

TGEE INTERNATIONAL B.V.

2300 3.0

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1 Preface

Read this user manual carefully before transporting, installing and using the machine.

This machine has been developed and manufactured according to the latest technologies. This means that the machine adheres to the applicable European Guidelines with regards to health and safety. The machine is CE-certified.

The manufacturer is not liable for any unsafe situations, accidents and damages that are the result of:

Ignoring warnings or regulations as depicted on the machine and/or described in this manual.

insufficient maintenance.

using the machine for other means other than stated

changes to the machine by third parties. This also covers installing replacement parts other than those described in the manual as well as changing the operation system.

This user manual contains relevant information for transport, installation, use, maintenance, repair, and dismantlement. These guidelines are to be closely followed.

2 Introduction

Manufacturer Information

Manufacturer:	TGEE International B.V. - Teus Gijsbertsen Embroidery Engineering
Address:	Zuiderlaan 2, Aalten
Postal Code:	7122 AC
Tel.:	+31(0)623877195
Fax.:	+31(0)543472360
Machine Name:	2300 3.0 Vliseline cutting machine
Build Year:	2022
Machine Number:	2300 3.0 xxx

Intended Machine Application

The 2300 3.0 is used for the continued, automatic cutting of Vliseline backings from big rolls

The allowed dimensions of the rolls are:

Max. width 900 mm

Max roll diameter 250 mm

Max 3 rolls running at the same time left, and 3 rolls running at the same time right.

The machine can only be used in the embroidery industry or an industry with similar applications (for example the sowing industry for automotives).

Other applications are not allowed.

Damages and injury caused by applications other than the above are the sole responsibility of the user.

Supplied Components of the 2300 3.0 Cuttingmachine for Vliseline

The 2300 3.0 is supplied with the following components:

base unit

1 set knives (50 pieces)

RVS pipe 3x with roll adaptors

3 Responsibility and Safety

Responsibilities

Read the manual carefully before transporting, installing, operating, maintaining or servicing the machine.

It is not allowed to adapt or change the machine without the manufacturer's permission. This manual contains vital information for an optimal and safe operating environment of the machine.

Installation, maintenance and other service activities may only be executed by authorized personnel.

The machine can only be operated by one person.

Safety Measures

Several safety measures have been implemented to guarantee safe and secure operation of the machine and to prevent getting stuck, wounded or any other form of danger.

Take care that the measures are applied before the main switch is activated and the machine is taken into production again.

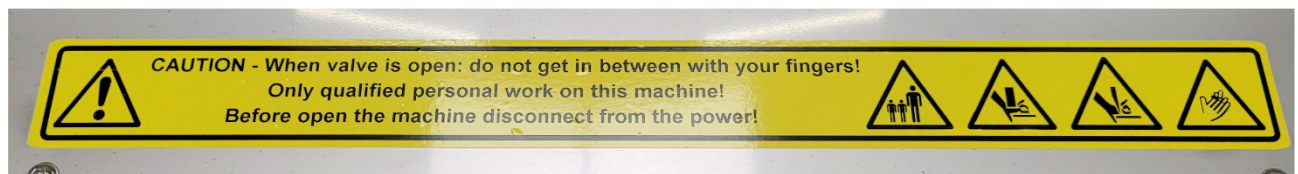
Several safety measures have been implemented on the machine:

Several pictograms, see paragraph 2.3 and 2.4.



Pictograms:

Indications of danger: Take care: danger of hands or fingers getting stuck.



Take care: danger of hands or fingers getting cut or stuck, and no kids near the machine

For safety, the linearwagon cannot run when the valve is open, But for safety always power off when working on or under the valve

Dangerous Zones

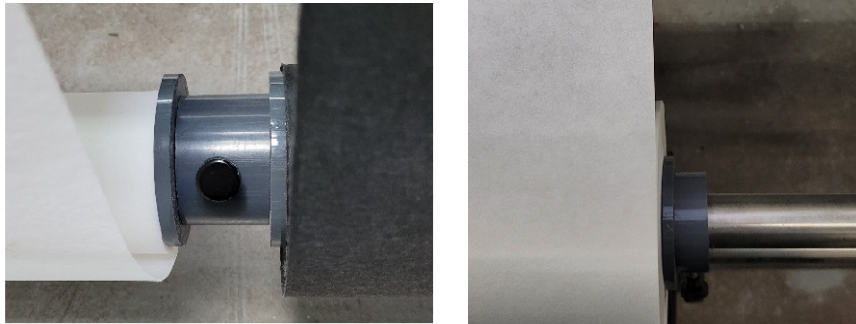


4 Instruction for Operation

Unpack the machine: the blades and roll adaptors are in a carton box.

