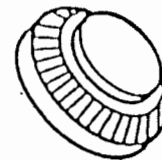


- (7) CANCEL ANGLE ERROR IN ESTABLISHMENT  
In mistaking condition, the angle error light will display and the alarm bell will show a noise due to your establishment is wrong. In the condition, you must use the button to do cancelling the error and establishing the new angle.



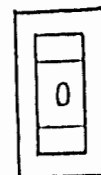
(8) ANGLE TEST

Pressing down the switch, the revolver of machine will obey your angle of establishment do action of one time for this work.



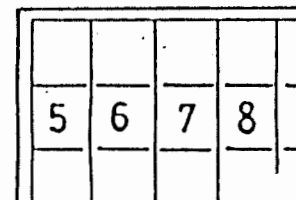
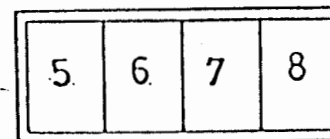
(9) CUTTING BLADE TIMES

In general condition, the cutting blade whose digital switch 0 can do normal work. While we use hot cutting blade to cut thicker materials which can't be cut, you must use 0 becoming 1 which will cut twice on the materials.



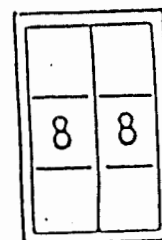
(10) QUANTITY CONTROLLER

According as the quantity be set, if the quantity be reached, the machine will be to stop automatically but the quantity must be than 1 pc.



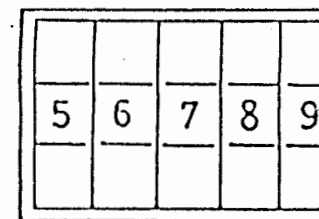
(11) SPEED CONTROLLER

According to the gravity of the speed, set the feeding speed as demanded 01 the slowest speed; 99 the top speed.



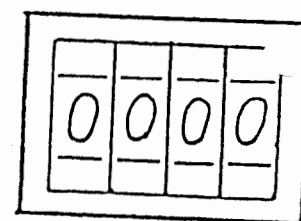
(12) LENGTH CONTROLLER (UNIT:MM)

Press on, the length decrease and Press off, the length increase.



(13) RIGHT ANGLE ESTABLISHED (UNIT:0.1° )

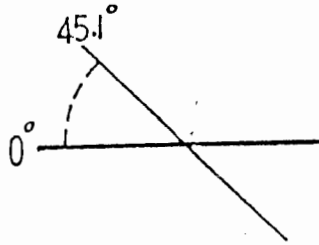
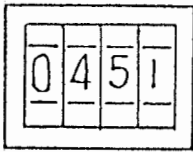
The established switch in range from 0 to 500 and from 1300 to 1799, the machine can do the action; however, in range from 501 to 1299 can't be established. (Because the error sign light with the alarm bell will appear condition; therefore, you have to correct establishment for unit again and use the "angle error switch".



FOR EXAMPLE:

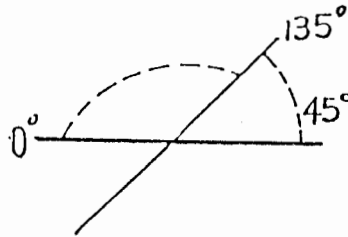
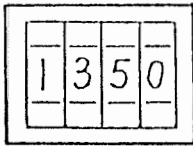
1

The four digits stand for  $45.1^\circ$ .



2

Those digits stand for right side  $45^\circ$ .



\*\*\* The establishment of angle starts on basic line  $0^\circ$  from left side.

(14) THE ANGLE ERROR SHOWER

While your establishment is wrong, the light will can show automatically.

(15) LEFT ANGLE ESTABLISHED

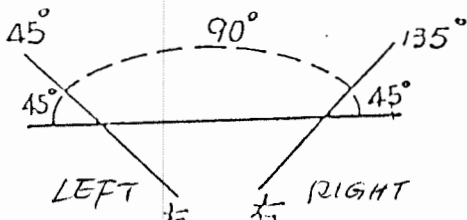
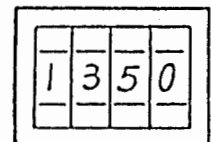
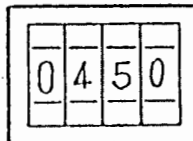
Its establishment is the same as (13).

5. The established angles whose examples are as follows:

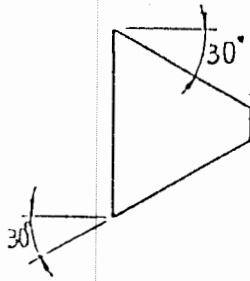
(1)

LEFT ESTABLISHED

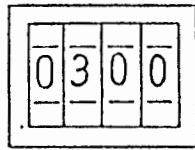
RIGHT ESTABLISHED



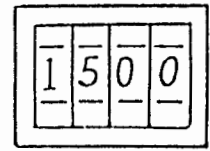
(2) If you want cut the angles as follows, you must adjust digits on shower.



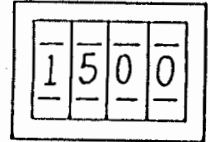
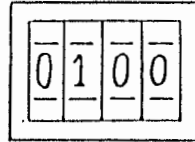
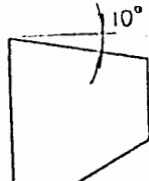
LEFT



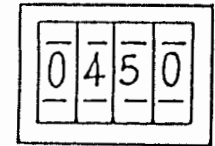
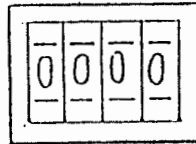
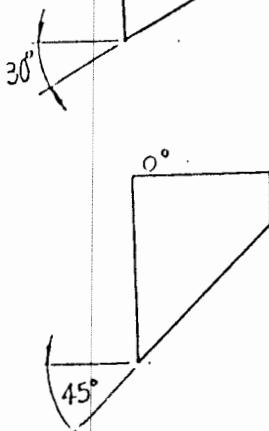
RIGHT



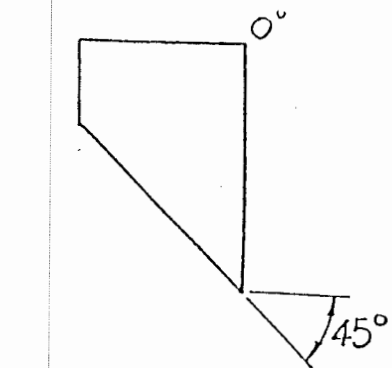
(3)



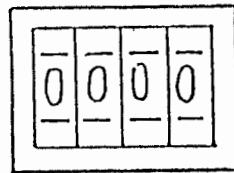
(4)



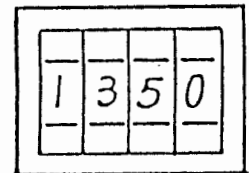
(5)



LEFT

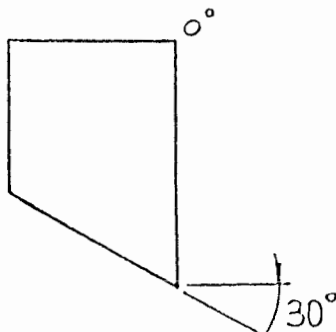


RIGHT

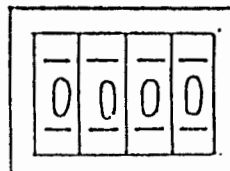


\*\*\* However, both (4) and (5) in steps are same.  
(Because their angles are 0° with 45° and their directions are different.)

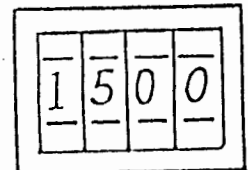
(6)



LEFT



RIGHT

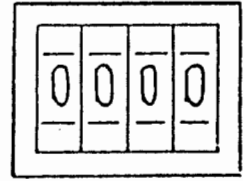
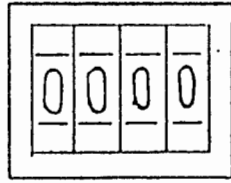
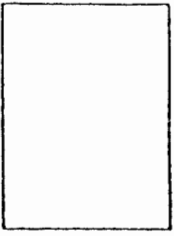




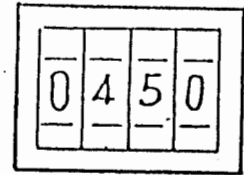
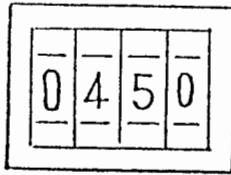
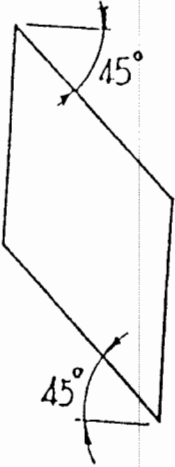
(7) If you cut materials which need straight result, please refer as follow:

LEFT

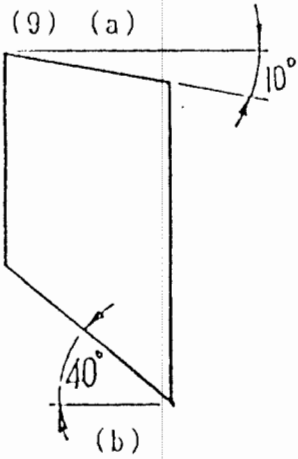
RIGHT



(8)

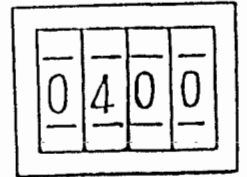
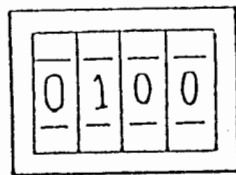


(9) (a)



