

# CS-9010 (小圓刀) CS-9020 (大圓刀) 鞋底內裏修邊機



## 使用說明書 INSTRUCTION MANUAL

No:9010A00

Read safety Instructions carefully and understand them before using.  
Retain this Instruction Manual for future reference.

爲了安全地使用，請您在使用之前仔細閱讀本使用說明書。  
另外，請您注意保管本使用說明書，以便隨時查閱。



## 1. 注意

- 1) 請注意馬達電壓的接綫與相數，是否與你的用電一致，改變電壓與運轉方向，請按馬達上的指示路綫圖接用。
- 2) 機器的運轉方向，機器後側ME0308-0A砂輪護蓋上，紅色箭頭所示方向運轉。

## 1. CAUTION

- 1) Before wiring the machine to power sources, check whether the motor voltage/phase/ wire connection are the same the local used. To change the voltage and turning direction, please follow the circuit diagram shown on the motor.
- 2) For the direction of turn of motor, please refer to the red arrowhead marked on the ME0308-0A grinding wheel cover at the rear of the machine.

## 2. 加油

本機上有紅色標記地方，操作時應經常加 #40 潤滑油。

## 2. SUPPLEMENT OF OIL (LUBRICATION)

During operation, #40 lubricating oil should be added regularly through the red-marked places at the machine.

## 3. 加水

機器右側透明圓盒ME0502-0A為水盒，工作時，將開關轉開，使水流下成點滴狀態，以冷卻上刀ME0112-0A和下刀ME0202-0A的溫度，工作完畢，將水關閉。

## 3. SUPPLEMENT OF WATER

ME0502-0A is a transparent water box at the right side of the machine. During operation, turn on the knob so that water comes down in droplets, so as to cool off ME0112-0A upper cutter and ME0202-0A under. Turn off the knob when not operation.

## 4. 操作人員的位置

- 1) 操作人員於機器的正前方。
- 2) 工作物由右向左移動。
- 3) 依據工作物毛邊的狀況，與上刀保持適當的修削角度。

## 4. POSITION OF THE OPERATOR

- 1) The operator situate himself at the front of the machine.
- 2) The work piece should move from right to left.
- 3) Referring to the condition of product trimming spew, keep a proper trimming angle with the upper cutter.

## 5. 壓腳ME0118-0A的高度調整

- 1) 工作物的毛邊（如鞋底的毛邊，鞋面的內裏）必需在壓腳ME0118-0A與下刀ME0202-0A之間，很容易滑動。
- 2) 壓腳ME0118-0A如太低時，工作物移動困難，毛邊修削不幹淨，如太高時，工作容易被修削到。
- 3) 壓腳ME0118-0A的高度調整，祇需轉動ME0302-0A、ME0303-0A的螺絲，調整完畢，將ME0302-0A、ME0303-0A螺帽鎖緊。

## 5. ADJUSTING POSITION OF PRESSING LEG ME0118-0A

- 1) The work piece, stationed between pressing leg ME0118-0A and under cutter ME0202-0A should easily pass through during trimming of the product (Such as shoe sole spews and its inner lining).
- 2) If the pressing leg ME0118-0A is too low, work piece would have difficulty moving through and trimming of spew would not be clean cut. If its too high, work piece would be badly cut off easily.
- 3) Turning screws ME0302-0A、ME0303-0A to adjust the height of pressing leg ME0118-0A after adjustment, retighten ME0302-0A、ME0303-0A screw cap.

