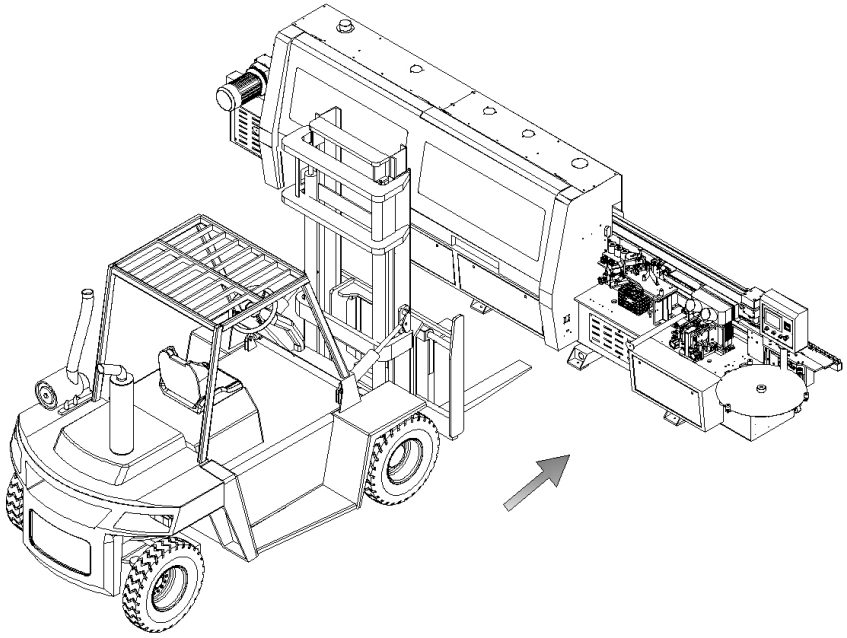
7 Transportation and Hoisting

Equipment Hoisting Schematic Diagram

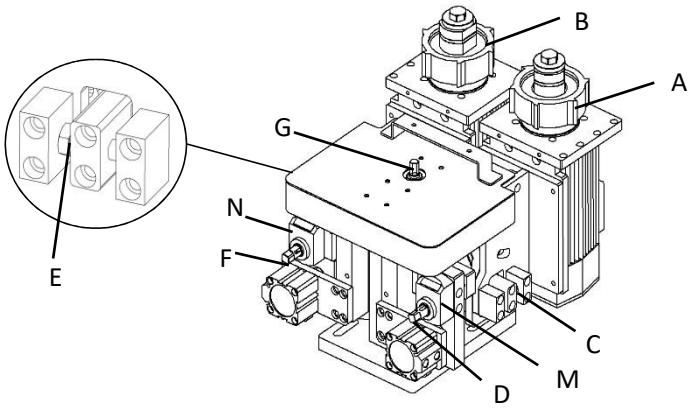


1. All the movement and lifting of the machine must be completed by professionals, and the operation process conforms to the guidance specifications.
2. The bearing force of the forklift used is applicable to the machine, and the weight of the equipment shall be shown in the weight of each model.

1. Before lifting, make sure that the forklift is at the weight balance of the equipment to prevent tipping due to uneven force.
2. When the equipment is moving, please avoid sudden movement, for unsteady operation may lead to damage and instability of the machine.

Hoisting Parameters of All Models		
Model	**Overall Dimensions (Length* Width *Height) (meter)**	**Reference Weight**
HH504	4*1*1.7	1400KG
HH505	4.5*1*1.7	1700KG
HH505R	5.7*1*1.7	1900KG
HH505RL	7*1*1.7	2200KG
HH506	5.5*1*1.7	2200KG
HH506R	6.5*1*1.7	2500KG
HH506RL	7.9*1*1.7	2700KG

12.3.2 Adjustment Component



A –Milling cutter 1

B - Milling cutter 2

G –Lifting adjusting shaft of dual-milling cutter

C –Angle adjustment lever of Milling Cutter 1

D – Milling amount adjustment lever of Milling Cutter 1

M- Location counter of Milling Cutter 1

E - Angle adjustment lever of Milling Cutter 2

F - Milling amount adjustment lever of Milling Cutter 2

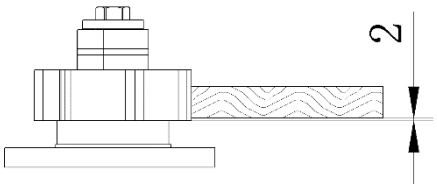
N- Location counter of Milling Cutter 2

12.3.3 Pre-Milling Parameters (Standard Model)

Cutter	H40x125
Motor parameters	2.2KW 380V 200HZ 12000rpm
Motor shaft	φ30x68

12.3.4 Height Adjustment of Milling Cutter

Turn the lifting adjusting shaft G of dual-milling cutter to get the lower edges of Milling Cutter 1 and 2 to protrude by about 2mm out of the lower edge of the panel.



