

GLOBAL

Skiving machine

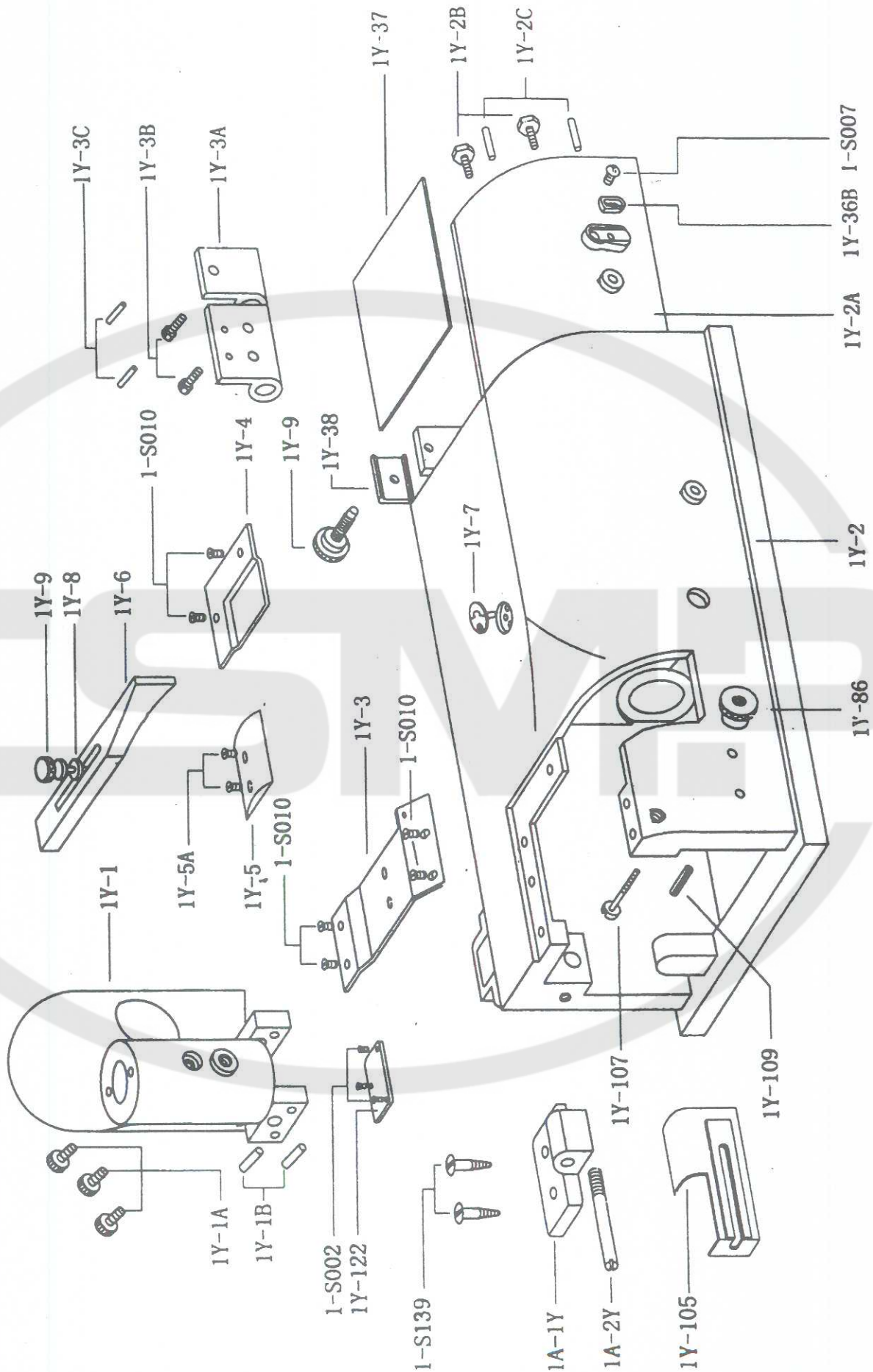
SK 111

CSMP

Parts catalogue

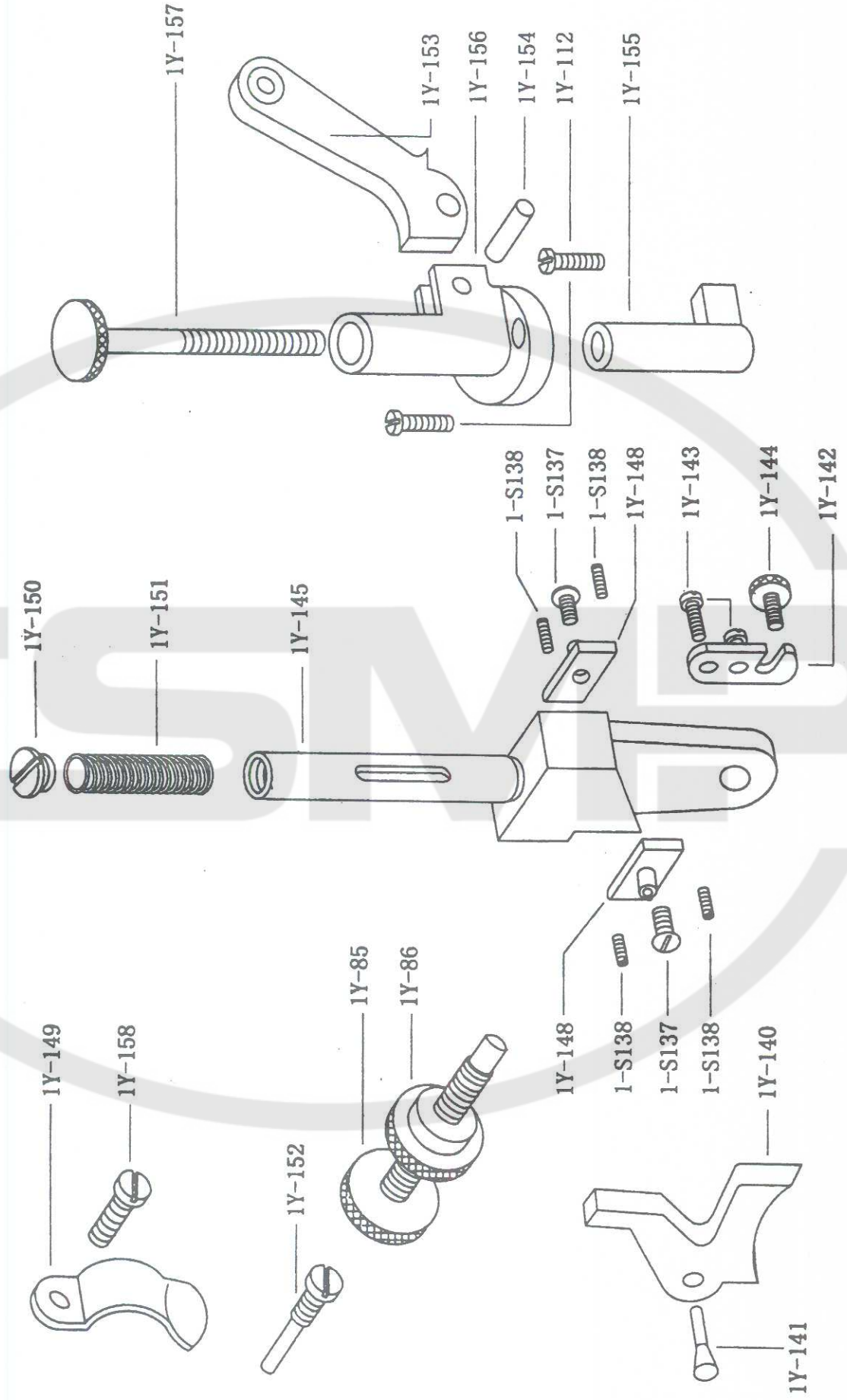
1.

