Translation of the original operating instructions

This manual must be kept for future reference and must always remain with the machine

CU410 ELITE S

INSTRUCTION MANUAL

CE

COMBINED UNIVERSAL MACHINE FOR WORKING WITH WOOD AND MATERIAL WITH SIMILAR PHYSICAL CHARACTERISTICS



Rel. 1.0 / 06-2011 **0000521316B** **EN**

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MANUFACTURER:	**SCM INDUSTRIA S.p.A.**
ADDRESS:	**Via Valdicella, 7 - 47892 - Gualdicciolo - Rep. San Marino**
DESIGNATION:	**COMBINED UNIVERSAL MACHINE FOR WORKING WITH WOOD AND MATERIAL WITH SIMILAR PHYSICAL CHARACTERISTICS**
BRAND:	**MINIMAX**
TYPE:	**C-03**
MODEL:	**CU410 ELITE S**
SERIAL N°:	
TYPE OF DOCUMENT:	**INSTRUCTION MANUAL**
DOCUMENT CODE:	**0000521316B**
EDITION:	**Rel. 1.0 / 06-2011**
CONFORMITY:	CE

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DICHIARAZIONE "CE" DI CONFORMITA'

(AI SENSI DELL' AII.IIA DELLA DIRETTIVA 2006/42/CE E DI ALTRE DIRETTIVE APPLICABILI)

"EC" DECLARATION OF CONFORMITY

(IN ACCORDANCE WITH ANNEX II A TO DIRECTIVE 2006/42/EC AND OTHER DIRECTIVES APPLICABLE)

IL FABBRICANTE: *THE MANUFACTURER:*	**SCM INDUSTRIA S.P.A** **VIA VALDICELLA 7 - 47892 GUALDICCIOLO (R.S.M.)**

DICHIARA CHE LA
DECLARES THAT THE

MACCHINA: *MACHINE:*	**COMBINATA UNIVERSALE PER LA LAVORAZIONE DEL LEGNO E DI MATERIE CON CARATTERISTICHE FISICHE SIMILI** **COMBINED UNIVERSAL MACHINE FOR WORKING WITH WOOD AND MATERIAL WITH SIMILARY PHYSICAL CHARACTERISTICS**		
MARCA: *BRAND:*	**Minimax**	N°DI SERIE: *SERIAL No.:*	
TIPO: *TYPE:*	**C-03**	ANNO DI COSTRUZIONE: *YEAR OF CONSTRUCTION:*	
MODELLO: *MODEL:*	**CU410 ELITE S**		

E' CONFORME A TUTTE LE DISPOSIZIONI PERTINENTI DELLE SEGUENTI DIRETTIVE:
COMPLIES WITH ALL THE RELEVANT REGULATIONS IN THE FOLLOWING DIRECTIVES:

2006/42/CE	***2006/42/EC***
2004/108/CE	***2004/108/EC***

ORGANISMO NOTIFICATO CHE HA EFFETTUATO L'ESAME CE DI TIPO *NOTIFIED BODY WHICH DELIBERATED ON THE "EC" TYPE EXAMINATION CERTIFICATE*	**CERMET Soc. Cons. arl. - NB 0476** **HEADQUARTER ITALY - VIA CADRIANO, 23** **40057 CADRIANO di GRANAROLO E. (BO) ITALY**
NUMERO DI ATTESTATO D'ESAME CE DI TIPO *NUMBER OF "EC" TYPE EXAMINATION CERTIFICATE*	**C09E223/09**

PERSONA AUTORIZZATA A COSTITUIRE IL FASCICOLO TECNICO: *PERSON AUTHORISED TO PRODUCE THE TECHNICAL FILE:*	**SCM GROUP spa Via Emilia n°77** **I - 47921, Rimini (RN) - ITALY**

IL RAPPRESENTANTE DELEGATO DEL FABBRICANTE
THE MANUFACTURER'S REPRESENTATIVE

CITTA', ***DATA***,

*** IDENTIFICAZIONE FIRMATARIO ***
FIRMA AUTOGRAFA

[IT] LINGUA ORIGINALE DICHIARAZIONE
[EN] TRANSLATION OF DECLARATION ORIGINAL LANGUAGE

FACSIMILE OF THE COPY OF THE "EC" DECLARATION PRINTED ON WATERMARKED PAPER THAT IS DELIVERED TO THE CUSTOMER

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1.1 AIM OF THE HANDBOOK

(ev-1-1_0.0)

Responsible for the introduction of the machine onto the EU market in compliance with article 9, paragraph 2 of the EMC 2004/108/EC Directive
SCM GROUP S.p.A. Via Emilia n.77, I-47921, Rimini (RN) - ITALY

This handbook has been written by the machine manufacturer and is an integrating part of the machine[2].
The information serves for qualified technicians[3].

With this handbook we wish to give you all information regarding to the use and maintenance of the machine: in this way you are sure to protect the production as well as the equipments.

The handbook defines the proper use of the machine and gives all information necessary for:
- right use of the machine
- working economy
- long operation life

If the instructions are always kept, it is possible to guaranty safety conditions for the operator, safe machine operation, service economy and a longer life of the machine.

To make the easier, the handbbok is divided in proper sections.
To quickly find the subject, see the Contents.



NOTE-INFORMATION:
some images present in this handbook may:
- not exactly correspond to the real machine version when this does not influence the validity of the information and instructions described and does not prejudice the safe operation.
- Be indicated without safety guards in order to make the parts described in the text more visible.



DANGER-WARNING:
the safety guards are necessary to ensure the safe machine operation and the working without the safety guards is forbidden.

SCM sales organization is always at your disposal for any technical problem (reparation, spare part delivery etc.) and to improve your business.
Keep this handbook for future information besides it shall always be with the machine.
SCM is not responsible for damages caused by wrong use or maintenance of the machine.

For any technical problem apply to SCM dealer:

2 The definition "machine" replaces "CU410 ELITE S" machine name.

3 Technicians who, thanks to their technical background and experience, are able to recognize and to avoid possible dangers during:
- the machine transport
- the installation
- the machine use and maintenance.

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1.2 MACHINE IDENTIFICATION

(gg-1-2_0.0)

Machine data are punched on the metallic plate applied to the side of the machine frame.

Designation		Abbreviated, conventional description of the machine designation and its function
Marca		Merchandise mark
Anno		Production year
N° Serie		Serial number
kg		Weight (kg)
Tipo		Machine type
Modello		Machine model
Un	V	Rated voltage (volt)
~		Phases number (alternate current)
In	A	Rated current (ampere)
F	Hz	Frequency (hertz)
Icc.	kA	Short circuit breaking capacity of the protective device (kA)
w.d.		Wiring diagram number
Comp.		Machine configurations
Ref.		Internal references



1.3 MAIL CONTACT

(gg-1-3_0.0_ce)

Writing or telephoning to the dealer or to SCM for problems concerning your machine, always specify the following information:

1) machine model
2) serial number
3) voltage and frequency
4) purchase date
5) name of the dealer where the machine was bought
6) detailed information about the trouble
7) detailed information about the working to be carried out
8) period of use - number of working hours

Manufacturer's address:

SCM INDUSTRIA S.p.A.
Via Valdicella, 7
47892 - GUALDICCIOLO - (R.S.M.)
E-mail: info@minimax.sm
web-site: www.scmgroup.com

Assistance Department
from Italy: Tel. 0549/876910 - Fax. 0549/999604

from abroad: Tel. 00378 - 0549/876912 - Fax. 00378 - 0549/999604
E-mail: info@minimax.sm

Spare Parts Department
from Italy: Tel. 0541/674714 - Fax. 0541/674720

from abroad: Tel. 0039 - 0541/674714 - Fax. 0039 - 0541/674720
E-mail: mastolfi@scmgroup.com

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1.4 NOTES FOR THE USER

(gg_1-4_0.0_ce)

The handbook describes all operations required for the normal maintenance of the machine.
Do not carry out any operation not described in this handbook.
All operations which require to desmount machine members as well as maintenance operations shall be carried out only by authorized technicians.
For the correct use of the machine carry out the proper instructions given in this handbook.
Only trained and authorized technicians may use the machine and carry out maintenance operations.
Keep the general safety norms as well as the rules of industrial medicine.
Keep this handbook for future necessity.

NOTE-INFORMATION:
- use only SCM ***parts. The manufacturer is not responsible for damages due to the use of not original parts.***

1.4.1 ABBREVIATIONS USED IN THIS HANDBOOK

(gg-1-41_0.0_ce)

pag.	=	page
fig.	=	figure
par.	=	paragraph
chap.	=	chapter
i.e.	=	example
ref.	=	reference
DPI	=	Individual protective equipment (IPE)

1.4.2 ENCLOSED DOCUMENTATION

(mmax_1-4-2_0.0)

The following attachments are an integral part of this instruction manual:

- Electrical diagrams (read the number of the electrical diagram on the identification plate placed on the machine in the "W.D." line).
- Spare parts catalogue

NOTE-INFORMATION:
the electrical diagrams are for the exclusive use of competent technicians, therefore they are only in Italian and English.

1.5 SYMBOLS USED IN THIS HANDBOOK

(gg-1-5_0.0_ce)

OPT	***OPTIONAL = devices indicated in list price available only upon request.***

	***Operator position.***
	***DANGER-WARNING: imminent dangers could cause serious injuries; careful attention is needed.***
	***NOTE-INFORMATION: technical, very important information.***
	***READ-MANUAL: indicates that before using the machine, you must read the instructions manual and understand all its parts***
	***FORBIDDEN: indicates manouvres, commands or others that cannot be carried out as they can create very dangerous situations for persons and damage the machine.***
	***CAUTION: suitable measures should be taken to prevent accidents or to prevent things from being damaged.***
	**MACHINE OFF STATUS** efore carrying out any type of maintenance and/or making any adjustment to the machine, all of the power supplies (electric and pneumatic) must be switched OFF. Make sure that the machine is stopped power supplies electric and pneumatic (if is present) must be switched OFF. Make sure that the machine is stopped and that it is impossible for it to start up unexpectedly (main switch in the “0” position and locked; compressed air cut-off valve closed and compressed air cut-off valve closed and locked).

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Personnel who will be working on the machine must, apart from being professionally trained for the job, read the manuals paying particular attention to the safety regulations and the paragraphs relative to his area of competence. The machine operators are identified as follows:



ASSIGNED OPERATOR

A professionally trained operator who is at least 18 years old, in compliance with the laws in force in the country where the machine is being used, qualified to exclusively turn on, use, tool-up, set (only with the safety devices enabled and the machine turned off) and to switch off the machine, in full compliance with the instructions given in this with the instructions given in this manual.



MAINTENANCE ELECTRICIAN

A qualified technician (electrician with the technical/professional qualifications required by current regulations), authorized to exclusively carry out operations on the electric devices in making adjustments, performing maintenance and/or repairs, even with the power supply ON and the safety devices disabled (subject to the consent of the health and safety officer), in full compliance with the instructions given in this manual or in other specific documents furnished exclusively by the Manufacturer.



OPERATOR IN CHARGE OF MOVING THE MACHINE

A professionally trained operator who is at least 18 years old, in compliance with the laws in force in the country where the machine is being used, qualified to drive fork lift trucks, bridge cranes or cranes used to safely move the machine and/or parts of the used to safely move the machine and/or parts of the machine.



MAINTENANCE MECHANIC

A skilled technician qualifi ed to exclusively carry out operations on the mechanical, hydraulic and pneumatic parts of the machine, to make adjustments, perform maintenance and/or repairs, even with the safety device disabled (subject to the consent of the health and safety officer), in full compliance with the instructions given in this manual or in other specific documents furnished exclusively by the Manufacturer.



COMPANY HEALTH AND SAFETY OFFICER

A qualified technician, designated by the Client with the technical/professional qualifications required by current regulations relative to worker health and safety in the by current regulations relative to worker health and safety in the workplace.



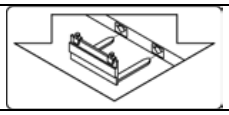
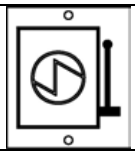
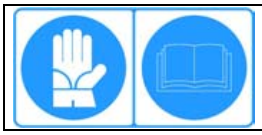
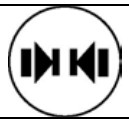
MANUFACTURER'S TECHNICIAN

A qualified technician sent by the Manufacturer and/or Dealer who is authorized to provide required technical assistance, to perform routine and extraordinary maintenance operations and/or operations not referred to in this manual which require specific and detailed knowledge of the machine.

1.6 SYMBOLS ON THE MACHINE

(gc-1-6_0.0_ce)

CAUTION:
the operator must pay attention to the signs and plates fixed on the machine.

	***Forks insertion point for lifting the machine with a fork lift truck***	**- A -**
	***Danger due to electric power***	**- B -**
	***It cuts electrical power supply to the machine***	**- D -**
	***Use gloves for handling the tools*** ***Read the manual and follow the manufacturer's instructions***	**- E -**
	***Blade dimensions plate***	**- F -**
	***Technical specifications plate***	**- G -**
	***Indicates the point where the hooks shall be applied for machine raising***	**- L -**
	***Locking symbol***	**- M -**

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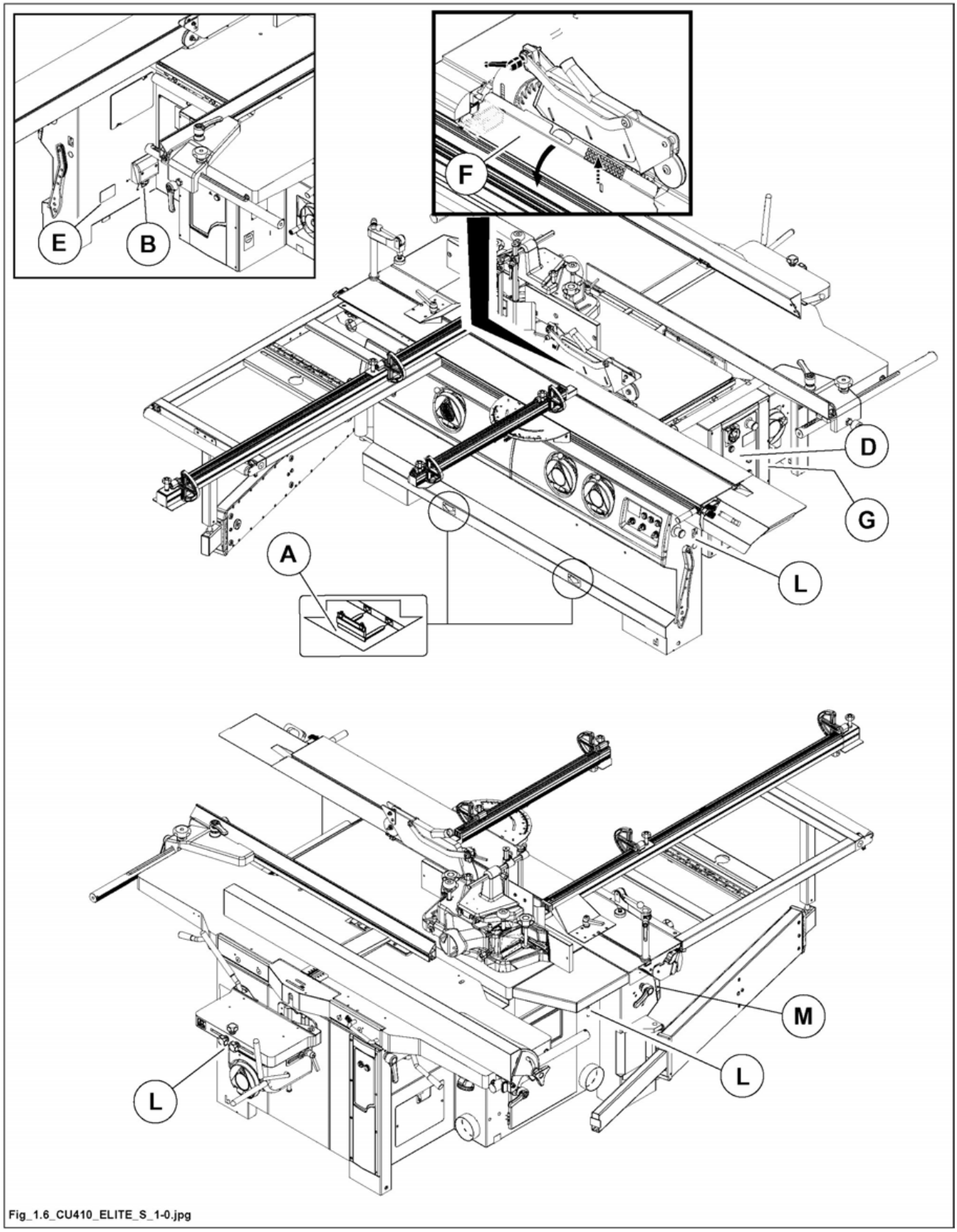
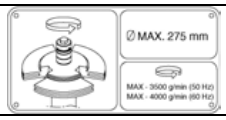
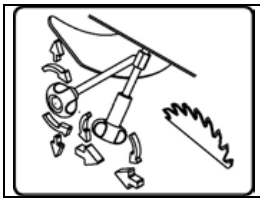
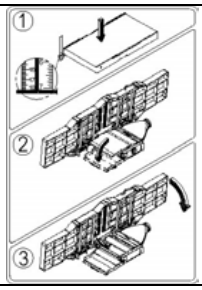
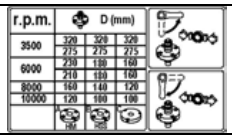


Fig. 1.6

	*Danger: cutting of upper limbs (rotating tools)*	**- N -**
	*Indicates the tool rotation direction*	**- O -**
	*Thicknessing table adjusting*	**- P -**
	*Inlet table adjusting*	**- Q -**
	*Tenoning hood warning plate*	**- R -**
	*Scoring saw adjustment plate*	**- S -**
	*Thickness speed selection plate*	**- T -**
	*Table closure plate*	**- U -**
	*Moulder spindle speed for positioning belt plate*	**- V -**
	*Moulder spindle speed for tool type and diameter*	**- Z -**

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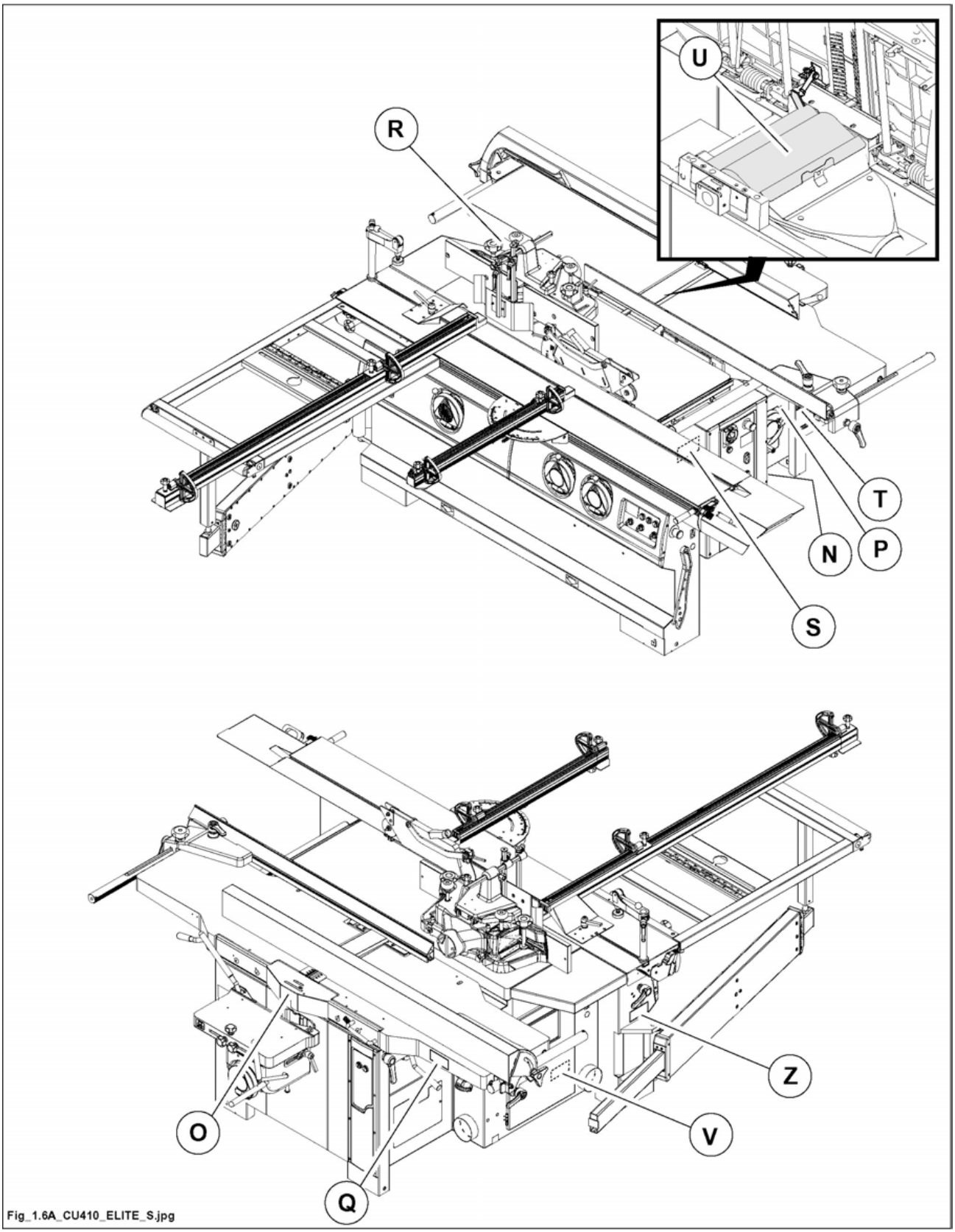


Fig. 1.6A

1.7 MACHINE DESCRIPTION

(ev_1.7-0.0)

The machine is a universal combined 6-working cycle machine. Available in two different versions with fixed or inclinable router, respectively, and sliding wagon of 2250 mm, 2600 mm or 3200 mm.

The machine is equipped with a scorer to prevent wooden panels from splitting during cutting. Thanks to its working capacity and flexibility, this machine can meet any user's requirement.
The saw blade inclination makes it practical and easy to execute any type of machining. Using the parallel fence, largesized panels can be trimmed or sectioned.

The basic machine parts are herein referred to and described to make you quickly familiar with them since they shall be later mentioned in this manual. Please pay attention to the following descriptions:

1 - RULE FOR 90°-CUTS

2 - GUARD FOR SAW BLADES

3 - SAW AND SCORER ASSEMBLY

4 - WAGON-TYPE ALUMINIUM SLIDE

5 - CONTROL BOARD

6 - WORKING TABLE

7 - SUPPORTING FRAME

8 - PRESSER

9 - PUSHER

10 - ADDITIONAL TABLE (EXIT SIDE)

11 - RULE FOR PARALLEL CUTS

12 - MOULDER LIFTING (ELECTRICAL LIFTING ON REQUEST)

13 - THICKNESSING TABLE LIFTING (ELECTRICAL LIFTING ON REQUEST)

14 - SAW GUIDE ASSEMBLY WITH MICROMETRIC RACK ADJUSTMENT (SLIDING ON CYLINDRICAL SECTION GUIDE)

15 - WAGON LOCKING

16 - DEVICE FOR ANGLED CUTS

17 - SAW LIFTING

18 - SAW INCLINATION

19 - REVERSIBLE STOPS

20 - SCORER - ALIGNMENT ADJUSTMENT

21 - SCORER - HEIGHT ADJUSTMENT

22 - WOOD STOP UNIT

23 - SURFACING TABLES

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24 - CUTTER FOR ANGLED CUTS ON SQUARING FRAME

25 - THICKNESSING TABLES

26 - SLOTTER

27 - BUZZ PLANER

28 - MOULDER UNIT

29 - MOULDER INCLINATION (ELECTRICAL LIFTING ON REQUEST)

30 - ELECTRICAL PLUG FOR DRIVE LINK (OPT)

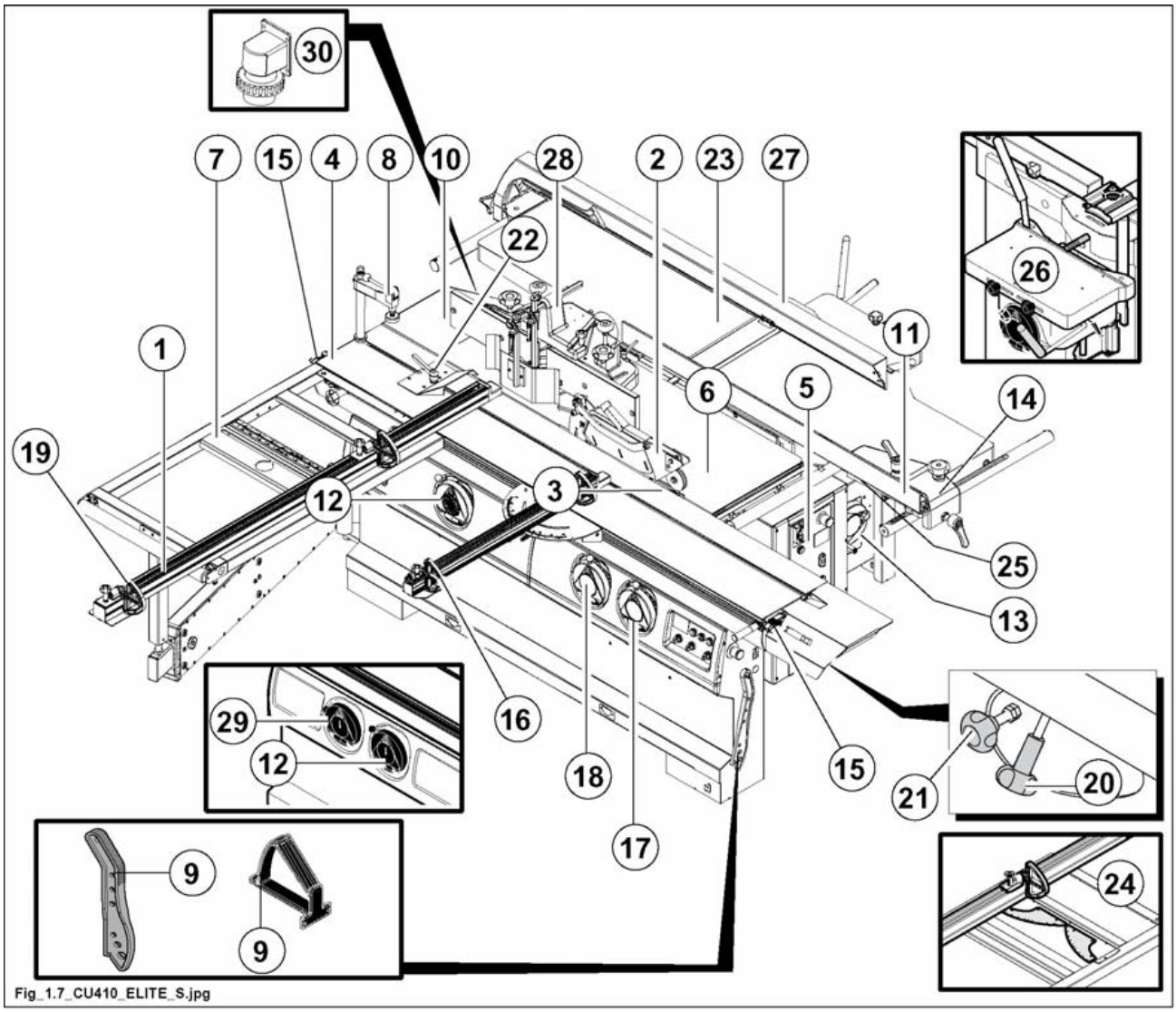


Fig. 1.7

1.8 CONDITIONS FORESEEN FOR THE USE

(ev_1-8_0.0)

This machine has been designed for cutting, squaring, milling, tenoning, drilling and thicknessing solid wood, ber boards, chipboard panels, ply-wood and laminboard, coated and non-coated.

DANGER-WARNING:
materials different from those quoted above, since dissimilar to wood, are thus prohibited: the user is solely responsible for any damage caused by machining such materials.

DANGER-WARNING:
the fitting of circular blades on the spindle is not permitted.
It is forbidden to insert shims between the spacer rings to willingly unbalance the tools.

1.9 TOOLS WHICH MAY BE USED

(ev_1-9_0.0)

The machine has been designed to use only tools for manual feed, in accordance with EN 847-1 Norm, proper for the material used.

By manual feed we mean the piece guidance by means of:
- the hand,
- the sliding table pushed by hand,
- the feeder.

MOULDER

The spindle moulder tools must be of the manual feed type (marked MAN).
Features of the tools required for manual feed:
- max. chip thickness 1.1 mm,
- tool shape round,
- chip exhaust space narrow.

As to the relation between tool and rotation speed see par. 9a.3.

1.10 WORKING ENVIRONMENT

(gg_1-9_0.0)

The machine can work under these conditions:
Max. humidity 90%
Temperature: Min. +1° C Max. +40° C
Max. altitudine sea level: 1000 m (in case of higher altitude apply to the machine manufacturer)

Always connect the machine to the suction system (see par. 4-5).

The machine may not be used in the open air.
The machine was designed for industrial use.

The machine may not operate in explosive rooms.

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1.11 INCORRECT USE THAT CAN BE REASONABLY EXPECTED

(1.1_(01-2010))

- DO NOT use the machine if you are not an authorised and trained operator.
- DO NOT use the machine in ways that differ from those that the machine has been designed for and described in this manual.
- DO NOT use the machine without the required guards for every machining process or removing part of the guards (DO NOT disassemble the fixed and mobile guards, bypass the safety microswitches)
- DO NOT use the machine in ways that differ from those described above (Sect.1.8).
- DO NOT use the machine in environmental conditions that differ from the ones indicated above (Sect.1.10)
- DO NOT handle the tools without individual protective equipment (not supplied by SCM) for the hands and forearms.
- DO NOT use the machine without individual protective equipment from noise (ear plugs)(not supplied by SCM).
- DO NOT use the machine without extraction.
- DO NOT use the machine without having assessed the need to use individual protective equipment (not supplied by SCM) in relation to wood dust (we recommend the use of individual protective equipment: hard wood dust is carcinogenic).
- DO NOT use the machine if the area around the machine is not flat, well maintained and free of loose material (e.g. shavings and rejects).
- DO NOT machine different materials from the ones that the machine has been designed for and that are not set out in this manual.
- DO NOT machine materials of dimensions that the machine has not been designed for and that are not set out in this manual(Sect.1.8).
- DO NOT use tools not included in standard EN847-1 or of a size not compatible with the machine technical specifications.
- DO NOT make modifications to the machine.
- DO NOT allow children, domestic animals or any unauthorised personnel in the work area.

NOTE-INFORMATION:
performing modifications, voids the machine's Declaration of Conformity.
The user will be solely responsible for any damages resulting from improper use.

1.12 RESIDUAL RISKS

(ev_1-12_0.0)

Any machine tool may be potentially dangerous, do not forget it.
The final safety depends on you.

The machine is equipped with proper guards to ensure the safe machine operation.
Such guards are efficient if they are properly used and kept.

Even if the safety prescriptions are kept and the machine use occurs in accordance with the rules described in this handbook, the following risks may rise:

- **contact with the saw blade and scorer in rotation or standstill.**
- **contact of the tool with the tenoning table.**
- **Contact with the standstill or rotating tool.**
- **Contact with the rotating spindle.**
- **Contact with rotating members (belts, pulleys, chains ...).**
- **Kickback of the workpiece or of its parts (splits): never stop in the position corresponding to the trajectory of possible split ejection.**
- **Ejection of tool inserts: never stop in the position corresponding to the trajectory of possibile split ejection.**
- **Dust inhalation in case of working without suction.**
- **Fulguration caused by contact with hot parts.**
- **Contrary direction of tool rotation due to wrong electric connection.**
- **Danger due to wrong working position of the operator.**
- **Danger caused by the wrong tool fitting.**
- **Possible squashing of the hands, with the fixed parts of the machine, during the sliding table motion.**

1.13 OPERATOR'S TRAINING

(ev_1-13_0.0)

It is compulsory that the machine operator is trained for the machine set up and operation.
The operators shall carefully read this handbook and consider the safety rules.

In particular:
a) the principles of the right use and operation of the machine, the adjustment of the fence and guards and the use of devices for special working.
b) The correct handling of the workpieces during the working.
c) The right position of the hands to the tools, before, during and after the cutting.
d) The right selection of the tools.
e) The piece feed to the tool which shall occur in the contrary direction to the spindle rotation direction.
f) The selection of the proper spindle speed required by the tool.

The operators are to be informed about the dangers due to the machine operation and about the precautions to be taken; besides the operator shall be able to carry out periodical tests on guards and safety devices.

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SAFETY OVER ALL

1.14 SAFETY RULES

(gg_1-13_0.0)

1- Carefully read this instructions manual completely before starting the machine.
2- Carefully read the warning plates applied on the machine and comply with their indications.
3- Only correctly trained personnel can use the machine.
4- The operator training must include information about the dangers associated with using the machine and the precautions that he must observe.
5- The operator must trained on the correct use of the guards and safety devices.
Moreover he must be trained to perform regular controls on the aforementioned guards and safety devices.
6- The operator must never leave the machine unattended while it is operating.
7- This machine has been designed to be used by one operator.
8- This machine has been manufactured to provide maximum safety along with optimum performance.
9- Unauthorised changes to the machine release the manufacturer of any responsibility from any damages that may result.
10- Do not use the machine under the influence of alcohol, drugs or sleep inducing medication.

The safety depends on you. Any machine tool may be potentially dangerous, do not forget it.

1.14.1 PERSONAL SAFETY

(gg_1-13-1_0.0)

1- Before starting the machine the operator shall already have read the handbook.
Your eyes are the best safety device you have: carefully look before moving.
2- Experience teaches that there are various objects on a person that can cause injuries; take off rings, watches, bracelets; button your sleeves tightly around yuor wrists, take off ties that could be caught in tight places, keep hair gathered underneath proper nets (cap, elastics, hair pins). Use prescribed footwear usually recommended by all countries.

ALWAYS WEAR THE FOLLOWING INDIVIDUAL PROTECTIVE EQUIPMENT (IPE) (NOT SUPPLIED BY THE SCM**) BEFORE STARTING TO WORK:**

A- Proper aprons, e.g: aprons made of double leather with synthetic fiber cloth insertion (not supplied by SCM**) to protect the operator in case of splinters ejection.**
B- Glasses or protective shields for your eyes.
C- Proper means for ear protection.
D- Proper means against dust inhalation (masks).
E- Gloves for handling the blades.
F- Proper shoes with reinforced steel point and rubber soles.

1.14.2 MACHINE SAFETY

(ev_1-14-2_0.0)

DANGER-WARNING:
the machine must be fixed to the floor.
Fix the supplied angles (B fig. 4.2) to machine feet (A fig. 4.2) and fix on ground by means of expansion bolts (C fig. 4.2) (not supplied).

1- Be extremely careful when starting any working and periodically check the shields and safety devices.
Follow the instructions for grounding the machine's electrical system.
2- Never start the machine without having properly closed the covers in the area for blade and belt change.
3- Before starting the machine make sure that on the worktable or inside the guard there are no wood residues or parts which do not relate to the working.
4- Do not machine workpieces too small or too big for the machine.
See relative paragraph 3.1 "DIMENSIONS OF WORKPIECE TO BE MILLED".
Ensure that the pushers are intact and efficient.
5- Do not machine pieces with defects (deflections, clefts, knots, metallic parts, ...).
6- The guards and reference rules or fence halves are to be fitted and set when the machine is off.
7- Work only with all guards properly fitted and efficient.
The use of the machine is not permitted if such conditions are not kept.
8- In case of long pieces use roller tables or table extensions (not supplied by SCM).
9- It is necessary to connect all suction hoods to the suction system.
Before starting the working make sure that the suction system is switched on.
10- Test working to check the cutterblock adjustment may not carried out without the guards required.
11- Never try to remove the wastes or other parts of the workpiece from the working area when the machine is in operation.
12- Push the workpiece forwards by using a proper pusher or feeder.
13- After a given working period the transmission belts get slack; this may cause an increase of the time required to stop the tool. In that case immediately stretch the belts (see paragraph 20.23 or 20.24).
14- Periodically remove chips and dust to avoid fire risk: carry out this operation always with the machine off.

