



**ZIGMA-02 SH
AUTOMATIC 22" MITER SAW**

User's Manual

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1. GENERAL INFORMATION

1.1. INTRODUCTION

The user's manual given by the manufacturer contains necessary information about the machine parts. Each machine operator should read these instructions carefully, and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following the instructions contained in this manual. The technical drawings and details contained in this manual constitute a guide for the operator.

1.2. DISTRIBUTOR

ATech Machine, Inc.
10752-A Tucker Street – Beltsville, MD 20705 - USA
Phone: +1-301-595-1816 Fax: +1-301-560-6627
Website: www.ATechMachinery.com E-mail: info@ATechMachinery.com

In case of any technical problem please contact your nearest ATECH dealer, or ATECH head office through the above mentioned phone, fax or e-mail address.

Technical labels with the model description of the machine are fixed onto the front side of each machine.

The machine's serial number and manufacturing year are stipulated on the technical label.

2. MACHINE DEFINITION and PURPOSE OF USE

2.1 GENERAL

Heavy duty miter saw with 22" (550 mm) circular saw blade designed for single sided straight and miter cut of vinyl (PVC) and aluminum profiles.

2.1.1 SC 550 P MACHINE DEFINITION

- Possibility to cut in the cutting unit at internal and external angles.
- Possibility to cut at 22.5 degree angles in cutting at inward and outward angle.
- Possibility to set the cutting unit to 90 degree unadjusted.
- Overhead clamp system.
- Variety of infeed & outfeed tables.
- The saw blade feed is hydro-pneumatic and it is possible to accurately adjust the desired blade feed speed according to the material type.
- Two hand control system for operator safety.
- Machine has been designed in accordance with UL, CSA and CE Safety Directives.

2.1.2 ACCESSORIES


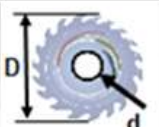




STANDARD ACESORIES	OPTIONAL ACCESSORIES
22" (550 mm) Diamond-Tipped Circular Saw Blade	Infeed & Outfeed Tables
Air Gun	Pneumatic Spray Mist Lubrication System
Twin Pneumatic Clamps	
User's Manual	

2.1.3. REST RISKS

The normal usage conditions needs only an operator presence, available in the area within control panel. Because the operator will use the buttons on the control panel for the operation, shut down and material supply actions during the cutting, he/she should be careful that another person except of him/her is not near the risk zone.

Furthermore, please take into consideration the other rest risks, arising from the defective installation of the electric and saw blade or from defective mounting of the machine / part.

2.1.4. TECHNICAL FEATURES

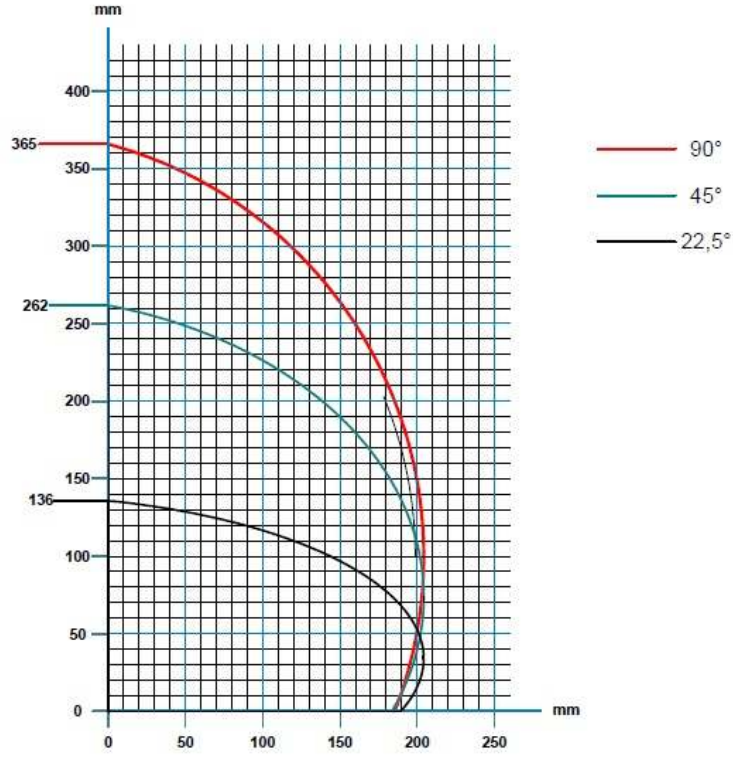
TECHNICAL FEATURES								
				psi	Air Cons.		lbs	lbs
ZIGMA-02 SH	3 HP 50/60 Hz 3-Phase 220V	d=1-1/5" D=22"	2400 rpm	90-120	1 CFM	38x59x56"	946	1320

