

OPERATION MANUAL

WINTER TRIMMERMAX - DELUXE



WARNING!

*The operator must thoroughly read this manual before operation.
Keep this manual for future reference.*

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1.Safety regulations

1.1Warning !

Please read the understanding manual and corresponding security proceduress at the before using;

After reading have any questions,please don't use equipment,should contact the nearby distributor.

1.2Safe operation

- please attention on the machine sundries at the start machine;
- At starting machine,please remind worker attention safety at the machine nearby;
- The machine coated with yellow place,please special attention safe,such as high temperature object,charged object and tool etc;
- When the working process appear any question,please at once press down emergency stop switch;
- Please at the cut off power repair machines;
- Strictly unskilled worker open the control box and go with power;
- Before replace electric components,please cut off machine power;
- Regularly check safety protection devices,at once discover fault should immediately maintenance;
- Starting sequence: connect external power → opening on the control panel power switch → Ordinal open the motor switch → begining work;
- Power off sequence: at first close the motor switch →cut off on the control panel power switch→ cutting off external power.

1.3Attention:

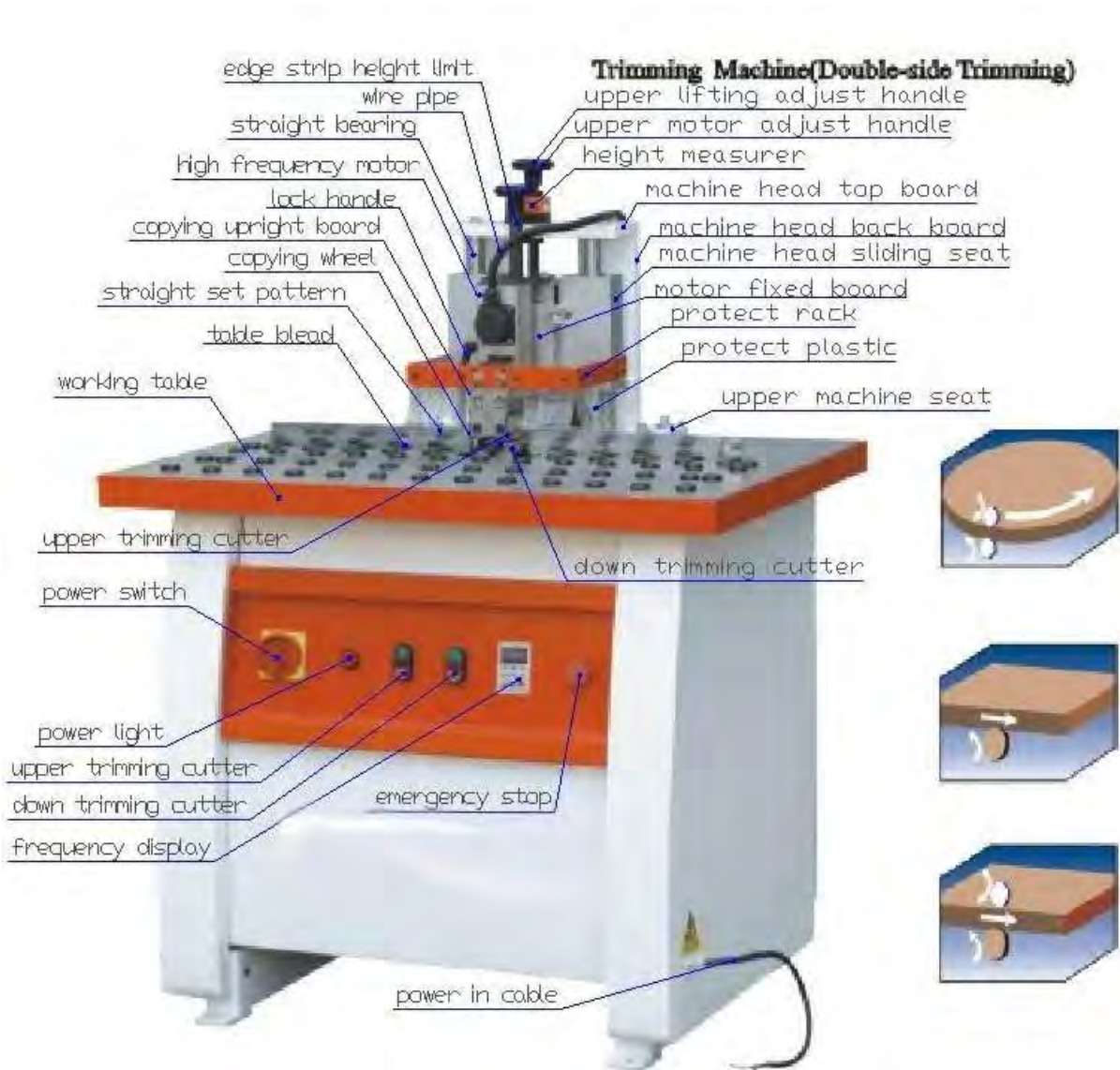
- The company without agree,please don't change machine structure!
- If you need replace parts,please use the original parts!
- Manual nothing maintenance content,please contact dealer solve!
- The manual use applicable hand movement straight and curve model!

