

2013



# SEBAT MAKINA

METAL ACCESSORY  
RIVETING MACHINE

## USER'S GUIDE

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## 1. Manufacturer, Supplier and Service Contacts

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## 2. CE Sign

 <p><b>MEHMET LATİF KADIOĞLU</b> <b>SEBAT MAKİNA</b> <b>TEKSTİL SAN. TİC. ŞTİ.</b></p> <p><b>ADDRESS:</b> İKİTELLİ ORG. SAN. BÖLGESİ ESKOOP SANAYİ SİTESİ C3 BLOK NO:106-108 İSTANBUL / TÜRKİYE <b>PHONE:</b> 0212 671 22 66 – 67 <b>FAX:</b> 0212 549 02 37</p>				
<b>OTOMATİK AKSESUAR ÇAKMA MAKİNESİ</b> <i>AUTOMATIC ACCESSORY RIVETING MACHINE</i>				
<b>ÜRETİM TARİHİ</b> <i>PRODUCT YEAR AND MONTH</i>	<b>SERİ NO.</b> <i>SERIAL NUMBER</i>	<b>MOTOR GÜCÜ</b> <i>MOTOR POWER</i>	<b>VOLTAJ</b> <i>VOLTAGE</i>	<b>MAKİNE KODU</b> <i>TYPE OF THE MACHINE</i>
20.../....	.....	0.37 kW	380 V	SBT .....

### 3. Product Traceability Sign (Serial No, Model-Type No etc.)

Automatic Metal Accessory Riveting Machine Submodels

**SBT-102**      AUTOMATIC 14-17mm BUTTON RIVETING MACHINE

**SBT-202**      TRIPLE AUTOMATIC RIVET NAILING MACHINE

**SBT-300 M/Y**      AUTOMATIC MODEL TEAM (MALE AND FEMALE) 54&61 SNAP RIVETING  
MACHINE

**SBT-303 M/Y**      AUTOMATIC TEAM (MALE AND FEMALE) BABY SNAP RIVETING MACHINE

**SBT-303**      TRIPLE AUTOMATIC SNAP RIVETING MACHINE

**SBT-401**      AUTOMATIC EYELET NAILING MACHINE

Date of Manufacture:

Model / Type Name:

Model / Type No:

Electrical Values: 0.37 kW motor, 380V triphase electrical systems

## 4. Technical Information about the Machine

### GENERAL FEATURES

- Full automatic
- Electronic equipped
- 380V triphase 24-volt outlet
- 220 single-phase (optional)
- Electronic hand protection (optional)
- Mechanical hand protection (optional)
- Electronic counter (optional)
- 0.37 kW electrical motor with 1400 rpm
- % 1/7 gear box, 200 series of hits per minute
- Magnetic brake
- Start stop magnetic switch
- Programmed Electronic card
- Indicator lights
- 1.5 kW power current pull
- Laser
- 1000 kg of pressure force
- Air system, automatic lubrication and cleaning
- Steel beds and dies
- Automatically thickness pressure setting for fabric
- 24-hour duty cycle
- Hard chrome plating on metal surfaces
- Powder coating against moisture and shock
- Dimensions: 52 x 54 x 132 cm
- Weight: 80 K

## 5. Considerations Instructions (General Safety Rules)

- The machine is not suitable for home usage
- When you want to throw away the product or scrap it, please contact authorized service to learn the necessary information and where to get advice.
- For any questions or problems about the machine please consult authorized service. Without the knowledge of the authorized service please do not interfere and do not make intervention to the machine except for the adjustments given in the user's guide.
- This machine should not be left plugged in when not used. After use or while cleaning the machine, always turn off the machine from on/off button or remove the plug from the electrical outlet.
- Before turning on the machine, make sure that the voltage of the electrical outlet matches the voltage recommended.
- This machine must be used only for the purposes specified in this User's Guide. Only use recommended equipment for the machine.
- While making an operation on the machine such as changing the pressure adjustment, placing new accessories or removing the accessories, always turn off the machine from on/off button or remove the plug from the electrical outlet.
- Before removing the covers, doing lubrication or making any adjustment specified in this User's Guide, always turn off the machine from on/off button or remove the plug from the electrical outlet.
- Electrical equipment repairs must be performed by qualified people only. Unconscious repairs can be dangerous for the user.
- The machine should not be used by children or weak people when not checked

## 6. Transportation and Installation

- The machine can easily be transported with the help of a wheelbarrow.
- At least 2 people are required during loading and unloading process
- Do not incline the machine more than 15 degrees during transportation.



