

# **TAKING**

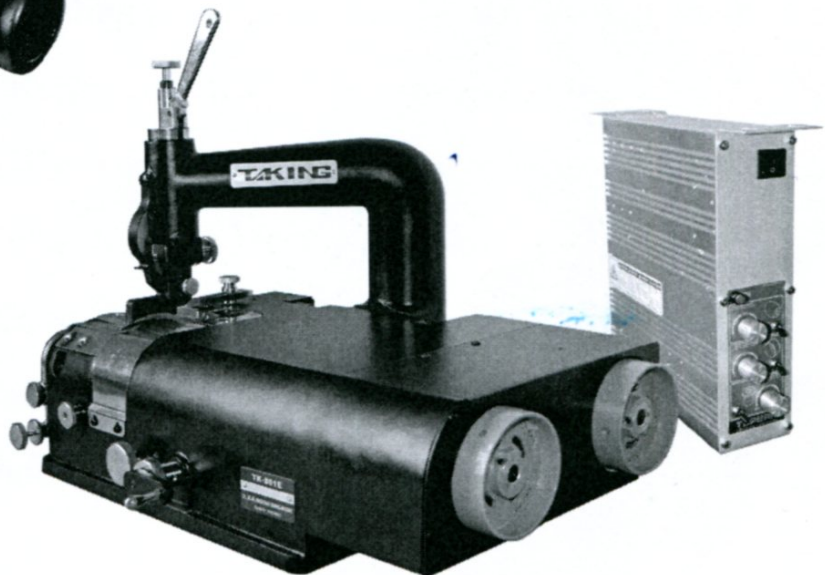
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**Model TK-801/TK-801E**

**Model TK-802/TK-802E**

**Leather Skiving Machine**

**Parts List & Instruction Manual**



**TA KING INDUSTRIAL CO., LTD**

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## 1. Introduction

TA KING Leather Skiving Machine, Which is designed and manufactured with the latest technology and materials, is noted for its easy operation and high precision and durability.

The various uses of this machine are for edge trimming and plain trimming in processing shoes bags, belts, wallets, gloves and all leather goods, vinyl and rubber products.

The main features of this machine are as follows:

- 1) The Width of plain trimming: Maximum 50mm  
(In first process)

The designated widths can be attained by trimming twice or thrice.

- 2) With a waste releasing device (a utility model pending)
- 3) With a knife sharpening clutch set
- 4) Easy replacment of component parts (a utility model pending)

## Specifications:

Measurement of Machine:	530 (W) x 340 (D) x 370 (H)
Weight of Machine:	39 kg
Capacity of Motor:	200W-400W
Rotation Speed:	1000rpm-1200rpm



## 2. Installation of Machine

### (1) Installation of Machine

Install machine on the table by using the accessories, i.e.; hinge, hinge axis and screws. Then make a square outlet of about 150mm beneath the knife edge to let the waste fall down.

### (2) Installation of Motor:

- (a) Use 200W-400W motor
- (b) Motor Pulley is A type V pulley with outer diameter of 50-60mm, which connect the machine with A type V-belt
- (c) The installation of motor should result in both machine pulley and motor pulley to be in a straight line with a distance of two pulleys measured minimum 300mm.

## 3. Lubrication

The rotation direction of the Machine is clockwise viewing from the right side of machine. (as Fig. 1)

Fig. 1 hinge

motor

Minimum 300mm

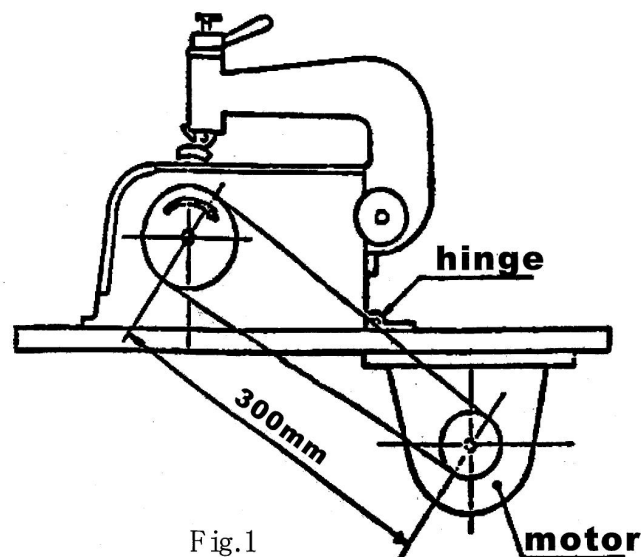


Fig.1



### 3. Lubrication

(1) As the all component parts of the machine are applied rustproof oil, please wipe out with dry cloth to prevent the oil from staining the materials before operation.

Especially, the oil on knife must be well cleaned least the materials should be stained with oil, or knife grindstone damaged.

(2) After installation of the machine, it is necessary to lubricate the portions which Illustrated in Fig. 2. please do not operate the machine until the whole portions are dull lubricated.

