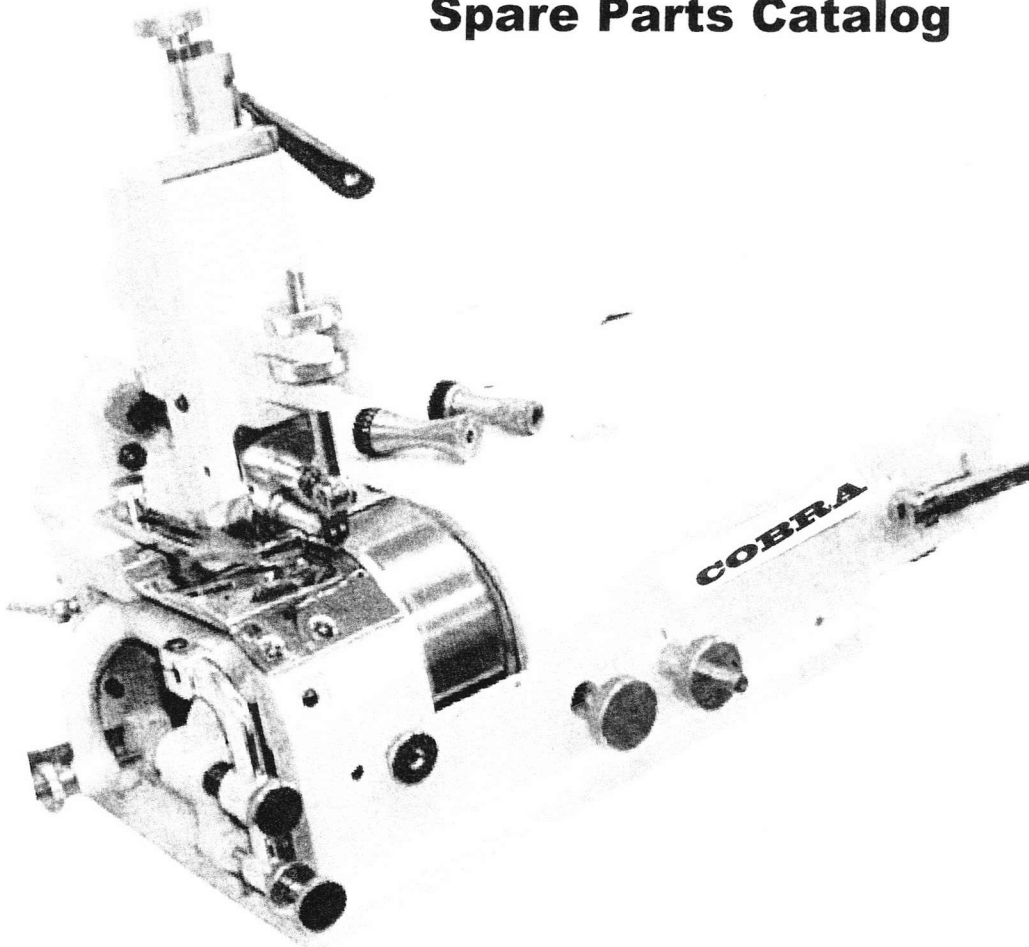


**Instruction Book
And
Spare Parts Catalog**



COBRA

NP 10

**Heavy Duty Top
Puller & Roller Feed
Skiving Machine**

I . Features and uses of the machine.

Leather Skiving Machine with circular knife is suitable for edge-skiving and whole surface skiving of any kinds of leather as well as plastic cloth, synthetic leather, felted wool and rubber for shoes, caps, bags, garments, belts, gloves and sports goods etc. It is one of necessary equipments which make above goods.

The machine has features of noiseless stable performance, easy operation, high productivity and long life etc.

II . Main Technical Specifications.

rotating speed of main shaft (circular knife)	1100-1200rpm
skiving width	4-15mm
size of the machine head	550 × 370 × 400mm
net weight of the machine head	45kg
motor power	370w
size of circular knife	Ø117 × 54 × Ø112

III . To prepare for using.

1.Assembling

The machine head, frame and motor etc. are packed separately. First assemble the frame, then set the motor at the long hole of the frame beam, and fix it with screw. Then place the table and machine head and align their positions. Tighten all screws and nuts.

