SU LEE MACHINE ®

FULLEY AUTOMATIC END CUTTER

MODEL : FA-200

INSTRUCTION BOOK AND PARTS BOOK

SU LEE MACHINE IND. CO., LTD.

MAINTENANCE & PARTS REPLACING

A. ADJUSTING THE GRINDER:

When the blade is worn out, adjust the grinder position by unscrewing the screw for the grinder arm so as to ensure a correct distance between the grinder and the blade edge. After finishing adjustment, screw up the screw.

B. REPLACING THE GRINDING WHEEL

Take off the grinding wheel (2626) by unscrewing it off. Mount the new grinding wheel then.

C. REPLACING THE KNIFE

1. Take off the grinsing wheel unit (F).
2. Unscrew the lock nut(G) for the knife.
3. Take off the knife.
4. When mounting the knife, make sure that the side printed with "SU LEE SPARE PARTS" should be placed gacing the operator.
5. After the blade is replaced, adjust the position of the grinder (B) at the proper.

D. REPLACING THE LOWER BLADE

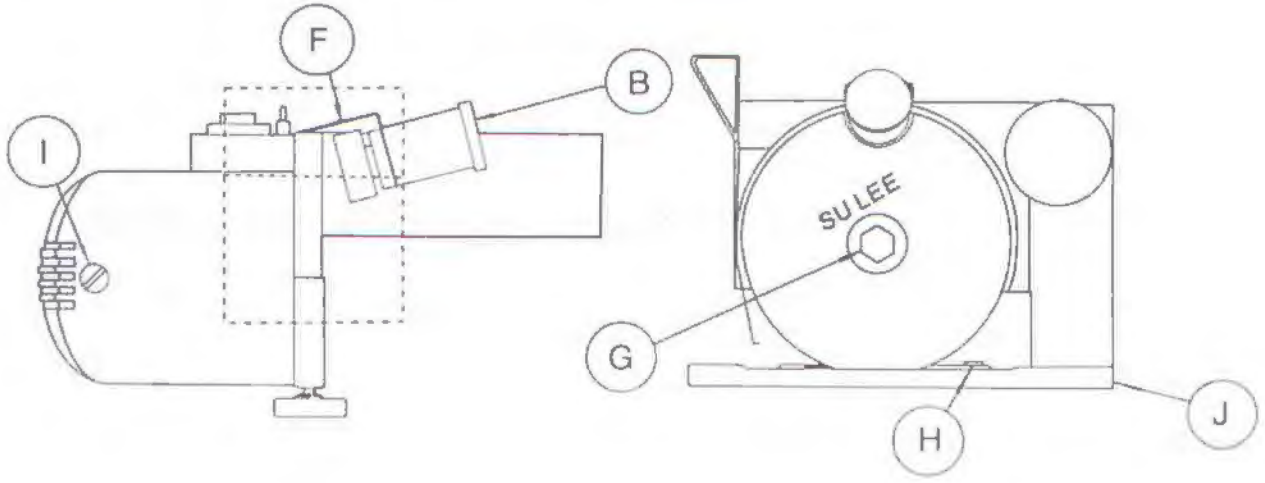
1. To take off the lower blade arm by unscrewing the screw (H) for the lower blade arm.
2. Replacing the lower blade by unscrewing the fixed screw.Replace the lower blade and ensureb the flat surface of the lower blade adjacent to the blade edge.

E. REPLACE OF CARBON BRUSH

1. Too much weaving of carbon brush will cause motor troubles. Carbon brush must be replaced when it wears to 5 ~ 6 m. m.
2. Carbon brush cap (I) is replaced by turning it left by attached wrench.
3. Always replace right and left carbon brushes simaltaneously.
4. Be sure to hold metallic part of the brush. Keep fingers away from carbon.

F. CLEAN THE TRACK AND THE MASTER MACHINE

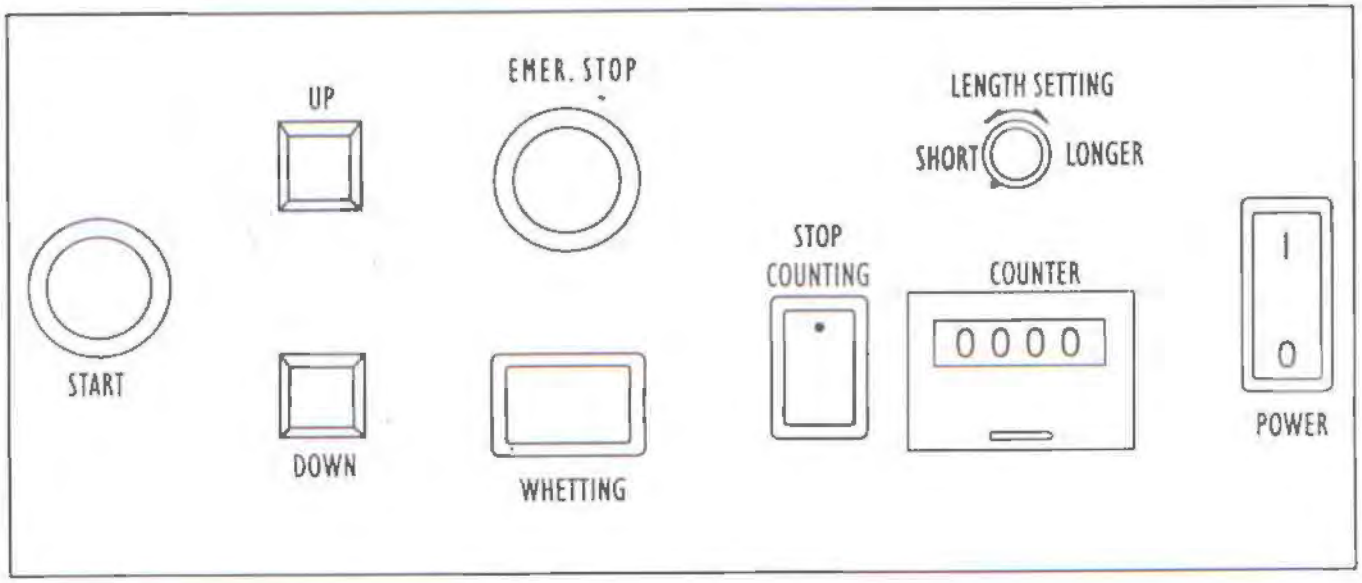
1. Clean all the wasted cotton and cloth in the track with a brush thoroughly after the machine is con tinuously running for 10 to 20 hours.
2. To take the master machine of the track and thoroughly clean the L-shaoed track with a brush after the machine is continuously running for 30 days. Repeatedly clean it as shown in Item (1). To mount the master machine in the track groove again after cleanness is ensured.



FA-200 INSTALLATION INSTRUCTION

1. Following the figure instruction, fixing lift motor set clamp (A) at the right side of the cutting table.
2. Fixing another set clamp (B) at the left side of the table opposite to the lift motor set clamp.
3. Fasten fist one end of the LIFT BELT into the BELT PRESS PIECE of the CLAMP ASSEMBLY and allow the other end to pass through the ROLLER of the BAR LIFTER, crossing under the RAIL thread through the ROLLER of the BAR LIFTER, then through the DOWN ROLLER on the BAR LIFTER finally tinghten it in the BELT PRESS PIECE.
4. Place rail (C) onto lift rod. Note: The end with power line out should be placed at the lift motor set clamp side.
5. Fasten both ends of the rail (C) onto the lift rod with set screws (E).
6. Hook the gear belt hook (F) from bottom upward onto the rear side. Put cutter (G) inside rail (C).
7. Fix Transmission motor assembly (H) at the power line out end with rail fixing screw (E), and connector the two plugs.
8. Fix belt pulley (I) at the other end of rail with rail fixing screw (E).
9. Wind the other end of belt across transmission gear (H), through bottom of the rail (C), up to the oppo site side belt pulley, back to inside of rail (C), then hook on to the front of cutter.
   (Note: Inspect the belt, make sure it is not twisted, otherwise it will endanger the operation)
10. Adjust gear belt by means of belt adjusting screw (J) to a suitable tension (about 5 mm)
11. Install control box frame (K), and place control box (L) onto it.
12. Installation of wiring bracket :
    a. Fixing set clamp (M) at cutting table.
    b. Install wiring pipe (N) and supporting bracket (O).
    c. Lead twin hole electric wire (Q) through wiring pipe (R) downward from the top.
    d. Install receptacle reserve suitable end length, then fix it with binding belt.
13. Installation of fabric supporting rack:
    a. Fix fabric supporting rack to both sides of the cutting table.
    b. Install lever respectively to the two fabric supporting rack.
    c. Insert the iron tube.
    d. Place on the fabric support rod to finish the installation.
14. Insert three wires respectively twin holes, five holes, and seven holes into the receptacles underneath control box (L).

