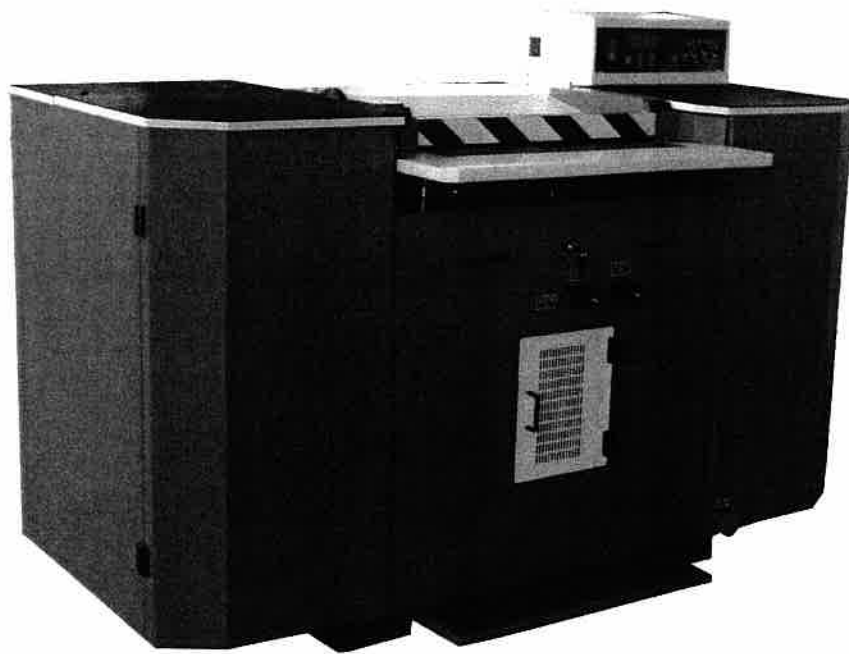


Band knife Splitting Machine

Specifications



Catalogue

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1.Introduction

The band knife splitting machine in our factory is designed and produced by leading the structure and manufacture technology of German Fortuna splitting machine. The splitting machine can split soft and hard leather whose thickness is under 8mm and width is under 420mm to desired thickness. The material and accessory of the machine is excellent and durable so it has a long service life. The splitting machine has functions such as stepless speed regulation in feed speed, automatic tool grinding , and circular material feed. The splitting surface is smooth and the machine has low noise. So this splitting machine cannot only provide the customer high output but also excellent quality of products. It is your first choice of splitting equipment in leather making trade.

2.Technical capability

1.Main capability

- a) Automatic feed positioning system.
- b) Automatic cutting tool adjustment guiding system.
- c) Automatic leather-entanglement stop equipment.
- d) Plate fork mouth automatic
- e) Individual leather scrap inhalation equipment.
- f) Individual grinding dust inhalation equipment.
- g) 500mm super band knife flywheel makes band knife s movement more stable and accurate.
- h) 3570mm long band knife is durable which can decrease the cost.
- i) Accurate track make flywheel s movement credible, and it is easier, faster and more convenient to replace band knife.
- j) Working pressure can be adjusted optionally.
- k) 8mm thickness finger protection equipment.
- i) Automatic electronic phasic check and measure.

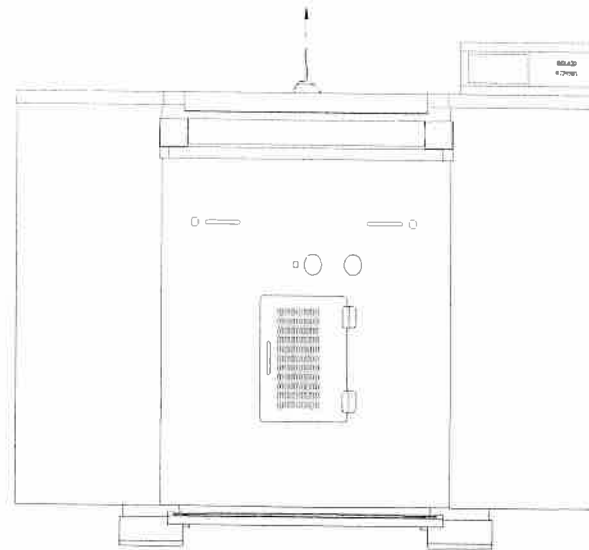
2.Technical parameter

a)Maximal splitting width	420mm
b)Splitting thickness	
Using double feed roller	0.6~8mm
Using feed pole	0.2~8mm
c)Minimal splitting thickness	0.2mm
d)Rotate speed of grinding wheel	4000rpm

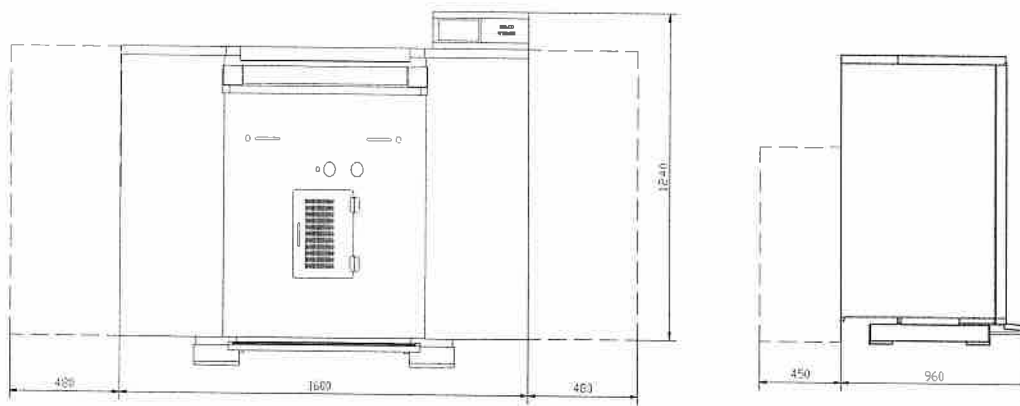
e)Impeller's rotate speed of big inhalation dust fan	6560rpm
f)Impeller's rotate speed of small inhalation dust fan	2800rpm
g)Linear speed of band knife	183m/min
h)Feed speed	stepless speed regulation
i)Band knife spec	0.8*50*3570mm
j)Electric machinery power	3.5KW
k)Size of machine outline	1600*960*1420mm
l)Packing size	1800*1230*1540
m)Machine weight	720kg
n)Gross weight	890kg

3.Installation

1. Put the crane hook into screw F which showed in picture 4, hoisting method is showed in picture 1.
2. Ensure there is some space left around machine in order to open machine door and scrap recycle box. Position and space is showed in picture 2.
3. Machine should be settled in flat ground to keep it at a level state.
4. Ensure the power supply in factory is the same as machine requirement. (Voltage is 380V; electrical source power should no less than 3.5KW. Prohibit using machine until made the security inspection.)
5. Clean the rust preventive oil in the machine surface. (Not use trichloroethylene or benzene to clean rust.)
6. Accessories are put in scrap box (Showed in Decomposition diagram 7, item 37), pull up handle and the scrap box will drop, can see the accessories when pull out the scrap box (Notice: put the scrap box in the right position when installation, press down handle to avoid ill inhalation which could affect the normal operation of machine).



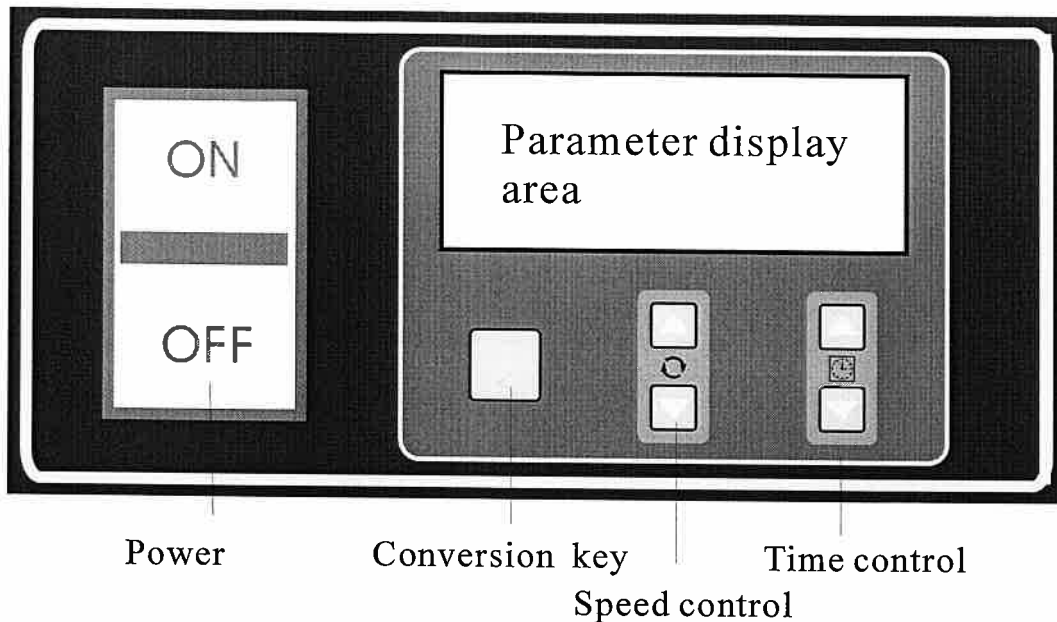
Picture 1



Picture 2

4. Instruction of operation panel

(Backwards function introduction)

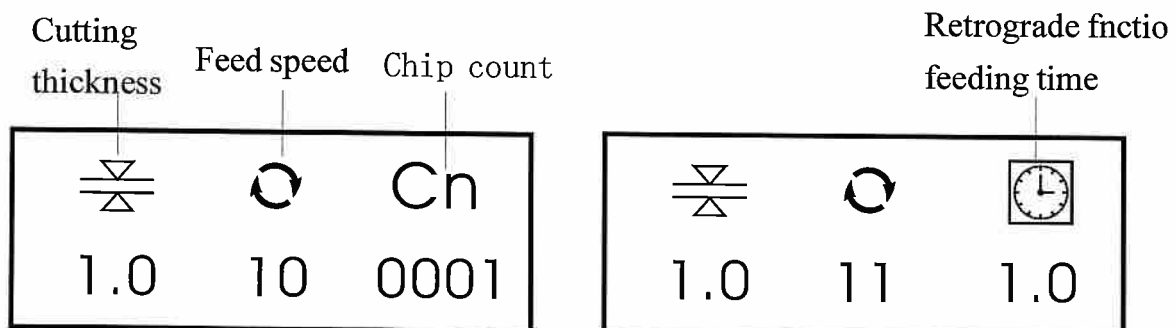


Picture 3

1. Power switch: Press ON, machine running, press OFF, the machine stops running
2. Parameter display area: Display of cutting parameters
3. Conversion key : Regressive function open (Picture 3A switched to Picture 3B)
4. Speed control: Feed speed regulation
5. Time control key: Feeding time adjustment

Parameter display area Brief introduction

a) After electrifying, display area of display (Picture 3A)