2.1.5. OVERALL DIMENSIONS

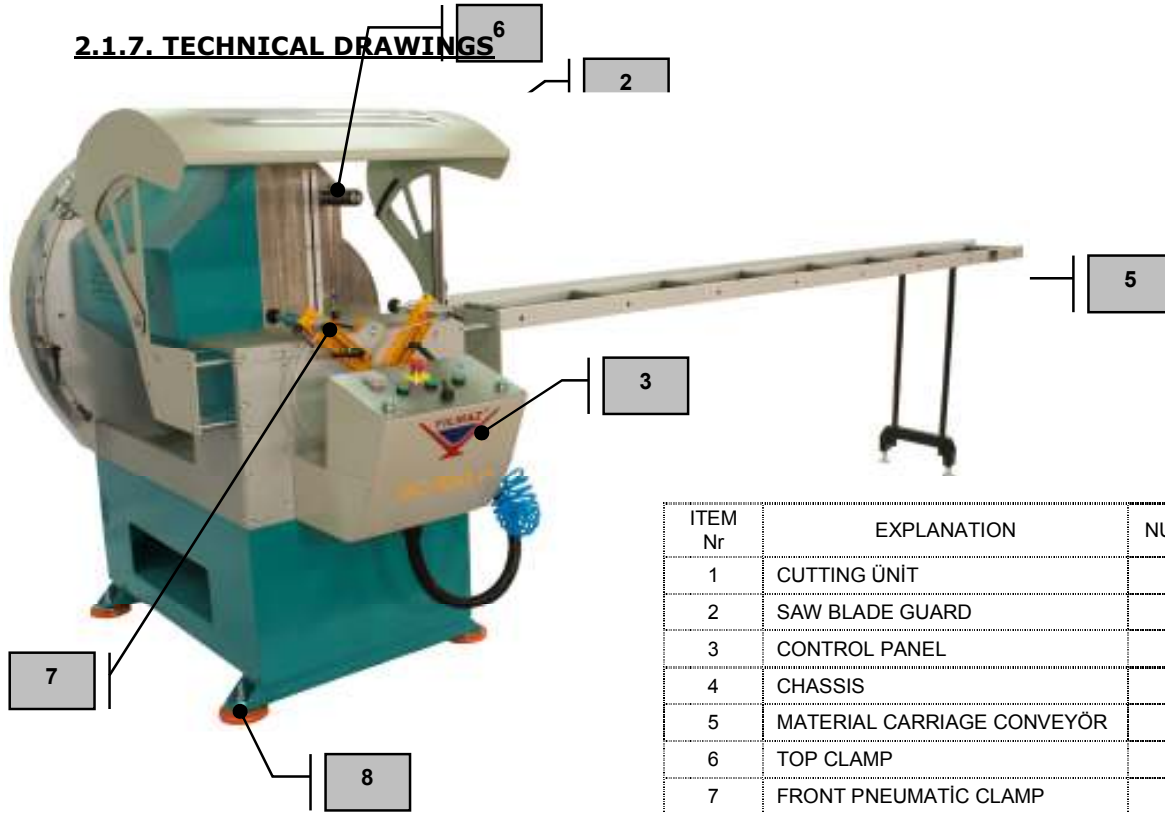


FIGURE – 1

2.1.6. CUTTING DIAGRAM



2.1.7. TECHNICAL DRAWINGS



ITEM Nr	EXPLANATION	NUMBER
1	CUTTING ÜNİT	1
2	SAW BLADE GUARD	1
3	CONTROL PANEL	1
4	CHASSIS	1
5	MATERIAL CARRIAGE CONVEYÖR	1
6	TOP CLAMP	1
7	FRONT PNEUMATIC CLAMP	2
8	CHASSIS LEVELLING BOLTS	4

FIGURE - 2

3.0. SECURITY

3.1. SECURITY INFORMATION

The following symbols are the symbols that is related to security and that require special consideration and reading. Not to be read or cared by the user may give physical damages to the equipment or himself/herself.

IMPORTANT

The IMPORTANT symbol above is a symbol in written explaining that it requires you to behave attentive and careful, to prevent your actions within limits not you to be damaged.

CAUTION !

The CAUTION! symbol above warns you against the specific hazards and requires certainly to be read. If you do not care , you may damage the equipment.



HAZARD WARNING

The HAZARD WARNING symbol above warns you against the specific hazards and requires certainly to be read. If you do not care , you may give yourself or the equipment physical damages.

Before you use the machine or make the maintenance, read the user manual carefully.

3.1.1. MACHINE SAFETY INFORMATION



By taking into consideration that the use of machine and tools carries certain risks it is required to show maximum attention to the action to be made. Because of the high circulation of the aluminium and PVC cutting machines and their high progress speeds they take place amongst the most dangerous machines. Therefore, the maximum care and concentrate should be shown to the work.

- All security and protection vehicles should be used for the excellent efficiency. It is necessary to obey always the warning signs on the machine and recommendations in the user manual.
- It is certainly forbidden that the protective top protection cover and such like protective security equipments are removed and then made them worked.
- The qualified and authorized personel should be used to pick up, move, carry the machine and fort he electrical and pneumatic maintenance works.
- It is certainly not applicable to modify any part / point on the machine.
- It is forbidden to make any adjustment, cleaning and maintenance when the machine is working.

3.1.2. SAFETY OF THE OPERATOR

The operator of the machine should wear proper clothing according to the working conditions. Avoid lose parts of clothing and/or accessories, which could be caught by machine components. Operator should be focused on the cutting operation.

3.1.3. INDIVIDUAL PROTECTION GOODS

It is recommended to use the protective items determined below.

- Powerful gloves to prevent the cutting, drilling or stinging cases by carrying materials,
- Ear protectors / taps against the noise,
- Eyeglasses against the pieces such as dust, chips etc. that may spring,
- Defensive shoes during the carriage of the materials that are in certain weight and size,
- The usage of mask in the use of cooling liquid are recommended.

3.1.4. MACHINE SECURITY

- Use always good whetted and balance taken original saws.
- Clean the saw and connection flanges well during the change of the saw and control whether it is damaged or not.
- The whetting should be made smoothly frequently and properly to the angular values of the tool.
- Do not take the chips and excelsiors on the table, use a proper tool for his work.
- Do not put any foreign object, tool etc. onto the working table.

3.1.5. WORKING ENVIRONMENT SECURITY

- Keep your machine and devices clean and in such a way that you will work at any moment to able to work safe. Obey the instructions in the maintenance and in the changes of accessory. Control the plug and cable regularly. Renew them to an authorized expert when you encounter any damage. Be careful that the oil and grease are contaminated on the handle and grab handles.
- Be careful that the working area is enlightened enough and in order.
- Arrange the machine round with machined and non-machined materials and in such a way that it is strolled among them easily.
- Clean the dust, chip and excelsiors on the floor, the disorder increases the accident risk.

3.1.6. PROCEDURE FOR MACHINE ISOLATION

- The machine electrical system should be closed from the main switch for any maintenance, repair cleaning and such works. Unmount the air pressure connections. Deflate the rest pressured air in the machine.
- The works such as maintenance, repair, cleaning should be made by the person who took the above precautions. If it is a simple action, that person may be the operator after the above written precautions are again taken.
- If the machine is not in use, the main switch and air system should be closed.

