

JEMA

AUTO CUTTING MACHINE

INSTRUCTION MANUAL



TAIZHOU JEMA SEWING MACHINE CO.,LTD.

1. General Discription

The machine adopts microcomputer numerical control device, length, speed, volume can be set freely, with features of high precision, fast, smooth cutting surface and easy operation. And It's suitable for braided belt, velcro belt tape, casing, plastic zipper. etc..It's your choice to increase productivity, improve product quality and saving labor.

2.Specifications

Power(KW)	Max. cutting width(MM)	Cutting length(MM)	Cutting speed (pcs/min)	Voltage (V)	Frequency (Hz)	Temperature (°C)
0.14(COLD) 0.54(HEAT)	95	10-9999	70-90	110/220	50/60	350(LR) 300-450(H)

3.Use Environment

The machine should work under the normal temperature, if the environment temperature is more than 70 °C , would influence the performance of the machine.

4.Operation

(1).Operation

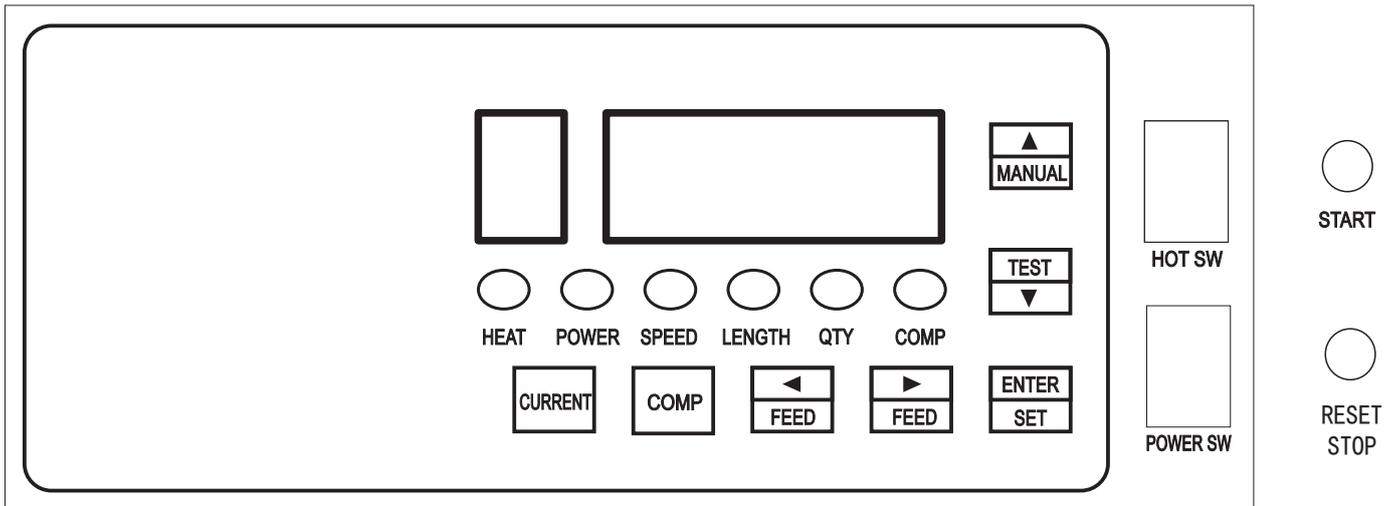
- “**Q**” shows current quantity
- “**L**” shows current length
- “**E**” shows current temperature
- “**1**” is to set up speed
- “**2**” is to set up length
- “**3**” is to set up quantity
- “**4**” is to set up compensation
- “**5**” is to set up temperature
- “**6**” is to set up label: input 1(open)、0(shut down)

2).Set Up

Please press SET UP button and put in datas by direction keys. And don't forget to confirm by ENTER.

Note: you can not start work while setting.

5. Key Functions



Hot knife



Start



Power



Reset
Stop



Press "CURRENT" display shows "□" current quantity; Second times pressing display shows "└" current length; Third times pressing display shows "└" current temperature. Press "COMP", input cut length. e.p. display length input is 50mm, the effect of actual cutting length is 40mm. So press "COMP", input 40cm length. Compensation use for materials cutting.



Manually backward the tape and to set up quantity, length and speed



Manually frontward the tape and to set up quantity, length and speed



Long press the key, test cut.



Press the key and test cut one time.



