

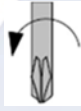
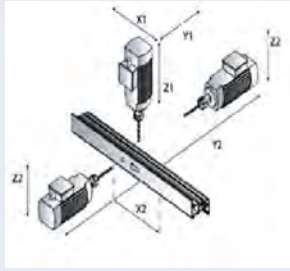
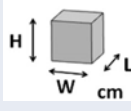




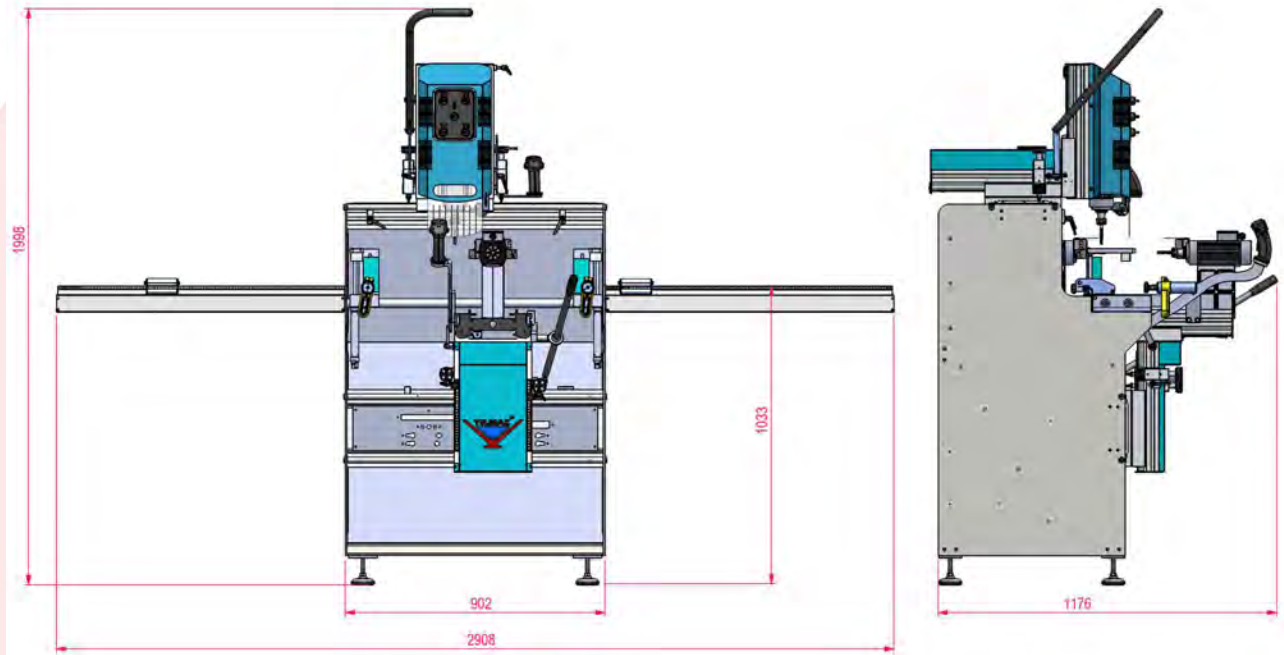
TECHNICAL FEATURES

												
											kg	kg
CRM 250S	230V 1P 200 Hz	1100W*3	6-8 BAR	10 Lt/dak. Lt/min.	12000 dev/dak RPM	x1,x2 = 650,350 mm y1,y2 = 180,230 mm z1,z2= 170,150 mm		W = 110 L = 110 H = 180		370	380	

MODEL TYPE MODEL		RATED CURRENT NOMINAL AKIM	10A
SERIAL NO	CRM 250S	IDLING REV. DEVİR SAYISI	12000 x3 RPM
PROD.DATE ÜRETİM TAR.		AIR CONSUMP.	10 Lt/min
TOTAL POWER	2200 W	AIR PRESSURE	6-8 BAR
RATED VOLTAGE NOMİNAL GERİLİM	230V AC 1P NPE	WEIGHT	380KG.

