

SS-627XH

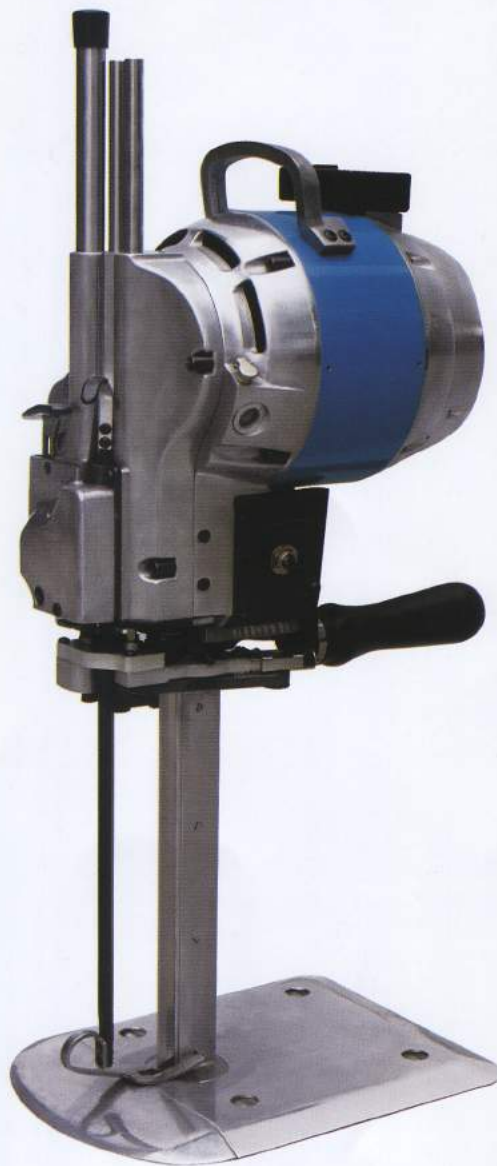
AUTO - SHARPENING CUTTING MACHINE

INSTRUCTION BOOK AND
PARTS LIST

IMPORTANT

This part book contains instruction and part number for the machine.

When ordering parts please specify machine part no. and name.



CAUTION

Machine Equipped
With
Sharp Blade

使用,加油 和维护

使用前请仔细阅读

使用前

应向油杯内加油,将电机后的旋钮推入转几转,刀片应能上下灵活移动。

——注意——

当心刀片快口伤人。操作时请使用木手柄推动机器,搬动机器时,请使用提手柄。

维护

(1)每星期两次用风管或风箱把马达和磨刀器上的绒毛吹掉。(2)每星期一次取下前盖将丝杆上的绒毛弄干净。(3)每天至少一次取下刀片,用槽子清洗器将刀槽清理干净。(4)请勿向底板滚轮加油。(5)若轮子滚不动,请拆下清洗。

——注意——

未装刀片时切勿磨刀,以免造成机器损坏。

磨刀时

请放下压脚,用力慢慢地按下磨刀手柄。如果轧死,请抬起拨叉,从新再来几次后,你便会知道怎样的轻重最适合。

Operation, Lubrication and care

Before operating machine, read this page carefully.

Before operating the motor, be sure that electric supply voltage and current are the same as stamped on the nameplate.

Fill oil cup. Push in turning knob and trun the machine over a few revolutions by hand to see if the knife moves easily.

WARNING

This machine is equipped with a sharp knife. Keep hands away from the knife area at all times. Use control levers and handles only when operating or handling machine.

CARE OF MACHINE

Use air hose or bellows with proper eye shields and blow lint out of motor and sharpener twice a week. Remove cover over cam and clean out lint arround screw mechanism in sharpener once a week. Remove knife and clean slides with slot cleaner at least once a day. To prevent undue accumulation of lint, do not oil plate rollers. If rollers stick, romove from plate and wash in cleaning solvent.