The RVS pipe 3x is for the big vliseline rolls, they can put in to the machine with the adaptors and rolls of vliseline, as show on the picture below

The holes in the pipe L+R has to fix with the pins of the pipeholder



The adaptor with a screw L & R has to be tight the rolls, between the adaptor and cone create a space of 1 mm, so the rolls of vliseline will roll easy.



example

Note the direction of the rollers, as in the

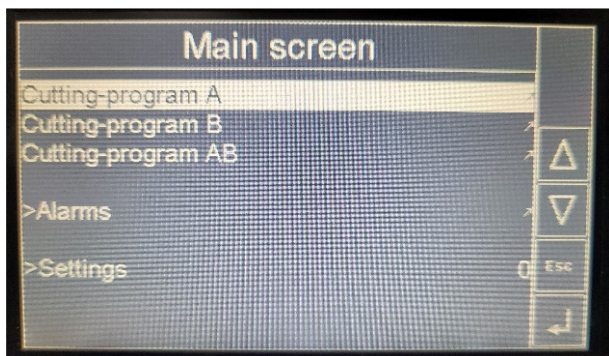


First turn the **master switch** button to **ON**, The machine will start up, please wait till machine is ready.

When ready you will see:



Touch screen



Choose Cutting A – enter (now only side A is working)

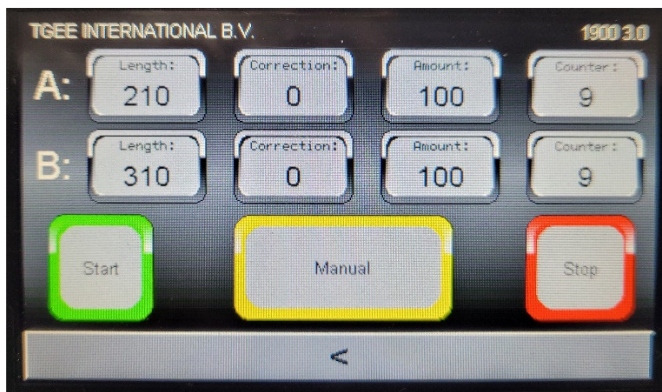
Choose Cutting B – enter (now only side B is working)

Choose Cutting AB – enter (now side A and B is working, and 2 different sizes possible)

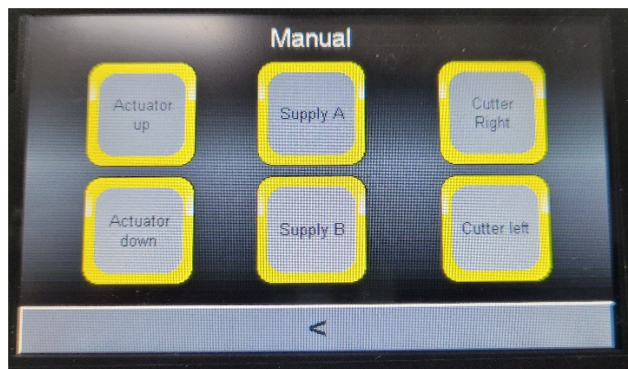
Alarms report errors when the machine is not running good.

Settings is password protected, and only for the technician of TGE Int. B.V.