DIMENSIONS

FIGURE 1



PARTS LIST

FIGURE 2

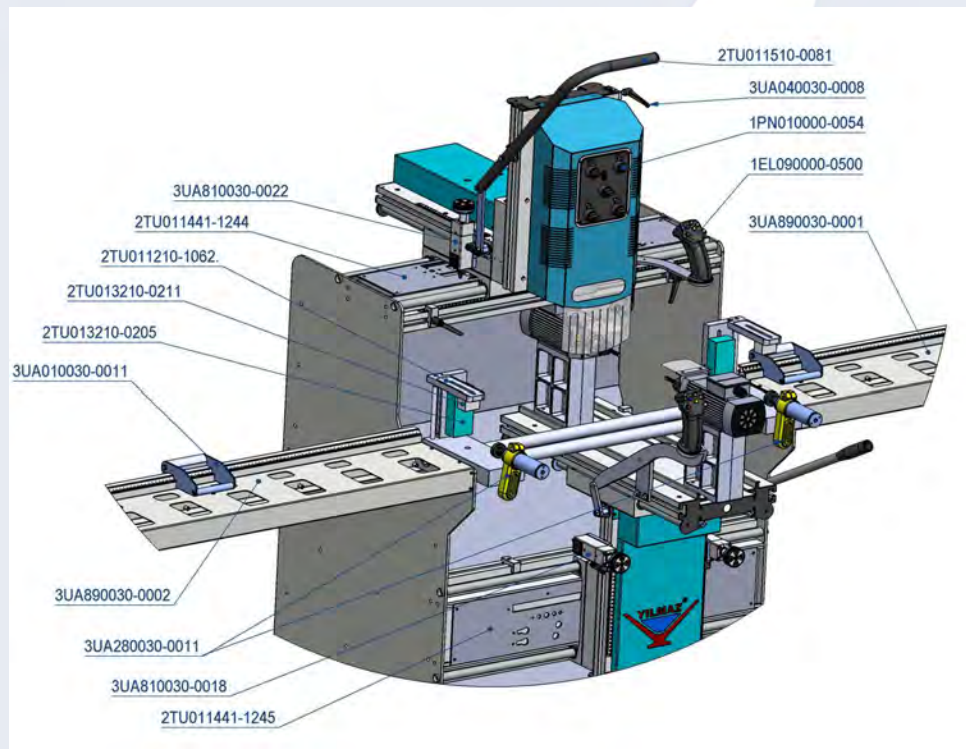


FIGURE 3

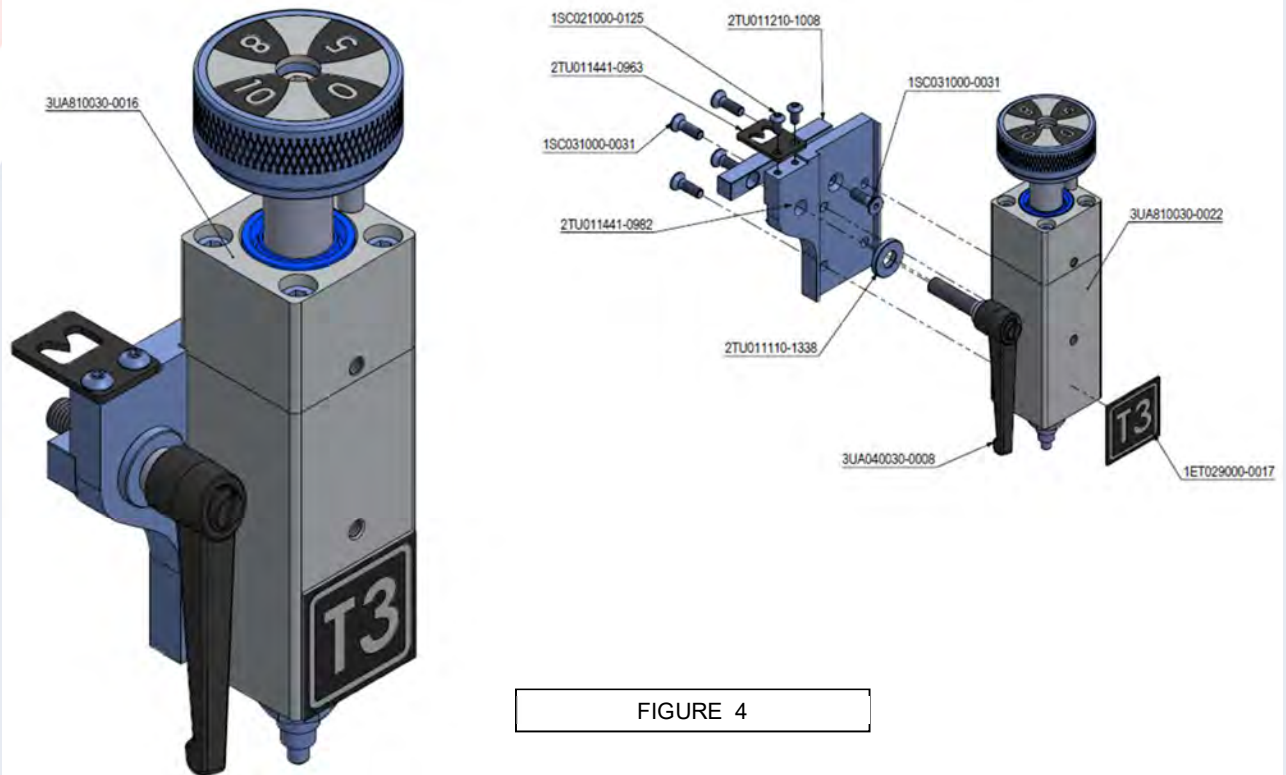
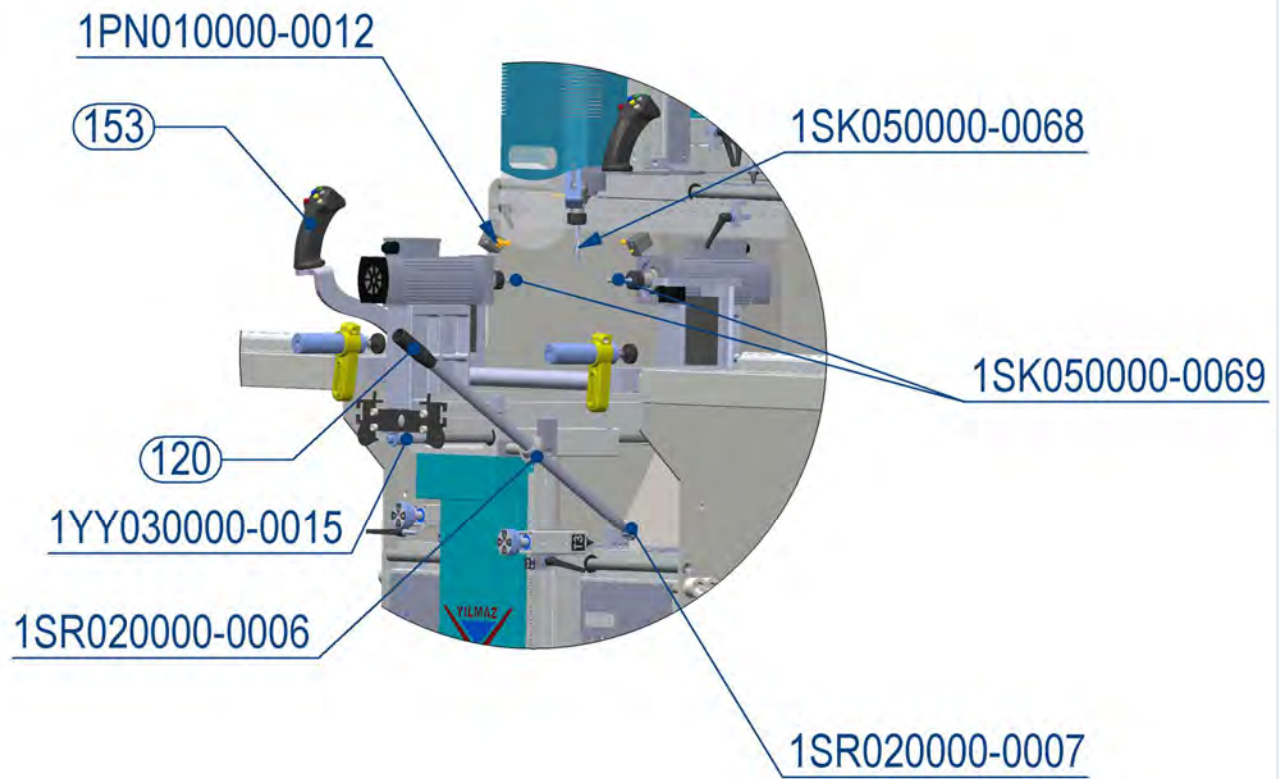
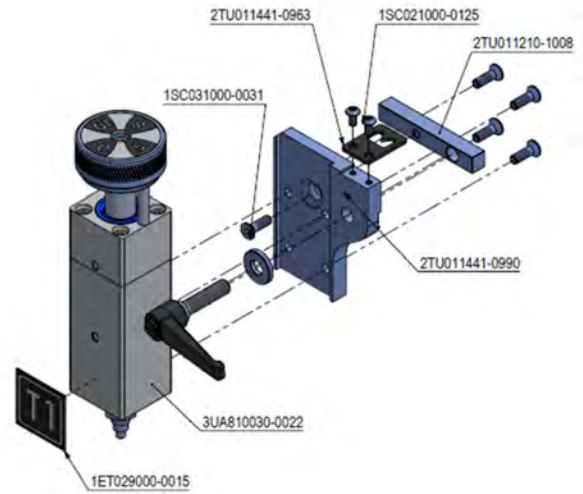
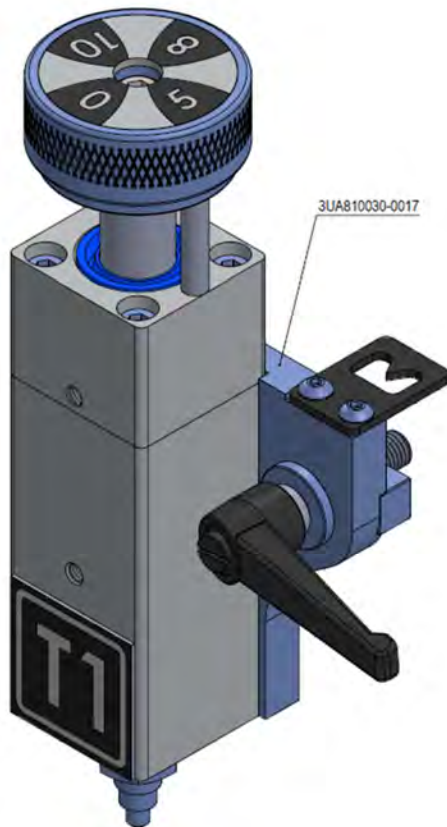





























FIGURE 4

FIGURE 5



SPARE PART LIST			
PART NO	PICTURE	STOCK CODE	PART NAME
1		3UA810030-0017	TEMPLATE LEFT PISTON MOUNTING
2		3UA810030-0016	TEMPLATE RIGHT PISTON MOUNTING
3		3UA810030-0015	LEFT SUPPORT MOUNTING
4		3UA810030-0014	RIGHT SUPPORT MOUNTING
5		3UA810030-0011	KN 152 SUPPORT- SEMI/COMPLETE
6		3UA280030-0011	CLAMP MOUNTING
7		3UA040030-0008*8 3UA040030-0007*2	PIPE HANDLE 3 M8*32
8		3UA040030-0002	PIPE HANDLE 1 (M10*50)
9		2TU011441-0975	SPRAY MIST CONNECTION PLATE
10		2TU012210-1258	FIXING PLATE
11		2TU012610-0044	CLAMP PISTON CONNECTION
12		2TU011210-1007	TRACER PIN
13		2TU011110-1345	JOYSTICK FIXING BOLT
14		1PN010000-0012	SPRAY VALVE