(Fig.2)

A. Worm & Wormwheel..... Replacing grease(once a month)

B. Feeding Roller Stand Shaft.

C. Upward Pressing Lever

D. Feeding Roller Shaft

E. Knife Shaft

F. Clutch Angle Piece

G. Knife Shaft Worm

H. Clutch Lever Shaft

} Applying machine oil in the interval of 3 or 4 days

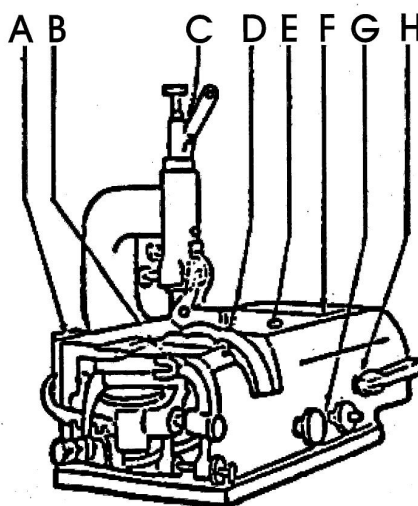


Fig.2

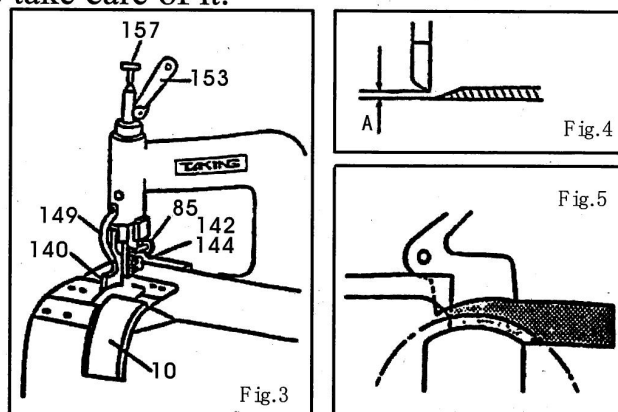
#### 4.Adjustment & Operation

Though the machine has been adjusted by the maker, please confirm rotating direction, rotation speed, lubrication etc. Then adjust the following items to meet with your desired trimming operation.

##### \*Pressing Metal

- (1) Press down Upward Pressing Lever (153).
- (2) To rotate an accessory, i.e., Pressing Metal Adjusting Screw(157) for fixing the gap (A) between Pressing Metal (140) and Knife (10). (as Fig. 4)
  - (a) For Thinner Trimming  
To rotate Adjusting Screw(157) clockwise to lower Pressing Metal to fix a suitable gap (about 0.5mm).
  - (b) For Thicker Trimming  
On the contrary, to rotate the Screw counter-clockwise moving Pressing Metal upward. To view gap(A) from the left side of the Machine for fixing.
- (3) For oblique Trimming (as Fig. 5)  
To rotate Adjusting Metal clockwise or counter-clockwise for fixing the angle of Pressing Metal.
- (4) For Trimming into Specific Shapes  
To cut Pressing Metal with a file and sand paper into designated shapes for trimming purposes.
- (5) Removal of Pressing Metal  
To pull up Upward Pressing Lever, and take out Plate Spring(149) horizontally by loosening Fastening Screw(144) of Pressing Metal and Stopping Pin.  
Then Pressing Metal and Stopping Pin are removed.  
(Pressing Metal is supplied in 4 pcs per set as an accessory.)

**Remarks:** When replacing Pressing Metal, move Pressing Metal upward by rotating Pressing Metal Adjusting Screw (157), then pull down Upward Pressing Lever (153).  
If Pressing Metal is moved down too far, it may damage Feeding Roller.  
Please take care of it.



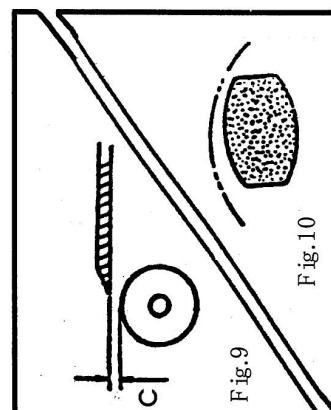
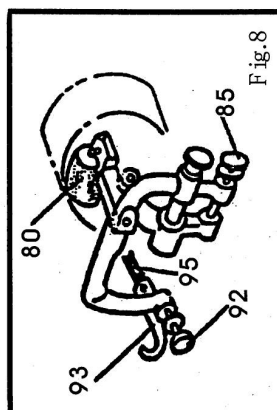
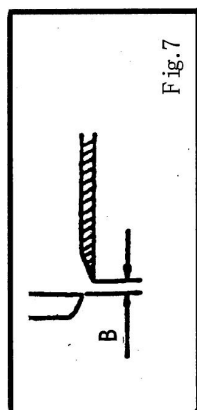
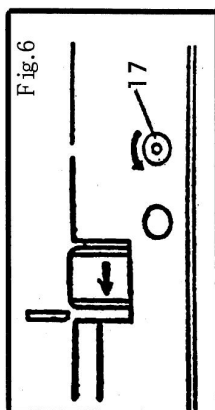
### \*Knife

- (1) After sharpening the Knife, the edge will be defaced gradually, please adjust from time to time the gap between Pressing Metal and Knife Edge.
- (2) To rotate Adjusting Knob (17) counter-clockwise; the Knife will be moved to the direction as arrow indicated. (as Fig.6)
- (3) The gap between Pressing Metal and Knife Edge may be changed according to the materials of processing.
  - (a) Superior Quality: 0.2-0.3 mm
  - (b) Ordinary Quality: 0.3-0.5 mm
  - (c) Thick and Hard Materials 0.5-0.8 mm

### \*Feeding Roller

- (1) Feeding Roller should be in parallel with the inner side of Knife by adjusting the gap (c).
- (2) In adjusting the gap (c), it can be widened by rotating Adjusting Screw (92) clockwise, and closed nearer to Knife by rotating counter-clockwise.
- (3) The gap (c) between Feeding Roller and Knife (as Fig. 9)
  - (a) For Thinner Trimming 0.3-0.5 mm
  - (b) For Thicker Trimming 1-0.5 mm
- (4) For Oblique Trimming (as Fig. 10)

To rotate Adjusting Screw (85) clockwise, the Roller becomes oblique against the inner side of Knife.
- (5) The Hardness of Materials under Process
  - (a) If the processing materials are hard, pull out Spring Lever (96) for stronger catching.
  - (b) If the materials are soft, weaken the pressure of Spring (95) contrary.
- (6) In processing soft materials, e.g., horse leather and goat-skin Feeding Roller is used to wind these round. It is advised to use a smaller diameter roller of a rubber roller instead.



