



**USE AND
MAINTENANCE MANUAL**

**MANUAL FINGER
CUTTING
MLT-F120**



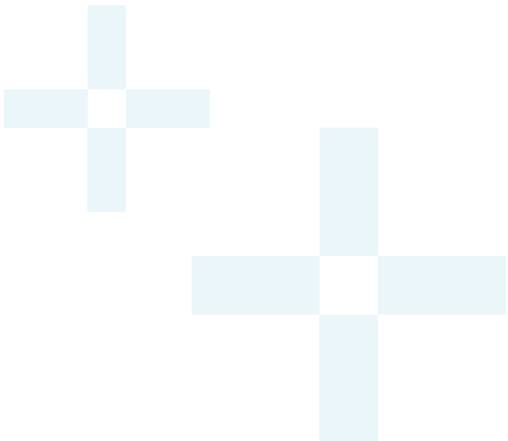
MLT GROUP
Conveyor Solutions Expert

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IMPORTANT

Read this user manual and follow the instructions and warnings before operating this device.
Any modification or transformation performed on this machine may cause the loss of the manufacturer’s guarantee and liability.
This manual must always remain near the machine and visible to all operating and maintenance staff in the event that future consultation is necessary.



«CE» DECLARATION OF CONFORMITY

We, the undersigned,

MLT ZI du Clos Marquet - Rue Michel Rondet - CS 70059 -
42 200 Saint-Chamond, France

The person(s) empowered to carry out the technical documentation :

- **Gilles FURNON** : product manager, MLT

We declare, under our responsibility, notwithstanding higher authorized criteria, that the machine:

| | |
|---------------------|-------|
| Model : | F 120 |
| Serial number : | 71103 |
| Manufacturer date : | 2018 |

Is in conformance with :

- Design and construction specifications of the European Standards on General Machine Safety: 2006/42/CE
- To the following directives / and or standards :
 - o EN ISO 12100-1
 - o EN ISO 12100-2
 - o EN 60204-1
 - o EN ISO 13250
 - o EN ISO 13857
 - o EN ISO 14121-1

A SAINT-CHAMOND,
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What is the manual finger cutting MLT-F120?



Description

Portable die cutter to cut conveyor belts in a zigzag pattern, featuring exchangeable cutting heads for different cutting geometries.

Support bench with material positioning guides.

This die cutter is especially designed to operate onsite for cut thermoplastic materials with interior tissue.

The head is removable to reduce the weight during the transport.



Technical characteristics:

| | FRAME |
|----------------|--------------------------------|
| Dimensions | 481 × 402 × 370 mm (l × w × h) |
| Weight | 12.4 Kg |
| Max. Thickness | 8 mm |

| | HEAD |
|------------|-----------------------------|
| Dimensions | 245 x 205 x 440 (l x w x h) |
| Weight | 30,6 Kg |