2.Cleaning grease dirt.

The machine are coated with anti-rust grease to prevent it from rusting before packing. But it may be through long time storage and long way transport, the grease may become hardened or dust may accumulate on it. The grease on the surface of the machine must be cleaned with gasoline and clean soft cloth after unpacking.

3.Checking the machine.

The machine may get strong shaking in the transport leading to loosening or shifting of its parts. Check the machine completely after cleaning it. Turn the belt pulley of the main shaft with hand and observe whether the feeding wheel and the grinding wheel impact the edge of the circular knife or not. If there is any impact, adjust the machine according to the methods of this instruction book, make the feeding wheel and the grinding wheel keep a clearance with the edge of the knife.

4.Filling oil and testing.

Before starting the machine, fill oil at oil holes and moving parts. Let the machine run a few minutes for testing. The belt pulley of the main shaft should turn clockwise. (observe from the right of operator)

IV . How to use and adjust the machine.

1.To adjust the position of the circular knife.

The edge of the knife should keep a clearance about 0.4-0.8mm with the side of presser foot. This clearance is an important factor for assuring skiving quality. The edge of the knife will get dull through skiving, and need to regrind. After several times or long time regrinding the relative position of the edge of the knife to the feeding grinding wheel and the side of presser foot will change, and can be made up by means of adjusting the axial position of the knife

The circular knife adjustment consists of precise worm and worm wheel which can make micro-adjusting by means of turning the adjusting handle of the knife. Turn it clockwise to increase the clearance and turn it counterclockwise to decrease the clearance.

2. To regrind the circular knife

The grinding wheel of the knife rotates when the machine works normally, so the edge of the knife can be regrind continually. Also can regrind it after the edge of the knife get dull. When turn the adjusting screw bar of the grinding wheel counter-clockwise, the grinding wheel closes to the dege of the knife and does grinding; turn the adjusting screw bar clockwise, the grinding wheel leaves the edge of the knife and stop grinding.

Caution: When grinding the edge of the knife, the grinding wheel should advance slowly to prevent the grinding wheel from impacting the edge of the knife, leading to destory the grinding wheel or the edge, even work accidents.

3. To adjust the height and centre of the feeding wheel arc.

The feeding wheel has two functions. The main one is feeding material, another is grinding burrs of the inner side of the knife. The R centre of the feeding wheel should be identical with the R centre of the knife. This will do great good to feeding the material and grinding the knife. The R centres should be adjusted if they are not on the same axis. The method is: loosen the R adjusting nut of feeding wheel, turn the R adjusting screw bar of feeding wheel when the clearance is big between the inner diameter of the knife and the right side of feeding wheel, turn the adjusting screw bar clockwise, on the contrary side, turn the adjusting screw bar counterclockwise until the clearance is consistent between the feeding wheel R and both sides of the inner diameter of the knife. Then retighten the adjusting nut R.

The outer diameter of the feeding wheel should connect the inner diameter of the knife. The big clearance between them will cause unsmooth feeding and poor quality skiving. The over interference will destroy the knife. The height of the feeding wheel is adjusted by means of loosening the adjusting nut, and turning the adjusting screw bar, turn clockwise to increase the height, turn counterclockwise to decrease the height, and tighten the height adjusting nut to adjust their connect.

4. To adjust the height and angle of the presser foot.

(a). To adjust the height of the presser foot.

To do heavy leather skiving or small volume skiving, it is to increase the height of the presser foot. And to do light leather skiving or big volume skiving, it is to decrease the height of the presser foot. The height of the presser foot is adjusted by means of adjusting the presser foot adjusting screw bar. Turn it clockwise to decrease the height, turn it counterclockwise to increase the height.

(b). To adjust the angle of the presser foot.

To do big width and small angle edge-skiving, the angle between the presser foot and the circular knife should be small. Under the contrary conditions, the angle should be big. The height of the angle is adjusted by means of loosening the angle adjusting nut of the presser foot and turning the angle adjusting, screw bar. Turn it clockwise to increase the angle, and turn it counterclock wise to decrease the angle. After the required angle is adjusted, retighten the adjusting nut.

