

# MT series decoiler

## INSTRUCTIONS MANUAL





## **PREFACE**

To our valued customer:

Hello! Welcome to use Lihao's MT series decoiler!

In the development process, Lihao Machine always adheres to the business philosophy of "quality first, service first". Lihao Machine has passed ISO90000:2000 quality system certification and EU CE certification. It strictly implements standardized production, manufacturing processes and strict testing procedures in the production process, maximizing and guaranteeing product quality and reaching international standards.

Based on years of customer feedback and our service experience, proper use and timely maintenance enable the machine to perform its optimum performance and maintain its original accuracy and vitality. To this end, we hope that this instruction manual will help you make the most of the functions of this device.

If you have any questions during reading this instruction manual or using the device, please send email to our service email: [\*\*export@lihaomachine.com\*\*](mailto:export@lihaomachine.com)

**Thank you for purchasing Lihao Machine**

**In order to use the equipment you purchased correctly, please read this manual carefully before use. Please be sure to submit this instruction manual to the actual user of the device.**

**SHENZHEN LIHAO MACHINE EQUIPMENT CO., LTD.**

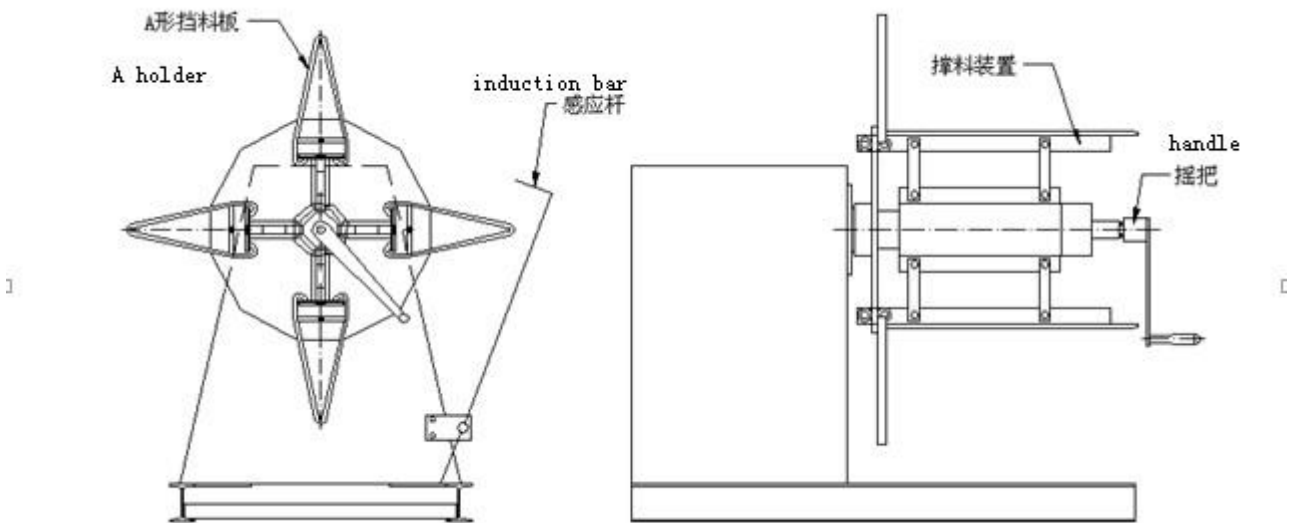


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## 1. Structure

- (1) This decoiler is welded by solid steel plate to construct the whole body.
- (2) Adopting long distance fulcrum, so can sustain heavy weight.
- (3) Adopting changeable diameter decoiler equipment so that can load material conveniently, decrease the speed by worm wheel and worm, so that can run placidly.
- (4) Adopting induction brake and control the brake time to get smooth for feeding material.