3.1.7 . SECURITY DURING MAINTENANCE

- The regular maintenance of the mechanical and electrical parts is an important security factor, because it increases the usage life of the machine and keeps better performance values.
- It is certainly forbidden that any mechanical part or maintenance work is made without applying the machine (without unmounting the electrical and pneumatic systems) isolation procedure.
- It should be paid attention that foreign objects etc. should not be forgotten during the operation when any part is demounted and mounted again. The convenience of them to their points should be controlled.
- Do not mount on the machine.
- Use gloves when you change the saw.
- The original parts should be used when any part is changed. Their electrical components should be the parts is proper to the values determined on the electrical schemas and in the equivalent safety values. Contact with the manufacturer company in case of doubt. In the event that it is not obeyed that any liability is accepted by the manufacturer company.

CAUTION !

The security information are defined above. Please read the safety information carefully to prevent the physical damages or equipment damages and keep these information always in your mind.



3.2. PREVENTION OF ACCIDENTS

3.2.1. The manufacturer company machines are produced properly to the safety standards including national and international directives and methods.

3.2.2. Here, the task of the employer is to warn the personel against the accident risks, to train about the possible accidents, to provide the protective safety equipment and devices that are necessary for the safety of the operator.

3.2.3. The operator should be used to his/her position held before starting to work (the similar machines should be used before) the characteristic features of the machine should be controlled by the operator.

3.2.4. The machine should only be used by the personnel that has read the user manual and understood its content.

3.2.5. The directives, recommandations and general safety rules that this user manual contains should be carried out completely by the user. The mixture the replacements of one or more machine parts, taken from the manufacturer company, without giving authorization or the difference of the accesories usage from all these recommendations increase the risk to be caught the accident. The manufacturer company has no legal liability or responsibility in such usages. The above mentioned applications cause also to end all warranty rules.

4. LOCATION INSTRUCTIONS

Our all machines are packed in the excellent mounting conditions after careful inetnal examination and control. The machines are packed in the wood cases in the overseas or articulated lorry deliveries bu being used special lubricant products providing protection against the oxidation. In case of any damage to be found inm the machines the damage should be informed to the transport company. In addition to this, it should be controlled that all Standard or optional accessories given with the machine are available.

- In the Figure 3 the minimum safe area measurements required for the building area are given. These measurements are;

L : Machine length 135" (3430 mm) (including conveyor from the saw line)

L1 : 540 mm (21")

L2 : 270 mm (11")

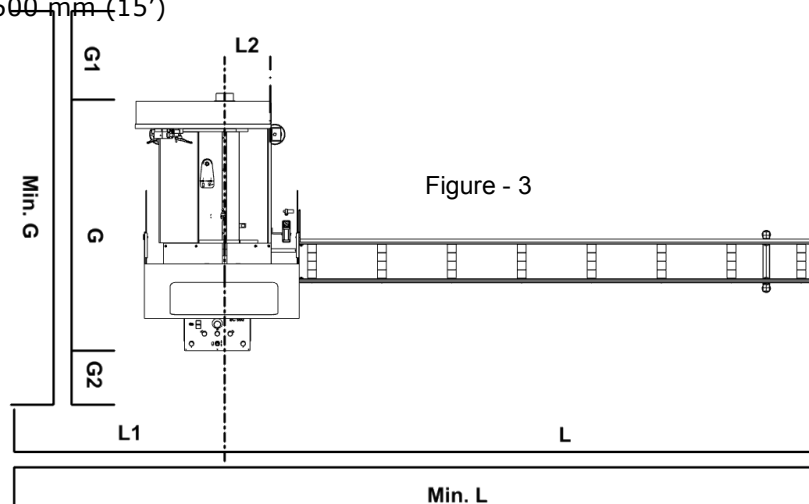
Min. L : Necessary working area 3970 mm (13')

G : Machine width 1500 mm (59")

G1 : Necessary working area Min.1500mm (to be able to make the maintenance and cleaning actions safely)

G2 : 1500 mm (Access to the control board)

Min G : 4500 mm (15')



CAUTION !

4.1 SAFETY TRANSFER OF THE MACHINE

The machine may be carried by fork-lift. It should not be forgotten that the machine weight is 430 kg (946 lbs).

Do not lift the machine before you are sure that the bearing knives of the equipments such as fork-lift come under the machine when transferring the machine.

Move the load as soon as possible by catching it from below when the machine is removed from its place so that more stability can be provided. Move the machine slowly without shaking it. Be sure t



Figure - 4

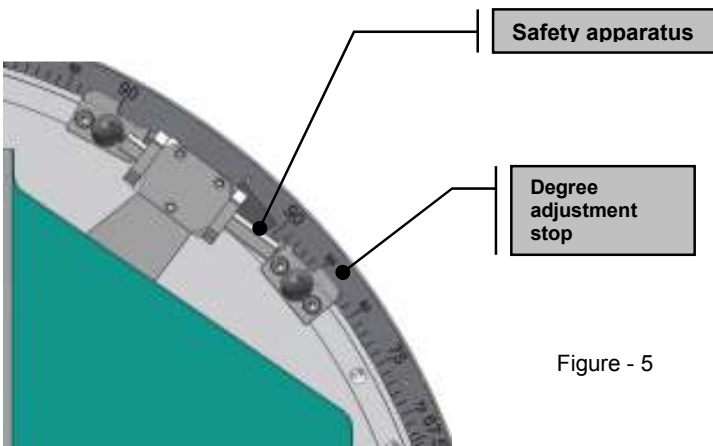
4.1.1. MACHINE INSTALLATION

4.1.1.1. A general control is recommended to be sure that any part is not lost in the steps such as transfer, loading etc. before putting the machine into use.

4.1.1.2. The locating the machine to the necessary area for the top protective cover to be opened towards the back, to be used the chip absorption manifold and to be made the proper maintenance and cleaning activities (See Figure 3).

4.1.1.3. The floor that the machine will be put should be hard, flat and in such a way that it will carry the machine weight.

4.1.1.4. Be sure that the counterforts are set on the ground to protect the stability of the machine. Make certainly the adjustments with the adjustment screws on the counterforts. (See Figure 2)



CAUTION !

The safety apparatus should not be removed from its place before the machine is worked firstly.