Picture 3 (A)

Picture 3 (B)

b) Cutting thickness: Leather cutting after the size (i.e., the finished size), adjustable cutting thickness roll adjusting hand wheel (decomposition)

diagram a piece 23),below 1 after the cutting of leather thickness 1mm

c)Feed speed:According to the control key“”,“”,regulating feeding

rate,according to the “”keys faster, “”the key to slow down

d)Chip count:The number of pieces of skin

e)Feeding time:Press the shift key ,in Picture 3(B),has now been opened into the cutting+return material function,below number 1 for feeding time 0.1s,0.1s starts after the regress function,regulation of chipping

back length,according to the “” , “”key,timeand feeding speed synchronious adjusment

5.Startup explication

Security check

In the course of handling the vibration of a machine can have harmful effects,check whether the points in a protected status

a) Picture 4 two a push knife oblique block A are two positioning pin B live,on both sides of block C is pictured state

b) Picture 5 handwheel screw A B is locked,or rotation of the handwheel B raised counterweight block C(pull handle,drop box,ou of scrap box,grinding wheel dust cover rear cover can be seen the counterweight blick).

c) Open cover open around,mon both sides of the front door,observation,a loser guide wheel is against the knife,or clockwise roation of the handle B(Picture13, Picture14).The two guide wheel and a cutrer.

d) Knife with 3 pairs of lubricating felt spring has not locked,in normal position(see diagram 6)

e) Check the feed roller and the edge of whether there is a gap between(minimum clearance for 0.1mm),otherwise,as shown in the direction of rotation of adjusting hand wheel B(see Picture7),so thaat the two gap increased(to avoid start –up feed roller and the cutter are bruised)

2.start

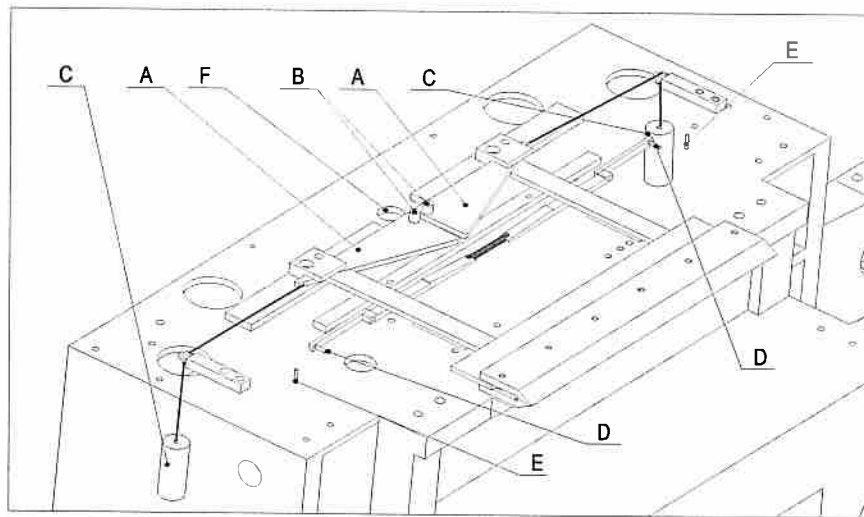
a)fore the start of the operation panel detail understanding,press the control panel switch ON/OFF control button,the machine starts to run,according to the actual needs of various parameter settings(see

control panel using)

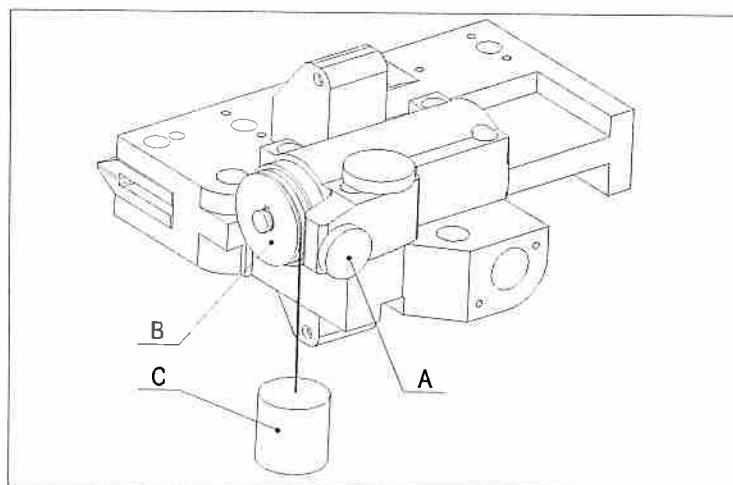
b)When the machine is idle 2-3minutes,release the safety inspection of A,B two

Notice: ① when the machine is under operating, prohibit open the upper&down guide pulley at the same time and adjust blot optionally (Showed in picture 13,14), that is to avoid band knife move its position which can cause position which can cause position inaccuracy and accident.

② This machine doesn't have electronic phasic check and measure system; it can not be startup when electrical source and fixed turing are conflicting. Replace two wires among the three wires to solve this problem (Electrical system only suit for clockwise rotate).



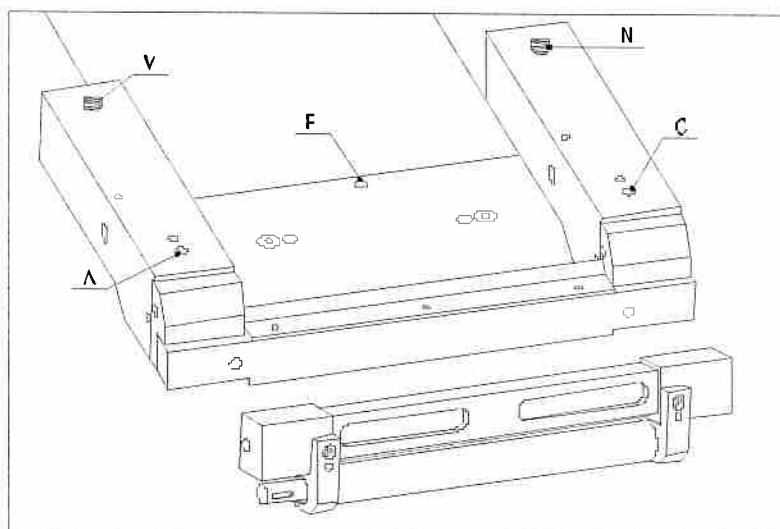
Picture 4



Picture 5

6.Operation explication

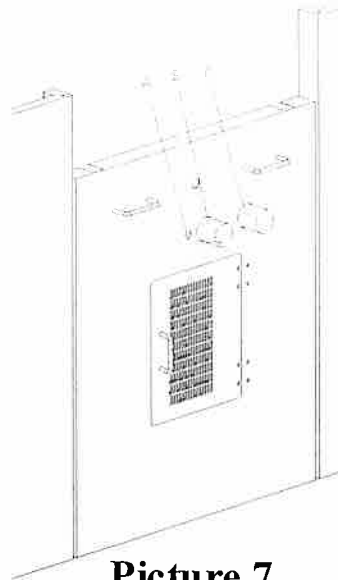
- 1.Magnifying glass: the magnifying glasses in two sides are used to check the tartness of blade, width of the blade of grinding knife and the operation state of band knife.
- 2.High splitting quality relies on sharp blade. Band knife should be grinded before new machine works.
- 3.Adjustment of splitting thickness:
 - a)Adjustment of splitting thickness: take reference in “instruction of operation panel” part.
 - b)When the splitting thickness is different in two sides, adjust blot M or blot N to make it the same. Showed in picture 6
 - c)Replacing operation of upper feed pole and upper feed roller: Put down the finger protection shield in working panel (Decomposition diagram 3, item 15), loosen tension bolts. Showed in Picture 6
 - d)After replacing upper feed pole and upper feed roller, if the splitting thickness is different from the displayed thickness, adjust the blots M, N in two ends to let the splitting thickness the same as the displayed thickness. Showed in Picture 6
 - e)When split is complicated, big-area, or material whose minimal splitting thickness is over 0.5mm, use upper feed roller is better than feed pole.



Picture 6

- 4.Feed speed
 - a)Choose different feed speed according to leather's flexible degree, gauffer and complicated degree.
 - b)Stepless speed regulation of feed speed.

- c) Can speed up splitting speed to soft and small material.
 - d) Should slow down the splitting speed to heavy and hard material.
 - e) If the material is not very wide, allows material to be feed aslant, and can be split as well.
 - f) If the leather surface is not smooth, there may have some force of friction when feed material. So use talcum powder or similar material to make its surface smooth in order to make material feed smooth.
 - g) Using the splitting experience, according to material's different flexible degree, gauffer and complicated degree, choose different feed speed.
5. The pressure and height of down feed roller and band knife blade are different according to the different thickness, flexible degree and size of leather.
- a) The pressure of feed roller is adjusted by spring pressure function.
 - ① When splitting soft leather, less pressure needed.
 - ② When splitting relative hard leather, medium pressure needed.
 - ③ When splitting great hard leather, big pressure needed.
- Adjusting method: Turn adjusting axis of spring pressure in Picture 7 as the picture shows which can adjust the pressure of down feed roller. Showed in Picture 7.
- b) The position of feed roller has a direct influence of the difficulty degree of feed. When the gap between band knife and upper feed roller or feed pole is the fixed thickness but not easy to feed material, should increase the gap between feed roller and band knife. The adjusting method: Turn adjusting axis B in Picture 7 as the picture shows to increase the gap between the two.
 - c) According to splitting experience, choose different down feed roller pressure and height to different materials according to their flexible degree, gauffer condition and complicated degree.



Picture 7

6. Clean up scraps (Clean up scraps after splitting): The scraps produce during operation are all dropped into scrap recycle box (Shown as decomposition diagram 7, item 37), pull up the handle then the recycle box will drop down, drag out recycle box and clean up scraps

(Notice: put the recycle box in the right position when installation, press down handle to avoid ill wind inhalation which will influence normal operation of machine).

7. Tool grinding of band knife

1. Tool grinding of band knife picture 7, 8

- a) The two magnifying glasses are used to check the tartness of blade, and the operation state of band knife.
- b) Band knife should be grinded before new machine works.
- c) After working for a period, when the splitting leather surface is not smooth or leather is moving with the band knife, the band knife needs to be grinded. Operation method: slowly turn the grinding knife handle C in picture 7 as it showed in picture, it is completed when appears symmetrical sparkle.
- d) The best width of the bevel width of band knife blade is 1.8mm, maximal is 2.0mm, minimal is 1.7mm (Check if the blade aligns with staff gauge by magnifying glasses in two sides).
- e) When the sparkle in two sides is not symmetrical or can not appear sparkle by using handle C in picture 7, should turn handle B, C in anticlockwise direction and let two guiding wheels close to band knife slowly until the sparkle grinded becomes the same in two sides (Shown in picture 8).

Notice: ① the grinding wheel should be slightly adjusted to the proper position in the two sides of knife when grind knife. If the blade is sharp enough, it is no need to grind again, otherwise, will lead to the waste of band knife.