The milling cutter with different widths shall be used to mill the panel with different thicknesses; in general, the milling cutter with the width of 35mm shall be used to mill the panel with the thickness less than 18mm.

12.7.3 Rough Trimming Parameters

Rough trimming knife	56*16*6Z
Motor parameters	0.75KW 380V 200HZ 12000rpm

12.7.4 Floating Displacement Adjustment of Rough Trimming Large Disc

As the same with the adjustment of fine trimming large disc (see Section 12.8.4)

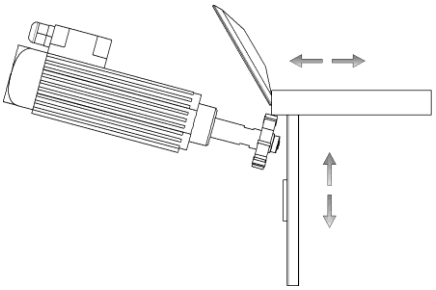
12.7.5 Floating Displacement Adjustment of Rough Trimming Small Disc

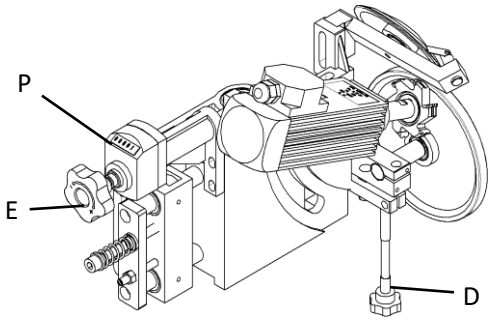
As the same with the adjustment of fine trimming small disc (see Section 12.8.5)

12.7.6 Pressure Adjustment of Trimming Disc

As the same with the pressure adjustment of fine trimming disc (see Section 12.8.6)

12.7.7 Adjustment of Top and Bottom Trimming Amounts





Rough trimming amount adjustment only needs to set the upper and lower rough trimming counter P to be consistent with the tape thickness through the quincunx handle E and then make a fine adjustment through the quincunx handle E of the upper and lower rough trimming units so that there are the tape allowances of 0.5-0.8mm reserved for upper and lower edges of the panel.

12.7.8 Routine Maintenance

Maintenance Item	Frequency	Lubricant
Cleaning air gun	Once/ 8 hours	
Clearing adhesive residue of trimming disc	Once/ 40 hours	Ethyl alcohol

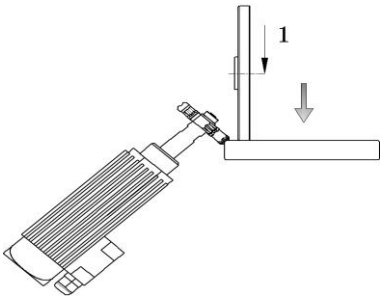
12.8.3 Fine Trimming Parameters

Fine trimming knife	56*16*6Z
Motor parameters	0.75KW 380V 200HZ 12000rpm

12.8.4 Floating Displacement Adjustment of Fine Trimming Large Disc

Adjustment of Upper Fine Trimming Disc

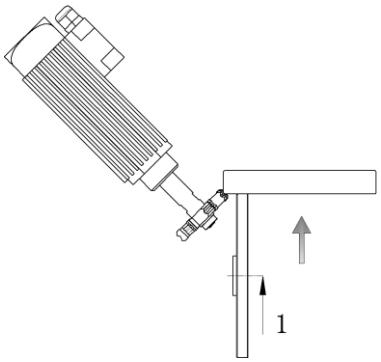
When the panel passes the upper fine trimming disc H, please adjust the nut on the trimming handing bracket until the upward floating amount of the disc is 1mm.



