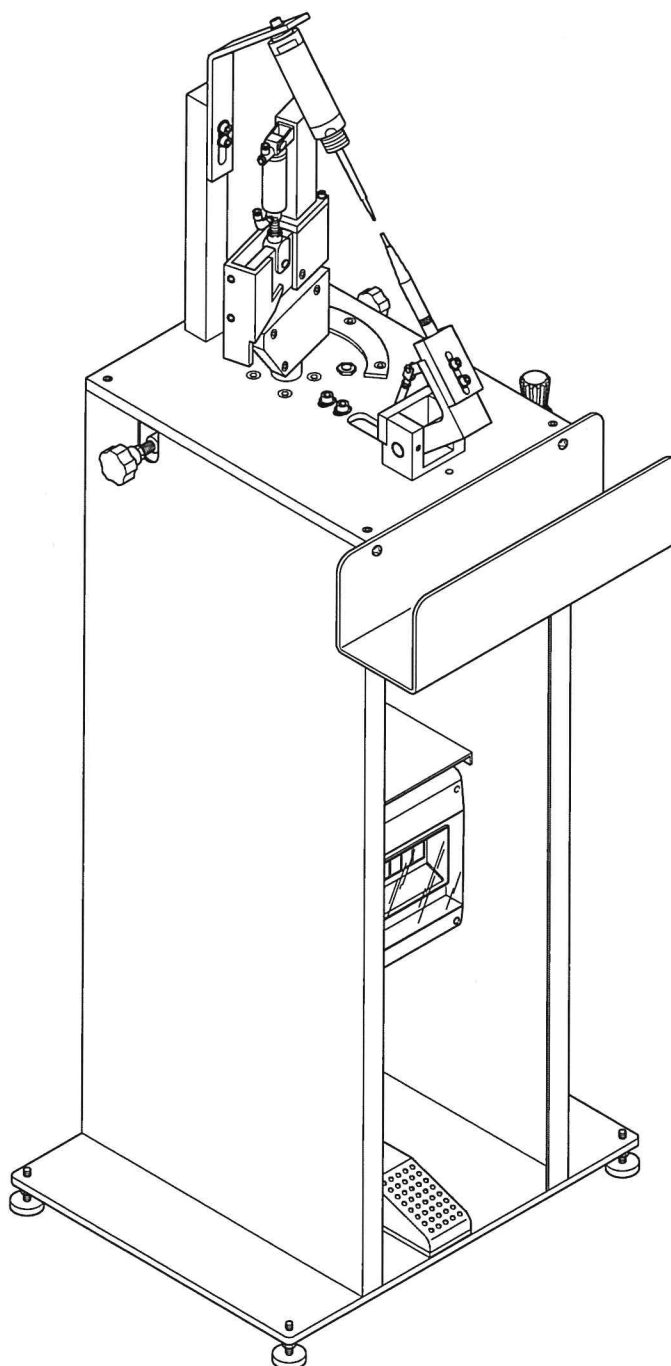


COLLAR TIP TRIMMER **mod. MTP**



Instructions for use and maintenance





Macchine Automatismi Industriali Camicerie Abbigliamento

Via Casale, 23 - 24060 Torre de' Roveri (Bergamo) - ITALY

Telefono (+39) 35 580040 - Telefax (+39) 35 580920

web: www.maicaitalia.com

e-mail: info.maicaitalia@maicaitalia.com

AUTHORIZED AREA DEALER FOR ASSISTANCE



EEC CONFORMITY DECLARATION

The **COLLAR TIP TRIMMER mod. MTP**, as described in this manual, complies with the standards set down by the following EEC Directives :

UNI EN 292-1	Machine safety. Essential principles.
UNI EN 292-2	Machine safety. Essential principles.
UNI EN 294	Machine safety. Safety distances for arms.
UNI EN 349	Machine safety. Minimum crushing distances.
UNI EN 418	Machine safety. Emergency stop devices.
pr EN 563	Machine safety. Contact surface temperatures. Ergonomic data.
pr EN 574	Machine safety. Two-hand control devices.
pr EN 953	Machine safety. Guard design and construction.
pr EN 1088	Machine safety. Interlocking devices with or without guard locking.
EN 60204-1	Electrical devices on industrial machines. Part 1: general standards.
EN 60529	Levels of protection guaranteed by guards (IP code).

Manufacturer:
M.AI.C.A. S.r.l.

01 - GENERALITIES

CHARACTERISTICS AND FIELD OF APPLICATION


The new MTP Collar Tip Trimmer lets you cut the collar tips and turn up the shirt collars in preparation for ironing.

You can adjust the angle of the cut to suit the model of collar used, without having to replace any templates or dies.

The electrically and pneumatically driven work cycle is controlled by PLC.

ADVISED USE

The MTP Collar Tip Trimmer should only be used to turn up shirt collars and to cut the collar tips on these collars. The manufacturer cannot be held liable for any damage to persons or property arising from the incorrect use of this machine or any use differing from the instructions indicated in this manual.

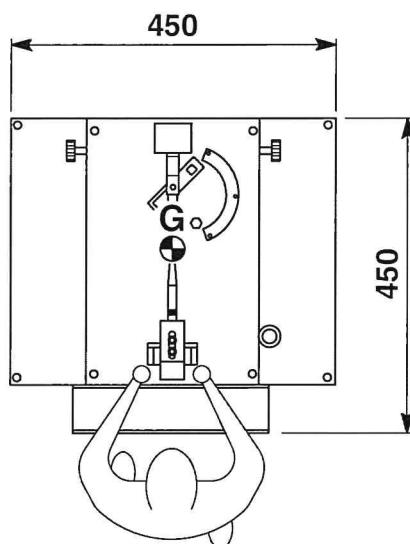
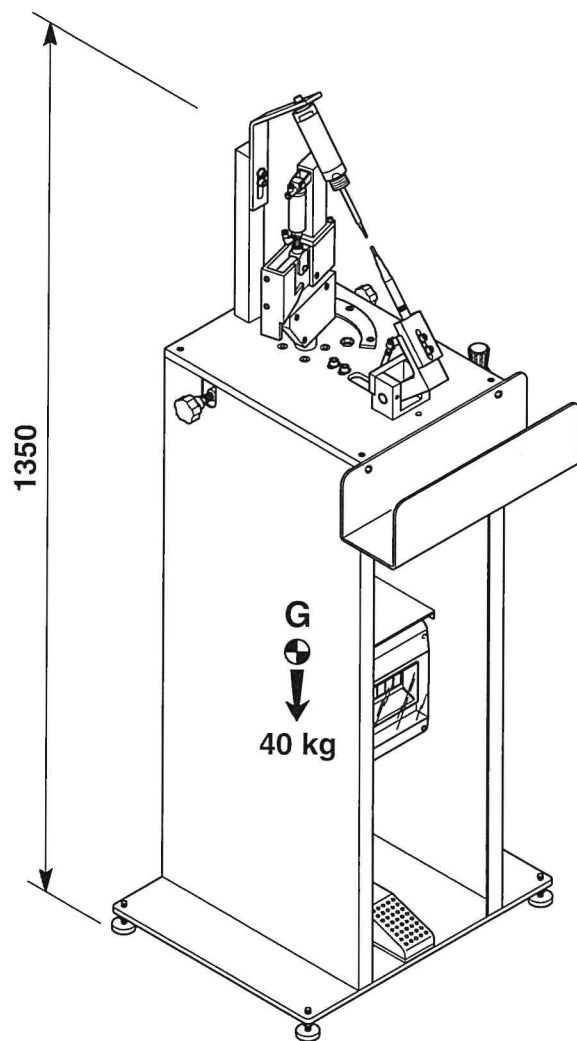
The  symbol indicates there exists a risk or danger for the health of the operator and, therefore, much care must be taken at this point.

The machine is fitted with a collar turn-up roller and a moving collar tip-cutting blade. Exercise extreme caution when near those parts.