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1.14.3 TOOLS SAFETY

(ev_1-14-3_0.0)

FORBIDDEN:
the use of circular blades fitted to the spindle is not permitted.
It is forbidden to insert shims between the spacer rings to willingly unbalance the tools.

- Before fitting the tools, make sure that each support surface is clean, free from dents and perfectly flat.
- The tools shall be fitted and set when the machine is off, STILL TOOLS and with proper instruments (gauge, comparator).
- Make sure that the tools are perfectly balanced, sharp and well clamped.
  Not sharp tools reduce not only the quality of the finished piece but they increase the piece kickback danger.
- Fit the tools in the right working direction.
- For fastening the saw blade to the spindle, the use of rings or bushes not prescribed by SCM is forbidden.
- Never use deformed saw blades and do not exceed the speed limit indicated on them and prescribed by the tool manufacturer or by SCM.
  Make sure that the dimensional limits and the specifications of the tools suitable for the machine have been stored.
- Use only tools in accordance with EN 847-1 Norm and proper for manual feed.
- Before starting the machine make sure that the tools do not touch the fixed parts of the machine.
- Start working only when the tools have reached the right cutting speed.

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1.14.4 WORKING AREA SAFETY

(gg_1-13-4_0.0)

The working area shall have a good lighting and a sufficient room so that the operator is always out of a dangerous area.
The floor shall be well leveled to avoid slipping danger and also free from loose material (e.g. waste, chips).
Only the authorized operator may stay in the working area.
The operator shall never stay in the trajectory where eventual splits or tool parts are ejected.
If along this trajectory there is another work station (that is another machine) or a passage for persons, immediately install proper protective barriers.

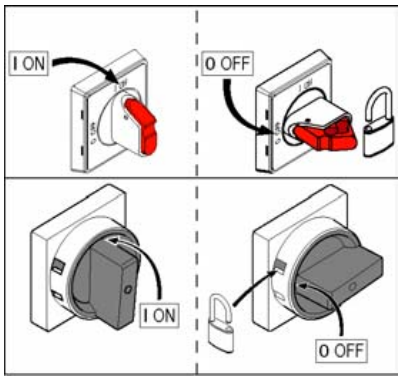
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1.14.5 MAINTENANCE SAFETY

(ev_1-14-5_0.0)

DO NOT THINK that the electric current is switched off during the maintenance .... CHECK IT PERSONALLY!
Strictly follow the indications provided for the frequency of the controls and maintenance of devices subject to checks and/or wear.

1- Stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.



2- Completely stop the machine before cleaning operations and before removing any guard to carry out the maintenance.
3- The general cleaning of the machine (in particular of worktable) and of the surrounding floor is an important safety factor.
4- Regularly carry out cleaning and maintenance operations: remove chips and dust to avoid fire risk.
5- Use proper gloves for handling the tools.
6- The tools require a regular maintenance: when necessary replace them.
7- In case of any trouble concerning the machine, the guards and the tools, it is necessary to immediately take the proper measures.

1.14.6 SAFE WORKING PRACTISE

(dj_1-14-6_5.0)

(Copy of C enclosure of EN 848-1 European Norm)

C.1 General

These notes are given as examples for the safe operation of the machine.

C.2 Operator training

It is necessary that all operators of vertical spindle moulding machines are properly trained in the use, adjustment and operation of the machine.
In particular:

a) The principles of the correct set up operations and the use of the machine including the right use and adjusting of the devices for workpiece locking and guidance, the selection of shields and tools.
b) The safe handling of the workpiece during milling operations.
c) How to adjust safety equipment such as shapes, table extensions and mechanical strikes.
d) The use of personal ear and sight protective devices.

C.3 Stability

To ensure the correct and safe operation of the machine, it shall be stable and and securely fixed to the floor (see Chapter 4).

C.4 Machine and set up

Before carrying out the machine equipment :
a) make sure that the tools are sharp, selected and set according to the tool manufacturer instructions.
b) shut off the machine from the power supply
c) reduce the bore on the table in order to get the room between table and spindle as small as possible
d) handle the tools with extreme caution

C.5 Piece guidance

It is important to use:

a) the hood-fence unit to ensure during the milling the proper piece guidance.

b) When possible a proper element joining the fence halves in order to minimise the gap between the tool and the fence halves.

c) A pusher for the manual piece feed or when possible a feeder which may be switched off when it shall not be used.

d) Roller tables or table extensions to support long pieces.

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C.6 Direction of rotation and rotation speed selection

C.6.1 Direction of rotation

It is very important that the tool rotates in the correct direction.and that the piece feed occurs in the direction contrary to direction of the spindle rotation.

C.6.2 Rotation speed selection

The operator must ensure that the right rotation speed has been selected and that the speed selected is proper for the tool fitted to the spindle.

C.7 Machine operation, guard selection and adjustment

Because of the variety of workings which can be carried out on vertical spindle moulding machines by using different spindles, toolholders and tools , no safeguard can be considered effective for all conditions.

Each working should be considered separately and the best practicable safeguard selected for that particolar job.
The cutter type, the tips projection and the height at which the tool is set, will determine the minimum diameter of the hole on the table.

This may be obtained by using the reducing rings supplied, thus reducing the risk that the workpiece oscillates or fits into the tools .

The guard shall enclose the tools to the greatest extent according to the working.

The distance between the fence halves shall be so large only to permit the tool rotation without contact.

If you use a removable feeder, the tools shall be covered as much as possible and trapping hazards are to be avoided.

If no feeder is used, pressers forming a tunnel, through which the workpiece can be fed, may be properly used; the pressers are to be used for milling at the fence.
It is necessary to reduce the room between fence halves and tool as much as possible.
In this case use a proper joining element .

C.8 Milling at the hood -fence unit; working on the entire piece length

To hinder the access to the tool during the milling at the hood-fence unit, it is necessary to use together with the fence a removale feeder with proper guards or vertical and horizontal pressure shoes eqipped with contact elements according to the workpiece size.

The following piece may be used to push the previous one; the last workpiece is milled at the end by using a pusher.

In case of thin pieces only the vertical pressure shoe may be used if its thickness is proper.

C.9 Interrupted milling

To hinder the access to the tool during the not-through milling (interrupted milling) it is necessary to use together with the hood-fence unit a removable feeder or guards equipped with proper pressers according to the piece dimensions.

To hinder kickback of the piece use front and rear stops which are fastened to the fence, to the table or to the table extension.

We recommend to use a clamping template unless the piece may be hold in a safe way by the hands.
For clamping the piece use fast locking devices which operate with levers or cams.

C.10 Milling at the spindle

To hinder the access to the tool during the milling at the spindle use the proper guard and a clamping template.

C.11 Chamfering

To hinder the access to the tool during the oblique milling, besides the hood-fence unit use a special template or an auxiliary stop.

C.12 Climb milling

When possible it is necessary to avoid the clim milling.

C.13 Tenoning

To ensure a safe piece guidance to the tool, it is necessary to use the proper additional table foreseen by the manufacturer as well as the tenoning hood.

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1.15 EMERGENCY CONDITIONS

(ev_1-15_0.0)

DANGER-WARNING:
in case of flooding of the room where the machine is housed, immediately disconnect the electrical power supply. Before starting work, have the machine checked by a specialised technician.

DANGER-WARNING:
in case of fire, immediately disconnect the electrical power supply and intervene using suitable fire extinguishers directing the jets at the base of the flames. Even if the machine has suffered no apparent damage, before restarting work have the machine checked by a specialised technician.

A free space without obstructions must be provided around the machine (see par. 3.7), to allow fast escape in case of danger.

This machine must not be operated in explosive environments.

1.16 MACHINE REMOVAL - STORING - DEMOLITION

(ev_1-16_0.0)

To remove the machine, disconnect it from the electric and pneumatic system. Follow the instructions in chap. 4.

In case of extended inactivity of the machine, disconnect it from the electrical and pneumatic system. Thoroughly clean it as already described for ordinary cleaning and cover the work and sliding tables and the tool holder spindles with antirust protection. Do not store the machine in humid environments and protect it from atmospheric agents.

The machine is constructed in non-toxic unharmful materials. In case of demolition, separate the ferrous material from the plastic materials and send them to the respective scrap yards.

1.16.1 OUT OF ORDER MACHINE

(1.16.1)

The machine is manufactured with non-toxic or harmful materials; in case of scrapping separate the ferrous materials from the plastic materials and scrap respectively. We recommend contacting a specialised and authorised company, in compliance with the applicable laws and standards.

The operators moving the machine and the maintenance personnel must wear the IPE required for the risks involved with the type of use and in compliance with the applicable laws and standards.

To move and transport the machine refer to the instructions in chap. 4.

INDEX

2.1 Arrangement and description of emergency devices (Fig. 2.1).....2

2.2 Arrangement and description of safety devices (Fig. 2.2).....4

2.1 ARRANGEMENT AND DESCRIPTION OF EMERGENCY DEVICES (FIG. 2.1)

(ev-2-1.0.0)

Emergency equipment consists of special devices whereby operators can promptly stop the machine if necessary or in case of danger.

DANGER-WARNING:
emergency devices must never be removed or disconnected for no reason whatsoever ("Machine Directive" 2006/42/CE).

Description

A - Emergency mushroom-head push-button:
it causes an immediate emergency stop.

CAUTION:
periodically, check that the devices, listed above, are efficient.

DANGER-WARNING:
any anomalies found during the control of these devices, must be reported promptly to the manager , who will put the machine out of service and call the SCM ***Support Service.***

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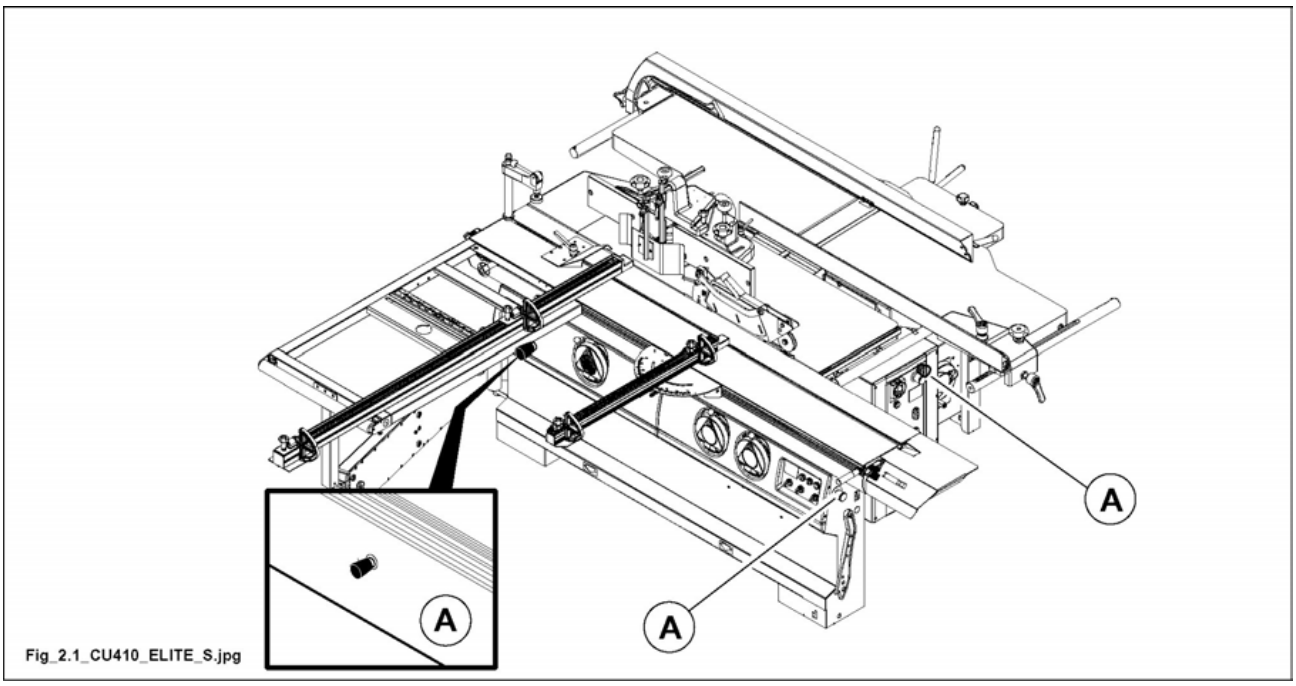


Fig. 2.1

2.2 ARRANGEMENT AND DESCRIPTION OF SAFETY DEVICES (FIG. 2.2)

(ev-2-2.0.0)
Safety devices are special accident-prevention guards whereby the machine is protected against possibly dangerous situations.

DANGER-WARNING:
emergency devices must never be removed or disconnected for no reason whatsoever ("Machine Directive" 2006/42/CE).

Description

A - Main electrical switch (padlockable):
when at zero (OFF), it cuts electrical power supply to the machine.

B - Botton guard for the saw unit.

C - Limit switch fitted on the side of saw unit guard:
to stop the machine after opening the guard and to ensure that with guard (B) open, the motor can not be started.

D - Automatic brake:
it acts directly on working unit.

E1 - Guard for saw unit

F - Limit switch under the belt cover (with 2 speeds OPT):
to stop the machine after opening the guard and to ensure that with guard (P) open, the motor can not be started.

Limit switches:
1) limit switch fitted to the motor housing door.
it commands the machine stop when the door R is open.
2) micro switch for tenoner hood ø 320 OPT :
when tenoner hood is installed ø 320, it enables machine start up only with Spindle moulder rotation speed at 3500 rpm (50 Hz) - 4000 rpm (60 Hz).
3) Limit switch for spindle locking.
disables machine start when mechanical block T is on.
4) Plane microswitch:
stops machine when planing tables tip. Enable the planer operating unit for processing to the thickness if the chip conveyor protection S is turned upside down.

Guards:
1P) guard for tenoning operations.
2P) Arm guard.
3P) Guard for shaping at the spindle.
4P) Guard for planer operations
5P) Hood-fence unit for profiling operations.
6P) Presser unit fitted to the hood-fence unit.

Suction hood under the table.

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M - Anti-kickback fingers:
anti-kickback fingers, working with pieces of different thickness, prevent the workpiece to be thrown back towards the operator, thus providing an effective protection.

CAUTION:
periodically, check that the devices, listed above, are efficient.

DANGER-WARNING:
any anomalies found during the control of these devices, must be reported promptly to the manager, who will put the machine out of service and call the SCM ***Support Service.***

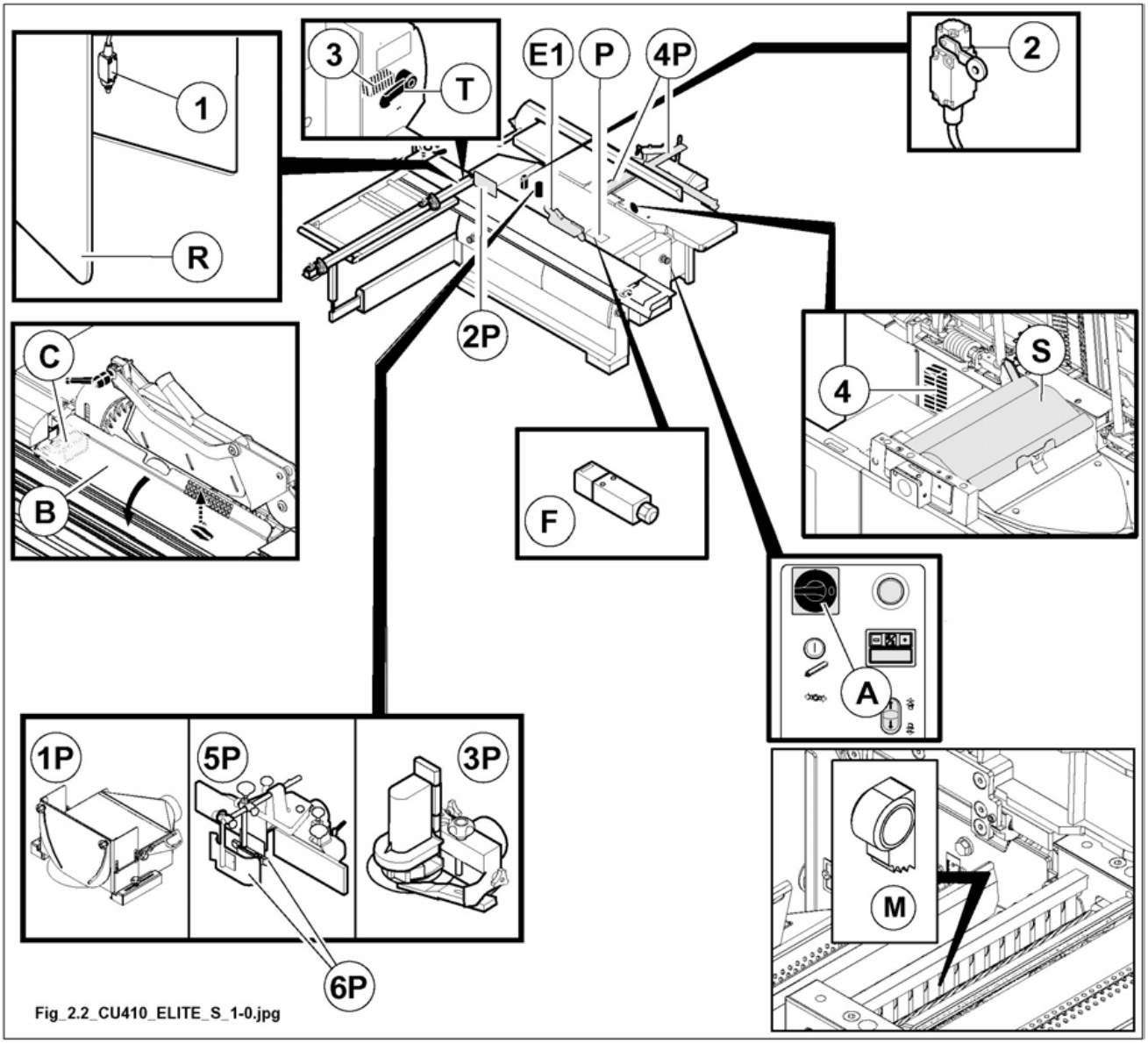


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3.1 DIMENSIONS OF WORKPIECE TO BE THICKNESSED

(ev_3-1_0.0)

SAW

DIMENSIONS OF WORKPIECE TO BE MILLED			
Maximum cutting height at 90°	With a blade of Ø 350	~ 104	mm
Maximum cutting height at 45°	With a blade of Ø 350	~ 68	mm
Maximum cutting height at 90°	With a blade of Ø 315	~ 94	mm
Maximum cutting height at 45°	With a blade of Ø 315	~ 61	mm
Maximum cutting height at 90°	With a blade of Ø 300	~ 89	mm
Maximum cutting height at 45°	With a blade of Ø 300	~ 57	mm
Maximum cutting height at 90°	With a blade of Ø 250	~ 67	mm
Maximum cutting height at 45°	With a blade of Ø 250	~ 42	mm
Maximum length	When squared up	2310	mm
Maximum length (OPT)	When squared with “slide 2600”	2660	mm
Maximum length (OPT)	When squared with “slide 3200”	3260	mm
Maximum width	For cutting to the parallel guide	1000	mm

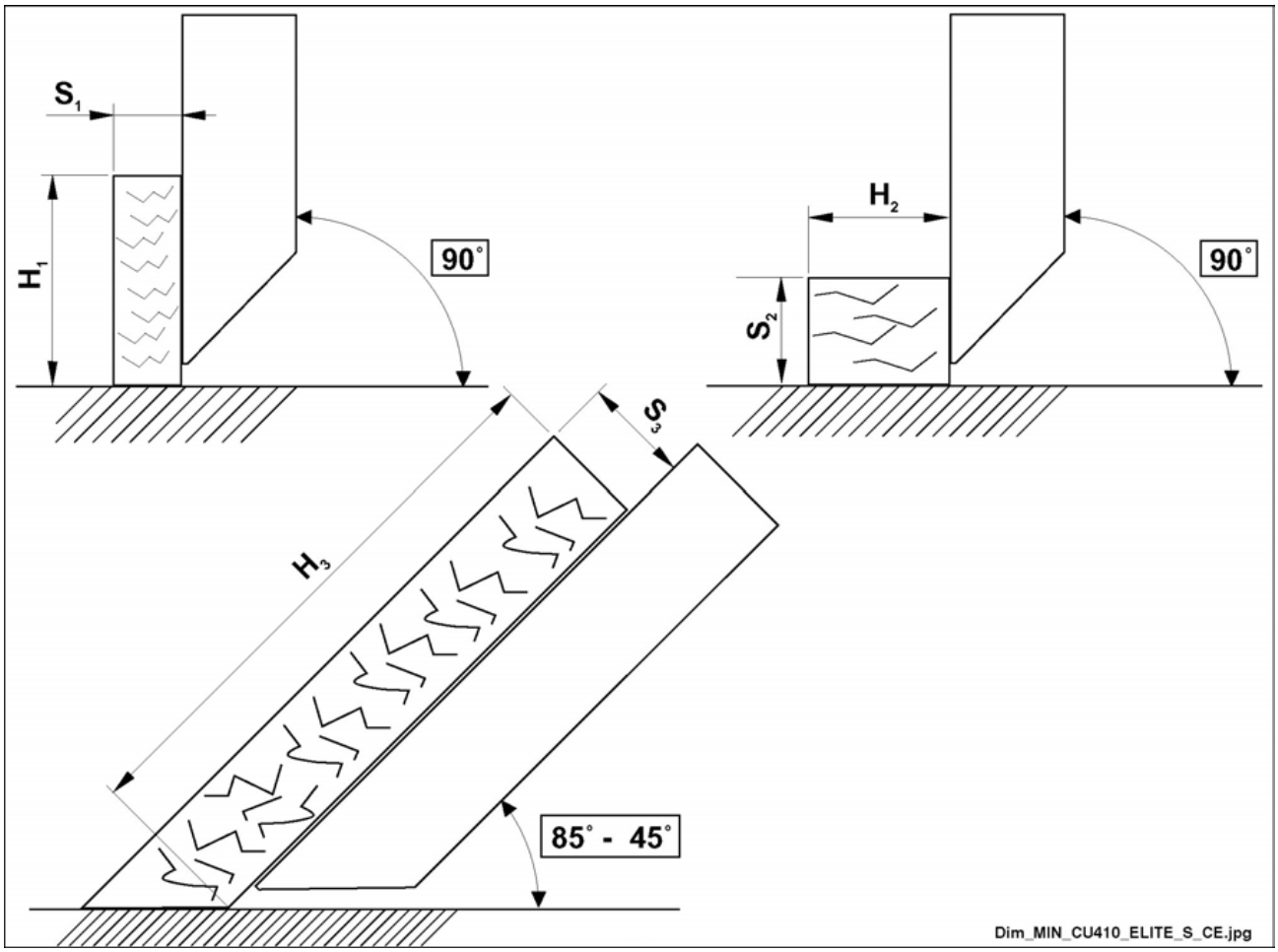
MOULDER

DIMENSIONS OF WORKPIECE TO BE MILLED			
Thickness	Min. piece size in case of profiling operation	8	mm
Width	Min. piece size in case of profiling operation	8	mm
Length	Min. piece size in case of profiling operation	400	mm
Thickness	Max. piece size in case of profiling operation	230	mm
Width	Max. piece size in case of profiling operation	180	mm
Length	Max. piece size in case of profiling operation	1000 (*)	mm
(*) In case of longer pieces use rest tables			
Thickness	Min. size of solid wood piece in case of tenoning	20	mm
Width	Min. size of solid wood piece in case of tenoning	20	mm
Length	Min. size of solid wood piece in case of tenoning	220	mm
Thickness	Max. size of solid wood piece in case of tenoning	100	mm
Width	Max. size of solid wood piece in case of tenoning	140	mm
Length	Max. size of solid wood piece in case of tenoning	2500 (**)	mm
(**) In case of longer pieces use rest tables			
Max. slot depth		100 (***)	mm
(***) Uprated motor power recommended			

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SURFACE PLANING MACHINE

Max. thickness under the guard	75 mm	
Max. length		**DANGER-WARNING: may be not defined; we recommend to use table extensions (not supplied by** SCM**) at entry and exit side in case of panels longer than 2000 mm.**
Max. width	410 mm	
Min. thickness	**H_1**=30 mm	
	H_2=20 mm	
	H_3=80 mm	
Min. length	150 mm	**We recommend to use pushers (not supplied by** SCM**).**
		DANGER-WARNING: never machine shorter workpieces.
Min. width	**S_1**=10 mm	**We recommend to use pushers (not supplied by** SCM**).**
	S_2=15 mm	**DANGER-WARNING: never machine shorter workpieces.**
	S_3=15 mm	



THICKNESSING PLANER

Max. thickness	240 mm	
Max. length		**DANGER-WARNING: may be not defined; we recommend to use table extensions (not supplied by** SCM**) at entry and exit side in case of panels longer than 2000 mm.**
Max. width	410 mm	
Min. thickness	3,0 mm	
Min. length	180 mm	**DANGER-WARNING: never machine shorter workpieces.**
Min. width	10 mm	**DANGER-WARNING: never machine shorter workpieces.**

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3.2 TECHNICAL DATA

(ev_3-2_0.0)

SAW

GENERAL SPECIFICATIONS			
Fixed table dimensions		1380 x 465	mm
Slide dimensions	With “Slide 2250”	2250 x 330	mm
Slide dimensions	With “Slide 2600”	2600 x 330	mm
Slide dimensions	With “Slide 3200”	3200 x 330	mm
Blade inclination		from 90° to 45°	
Saw blade maximum diameter		Øi 30 x 350	mm
Saw blade minimum diameter		Øi 30 x 250	mm
Scoring saw blade diameter		Øi 20 x120	mm
Maximum projection at 90°	With a blade of 350 mm	118	mm
Maximum projection at 45°	With a blade of 350 mm	84	mm
Maximum projection at 90°	With a blade of 315 mm	101	mm
Maximum projection at 45°	With a blade of 315 mm	71	mm
Maximum projection at 90°	With a blade of 300 mm	93	mm
Maximum projection at 45°	With a blade of 300 mm	66	mm
Maximum projection at 90°	With a blade of 250 mm	68	mm
Maximum projection at 45°	With a blade of 250 mm	49	mm
Saw blade rotation speed		4200	r.p.m.
Saw blade stop time:		less than 10 seconds	
Scoring saw blade rotation speed		9200	r.p.m.
Motors:			
Saw motor power:	50 Hz	5,0	kW
	60 Hz	6,0	kW
Technical details: see data plate on the motor Duty cycle: S6 - 40% (excluded from the energy efficiency constraints of EC Commission Regulation 640/2009) Conditions of service: see Par. 1.10			
Scoring saw motor power		0,5	kW
Net weight: see plate of machine identification			
Working voltage and frequency: see plate of machine identification			

MOULDER

GENERAL SPECIFICATIONS			
Worktable size:		1380 x 465	mm
Worktable height from the floor:		900	mm
Working spindle height:	Ø 30 - 35	125	mm
Working spindle height:	Ø 40 -50	125	mm
Max. tool diameter for rebating (with a perpendicular spindle)		Ø 230	mm
Max. tool diameter for rebating (with an inclined spindle)		Ø 150	mm
Max. tool diameter: moulding hood	with Ø 30 mm spindle	150	mm
	with Ø 35 mm spindle	150	mm
	with Ø 40 mm spindle	180	mm
	with Ø 50 mm spindle	180	mm
Max. tool diameter: tenoning hood Ø 275 (OPT)		275	mm
Max. tool diameter: tenoning hood Ø 320 (OPT)	with Ø 40 mm spindle	320	mm
	with Ø 50 mm spindle	320	mm
Max. diameter of the tool disappearing under the table:		Ø 240 x h 85	mm
Vertical spindle adjusting:		~ 165	mm
Spindle rotation speed (50 Hz)	3500-6000-8000-10000		r.p.m.
Spindle rotation speed (60 Hz)	4000-7000-9000-12000		r.p.m.
Time required to stop the spindle:		less than 10 seconds	
Motors:			
Main motor power:	50 Hz	5,0	kW
	60 Hz	6,0	kW
Technical details: see data plate on the motor Duty cycle: S6 - 40% (excluded from the energy efficiency constraints of EC Commission Regulation 640/2009) Conditions of service: see Par. 1.10			
Basic machine weight: see plate of machine identification			
Working voltage and frequency: see plate of machine identification			

DANGER-WARNING:
the table lists the tool mass allowed based on its speed and diameter.

3500 (r.p.m.) (50 Hz) – 4000 (r.p.m.) (60 Hz)	
Diameter (mm)	**Weight (Kg)**
320	**12**

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SURFACE PLANING AND THICKNESSING MACHINE

GENERAL TECHNICAL DATA			
Planer table total length		2200	mm
Useful working length (Planer - Thicknesser)		410	mm
Max. depth of cut in one stroke (Thicknesser)		5	mm
Max. depth of cut in one stroke (Planer)		5	mm
Min. width of the piece to be machined (Thicknesser)		10	mm
Cutterblock diameter		95	mm
Knives		30x3x410	N° 4
Cutterblock speed		5000	rpm
Time required to stop the cutterblock		less than 10 sec.	
Fence dimensions		1800x150	mm
Motors:			
Motor power	50 Hz	5,0	kW
	60 Hz	6,0	kW
Technical details: see data plate on the motor Duty cycle: S6 - 40% (excluded from the energy efficiency constraints of EC Commission Regulation 640/2009) Conditions of service: see Par. 1.10			
Planer guide tilt		from 90° to 45°	
Feed speed to thicknesser		6-12	m/min
Weight without mortiser:		see identification plate on the machine	

SUCTION SPECIFICATIONS		
Saw suction mouth diameter	Ø 120	mm
Saw guard suction mouth diameter	Ø 36	mm
Lower spindle suction mouth diameter	Ø 120	mm
Spindle hood suction mouth diameter	Ø 120	mm
Moulding hood suction mouth diameter	Ø 100	mm
Tenoning hood suction mouth diameter (OPT)	Ø 120	mm
Thickness hood suction mouth diameter	Ø 120	mm
Mortiser suction mouth diameter (OPT)	Ø 120	mm
Suction air speed: chips dry (chips wet)	20 (28)	m/sec
Suction air consumption [Ø 120 + Ø 36]	887 (1243)	m³/h
Suction air consumption [Ø 120 + Ø 100]	1379 (1932)	m³/h
Suction air consumption [Ø 120 + Ø 120]	1628 (2280)	m³/h
Suction air consumption [Ø 120] (OPT)	814 (1140)	m³/h

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3.3 STANDARD ACCESSORIES

(ev_3-3_0.0)

Auto-brake motors
Trasformer for auxiliary circuit 110 V
Motor overload cutout
2 Brackets (for fastening the machine to the floor)

Pusher
Handle for pusher
Set of tools and wrenches for use and maintenance

SAW

Eccentric clamping
Cast iron table extensions
Squaring frame with extension arm and extendable aluminium rule with stops

Fence for parallel cuts with micrometric adjustment
Sliding table made of aluminium alloy with motion on guides
Tile-shaped stop
1 Riving knives

Direct start of main motor

Manual height adjusting and tilting of saw unit
Mechanical numeric indicator for reading blade unit angle of tilt

Scorer unit with independent motorisation

Guard for saw blade and scorer with suction hood of 36 mm diameter

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MOULDER

Cast iron table extensions
Rotation direction reversal
Manual mouvement of the spindle
Numerical height display, spindle height adjustment

Direct start of main motor
Light indicating the speed selected for spindle moulder

Prewiring for feeder

Adjustable molder-fence unit
Shaping moulder hood

*) Guard of presser unit for moulding

*) Guard for machining at spindle

Suction hood Ø 120 mm, on the rear frame side

Set of spacer rings on spindle

Tool fixing device

*) Accessories supplied with machine to be mounted according to the type of machining to be carried out.

SURFACE PLANING AND THICKNESSING MACHINE

1.st top feed roller (inlet side): steel scored roller
One feed roller (exit side): steel roller

Numerical display for the vertical motion of the thicknessing table
Height adjusting of thicknessing table by handwheel

Knife setting gauge
N° 4 knives
Suction hood of 120 mm diameter
Direct start of main motor

Planer spindle guards
Tilting guide for supporting pieces
Manual movement of table (planer) in infeed
Reading of removal (planer) with index on sliding scale

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3.4 OPTIONAL ACCESSORIES

(ev_3-4_0.0)

Motors power (three-phase) - S6 / 40%:
..... 7,0 kW - 50 Hz
Automatic 0-star-delta motors starting

Motors power (single-phase) - S1:
..... 3,6 kW (60 Hz)

Displacing wheels

SAW

Sliding table length: 2600 mm
Sliding table length: 3200 mm

Wagon attachment

2 speed values of saw blade (3500 - 5000 rpm)

Power height adjusting and tilting of the units
Electronic display for reading the vertical motion and the tilting of the units

Device for oblique cuts

MOULDER

Motor-driven movement of tool holder spindle shown by electronic digital readout

The machine is prewired for connecting the feeder with an ON/OFF switch.

Tenoning table and hood Ø 320 mm (max. tool diameter 320 mm)
Tenoning table and hood Ø 275 mm (max. tool diameter 275 mm)
Anodised aluminium tables for moulder guide

Moulder spindle inclination. 90° / 45°

Interchangeable moulder spindle
Moulding spindles available:
Ø 30 - Ø 35 - Ø40 - Ø50 spindle to fit to the hole of the cutters used

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SURFACE PLANING AND THICKNESSING MACHINE

2.nd top feed roller with rubber coating

Cutterblock with throw-away knives
Power height adjusting of thicknessing table
Electronic display for reading the vertical motion

Mortiser with:

- Table size	470X230	mm
- Longitudinal stroke	160	mm
- Trasverse stroke	120	mm
- Vertical stroke	110	mm
- Coupling of left-hand bit Ø max.	16	mm
- Suction hood diameter	120	mm
- Suction air speed	20	m/sec
- Suction air consumption	814	m^3/h
- Weight	~50	kg
- clamping arm		
- selfcentering (OPT) chuck for bits of max. diameter	Ø max.16	mm
- collet spindle (OPT)		
	Ø 5	mm
	Ø 10	mm
	Ø 16	mm

3.5 NOISINESS LEVEL

(ev_3-5_0.0)

SAW

Operating conditions – **Cutting with circular saw** (according to norm EN 1870-1:2007+ A1:2009)*					
Measured size description		Reference norm	Uncertainity **K** (probability 68.27%)	**Cutting with circular saw**	
				VSA	**LAV**
Lop: sound pressure level at operator station dB (A) and peak level [dB(C)]	Operator station	EN ISO 11201:1995	2.5	80.2	90.3 [99.0]
	INPUT				
Lw: sound power level dB (A) re 1pW [mW (A)]		EN ISO 3744:1995	2.0	95.1 [3.2]	103.8 [23.8]
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA : Idle working without suction		**LAV** : In operation			
*Refer to the test document N° 06158 (Rdp 06158) to analyse the actual operating conditions used to make the test, different from those operating conditions prescribed by the norm mentioned above.					

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MOULDER

Operating conditions – **Profiling** (according to norm 848-1:2007+ A1:2009)*					
Measured size description		Reference norm	Uncertainity **K** (probability 68.27%)	**Profiling**	
				VSA	**LAV**
Lop: sound pressure level at operator station dB (A) and peak level [dB(C)]	Operator station	EN ISO 11201:1995	2.5	87.4	89.8 [98.2]
	INPUT				
Lw: sound power level dB (A) re 1pW [mW (A)]		EN ISO 3744:1995	2.0	95.9 [3.9]	97.6 [5.7]
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA : Idle working without suction		**LAV** : In operation			
*Refer to the test document N° 06158 (Rdp 06158) to analyse the actual operating conditions used to make the test, different from those operating conditions prescribed by the norm mentioned above.					