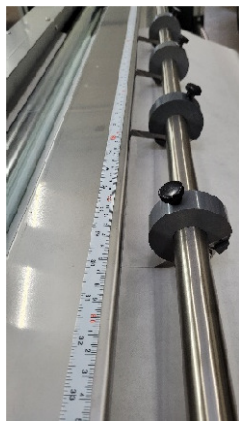
Choose Cutting AB – enter



Choose Manual (for accidental touch, hold down longer)



Starting the feed of the vliseline through the machine:



Turn up the knife out the Vliseline.



Push the vliseline to the rollers

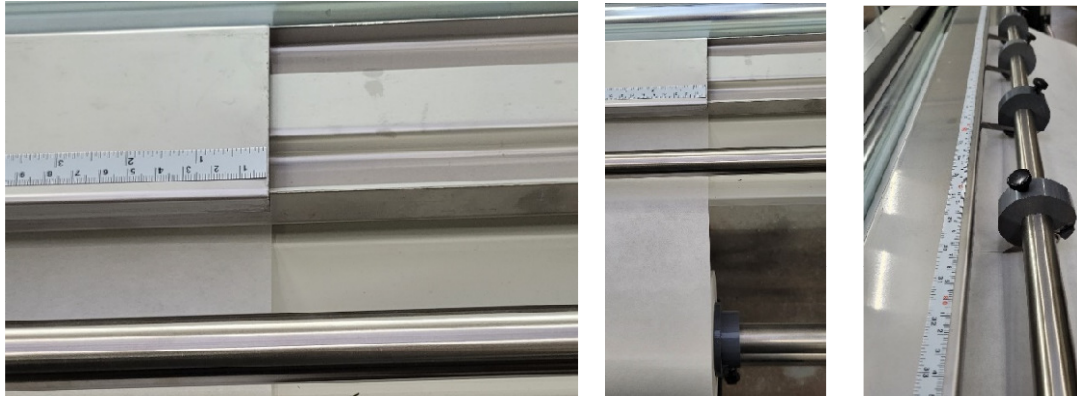
Choose **Actuator up**, the valve will open,

Press **Supply A** and the vliseline side A will go forward between the rollers and you see the vliseline in front of the machine.

Press **Supply B** and the vliseline side B will go forward between the rollers and you see the vliseline in front of the machine.

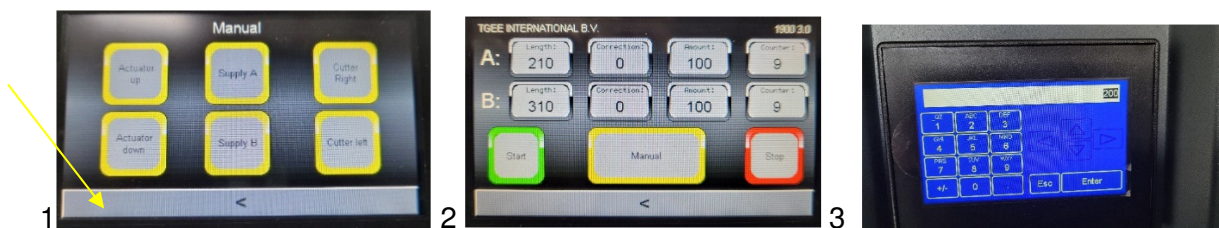
Choose **Actuator down**, the valve will close.

Now make a clean cut to start at zero: press **Cutting left** or **Cutting right** and the front knife will make a slide from side A to B or B to A.



Turn in the knives on the good measure size, make sure point zero is at the begin of the roll

4a Start the first cutting session:



1 Touch Back display,

2 Choose A **length** cutting, 3 Set length, Enter

2 Choose B **length** cutting, 3 Set length, Enter

2 Choose A **Amount**, 3 Set Amount, Enter

2 Choose B **Amount**, 3 Set Amount, Enter

If **Correction** is not 0: press **Correction** and set

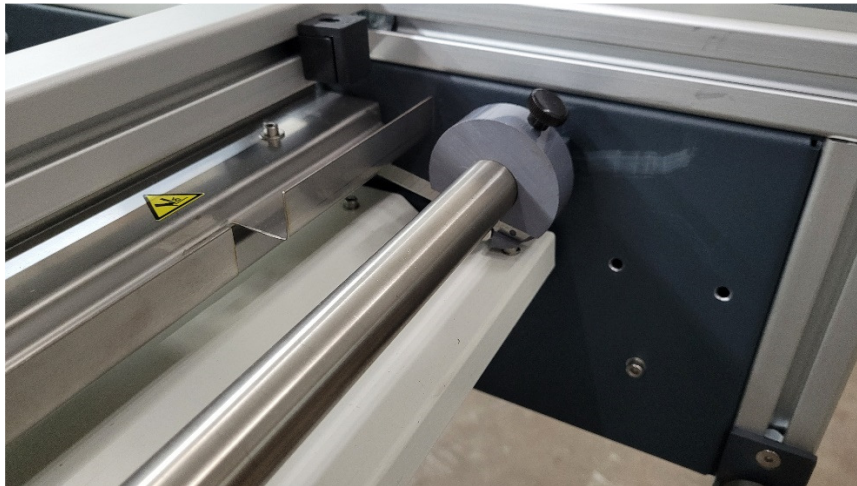
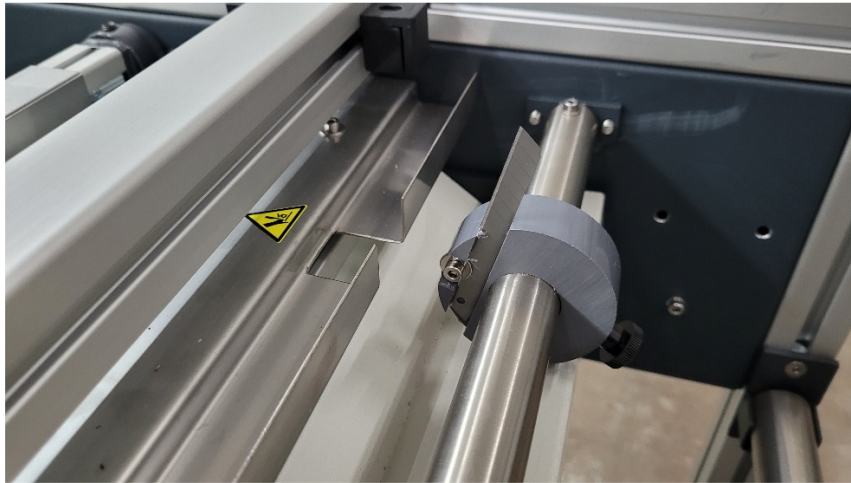
Correction to 0 - enter

4^e The machine is ready for use, press **Start** and the machine will start the series

5^e To stop a series earlier press **Stop**, and after the machine finishes the cutting the machine will stop

5 Changing knives

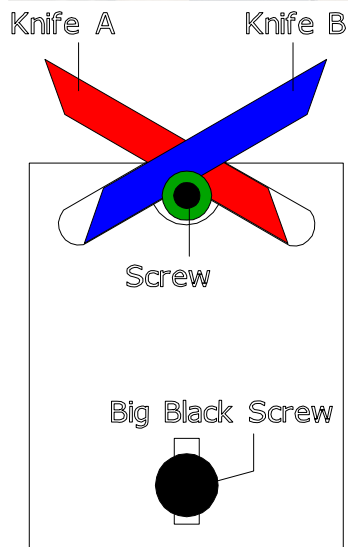
Changing the blades of width



There is a room L & R of the machine for changing the blades of width, easy turn in the space the blade up and there is a lot of space too changing, **beware of the sharp knives and not cut into fingers.**

