

# Fleshing machine XL T4/T5 2010

User manual

*Fleshing machine XL T4/T5  
2010*



## 1. Declaration of Accordance

### Declaration of accordance with European standards

Manufacturer:	Jasopels Production A/S	Phone + 45 98439966
Address:	Fabriksvej 19 Denmark	DK - 7441 Bording
Machine:	Fleshing Machine	
Type:	02-0000 400 V	

Jasopels Production A/S declares that this product is in accordance with the following EU directives:

89/336 EEC

98/37 EEC

Furthermore it is declared that the following harmonised standards have been used:

EN 60204-1

EN 983

Place and date: Bording July 2009

Name: Managing Director Poul Bach

A handwritten signature in black ink, appearing to read "Poul Bach". The signature is fluid and cursive, with the first name "Poul" and last name "Bach" clearly distinguishable.

## 2. Table of Contents

<b>1.</b>	<b>Declaration of Accordance</b>	<b>2</b>
<b>2.</b>	<b>Table of Contents</b>	<b>3</b>
<b>3.</b>	<b>Preface</b>	<b>5</b>
<b>4.</b>	<b>Explanation of Symbols</b>	<b>6</b>
<b>5.</b>	<b>Introduction to the Machine</b>	<b>7</b>
<b>6.</b>	<b>Start-Up</b>	<b>8</b>
<b>7.</b>	<b>Operation</b>	<b>11</b>
<b>7.1</b>	<b>Start</b>	<b>11</b>
<b>7.2</b>	<b>Operation</b>	<b>13</b>
<b>7.3</b>	<b>Setting of Pressure</b>	<b>14</b>
<b>7.4</b>	<b>Customer option</b>	<b>16</b>
<b>7.5</b>	<b>Type option</b>	<b>17</b>
<b>7.5.1</b>	<b>Reading Piece and Hours</b>	<b>18</b>
<b>7.5.2</b>	<b>Adjusting impellers</b>	<b>22</b>
<b>7.5.4</b>	<b>Sawdust and beam washer</b>	<b>24</b>
<b>8.</b>	<b>Maintenance</b>	<b>26</b>
<b>8.2</b>	<b>Daily Maintenance</b>	<b>27</b>
<b>8.4</b>	<b>Changing the impellers</b>	<b>29</b>
<b>8.5</b>	<b>Adjusting the impellers</b>	<b>31</b>

<b>9.</b>	<b>Technical Data</b>	<b>.....</b>	<b>33</b>
<b>10.</b>	<b>Electrical diagrams</b>	<b>.....</b>	<b>34</b>
<b>11.</b>	<b>List of Spare Parts</b>	<b>.....</b>	<b>37</b>
<b>12</b>	<b>Extra equipment</b>	<b>.....</b>	<b>50</b>
<b>13.</b>	<b>Trouble Shooting</b>	<b>.....</b>	<b>55</b>
<b>14.</b>	<b>Personal Notes</b>	<b>.....</b>	<b>60</b>



### 3. Preface

- This User's Manual is an important part of your new machine. Read this manual thoroughly and use it as a reference book.
- This manual contains important information about security and the use of the machine.
- The manual should be stored with the machine. It is important that the user's manual is enclosed in the resale or lending of the machine to third parties.
- The user of the machine is to ensure the operator, service personnel and other who have access to the machine have been instructed in the right use and handling of the machine. Refer to this user's manual for further information.

## 4. Explanation of Symbols

- Please read this User's Manual and follow the instructions given. In order to stress certain parts of the information the following expressions are used:



- Note!!  
A triangle containing an exclamation mark is a warning symbol that warns you of important instructions or information concerning this machine.



- Danger!!  
A triangle containing a lightning bolt is a warning symbol warning you of "High Voltage".



- Warning!!  
Triangle containing a warning about the risk of danger of crushing.



- Warning!!  
High noise level, always use ear protectors.

## 5. Introduction to the Machine

- This fleshing machine has been designed for the fleshing of mink skin.
- New ideas concerning the shape of the beam, the form of the impellers, the motor suspension and automatic controls have developed this fleshing machine into an extremely fast device with a capacity of up to 400 skin/hour and high-quality fleshing work.
- The combination of the form shape of the beam and a changeable fleshing pressure on the front and hind part of the skin has made it possible to scrape the fat completely off the skin.
- By keying in one number on the display of the PLC controlled automatic control you can adjust the fleshing length, after which the change between the fleshing pressure and the fleshing length on the back and hind part of the skin is computed automatically.
- The fleshing pressure for the side-impeller, upper and lower impeller can be adjusted individually on the control panel for the air control.
- The impellers are lifted independently from each other after the skin has passed through. This reduces the time where the beam is in contact with the impeller and thereby wear is reduced. This construction entails that it is possible to scrape up till 10.000 skins before the impellers have to be changed.
- The fleshing machine can be equipped with different kinds of impellers. Together with the adjustable fleshing pressure this protects the skins against damage while being scraped.

**Note!!**

- The user of the machine is to ensure that operator, service personnel and others who have access to the machine have been instructed in the correct operation and handling of the machine. Refer to this User's Manual for further information.
- The user's manual has to be read in its entirety before the machine is used.
- The machine must only be used for the purpose for which it has been constructed.
- Under no circumstances may faults in the machine or its operation - no matter what they are – corrected before the machine has been properly switched off, unless a minor correction can be made through the machine's control buttons.
- The user's manual must always be available for the operator.

## 6. Start-Up

- Before start-up the fleshing machine has to be placed on a strong and stable base. The adjustable bases are adjusted in such a way that the machine stands plumb and level, measured by the vertical and horizontal profiled tubes.



**DANGER!**

**Keep a safe distance from all the movable parts under the connection of pressed air because there may occur unintended cylinder movements during this process.**



- In the factory the machine has been assembled with a 5-poled 32 A CEE plug at the end of the power supply cable, which is connected to a socket in the wall. The air connection is connected to the compressed air filter, which has been mounted to the vertical member under the machine.

**DANGER!**

**Switch off the compressed air and the power supply before starting on any maintenance, cleaning or other service on the machine.**



- After having connected the machine and before the fleshing is started the direction of the fleshing motor's rotation has to be checked.



**Fig. 1 "steering cabinet"**

- The **main switch**, which is placed on the left side of the cabinet nr. 1 fig. 1, is turned to position 1. Check that the two EMERGENCY STOPs are pressed out. Activate the blue button **RESET EMERGENCY STOP** on cabinet nr 2 and the error report on the screen will now disappear. Now an initial starting of the machine is performed by pressing **Initial starting**. The fat suction device will start (if connected) and the impellers will begin to rotate. When the fat suction device and all 4 fleshing motors have started the green **READY** light will come alight. Press now STOP and while the impellers a decelerating check that all impellers rotate in such a way that the skin will be drawn onto the beam. The impellers direction of rotation can be turned by turning 2 phases in the CEE plug on the power supply cable.



- The machine has been designed to be able to control a Jasopan fat suction device / fat conveyor. The connection to the fat suction system has to be made by an electrician. The fat suction system's tube connection is connected on the manifold under the machine.
- Before the fleshing machine is used the impellers setting should be checked.
- When the sawdust machine has been filled with sawdust the fleshing machine should be ready for use.
- The automatic controls on the fleshing machine are designed to steer and control Jasopels Leather side drum, Jasopels sawdust conveyor, and Jasopels sawdust screw conveyor for return material, if these are connected with the controls via CEE plug to the right of the air cabinet figure 5. (Ext. Socket).

**Note!!**

**In order to avoid possible damage of the steering micro controls and the rest of the electrical system in connection with thunderstorms it is advisable to disconnect the electrical connections when the machine is not used.**



## 7. Operation

### 7.1 Initial Starting

- The **main switch**, which is placed on the left side of the cabinet no. 1 fig. 1 is turned to position 1.
- Check the two “EMERGENCY STOP” are up.
- Activate the blue “**RESET EMERGENCY STOP**” button (on the cabinet 2) and the light has now to be switched off if the initial starting is to continue.
- Press the “**INITIAL STARTING**” button. Screen with the remaining time and skin amount on the impellers will appear now (fig. 2). The fat suction device will start (if connected) and the impellers will begin to rotate. After a few seconds, when the fat suction device and all 4 fleshing motors have started the green “**READY**” light lights up and the machine is now ready to start fleshing.
- Functions are operated directly on the screen through menu points.
- There is also a possibility to change the values in the different fields.



Fig. 2 Menu

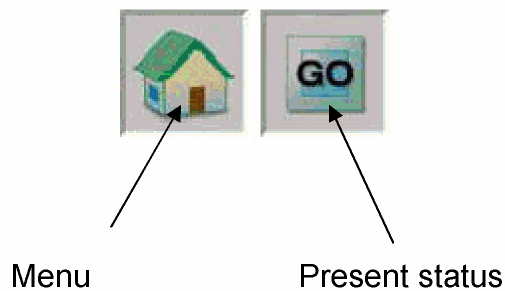
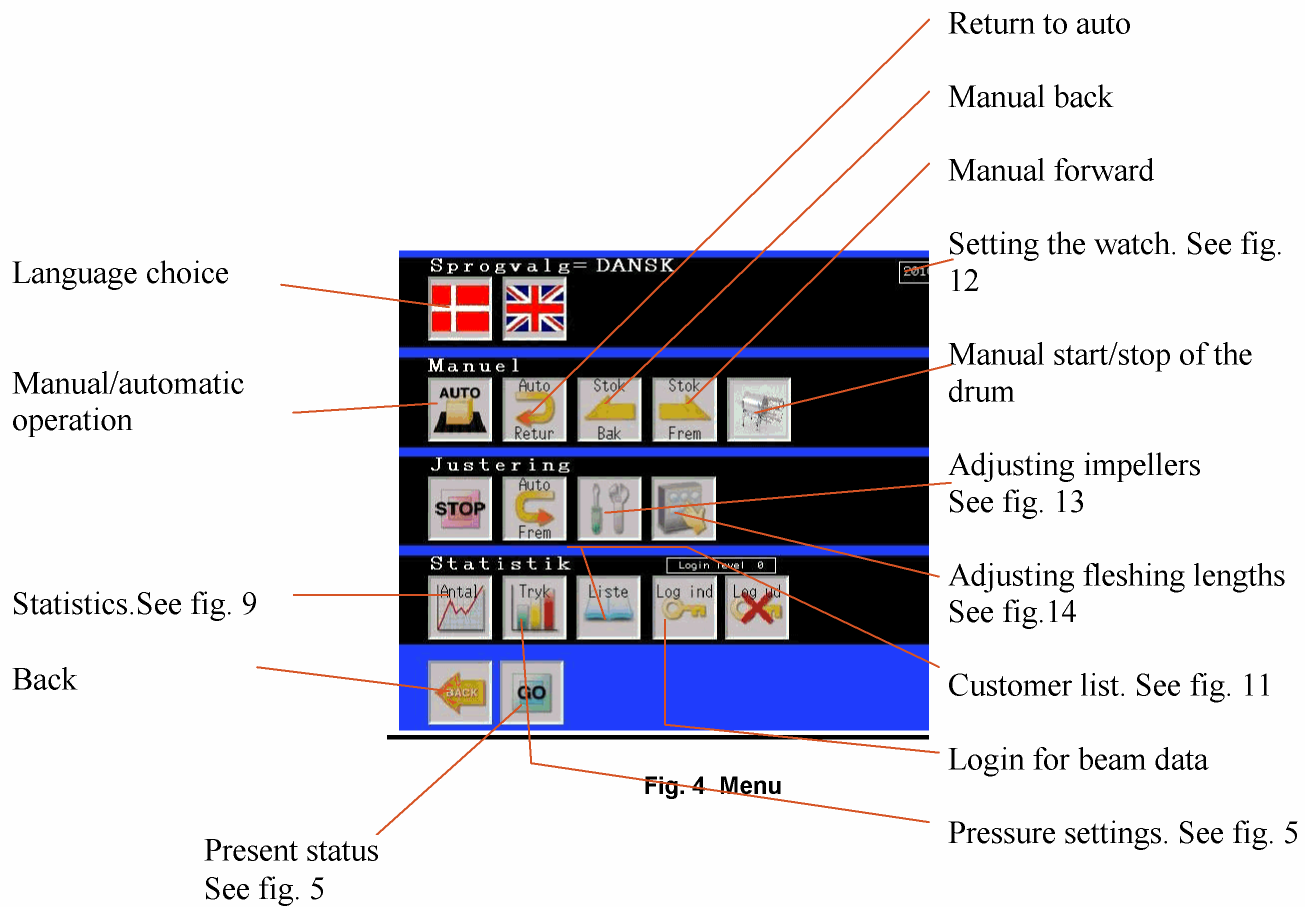


Fig. 3 Starting picture





## **7.2 Operation**

- Pull the skin onto the beam with its back up and place it so the two pins at the end of the beam stick out through the eye sockets.
- The front part of the skin, from the nose to the forelegs are pulled tightly onto the beam while the rest has to sit as loosely as possible so that the impellers can work with the skin.
- When the skin has been pulled onto the impeller the fleshing process can begin.
- Press the green button "**START PRESS1**". The beam will now run evenly forward while the skin is scraped. After the skin has passed the impellers it is processed through the skin scraper where the loose fat is scraped off. Then it is run through the sawdust device where it is sprinkled with a layer of sawdust before the skin remover takes hold of the skin and drops it into the inlet duct to the leather side drum before the beam turns back.

### **Warning!!**

**Ear protectors should be worn while working with the fleshing machine because of the loud sounds that occur when the skin is run past the impellers.**



- When the beam has returned to its original position, it has to be cleaned of fat residue if necessary with sawdust (unless a beam washer is installed) before pulling a new skin over it and starting a new fleshing.
- If the fleshing rolls are to be stopped, maybe for periodic cleaning as described in part 8.2, the red "**STOP**" button is pressed briefly. If the "**STOP**" button is pressed for more than 3 sec the impellers, fat suction device and all the equipment connected through the extra socket are stopped.

### 7.3 Setting the pressure

- The fleshing pressure is the pressure the impellers exercise on the skin once it is mounted on the beam.
- Pressure is set for the standard values from the factory (check if skins are scraped correctly).
- You can set the pressure by pressing the bar and a keyboard will appear. You confirm the value by pressing ENT. (You have to be logged in to change values, see fig. 4).