FUNCTION OF KEYS



Power Switch : Turn on Power Switch, the lights up, shows power is on.

Length Setting Tuner : Setting cutter foward feeding distance, turn to the right for larger distance, to the left for shorter.

Counter : Counting number of layer that has been cut.

Counter Stop Switch : Control operation of counter.

Emergency Stop Switch : Stop all operations.

Lift up Switch : Use this switch for singly lift up.

Down Switch : Use this switch for singly descending.

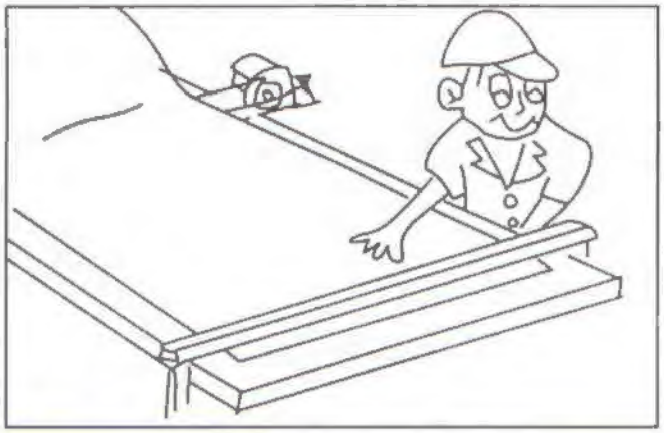
Cutter Sharpening Switch : Turn on cutter sharpener switch (Indicator lights up), shows power for cutter motor in on. Motor starts to rotates.

Starting Switch : Enable cutter to fully automatic operate.

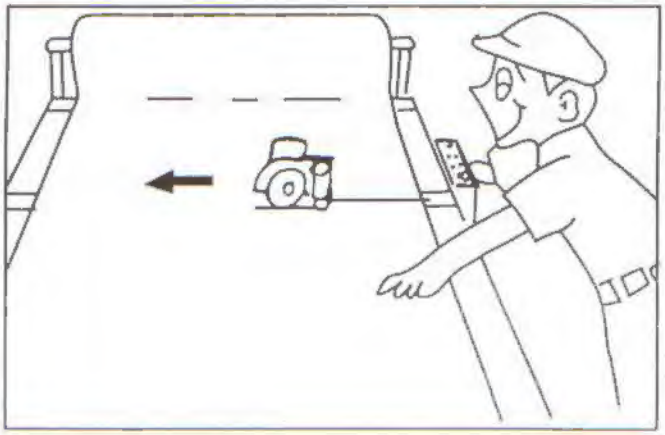
Operation instruction

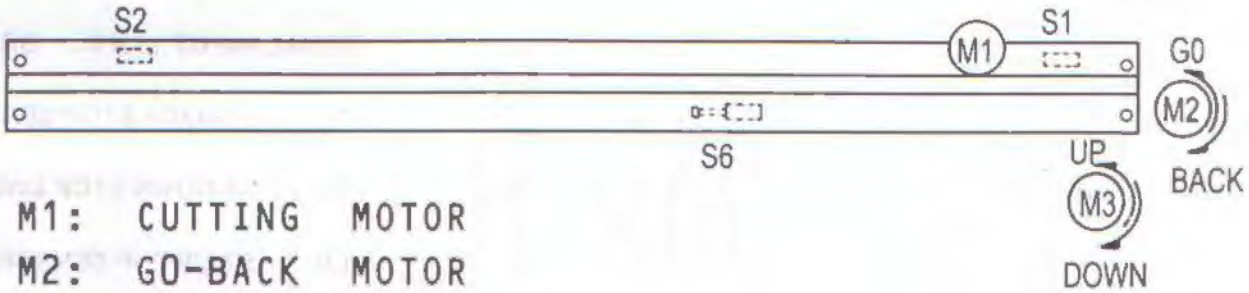
1. Befing operating the machine, make sure of complete cleanness of the track surface.
2. Turn on the power switch (light up)
3. Push one buttom START SW. Then the computer box will reset 5 second.
4. Turn on WHEETING SW. (light up) and grind the knife fdge sharp by pushing the grind switch (pare no. 2623) for several time. And turn off.
5. Push the COUNTER reset to 0000 and exect the STOP COUNTER SW. is on can begin use.
6. A Spreading cloth to angle track and lay down.

B Push UP SWITCH then the cloth press track will up then down.



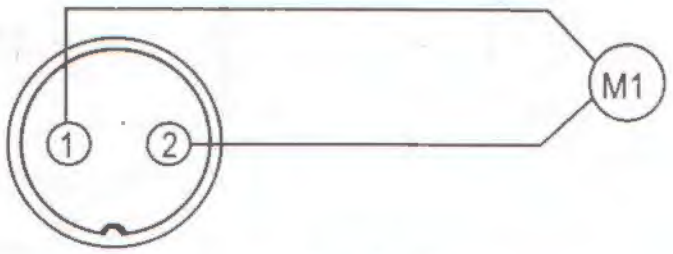
C Push START SW the cutter will automatic cutting and track up and down.



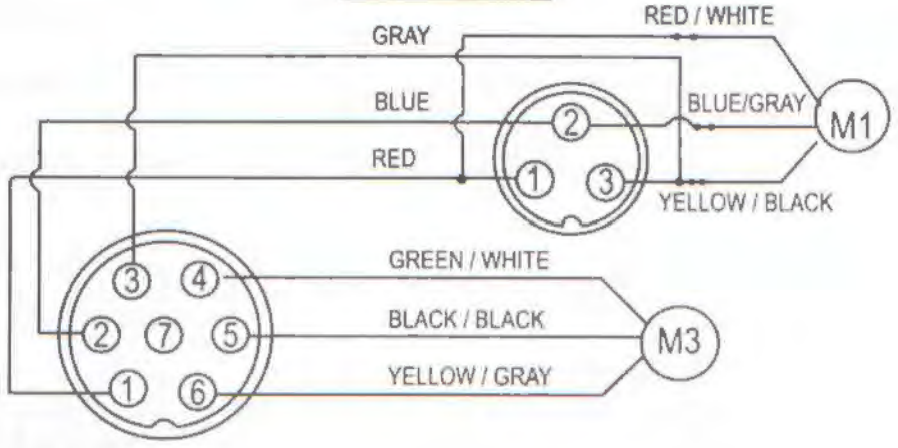


M1: CUTTING MOTOR
M2: GO-BACK MOTOR
M3: UP-DOWN MOTOR
S1: BACK STOP SENSOR
S2: RETURN SENSOR
S6: DOWN STOP MICRO SWITCH
S7: UP TOP SENSOR