15		1EL090000-0500	JOYSTICK ARM
16		1EL070004-0014	MOTOR 1.1Kw 12,000
17		1SK050000-0069	Ø10.0 L100- SINGLE HEAD
18		1SK050000-0068	Ø5.0 L100- SINGLE HEAD
19		1YY030000-0016	TOP HEAD GAS SPRING 1
20		1YY030000-0017	BOTTOM HEAD GAS SPRING 2
21		1YY030000-0015	FRONT GAS SPRING 3
22		1YY030000-0014	REAR GAS SPRING 3
23		1SR020000-0007	BALL JOINT
24		1SR020000-0006	ROD EYE
25		2TU013210-0205	BACK GAUGE
26		2TU013210-0211	UPPER CLAMP PAD
27		1PL010000-0033	FRONT CLAMP TIP

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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. Service Information

In case of any technical problem please contact your nearest ATech dealer, or ATech head office through the following 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.

Average life usage of production is 10 years. If you have any further failure and complaint, please inform to our below mentioned technical service by verbal or written

AUTHORIZED DISTRIBUTOR

Atech Machine, Inc., 8539 Ziggy Lane, Gaithersburg, MD 20877 - USA

Tel +1-240-505-1967

Fax +1-350-6627

E-mail info@ATechMachinery.com













Web www.ATechMachinery.com

To minimize the documentation, It is necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines

- | | |
|------------------------------------|--|
| • Machine model | • Voltage and frequency |
| • Machine's serial number | • Date of purchase |
| • Description of the machine fault | • Name of dealer where machine was purchased |
| • Average daily operation period | |

2. SAFETY

2.1. Safety Symbols and Their Meanings

	Read the user guide		Ensure safe working position, always keep your balance.
	Wear ear protectors		Electrical excitation
	Wear safety goggles		Don't place your hands between parts in motion..
	If the power cable should be damaged during operation, don't touch and unplug it. Never use damaged power cables.		High temperature warning
	During saw blade change operations, use protective gloves		Keep your fingers clear of the movable parts of the glide arm.
	The above symbol DANGER WARNING , warns you against specific dangers, and you have definitely to read them..		The IMPORTANT symbol above is one telling to apply special care and to be careful at carrying out the specified operation

2.2. Accidents Prevention

- 2.2.1 Our machines are manufactured in accordance with CE safety directives, which cover national and international safety directives.
- 2.2.2 It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.
- 2.2.3 It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.
- 2.2.4 Machine should be operated only by staff members, who have read and understood the contents of this manual.
- 2.2.5 All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty

2.3. General Safety Information

- 2.3.1 The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the inlet and outlet sockets
- 2.3.2 Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated values.
- 2.3.3 Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The lighting of indoor work system)
- 2.3.4 Do not leave any things on the machine.
- 2.3.5 Don't use any materials other than those recommended by the manufacturer for cutting operations on the machine.
- 2.3.6 Ensure that the work piece is clamped appropriately by the machine's clamp or vice

- 2.3.7 Ensure safe working position, always keep your balance.
- 2.3.8 Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let it replace by a qualified electrician. Keep handles and grips free of any oil and grease.
- 2.3.9 Unplug first, before conducting and maintenance works.
- 2.3.10 Ensure that any keys or adjustment tools have been removed before operating the machine..
- 2.3.11 If you are required to operate the machine outside, use only appropriate extension cables.
- 2.3.12 Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur.
- 2.3.13 Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer).
- 2.3.14 Don't use machines with improper functioning buttons and switches
- 2.3.15 Don't keep flammable, combustive liquids and materials next to the machine and electric connections.

3. MACHINE'S DESCRIPTION

Copy router machines designed to open lock, handle, hinge and window fastening slots onto PVC and Aluminum profiles.

- Channels in different dimensions can be opened independently from copying.
- Pneumatic clamps.
- Pneumatic template pins.

<u>STANDARD ACCESSORIES</u>	<u>OPTIONAL ACCESSORIES</u>
Cutter Ø 5 mm	Mill tip (Ø5 mm)
Cutter Ø10 mm x 2 pc.	Mill tip (Ø 10mm)
Reference stops (Right - Left Conveyor)	Collet Ø8
User's Instruction Manual	Collet Ø10
Service Tool (22 mm)	Special templates
Collet wrench key	
Cooling system	
Copying pattern	
Air gun	

4. TRANSPORT OF THE MACHINE



4.1. The transport should be done by qualified personnel only.

- 4.2. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).
- 4.3. Unless customer requests the contrary, the machine will be delivered with wooden packaging.
- 4.4. Movable parts on the machine should be fixed before carrying out the transport.
- 4.5. The machine size and weight measurements, given the technical specification sheet.