② The blade slope in two sides of band knife should keep consistent which will improve the split quality.

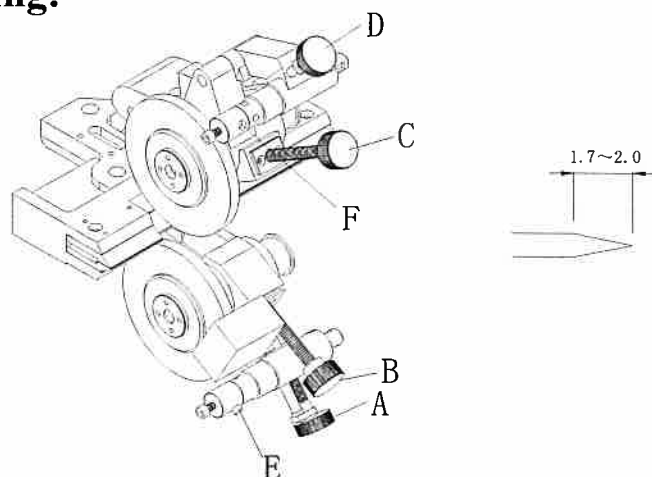
2. Maintenance of grinding wheel

f) The finishing of grinding wheel: when the grinding band knife surface is not smooth, the grinding wheel needs finishing. Turn adjusting handle A, D individually in anticlockwise direction and let two diamond pens close to grinding wheel slowly, push two diamond pens E, F by hands individually to the right position then loosen them, that will finishing the grinding wheel. Showed in picture 8.

g) Replacement of grinding wheel: the grinding wheel needs to be changed when external diameter of grinding wheel is less than $\varnothing 80\text{mm}$.

Notice: two grinding wheels in same size must be replaced at the same time. The maximal diameter of grinding wheel is $\varnothing 110\text{mm}$, the minimal diameter of grinding wheel is 80mm .

3. The dust produced by grinding knife should be cleaned up everyday. Pull up hand and the scrap box will drop, drag out the box, and open the covet board in the down left of the base (Showed in decomposition diagram 9, item 20), then clean the dust. **The electrical source should be cut when cleaning.**



Picture 8

8. Instruction of adjustment

Notice: content in this part is forbidden to adjust optionally, otherwise, may cause accident.

1. The relationship between band knife, upper feed roller (Feed pole) and down feed roller

a) When machine is under normal operation, upper feed roller (Feed pole) and down feed roller should be parallel in two directions which will ensure symmetrical thickness when splitting.

b) The track of band knife should be parallel in two directions with upper feed roller (Feed pole) and down feed roller.

c) The size relationship between band knife, upper feed pole and down feed roller (Shown in picture 10). All data showed in picture has been adjusted strictly before leaving factory, which is forbidden to adjust optionally. (If really needs adjustment, concrete method is as follows)

1) Position adjustment of down feed roller showed (Shown in picture 9)

Loosen the locknut in adjusting bolt B, turn adjusting bolt B to make down feed roller moving ahead or backwards until the distance between the down roller axis board in two ends and the knifepoint is 20.7mm which is showed as size D in picture.

2) Utmost upside position adjustment of down feed roller (Shown in picture 9)

The minimal gap between knife-edge and down feed roller should equal to or more than 0.10mm. Loosen locknut in adjusting bolt A in two ends, turn the adjusting bolt A in anticlockwise direction which can increase the gap.

Notice: locknut should be locked.

2. Pressure adjustment of upper press blade showed in Picture 6

Turn pressure-adjusting blot C in anticlockwise direction which makes the pressure of press blade decrease. Contrariwise, pressure will increase. The pressure uses the standard that turning band knife wheel by hands is not very heavy.

3. Adjustment of band knife showed in Picture 11

Newly settled band knife, when not controlled by anything, the normal track which band knife works in flywheel, move ahead slightly (It is unnecessary needs adjust when machine is not changed).

If really needs adjust, concrete method is as follows:

a).Adjustment of band knife tension

Turn band knife tension adjusting axis B in anticlockwise direction which is showed in Picture 11, the tension will increase. Contrariwise, tension will decrease. **Notice: band knife's tension cannot be adjusted too large, only need to keep in the middle position of red sign of warning board in hole C. Otherwise, will damage band knife.**

b)Position adjustment of band knife

Turn adjusting nut sleeve E, F in two ends in the Picture showed direction, and let band knife move ahead or backwards.

Notice: The High-low position of the two band knives wheel can not be adjusted optionally, otherwise, will influence the normal operation of machine. (Picture 11, G, H)

4.The relationship between band knife orientation and guide pulley

Picture 12~ Picture 14

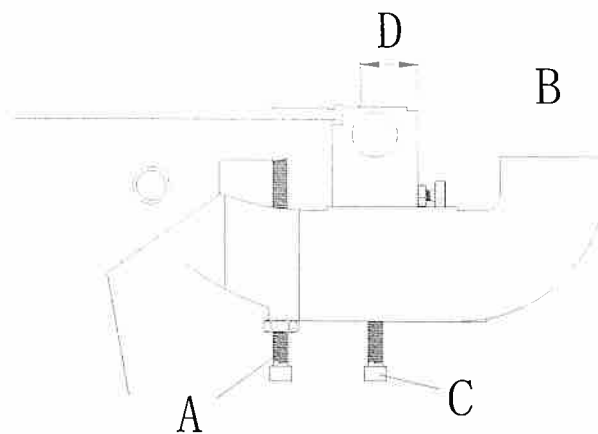
a)The moving track of band knife blade should be in the central position of guide pulley (Showed in Picture 12). Otherwise, adjust the adjusting bolts A , B in upper&down guide pulleys individually (Showed in Picture 12, Picture 13) that can adjust the high-low position of guide pulley.

b)Orientation of band knife operation: there are two automatic mechanical equipment behind band knife (On the top of machine and in the back of grinding knife bracket), its work relies on the thrust produced by the gravity of three clump weights, keep the contact of band knife and guide pulley all the time.

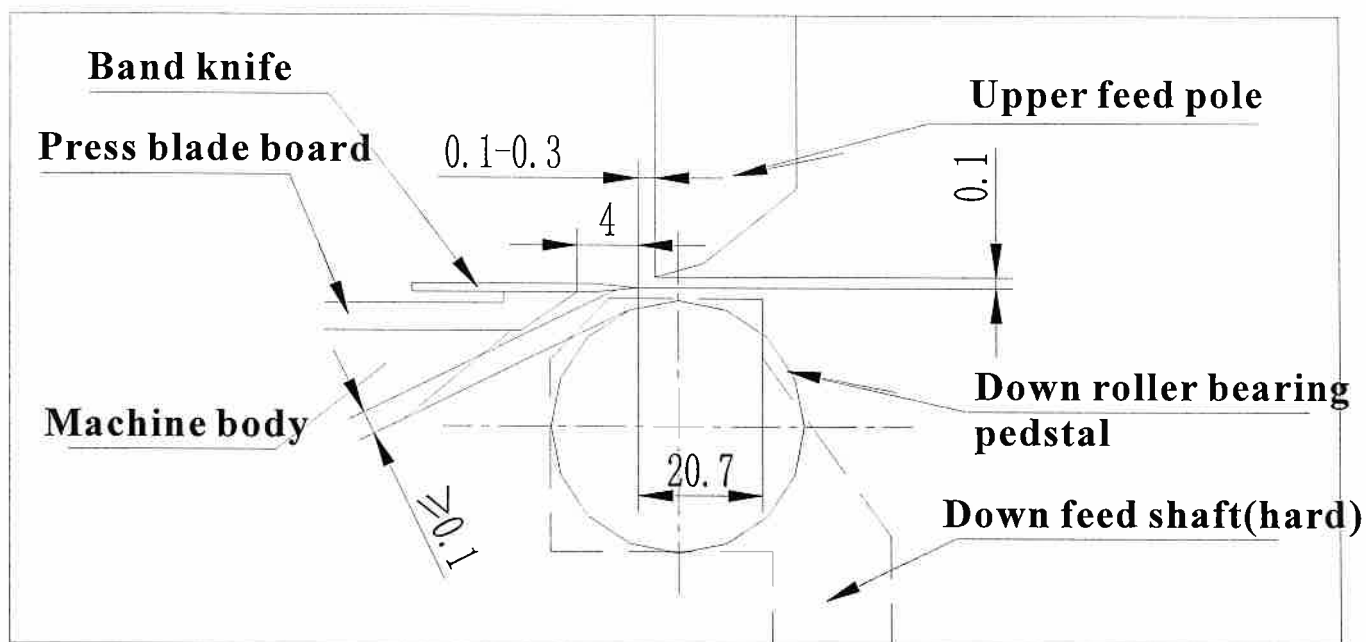
c)The maximal horizontal range between band knife blade and down press blade is 4mm, and the minimal horizontal range is 3.5mm. When the distance between band knife and feed pole is larger or less than 0.1~ 0.3mm, turn the adjusting bolts C, D in clockwise direction which is showed in Picture 13, 14, that will make the guide pulley mine ahead. When need the guide puller move backwards, should disengage the two automatic mechanical equipments behind band knife, and turn adjusting bolts C, D in a reverse direction.

Notice: make sure the upper and down guide pulleys burden the same pressure (press them by finger and test the pressure)

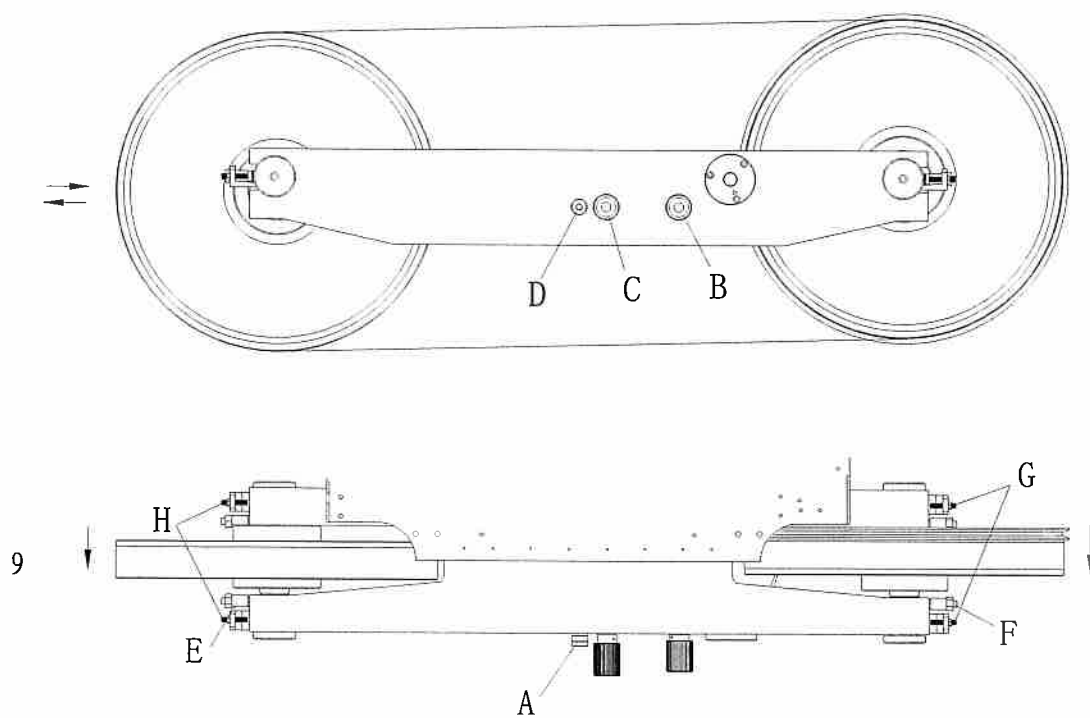
Strictly prohibit: open the upper and down guide pulleys at the same time, otherwise, band knife may move out which will cause unpredictable accident!



