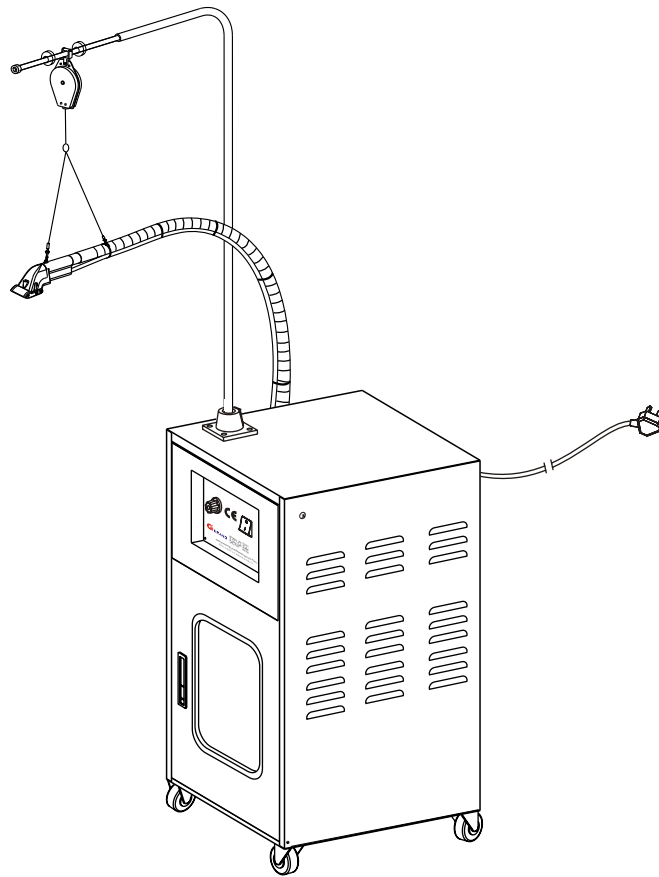


MANUAL



— *HIGH SPEED TRIMMER SERIES* —

MODEL T261

Application instruction

- Application instruction..... (1)
- Clipper blade maintenance (2)
- Vacuum suction motor maintenance..... (3)
- Clipper blade accessory and assembly (4)
- Main box and bracket accessor (5)
- Box components and support components list (6)
- Suction accessor and assembly (7)

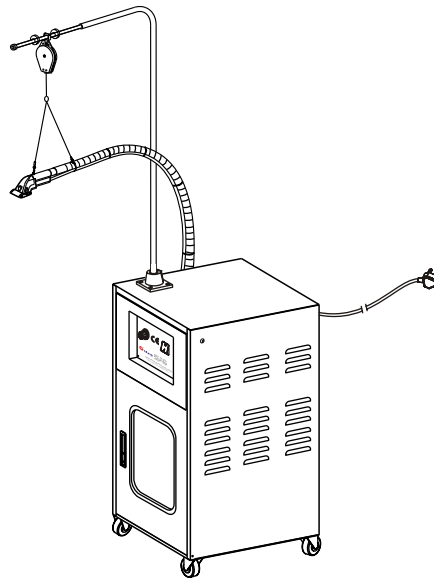
Intruouction

1、 The thread trimmers are particularly made for those who manufacture garments , thread trimmers are the necessary equipments to substitute the procedures of cutting thread ends made by manual labors ,the machines combine the labor procedures of cutting and sucking thread ends in a unit ,there is no remained thread ends left on the garments and surely they keep the working environment clean ,thread trimmers can raise working efficiency and eliminate manual labors ,they are the necessary machines that modern garment factories must possess.

2、 These thread trimmers are small in size ,low voice frequency ,high efficiency for cutting thread ends ,you can easily adjust the cutting speed of thread ends ,the rate of cutting ends is up to 95%,according to your own habit ,you can arrange the blade head cutting direction and the same length of finished thread ends from 1.5mm to 5mm as you wish ,our thread trimmers are particularly suitable for those garments with plenty of thread ends such as clothes made with knitted and women fabrics or denim garments with thick thread ends, as well as for those of computer embroidery factories .