WARNING

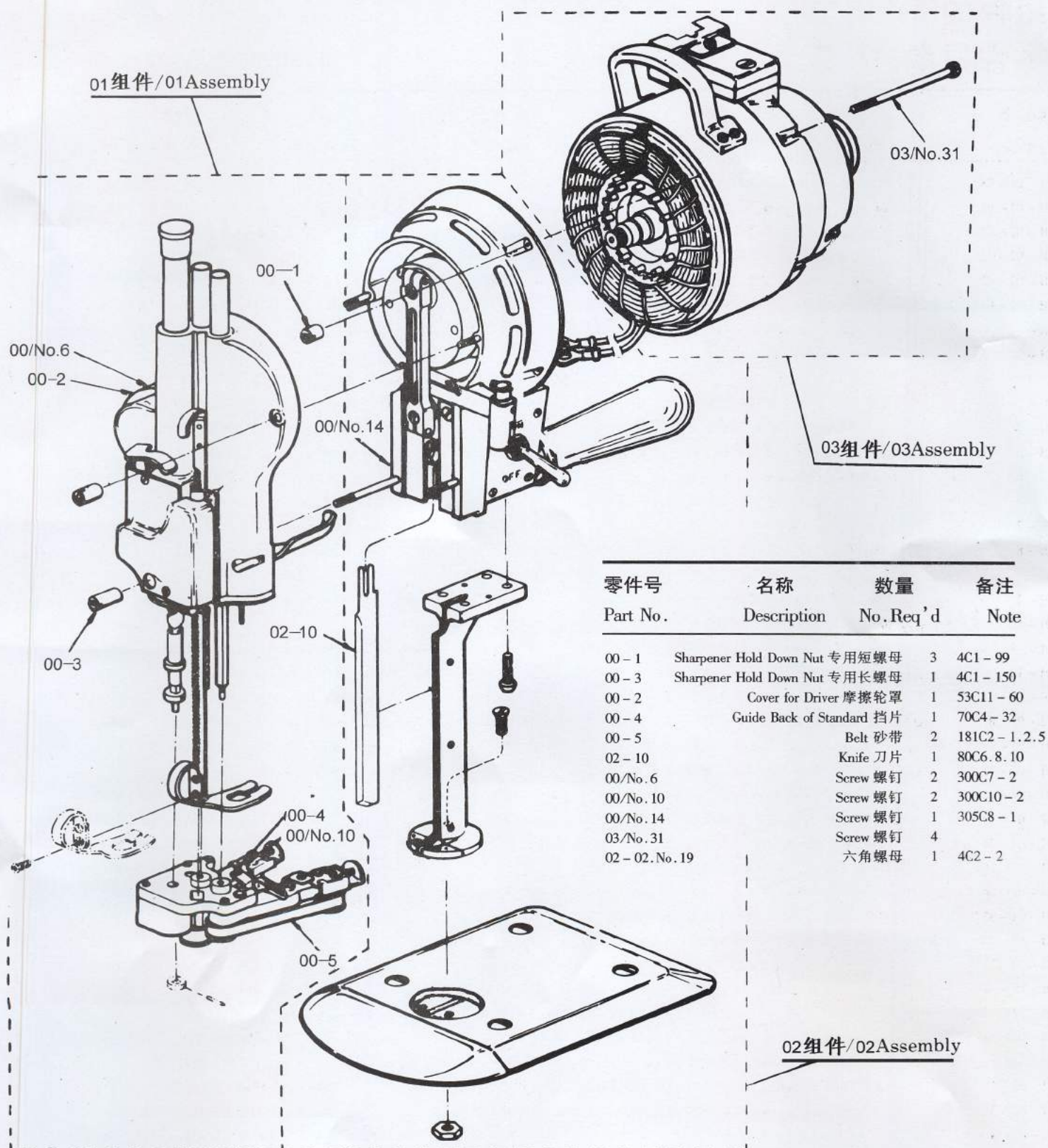
Do not operate sharpener without knife in machine or the sharpener will be damaged.

TO SHARPEN THE KNIFE

Take the machine out of the lay. Drop pressure foot by means of pressure foot lever located next to machine operating handle. Press release lever downward with a slow, firm pressure to engage sharpening mechanism. Too fast lever action may cause lever to lock. If this occurs. lift latch lever and start over. After a few tries you will feel correct operating pressure.

零件的 图解目录

Illustrated Parts List



零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
00-1	Sharpener Hold Down Nut 专用短螺母	3	4C1-99
00-3	Sharpener Hold Down Nut 专用长螺母	1	4C1-150
00-2	Cover for Driver 摩擦轮罩	1	53C11-60
00-4	Guide Back of Standard 挡片	1	70C4-32
00-5	Belt 砂带	2	181C2-1.2.5
02-10	Knife 刀片	1	80C6.8.10
00/No.6	Screw 螺钉	2	300C7-2
00/No.10	Screw 螺钉	2	300C10-2
00/No.14	Screw 螺钉	1	305C8-1
03/No.31	Screw 螺钉	4	
02-02.No.19	六角螺母	1	4C2-2