LEFT

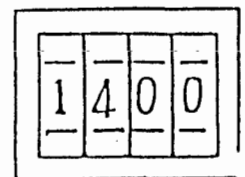
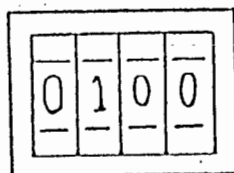
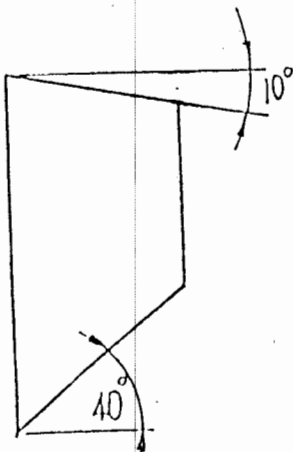
RIGHT



(b)

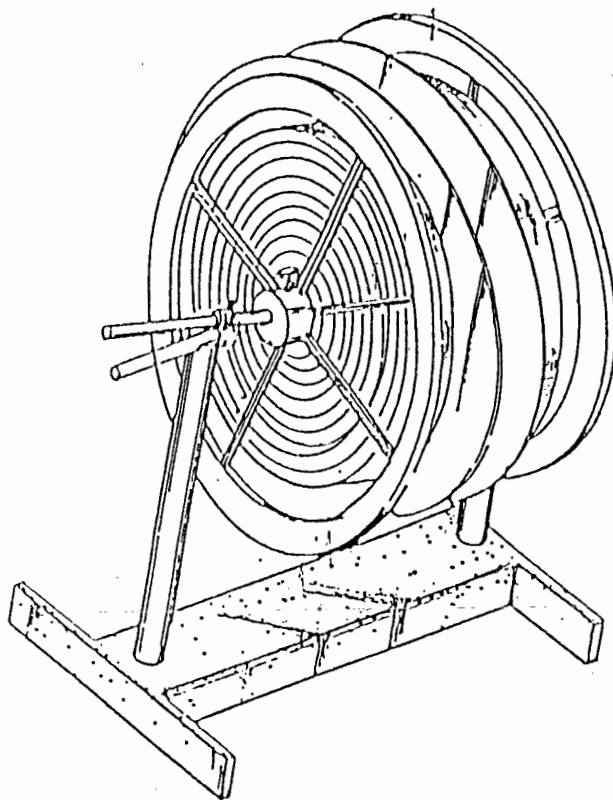
LEFT

RIGHT

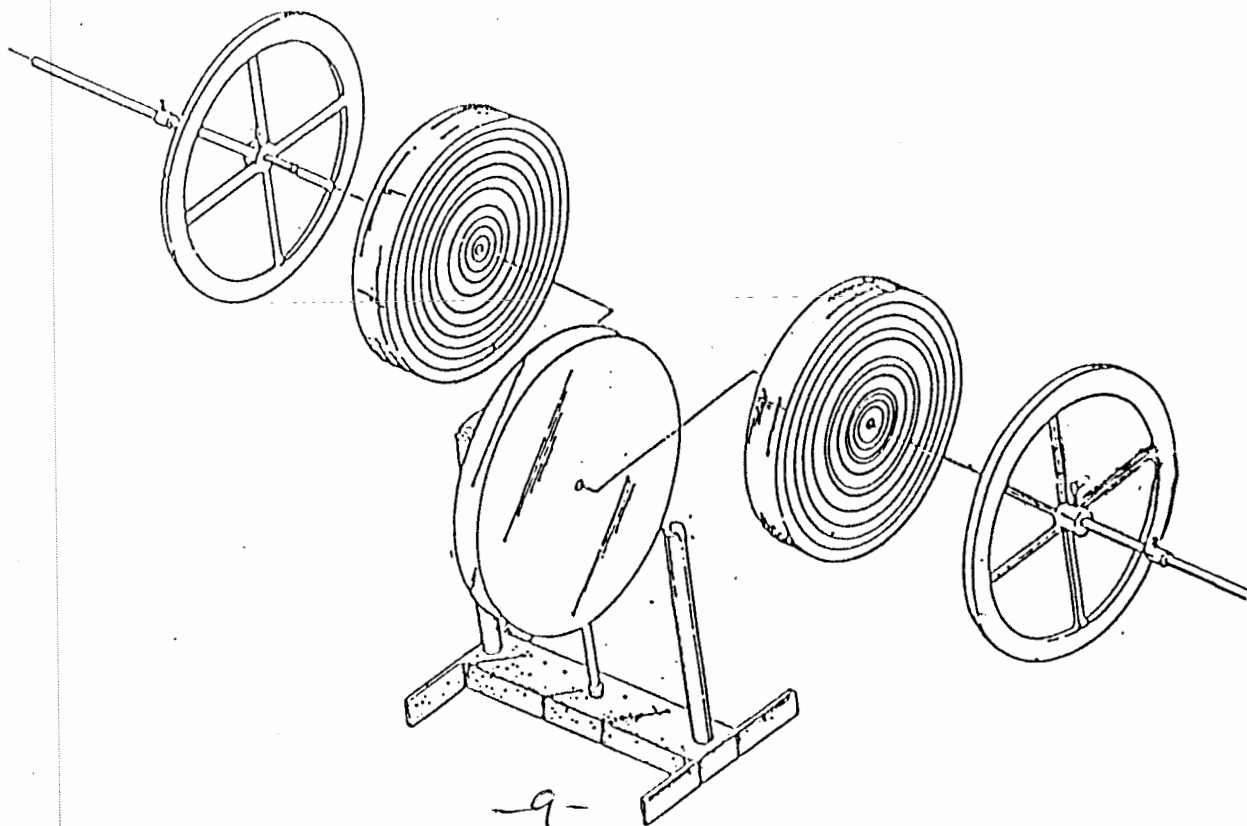


## 6. THE INSTALLATION AND OPERATION OF THE MATERIAL

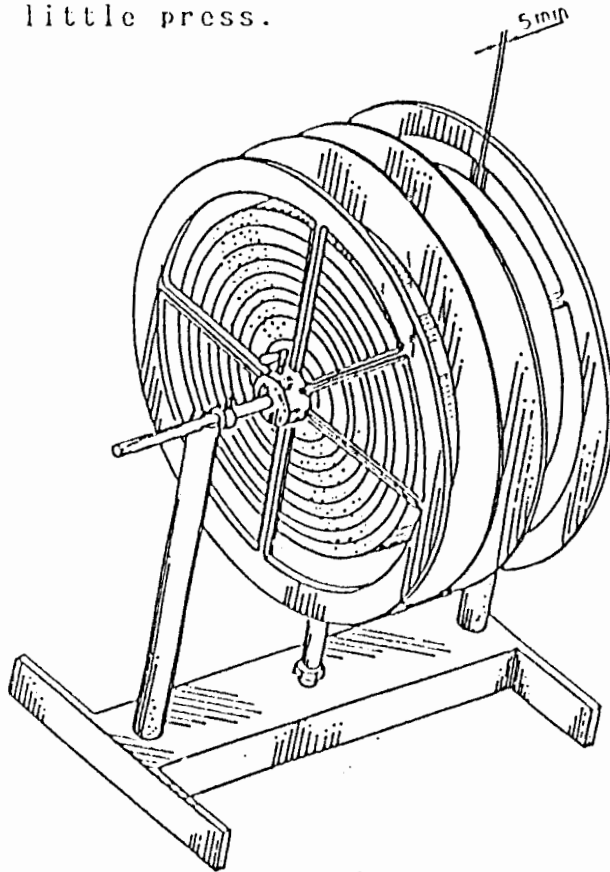
- (1) The first to loose the screw as fig and tilted, then to take out the feeding disc at left.



- (2) And then to insert the shaft in the center hole of the material will be cutting.

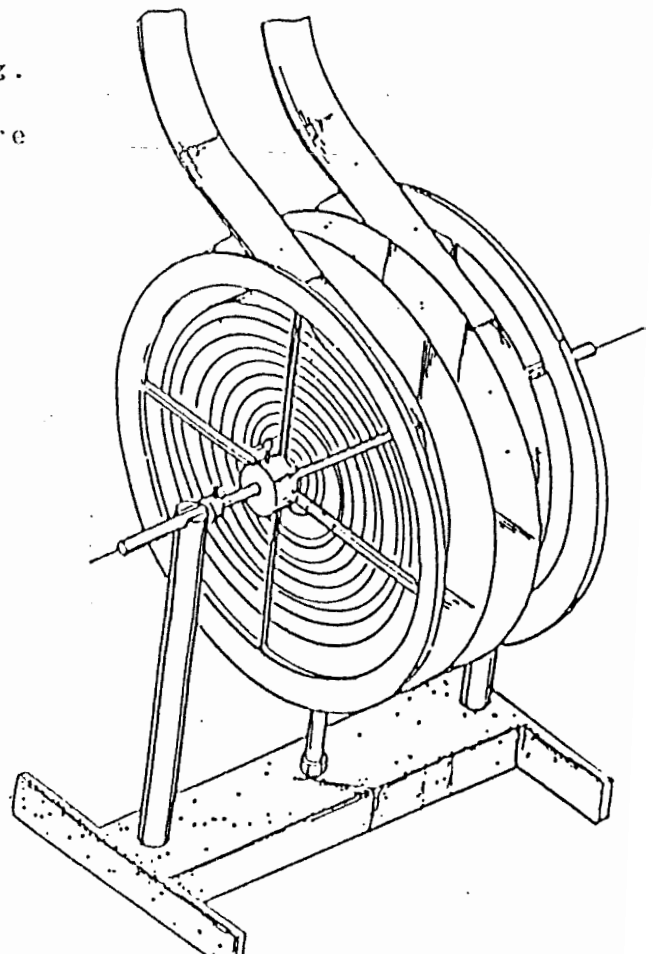


- (3) Put the material on the feeding reel and press the aluminium disc, in order to reduce the friction and feeding smooth, you must restore little press.