## 2. Configuration

Model		MT-100	MT-200	MT-300	MT-400	MT-500	MT-600	MT-800
Max Width	mm	100	200	300	400	500	600	800
Thick	mm	0.35-1.6						
Coil I.D	mm	200-300	350-530	450-530	450-530	450-530	450-530	450-530
Coil O.D	mm	1000	1200	1200	1200	1200	1200	1200
Material Weight	kg	200	500	800	1000	1500	2000	2000

## 3. Installation

- (1) Put the machines in right places, make sure that the material plane center and the feeder roller center and stamping die standing into a straight line, otherwise some feeding error may be existed.
- (2) Connect 380V three-phase electrical source, (electrical control box have circuit diagram), check the running direction, material should be feed upwards, material is plumb to induction pole.
- (3) Adjusting feeding distance, when decoiler center height is parallel with punch machine

working surface, keep 4 meters-4.5 meters from feeding equipment feeding orifice, when decoiler and punch machine working surface are too high or too low, extend feeding distance, and adjust material feed out direction.

(4) Shake the shaking-bar anticlockwise, decrease the diameter of uncoil, install a piece of material controlling bar on the two pieces of opposite decoiler plates (A type bar) each, then load coil material, and then install a piece of material control bar on the other two decoiler plates each. Pay attention to that, material control bars can not grip coil material tight, should remain a little spacing. Shake the shake bar deasil to load coil material tight.

(5) Time control is brake time control, base on product request, adjust feeding speed, adjust the height of induction pole, to control feeding length suitably.

(6) After the above steps were finished, please send the coil in by hand to ensure the coil is moving rightly, then you can press the automatic push-button.

#### **4. Maintaining**

(1) When long time use, must oil butter onto the principal axletree per month, change for new speed reducing machine oil per half year, oil to place of third of capacity.

(2) The wire connection point in electrical control box must not become slack, otherwise may burn electrical equipment.

(3) When long time use, must check axletree stand, check screw if they are slack.

(4) If long time no use, must add butter onto the principal axis, and check electrical control box.

#### **5. Attention**

(1) Before connect to electrical source, firstly should check if electrical source is suitable or not, check if there is any bad connection, otherwise may damage electrical equipment.

(2) Should connect to land, to avoid hurting people when electrical equipment is damaged.

(3) When coil material is in decoiler, should take away the shake bar, to avoid hurting people when running.

(4) Switch electrical source off when load material. After switch on it, there must not be people stand around the material sustain plates.





# Certificate of inspection

**Product type:** \_\_\_\_\_

**Product code:** \_\_\_\_\_

**The product is qualified in accordance with the  
technical standards of the product.**

**Permission to leave the factory**

**Examination clerk:**

**Date:**



# Warranty card

<b>User name</b>		<b>Factory number</b>	
<b>Production type</b>		<b>Date of production</b>	
<b>Date of purchase</b>		<b>Invoice number</b>	

## Instructions for warranty

Thank you for using Lihao stamping peripheral equipment ,in order to ensure the interests of users,our company sincerely promises to provide you with the following services with this warranty card.

1. Lihao servo feeder is guaranteed for one year from the date of purchase.
2. The machine can be repaired free of charge within the stipulated warranty period for any faults that occur in manufacturing problems.
3. The following conditions do not belong to the scope of free maintenance,but can be implemented by fee-based maintenance,life-long service.

1) Don't show the warranty card or the warranty card without the company's seal confirmation.

2) Faults caused by accidental factors or user failure to operate according to random instructions.

3) Fill in the warranty card that the products does not conform to or be altered with the repaired product.

4) Over the stipulated warranty period,the repairs will continue.

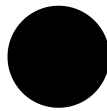
**Seal:**

**Service email: [export@lihaomachine.com](mailto:export@lihaomachine.com)**

**Please keep this card properly.**



**力豪机械**  
LIHAOMACHINE



中国 . 深圳 . 力豪机械设备有限公司  
CHINA SHENZHEN LIHAO MACHINE EQUIPMENT CO. LTD.

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Add:NO.25, ShaPo Road, BiLing Village, PingShan, ShenZhen

Tel:0755-89230087

WEB:www.lihaomachine.com