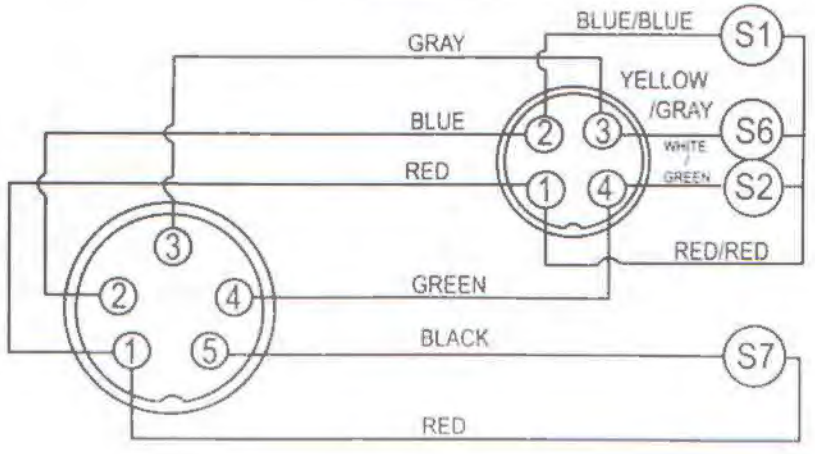
AC OUTPUT

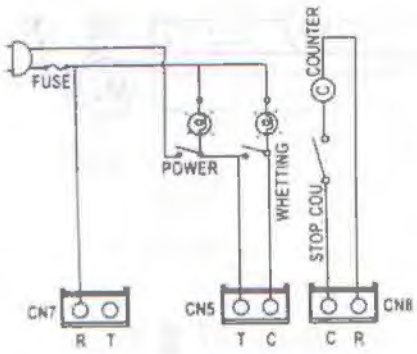


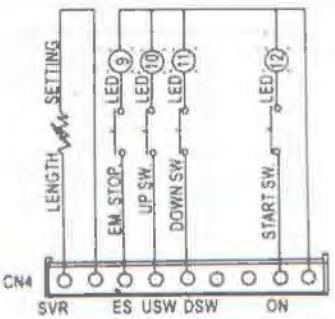
AC OUTPUT



DC INPUT







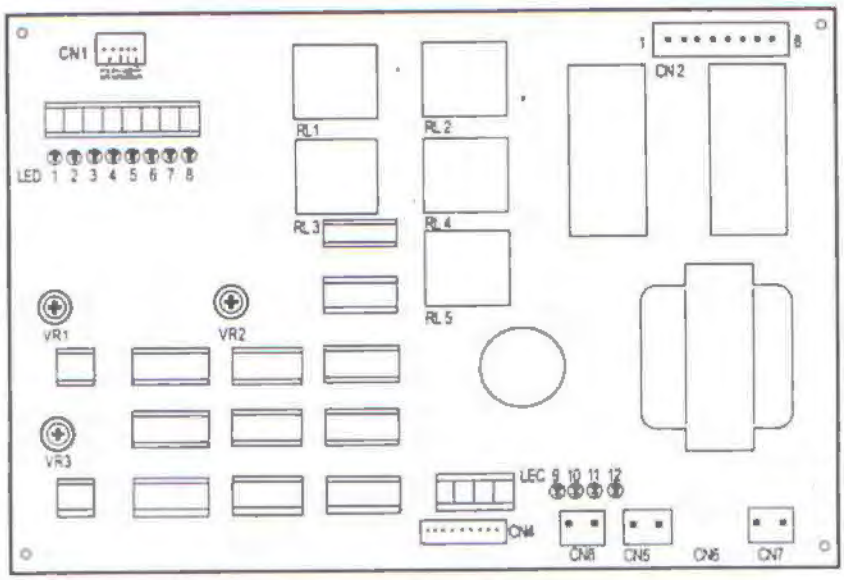
SIGNAL INPUT LIGHT: GREEN

LED 1 : S1-BACK STOP SENSOR

LED 2 : S6-DOWN STOP SWITCH

LED 3 : S7-UP TOP SENSOR

LED 4 : S2-RETURN SENSOR



LED 9 : EMER. STOP SWITCH

LED 10: UP SWITCH

LED 11 : DOWN SWITCH

LED 12 : START SWITCH

POWER OUTPUT LIGHT: RED

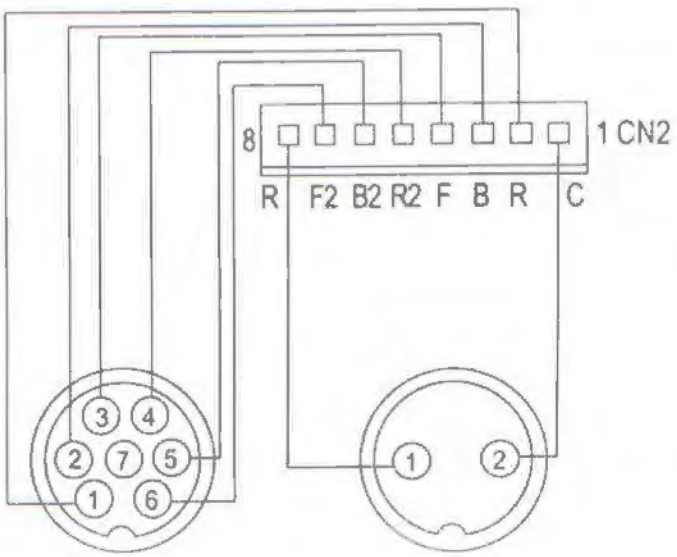
LED 5 : CUTTER MOTOR TURN. AND GO

LED 6 : TRACK LIFT

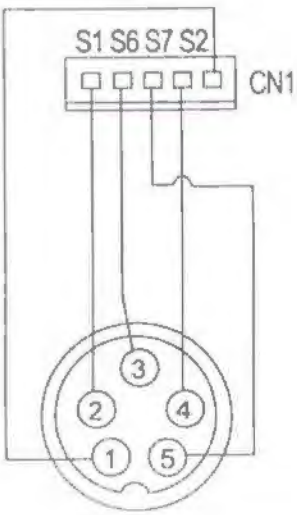
LED 7 : TRACK DOWN

LED 8 : CUTTER RETURN

AC OUT PUT



DC IN PUT



SIMPLE TROUBLE FIXTING

Open the control box cover, when the STAR SW. for normal action is pressed.

LED 5 lights up :	Cutter is rotating and go
LED 5 goes out :	Cutter rotating and go stop
LED 8 LED 6 light up :	Cutter reversing and track lift (LED2 goes out)
LED 8 goes out :	Cutter reversing stop
LED 6 goes out :	Track lift stop
LED 7 light up :	Track moveing down
LED 2 light up :	Track has reached the button
LED 7 goes out :	Track moving down stop

SIMPLE TROUBLE SHOOTING OF FA-200

Q1: When the track can only move up and cannot move down. it is probably caused by:

Ans: the stuck microswitch under the track or the broken wire of the motor controlling up-and-down movement. To remove the trouble of the microswitch under the track. To check if the LED Light (2) keeps lighting;if the light doesn't light up, this indicates that it switch is still stuck.

Q2: When the track cannot stop when moving down or its chain can easily drop off, this is probably caused by.

Ans: malfunction of the microswitch under the track.
Check if the LED Light (2) keeps lighting. If it doesn't light up, no signal for stopping the descending track has been keyed in. Under such case, straighten the microswitch and check the circuit.

Q3: When the cutter doesn't rotate, it is probably caused by:

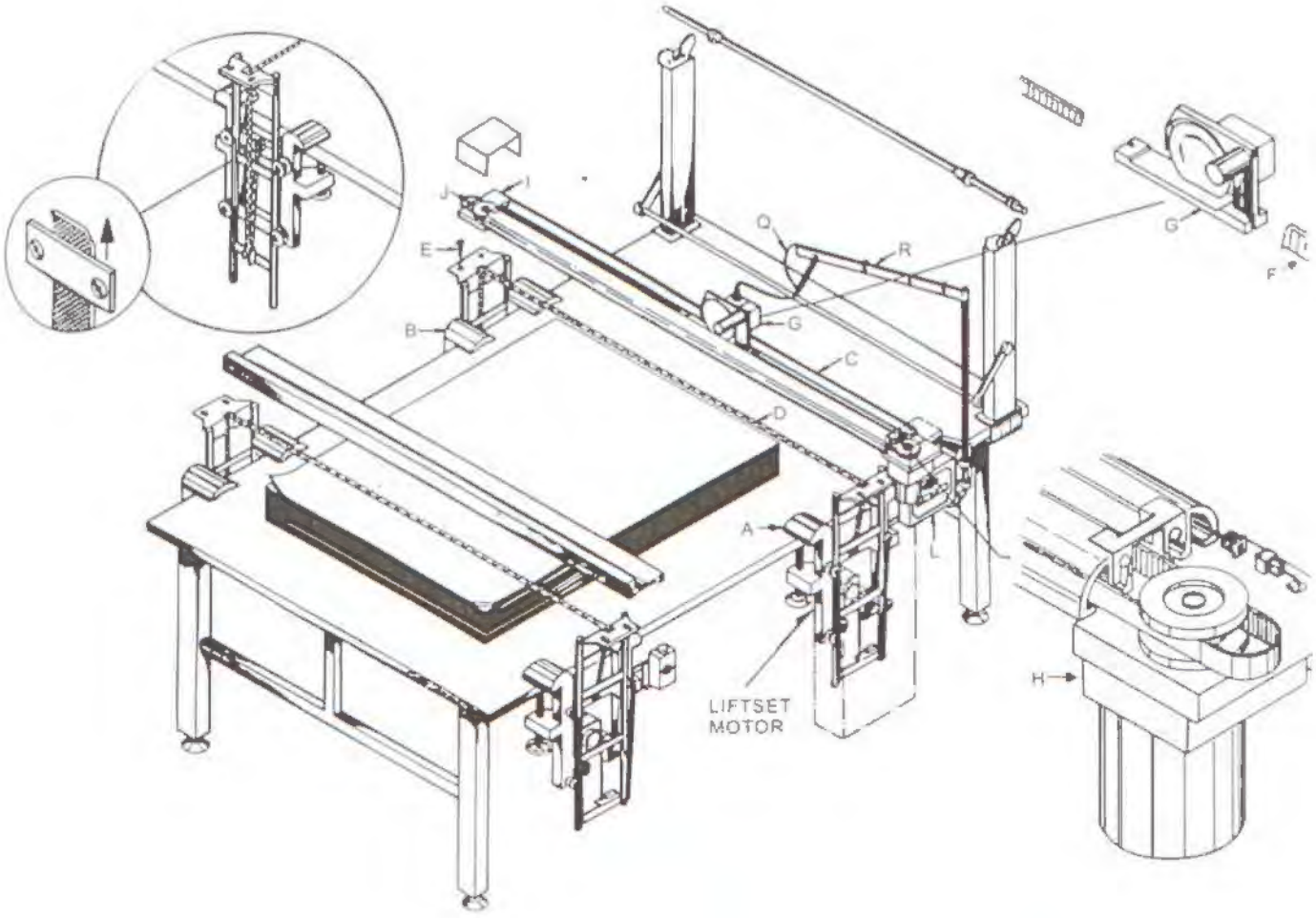
Ans: the broken wire between the control box and the cutter.
So far as the cutter advances, there is output of the power: check the outer circuit and the control box.