### \*Use of Ruller

In edge trimming, please use the attached Ruller (6) for fixing the desired width of trimming.

- (1) To fix the Ruller on the Sliding Plate (5) with Washer(8) and Fixing Screw(9) to meet with the width of trimming.

In the event,Ruller should stick to the left side of Pressing Metal.

- (2) By changing the position of Ruller,the width of edge trimming can be changed accordingly.

### 5. Sharpening Knife

The Knife Edge will, become operation,it has to be shapened as the following manners.

- (1) Use of Knife Sharpening Clutch Set

- (a) To pull out Clutch Lever (39) and push it downward light and Whetstone will be rotated.

- (b) After sharpening,push upward Clutch Lever to stop Whetstone.

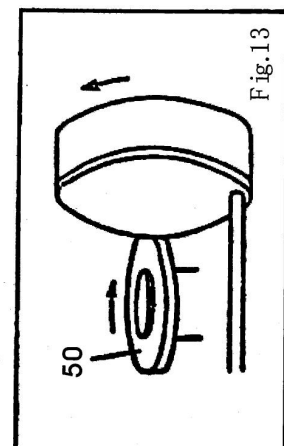
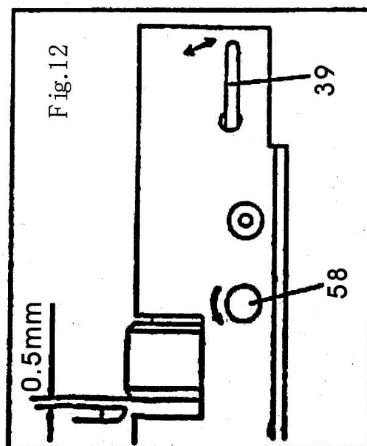
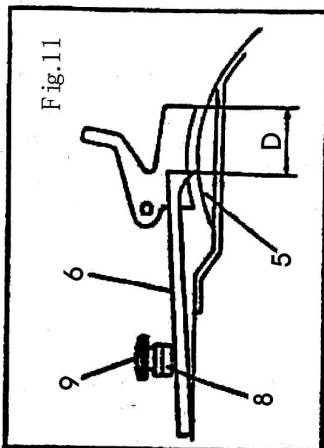
- (2) To fix gap (A) between Knife and pressing Metal into about 0.5mm.

- (3) After turning Whetstone Adjusting Knob (58) counter-clockwis Whetstone comes to contact Knife for sharpening.

**Remarks:** Please do not press Whetstone hardly against Knife otherwise the latter will be over-heated and vibrated during operation.

- (4) As the inner side of Knife is used to happen burr, apply Bar whetstone softly in paralle to the inner side of Knife for removing burr then a sharp edge can be obtained.

- (5) After sharpening, put Whetstone to original position and disengage the Clutch



## 6. Use of Dresser

When the surface of Knife Whetstone is stained with iron dust and oil, it can not sharpen the Knife Edge well. Please apply an accessory, i.e., Dresser (3T) softly to the Whetstone to shave the surface

**Remarks:** Take care of what flying whetstone dust which may hurt your eyes.

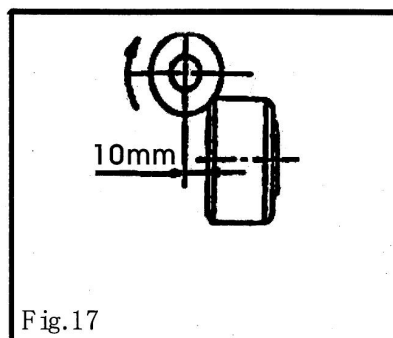
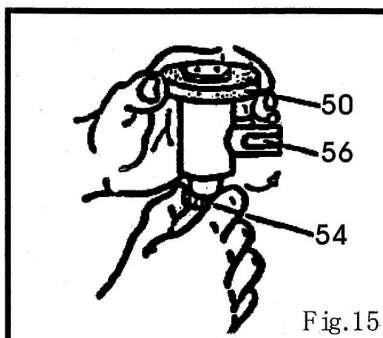
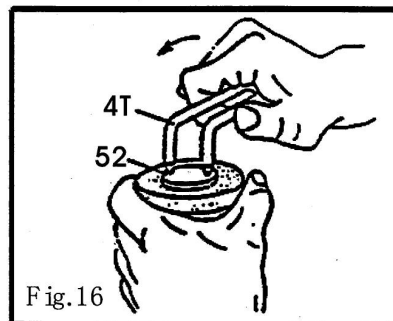
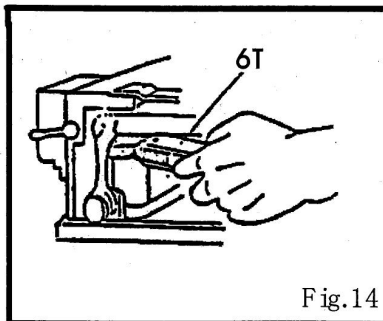
## 7. The Replacement of Spare Parts