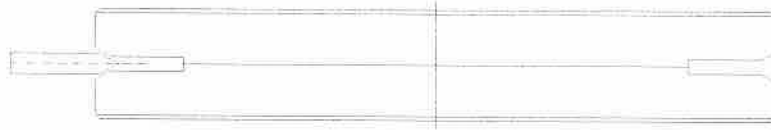
Picture 9



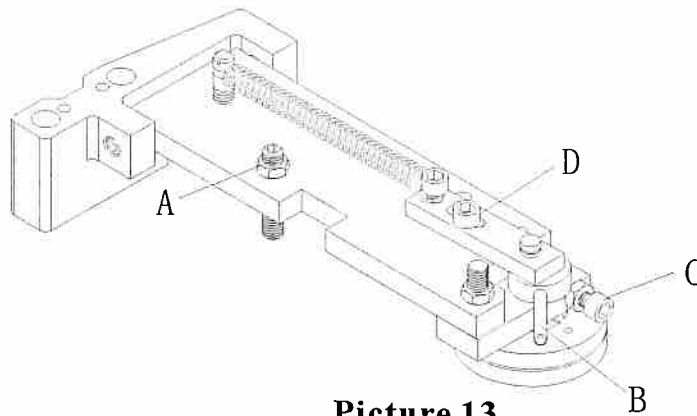
Picture 10



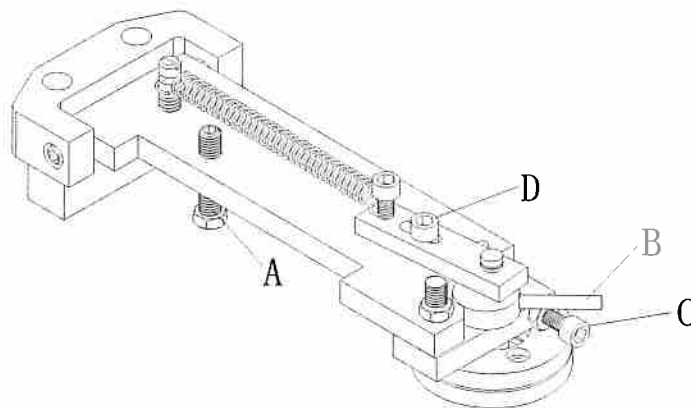
Picture 11



Picture 12



Picture 13



Picture 14

9. Replacement of band knife

When band knife's width is less than 20mm, should replace new band knife. Otherwise, unpredictable accident maybe happens.

Notice: when offload old knife, should cut down electrical source at first, then use portable grinding wheel to grind the blade to make it blunt in order to avoid accident.

Step 1 Offload front working panel, open the upper cover and security door in two sides, move middle door.

Step 2 Press the “PageUp” button in operation panel which will make upper feed roller (pole) rise. Tread footplate, let the down feed roller descend and take off blade, lock adjusting handle B (showed in Picture 7).

Step 3 Offload the wooden cover in machine, loosen two locknuts D, E (**notice: write down the sign and original position sign of these two locknuts. Strictly prohibit to adjust blot B optionally**), offload installation board F of press blade (showed in Picture 6). Pull back two feed bevel blocks in Picture 4, and fore lock by two locating pins E in two ends.

Step 4 Drag out scrap box, turn handwheel B in anticlockwise direction by hands which showed in Picture 5, and make the rack withdrawal, lock the adjusting bolt A.

Step 5 Offload every lubricant parts in band knife.

Step 6 Turn eccentricity handle B in Picture 13 and Picture 14 individually, and let the upper and down guide pulley disengage from band knife individually, then turn two subassemblies in the direction which showed in picture (**notice: do not adjust the adjusting bolts in every parts optionally**).

Step 7 offload the strap of grinding knife’s grinding wheel, divide two grinding wheels. Offload the strap of feed electric machinery.

Step 8 Loosen two tie bars in footplate (Adjust two tie bars’ tension to the same when installation).

Step 9 Turn the tension adjusting axis B in Picture 11 in anticlockwise direction and let the strap wheel withdrawal. The band knife is loosened, and takes off the band knife.

Step 10 Replace a new knife, turn the band knife tension adjusting axis in Picture in clockwise direction and let the knife band stretch (**Notice: turn the flywheel by hands and stretch adjustment at the same time, and let the band knife work in a normal track in the two flywheels**), when band knife is tensioned correctly, the caution board (its color is half red and half white) is located in the middle position of hole C.

Step 11 Converse restoration the above parts.

10.Maintenance

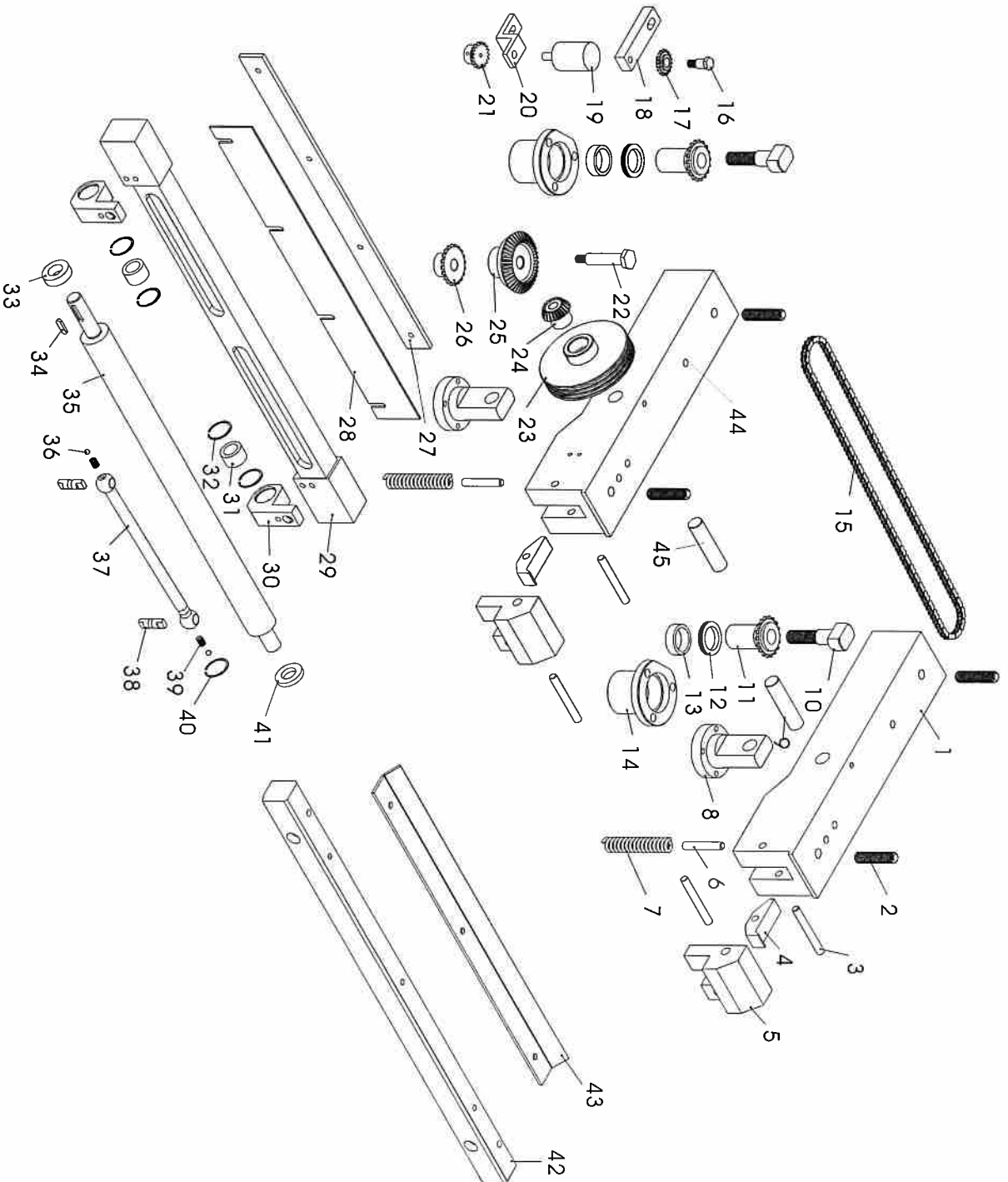
- 1.Seriously clean the dust in machine's surface everyday, especially the dust in grinding knife parts.
- 2.Scrap are inhaled into the scrap box which behind machine, clean it timely. The small holes in filtration net of the dust collector box (Decomposition diagram 7, item 40), which in the upper part of scrap box should be cleaned by hairbrush to avoid jam which may cause ill wind inhalation and influence splitting operation.
- 3.Clean the dust in grinding knife and grinding wheel timely. (Drag out scrap box, open the back door in down base, and then clean the dust).
- 4.Splitting dust is inhaled to dust collector bag, clean it timely.
- 5.Check the lubricating oil in the knife timely, check if the oil in asphalt felt is enough, otherwise, inject by oil gun.
- 6.Clean the plastic squeegee in two flywheels every 100 working hours.
- 7.Clean the oil and dust in asphalt felt every 500 working hours, if necessary, replace lubricant asphalt felt.

11.Attention during transportation

- 1.As showed in Picture 4, the two bevel blocks A are forelocked by locating pin B, two pressure adjusting bevel blocks hang in the locating pin in two ends.
- 2.Lock the lock blot A in Picture 5.
- 3.Put the crane hook into screw F which showed in Picture 4, and then hoisting it.