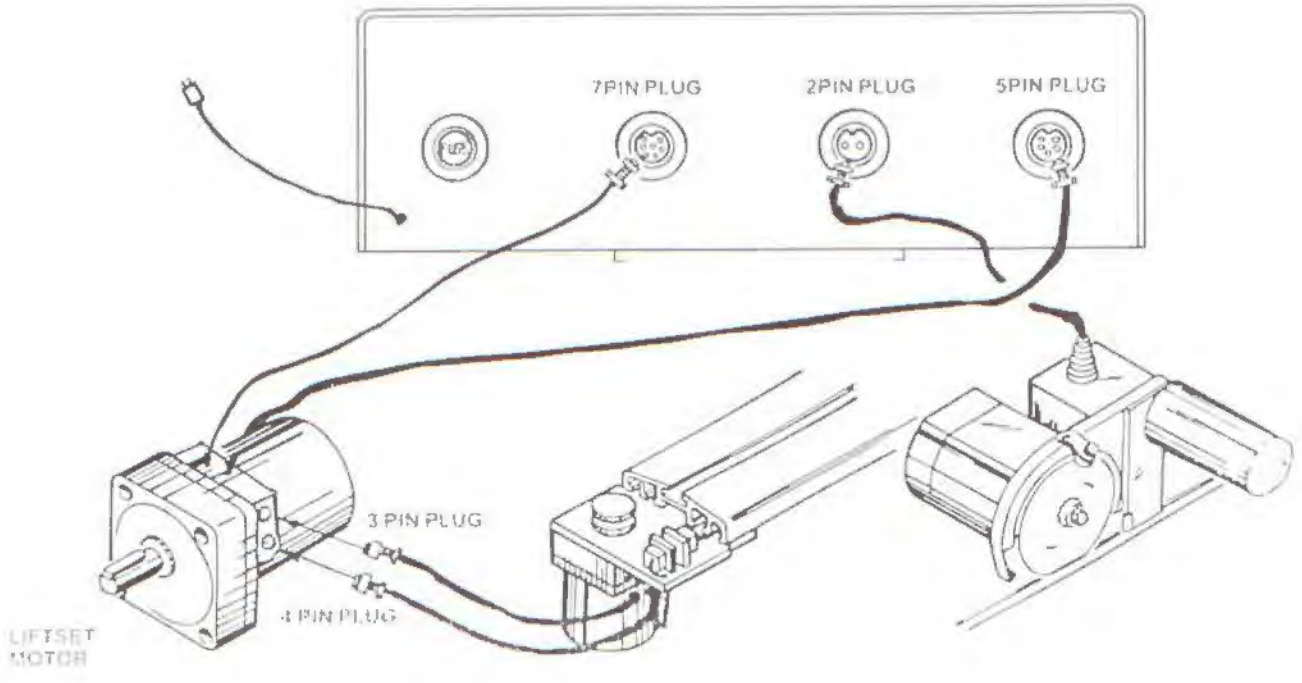
Q4: When the cutter advances to the end, severe bump occurs. it is probably caused by:

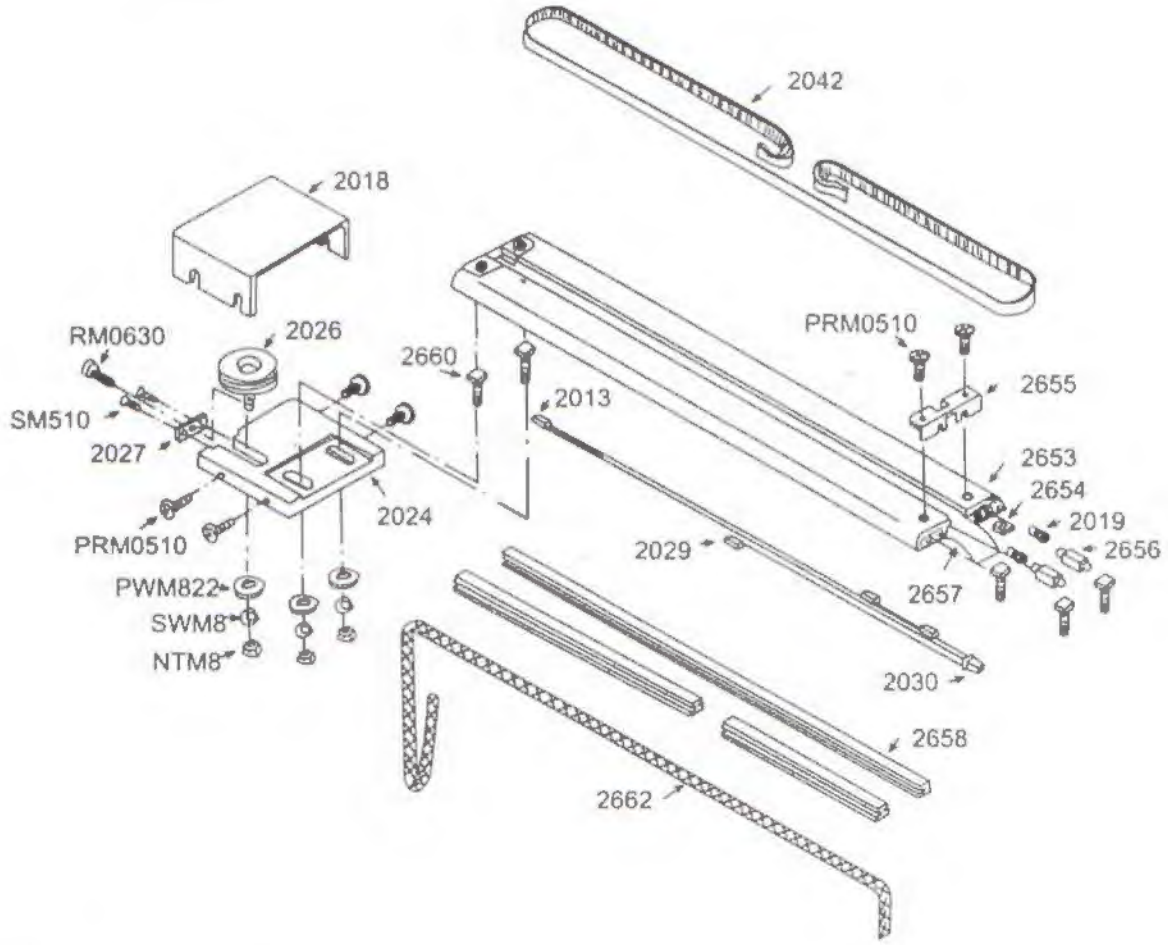
Ans: Open the control box and check the LED Light (4); and the lights don't light up, this indicates that no signal of sensing reversing has been keyed in. If so, inspect the outer circuit with an electric meter and ensure if there is any broken circuit and Sensor Switch.