Operating Instructions

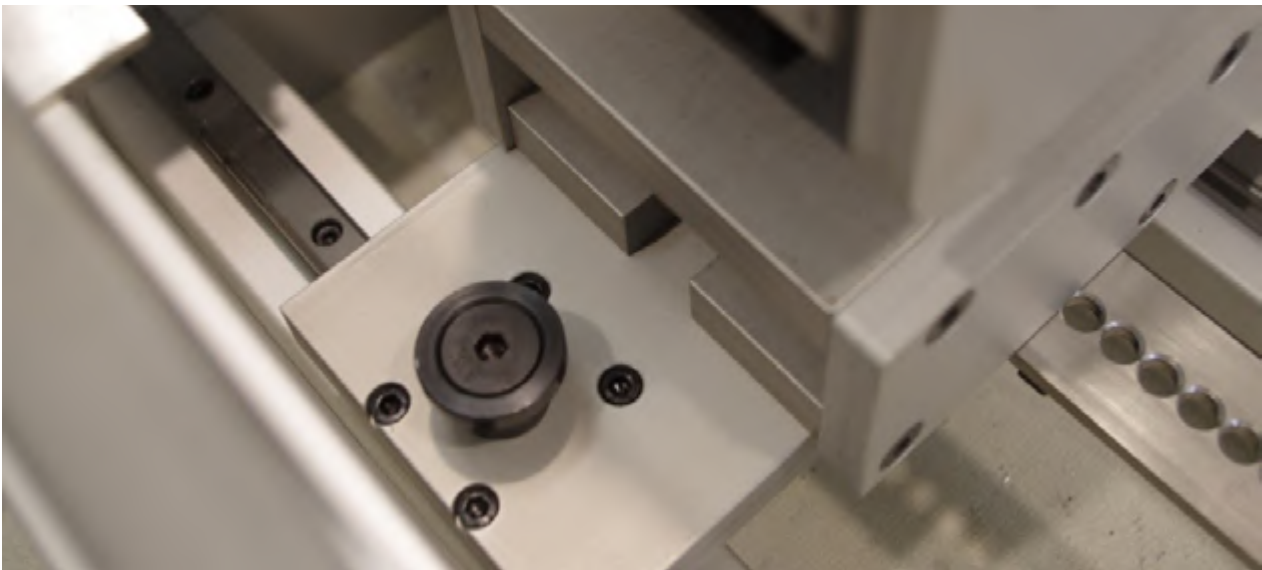
WARNING

THIS DEVICE INVOLVES THE HAZARD OF HANDS AND ARMS BEING TRAPPED BY THE MOVEMENT OF THE CUTTING HEAD

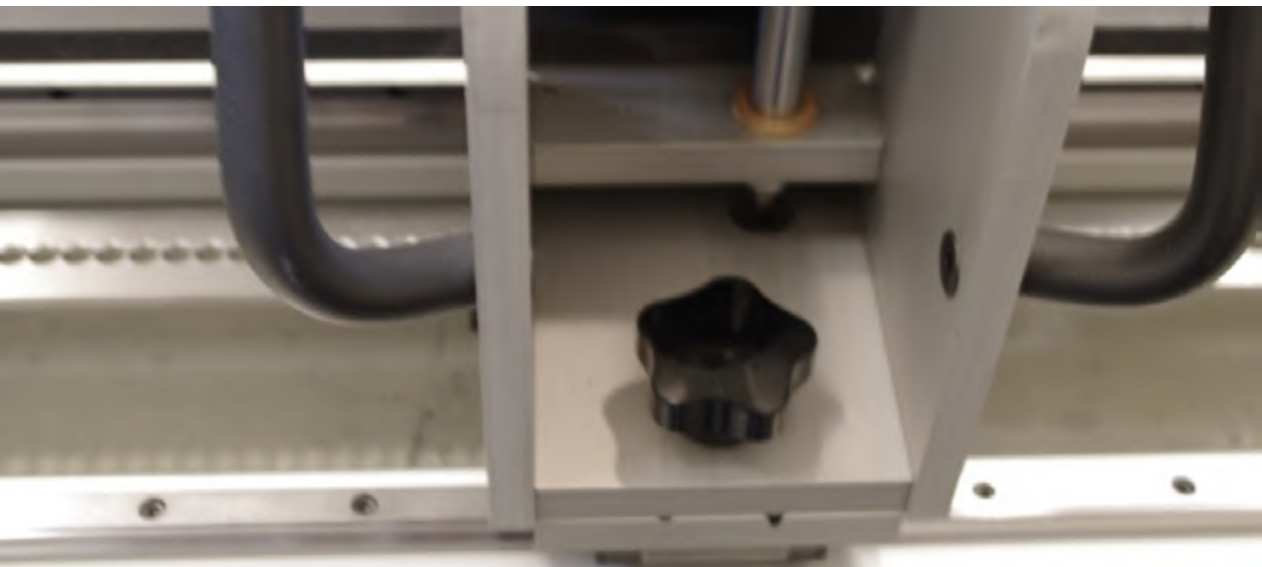
GREAT CARE MUST ALSO BE TAKEN BETWEEN THE CUTTING HEAD AND THE SUPPORT PLATE, AS THERE IS A DANGER OF CUTTING LIMBS.

Portable head assembly

Ensure the cutting handle is positioned completely vertical to keep the down pin inside the body. Introduce the punching head on top of guides plate until the end.



Fix the head with the knob M-10



Push the down camp to liberate the step pin and move the head until the centre of the frame.



Operating instructions

First, place the first end of the belt on the GREEN side by the guide rail with the coverage on top, and position the tread bar to the end of the plastic plate.



Fix the belt by lowering the bar with two knobs and tightening at the same time.

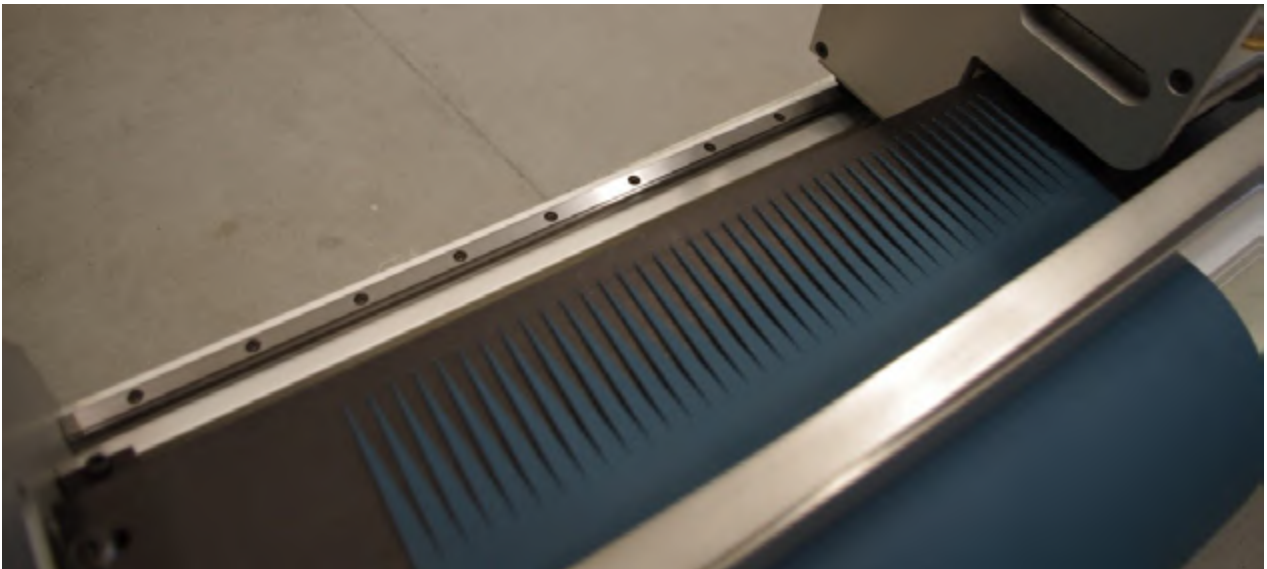
Avoid over-tightening to prevent bending of the clamp in the central part.