13(1) Decomposition diagram of upper feed roller and

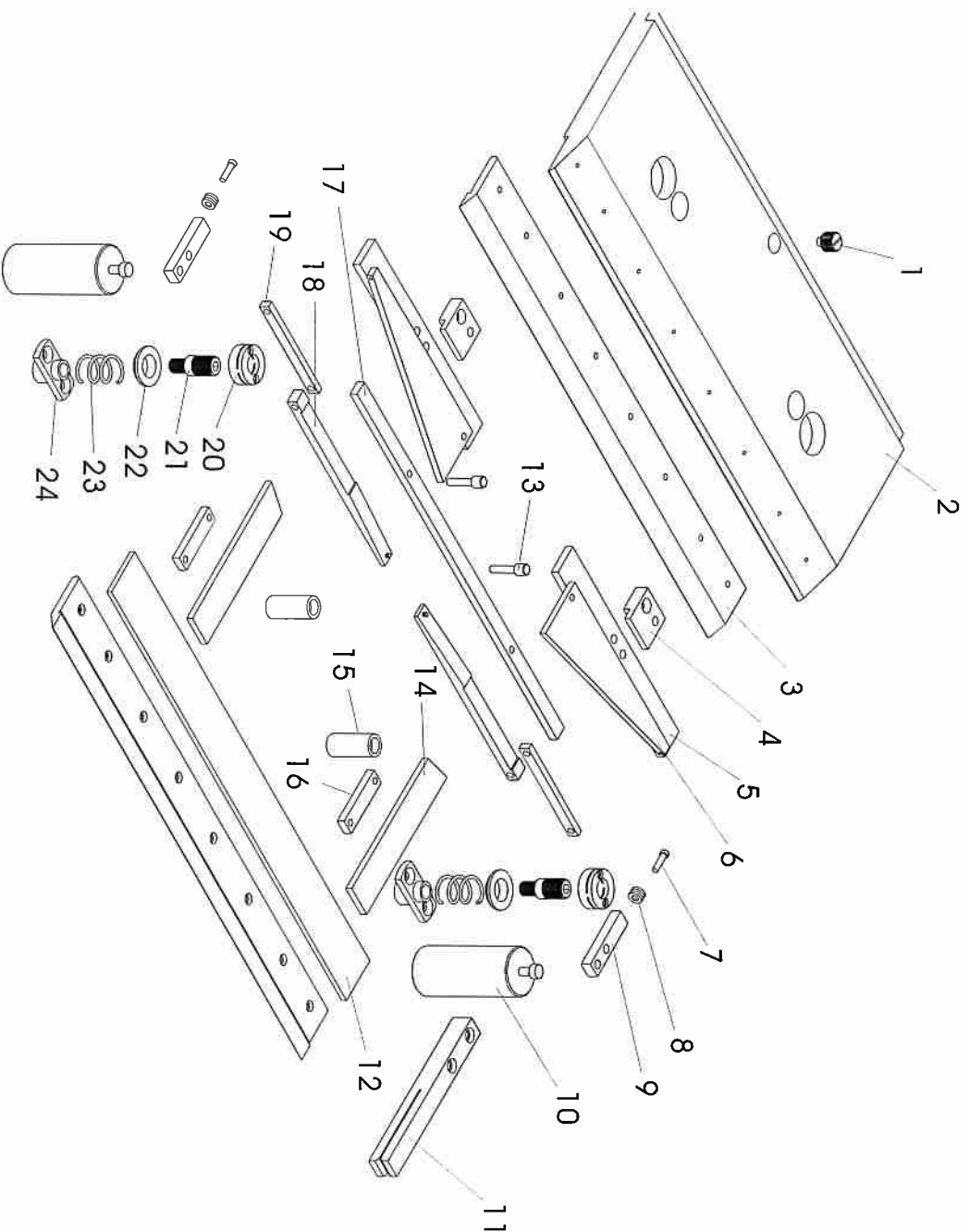
bracket parts



No	Chart number	Name	Quantity
1	L420-0101	Right bracket	1
2		Screw	4
3	L420-0163	Round pin	2
4	L420-0113	Pressing block	2
5	L420-0104	Upper feed pole block	2
6		Elastic round pin	2
7	L420-0165	Compression spring	2
8	L420-0105	Bearing	2
9	L420-0102	Right pin	1
10	L420-0106	Adjusting screw	2
11	L420-0107	Adjusting chainwheel	2
12		Plane bearing	2
13		Needle roller bearing	2
14	L420-0107.1	Joint flange	2
15		China	1
16	L420-0116	Tension pulley joint	1
17	L420-0115	Tension chainwheel	1
18	L420-0117	Tension chainwheel joint block	1
19		Potentiometer	1
20	L420-0166	Joint pin	1
21	L420-0167	Chainwheel	1
22	L420-0110	Joint pin	1
23	L420-0112	Adjusting handwheel	1

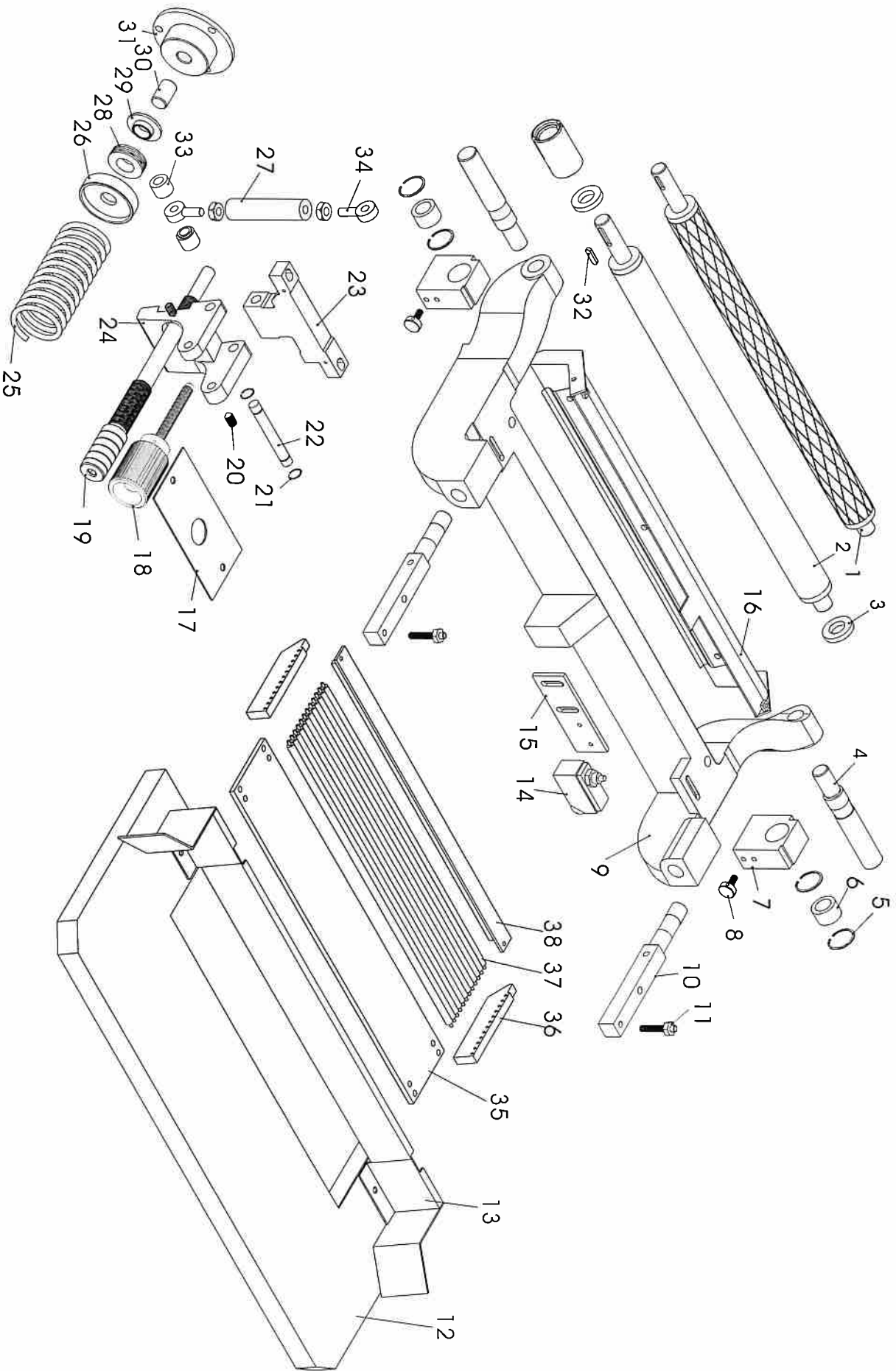
No	Chart number	Name	Quantity
24	L420-0111	Driving bevel	1
25	L420-0108	Passive bevel gear	1
26	L420-0109	Chainwheel	1
27	L420-0123	Layering	1
28	L420-0144	Scraper	1
29	L420-0156	Connecting rod	1
30	L420-0139	Upper feed roller joint block	2
31		Needle roller bearing	2
32		Elastic closing ring for hole	4
33	420-0142.3	Washer	1
34		Flay key	1
35	L420-0138	Upper feed shaft	1
36		Steel ball	2
37	420-0213	Gimbal shaft	1
38	420-0214	Gimbal pin	2
39	L420-0169	Spring	2
40		Steel wire closing ring for hole	1
41	420-0142.1	Washer	1
42	L420-0155	Upper feed pole	1
43	L420-0164	Roll-proof board	1
44	L420-0101.1	Left bracket	1
45	L420-0102.1	Left pin	1

13(2)Decomposition diagram of upper press blade parts



No	Chart number	Name	Quantity
1	420-0808	Adjusting screw	1
2	420-01 25A	Press blade installation board	1
3	420-01 24	Press blade board	2
4	420-01 13	Pressing block	2
5	420-01 14	Cushion block	2
6	420-01 19	Bevel block	2
7	420-01 18	Pin	2
8	420-01 17	Idler wheel	2
9	420-01 16	Counterweight bearing block	2
10	420-01 53	Clump weight	2
11	420-01 52	Dust scraping block	1
12	420-01 29	Feed board	1
13	420-01 58	Round pin	2
14	420-01 22	Feed board bevel block	2
15	420-0801	Limit pin	2
16	420-01 11	Small cushion block	2
17	420-01 12	Limit bar	1
18	420-0802	Press blade adjusting bevel block	2
19	420-0807	Bevel block toggle	2
20	420-0805	Lock nut	2
21	420-0804	Adjusting screw	2
22	420-0803	Apherical washer	2
23	420-0809	Spring	2
24	420-0806	Screw whlder	2