01

组件的 零件目录

磨刀机构组件

Assembly Illustrated Parts List

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
01-01-01	Thrust Ball Bearing 轴承组件	3	71C3-15
01-01-04	Release Lever with Cam 磨刀手柄组件	1	621C1-7
01-02-01	Slide with Pulley 滑动小轮组件	2	712C1-1
01-02-02	Stabilizer 紧定滚轮组件	2	728C1-5
01-02-03	R.H.Pre-set Sharpener Shoe 右磨刀垫组件	1	743C1-28
01-02-04	L.H.Pre-set Sharpener Shoe 左磨刀垫组件	1	743C1-29
01-1	Pressure Foot ver Screw 放松手柄螺钉	1	20C4-17
01-2	Knife Guard Rod 压脚杆	1	605C1-35 36.37
01-3	Cap of Tube 塑料帽	1	86C7-34
01-4	Cover for Lift Handle 提手塑套	1	53C11-103
01-5	Lift Handle for Knife Guard Rod 压脚杆提手柄	1	22C3-2
01-6	Spacer for Knife Guard Lock Bracket 护齿托架垫片	1	55C4-49
01-7	Cover Over Cam 前罩	1	53C11-72
01-8	Vinyl Cover for Pressure Foot Lever 压脚放松手柄塑料套	1	53C11-104
01-9	Pressure Foot Lever 压脚放松手柄	1	527C7-39
01-10	Spring for Pressure Foot Lever 放松手柄弹簧	1	34C10-100
01-11	Pressure Foot Shoe 压脚	1	68C1-192
01-12	Spring Washer 弹性圈	1	
01-01-1	Nut for Screw Shaft 丝杆上螺母	1	73C
01-01-8	Screw for Release Lever 磨刀手柄活动螺钉	1	20C-156
01-01-9	Screw for Latch 拨叉定位螺钉	1	20C12-113
01-01-11	Cam Shaft Spring Screw 发条销限位螺钉	1	20C12-13
01-01-12	Thrust washer for Nuts 轴承片	4	12C15-74
01-01-13	R.H.Nut for Screw Shaft 右向螺母	1	4C2-112
01-01-14	L.H.Nut for Screw Shaft 左向螺母	1	4C2-113
01-01-15	Thrust Washer - Upper Nut 轴承片	2	12C15-91
01-01-24	Bearing for Cam Shaft 发条销下轴衬	1	90C4-47
01-01-32	Spring for Latch 拨叉弹簧	1	34C10-107
01-01-33	Spring Washer for Release Lever 弹性垫圈	1	12C15-57
01-01-34	Latch for Cam 拨叉	1	97C3-35
01-01-36	Cam Spring 锁紧发条	1	34C1-20
01-01-37	Shaft for Cam 发条销	1	11C12-54
01-01-38	Bearing for Cam Shaft 发条销上轴衬	1	90C4-47
01-02-1	R.H.Shaft Extension 滑轮轴	1	147C1-28
01-02-2	L.H.Shaft Extension 8 牙齿轮轴	1	157C1-29
01-02-3	Intermediate Gear 双联齿轮	1	87C5-13
01-02-4	Lower Gear Bracket with Cover 磨刀架	1	715C1-19
01-02-6	Screw Shaft 双向丝杆	1	11C12-95.96

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
01-02-7	Screw for Sharpener Shoe 磨刀垫螺钉	2	20C12-152
01-02-8	Gear on Screw Shaft 24 牙齿轮	1	87C3-15
01-02-9	Screw for Clamping Arm 夹紧螺钉	1	20C12-143
01-02-10	Gear Cover 磨刀架盖板	1	53C4-78
01-02-11	Adjusting Screw 磨刀架盖板螺钉	1	20C6-25
01-02-12	Front Pulley for Belt 传动小轮	2	152C1-19
01-02-13	Collar for Extension 双向丝杆档圈	1	5C5-16
01-02-14	Neoprene Band for Pulley 传动小轮橡胶套	2	209C1
01-02-15	Bearing for Shaft Extension 传动小轮衬套	2	90C4-59
01-02-16	Bearing for Intermediate Gear 双联齿轮衬套	1	90C4-47
01-02-17	Spring for Pulley Slide 滑动小轮弹簧	2	34C10-45
01-02-18	Clamping Arm for Shoe 夹弹簧	1	35C7-28
01-02-19	Spring for Arm 夹紧臂弹簧	1	34C10-123
01-02-20	L.H.Sharpener Shoe Spring 左弹簧	1	34C10-148
01-02-21	Bearing for Screw Shaft 双向丝杆衬套	1	90C4-51
01-02-22	R.H.Sharpener Shoe Spring 右弹簧	1	34C10-149
01-02-23	Washer 磨刀垫螺钉垫片	4	12C15-94
01-02-24	Bushing for Sharpener Shoe 磨刀垫螺钉衬套	2	21C13-17
01-02-25	Washer Plate 耐磨板	2	79C12-218
01-03-1	Knife Guard Lock Bracket Complete 压脚托架	1	553C1-8
01-03-2	Screw for Knife Guard Lock 护齿螺钉	1	20C12-137
01-03-3	Lock for Pressure Foot 压脚定位板	1	171C1-16
01-03-4	Knife Guard Lock Bracket Only 支持桩子	1	553C1-8
01-03-5	Spring for Knife Guard Lock 护齿弹簧	1	34C8-12
01/No. 16	Screw for Pressure Foot Shoe 沉头螺钉	2	20C12-117
01/No. 17	Screw 沉头螺钉	1	302C10-8
01/No. 18	Screw 沉头螺钉	1	302C10-4
01/No. 19	Screw 半圆头螺钉	4	300C10-4
01/No. 20	Screw 半圆头螺钉	2	300C10-1
01-01/No. 43	Stop Nut for Screw Shaft 锁紧螺母	1	4C1-149
01-01/No. 46	Set Screw for Cam 圆柱端紧定螺钉	1	309C15-7
01-02/No. 30	Roll Pin 弹性圆柱销	3	17C15-106
01-02/No. 31	Screw 圆柱头螺钉	2	301C7-2
01-02/No. 32	Screw 半圆头螺钉	3	300C10-6
01-02/No. 33	Nut for sharpener Shoe Screw 六角螺母	2	4C2-63
01-02/No. 34	Screw 半圆头螺钉	4	300C7-3
01-02/No. 35	Screw 半圆头螺钉	1	301C10-3
01-02/No. 36	Grease Plug 平端紧定螺钉	1	54C4-35
01-02-04/No. 3	Jam Nut 小六角较扁螺母	1	4C1-189
01-02-04/No. 4	Stop Screw 内六角锥端紧定螺钉	1	309C12-2
01-03/No. 6	Nut for Pressure Foot Lock 锁紧螺母	1	4C1-161