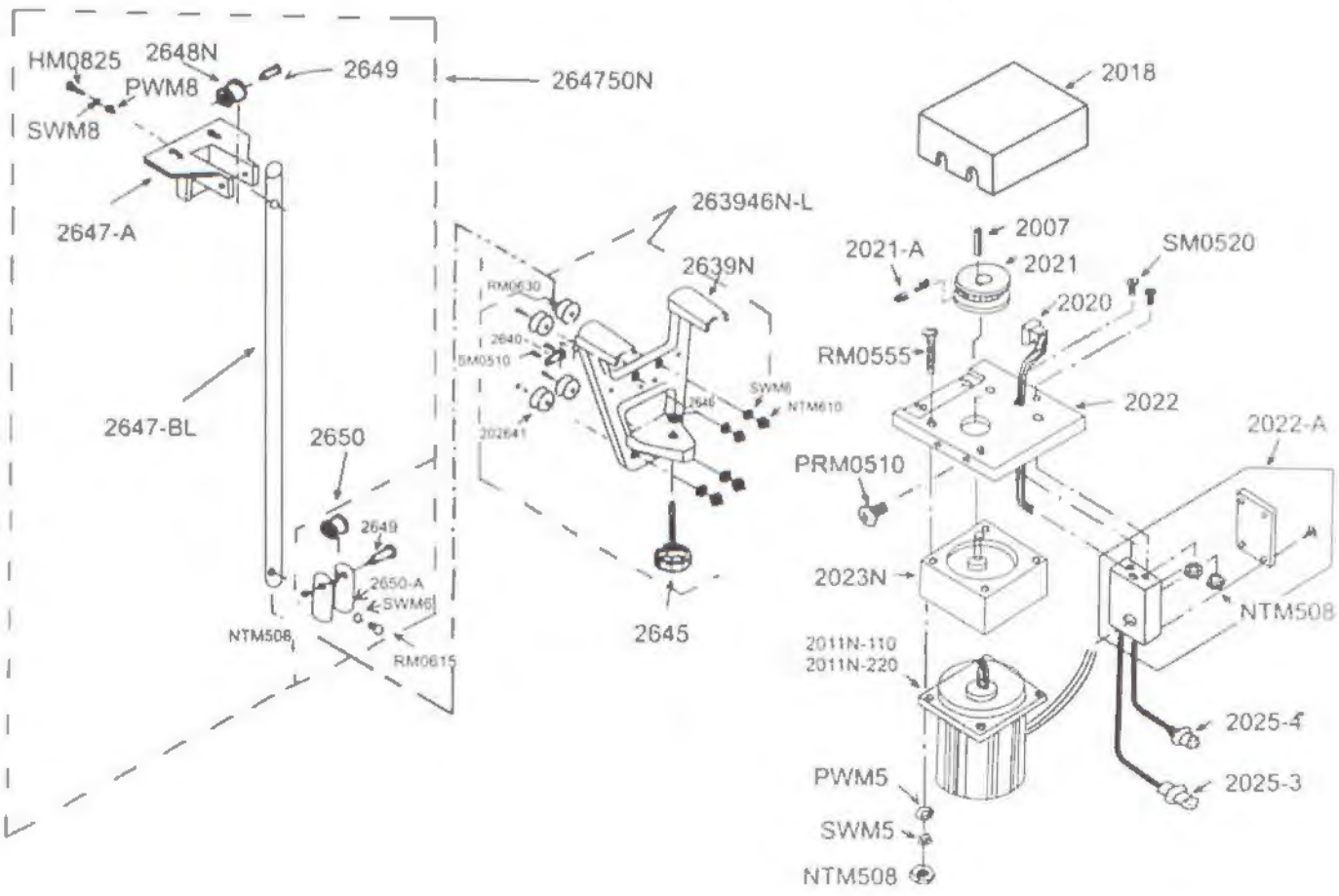
Q5: When the cutter adverses, severe bump occurs.

Ans: To check the LED Light (1) and others by using the same way mentioned above.

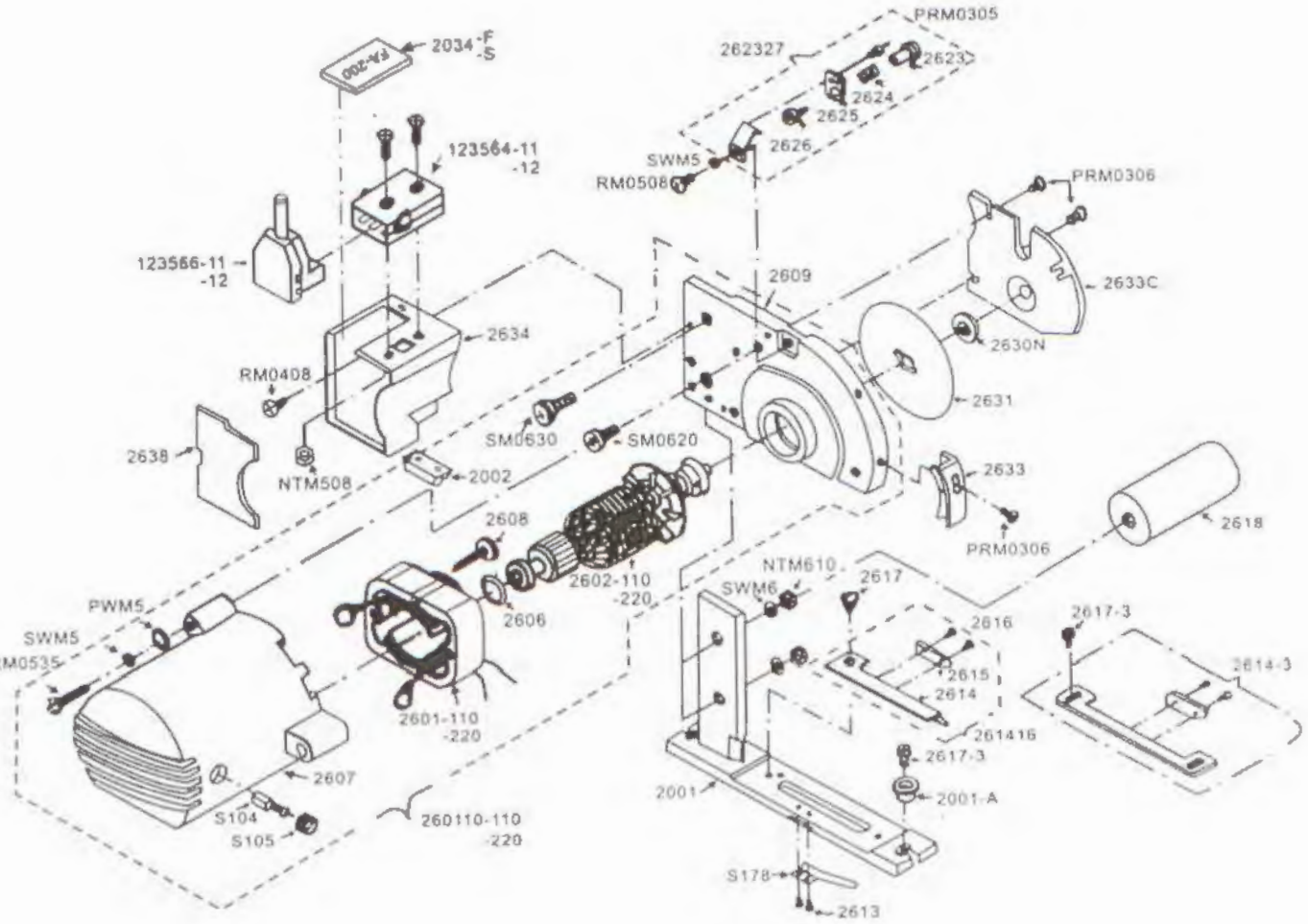

J
I
E
B
O
R
G
G
F
C
D
A
L
H
LIFTSET
MOTOR


7PIN PLUG
2PIN PLUG
5PIN PLUG
3 PIN PLUG
4 PIN PLUG
LIFTSET
MOTOR


2042
2018
RM0630
2026
2660
2013
PRM0510
2655
SM510
2027
2653
2654
2019
2656
2024
PRM0510
2029
2657
PWM822
SWM8
NTM8
2030
2658
2662


HM0825
2648N
2649
264750N
PWM8
SWM8
2647-A
2647-BL
2650
2649
2650-A
SWM6
NTM508
RM0615
263946N-L
2639N
RM0630
2640
SM0510
2646
SWM8
NTM610
202641
2645
2018
2021-A
2007
2021
SM0520
2020
RM0555
2022
2022-A
PRM0510
2023N
NTM508
2011N-110
2011N-220
2025-4
2025-3
PWM5
SWM5
NTM508

