



**Sewn Products Equipment Company**

**TSM 610A**

**Installation Manual**

**Ver 2.4, 2014**

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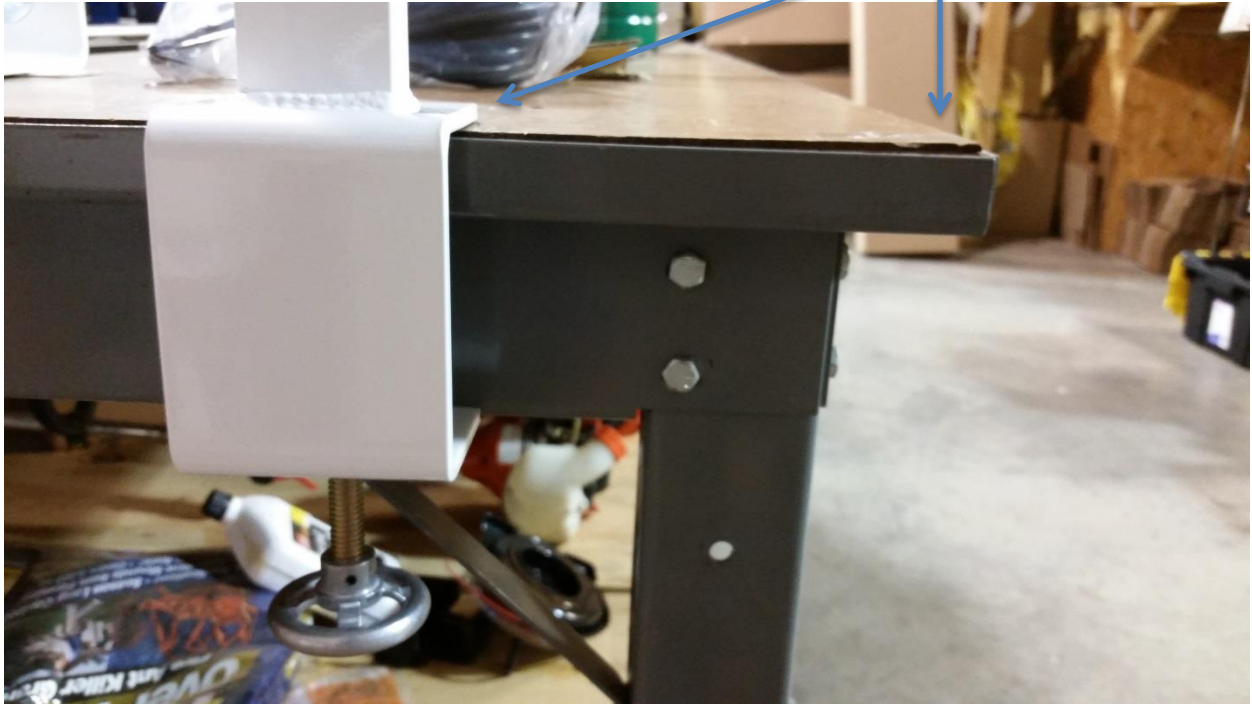
Step 1A:



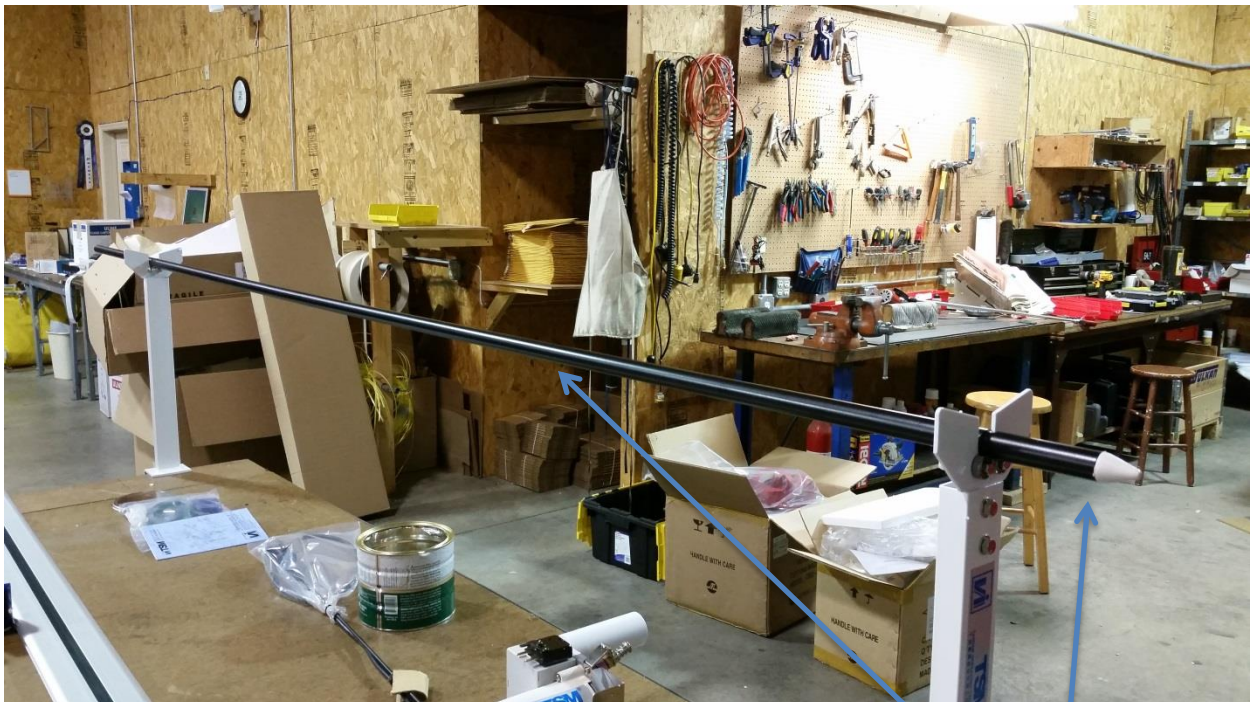
Sewn Products Equipment Company

Make sure that the posts on either side are equal distance from the end of the table

Step 1B:



Step 2:

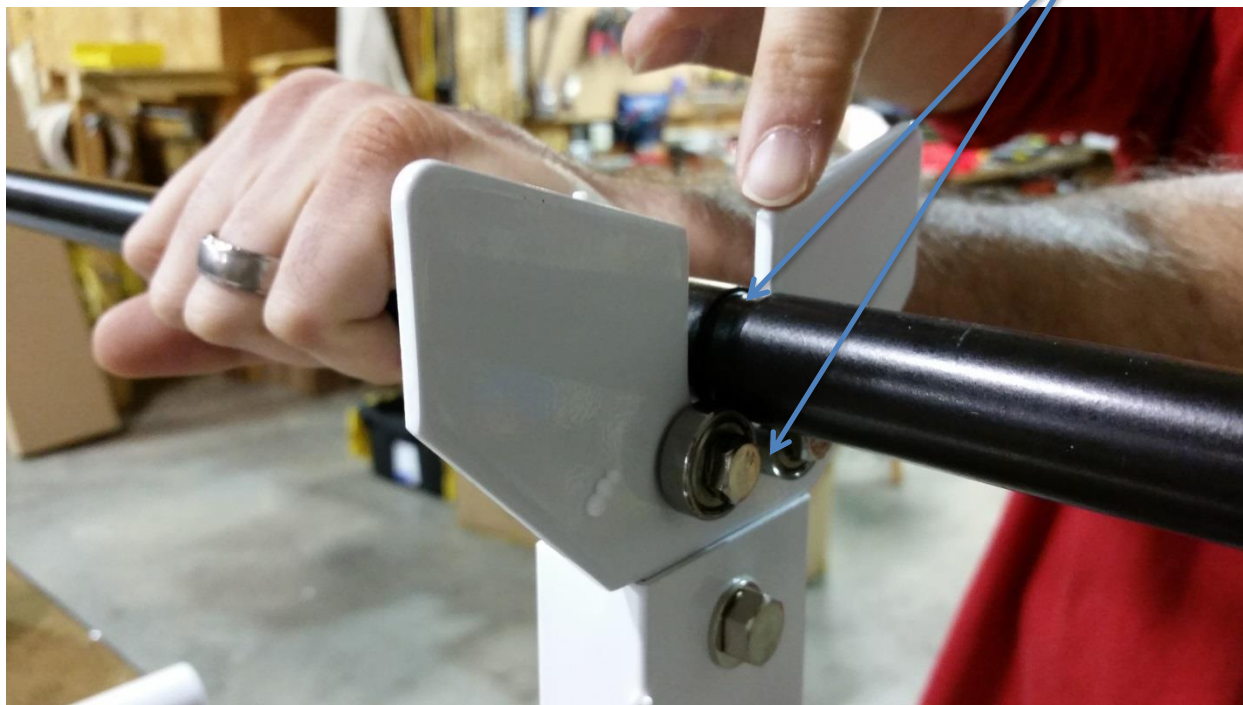


Put the roll rack on the two posts. Make sure that the cone end of the pole is on the operator side.



Align the groove with the top of the ball bearings on the operator side.

Step 2B:



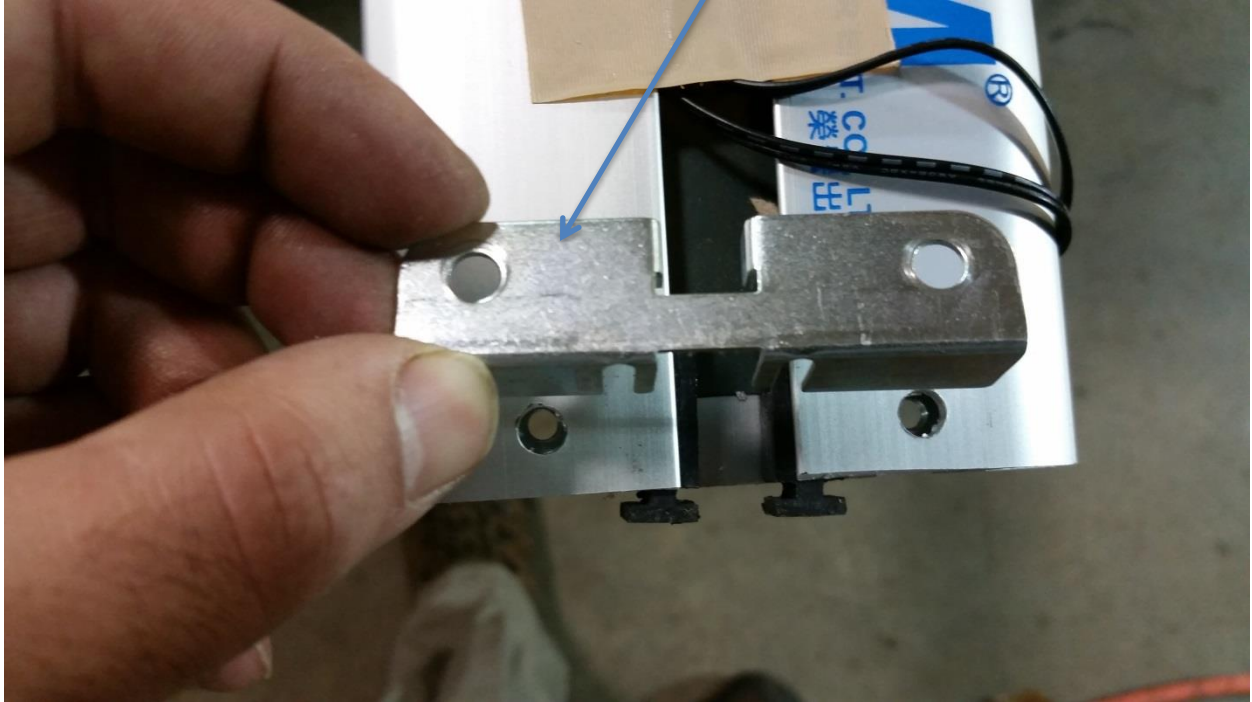
Step 3- 6 (taking off the guard/stoppers):