Operating conditions – **Tenoning** (according to norm 1218-1:1999+ A1:2009)*					
Measured size description		Reference norm	Uncertainity **K** (probability 68.27%)	**Tenoning**	
				VSA	**LAV**
Lop: sound pressure level at operator station dB (A) and peak level [dB(C)]	Operator station	EN ISO 11201:1995	2.5	77.5	89.2 [97.7]
	INPUT				
Lw: sound power level dB (A) re 1pW [mW (A)]		EN ISO 3744:1995	2.0	85.5 [0.4]	98.4 [7.0]
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA : Idle working without suction		**LAV** : In operation			

SURFACE PLANING MACHINE

Operating conditions – **Surface planning** (according to norm EN 859:2007+ A1:2009)*					
Measured size description		Reference norm	Uncertainity **K** (probability 68.27%)	**Surface planning**	
				VSA	**LAV**
Lop: sound pressure level at operator station dB (A) and peak level [dB(C)]	Operator station	EN ISO 11201:1995	2.5	78.4	91.3 [98.0]
	INPUT				
Lw: sound power level dB (A) $_{re\ 1pW}$ [mW (A)]		EN ISO 3744:1995	2.0	91.0 [1.3]	100.4 [10.8]
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA : Idle working without suction		**LAV** : In operation			
*Refer to the test document N° 06158 (Rdp 06158) to analyse the actual operating conditions used to make the test, different from those operating conditions prescribed by the norm mentioned above.					

THICKNESSING MACHINE

Operating conditions – **Thicknessing machine** (according to norm EN 860:2007+ A1:2009)*					
Measured size description		Reference norm	Uncertainity **K** (probability 68.27%)	**Thicknessing machine**	
	Operator station			**VSA**	**LAV**
Lop: sound pressure level at operator station dB (A) and peak level [dB(C)]	INPUT	EN ISO 11201:1995	2.5	77.6	87.9 [95.7]
	OUTPUT			75.0	84.2 [92.6]
Lw: sound power level dB (A) $_{re\ 1pW}$ [mW (A)]		EN ISO 3744:1995	2.0	90.1 [1.0]	97.7 [5.9]
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA : Idle working without suction		**LAV** : In operation			
*Refer to the test document N° 06158 (Rdp 06158) to analyse the actual operating conditions used to make the test, different from those operating conditions prescribed by the norm mentioned above.					

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SLOTTER

NOISE LEVEL				
Working - **BORING**				
	Reference norm		**BORING**	
Lop: Sound pressure level at operator place dB (A)	EN ISO 11201:1997		89.8	
Lw: Sound power level dB W (A) [mW (A)] LW	EN ISO 3744:1994		101.4 [12.4]	
The maximum value of instantaneous acoustic pressure is less than 130 dB (C).				
VSA : Idle working without suction		**LAV** : Idle working without suction		
The values refer to the "free field" conditions in accordance with the test modalities foreseen by the reference norm.				



DANGER-WARNING:
the noise levels which have been measured are emission levels and not levels of safe working. The relation between emission levels and exposure levels may not be used to determine whether further precautions are required. Factors which influence the real exposure level for the operator include the exposure time, the room features, further sound sources (as for example number of the adjacent working machines). Also the exposure levels permitted are not the same for all countries. Thank to this information the operator to evaluate the risks and the dangers.

Here are some factors which reduce the exposure to the noise:
- right tool selection
- right rotation speed selection
- machine and tool maintenance
- proper use of ear protective means.

3.5.1 DUST EMISSION

(mmax_3-5-1_0.0)

DUST EMISSION	
Operating conditions – **Cutting, Surfacing, Thicknessing, Drilling, Moulder machining**	
Reference regulations: **BG-GS-HO- 05**	Dust emitted [mg/m^3]
Operator's site	< 2



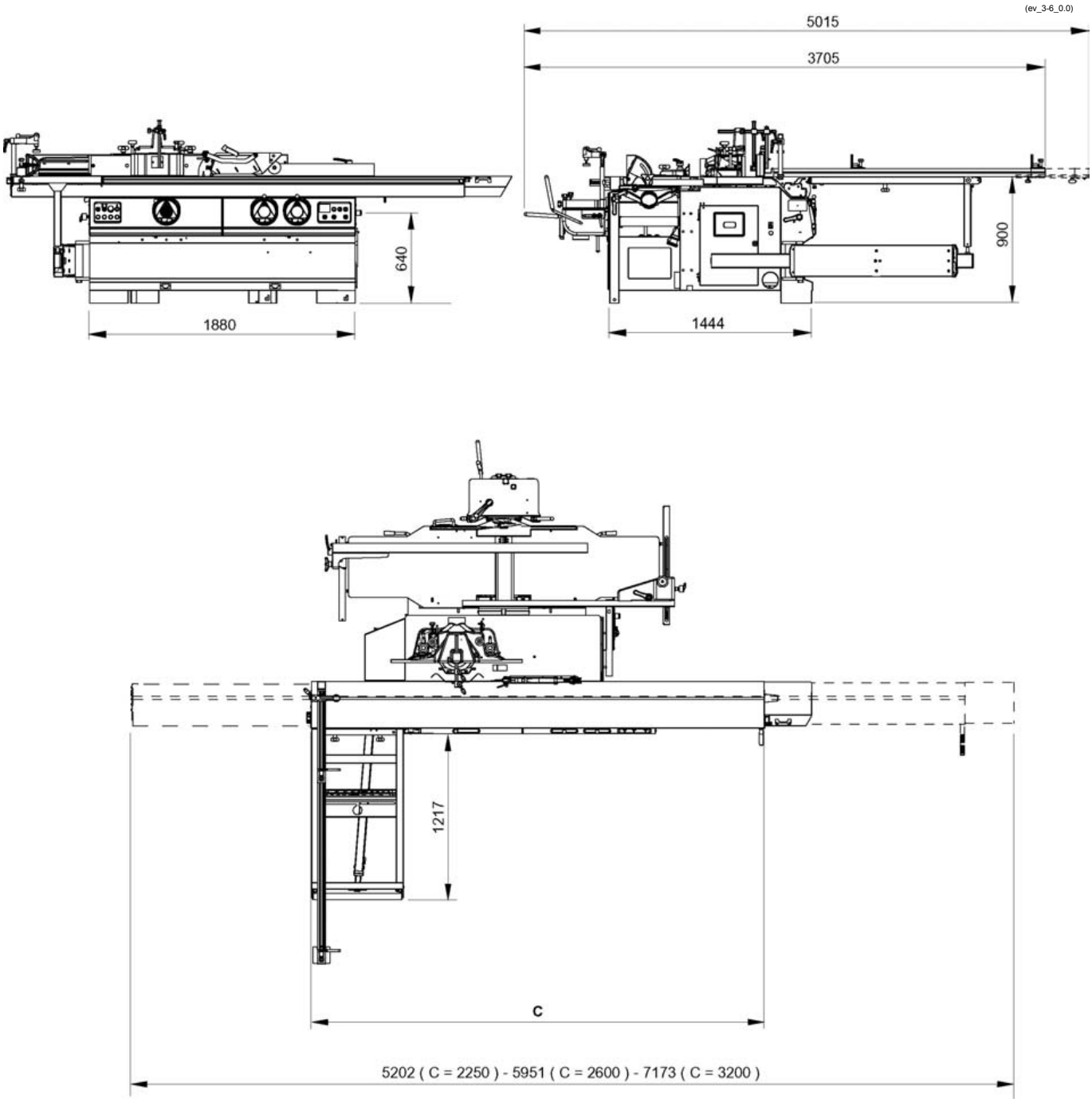
FORBIDDEN:
DO NOT USE COMPRESSED AIR.



DANGER-WARNING:
it is necessary to connect all suction hoods to the suction system.
Before starting the working make sure that the suction system is switched on.

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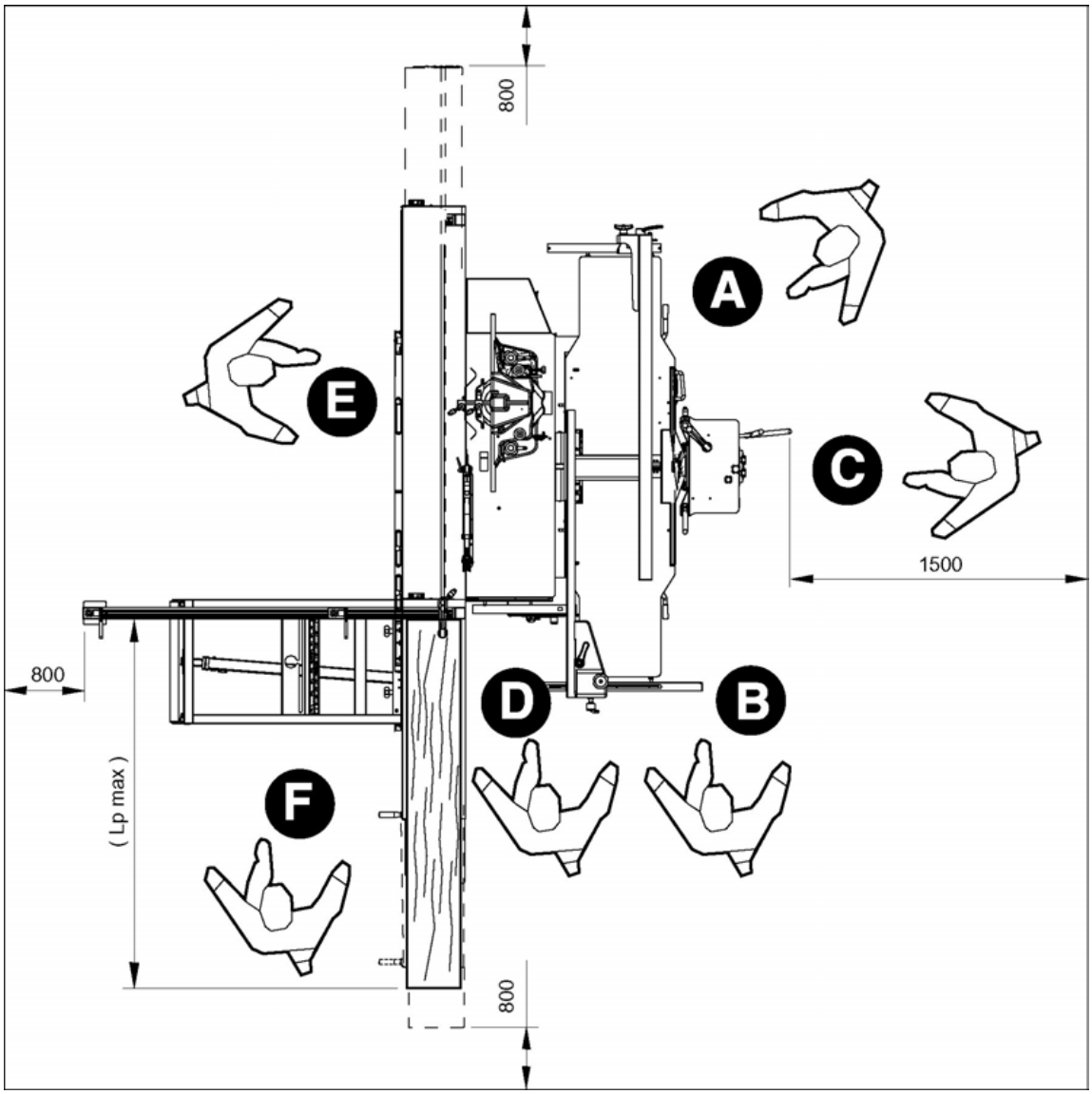
3.6 OVERALL DIMENSIONS



C = sliding table length: (STD) 2250 mm - (OPT) 2600 mm - (OPT) 3200 mm

3.7 WORKING AREA

(ev_3-7_0.0)



CAUTION:
the measures above indicated are to be considered as the free room of the working area.

DANGER-WARNING:
this machine has been designed to be used by one operator.

A = Surfacing planer ..... B = Thicknessing planer
C = Drilling ..... D = Parallel cutting
E = Moulder machining ..... F = Slide machining

Lp max = Max. workpiece length

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(st 1)

4.1 UNLOADING THE MACHINE

(ev_4-1_0.0)

NOTE-INFORMATION:
the packing of the machine indicates:
- the weight to be raised
- the hooking areas

DANGER-WARNING:
lifting and handling should only be carried out by skilled personnel specially trained to execute this kind of operations. During loading and unloading, avoid knocks to prevent damages to persons or things. Make sure no one is standing under the overhung load and/or within the bridge crane working range during machine lifting and handling.

Before unloading the machine take off all parts rested on it for packing and transport reasons.

DANGER-WARNING:
- the machine shall be lifted by crane or other raising means by hooking the slings as shown in fig. 4.1.
- Make sure that the crane, the slings as well as the fork truck are proper for lifting the machine.

If a bridge crane or a crane is available, proceed as follows:
– provide three slings (C fig. 4.1) of suitable length and capacity (belts minimum length 2000 mm);
– lift the slings and position them as is shown in the figure 4.1;
– fasten the slings to the bridge crane (D fig. 4.1) having adequate lifting power;
– move the bridge crane by small steps to allow the slings (C fig. 4.1) to settle, until optimum stability conditions are reached;
– lift carefully and slowly, without causing the load to swing, and place the machine in the selected setting.

NOTE-INFORMATION:
if lifting with a hook, open the holes already prepared and indicated by the plate as shown in the figure.

If hoisting is carried out with a lift truck A, proceed as follows:
– provide a fork lift truck (A fig. 4.1) having suitable carrying capacity;
– insert the forks (B fig. 4.1) as per the figure (keeping them alongside the two feet (E fig. 4.1) and check that these protrude at least 15 cm from the rear part of the base.

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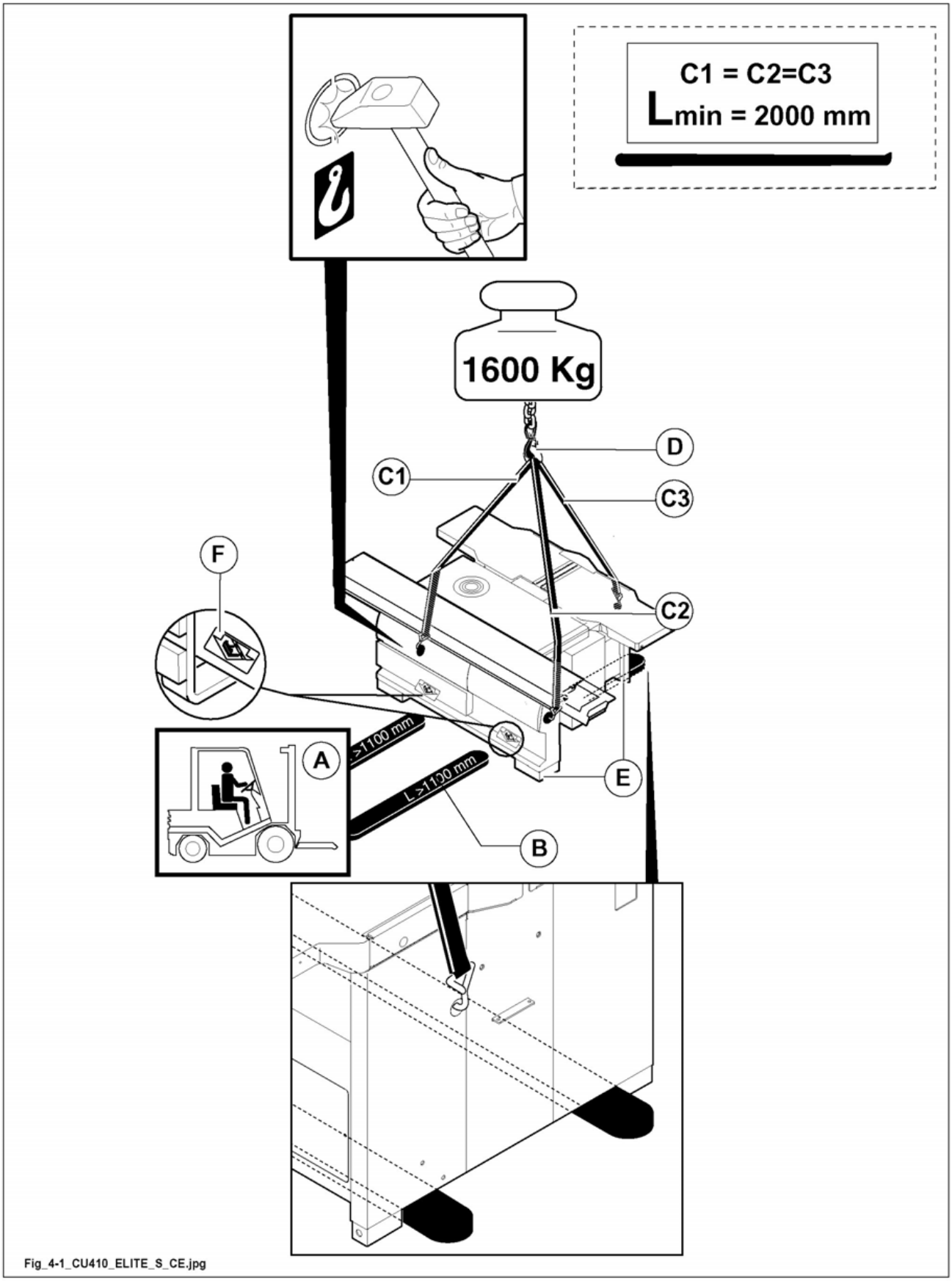

C1 = C2=C3
Lmin = 2000 mm
1600 Kg
D
C1
C3
C2
F
A
L≥1100 mm
L≥1100 mm
E
B
Fig_4-1_CU410_ELITE_S_CE.jpg

Fig. 4.1

4.2 MACHINE POSITIONING

(ev_4-2_0.0)

The position where to install the machine shall be well lightened (at least 500 LUX), proper for the connection to the power line, to the suction system and for maintenance operations.

DANGER-WARNING:
during the machine positioning you have to consider that, in case of longer pieces, a sufficient room is required to avoid squashing points towards the fixed parts of the working envinronment as walls, columns etc... (see par. 3.7).

Check that the floor is firm in order to ensure a uniform rest of the machine.
A concrete floor is recommended; an asphalt floor is not proper.
We recommend to insert steel plates between machine feet and floor eventually with vibration-dumping material.

DANGER-WARNING:
remove the bracket (D fig. 4.2) fastening the surface tables during transport operations.
Keep the bracket necessary to change the machine position.

DANGER-WARNING:
the machine must be fixed to the floor.
Fix the supplied angles B (fig. 4.2) to machine feet A (fig. 4.2) and fix on ground by means of expansion bolts C (fig. 4.2) (not supplied).

Some machine parts are greased and oiled.
Before starting working carefully degrease the working areas as well as the guards with not dangerous solvent.

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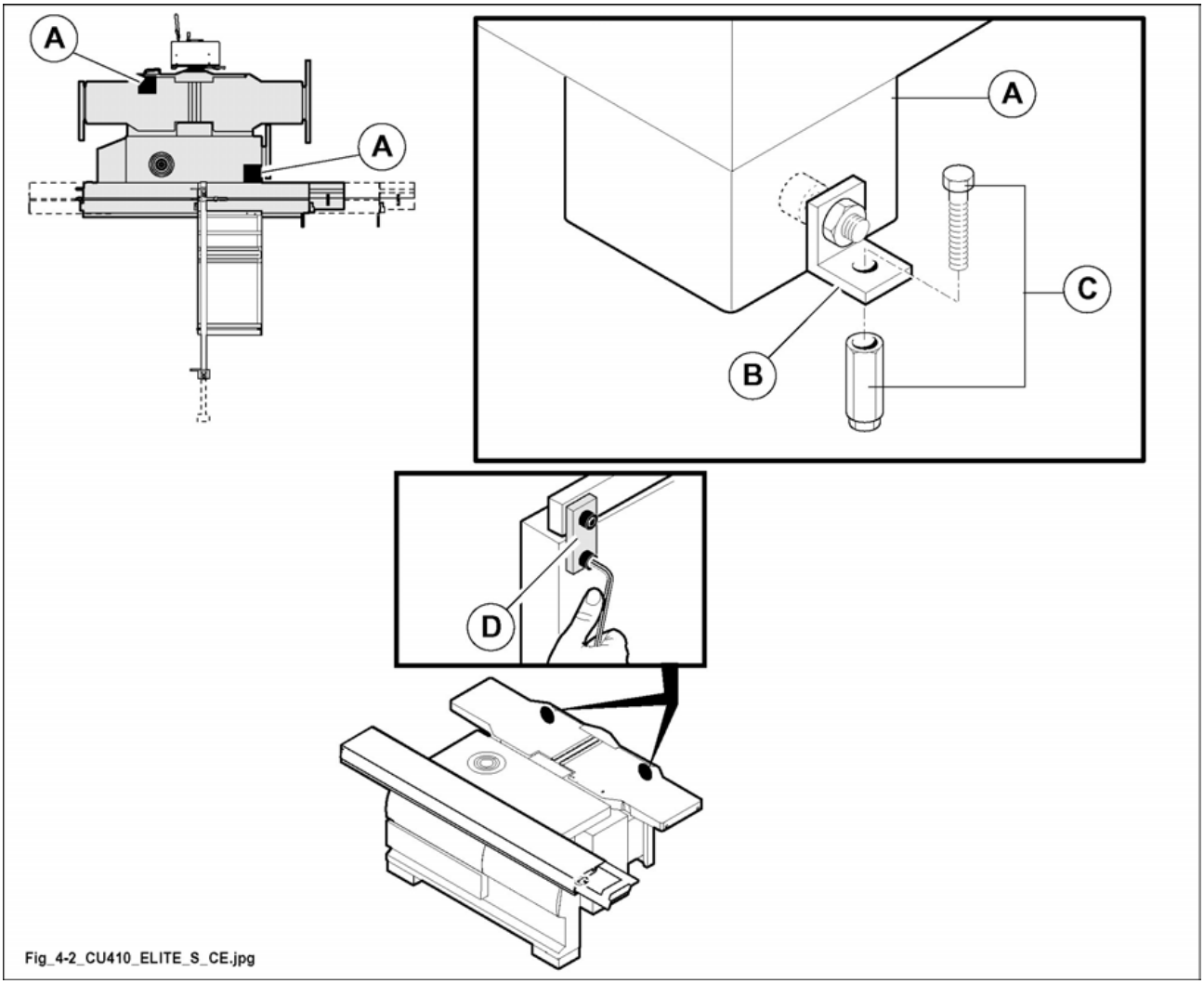


Fig. 4.2

4.3 FITTING THE PARTS DEMOUNTED FOR TRANSPORT REASONS

(ev_4-3_0.0)

For packing and transport reasons some machine members are removed.

4.3.A DISPLACING WHEELS - ASSEMBLY

(cu_4-3-a_0.0)

OPT

The unit is composed by:
- 2 fixed wheels (A fig. 4.3-A).
- 1 movement lever (B fig. 4.3-A).

1) Strike the sheet-metal to open the holes provided for supports (C fig. 4.3-A) and fixed wheels (A fig. 4.3-A).
2) Disassemble the doors corresponding to positions 3 and insert the wheels in the relative feet.
3) Mount the fixed wheels (A fig. 4.3-A).

To use the wheels, proceed as follows:
- open surfacer tables;
- insert lever (B fig. 4.3-A) into support (C fig. 4.3-A) from side 1 and use it as a lever to raise the machine;
- move the fixed wheels (A fig. 4.3-A) into the slot next to (E fig. 4.3-A); if necessary move by inserting a hexagonal wrench into screw (D fig. 4.3-A);
- move lever (B fig. 4.3-A) dto the opposite side of the machine (side 2), insert it into mount (C fig. 4.3-A) and proceed with moving the machine.

DANGER-WARNING:
the machine must be fixed to the floor.

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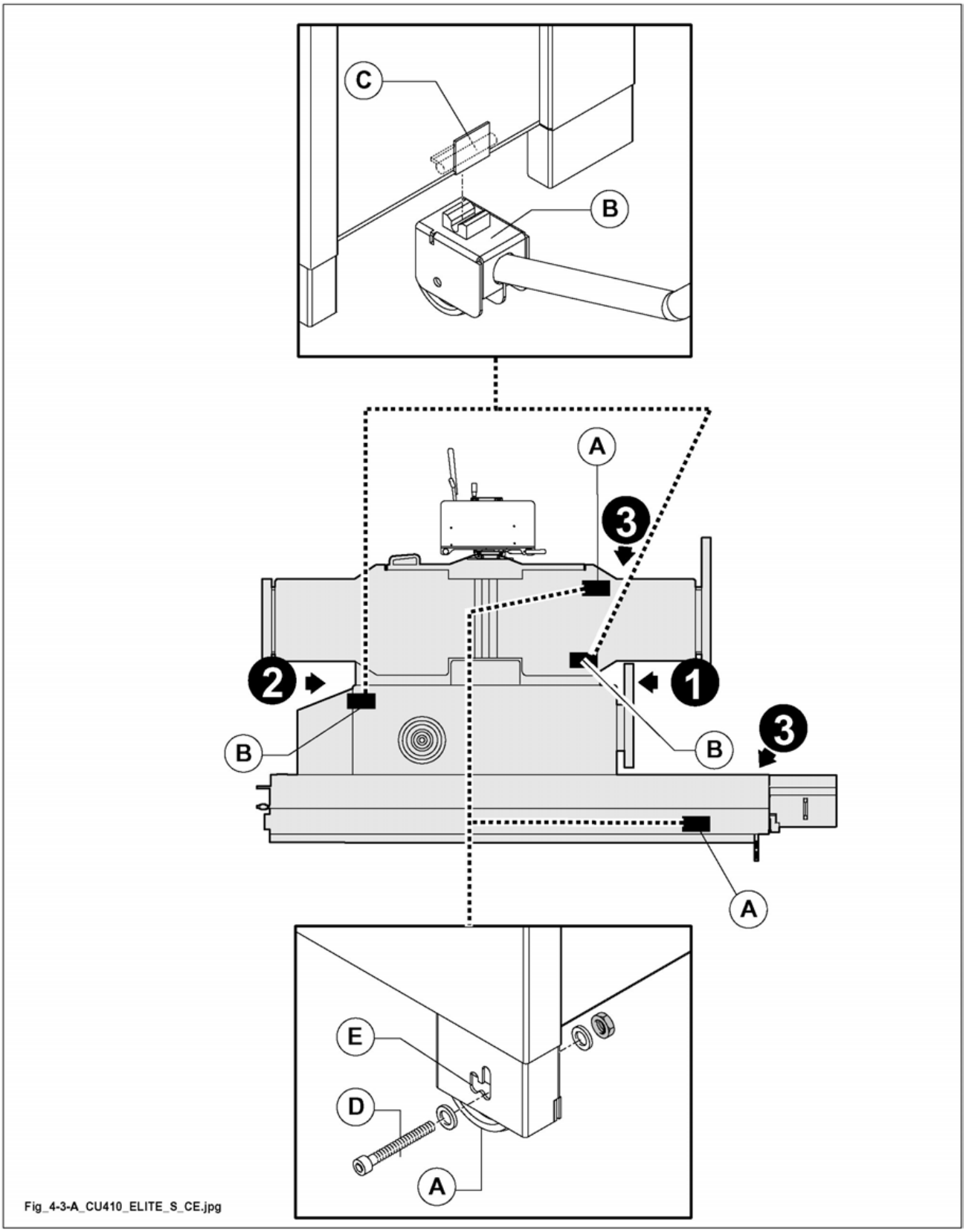


Fig. 4.3-A

SAW / SAW - SPINDLE MOULDER

(titolo_sega)

4.3.1 FITTING THE SLIDING TABLE

(ev_4-3-1_0.0)

Sliding table length: 3200 mm OPT

DANGER-WARNING:
all fitting operations require 2 persons.

Gently position the wagon unit on the base in such a way as not to knock the screws C – D and the pins E.

DANGER-WARNING:
do not move the sliding table in any direction too much because it might upset.

Proceed as follows:

1) remove the side cap (A fig. 4.3-1).
2) Position the wagon unit (B fig. 4.3-1) to rest on the screws (C fig. 4.3-1), inserting the 3 screws (D fig. 4.3-1) in the respective holes. Ensure that the 2 pins (E fig. 4.3-1) fit perfectly in the groove underneath the wagon unit.
3) Fit the washers to the 3 screws (D fig. 4.3-1) and tighten the nuts (F fig. 4.3-1).
4) Remount the side cap (A fig. 4.3-1).

Adjustment of slide (B fig. 4.3-1) is not necessary because presetting is carried out in SCM factory during the machine testing phase.
The lever (G fig. 4.3-1) is used to lock the wagon in the rest position (wagon closed) and in the loading position for the piece to be machined (wagon translated to right end stop).

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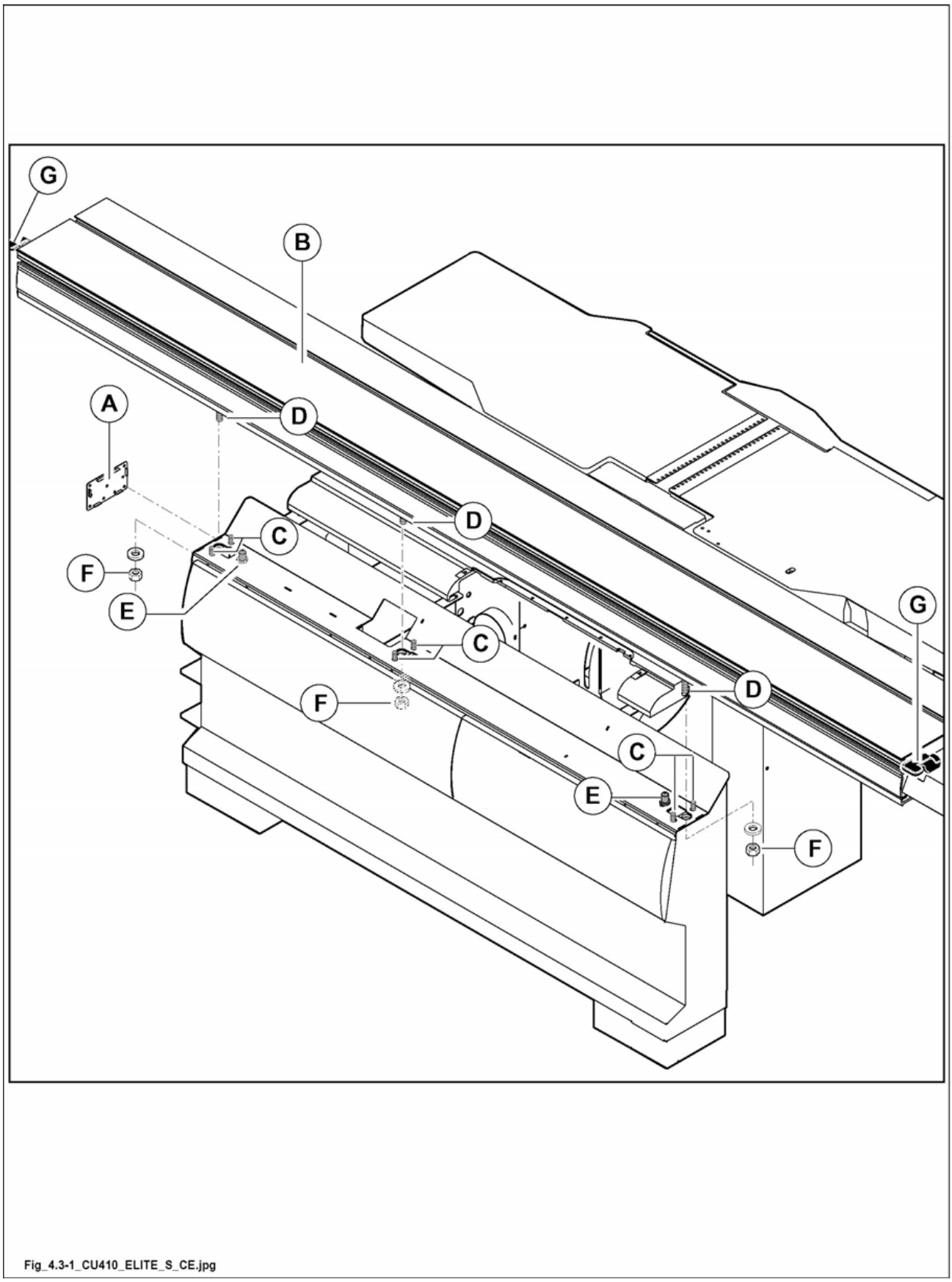


Fig. 4.3-1

4.3.11 TABLE FOR SLIDING TABLE - INSTALLATION

(mmax_4-3-11_0.0)

1) Remove sheet metal block (A fig. 4.3-11).
2) Tighten up the screws again (B fig. 4.3-11).
3) Position locking lever (C fig. 4.3-11) in closing cap housing (D fig. 4.3-11).
4) Bring closing cap (D fig. 4.3-11) alongside wagon, ensure that tables are aligned and tighten the 4 screws (E fig. 4.3-11).
5) Tighten grub screw (F fig. 4.3-11) ensuring that it is inserted into hole of pin (G fig. 4.3-11).
6) Remove lever blocking metal sheet from side opposite the wagon.

Lever (C fig. 4.3-11), is used to block carriage wagon into home position (wagon closed), and in loading piece to machine position (wagon transferred to right hand limit switch).

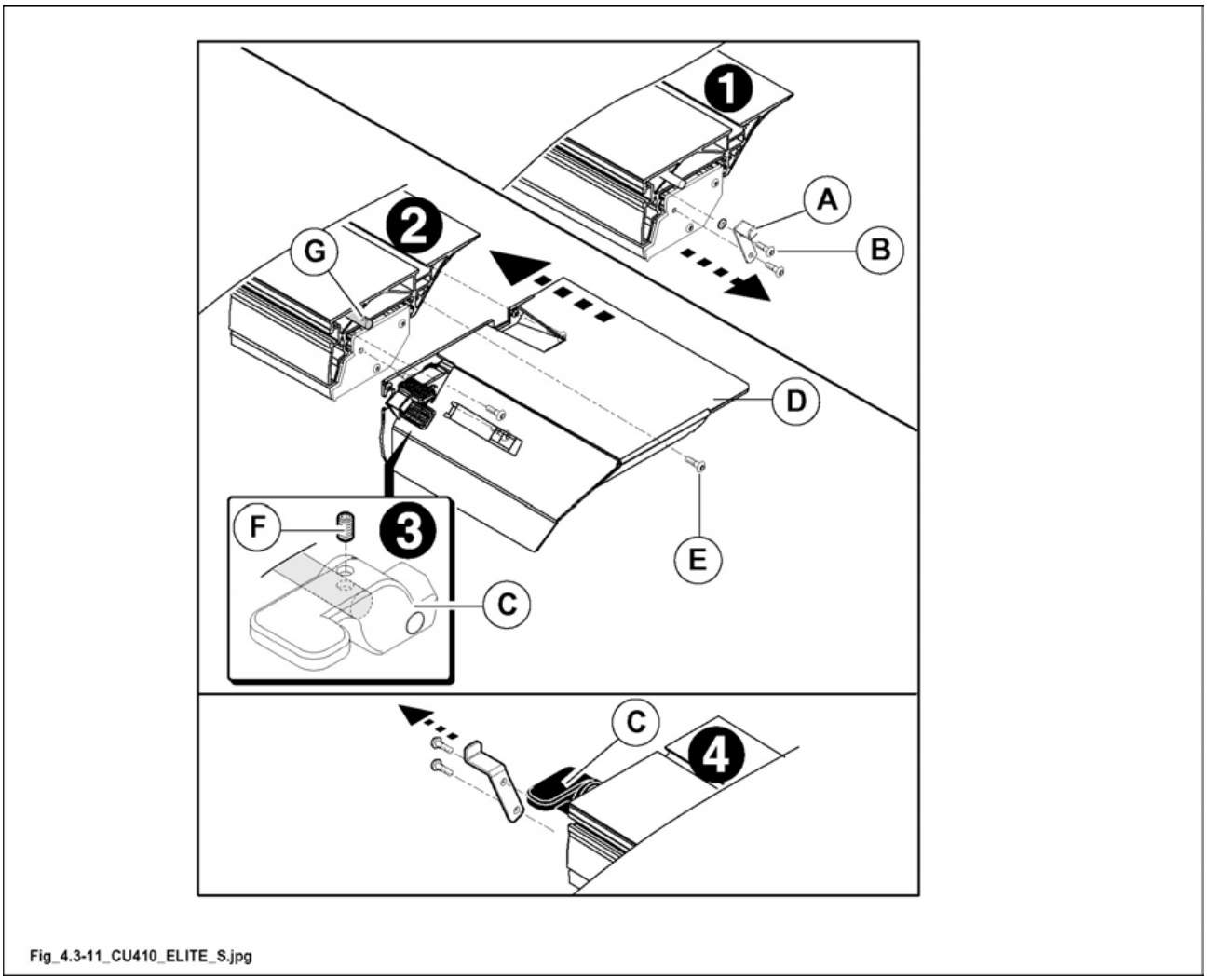


Fig_4.3-11_CU410_ELITE_S.jpg

Fig. 4.3-11

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(vuota_4-0)

4.3.12 FITTING THE GUARD FOR SAW BLADE AND SCORER

(hg_4.3.12)

- Lift the saw assembly by turning the handwheel (A fig. 4.3-12).
- Insert the protection (C fig. 4.3-12) in the hole (D fig. 4.3-12) tightening the handle (E fig. 4.3-12).