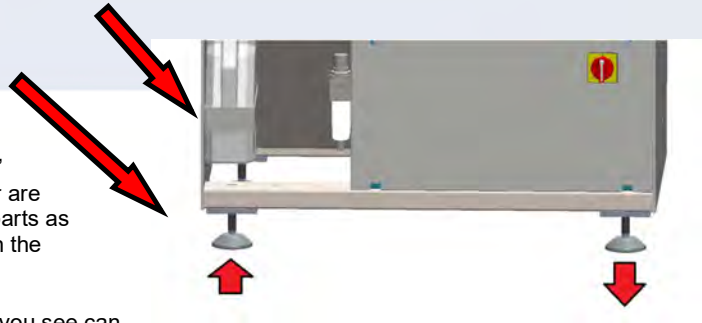
5. INSTALLATION OF THE MACHINE

5.1 Preparation

- 5.1.1 The machine size and weight measurements, given the technical specification sheet. The ground, where the machine will be placed, should be even, solid enough to bear the weight of the machine.
- 5.1.2 The machine should be located approx. 50 cm away from the rear wall. The power connection plug of the machine is located on the rear side of the machine.
- 5.1.3 You can provide the balance of the machine with adjustable counterforts in the bottom part.

- 5.1.4 Profile reference stops '3UA810030-0011' (PICTURE 2) conveyors, shock absorbers and lever are delivered disassembled. Assemble the profile fitting parts as described in the mounting manual given together with the machine.

Install the profile reference stops on the conveyor as you see can see on PICTURE 2



5.2 Connecting to Power Source

- 5.2.1 Electrical connection must be made by a qualified electrician
- 5.2.2 The power outlet socket on the machine should be available.
- 5.2.3 Plug the machine to a grounded socket.



- 5.2.4 Check the supply voltage. **The source voltage must be in accordance with the data on the machine's label.**

- 5.2.5 After electrical connection is made, machine must be operated in idle running and it must be controlled whether rotation directions of cutting tools are correct or not and if the rotation direction is wrong, appropriate connection must be made.

6. MACHINE'S SAFETY INFORMATION

- 6.1 Lifting, installation, electric maintenance of the machine should be carried out by qualified personnel only.
- 6.2 Routine maintenance and scheduled maintenance should be carried out by qualified personnel after unplugging the machine first.
- 6.3 Ensure that the machine has been cleaned, tested and maintained before starting to operate it.
- 6.4 Check the safety devices, power cable and moving parts regularly. Don't operate the machine before having replaced defective safety devices or faulty parts.
- 6.5 Never replace the cutting tools before unplugging first.
- 6.6 Keep foreign materials away from the working area of the machine, keep away from the machine's moving parts.
- 6.7 Do not work on the machine by removing the protective parts



The safety data have been defined above. In order to prevent physical damage or damage to the equipment, please read the safety information carefully and keep the manual always in an easy accessible place.

7. OPERATION

7.1 Preparation

- 7.1.1 Degrease and dry the machine table. Especially ensure that the holding grips and handles are clean and dry
- 7.1.2 Clean all surfaces of the machine from chips and foreign particles. Use eye glasses for protection.
- 7.1.3 Copy router machines can process on products manufactured from rigid plastic and aluminum materials that don't include iron alloy.
- 7.1.4 Control whether cutting tools (FIGURE 2 NO.78) are inserted safely to their places.
- 7.1.5 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them.
- 7.1.6 Cutting tool must process on the part after machine is operated and cycled.
- 7.1.7 **Do not process the profile before clamping the work piece properly.**

7.2 Operation

- 7.2.1 Place PVC or aluminum profile that you are going to process on to the work table. Fix the profile with the clamps that are on the work plate.
- 7.2.2 You can adjust the forward - backward and upward - downward positions of the clamps with the special support piece (PICTURE 6, No 96, 108 and 97). The control of the pneumatic clamps can be operated with the button on which the figure of clamp can be seen on the control panel (PICTURE 2 No: 1PN010000-0054).

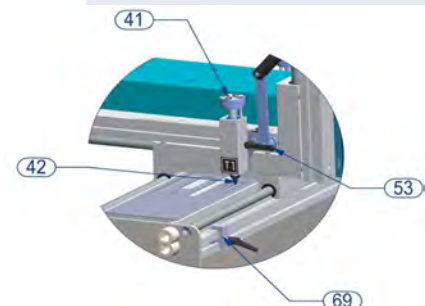
RESİM-FIGURE-PICTYHOK 6



- 7.2.3 Choose from the patterns that are on the machine such as (PICTURE 7) lock, handle, hinge slot etc. Place the tracer pin (PICTURE 7 No: 42) inside the hole automatically in which process will be done by rotating the related button (T1 – T2 – T3 – T4).

RESİM FIGURE-PICTYHOK 7

- 7.2.4 By rotating the head that has been shown at the picture next to here (PICTURE 7 No: 41) to right – left, you can set the tracer pin as Ø5, Ø8 or Ø10mm

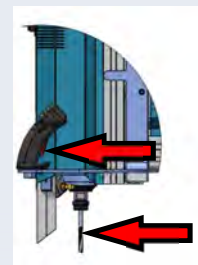


- 7.2.5 You can adjust the forward - backward and upward - downward movement of the tracer pin group (PICTURE 2 No. 3UA810030-0018 and 3UA810030-0022) with the special ratchet handle (PICTURE 7, No 53).

- 7.2.6 Put the system start switch at the back of the machine to "ON".