### \*The Replacement of Knife Whetstone

- (1) To remove Flat Belt after inspecting the method of belt connection.
- (2) To hold Whetstone (50) with your left hand, and revolve Pulley (54) clockwise to release it. (as Fig. 15)
- (3) To apply an accessory, i.e., Spanner for Whetstone Nut (4T) to the holes of Nut (52), then turn counter-clockwise for releasing Whetstone. (as Fig. 16)
- (4) In connecting Flat Belt, revolve Whetstone clockwise as viewing from the upper side of the machine.(as Fig. 17)

**Remarks:** If you want to replace Knife Whetstone Stand (56) in set. the relative position of Whetstone and Knife should be set in the distance of 10mm. (as Fig. 17)

**Remarks:** Keep Whetstone surface clean from oil.



### \*The Replacement of Feeding Roller

- (1) Lifting Spring Lever (96) to fix to Lever Fixer(97)
- (2) To hold Stand Arm (91) with your right hand, and release Center-Pin Fixing Screw (100),. then pull Center-Pin to left side for releasing Stand Arm.

**Remarks:** In the same time, take special care for the Knife Edge from any damage by contacting with other article Especially, the Joint of Feeding Roller may contact the Knife edge when releasing. Please hold the Joint with your hand when releasing.

- (3) To unfasten the Screw (S147) of Roller Stand, and push out Roller Shaft (81)for releasing Toller (80).

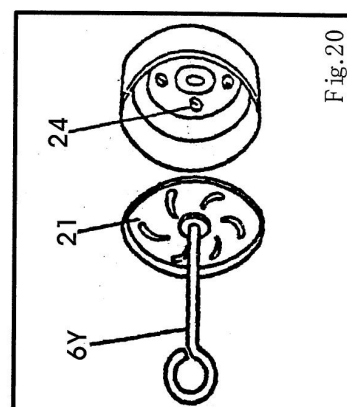
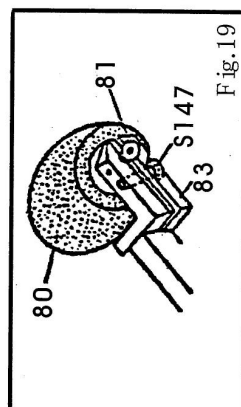
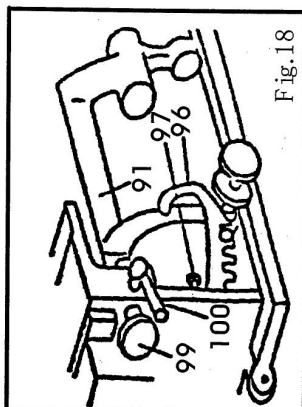
### \*The Replacement of Knife

- (1) To release Feeding Roller Stand Arm (91).
- (2) To apply an accessory, i. e. , Exhaust-Plate Releasing Shaft (6Y), into Trimming Waste Exhaust-Plate (21) to pull it out.
- (3)To unfasten 4 screws that fix Knife then release Knife gradually.

**Remarks:** As Knife a is tightly fixed, use a screw driver to rotate it and push it uniquely with aid of your hand for releasing

- (4)As a new Kinfe is applied rust-proof oil,wipe the surface with gasoline for cleaning.
- (5)To keep the surfaces of Knife and also Knife Shaft connection face clean before fixing Knife.
- (6)Rotating Knife in order to fasten 4 Knife FixingScrews evenly.

**Remarks:**If the screw are fastened unevenly,it may cause the vibration of Knife.Please pay special attention to this.



### **\*The Replacement of Worm & Wormwheel**

- (1) To release Ceiling Plate (122) of Worm Chamber (114).and Cap Screw(123)

**Remarks:** At the same time, oil will be leaked out, please take precaution.

- (2) To unfasten Fixing Screw (S005) of Wormwheel (116), and Push Driving Shaft (118) inside for taking out Wormwheel.
- (3) To take out Worm (115) from the hole of Cap Screw.
- (4) During the replacement, install the parts alongwith Key-Grooves.

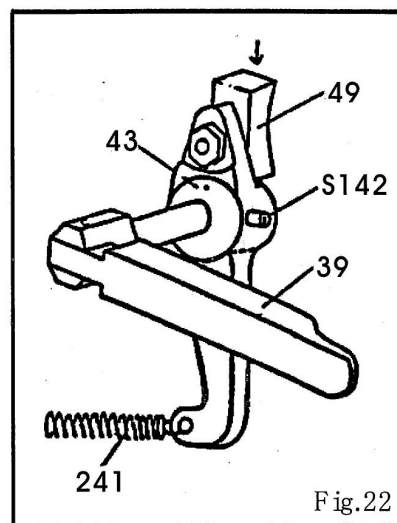
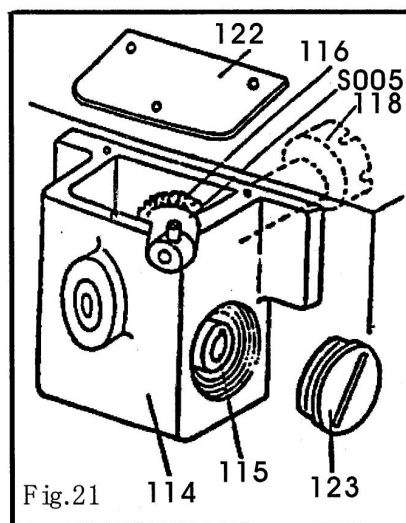
### **\*The Replacement of Clutch Angle Piece**

Though Clutch Angle Piece is made with anti-defacement materials, it is necessary to be replaced after a long duration of operation.

- (1) To release Clutch Pulling Spring (241)
- (2) To release Clutch Arm Fixing Screw (S142) and pull out Clutch Lever (39).
- (3) After Clutch Arm is released, replace Clutch Angle Piece (49).