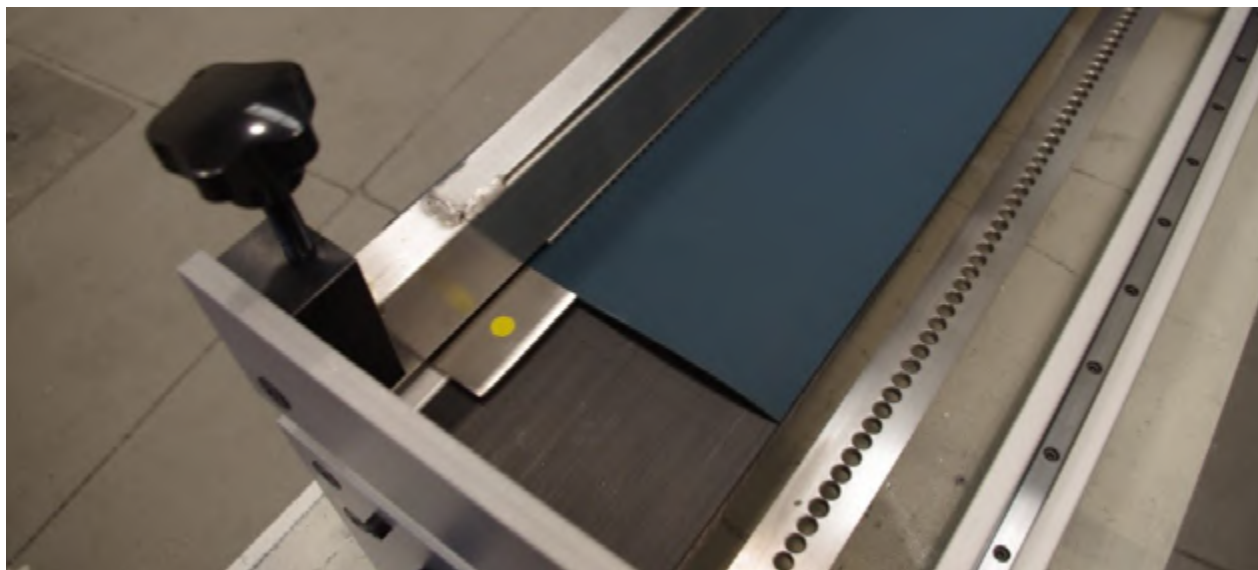
Once the belt is in position and complete fixed, push the down camp to liberate the step pin and move the head until end of stroke of GREEN side.

Then we can start to punch acting with handle in all the stork up and down.

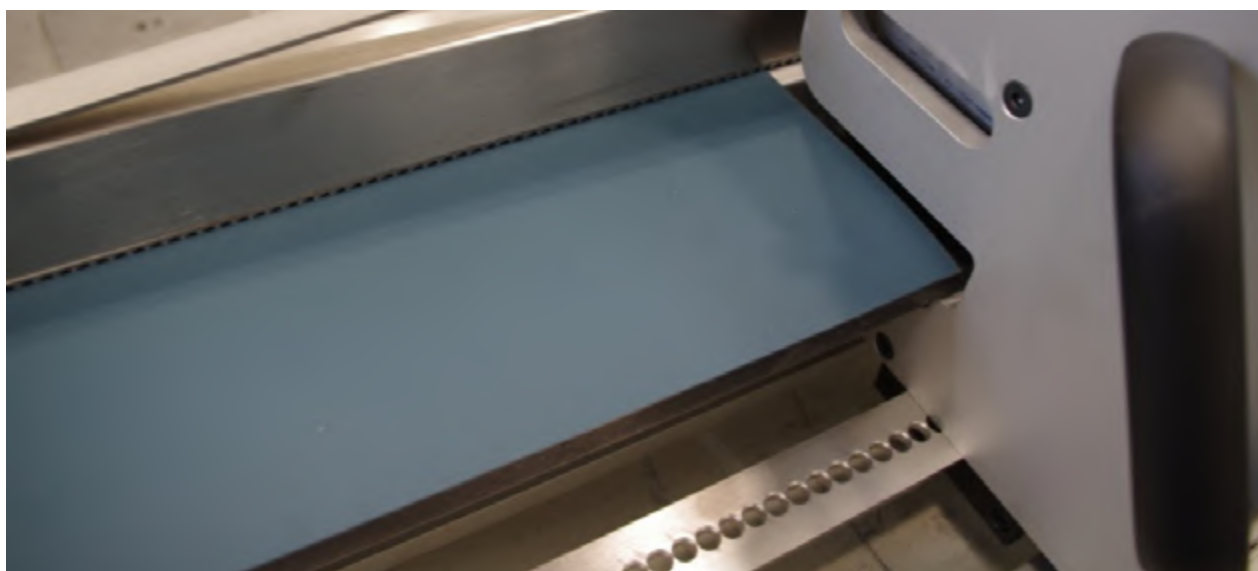
After each cut operation, position the handle up and push the head to the left side until it locks again. Then the punching head is in the next position to repeat the operation.



When the first head of the belt is completely punched, open the clamp and introduce the second head in the YELLOW side, with coverage on top also.



When handle is completely up, push the head to YELLOW side until the belt down the blades.



Once the head is in position to cut the second head of the belt, start to punch until end of stroke in YELLOW side.

NOTE:

This punching head, only works in one direction (green to yellow)
Belt cutting measures for the different dies.