PART NO.	PART NAME
260110-110	110V MOTOR ASSEMBLY
260110-220	220V MOTOR ASSEMBLY
2601-110	110V STATOR
2601-220	220V STATOR
2602-110	110V ARMATURE
2602-220	220V ARMATURE
2603	WASHER FOR ARMATURE
2606	O RING
2607	MOTOR COVER
2608	SCREW FOR STATOR
2609	MOTOR PLATE
2610	RUBBER FOR BEARING
2613	SCREW FOR PRESSURE SPRING
261416	LOWER BLADE SET
2614	LOWER BLADE ARM
2614-3	3rd LOWER BLADE
2615	LOWER BLADE
2616	SCREW FOR LOWER BLADE
2617	SCREW FOR LOWER BLADE ARM
2617-3	SCREW FOR 3rd LOWER BLADE ARM
2618	BALANCE IRON
262327	WHETSTONE ASSEMBLY
2623	WHETSTONE COLLAR
2624	SPRING FOR WHETSTONE COLLAR
2625	WHETSTONE ARM(UPSIDE)
2626	WHETSTONE
2630N	LOCK NUT FOR KNIFE
2631	KNIFE (ROUND)
2633	KNIFE GUARD
2633C	KNIFE COVER
2634	TERMINAL BOX
2638	COVER FOR TERMINAL BOX
2001	STANDARD FOR FA-200
2001-A	LINK FOR TIMING BELT
2002	MAGNET EOR SENSOR
2034-F	MODEL PLATE FOR FA-200
-S	MODEL PLATE FOR SA-190
S104	CARBON BRUSH
S105	CAP FOR CARBON BRUSH
S178	PRESSURE SPRING FOR LOWER BLADE
123564-11	110V TERMINAL BLOCK WITH PINS
-12	220V TERMINAL BLOCK WITH PINS
123566-11	110V CURRENT CONNECTOR
-12	220V CURRENT CONNECTOR


PRM0305
262327
2623
2624
2625
2626
SWM5
RM0508
2034-F
-S
123564-11
-12
123566-11
-12
PRM0306
2609
2633C
2630N
2634
RM0408
2631
SM0630
SM0620
2638
NTM508
2002
2633
2618
2608
2602-110
-220
PRM0306
NTM610
SWM6
2617
2606
PWM5
SWM5
RM0535
2616
2617-3
2614-3
2615
2614
261416
2601-110
-220
2617-3
2607
2001
2001-A
S104
S105
260110-110
-220
S178
2613

Q6: When the cutter is advancing and reversing, slight bump may occur or every time the cutter cannot be back to the bottom, it is probably caused by:

Ans: improper position of the "Sensor Magnetic Spring Switch" for controlling advancing,reversing and stopping, or tension of the drive belt.

(a) To move the "Sensor Switch" at the proper position.

(b) To adjust the tension of the TIMING belt until it is ensured of 5mm elasticity.

Q7: When the cutter is checked or doesn't work smoothly. it is probably caused by.

(a) the TiMING belt which is not well set;

(b) The inner part of the track which is stuck by broken cloth or other foreign matters;

(c) the track surface which is bumped into dent or damaged.

Ans:

(a) To straighten the TIMING belt until it works smoothly.

(b) To clean the inner part of the track, or to draw out the copper plate of the track for cleaning the bottom part, because some broken cloth probably dorps in under the copper plate. After resetting the copper plate, drop some oil for sewing machines oil before placing the cutter on it.

(c) To replace the track.

Q8: When the start switch is pressed, and the cutter rotates but cannot advance, this is probably caused by:

(a) bad contact of the connected wire; if so, check M2 motor the black and the yellow wire;

(b) breakdown motor.

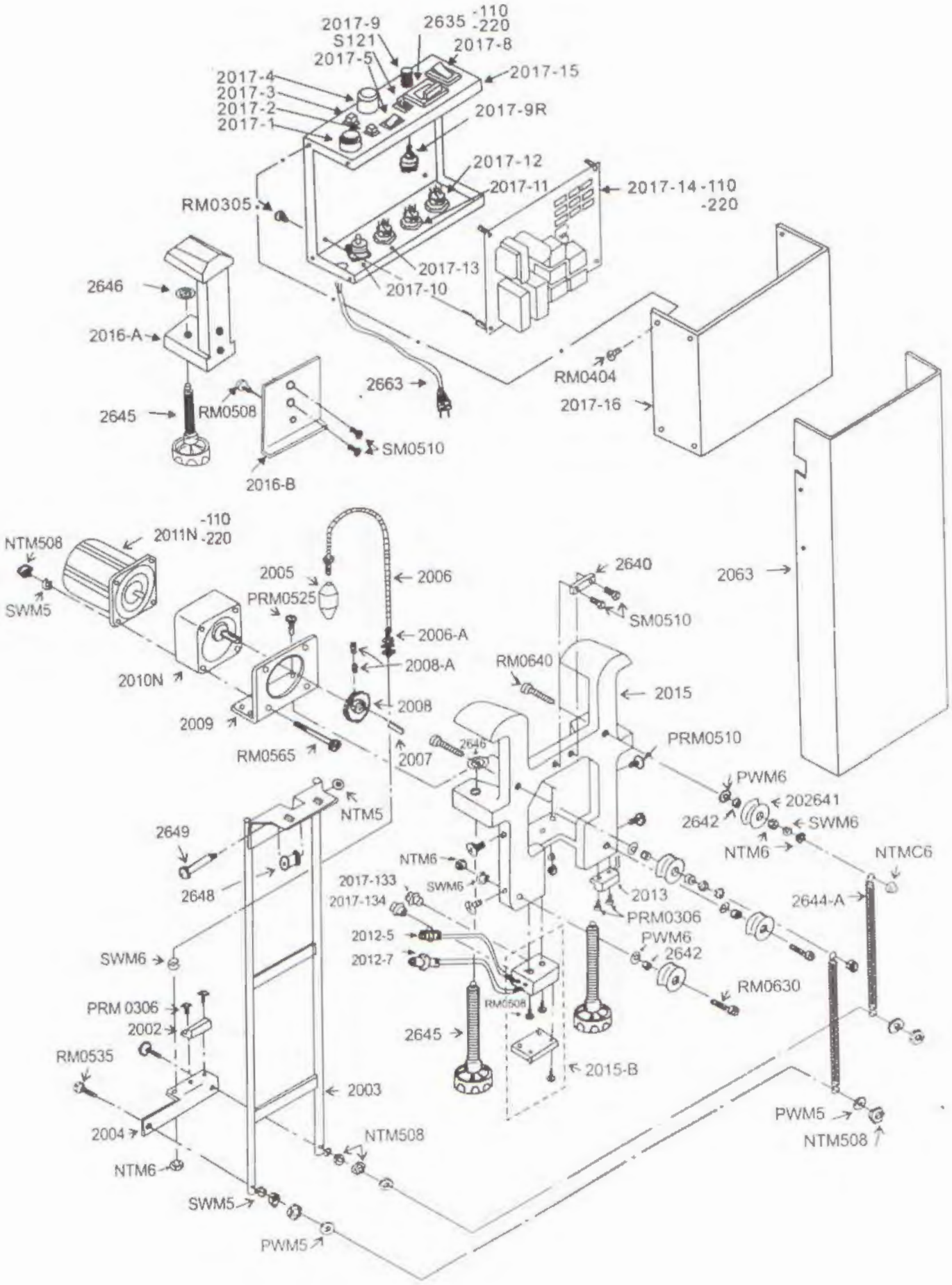
Q9: When the start switch is pressed, the main engin can advance and reverse and the cutter can rotate, but cannot ascend or descend, this is probably caused by:

(a) bad insertion of the 5-pin plug;

(b) loose wiring of the motor controlling ascending and descending;

(c) brokendown motor.

