MANUAL
STRIP CUTTER CMS1800-A
Dear customer,

Thank you for choosing a product from Svegea of Sweden. Please note that Installation, operation and maintenance should be carried out by trained personal. Please take the time to read these instructions carefully and in advance. If you follow all the instructions, you will save yourself much time.

It is also essential to read the instruction manual because incorrect use of the equipment can damage the machine itself, other parts of the system and give personal injuries.

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Safety & Cautions

This machine is equipped with **sharp** knife.
Keep hands away from knife at all time.

Keep hands away from shafts and rollers at all time.

This machine only to be operated by authorized and trained personal.

Never operate this machine with any guards removed.

Maintenance/service only by authorized personal.
Before performing - disconnect from the mains.

Maintenance/service **inside** the machine only by authorized personal.
Before performing - disconnect from the mains and wait **two minutes** for the intermediate circuit capacitors to discharge in the frequency inverters.
### Technical Data

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum Operation width</td>
<td>1800 mm</td>
</tr>
<tr>
<td>Maximum roll diameter</td>
<td>280 mm</td>
</tr>
<tr>
<td>Cutting Knife diameter</td>
<td>400 mm</td>
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<tr>
<td>Diameter of fabric shaft</td>
<td>37.5 mm</td>
</tr>
<tr>
<td>Card board tube inside diameter</td>
<td>38-40 mm</td>
</tr>
<tr>
<td>Machine speeds</td>
<td>Inf. variable, electronic</td>
</tr>
<tr>
<td>Motor power</td>
<td>1.5 and 1.1 Kw</td>
</tr>
<tr>
<td>Power:</td>
<td>380V, 3-phase, 50/60Hz</td>
</tr>
<tr>
<td>Machine dimensions</td>
<td>2700/1200/1400 mm</td>
</tr>
<tr>
<td>Weight</td>
<td>400 Kg</td>
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</tbody>
</table>
The series computer automatic variable frequency cutting and striping machine is specially used for cutting cloth, leather, paper, fusible interlining, chemical fiber etc. into strips of various specifications. The machine features easy control, user interface touch screen and computer control data input, with one winding shaft being able to offer strips of five specifications. One clamping is enough without manual work, which is accurate and fast. It is equipped with automatic knife grinder, and the sharp blade and level cutting will give you satisfaction.
Operations

1. Connect the power cable with a 60A leakage protection switch, and connect ground wire.
2. Upon power connection, turn on the main switch on 1 or 2. Open the control panel. Press the terminal switch to turn on the cutting machine’s after power is connected for 10-15 seconds. Adjust the speed of host machine. Try all the functions to finish the test run.
3. Install the blade on basic shaft of cutting machine and lock it well. Adjust the edge between 2-3 mm away from the central shaft. Lock the screw bar tightly.
4. Open the three-jaw chuck. Sleeve the wound fabric on central shaft and lock it on the chuck. Remove chuck key. Put back end support in position, lock it.
5. Operation process: After testing, the machine can work normally, Grind the brand-new blade with a stone and than ready.
6. (1)Put fabric on the shaft, grip the core/fabric with chuck, eventually adjust the needle pins, tight the chuck with key. Remove key. (2)Bring back the end-support, lock it in position.(3) adjust the scale.(4)Connect the power.(5)Turn on the cutter and adjust the speed.(6)Turn on the basic rotating shaft.(7)Move the blade to the end of the fabric roll. Cut the the edge of the roll so a clean cut being obtained and pull the balade back and start working.
Guide to use Operating panel
1. Emergency switch, it is used in emergency to stop the machine. When you press this button in any case, machine stops running.
2. Manual/automatic mode: **Manual mode:** push this button to move operating board according to directional arrow and than machine begins to trim. **Automatic mode:** machine trims according to parameters set up on the touch screen panel.
3. Choose direction of rotation of bar.
4. Setting of Forwarding speed.
5. Setting of Knife speed.
7. Cross bar button, in manual when the button is pressed, knife carriage moves to the direction showed by arrow.
8. Automatic start-up button, in automatic, the button activates automatic trimming/cutting system.
9. Switches of grinding: use this to start/stop grinding wheel and grinding (1) to sharpen blade edge and time it in manual grinding mode (2) to set up grinding time and pause time in automatic mode.
Manual Strip Cutter CMS 1800-A