ARM BED AND ITS ACCESSORIES



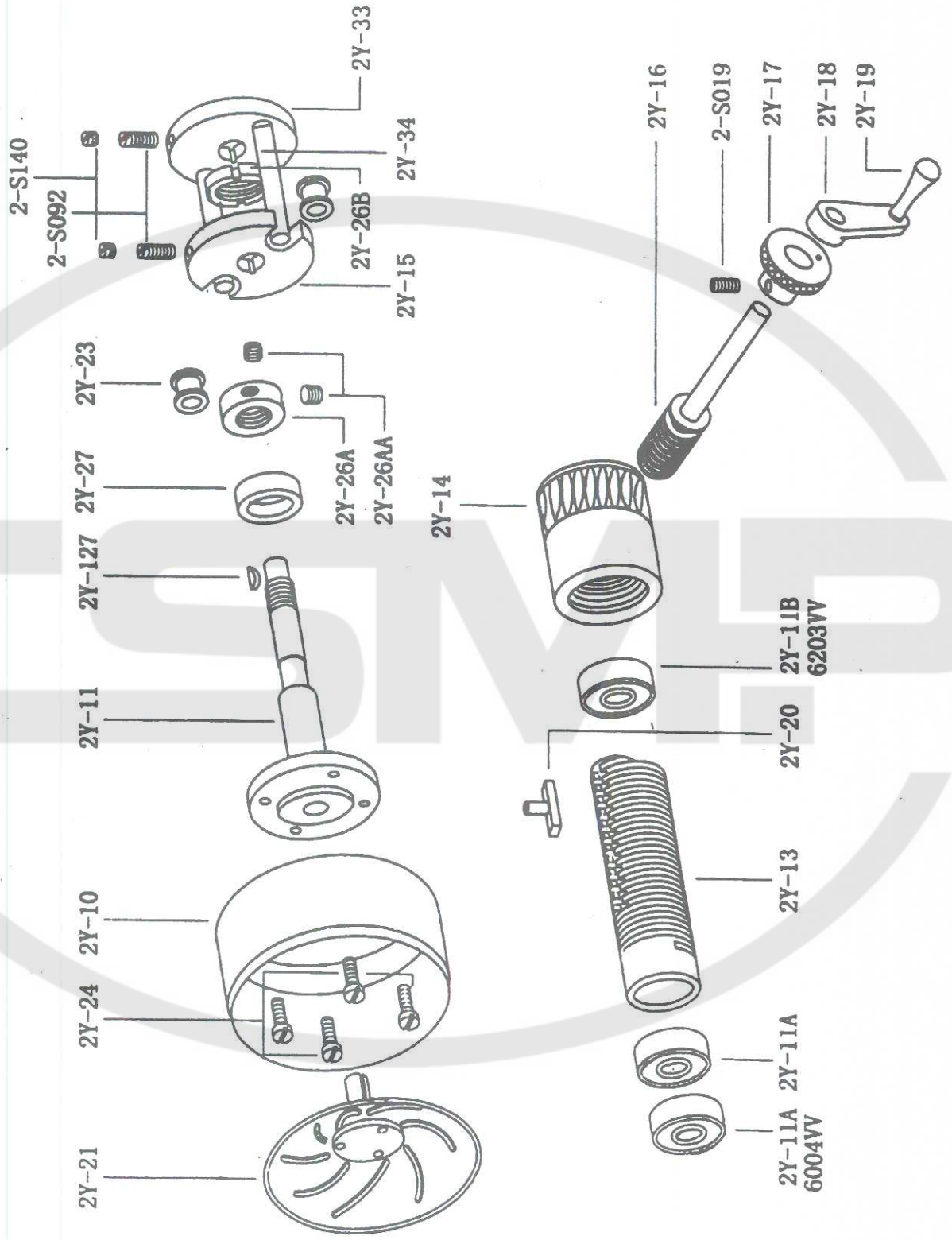
2. B.

PRESSER FOOT MECHANISM



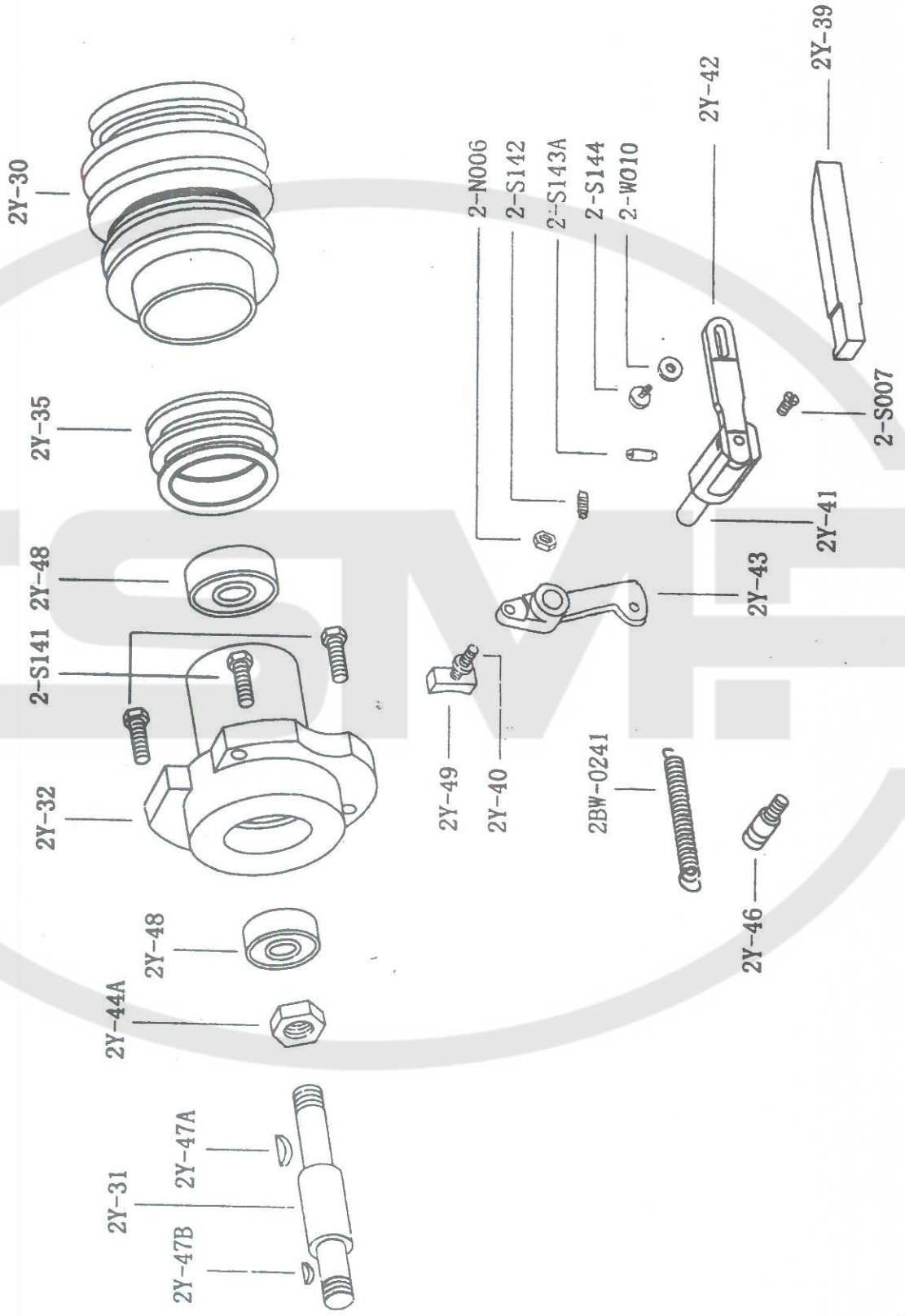
3. C.