5. To adjust the blocking board.

The blocking board takes a role of limiting the width of skiving. Move it to the operator to decrease the width of skiving, under the contrary conditions, move it to another direction. The position of the blocking board is adjusted by the screw.

6. To adjust skiving speed.

The leather skiving machine with the circlur knife has two or three speeds to choose depending on operator skill and the skiving matetial. To adjust the speed, first open or take away belt cover, slide the belt into required skiving speed with screw driver, right side is low speed and left is high speed.

V. To dress the grinding wheel.

1. To dress the feeding grinding wheel.

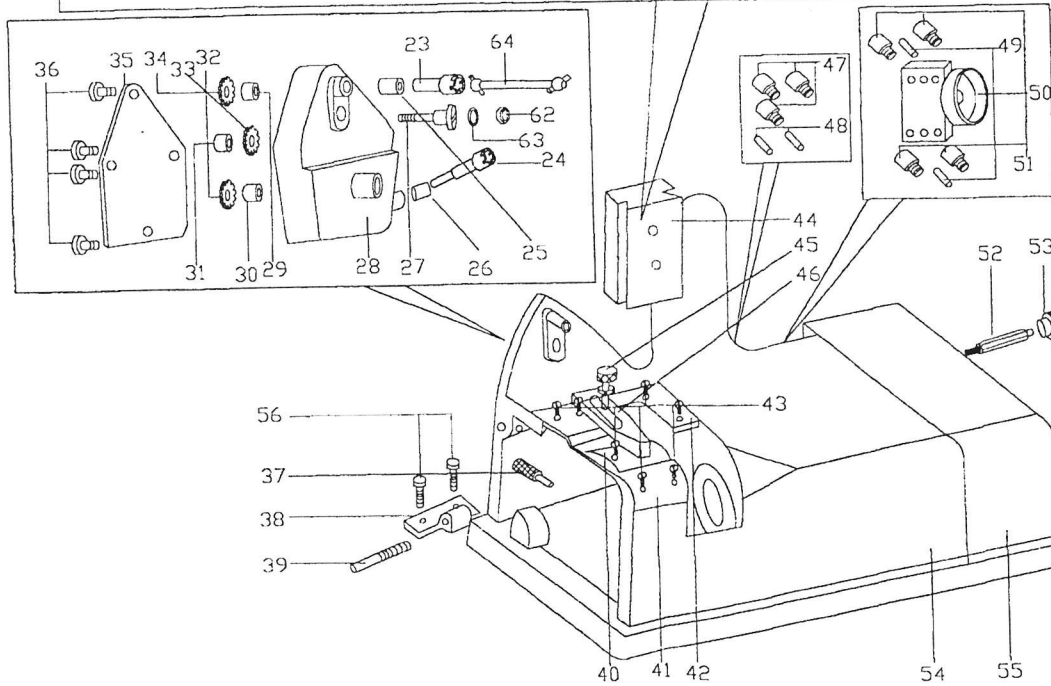
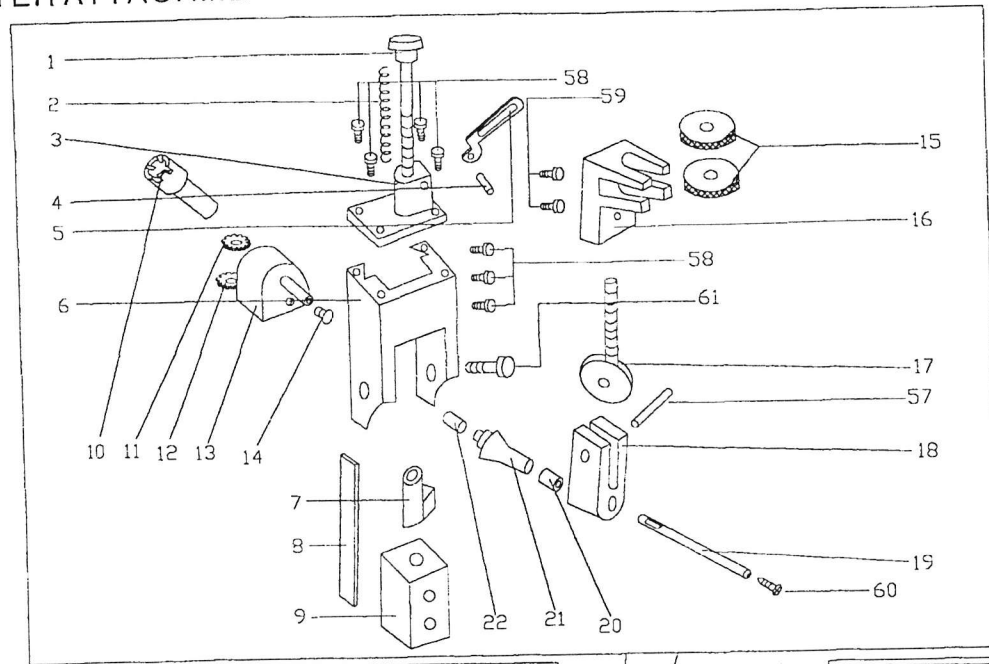
After long time use, various kinds of skiving chips are stuck on the surface of the feeding wheel, weaken feeding friction force, lead to unsmooth feeding. To resume normal feeding, the surface of the feeding wheel must be dressed with grinding wheel dresser. First remove the feeding sliding plate to let the feeding wheel lie bare, switch on the machine, aim the dresser at the feeding wheel. The teeth of the dresser rotate with the feeding wheel and move left and right until the surface of the feeding wheel become sharp.