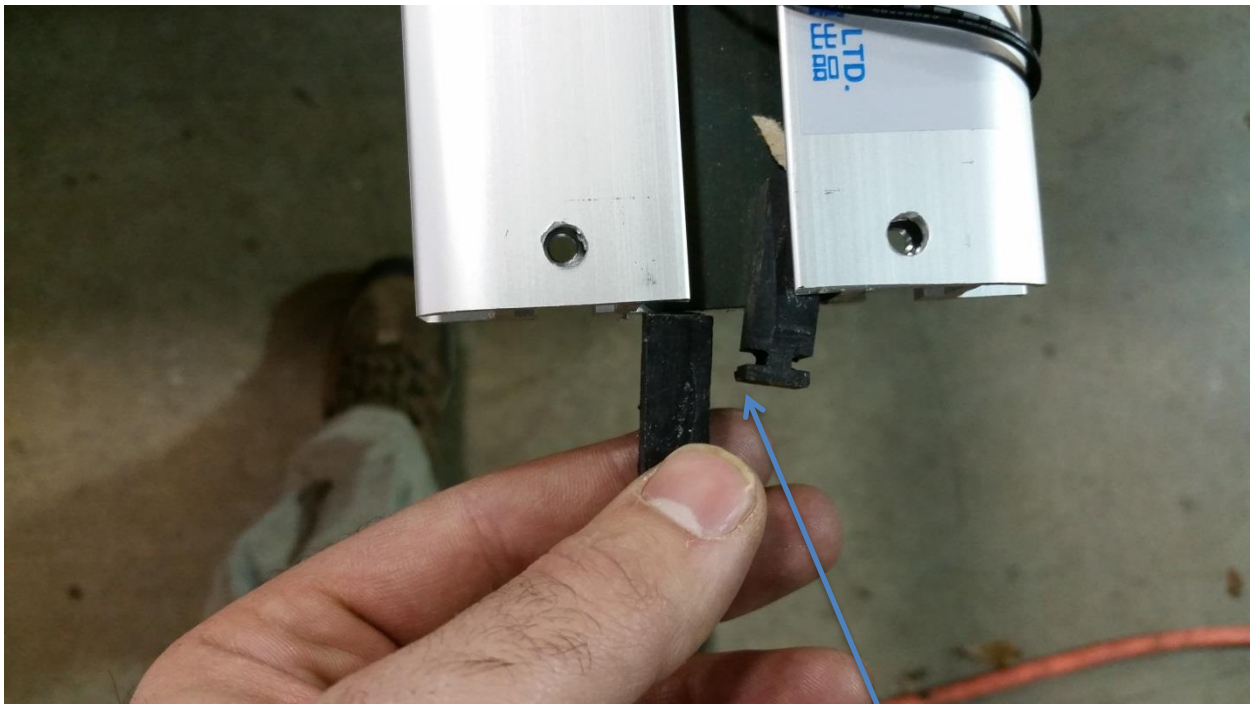
Unscrew the two screws that are holding in the guards/stoppers.

Take off guard/stopper

Step 3:



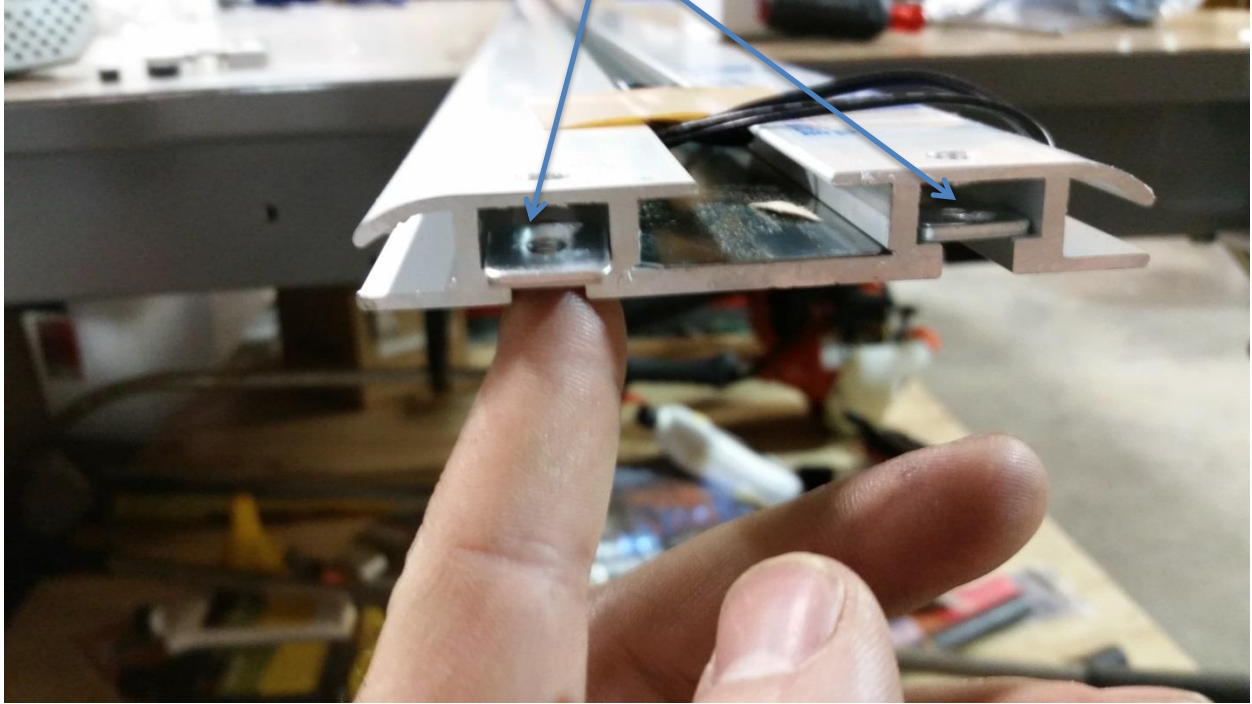
Step 4:



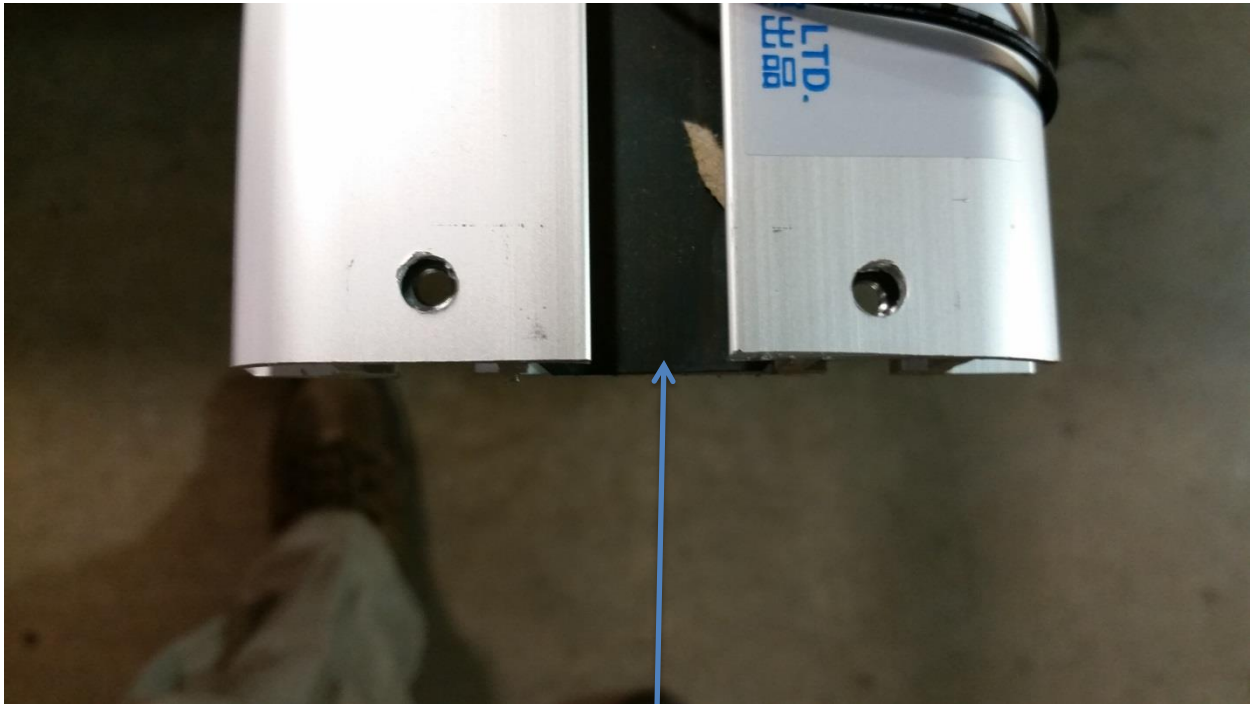
Take out rubber stoppers  
from track.