KNIFE SHAFT MECHANISM



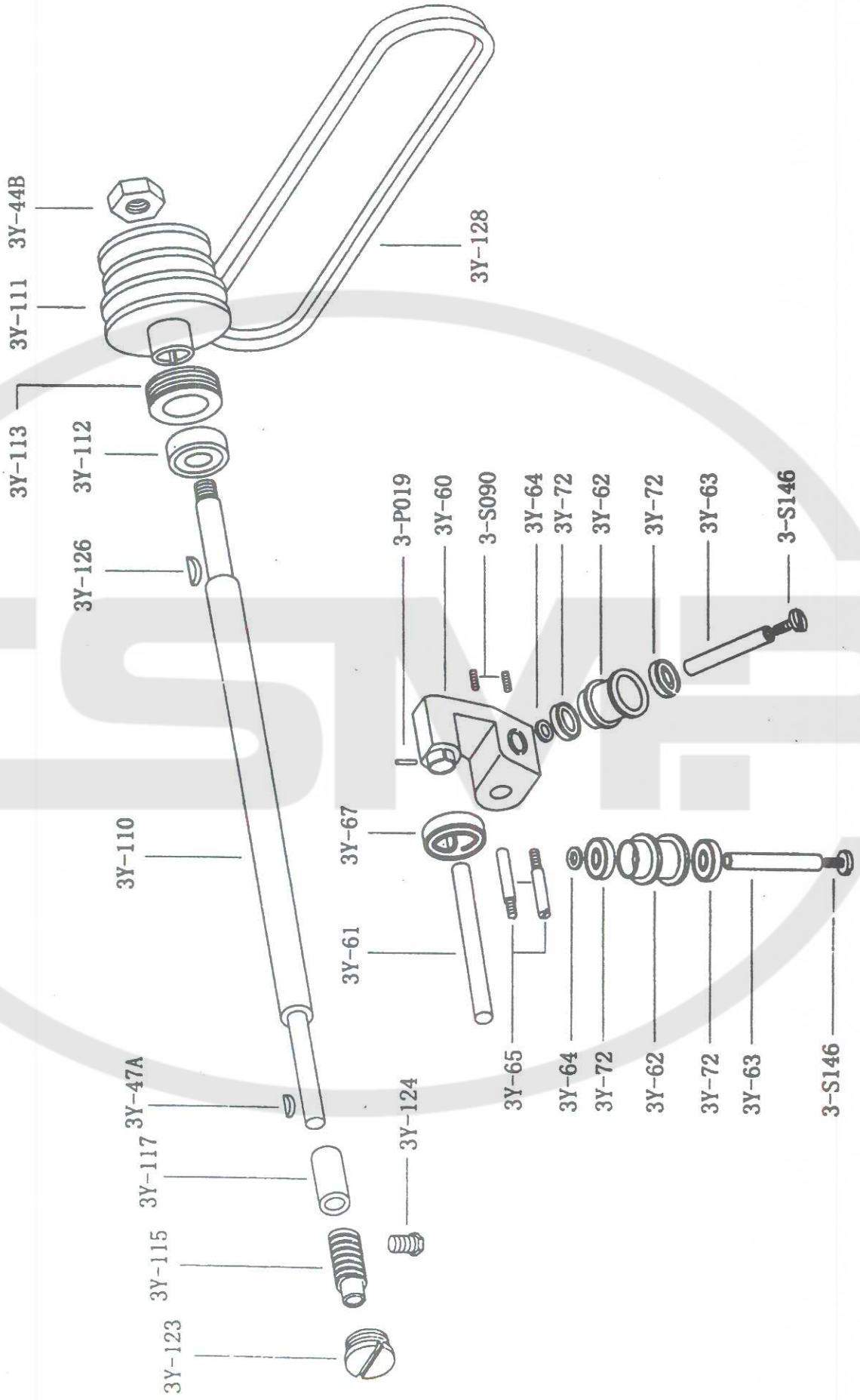
4. C.

KNIFE SHAFT MECHANISM



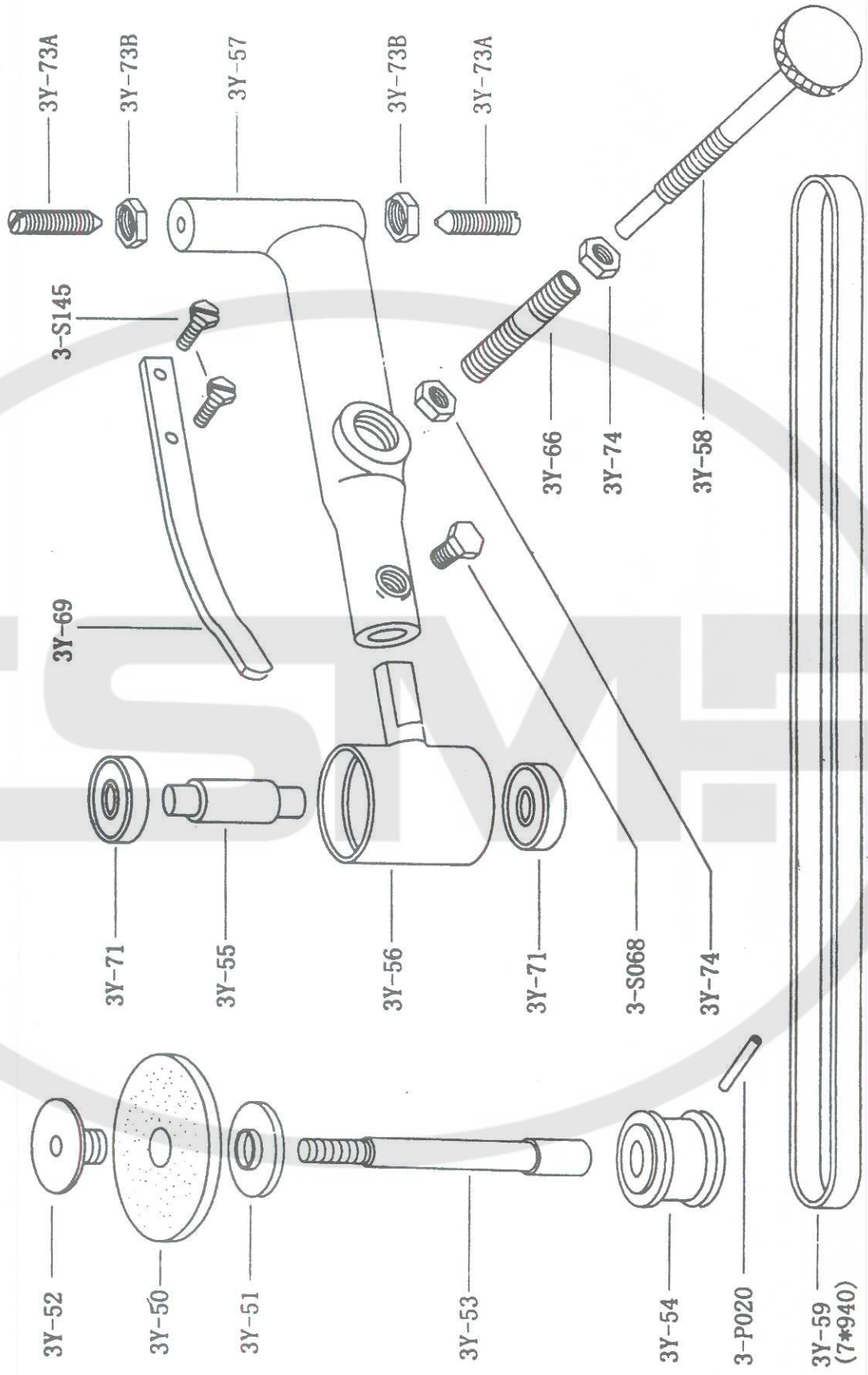
5. D.