80 x 10 90°.....100 mm. Longer

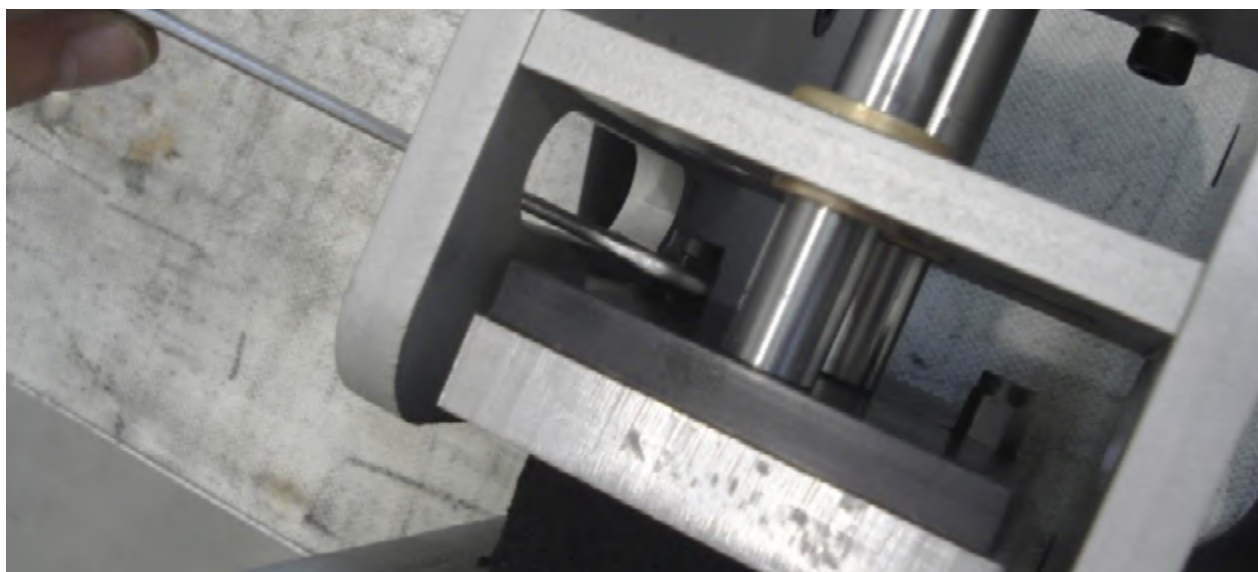
Changing the die head :

WARNING

WHEN CHANGING THE DIE, IT IS RECOMMENDED TO TURN OFF THE EQUIPMENT WITH THE OFF SWITCH FOR GREATER SAFETY.

Remove the punching head for replacing the knives plate.

Remove the 2 bolts using a 10mm key.



Remove the die and install the new one.



Tighten the 2 bolts again.

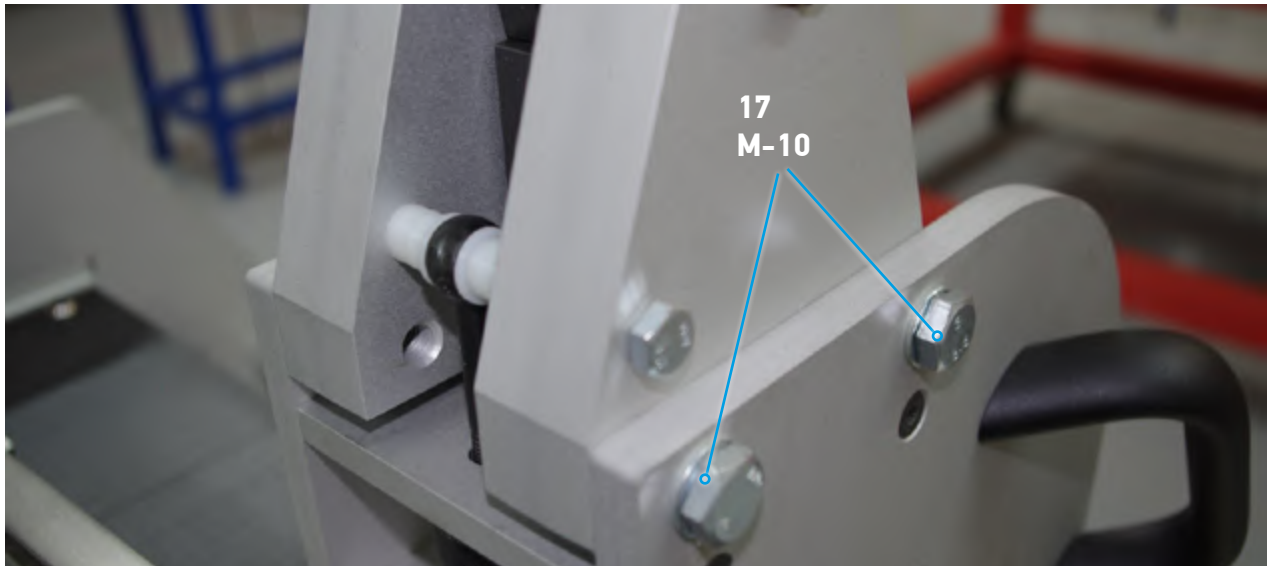
Adjust the pressure stroke.