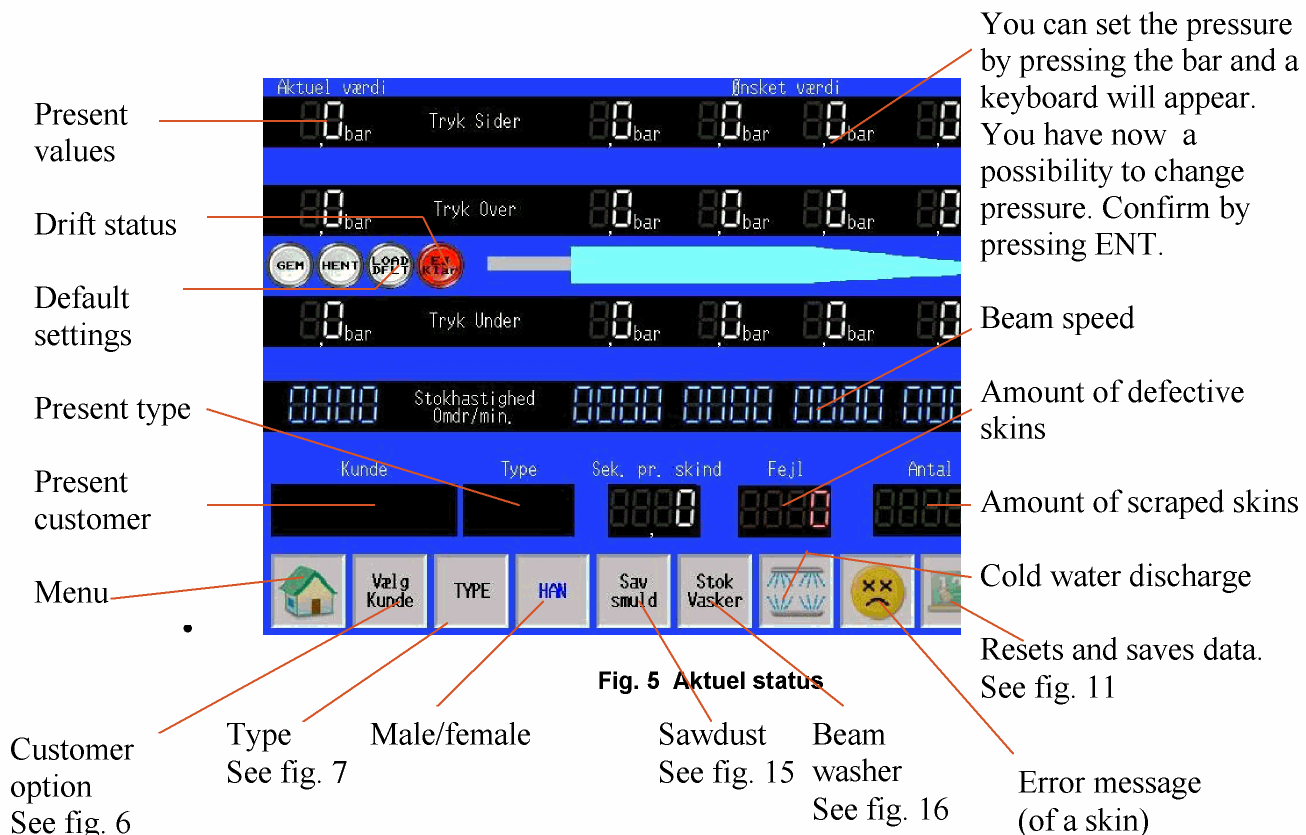
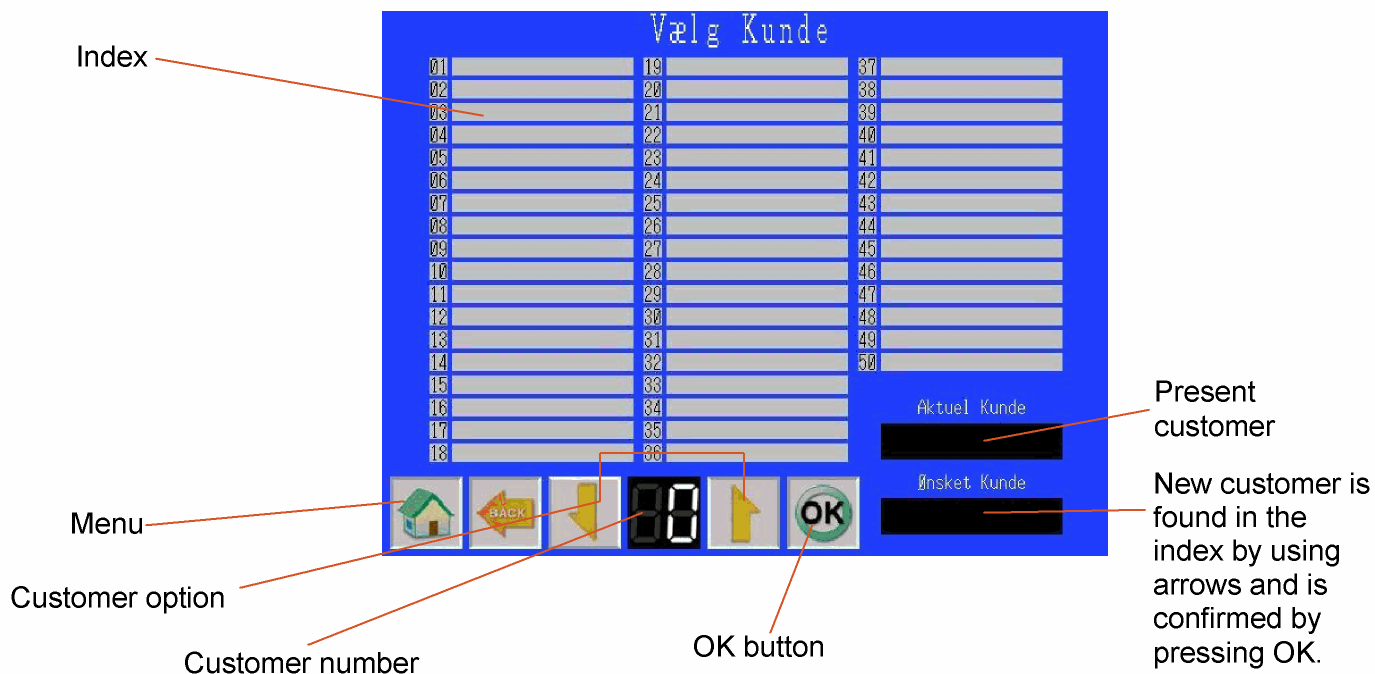


Fig. 5 Aktuell status

- The fleshing pressure varies a lot between different kinds of minks and depends also from the impellers that are mounted on the machine. The recommended pressure is only a guideline and can be used at the initial start but the operator has continuously to control the quality of the fleshing and depending on the nature of the skin it can be necessary to readjust the fleshing pressure.
- The fleshing pressure depends as well on the speed of the beam. The higher the speed the higher the pressure has to be on the impellers.

## 7.4 Customer option

- There is a possibility to type in different customers in the panel's index.
- Press the bar in the index and a keyboard will appear. You can now edit or create customer's name. You confirm by pressing ENT.



## 7.5 Type option

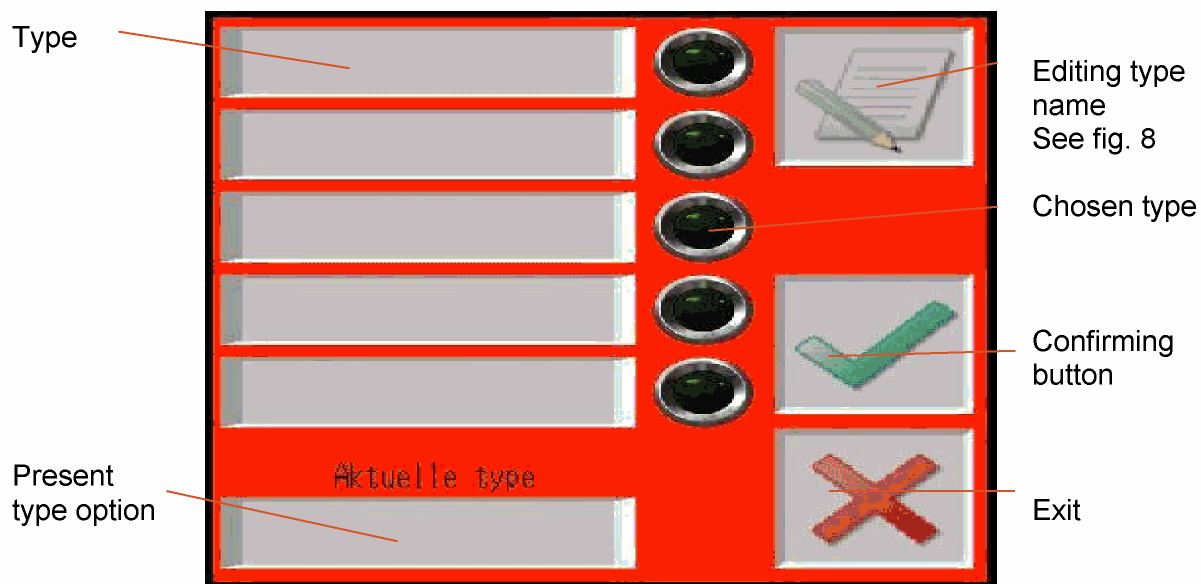


Fig. 7 Type option

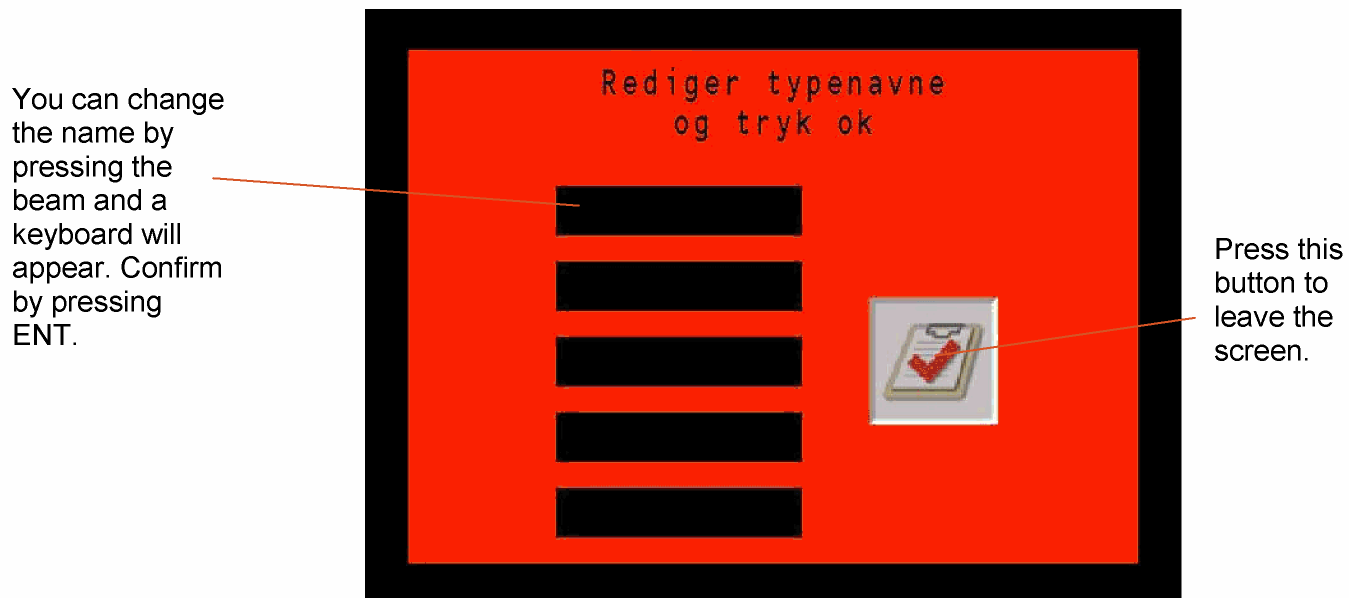


Fig. 8 Type option

### 7.5.1 Reading Piece and Hours

- You can go to this screen by choosing “statistics” – “amount” in fig. 4 or “amount” in the picture with pressure settings (fig. 5)



You can reset/change the amount by pressing the bar. A keyboard will appear. Change or reset the amount. Confirm by pressing ENT