- 7.2.7 Press continuously to the release button, illustrated at the picture to ensure that the vertical motor runs and the cutting tool 1SK050000-0068 rotates.

- 7.2.8 With the help of the Joystick arm (PICTURE 3 No: 153) on the upper head, you can machine the profile. To reach the preferred depth with the cutting tool, use the up – down movement handle (PICTURE 2 No: 2TU011510-0081).



- 7.2.9 With the help of the handle on the lower group (PICTURE 3 No: 120) move the group and realize the process on the profile. To reach the preferred depth with the cutting tool, move the joystick arm (No: 153) forward and backwards.



- 7.2.10 On the joysticks, there is one button on the upper handle and two buttons on the lower handle. On the picture next to this text (No: 153) you see the lower joystick and by pushing the right button the back motor and by pushing the left button, the front motor are spraying the cooling water. By pushing again the same button, you can stop the spraying. In case wanted, you can arrange the amount of spraying from the turning stick on the valve (PICTURE 3 No: 1PNO10000-0012) Same procedures apply for the upper motor group, too.

- 7.2.11 To make free work independent from the template, pull out tracer pin from the hole on the pattern.
- 7.2.12 While making free work, you can arrange the moving area of the head with stopping pieces (2TU012210-1258-3UA040030-0008).
- 7.2.13 For safety reasons, the upper and lower motors do not work at the same time. When you complete the upper motor process, push it forward and distract the milling cutter from the working area. It goes up through dampers. If you see any abnormality in this movement do not start the machine.
- 7.2.14 While the upper motor works or while material is loaded, the forward – backward move of the lower motors is put to middle position through the dampers to prevent crashes. Always check the positions of the dampers and be careful for the possibility of collision of the milling cutter tips.
- 7.2.15 When the process is finished, leave the button. The cutting tool will stop after approximately running 10 seconds idle.
- 7.2.16 Open the clamps and take the piece out.

8. MAINTENANCE, SERVICE AND REPAIR

8.1 Maintenance

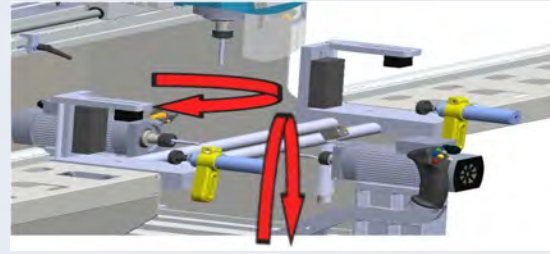
- 8.1.1 Cut the electric and pneumatic (if any) power connections of the machine.
- 8.1.2 Clean all surfaces of the machine from burs, chips and foreign substances. If the machine will not be used for a long time, lubricate undyed parts with oil that prevents rusting.
- 8.1.3 When cleaning the machine, do not use materials that may damage the dye.
- 8.1.4 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them.
- 8.1.5 Before using cutting tool, operate the machine out of gear and control whether it is inserted correctly, it is without flexure and it is inserted appropriately. Do not use cutting tools that are damaged or lost its functionality.

8.2 Changing the cutting tool

- 8.2.1 Cut off the electric connection of the machine.

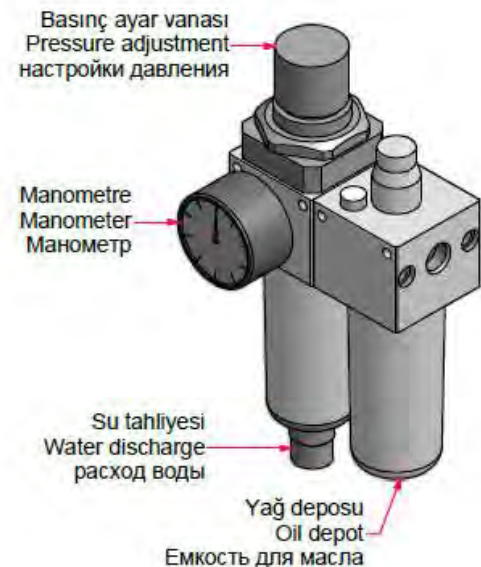
8.2.2 Collets supplied with machine by turning it counter clockwise with the help of wrenches that are given with the machine. Remove cutters (FIGURE 3 NO. 1SK050000-0068-69) by loosening the nut. Tighten the collet nut by inserting the new cutter to the collets.

8.2.3 Before using cutter, check them if they are fixed correctly and inserted appropriately. Do not use cutting tools that are damaged or lost its functionality.



8.3 Adjust the air pressure (pneumatic systems)

- 8.3.1 Pull up pressure adjustment valve. Set adjustment valve to the desired value on manometer by turning it clockwise or counter clockwise. Then lock the valve by pressing it down.
- 8.3.2 Set the air pressure between 6 and 8 BAR. If air pressure drops below the stated values, accessories operating with pneumatic power do not work.
- 8.3.3 Conditioner unit accumulates the water in the air in the collection container so that it won't damage pneumatic components. At the end of the working day, empty the accumulated water by opening water discharge valve under the collection container.
- 8.3.4 In order to put oil to the oil tank, remove the reservoir by turning. Oils recommended by the manufacturer are; TELLUS C10 / BP ENERGOL HLP 10 / MOBIL DTE LIGHT / PETROL OFİSİ SPINDURA 10.