- The machine should be placed to the transportation vehicle as such the rear part of the machine (where the motor exists) comes to the ground.
- If a chain hoist crane is available then the machine can be moved with straps that strong enough by holding the body part of the machine.
- 380V voltage is needed where the machine runs.
- An air compressor is required in a smaller size by the purpose of lubrication and cleaning of the machine, where it runs

## 7. Accessories and Spare Parts

Machine is delivered to the user together with spare parts and accessories listed below:

- 1 piece 3mm Allen wrench
- 1 piece 4mm Allen wrench
- 1 piece 5mm Allen wrench
- 1 piece 6mm Allen wrench
- 1 piece tank channel ( this amount can change with the machine type and the diversity of the accessories)
- 1 piece upper jaw(Optional)
- 1 piece upper mold(Optional)
- 1 piece lower mold(Optional)

## 8. Ground Information and Control

When the machine is set up, it is needed to choose the ground, where the machine is placed, well. The ground should be flat in order to prevent the quaking and rocking of the machine. It should be observed whether the machine is quaking or not, during it runs. If so, the machine's location should be changed, it should be supported as preventing the shaking or it should be fixed by adjusting the feet of it.



## 9. Installing and Using the Machine

### 1. Check the machine.

After unpacking the machine, check for any transport failure or damage.

### 2. Connect the machine to a compressor.

An air system exists on the machine in order to lubricate the machine parts and remove the small dirt, debt and debris away from it. For this purpose a small scale air connection should be made with the help of a compressor. Ensure that min. 4 bar pressure is available on the gage after the connection is made.



### 3. Plug in the machine.

Machine works with 380V and triphase power system is available. So it is needed a four-port power socket. If not, it should be provided firstly.



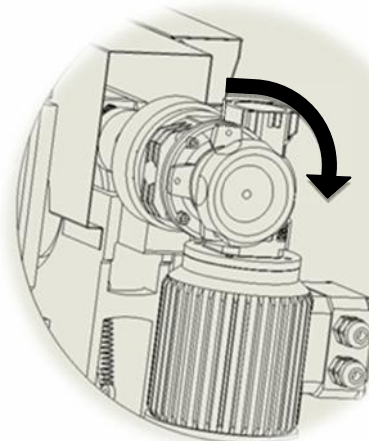
### 4. Turn on the machine.

To turn on the machine, turn the on-off button to the right from position 0 to 1. Red light will go on under of it when it comes to position 1. If not, the electrical connection may not have been correctly or there may be a problem with the electrical components. Control the electrical connection and try again.



### 5. Check the direction of motor rotation

Make sure there is no material in the reservoirs and run the machine by pressing the pedal once. Observe the direction of rotation of the motor. You can go to step 6, if the direction is as shown in the figure. If it runs in the opposite direction the ends of the plug needs to be changed.



## 6. Pour the suitable materials to the appropriate reservoirs

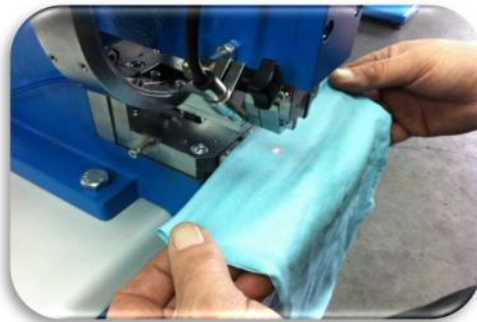
The reservoirs where the materials poured to and the accessories varies according to the model of the machine. Pour the the materials to the appropriate reservoirs as they don't exceed the half of the reservoirs. (Materials placed in the wrong chamber, could cause a damage on the working parts. In such a case, please do not operate the machine and empty the reservoir.