Fig. 9 Reading statistics

Menu      Pressure settings      Customer option

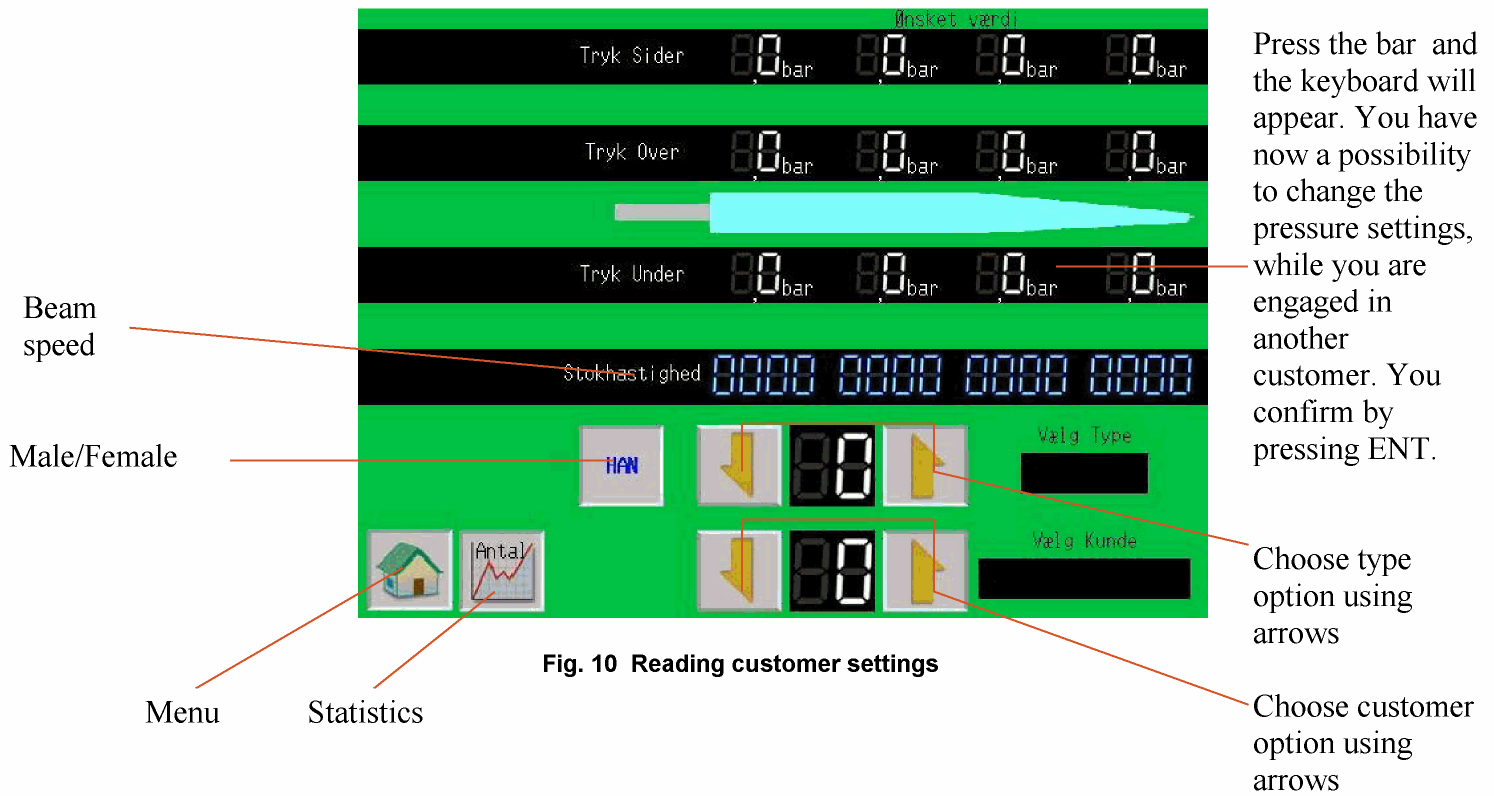


Fig. 10 Reading customer settings

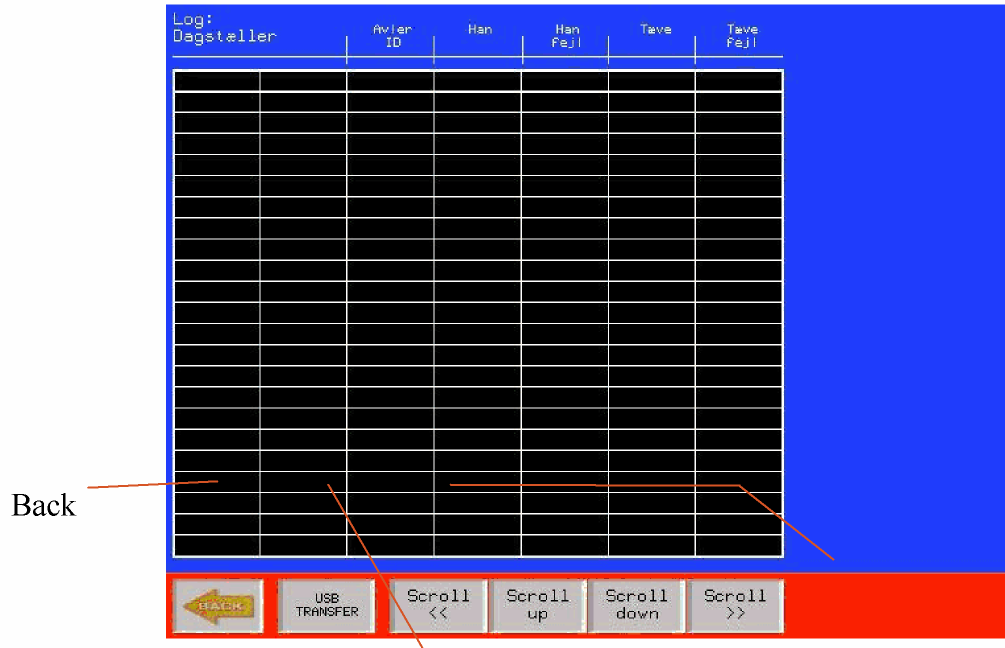
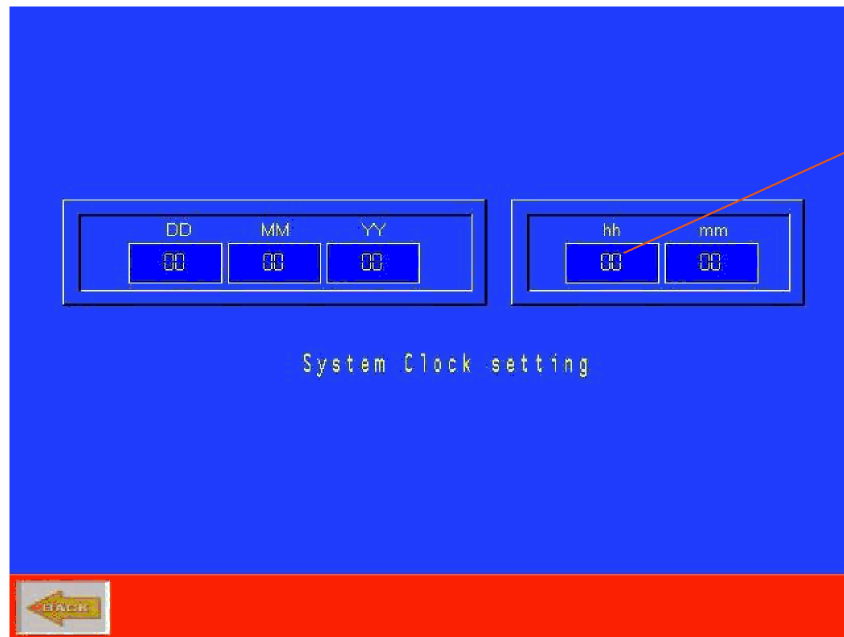


Fig. 11

There is a possibility to move the data from a Flething machine to a computer. Connect a USB cable to the operation panel and read the data. The data can be opened as an Excel file in a computer.



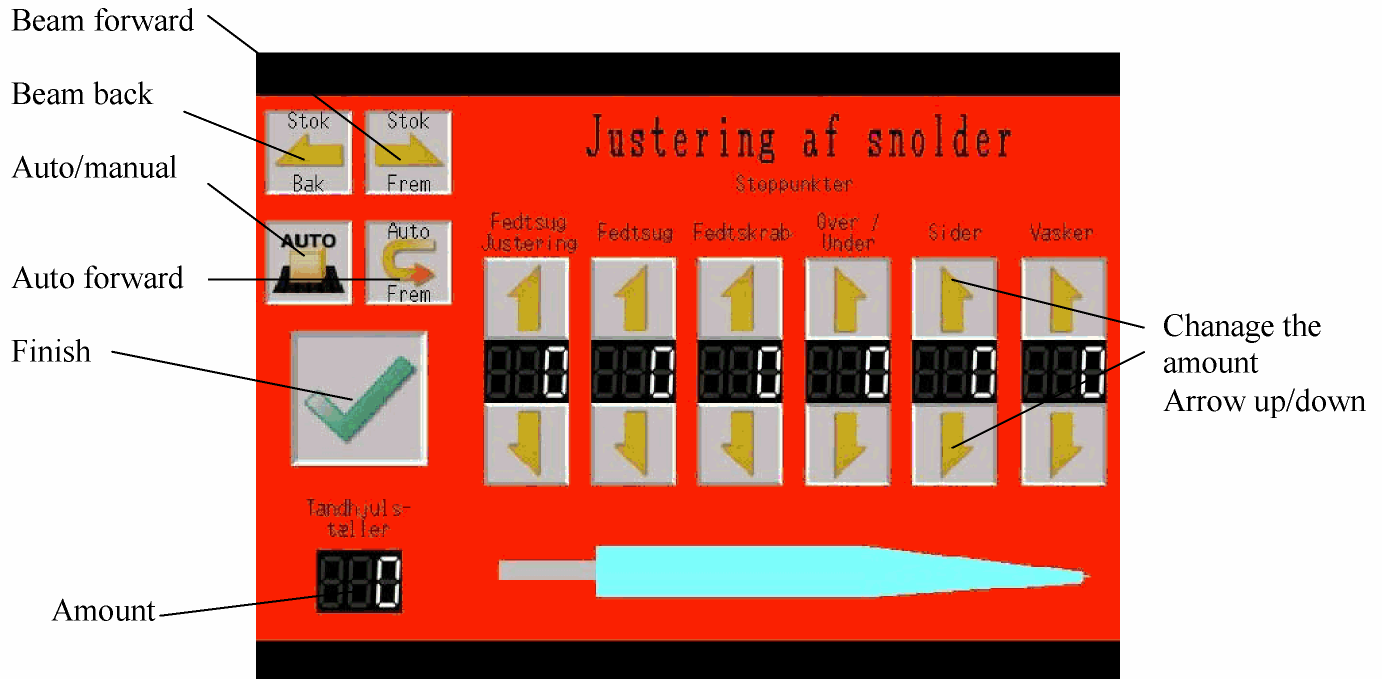


Press the bar and the keyboard will appear. You have now a possibility to change the time settings.

Fig. 12

## 7.5.2 Adjusting impellers

- You have a possibility to create settings for fat suction, fat scrape, stopping points, sides and washer. In order to do this, use arrows. You confirm changes by pressing a green arrow.



- Set the machine to a manual function in order to adjust.
- When you press auto forward, the beam will go to the first stopping point. The washer will now close to be ready to adjust.
- When you press auto forward one more time, the washer will open and the beam will continue to the next stopping point, etc.
- To find out more about adjusting impellers, see 8.5, page 26.

### 7.5.3 Adjusting fleshing lengths

- Here you can type in fleshing lengths by pressing different buttons on the beam.
- Press the bar and a keyboard will appear. You can now edit the numbers. Confirm by pressing ENT.

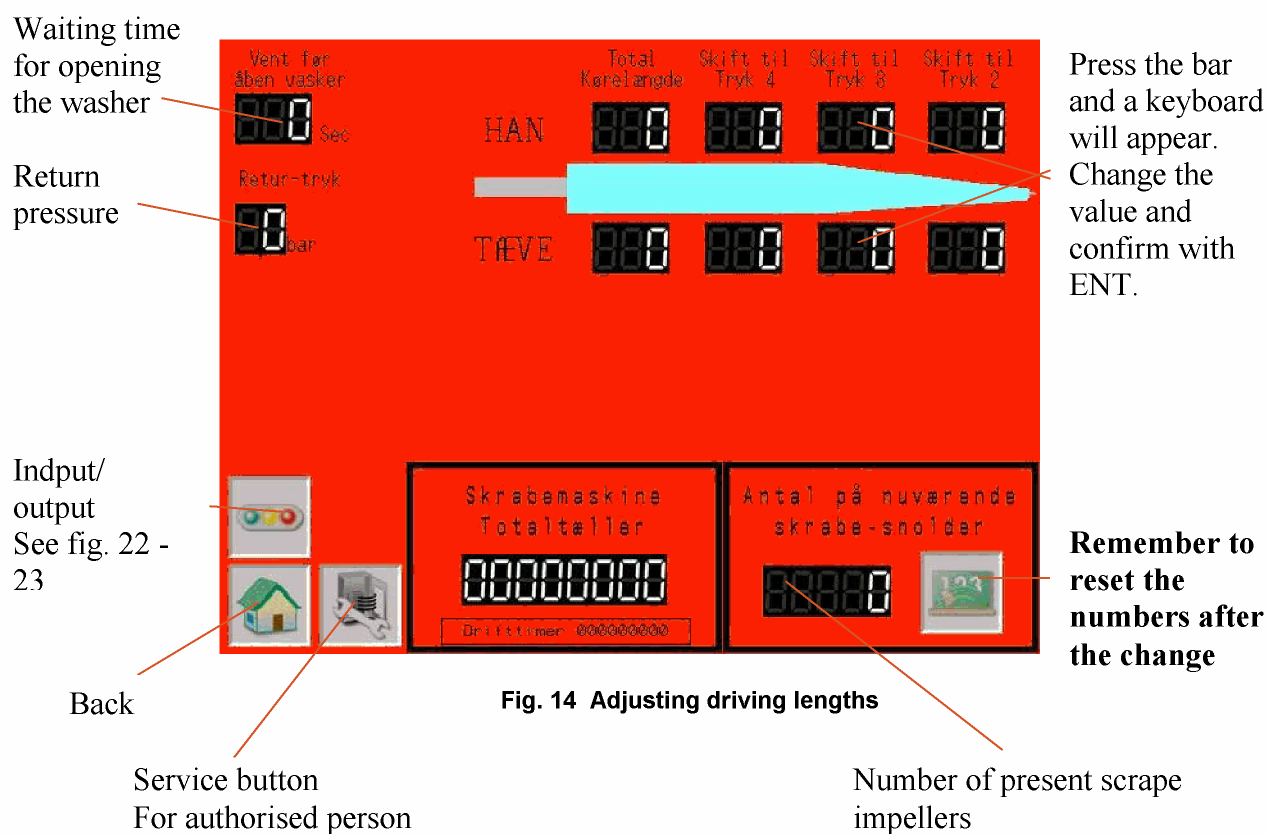


Fig. 14 Adjusting driving lengths

## 7.5.4 Sawdust and beam washer

- Using arrows, you can choose starting and stopping points for sawdust dosage and beam wash.
- Points are set for the standard values from the factory. Confirm by pressing a green arrow.