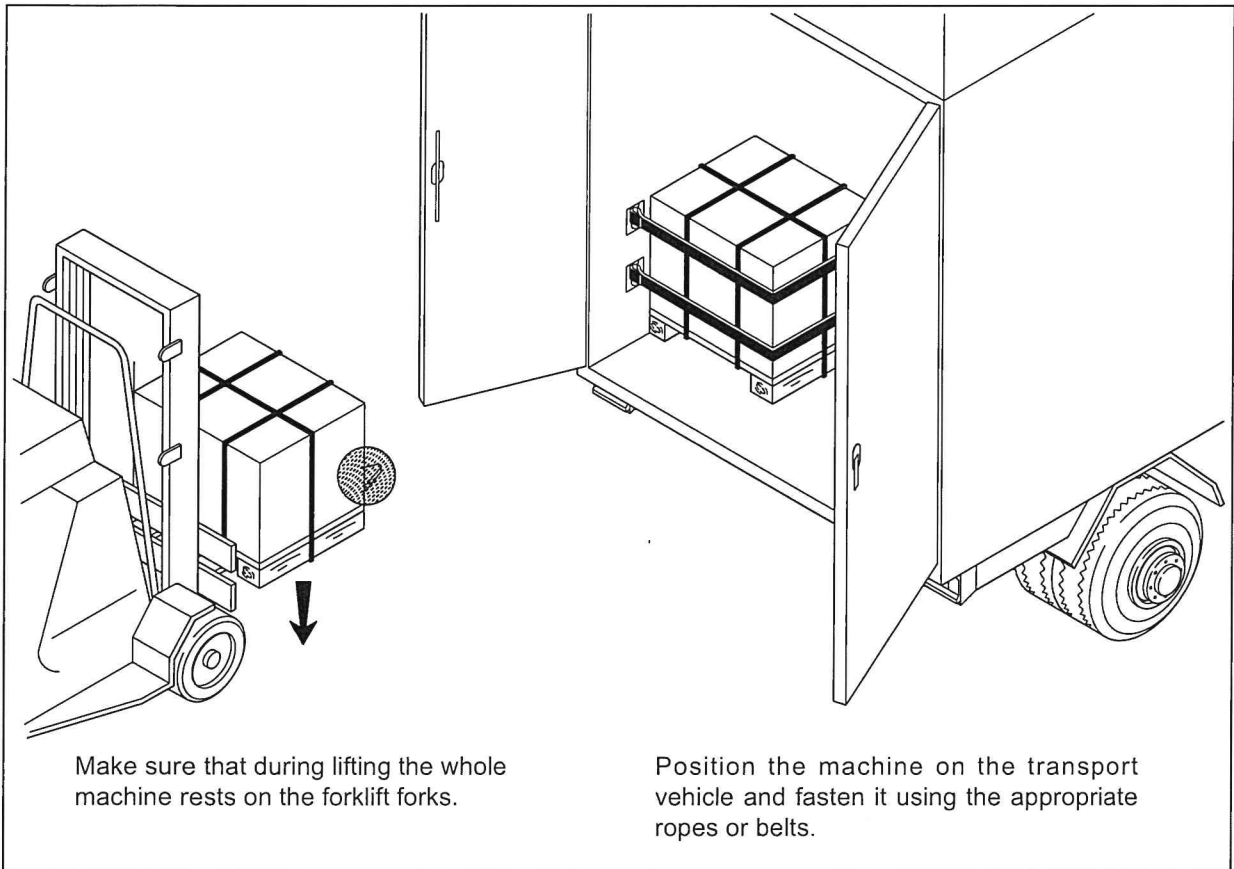
Always disconnect the machine from the mains supply, and the compressed air supply before undertaking any adjustment, replacement or maintenance work.

The machine **must not be** exposed to the weather (rain, sun, etc).

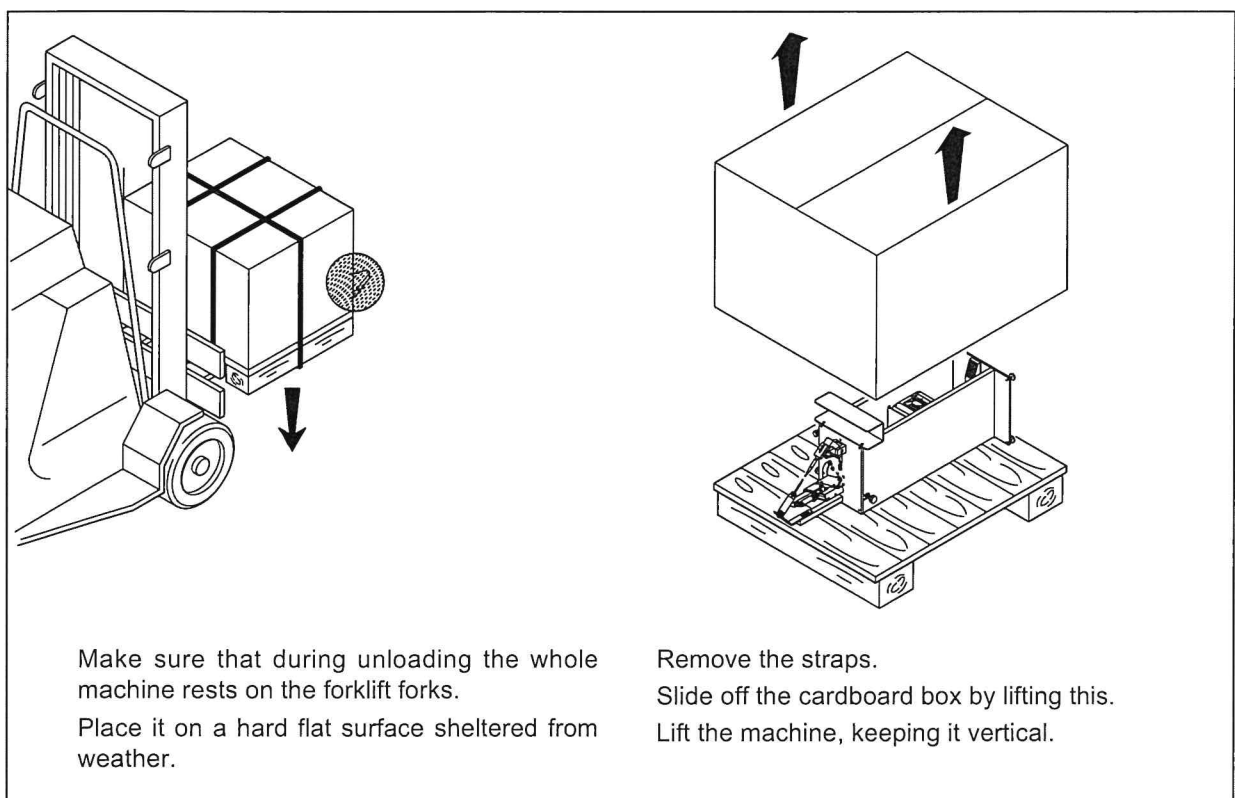
02 - COLLAR TIP TRIMMER mod. MTP TECHNICAL DATA