Press this key start setting. e.p. display 1-speed, input numbers for speed. Then again press "set" finish setting. 1-speed 2-length 3-quantity 4-compensation 5-temperature 6-color sensor(input "0": OFF; input "1": ON)



Stop working; Finish setting; Keeping pressing two times length back to "0"; Pressing continue few seconds, length、quantity return back to "0". After each parameter setting done, press "○" finish setting.



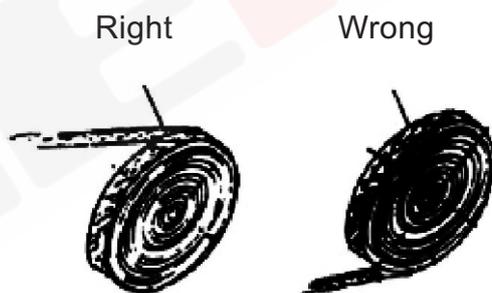
Start work.

6 . Caution

- 1.Before operation, please confirm the voltage and make ground(earth) connection.
- 2.Do not access hands or any object close to the working knife.
- 3.Pls do not take off any of the parts except for normal maintenance.
- 4.Lubricate the machine every few day use the machine. (Attention: no sewing oil)
- 5.When the knife blade becomes dull, pls use it after grinding with the grinding machine (pls do not let the unskilled person grind manually or install the knife blade)
- 6.Cut off the electricity before any adjustment(for safety)
- 7.Welcome to contact us for any further information.

7 . Fault Clearance

- 1.Check the connection, if the temperature does not work.
- 2.Increase the temperature if the cut unsealed.
- 3.Please wait the temperature reaches to the set temperature before working and with right material putting.



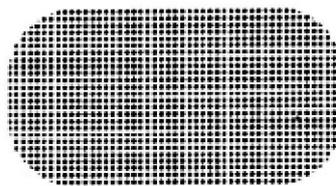
- 4.If you couldn't loose the screw while exchange the knife, you may open the temperature control and adjust the temperature to about 200℃ . Then loose the screw and turn off the control. And screw out completely after the knife is cool. (Note that is hot and not burned yourself)

Caution:

- Do not cut two velcro in the same time.
- When cut velcro, please make sure that the rough surface is upward.



The rough surface is upward(correct)



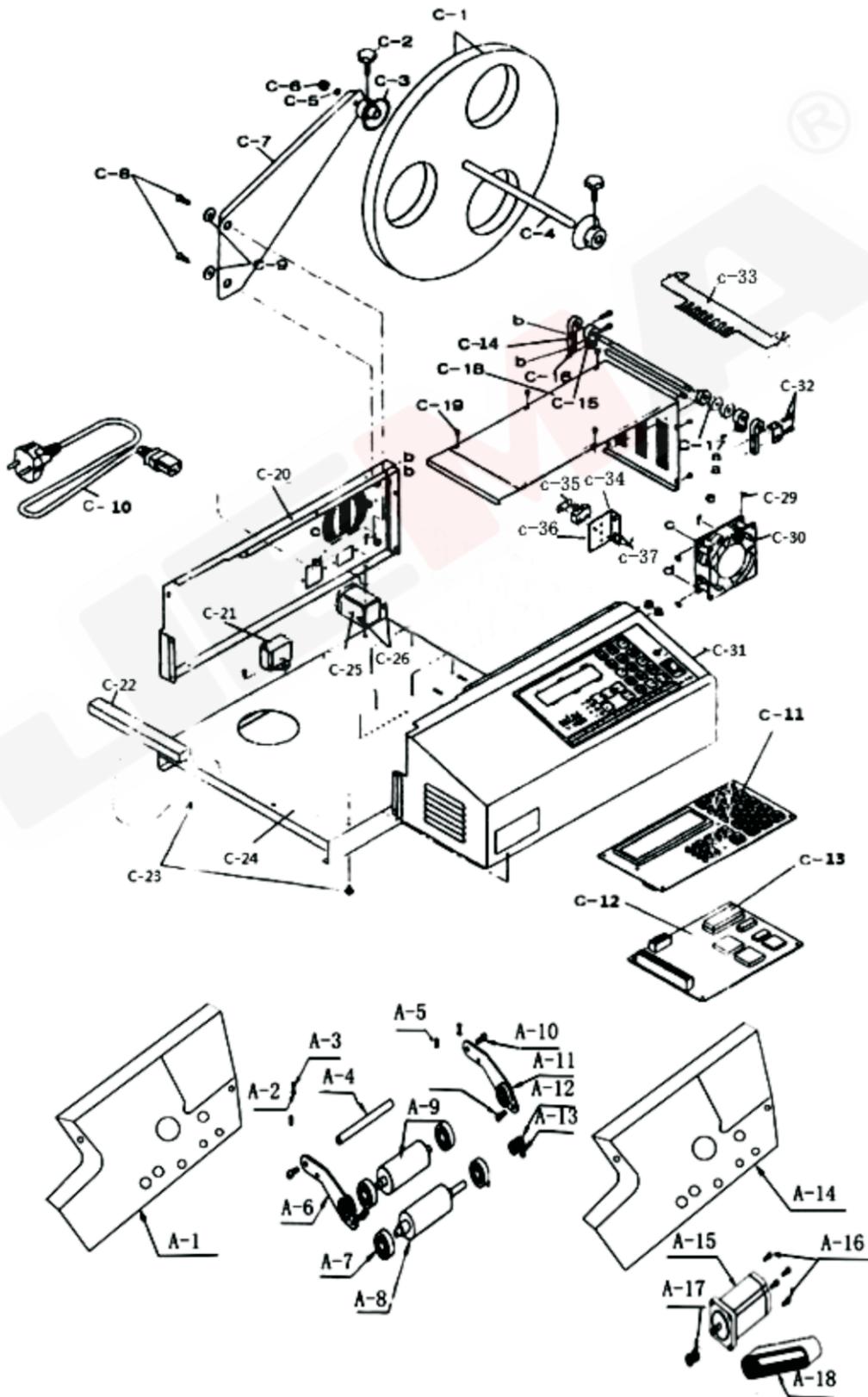
The rough surface is downward(false)