Chuck

Knife

Emergency switch - wire

Chuck key
Manual Strip Cutter CMS 1800-A

Knife Cooling System (option)
Manual Strip Cutter CMS 1800-A

Air pressure/Flow

Nozzle

Lubrication bottle
Guide to use manual machine interface

- **Current coordinate parameter**: to show its relative value against the value at start.
- **Coordinate clearance**: touch this button to clear coordinate value.
- **Start up**: when this button is pressed in automatic mode, roll/chuck and Knife will start operating and cutting/trimming will start based on values being set on panel.
- **Start-up/stop of principal axis**: in manual mode, touch it to start the chuck/roll and touch it again to stop.
- **Start-up/stop of parting-tool**: in manual mode, touch it to start knife rotation and touch it again to stop.
- **Length of fabric bolt**: to show the length of fabric roll. The PLC calculates the length when length and number parameters of material are set up.
- **Current set size**: to show width of trimmed material.
- **Current set number**: to show quantity of trimmed/cut material.
- **Total output**: to show the total figure of set size and set number of trimmed/cut material.
- **Clearance**: touch this button to clear figure of total output and current set.
- **Trimming parameter set-up**: touch this button to enter the page for trimming/cutting parameter set-up.
Service regulations
For example: to trim a 1000 mm-long bundle of fabric into 30 - 20mm sets and 8 - 50mm sets and meanwhile the machine grinds the knife every 20 seconds and grinding time of 5 seconds.

1. Switch on power main power, machine starts up in 3 minutes.
2. Pull manual/automatic button to the manual position, press moving button (left or right) to move trimming board to starting position and than use co-rotation/reversal switch to choose running direction.
3. Touch start-up/stop button of principal axis and parting-tool on manual machine interface to start both of them and adjust their running speeds.
4. Touch clearing button on manual machine interface to clear coordinate values.
5. Move parting-tool by hand and it will return to start position. At this time the feeding speed can be adjusted by pressing feed speed button.
6. Pull manual/automatic button to the automatic position and touch trimming parameter set-up button an manual machine interface to enter the page for parameter set-up.
Guide for setting up trimming/cutting parameters (pic1)

1. **Set Size**: Press the button and small keyboard will pop up on interface. Press the number at keyboard and then press ”enter” key to input the width of material to be trimmed (pic 2). Finding any mistakes, press ”CR” key to clear. Limit values of parameters can be found in instructions on small keyboard. The unit is mm.
2. **Set number**: Press the button and a small keyboard will pop up on the interface. Press the number at keyboard and then press "ENT" key to input set number of material to cut/trimmed. Finding any mistakes, press "CR" key to clear. Limit values of parameters can be found in instructions on small keyboard.
3. **Trimming/cutting time**: Press the button and a small keyboard will pop up on interface. Press the number at keyboard and than press "ENT” key to input trimming time. Finding any mistakes, press "CR” key to clear. Limit values of parameters can be found in instructions on small keyboard.

Note: trimming time refers to pause time of trimming/cutting board after it finishes trimming/cutting fabric bolt.

Set-up parameters (II-V) is the same as above. After setting up parameters, press "BACK” key to return to homepage.
Choice of grinding modes:
1. **Manual mode**: touch button on touch screen to move grinding socket to grind.
2. **Automatic mode**: set up grinding time and stopping time.

**Grinding time**: it begins to be calculated from the time when grinding wheel feeds to photoelectric on-off and meanwhile grinding socket stops.

**Pause time**: it begins to be calculated at the time when grinding wheel sets out of blade and grinding wheel socket stops.
3. Press "BACK" key to return to homepage

At this moment the system will calculate the length of fabric bolt/roll (1000 mm). Press "Automatic start-up" key on control panel OR touch start-up on machine interface and the system will trim/cut material according to parameters been set. During this course, arrow on left of set number will glitter to show that the material is being trimmed/cut. After cutting, cutting finished, Cutter Carriage will return to start place, ready for future operation/running.
## Trouble shooting

<table>
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<tr>
<th>Common failure</th>
<th>Troubleshooting</th>
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| There is adhesive on the blade  | ①: Check the material cut.  
②: Adjust the speed of cutter and basic shaft.  
③: Grind the cutting blade.  
④: Adds the silicone oil lubrication or the watering cools. |
| Shifting is improper            | ①: Check that if the driver is working and the position switch and frame exit completely.  
②: Change the driver and send it back to the factory for repair. |
| Speed control potentiometer doesn't work | ①: Disassemble the housing, and check the contact of resistance spring.  
②: Change potentiometer. |
| The speed is unstable           | ①: Check that if the belt of the cutter's motor is loose, and change the 900A belt.  
②: Check frequency converter and conversion data. (Refer to instruction manual of the converter.) |
| The basic shaft doesn't work.  | ①: Check speed control potentiometer.  
②: Check frequency converter. |
| The cutter doesn't work         | ①: Check speed control potentiometer.  
②: Check frequency converter. |