DANGER-WARNING:
never remove this guard: it shall be fitted in order to cover the saw blade as much as possible.

NOTE-INFORMATION:
the machine is always equipped with 1 riving knife.
Fit the guard to the riving knife according to saw blade diameter (you have to consider the reference elements engraved on the riving knife).

DANGER-WARNING:
adjust the position of the riving knife (see Par. 6.1) so that its distance from the saw blade is between 3 and 8 mm (see example in fig. 4.3-12).
The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

Connect the exhaust pipe (H fig. 4.3-12) to the suction system with hoses of proper diameter.

With this protective hood, it's strictly forbidden to carry out not-through cuts.

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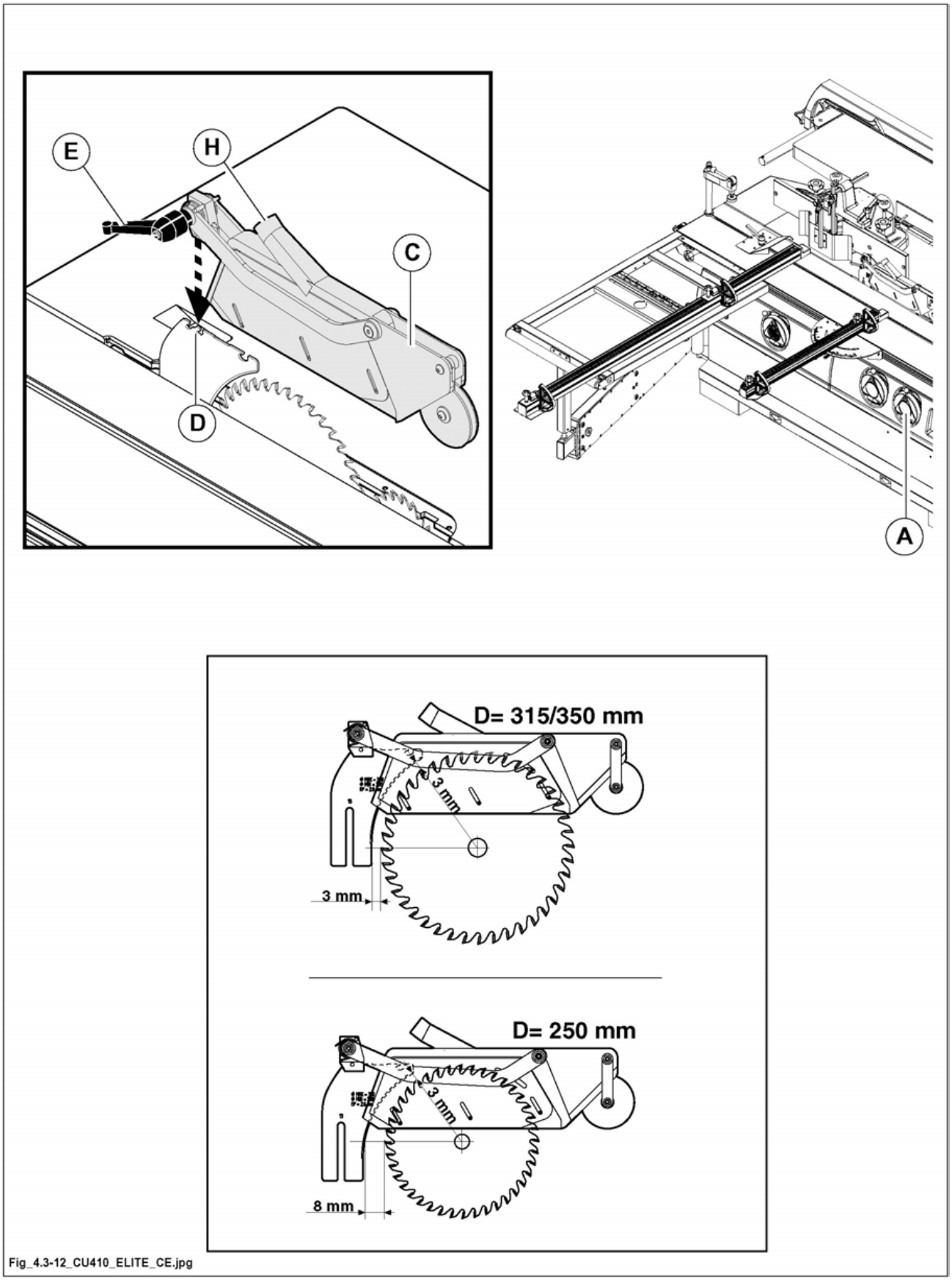

E
H
C
D
A
D= 315/350 mm
3 mm
3 mm
D= 250 mm
3 mm
8 mm
Fig_4.3-12_CU410_ELITE_CE.jpg

Fig. 4.3-12

4.3.14 FITTING THE ADDITIONAL TABLES

(ev_4-3-14_0.0)

DANGER-WARNING:
all fitting and demounting operations require 2 persons.

4.3.14.2 FITTING THE ADDITIONAL TABLE AT EXIT SIDE

(ev_4-3-14-2_0.0)

Fix additional table (A fig. 4.3-14-2) to table (B fig. 4.3-14-2) with screws (C fig. 4.3-14-2) and align the additional table to the table by means of grub screws (D fig. 4.3-14-2) (check the alignement with a proper rule).

A ***Standard extension table***

B ***Extension table for the version with a feeder system***

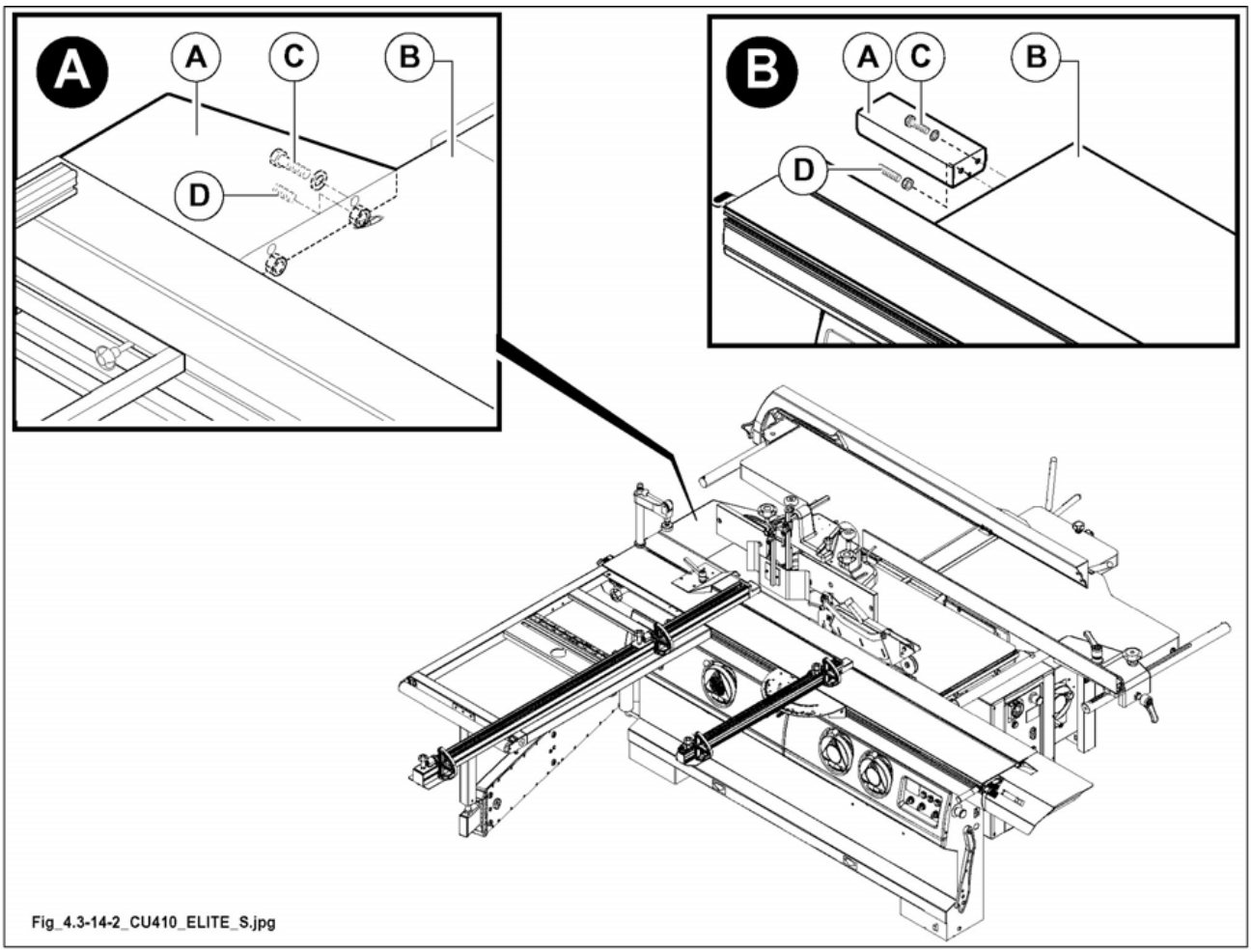


Fig. 4.3-14-2

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(vuota_4-00)

4.3.24 FITTING THE SUPPORTING FRAME

(hd_4.3-24_0.0)

NOTE-INFORMATION:
for transport reasons the frame is demounted from the machine.

DANGER-WARNING:
all fitting operations require 2 persons.

1) Insert the support (B fig. 4.3-24) in the groove of the wagon (A fig. 4.3-24).
2) Place the frame (D fig. 4.3-24) on the support (B fig. 4.3-24) and on the pin (F fig. 4.3-24), inserting the two pads (H fig. 4.3-24) in the groove of the wagon.

NOTE-INFORMATION:
the screw (F fig. 4.3-24) must sit perfectly in the special hole underneath the frame (D fig. 4.3-24).

3) Level the table (D fig. 4.3-24), if necessary, acting on the pin (F fig. 4.3-24).
4) Tighten the knobs (C fig. 4.3-24).
5) Insert the stud bolt (L fig. 4.3-24) with the presser (M fig. 4.3-24) in the groove of the wagon (A fig. 4.3-24) and turn it clockwise to lock it.
6) When the wagon (A fig. 4.3-24) is not used, lock it with the lever (N fig. 4.3-24).

The table is already registered; to make further adjustments proceed as follows:
- loosen knobs (C fig. 4.3.24);
- loosen screws (P fig. 4.3.24) and move the dowels (Q fig. 4.3.24) to adjust the height position.

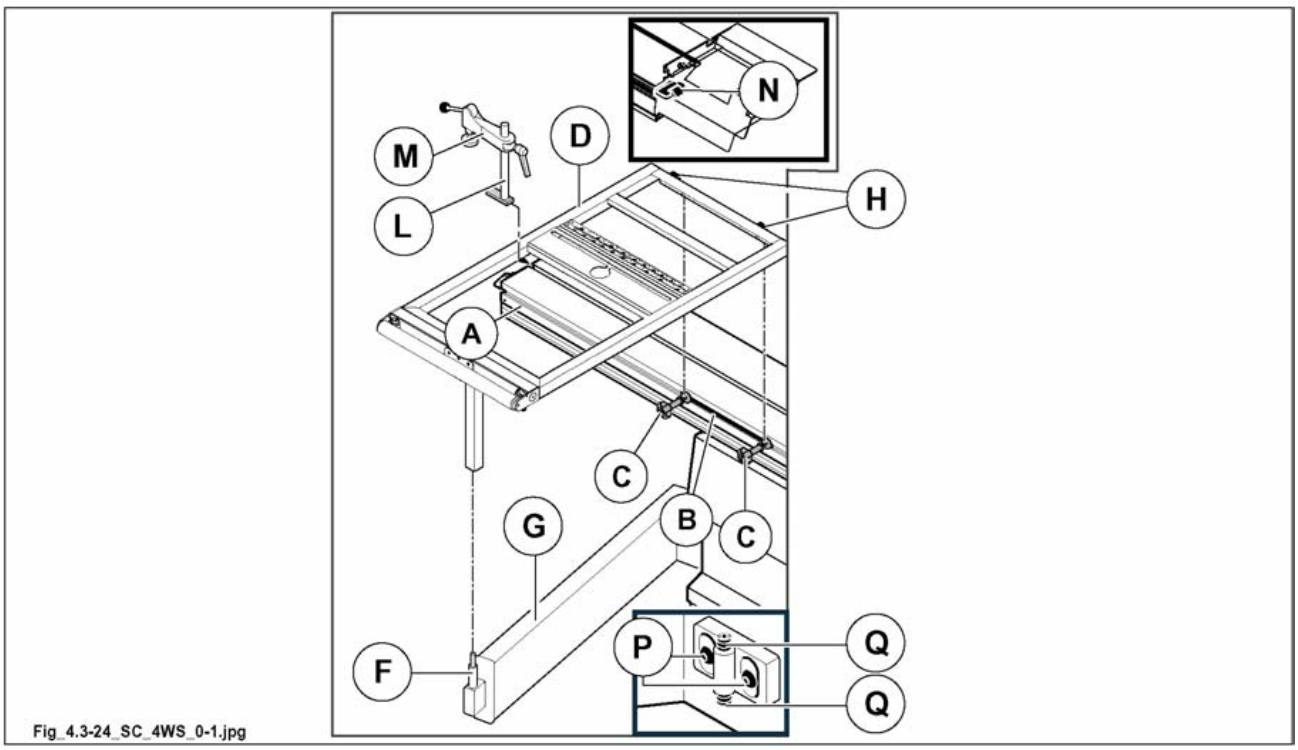


Fig. 4.3-24

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4.3.24.2 FITTING THE REST RULE

(hd_4.3.24.2_0.0)

A *Installation for 90° cuts*

1) Place the telescopic ruler on the table (A fig. 4.3-24-2), inserting the fulcrum (C fig. 4.3-24-2) in the hole (R fig. 4.3-24-2).
   Insert the knob (F fig. 4.3-24-2) in the slot (T fig. 4.3-24-2) by means of the hole (D fig. 4.3-24-2).
2) Position the telescopic ruler in such a way that the pin (C fig. 4.3-24-2) fits into place against the gib (L fig. 4.3-24-2). The gib (L fig. 4.3-24-2) is adjusted by our technicians and is used to rapidly position the telescopic ruler at the right distance from the saw blade (only at a 90° position).
3) Position the telescopic ruler in such a way that it fits into place against the device (S fig. 4.3-24-2).
4) Tighten the knobs (F fig. 4.3-24-2) and (E fig. 4.3-24-2).

B *Installation for inclined cuts*

1) Place the telescopic ruler on the table (A fig. 4.3-24-2), inserting the fulcrum (C fig. 4.3-24-2) in the hole (R fig. 4.3-24-2).
   Insert the knob (F fig. 4.3-24-2) in the slot (T fig. 4.3-24-2) by means of the hole (D fig. 4.3-24-2).
2) For use, position the ruler referring to the plate (P fig. 4.3-24-2).
3) Tighten the knobs (F fig. 4.3-24-2) and (E fig. 4.3-24-2).

The ruler is fitted with an extractable telescopic extension (H fig. 4.3-24-2), which may be lengthened as required after loosening the knob (G fig. 4.3-24-2).
When the chip guard (M fig. 4.3-24-2) is worn, bring it up to the saw blade by loosening the grub screw (N fig. 4.3-24-2).

The telescopic rule is supplied with the stops (B fig. 4.3-24-2). These can rapidly be positioned to rest on or push the workpiece during machining, by simply tipping them over.

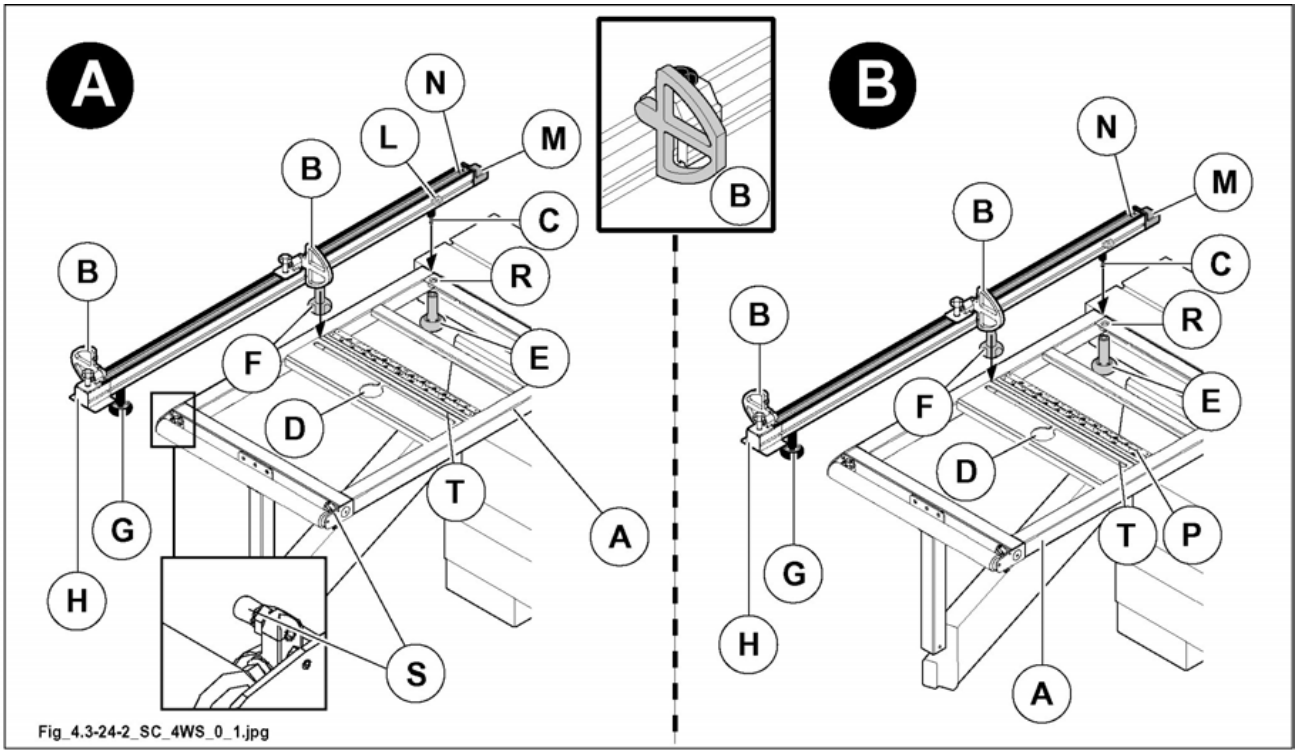


Fig. 4.3-24-2

4.3.30.1 FITTING THE ANGLED CUTS DEVICE

(mmax_4.3.30.1_0.0)

OPT

1) Insert the stud bolt (N fig. 4.3-30-1) with the presser (E fig. 4.3-30-1) into the groove of the wagon (C fig. 4.3-30-1).
2) Mount the ruler assembly (A fig. 4.3-30-1) inserting the gib (R fig. 4.3-30-1) in the groove of the wagon (C fig. 4.3-30-1).
3) Tighten the lever (G fig. 4.3-30-1).
4) Loosen handle (F fig. 4.3-30-1).
5) Position the ruler assembly at the right distance from the saw blade; at a 90° angle send the ruler assembly to stop up against the gib (L fig. 4.3-30-1); the gib (L fig. 4.3-30-1) is adjusted by our technicians and serves to quickly position the ruler assembly at the right distance from the saw blade.
6) To make angular cuts turn the ruler assembly (A fig. 4.3-30-1) using index (D fig. 4.3-30-1) as a reference.
7) Block by tightening handle (F fig. 4.3-30-1).
8) Position the presser up against the ruler assembly ensuring that the washer (Q fig. 4.3-30-1) is inserted into the groove.
9) Rotate the stud bolt (N fig. 4.3-30-1) clockwise to block.

The table has already been adjusted; to adjust proceed as follows:
- loosen levers (G fig. 4.3-30-1);
- adjust the dowels (S fig. 4.3-30-1) to ensure the table is parallel to the wagon;
- loosen screws (T fig. 4.3-30-1) and move the dowels (U fig. 4.3-30-1) to adjust the height position.

When the clip guard (M fig. 4.3-30-1) is worn, bring it up against the saw blade by turning the blocking screws.

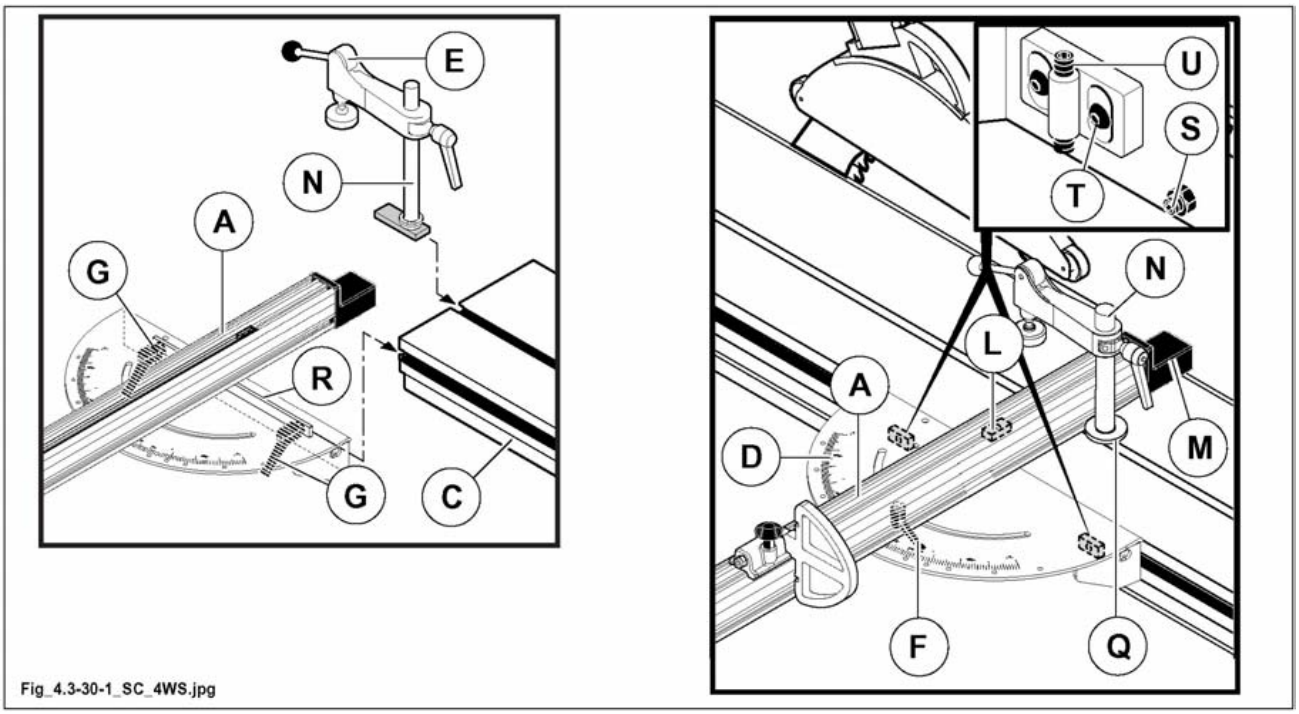


Fig. 4.3-30-1

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4.3.31 WAGON ATTACHMENT - INSTALLATION

(mmax_4.3.31_0.0)

OPT

1) Mount the attachment (A fig. 4.3-31) inserting the gib (B fig. 4.3-31) in the groove of the wagon (C fig. 4.3-31).
2) Tighten the lever (D fig. 4.3-31).
3) The table has already been adjusted; for further adjustments, act on the grub screws (E fig. 4.3-31) (levelling) and the screw (F fig. 4.3-31) (positioning in height).

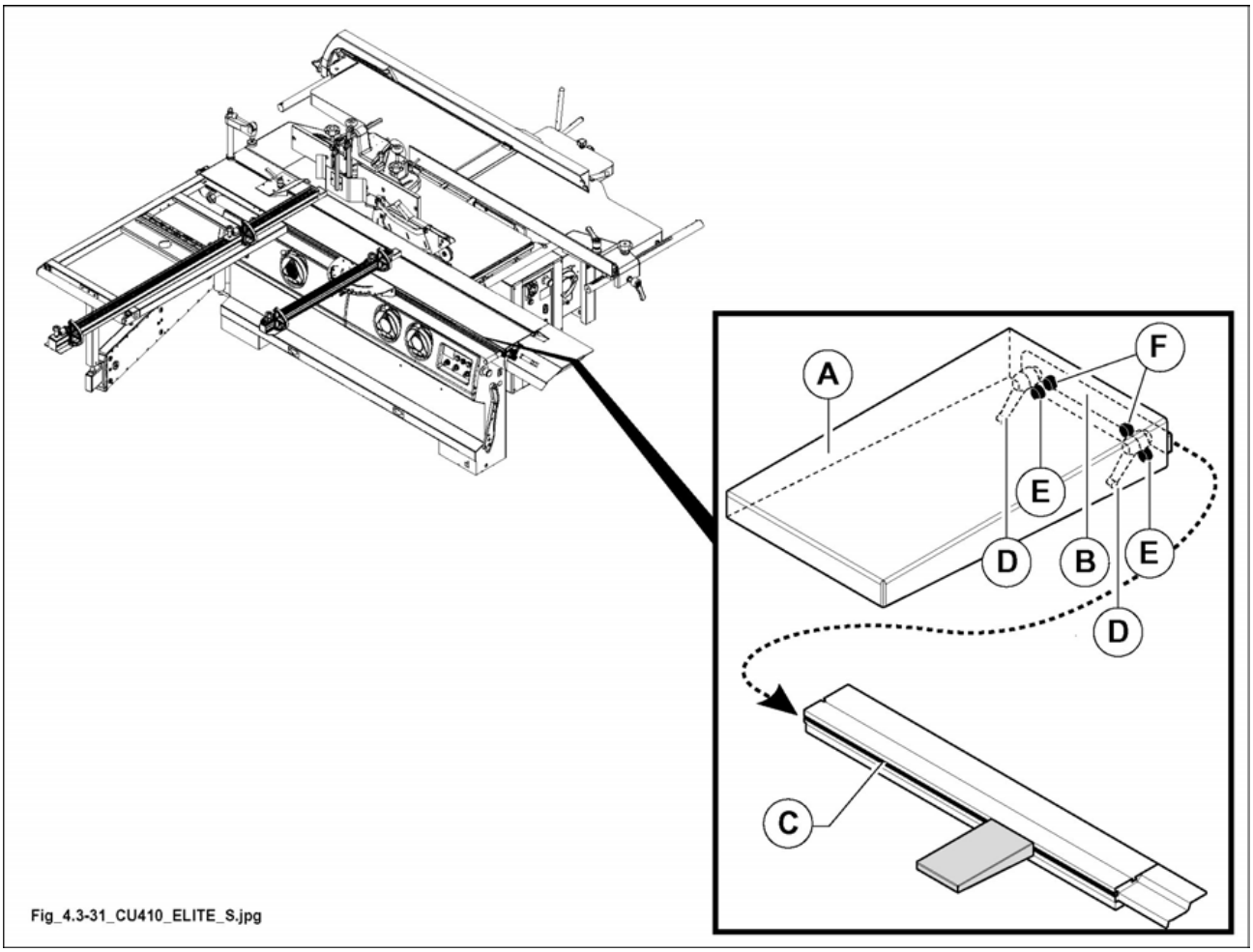


Fig. 4.3-31

4.3.33 FITTING THE FENCE FOR PARALLEL CUTS

(gu_4.3.33_0.0)

DANGER-WARNING:
all fitting and demounting operations require 2 persons.

For transport reasons round bar (A fig. 4.3-33) may be demounted.

- Position the calibrated spacers (C fig. 4.3-33) as indicated in the figure and insert the guide (A fig. 4.3-33) in the table (B fig. 4.3-33).
- Block the guide (A fig. 4.3-33) with the knobs (D fig. 4.3-33).

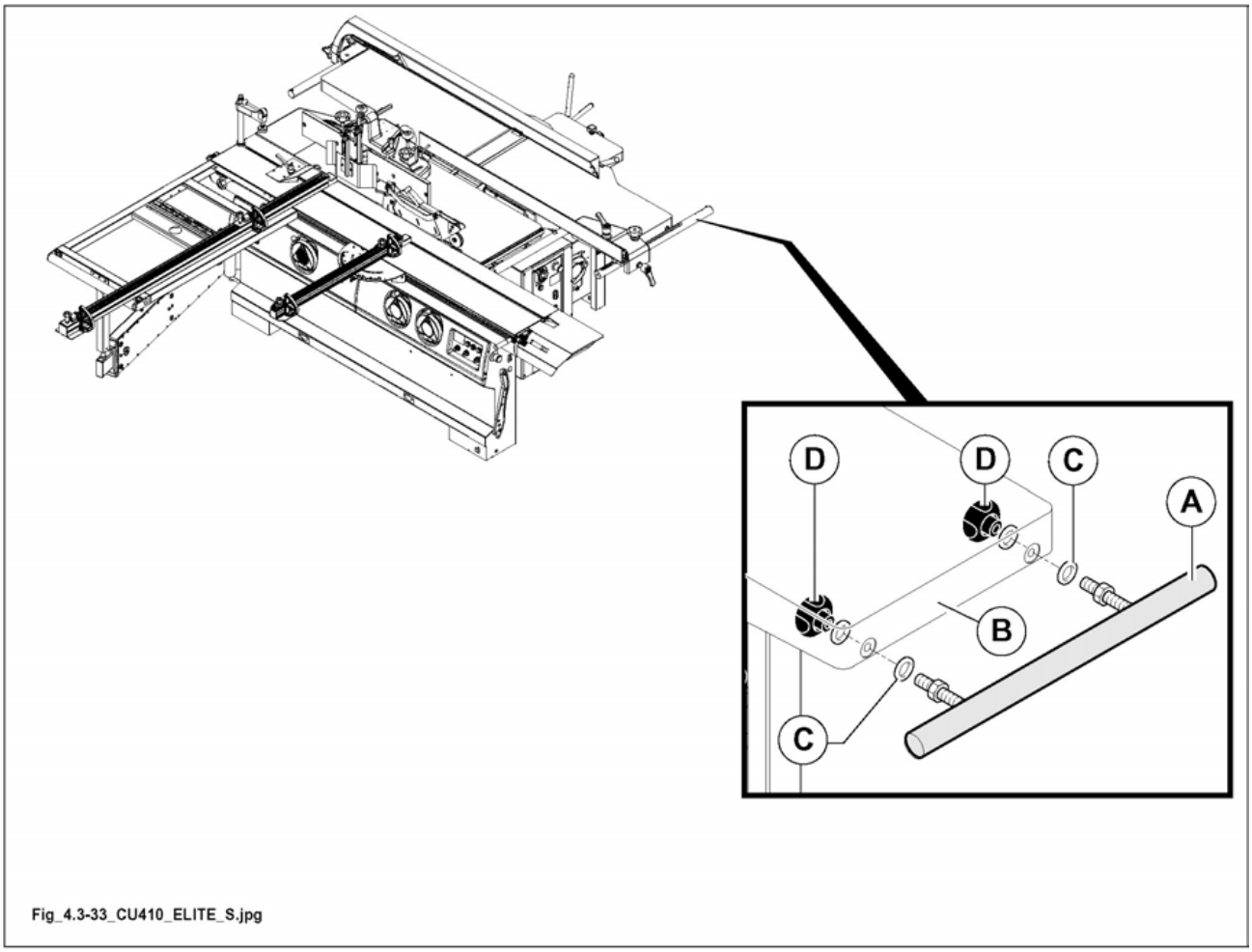


Fig. 4.3-33

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4.3.33.1 SAW GUIDE ASSEMBLY WITH MICROMETRIC ADJUSTMENT

(mmax_4.3.33.1_0.0)

Position the saw unit fence (A fig. 4.3-33-1) in the required position, press the lever (D fig. 4.3-33-1) to position (1 fig. 4.3-33-1) and rotate it to position (2 fig. 4.3-33-1).

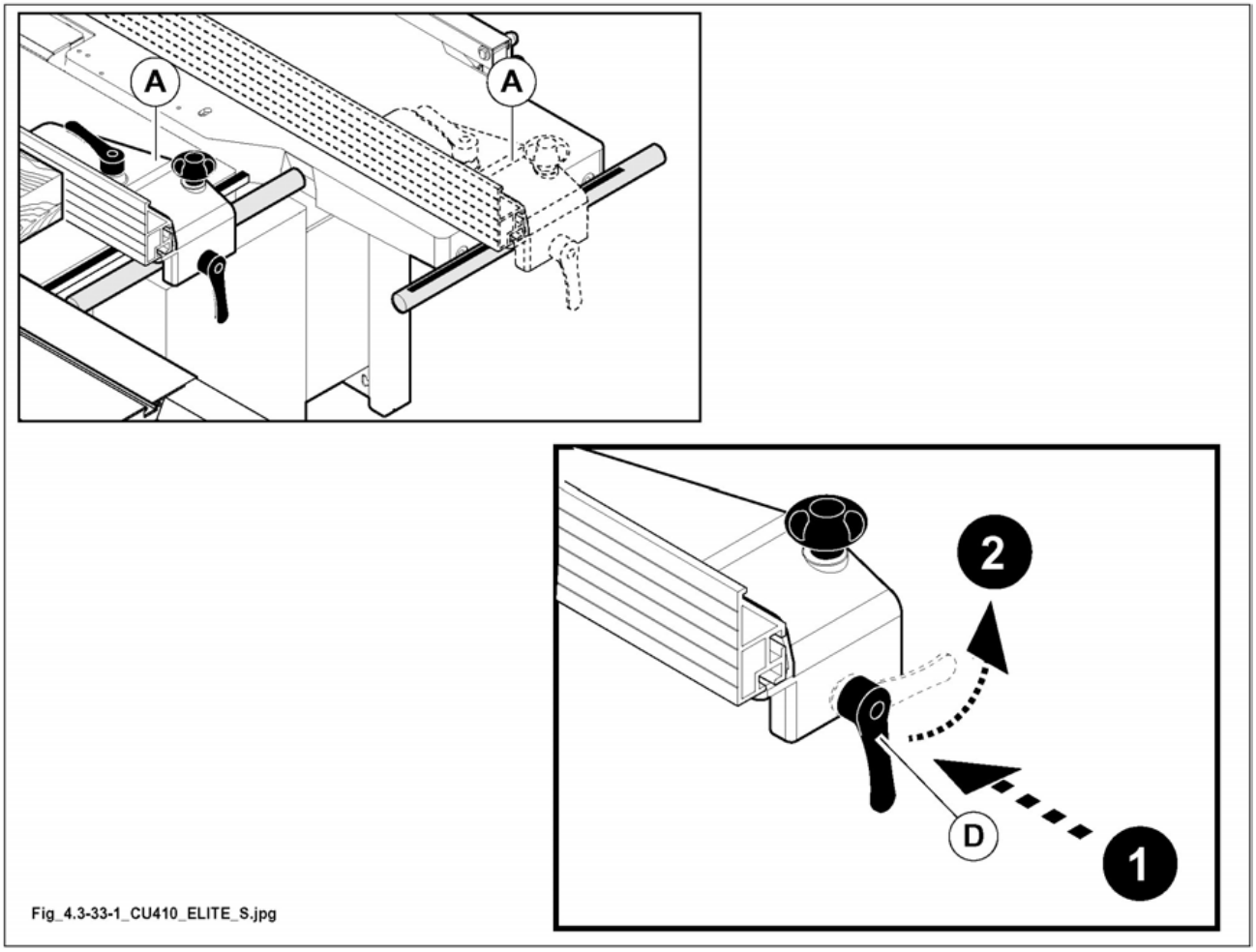


Fig. 4.3-33-1

4.3.40 RIVING KNIFE FITTING

(hg_4.3.40_0.0)

NOTE-INFORMATION:
see Chapter 6.