Application instruction

- 1、 There are two plugs at the back of the main machine for the america style ,there is one plug for suction electric thread trimmer and the other for light.
- 2、 Firstly turn the adjust button to the lowest position as shown on picture 5-1 and shake the lube times and spray towards the gaps of the blade teeth ,then spray the drive shaft of the clipper for blades head .
- 3、 Put on the switch of the machine as shown on picture 5-4, and the switch of the table board as shown on picture 5-5, the whole machine is ready to work .
- 4、 At last turn the adjust button to the adequate position according to thickness of the fabric and thread ,at this moment the machine is in working condition .
- 5、 If you find that the thread ends to be cut is too long or too short ,or damage the fabric or unable to cut the thread ends ,please refer to the instruction of clipper blades adjustment .
- 6、 Before using the machine ,spray the lube a time ,also spray the lube to the machine after working for an hour ,when you add the lube to the machine ,adjust the sucking volume to the lowest position and spray the lube to the gaps of upper and lower teeth ,take a piece of cloth to wipe off the excess lube and continue to operate the machine.
- 7、 The filter of suction motor should be cleaned every day ,if necessary ,clean the filter ,the used filter can be cleaned for complementary use .



Description of operation

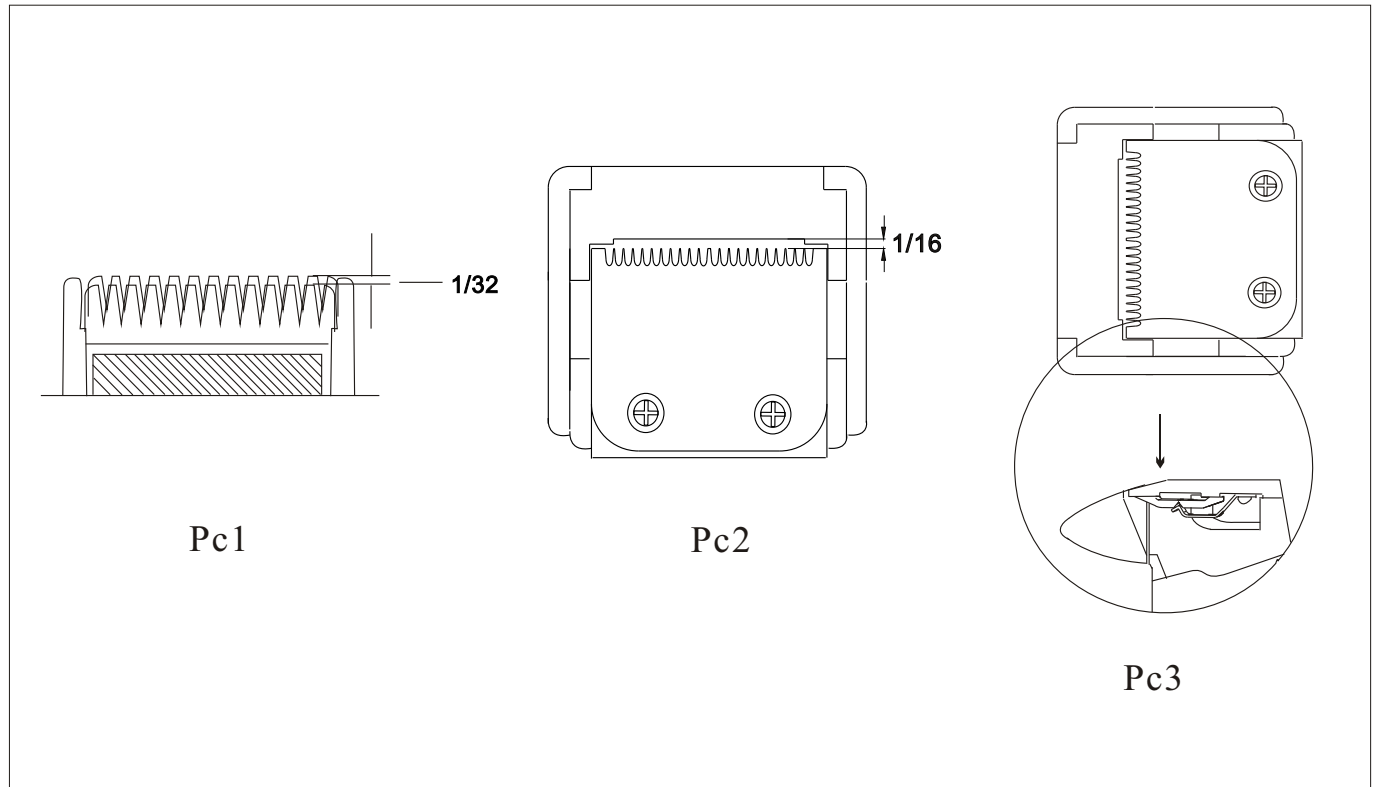
- 1、 Put the thread ends of the finished garment towards the teeth of the Clipper Blade sand horizontally move to and for that you can get the result of cutting thread ends efficiently.
- 2、 According to habitual operation ,you can arrange the distance between you and the Clipper Blades in order to eliminate your tiredness.
- 3、 Choose different blade model and speed according to the quality of fabrics in order to avoid damage to fabrics .below is a table for your reference .