03 - LIFTING AND TRANSPORTATION



04 - LOADING AND UNLOADING



05 - INSTALLATION

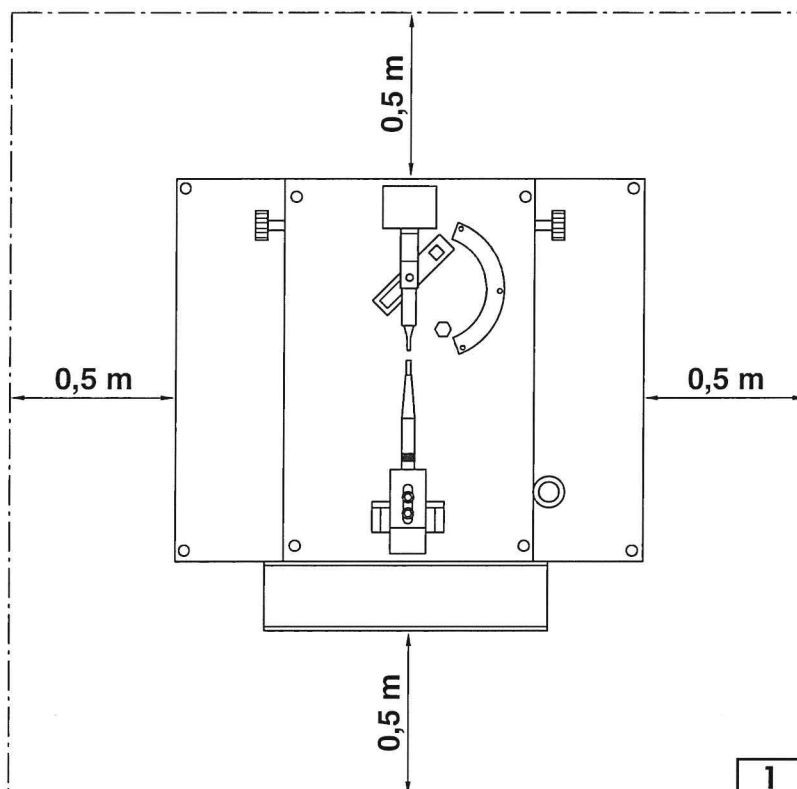
ATTENTION: This machine must only be installed by specialized personnel.

The manufacturer cannot be held liable for any damage to persons or to property arising from incorrect installation not in accordance with these instructions and connection to a mains supply that does not meet the necessary requirements.

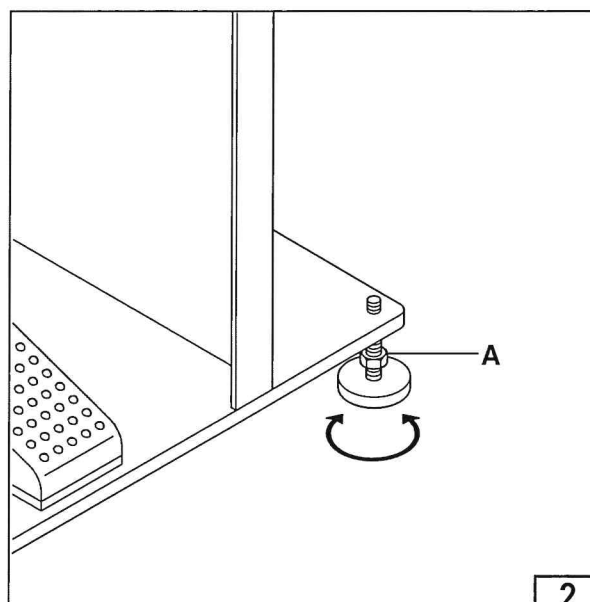


If the machine is installed on a suspended surface, check that the surface can withstand the weight of the machine. This machine must not be installed in areas where there are explosive or inflammable materials and substances.

To facilitate use and maintenance operations, keep the distances indicated in fig. 1.



The machine must be placed on a solid and even surface. Turn the nuts "A" (fig. 2) on the leveling feet to adjust the height.



ELECTRICAL CONNECTIONS

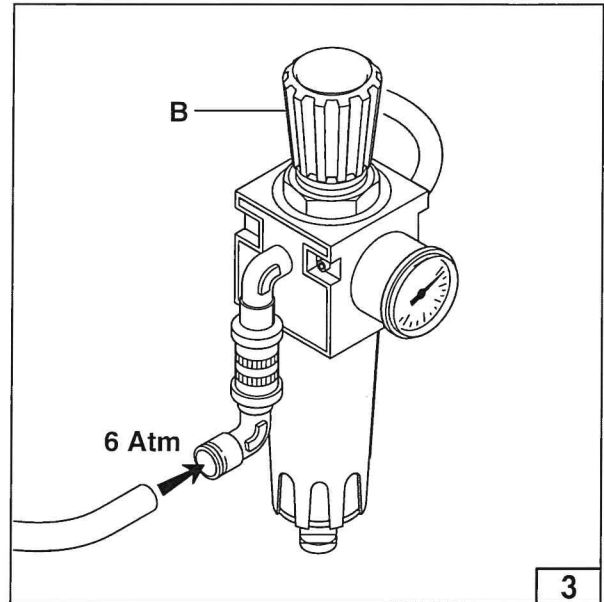
The machine is delivered complete with power cable.

Connect the power cable to a 220V-50Hz single-phase plug.

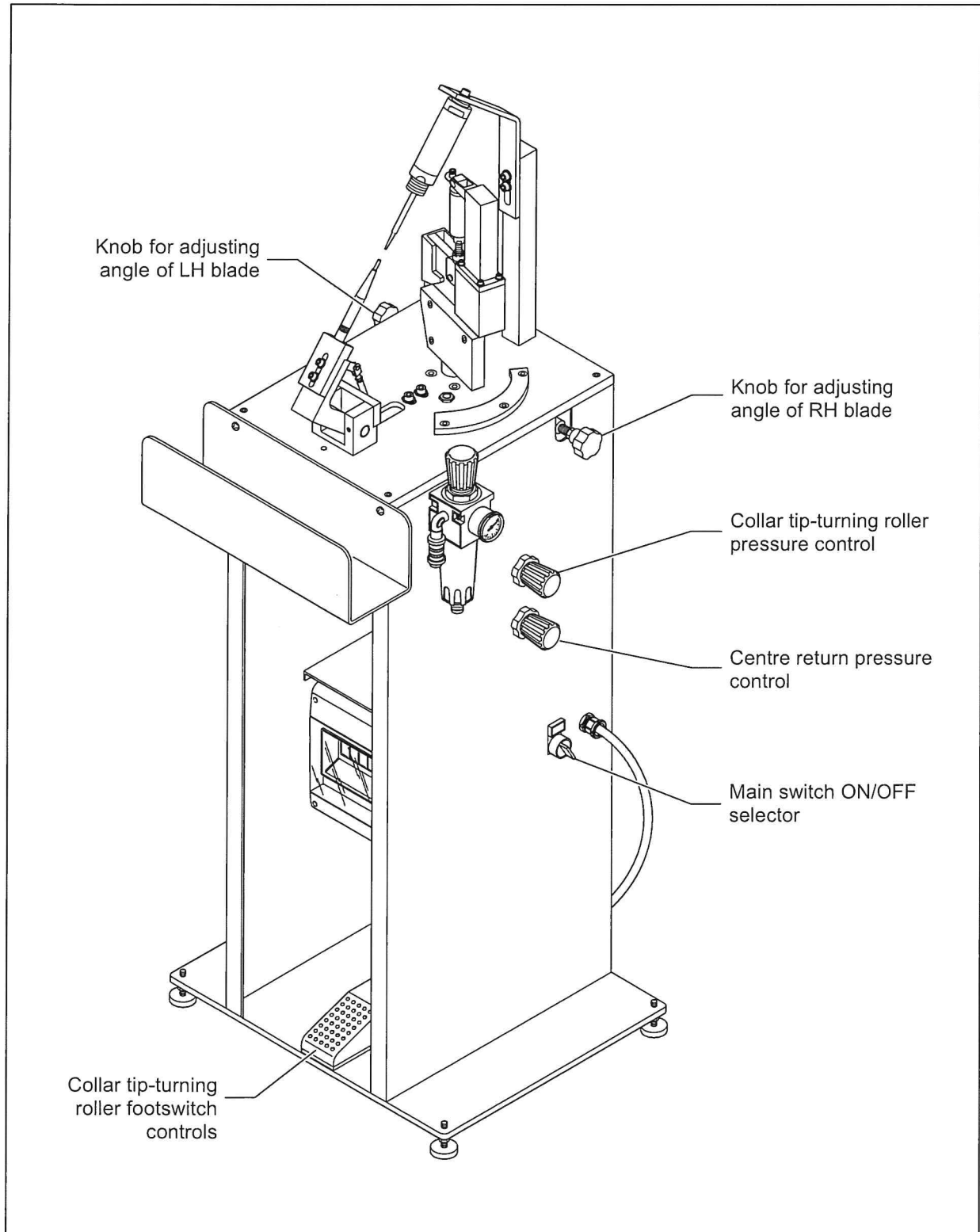
Before installation, check the efficiency of the earth system to which the machine will be connected.