Step 5:

Take out square washer



Step 6:



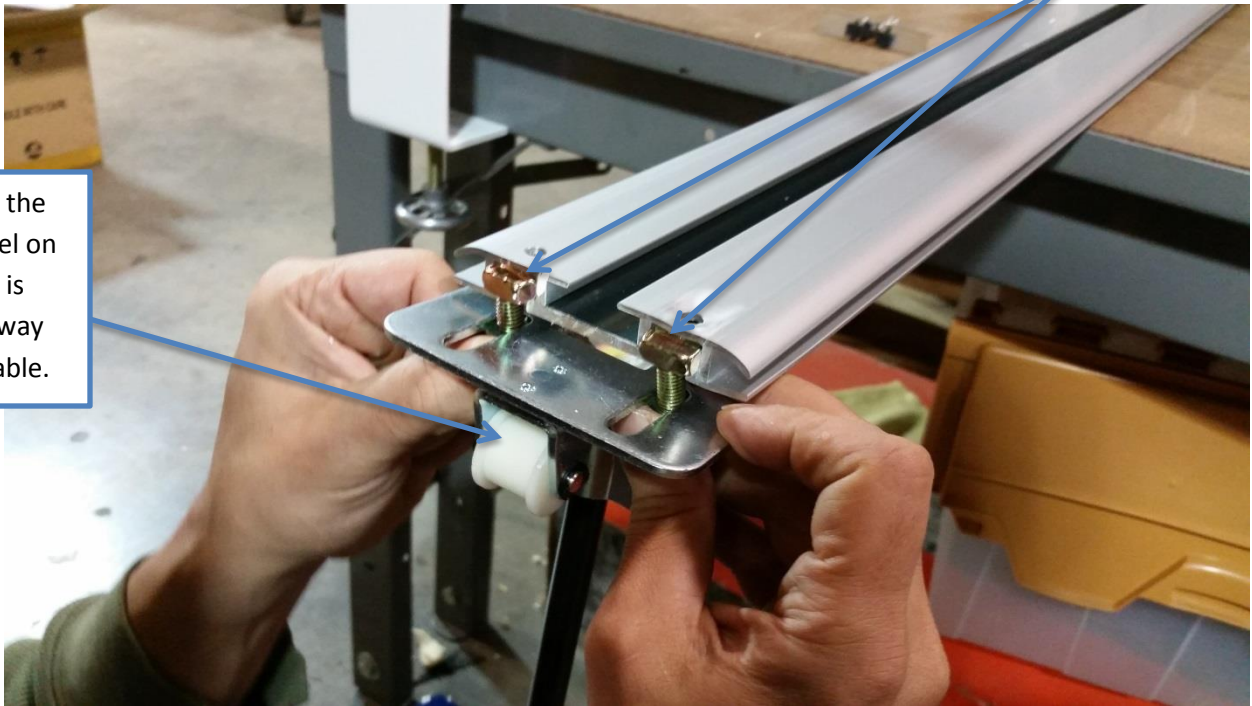
Taking off guard is complete  
and this is what it should  
look like on both sides



Guide and evenly push the bolts on the lifts inside the track where the square washers were for the guard/stopper.

Step 7A :

Make sure the plastic wheel on the lifter is pointing away from the table.



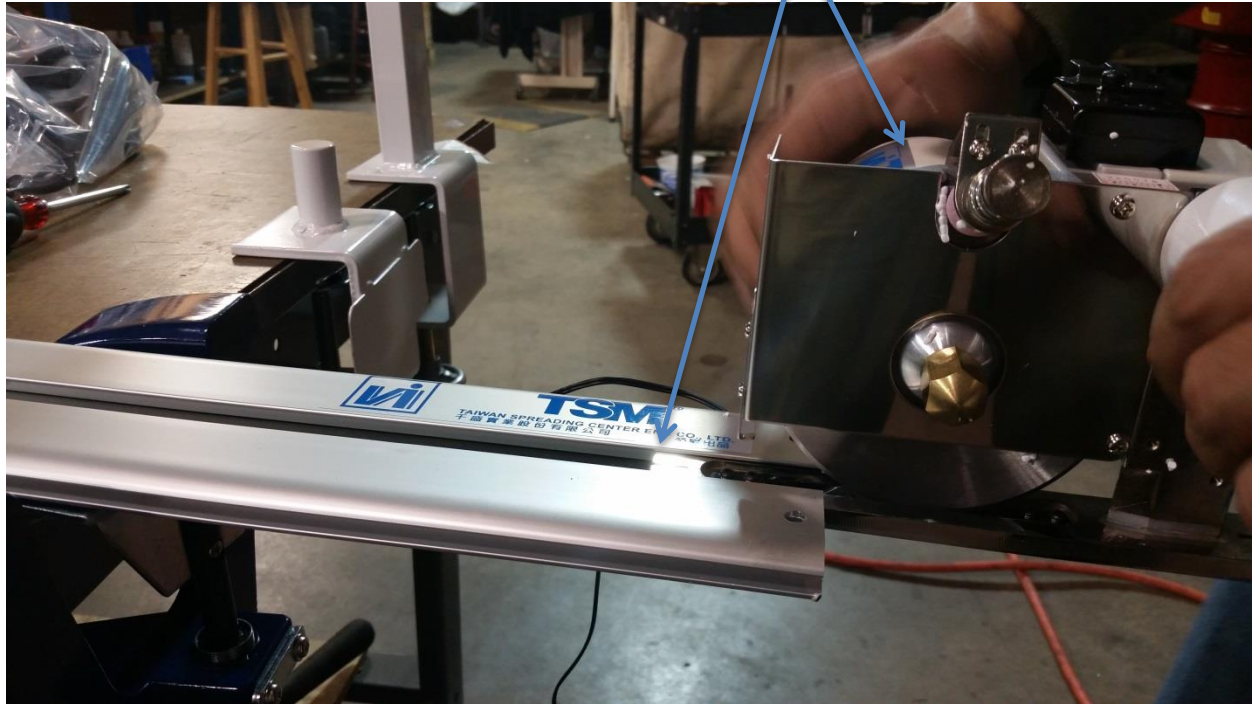
Step 7B:



Clamp down the track lifters to the table and tighten the lifter to the track by tightening the bolts that we guided into the track on Step 7A. **(Repeat Step 7A & 7B on the other side of the track/table)**

Place the cutting head on the track, facing away from the operator side.

Step 8:



Step 9:

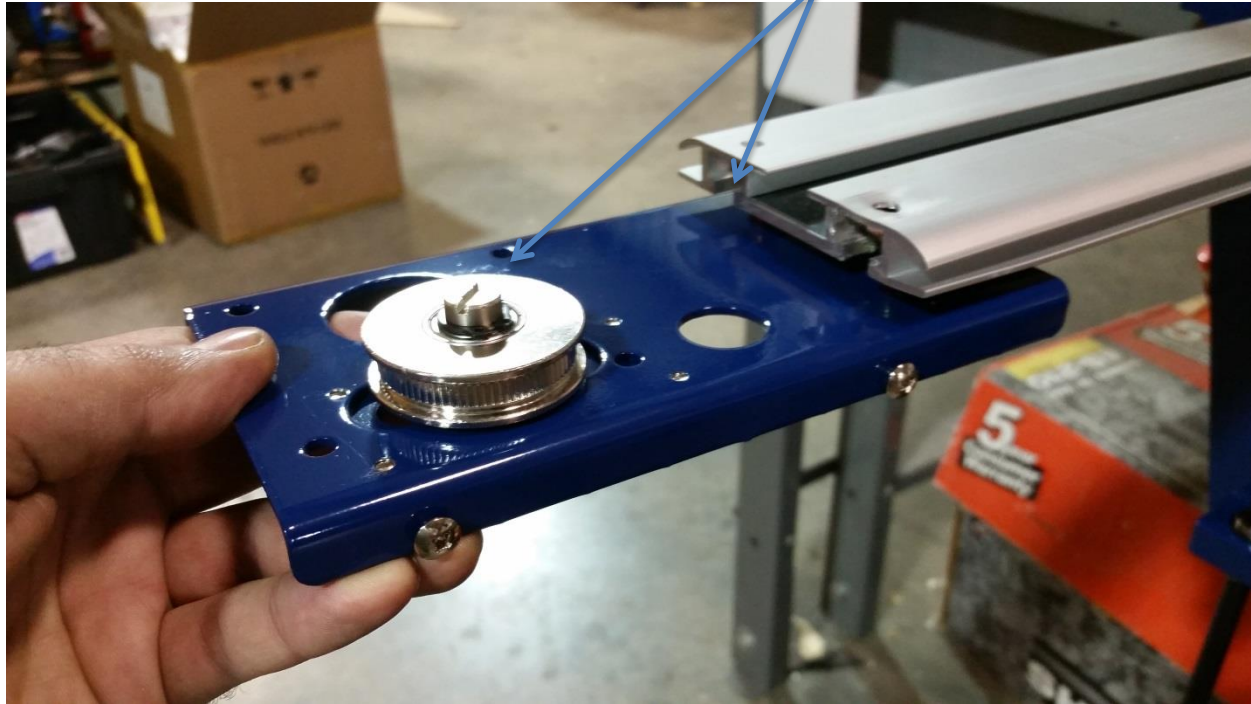


Take off cover and place the motorized end on the track like lifters (**refer to step 7A**).



On the other side of the table (non-operator side) place the other end piece into the track like **Step 9**.

Step 10:

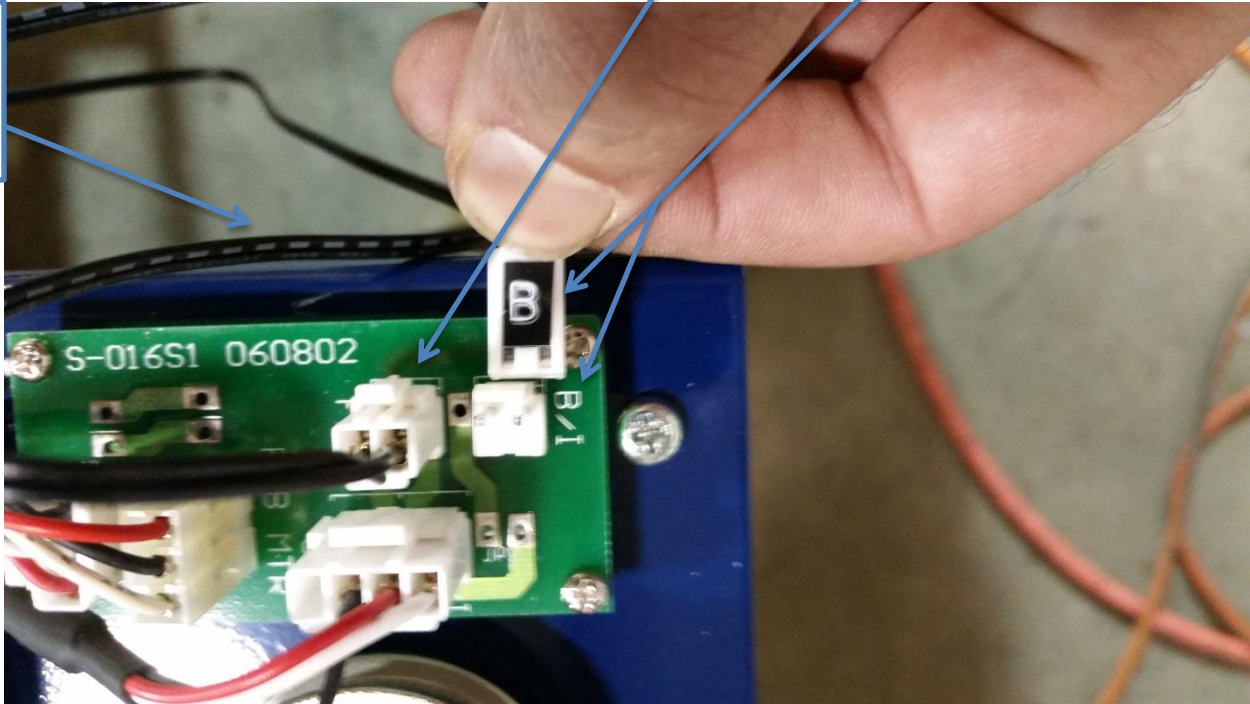


Should look like this.