Figure - 5

4.2. PRELIMINARY PREPARATION

4.2.1. Remove the transfer safety connection parts before the machine is worked. (See Figure-5) Do not make the electric and pneumatic connections before removing the transfer safety connection parts.

4.2.2. Keep the removed transfer safety connections by thinking that you may use them in the next transfers.

4.2.3. The front control board is delivered disassembly not to be damaged during the transfer. Mount the front control board to the place on the machine as seen in Figure 5.

4.2.6. The chip receiving speed (discharge air capacity) should be thought as Min.20 M/sn for dry chips to use the chip absorption manifold.

4.2.7. The discharge air capacity should be thought as Min.28M/sn for wet chips (if moisture is 18% and over).

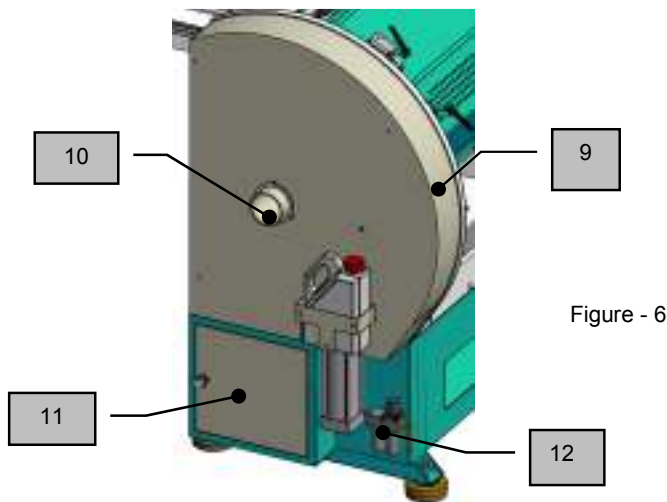


Figure - 6

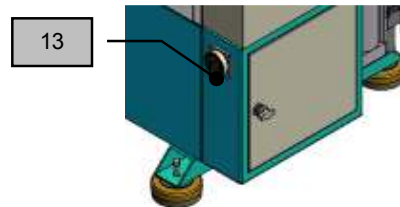


Figure - 7

Item Nr	EXPLANATION	NUMBER
9	BACK PROTECTION COVER	1
10	CHIP ABSORPTION MANIFOLD	1
11	ELECTRIC BOARD	1
12	AIR CONDITIONER	1
13	MAIN SWITCH	1

4.3. CONVEYOR MOUNTING

After positioning and levelling the machine properly, fasten MKN 300 (optional) material supply conveyor onto the cutting unit to the right side surface of the machine as seen in the Figure-8 by using the screws on the machine. Provide the conveyor bobbins and machine top surface to be the same parallelism by using a sensitive and calibrated water gauge.

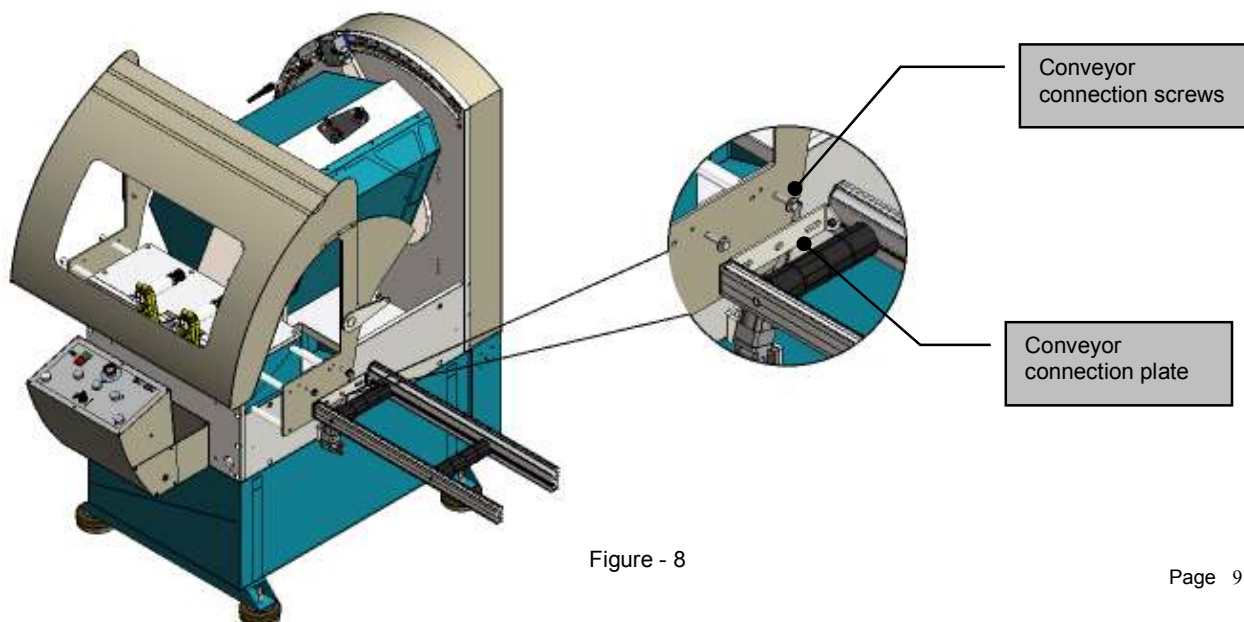


Figure - 8

4.4. PNEUMATIC CONNECTIONS

- The machine's pneumatic system components are numbered on the pneumatic hoses.
- In case of stopping the machine use the air gun to isolate the rest air in the system.
- Pneumatic working pressure should be 6-8 bar.
- It is recommended that 8 mm pneumatic hose should be kept available for the machine pneumatic supplies.

4.4.1. AIR PRESSURE ADJUSTMENT

- Pull the conditioner adjustment button up. (See Figure - 9)
- If the adjustment button is turned in the direction of clockwise, the pressure increases.
- If the adjustment button in the direction of counter clockwise, the pressure decreases.
- When you read 6-8 bar pressure adjustment on the manometer, lock the conditioner adjustment button by pushing downward. See Figure-9
- Oil used in the conditioner and recommended by the manufacturer is TELLUS C 10 / BP ENERGOL HLP 10/ MOBIL DTE LIGHT / PETROL OFISI SPINDURA 10.
- The conditioner unit collects the water in the air system in the receiver vessel not to damage the pneumatic system components. Unload the water by pressing the button under the conditioner cylinder storage to unload the periodically collected water (end of the working day).