PNEUMATIC CONNECTION

- Connect the machine to the compressed air outlet and make sure that the air flow is sufficient to allow for operation with a constant rate of pressure of 6 Atm.
- Calibrate pressure regulator "M" at between 6 Atm (fig. 8).



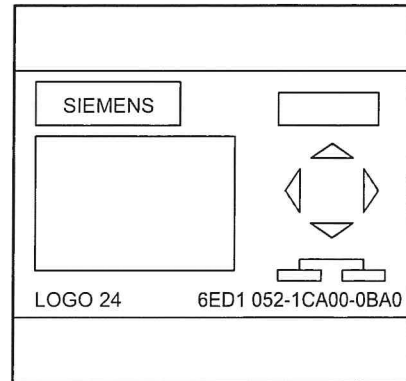
06 - MACHINE CONTROLS



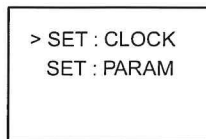
FUNCTION CONTROL VIA LOGO PROGRAMMER


The Logo programmer lets you program:

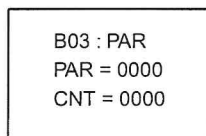
- 1 - **B6** Cutting time (0 -10).
- 2 - **B10** Start rotation time (0-30).
- 3 - **B21** 1st cut after rotation time (0-10).
- 4 - **B22** 2nd cut after rotation time (0-10).
- 5 - **B25** Reverse rotation start time (0-50).








- Press keys (OK) and (ESC) at the same time.
The words SET : CLOCK - SET : PARAM: appear on the display.



- Use arrow key  to take the cursor > to SET : PARAM
- Press (OK).
- The display should now read:



- Use arrow key  to go to the parameter you want.
- Press (OK) and then use the arrow keys   to go to the value you want to change.

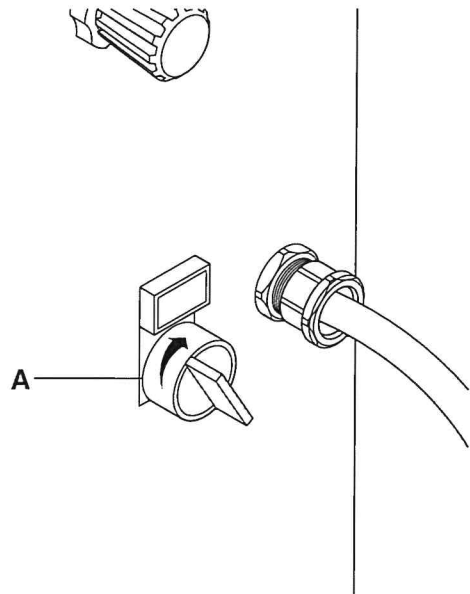
Press arrow keys   to increase/decrease the value.

- Having changed the value, press (OK).

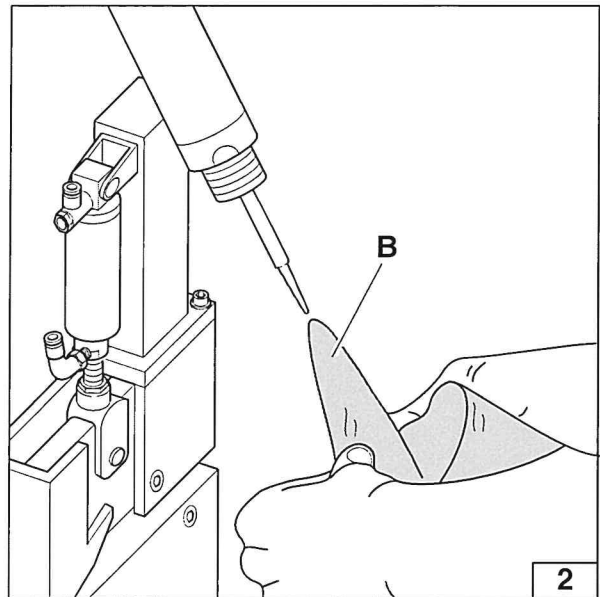
07 - OPERATION

START-UP

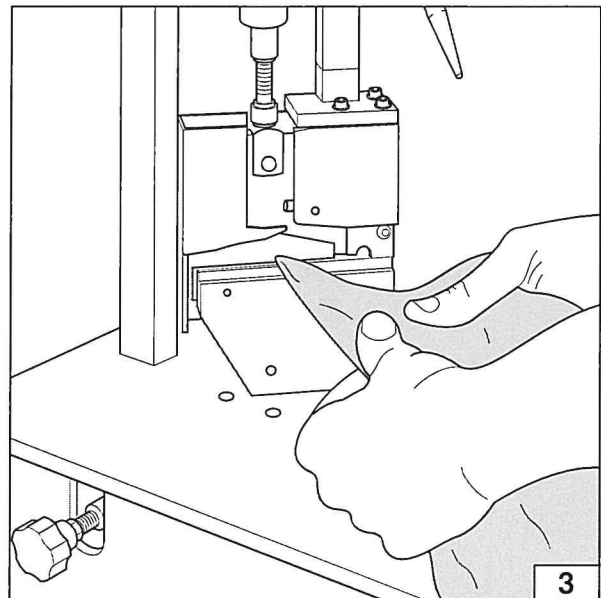
- Switch on the main switch by turning selector "A" (fig. 1) to the right.
- Open the air inlet valve.



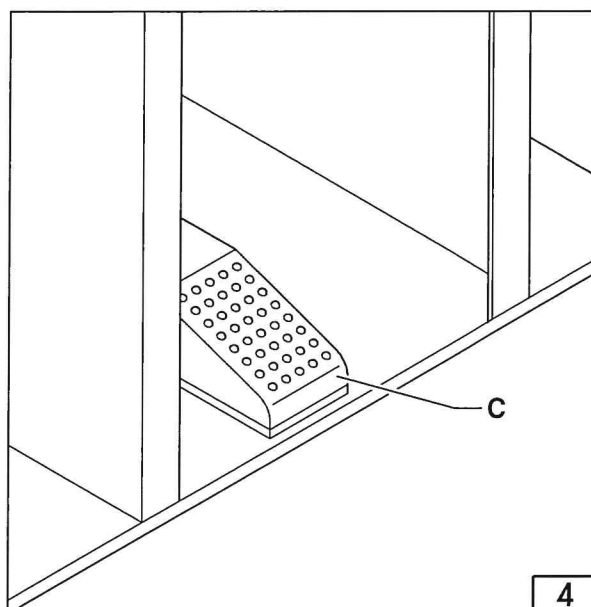
- Place collar "B" on the collar tip holder (fig. 2).



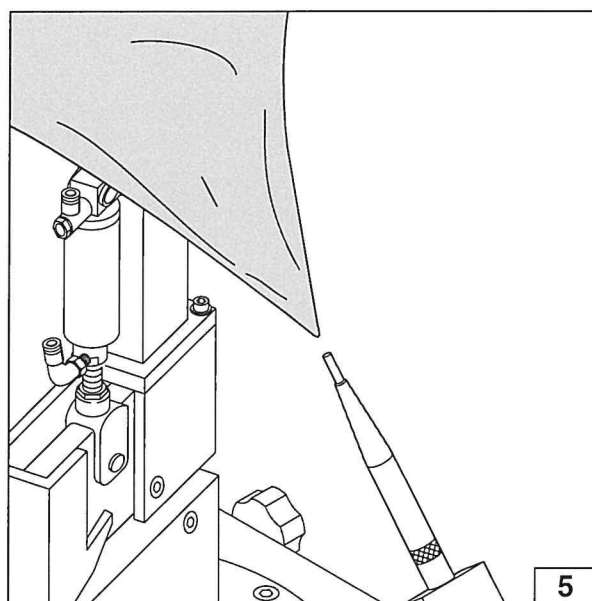
- Press the collar-bearing collar tip holder up against the blade (fig. 3) and hold until the 1st and 2nd cuts are both made.
- Release the collar tip holder so that it returns pneumatically



- Once the collar tip holder has returned to its original position, press footswitch "C" (fig. 4) to activate the collar tip-turning roller.