Changing the blades of the length

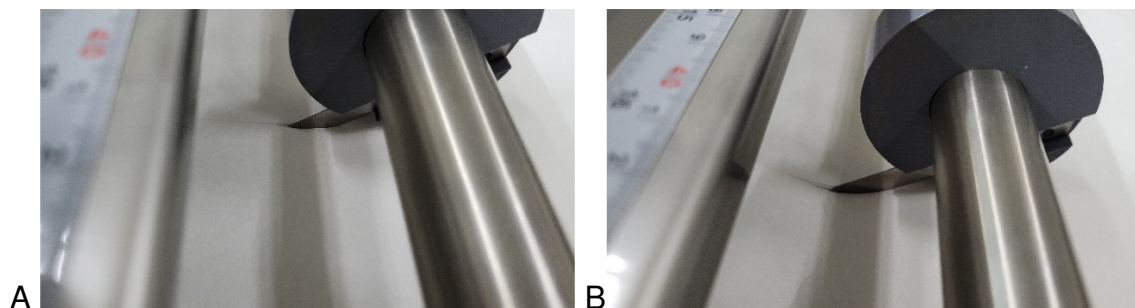
If you want to change the blades of the length cutting, go to the front and look down under the machine and look where is the knife-blok (L or R), then you see a big black screw, unscrew it and you can pull easy the blok down out of the machine, and can change the blades easy on a table without cutting in your hands, look for the space on to the grey plates: there is 1 way too put the blade good in the space of the plates, First knife A then knife B.



After changing set the blok back in the machine, and hold about 2á3 mm space between the blok and the profiles above it.

If the rolls are into the machine, the blades are sharp and in position; you can set the length and numbers of pieces on the display, see description above.

When a blade is blunt:



The width blades for the width are blunt if the vlieline goes down slightly to find a sharper cutting point, turn the blade over or change for a new one.

You can't see the blades for the length cut, but you can hear it: when 4 strips are cut and the blades are sharp you hear nothing, if the blades become blunt you hear with every transition to a new strip POK - POK – POK, when you hear that turn the blades or switch blades.

The lifetime of the knives depends on the type of material, some types are more difficult to cut, and ask more changes

The knives can be turned 1x at both positions, so use 2x before they are removed.

PS: The knives are Olfa snap-off knives, any other brand is also possible, but Olfa gives a good cutting result.

6 length adjustment

After the 1 or 2 first cuts you can stop the machine **Stop**, in order to measure the length, and if necessary, to correct.



As 200 mm is required, and get 220 mm measured go to **Correction** – enter, and specify the number of mm to 200 mm above so set -20 and enter, now the size go down 20mm

As 200 mm is required, and get 180 mm measured go to **Correction** – enter, and specify the number of mm to 200 mm below so set 20 and enter, now the size go up 20mm

7 Troubleshooting



When the viseline will stuck beneath the valve, **the valve is Electric and can not be open by hand,**

Turn the **main switch** the machine stop right now, **now you can get the length knives out for safety;**

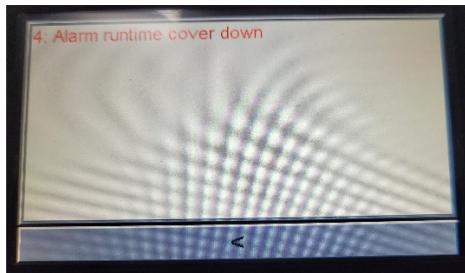
1 First turn on the **main switch**, 2 Push Cutting AB- enter, 3 press **Manual** , 4 press Actuator Up and clean all the Viseline, press Actuator down, the knife block can be put back in the machine and the machine is ready for new Viseline, start see **point 4a**



When the vliseline is too much to the front and it has to be a bit backward: press first **Rewind** button (button will light white up) and then **Supply A** or **Supply BA**, the vliseline will go back, it will stop when you stop press **Supply**.

For forward again press **Rewind** (button will light out), when you press **Supply** and the Vliseline will go forward.

ALARMS



When the machine stops and on the Display you see a Alarm message:

See what it says, it can be the Valve did not close or open correct, or the sensor missed some pulse, or the lineairwagon is stuck and did not move on time.