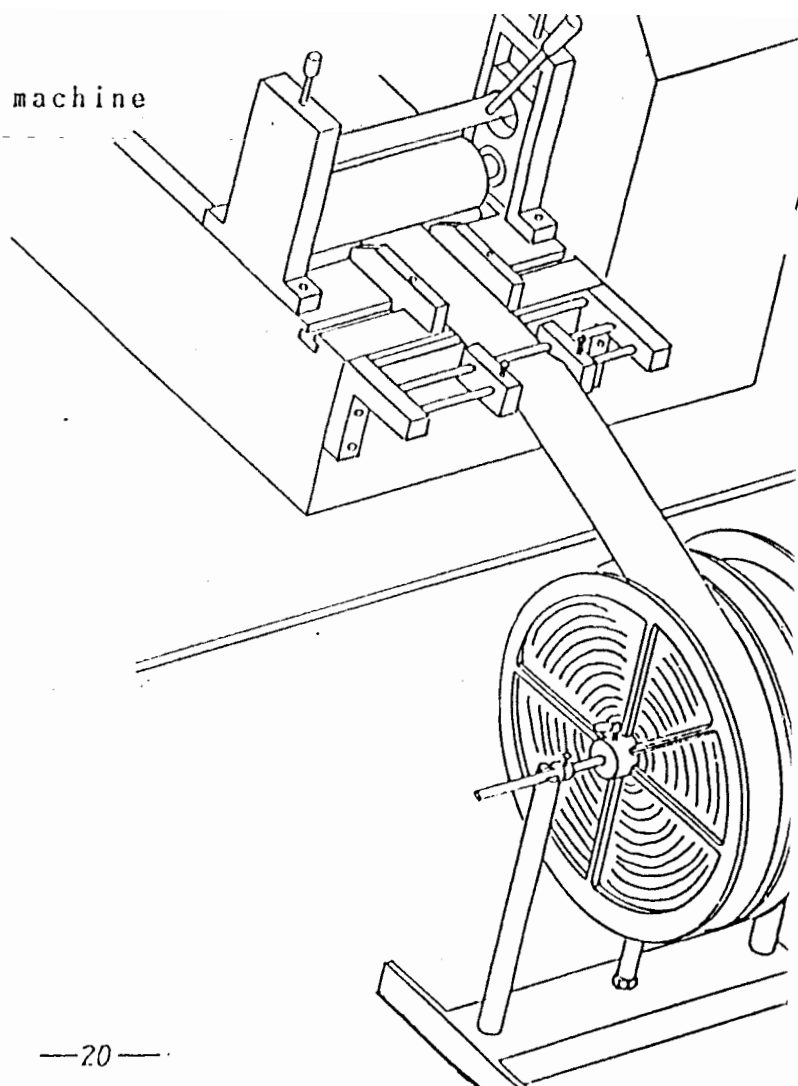


- (4) Take out the belt head . as fig.

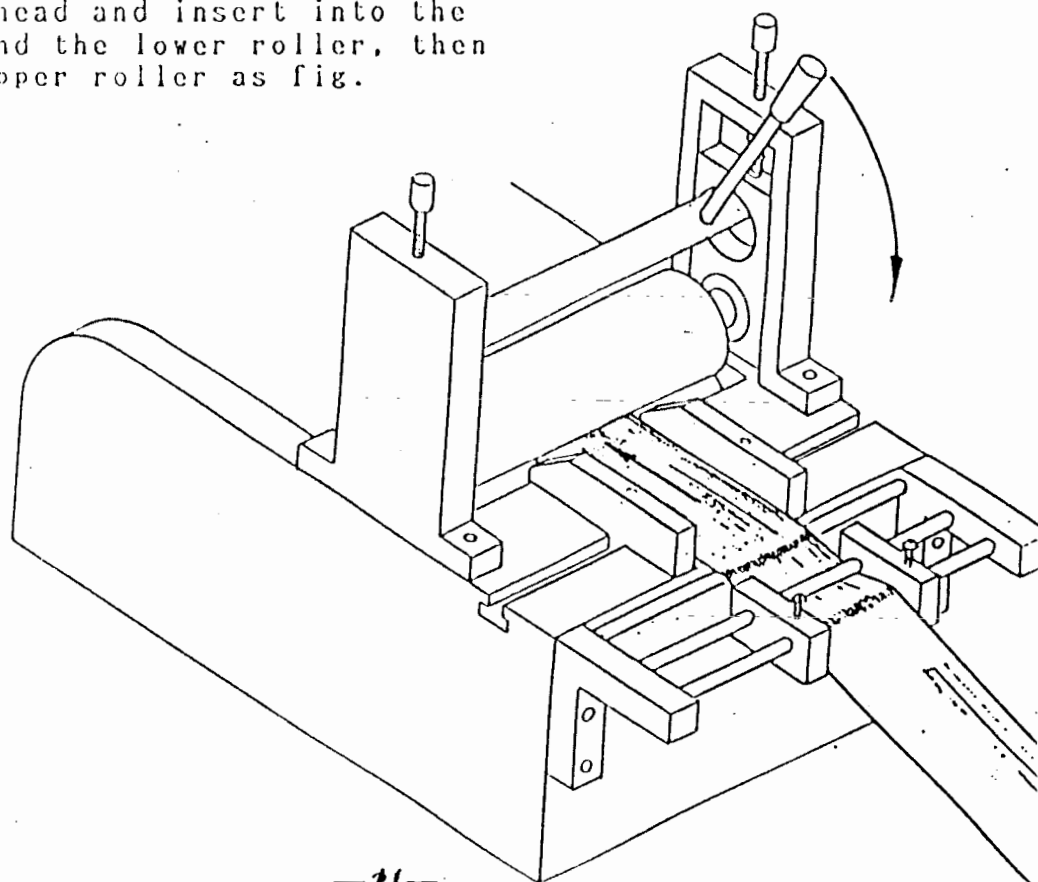
- (5) The right reel as same procedure as the left.



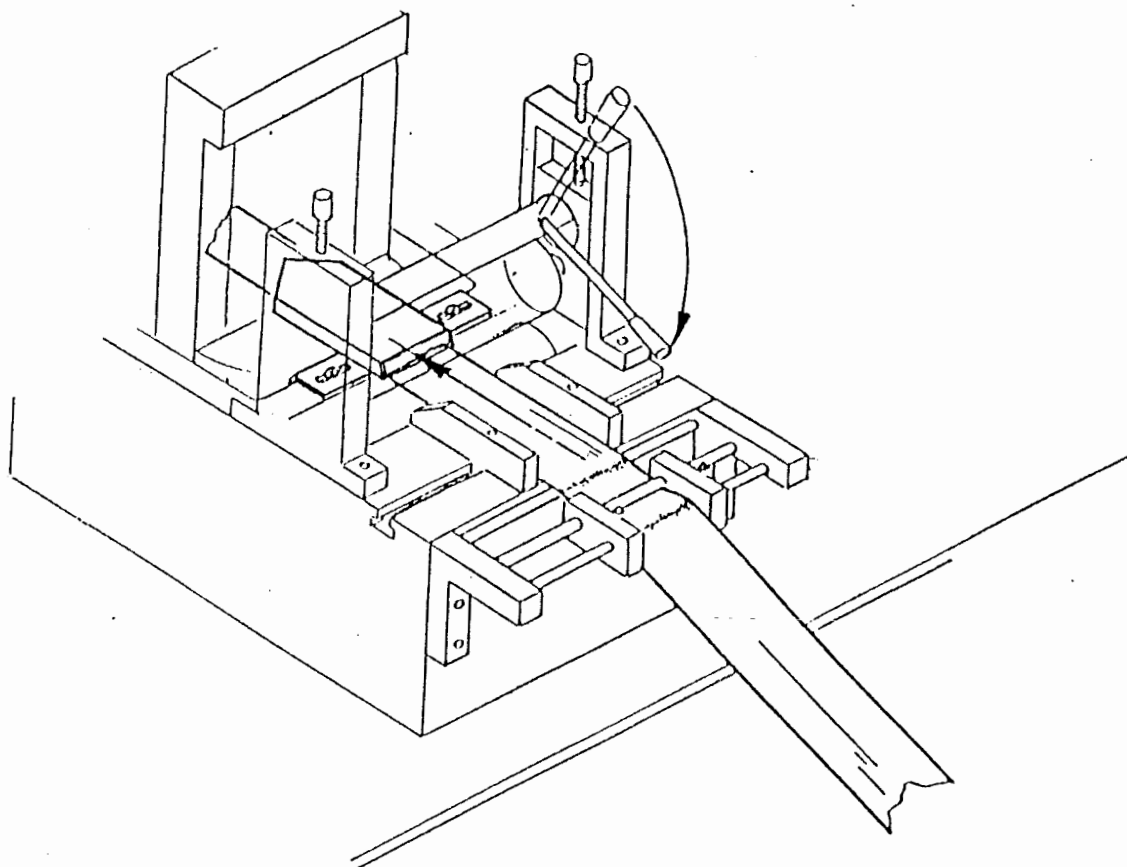
(6) Draw the belt head to the machine desk as fig.



(7) Draw the belt head and insert into the upper roller and the lower roller, then put down the upper roller as fig.



- (8) Taking sight the belt head to the feeding tube which will make the belt the center.



- (9) Press on the power and the micro button for the material reach the rear of the cutting desk, push the cutting blade button to cut off the material.
- (10) Set the digital of the length controller (unit:mm)  
If you want to cut 188mm then you must turn the digital to 00188mm as fig.