FEEDING MECHANISM AND KNIFE GRINDING MECHANISM



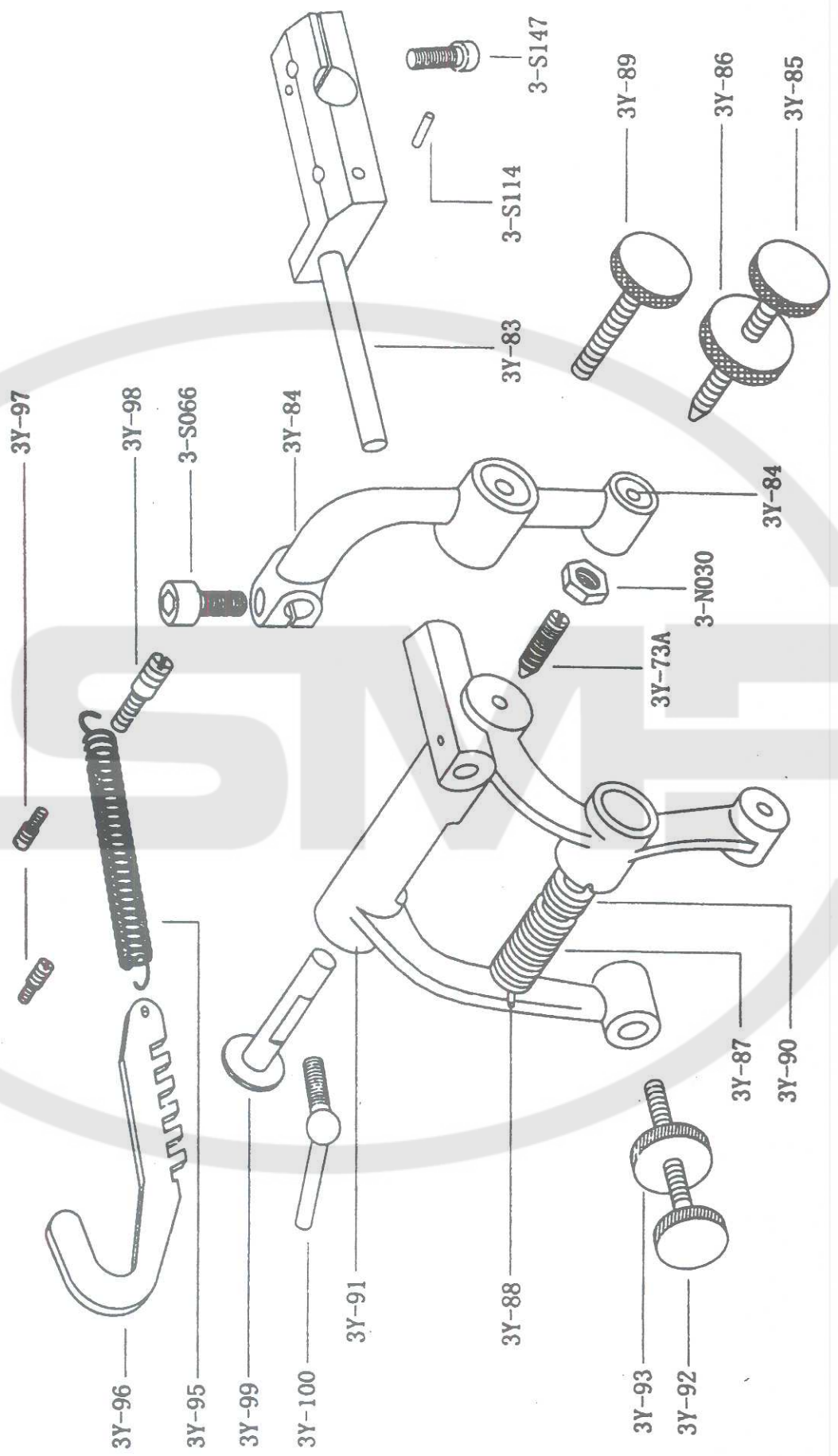
6. E.

KNIFE GRINDING MECHANISM



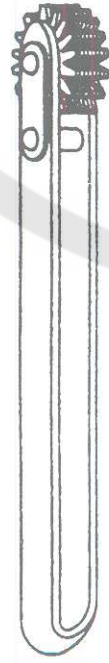
8. G.

FEED REGULATING MECHANISM

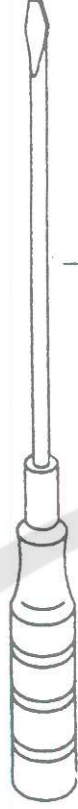


9. I.

ACCESSORIES



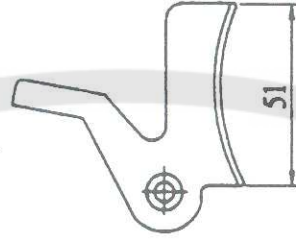
4A-3Y



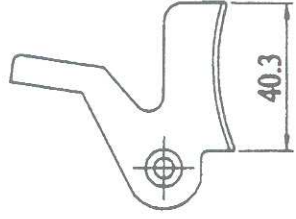
4A-6B



4A-4Y



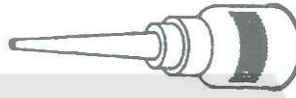
1Y-140



40.3
4A-140B



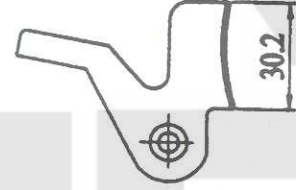
4A-5Y



4A-4B



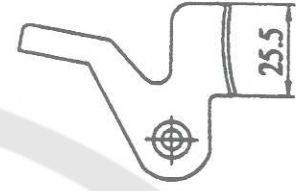
4A-6Y



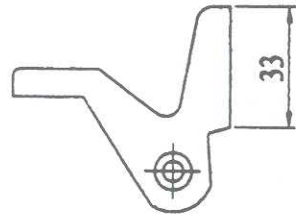
30.2
4A-140C



4A-7Y



25.5
4A-140D



33
4A-140E

LEATHER SKIVING MACHINE



INSTRUCTION
MANUAL & PARTS LIST

General Description and Instruction

I. Application

This machine is a special equipment for making of leather goods. It is widely used for the shaping of slope edge and the even shiving of various Parts for leather material and PU material goods such as leather shoes, Gloves, bags, wallet, belt, macket 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 criving.