**Remarks:** It is necessary to lubricate Clutch Angle Piece from time to time for its durability, and prevent it from being over-heated by friction.

At the same time, pay your attention to prevent flat belt from staining by lubricant.





### \*The Adjustment of Knife Shaft

It is important that the machine operates without the Vibration of Knife. After long duration of operation, Knife is used to rotate with vibration.

Please adjust the shaft as follows:

- (1) Knife looses in front and rear directions.

Use an accessory,i.e., Spanner (5T) for Knife Shaft Nut to fasten Double Nut (26A) of Knife Shaft (11).

**Remarks:** Do not Fasten the Nut too tight, otherwise Knife can not be rotated. To fasten Nut in order to prevent its looseness during operation.

- (2) Knife looses upward and downward

To loosen Nut (28)of Knife Shaft Metal (12) slightly then fasten Nut (27) repeatedly until Knife is fixed.

- (3) In replacement of Knife, it is necessary to adjust Knife Shaft.

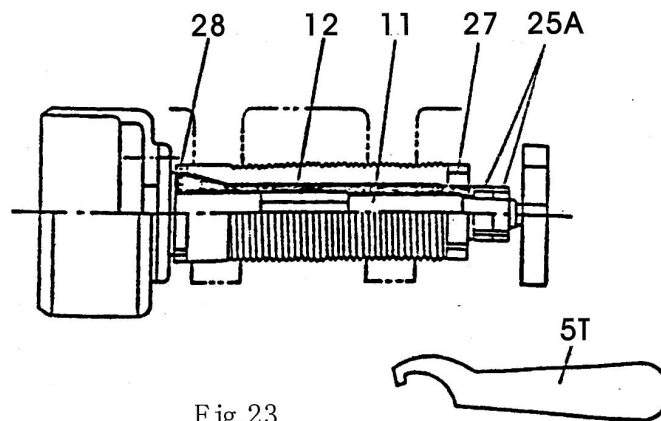


Fig.23

## 9. Mal-Condition of the Machine: Its Causes and the Methods of Adjustment

Condition of Machine	Causes	Methods of Adjustment
Bad Trimming	<ol style="list-style-type: none"> <li>1. Mal -Installation of Knife results in deviation of Knife center line.</li> <li>2. Knife Shaft moves in the front and rear direction</li> <li>3. Loosing of Knife Shaft Metal</li> <li>4. Burr on the Knife edge is remained after sharpening</li> <li>5. Pressing Metal is not fastened</li> <li>6. Pressing Metal contacts Feeding Roller</li> <li>7. Uneven surface of Feeding Roller</li> <li>8. Center-Pin of Roller Stand Arm does not press correctly</li> </ol>	<ol style="list-style-type: none"> <li>1. To take Knife for cleaning wate in the side where Knife, is fixed</li> <li>2. To adjust Nuts on Knife Shaft then fasten these</li> <li>3. To adjust Nuts on Knife Shaft Metal</li> <li>4. To take off Burr with Bar Whetstone</li> <li>5. To fasten Pressing. Metal again</li> <li>6. To adjust Pressing Metal Fixing Screw to remove Pressing Metal upward.</li> <li>7. To replace the defective Roller</li> <li>8. To press Center-Pin into correct position then fasten Center-Pin Fixing Screw</li> </ol>
Trimmed surface has wave pattern scratch	<ol style="list-style-type: none"> <li>1. Defaced edge of Knife</li> <li>2. Knife Shaft looses in the front and rear direction</li> <li>3. Knife Shaft moves upward and downward</li> </ol>	<ol style="list-style-type: none"> <li>1. To sharpen Knife</li> <li>2. To adjust Nuts on Knife Shaft and fasten</li> <li>3. To adjust Nuts of Knife Shaft Metal and fasten</li> </ol>
Unsmooth Feeding of Materials	<ol style="list-style-type: none"> <li>1. Gap between Feeding Roller and Knife is too narrow.</li> <li>2. Defacement of Pressing Metal</li> <li>3. Knife is blunt.</li> <li>4. Spring of Spring Lever is too tight.</li> </ol>	<ol style="list-style-type: none"> <li>1. To lower Feeding Roller slightly for thicker materials</li> <li>2. To replace with a new Pressing Metal</li> <li>3. To sharpen Knife</li> <li>4. To loosen Spring of Spring Lever. and polish Metal surface for smooth feeding. of the material.</li> </ol>