PART NO.	PART NAME
263946N-L	LEFT CLAMP SET
2639N	A CLAMP
2640	LIFT BELT CATCH
2645	BIG SCREW
2646	WASHER FOR BIG SCREW
264750N	LEFT BAR LIFTER
2647-A	BAR LIFTER PLATE
2647-BL	LEFT BAR
2648N	ROLLER FOR LIFT BELT
2649	ROLLER SHAFE
2650	ROLLER SET
2653	RAIL
2654	SQUARE NUT
2655	RAIL GUARD
2656	IMPACT-RESISTANT RUBBER
2657	STEEL PIECE (SIZE)
2658	RAIL RUBBER (SIZE)
2660	SCREW FOR RAIL
2662	LIFT BECT (SIZE)
200725-110	110V TRANSMISSION MOTOR SET
-220	220V TRANSMISSION MOTOR SET
2007	GEAR LATCH
2011N-110	110V F.R.MOTOR
-220	220V F.R.MOTOR
2013	SENSOR SWITCH
2018	TRANSMISSION BASE COVER
2019	SPRING FOR 2656
2020	RAIL PLUG SOCKET (M)
2021	TRANSMISSION GEAR
2021-A	SCREW FOR TRANSMISSION GEAR
2022	F.R.MOTOR BASE
2022-A	F.R.MOTOR TERMINAL BOX
2023N	REDUCTION GEAR
202427	TRANSMISSION PULLEY SET
2024	TRANSMISSION PULLEY BASE
2025-3	THREE HOLES CABLE
2025-4	FOUR HOLES CABLE
2026	TRANSMISSION PULLEY
202641	CUPRUM WHEEL
2027	PULLEY FIXED BLADE
202830	FA-200 RAIL SET (SIZE)
2028	RAIL (SIZE)
2029	MICRO SWITCH
2030	RAIL PLUG SOCKET (F)
2042	TIMING BELT


2017-9
S121
2635 -110 -220
2017-8
2017-5
2017-15
2017-4
2017-3
2017-2
2017-1
2017-9R
2017-12
2017-11
2017-14 -110 -220
RM0305
2017-13
2017-10
2646
2016-A
2663
RM0404
2017-16
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RM0508
SM0510
2016-B
NTM508
2011N -110 -220
SWM5
2005
PRM0525
2006
2006-A
2008-A
2010N
2008
2009
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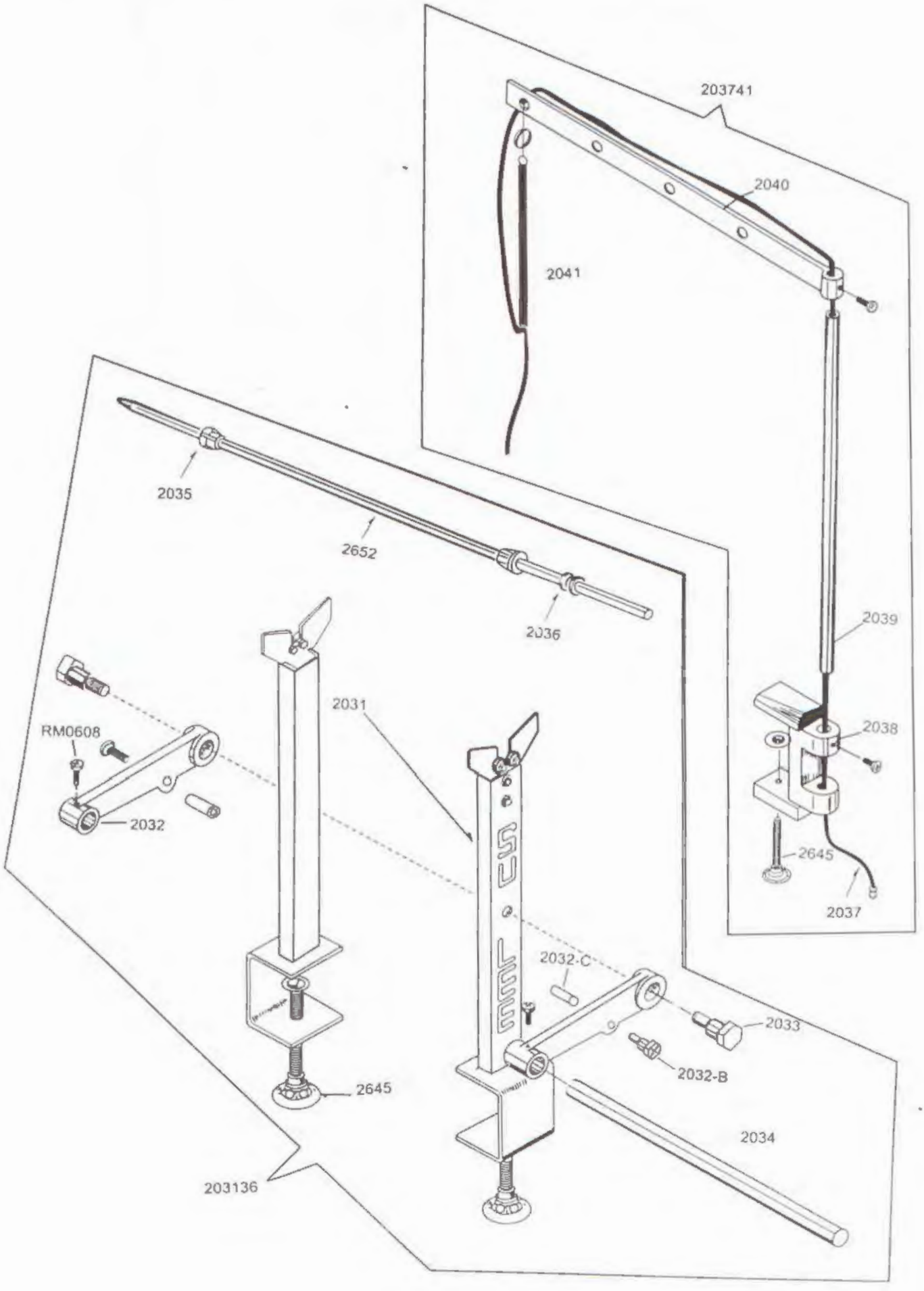
2640
SM0510
2063
RM0640
2015
PRM0510
2646
PWM6
202641
2642
SWM6
NTM6
NTMC6
NTM5
2649
2648
2017-133
2017-134
SWM6
NTM6
2013
PRM0306
2644-A
2012-5
2012-7
PWM6
2642
RM0630
SWM6
PRM 0306
2002
RM0535
2003
2645
RM0508
2015-B
2004
NTM6
NTM508
SWM5
PWM5
PWM5
NTM508