- Pull the fabric up and turn the collar over (fig. 5).



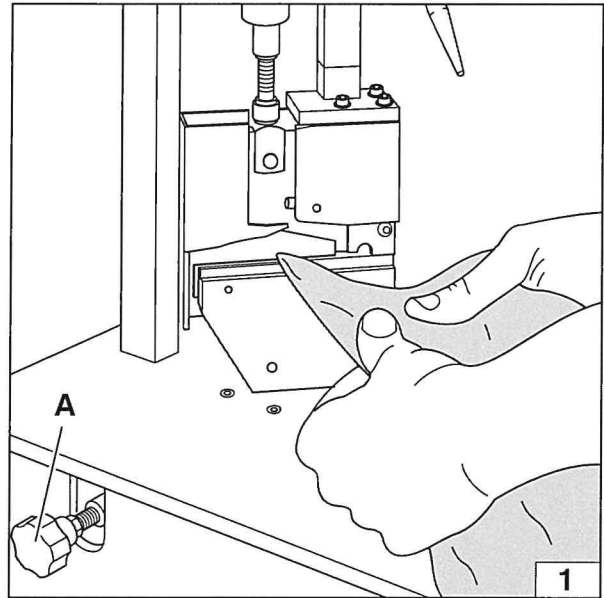
08 - ADJUSTMENTS



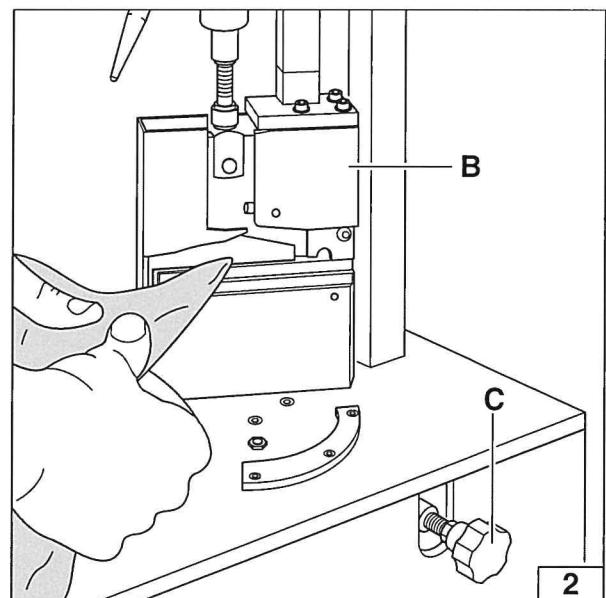
The operations described below must only be carried out by specialized personnel.

ADJUSTING THE CUTTING ANGLE

- Switch the machine off and cut the compressed air supply.
- Place the collar on the collar tip holder and press against the blade (fig. 1).
- Adjust the 1st cutting angle "LX" using knob "A" (fig. 1).

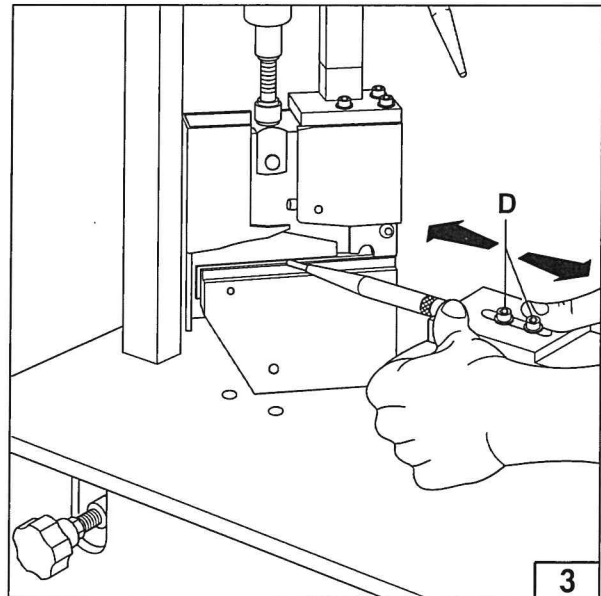


- Manually secure blade-holder "B" and adjust the 2nd cutting angle "RX" using handwheel "C" (fig. 2).
- Take the blade-holder unit to the actual cutting position for the 1st cutting angle.
- Switch the main switch back on and return the compressed air supply.

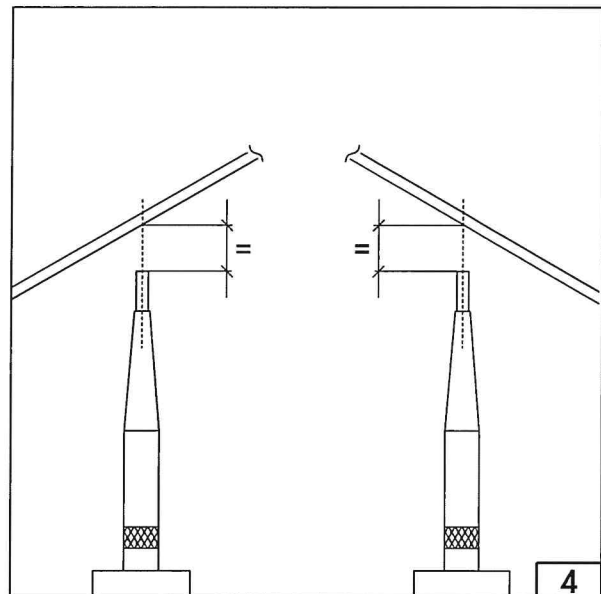


ADJUSTING THE CUTTING DEPTH

- Switch the machine off and cut the compressed air supply.
- Take the collar-holding collar tip holder up against the blade, horizontally, and adjust the cutting depth using screws "D" (fig. 3);



- Check that the collar tip holder is the same distance from the blade in both cutting positions (fig. 4);
- Switch the main switch back on and return the compressed air supply.

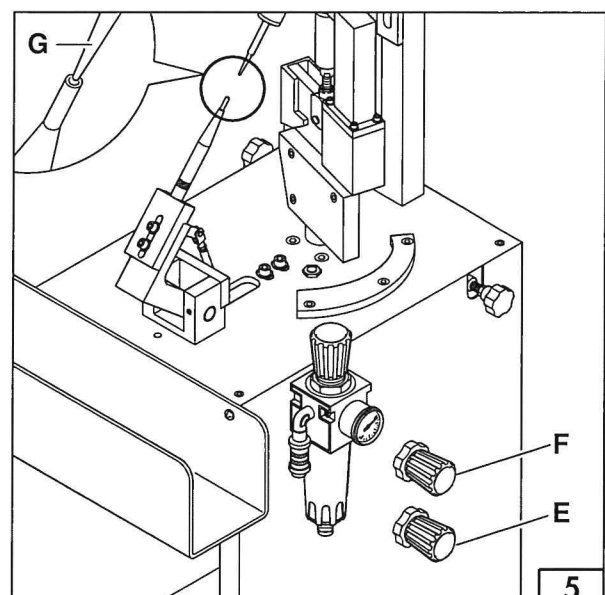


ADJUSTING THE COLLAR TIP HOLDER BACKPRESSURE

- Pull out pressure regulator "E" (fig. 5) and adjust the pressure so that the collar tip holder moves smoothly and returns to the start position after cutting the collar tips.

ADJUSTING THE STICHT-TURNING ROLLER PRESSURE

- Pull out pressure regulator "F" and adjust the pressure so that the tip of roller "G" enters the centre of the collar tip holder (fig. 5).