Materials is feeded beneath Knife edge	<ol style="list-style-type: none"> <li>1.Knife edge comes out to the front of Pressing Metal</li> <li>2.Pressing Metal comes down the edge of Knife</li> <li>3.The gap between Feeding Roller and Knife is too large</li> </ol>	<ol style="list-style-type: none"> <li>1.To adjust the gap to 0.3-0.5mm between Knife edge and Pressing Metal</li> <li>2.To move Pressing Metal upward</li> <li>3.To adjust gap with Adjusting Screw</li> </ol>
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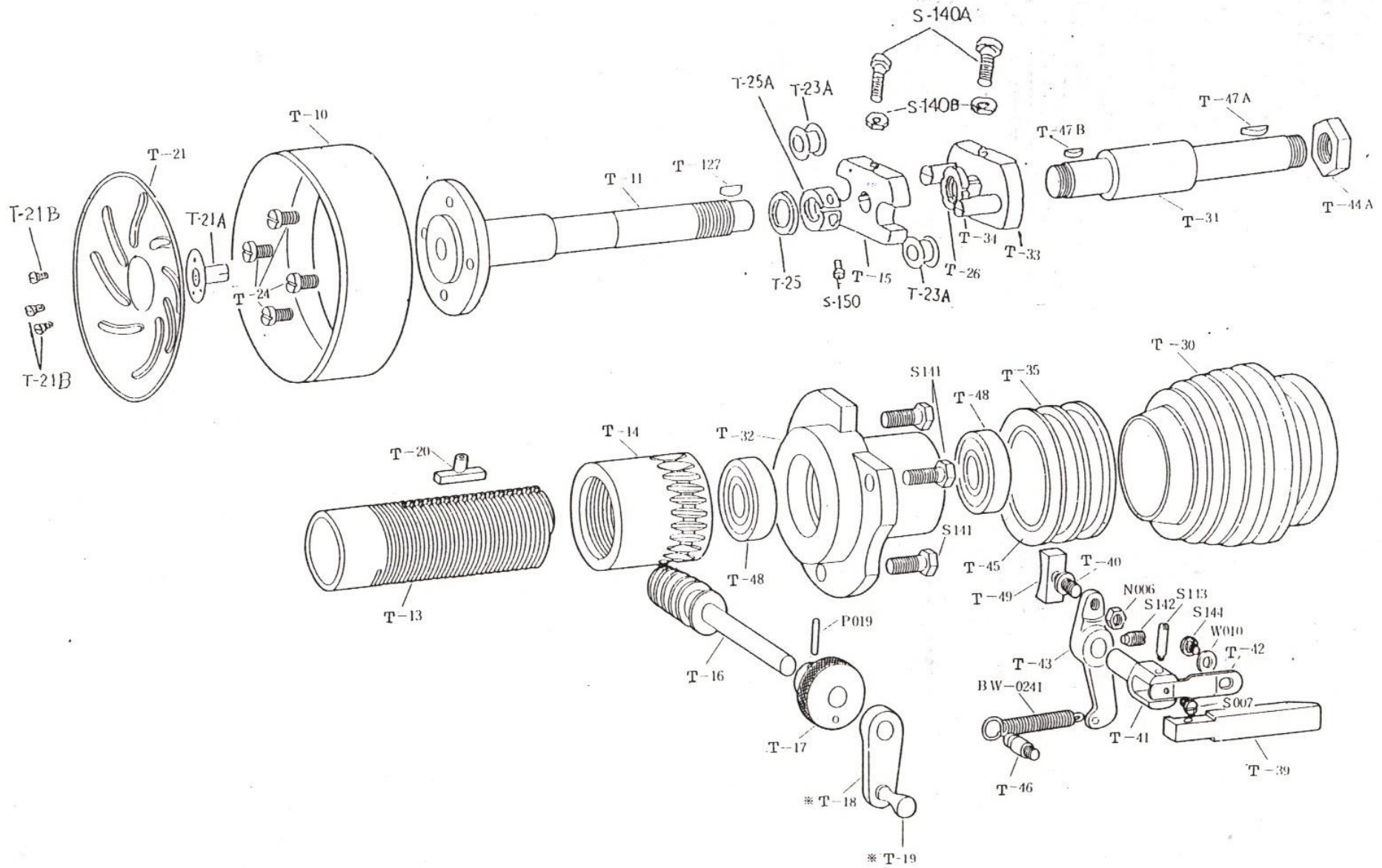
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Trimming Waste comes out	<ol style="list-style-type: none"> <li>1.Rotation Speed of the Machine is too high</li> <li>2.Uneven surface of Feeding Roller</li> </ol>	<ol style="list-style-type: none"> <li>1.To change Motor-Pulley to a smaller one.</li> <li>2.To replace a new Roller</li> </ol>
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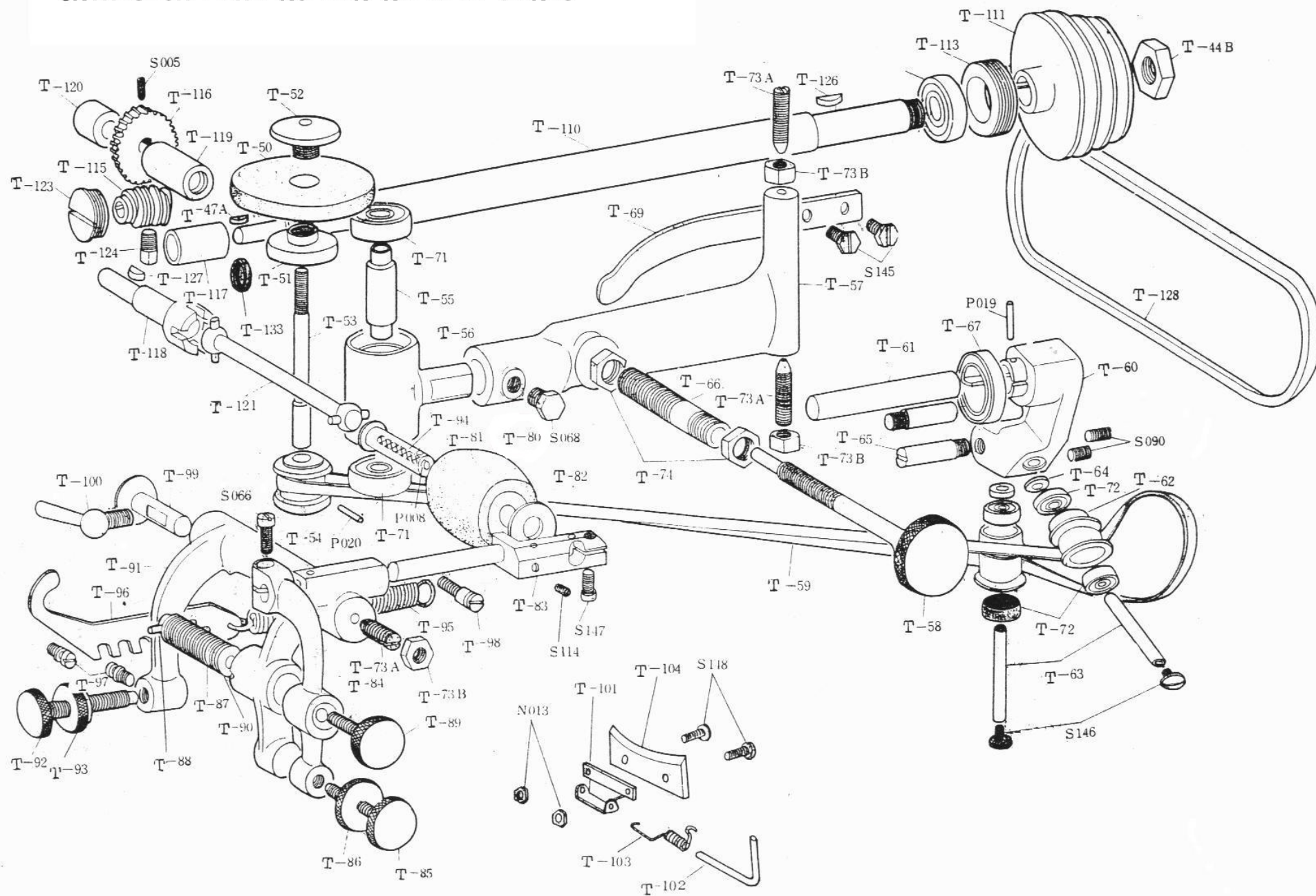




