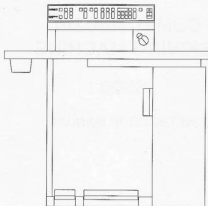


COMPUTERIZED SKIVING MACHINE

SS20

INSTRUCTION MANUAL



Model

SS20

Serial No.

Manufactured by

COMELZ spa

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COMELZ_ITALIA
<http://www.comelz.com>

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1. DESCRIPTION OF THE MACHINE



Picture 1

The SS20 Computerized Skiving Machine, manufactured by COMELZ and outlined in picture 1, is used to skive the edge of leather components and of other materials of similar nature.

The operative inserts the component piece under a guide; a roller feeds it against a bell-shaped knife that cuts the exceeding material.

2. PROTECTIONS USED FOR SAFETY PURPOSES, picture 2



Picture 2

A) Handling

The low weight of the machine does not cause handling problems.

Correct procedures to handle the machine are described in chapter 5.

B) Use

Covers fixed with screws to the frame protect from electrical and mechanical hazards.

- The SP27 cover protects from the knife and other moving mechanical parts. The machine turns off when this cover is opened.

It is not enough to press the safety micro-switch to turn on the machine again.

- A brake fitted to the knife motor stops the rotation of the knife when the SP27 lid is opened.

Warning! Never operate the machine without its covers in place.

IMPORTANT - For safety reasons remove the knife cutting edge (use a grindstone) before any maintenance service. The knife, even when idle, has a very high cutting potential.

C) Maintenance

The machine does not require specific preventive maintenance service.

Warning! Maintenance servicing, for its very own nature, can be necessary when the machine does not work correctly. For this reason, as a rule during maintenance operations, it is extremely hazardous to rely on the correct functioning of safety devices, even when they appear to be perfectly working. See chapter 10.1.

3. TECHNICAL SPECIFICATION

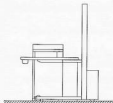
- Skive width**
adjustable from 0 through 20 mm
- Skiving speed**
adjustable from 0 through 750 mm/s
- Knife rotating speed**
2700 rpm
- Overall dimensions**
height 1030 mm
width 1050 mm
depth 550 mm
- Mass**
net weight 145 kg

4. CONTEMPLATED AND NOT CONTEMPLATED USE OF THE MACHINE

The SS20 machine was designed to skive the edge of leather pieces and plastic materials with similar characteristics. It is commonly used to manufacture shoes, leatherware and leather garments.

Unconventional use can procure serious injuries to the operative and damage the machine.

5. HANDLING AND TRANSPORTATION



Picture 3

The lifting and transportation of the machine must be performed by skilled personnel with adequate equipment to deal with its dimensions and weight.

The machine must be secured as indicated in picture 3.

6. INSTALLATION OF THE MACHINE

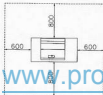
6.1 OVERALL DIMENSIONS



The overall dimensions of the skiving machine are shown in picture 4.

Picture 4

6.2 REQUIRED CLEARANCE



Position the machine so as to leave enough clearance to allow servicing, as shown in picture 5.

Picture 5

6.3 ENVIRONMENT

- Do not place the machine in rooms with explosion or fire hazard.
- Shelter the machine from bad weather.

7. PREPARATION OF THE MACHINE FOR THE INSTALLATION**7.1 CLEANING AND INSPECTION**

- Make sure that the various components of the machine were not damaged during transportation and handling.
- Accurately clean the machine from dust and smearing substances, if any.

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8.3 TOUCH-PAD - SKARF, picture 7



8.3.1 Adjustment of the skive width

T16 - To increase the width of the skarf.

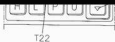
T17 - To reduce the width of the skarf.

D15 - It shows the selected width.

The symbol -- is shown when the width is increased beyond number 80; the ST16 work gauge moves under the work surface and the component must be guided against the fixed gauge under the presser foot.

8.3.2 Adjustment of the skive thickness

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Picture 9

and they are grouped into two programs of 8 styles each. Therefore one number (from 0 through 99) and any one of the 8 letters identifies each skarf style.

The machine retains in memory the following data for each skarf style:

Width

Thickness

Inclination

Feed speed

Feed mode (pedal or continuous)

- Press the SN27 pedal to step from one skarf style to the next.

8.6 TOUCH-PAD - KNIFE



Adjustment of the gap between the SQ1 knife and the SU16 presser foot.

T5 - It moves the knife toward the SU16 presser foot.

T6 - It moves the knife away from the SU16 presser foot.

D4 - It shows the selected adjustment.

The minimum value is 00 (zero), the closest to the presser foot. The maximum value is 50, that resembles a gap of approximately 1 mm.

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Press the T8 touch button again to stop it.

T8 - It starts and stops the sharpening.

D7 - When the lamp is on, the sharpening is active.

T9 - It starts and stops the grindstone dressing.

Grindstone dressing is automatically executed according to the pre-set parameters.

D8 - When the lamp is on, the dressing is on.

D9 - When the lamp is on, the dressing is neither executed automatically nor it can be started by pressing the T9 touch button.

T10 - Press it repeatedly to select programmable parameters.

D10 - They show which parameters are selected.

T11 - To increase the value of the selected parameter.

T12 - To reduce the value of the selected parameter.

D11 - It shows the value of the setting.