Refer to the following form

Fabric	Pure Silk & wool	Knitted Fabric	Tatting & Jeans
Blade model	046	036	196
Suction scale	2-4	5-7	7-9

Intruouction

1. Whilst re-installation for clipper blade, firstly assure the active blade tip and fixed blade are put together to the correct position exactly. Active blade tip is 0.604mm shorter than fixed one. Such adjustment only needs to release screw with spring washer and in parallel impel active blade.
2. Whilst adjustment for clipper blade wing guard, please retain approximate 1.28mm gap between wing guard and clipper blade tip after completion of the blade installation; if the cloth is extremely thin, 0.64mm adjustment is also acceptable, such manner should avoid any damage of garment or over-lock thread whilst cutoff.
3. Blade tip and wing guard shall retain 0.5mm gap, that is to say, wing guard is 0.5mm higher than blade tip; however, garment or over-lock thread is easily damaged if they both are equal to each other at height; as for some comparatively thinner garment or requirement for over 2mm thread length after cut operation, the gap between wing guard and blade tip must be adjusted into comparative larger setup, herein, only release screw (see Diagram 3) and push down blade assembly until onto appropriate position, replace some thicker wing guard is also acceptable if available.
4. In case clipper blade is blunt, please release the screw tightened on the blade, review if any peculiar substance exists between blade and blade teeth, if some accumulative dirt completely exists which results in unsuitable position whilst thread head feeds into blade, must immediately clean up it completely; also review the stress of tension spring, first left hand holds on fixed blade, and then right thumb and first finger impel active blade, it is ok if feeling 3-3.5kg push force, otherwise, please rectify the spring pressure or replace new one.
5. Once some special sound such as Dadada takes place on the blade head, please release the screw tightened on the blade, review the matching gap between eccentric block and fixed blade, immediately replace the eccentric block if too larger matching gap, whilst checking up if some axial gap exists, also immediately reset it if too larger clearance.
6. No use sewing machine oil or WD-40 instead of grand special thread trimmer oil since these kinds of oil shall shorten the life of blade, however, grand lubricant is one of composite oil with quiet fine, higher specification value, easier solubility to water and mobile viscosity, also beneficial for improvement for blade life.