NOTE

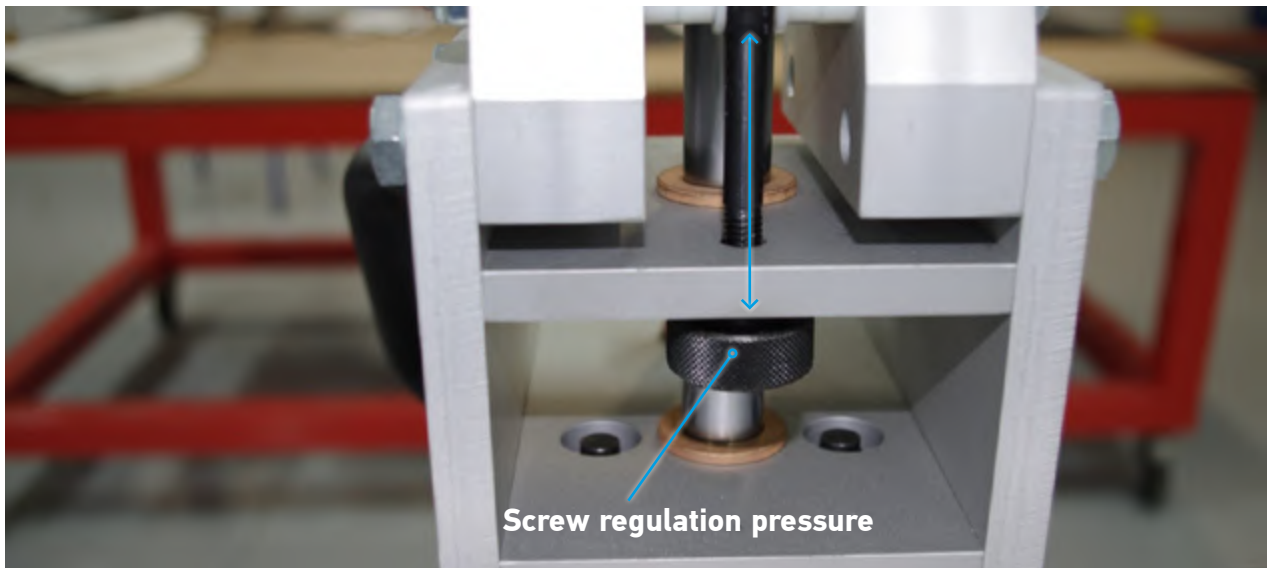
You must adjust the cutting pressure every time that nylon plate is replaced.

Otherwise, excess pressure may cause breakage of the blades, or deterioration of the cutting nylon.

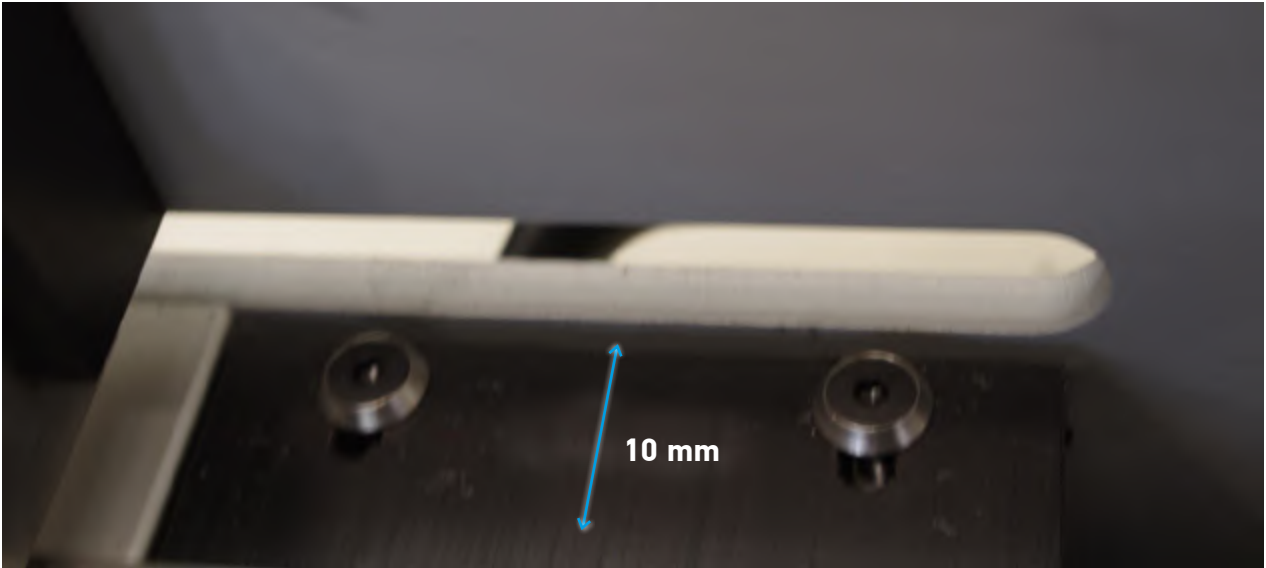
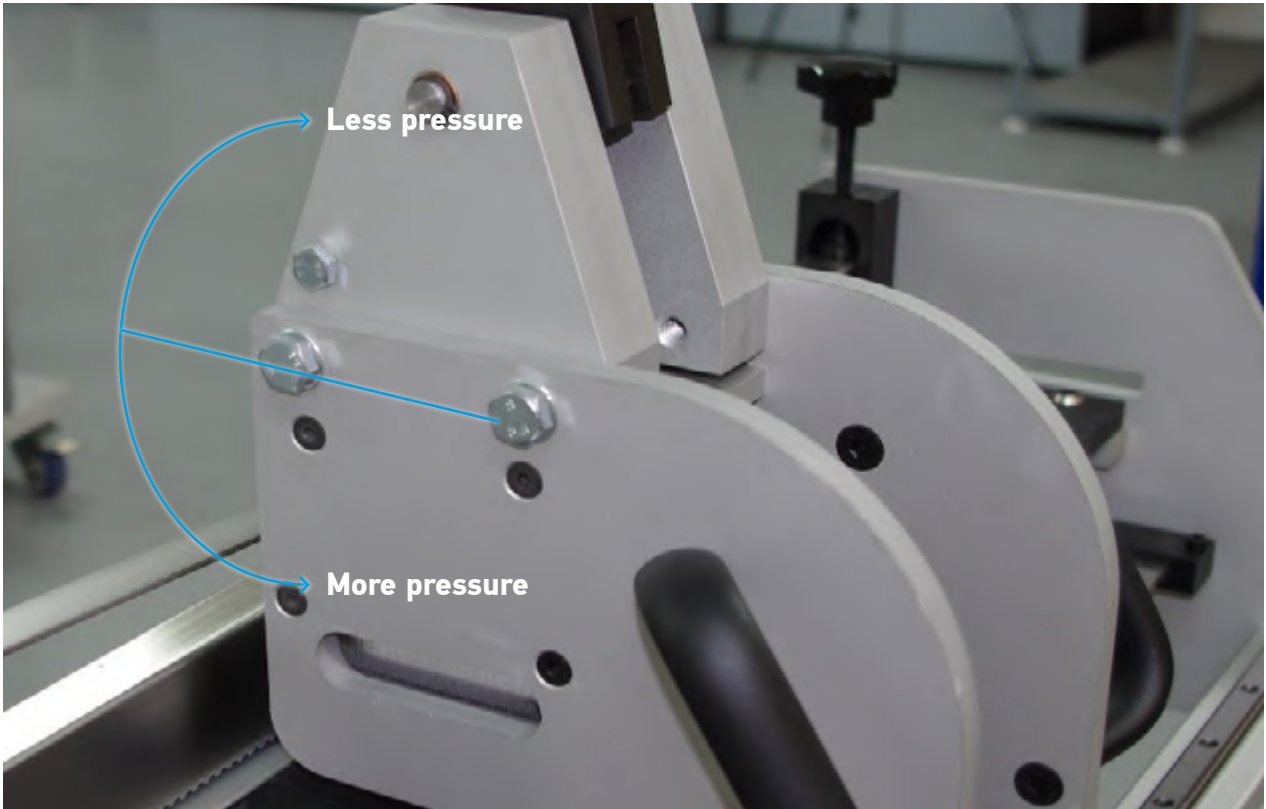
Loosen the 4 screws key 17mm M-10