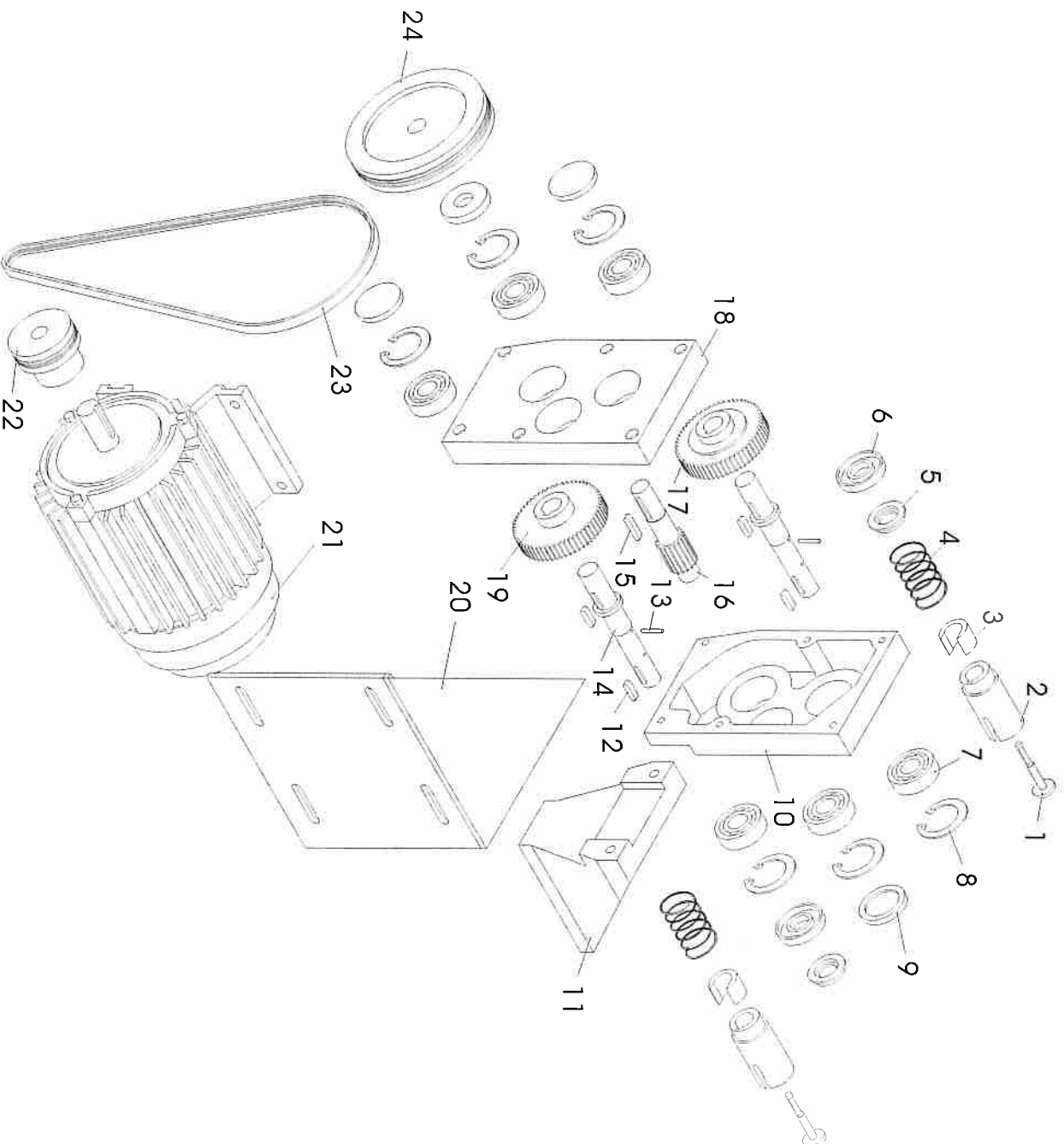
13(3)Decomposition diagram of down feed roller parts



No	Chart number	Name	Quantity	No	Chart number	Name	Quantity
1	420-0215	Down feed shaft (hard)	1	24	420-0202	Spring seat	1
2	420-215A	Down feed shaft(soft)	1	25	420-0261	Spring	1
3	420-0142.1	Shim	2	26	420-0224	Spring end shield	1
4	420-0207	Pin	2	27	420-0221A	Connecting rod	1
5		Elastic closing ring for hole	4	28		Plane bearing	1
6		Needle roller bearing	2	29	420-0223	Shim	1
7	420-0208	Down roller bearing pedestal	2	30		Automatic lubrication shaft liner	1
8	420-0210	Adjusting screw	2	31	420-0222	Gland	1
9	420-0203	Bracket	1	32		Flay key	1
10	420-0216	Pipe link	2	33	420-0202.1	Spacer sleeve	2
11	420-0217	Screw	2	34		Joint bearing	2
12	L420-6160	Working bedplate	1	35	L420-6158	Baseplate	1
13	L420-0150	Caution board	1	36	L420-6156	Support plate	2
14		Travel switch	1	37	L420-6157	Scrollbar	12
15	420-0254	Switch joint block	1	38	L420-6155	Support plate	1
16	420-0151	Safety board assembly	1				
17	420-0606	Middle small cover plate	1				
18	420-0253	Limit adjusting pole	1				
19	420-0228	Spring adjusting shaft	1				
20	420-0258	Locknut	4				
21		Elastic closing ring for shaft	4				
22	420-0246	Pin	2				
23	420-0201	Fixed block	1				

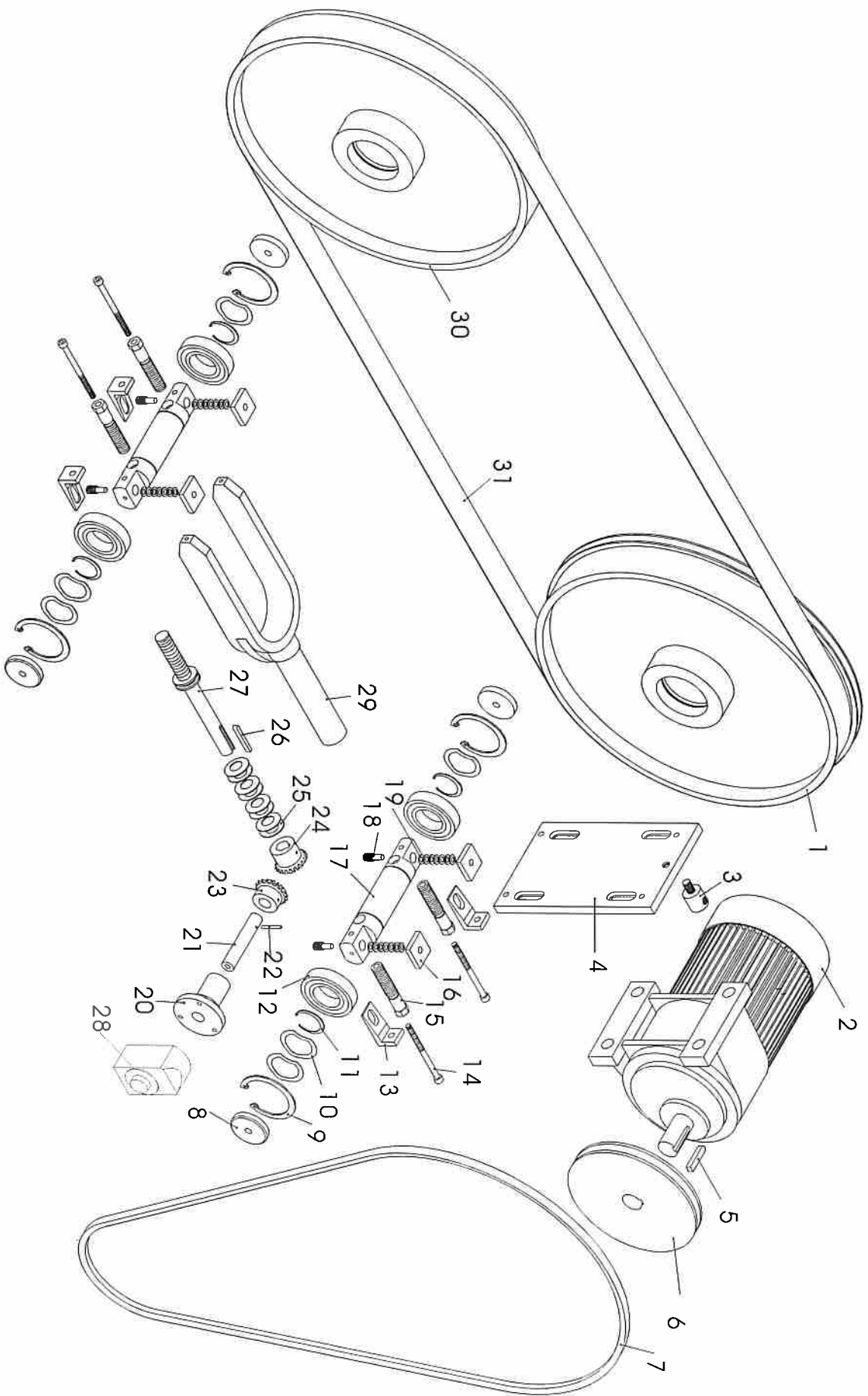
13(4)Decomposition diagram of transmission case parts

23



No	Chart number	Name	Quantity
1	420-0232	Pin	2
2	420-0244	Gimbal joint sleeve	2
3	420-0230	Spacer sleeve	2
4	420-0250	Spring	2
5	420-0231	Washer	2
6		Oil seal	2
7		Bearing	6
8		Elastic closing ring for hole	6
9	420-0243	Transmission case caulking	3
10	420-0206	Transmission case body	1
11	420-0204	Transmission case bracket	1
12		Flat key	2
13		Elastic round pin	2
14	420-0229	Power output shaft	2
15		Flat key	2
16	420-0235	Shaft gear	1
17	420-0233	Gear (1)	1
18	420-0205	Transmission case cover	1
19	420-0234	Gear (2)	1
20	420-0237	Electric machine installation bracket seam	1
21		Electric machine	1
22	400A-0236	Electric machine belt pulley	1
23		Belt	1
24	400A-0226	Transmission case belt pulley	1