Place the guard/stopper back on to the track. To place the guards back on to the track follow the step 6-3.

## Step 11:

Wires  
from the  
track



Back on the operator side (motorized end piece) take the wires from the track and place them in their corresponding socket on the circuit board.

## Step 12-16: Belt for Lifters



On the operator side, take the green nitrile belt and run it through the hole in the lifter, then over the plastic wheel.



Step 13:

Clamp down green belt

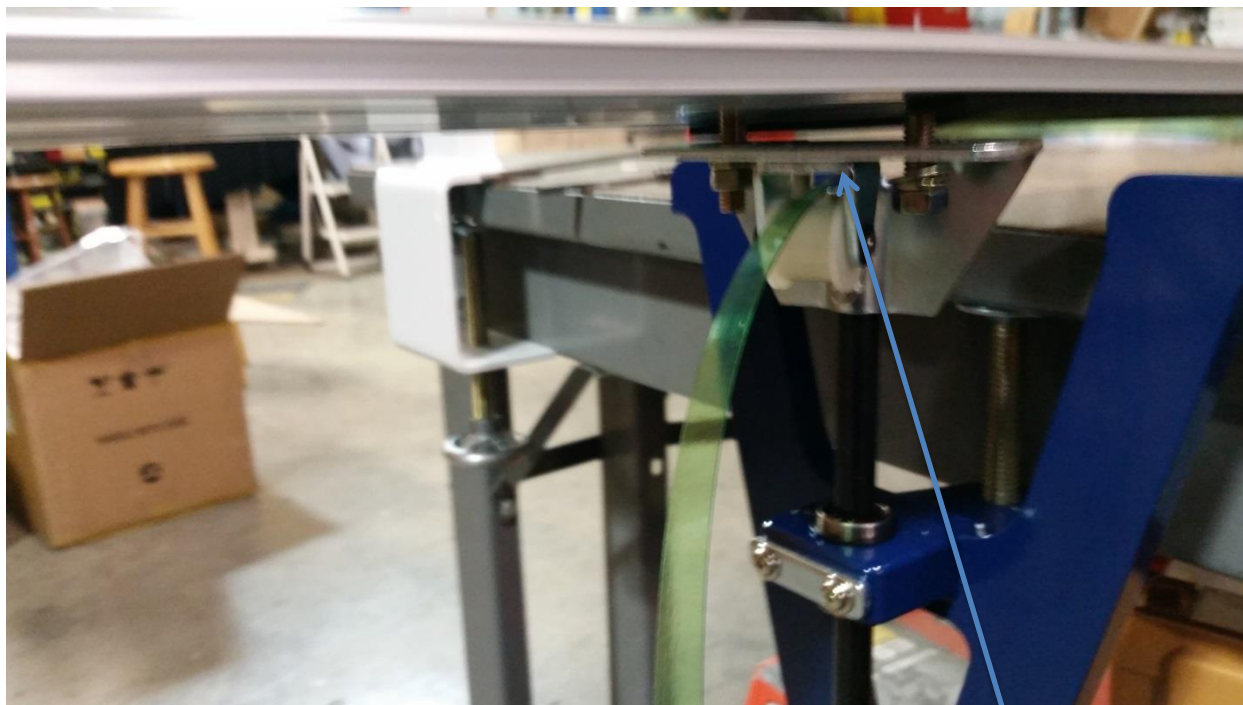


Step 14:



Run the green belt from the operator side  
under the track to the other side of the  
track

Step 15:



Repeat step 13 on  
the non-operator  
side





Feed the green belt under the plastic wheel at the bottom of the lifter.

Step 16:

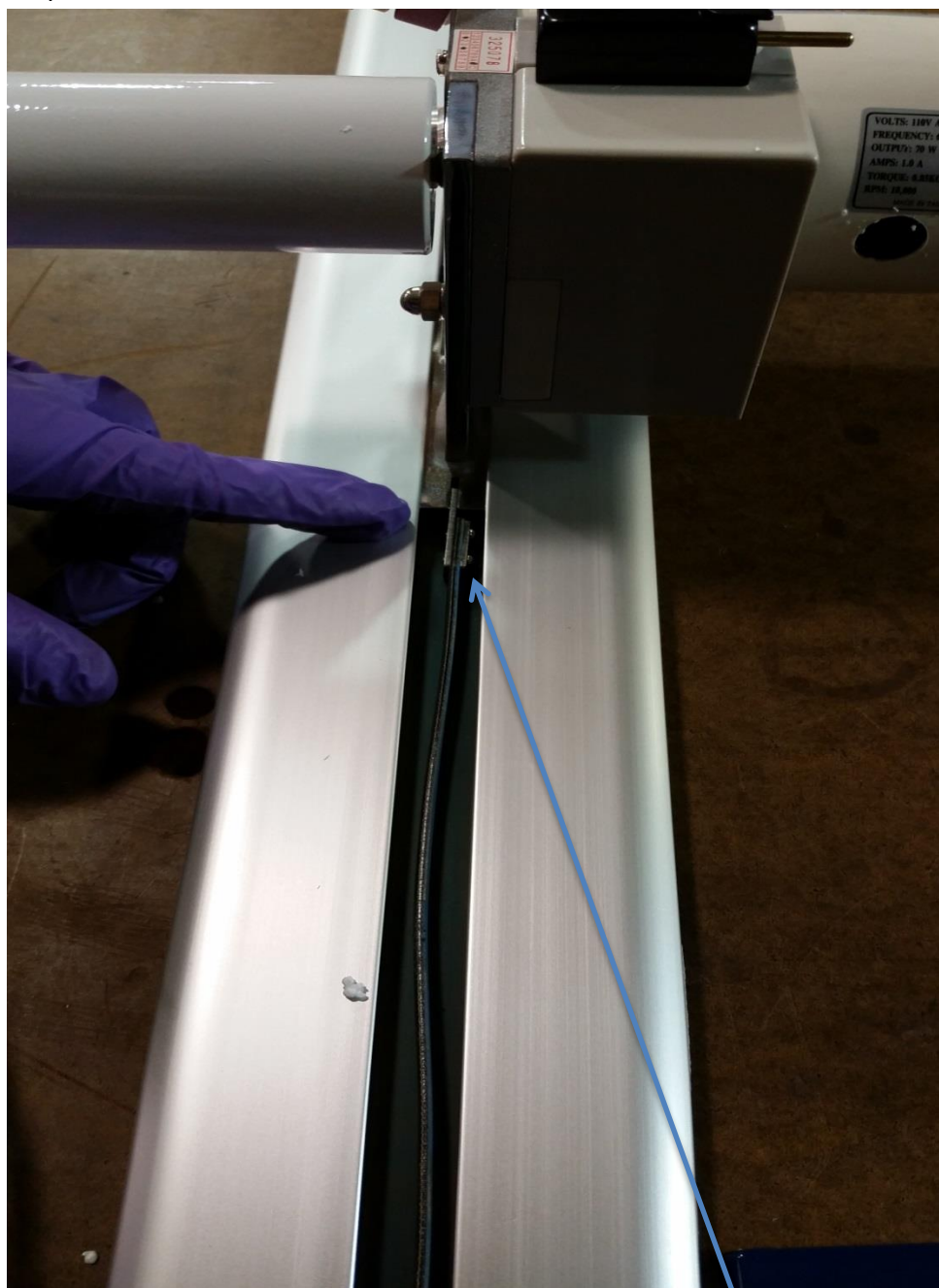


After looping the belt around the plastic wheel feed the green belt to the metal plate and clamp the belt down.

Note: Make sure the green belt is tight.



Step 17-22 knife belt installion:



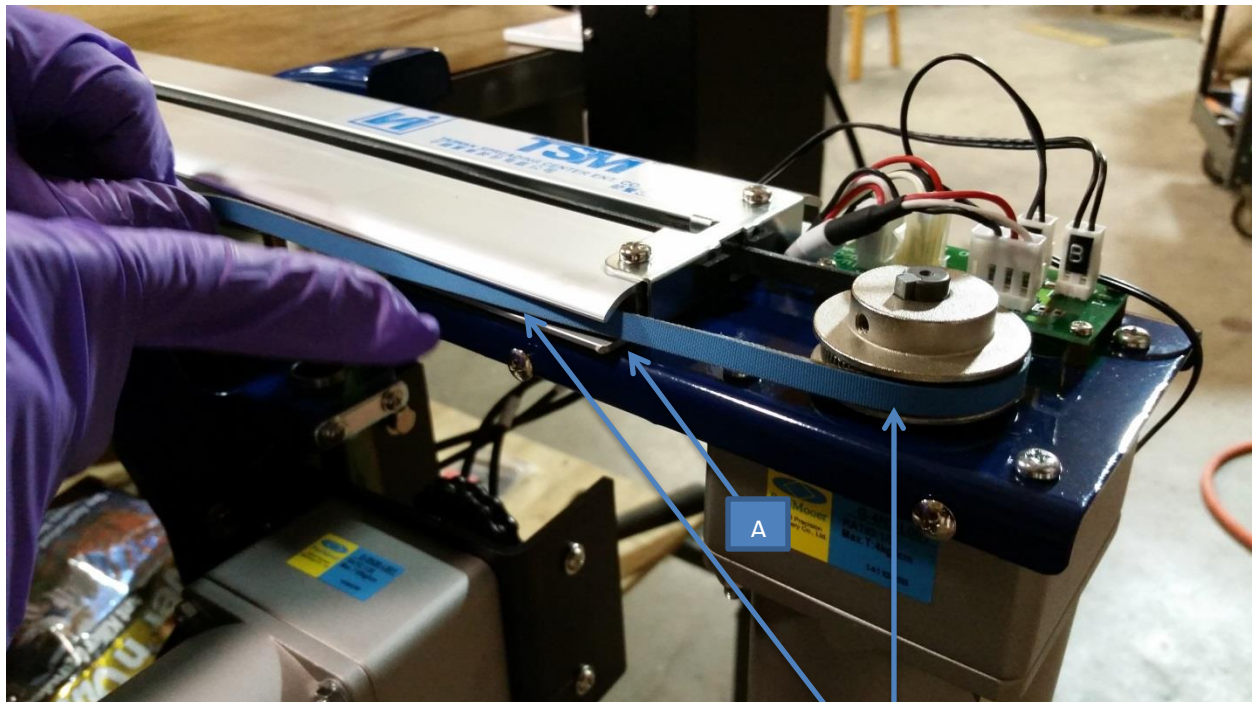
Attach the knife belt (blue) to the cutting head on the operator side (back end of the cutting head). Attach the belt through the hook on the end of the belt and bar on the cutting head.

Feed the knife belt through the center of the track than around the gear.