5. With automatic of spare parts.

6. Easy replacement cleaning.

III. Main specifications

1. Motor: 370-550W, 1400rpm

2. Knife size: $\Phi 118 \times \Phi 114 \times 52$ (mm)

3. Knife speed: 1270rpm

4. Knife axial displacement: 30mm

5. Feed wheel speed: 62, 99, 132rpm

6. Feeding speed: 9247, 14766, 19688 mm/min

7. Skiving width: 10-50mm

8. Abrasive wheel size: $\Phi 70 \times \Phi 16 \times 8$ (mm)

9. Noise level: <60dB(A)

10. Weight: 40kg

IV. Instllation and adjustment

1. Installation

When its 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 trialoperated 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(1-16)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(1-31)

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 (3 - 64&3 - 67) . When equal or different clearance along the knife edge is required,please turn the handle(3 - 67).Turning the handle(3 - 64)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(3 - 36)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(2-1)by accessory(4-4) , 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.

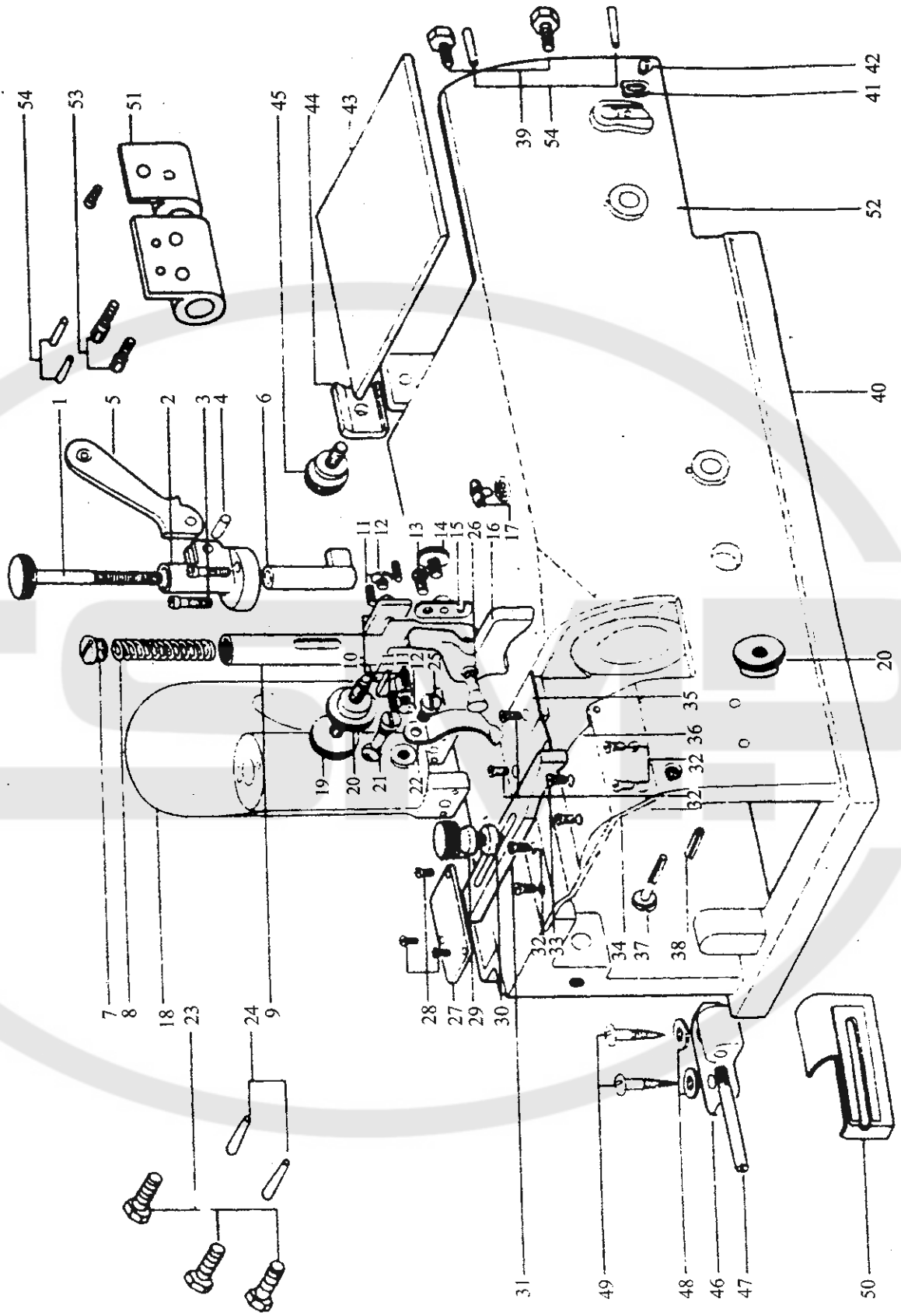
2.Periodically feed oil on the moving parts.

3.sharpen the knife when it is blunt.

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

5.keep the machine clean.