8. Trouble shooting of 110 series(only reference)

NO.	Troubles		Applicable Model	Causes & Measures
1	No power supply		All models	-Check if electric cord is connected well -Check if the fuse blows out or not
2	Power is on, but no work	Feed roller does not work	All models	-Check if there is inserted any alien substance in roller -If the display shows "sensor error" or any other error, put off SW for 10 seconds and put on again. -If still does not work, exchange the drive board.
		Knife does not work	All models	-Check if pressure plates of upper knife are too much fastened or not. (cool:#20&29,hot:#32&36)
		LCD display does not work	All models	-Check if the temperature is too high with over-time working, switch off the machine for seconds, if still doesn't after several times' trying.. Please opening the cover and check the connection. (Especially between operation and CPU board)
3	Material is no cut		Hot cutter	-Check if temperature goes up to set-degree -Check if knife blades are even.
4	Material is cut one side		All models	-Check if blades are damaged or wears -After making both knives close each other by M/CUT button and check if they are even or not. (If they are not, adjust them by bolts)
5	Cut-length is different from set-length		All models	-Test after loosening material from the reel by hand or attaching feeding device.
6	EГ 01 Alarm of no material		All models	-Check if the materials are used up, and please replace with new materials then needed. -Check if there is material or if the pressing plate drops into the slot. -If all is confirmed normal, check if the travel switch is stuck and doesn't bounce back.

NO.	Troubles		Applicable Model	Causes & Measures
6	EΓ 02 Cutting error		All models	Troubles in cutting motor or counting sensor
				-Turn on the machine and press the  button, check if the knife can be moved or knife may locked. -Open the button cover of the knife, check if the sensor is loose and wrong positioned. -Open main cover, check the SW of cutting sensor is right or not. If not, exchange it.
				Check the cutting motor is right or not.
				EΓ 03 Label error
It cuts after the cutting line of label	Label	Move the sensor towards counter-knife side as long as the difference by pushing.		
MARK error	Label	-Trouble in MARK sensor. -Check if the sensor is connected well or not. -Check if the sensor is adjusted well or not. -Check if the input length is cord with the label length.		
7	Operator feels electric current in touch of machine		All models	Connect the earth cord (green) to any bolt of backside of machine.
8	No heating		Heating series	-Check if the heating tube connected well or not. -Change a new heating tube.
				Lamp off