4.3.41 FITTING THE SAW BLADE

(he-4.3.41_0.0)

DANGER-WARNING:
- use proper gloves for handling the saw blade.
- In case of large pieces and it is necessary the help of another person, on the machine, we recommend to apply an extension table to the exit side for removing the piece already cut and the second operator shall stay at the exit side of the additional table.

DANGER-WARNING:
Stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

Turn selector (3 fig. 4.3-41) to ( ); unlocked motor brake, pilot lamp switched on.

For fitting or replacing the saw blade proceed as follows:
1) lift the saw unit totally up (inclination: 90°).
2) Position the squaring frame (A fig.4.3-41) as shown in the figure and translate the wagon (H fig.4.3-41) completely to the right.
3) Lift the lever (M fig.4.3-41) and open the guard (N fig.4.3-41).
4) Fit pin (B fig.4.3-41) into the saw shaft pulley hole.

NOTE-INFORMATION:
a limit switch ensures that with guard (N fig. 4.3-41) open the motor can not be started.

NOTE-INFORMATION:
the locking nut (C fig. 4.3-41) of the saw blade is counter-clockwise; to unscrew it turn it clockwise.

5) Loosen the lock nut (C fig. 4.3-41) using a 24 mm hex wrench and remove flange (D fig. 4.3-41).
6) In sequence mount the saw (E fig. 4.3-41), the flange (D fig. 4.3-41) and the nut (C fig. 4.3-41) (to prevent any vibration, thoroughly clean the flanges before mounting the saw blade).
7) Tighten the nut using the 24 mm wrench and the pin (B fig. 4.3-41).
8) Adjust dividing knife (F fig. 4.3-41) height by unloosing nut (G fig. 4.3-41).

Turn selector (3 fig. 4.3-41) to ( ); locked motor brake, pilot lamp switched off.

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DANGER-WARNING:
for safety reasons you must close guard (N fig. 4.3-41), otherwise:
- the machine does not start.
- The guard interferes with the sliding table motion.

Adjust the position of the riving knife so that its distance from the saw blade is between 3 and 8 mm.
The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

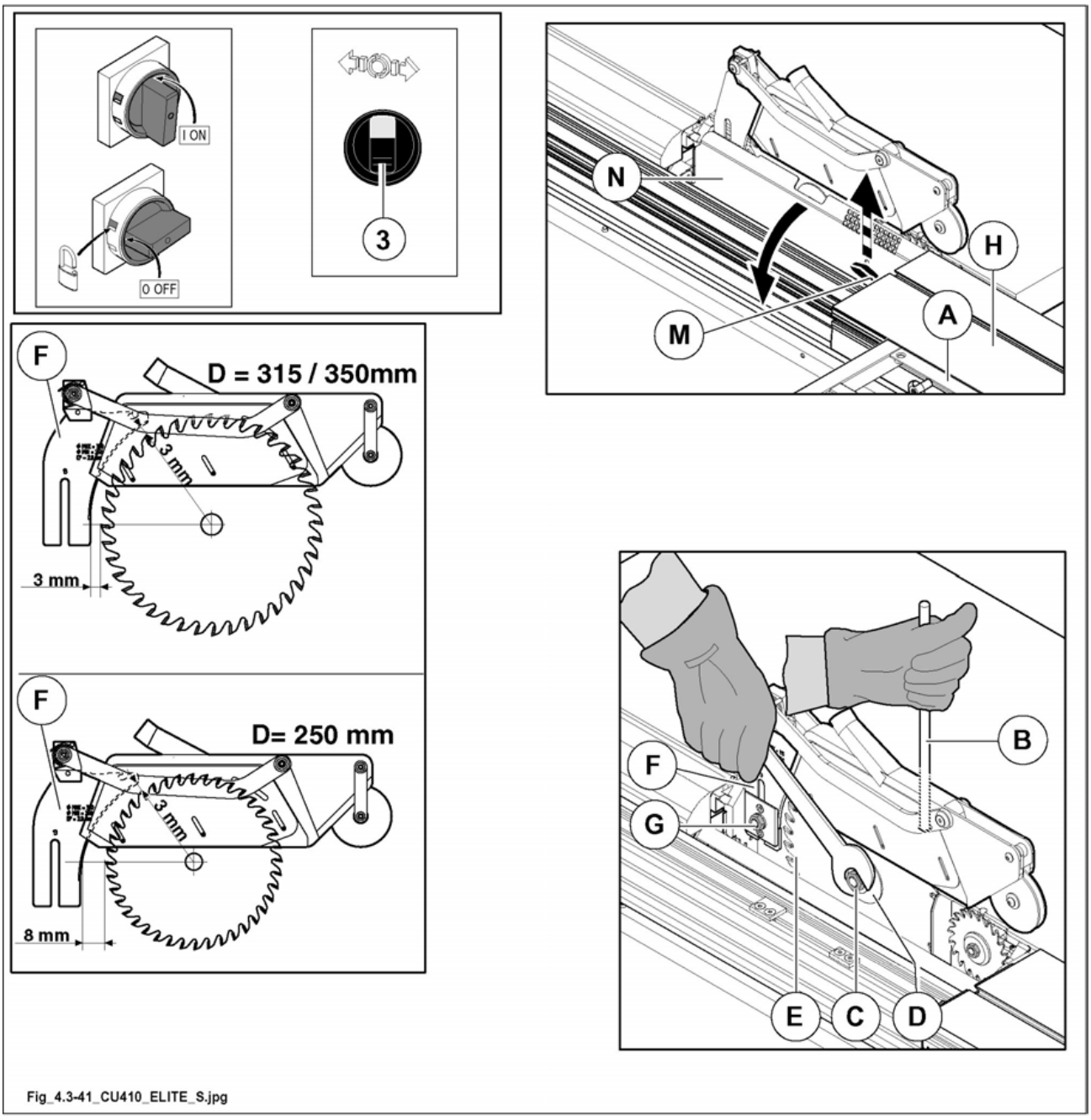


Fig. 4.3-41

4.3.45 FITTING THE SCORER

(ev_4-3-45_0.0)

DANGER-WARNING:
use gloves for handling the scorer blade.

DANGER-WARNING:
Stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

Turn selector (3 fig. 4.3-45) to ( ); unlocked motor brake, pilot lamp switched on.

For fitting or replacing the scorer blade proceed in this way:

1) position the squaring frame (A fig.4.3-45) as shown in the figure and translate the wagon (H fig.4.3-45) completely to the right.
2) Lift the lever (M fig.4.3-45) and open the guard (N fig.4.3-45).
3) Fit pin (B fig.4.3-45) in the blade-holding flange hole.

NOTE-INFORMATION:
a limit switch ensures that with guard (N fig. 4.3-45) open the motor can not be started.

4) Loosen the lock nut (C fig. 4.3-45) using a 17 mm hex wrench and remove flange (D fig. 4.3-45).
5) In sequence mount the blade (E fig. 4.3-45) with the teeth opposed to the ones of the saw, the flange (D fig. 4.3-45) and the nut (C fig. 4.3-45).
6) Tighten the nut using the 17 mm wrench and the pin (B fig. 4.3-45).

Turn selector (3 fig. 4.3-45) to ( ); locked motor brake, pilot lamp switched off.

CAUTION:

with tapered scoring saw (tipo A) always fit the spacer ring L.

With adjustable scoring saw (tipo B) the spacer ring L should not be fitted.

DANGER-WARNING:
for safety reasons you must close guard (N fig. 4.3-45), otherwise:
- the machine does not start.
- The guard interferes with the sliding table motion.

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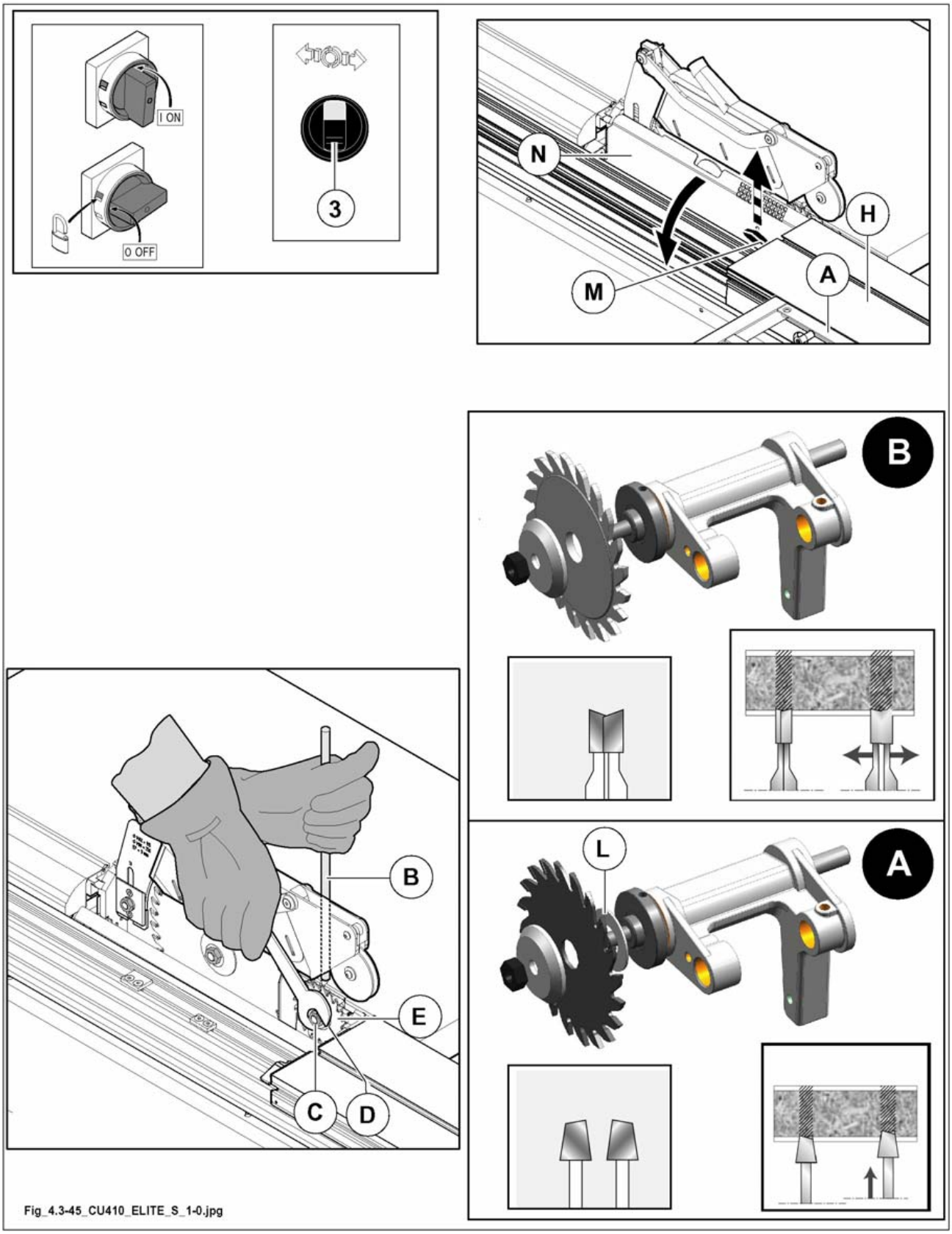


Fig. 4.3-45

SURFACE PLANING AND THICKNESSING MACHINE

(titolo_fs)

4.3.47 BRIDGE GUARD FITTING

(cu_4-3-47_0.0)

NOTE-INFORMATION:
the protections must always be mounted and be positioned in such as way as to completely cover the tools.

For transport reasons bridge (A fig. 4.3-47) is demounted.

For fitting the bridge again:
1) fit the protection (A fig. 4.3-47) into place as shown in the picture.
2) Screw the 2 retaining screws through the holes (B fig. 4.3-47).

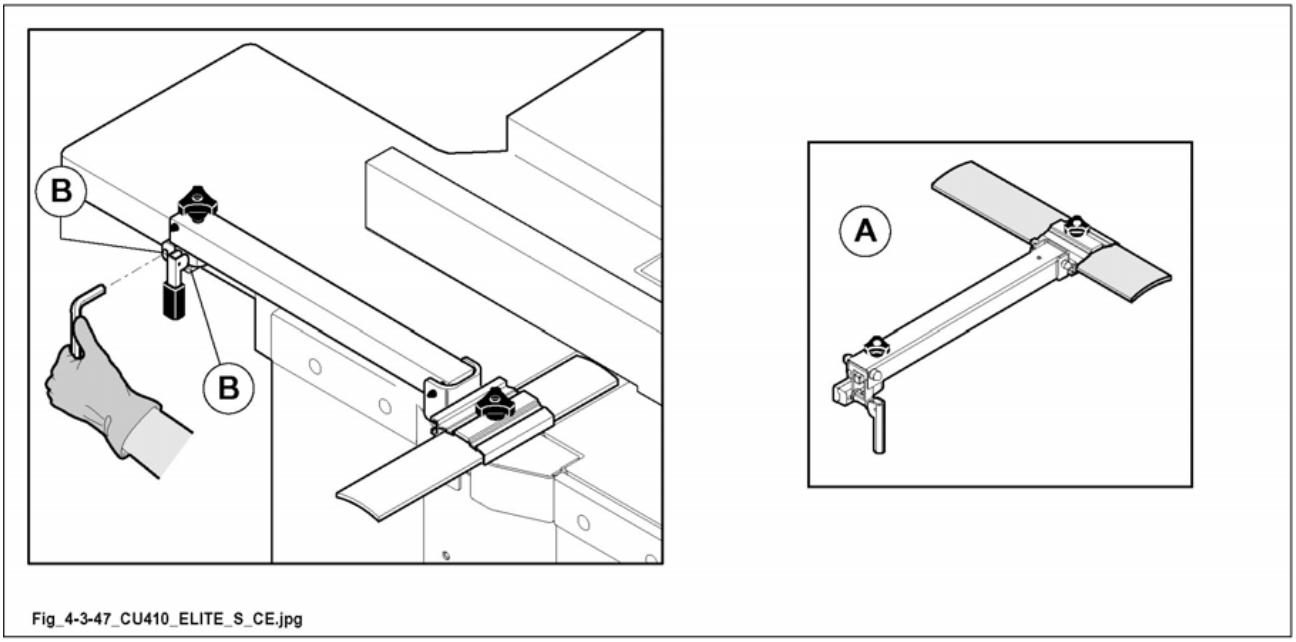


Fig. 4.3-47

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4.3.48 PLANING FENCE - ASSEMBLY

(cu-4-3-48-0.0)

Position the planing fence (A fig. 4.3-48) in the required position, press the lever (D fig. 4.3-48) to position (1 fig. 4.3-48) and rotate it to position (2 fig. 4.3-48).

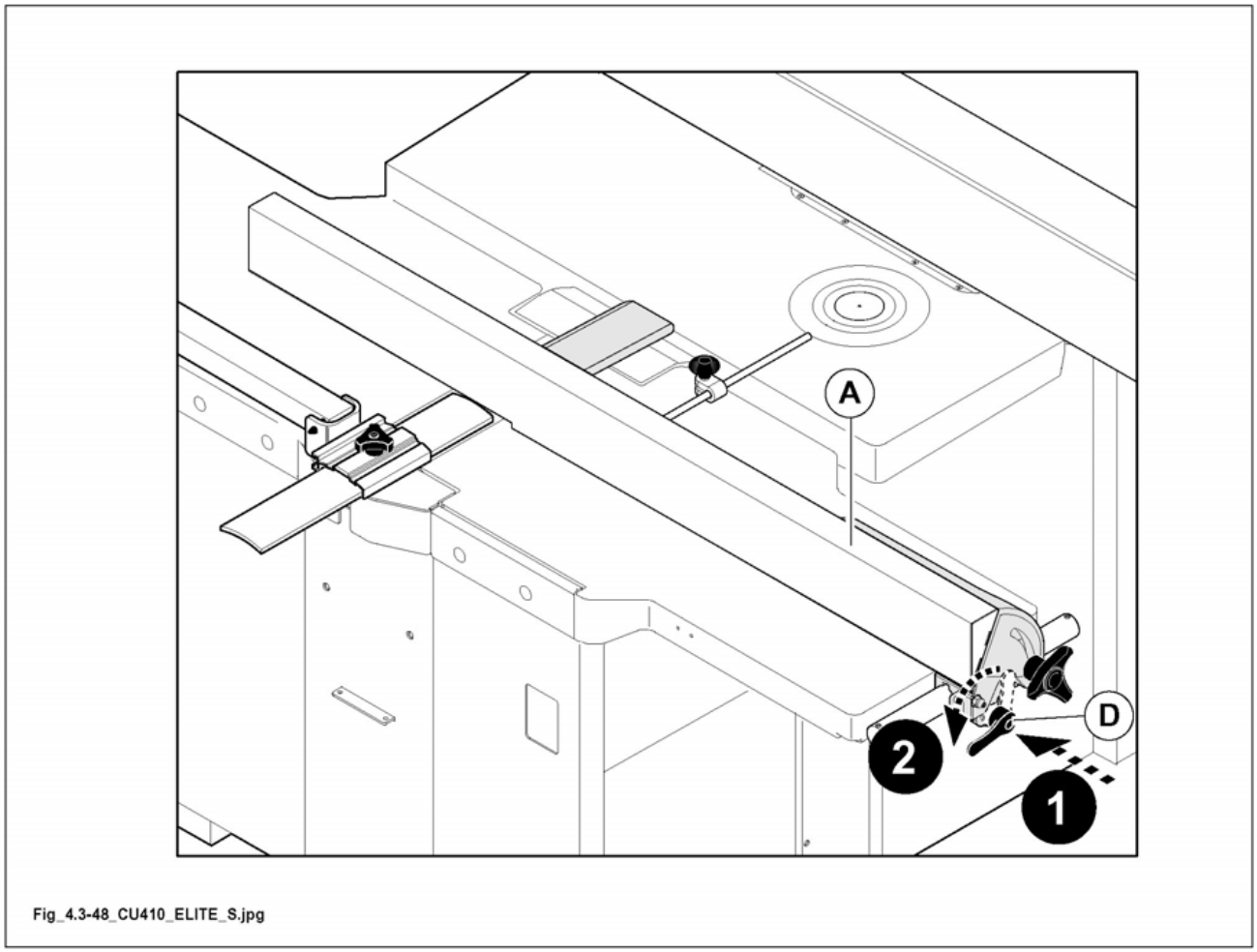


Fig. 4.3-48

SPINDLE MOULDER

(titolo_toupie)

4.3.52 TENONING TABLE AND GUARD - ASSEMBLY

(cu-4-3-52-0.0)

NOTE-INFORMATION:
for packing and transport reasons some machine members are removed.

- Insert the wedge (A fig. 4.3-52) in the slot on the wagon.
- Fasten the tenoning table (C fig. 4.3-52) to the table (D fig. 4.3-52) or (F fig. 4.3-52), using screws (E fig. 4.3-52).

Chip shield

DANGER-WARNING:
the chip shield (N fig. 4.3-52) is not suitable for tenoning.

Therefore:
- loosen screw (P fig. 4.3-52) and remove the chip shield (N fig. 4.3-52).
- Construct one or two wooden pegs (Q fig. 4.3-52) on the basis of the length of the panel, so as to ensure an adequate support for the piece to be processed.
- Fix it to the guide using two securing countersink screws (L fig. 4.3-52).

CAUTION:
the screw heads must be sunk completely into the wood so they don't protrude.

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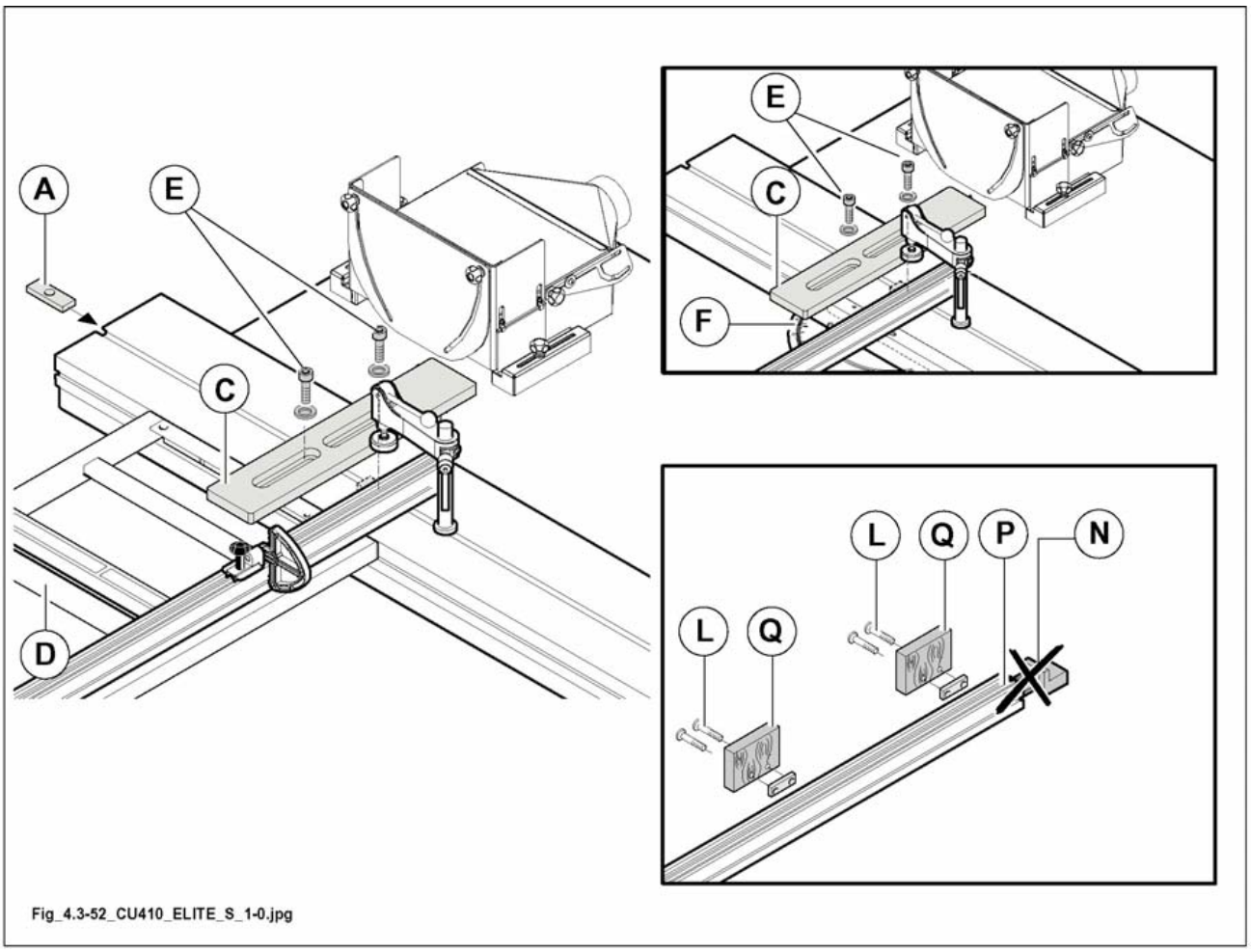


Fig. 4.3-52

4.3.73 FITTING GUARDS

(cu_4-3-73_0.0)

DANGER-WARNING:
the guard must always be mounted and must be positioned in such a way as to completely cover the tool.

4.3.73.1 SPINDLE MOULDER HOOD GUIDE

(cu_4-3-73-1_0.0)

DANGER-WARNING:
all fitting operations require 2 persons.

House the reference plugs underneath the hood in the appropriate seats on the worktable.
Screw the two knobs (A fig. 4.3-73-1) into the appropriate holes on the worktable.

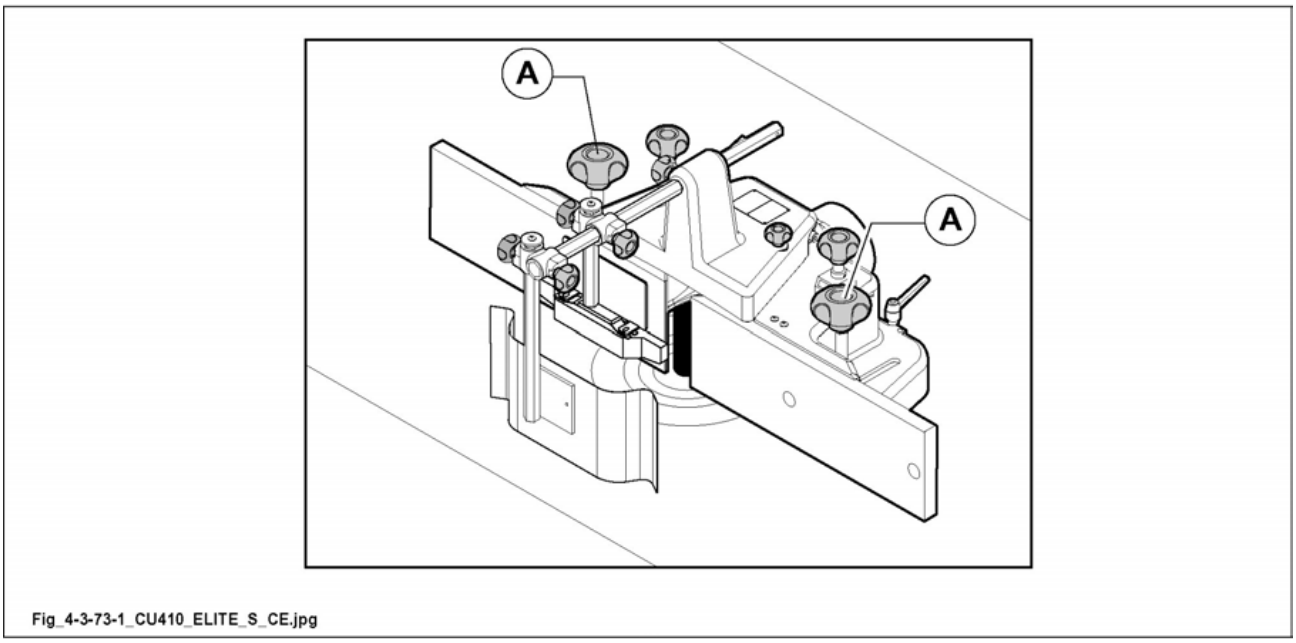


Fig. 4.3-73-1

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4.3.73.4 TENONING HOOD-FENCE UNIT

(cu_4-3-73-4_0.0)

OPT

- Rest the hood on the table in the position proper for the milling depth required, the fasten it by tightening knobs (1 fig. 4.3-73-4).

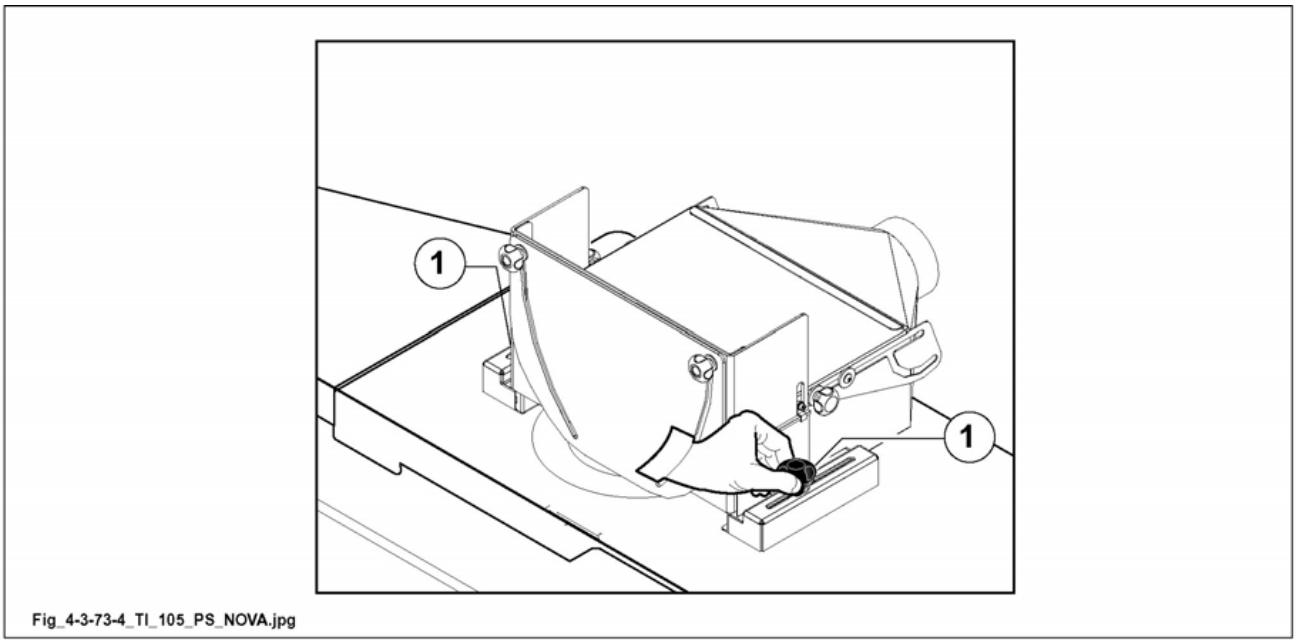


Fig. 4.3-73-4

4.3.73.5 GUARD FOR MILLING AT THE SPINDLE

(cu_4-3-73-5_0.0)

- Position the hood on the work table centring the reference pin (C fig. 4.3-73-5) in the through hole.
- Screw down the pin (D fig. 4.3-73-5).
- Mount the bracket (A fig. 4.3-73-5) (supplied only for the version with router rotation inversion).

When necessary, move the guide (B fig. 4.3-73-5) screwing it into the bracket (A fig. 4.3-73-5).

DANGER-WARNING:
all adjusting operations are to be carried out with standstill spindle.

DANGER-WARNING:
before starting working manually turn the tool to make sure that there is no contact with the fixed parts.

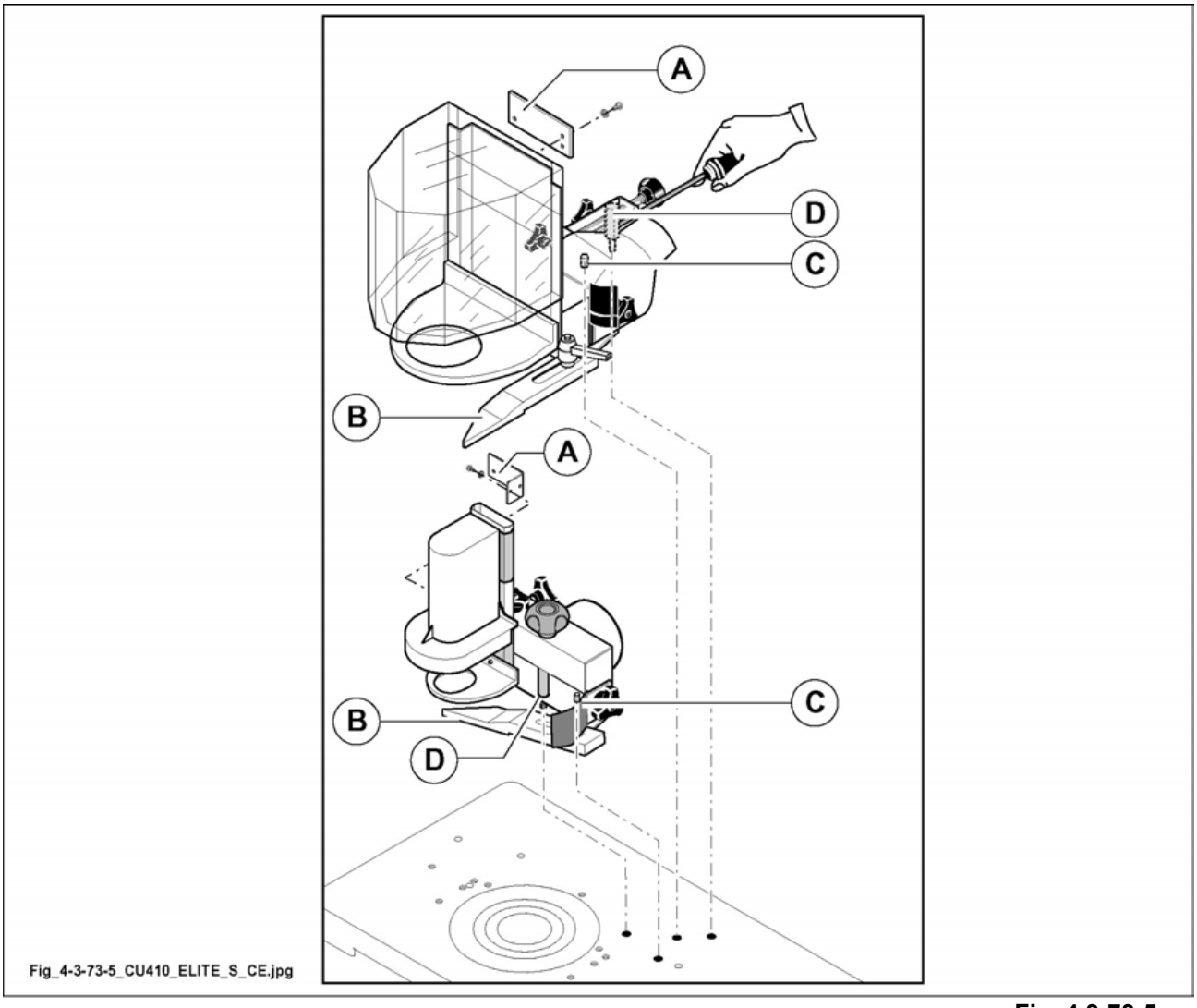


Fig. 4.3-73-5

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(st-5)

4.3.76 FITTING SPINDLE

(cu_4-3-76_0.0)

4.3.76.1 INTERCHANGEABLE SPINDLE

(cu_4-3-76-1-0.0)

OPT

DANGER-WARNING:
take off or fit the interchangeable spindle when no tools are fitted to the spindle.
Handle the tools with protective gloves.

1) Lift spindle moulder spindle, by rotating handwheel (B fig.4.3.76.1) or using electric controls if present OPT.
2) Press the emergency button.
3) Move the moulder hood to free the worktable.
4) Turn selector (G fig. 4.3-76-1) to ( ); unlocked motor brake, pilot lamp switched on.
5) Lock rotation of the router spindle moving it manually until managing to lock it by turning the lever (C fig.4.3.76.1).
6) Unscrew ring nut (Q fig.4.3.76.1) counterclockwise by wrench (P fig.4.3.76.1) in order to take off spindle (O fig.4.3.76.1).
7) Manually unscrew the ring nut from the spindle and screw it down to the new spindle (S fig. 4.3.76.1) so that it touches the rubber ring (R fig. 4.3.76.1), then tighten the ring nut half turn.
8) Make sure that taper shanks (D fig.4.3.76.1) and the threads of the spindle and of the chuck are clean, free from dents and flat.
9) Fit the new spindle by screwing it down to the rubber ring (R fig. 4.3.76.1), clamp it by half turn, then tighten ring nut (Q fig.4.3.76.1) by turning wrench (P fig.4.3.76.1) clockwise.
10) Ensure the moulder spindle can rotate freely by moving lever (C fig.4.3.76.1) to its original position.
11) Turn selector (G fig. 4.3-76-1) to ( ); locked motor brake, pilot lamp switched off.
12) Release the emergency button.