01

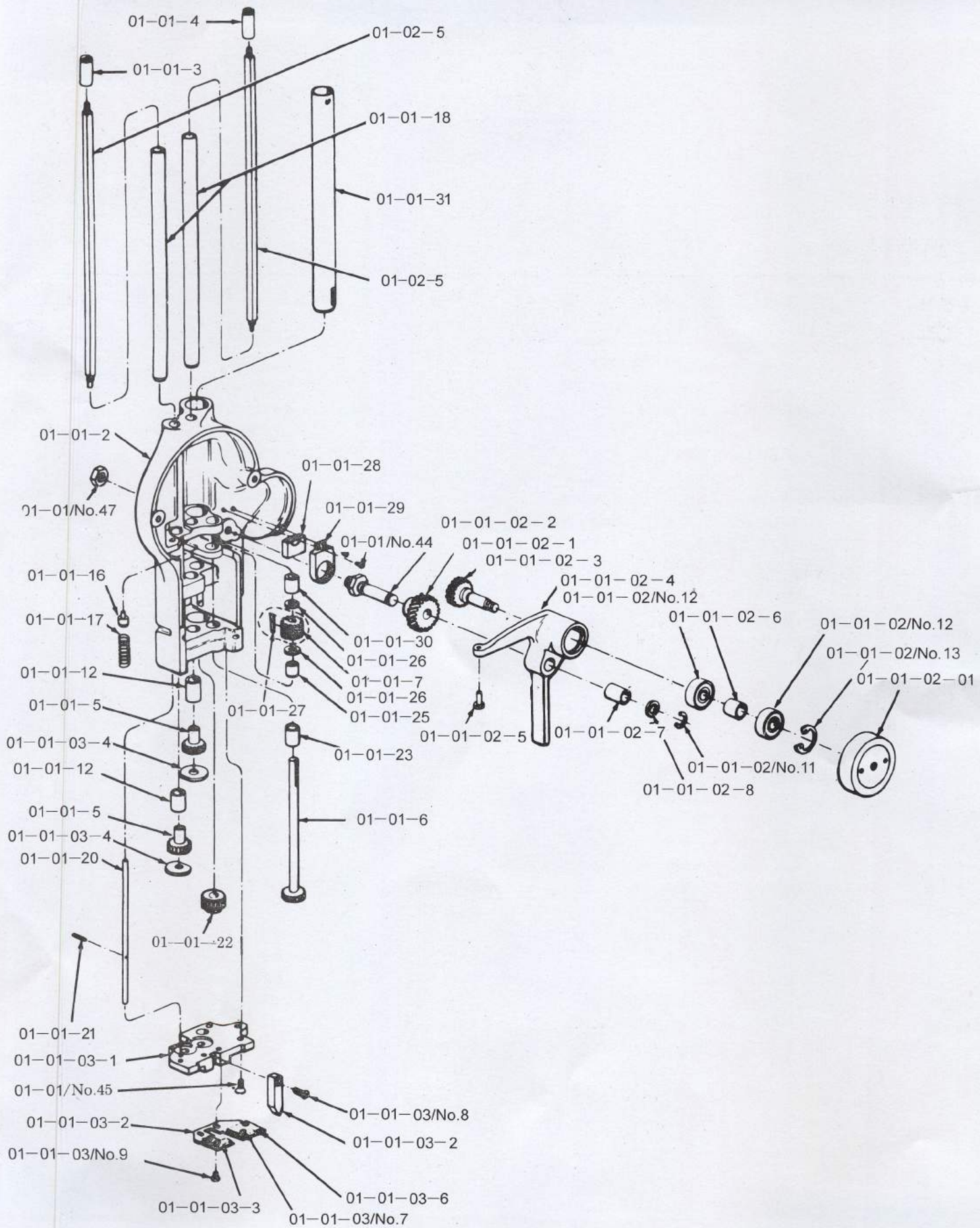
磨刀机构组件

组件的 零件目录

Assembly Illustrated Parts List

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
01-02-02-01	Driver Pulley with Driver 磨擦轮组件	1	602C1-9
01-01-2	Sharpener Housing 磨刀机匣	1	62C16-151
01-01-3	R.H. Follower Nut 随动右螺母	1	4C2-85
01-01-4	L.H. Follower Nut 随动左螺母	1	4C2-86
01-01-5	Spur Gear 20 牙齿轮	2	87C3-44
01-01-6	Driver Shaft with Gear 齿轮传动杆	1	718C1-12
01-01-7	Spiral Gear 15 牙斜齿轮	1	87C3-8
01-01-12	Bearing for Gears 牙斜齿轮轴衬	2	90C4-33
01-01-16	Pin for Sharpener Housing 推杆挡桩	1	17C15-82
01-01-17	Spring for Bell Crank 支撑弹簧	1	34C10-89
01-01-18	Tube for Square Shaft 方导杆管套	2	73C7-46,47
01-01-20	Push Rod 推杆	1	65C6-75
01-01-21	Roll Pin for Push Rod 推杆定位销	1	17C15-103
01-01-22	Bearing for Screw Shaft 丝杆轴套	1	90C4-58
01-01-23	Bearing for Drive Shaft 齿轮传动杆下轴衬	1	90C4-29
01-01-25	Bearing for Drive Shaft 齿轮传动杆中轴衬	1	90C4-42
01-01-26	Thrust Washer 15 牙斜齿轮垫圈	2	12C15-29
01-01-27	Key 键	1	142C1-7
01-01-28	Felt Pad for Oil Retainer 从动斜齿轮油盖毛毡	1	191C-34
01-01-29	Oil Retainer - Idler Gear 从动斜齿轮油盖	1	71C1-10
01-01-30	Bearing for Drive Shaft 斜轮传动杆上轴衬	1	90C4-48
01-01-31	Tube for Screw Shaft 丝杆管套	1	73C7-48,49
01-01-02-1	Idler Gear 斜齿轮	1	87C3-40

