

MI-65F hose skiving machine adopts flexible knife, which can run smoothly in irregular curved line along the surface of hose wire layer. It can max eliminate the uneven skiving caused by the eccentricity of wire layer, and avoid the damage to wire layers. The release bearing between rotating arm and core bar keeps the core bar free of rotating arm motion when external skiving, which is more safe and stable to operate. You can set main or vice knife for external skiving. The scaleplate can locate rapidly. Once the cover is open, the machine will close down and stop working automatically. All in all, this type of machine makes your work more security, pleasant and high efficient.

**Note:**

Don't operate the machine before reading the operation manual.

Don't touch the skiving blade when the machine is working!!



### Technical data

Types	MI-65F
Working range	1/4"~2"
Voltage	380V/50Hz
Speed	284r/min
Noise level	≤65dB
Volume	580×570×1120 mm <sup>3</sup>
Weight	64Kg

Diagram



1. Motor

2. Safe cover

3. Foot switch

## Instructions for use and maintenance

**Install**

1. Place the machine on the flat ground so that it can work stable and reliable

2. The input voltage is 380V 50HZ/3PH (A.C.)

The AC power cord:  $\geq 1^2 \times 3$  core per wire;

Switch: three phases  $\geq 5A$ .

Please ask the professional electrician to connect the wires and confirm the power source is accordance with the machine required And the machine body must be firmly grounded against accident.

3. After the first connection, please close the switch and check the rotation direction of blade carrier to keep it is in accordance with the direction on the rotating arm. Otherwise, change any two live wires to make the direction right.

**Operation points****External skiving**

1. Choose and install the suitable spindle according to the hose I.D.

2. Wear the locating ring onto the spindle and fix it to the right position according to the skiving length.

3. Adjusting the knives. The direction of knives sharp should be in accordance with the rotation direction of the blade carrier. Fix the knife as the point lean 18mm out of the inside surface of moving arm. Adjust the moving arm to make its scale the same as rotating arm (the hose can just touch the knife when putting on hose). Adjust the knife bolts according to the hose rubber thickness, keeping the skiving force approximating the external rubber thickness, then screw them down.

4. Close the safe cover. The machine is equipped with safe cover, machine won't run unless the cover is closed totally.

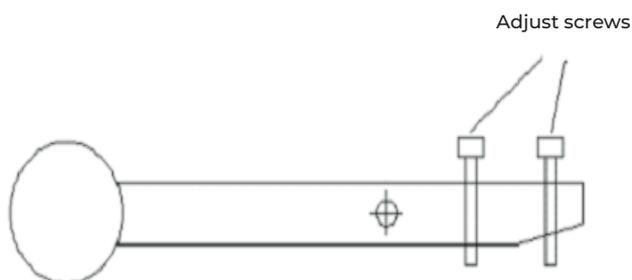
5. Wear the hose to the spindle against the locating ring, hold it both hands and step the pedal switch to skive.

6. Pull the hose out slowly.

**Operation details are as follows****Step one: Align the scale plate**

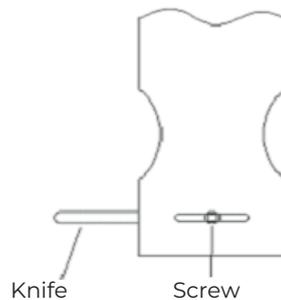
Loose the screws behind the rotating arm, align the scale line with the knobs and then screw them down.

**Step two:** push the adjust screws to the outermost tip, as shown blow.

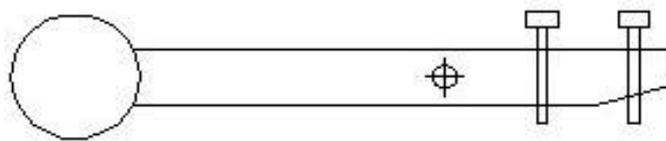


**Step three: Fix the knife**

1. Loose the screws of the knife.
2. Turn the hammer to max stroke by hand.
3. Pull the knife against the hose outer skin and screw down the bolt.



**Step four:** Screw the adjust screws clockwise according to the hose thickness , better to let the blade just against the wire of the hose.

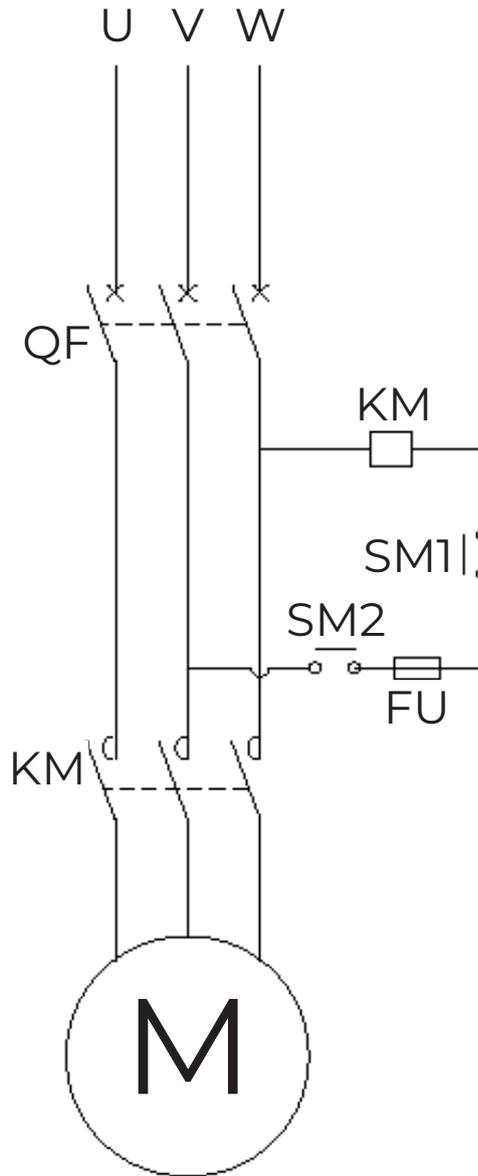
**Internal skiving**

1. Choose and install the suitable spindle according to the hose I.D., and fit the knife on the spindle.
2. Adjust the knife as per the hose wire layers, knife sharp does not touch the steel wire.
3. Wear the hose to spindle edge (do not touch the knife), and step the pedal switch to rotate the blade carrier, then push the hose to the suitable position with appropriate speed. Slacken your speed as the hose touches the knife, and keep pushing the hose at a steady rate when skiving.

**Maintenance**

1. The gear reducer together with the motor has been lubricated with oil WA460 , normally it can run for 400 hours. Check regularly for oil leakage and lubrication every 400 work hours , and fill in or change the oil in time.
2. Clear up the skiving waste in time, avoiding they twining to the blade carrier.
3. Check whether all the parts are normal or not , the bolts are loosen or not regularly, adjust or change them in time.

Circuit diagram



QF: miniature breaker

KM: AC contactor

FU: fuse

SM1: pedal switch

SM2: touch switch

M: gear reducer