09 - MAINTENANCE



Cut the electricity and compressed air supplies before carrying out any maintenance or replacement. The operations described below must be carried out by expert personnel only.

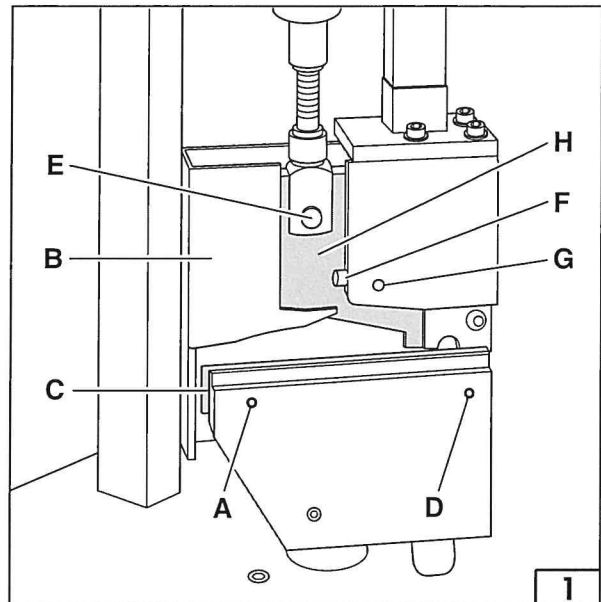
CLEANING THE CUTTING BLADE

Regularly remove any threads from the blade using a blast of compressed air.

SHARPENING THE CUTTING BLADE (FIG. 1)

If the cut is not sharp and correct, try moving the counterblade towards the blade using grub screw "A". If this doesn't improve matters, sharpen or replace the blade and counterblade as follows:

- Remove safety cover "B";
- Extract counterblade "C" by loosening screw "D";
- Remove roller connection pin "E";
- Loosen setscrew "F";
- Loosen screw "G" and extract blade "H";
- Sharpen or replace the blade and counterblade, then reassemble everything in the reverse order.



DEMOLITION

In case of machine demolition, separate the different materials making up the machine so that they can be shipped to designated collection sites for re-cycling.

10 - MALFUNCTIONS, CAUSES AND REMEDIES

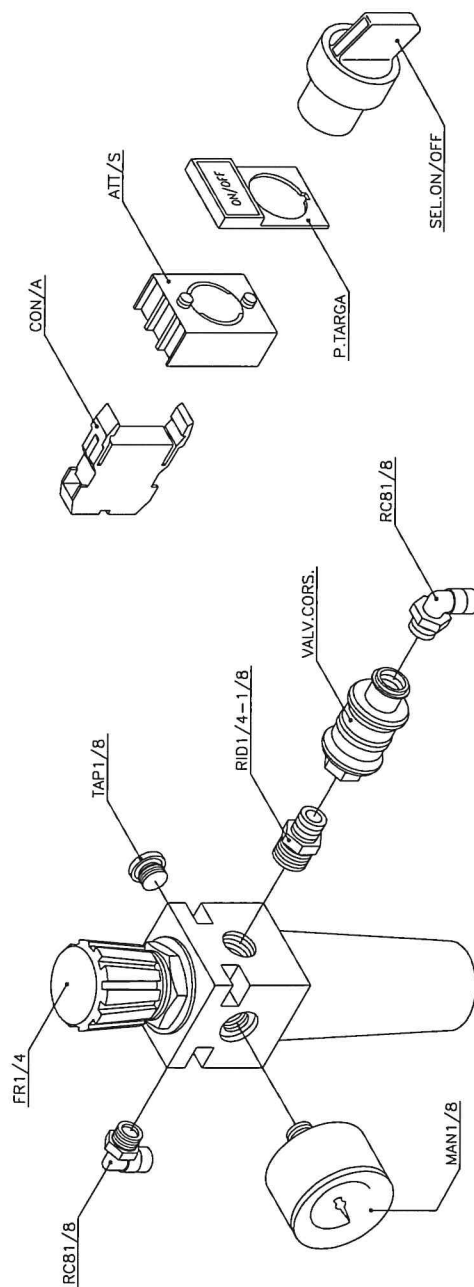
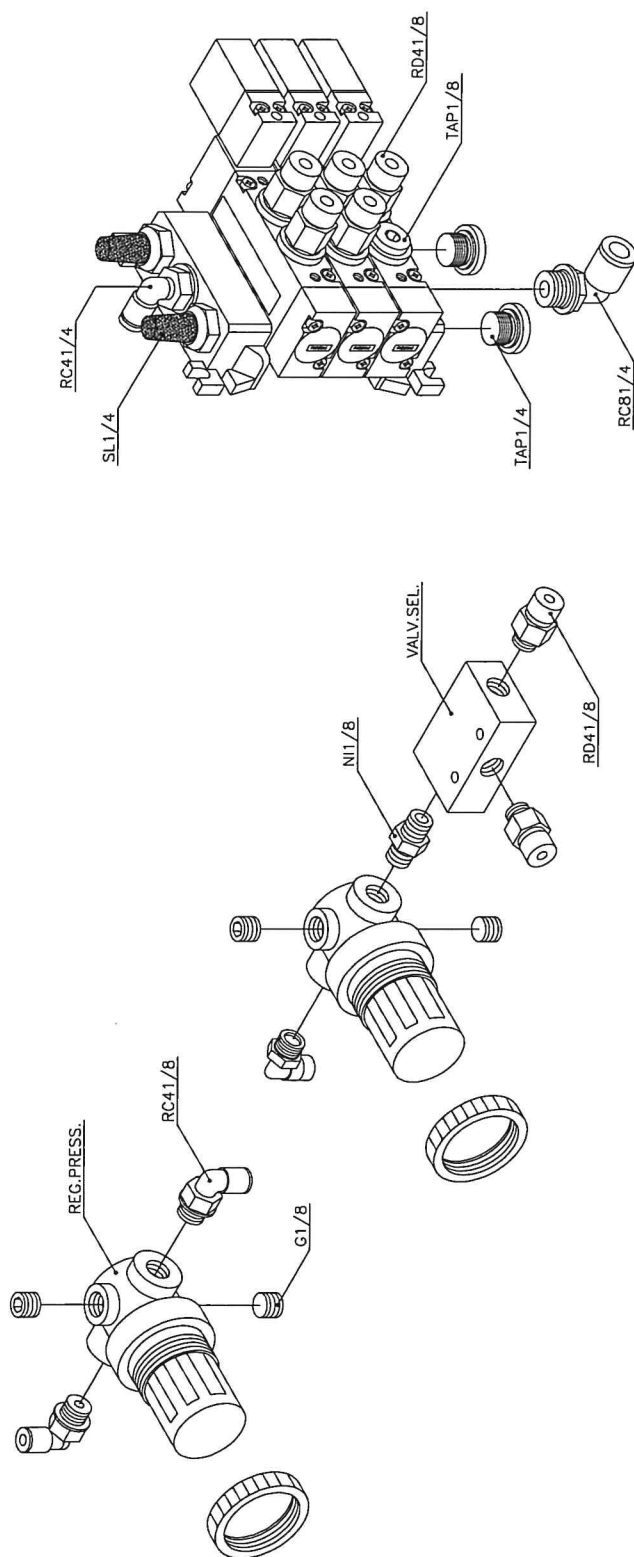
MALFUNCTION	CAUSE	REMEDY
The machine won't start	Main switch not turned on.	Turn the selector to the right.
	Inefficient PLC.	Check PLC switches on properly.
	No pressure	Check the pressure in the pneumatic circuit.
The machine won't make the 1st cut	Inefficient collar tip holder movement roller limit switch, or in wrong position	Check efficiency of limit switch. Adjust its position so that the led comes on when the roller reaches the end of its stroke. Check that the PLC signal arrives.
The machine only makes the 1st cut	Inefficient proximity switch	Check the efficiency of the proximity switch and replace if necessary.
Cut isn't sharp	Blade and counterblade need sharpening or cleaning	See instructions in paragraph 09-MAINTENANCE on page 13.