9. WARRANTY CONDITIONS

ATech Machine Inc. guarantees that all machines have been tested and conform to the international standards.

The guarantee is valid 24 months from dispatch date and does not cover the electrical parts of the machine.

During this period:

- Any repair and replacement effected at our workshop is completely free of charge (only transport costs are at customer's charge).
- For repair and replacement effected by our technician at the customer's site, we will invoice only the travel and lodging costs for our technician.

The guarantee does not cover damages caused by:

- not respect of the rules indicated in the manual instruction book
- not correct voltage
- improper use or use not in accordance with what the Machine has been designed for
- use of non original tooling
- programming errors

- lack of cleaning and of ordinary maintenance by the customer
- transport or displacement (even inside the workshop)
- natural events (lightnings, fires, floods)
- Phase failure or overvoltage, failures due to faulty electrical installation
- The problems caused by the absence of grounding in the electrical installation

The warranty does not cover, in any case, damages caused by the malfunction of the Machine

10 Mounting Manual

10.1- Installation of the Dampers

A- Horizontal Platform Damper Installation

A.1- Loosen the clamp lever on the platform (Picture 1-1), pull the platform toward one self through the control lever (Picture 2-1).



Pic .1- 1



Pic. 2.1

Pic.2-1

A.2- The damper that comes with the machine shall be screwed to its place as it can be seen on the picture and the bolt must be firmly tightened (Picture 3-1, picture 4-1)



Pic. 3-1



Pic. 4-1

By this, the installation of the horizontal platform damper installation is realized.

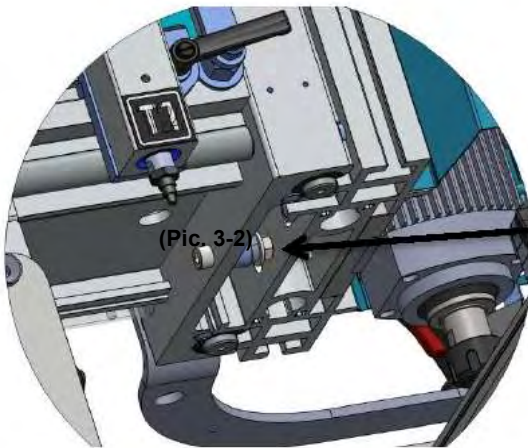
B- Vertical Head Damper Installation

B.1- Loosen the clamp lever (picture 1-2), through the black color arm pull the head up (picture 2-2)



(Pic. 2-2)

B.2- Without changing this position, the ferrule, thin ferrule and screw shall be detached (picture 3-2) and it will be prepared. First, the thick ferrule shall be placed between the damper and profile as seen on the picture (Picture 4-2), here attention must be paid that the holes must overlap.



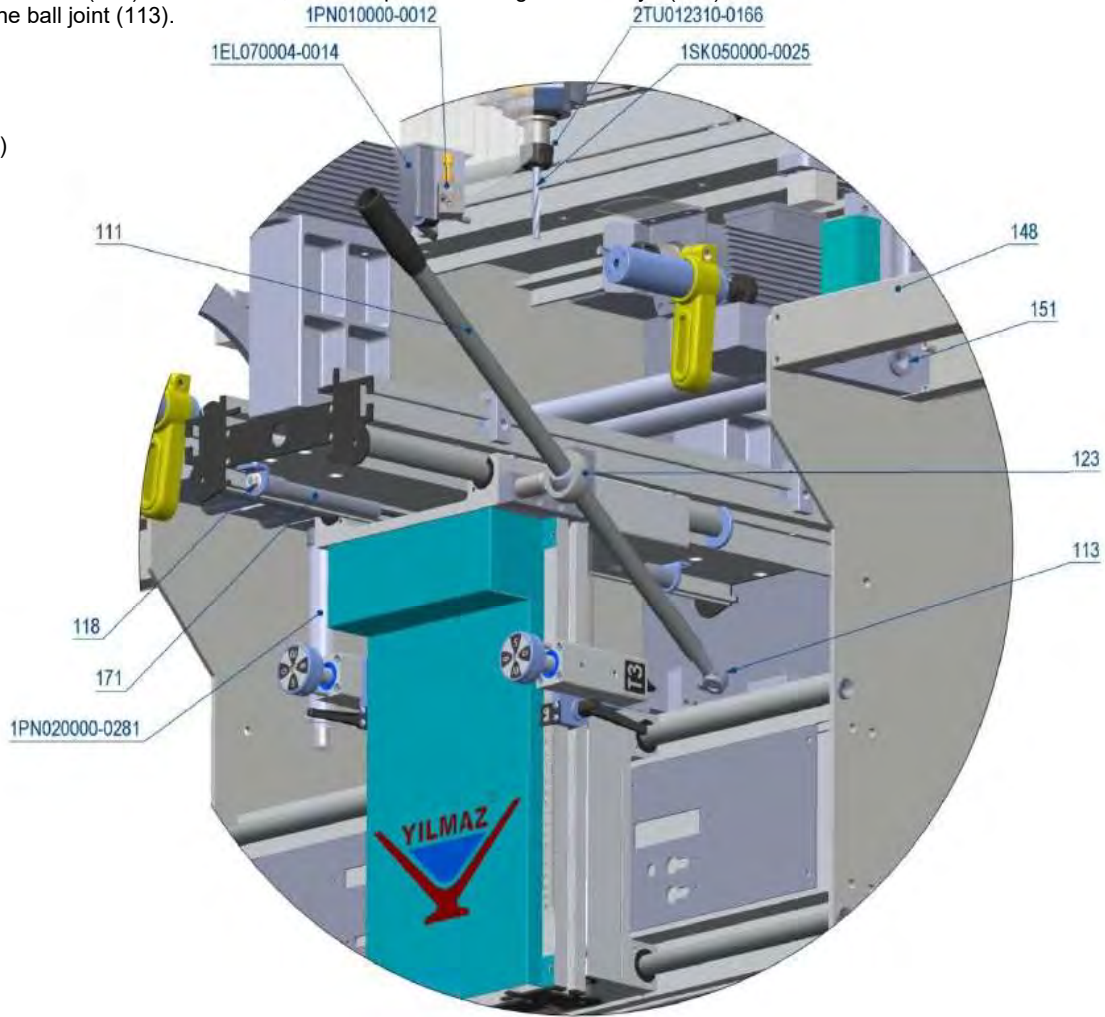
(Pic.4-2)