Adjust the lubricant level in every 10 working cycles as DROP.

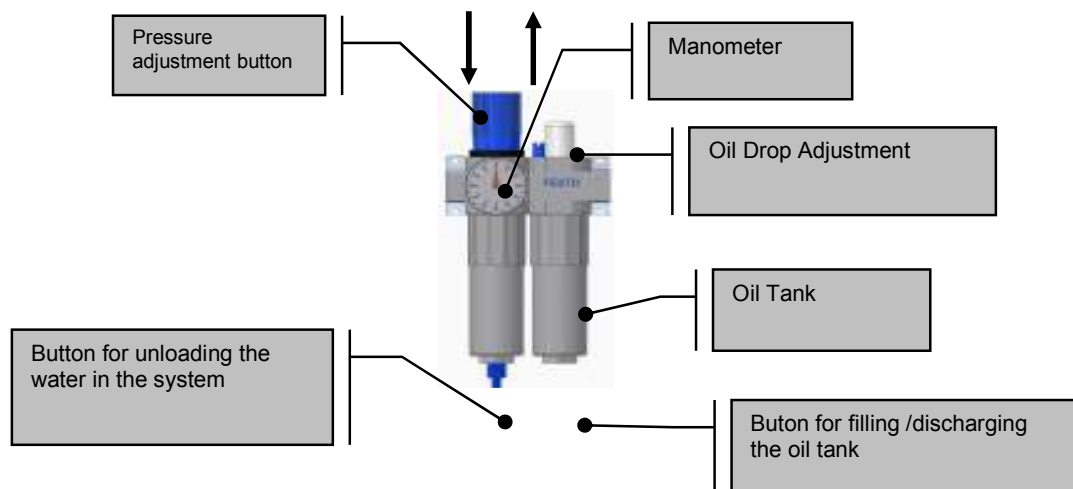


Figure - 9

4.5. ELECTRICAL INFORMATION

- First of all the machine electric system voltage and frequency values should be compatible with the line voltage and frequency providing electrical energy.
- Apply the connection cable socket with a socket (Electrical plug) that is proper to UL, CSA, CE standards.
- Make the electrical socket connections after positioning the MAIN SWITCH on the machine to 0.
- Make the machine connections according to the electric scheme.

- The socket connections should be made by a licenced electrician, its direction of rotation should be controlled based on the direction rotation label on the machine (by being used a device that is proper to the saw direction of rotation control)
- In the cases that the saw direction of rotation is adverse, the electrical power cable connections should be reviewed by authorized and licenced electrician and the connections should be corrected.
- If the saw direction of rotation is reverse, it endangers fort he operator and equipment. It may cause the sawteeth to be destroyed and broken.
-

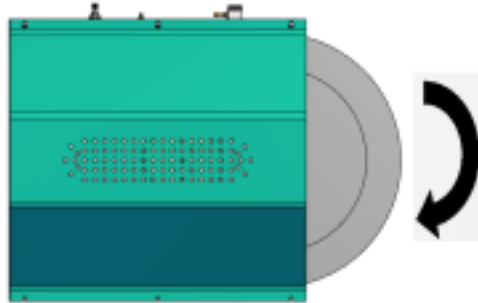


Figure - 10

4.6. PRELIMINARY PREPARATION CONTROLS

It is recommended to make a few preliminary preparation controls before starting the cutting action.

- The control of the voltage and frequency information in the identification label on the machine,
- Whether the power cable is selected in proper section or not,
- The saw is tightened well, drunken / distorted does not return and is its direction of rotation proper to the label direction of rotation on the machine, (in the direction of the label direction of rotation on the machine table (See Figure -10)
- Has the air input provided to the pneumatic system, (otherwise the machine does not work.)
- Is sufficiently lube oil available in the air system conditioner,
- Are the conveyor / conveyors mounted onto the machine properly,

4.7. SAW BLADE FEED SPEED ADJUSTMENT

4.7.1. The saw cutting speed adjustment and the working simultanously of the saw group are important in terms of reducing the time loss and providing surface flatness of the cut material.

4.7.2. The saw group can be adjusted independently of each other through the reducer valves on the Hydro-Pneumatic system in the cutting unit group (See Figure-11)

4.7.3. Adjust the reducer speed adjustment screw (See Figure-11) by rotating in the direction of clockwise until providing the desired progress if the saw group cutting progress is fast. Make the opposite of the above action if the saw group cutting progress is slow.

4.7.4. According to the type and shape of the material to be cut it can be adjusted by controlling the clamp speed.

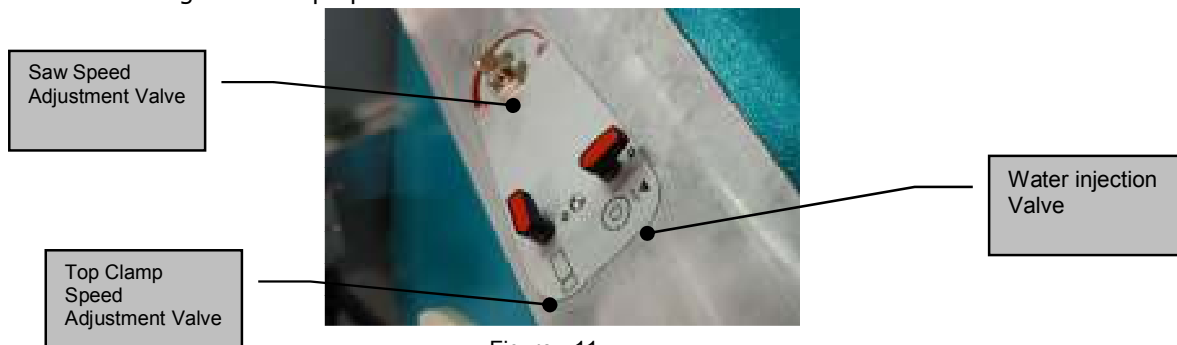


Figure - 11



NOTE: When making the saw cutting progress speed adjustment, be careful especially that the top clamps are out of the saw working area. See Figure 11



CORRECT

Figure - 12



FALSE

5. OPERATION

ZIigma-02 SH (SC 550 P) cuts roducts made of aluminium, wood and hard plastic materials that are not ferrous. The operator adjusts the saw cutting progress according to the type and size of the material to be cut. (Figure-11) the internal and external sharp edge ports of circular saw provides you to get rubbed surface in high quality.