Remarks

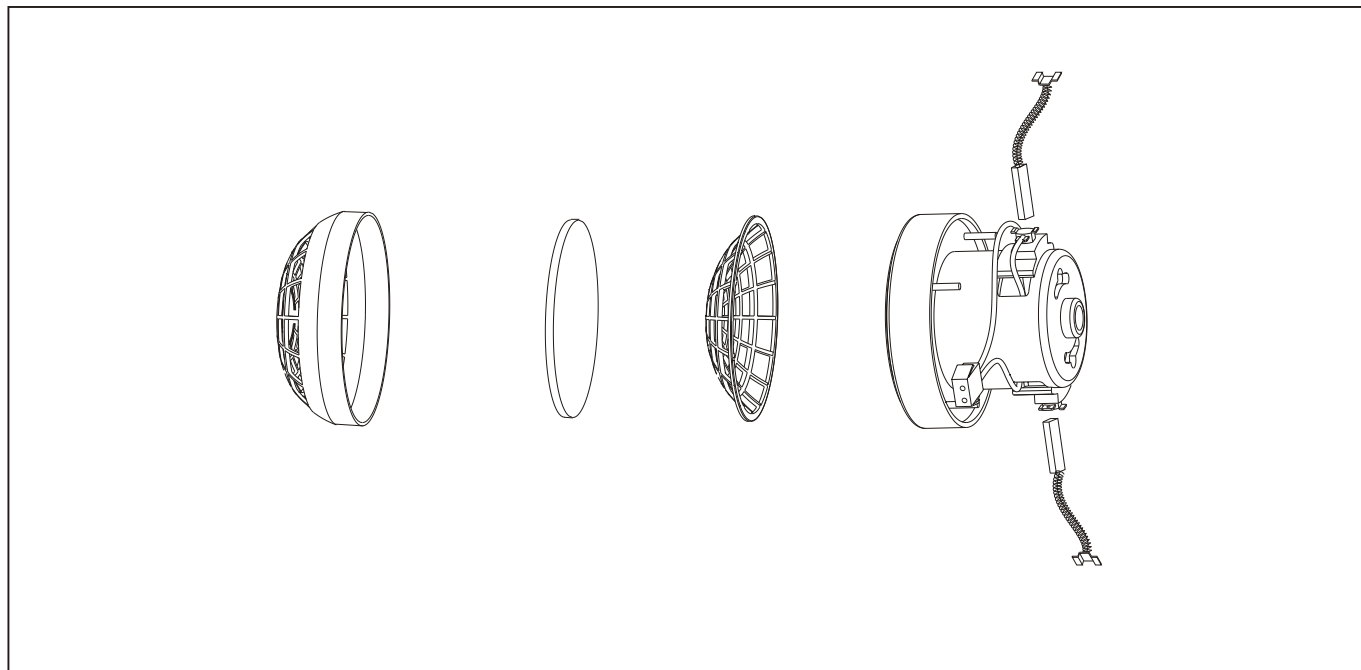
Clipper blades to be used continuously after six months may be blunt, please go to our dealers to sharpen the blades or buy new one.

Vacuumsuction motor maintenance

Suction motor has been to high pressure resistance before factory shipment, which is durable to 1200V and with thermal protection device. Once temperature exceeds 120°C, the motor shall be automatic shutdown, and restart it after temperature lowers to normal one, such operation become more safe and reliable.

If not enough suction force exists in suction motor whilst use, first check up if air speed adjustment knob is at appropriate position, finally check up if the barrel is too filled with thread end and if dustproof cover accumulated too much thread end or dust.

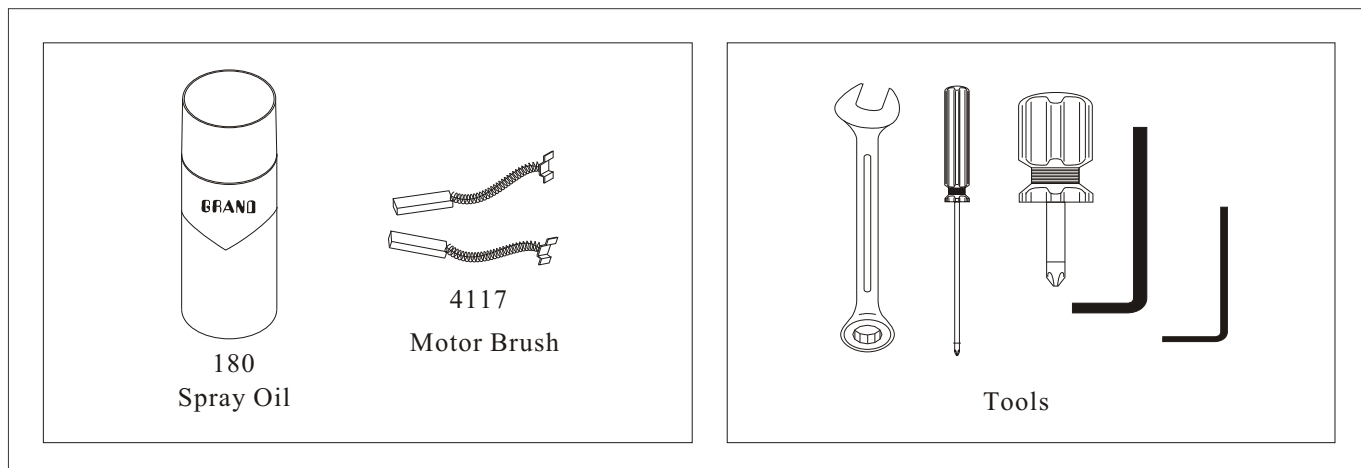
Must clean up plastic barrel once a day, and better cover up it once its better cleanup after operator affirm that dustproof cover is at normal status.