DANGER-WARNING:
after machining, before changing the spindle, allow it to cool, then substitute it.

The right machine use is a determinant factor to obtain the best results. It is important to carry out the maintenance operations foreseen in this handbook.

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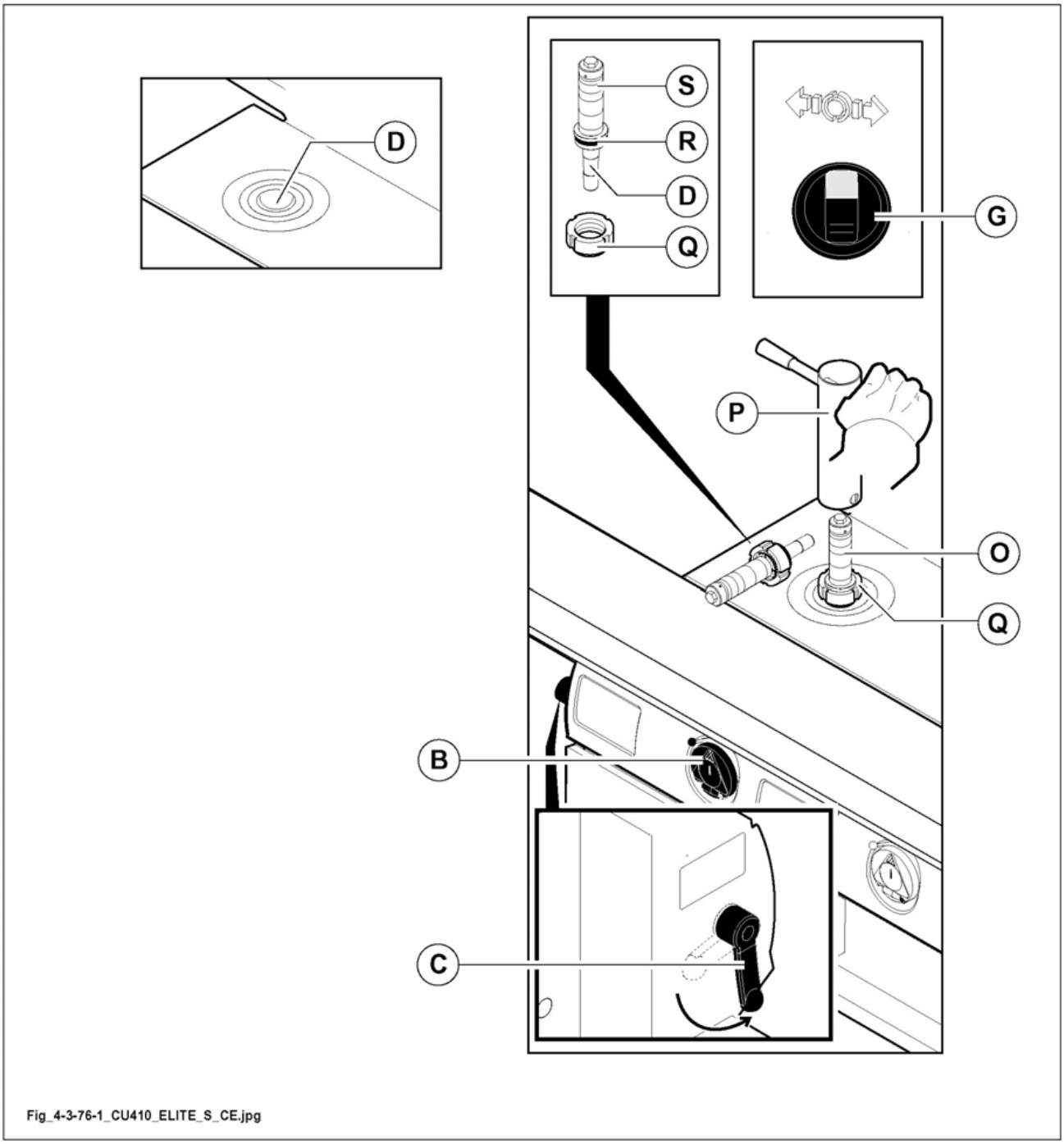


Fig. 4.3-76-1

(vuota_4-06)

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4.3.82 TOOL FITTING - SAFETY NOTES

(cu_4-3-82_0.0)

SAFETY OVER ALL

- **Circular blades may not be fitted to the spindle.**
- **It is not permitted to insert shims between the spacing rings of the spindle to willigly unbalance the tools.**
- Each working shall be separately considered and you have to fit the proper guard.
- The min. hole diameter on the table depends on the tool and the height at which the cutter is set.
  To get the hole as small as possible use the supplied rings (T fig. 4.3.82 supplied with machine).
  In this way you reduce the risk that the workpiece oscillates and fits into the cutters during its passage on the hole.
- Make sure that the last ring with screw or nut for tool locking (untiunscrewing device) has a sufficient grip on the spindle, then clamp.
- Adjust the hood - fence unit in order to reduce the opening between fence halves and tool to a minimum.
- The tool adjustment shall be carried out with the machine off and with proper instruments (gauge, comparator).
- **Before working make sure that there is no contact between the tool with the machine parts.**

NOTE-INFORMATION:
the operator may use both set of tools and single cutters.
In that case it is convenient to number the single cutters.
Each number indicates:
- a measure corresponding to the tool height from the worktable.

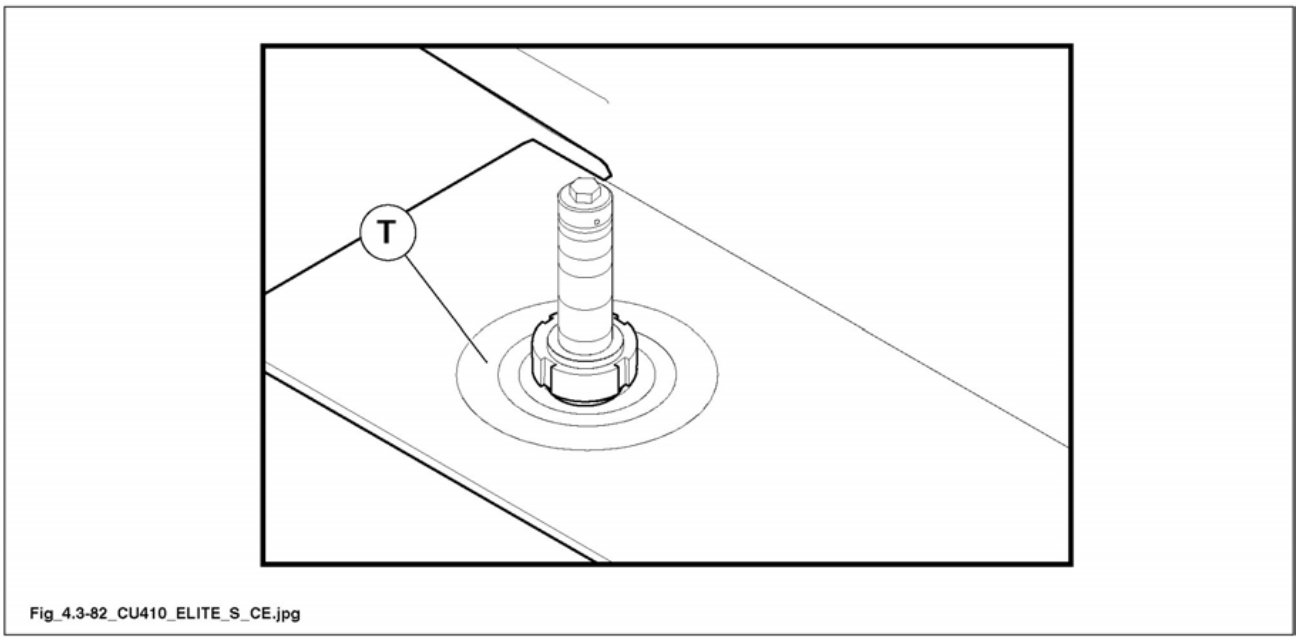


Fig. 4.3-82

4.3.82.1 TOOL FITTING

(cu_4-3-82-1_0.0)

DANGER-WARNING:
use proper gloves for handling the tools.

1) Lift spindle moulder spindle, by rotating handwheel (B fig.4.3.82.1) or using electric controls if present (OPT).
2) Press the emergency button.
3) Turn selector (G fig. 4.3-82-1) to ( ); unlocked motor brake, pilot lamp switched on.
4) Lock rotation of the router spindle moving it manually until managing to lock it by turning the lever (C fig.4.3.82.1).
5) Loosen knob (D fig. 4.3-82-1).
6) Raise door (L fig. 4.3-82-1) of the spindlemoulder hood (1 fig. 4.3-82-1).
7) If the shaping hood (2 fig. 4.3-82-1) is installed on the machine, disassemble the guard (Q fig. 4.3-82-1) and the tracer rests (T fig. 4.3-82-1), while with the tenoning hood (3 fig. 4.3-82-1) remove the door (Z fig. 4.3-82-1) to mount the cutters.
8) Loosen the screw (R fig. 4.3-82-1) by means of the accessory wrench.
9) Remove spacer rings (E fig. 4.3-82-1).
10) Remove if necessary rings (S fig. 4.3-82-1) from the machine table.
11) Mount milling cutters (F fig. 4.3-82-1) on the moulder shaft using the special spacer rings between one tool and another.

CAUTION:
fit the cutters as low as possible on the spindle, taking every precaution to avoid vibrations.
It is prohibited to mount tools with a diameter and weight exceeding that indicated in Chap. 3.

12) Tighten screw (R fig. 4.3-82-1).
13) Ensure the moulder spindle can rotate freely by moving lever (C fig.4.3.82.1) to its original position.
14) Return the moulder guard (1,2,3 fig. 4.3-82-1) to the initial conditions (tighten the door L, Z fig.4.3.82.1 or the guard Q fig.4.3.82.1).
15) Turn selector (G fig. 4.3-82-1) to ( ); locked motor brake, pilot lamp switched off.
16) Release the emergency button.

NOTE-INFORMATION:
the shaft vertical positioning should always be executed starting from its lower part, to counteract the effect of any possible mechanical slack.

DANGER-WARNING:

with selector (G fig. 4.3-82-1) turned to ( ) (pilot lamp lit) the machine is in safe condition.

Remember that the the motor can be started only if selector (G fig. 4.3-82-1) is turned to ( ) again; locked motor brake, pilot lamp switched off.

NOTE-INFORMATION:
the operator may use both set of tools and single cutters.
In that case it is convenient to number the single cutters.
Each number indicates:
- a measure corresponding to the tool height from the worktable.

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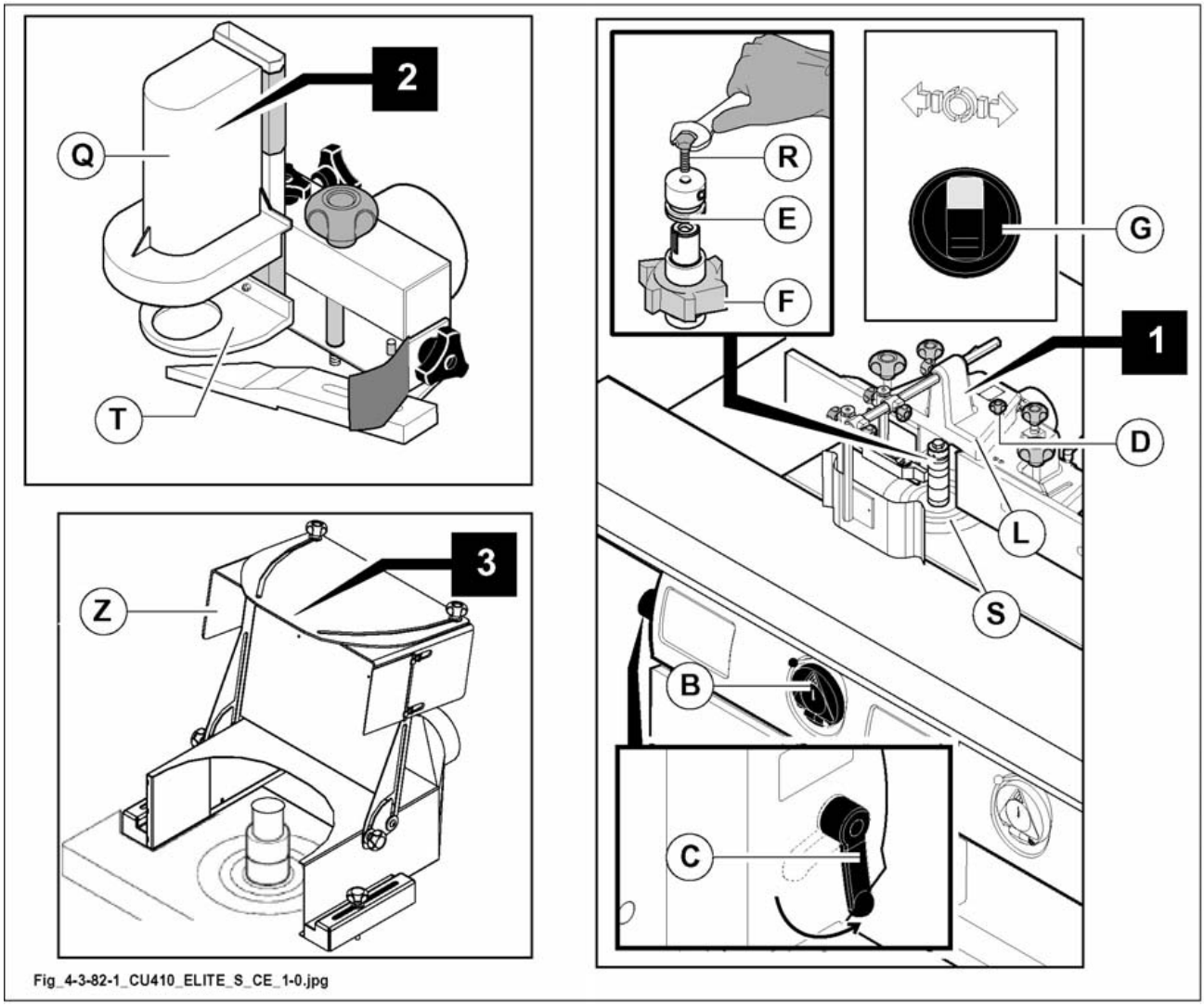


Fig. 4.3-82-1

(vuota_4-07)

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4.4 ELECTRIC CONNECTION AND GROUNDING

(ev_4-4_0.0)

DANGER-WARNING:
the electric connection as well as the check operations described later on shall be carried out by a skilled electrician.

Make sure that the main electric system of the factory can absorb the machine power and that earthing system meets the norms in force.

In the connection point the supposed short-circuit current shall be lower than 10 kA.
Make sure that the mains voltage corresponds to the machine one.

NOTE-INFORMATION:
the right working voltage is indicated on the plate fig.4.4; tolerance range: +/- 5%.

For voltage values out of this range you have to set the mains voltage.
Read out the value of the total absorbed current (Ampere) on the machine identification plate.

DANGER-WARNING:
use the table indicated below and select the cable section and the "RETARDED INTERVENTION" fuses to fit ahead of the machine.

ELECTRICAL INPUT (Amp.)	CABLE SECTION (mm²)	AM FUSE
0 → 10	2,5	12 A aM
10 → 14	4,0	16 A aM
14 → 18	6,0	20 A aM
18 → 22	6,0	25 A aM
22 → 28	10,0	32 A aM
28 → 36	10,0	40 A aM
36 → 46	16,0	50 A aM
46 → 54	16,0	63 A aM
54 → 76	25,0	80 A aM
76 → 92	35,0	100 A aM
92 → 110	50,0	125 A aM

DANGER-WARNING:
the machine is not protected against risks of electrocution due to indirect contact.

Machine protection against indirect contact is the responsibility of the Customer, which must use specialist personnel (electrician qualified to install electrical systems) for that purpose.

NOTE-INFORMATION:
with regard to this, in the following systems:

1) TT type, Low Voltage, mains-powered
2) TN type, Medium Voltage, mains-powered

the machine power supply line must be protected by type A or B Residual Current Devices, suitably coordinated with the user's earthing system.

For environments at greater risk of fire, the maximum value of the RCD trip current is 1A (even with delayed activation).

For TN type systems, the system must be type TN-S with separate neutral and protective earth conductors.

Connect the machine to the elecric system by proceeding as follows:

DANGER-WARNING:
ensure that the connection cable is not electrically powered.

- shut off the power (indicate it by a sign);
- take off the cover of the terminal board (C fig. 4.4);
- insert the supply cable into proper terminal screw (P fig. 4.4);
- connect the 3 phases to terminals L1-L2-L3 (fig. 4.4);
- connect the ground cable yellow-green, to terminal (⏚ / PE);
- if necessary connect neutral cable to terminal (N fig. 4.4);
- fit the cover of terminal board C;
- clamp terminal screw (P fig. 4.4).

DANGER-WARNING:
CAREFUL WITH THE ELECTRICAL CONNECTION.
Incorrect rotation of the tool causes danger to the operator and damage to the product. Activate the saw assembly for a fraction of a second and check that the disc turns clockwise. Should rotation be incorrect, immediately switch off the power and invert two of the three phases on the terminals (L1-L2-L3).

CAUTION:
if the machine is connected by a mobile supply cable, use a flexible rubber cable marked H07RN-F or A07RN-F.
The relative socket shall meet DIN 49463 as well as IEC 309-1 and IEC 309-2.

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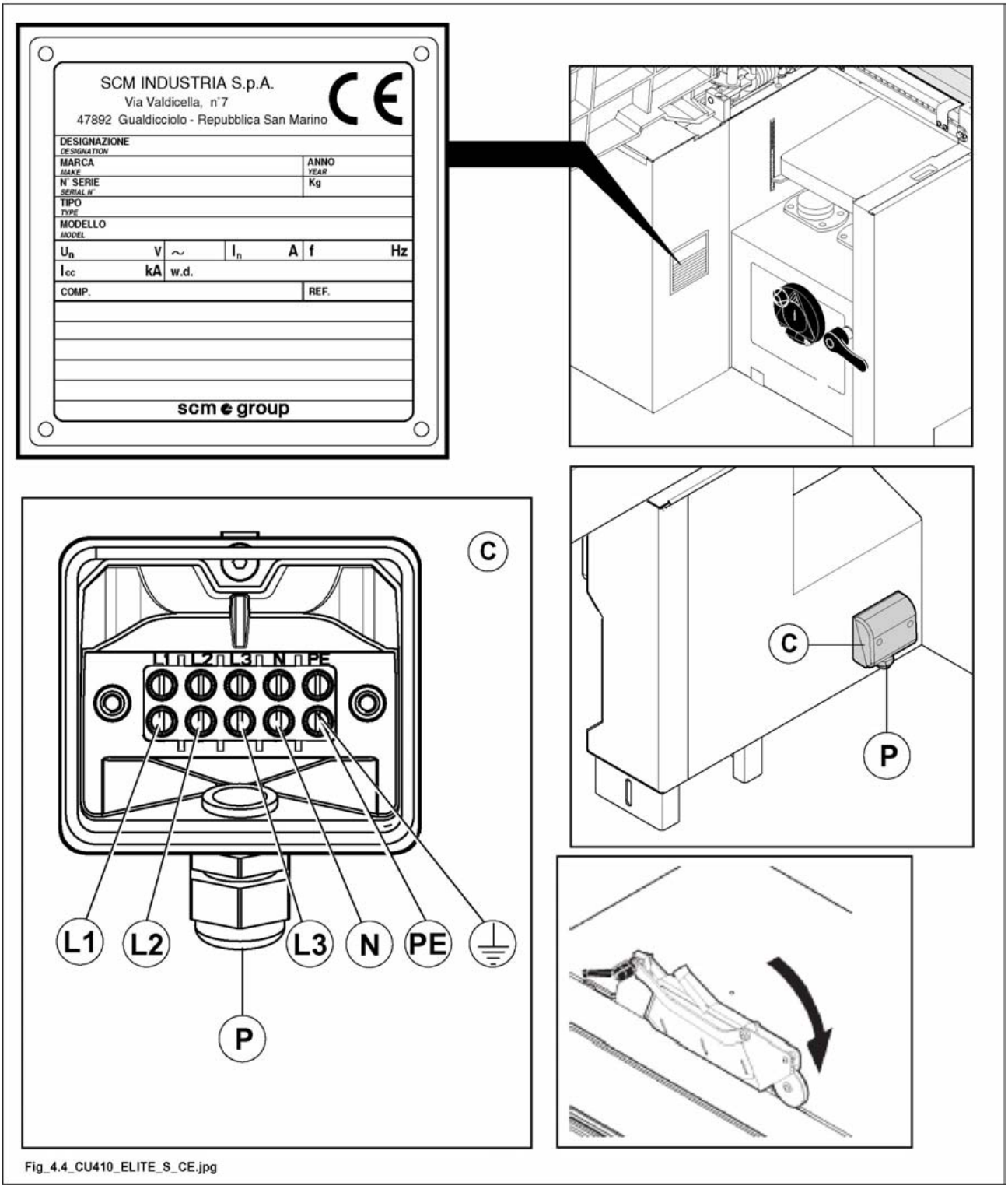


Fig. 4.4

NOTE-INFORMATION:
the documentation with wiring diagram and certificates is inside the accessories case. A set of fuses is supplied in the accessories bag.

All machines are prewired for connecting the feeder, and the socket (A fig. 4.4A) is always located on the rear of the base, while the plug for the feeder is inside the accessories kit. When the spindle motor has reached the right number of revolutions, the feeder socket is automatically powered up.

DANGER-WARNING:
to connect the feeder (not supplied by SCM ***), use only the socket (A fig. 4.4A power max. 0,75 kW), because when the emergency pushbutton is pressed, the power supply to the socket (A) is also interrupted, thus blocking the feeder.***

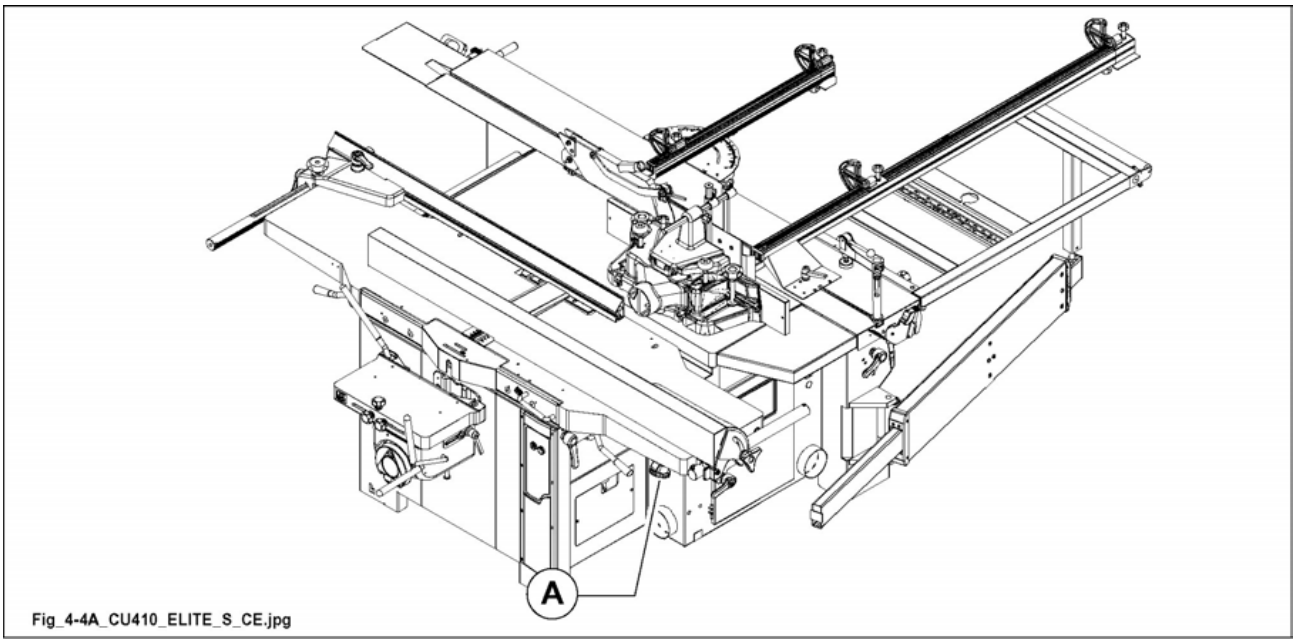


Fig. 4.4A

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(vuota_4-08)

4.5 CONNECTION TO THE SUCTION SYSTEM

(ev_4-5_0.0)

DANGER-WARNING:
the connection to the suction system is necessary for the machine operation and for the operator's safety. Always work with the suction system in operation.

NOTE-INFORMATION:
the extraction system must comply with EN 12779:2004.

Always start the suction system and the operator assembly motor at the same time.

Connect the exhaust pipes to the suction system with hoses of proper diameter.

NOTE-INFORMATION:
we recommend that the suction sleeve is arranged out of the suction hood in order to avoid clogging caused by chips.
The suction pipe fitting should not hinder the operator during the woodworking process.

Connect the hose to suction hood:
- (A fig. 4.5) diameter 120 mm (Moulder hood)
- (B fig. 4.5) diameter 100 mm (Shaping hood)
- (C fig. 4.5) diameter 36 mm (Saw protection)
- (D fig. 4.5) diameter 120 mm (Spindle moulder lower extraction)
- (E fig. 4.5) diameter 120 mm (Saw suction)
- (F fig. 4.5) diameter 120 mm OPT (Mortising machine suction)
- (G fig. 4.5) diameter 120 mm (Thicknessing planer hood)
- (H fig. 4.5) diameter 120 mm (Tenoning shaper hood)

Clamp it with the proper metallic clip to ensure the contact between suction hood and hose.

(A , D , E , G, H, F OPT)	the suction system shall ensure a flow equal to 814 m^3/h at a flow speed at least of 20 m/s - chips dry (1140 m^3/h --> 28 m/s - chips wet).
(B)	the suction system shall ensure a flow equal to 565 m^3/h at a flow speed at least of 20 m/s - chips dry (792 m^3/h --> 28 m/s - chips wet).
(C)	the suction system shall ensure a flow equal to 73 m^3/h at a flow speed at least of 20 m/s - chips dry (103 m^3/h --> 28 m/s - chips wet).

This value shall be checked before starting the working.
If further machines are connected to central suction system carry out a test when all suction systems are in operation.
The right operation of the suction system reduces the risks due to dust inhalation.

Other factors which reduce the dust emission in the working environnement.
- maintenance of tools, of the machine and of the suction system;
- proper use of protective devices against dust.

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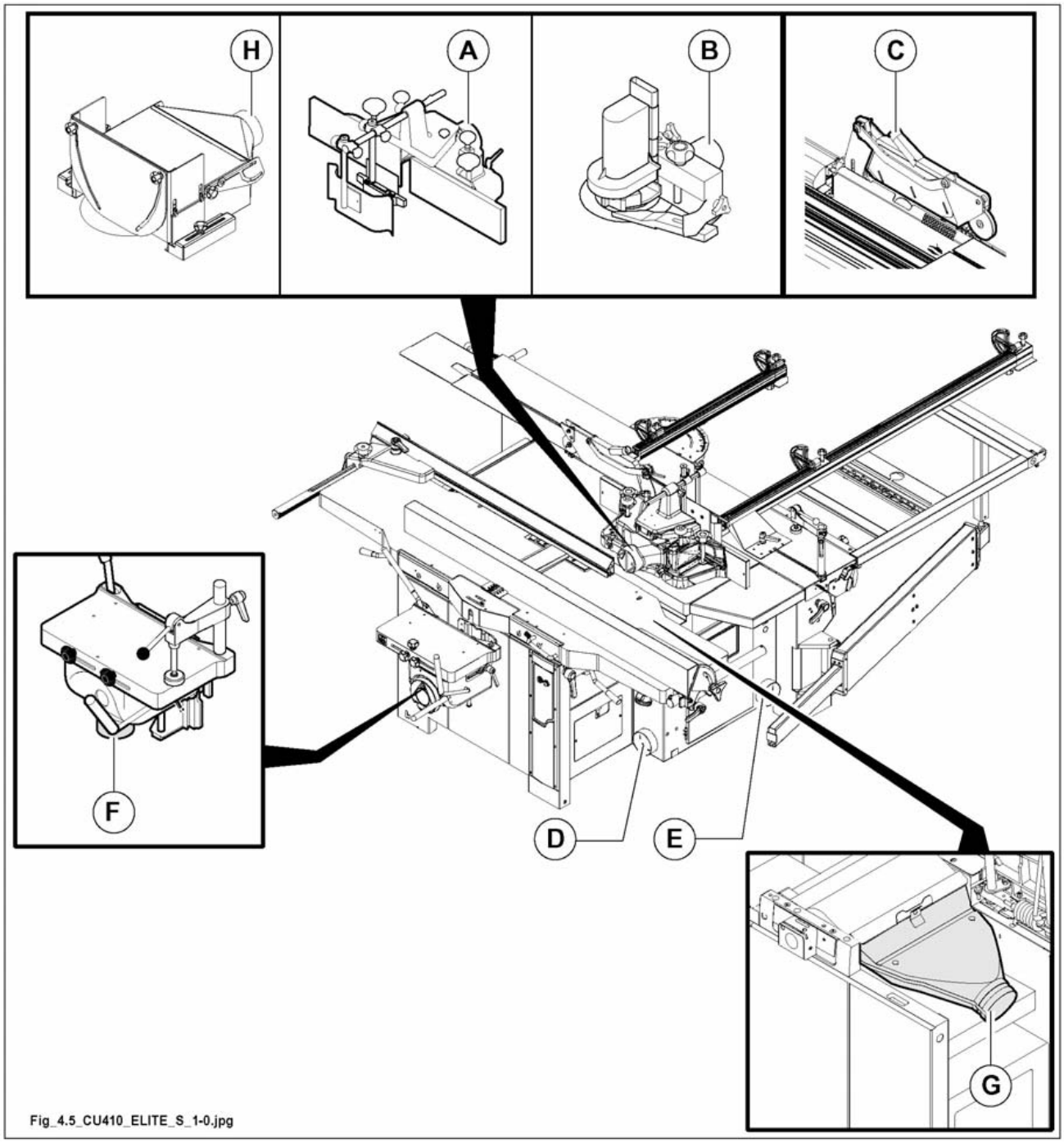


Fig. 4.5

NOTE-INFORMATION:
to connect the machine to the suction plant, use hoses made of antistatic and self-decomposing material, in order to prevent electric discharges due to an accumulation of static electricity (the discharges could compromise the right operation of the electronic components on the machine) and to avoid possible fire to propagate.

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5.5 Machine start - stop 12

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5.5.2 Machine with CLOCKWISE rotation (feed direction) 16

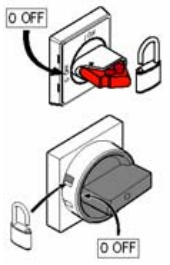
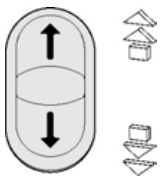
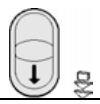
5.11 Auto-brake motor 18

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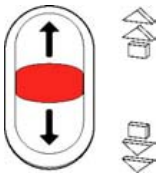
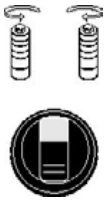
5.1 CONTROLS BOARD

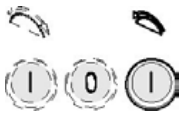
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The control board depends on the machine version:

Ref.	Image	Function	Use
1		Padlockable main switch on the control cubicle. It switches on/off the voltage for the machine power supply. It may be locked in position "**0**" by means of padlock.	I ON = ON O OFF = OFF
2		Emergency button. To shut off the motor supply voltage with intervention of the brakes when present.	Pressed: machine in emergency conditions. Turn to the arrow direction to reset.
3		2-position selector for locking/releasing the autobrake motor.	 = Motor brake locked : pilot lamp off .  = Motor brake released: pilot lamp lit.
4		Planer starting button.	Press the button to start the planer motor.
5		Planer stop button.	Press the button to stop the planer motor.
6		Numerical display for the vertical motion of the thicknessing table.	
7		Buttons (OPT) to lift or to lower the surfacing table.	 Surfacing table lifting.  Surfacing table lowering.

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Ref.	Image	Function	Use
		Pilot lamp thicknessing table motor overload.	Contact our technical service (see telephone number on Chap. 1).
8		Working height digital display (OPT) .	
9		Power on warning lamp.	Lights up when you turn switch **"1"** to position **I** and indicates the presence of power in the machine electrical circuit.
10		Lever for feed speed change.	Turn lever for selecting the speed (6 -12 m/min).
11		Buttons for starting the spindle.	Press this button to start.
12		3-position selector to select the spindle rotation direction.	 To select the counterclock-wise rotation of the spindle (normal direction of rotation). Spindle moulder motor disenabled. To select the clockwise rotation (pilot lamp lit). **Dangerous rotation.**
13		Numerical height display, spindle height adjustment.	
14		Spindle moulder height adjustment button. (OPT)	 = Raising spindle moulder. = Lowering spindle moulder.
15		Spindle moulder lifting indicator. Digital display (OPT) .	

Ref.	Image	Function	Use
16		Spindle moulder tilt indicator (OPT) .	
17		Spindle moulder tilt adjusting selector. (OPT)	 = Tilt towards 0°.  = Spindle moulder tilt towards 45°.
18		Spindle moulder tilt indicator. Digital display (OPT) .	
19		Lamps to indicate the selected spindle speed.	To select the speed move the belt into the race corresponding to the desired speed.
20		Saw start pushbutton. Starts saw unit motor.	 Press to start.
21		Scorer start pushbutton. Starts scorer unit motor.	 Press to start.
22		Stop pushbutton. Press this button to switch OFF the power supply immediately.	 Press to stop.
23		Mechanical numeric indicator for reading blade unit angle of tilt.	
24		Saw height adjustment selector switch. (OPT)	 = Raising blade.  = Lowering blade.
25		Saw inclination adjustment selector switch. (OPT)	 = Tilt towards 0°.  = Saw tilt towards 45°.

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Ref.	Image	Function	Use
26		Saw tilt indicator. Digital display (OPT) .	

5.2 EMERGENCY BUTTONS

(ev_5-2_0.0)

In case of danger if you press the emergency button, any function of the machine is locked.

Emergency buttons present on the machine are:

- on the electrical control panel (1 fig. 5.3).
- Parallel fence side (2 fig. 5.3).
- On the spindle side of the machine front (3 fig. 5.3).

Periodically press the emergency buttons to check whether they are efficient.

