CUSTOMIZABLE SET FOR POCKET SETTER MACHINE PS342 SERIES:
CUTTING INSTRUCTION BOOK
CUSTOMIZABLE STARTER KIT FOR POCKET SETTER

1. Internal clamp (fixed / retractable)
2. External clamp
3. Feeder clamp
4. Loader clamp
5. Inner pocket blade
6. Folding group
**CUSTOMIZABLE STARTER KIT FOR POCKET SETTER**

**STARTING KIT**

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**STANDARD EQUIPMENT SUPPLIED WITH POCKET SETTER UNIT PROVIDES:**

- Customizable pocket holder plate
- Standard jigs to hold the plastic clamps
- Plastic sheets
- Rubber
- Standard folding blade
- Standard plate for pocket support
- Place the pocket sample at the centre of the plate and mark carefully the external profile;
Draw an internal offset at 4 mm from the external line of the finished sewn pocket.
THE BLACK LINE IS THE CUTTING LINE
Cut out along the black line and make chamfer 3x45° and slots as specified below.
INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

DETAILED DRAWINGS MEDIUM KIT

JIGS CUTTING INSTRUCTION
INTERNAL CLAMP RETRACTABLE LARGE / MEDIUM

DETAILED DRAWINGS LARGE KIT
INTERNAL CLAMP FIXED (MEDIUM)

For internal sewing path

REFERENCE POINT

SV 3 x 90° 2,3 (Ø8,8mm)

FINISHED SEWN POCKET

STAINLESS STEEL X6Cr17 – AISI430
For internal sewing path

STAINLESS STEEL X6Cr17 – AISI430
✓ Place the finished pocket sewn on the plate as specified in the picture below;
✓ Draw with a mark pen the pocket profile;
✓ Cut carefully the plate obtaining the pocket profile;
✓ The pocket **must fit exactly inside the cut line**;

✓ Open the upper area of the plastic sheet according the picture above;
✓ Make countersink for M4 screw;
✓ Place the rubber as described on the next page;
EXTERNAL CLAMP (RUBBER)

- Remove the film on the adhesive side;
- Place carefully the rubber on the lower side of the mask;
- Cut out carefully the rubber following the same profile of the pocket;

RUBBER CODE SIP.P.001997
Place the finished pocket sewn on the plate as specified in the picture below;

Draw with a mark pen the pocket profile;

Cut carefully the plate obtaining the pocket profile;

The pocket must fit exactly inside the cut line;

Make countersink for M4 screw;

Place the rubber as described on the next page;
FEEDER CLAMP (RUBBER)

- Remove the film on the adhesive side;
- Place carefully the rubber on the lower side of the mask;
- Cut out carefully the rubber following the same profile of the pocket;
Place the finished pocket sewn on the plate as specified in the picture below;
Draw with a mark pen the pocket profile;
Draw an **internal** offset of 3 mm;
Cut carefully the plate obtaining the pocket profile 3 mm smaller;
Open the upper area of the plastic sheet according the following specifications;
Make countersink for M4 screw;
Place the rubber as described on the next page;
✓ Remove the film on the adhesive side;
✓ Place carefully the rubber on the lower side of the mask;
✓ Cut out carefully the rubber according the instruction below:
POCKET WELDED SUPPORT

A Pocket support
B Reinforce plate

REFERENCE POINT

POCKET SUPPORT 1mm
REINFORCE 1mm
POINT WELDER

REFERENCE POINT
POCKET WELDED SUPPORT

- Place the finished pocket sewn at the centre of the plate A;
- Align it on the top of the plate;
- Draw with a mark pen the pocket profile;
- Cut carefully the plate obtaining the pocket profile;

- Make the detailed modification according the following specification:
  - Chamfering and deburring carefully all the sharp edges;

Final result
5  POCKET WELDED SUPPORT

✓ Place the finished pocket sewn at the centre of the plate B;
✓ Align it on the top of the plate;
✓ Draw with a mark pen the pocket profile;
✓ Draw an INTERNAL offset of 20 mm;
✓ Cut carefully the plate obtaining the reinforcement element.

✓ Chamfering and deburring carefully all the sharp edges;
✓ Weld together by using spot welding technology (or structural bonding) the plate with the reinforce;
✓ **PAY ATTENTION:** align the top line and centre the reference holes before weld;

çu Mount on the support between the lower plate and the upper element as shown on the picture above.
NEEDED MATERIAL:

1) Folding group
2) Flat screwdriver
3) Wrench CH#7
4) Folding plates set
5) Marking pen
6) Steel cutter
7) Welding set or structural glue
* Pay attention: ALL CILINDERS OPENED

- IF your folding group size is M-L skip to the next page;
- IF your folding group size is M-S, you must cut 40 mm around the plates #1 and #4 as shown in the side picture:
✓ Make countersink on the plates for M4 screws;
✓ Remove screws from the folding group;
✓ Bring all cylinders in the open position;
✓ Place the plates as specified on the picture;

Adjust opportunely the plate’s supports in order to have plates #1 and #4 in contact with rubber sponge, and above the plates #2 and #3;
FOLDER GROUP 4C M-L/M-S

* Pay attention: ALL CILINDERS OPENED

- Place the plates as specified on the picture (plates #1 and #4 below and plates #2 and #3 above);
- Place the pocket (finished sewn pocket) at the centre of the plates and aligned on the top;
- Draw the external profile with marker pen and then make an **external** offset of 3 mm on all the plates *.

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JIGS CUTTING INSTRUCTION

**ITALY**
mechatronics engineering and production

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FOLDER GROUP 4C M-L/M-S

* Pay attention: ALL CILINDERS OPENED

- Draw cutting line on plates #2 and #3 according to the following specification *:

  - Pay attention: chamfer 15x11 mm only on the plate #2;
  - Chamfering and deburring carefully all the sharp edges;

Blades #2

Blades #3

Final result
Draw cutting line on plates #1 and #4 according to the following specification *:

- Pay attention: lower surplus material depend on the pocket dimension;
- Chamfering and deburring carefully all the sharp edges;

* Pay attention: ALL CILINDERS OPENED
✓ Draw cutting line on reinforcement plates according to the following specification:

- Cut the strengthening plates;
- Point-weld (or structural bonding) the plates as specified;
- Chamfering and deburring carefully all the sharp edges;

Final result