Up or down the back side of head across the screw pressure like a next picture.

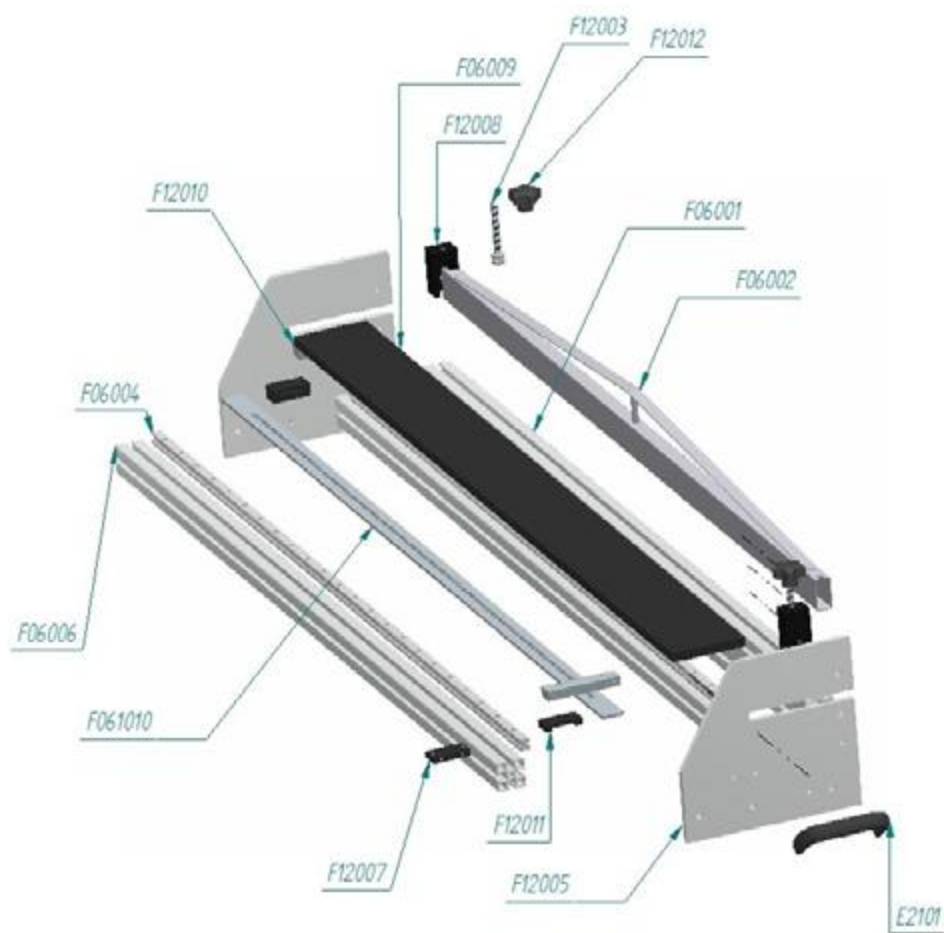


Also, you can move the cutting nylon to profit all the surface because the step always is the same.