2.Overview

2.1Main part chart specifications:

Processing board thickness	12-60mm
Edge materials thickness	0.4-3mm
Trimming motor power	0.7kw×2
Trimming motor rpm	18000r/min
Net weight	200kg
Overall size	1000×800×1350mm
Functional	Single side double sides and profile trimming

3.Main part schematic



(Picture 1)

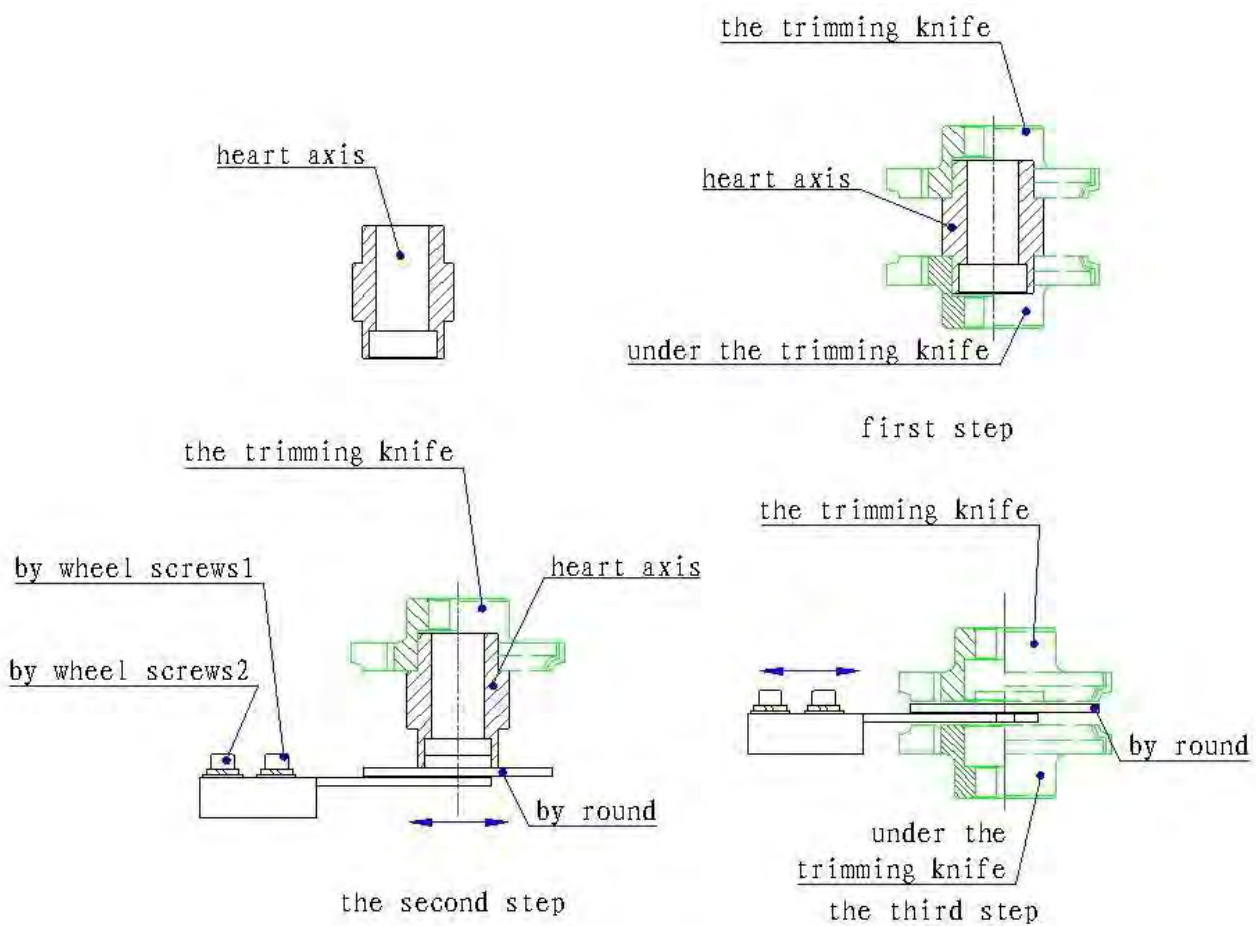
4.Wiring

After confirm the power supply and on the machine control panel cut off power, the machine power lines attach on the special power to three phase AC380V、50Hz, and the machine ground lead reliable the land (power lines is four core wire,yellow and green double color attach ground lead).