Movement Direction of Upper Fine Trimming Disc

Adjustment of Upper Fine Trimming Disc

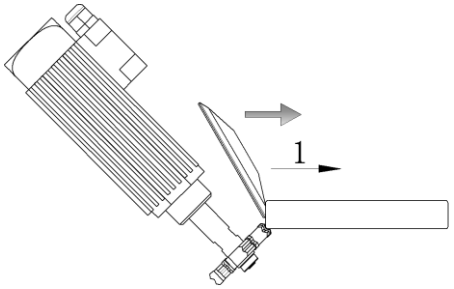
When the panel passes the low fine trimming disc C, please adjust the lower trimming stop bolt L until the downward floating amount of the disc is 1mm.

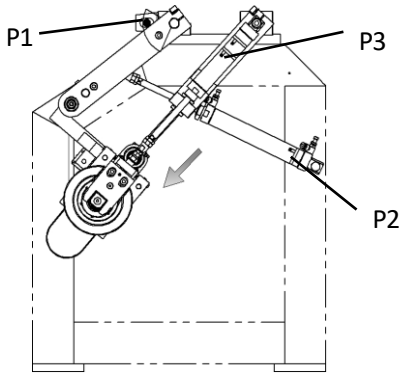


Movement Direction of Upper Fine Trimming Disc

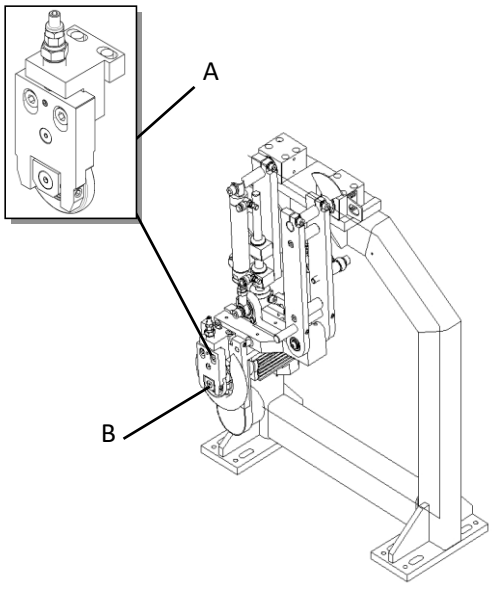
12.8.5 Floating Displacement Adjustment of Fine Trimming SmallDisc

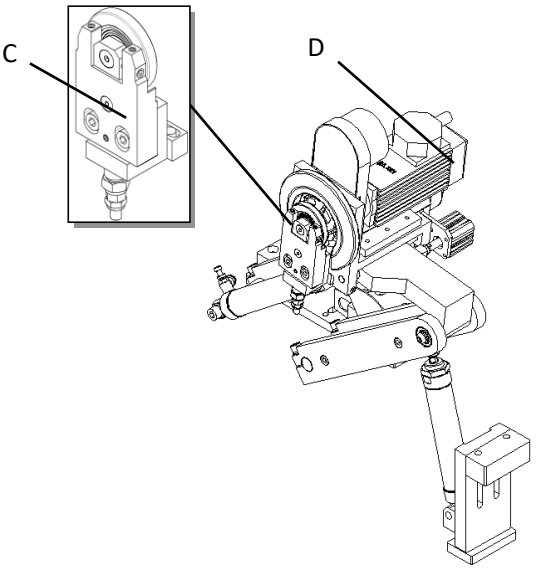
Adjust the profiling block of the lower rough trimming unit until the profiling block K just touches the board. Adjust the horizontal limit screw J of the lower trimming unit so that the fine trimming small disc press against the board by 1mm. Front and rear floating amounts of the fine trimming disc K shall be 1mm after the board leaves the fine trimming small disk K.



Mechanism Status	Sensor Status
	Upper tracking operating state (lower right corner) After the upper tracking unit completes the tracking action in the upper left corner, when the panel passes it, the cylinder pushes the motor to swing so as to complete the tracking of the upper right corner of the panel. Inductive switch P1: ON state Inductive switch P2: OFF state Inductive switch P3: ON state

12.9.3 Adjustment Component





A –Upper tracking slide former B –Upper tracking motor C –Lower tracking slide former D- Lower tracking motor

12.9.4 Tracking Parameters

Tracking knife	68*16*6Z*R2.5
Motor parameters	0..37KW 380V 200HZ 18000rpm