2. To dress the grinding wheel.

After regrinding the edge of the knife several times, grinding chips of metal and the grinding wheel are stuck on its surface, weaken grinding speed and quality. So its surface must be dressed with the grinding wheel dresser.

Motor	370-400W(2850)
Knife speed	3500
Feed wheel speed	62,99,132(rpm)
Knife size	$\Phi 118 \times \Phi 114 \times 54$ (mm)
Knife axial displacement	30(mm)
Skiving width	10-50(mm)
NW / GW	40 / 45(kg)
Measurement	630X480X415(mm)

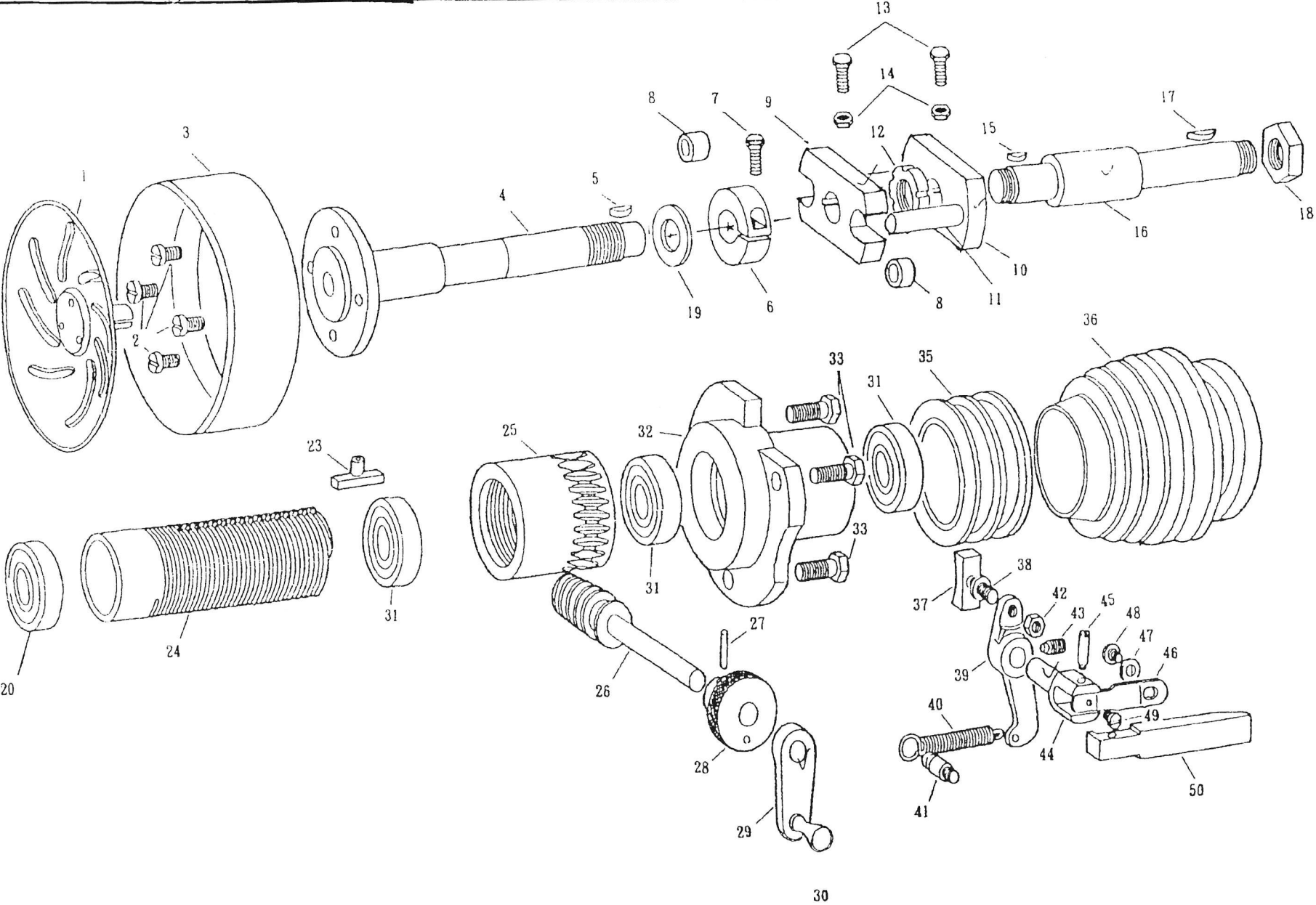
1. PRESSER FOOT AND OUTER ATTACHMENTS



1.PRESSER FOOT AND OUTER ATTACHMENTS

1-1	H8103	1		1-36		4
1-2	H8106	1		1-37	H8401	1
1-3	H8105	1		1-38	10113	2
1-4	M5×16	1		1-39	10343	2
1-5	H8101	1		1-40	10326	1