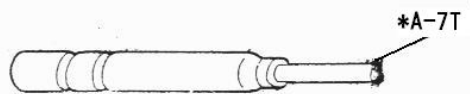
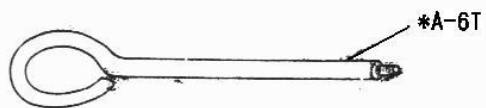
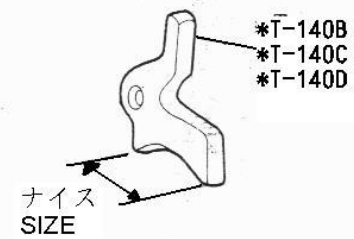
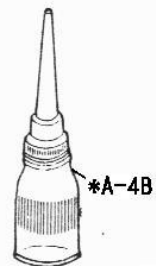
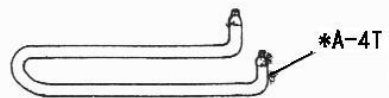
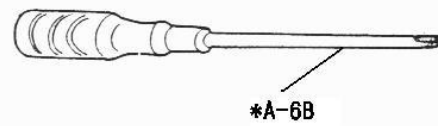
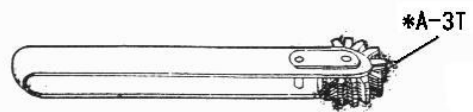
2. 切刀軸方面  
KNIFE AND RELATED PARTS



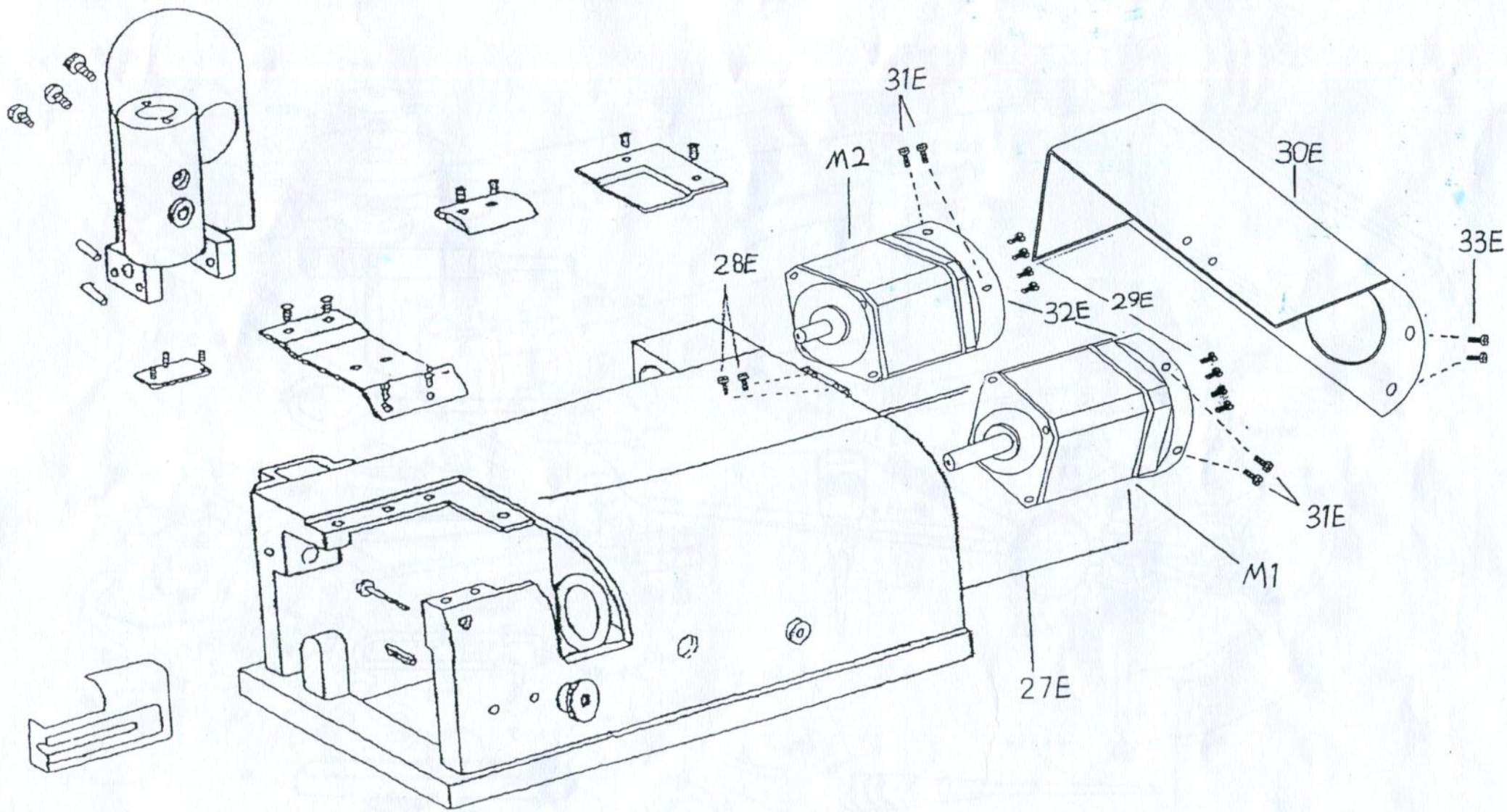
### 3. 磨石及輓子相關零件 GRINDSTONE AND ROLLER RELATED PARTS