## 7. Close the reservoir covers, Check for the rotation of the diffuser and now ready to use the machine..

After pouring the materials, check for the diffusers move freely. The diffusers can be rotated until the channels are full. If it does not rotate, wrong material may be poured in or a material may stuck in the cover or dust, dirt, debris may be entered to the diffusers. In such a case, please do not operate the machine and empty the reservoir.

After that, place the fabric between two jaws of the machine and start to work on the machine by just pressing the pedal.



## 10. Removing the materials, Putting new materials in and Settings

### 1. Switch off the machine.

Turn the on-off button to the left from position 1 to 0 (closed position)



### 2. Open the channels.

Open the channel from whom the material will be removed, with the help of an allen wrench by putting it to the bolt fully.



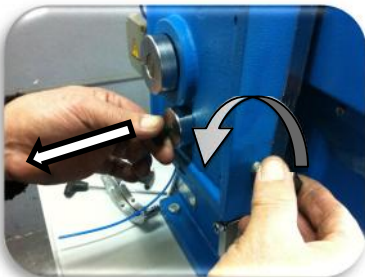
### 3. Remove materials from channels

Remove the channel from its bed and empty the materials in it.



### 4. Open the stopper of the reservoir.

Pull out the stopper by turning the bolt in front of the reservoir and empty the materials from the reservoir.



### 5. Make sure you have removed all the material from the reservoir.

After removing the materials, turn the diffusers a lot and enter some air to the reservoir to ensure that there is no material in it.



### 6. Replace the stopper.

While replacing the stopper, place it to the direction that the bolt match and tighten, by turning it to the right.



### 7. Replace the channel.

Pay attention that the channel is placed to its groove well. The channel that is not fully seated causes the materials not to flow correctly.



### 8. Put the new materials in.

After connecting again the channel with the help of an allen key, put the new materials in the reservoir.



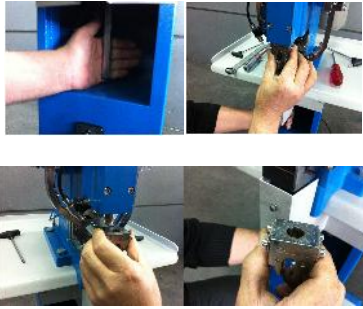
### 9. Do the same operations for the other material.

If you also need to change other materials in the other reservoir, repeat the steps 1-8 for it.



### 9. Pull the upper jaw down.

Pull down the upper jaw after pulling the bottom lever to yourself

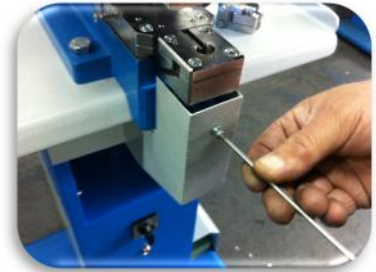


### 10. Change the upper mold.

Again with the help of an allen wrench, open the bolt attached to the mold, remove the mold, place the new mold suitable for the new material and tighten the screw.

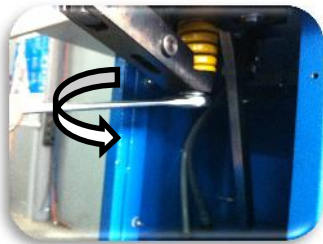
### 11. Remove the cover of the lower jaw.

Remove the cover by opening the bolts at the middle and two sides.



### 12. Tighten the bottom bolt.

Tighten the screw under the impact mechanism with the help of the appropriate wrench.



### 13. Remove the part that hold the mold.

First remove the circlip that hold the mold and then displace the mold itself.



### 14. Change the bottom mold.

Remove the mold after the mold is free and replace it with a new one that suitable for the new material.



### 15. Refit all the parts.

Replace the removed parts in the same way. Open the lower screw by turning it in the opposite direction to and close the cover.