Fig. 15 Sawdust dosage

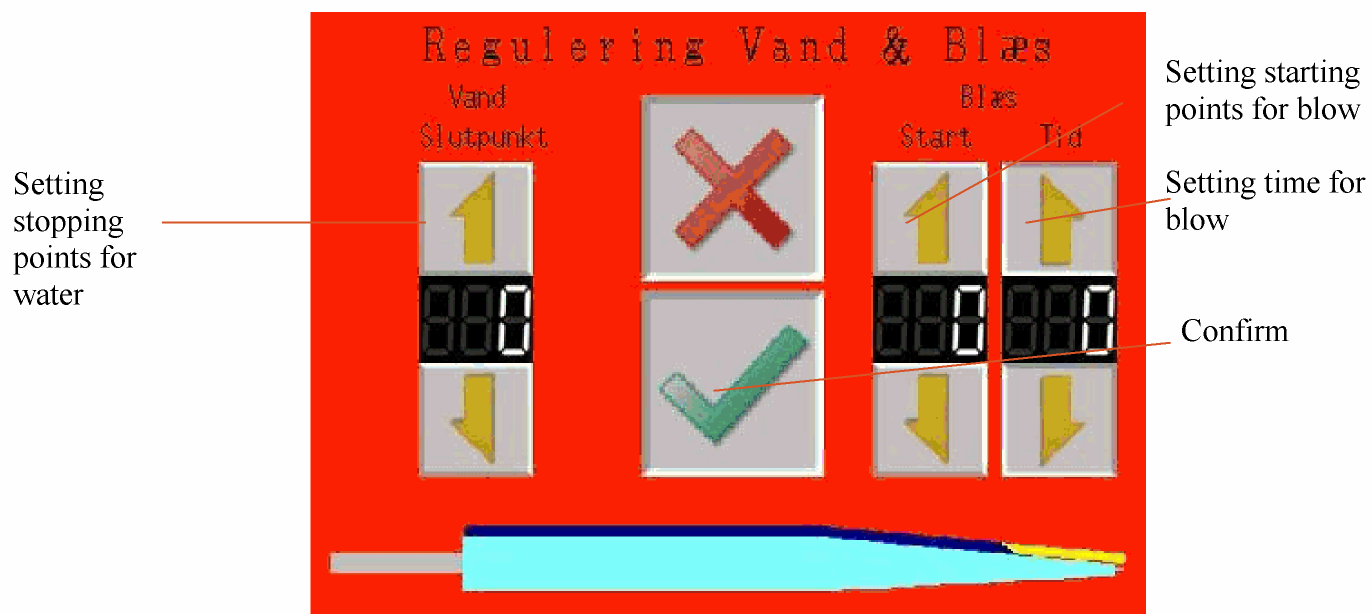
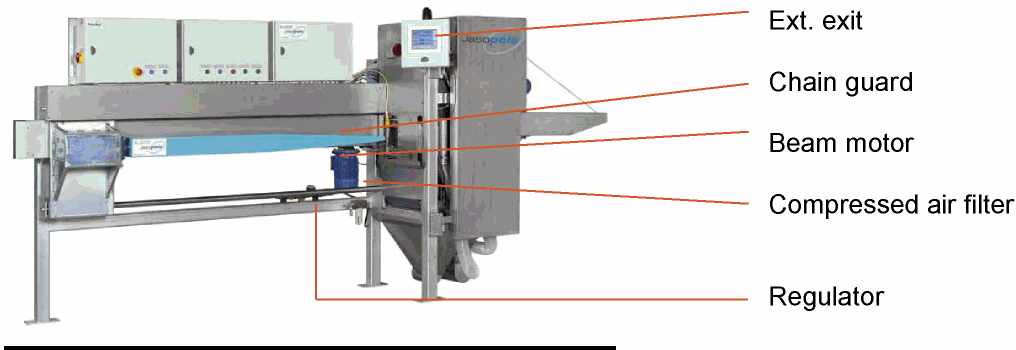


Fig. 16 Water and blow regulation

## 8. Maintenance



### 8.1 At the Beginning of the Season

Before the machine is taken into use at the beginning of the season check the following:

- Empty and clean the compressed air filter's water trap.
- Check cleaning as described in part 8.3.
- Shafts are cleaned of rust build-up or other impurities. If the shafts are marked by corrosion it has to be removed with a fine emery cloth.
- All shafts are lubricated with a thin layer of acid-free oil.
- Check that the fleshing motor, beam and skin scraper can move freely.
- Check the motor suspension for cracks.
- Check the impeller's quality (the blade and deformation of the surface).
- The beam and beam scraping rubber, rubber on the sawdust machine, skin scraping rubber and springs on the beam scraper are checked for cracks and deformations.



**DANGER!**

**Switch off the compressed air and the power supply before starting on any maintenance, cleaning or other service on the machine.**

- Suction tubes and suction heads are checked for leaks and deformations.
- Check all cables and air tubes for cracks and leaks.
- After these checks start the machine as described in chapter 6 part 4, connected to the fat suction device, leather side drum, saw dust conveyor a.s.f. **REMEMBER! The Start button must never be activated without a skin on the beam.**

## **8.2 Daily Maintenance**

The fleshing machine does not demand much daily maintenance if you stick to a few points:

- Clean the beam scraper with a blowgun for every 100 – 150 pelts or at least at every break the operator takes.
- For every 1 – 2 operating hours the sawdust machine is opened just so much that the left side motor's aluminium bearing blocks and the let scraper (at the sawdust machine) can be cleaned with compressed air.

**DANGER!**

**Do not start the machine without guard.**



- At the end of every working day the fleshing room itself has to be cleaned. Briefly press the stop button so the fleshing motor stops but the suction nozzle still is on. Open the sawdust machine and clean the fleshing room – i.e. the beam, sliding guide, motors, compressed air cylinders, and suction nozzles a. s. f. – with compressed air.
- After the cleaning the motor suspension is checked for cracks. Check whether the fleshing motor, compressed air cylinders, scraper a. s. f. can move freely. Check whether parts have come loose, and check the impellers and beam scraping rubber for damage.

- Empty the water emitter of the compressed air filter for water daily by pressing the button under the glass.

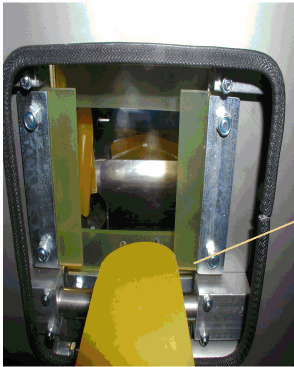


Figure 18.  
Beam scraper

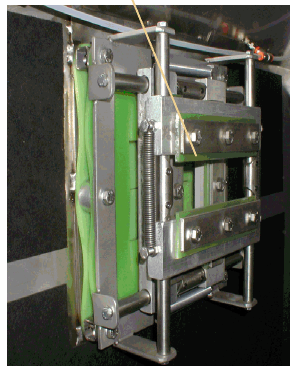


Figure 20  
Pelt scraper



Figure 19.  
Aluminium bearing

**DANGER!**

**Switch off the compressed air and the power supply before starting on any maintenance, cleaning or other service on the machine.**



### **8.3 At the End of the Season**

At the end of the season the fleshing machine has to be cleaned thoroughly. If you leave the fleshing machine dirty and without final maintenance there is a risk

for unnecessary expenses for the cleaning of the machine at the beginning of the next season. Rust on shafts a. s. f. can result in wear on the fleshing rings and bearings, a dirty machine is a welcome target for rodents and vermin, which can result in the damage of cables and air tubes.

- The sawdust machine is emptied of sawdust.
- The guard over the upper longitudinal shaft and the guard at the beam scraper are dismounted and cleaned.
- Suction nozzles with tubes are dismounted, cleaned and checked for cracks, even the rest of the suction tubes with manifold have to be separated and washed in order to keep up the maximal suction.
- If the impellers can still be used it is recommended that they are dismounted, washed and stored in a dark and cool place. (Under normal circumstances the capacity of the impellers is up to 10 000 skins in the normal circumstances).
- The whole machine is cleaned with compressed air but the dirtiest parts of the machine can be cleaned with a high-pressure washer. Avoid hosing down bushings, bearings and electrical parts. If the fleshing motors have been sprayed with water they should run for about 30 min afterwards in order to let the water evaporate.
- At the end the whole machine is blown dry with compressed air and all shafts have to be lubricated with a thin layer of oil in order to stop rust attacks.
- Remember to close all steering cabinets in order to avoid rodent attacks.

## 8.4 Changing the impellers

The change of impellers becomes necessary when the blades on the impellers are worn, deformed or need to be changed to a set of impellers with a different edge. The capacity of a set of impellers is normally up to 10 000 skins. Conditions that can contribute to a shorter lifespan on the impellers can be the

fleshing of mink skins, which still have parts of the paws attached, because this can ruin the blades of the impellers. The incorrect storage of the impellers can ruin them, too. Impellers should be kept in a dark and cool place. Underneath you find a description of how to change the impellers.

**DANGER!**  
**Switch off the compressed air and the power supply before starting on any maintenance, cleaning or other service on the machine.**

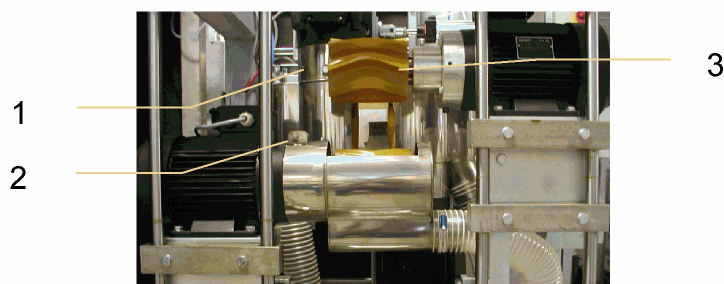


Figure 21

- Loosen the screw on figure 21.2 just enough so you can pull out the suction nozzle.
- When the self-locking bolt and the washers, fig. 21.1 are removed the impellers can be pulled out.
- The new impellers are pushed in over the extended motor shaft. Note that the two holes in the impellers have to hit the pins on the aluminium drivers fig. 21.3. The two sides and the lower part are mounted with V-shaped impellers, the upper has to be a U-shaped impeller.

- If the impellers sit only loosely on the shaft the result of the fleshing will be improved if the impeller is centred. This can be achieved by spiralling insulating tape around the shaft before the impeller is mounted.
- Put back the washers and the self-locking bolts. The bolts have to be tightened enough to keep the impeller in place but not so much that the impeller arches outwards in the middle. One way to do this is described here: Tighten the bolt so much that the impeller is pressed hard against

the aluminium drivers, loosen the bolt just enough that the washer can be turned with the fingers, then tighten the bolt again 1 turn.

- Attach the suction nozzles and tighten the screws fig. 7.2. Close the sawdust machine and after the start of the fleshing device the machine should now be ready to continue working.
- After having changed the impeller the quality of the fleshing has to be checked immediately. If the skin has not been scraped evenly on all four

sides the reason can be that the impellers are not centred on the fleshing beam. If you need help to adjust the impellers please contact Jasopels' service department for instruction or arrange for a service engineer to visit.

## **8.5 Adjusting the impellers**

The impellers are basically adjusted as follows:



1. Find the picture "adjusting impellers", see fig. 13.
2. The beam is moved forward to the end of the rubber surface and is aligned with the back edge of the suction nozzles.
3. Check the distance between the beam and the impellers.
  - Distance between upper impeller and beam 1 mm
  - Distance between side impellers and beam 1 mm

- Distance between lower impeller and beam 2 mm
4. Adjust the distance by changing the length of the fleshing cylinders' piston rod. (The piston rod is screwed in and out of the fork rod).
  5. After the adjustment the beam is moved back to its original position by pressing "BEAM BACK".



## 9. Technical Data

- Electrical connection 32A 5 poled CEE plug 3 X 400 V + N + PE
- Power consumption Max. incl. fat suction device 34.7 A
- Air connection Quick coupling
- Measurements
  - Height 190 cm
  - Length 410 cm
  - Width 100 cm