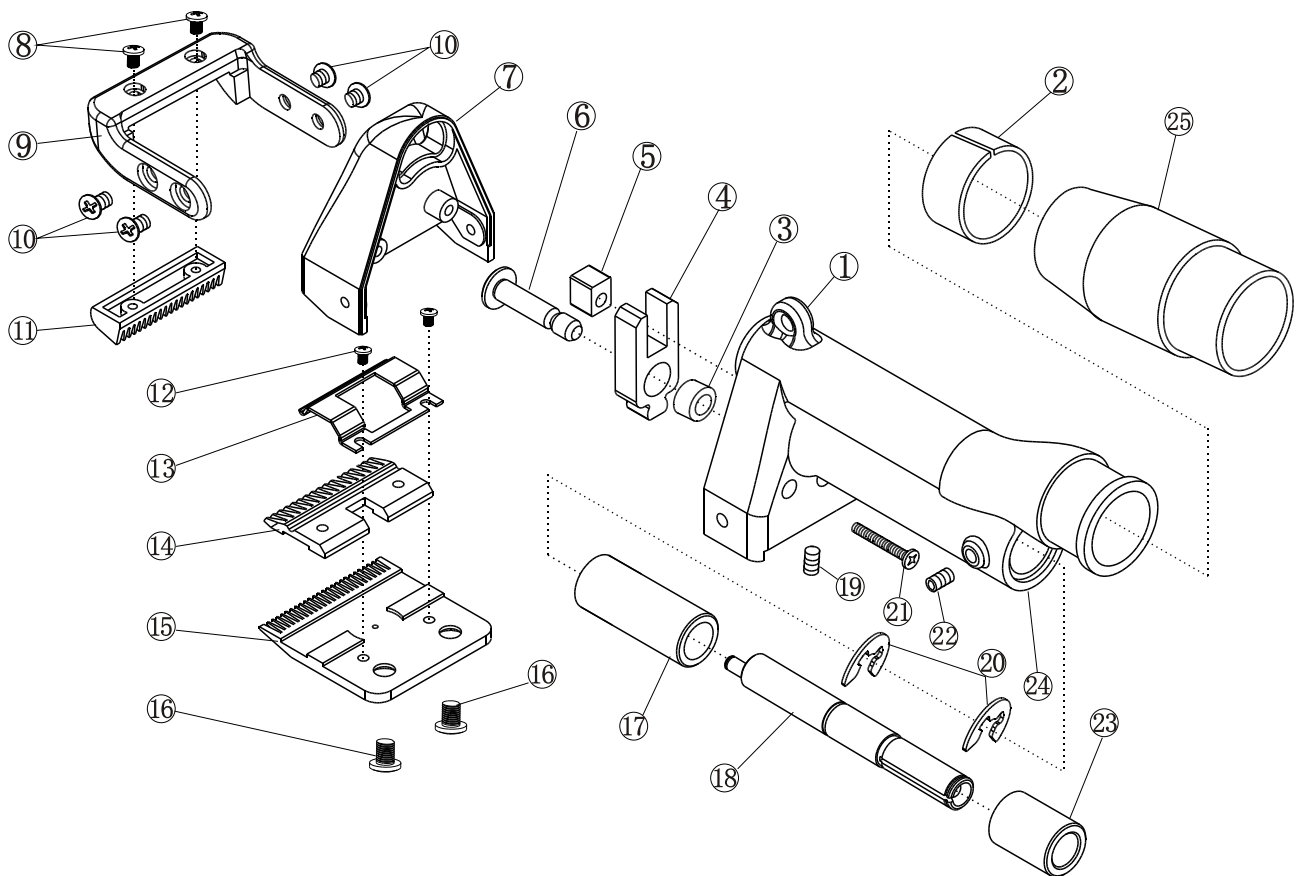
Remarks

For the carbon brush motor, if it works 10 hours per-day, it needs to change the carbons about 800 work-hours.