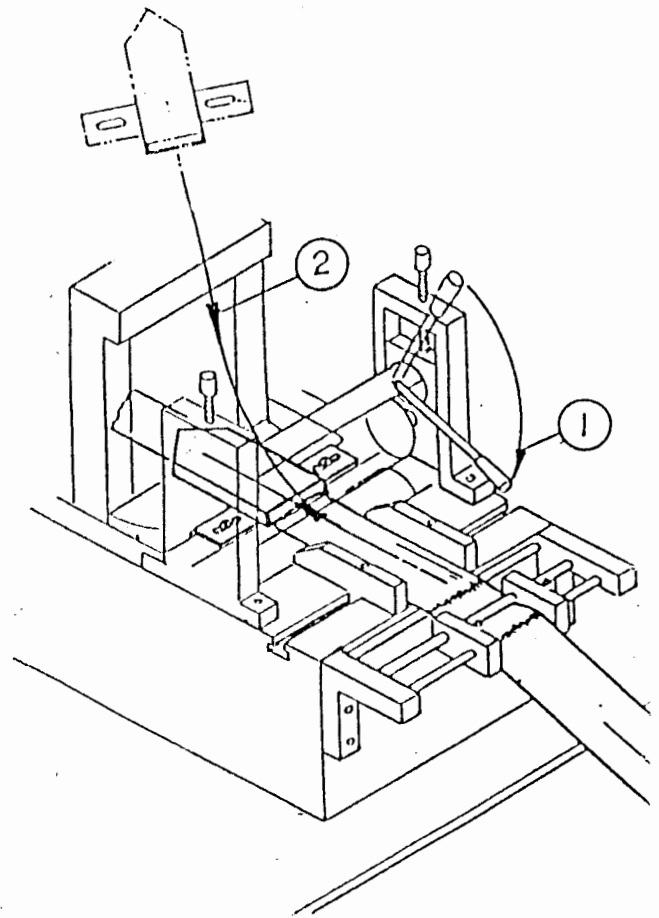
0	0	1	8	8

- (11) Set the digital on the quantity controller.
- (12) Establishing the left digits.
- (13) Establishing the right digits.
- (14) Press the start button, then the machine will be running.
- (15) If you want to stop during the operating, you just press the stop button, if you are not to press and then the machine will operate to the setted quantity is reached. You will press the restore zero button and the all button can be operated for next operation.

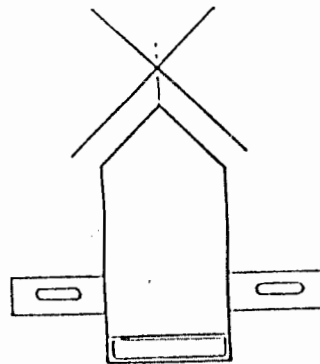
## 7. INSTALLING METHOD OF FEEDING TUBE:

(1) Press the club of upper roller make upper roller raise. as fig

(2) Let the feeding tube slant and put on a supporting rack. as fig



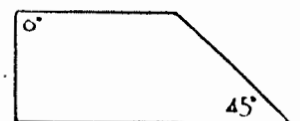
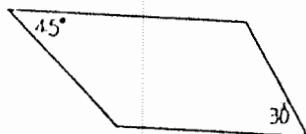
(3) Taking sight the central point with locking both right and left screws. as fig



(4) While the machine uses cold cutting blade to cut materials, the central point of blade doesn't change.

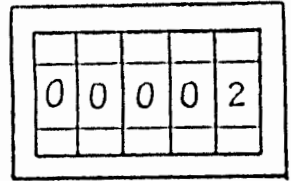
(5) When the machine cuts two side angles are same, its central point doesn't change for hot cutting blade. (But two side angles are different, its central point will be changed.)

For example

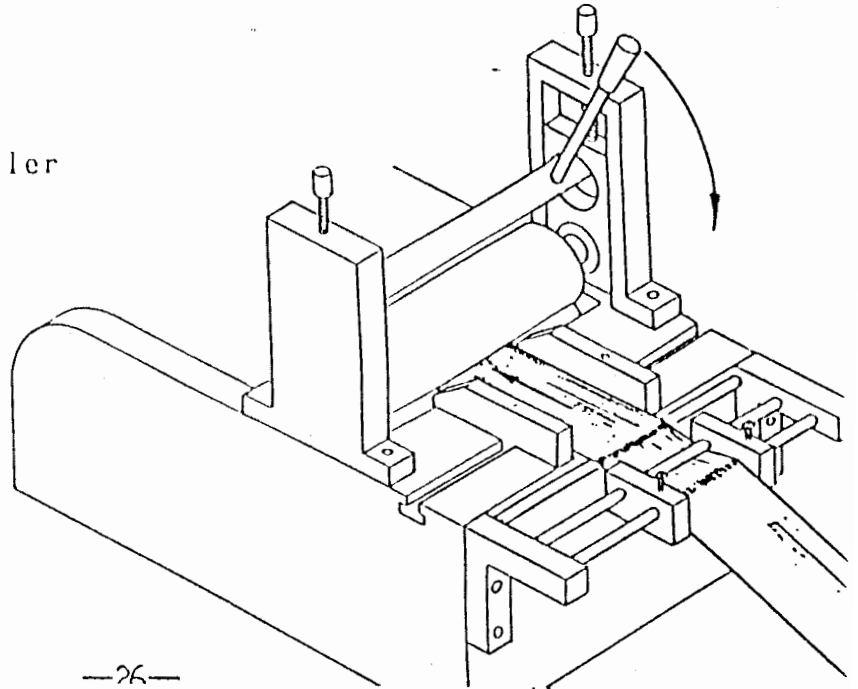


### 8. HOW CAN THE CENTRAL POINT OF MACHINE ADJUST?

- (1) Both left and right digits are established.
- (2) With the angles establish the button.
- (3) To establish the controlling digits about the quantity on (2).

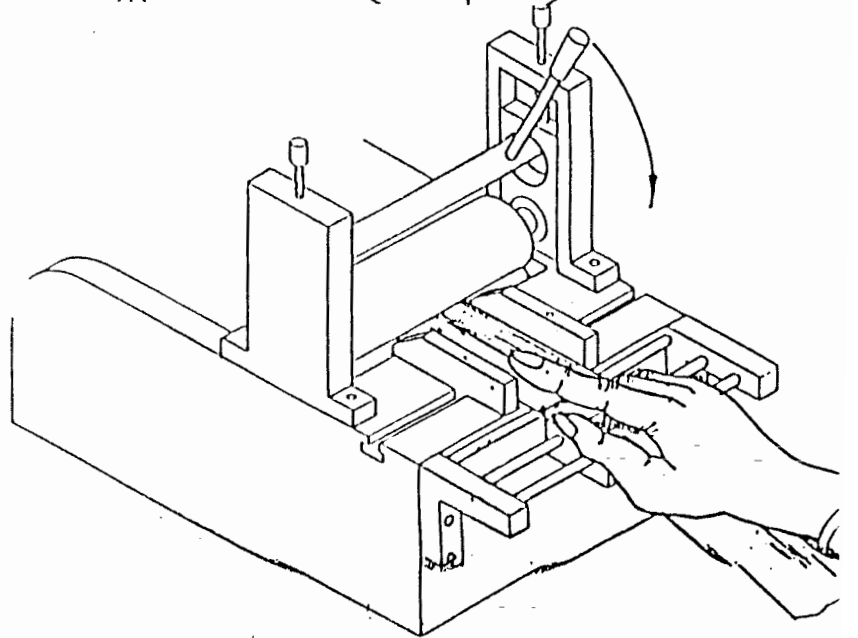


- (4) Press the club of upper roller make the upper roller break away lower roller. as fig

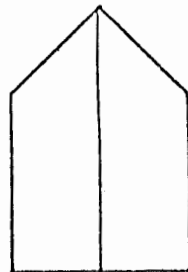


-26-

- (5) Let the belt put in center of the feeding tube, and make the belt go out another exit.
- (6) Fixing another side with your hand. Look out!!! Don't let the belt loose.

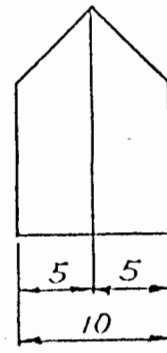


- (7) Press start button, the machine can do twice actions and cut the belt becoming sharp shape.



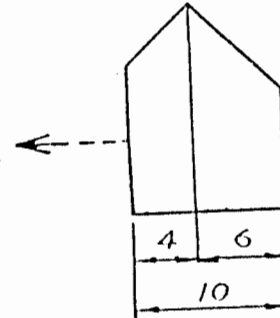
(8) Pull the belt check its angle.

(9) When the result of belt was as fig, we will tell you that the central point is right.



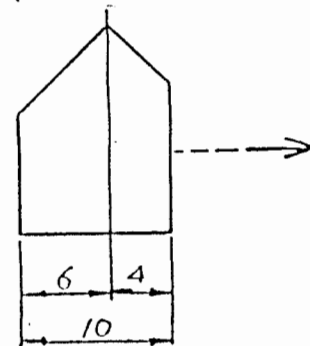
(10) As fig

Method: The feeding tube must move left direction (1m/m), then fix the belt. [Because  $(6-4)/2 = 1$ ]



(11) As fig

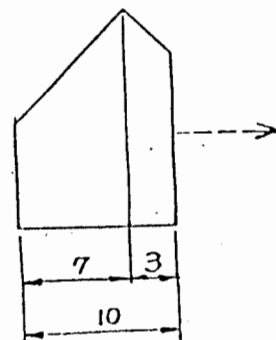
The feeding tube must move right direction (1m/m), then fix the belt.