While in this position, the screw will be installed so that it passes through the hole of the damper and after the thin ferrule will be put on the screw and the installation is finished with the bolt screwed.

10.2- Motion Lever Installation (piece no 111)

While the Lever (111) is demounted, it will be passed through the rod eye (123) of the machine and then will be screwed with a bolt to the ball joint (113).

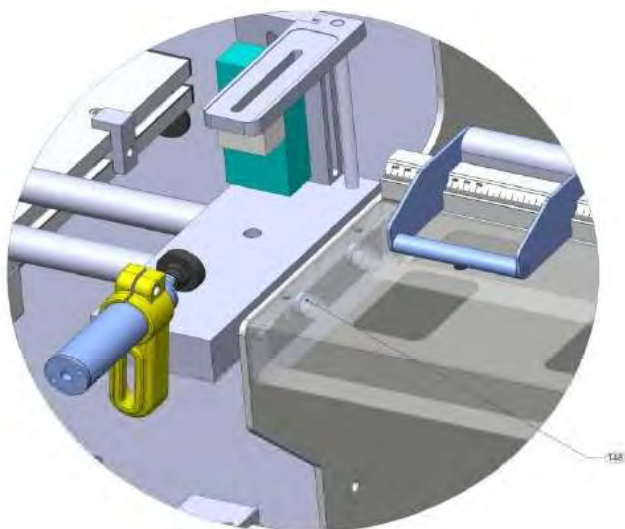
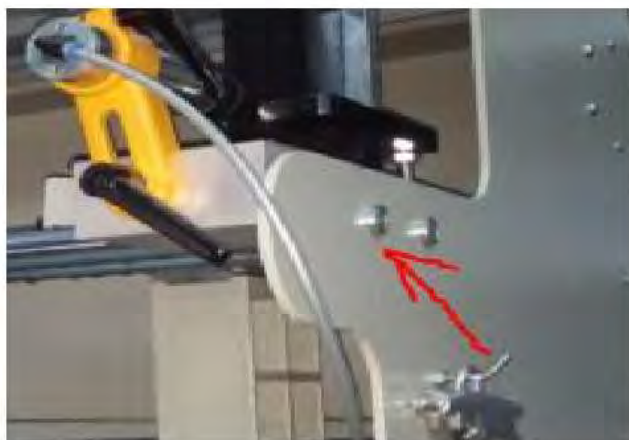
(Pic.1-3)



10.3-CONVEYOR INSTALLATION

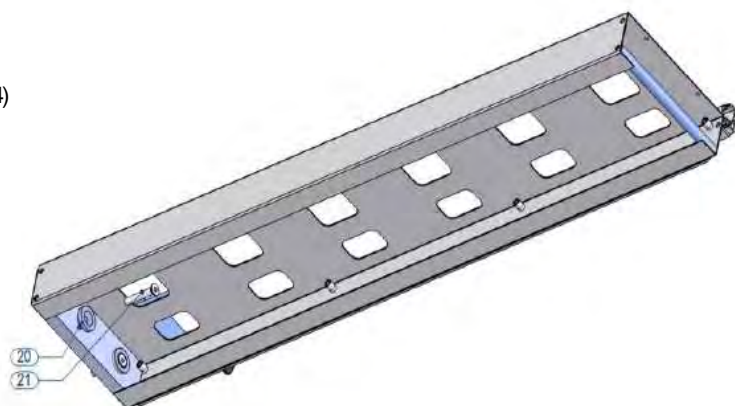
The conveyors are adjusted as right and left so that the meter parts are at the back and at the same time, from two of the bolts that hold the clamp pin, only one screw, without removing the ferrule (148) (As shown at the picture below) will be taken out and it will be fastened so that it fits on the conveyor ferrules.

(Pic.14)



At this stage, ferrule no 20 and bolt number 21 that come with the machine will be firmly screwed to the hole detached. The other bolt not dismantled shall be also dismantled and the same procedure shall be applied for this bolt. The bolts that we remove have to be saved to be used during the dismantling of the conveyors. The same procedure must be followed on the other conveyor, too.

(Pic.24)





ELECTRIC&PNEUMATIC DIAGRAM