5.1. GENERAL OPERATION INFORMATION

CAUTION !

When the machine is opened from the Main Switch (Figure-7) or the Emergency Stop button is pressed, any one of the degree selection buttons shown in the Figure-14 should be presse done time for the machine to come to reference.

5.1.1 Do not try to cut the part / material, desired to be cut, without tightening with clamps on the machine.

5.1.2 Avoid to touch random the buttons on the board. If you feel a hazard during the cutting action, pres immediately the emergency stop button and abort the cutting action.

5.2 SIZE and DEGREE ADJUSTMENTS

After comploting the application of the electrical and pneumatic connections of DC 550 Automatic double head cutting machine safely, the cutting lengths to be proper to the tolerances in the given measurement and angles are provided with

- a) Size adjustment and
- b) Making proper its degree adjustment.

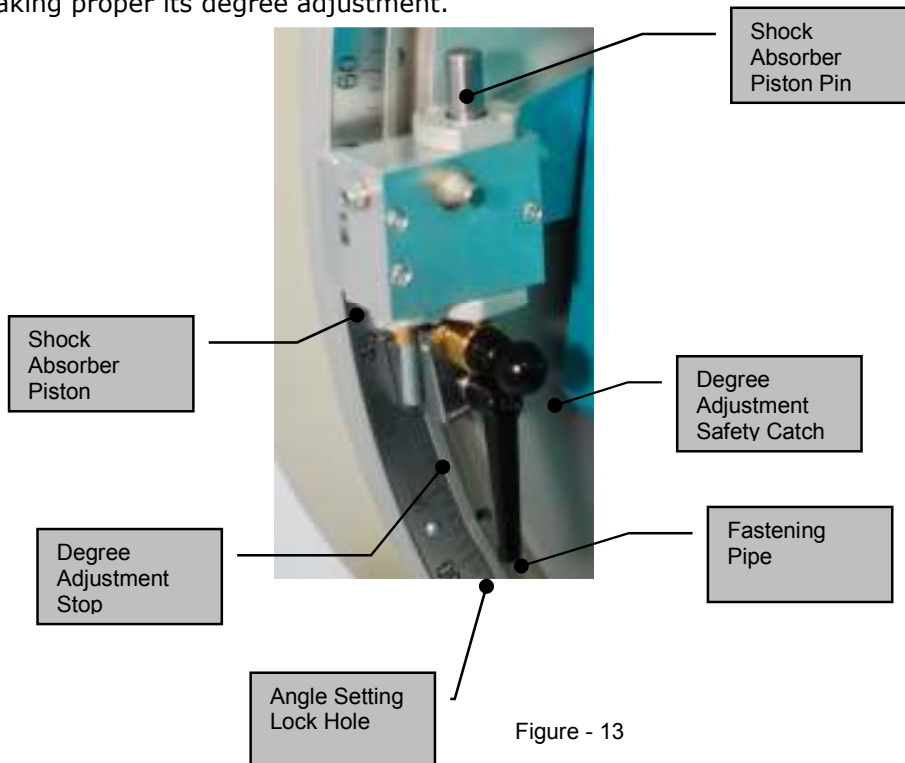


Figure - 13

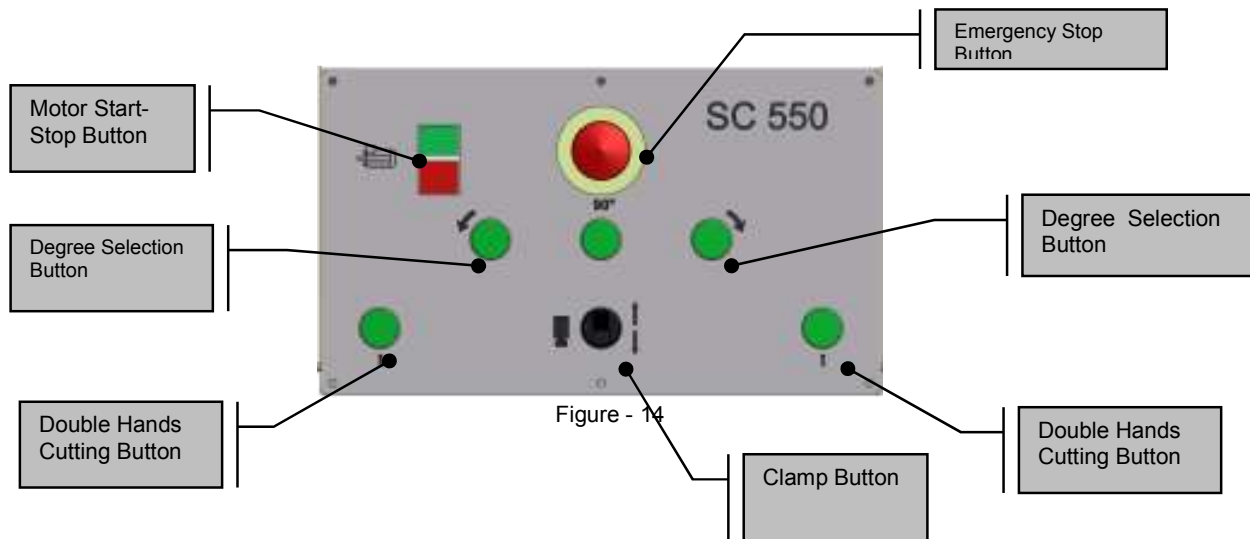
6.0. ZIGMA-02 SH (SC 550 P) CUTTING MACHINE OPERATION INFORMATION

The cutting direction angles of heads are determined with the Degree selection button seen in the Figure-14. When button is taken to which direction position (internal angle or external angle), the head will go that angle in that direction. To get the desired angle values in heads on the cutting unit;

6.1. Internal Angle Adjustment: Whichever head angle is adjusted to adjust the internal side angle it is put firstly towards external side angle. The fastening pipe in the internal side are loosens and the safety catch is pulled backward and after it is brought to the desired angle and then left, the safety catch is also left. Finally the fastening pipe is tightened again and the adjustment of the internal side is completed.