8.8 TOUCH-PAD - SHARPENING AND DRESSING PROGRAMS, picture 12

Use the T10 touchbutton to select the following options:

D10/1 - Sharpening pressure.

Minimum value 5

Maximum value 80

Recommended value 10 - 20

D10/2 - Programmed sharpening time on.

Minimum value 1 s

Maximum value 99 s

Recommended value 10 s

D10/3 - Time interval between two sharpening cycles.

Minimum value 1 min

Maximum value 99 min

Recommended value 2 - 10 min

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presser foot parallel to the feed roller and skimming it.

WARNING! While adjusting this clearance be careful not to move the presser foot against the feed roller, to prevent damaging both.

- Press the T4 touchbutton twice.
The D3 lamp goes off.

WARNING! The machine only works when the D3 lamp is on.

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8.10 PRESSER FOOT LIFTING

The SN12 toggle switch (located under the table on the right, at knee-height) controls the full lifting of the presser foot.

Press the switch once to lift the presser foot and a second time to move it back to working position. Three lines show on the D16 picture 7 display while the presser foot is released.

8.11 ADJUSTMENT OF THE FEED ROLLER, picture 14

SR32 - To adjust the vertical position of the SR45 feed roller.

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10. MAINTENANCE OF THE MACHINE

Warning! Always turn off the machine when carrying out maintenance.

10.1 REPLACEMENT OF THE KNIFE

This operation must be carried out by qualified personnel.

IMPORTANT - For safety reasons wear heavy gloves and remove the cutting edge of the old knife (use a grinder) before replacing it. The knife, even when idle, has a very high cutting potential.

To replace the knife do the following:

- Move the knife away from the presser foot, picture 10, by pressing the T6 touchbutton.
- Turn off the machine and open the SP27 lid, picture 2.
- Move the knife all the way to the right by turning clockwise the SY23 knob, located on the right side of the machine's body, till it stops.
- Tilt the knife electro-spindle.
- Remove the SQ29 scrap deflector.

- Remove the four SQ2 screws that lock the knife.
- Accurately clean the spindle and the new knife before fitting it.
- Fit the SQ25 spacer in case it was dismantled.
- Adjust the knife zero position (see chapters ZERO POSITION OF KNIFE AND PRESSER FOOT) and execute the sharpening.

It is necessary to re-adjust the knife zero position because of the small size difference of knives that, though small, cause malfunctions.

10.2 GRINDSTONE REPLACEMENT

To replace the grindstone do the following:

- Unscrew the two SQ23 knobs and remove the SQ28 cover.

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D20 - The warning reminds appear on the display in case of malfunctioning of the machine.

D21 - It lights up when the sharpening pressure is too high.

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03 - Missing power supply (12V) to the KK10 PC board.

Turn off the machine and disconnect: the connector of the KM12 pedal, the connector of the KM10 toggle switch and the connector of the SZ22 PC boards cooling fan.

Turn on the machine again; if the error code persists replace the KK10 PC board.

In case the error code does not show re-connect the various components one by one, turning the machine on each time, until the code reappears; replace then the part that caused the malfunctioning.

06 - The KK10 PC board is faulty.

11 - The control of the SV1 stepper motor for THICKNESS adjustment on the KK30 PC board is faulty.

12 - Interruption in the connection of the SV1 THICKNESS motor.

13 - Short circuit in the connection of the SV1 THICKNESS motor.

14 - The control of the SV1 stepper motor for WIDTH adjustment on the KK30 PC board is faulty.

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14. DISMANTLING THE SS20 SKIVING MACHINE

When it is necessary to dispose of the machine, a few essential rules must be followed to protect the environment.

- All components made of plastic or other non-metallic materials must be disassembled and disposed of separately.
- Electrical components (switches, transformers, motors and the like) must be re-used, if possible.
- Metallic parts of the machine must be disassembled and grouped according to the type of material. They must then be demolished and melted separately.

15. SOUND LEVEL OF THE SS20 SKIVING MACHINE

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16. WIRING DIAGRAM



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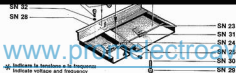
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Angle control

REGOLATORE ALTEZZA
Thickness control

REGOLATORE LARGHEZZA
Width control

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SV01.M = molla (4x)
spring (4x)

SV01.D = bussola di guida
guide sleeve

SV 12

SV 2

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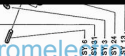
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SY31 = diametro albero
SY1 = diametro albero
(tipo vecchio / old type)

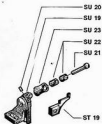
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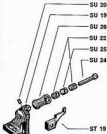


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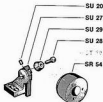
SU100

Gruppo piedino rotante L = 20mm.
Presser foot with roll L = 20mm.



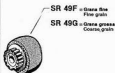
SU200

Gruppo piedino rotante L = 25mm.
Presser foot with roll L = 25mm.



SU300

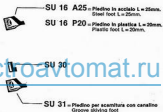
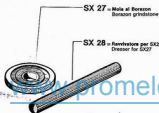
Gruppo per scamire a 45°
45° skiving attachment



Rullo trasportatore in smeriglio
Emery feed roll



Rullo trasportatore in vulkanian
Rubber feed roll



SU 16 A25 = Piedino in acciaio L = 25mm.
Steel foot L = 25mm.

SU 16 P20 = Piedino in plastica L = 20mm.
Plastic foot L = 20mm.

SU 30

SU 31 = Piedino per scamire con canale
Groove skiving foot