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
01-01-02-2	Shaft for Crank 斜齿轮轴	1	11C12-64
01-01-02-3	Gear and Shaft 斜齿轮轴	1	87C3-53
01-01-02-4	Bell Crank 斜齿轮传动机匣	1	85C3-6
01-01-02-5	Pin for Bell Crank 顶针	1	17C15-78
01-01-02-6	Spacer for Bell Bearings 斜齿轮轴衬圈	1	55C4-41
01-01-02-7	Bearing for Bell Crank 斜齿轮芯轴衬套	1	90C4-34
01-01-02-8	Washer for Shaft 垫片	1	12C15-52
01-01-03-1	Bottom Plate 磨刀机匣底板	1	79C2-163
01-01-03-2	Oil Pad and Holder 油垫座	1	727C1-6
01-01-03-3	L.H. Oil Pad 油垫座垫毡	1	
01-01-03-4	Thrust Washer for Bottom Plate 底板座垫圈	2	12C15-30
01-01-03-5	Spreader Pin 分离块	1	17C15-113
01-01-03-6	R.H. Oil Pad 油垫座右垫毡	1	
01-02-5	Square Pin 方导杆	2	11C12-56,57
01-01/No.44	Screw 半圆头螺钉	2	300C7-1
01-01/No.45	Screw 沉头螺钉	3	302C12-3
01-01/No.47	Lock Nut for Shaft 六角扁螺母	1	4C2-2
01-01-02/No.11	Retaining Ring for Shaft 轴用弹性挡圈	1	18C6-8
01-01-02/No.12	Ball Bearing for Crank 单列向心球轴承	2	90C6-24
01-01-02/No.13	Retaining Ring for Bell Crank 孔用弹性挡圈	1	18C6-26
01-01-03/No.7	Rivet 控心铜铆钉	4	GB975-76
01-01-03/No.8	Screw 沉头螺钉	1	302C10-6
01-01-03/No.9	Screw 半圆头螺钉	2	300C10-1