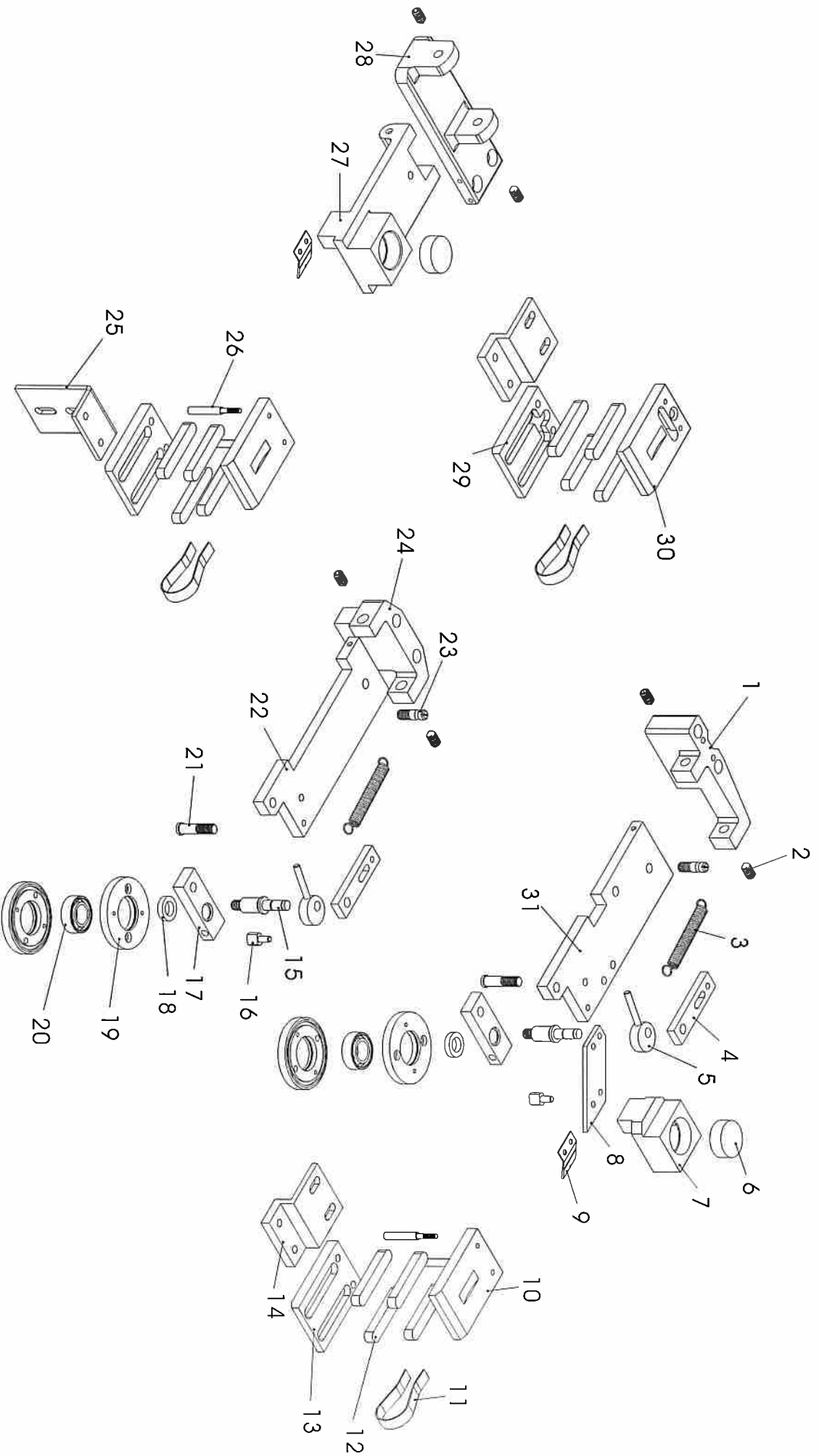
13(5) Decomposition diagram of band knife wheel parts



No	Chart number	Name	Quantity
1	420-0302	Driving band knife wheel	1
2		Electric machine	1
3	420-0336	Main electric machine adjusting fixed pole	1
4	420-0333	Electric machine installation board	1
5		Flay key	1
6	420-0334	Main electric machine belt pulley	1
7		Triangle zone	1
8	420-0332	Shaft end shield	4
9		Elastic closing ring for shaft	4
10		Waveform shim	4
11		Elastic closing ring for shaft	4
12		Bearing	4
13	420-0330	Adjusting bevel block	4
14	420-0342	Adjusting bolt	4
15	420-0327	Adjusting screw	4
16	420-0329	Cushion block	4
17	420-0326	Band knife wheel shaft	2
18	420-0328	Set screw	4
19		Dishing shim	40
20	420-0323.1	Fixed sleeve	1
21	420-0323	Tension adjusting shaft	1
22		Elastic round pin	1
23	420-0324	Driving bevel gear	1

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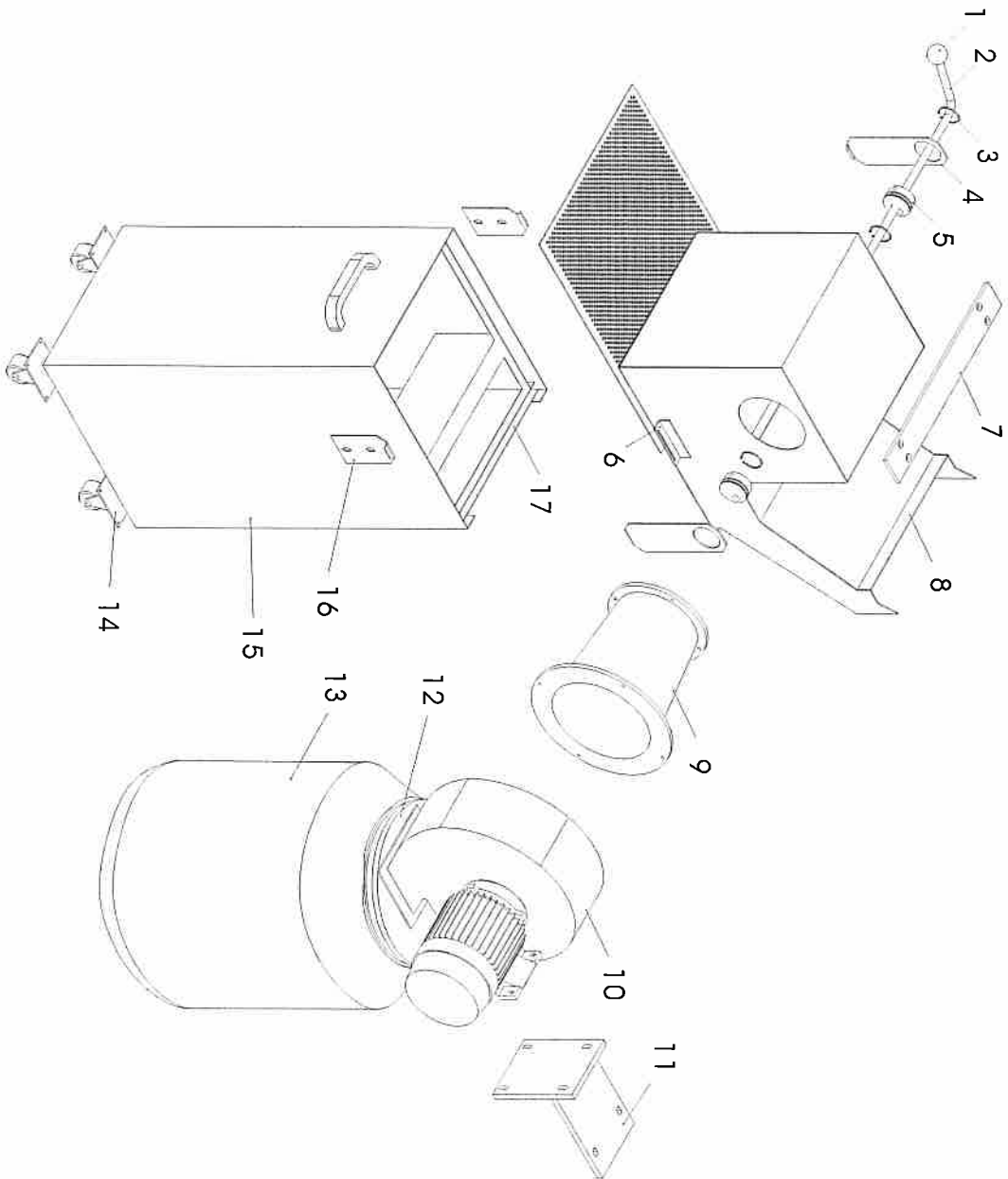
13(6)Decomposition diagram of guide pulley and lubricant Parts



No	Chart number	Name	Quantity
1	420-0305	Top right guide pulley joint block	1
2	420-0258	Set screw	6
3	420-0343	Extension spring	2
4	420-0312.2	Joint block	2
5	420-0308	Eccentric wheel	2
6	420-0344	Magnifier	2
7	420-0307	Magnifier shell	
8	420-0313	Magnifier joint block	1
9	420-0314	Dial plate	2
10	420-0315A	Upper lubricant plate	2
11	420-0316A	Clip ring spring	3
12	420-0319.1	Wool felt	12
13	420-0315.1	Down lubricant board	2
14	420-0318.3A	Joint plate	2
15	420-0309	Eccentric wheel pin	2
16	420-0312.1	Top pin	2

No	Chart number	Name	Quantity
17	420-0311	Eccentric wheel joint block	2
18	420-0308.1	Guide pulley shim	2
19	420-0306	Guide pulley	4
20		Bearing	2
21	420-0310	Joint pin	2
22	420-0338	Down left guide pulley joint plate	1
23	420-0516	Spring hanger pin	2
24	420-0304	Down left guide pulley joint block	1
25	420-0322A	Down joint flat steel	1
26	420-0317A	Joint pin	6
27	420-0108	Magnifier bracket	1
28	420-0106	Joint block	1
29	420-0319A	Top left lubricating plate II	
30	420-0320A	Top left lubricating plate I	
31	420-0312	Upper guide pulley joint plate	1

13(7)Decomposition diagram of big fan parts



No	Chart number	Name	Quantity
1		Ball knob	1
2	420-0420.4	Lock lever	1
3		Elastic closing ring for shaft	4
4	420-0420.1	Lock plate	2
5	420-0420.3	Eccentric lock wheel	2
6	420-0420.5	Locating angle steel	2
7	420-0425	Joint steel plate	1
8	420-0420	Dustbin seam	1
9	420-0424	Fan inlet	2
10	DF-7	Wind machine	1
11	420-0418	The fan mounting bracket	1
12	420-0416	Wase outlet	1
13	420-0427	Dust bag	1
14		Aero wheel	4
15	420-0421	Dustbin seam	1
16	420-0421.1	Hanging board	2
17	420-0421.2	Seal ring	1