1-6	H8109	1		1-41	10327	1
1-7	H8102	1		1-42	10328	1
1-8	H8104	1		1-43	11/64×40	8
1-9	H8108	1		1-44	H8107	1
1-10	H8112	1		1-45	10338	1
1-11	H8113	1		1-46	10112	1
1-12	H8117	1		1-47	M10×20	3
1-13	H8111	1		1-48	M5×20	2
1-14	H8114	1		1-49	M5×20	2
1-15	H8123	2		1-50	10107	1
1-16	H8110	1		1-51	M8×12	4
1-17	H8121	1		1-52	10329	1
1-18	H8120	1		1-53	10330	1
1-19	H8115	1		1-54	10101	1
1-20	H8118	1		1-55	10311	1
1-21	H8116	1		1-56	M8×65	2
1-22	H8119	1		1-57	φ 6×15	1
1-23	H8306	1		1-58	M4×16	7
1-24	H8310	1		1-59	M6×18	2
1-25	H8312	1		1-60	M5×12	1
1-26	H8303	1		1-61	M8×60	1
1-27	H8309	1		1-62	M8	1
1-28	H8301	1		1-63	φ 10	1
1-29	H8302	1		1-64		
1-30	H8304	1				
1-31	H8308	1				
1-32	H8305	1				
1-33	H8307	1				
1-34	H8311	1				
1-35	H8313	1				