02

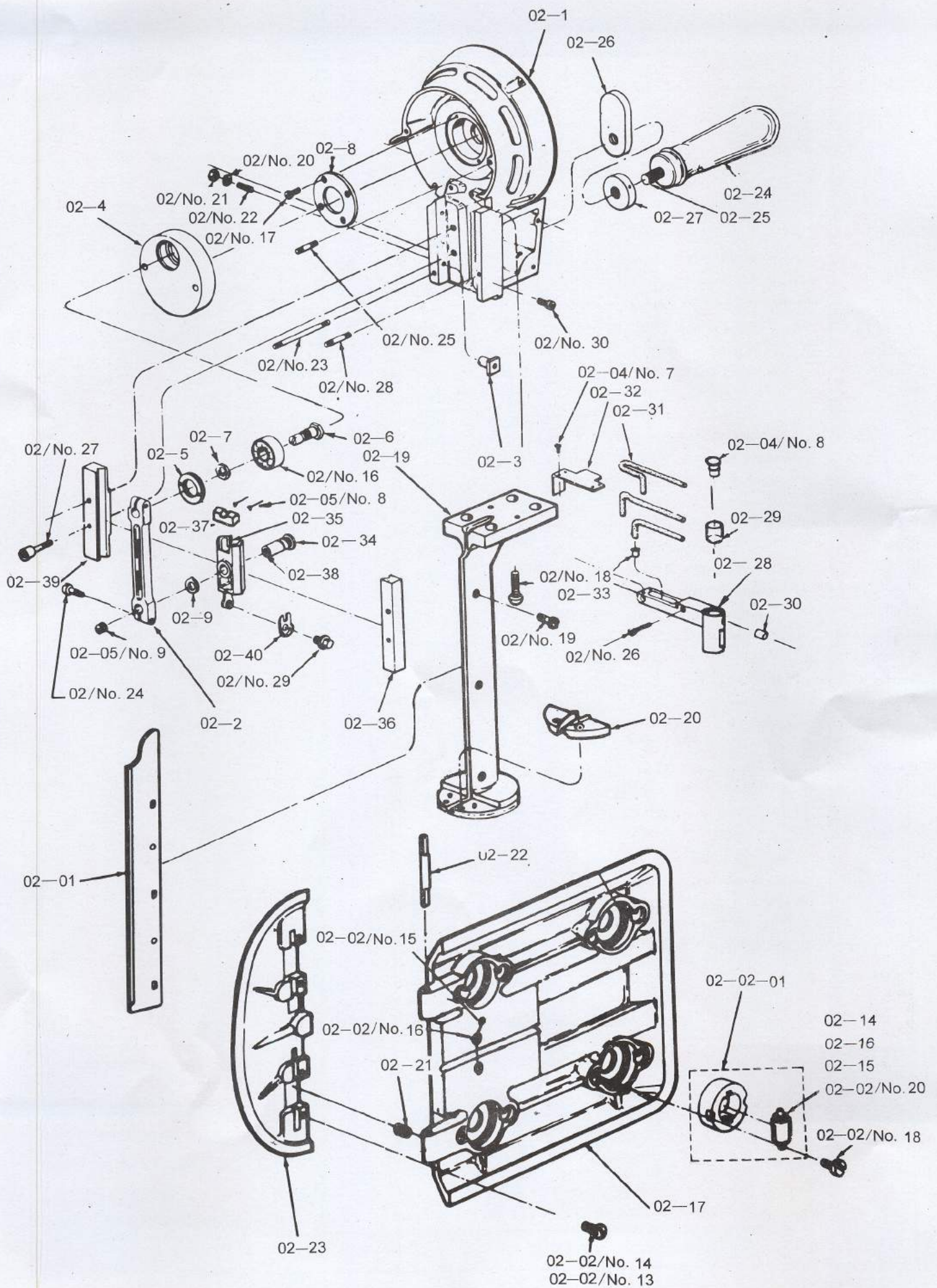
机架组件

组件的 零件目录

Assembly Illustrated Parts List

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
02-01	Knife Slide 刀壳组件	1	643C1-41 43.47
02-1	Front Bearing Housing 前机匣	1	90C2-139
02-2	Connecting Rod 连杆	1	664C1
02-3	Guide Adjustment Nut 支撑螺套	3	4C3-8
02-4	Crank 偏心轮	1	85C1-45
02-5	Crank Ball Bearing, Lock Nut 轴承挡圈	1	71C31-18
02-6	Shaft for Ball Bearing 传动销	1	11C12-92
02-7	Lock Nut for Shaft 传动销螺母	1	4C1-190
02-8	Front Ball Bearing Retainer 前机匣轴承挡圈	1	4C1-132
02-9	Connecting Rod Washer 垫片	1	12C15-53
02-14	Swivel Roller Assembly 底板滚棒轴	4	619C1-31
02-15	Swivel Roller Assembly 滚针	40	619C1-31
02-16	Swivel Roller Assembly 底板滚棒衬套	4	619C1-31
02-17	Plate 底座	1	500C3-224
02-19	Standard 立柱	1	528C1-116 120, 121
02-20	Foot Plates 脚板	2	79C4-12/1 13/1
02-21	Plate Wing Spring 导板弹簧	1	34C1-57
02-22	Hinge Pin 导板连接轴	2	17C6-9
02-23	Plate Wing 导板	1	60C1-56
02-24	Operating Handle 木头柄	1	531C1-53
02-25	Screw for Operating Handle 木头柄螺板	1	531C1-53/1
02-26	Handle Bracket 力板	1	62C1-140/1
02-27	Operating Handle Lock Nut 木手柄锁紧螺母	1	62C1-140/2
02-28	Oil Tube 油杯座	1	
02-29	Glass Tube 油杯窗	1	
02-30	Oil Tube Plug 油塞	1	
02-31	Long Wicking 油绳	3	
02-32	Cover for Oil Tub 油杯座盖板	1	53C6-1
02-33	Eyelet 空心铆钉	1	201C1-11
02-34	Wrist Pin 从动销	1	17C4-6

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
02-35	Cross Head 中心滑块	1	579C2-17
02-36	R. H. Guide 右导轨	1	525C1
02-37	Felt Pad for Cross Head 滑动块毛毡垫	1	
02-38	Long Wicking 从动销毛毡	1	191C1-38
02-39	L. H. Guide 左导轨	1	525C1
02-40	Knife Lock Washer 固定刀垫片	1	12C1-24
02-02-01	Rubber Mounted Roller 橡胶安装座组件	4	532C2-5
02/No. 16	Bearing 单列向心球轴承	1	
02/No. 17	Screw 沉头螺钉	4	
02/No. 18	Screw 圆柱头内六角螺钉	4	20C5-12
02/No. 19	Screw 圆柱头螺钉	3	4C2-2
02/No. 20	Washer 垫圈	9	10C10-2
02/No. 21	Nut 螺母	3	4C2-91
02/No. 22	Screw 内六角平端紧定螺钉	3	309C15-5
02/No. 23	Stub, upper 双头螺栓	1	15C13-34
02/No. 24	Screw 圆柱头内六角螺钉	2	20C5-17
02/No. 25	Stub, lower 双头螺栓	1	15C13-23
02/No. 26	Screw 沉头螺钉	2	302C8-2
02/No. 27	Screw 圆柱头内六角螺钉	6	308C14-1
02/No. 28	Stub, lower 双头螺栓	1	15C13-39
02/No. 29	Screw 方头螺钉	1	24C1-3
02/No. 30	Screw 圆柱头内六角螺钉	2	20C13-14
02-02/No. 13	Washer 外齿锁紧垫圈	4	12C1-35
02-02/No. 14	Screw 半圆头螺钉	4	20C13-51
02-02/No. 15	Pin 圆柱销	2	79C4-12/13/2
02-02/No. 16	Screw 十字槽沉头螺钉	2	79C4-12/13/2
02-02/No. 18	Clamp Screw for Roller 底板压轴螺钉	8	20C5-12
02-02/No. 20	Swivel Roller Assembly 垫圈	8	619C1-31
02-04/No. 7	Screw 半圆头螺钉	4	300C3-2
02-04/No. 8	Oil Hole Cover 油杯	1	
02-05/No. 8	Needle Pin 大头针	2	
02-05/No. 9	Screw 平端紧定螺钉		54C4-32