Step 18:



Step 19:

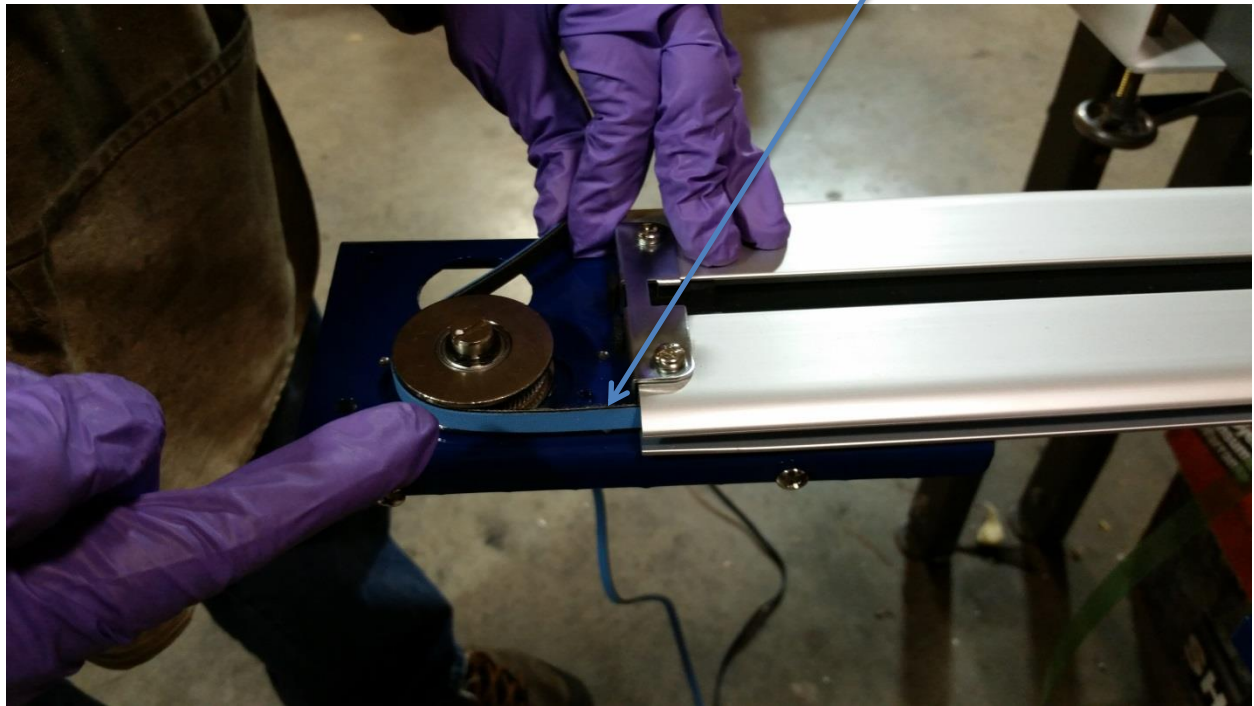


After looping the knife belt around the gear, run the belt on the side of the track to the other side. Make sure to place the belt inside the edge of the track.  
**(refer to arrow A on this picture)**

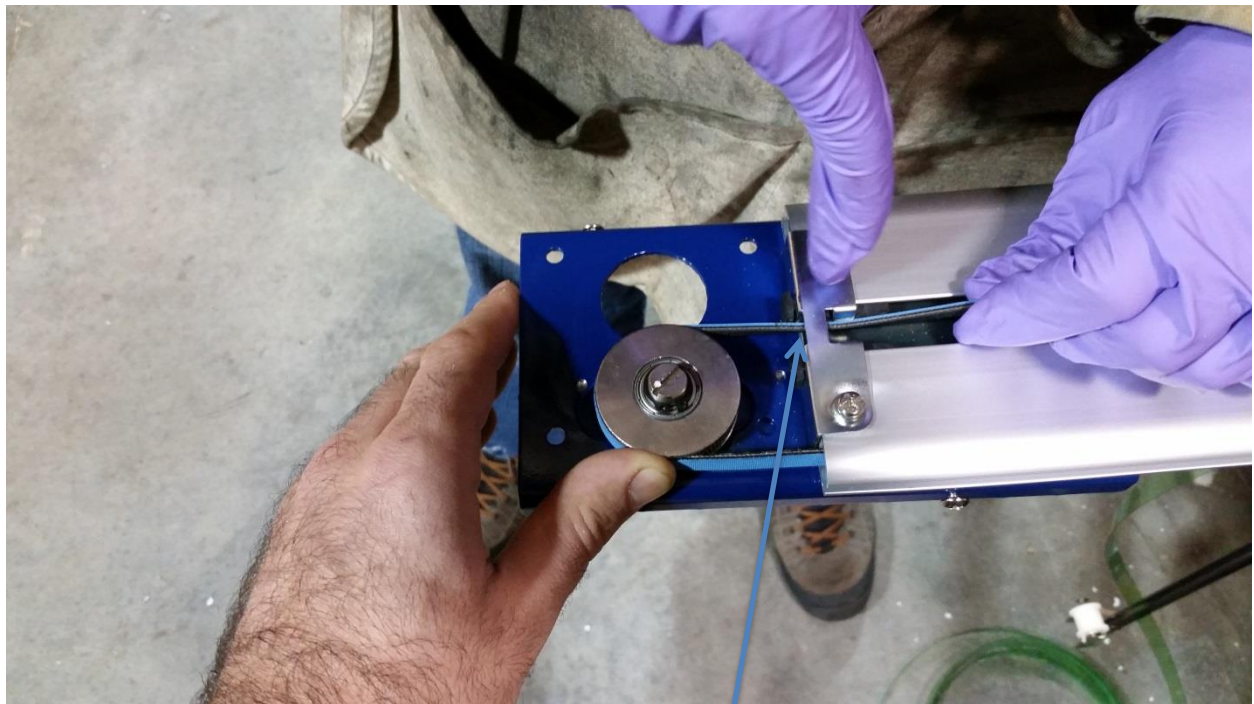


After running the belt all the way through the side of the track  
loop the belt around the non-operator side gear.

Step 20:



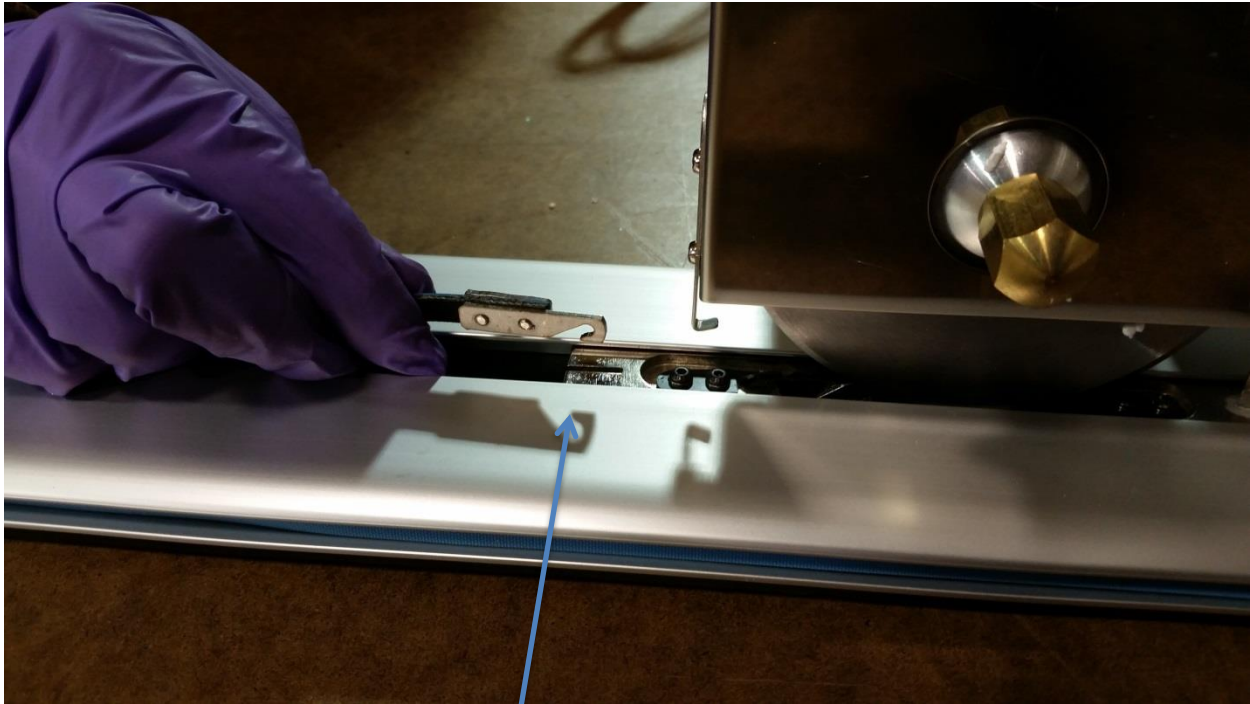
Step 21:



Feed the belt through the center of  
the track to the other side of the  
cutting head.

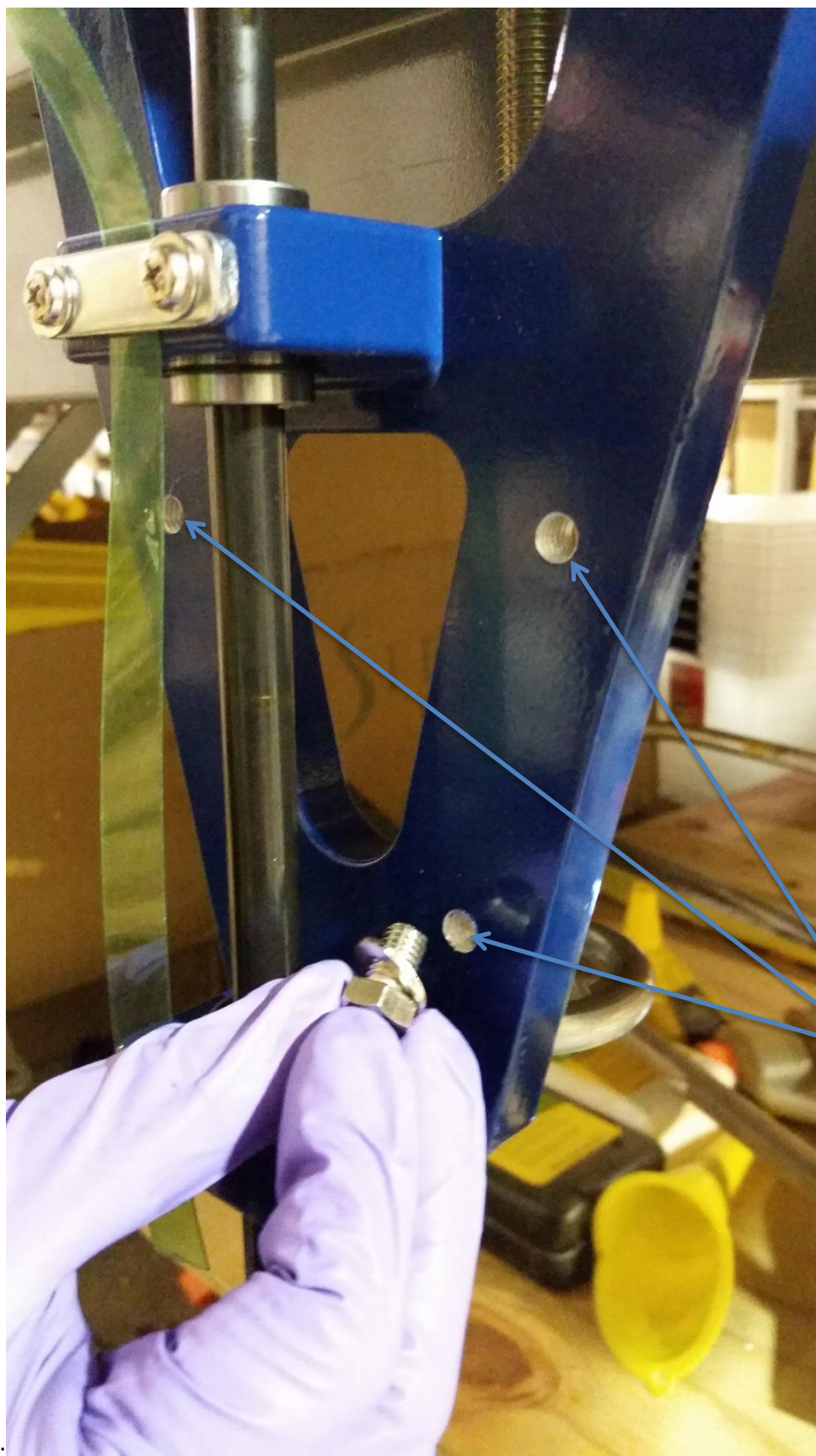
**Note:** Make sure that the knife belt (blue) is tight. You can achieve this by pulling either end piece (operator or non-operator) away from the track and tighten down either of the end pieces.