2.KINFE AND RELATED PARTS

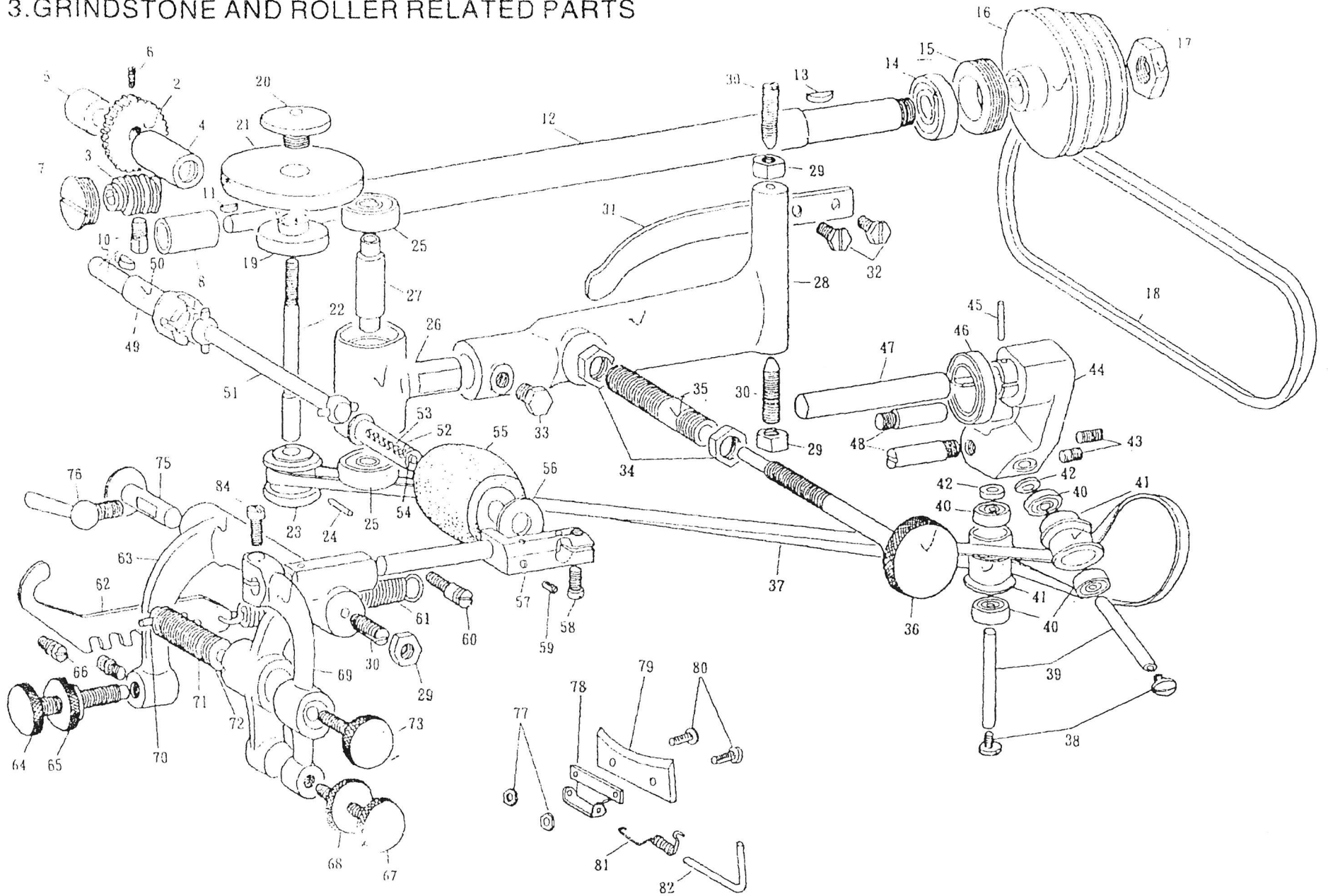


2.KINFE AND RELATED PARTS

Part NO.	Name of Part			Quan
8010201	P2-1	2Y-21 2Y-21-2	1021	1
8010202	P2-2	2Y-24	M6P1.0X10	4
8010203	P2-3	2Y-10	1010	1
8010204	P2-4	2Y-11	1011	1
8010205	P2-5	2Y-127	3X13	1
8010206	P2-6	2Y-26A	28X18X7X1.5	1
8010207	P2-7	2Y-26-1		
8010208	P2-8	2Y-23	1023	2
8010209	P2-9	2Y-15	1015	1
8010210	P2-10	2Y-33	1033	1
8010211	P2-11	2Y-34	1034	2
8010212	P2-12	2Y-26B	28X16X7X1.5	1
8010213	P2-13	2S-140	9/32X28X4.5	2
8010214	P2-14	2S-092	9/32X28X18	2
8010215	P2-15	2Y-47B	3X10	1
8010216	P2-16	2Y-31	1031	1
8010217	P2-17	2Y-47A	3X16	1
8010218	P2-18	2Y-44A	M16XP1.5	1
8010219	P2-19	2Y-28	39X34X3XP1.0	1
	P2-20		2005	
8010221	P2-21	2Y-12	1012	1
8010222	P2-22	2Y-27	36X27X7XP1.5	1
8010223	P2-23	2Y-20	1020	1
8010224	P2-24	2Y-13	1013	1
8010225	P2-25	2Y-14	1014	1
8010226	P2-26	2Y-16	1016	1
8010227	P2-27	2P-019	3X18	1
8010228	P2-28	2Y-17	1017	1
8010229	P2-29	2Y-18	1018	1
8010230	P2-30	2Y-19	1019	1
8010231	P2-31	2Y-48	6203ZZ	2
8010232	P2-32	2Y-32	1032	1