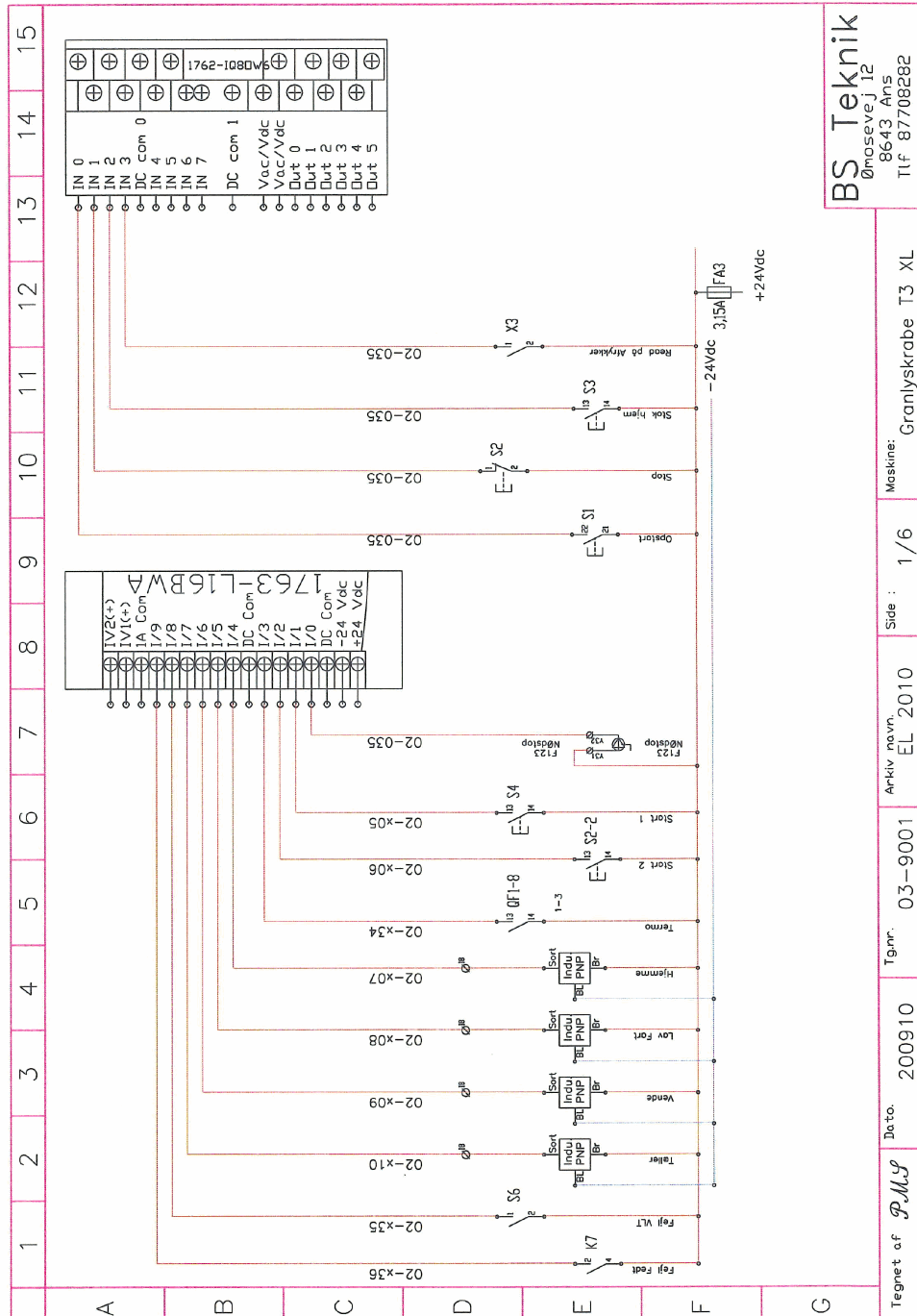
## 10. Electrical diagrams

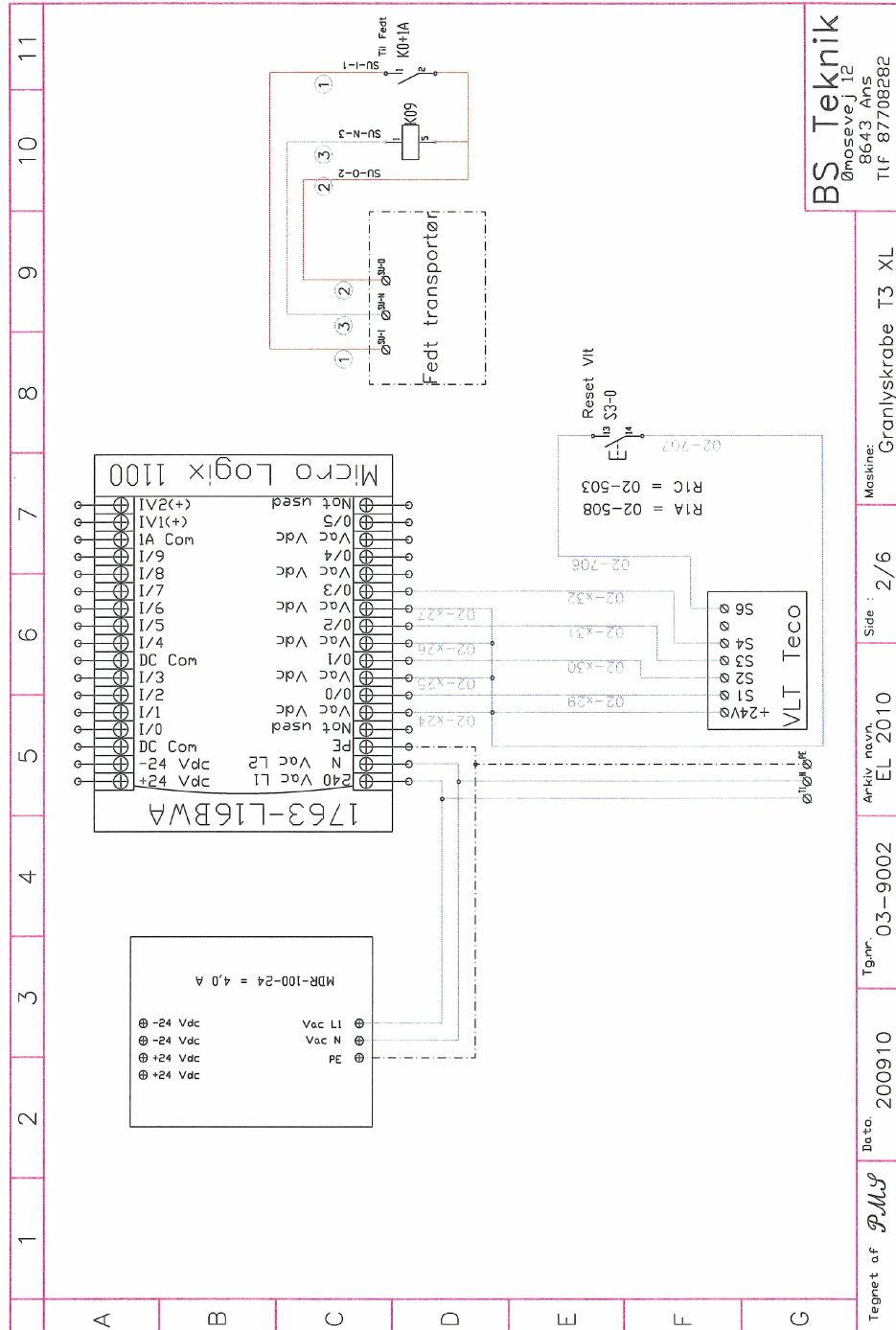


Fig.22



Fig. 23





**BS Teknik**  
Ømosevej 12  
8643 Årns  
Tlf. 87708282

Maskine: Granlyskrabbe T3 XL

Side: 2/6

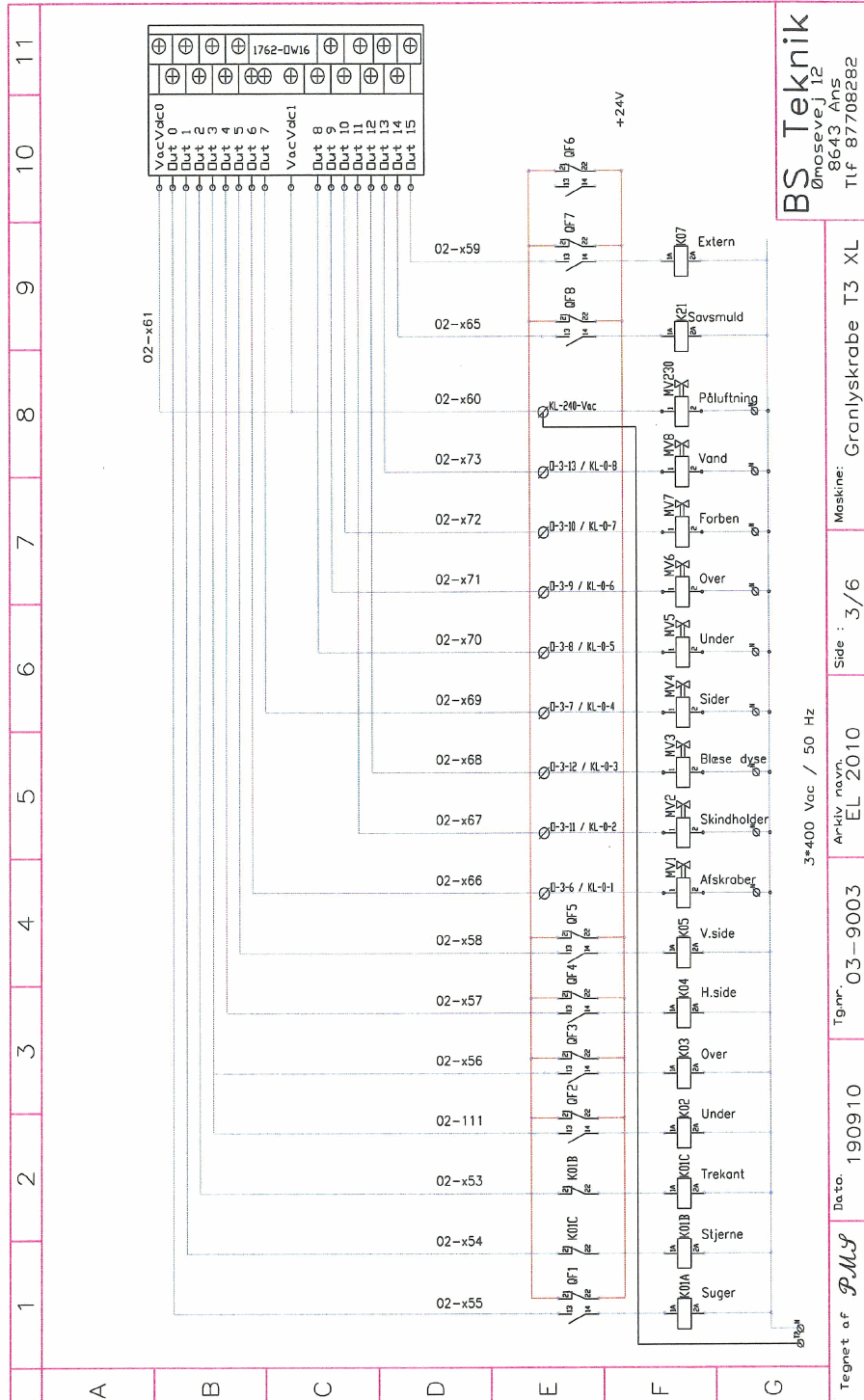
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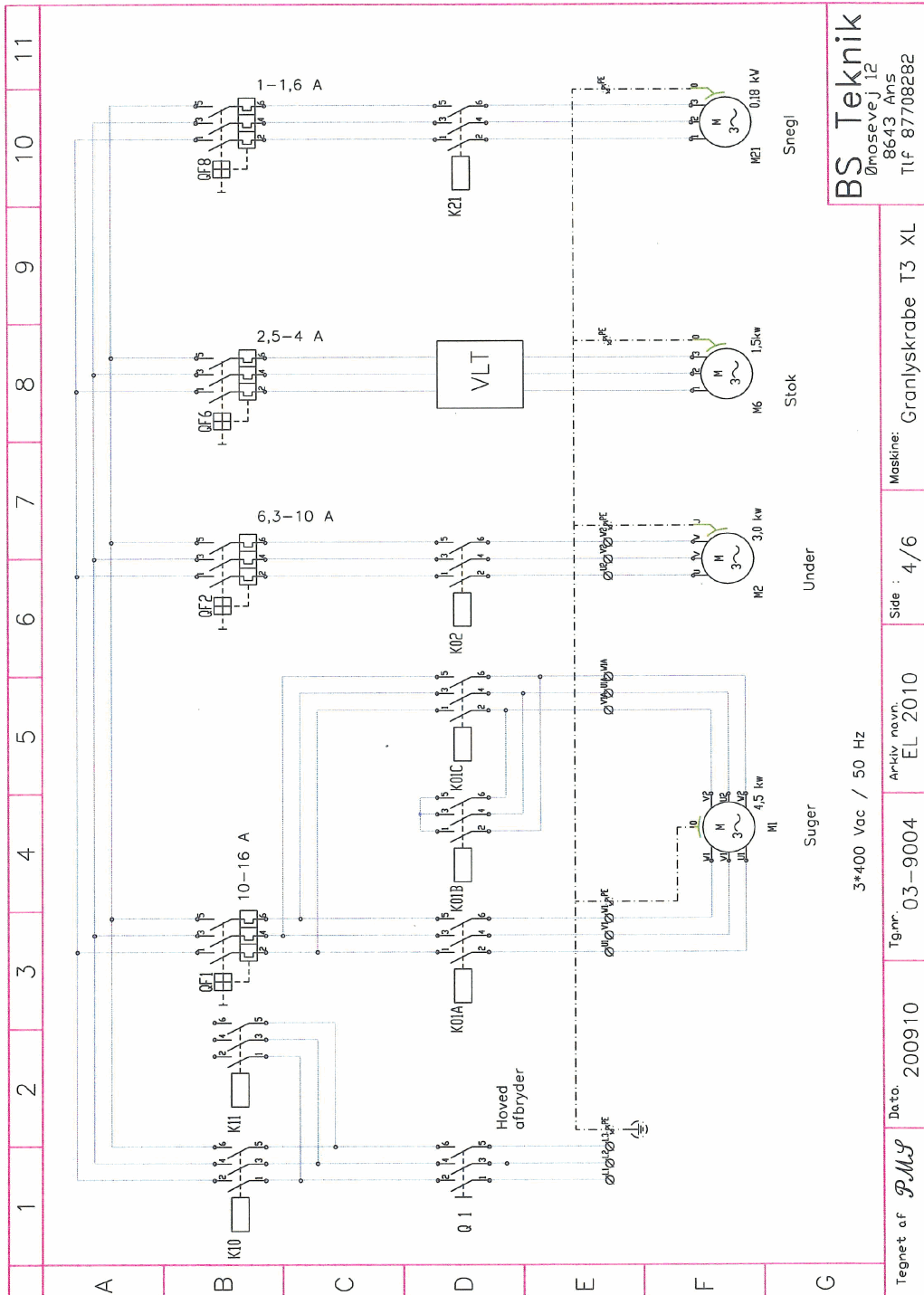
Tegn.: 03-9002

Dato: 200910

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BS Teknik  
Ømosevej 12  
8643 Års  
Tlf 87708282