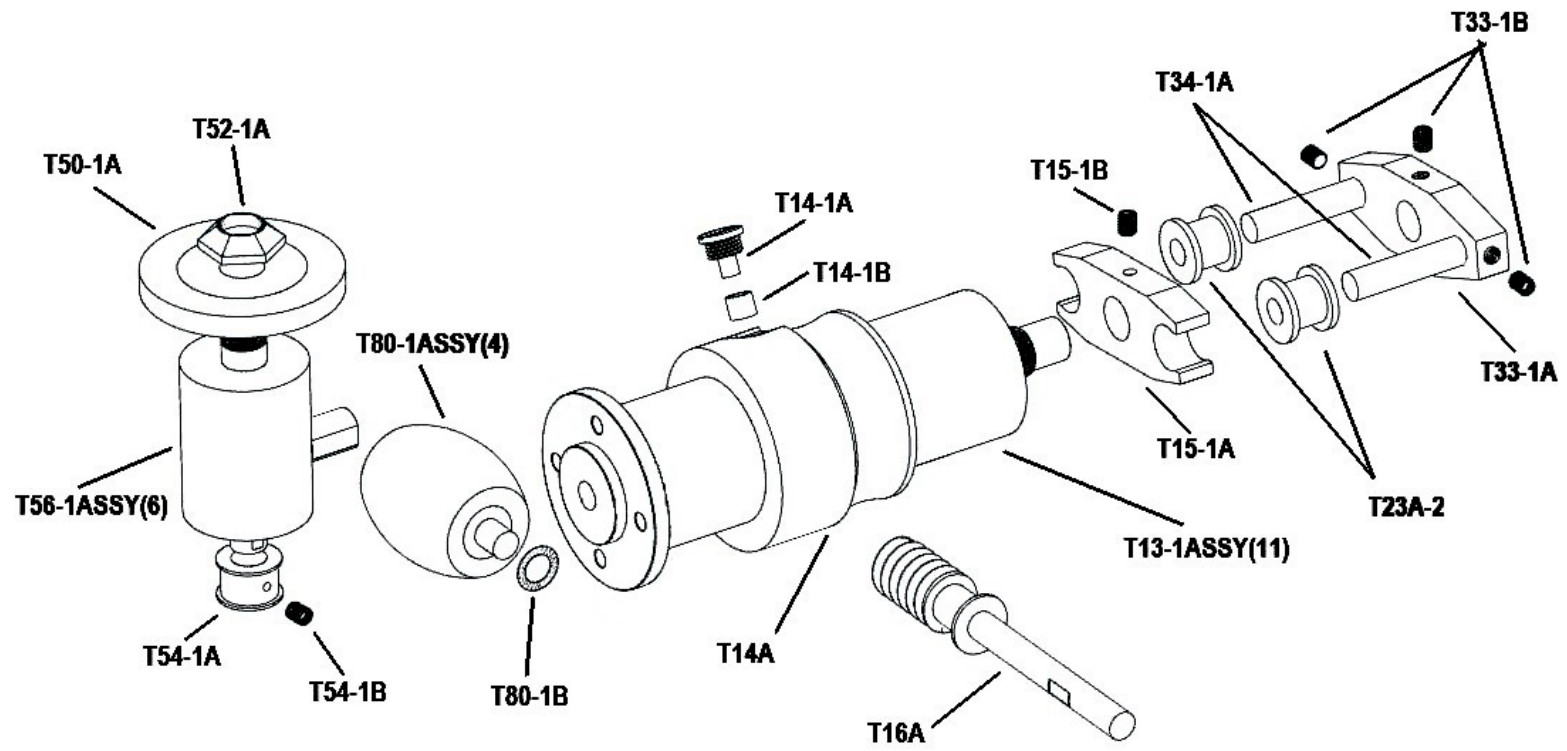
#### 4. 附件 ACCESSORIES







TK-801E / TK-802E



PARTS FOR 802/802E