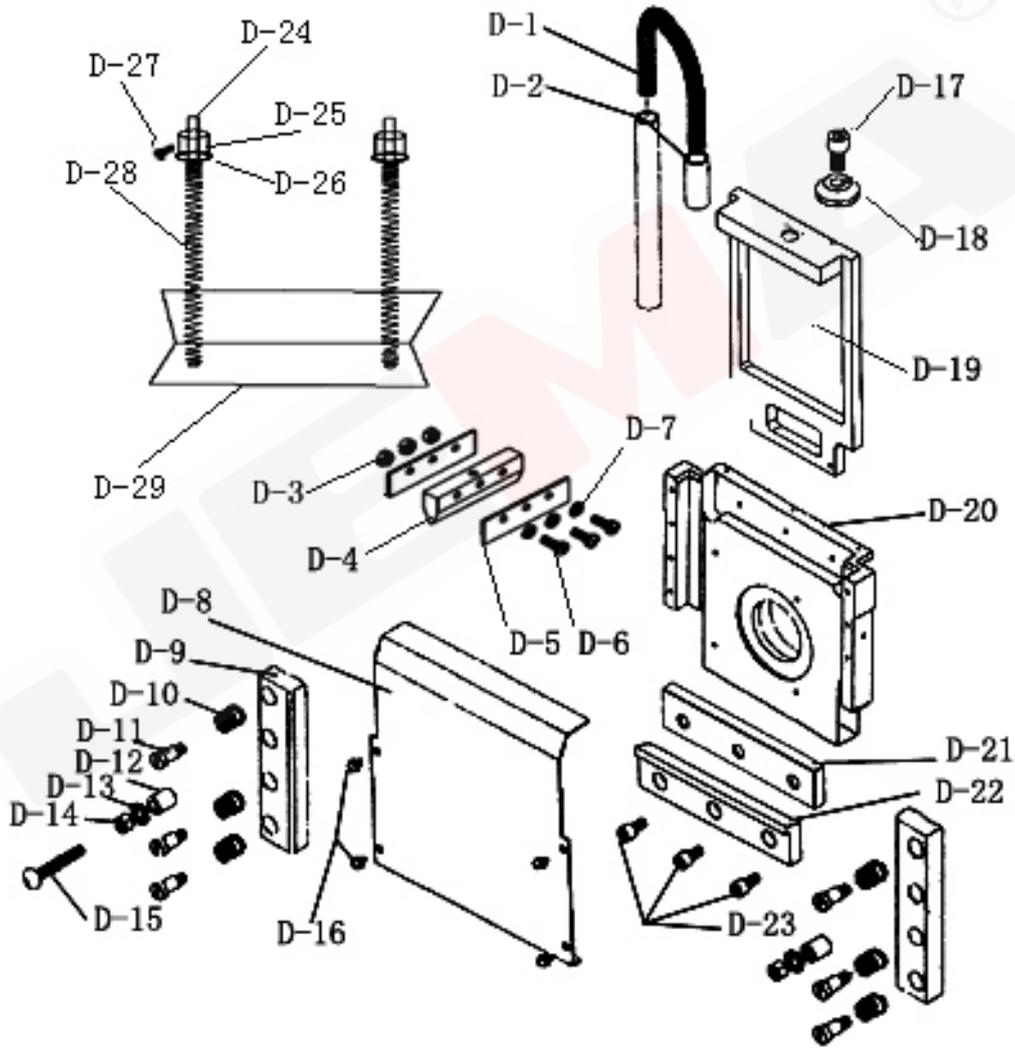
SPARE PARTS



PARTS DRAWING

Part No.	Description	Part No.	Description
A-1	Left barrel bracket	C-11	Operation board
A-2	Neck washer	C-12	Control circuit board(MB)
A-3	Clamping bolt	C-13	ROM
A-4	Pull shaft	C-14	Rear guide-pin bracket
A-5	Spring	C-15	Rear tension-guide block
A-6	Upper –roller bracket(right)	C-16	Detent screw(M4×6L)
A-7	Bearing	C-17	Guide ting
A-8	Lower roller	C-18	Upper guide plate
A-9	Upper –roller	C-19	Clamping bolt (M3×5L)
A-10	Clamping bolt M5	C-20	Back cover
A-11	Upper –roller bracket(left)	C-21	Condenser
A-12	Feed –timing belt	C-22	Sponge
A-13	Clamping bolt M4	C-23	Clamping bolt (M4×10L)
A-14	Right barrel bracket	C-24	Base