Part NO.	Name of Part			Quan
8010233	P2-33	2S-141	5/16"X24X21	3
	P2-34			
8010235	P2-35	2Y-35	1035	1
8010236	P2-36	2Y-30	1030	1
8010237	P2-37	2Y-49	1049	1
8010238	P2-38	2Y-40	1040	1
8010239	P2-39	2Y-43	1043	1
8010240	P2-40	BW-024	1024	1
8010241	P2-41	2Y-46	1046	1
8010242	P2-42	2N-006	1/4"X40	1
8010243	P2-43	2S-142	15/64"28X8	1
8010244	P2-44	2Y-41	1041	1
8010245	P2-45	2S-143A	1160	1
8010246	P2-46	2Y-42	1042	1
8010247	P2-47	2W-010		1
8010248	P2-48	2S-144	9/64"X40X6	1
8010249	P2-49	2S-007	9/64"X40X6	1
8010250	P2-50	2Y-39	1039	1
8010251	P2-51		NTB2035	2
8010252	P2-52		20X35X1	2
8010253	P2-53		6004ZZ	
8010254	P2-54		6203ZZ	

3. GRINDSTONE AND ROLLER RELATED PARTS

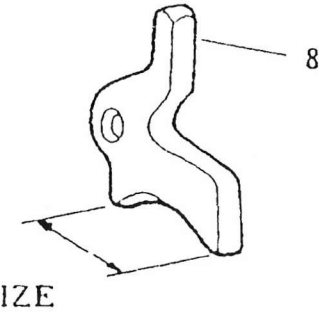
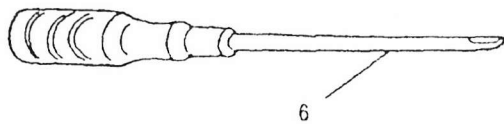
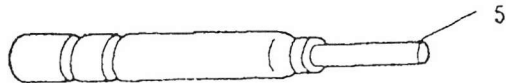
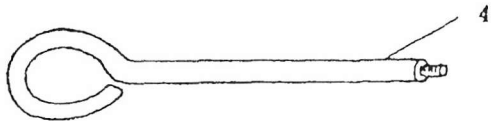
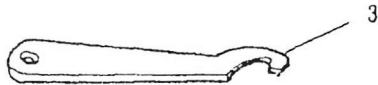
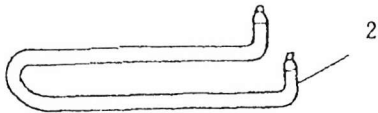