## 6. 研磨上刀ME0112-0A的方法

- 1) 鬆開ZMB04011螺絲，將壓腳ME0118-0A移往右方。
- 2) 鬆開ZMJ04001螺絲，取下ME0111-0A上刀板，取出上刀ME0112-0A。
- 3) 將上刀ME0112-0A置於機器後側的磨刀固定架ME0309-0A，刀刃斜面朝下，輕微與砂輪ME0305-0A往復接觸，接觸時間越短越好，以免燒焦，或沾水亦可。
- 4) 上刀ME0112-0A研磨完畢，需將毛邊用細磨石磨掉，將上刀ME0112-0A與下刀ME0202-0A接觸的平面用細磨石磨平。
- 5) 磨刀固定架ME0309-0A，可調整上下、左右，以吻合上刀的角度。

## 6. SHARPENING UPPER CUTTER ME0112-0A

- 1) Release screw ZMB04011, move pressing leg ME0118-0A to the right.
- 2) Release screw ZMJ04001, remove upper cutter plate ME0111-0A and thus upper cutter ME0112-0A.
- 3) Place upper cutter ME0112-0A on the grinding frame ME0309-0A, located at the rear of the machine, With blade facing downward, constantly slightly touching grinding wheel ME0305-0A. Time of touch should be as short as possible to prevent burnt, water covered be added too.
- 4) After completion of grinding, use smooth grade grind stone to rid of the spew from the blade.
- 5) The touching blade side of upper and under cutter should be grind level too. Grinding frame ME0309-0A can be adjusted up-down, left-right to meet the angle of the upper cutter.

## 7. 上刀ME0112-0A的裝置

- 1) 把上刀ME0112-0A置於ME0109-0A刀杆槽內，裝上ME0111-0A上刀板，將ZMJ04001螺絲輕微鎖住用手轉動機器後側的塑料輪ME0307-0A,使刀杆ME0109-0A下降至最低點，調整上刀ME0112-0A的上端角與下刀ME0202-0A的距離為0.5mm-1.0mm，後鎖緊ZMJ04001螺絲。
- 2) 移回壓腳ME0118-0A，鎖緊ZMB04011螺絲。
- 3) 用手轉動機器後側塑料輪ME0307-0A，檢查轉動是否順暢，如順暢，然後才開動馬達。

## 7. INSTALLATION OF UPPER CUTTER ME0112-0A

- 1) Put upper cutter ME0112-0A into ME0109-0A cutter bar groove, to fix ME0111-0A upper cutter plate, slightly turning screw ZMJ04001, then turn the plastic wheel ME0307-0A at the rear of the machine to allow cutter bar ME0109-0A to drop to its lowest point. Adjusting the distance from the upper end angle of upper cutter ME0112-0A to the under cutter ME0202-0A is 0.5mm-1.0mm, then tighten screw ZMJ04001.
- 2) Return pressing leg ME0118-0A to its position, and tighten screw ZMB04011.
- 3) Turning the plastic wheel ME0307-0A at the rear of the machine by hand to check if it turns smoothly then switch on the motor.

## 8. 下刀ME0202-0A彈力的調整

將ZMH06012、ZMH06001螺絲轉鬆，把ME0207-0A鐵環向下移，後鎖緊ZMH06012、ZMH06001螺絲，則下刀ME0202-0A彈力強，反之則弱。

## 8. ADJUSTING SPRING POWER OF UNDER CUTTER ME0202-0A

Loosen screws ZMH06012、ZMH06001, lower iron ring ME0207-0A, then retighten screws ZMH06012、ZMH06001, thus a strong spring power for under cutter ME0202-0A, otherwise weak.

## 9. 傳動皮帶之替換

如傳動皮帶斷時轉一下ME0307-0A塑料輪，卸下皮帶護蓋和ME0308-0A砂輪護蓋，換上皮帶即可。斷裂的皮帶，可再接合，即皮帶二端用火均勻燃燒，使其融化，後二端接合，將毛邊剪掉，即可再使用。

## 9. CHANGING THE TRANSMISSION BELT

In the case the transmission belt was broken. Loosen the plastic ME0307-0A, take off the belt covers and grinding wheel covers, thus change the transmission belt. The broken belt can be use and can be connected again by burning the two edges of the broken belt, then connect together, after it cool off and trimming spew.

GOLDEN WHEEL

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