DANGER-WARNING:

any anomalies found during the control of these devices, must be reported promptly to the manager, who will put the machine out of service and call the electrical, mechanical maintenance personnel or the SCM ***Support Service.***

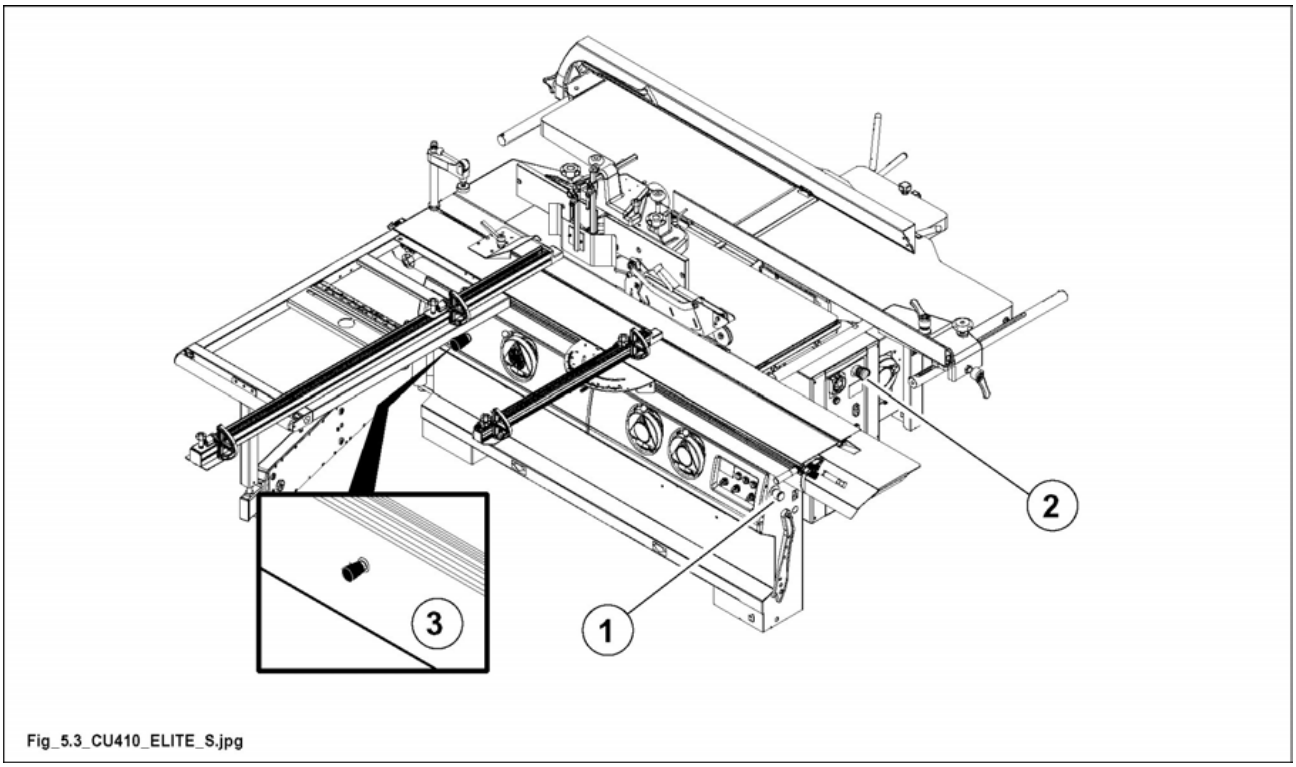


Fig. 5.3

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(st_5-001)

5.4 GENERAL CONTROLS BEFORE MACHINE STARTING

(ev_5-4_0.0)

Make sure that:
- The spindle motor housing door is closed.
- The saw motor housing door is closed.
- The blade change motor access door is closed.
- The machine is connected to the suction system.
- The emergency buttons (2 fig. 5.4) are in the right position (if necessary release them).

- Switch (3 fig. 5.4) is turned to (pilot lamp off).
- Main switch (1 fig. 5.4) is turned to I (ON).

DANGER-WARNING:

any anomalies found during the control of these devices, must be reported promptly to the manager, who will put the machine out of service and call the electrical, mechanical maintenance personnel or the SCM ***Support Service.***

NOTE-INFORMATION:
make sure that the speed indicated is proper for the tool fitted to the saw spindle.

FORBIDDEN:
do not modify or exclude any of the circuits or devices installed.

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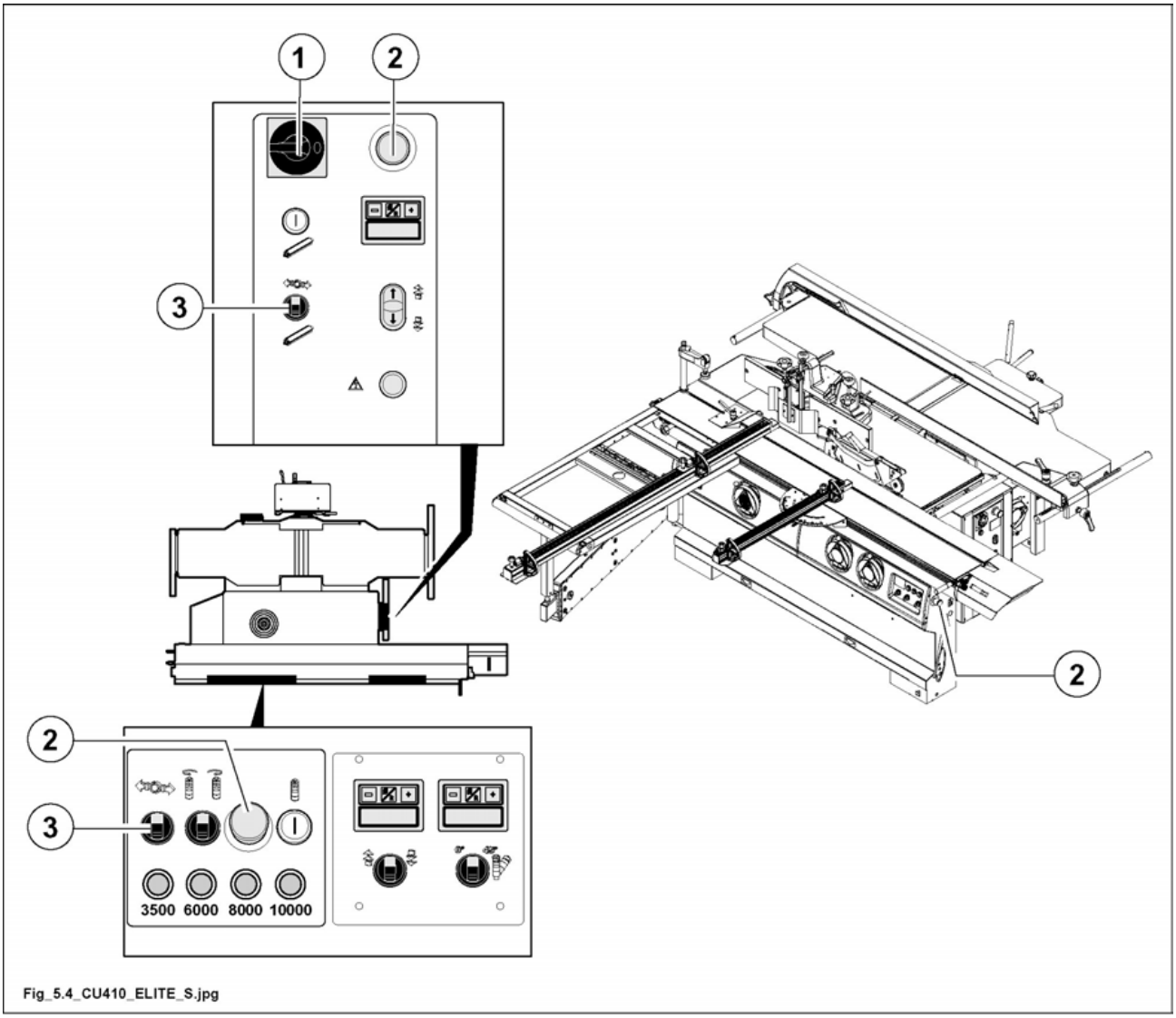


Fig. 5.4

5.4.1 PROFILING OPERATIONS

(cu_5-4-1_0.0)

Make sure that:
- hood-fence unit (V fig. 5.4-1) is in right position and locked by knobs (H, B fig. 5.4-1).
- NEVER exceed the max speed nMAX indicated on the tool; see Chapter 9A.
- Presser shoes (F and G fig. 5.4-1) cover the toolas much as possible (see paragraph 9.50A); for the workpiece feed use a proper pusher (S fig. 5.4-1) or a feeder.

5.4.2 MILLING AT THE SPINDLE (SHAPING)

(cu_5-4-2_0.0)

Check that:
- guard (P fig. 5.4-1) is in the right position and locked by the pin (M fig. 5.4-1).
- The speed displayed on the display is proper for the tool (see Chapter 9A).

5.4.3 TENONING

(cu_5-4-3_0.0)

Check that:
- tenoning hood (T fig. 5.4-1) is in right position and locked by knobs (R fig. 5.4-1).
- The max. spindle speed is 3500 rpm and that it does not exceed the max. speed permitted for the fitted tool.

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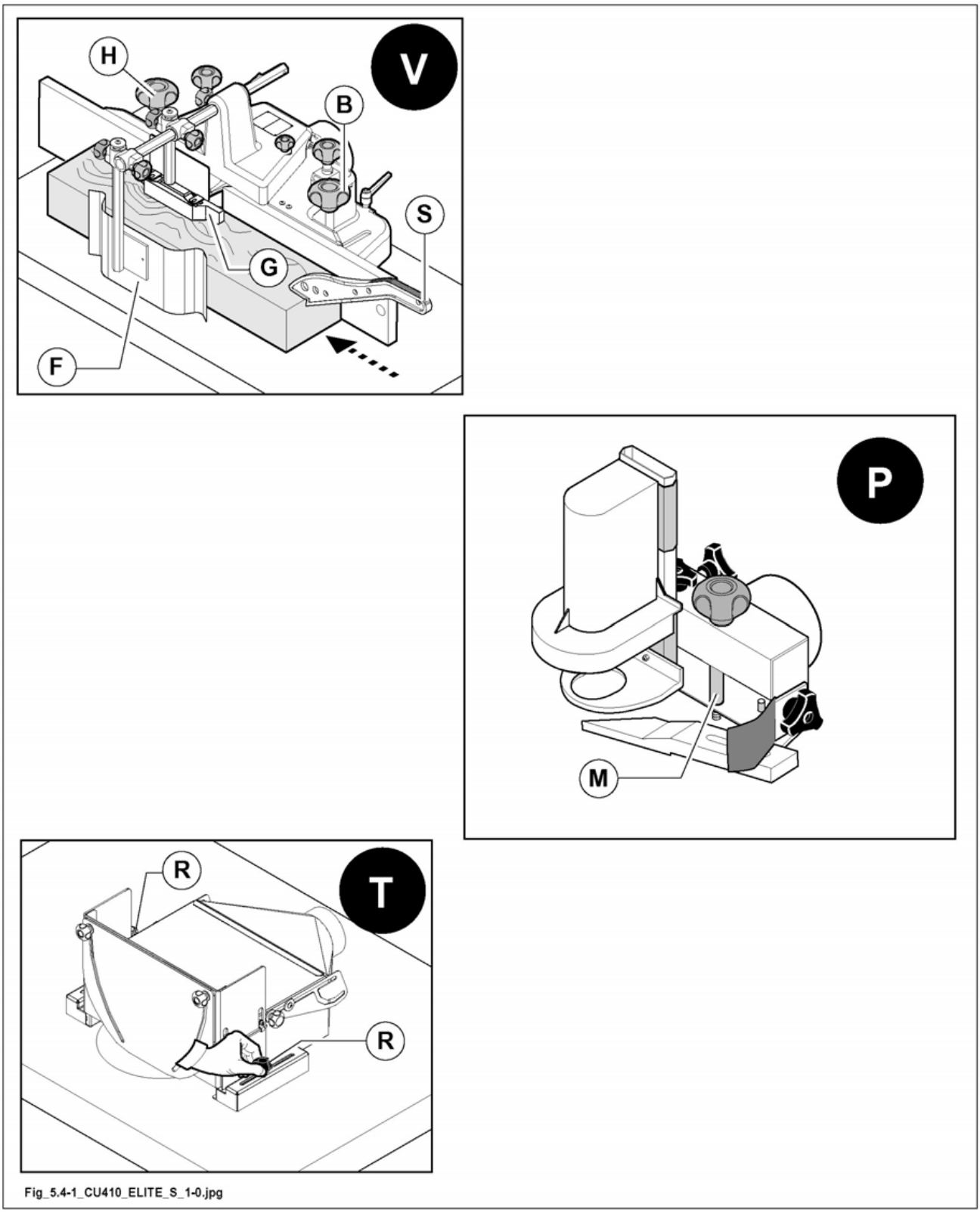


Fig. 5.4-1

5.5 MACHINE START - STOP

(ev_5-5_0.0)

DANGER-WARNING:
before switching on the machine, ensure that all the tools are well tightened, that the set spindle rotation speed is correct (see Chapter 9A) and that the router protection suitable for the type of machining has been installed.

NOTE-INFORMATION:
carry out the checks of par. 5.4.

SAW

Machine Start procedure

1) To start the saw motor press button (4 fig. 5.5).
2) To start the scorer press button (5 fig. 5.5).

NOTE-INFORMATION:
the scorer motor may be started only after that the saw motor has reached the max. speed; pilot lamp of button (4 fig. 5.5) lit.

Machine Stop procedure

1) Press the (B fig. 5.5) button.
2) Turn the magnetothermal switch (A fig. 5.5) to position O.

SPINDLE MOULDER

Machine Start procedure

With automatic starter of main motor:
- press button (T fig. 5.5).

Machine Stop procedure

1) Turn the magnetothermal switch (A fig. 5.5) to position O.

FORBIDDEN:
it is forbidden to stop the motor by turning selector (3 fig. 5.5) to .

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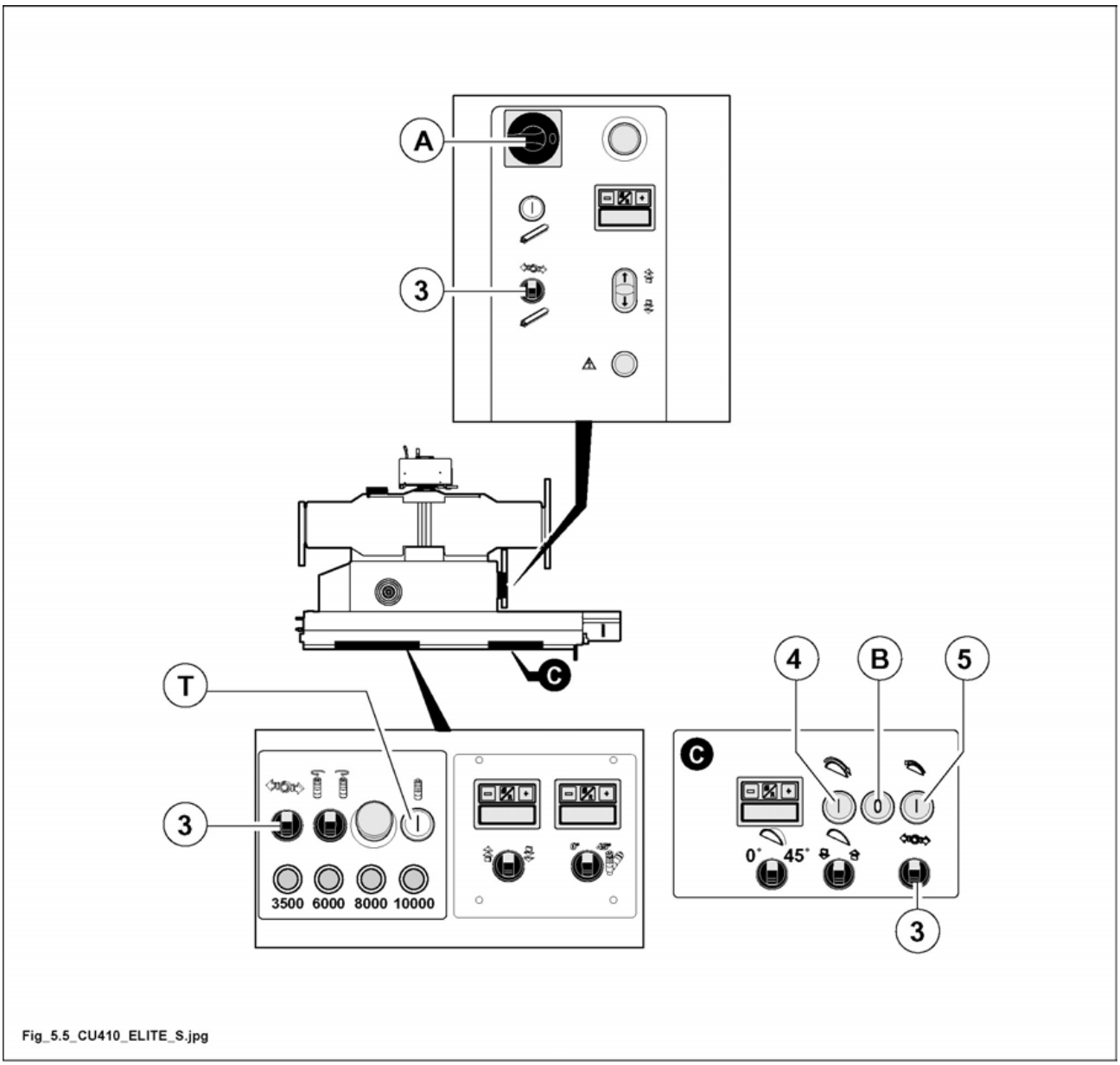


Fig. 5.5

SURFACE PLANING AND THICKNESSING MACHINE

Start - stop Single cylinder planer - Mortiser OPT

Machine Start procedure

1) Check that planer tables are completely closed and lock them with handle (M fig. 5.5A).
2) Turn the padlockable main switch (A fig. 5.5A) to I (ON).
3) Press push-button (D fig. 5.5A) to start the machining head.

Machine Stop procedure

1) Press the (H fig. 5.5A) button.
2) Turn the magnetothermal switch (A fig. 5.5A) to position "0".

Start - stop Thicknesser

Machine Start procedure

- Check that the planer tables are completely opened (F fig. 5.5A).
- Check that tilting safety guard is closed (R fig. 5.5A).
- Turn the padlockable main switch (A fig. 5.5A) to I (ON).
- Choose work height (see par. 9.6).
- Press push-button (D fig. 5.5A) to start the machining head.
- Select feed speed with lever (L fig. 5.5A).

Machine Stop procedure

1) Press the (H fig. 5.5A) button.
2) Turn the magnetothermal switch (A fig. 5.5A) to position "0".

FORBIDDEN:

it is forbidden to stop the motor by turning selector (3 fig. 5.5A) to .

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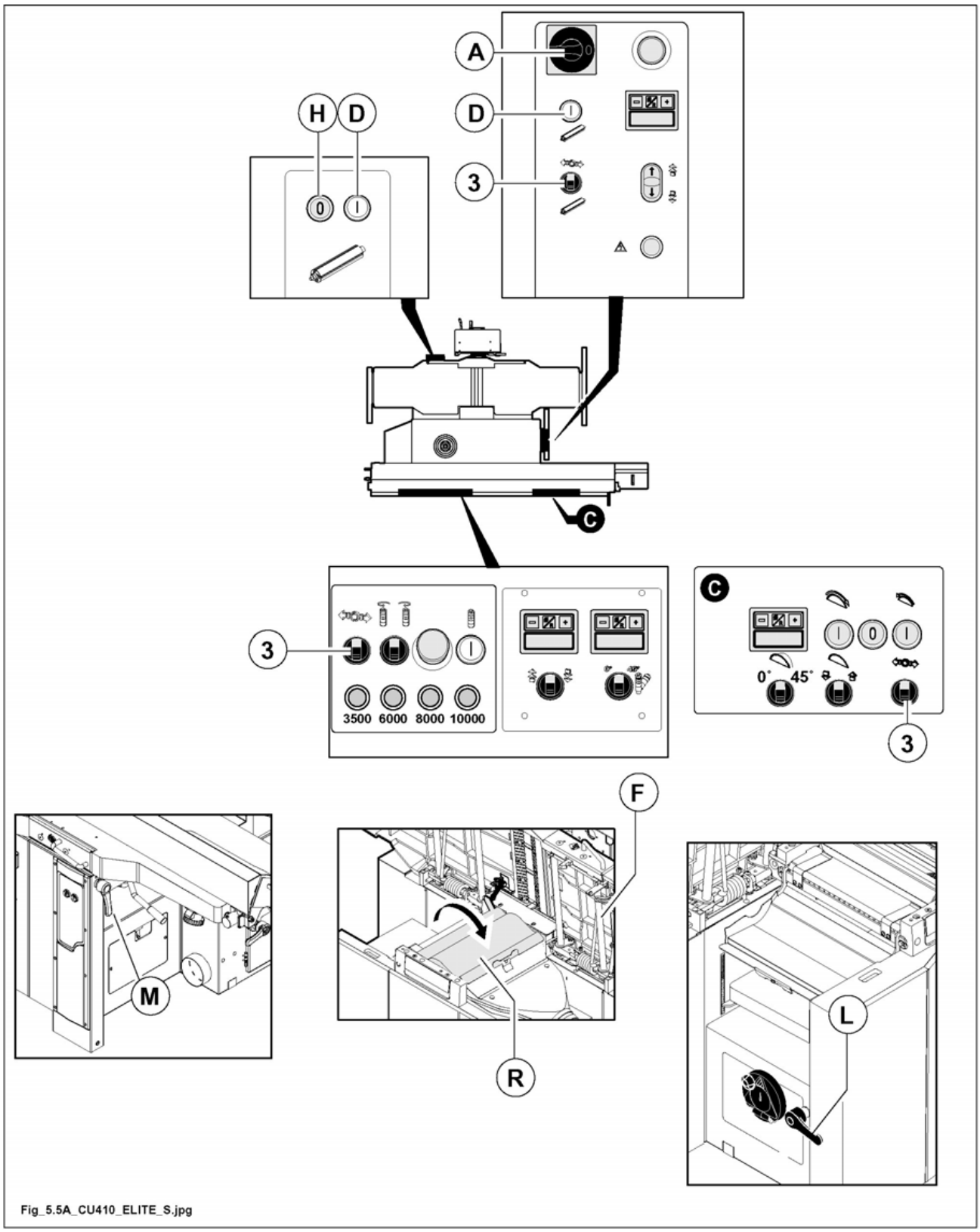

A
H
D
D
3
0
I
C
3
3500 6000 8000 10000
C
0
0˚ 45˚
3
F
M
R
L
Fig_5.5A_CU410_ELITE_S.jpg

Fig. 5.5A

5.5.1 MACHINE WITH COUNTERCLOCKWISE SPINDLE ROTATION (AGAINST FEED DIRECTION)

(cu_5-5-1_0.0)

NOTE-INFORMATION:
when possible always use this rotation direction when possible as it is the normal rotation direction.

Machine Start procedure

- Turn the main selector switch (A fig. 5.5-2) to position I.
- Turn the selector switch (N fig. 5.5-2) towards the left and keep it in that position. Press the button (M fig. 5.5-2) to start the operator unit; release the selector switch (N fig. 5.5-2) to return to the central position.
- Go to the relative work station.

NOTE-INFORMATION:
when you stop the machine it is necessary repeat instructions if you want to start with counterclockwise spindle rotation.

Machine Stop procedure

- Turn the magnetothermal switch (A fig. 5.5-2) to position "0".

FORBIDDEN:

it is forbidden to stop the motor by turning selector (3 fig. 5.5-2) to .

5.5.2 MACHINE WITH CLOCKWISE ROTATION (FEED DIRECTION)

(cu_5-5-2_0.0)

DANGER-WARNING:
for safety reasons rotation inversion cannot be used when tenoning.

DANGER-WARNING:
avoid this direction of rotation as much as possible: as the cutter rotates "in feed direction "there is the risk that the cutter withdraws the workpiece from the presser: pay attention!.Set the pressers (see Chapter 9A).

Machine Start procedure

- Turn the main selector switch (A fig. 5.5-2) to position I.
- Turn the selector switch (N fig. 5.5-2) towards the right and keep it in that position. Press the button (M fig. 5.5-2) to start the operator unit; release the selector switch (N fig. 5.5-2) to return to the central position.
- Go to the relative work station.

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NOTE-INFORMATION:
this operation is to be carried out every time you stop the machine and when you want to start the machine with clockwise spindle rotation.

Machine Stop procedure

- Turn the magnetothermal switch (A fig. 5.5-2) to position "0".

FORBIDDEN:

it is forbidden to stop the motor by turning selector (3 fig. 5.5-2) to .

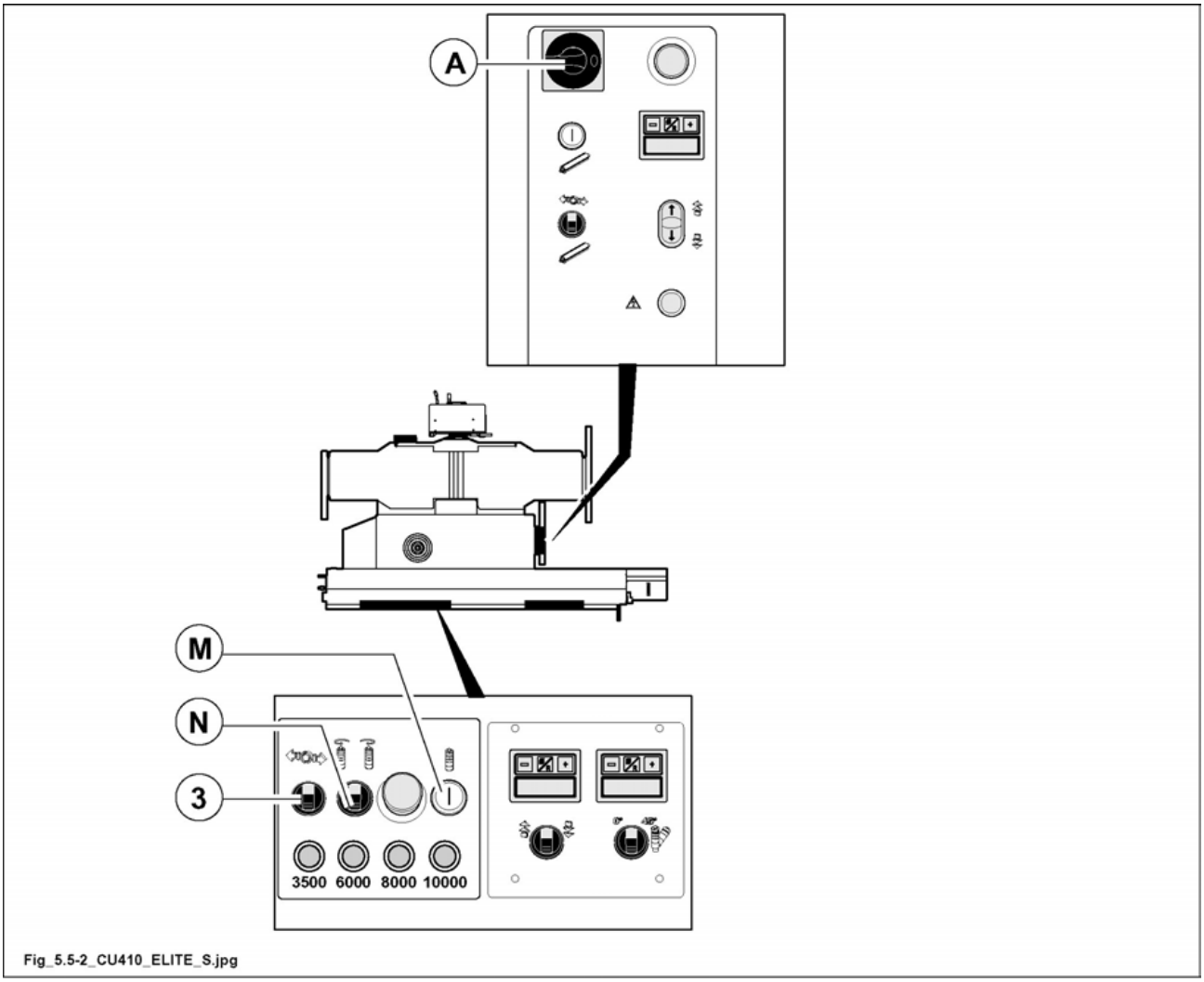


Fig. 5.5-2

5.11 AUTO-BRAKE MOTOR

(ev_5-11_0.0)

The spindle rotation occurs by means of autobrake motor.

Under normal working condition selector (3 fig. 5.11) is turned to ; locked motor brake, pilot lamp switched off. When you switch off the motor or you shut off the power, the motor automatically brakes and remains braked until the next spindle start.

In case of adjustment as cutter fitting etc. for which the spindle shall turn freely, turn selector (3 fig. 5.11) to ; the pilot lamp lights up at the same time.

The motor may be started only when selector (3 fig. 5.11) is turned to ; locked motor brake, pilot lamp switched off.

NOTE-INFORMATION:
the material used for auto-brake motors does not contain any cancerous components.

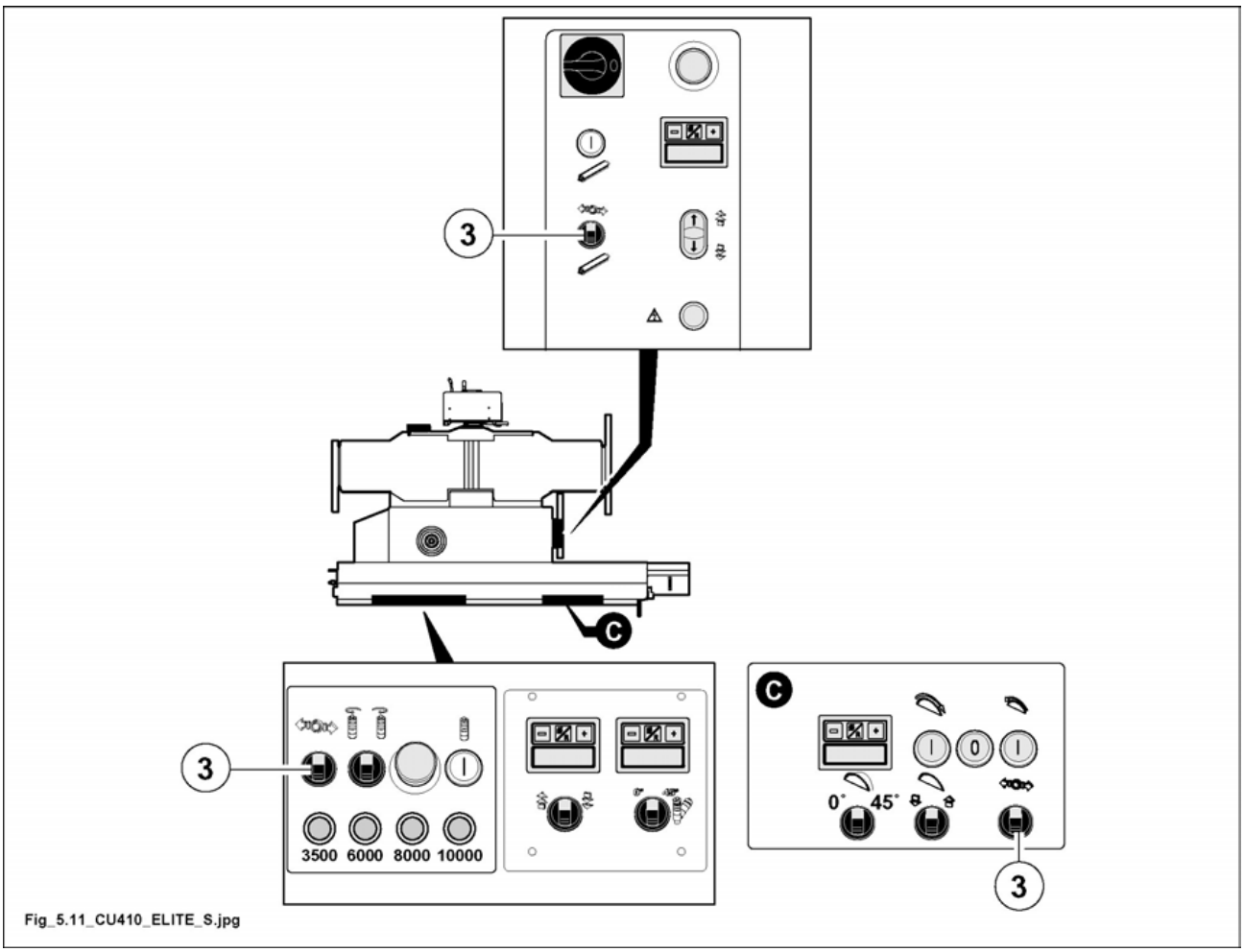


Fig. 5.11

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6.1 RIVING KNIFE ADJUSTING

(ev_6-1_0.0)

DANGER-WARNING:
do not work with bare hands; wear safety gloves.

NOTE-INFORMATION:
the machine is always equipped with 1 riving knive.

DANGER-WARNING:
always fit the proper riving knife (supplied).

DANGER-WARNING:
Stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

1) Lift the saw unit totally up (inclination: 90°).
2) Position the squaring frame (A fig. 6.1) as shown in the figure and translate the wagon (H fig. 6.1) completely to the right.
3) Lift the lever (M fig. 6.1) upwards and open the guard (N fig. 6.1).
4) Adjust dividing knife (F fig. 6.1) height by unloosing nuts (G fig. 6.1).

DANGER-WARNING:
adjust the position of the riving knife so that its distance from the saw blade is between 3 and 8 mm.
The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

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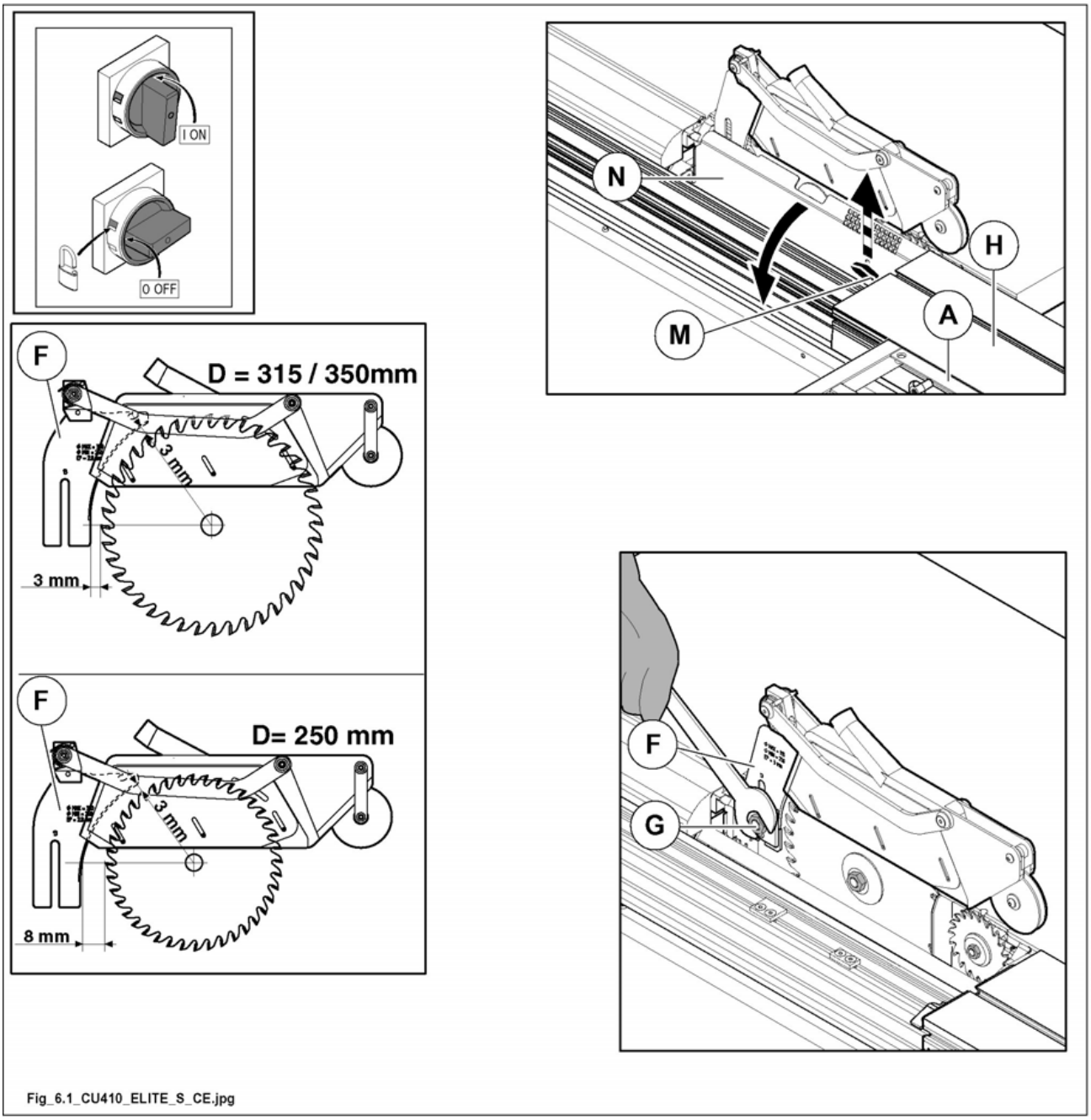

I ON
0 OFF
N
H
A
M
F
D = 315 / 350mm
3 mm
3 mm
F
D= 250 mm
3 mm
8 mm
F
G
Fig_6.1_CU410_ELITE_S_CE.jpg

Fig. 6.1

6.3 AXIS POSITIONING

(gu_6-3_0.0)

6.3.1 HEIGHT ADJUSTING OF THE SAW UNIT

(ev_6-3-1_0.0)

- Press emergency button.
- Loosen knob (H fig. 6.3-1).
- Turn handwheel (M fig. 6.3-1)clockwise the saw blade rises.
- Adjust the saw blade height according to the piece thickness.
  The saw blade height is right when it exceeds the piece thickness 1-1.5 cm.
- After adjusting lock handwheel (M fig. 6.3-1) by knob (H fig. 6.3-1).
- Release emergency button.