组件的 零件目录

03

电机组件

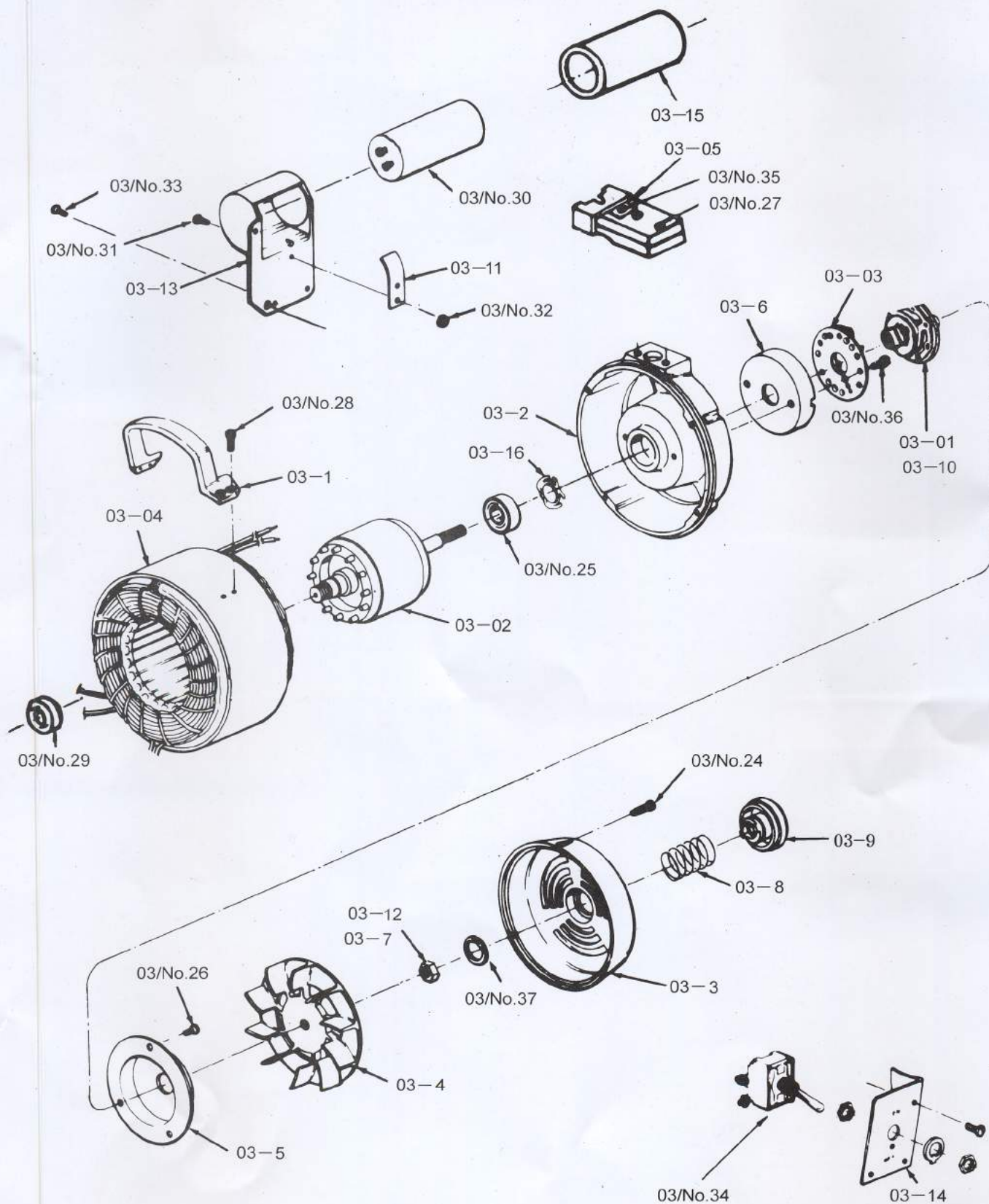
Assembly Illustrated Parts List

零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note	零件号 Part No.	名称 Description	数量 No. Req'd	备注 Note
03-01	Automatic Cutout Switch 离心开关组件	1		03-14	Swich Base 开关盖	1	52C5-161
03-02	Rotor with Shafe 电机转子组件	1		03-15	Cover for Capacitor 电容器外套	1	
03-03	Automatic Cutout 离心开关切断器	1		03-16	Loading spring washer 弹性垫圈	1	12C1-12
03-04	State with Band 电机定子组件	1		03-17	Nut 机壳螺母	1	4C1-179
03-05	Terminal Block 插头组件	1		03/No. 24	Screw 十字槽盘头螺钉	2	301C8-1
03-1	Carrying Handle 提手柄	1	22C1-24	03/No. 25	Rear Nall Bearing 单列向心球轴承	1	GB278-64
03-2	Rear Bearing Housing 后机匣	1	90C1-146	03/No. 26	Screw 十字槽盘头螺钉	2	305C8-1
03-3	Fan Cover 风轮盖	1	53C7-35	03/No. 27	Screw 沉头螺钉	1	302C15-6
03-4	Rotor Fan 风轮	1	10C1-41	03/No. 28	Screw 十字槽盘头螺钉	4	300C12-16
03-5	Cover for Cutout 离心开关盖	1	30C1-8	03/No. 29	Bearing 滚珠轴承	1	
03-6	Cutout Switch Mount 离心开关罩	1	67C1-10	03/No. 30	Capacitor 启动电容	1	
03-7	Clutch Nut 电机转子螺母	1	4C2-87	03/No. 31	Screw 半圆头螺钉	1	300C12-3
03-8	Clutch Spring 弹簧	1	34C1-51	03/No. 32	Shaft Lock Nut 六角螺母	1	4C2-110
03-9	Turning knob 旋钮	1	13C1-9	03/No. 33	Screw 球面圆柱螺钉	6	305C8-1
03-10	Shaft Cover 轴套	1	597C2-15/1	03/No. 34	Switch 电机开关	1	
03-11	Spring for Capacitor 电容压板	1	34C10-142	03/No. 35	Screw 圆柱头螺钉	1	301C15-5
03-12	Nut 六角销紧螺母	1	C41-145	03/No. 36	Screw 十字槽盘头螺钉	2	300C12-5
03-13	Capacitor Cover 电容器罩	1	53C11-91	03/No. 37	Retaining Ring 轴用弹性挡圈	1	18C6-16

不同尺寸零件表

10", 8", 6" Different Size Parts List

图 号 Part No.	名 称 Description	尺 寸 规 格 Size		
		10"	8"	6"
01-2	Knife Guard Rod 压脚杆	364	314	314
01-01-18	Tube for Square Shaft 方导杆管套	245	195	195
01-01-31	Tube for Screw Shaft 丝杆管套	244	194	194
01-02-5	Square Shaft 方导杆	297	247	247
01-02-6	Screw Shaft 双向丝杆	369	319	269