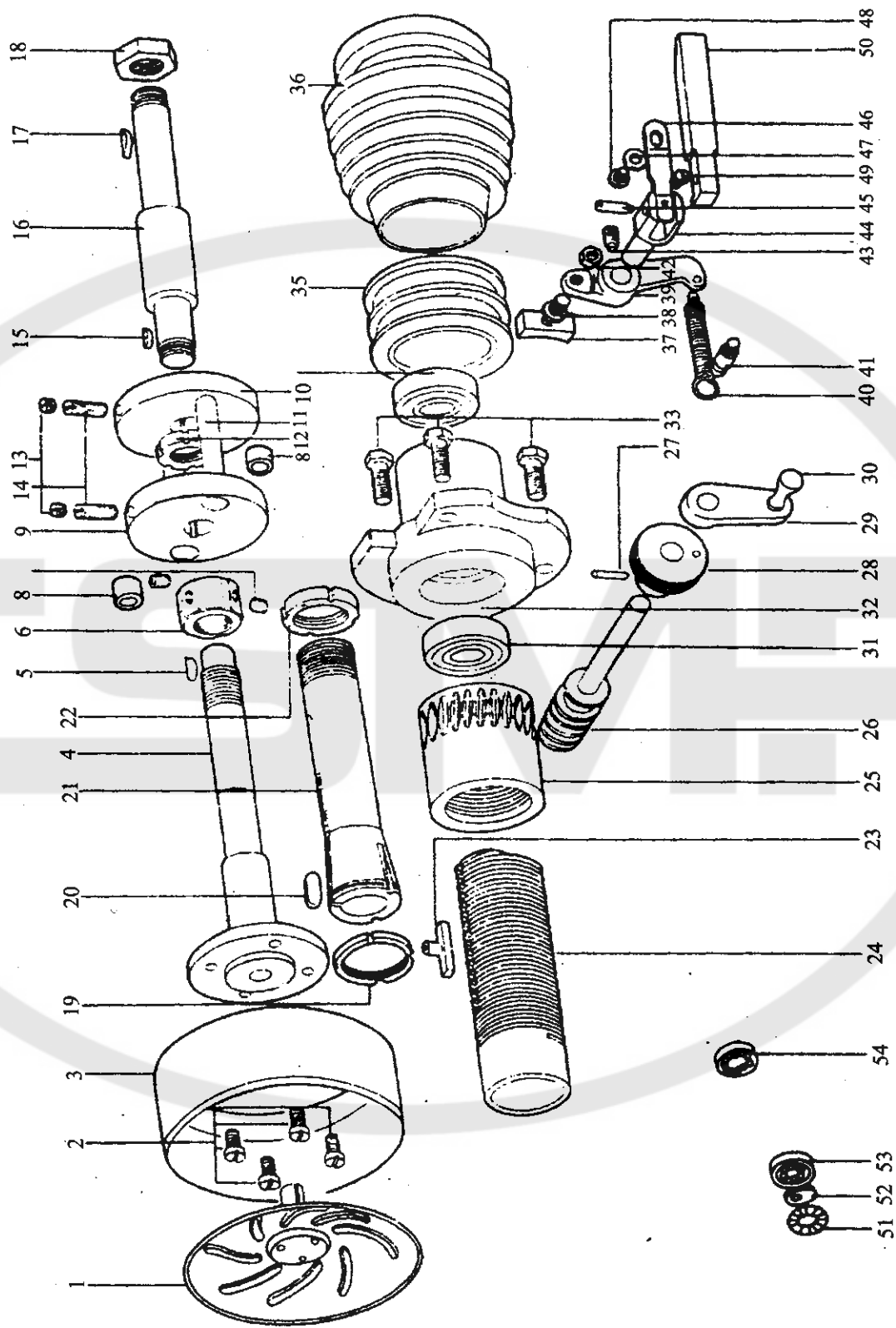
1. PRESSER FOOT AND OUTER ATTACHMENTS



| Item | Part No. | Description | Quan | Romar |
|------|-------------------------------|---|------|-------|
| 1.1 | 1157 | Presser bar adjusting screw | 1 | |
| 1.2 | 1156 | Presser bar lifter bracket | 2 | 9223 |
| 1.3 | 3/16" × 28 × 15 ^o | Presser bar lifter bracket screw | 2 | 9223 |
| 1.4 | 5 × 16 ^o | Presser bar lifter pin | 1 | |
| 1.5 | 1153 | Presser bar lifter | 1 | |
| 1.6 | 1155 | Presser bar lifter lever | 1 | |
| 1.7 | 1150 | Presser bar cover screw | 1 | |
| 1.8 | 1151 | Presser bar spring | 1 | |
| 1.9 | 1145 | Presser bar | 1 | |
| 1.10 | 1148 | Presser foot side plates | 2 | |
| 1.11 | 9 × 64" × 10 ^o | Presser foot side plates adjusting screws | 4 | |
| 1.12 | 3/16" × 28 × 6 ^o | Presser foot side plates screws | 1 | |
| 1.13 | 3/16" × 28 × 10 ^o | Presser foot shaft hook metal hinge screw | 1 | |
| 1.14 | 1144 | presser foot shaft hook metal set screw | 1 | |
| 1.15 | 1142 | presser foot shaft hook metal | 1 | |
| 1.16 | 1140 | Presser foot 50mm | 1 | |
| 1.17 | 1007 | Oil cup | 1 | |
| 1.18 | 1001 | Arm | 1 | |
| 1.19 | 1085 | Presser foot adjusting screw | 1 | 3.67 |
| 1.20 | 1086 | Presser foot adjustabe screw nuts | 2 | 3.68 |
| 1.21 | 1152 | Presser bar spring pin | 1 | |
| 1.22 | 1140 | Presser foot spring | 1 | |
| 1.23 | 3/8" × 16 × 25 ^o | Inner hexagonal screw | 1 | |
| 1.24 | Φ6 × 25 ^o | Taper pin | 1 | |
| 1.25 | 3/16" × 32 × 10 ^o | Presser foot spring screw | 1 | |
| 1.26 | 1141 | Presser foot shaft | 1 | |
| 1.27 | 1122 | Worm shamber plate | 1 | |
| 1.28 | 9/64" × 40 × 7.5 ^o | Screws | 1 | |
| 1.29 | 1009 | Ruler set screw | 1 | |
| 1.30 | 1008 | Ruler set screw washer | 1 | |
| 1.31 | 1006 | Ruler | 1 | |
| 1.32 | 11/64" × 40 × 9 ^o | Slide plate screws | 6 | |
| 1.33 | 11/64" × 40 × 7 ^o | Slide plate screws | 2 | |
| 1.34 | 1003 | Slide plate A | 1 | |
| 1.35 | 1004 | Slide plate B | 1 | |
| 1.36 | 1005 | Slide plate C | 1 | |
| 1.37 | 15/64" × 28 ^o | Waster feeder screw | 1 | |
| 1.38 | 6 × 25.4 ^o | Waster feeder stop pin | 1 | |
| 1.39 | 5/16" × 24 × 21 ^o | Hexagon slotted screw (Base plate) | 2 | |
| 1.40 | 1002 | Bed | 1 | 233 |
| 1.41 | 1036 | Belt cover plate | 1 | |
| 1.42 | 9/64" × 40 × 6 | Belt cover plate screw | 1 | |
| 1.43 | 1037 | Belt cover lid | 1 | |
| 1.44 | 1038 | Belt cover lid stopper | 1 | |
| 1.45 | 1009 | Ruler set screw | 1 | 1.29 |
| 1.46 | 2001 | Hinges | 2 | |
| 1.47 | 2002 | Hinge pins | 2 | |
| 1.48 | 18 × 6.3 × 1.6 | Hinge set screw washers | 4 | |
| 1.49 | 6 × 30 | Hinge set screws | 4 | |
| 1.50 | 1105 | Waste feeder metals(SET) | 1 | |