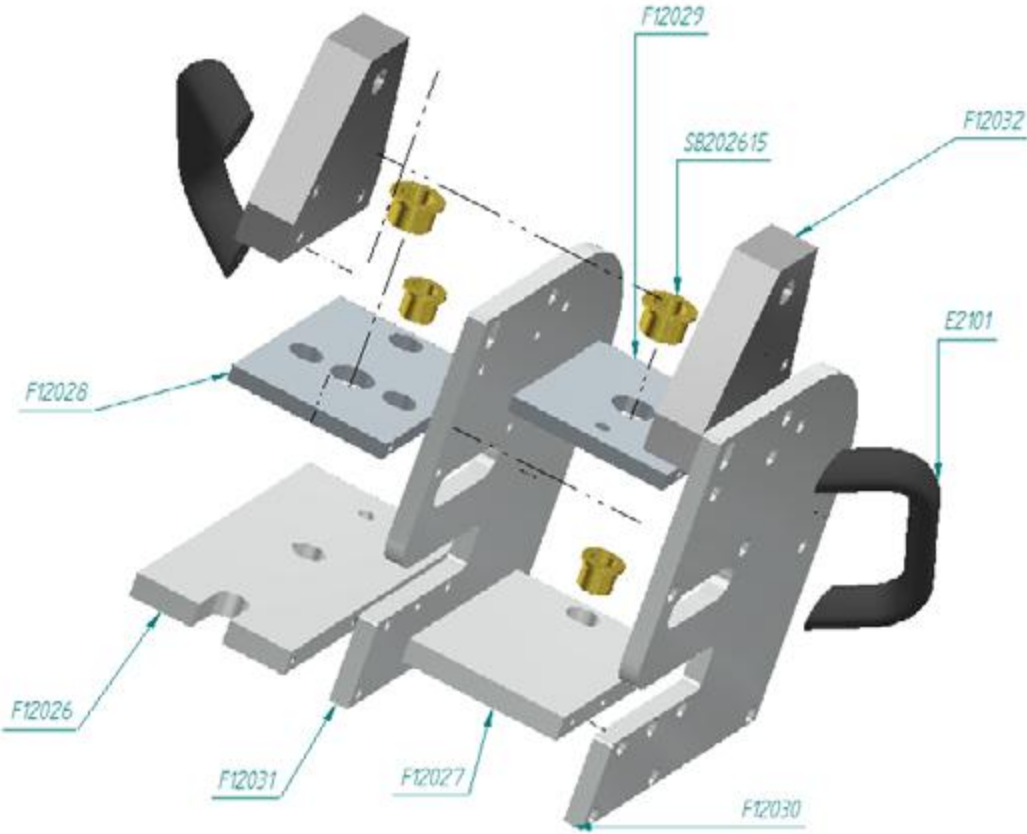


Spare parts

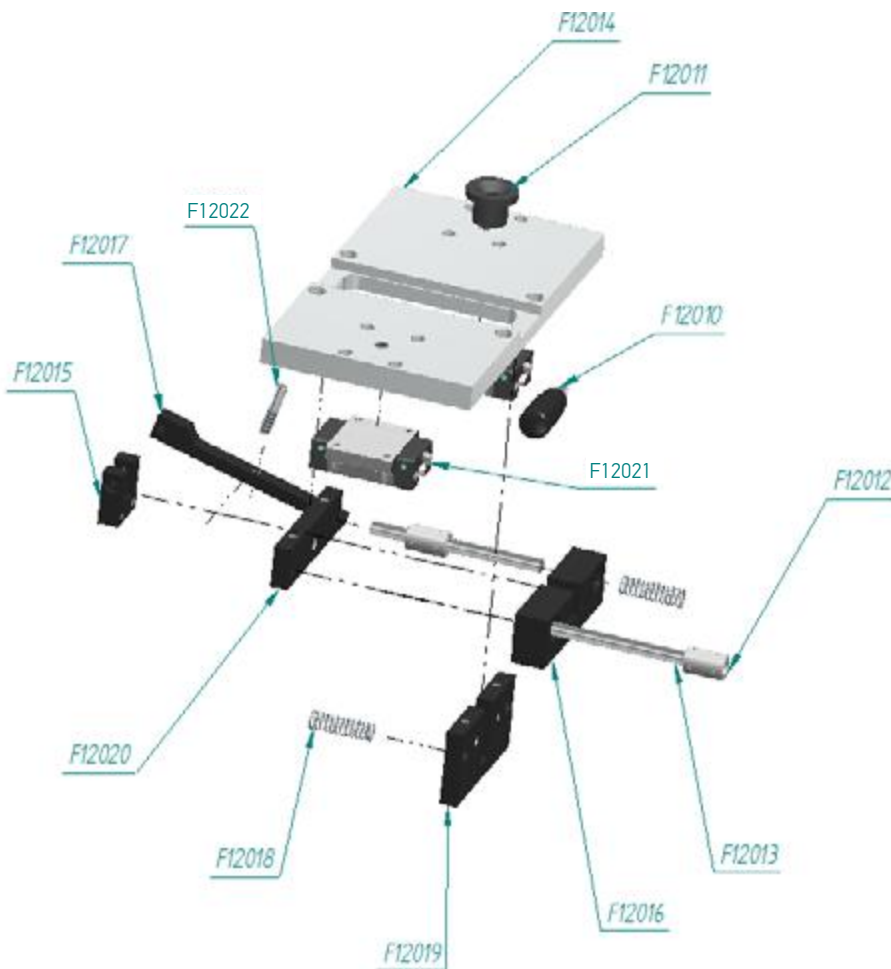
| Number | Part name | Units |
|---------|---------------------|-------|
| F06001 | 45x90x1850 | 1 |
| E2101 | Inclined handle | 2 |
| F06002 | Clamping bar | 1 |
| F12003 | Belt clamp | 2 |
| F06004 | Rail Franke | 2 |
| F12005 | Side frame | 2 |
| F06006 | miniter_20_1033_0_ | 2 |
| F061010 | Ramp | 1 |
| F12007 | Ramp tongue | 2 |
| F12008 | Belt clamp tongue | 2 |
| F06009 | Poliamide | 1 |
| F12010 | Nylon support | 2 |
| F12011 | Tongue plug | 2 |
| F12012 | vc_192_50_b_m10.par | 2 |