Step 22:



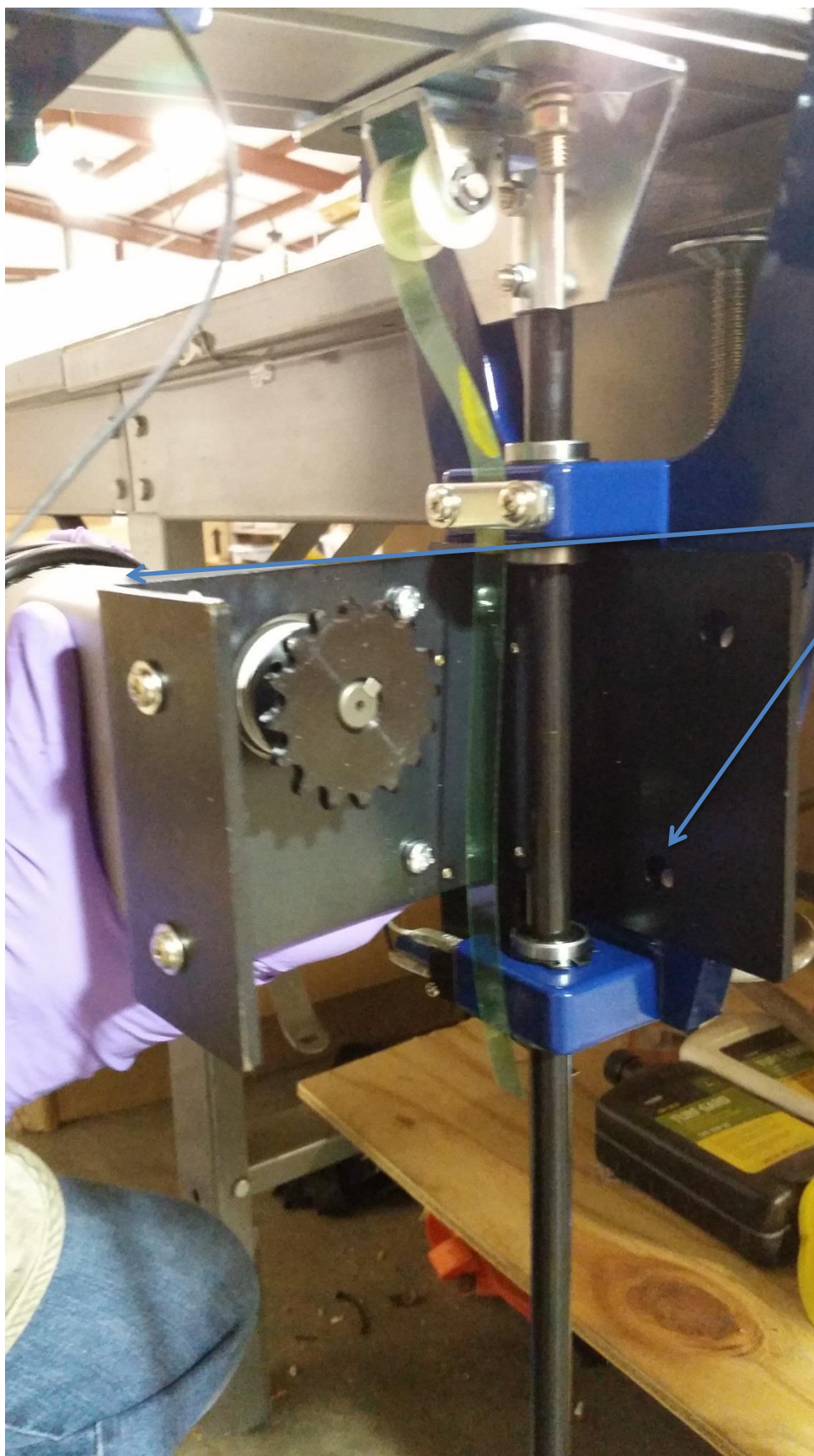
Hook/ attach the belt to the other side of the cutting head to complete the knife belt installation





Take off screws on  
the operator's  
side lifters

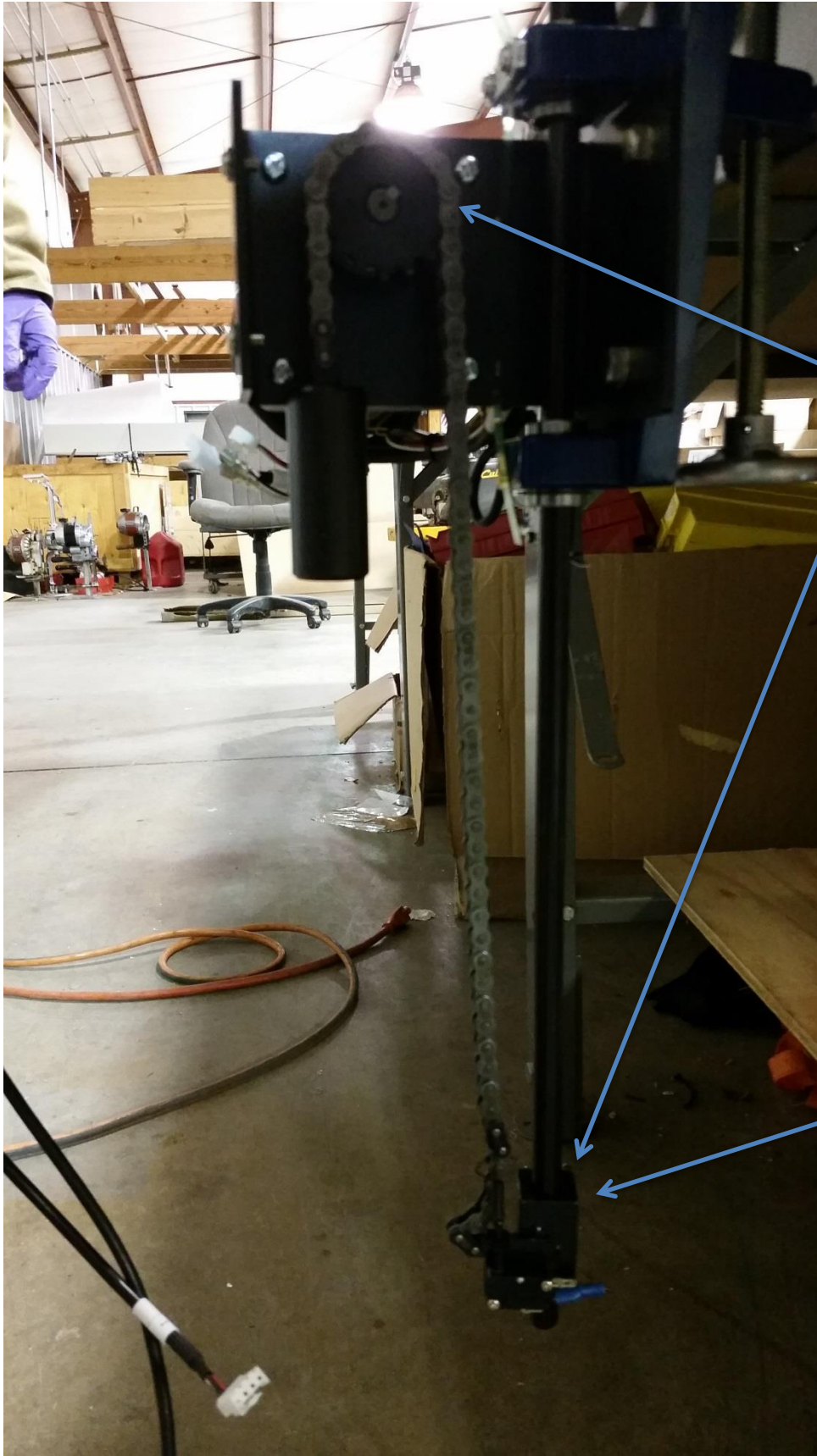
Step 23:



Line up the motor (seen in this picture) and the wholes that the bolts that you took out in last step (step 24). Then place the bolts back and then tighten

Step 24:



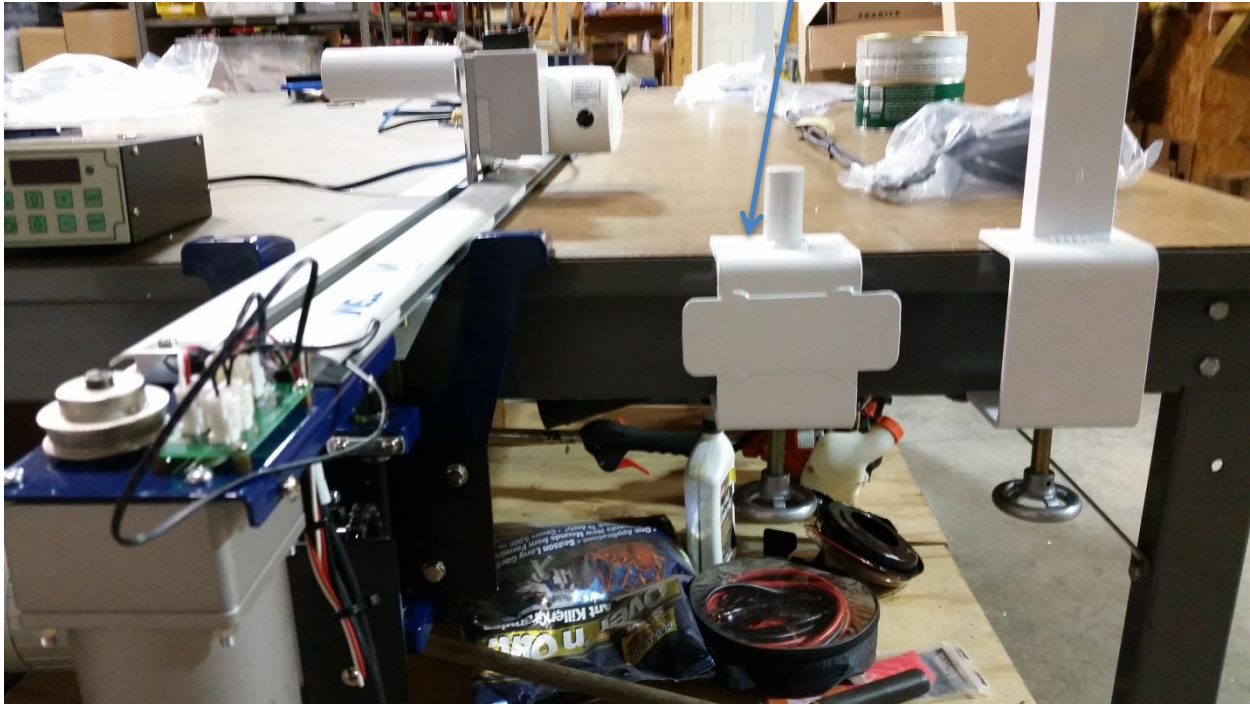


Place chain on the gear. Make sure that the counter weight is hanging on the gear away from the table. Also, attach the switch to the bottom of the lifters.

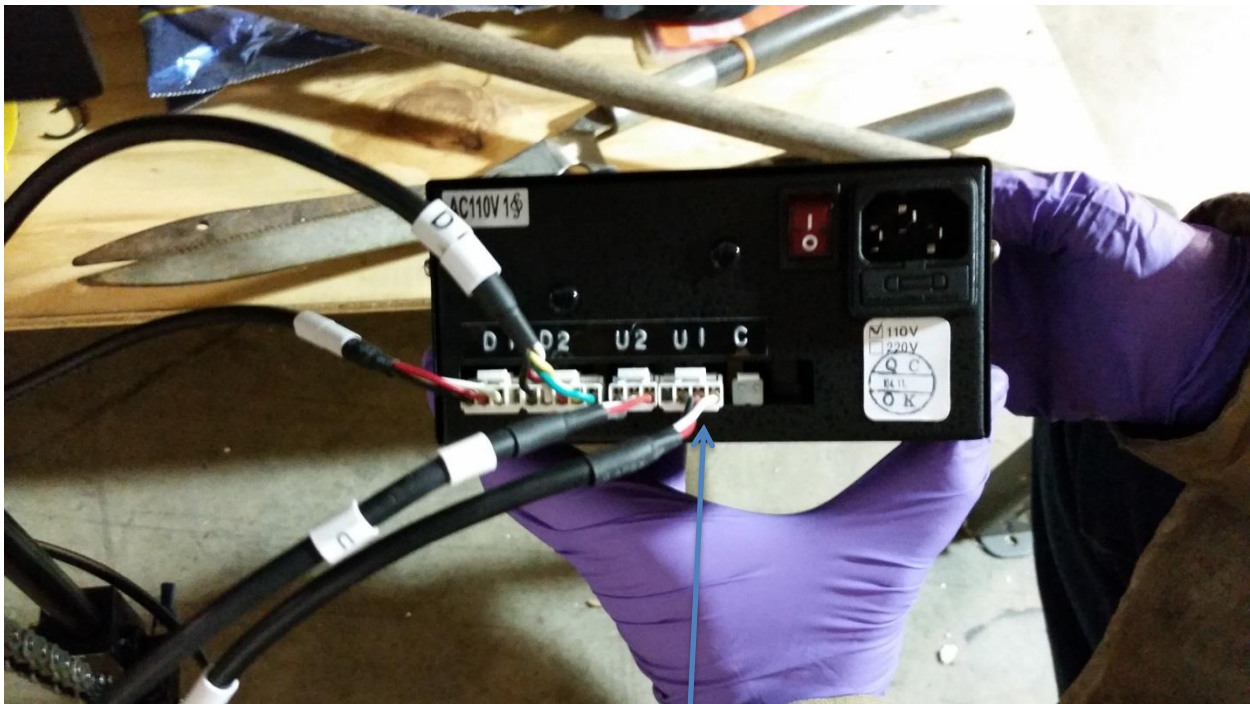
Note: moving the bottom switch up or down effects the height the track rises. Adjust according to your application needs.

Place the control box holder on to the table in between the track and the fabric roll rack.

Step 26:



Step 27:

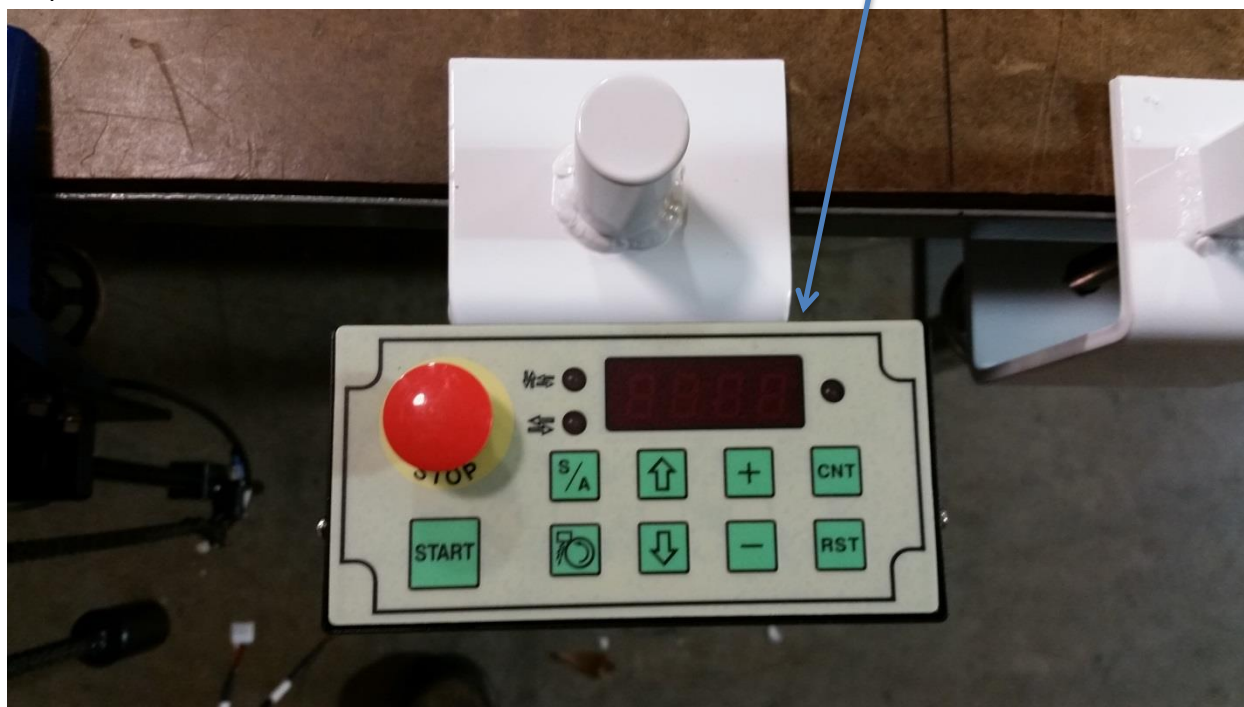


Take the wires from the big motor and connect the wires to the control box. Connect the wires to the corresponding sockets in the control box.



Place the control box on  
its holder.

Step 28:



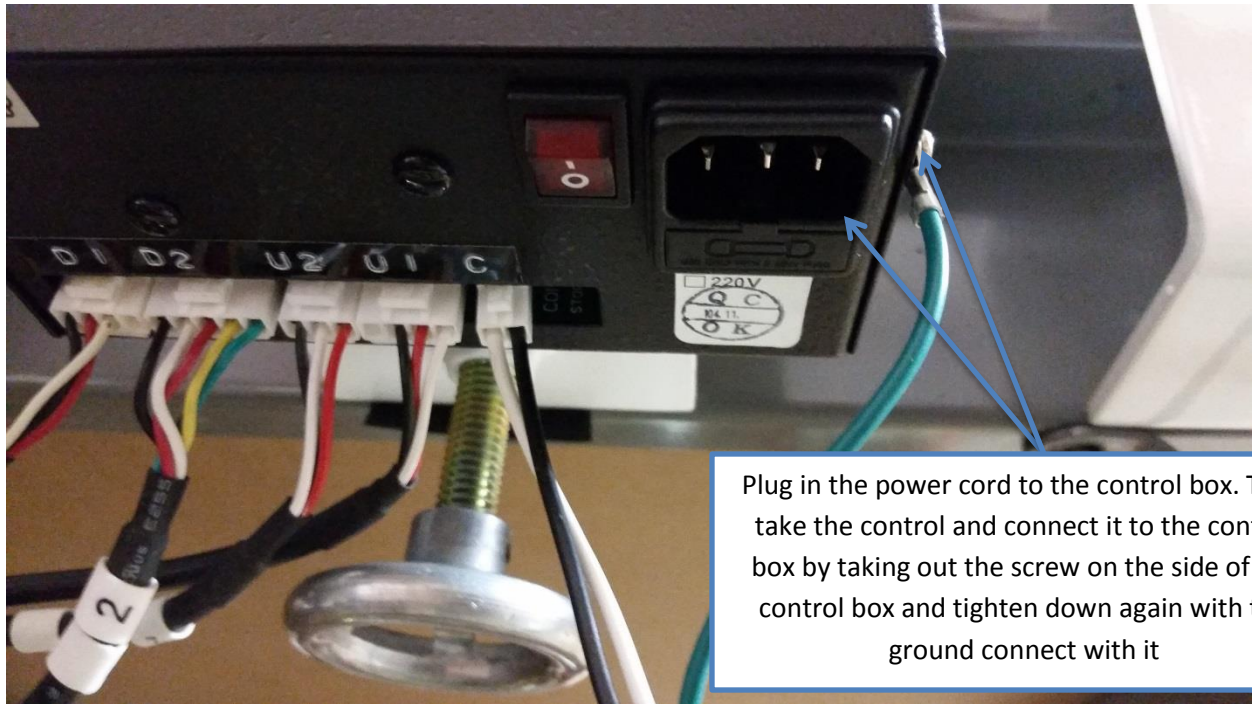


Place the power  
cord on the  
control box  
holder.