6.2. External Angle Adjustment: Whichever head angle is adjusted to adjust the external side angle it is put firstly towards internal side angle. The article 6.3 is applied.

6.3. Bring the "**Degree adjustment stop**" to the desired angle value and tighten the fastening pipe on it (see Figure 13). If the angle value of the part to be cut is one of the 15-22.5-30-45-90 degrees, be sure that the "**safety catch axle** " runs to the hole slot in the channel. If the cutting action will be made in the space degrees except of the above mentioned degrees, there is no hole against the safety catch axle. It will be enough only to tighten the screws on the degree adjustment stop. After making these actions the button on that direction, from the degree selection buttons seen in the Figure 14, is pressed depending on the angle in sides of internal and external and the head is put in the desired angle. Furthermore, in any case the head is adjusted in any angle, when pressing 90 degree button, it comes to 90 degree automatically and without any adjustment.



6.4. CARRYING OUT THE CUTTING ACTION

6.4.1. Cutting action at SC 550 cutting machines;

After making the adjustment of the cutting progress speed in accordance with the article 4.7.;

6.4.2. Provide the vertical pneumatic clamps to tighten the part by using the clamp button on the machine (See Figure -14).

6.4.3 Bring the head to the desired angle for the cutting. (Article-6.3)

6.4.4. Provide the saws to rotate by pressing the motor start buttons on the control panel.

6.4.5. After making all preparation actions, provide the motor to rotate by pressing the Motor Start button on the control panel. (Figure 14)

6.4.6. Provide the saw to come forward by pressing simultaneously the double hands safety modul buttons and then continue to press the buttons until the working part is cut. (When pressing the double hands buttons, the top protection will be closed automatically.)

6.4.7. After the end of cutting action, remove the hand pressure on the button. Both of the saws will come to the initial position.

6.4.7. Take the cut working part by bringing the safety catch button to the initial position.

CAUTION !

Remove the pressure on the cutting buttons in a possible hazard, or press the emergency stop button.

After pressing the Motor Stop button, the saws completes their free rotation in the closed protection within 15 sec. and remain completely motionless.

6.5 TERMINATION OF THE CUTTING ACTION

6.5.1. Use the motor stop button to stop the saw rotation.

6.5.2. Bring the main switch to "0" position (Figure-7)

7.0. CHANGING THE SAW BLADE SAFELY

Apply the following sequence to demount the circular saw from the saw axle.

- Apply the machine isolation procedure (See Article 3.1.6)
- Take the M10 screw (Figure 15 159 number) outside by rotating in the direction of counter clockwise with 8mm Allen switch. (Hold with 17 two-edged switch from the side in the saw axle of which switch edge is opened)
- Remove the parts 158 Number washer, 155 Number External Coupler, 29 number Saw flange II regularly.
- Remove the saw carefully.
- Mount the saw by being sure that the rotation direction onto the axle is true.
- Mount the other parts (Washer and Coupler) onto the axle respectively.
- By holding the M10 Allen screw by 8mm Allen switch and the saw axle simultaneously by 17 switches tighten in the direction of clockwise.
- It is necessary the saw that you use to be sharpened at certain intervals depending on the cut material type. The sharpening action is made in the cases that the cut working part is burry at the end of the cutting or the saw has difficulty.

CAUTION !

- Control the saw before using it. The saw should be installed to the axle perfectly (without runout and from the proper point). Do not use the damaged and vestigial saw. Try the machine by making it ungeared at least 20 sec.
- The saw hole size is 32 mm. If the saw hole size that you will use is 30 mm, mount the saw stamp in Figure 15 122 number to its place turning down.



- Use protective glooves in the saw changing action.

CAUTION !

When replacing the saw blade with a new one, use the part of 122 number saw washer that is proper to the saw axle size. The external size of the saw washer is two-stage according to 30 and 32mm.

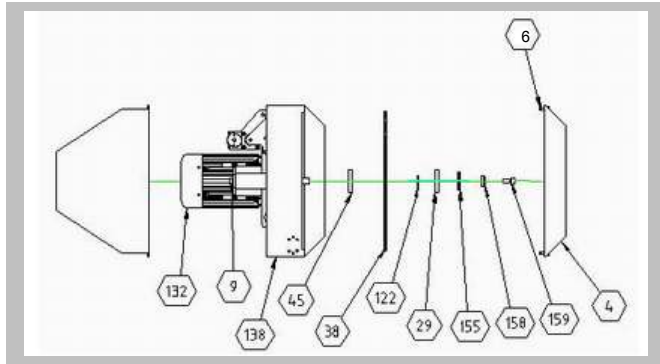


Figure - 15

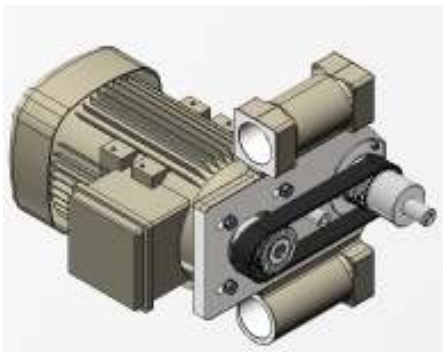
Nr	Stock nr / Part Name	Number
4	2TU012510-0180	2
6	1SC021000-0012	8
9	2TU011110-0456	2
29	2TU011110-0423	2
38	1SK010000-0005	2
45	2TU011110-0422	2
122	2TU011110-0122	2
132	1EL070000-0001	2
138	2TU012510-0179	2
155	2TU011441-0016	2
158	2TU011110-0203	2
159	1SC011000-0002	2

7.1. MAINTENANCE and CLEANING OF THE SAWS

The recommendations for the maintenance and cleaning of the saw are these;

- Clean the saws with a proper cleanser to purify it from the scales adhered on it.
- If the sawteeth are blunted, change immediately with a new / sharpened saw.
- Sharpen with proper sharpening machines by taking the angular value of the saw into consideration.
- Protect the saws in proper storage conditions without contacting with each other.