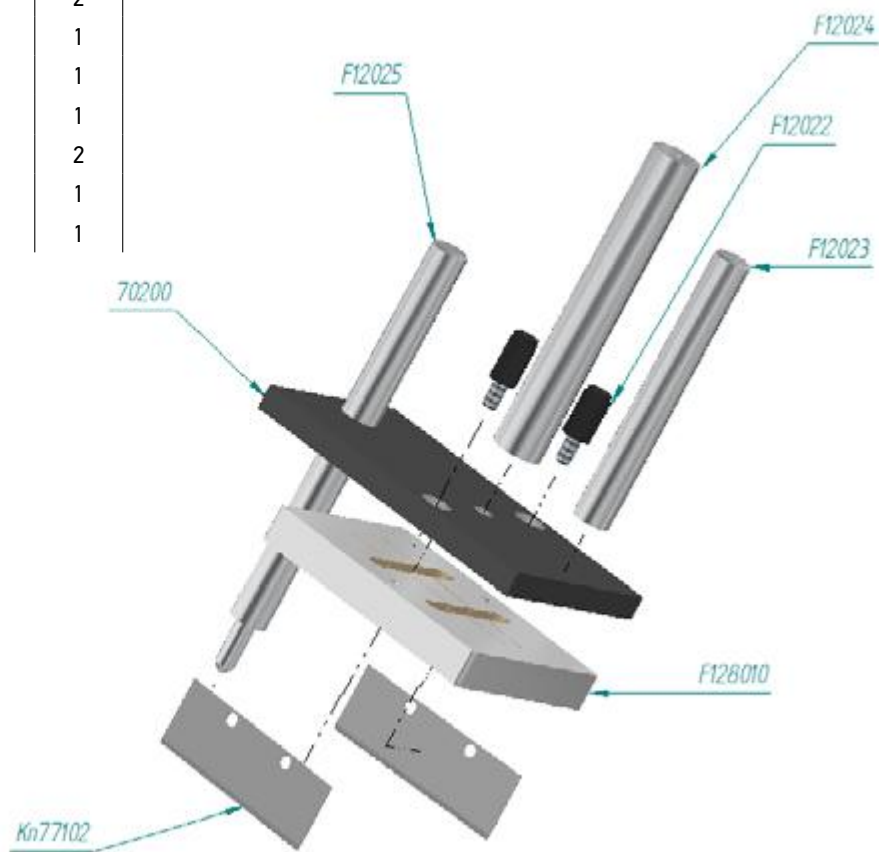
| Number | Part name | Units |
|----------|--------------------------|-------|
| E2101 | Inclined handle | 2 |
| F12026 | Base of the device | 1 |
| F12027 | Cutting base | 1 |
| F12028 | Spacer upper punch | 1 |
| F12029 | Spacer inferior pointer | 1 |
| F12030 | Device side-1.par | 1 |
| F12031 | Device side-2.par | 1 |
| F12032 | Pressure regulator | 2 |
| SB152015 | Rolling bearing 15-20-15 | 2 |
| SB202615 | Rolling bearing 20-26-15 | 2 |



| Number | Part name | Units |
|--------|-----------------------|-------|
| F12013 | Trigger guide bar | 2 |
| F12014 | Base of the runner | 1 |
| F12015 | Trigger hinge | 1 |
| F12012 | Bushing_kh_0824_0.par | 2 |
| F12016 | Trigger switch | 1 |
| F12017 | Trigger | 1 |
| F12010 | i_280_40_p_m6x1.par | 1 |
| F12018 | Spring | 2 |
| F12019 | Trigger guide ramp 2 | 1 |
| F12020 | Trigger guide ramp | 1 |
| F12021 | Hiwin trolley/skid 15 | 2 |
| F12022 | Pin/Bolt | 1 |



| Number | Part name | Units |
|---------|-------------------------------|-------|
| Kn77102 | Blade 0.7x82xdable bis normal | 2 |
| 70200 | Spacer punch | 1 |
| F12023 | Anti-rotation shaft | 1 |
| F12024 | Pressure axis | 1 |
| F12022 | Punch screw | 2 |
| F128010 | Punch | 1 |
| F12025 | Pin | 1 |



HOTLINE MLT service



Our MLT representatives will assist you remotely and in pictures

The **HOTLINE MLT** service is at your disposal to assist you live in the resolution of any problems you may encounter :

belt rupture, a rip or any other problem on your conveyor belt, we can help you free of charge, remotely and in pictures.

Our teams are available to answer your questions in **10 languages!**

Register online so that one of our representatives can contact you and help you as soon as possible:

www.mlt-lacing.com/mlt-hotline



hotline pre-registration

www.mlt-lacing.com/mlt-hotline



DIE CUTTER MLT-F120

PATENTED PRODUCT
MADE IN FRANCE

MLT Minet Lacing Technology

More than 70 years of innovation
at your disposal



Distributor's logo

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