3. GRINDSTONE AND ROLLER RELATED PARTS

Part NO.	Name of Part			Quan
8010301	P3-1	3Y-2A		1
8010302	P3-2	3Y-116	1116	1
8010303	P3-3	3Y-115	1115	1
8010304	P3-4	3Y-119	1119	1
8010305	P3-5	3Y-120	1120	1
8010306	P3-6	3S-005	9/64"x40x9	1
8010307	P3-7	3Y-123	1123	1
8010308	P3-8	3Y-117	1117	1
8010309	P3-9	3Y-133	121803	1
8010310	P3-10	3Y-124	1124	1
8010311	P3-11	3Y-47A	2.5x10	1
8010312	P3-12	3Y-110	1110	1
8010313	P3-13	3Y-126	3x16	1
8010314	P3-14	3Y-130	6002ZZ	1
8010315	P3-15	3Y-113	M63x10xP1.5	1
8010316	P3-16	3Y-111	1111	1
8010317	P3-17	3Y-44B	M14xP1.5	1
8010318	P3-18	3Y-128	3 STAR K20	1
8010319	P3-19	3Y-51	1051	1
8010320	P3-20	3Y-52	1052	1
8010321	P3-21	3Y-50	1050	1
8010322	P3-22	3Y-53	1053	1
8010323	P3-23	3Y-54	1054	1
8010324	P3-24	3P-020	2.5x20	2
8010325	P3-25	3Y-71	6200ZZ	1
8010326	P3-26	3Y-56	1056	1
8010327	P3-27	3Y-55	1055	1
8010328	P3-28	3Y-57	1057	3
8010329	P3-29	3N-030	5/16"x24	3
8010330	P3-30	3Y-73A	1731	1
8010331	P3-31	3Y-69	1069	2
8010332	P3-32	3S-145	15/64"x24x14	1
8010333	P3-33	3S-068	15/64"x24x14	2
8010334	P3-34	3Y-74	1/2"x28	1
8010335	P3-35	3Y-66	1066	1
8010336	P3-36	3Y-58	1058	1
8010337	P3-37	3Y-59	1059	2
8010338	P3-38	3S-146		2
8010339	P3-39	3Y-63	1063	4
8010340	P3-40	3Y-72	626ZZ	2
8010341	P3-41	3Y-62	1062	2
8010342	P3-42	3Y-64	1064	2

Part NO.	Name of Part			Quan
8010343	P3-43	3S-090	15/64"x28x8	1
8010344	P3-44	3Y-60	1060	1
8010345	P3-45	3P-019	3x18	1
8010346	P3-46	3Y-67	1067	1
8010347	P3-47	3Y-61	1061	2
8010348	P3-48	3Y-65	1065	1
8010349	P3-49	3Y-118	1118	1
8010350	P3-50	3Y-127	3x13	1
8010351	P3-51	3Y-121	1121	1
8010352	P3-52	3Y-94	1094	1
8010353	P3-53	3Y-81	1081	1
8010354	P3-54	3P-008		1
8010355	P3-55	3Y-80	1080	1
8010356	P3-56	3Y-82	1082	1
8010357	P3-57	3Y-83	1083	1
8010358	P3-58	3S-147	15/64"x28x10	1
8010359	P3-59	3S-114	11/64"40x3.5	1
8010360	P3-60	3Y-98	1098	1
8010361	P3-61	3Y-95	1095	1
8010362	P3-62	3Y-96	1096	1
8010363	P3-63	3Y-91	1091	1
8010364	P3-64	3Y-92	1092	1
8010365	P3-65	3Y-93	1093	1
8010366	P3-66	3Y-97	1097	2
8010367	P3-67	3Y-85	1085	1
8010368	P3-68	3Y-86	1086	1
8010369	P3-69	3Y-84	1084	1
8010370	P3-70	3Y-88	1088	1
8010371	P3-71	3Y-87	1087	1
8010372	P3-72	3Y-90	1090	1
8010373	P3-73	3Y-89	1089	3
	P3-74		1/4"x20x20	
8010375	P3-75	3Y-99	1099	1
8010376	P3-76	3Y-100	1100	1
8010377	P3-77	3N-013	9/64"x10	2
8010378	P3-78	3Y-101	1101	1
8010379	P3-79	3Y-104	1104	2
8010380	P3-80	3S-148	9/64"x40	2
8010381	P3-81	3Y-103	1103	1
8010382	P3-82	3Y-102	1102	1
	P3-83		4x22	
8010384	P3-84	3S-066		1

4. ACCESSORIES



4. ACCESSORIES

Part NO.	Name of Part			Quan
8010401	P4-1	4A-3Y	3001	1
8010402	P4-2	4A-4Y	3002	1
8010403	P4-3	4A-5Y	3004	1
8010404	P4-4	4A-6Y	3005	1
8010405	P4-5	4A-7Y	3006	1
8010406	P4-6	4A-6B	3007	1
8010407	P4-7	4A-4B	3008	1
	P4-16A		1140A	1
	P4-16B		1140B	1
	P4-16C		1140C	1
	P4-47		2002	2
	P4-46		2001	2
	P4-48		18x6.3x1.6	2
	P4-49		6x30	4
	P4-29		1018	1
	P4-30		1019	1
	P4-5		3006	1