— 28 —

(12) As fig

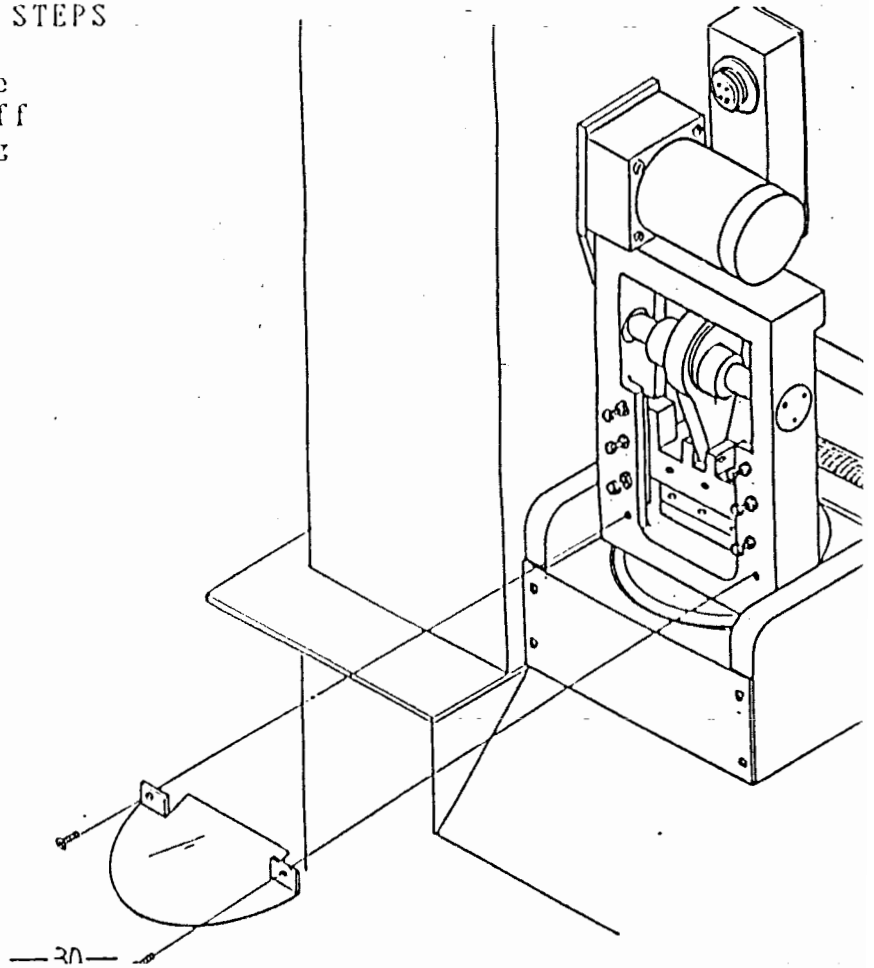
The feeding tube must move right direction (2 m/m). [Because  $(7-3)/2 = 2$ ]



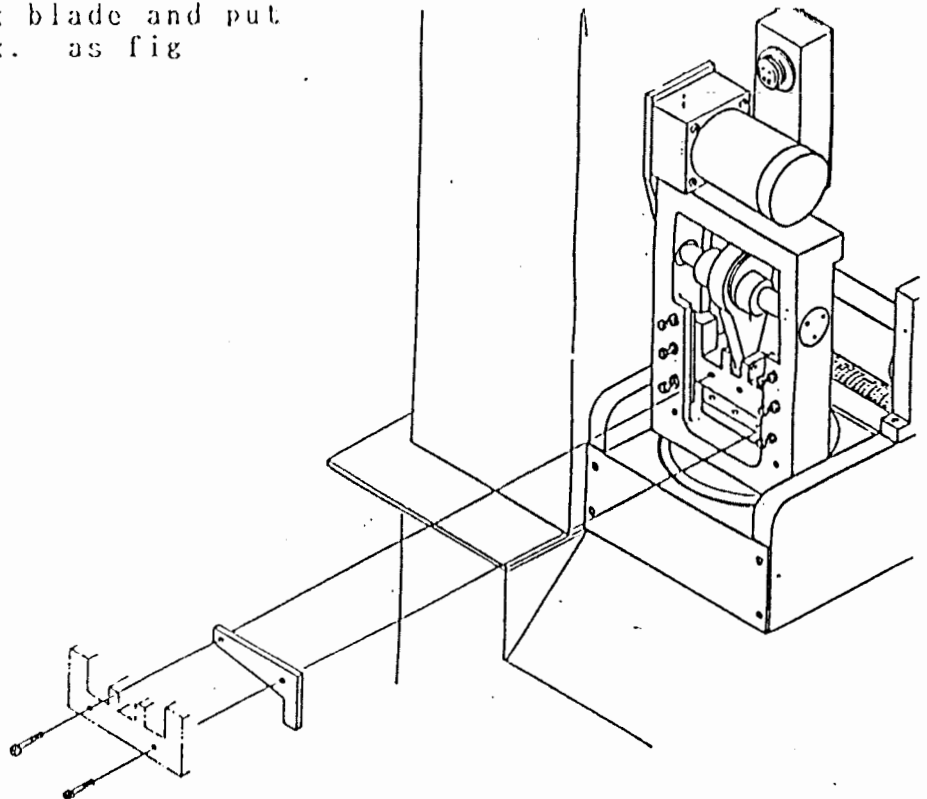


9. THE COLD CUTTING BLADE REPLACES  
THE HOT CUTTING BLADE WHOSE STEPS

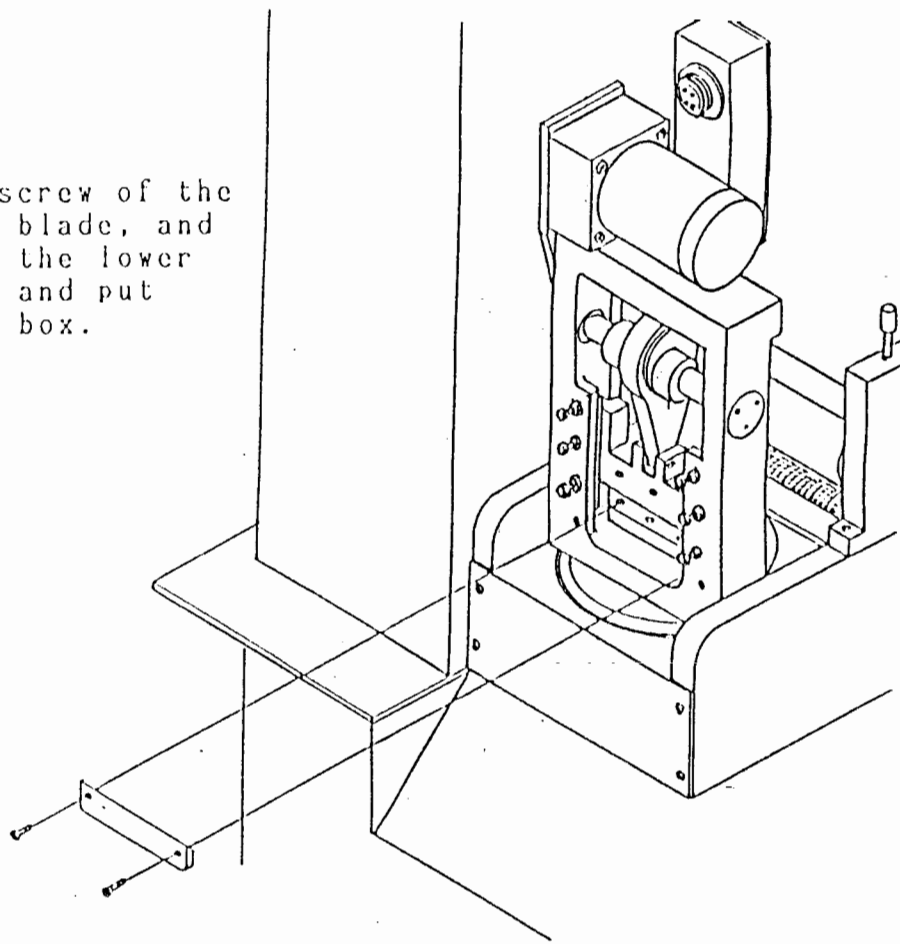
- (1) To loose the screw of the  
feeding tube, and take off  
the feeding tube. as fig



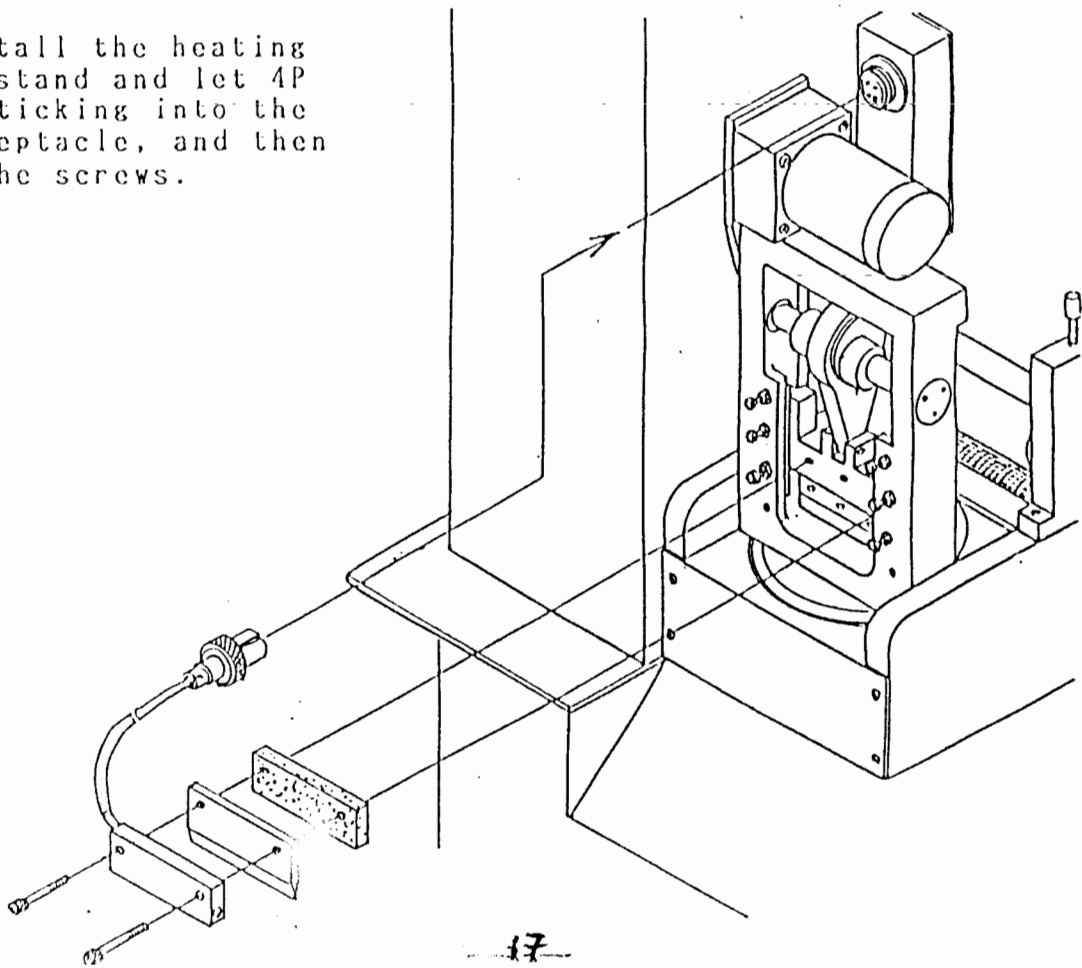
- (2) To loose the screw of the upper  
cutting blade, and then take off  
the upper cutting blade and put  
into the tool box. as fig