Accessory

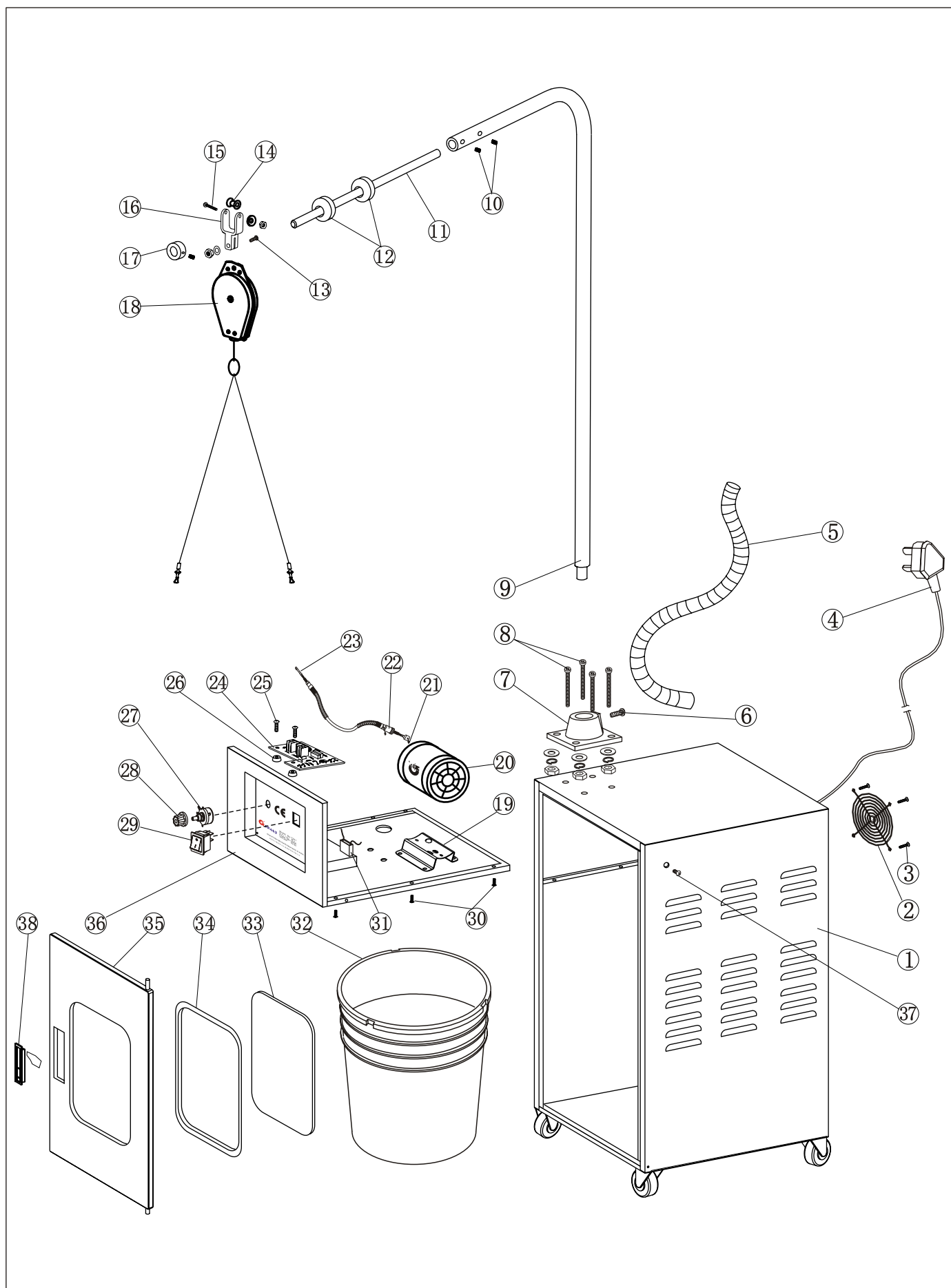


Clipper blade accessory and assembly



No	Part no	Description	Qty	Remarks
1	XM-4-1	Clipper blade base	1	
2	GT26-025	Bushing	1	
3	261-05	Needle bearing	1	0608
4	GT36-016-07	Clipper toggle	1	
5	124D	Eccenrtic block	1	
6	GT36-016-05	Clipper crank shaft	1	
7	XM-4-2	Blade cover	1	
8	M2.5X4	Wind guard screw	1	
9	XM-4-3	Wind guard bracket	1	
10	M4X6	Windguardbracket screw	4	
11	XM-4-4	Wind guard	1	
12	M3X4	Tension spring screw	2	
13	130-3	Tension spring	1	
14	277/242/279	Active clipper blade	1	
15	277/242/279	Fixed clipper blade	1	
16	M5X10	Clipper blade screw	2	
17	181-07-30	Long oil bearing	1	Φ 10X30
18	GT36-016-06	Drive shaft	1	
19	M4X8	Crank shaft	1	
20	181-08B	Open washer	1	Φ 7
21	M3X25	Blade head fixed screw	2	
22	M5X8	Flexible shaft fixedscrew	1	
23	181-07-22	Short oil bearing	1	
24	GT36-016-04	Aluminum pipe	1	
25	GT26-023	Chain check pipe	1	