203741
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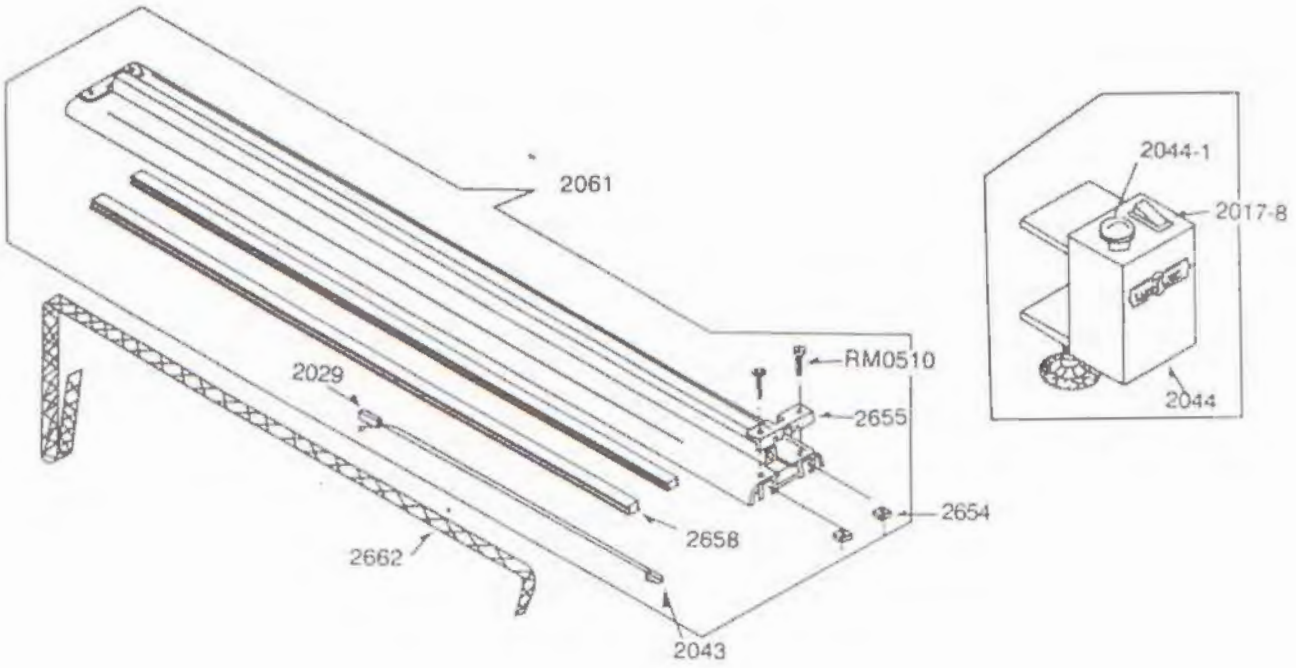
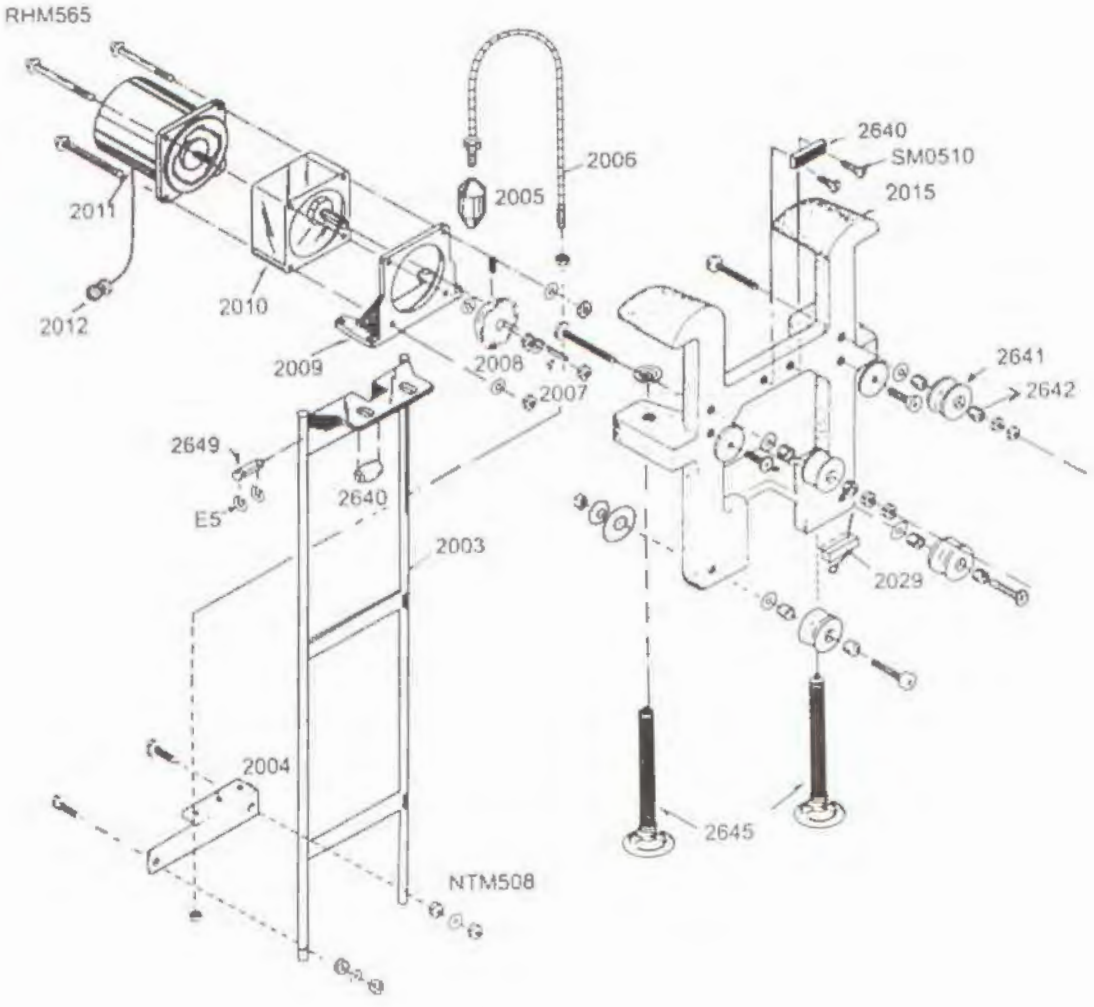
2035
2652
2036
2039
2038
2645
2037
RM0608
2032
2031
2032-C
2033
2032-B
2645
2034
203136

PART NO.	PART NAME
2002	MAGNET FOR SENSOR
2003	LIFTER
2004	MAGNET BASE
2005	CHAIN PENDANT
2006	CHAIN
2006-A	CHAIN SCREW
2007	GEAR LATCH
2008	CHAIN GEAR
2009	F.R.MOTOR PLATE
2010N	REDUCTION GEAR FOR LIFTING
2011N-110	110V F.R.MOTOR
-220	220V F.R.MOTOR
2012-5	FIVE HOLES CABLE
2012-7	SEVEN HOLES CABLE
2013	SENSOR SWITCH
2015	LIFTING FIXED CLAMP
2015-B	LIFTING MOTOR TERMINAL BOX
2016	CONTROL BOX STANDARD
2017-110	110V CONTROL BOX SET
-220	220V CONTROL BOX SET
2017-1	START SWITCH
2017-2	DOWN SWITCH
2017-3	UP SWITCH
2017-4	EMER. STOP SWITCH
2017-5	WHEETING SWITCH
2017-8	POWER SWITCH
2017-9	LENGTH SETTING TUNER CUP
-9R	LENGTH SETTING TUNER
2017-10	FUSE BASE
2017-11	2 HOLES PLUG
2017-12	5 HOLES PLUG
2017-13	7 HOLES PLUG
2017-14-110	110V P.C.BOARD
-220	220V P.C.BOARD
2017-133	3 HOLES PLUG
2017-134	4 HOLES PLUG
2017-15	CONTROL BOX CASE
2017-16	CONTROL BOX COVER
2063	LIFT SET COVER
2635-110	110V COUNTER
-220	220V COUNTER
2640	LIFT BELT CATCH
2642	WHEEL RING
2644-A	SPRING FOR LIFT
2645	BIG SCREW
2646	WASHER FOR BIG SCREW
2648	BIG ROLLER
2649	ROLLER SHAFT
S121	SWITCH


2061
2044-1
2017-8
RM0510
2029
2655
2654
2658
2662
2043
2044


RHM565
2006
2005
2640
SM0510
2015
2011
2012
2010
2009
2008
2007
2641
2642
2649
E5
2640
2003
2029
2004
2645
NTM508

PART NO.	PART NAME
203136	SUSTAINING FRAME UNIT
2031	SUSTAINING FRAME
2032	ROCKER
2032-B	ROCKER STOP SCREW
2032-C	ROCKER STOP SCREW COVER
2033	ROCKER SCREW
2034	ROCKER LEVER (SIZE)
2035	CLOTH FIXTURE
2036	CLOTH SUPPORT FIXING RING
203741	WIRE FRAME ASSEMBLY
2037	TWO HOLES CABLE
2038	WIRE SUPPORT BASE
2039	WIRE SUPPORT LEVER
2040	WIRE BRACKET ARM
2041	SPRING FOR WIRE STAND
2652	SUSTAINING BAR(SIZE)

PART NO.	PART NAME
2003	LIFTER
2004	MAGNET BASE
2005	CHAIN PENDANT
2006	CHAIN
2007	GEAR LATCH
2008	CHAIN GEAR
2009	F.R MOTOR PLATE
2010	REDUCTION GEAR
2011	F.R MOTOR
2012	MOTOR PLUG
2015	LIFTING FIXED CLAMP
2029	MICRO SWITCH
2043	2 PIN PLUG
2044	ELECTRIC BOX
2044-1	UP SWITCH
2017-8	POWER SWITCH
2061	CLOTH PRESS TRACK SET

INSTRUCTION MANUAL

1. Open the Power Switch, the Press Track will moving down, when the micro switch (2029) touch the table or cloth That will stop.

2. If you want to lifting 10 cm and stay there,
   METHOD: Push the Up Switch and when the press track lifting 10 cm turn off the Power Switch.

SPECIFICATON:

KNIFE SIZE : 4 ¼ inch
POWER : 130w
VOLTAGE : 100 - 120v
220 - 240v
CYCLE : 50 - 60Hz
SIZE (FOR TRACK) : 36" - 96"
SPECIAL ORDER: OVER 97" - 120"

HOW TO ORDER END CUTTER:

MODEL	SIZE	Q'TY
FA-200H(220v/50Hz)	72"	20 SETS
ER-209 (CLOTH PRESS)	72"	20 SETS

GUARANTEE

We guarantee our machines for six months from date of invoice against defective parts and workmanship and will repair or replace any machine going wrong from these causes when returned to us carrying charges prepaid. This guarantee does not contemplate making good damage caused by misuse or negiect; and is void if other than genuine Su Lee knives, emery wheels and parts are used in the machine.

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