5.Adjustment and operation

5.1 Adjust

5.1.1 Trimming knife and near wheel concentric adjust

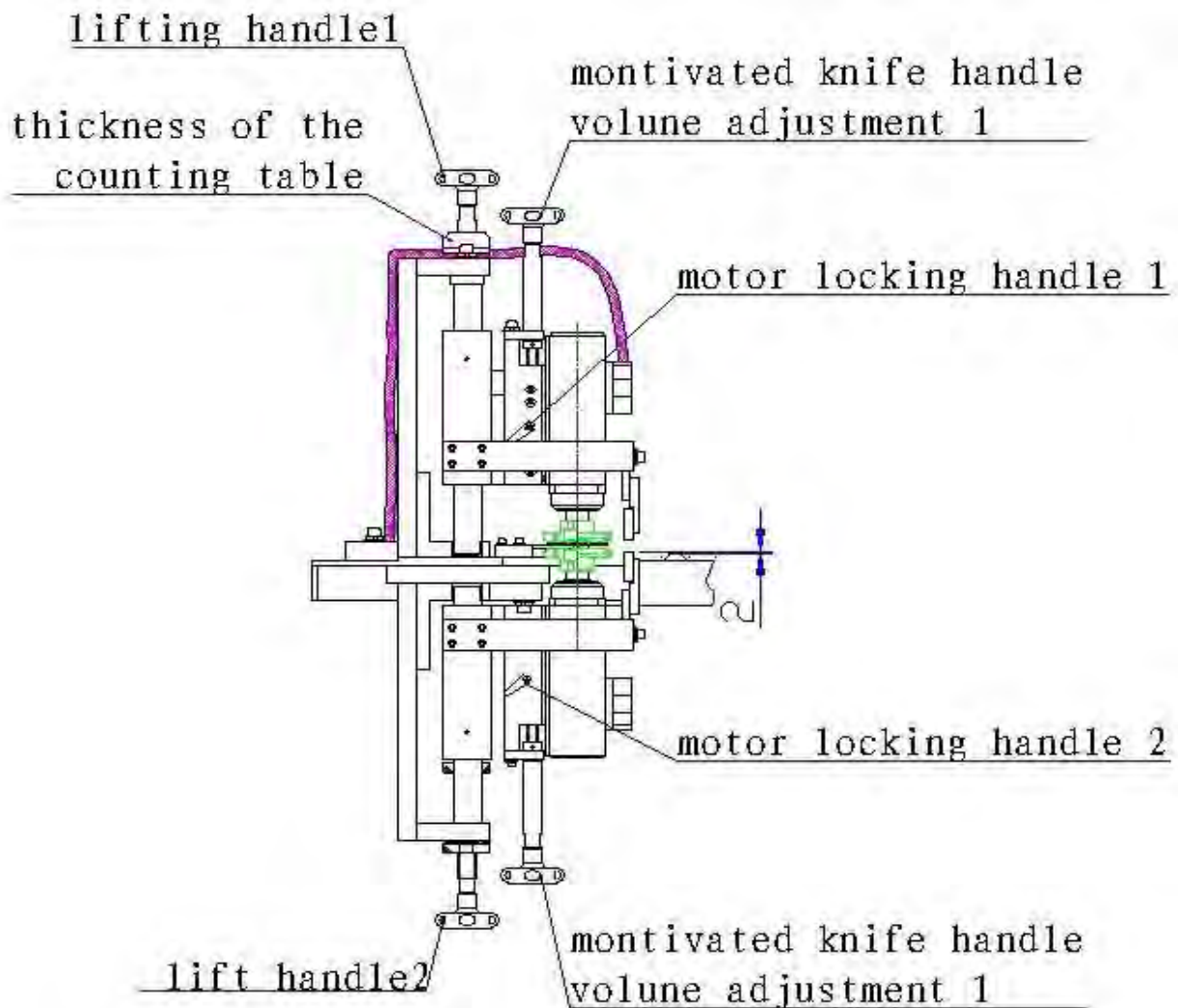


(Picture2)

As show in picture 2,the concentric insert up and down trimming knife hole at first,get to the up and down trimming knife concentric.Second the concentric insert up and down trimming knife hold,the need wheel convex insert concentric hold, get

to near wheel and up trimming knife of the concentric.the up and down trimming and near wheel of the concentric at last.

5.1.2 Board thickness adjust



(Picture 3)

As show in picture3,before leave factory setting higher table-board 2mm,to the bottom copy bearing,the board thickness need not adjust of the change.when the change board thickness,main adjust up handle,when the thickness numeration table display board thickness numeration is OK.(when the up handle clockwise rotation,board is add,opposite is reduce).