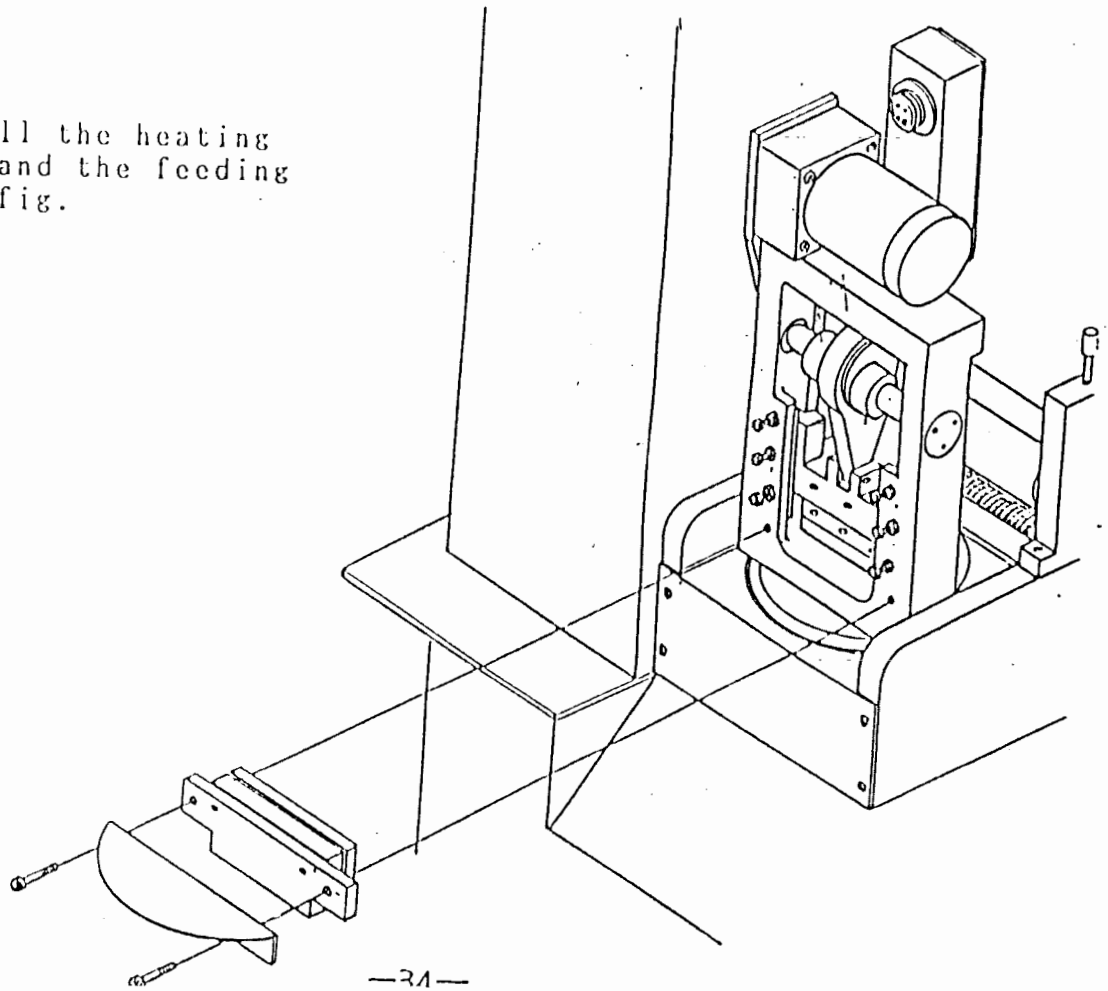
- (3) To loose the screw of the lower cutting blade, and then take off the lower cutting blade and put into the tool box. as fig



- (4) To install the heating brass stand and let 4P plug sticking into the 4P receptacle, and then lock the screws.

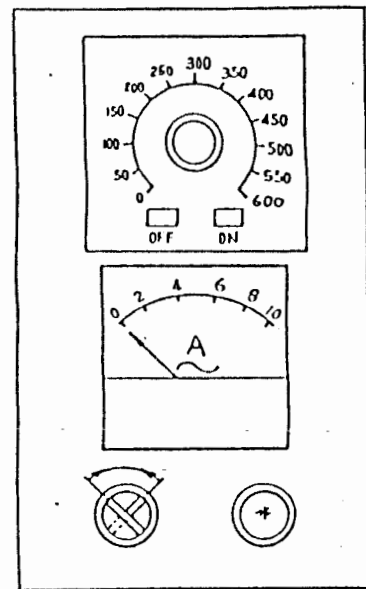


(5) To install the heating cushion and the feeding tube as fig.



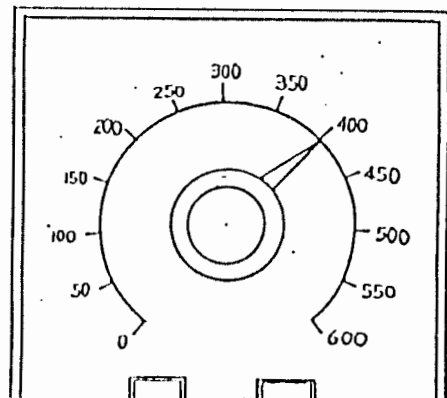
-21-

(6) Turn the temp control selection switch on clockwise to the ON position as fig.



(7) Set the actual operating temp. -- (as for the actual temp be set by the material thin or thickness, in general for about 400° C as fig.)

(8) If the heating temp is reached, the temp select switch will back to the OFF position, and then you can start to operate as fig.  
It needs time about 5-7 minutes.