Maskine: Granlyskrabe T3 XL

Side : 4/6

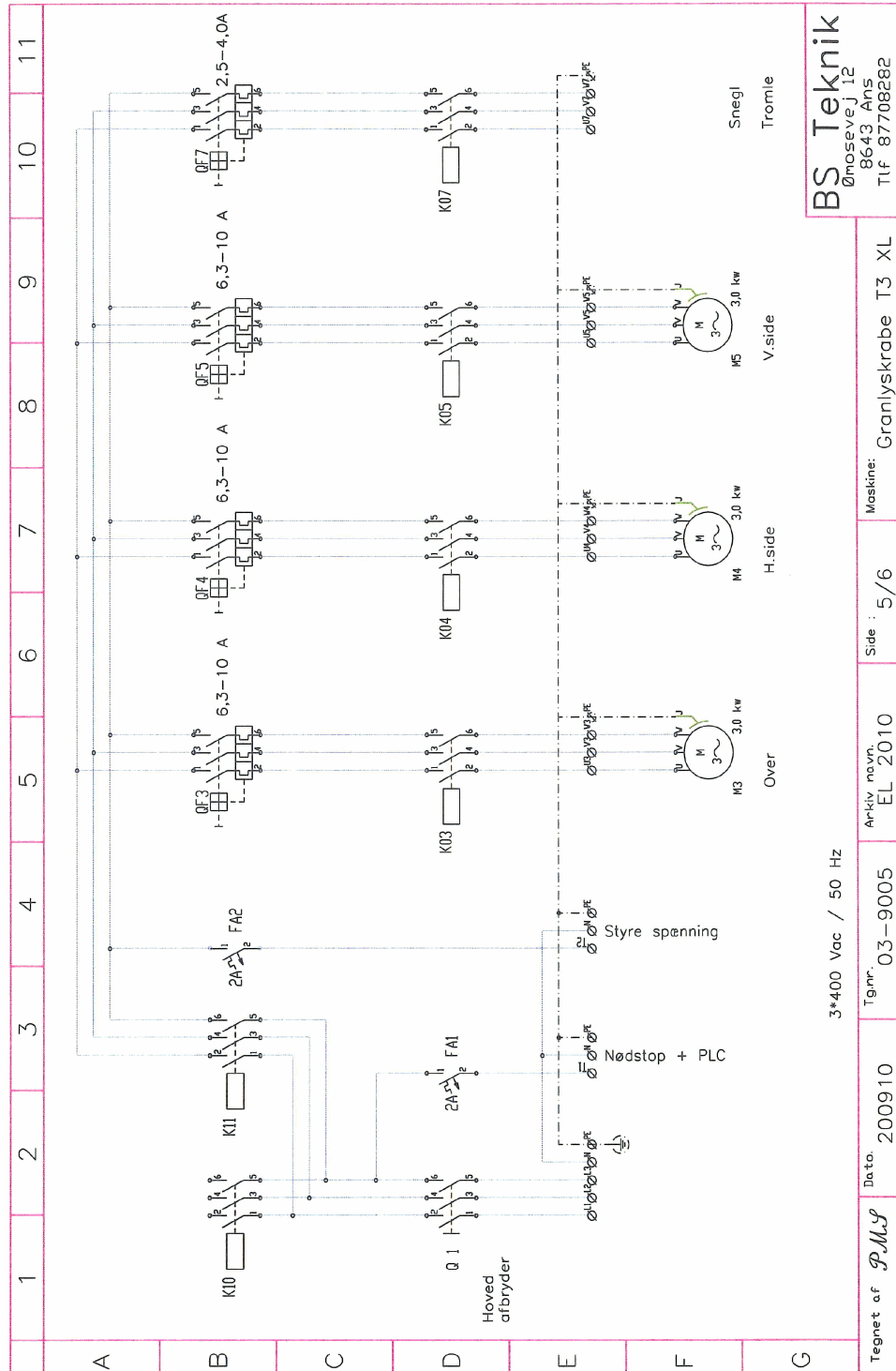
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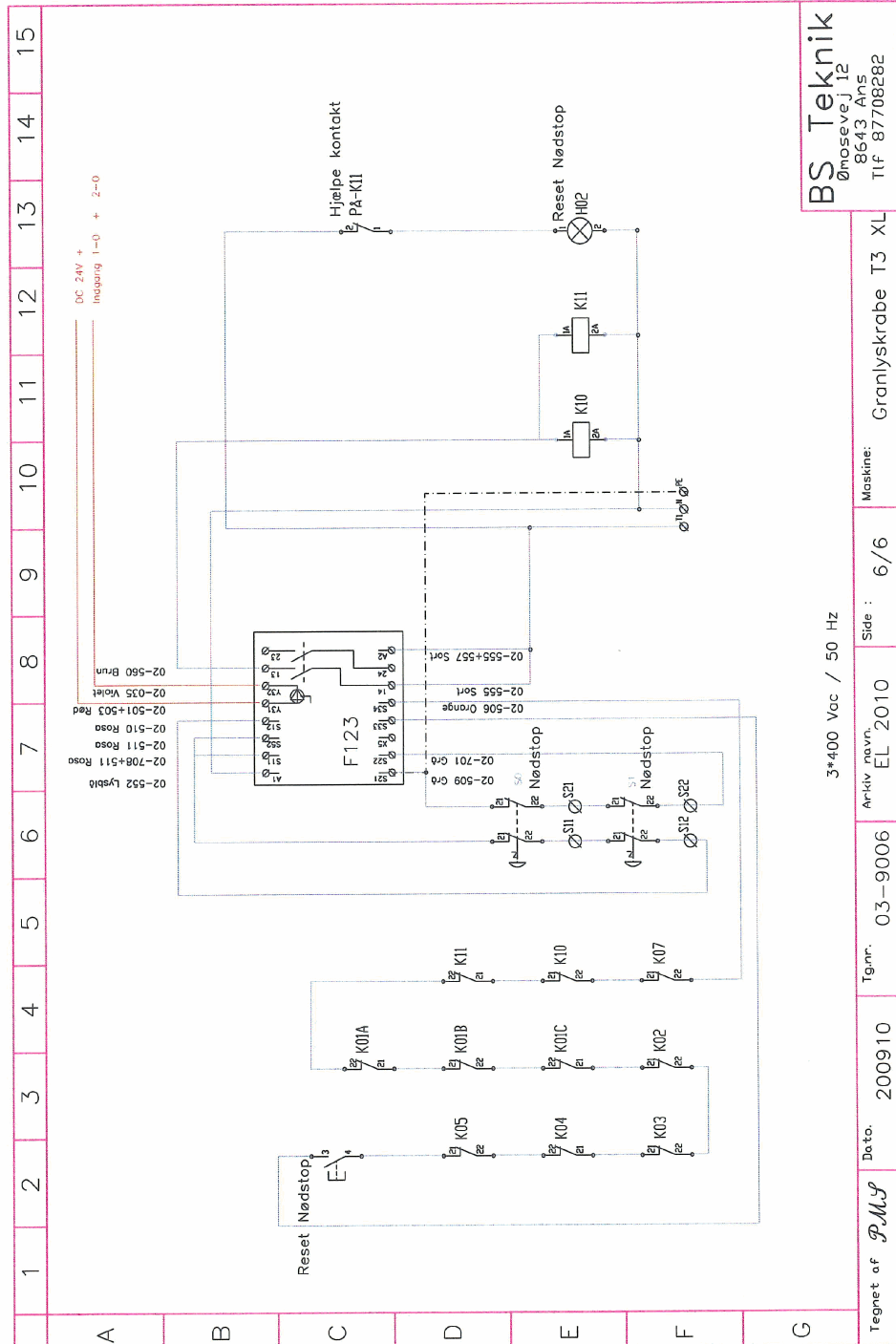
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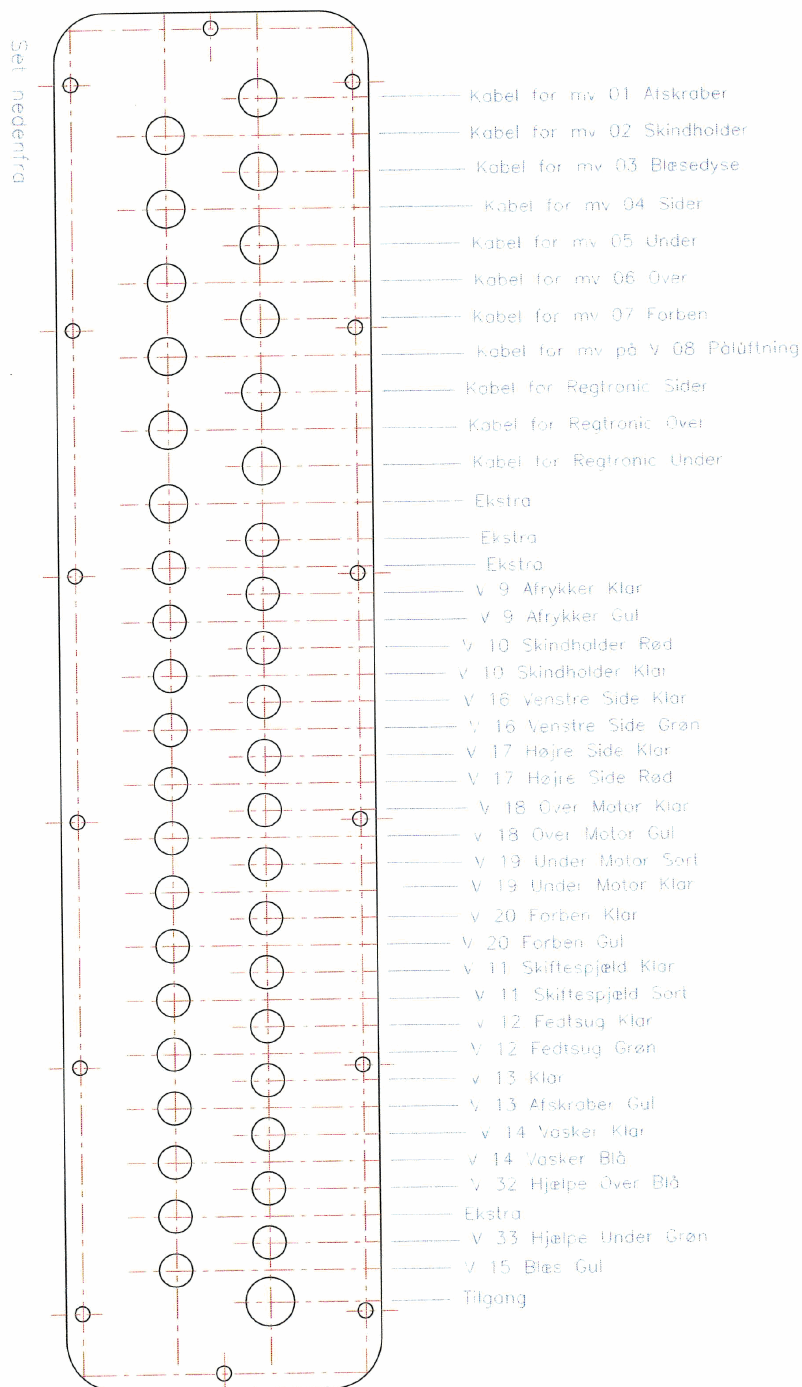
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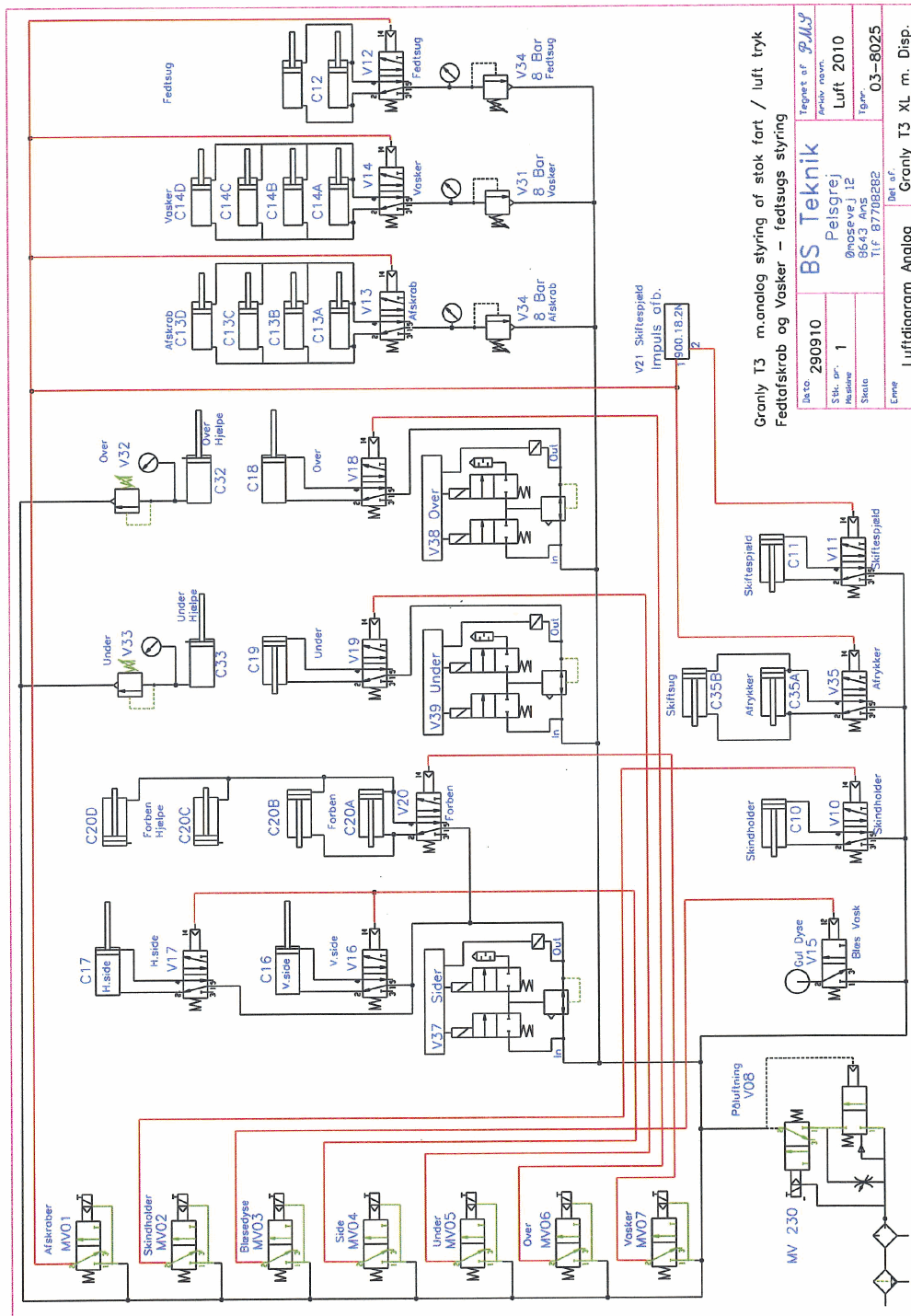
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3\*400 Vac / 50 Hz









## 11. List of Spare Parts

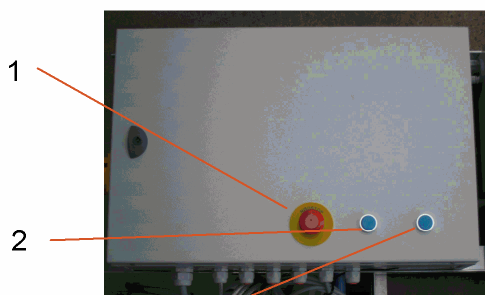


Fig. 24 VLT lage

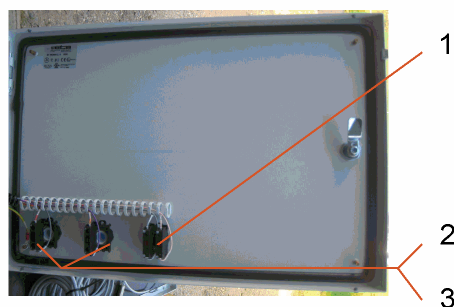


Fig. 25 VLT lage

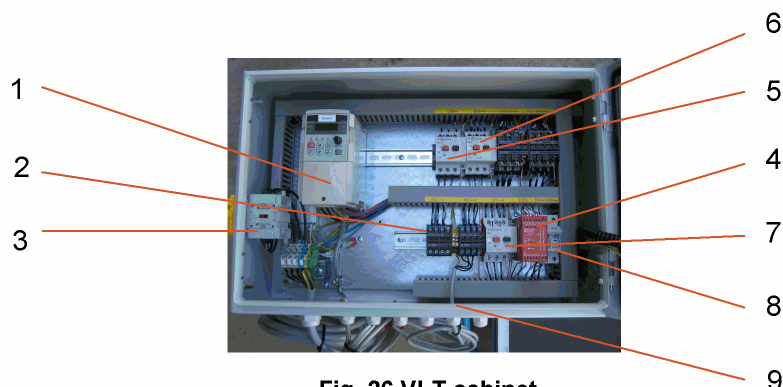


Fig. 26 VLT cabinet

Fig nr	Jaso number	Spare part number	Name
24.1	5924-74010010	BS3P44T RT	B&J safety emergency stop 40mm
24.2	5924-74010080	BC3D BL	B&J pressure head flat blue
24.3	5924-74010080	BC3D BL	B&J pressure head flat blue
25.1	5924-74011020	B3T01	B&J plug element 1NC
25.2	5924-74011030	B3T10	B&J plug element 1NO
25.3	5924-74011030	B3T10	B&J plug element 1NO
26.1	5921-24000300	10564023	Teco7300CV JNTHBCBA0002BE-UF
26.2	5925-14020030	K2-12A01-230V	B&J contactor K2-23A01-230V
26.3	5924-37238224	54.17.248.227	AB switch 3P 0-1 90g
26.4	5922-14001110	440R - J23103	Tesch F123 with monitored reset
26.5	5925-14020070	K2-23A01-230V	B&J contactor K2-23A01-230V
26.6	5925-24021030	MU25A-1,6	B&J motor protector man. 1-1,6A
26.7	5925-24021050	MU25A-4,0	B&J motor protector man. 2,5-4A
26.8	5922-54005106	2211003	06 A Fuse D01
26.9	5926-16420031	ST6420-BS-VLT3	ETA cabinet B600*A400*D200 M.2010