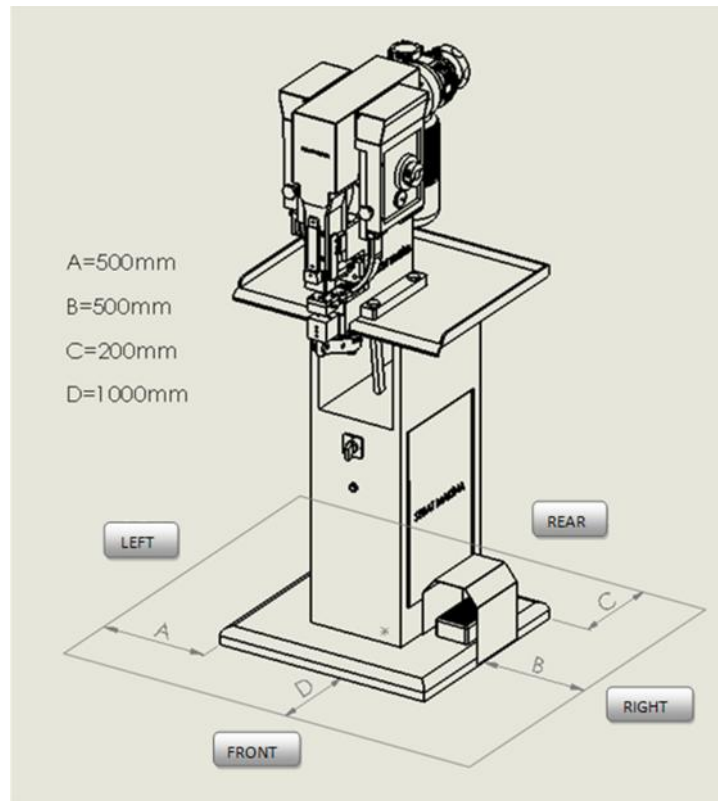


### 16. Put the new materials in and you are ready to work.

Now the machine is set for new materials. You can begin to work with machine by pouring the new materials to the reservoir.



## 11. Operator Working Positions



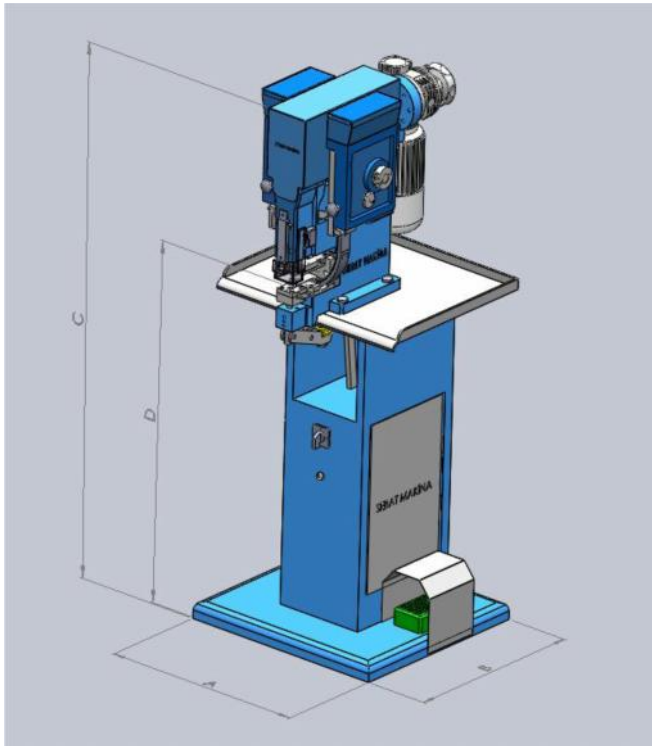
- In normal operation, the operator is located in front of the machine.
- The operator should operate the machine by sitting in front of it.
- The operator can easily sit a chair in front of the machine. So, there should be enough space to fit a chair
- As described in the picture above, the machine should be placed somewhere that has enough space.
- Sufficient space must be provided between the machine and the operator.



## 12. Noise Declaration and Dimensions

Acoustic radiation pressure level of the machine is measured from 1m distance and 1.6m height as 80.1 dB.