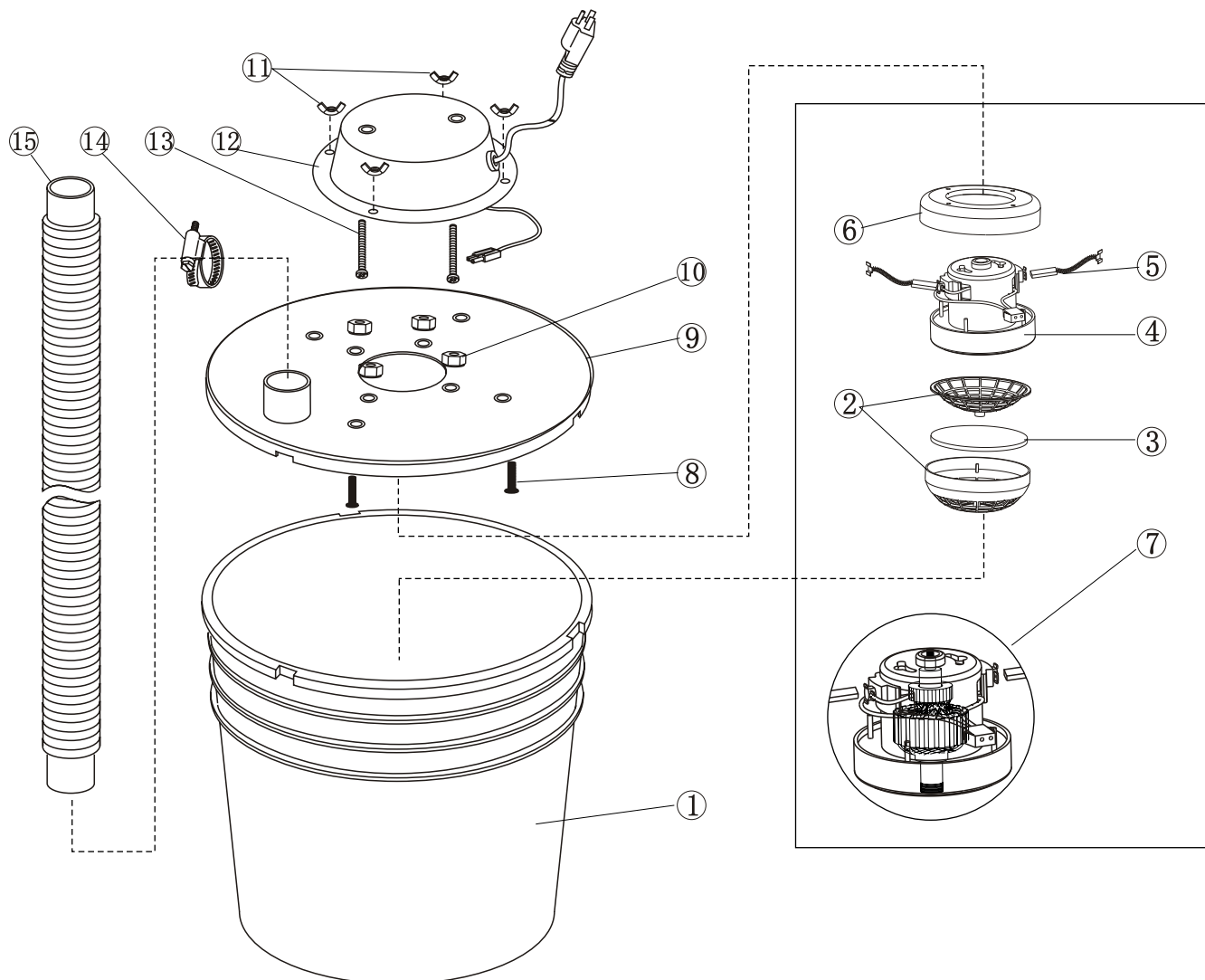
Main box and bracket accessor



Box components and support components list

No	Part No	Description	Qty	Remarks
1	T261-001	Inside box	1	
2	120X120	Air fan cover	1	
3	M4X24	Screw	4	
4	220V/16A	Plug wire	1	
5	182-10	Hose	1	
6	M6X20	Screw	1	
7	222-02	Flange base	1	1 flat nut, 1 spring washer
8	M6X60	Screw	4	
9	GT26-003-02	Support pipe	1	
10	M4X6	Screw	3	
11	GT36-003-04	Active support pole	1	
12	Φ 15X Φ 25	Nursing aprons	1	
13	M4X20	Screw	1	1 flat nut, 1 washer
14	GT36-022-01	Moving wheels	1	
15	M4X30	Screw	1	1 flat nut, 1 washer
16	GT36-003-02	Link a piece	1	
17	GT36-003-03	Orientation ring	1	
18	GT26-008	Balancer	1	
19	GT26-06	Motor fixation	1	
20	182-01	Clipper motor	1	
21	M3X4	Screw	2	
22	182-05	Motor coupling	1	
23	182-06-C	Flexible shaft wire	1	
24	TSZJ-220V	Circuit board	1	
25	M4X14	Screw	2	Flat 2 nut
26	182-18	Robber stand	1	
27	10K/2W ±5%	Regulation resistance	1	
28	182-12	Adjustment knob	1	
29	250V/10A	Switch	1	
30	M4X8	Screw	6	
31	2.5UF/450V	Capa citor	1	
32	183-02	Plastic containre	1	
33	T261-001-03	Glass doors	1	
34	T261-001-08	Aprons sealed	1	
35	T261-001-02	Door plank	1	
36	T261-001-06	Separate plank	1	
37	M4X20	Screw	2	
38	T261-001-07	Hold the door	1	

Suction accessor and assembly



No	Part No	Description	Qty	Remarks
1	183-02	Plastic container	1	
2	183-06A	Filter frame	2	
3	183-06B	Filter sponge	1	
4	183-01	Motor fly	1	
5	4117	Carbon brush	2	
6	183-08	Motor washer	1	
7	183-01-Z	Motor rotor	1	
8	M5X14	Screw	4	
9	183-03	Mounting plate	1	
10	M4	Wing nut	4	
11	M5X4	Screw	4	
12	183-04	Motor cover	1	
13	M6x60	Screw	1	
14	183-11	Hose clamp	1	
15	183-10	Hose	1	