11 - SPARE PART SHEETS

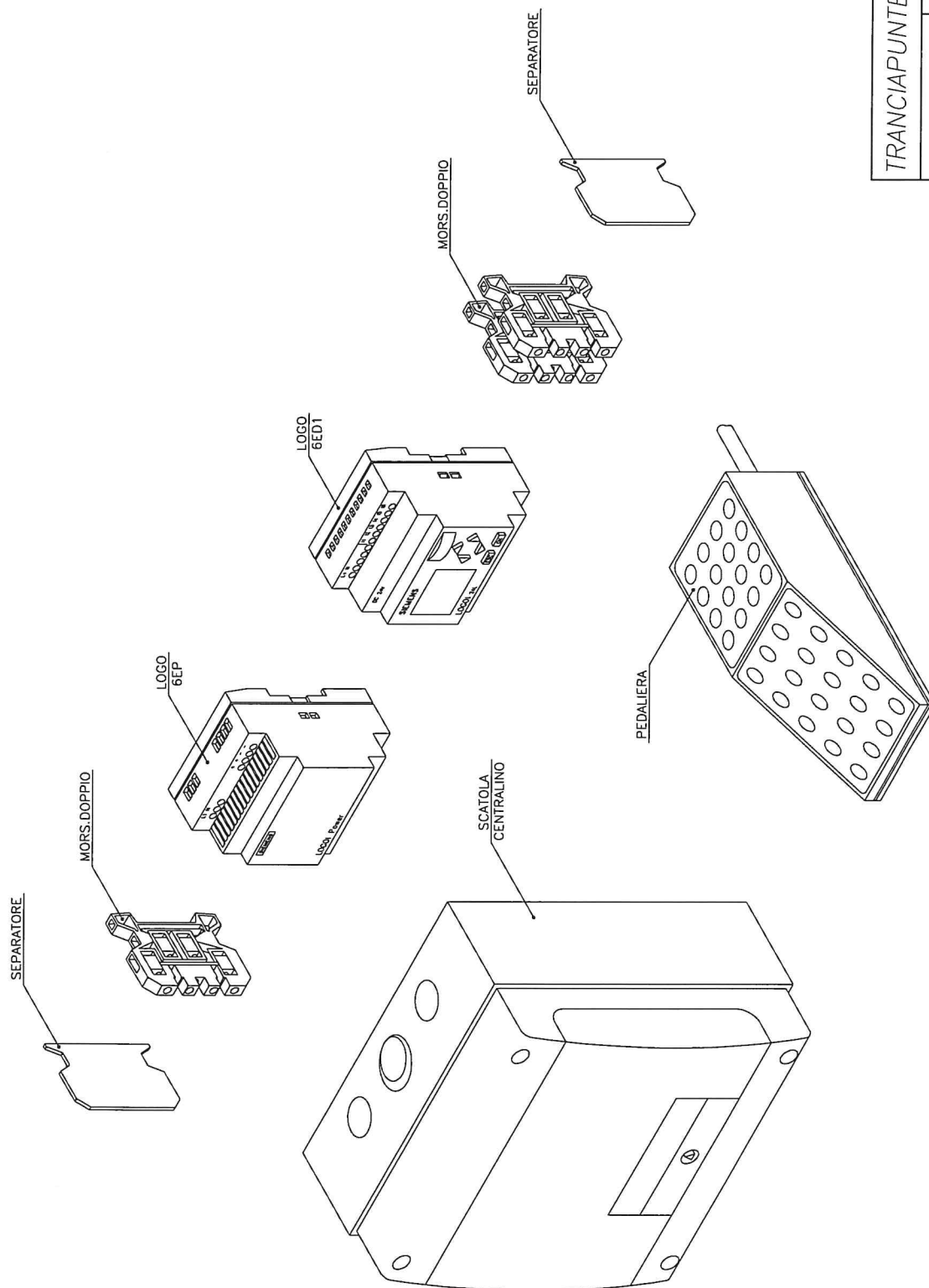
For prompt part identification, the following data must be provided:

1. Machine model and serial number
2. Spare part code
3. Sheet in which the spare part is shown

Example: COLLAR TIP TRIMMER mod. MTP Serial No. Code MTP09 Table 1



TRACIAPUNTE MTP
M.A.I.C.A. TAV. 2



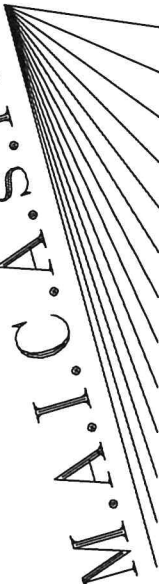
TRACIAPUNTE MTP	
M.A.I.C.A.	TAV. 3

A/1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27
B																										
C																										
D																										
E																										
F																										
G																										
H																										
I																										
L																										
M																										
N																										
O																										
P																										
Q																										
R																										
S																										