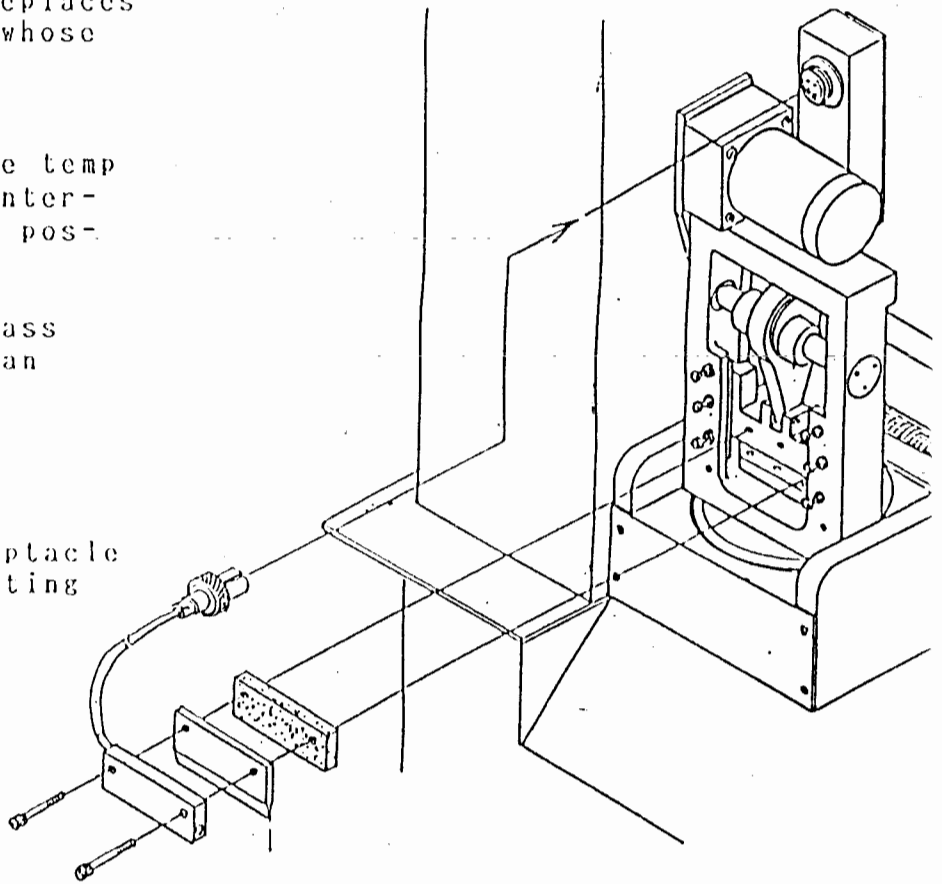
-18-

10. The hot cutting blade replaces the cold cutting blade whose steps as follows:

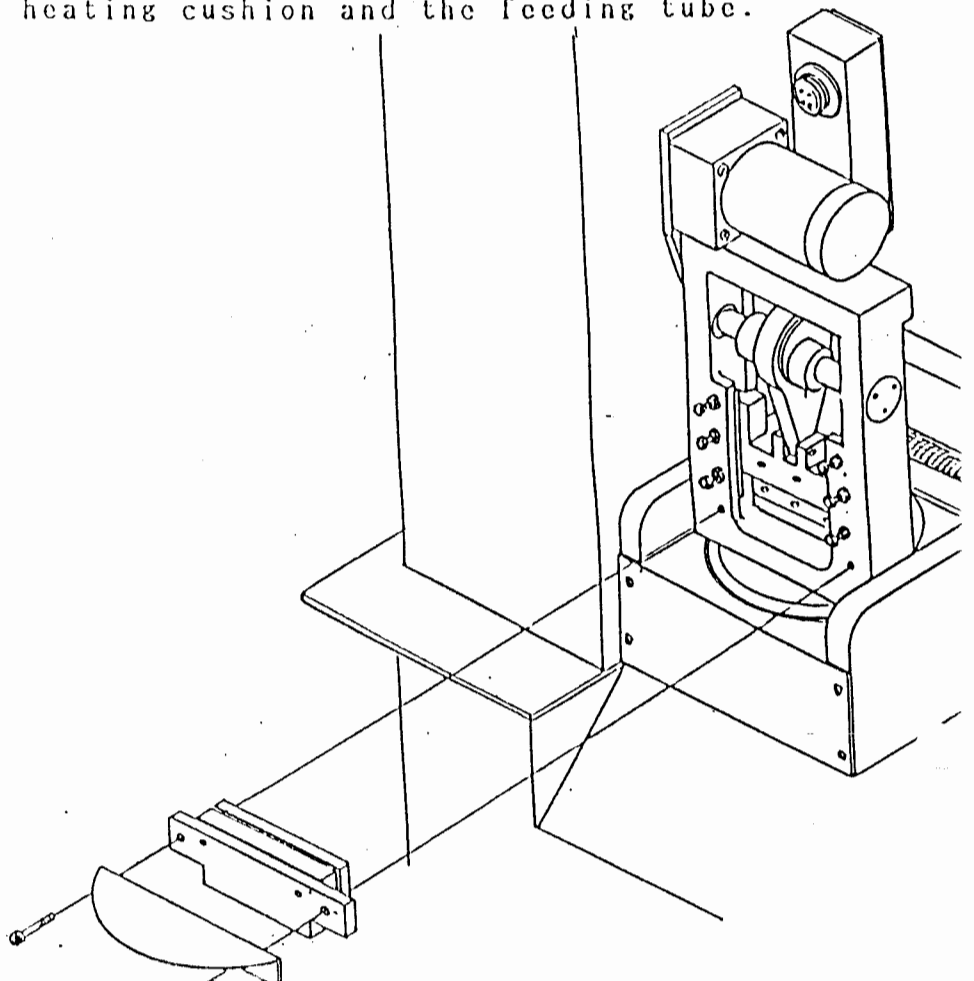
- (1) The first to turn the temp select switch on counter-clockwise to the OFF position as fig.

After the heating brass stand cold off, we can replace it.

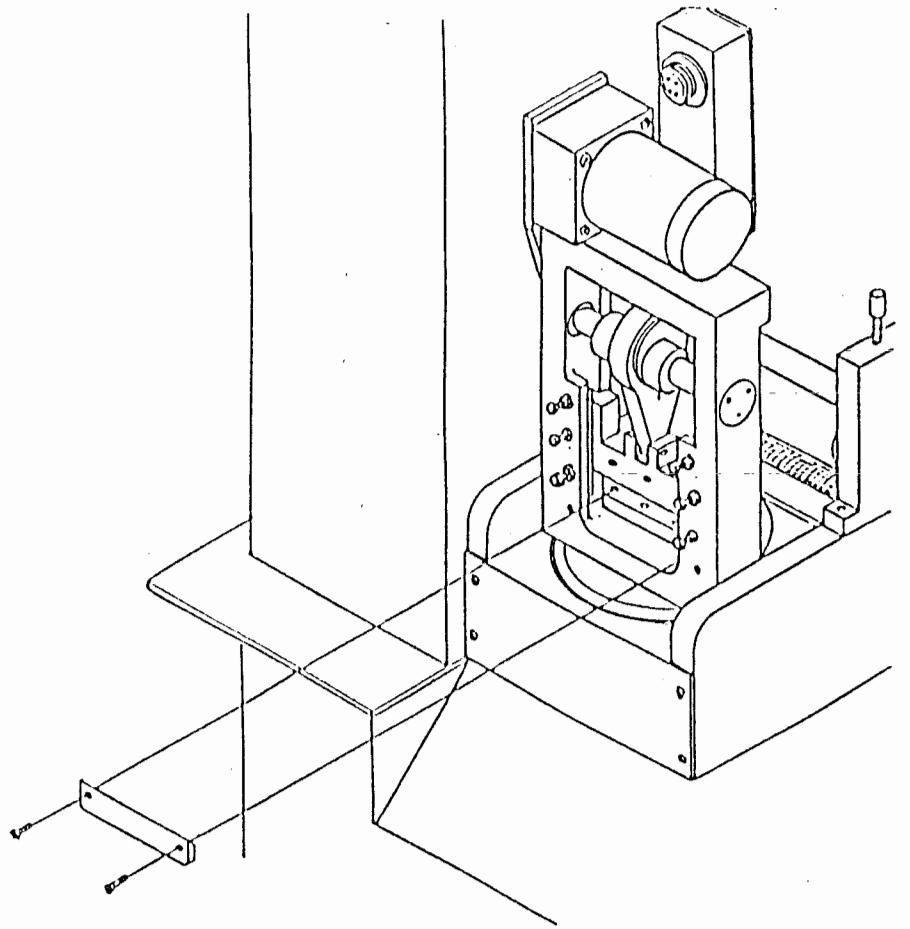
- (2) To loose the 4P receptacle and take off the heating brass stand.



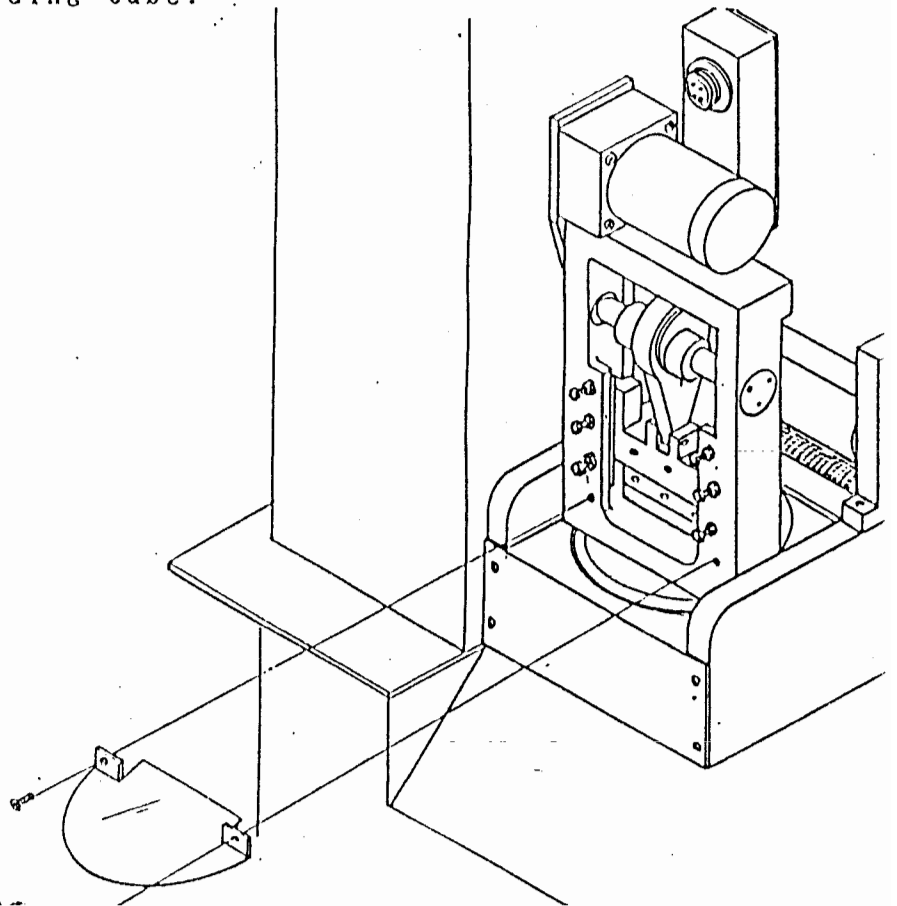
- (3) To take off the heating cushion and the feeding tube.