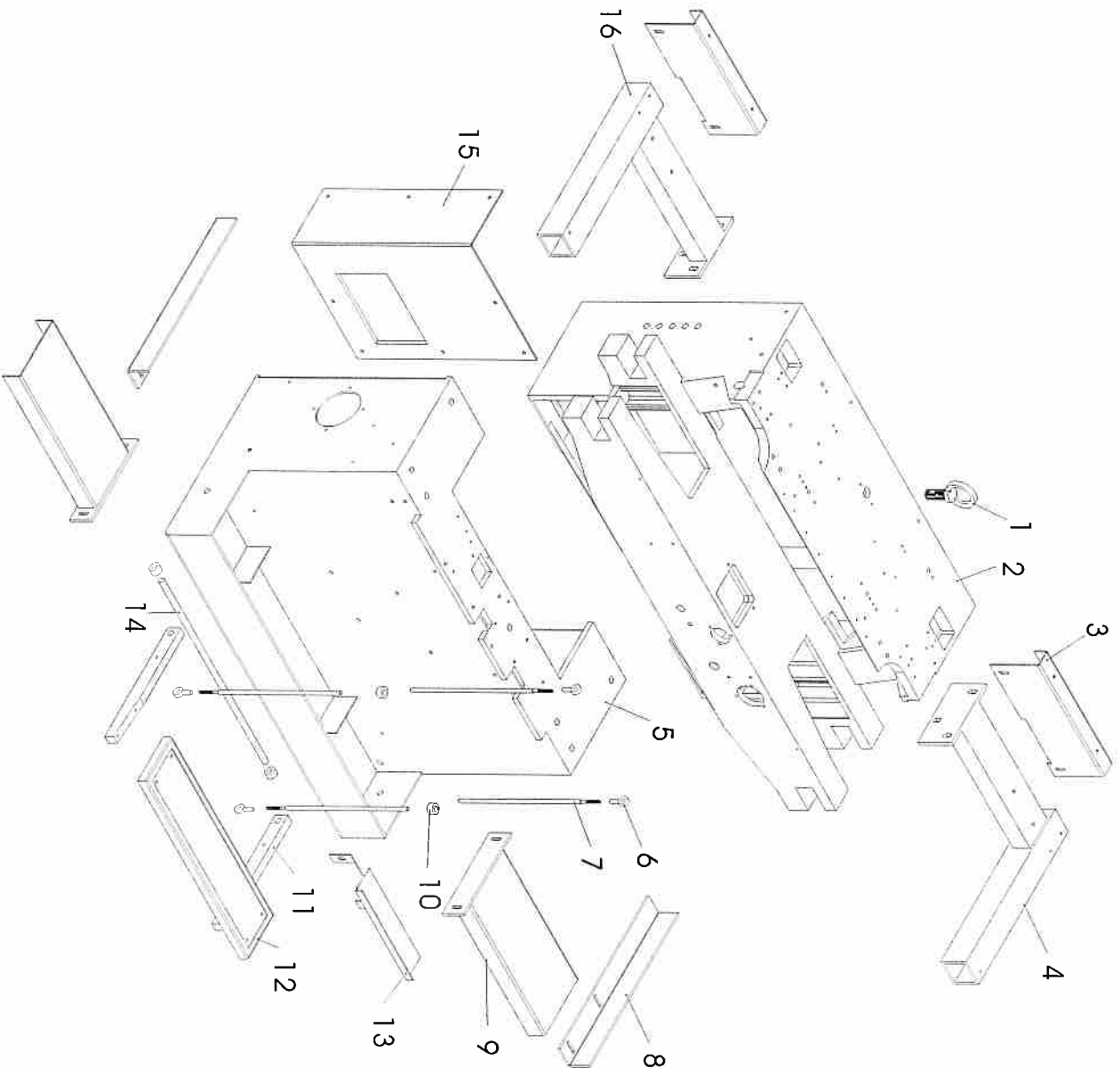
No	Chart number	Name	Quantity
1	420-0523	Cutting knife joint pin	2
2		Diamond pen	2
3	420-0520	Cutting knife shaft	2
4	420-0521	Dustproof sleeve	2
5	420-0554	Spring	2
6	420-0516	Spring hanger pin	6
7	420-0503	Upper cutting knife bracket	1
8	420-0519	Joint pin	2
9	420-0503.1	Running-proof key	2
10	420-0526	Adjusting screw II	2
11	420-0527	Pin return-proof assembly	2
12	420-0553	Upper extension spring	2
13	420-0258	Set screw	4
14	420-0511	Upper grinding wheel shaft	1
15		Bearing	4
16		Waveform shim	2
17		Elastic closing ring for hole	4
18	420-0512	Spacer sleeve	1
19	420-0502	Upper grinding wheel bracket	1
20	420-0517.1	Return-proof shim	2
21	420-0517	Dustproof gland	1
22	420-0518	Adjusting screw I	2
23	420-0513	Grinding wheel inner end shield	2

No	Chart number	Name	Quantity
24	420-0514	Inner locknut	2
25		Grinding wheel	2
26	420-0515	Grinding wheel outer end shield	2
27	420-0568	Dust absorption mouth	1
28	420-0546	Locating key lock block	1
29	420-0545	Grinding knife bracket locating key	1
30	420-0501	Grinding knife bracket	1
31	420-0560	Joint pin	2
32	420-0555	Upper control pole	1
33	420-0555.1	Down control pole	1
34	420-0556	Joint block	1
35	420-0560.1	Joint pin	1
36	420-0557	Pipe link	1
37	420-0558	Chainwheel	2
38		Chain	1
39	420-0 558.1	Chainwheel	1
40	420-0566	Switch control block	1
41		Steel ball	1
42	420-0570	Spring	1
43		Elastic closing ring for shaft	4
44	420-0565	Tension chainwheel pin	1
45	420-0567	Tension pole	1
46		Switch	1

No	Chart number	Name	Quantity
47	420-0559	Adjusting shaft	1
48		Elastic round pin	1
49	400A-0223	Adjusting knob	1
50	420-0561A	Bearing	1
51	420-0563A	Adjusting nut	1
52	420-0562A	Adjusting screw	1
53	420-0564A	Connecting block	1
54	420-0553.1	Down extension spring	2
55	420-0508	Grinding knife upper press blade plate	1
56	420-0509	Grinding knife down press blade plate	1
57	420-0535	Adjusting wheel	1
58	420-0530	Clutch closing ring	2
59	420-0534A	Brake outer ring	1
60	420-0530A	Brake inner ring	1
61	420-0536	Pin	1
62		Round pin	3
63	420-0504	Cover	1
64	420-0528.1	Pressure adjusting screw	1
65	420-0528.2	Set screw	1
66	420-0529	Gear	1
67	420-0510	Rack	1
68	420-0514.1	Inner locknut	2
69	420-0506	Down grinding wheel bracket	1

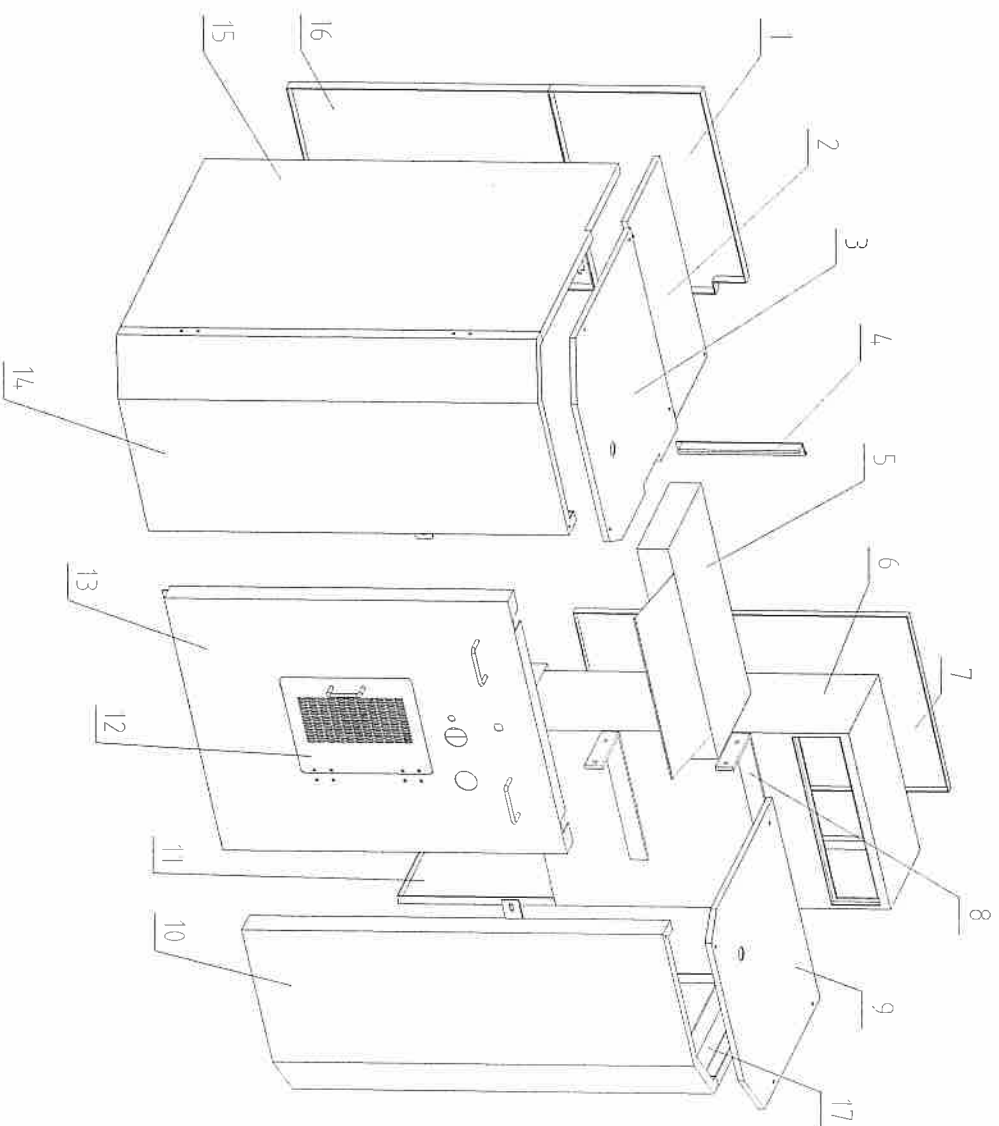
No	Chart number	Name	Quantity
70	420-0551	Grinding wheel shield	1
71	420-0512.1	Spacer sleeve	1
72	420-0511.1	Down grinding wheel shaft	1
73	420-0548	Middle wheel pin	1
74		Bearing	2
75		Elastic closing ring for hole	2
76	420-0547	Middle belt pulley	1
77	420-0549	Spacer sleeve	1
78		Shim	1
79	420-0538	Grinding knife upper cover	1
80	420-0540	Grinding knife dustproof cover	1
81	420-0537	Grinding wheel dust box	1
82		Belt	1
83	420-0542	Grinding knife electric machine belt pulley	1
84		Flat key	1
85	420-0543	Electric machine joint block	2
86	420-0544	Grinding knife electric machine installation board	1
87		Plane bearing	2
88		End cover	1
89		Electric machine	1
90	DF-3	Small blower fan	1
91	420-0629	Small blower fan Suction canal	1
92	420-0629.2	Fan inlet	1

13(9) Decomposition diagram of frame parts



No	Chart	Name	Quantity
1		Hook	1
2	420-0601	Machine body	1
3	420-0610	Bearing plate	2
4	420-0611	Right plate joint bracket seam	1
5	420-0602	Machine body base	1
6		Joint bearing	4
7	11-1055	Toggle arm	4
8	420-0613	Down joint angle steel	2
9	420-0612	Down joint bracket seam	2
10	420-0240	Closing ring	4
11	420-0238	Step tread board pipe link	2
12	420-0242	Step tread board	1
13	420-0640	With a knife the right protectoin board	1
14	420-0239	Pedal lever shaft	1
15	420-0618	Left rear fuselage	1
16	420-0633	Left joint bracket seam	1

13(10)Decomposition diagram of outside shield



No	Chart	Name	Quantity
1	L420-0608	Left-back cover plate	1
2	L420-0609.2	Left cover II	1
3	L420-0609	Left upper cover	2
4	L420-0608.2	Connecting plate	1
5	L420-0150	The fuselage cover	1
6	L420-0624	Electric box seam	4
7	L420-0627	Electric box cover plate	4
8	L420-0626	Electric box joint steel plate	2
9	L420-0603	Down joint bracket seam	2
10	L420-0621	Front cover plate	4
11	L420-0630	Electric box bottom cover	2
12	L420-0628.2	Small front door	1
13	L420-0628	The front door	1
14	L420-0621.1	Left front cover welding	1
15	L420-0623	Left cover plate	1
16	L420-0608.1	Left rear cover	1
16	L420-0620	Right cover plate seam	1