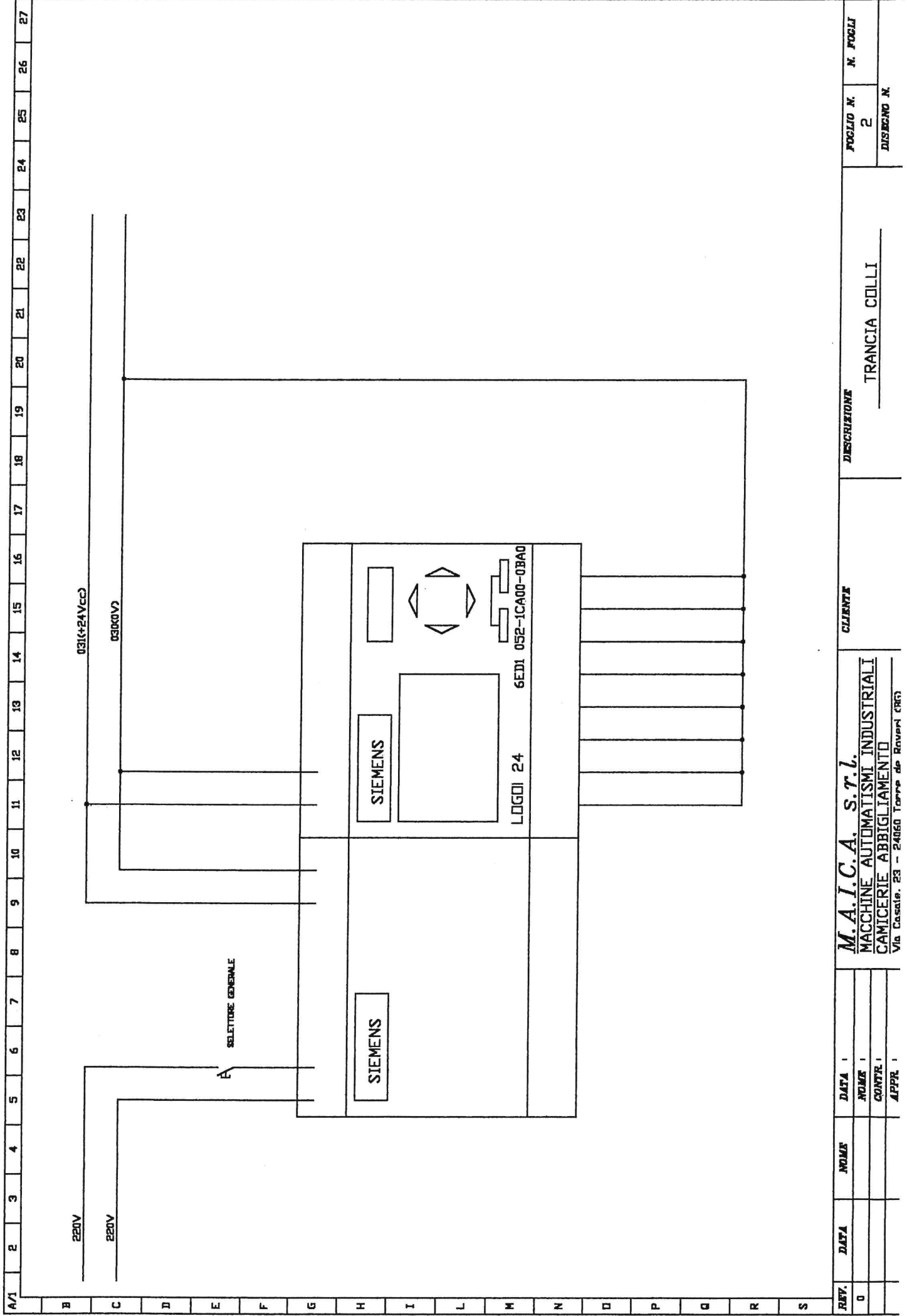
MTP

COLLAR TIP TRIMMER

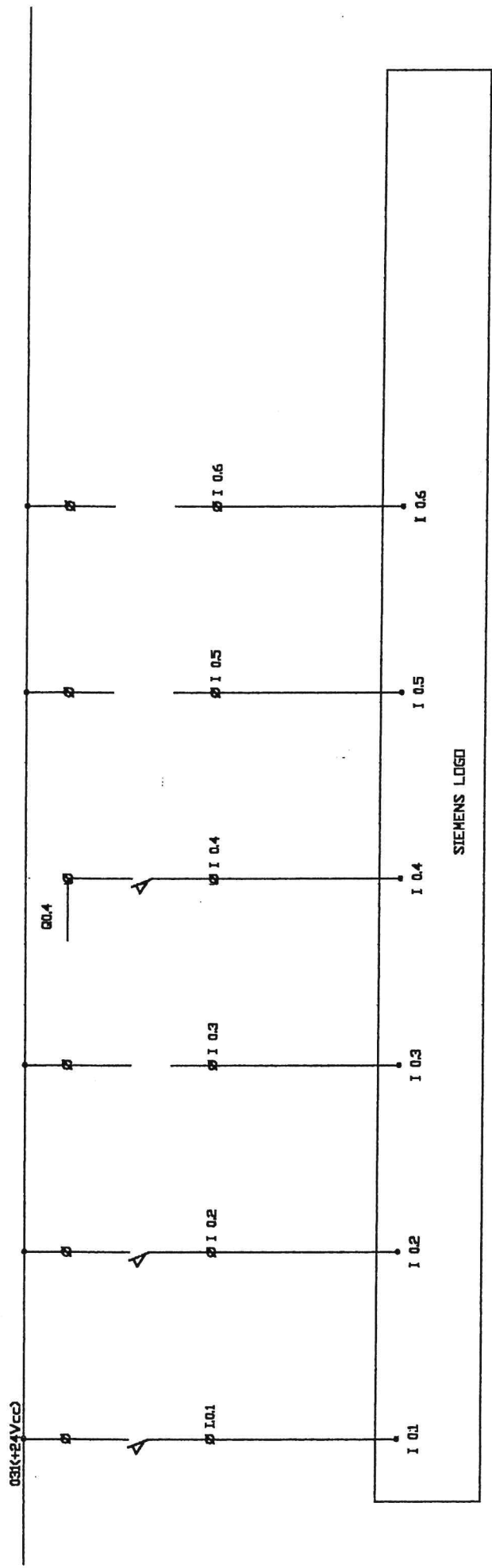
M.A.I.C.A.S.r.l.



REV.	DATA	NOME	DATA : 25/07/2002	M.A.I.C.A. S.r.l.	CLIENTE	DESCRIZIONE	FOGLIO N.	N. FOGLI
	0		NOME : CONTR. : APPR. :	MACCHINE AUTOMATISMI INDUSTRIALI CAMICERIE ABBIGLIAMENTO Via Casale, 23 - 24060 Torre de Roveri (BG)		TRANCIA PUNTE	1	4



REV.	DATA	NOME	DATA	M.A.I.C.A. S.r.l.	CLIENTE	DESCRIZIONE	FUOGIO N.	N. FOGLI
0				MACCHINE AUTOMATISMI INDUSTRIALI		TRANCIA COLLI	2	
				CAMICERIE ABBIGLIAMENTO				DISSEGNO N.
				Via Casale, 23 - 24060 Torre de Rovera (CR)				



0V

FINCORSIA TRANCIA AVANTI	FINCORSIA CILINDRO PUNTA BASSO	DISPONIBILE	PEDALE GIRA PUNTE	DISPONIBILE	DISPONIBILE
--------------------------------	--------------------------------------	-------------	----------------------	-------------	-------------

M.A.I.C.A. S.r.l.
MACCHINE AUTOMATISMI INDUSTRIALI
CAMICERIE ABBIGLIAMENTO
Via Casale, 23 - 24060 Torre de Roversi (BG)

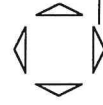
CONTROLLO FUNZIONI TRAMITE PROGRAMMATORE LOGO

IL PROGRAMMATORE LOGO PERMETTE DI PROGRAMMARE:

- 1)B6 TEMPO TAGLIO
- 2)B10 TEMPO RITORNO CILINDRO GIRO
- 3)B21 TEMPO INIZIO TAGLIO DOPO GIRO
- 4)B22 TEMPO IMPULSA TAGLIO DOPO GIRO (non toccare)
- 5)B25 TEMPO RITORNO CILINDRO GIRO

PREMERE CONTEMPORANEAMENTE I TASTI <OK> E <ESC>
SUL DISPLAY APPARIRA' LA SCRITTA SET:Clock- SET:PARAM

SET:Clock
SET:PARAM



CON IL PULSANTE FRECCIA GIU' PORTARE IL CURSORE > SU SET:PARAM

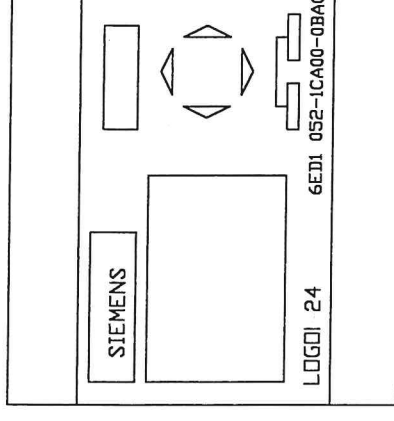
PREMERE <OK>

SUL DISPLAY APPARIRA'

B03:PAR
PAR=0000
CNT=0000

PORTARSI CON LA FRECCIA GIU'
SUL PARAMETRO DESIDERATO

PREMERE <OK> PORTARSI CON LE FRECCIE <DX> <SX> SUL VALORE DA MODIFICARE
IL VALORE AUMENTA O DIMINUISCE PREMENDO LE FRECCIE <SU> <GIU'>
TERMINATA LA VARIAZIONE PREMERE OK



M.A.I.C.A. TRANCIA PUNTE

PLC KEYBOARD FUNCTIONS AND SETTINGS

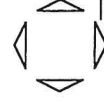
THE PLC PERMIT TO SET:

- 1)B6 CUT TIME
- 2)B10 TURN CYLINDER RETURN TIME
- 3)B21 CUT START TIME AFTER TURNING
- 4)B22 AFTER TURNING CUT START TIME (don't touch)
- 5)B25 TURN CYLINDER RETURN TIME

PRESS TOGETHER KEYS <OK> AND <ESC>

ON THE DISPLAY WILL APPEAR "SET:CLOCK- SET:PARAM"

SET:CLOCK
SET:PARAM



PRESS KEYS <LEFT> AND POSITION THE CURSOR > ON SET:PARAM

PRESS <OK>

ON THE DISPLAY APPARES

B03:PAR
PAR=0000
CNT=0000

WITH KEYS <LEFT> POSITION THE CURSOR ON DESIRED VALUE

PRESS <OK> AND WITH KEYS <DX> <SX> POSITION THE CURSOR ON THE VALUE TO BE CHANGED THE VALUE INCREASES OR DECREASES PRESSING KEYS <LEFT> OR <RIGHT> AFTER CHANGING THE VALUE PRESS <OK>