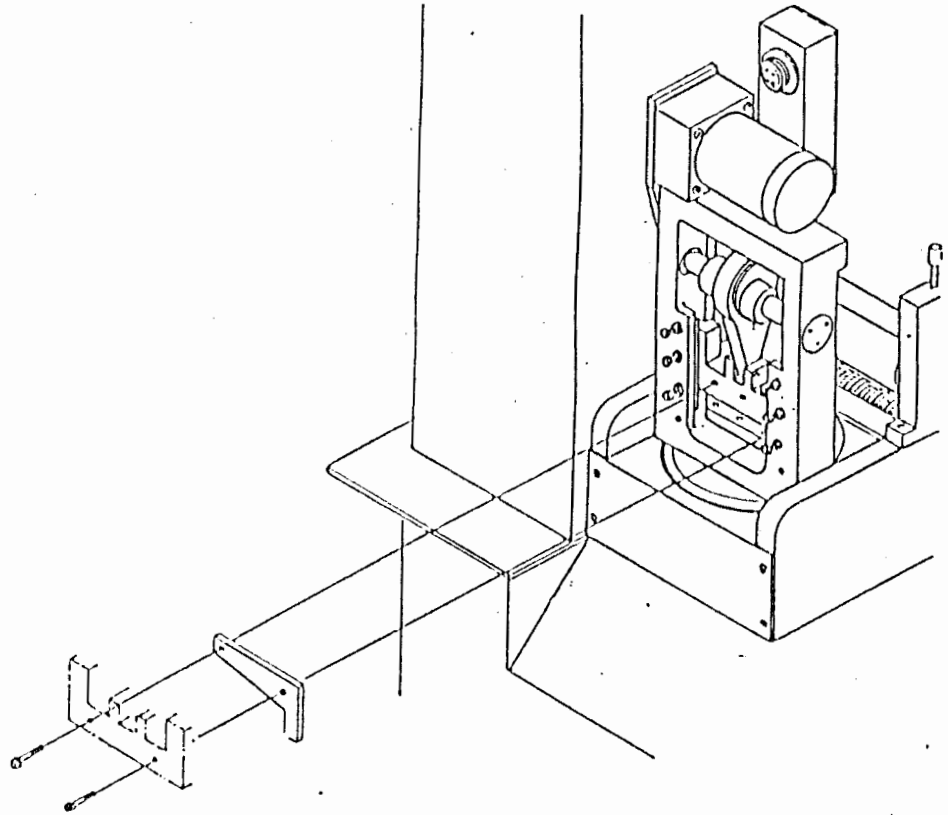
(4) To install the lower cutting blade.



(5) To install the feeding tube.

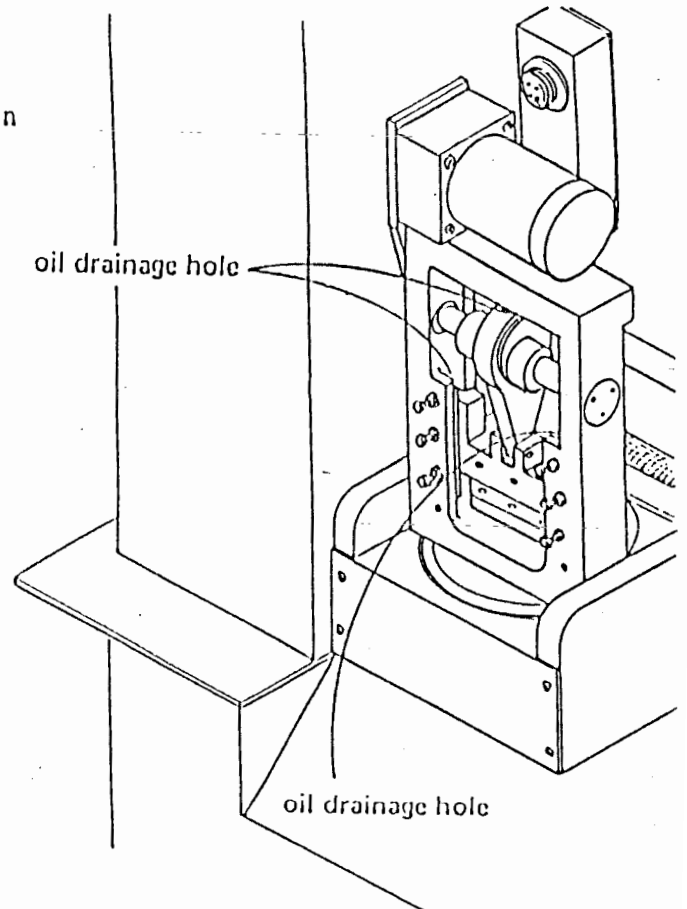


(6) To install the upper cutting blade.



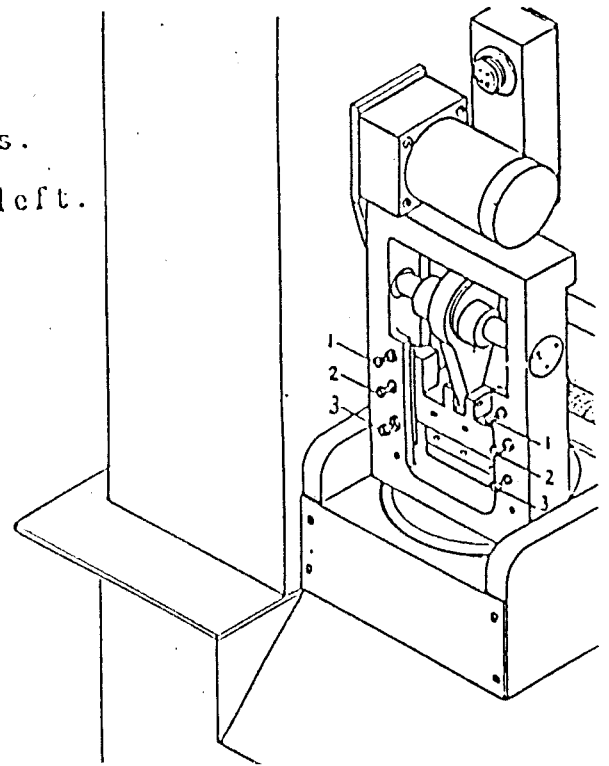
## 11. MAINTENANCE

- (1) Before the operating you must pouring the lubricating oil on the crankshaft.
- (2) Pouring little oil on the two sides of the sliding seat (#30 oil)
- (3) Push off the power after the operating is over.
- (4) After operating, you must to clean the machine and brush little protection oil on the machine.



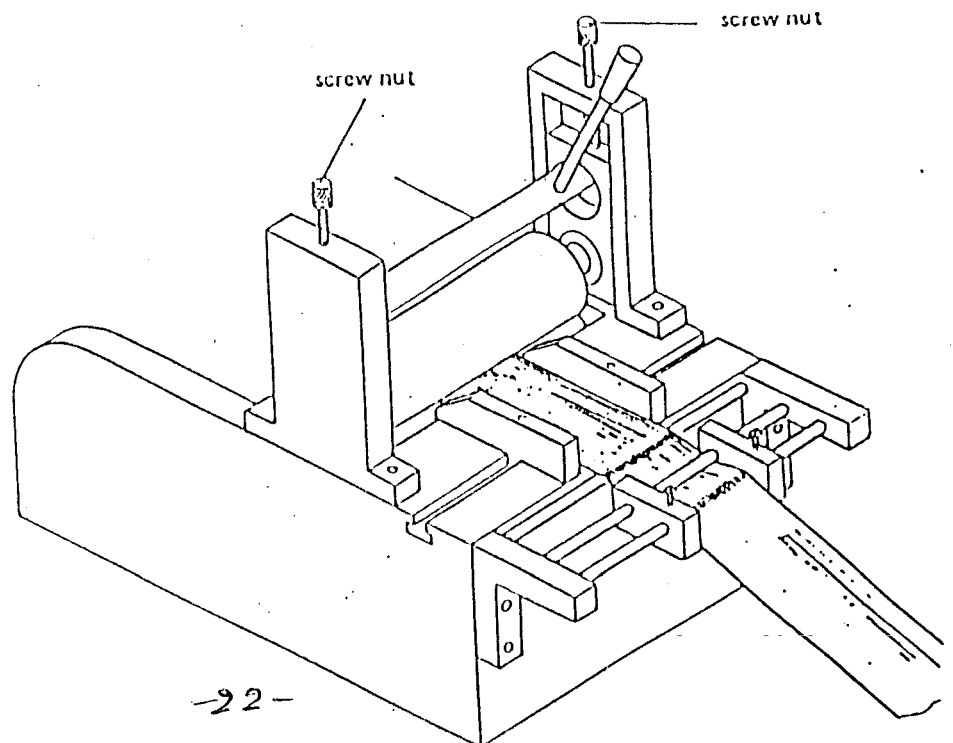
## 12. THE ADJUSTMENT OF THE COLD CUTTING BLADE

- (1) If the cold cutting blade will not cut off the material, you adjust the screw on the sliding seat as fig.
- (2) To turn left screw on the clockwise little. (just lock and r. too tight)
- (3) Test cutting.
- (4) If the test will not well, please repeat the above process.
- (5) The right side is same as the left.



## 13. THE ADJUSTMENT OF THE CUTTING LENGTH

If the length of product will not match the length be set, and to adjust the screw nut on the two sides of the upper press roll to strengthen the spring pressure, if the condition will not go maybe the material having the elongation, then you must adjust the length digital for reference the material elongation.



#### 14. TEST INSTRUCTION

- (1) First press the stop key and then press on the power button.
- (2) Press off the stop key and then indicate TEST for enduser test.
- (3) Press start key and then to test the cutting length indicate
- (4) And then press the start key again for that remove the model cutting length indicate restore to test by enduser.
- (5) Press the Reset key and then to test the cutting quantity indicate.
- (6) And then press the Reset key again for that remove the model cutting quantity indicate restore to test by enduser.
- (7) Press cutting knife key and then test 99 steps variable speed indicate.
- (8) If you press the start key again for that to test the cutting knife is in normal condition or not.
- (9) And then press cutting knife key again for that remove the model off 99 steps variable speed indicate restore to test by enduser.
- (10) Press micro button and then indicate feeding material rpm value can be adjusted at outside.
- (11) If you press start key and then indicate high speed rpm value can be adjusted at outside.
- (12) And then press the start key again for that remove the model of high speed rpm test restore to test by feeding material rpm value
- (13) If you press the micro again for that to restore the test by enduser.
- (14) The test by enduser are completed and press stop key then restore to the normal operation.