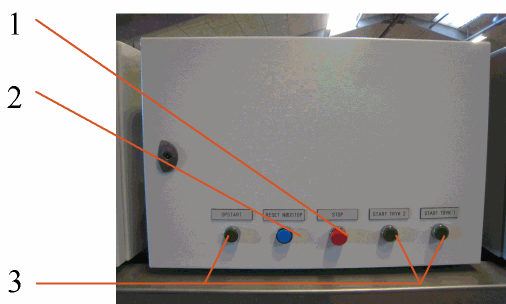


Fig. 27 PLC cabinet

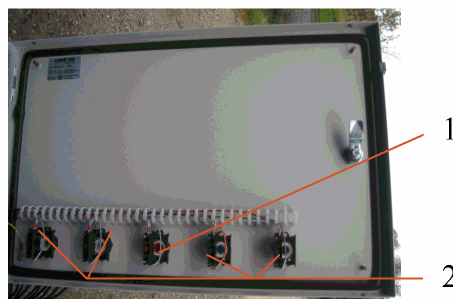


Fig. 28 PLC cabinet

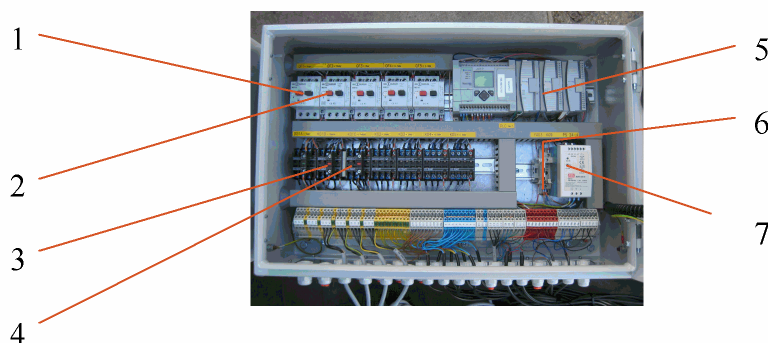


Fig. 29 PLC cabinet

Fig nr	Jaso number	Spare part number	Name
27.1	5924-74010050	BC3P1 RT	B&J LED lamp red 28mm
27.3	5924-74010080	BC3D BL	B&J pressure flat head blue
27.3	5924-74010090	BC3D GN	B&J pressure flat head green
28.1	5924-74011030	B3T10	B&J plug element 1NO
28.2	5924-74011020	B3T01	B&J plug element 1NC
29.1	5925-24021080	MU25A-16,0	B&J motor protector man. 10-16A
29.2	5925-24021070	MU25A-10,0	B&J motor protector man. 6,3-10A
29.3	5925-14020070	K2-23A01-230V	B&J contactor K2-23A01-230V 11KW
29.3	5925-14020030	K2-12A01-230V	B&J contactor K2-12A01-230V
29.4	5921-14002070	1763-L16BWA	Microcontroler 1763-L16BWA
29.5	5921-14002120	1762-OW16	Micrologix 16 PT Relay output
29.6	5922-54005102	2211001	02 A Fuse D01
29.7		MDR-100-24	Power supply 240Vac / 24Vdc 4,0A



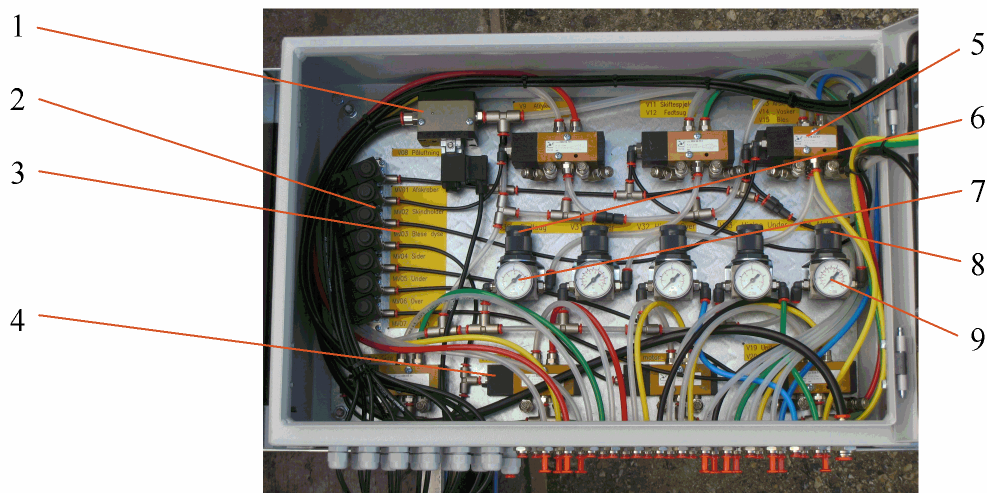


Fig. 30

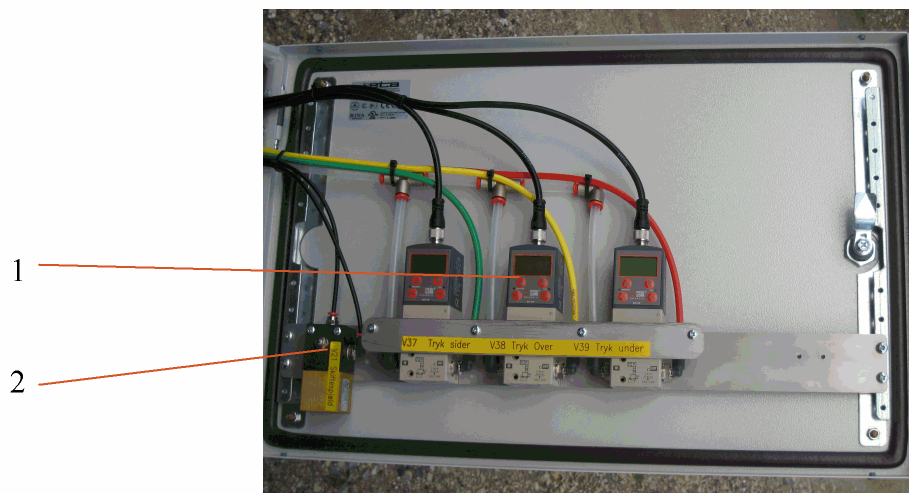


Fig. 31

Fig nr	Jaso number	Spare part number	Name
30.1	5911-5001711002		17110.M2 Ventilation
30.2	5911-5023051258		MB 58,230/50-60 Hz coil
30.3	5911-5023051262		M 2 pilot NC
30.4	5911-5228521101		228,52,11,1
30.5	5911-5228321101		228,32,11,1
30.6	5914-32001010	5107003	Regulator MR bit 1/8 08 bar
30.7	5914-32000110	9700106	40mm 0-10 Bar Manometer
30.8	5914-32001000	5107002	Regulator MR bit 1/8 04 bar
30.9	5914-32000100	9700102	40mm 0-4 Bar Manometer
31.1	5914-15522500	5522500	Proportional regulator
31.2	5911-5009001820	900,182N	Impulse switch

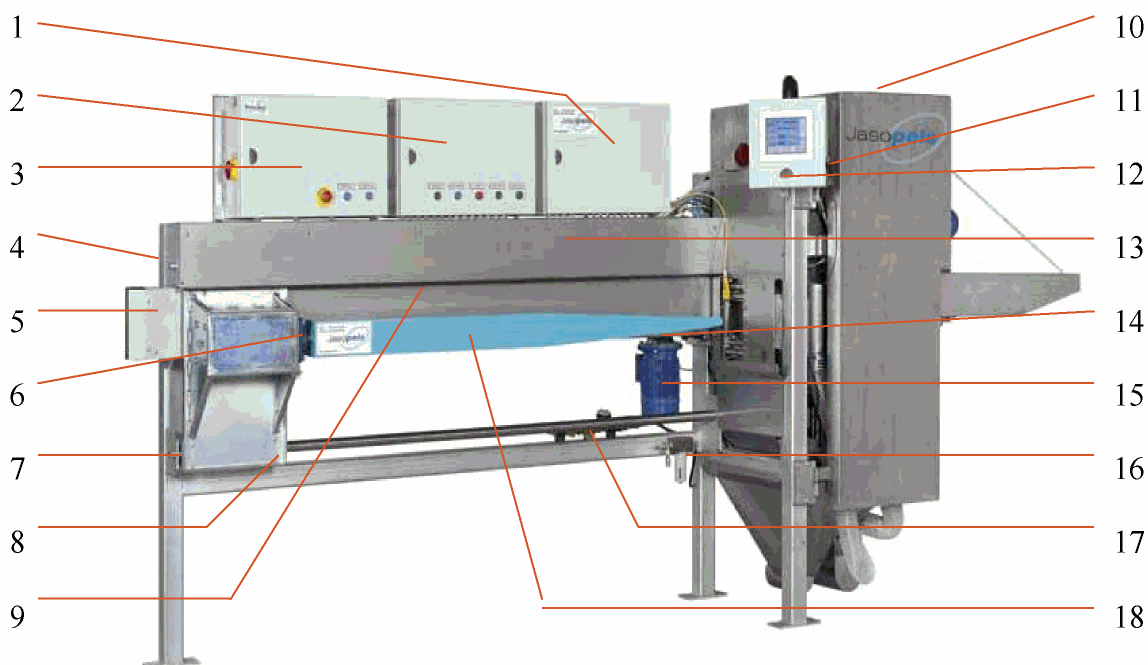


Fig. 32

Fig.Nr.	Jaso number	Spare part number	Name
32.1			Air Cabinet
32.2			PLC Cabinet
32.3			VLt Cabinet
32.4	5923-14002220	E2A-M18KN16-WP-B1-2M	Proximity switch O18 mm O18 PNP NO
32.5	5110-00021061	15 tds. Chain gear w/hub 3"	Gear wheel
32.6	5940-10441210	SAF 210 (KHF 210) O50	Flange bearing with retaining ring
32.7	5940-10104060	G 40*52*5 to KGHA 40 PP	Bearing without housing
32.8	5940-10114060	KGHA 40 PP with housing	Bearing with housing
32.9	5967-0600121016	050 71 4000999	Roller chain 3" reinforced
32.9	5967-0611061000	050 71 4000999	Straight joint link 3" reinforced
32.10	5912-31040150	1260,40,150	Cylinder
32.11	5924-34009290	800E - PYP5A2	Emergency stop plastic enclosed complete
32.12			Operation panel
32.13	5940-10140237	W 40 H6 O40*2378 mm	Longitudinal shaft
32.14	5935-13872020035	LPC 87-20-200-O24-O35	Gear for frame motor
32.15	5931-10150405	ST90LS4 1,5kW 1380o/m	Frame motor
32.16	5914-32001630	Filter 3/8 -200	Compressed air filter
32.17			Regulator
32.18	3272-00035100		Fleshing beam T3 XL - 140*120*2260mm



Fig. 33 Fleshing room

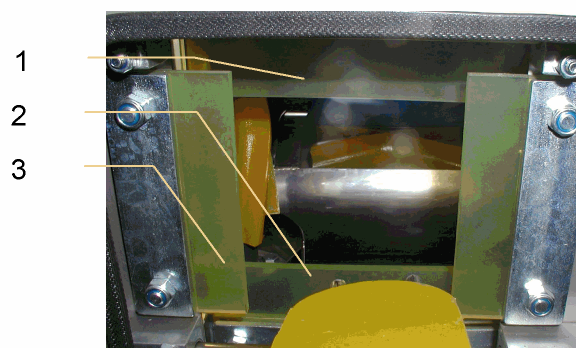
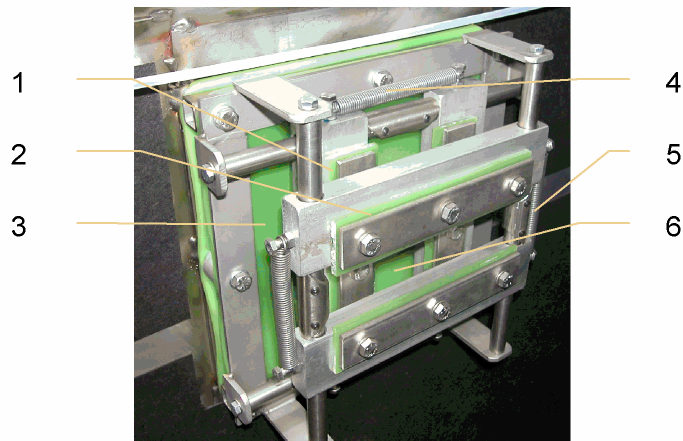


Fig. 34 Beam scraper

Fig.Nr.	Jaso number	Spare part number	Name
33.1	5912-31025075	Cylinder round O25*075	Cylinder for horizontal frame scraper
33.2	5912-31025125	Cylinder round O25*125	Cylinder for vertical frame scraper
33.3	5940-10122540	G 25*35*4 A til KH 2540 PP	Scraping ring
33.4	5940-10102540	KH 2540 PP	Bearing without housing
33.5	5912-32040050	VDMA O40-0050 ub and um	Cylinder
33.6	5912-39040000	W0950402003/8	Back mounting (B + GL) O40 mm
33.7	5110-00026000	ST 100LS 4 3,0kW 1400o/m	Fleshing motor, complete 3 KW
33.8	5110-00026002		Flange for fleshing motor
33.9	5110-00026003		Driver for fleshing motor
33.10	5110-00023002		Suction nozzle angular
33.11	5110-00023100		Suction tube Alfa pure 7 O 80
33.11	5110-00023200		Clip ABA galv. 77-95 MM
33.12	5110-00023001		Suction nozzle straight
33	3272-00026176		Impeller V-shaped 155 mm 7 teeth black ord
33	3272-00026179		Impeller V-shaped 155 mm 7 teeth yellow
33	3272-00026181		Impeller V-shaped 155 mm 7 teeth green
33	3272-00026183		Impeller V-shaped 155 mm 7 teeth light
33	3272-00026187		Impeller V-shaped 155 mm 7 teeth black
33	3272-00026272		Impeller U-shaped 155 mm 7 teeth black
33	3272-00026275		Impeller U-shaped 155 mm 7 teeth black
33	3272-00026279		Impeller U-shaped 155 mm 7 teeth yellow
33	3272-00026281		Impeller U-shaped 155 mm 7 teeth green
33	3272-00026283		Impeller U-shaped 155 mm 7 teeth light
33	3272-00026287		Impeller U-shaped 155 mm 7 teeth black
33	3272-00026379		Impeller V-shaped 155 mm 8 teeth yellow
33	3272-00026381		Impeller V-shaped 155 mm 8 teeth green
34.1	3272-00021211		Beam scraper rubber horizontal 75 mm
34.2	3272-00021212		Beam scraper rubber horizontal 65 mm
34.3	3272-00021216		Beam scraper rubber vertical



**Fig. 35 Skin remover**

Fig.Nr.	Jaso number	Spare part no	Name
35.1	3272-00024090		Skin scraper rubber
35.2	3272-00024090		Skin scraper rubber
35.3	3272-00021221		Rubber for sawdust machine in. outs.
35.4	5110-00024095		Tension spring 105 mm pelt scraper
35.5	5110-00024095		Tension spring 95 mm pelt scraper
35.6	3272-00021222		Rubber for sawdust machine in. outs.
	3272-00021230		Skin scraper rubber short
	3272-00021231		Skin scraper rubber short

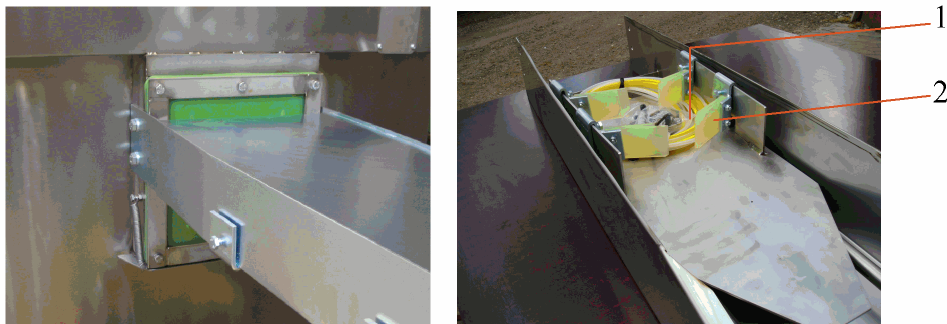


Fig. 36 Skin scraper standard

Fig nr	Jaso number	Spare part number	Name
36.1	3272-00021230	02-1230	Scraper rubber short
36.2	3272-00021231	02-1231	Scraper rubber long
	3272-00021232	02-1232	Scraper rubber extra short
	5912-51032400	109C320400AP	Round O 32*400 A M.Br. & U.Mag. 109
	5913-302134007	2L34007	Swivel elbow RL34-6-1/8

## 12. Extra equipment

### 12.1 Beam washer

- The beam is washed under high pressure in 60o C water during the return course. In this way it is not necessary to use sawdust.
- As a result you get a cheaper and more effective scraping.