CAUTION !



In cases that the motor straps should be changed, demand certainly by us technical service dsupply.

8.0 MAINTENANCE

8.1. ROUTINE CONTROLS and MAINTENANCE

8.1.1 Before any maintenance or cleaning operation, bring certainly the **MAIN SWITCH** Position to 0 position. Apply the machine isolation procedure.

8.1.2. If the machine is not active due to the maintenance or service, hang a proper warning sign determining this to a visible side of the machine.

8.1.3. Be sure that the table and profile stop surfaces on both cutting unit are clean and dry. Clean the chassis and used surfaces from the oils and then dry. Be sure especially that the holding handles are clean and dry.



8.1.4. Clean all surfaces of the machine from burries, excelsiors and foreign materials. Use eyeglasses to protect yourself from the harmful materials.



8.1.5. Control the saw knife against the erosion, deflection, crackage and refractions before every usage. If the saw is damaged, change the saw.

8.1.6. Control the pressure in the air pressure system. If necessary, adjust the air pressure about 7 – 8 bar (As mentioned in the Article 4.4.1)

8.1.7. Control the air pressure filters and oil level in the conditioner. If the oil amount is lack, complete it. (See Article 4.4.1)



Before doing all these actions disconnect the electrical power connection and air pressure connections.

8.2. WORKING DAY OFF MAINTENANCE

8.2.1. Disconnect the Electrical and Pneumatic power connections.

8.2.2. Clean all surfaces of the machine from burries, excelsiors and foreign materials. Use eyeglasses to protect yourself against the harmful materials.

8.2.3. Clean the table, profile stop surfaces and chassis and purde in dry way.

8.2.4 Lubricate both two surfaces of the saw with the machine oil or a protective oil to protect the saw against the corosion.

8.3. GENERAL LUBRICATION

8.3.1. Because the machine is furnished with the lubrication-free ball bearings, it does not require a special lubrication or greasing. Control the conditioner oil level in the pneumatic system periodically. For the oil to be used (See 4.3.1 Article)

8.4. SPECIAL PRECAUTIONS

8.4.1. In the cases that the machine does not work more than a few days, lubricate it to prevent the oxidation on the undyed surfaces. In the case that it works again, clean the oil layer.

8.4.2. If the machine malfunctions for a long time;

- Bring the Main Switch to 0 position
- Close the pneumatic system
- Apply the 9.3.1 and 9.4.1 articles.

9.0 NOISY EMSSION VALUES

9.1. MACHINE CHARACTERISTIC INFORMATION:

- Saw Rotation Speed : 2400 rpm
- Motor Power : 2 kW
- Nominal Voltage : 400 V

9.1.1. TURNINGS ABSORPTION MANIFOLD INFORMATION:

- Manifold Internal Size : 92 mm
- Manifold External Size : 100 mm

9.1.2. SAW CHARACTERISTIC INFORMATION :

- Saw Blade Size : 550 mm (22")
- Saw Blade Thickness : 4.2 mm
- Saw Blade Shaft Thickness : 3.4 mm
- Saw Progress Speed (According to aluminum material) : 64 m/sec

9.1.3. NOISE VALUES :

9.1.4. NOISE VALUES TEST MATERIAL FEATURES:

- Material : Aluminum
- Length :1000
- Width :70
- Height :50

LwA : 98 dB (Measured Value)

LpA : 93 dB (Average Sound Pressure Value As a Result of Measurement)

K : 4 dB (Uncertainty in the Measurements)

The values given for the noise are the emission level and it does not show that it is in the safe working level. A connection between emission and exposure levels is available, however it is not used confidently for the determination whether these more advanced precautions are necessary or not. The factors that affect the real level of exposure, affecting the working power, are residence time, features of working place, in other words other noise resources, actions on other side and the number of the machines. Furthermore, the exposure level given permission can change from country to country. This information, however, provides the machine user to evaluate the hazard and risks well.

10. TROUBLESHOOTING GUIDE

Our suggestions to remove the emergency problems are above. If it cannot be troubleshooted or if you encounter a failure except of the followings, please consult to the technical service.

PROBLEM	CAUSE	SOLUTION
Low surface quality (In aluminum and similar materials): Rough surface, Coarse Turnings, Nonhomogeneous surface, The saw traces are too clear	Saw blade surfaces not cooled.	Lubrication to the saw cutter surfaces, Use the cooling liquid
	To use defective saw blade or saw with worn teeth	Check the teeth of the saw, there may be broken tooth. If you find a mistake, change the saw.
	The cutting progress of the saw is too fast	The cutting progress is too much according to the material. Delay the cutting progress time.
Motor does not work (the motor pressed to Start button does not work)	There is no machine electrical power connection	Check the electrical cable connections.
Motor works, but it does not start the cutting action although the saw group cutting start button is pressed.	The air power resource connections are lack or defective The clamp pistons are not in the tightening position. The brake system on the movable cutting unit is not activated.(DC 550 M)	Check the air compressor connections Adjust the air pressure from the conditioner on the machine between 6-8 bar Bring it in the active position by rotating the button of the brake system on the movable cutting unit.
The saw blade rotates reverse.	The electrical connections, energy cable or the connection on the board is defective	Make the electrical connections done to a licenced and authorized electrician.

<p>The clamps that tightens the profile does not work</p>	<p>The air power connection is lack or air pressure is low The brake system on the movable cutting unit is not activated.</p>	<p>Review the air connections. Bring it in the active position by rotating the button of the brake system on the movable cutting unit.</p>
<p>The barcode printer does not write</p>	<p>It is in Print OFF Position. The Print prepare button is not pressed.</p>	<p>Come from the service page to Print ON Position Activate it by pressing the Print button If the trails do not give result, close the switch and open it again</p>