5.1.3 Trimming feeding adjust

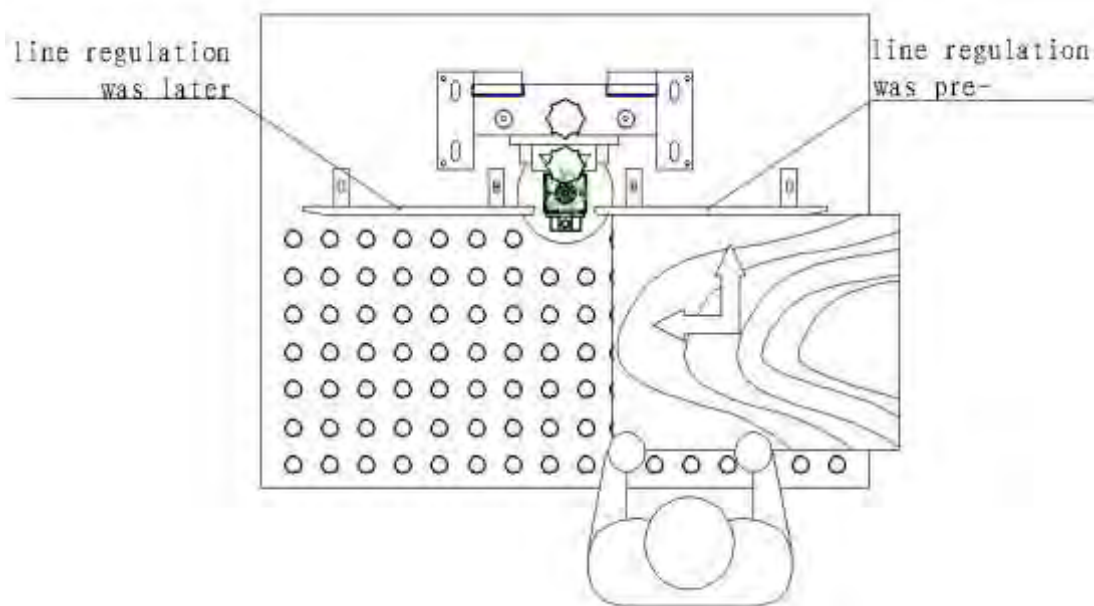
When the up and down board trimming measure is not appropriate, as shown in picture 3, loosen the motor lock handle, turn the up and down feeding measure adjust handle to make the trimming measure appropriate. (clockwise rotation feeding measure adjust handle, the trimming is reduced, opposite the trimming is added.)

5.2 Operation.

5.2.1 Start machine

The power switch turned on, the power light is lit, at the same time the up and down trimming motor starts. If double trimming, press on the up trimming electric switch and the down trimming electric switch, the motor begins to work. If single trimming, just need to open the down trimming motor, the work is OK. (Note: when the motor is in the high speed state, the frequency reaches 200HZ or above and the other motor stops, if you open the motor, the frequency must be adjusted to 0HZ after the two motors are opened together.)

5.2.2 Straight line trimming



(Picture 4)

As show in picture 4,the board according to arrow direction depend on front straight line set pattern,at the straight line trimming before.again turn left move the board until leaving trimming knife is ok.

5.2.3 Curve line trimming

Reference picture4, at the curve trimming remove the before and behind straight line set pattern.(If the behind straight set pattern don't block panel move can need not remove)the depend on wheel according the panel exterior move until trimming finish.

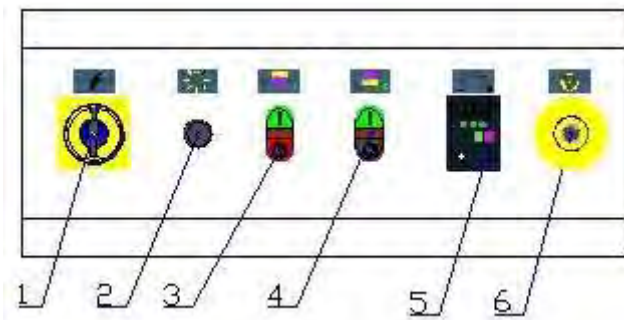
5.2.4 Power off

Strictly direct close the power switch,should one by one close power switch,cut off without power at last.