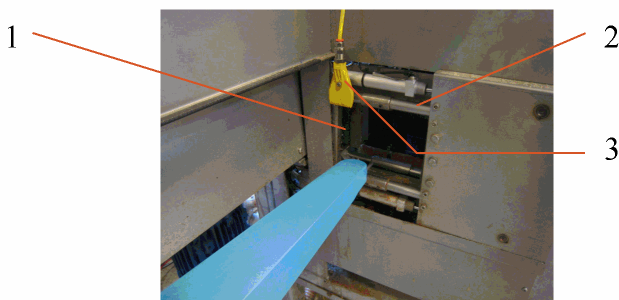
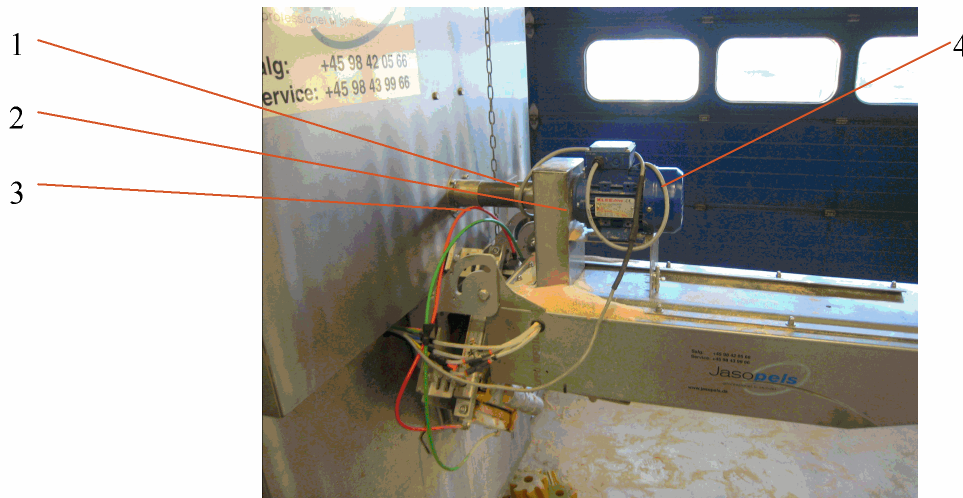


Fig. 37

Fig.Nr.	Jaso number	Spare part number	Name
	5911-5030021128		1/2" Magnetic valve with viton 240 VAC 0-18
	3272-00022430	02-2430	Horizontal scraper wash 2009 with green core
	3272-00022440	02-2440	Vertical scraper wash 2009 with green core
37.1	3272-00021214	02-1214	Beam scraper rubber vertical 128*55mm gold
37.2	3272-00021212	02-1212	Beam scraper rubber horizontal 65mm gold
	5290-23946004		1/2" Red.valve malg. 0,5-6 bar
	5290-23700104		1/2" Hose protection 1/2" Thread
	5290-23130104		1/2" T-piece
37.3	5290-23072715		WindJet ABS Plastic
	5290-23005002		Kynar VeeJet Nozzle BSPT

## **12.2 Sawdust conveyor**

- Conveyor for dosing sawdust before drumming the skin.



**Fig. 38**

Fig nr	Jaso number	Spare part number	Name
38.1	5110-00024856		Rubber hose O 50 * 165 mm
38.2	5110-00024852		Motor console
38.3	5110-00024860		Console to sawdust conveyor out of silo
38.4	5931-30018434		ST 63 C4 0,18 kW 1400 o/m B34
	5110-00024880		Conveyor to sawdust conveyor out of silo

## 12.3 Skin remover tower

- Adjustable mechanic skin remover, which assures that the skin is always delivered in the middle of the leather side drum together with sawdust.

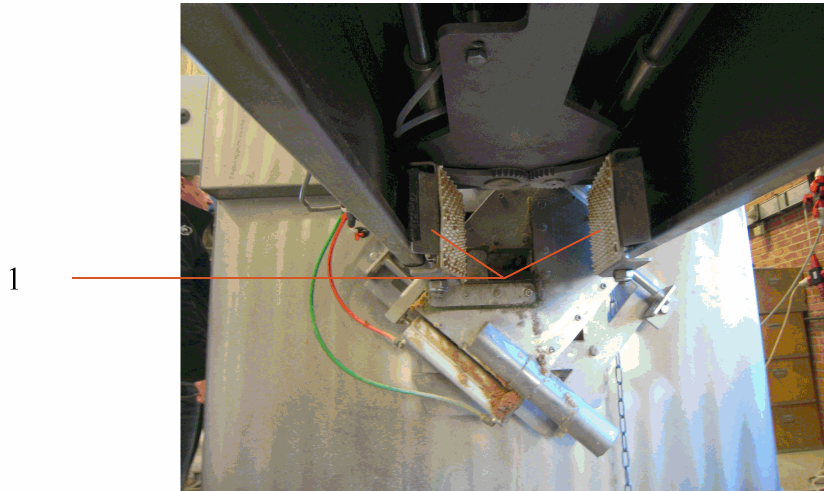


Fig. 39

Fig nr	Jaso number	Spare part number	Name
	5912-31332400	1130320400CP	Round O 32*400 AM M.Br. & M.Mag.
	5912-51125100		Round O 25*100 A M.Br. & U.Mag.
	5913-302134007	2L34007	Swivel elbow RL34-6-1/8
39.3			Holding rubber to Skin remover tower



## 12.4 Extra impellers

- Extra impellers are installed directly over the existing impellers. Thanks to them you dispose of difficult fat and flesh residues under forelegs.

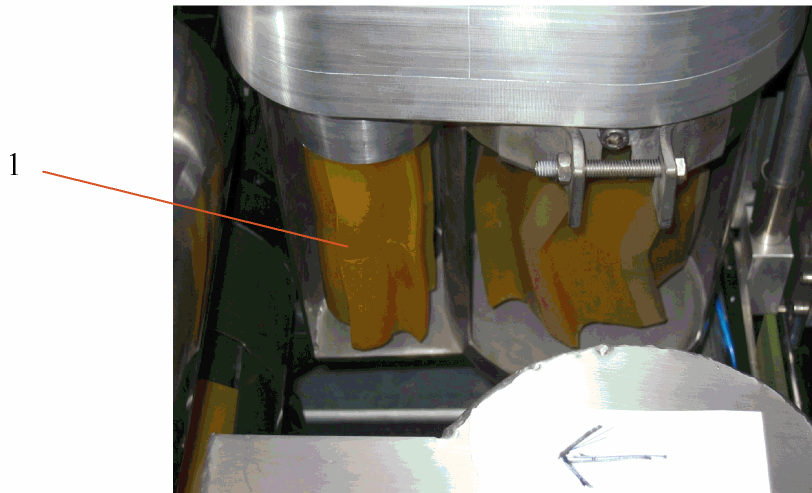


Fig. 40

Fig nr	Jaso number	Spare part number	Name
40.1	3272-00026479	03-6479	Impeller yellow, small, to foreleg 9 teeth
	3272-00026382	03-6481	Impeller green 155 mm 9 teeth

## 12.5 Extra fat scrape

- Extra fat scrape scrapes loose fat off, before the skin is taken off the beam. This assures better and more effective leather drumming.

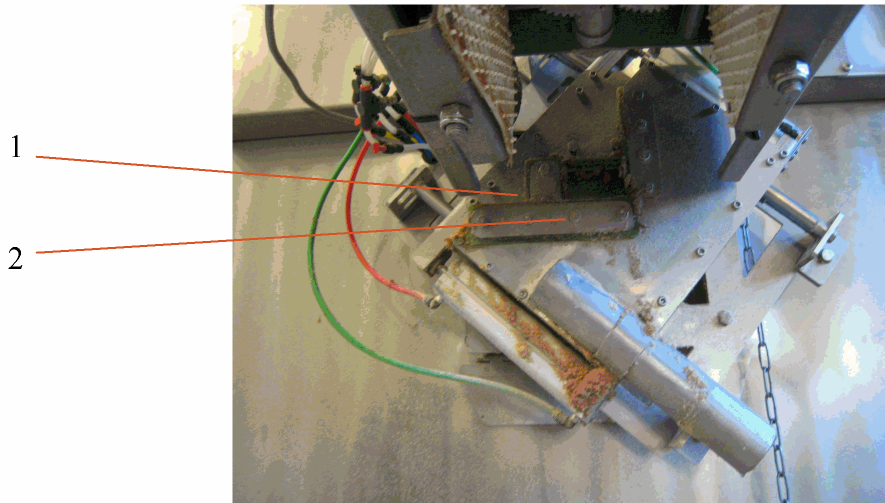


Fig. 41

Fig nr	Jaso number	Spare part number	Name
41.1	3272-00025944	02-5944	Fat scraper short with core 40*132
41.2	3272-00025949	02-5949	Fat scraper long with core 40*162

## 13. Trouble Shooting

This part describes how some known problems can be solved by the user. This is not as description of how the machine can be repaired but more an orientation about how to fix some minor problems. With problems the user cannot fix it is recommended to contact Jasopels' service department for further help.

### **DANGER!**

**Switch off the compressed air and the power supply before starting on any maintenance, cleaning or other service on the machine.**



### **13.1 The Functions Manual forward/back do not work**

For safety reasons the machine has been designed in such a way that when the "MAN/AUTO" button is switched to MAN, the "STOP" button has to be pressed before the buttons "MAN BACK" and "MAN FORWARD" are operational.

### **13.2 The Function "initial start" does not work**

If the fleshing machine has been stopped before the beam has returned to its original position it cannot be started again before the button "BEAM BACK" has been activated.

### **13.3 Loose Fat on the Leather**

If there still is a lot of fat on the leather after the skin has left the machine this can be sign of a malfunction of the skin scraper.

- Check whether the beam scraper rubber is intact.
- Check whether all metal springs on the scraper are all right.
- Check whether the four aluminium valves on the scraper can move freely. The screw that keeps the fleshing springs in place may be tightened so much that the aluminium valve cannot move.
- The skin scraper has to be centred so the beam is touched right in the middle.



### **13.4 Overload Error Fleshing Motor**

Overloading of a fleshing motor will usually be signalled by a picture of “Thermal error” (fig. 42) which will pop up on the screen. The machine, including the fat suction device will stop completely.



**Fig 42 Thermal error**

- Switch off the power at the main switch. (The piece and hour counters are reset.)
- Check in the PLC cabinet (cabinet no. 2) whether the black button is pressed in for all the 8 manually operated motor protectors. If one of them is jumped up because of the overload you can see on the indicator plate on the motor protectors, which motor it is.
- Open the sawdust machine, check if the fleshing motor in question rotates freely, if it runs slowly it has to be cleaned or replaced.
- Close the sawdust machine, press the black button on the motor protector and close the PLC cabinet.
- Connect to power at the main switch and press "BEAM HOME"
- Repeat the procedure as described in part 7.1.

### 13.5 Overload Error Beam Motor



Fig 43 VLT error

Overloading of the beam motor will as well be signalled by a picture “VLT error” (fig. 43) popping up. The machine will stop completely.

- Press the button “RESET VLT” on the VLT-cabinet, now the display will again show the speed of the beam.
- An overload of the beam motor can also result in an activation of the manually used motor protector QF6, placed in the VLT cabinet. In this case it is difficult to check whether the motor can move freely, since there is a right-angle gear mounted on the motor.
- Beam motor errors can be due to the fact that the chain has become too tight, maybe because there is sawdust in the chain guard, which may cling to the gear wheel, which thereby has become too big. It can also be due to the fact that the beam does not touch the skin scraper right in the middle but slides up one of the sides, which will result in increased friction.



Contact Jasopels' service department for advice and directions in order to fix this error.

- Press the button "BEAM BACK" on the VLT cabinet and the beam will return to its original position.
- Repeat the start-up procedure as described in part 7.1.

### **13.6 Overload of added Equipment**

Even motor faults on equipment connected through the CEE plug between the air cabinet and the sawdust machine (leather side drum, screw conveyor for return sawdust and so on) and maybe the fat suction machine can make the fleshing machine stop and picture “Error message fat pump” will show up (fig. 44)



**Fig 44 Error message fat pump**

- The fat suction machine is protected by a manually operated motor protection QF1, which is placed in the VLT cabinet. Check whether the motor protection is activated. Check always whether you can find the reason the heating up of the motor. Increased power usage can be due to the fact that the fat suction machine is running slowly because the impeller is covered with dirt or because of a leak in the piping between the suction nozzles and the fat suction machine.
- An overload of external equipment that is connected to the CEE plug can activate the manually operated motor protection QF7, which is placed in the VLT cabinet. Here you have to find the reason for the overload as well before the motor protection is switched on again.
- Press the button “BEAM BACK” on the VLT cabinet and the beam will return to its original position.
- Repeat the start-up procedure as described in part 7.1.



## 13. Personal Notes