Step 29:



Step 30:



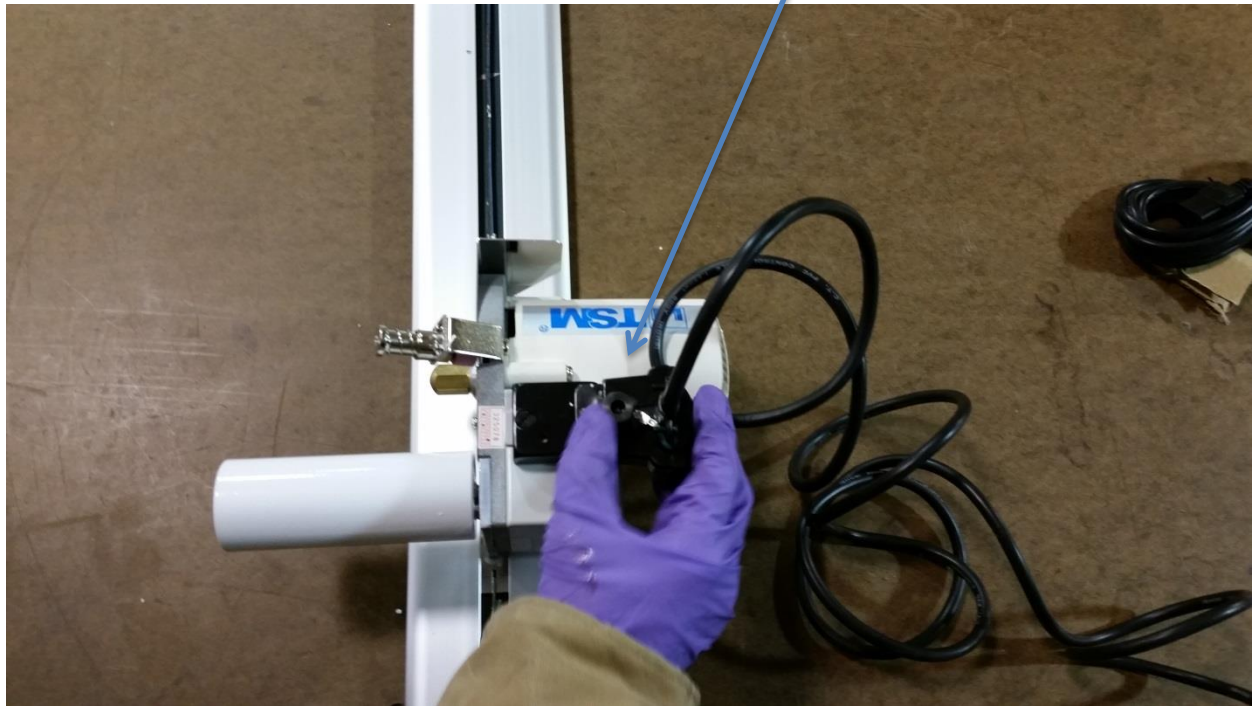
Plug in the power cord to the control box. Then take the control and connect it to the control box by taking out the screw on the side of the control box and tighten down again with the ground connect with it



Should look like this.

Take the other side of the power cord and attach it to the cutting head

Step 31:

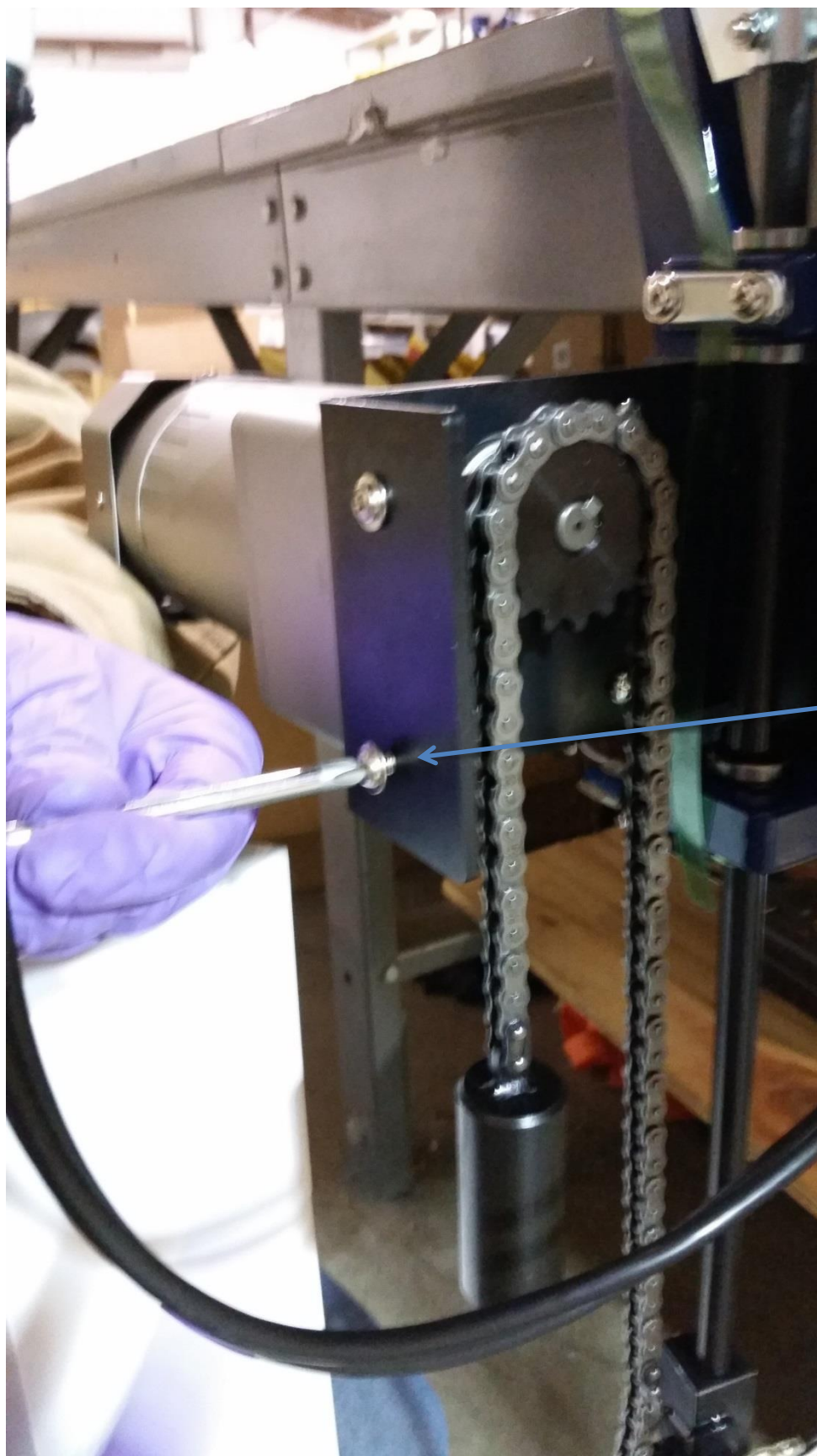


Step 31:

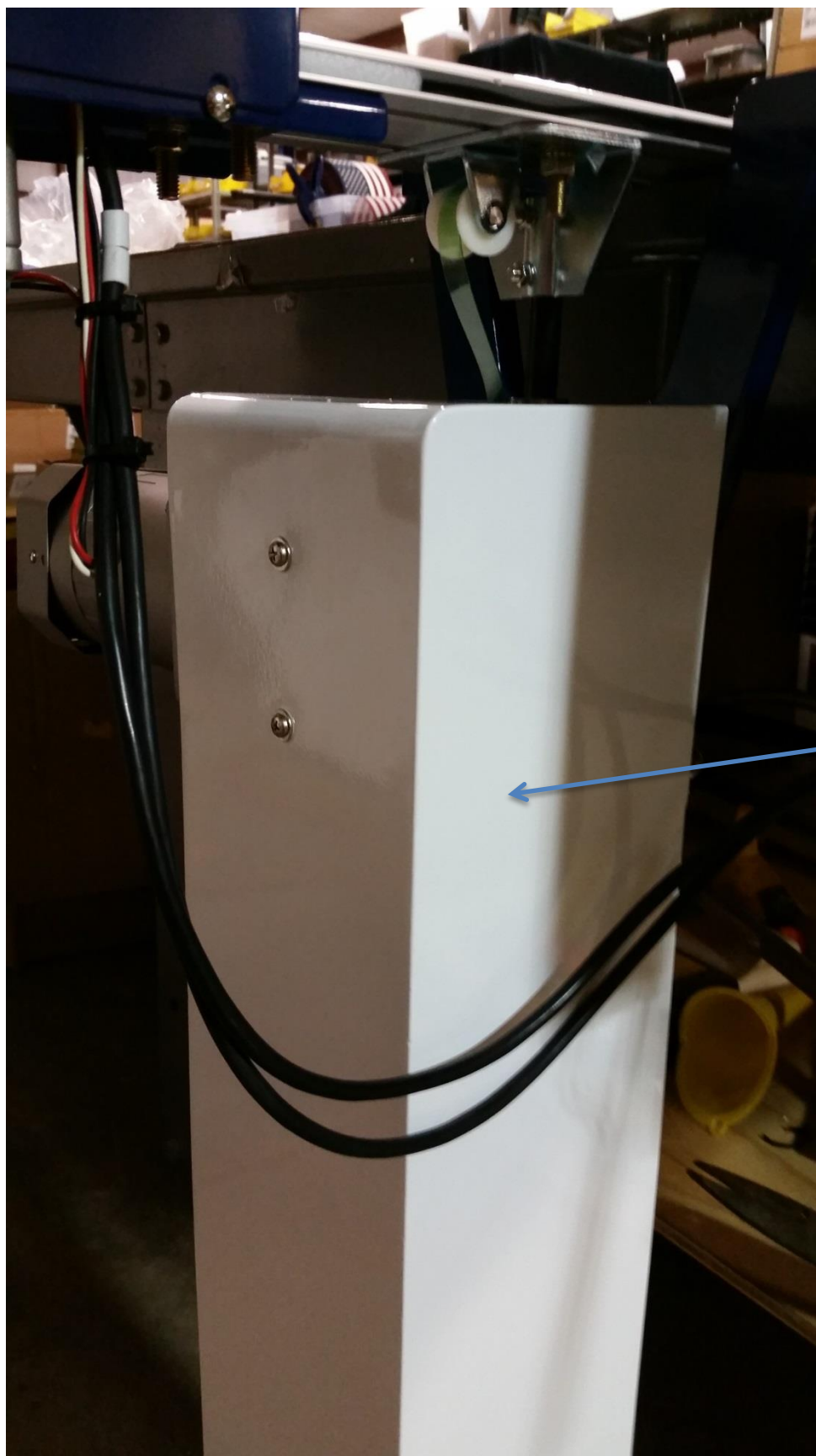


Place covers on both end pieces.





Place cover on by unscrewing these two screws and placing cover over the wholes. Than screwing screws back in.



Should look like this.





Plug control box  
into the power  
source.

Step 32:



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Completed Assembly:



Thank you for your purchase from Sewn Products Equipment Company. If you have any questions about your new automatic end cutting system (610A) please email [sewnproducts@sewnproducts.com](mailto:sewnproducts@sewnproducts.com) or call +706 367-2755 (in the USA call toll free, 800 327-2677).