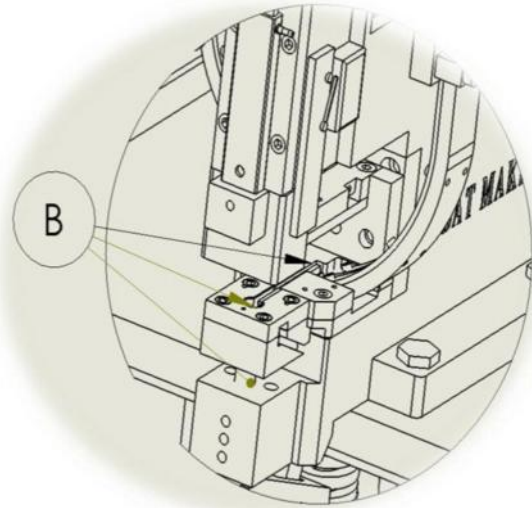
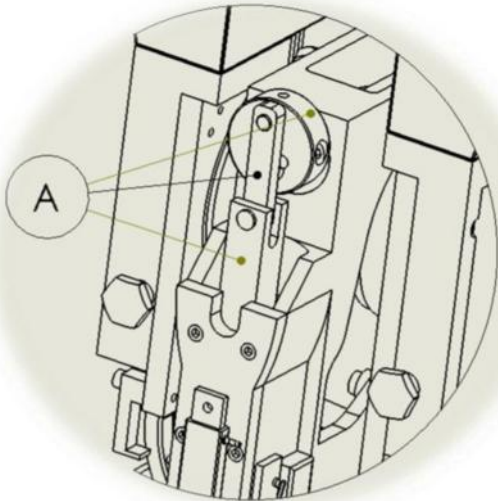
In addition, the overall dimensions of the machine are as follows:



General Measurements AxBxC	500x470x1276 mm
Working surface height (D)	856 mm
Working Speed	200 rpm
Electric Motor Power	0.37 kW
Weight	80 kg
Voltage	380 V

### 13. Maintenance, Repair, Lubrication and Cleaning Information

- The machine must be lubricated depending on how much it is used and where it is stored. Lubricating the machine once in every 3 months is sufficient if it is used a few times a month. If you use it frequently, you should lubricate it at least once a week. Necessary lubrication points are shown in the picture below. The places shown as "A" and "B" should be lubricated with grease and light machine oil respectively.



- The machine should be cleaned at the end of the day and left accessories, fabric pieces, dust and dirt should be removed from the machine.

## 14. Possible Malfunctions and Troubleshooting

PROBLEM	PROBABLE CAUSE	SOLUTION
<p>The machine is plugged in and the power is switched on, the machine not operating when I press the pedal.</p>	<ul style="list-style-type: none"> <li>➤ The motor may not be come to the axis.</li> <li>➤ Break sensor may work imprecisely.</li> </ul>	<p>Switch off the machine and turn the axis of the motor a lot. When you turn on the machine, it will start to work. If not please call for service.</p>
<p>While the diffusers are turning, rubbing or retention occurs.</p>	<ul style="list-style-type: none"> <li>➤ Suitable material may not be selected.</li> <li>➤ It can be inappropriate cover, crushed or damaged material in the reservoirs.</li> <li>➤ One or more stoppers can be inserted to their groove incompletely or wrongly.</li> </ul>	<p>Empty the reservoirs by pulling out the stoppers as explained in the user manual. After, replace the stoppers. Check the material you will use. If there are crushed or damaged materials, comb them out. If the problem persists, call for service</p>
<p>There is a problem with material flows in the channel. The material does not flow channel well.</p>	<ul style="list-style-type: none"> <li>➤ Corrupted material may come to the channel</li> <li>➤ Wrong channel may be installed.</li> <li>➤ The channel may be installed improperly.</li> </ul>	<p>Remove the channel and empty it. If there is any damaged material in the channel, comb it out. If the problem persists, call for service.  <b>Attention:</b> Avoid destroying the channels with a screwdriver, file and so on. Our company is not responsible for products damaged in this way.</p>



<p>When I press the pedal, the machine suddenly stops.</p>	<p>➤ The motor of the machine may be turning in the opposite direction.</p>	<p>Turn off the machine and remove the plug. Open the plug. You will see four wires coming to the plug. The middle wire is ground and the other three are phases. The problem will be solved when the two of the three wires are changed.</p>