6.Electrical part

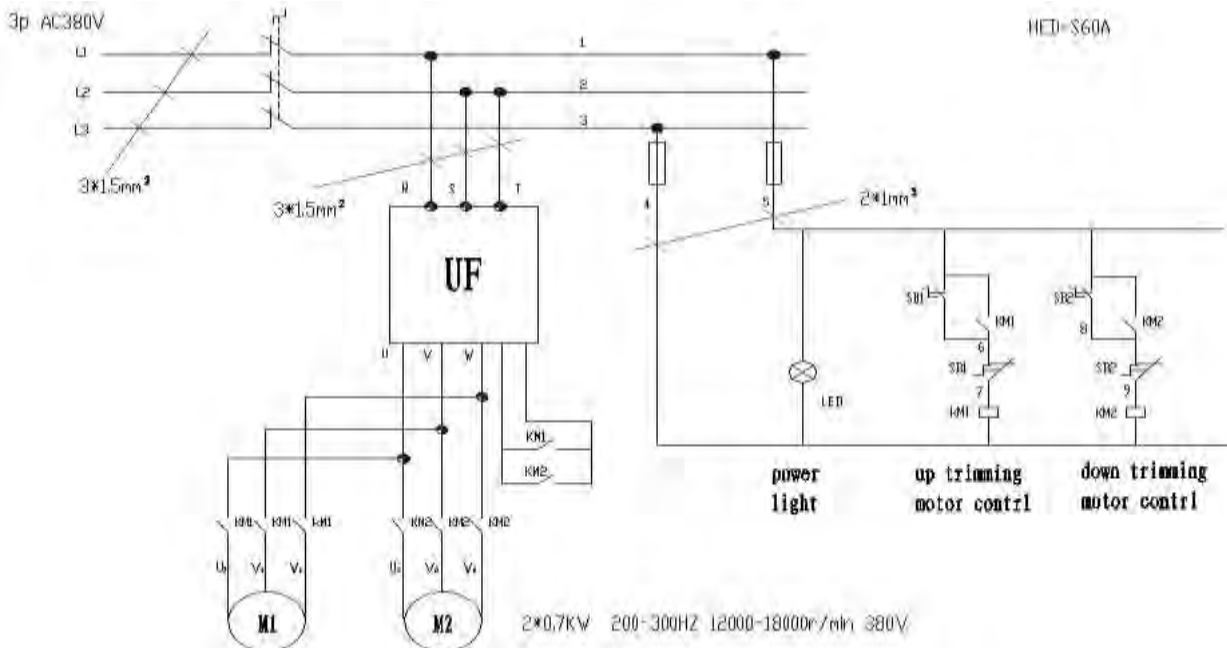
6.1 Control panel

- 1、 Power switch
- 2、 Power indicator light
- 3、 Down motor switch
- 4、 Up motor switch
- 5、 Speed adjusting table
- 6、 Stop switch



HED-S60A Control panel

6.2Electrical diagram



7.Maintenance

- 1.after working finish for each time,the machine need to be cleaned,but not use water.
- 2.the metal material such as glue part need to use alcohol clean, but not use other chemical or it will change shape and affect the function of machine.

Every part stick on the glue is forbidden to use hand things to scratch,avoidscathe the surface and affect the function of machine.

3. Up and down straight line bearings pole and hight adjust pole much regularly the clean behind add lubrication oil.at the general workload case,each week about 1 times.

8.Troubleshooting

No	Malfunctions	Solutions
1	Electric light not on,machine do notwork	a.check if the electric wire whether connected. b.stop whether loose. c.check if the control wire whether ruin.
2	Motor do not run	a.if the motor have voice,then the electric wire less one phease,connect it; b.check the motor whether load excessive ,cause plugging turn; c.other problem,find special worker.
3	At the trimming resistance excessive shake obviously.	a.check the knife edge whether than more glue? If is glue than more ,please clean glue; b.check the knife whether change blunt ,please grinding or changing tools at the blunt; c.check motor base ,motor fixed nuts whether loose.

9. Inverter Parameter setting way

At the stop state,long press “MODE”key about 3 seconds,(the numerical tube at the same times display “MODE”),when the numerical tube display “EAC” and at the numerical replace mutual flashing,said explain already enter into common parameters setting state.press the up key and down key change parameters,press “MODE” key enter into next ,(at the not need change times,direct press “MODE ” key enter into next parameters.)when the parameters setting finish,the numerical tube display “SAVE ”, prompt whether save this time change,press “MODE” key save exit.

9.1 Inverter Parameter setting

Symbols	Parameters
EAC	4
LDC	2.5
FFS	0
Fun	3
Fb	3.0
FH	200HZ
CE	6

When the display $\text{LO} = 72$ enter extended parameters.

9.2 The need setting expand parameters.

d026	250HZ
d041	5