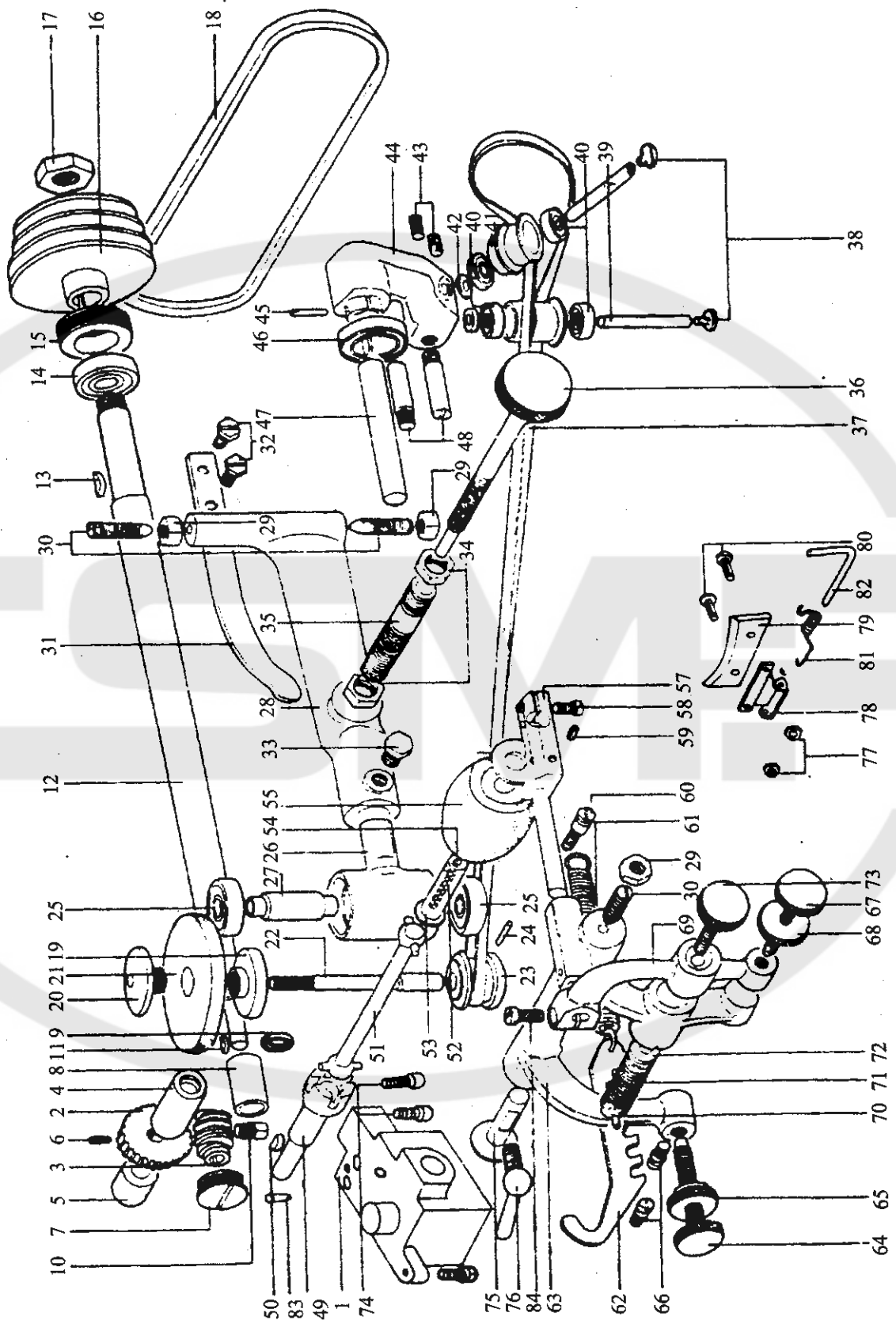
| Item | Part No. | Description | Quan | Romar |
|------|-----------------------------|--------------------------------|------|-------|
| 1.51 | 2003 | Fransmission shelf | 1 | |
| 1.52 | 2004 | Basic plate | 1 | 3.47 |
| 1.53 | 1/4" × 20 × 20 ^o | Set screw (Transmiasion shaft) | 2 | |
| 1.54 | Φ4 × 22 ^o | Tape pin | 4 | 3.83 |

2. KNIFE AND RELATED PARTS



| Item | Part No. | Description | Quan | Romar |
|------|------------------------------|---------------------------------|------|-------|
| 2.1 | 1021 | leather peeled cover | 1 | |
| 2.2 | M6 p1.0 × 10 ^p | Knife set screws | 4 | |
| 2.3 | 1010 | Knife | 1 | |
| 2.4 | 1011 | Knife shaft | 1 | |
| 2.5 | 3 × 13 | Knife shaft key | 1 | |
| 2.6 | Φ28 × M16 × 7 × P1.5 | Knife shaft nuts | 2 | |
| 2.8 | 1023 | Rubber bushings | 2 | |
| 2.9 | 1015 | Puller shaft flange holder | 1 | |
| 2.10 | 1033 | Pulley shaft flange | 1 | |
| 2.11 | 1034 | Flange shafts | 2 | |
| 2.12 | Φ28 × M18 × 7 × P1.5 | Pulley shaft flange nut | 1 | |
| 2.13 | 9/32" × 28 × 4.5 | Pulley shaft flange screws(B) | 2 | |
| 2.14 | 9/32" × 28 × 18 | Pulley shaft flange screws(A) | 2 | |
| 2.15 | 3 × 10 | Pulley shaft key(small) | 1 | |
| 2.16 | 1031 | Pulley shaft | 1 | |
| 2.17 | 3 × 16 | Pulley shaft key | 1 | |
| 2.18 | M16p × P1.5 | Hexagonal nut(A) | 1 | |
| 2.23 | 1020 | Knife shaft lead pipe key | 1 | |
| 2.24 | 1013 | knife shaft lead pipe | 1 | |
| 2.25 | 1014 | Knife shaft worm wheel | 1 | |
| 2.26 | 1016 | Knife shaft worm | 1 | |
| 2.27 | 3 × 18 ^p | Taper pin | 1 | |
| 2.28 | 1017 | Knife adjusting knob | 1 | |
| 2.29 | 1018 | Knife adjusting handle | 1 | |
| 2.30 | 1020 | Knife adjusting handle Knob | 1 | |
| 2.31 | 6203Z | pulley shaft bearings | 1 | |
| 2.32 | 6023Z | Pulley shaft metal | 1 | |
| 2.33 | 5/16" × 24 × 21 ^p | pulley shaft metal screws | 3 | 1.39 |
| 2.34 | | Pulley shaft bearing | 1 | |
| 2.35 | 1035 | Clutch | 1 | |
| 2.36 | 1030 | Pulley | 1 | |
| 2.37 | 1049 | Clutch slide block | 1 | |
| 2.38 | 1040 | Clutch slide block screw | 1 | |
| 2.39 | 1043 | Clutch arm | 1 | |
| 2.40 | 1024 | Clutch spring | 1 | |
| 2.41 | 1046 | Clutch spring hook | 1 | |
| 2.42 | 1/4" × 40 | Clutch slide block screw nut | 1 | |
| 2.43 | 15/64" × 28 × 8 ^p | Clutch lever screw | 1 | |
| 2.44 | 1041 | Clutch lever shaft | 1 | |
| 2.45 | 1160 | Clutch arm screw | 1 | |
| 2.46 | 1042 | Clutch lever spring | 1 | |
| 2.47 | | Clutch lever spring washer | 1 | |
| 2.48 | 9/64" × 40 × 6 ^p | Clutch lever spring hinge screw | 1 | |
| 2.49 | 9/64" × 40 × 6 ^p | Clutch lever spring screw | 1 | |
| 2.50 | 1039 | Clutch lever | 1 | |
| 2.51 | NTB2035 | Trust bearing | 1 | |
| 2.52 | 20 × 35 × 1 | Flat gasket | 1 | |
| 2.53 | 6004 ZZ | Bearing | 1 | |
| 2.54 | 6023 ZZ | Bearing | 1 | 2.31 |