A-15	Stepping motor	C-25	AC connecter(IN-PUT)
A-16	Clamping bolt M5	C-26	Clamping bolt (M3×5L)
A-17	Feed timing gear	C-29	Clamping bolt (M3×5L)
A-18	Timing belt	C-30	Cooling fan
C-1	Roll-hanger wheel	C-31	Control cover
C-2	Clamping bolt of holder	C-32	Wrench bolt(M5×15L)
C-3	Holder	C-33	Existence detector
C-4	Roll-hanger shaft	C-34	Micro limit switch
C-5	Roll-hanger shaft washer	C-35	Plate-nut
C-6	Check nut(M6)	C-36	Limit switch bracket
C-7	Roll-hanger	C-37	Clamping bolt(M2×10L)
C-8	Flat-head bolt(M6×15L)		
C-9	Neck washer of roll-hanger		
C-10	Out connect plug		

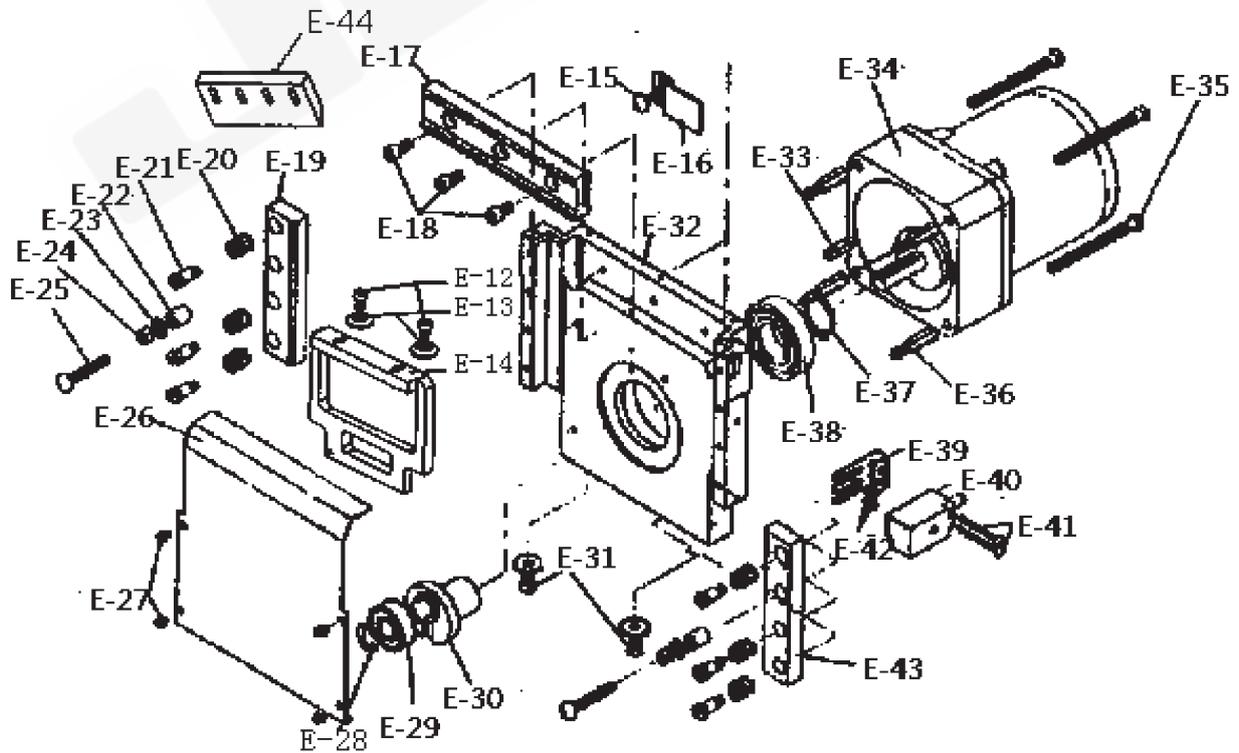
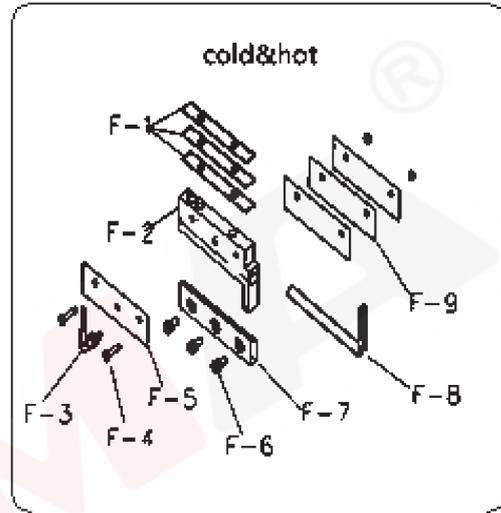
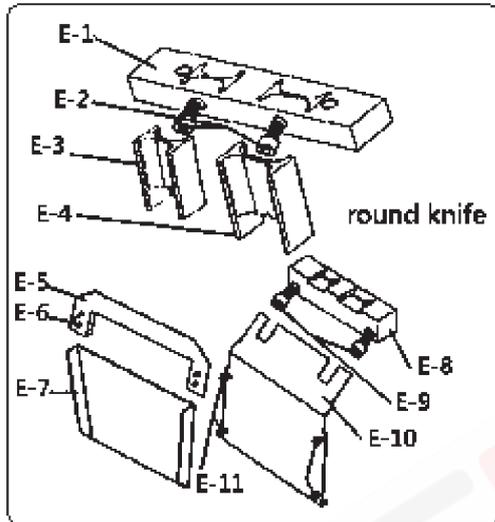
SPARE PARTS