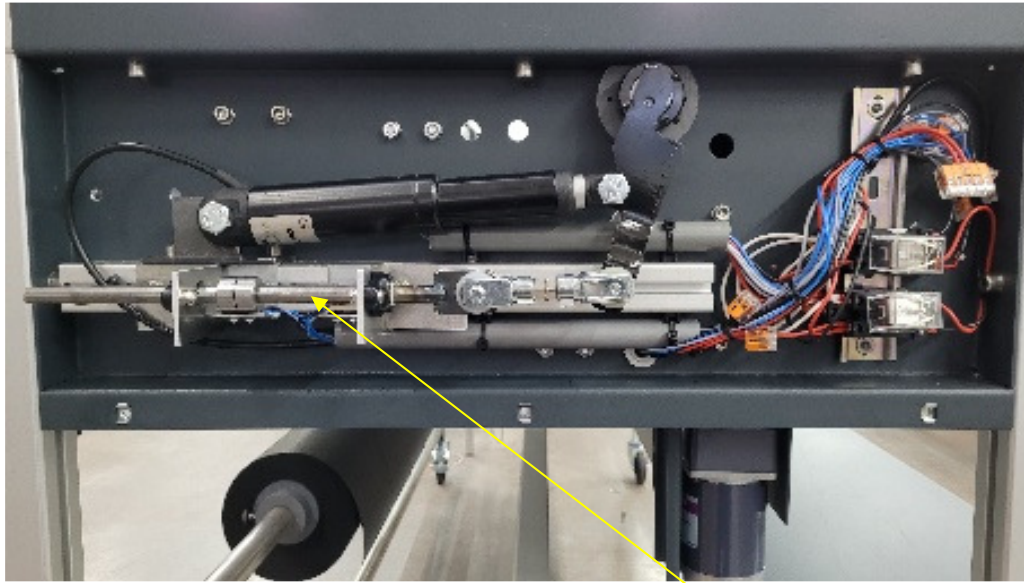
First fix the trouble, if possible or otherwise call TCEE Int bv, then press Reset, now continue with the cutting

On the screen you can see how many pieces the machine will cut, and how many are already finished, + the length of the pieces.

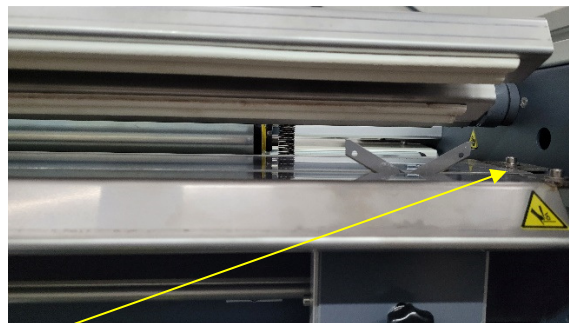
When the end of the day the machine has to stop, press the F4 key, after the machine finishes the cutting the machine was busy with, the machine stops, now turn off the main-switch.

This is a short note how to work with the machine.

8 Maintenance



The slide shaft need sometimes a little oil spray



Keep the linear carriage space clean, remove loose pieces of viseline and dust by hand or airpressure.

9 Technical Data

1.1 Electrical

Power supply: Input 100-240V 1.5A 50-60Hz.

1.2 Mechanical

Mass	: 450 kg
Base dimensions (lxbxh)	: ca 2700x800x980 mm
Max. height	: ca 980 mm

10 EG – Declaration of Conformity TGEE International B.V.

Appendix A

EG-DECLARATION OF CONFORMITY FOR MACHINES (Conform Appendix II, sub A of Guideline 2006/42/EG)

Manufacturer : TGEE - Teus Gijsbertsen Embroidery Engineering
International BV

Adres : Zuiderlaan 2
7122 AC Aalten

hereby declares that:

Machine type : TGEE 2300 3.0 Cutting machine for Vliseline
Machine number : 23003.0 xxx

adheres to the terms of the Machine guideline (Guideline 2006/42/EG, as in its latest version) and the national laws regarding the execution of this guideline;

adheres to the terms of the following other EG-guide lines:

Low voltage and EMC. Guide line

and that

- the following (parts of) harmonized norms are applied:

EN 292-1, EN 292-2, EN 294, EN 60204-1, and EN 50065-1

- the following (parts of) national technical norms and specifications are used:

n/a

Signed at: Aalten Holland , ____ - ____ 20__

Dhr. T.J. Gijsbertsen

If there are questions about somethings of the machine don't hasitate to E-mail
t.gijsbertsen@tgee.eu or call 0031623877195

Best regards Teus Gijsbertsen