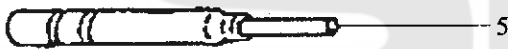
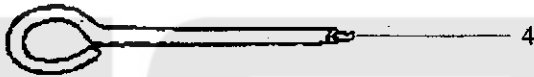
3. GRINDSTONE AND ROLLER RELATED PARTS



| Item | Part No. | Description | Quan | Romar |
|------|-------------------|---|------|-------|
| 3.1 | | Worm wheel box | 1 | |
| 3.2 | 1116 | Main shaft worm gear Wheel | 1 | |
| 3.3 | 1115 | Main shaft worm gear | 1 | |
| 3.4 | 1119 | Roller driving shaft Metal | 1 | |
| 3.5 | 1120 | Roller driving shaft metal(2) | 1 | |
| 3.6 | 9/64" x 40 x 90° | Main shaft worm gear Wheel screw | 1 | |
| 3.7 | 1123 | Main shaft worm gear Chamber cover screw | 1 | |
| 3.8 | | Main shaft front bushing | 1 | |
| 3.9 | 121803 | Main shaft worm gear chamber oil seal | 1 | |
| 3.10 | 1124 | Main shaft worm gear Chamber screw | 1 | |
| 3.11 | 2.5 x 10 | main shaft key(1) | 1 | |
| 3.12 | 1110 | main shaft | 1 | |
| 3.13 | 3 x 16 | Main shaft key(2) | 1 | |
| 3.14 | 6002 ZZ | main shaft bearing | 1 | |
| 3.15 | M63 x 10 x P1.5 | Main shaft bearing holder screw | 1 | |
| 3.16 | 1111 | Main shaft pulley | 1 | |
| 3.17 | M14 x P1.5 | Hexagonal nut B | 1 | |
| 3.18 | 3 starK20 | Main shaft belt | 1 | |
| 3.19 | 1051 | Grindstone set screw | 1 | |
| 3.20 | 1052 | Grindstone set screw nut | 1 | |
| 3.21 | 1050 | Grindstone | 1 | |
| 3.22 | 1053 | Grindstone shaft | 1 | |
| 3.23 | | Grindstone shaft pulley | 1 | |
| 3.24 | 2.5 x 20 | Grindstone shaft pulley taper pin | 1 | |
| 3.25 | 6200 Z | Grindstone shaft bearing | 1 | |
| 3.26 | 1056 | Grindstone shaft bracket | 1 | |
| 3.27 | 1055 | Grindstone shaft bearing roller | 2 | |
| 3.28 | 1057 | Grindstone shaft bracket arm | 1 | |
| 3.29 | 5/16" x 24 | Grindstone shaft bracket arm center screw nuts | 1 | |
| 3.30 | 1731 | Grindstone shaft bracket arm center screws | 3 | |
| 3.31 | 1069 | Grindstone shaft bracket arm spring | 1 | |
| 3.32 | 15/64" x 24 x 14° | Grindstone shaft bracket arm spring screws | 2 | |
| 3.33 | 5/16" x 24 x 14° | Grindstone shaft bracket screw | 1 | |
| 3.34 | 1/2" x 28 | Grindstone adjusting screw pipe nuts | 2 | |
| 3.35 | 1066 | Grindstone adjusting screw pipe | 1 | |
| 3.36 | 1058 | Grindstone adjusting screw | 1 | |
| 3.37 | 1059 | Grindstone shaft belt | 1 | |
| 3.38 | | Belt guide pulley screws | 1 | |
| 3.39 | 1063 | Belt guide pulley shaft | 2 | |
| 3.40 | 626 Z | Belt guide pulley bearings | 4 | |
| 3.41 | 1062 | Belt guide pulley | 2 | |
| 3.42 | 1064 | Belt guide pulley washers | 2 | |

| Item | Part No. | Description | Quan | Romar |
|------|--------------------|--|------|-------|
| 3.43 | 15/64" x 28 x 8° | Belt guide pulley shaft screws | 2 | |
| 3.44 | 1060 | Belt guide bracket | 1 | |
| 3.45 | 3 x 18 | Belt guide bracket taper pin | 1 | 2.27 |
| 3.46 | 1067 | Belt guide bracket spring | 1 | |
| 3.47 | 1061 | Belt guide bracket shaft | 1 | |
| 3.48 | 1065 | Belt guide bracket turing stoppers | 2 | |
| 3.49 | 1118 | Roller driving shaft | 1 | |
| 3.50 | 3 x 13 | Roller driving shaft key | 1 | |
| 3.51 | 1121 | Roller driving shaft joint | 1 | |
| 3.52 | 1094 | Roller shaft oil wick | 1 | |
| 3.53 | 1081 | Roller shaft | 1 | |
| 3.54 | | Roller shaft oil seal plug | 1 | |
| 3.55 | 1080 | Roller | 1 | |
| 3.56 | 1082 | Roller washer | 1 | |
| 3.57 | 1083 | Roller bracket | 1 | |
| 3.58 | 15/64" x 28 x 10° | Roller shaft screw | 1 | |
| 3.59 | 11/64" x 40 x 3.5° | screw | 1 | |
| 3.60 | 1098 | Waste clear metal shaft screw spring hooks(2) | 1 | |
| 3.61 | 1095 | Roller bracket arm spring | 1 | |
| 3.62 | 1096 | Roller bracket arm spring hook metal | 1 | |
| 3.63 | 1091 | Roller bracket arm | 1 | |
| 3.64 | 1092 | Roller bracket arm adjusting screw | 1 | |
| 3.65 | 1093 | Roller bracket arm adjusting screw nut | 1 | |
| 3.66 | 1097 | Roller bracket arm spring hooks(1) | 2 | |
| 3.67 | 1085 | Roller bracket turning arm adjusting screw | 1 | |
| 3.68 | 1086 | Roller bracket turning arm adjusting screw nut | 1 | |
| 3.69 | 1084 | Roller bracket turning arm | 1 | |
| 3.70 | 1088 | Roller bracket turning arm spring stopper | 1 | |
| 3.71 | 1087 | Roller bracket turning arm spring | 1 | |
| 3.72 | 1090 | Roller bracket turning arm spring nut | 1 | |
| 3.73 | 1089 | Roller bracket turning arm spring adjusting screw | 1 | |
| 3.74 | 1/4 x 20 x 20° | Set screw | 3 | 1.53 |
| 3.75 | 1099 | Roller bracket arm center pin | 1 | |
| 3.76 | 1100 | Roller bracket arm center pin screw | 1 | |
| 3.77 | 9/64" x 10 | Waste clear metal leather nuts | 2 | |
| 3.78 | 1104 | Waste clear metal | 1 | |
| 3.79 | 1104 | Waste clear metal leather | 1 | |
| 3.80 | 9/64" x 10 | Waste clear metal leather screws | 2 | |
| 3.81 | 1103 | Waste clear metal spring | 1 | |
| 3.82 | 1102 | Waste clear metal shaft | 1 | 1.54 |
| 3.83 | Φ4 x 22° | Taper pin | 1 | |
| 3.84 | | Roller shaft screws | 1 | |

4. ACCESSORIES



A 40m/m
B 30m/m
C 25m/m

| Item | Part No. | Description | Quan |
|-------------|---------------|---------------------------|------|
| 4.1 | 3001 | Grindstone dresser | 1 |
| 4.2 | 3002 | Grindstone nut spanner | 1 |
| 4.3 | 3004 | Knife shaft spanner | 1 |
| 4.4 | 3005 | Knife inter cover remover | 1 |
| 4.5 | 3006 | Bar type grindstone | 1 |
| 4.6 | 3007 | Screw driver large | 1 |
| 4.7 | 3008 | Oiler | |
| 4.16A | 1140A | Presser foot 50 mm | 1 |
| 4.16B | 1140B | Presser foot 30 mm | 1 |
| 4.16C | 1140C | Presser foot 25 mm | 1 |
| Accessories | | | |
| 1.47 | 2002 | Hinge pins | 2 |
| 1.46 | 2001 | Hinges | 2 |
| 1.48 | 15 × 6.3 × 1. | Hinge set screw washers | 2 |
| 1.49 | 6 × 30 | Hinge set screw | 4 |
| 2.29 | 1018 | Knife adjusting handle | 1 |
| 2.30 | 1019 | Adjusting handle | 1 |
| 4.5 | 3006 | Bar type grindstone | 1 |