PARTS DRAWING

Part No.	Description	Part No.	Description
D-1	Heating spring	D-26	Washer
D-2	Heating spring	D-27	Clamping bolt M3
D-3	Screw cap	D-28	Spring
D-4	Hot knife	D-29	Tape tension plate
D-5	Thermal shield		
D-6	Clamping bolt M4		
D-7	Neck washer		
D-8	Bed plate		
D-9	Guide way plate		
D-10	Spring		
D-11	T-shape bolt		
D-12	Pressing sleeve		
D-13	Washer		
D-14	But		
D-15	Bolt M5 × 30		
D-16	Bolt M3 × 5		
D-17	Bolt M8 × 28		
D-18	Washer		
D-19	Upper knife holder		
D-20	Lower knife holder		
D-21	Lower knife packing block		
D-22	Lower knife		
D-23	Bolt M5 × 15		
D-24	Bearing		
D-25	Shaft ring		

SPARE PARTS



PARTS DRAWING

Part No.	Description	Part No.	Description
E-1	Upper cutting die soleplate	E-23	Tension-control washer
E-2	Bolt M6×12	E-24	Tension-control nut
E-3	Upper cutting die(1.5/1.0)	E-25	Clamping bolt(M5×30L)
E-4	Upper cutting die(2.0/2.5)	E-26	Front cover
E-5	Baffle	E-27	Clamping bolt(M3×5L)
E-6	Bolt M3×5	E-28	E-ring
E-7	Material guide plate	E-29	Ball bearing(#6000)
E-8	Lower cutting die	E-30	Crank bundle
E-9	Bolt M6×32	E-31	Wrench bolt(M5×10L)
E-10	Front cover	E-32	Knife case(L/LR/R)
E-11	Bolt M3×5	E-33	Motor key
E-12	Bolt M6×30	E-34	Motor+reduction gear
E-13	Washer	E-35	Clamping bolt(M5×42L)
E-14	Upper knife holder	E-36	Motor supporter
E-15	Clamping bolt(M4×6L)	E-37	Snap ring
E-16	Couting –sensor bracket	E-38	Ball bearing(#6004)
E-17	Lower knife (cold)	E-39	Clamping bracket
E-18	Bolt M5×10L	E-40	Couting sensor
E-19	Left pressure plate	E-41	Clamping bolt(M3×20L)
E-20	Pressure spring	E-42	Clamping bolt (M3×15L)
E-21	Clamping bolt of pressure plate	E-43	Right pressure plate
E-22	Urethane bush	E-44	Upper knife (cold)

TAIZHOU JEMA SEWING MACHINE CO.,LTD.

ADD: Liuyang Industrial Zone, Xiachen, Jiaojiang,
Taizhou, Zhejiang, China

Http : [//www.chinajema.com](http://www.chinajema.com)

E-mail : jema@chinajema.com

Tel : 0576-88172026 88157528

FAX : 0576-88172167

P.C. : 318010