02-01	Knife Slide 刀壳组杆	269	219	169
02-10	Knife 刀片	294	244	194
02-19	Standard 立柱	274	224	174
02-26	Handle Bracket 力板	专用	/	/
307C18-2	Screw 内六角螺钉	专用	/	/
20C12-79	Screw 沉头螺钉	专用	/	/



常见的故障原因及处理方法

Another Causes of Machine

1、磨刀器放不下来

- ①零件 (01-01-02-01) 沾到油, 用布擦干净。
- ②零件 (01-01-17) 坏了, 换新的。
- ③零件 (01-01-02-01) 磨损, 换新的。

2、磨刀器下

磨刀架内齿轮和丝杆无油脂, 加油脂。

3、刀片切不动

- ①砂带 (00-5) 坏了, 换新的。
- ②砂带磨不到刀片, 调整螺丝 (02-02-7)。
- ③刀片已磨到底, 换新的。
- ④磨刀角度左右不平均, 调整左、右磨刀垫 (01-02-03, 04)

4、启动不良

- ①马达内有杂物, 修理或清除。
- ②刀壳 (02-01) 内部烧坏或有烧焦物, 换新的。
- ③电压太低, 量电压是否正常。
- ④电线太长, 用的电线不要超过四公尺。
- ⑤用油不好, 换用随机的润滑油。

5、机器表面带静电

插头未接地, 将插头接地。

1.Sharpener dose not drive

- ①Drive puller(01-01-02-01) is oiled. Clean it please.
- ②Spring(01-01-17)damaged . Change a new one please.
- ③Driver pulley (01-01-02-01) damaged, Change a new one please.

2.Sharpener falls down easily.

Remove Screw (01-02/No.36)and Squeeze some grease into opening.

3.Machine does not cut easily

- ①Belts (00-5) damager, change new Belts please.
- ②Belts can not sharpen Knift, adjust Screw (02-02-7) please.
- ③Knife damaged, change a new one please.
- ④Level on both sides of Kinfe is not approximate, djust Sharpener shoes (01-02-03, 04) , please.

4.Motor can not be running

- ①Clear or repair Motor Please.
- ②Knife Slide daanaged,change a new one please.
- ③Electric supply voltage is not correct.
- ④Electric supply wire of machine is too long, don' t be longer than 4 m please.
- ⑤Use the oil following the machine or 30 weight non-detergent oil please.

5.Connected Attachment Plug with ground please.

附 件

Maintenance Supplies

零件号 Part No.	名称 Description	数量 No.Req'd	备注 Note
F02	Slot Cleaner槽子清洗器	1	81C-2
F03	Wrench板手	1	529C1-8
F04	Attachment Plug电源插头组件	1	
F05	Terminal Plug三眼插头	1	
02011	Knife刀片	1	80C6, 8, 10