For version with electrical lift (OPT)

- Turn selector (N fig. 6.3-1) to for lifting the saw blade, to for lowering it.
- Adjust the saw blade height according to the piece thickness.

NOTE-INFORMATION:
the saw blade height is right when it exceeds the piece thickness by 1-1.5 cm.

FORBIDDEN:
with protective hood fixed to the riving knife, it's strictly forbidden to carry out not-through cuts.

6.3.2 SAW BLADE TILTING

(ev_6-3-2_0.0)

- Press emergency button.
- Loosen knob (E fig. 6.3-1) and turn handwheel (V fig. 6.3-1) to tilt the saw blade up to 45°.
- Read out the blade tilting angle on indicator (G fig. 6.3-1) then tighten knob (E fig. 6.3-1).
- Release emergency button.

For version with electrical inclination (OPT)

- Turn selector (P fig. 6.3-1) to or to to change the saw blade tilting.
- Read out the blade tilting angle on display (Y fig. 6.3-1).

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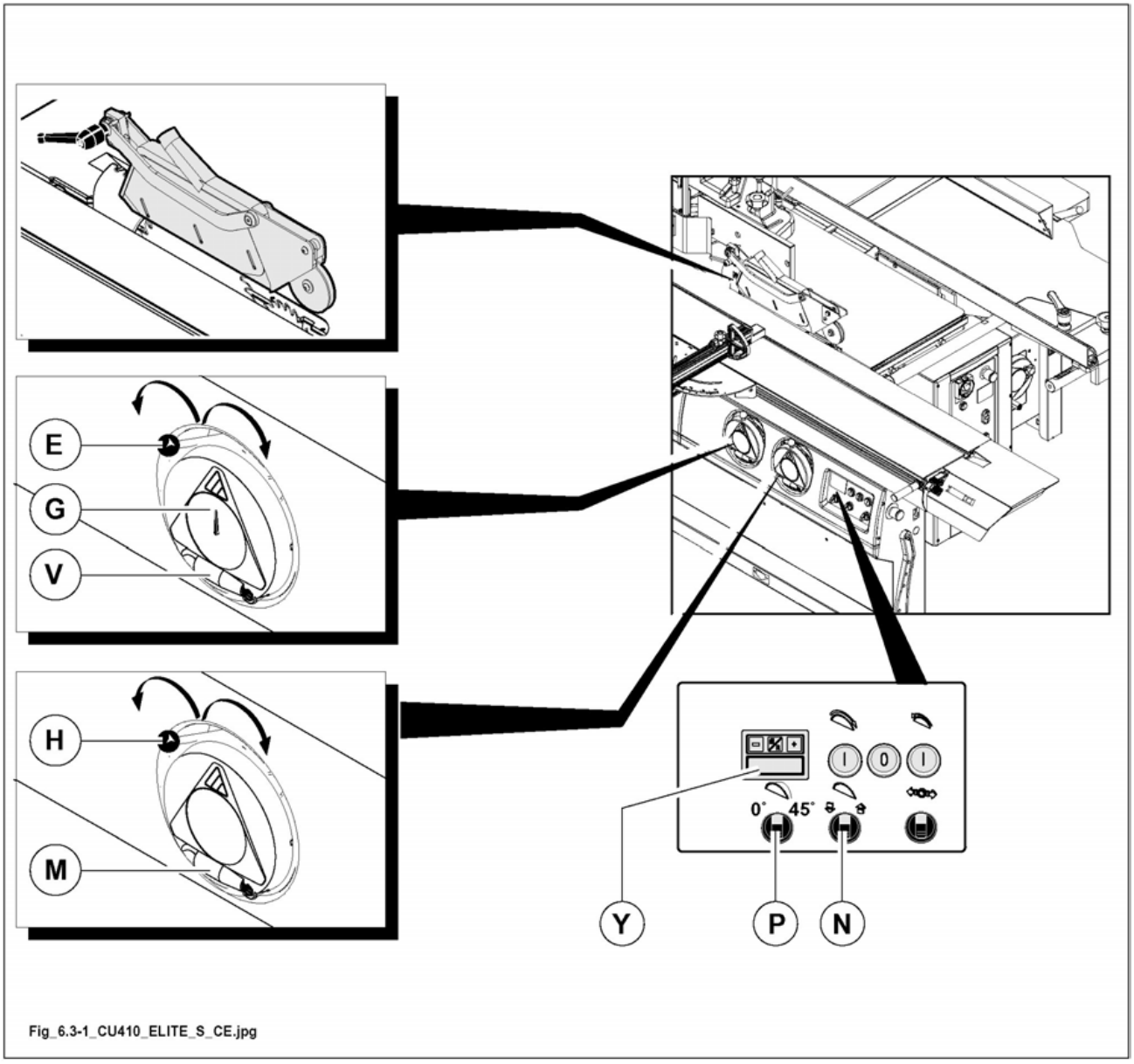


Fig. 6.3-1

6.3.4 SCORER ADJUSTING

(ev_6-3-4_0.0)

CAUTION:
for cutting panels coated with finishingmaterial you have to use the scorer (A fig. 6.3-4-1).
Position the scoring saw in order to have an engraving equal to 1-1,5 mm;
when it is not necessary to use the scorer, lower the scorer to the end of stroke under the table.

6.3.4.1 SCORER HEIGHT ADJUSTING

(gu_6-3-4-1_0.0)

Proceed as follows if it is necessary to adjust scorer positioning with respect to the saw:
- adjust scoring saw height using the knob (L fig. 6.3-4-1).

6.3.4.2 ALIGNING THE SCORER WITH THE SAW BLADE

(gu_6-3-4-2_0.0)

You have to carry out some cutting tests.

- Regulate the alignment of the scoring unit with the saw by turning the knob (N fig. 6.3-4-1).

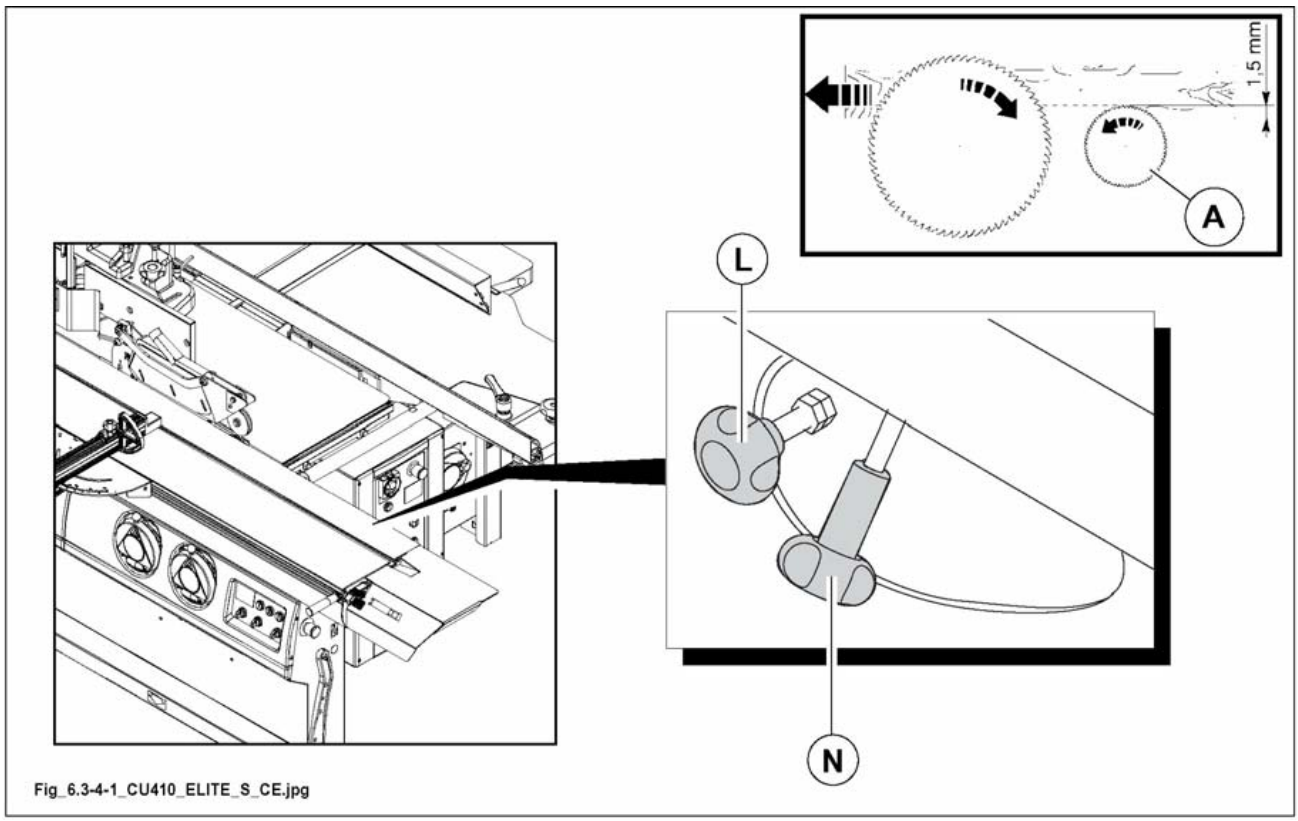


Fig. 6.3-4-1

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6.4 CORRECT USE FOR CIRCULAR SAW

(mmax_6-4_0.0)

CAUTION:
first make sure that the machine does not vibrate.
Do not try to take off the material when the cut has already started; proceed with a continuous and uniform speed.
Workpiece feeding towards the blade (especially where there are knots) should not be too fast (feeding speed should be in accordance with workpiece thickness).
Do not let workpieces stop between the saw fence and the blade.

DANGER-WARNING:
always remove any trimmings produced during machining because trimmings interposed between the blade and the saw table might damage the machine or be a source of danger for the operator.

Before removal, switch off the machine and wait for the saw blade to stop.

- Avoid contact of the tips against metallic objects.
- When necessary sharpen the saw blade.
- Often clean the steel body and the tips with proper liquid products. Let the saw blade in the bath, then clean it with brush: don't use metallic brushes.
- As regards the toothing at least 2-3 teeth shall cut at the same time (A fig. 6.4). If only one tooth cuts (B fig. 6.4) you don't get a good cutting.
- Whenever this is possible, it is also critical to lift the blade until the whole tooth cutting part protrudes from the wood thickness.

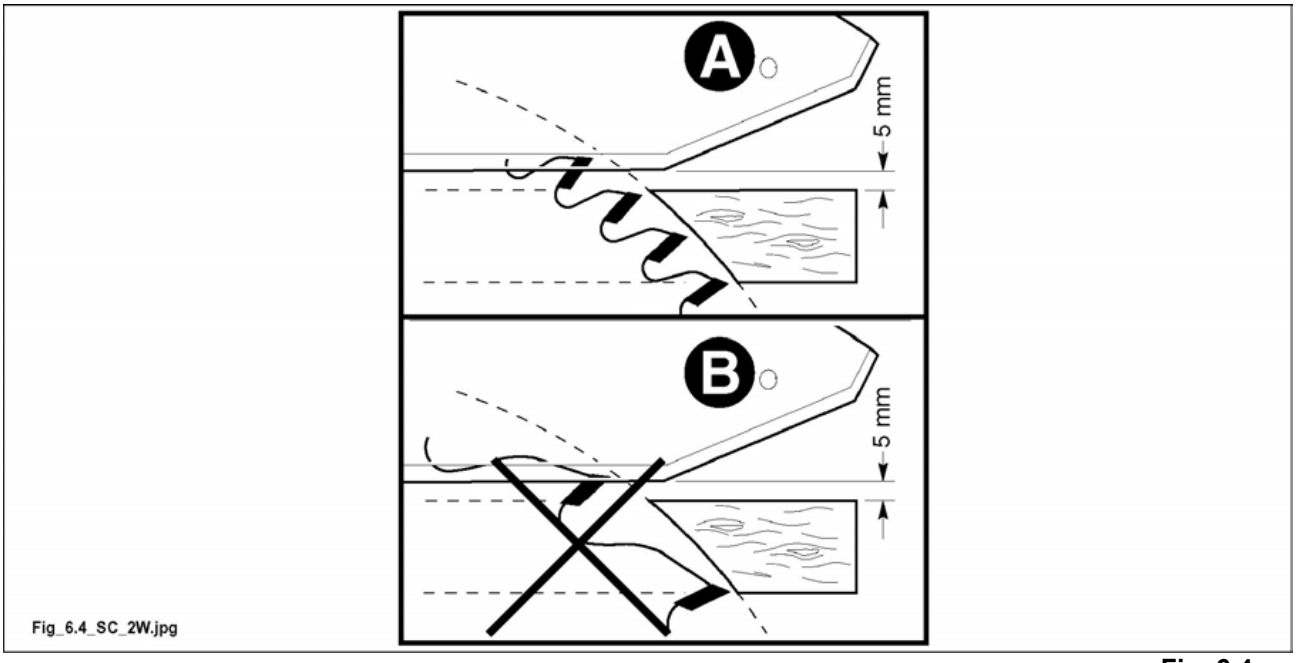


Fig. 6.4

6.8 GUARD ADJUSTING

(hg_6-8_ce_0.0)

- Clamp handle (E fig. 6.8).
- The guard is made of such material so that in case of contact with the suction hood, the saw blade is not damaged.

FORBIDDEN:
with protective hood fixed to the riving knife, it's strictly forbidden to carry out not-through cuts.

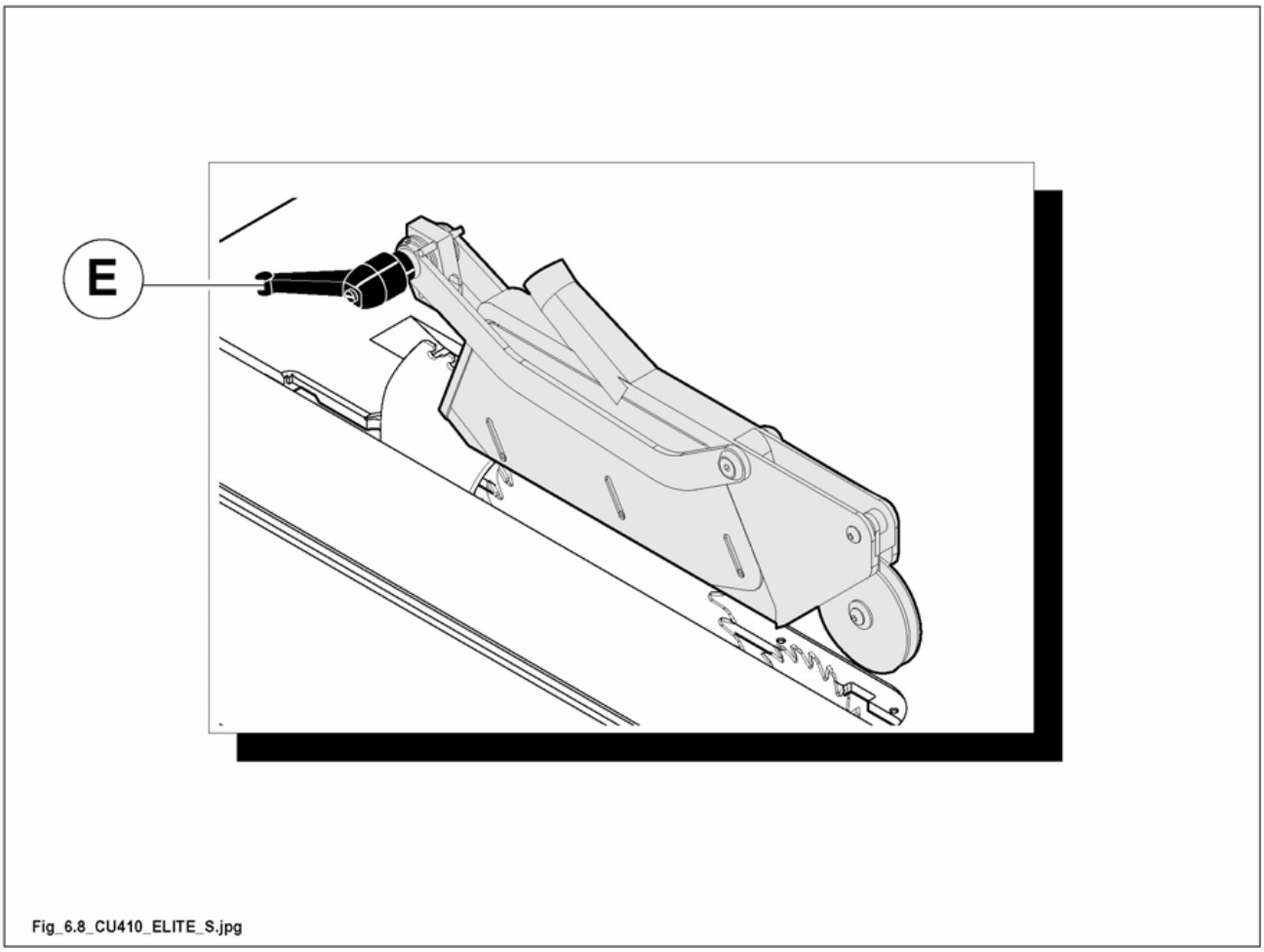


Fig. 6.8

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(vuota_cu-6-01)

6.19 SPEED CHANGE

(ev_6-19_0.0)

OPT

1) Completely lift saw unit.
2) Press the emergency button.
3) Release the motor brake by turning selector (O fig. 6.19) to ; at the same time the pilot lamp lights up.
4) Take off cover (C fig. 6.19), on the machine table to reach the housing for changing the belts.
5) Loosen screw (A fig. 6.19).
6) Lift motor unit support using handle (R fig. 6.19).
7) Tighten screw (A fig. 6.19).
8) Replace the belt (D fig. 6.19).
9) Unscrew screw (A fig. 6.19) again, tension the belts by pressing lightly on handle (R fig. 6.19) and tighten screw (A fig. 6.19).
10) Fit cover (C fig. 6.19).
11) Reset the motor brake by turning selector (O fig 6.19) to .
12) Release the emergency button.

To display the speed, look at the position of the belt through door (B fig. 6.19).

NOTE-INFORMATION:
microswitch (H fig. 6.19) under cover (C fig. 6.19) shuts off the power to the control board when cover (C fig. 6.19) is not housed in its seat.

DANGER-WARNING:
make sure that the selected rotation speed is proper for the working and for the saw blade.

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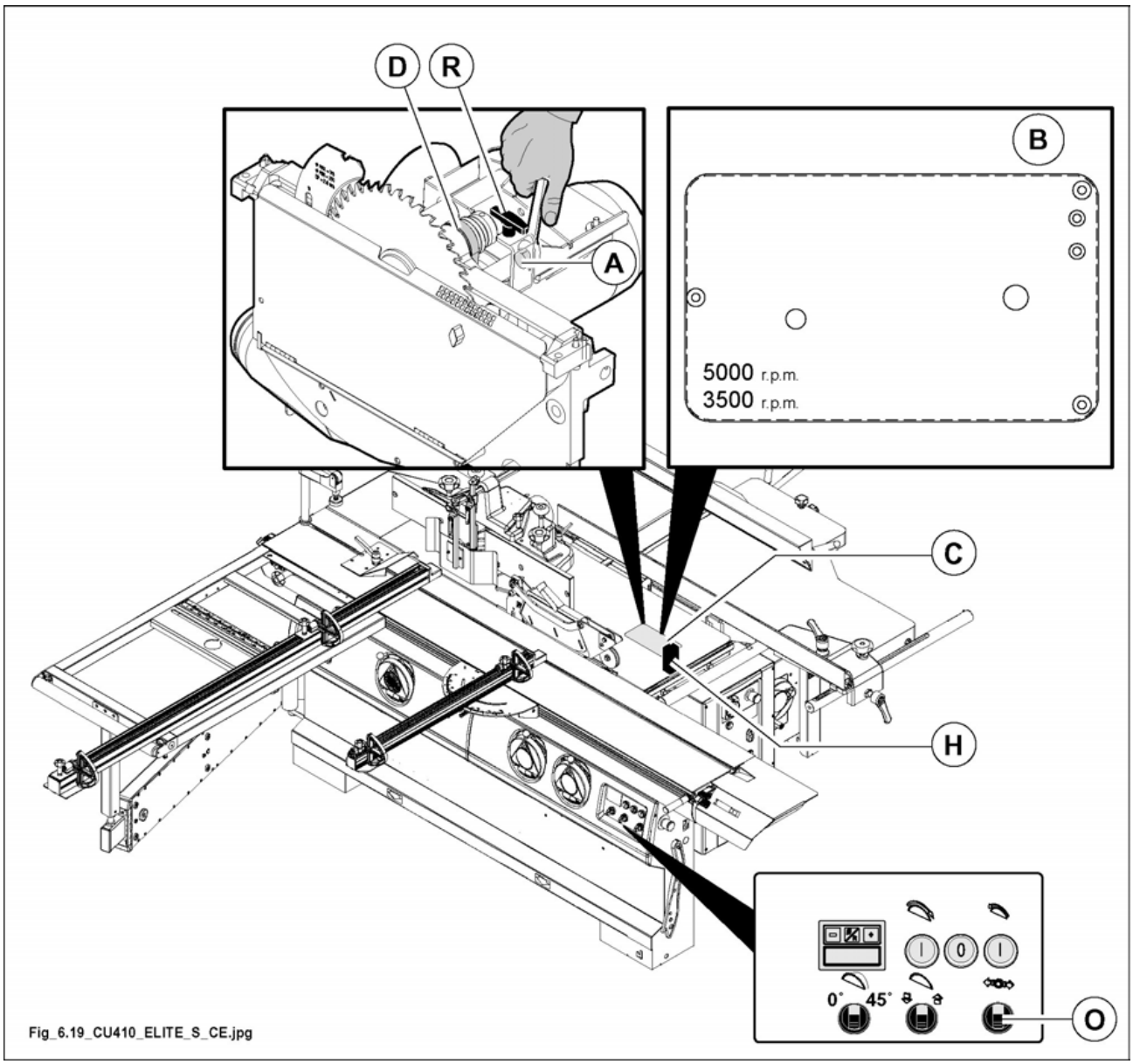


Fig. 6.19

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7.1.3 SPLINTER GUARD ADJUSTMENT

(par_7.1.3_2010)

You can trim the splinter guard a few times (K fig. 7.1-3), without having to move the entire support rule.
Loosen the screw (V fig. 7.1-3), slide the sprinter guard (K fig. 7.1-3) towards the blade, tighten the screw and perform the trim again.
If you need to replace it see Section 20.

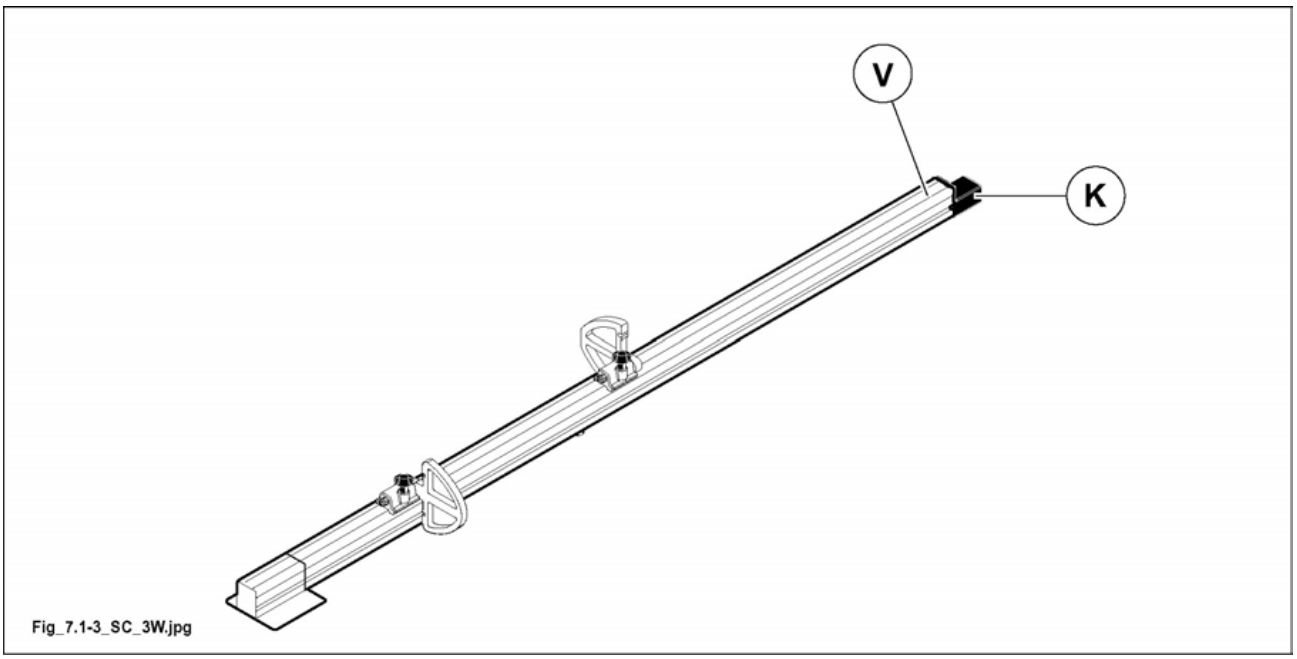


Fig. 7.1-3

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7.4 USE OF TELESCOPIC RULER

(mmax_7.4_0.0)

A *For 90° cuts*

- Position the telescopic ruler in such a way that the pin (C fig. 7.4) fits into place against the gib (L fig. 7.4). The gib (L fig. 7.4) is adjusted by our technicians and is used to rapidly position the telescopic ruler at the right distance from the saw blade (only at a 90° position).
- Position the telescopic ruler in such a way that it fits into place against the device (S fig. 7.4).
- Tighten the knobs (F fig. 7.4) and (E fig. 7.4).
- For use, position the stops (B fig. 7.4) referring to the metric ruler (P fig. 7.4).

B *For inclined cuts*

- For use, position the ruler referring to the plate (P fig. 7.4) and tighten the knobs (F fig. 7.4) and (E fig. 7.4).

  The ruler is fitted with an extractable telescopic extension (H fig. 7.4), which may be lengthened as required after loosening the knob (G fig. 7.4).
  When the chip guard (M fig. 7.4) is worn, bring it up to the saw blade by loosening the grub screw (N fig. 7.4).

  The telescopic rule is supplied with the stops (B fig. 7.4). These can rapidly be positioned to rest on or push the workpiece during machining, by simply tipping them over.

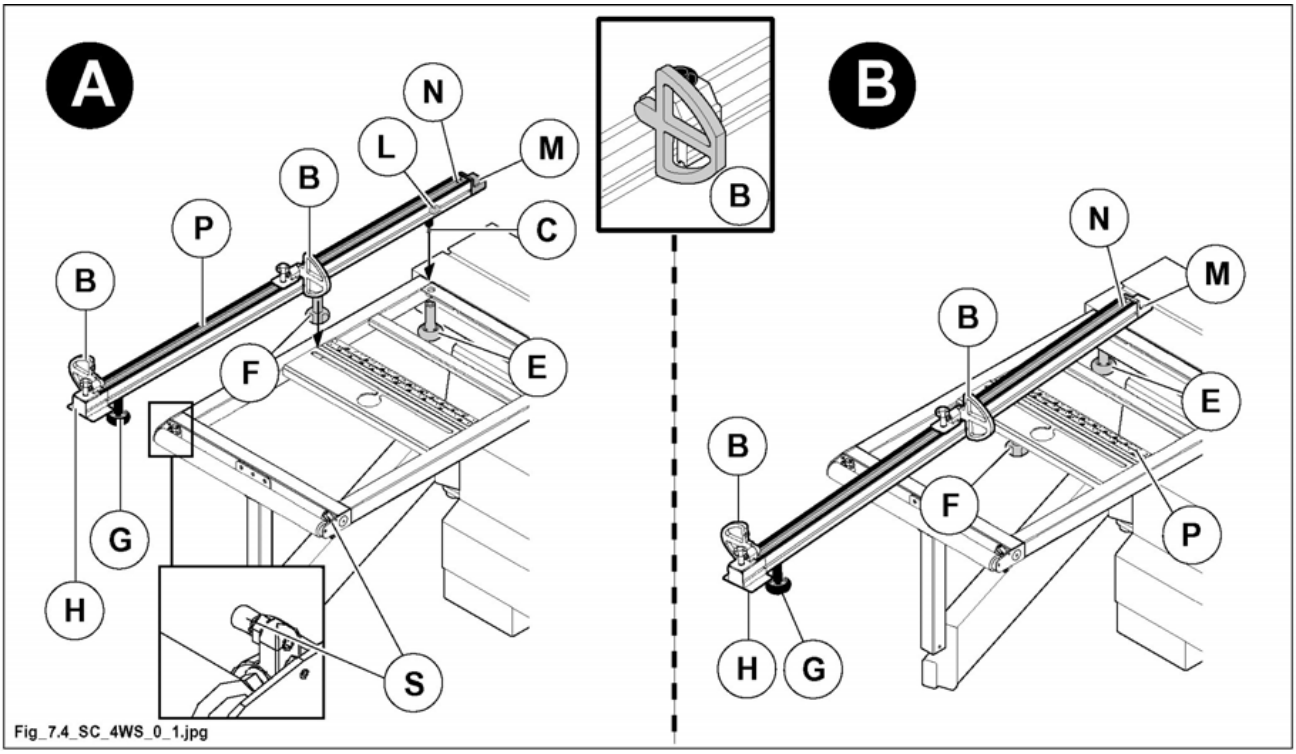


Fig. 7.4

7.14 MANUAL FENCE FOR PARALLEL CUTS

(gu_7-14_0.0)

Saw guide unit with micrometric rack adjustment (sliding on cylindrical section guide).

7.14.1 SETTING TO ZERO THE FENCE FOR PARALLEL CUTS

(gu_7-14-1_0.0)

1) With motors off lift the saw guard.
2) Unlock the fence for parallel cuts (D fig. 7.14-1) by means of handle (L fig. 7.14-1) and move it in order to read a value (e.g. 200 mm) between the edge (R fig. 7.14-1) turned to the blade and millimeter rule (N fig. 7.14-1).
3) Measure the distance between saw blade and parallel fence.
4) Loosen nuts (M fig. 7.14-1) and move millimeter rule (N fig. 7.14-1) in order to read the same value previously measured on the edge (R fig. 7.14-1) of fence.
5) Lock the fence unit with handle (L fig. 7.14-1)
   Lower the guard and carry out a test cut.
6) Tighten nuts (M fig. 7.14-1).

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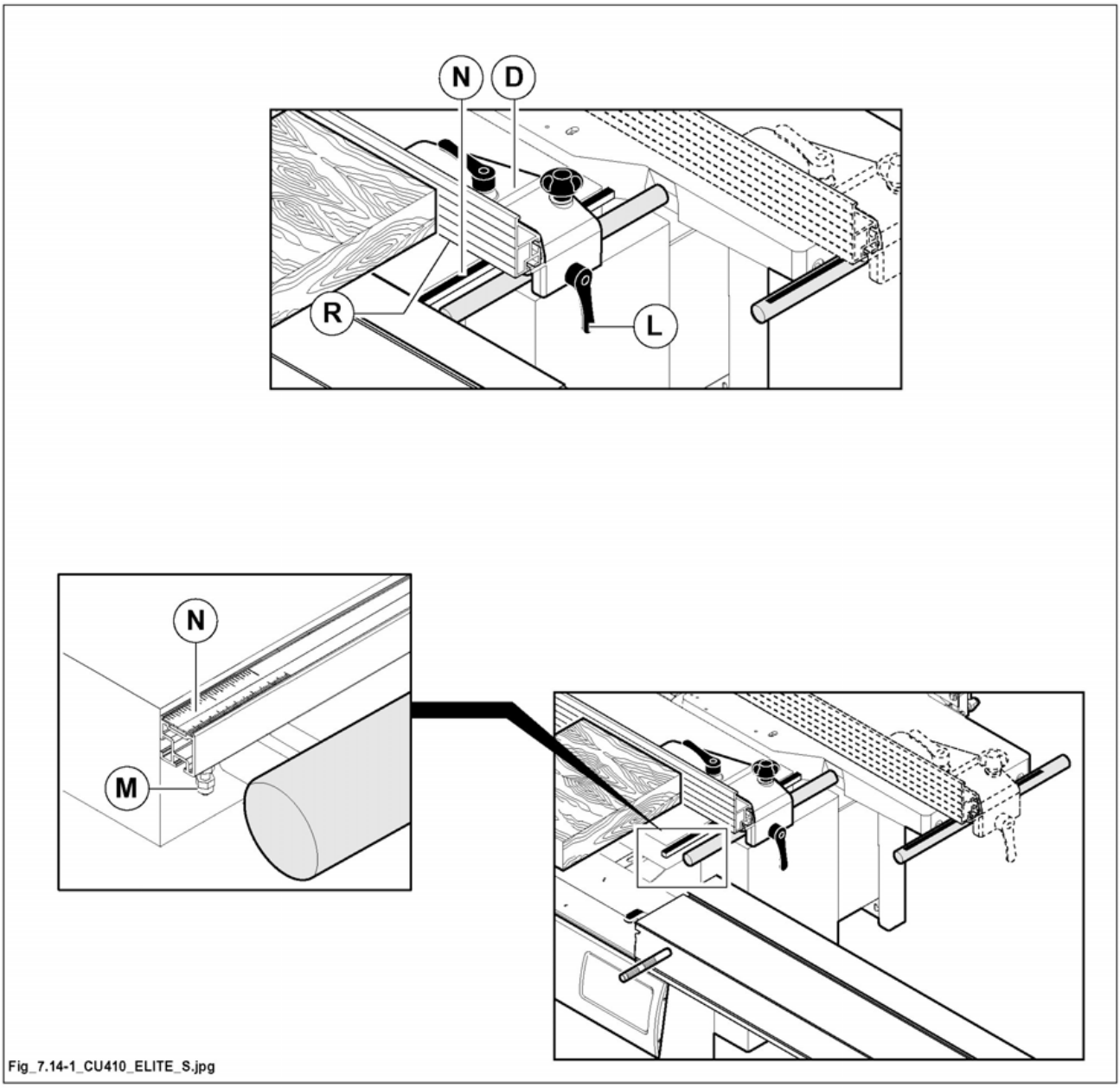


Fig. 7.14-1

7.14.2 OPERATION

(gu_7-14-2_0.0)

It is used for parallel cuts with cutting width up to 1000 mm.

Rule (R fig. 7.14-2) can move in longitudinal direction after unlocking lever (P fig. 7.14-2); after every adjustment tighten lever (P fig. 7.14-2).
The parallel rule shall be adjusted in longitudinal direction, so that the workpiece can not lock between rule and riving knife.

DANGER-WARNING:
the front end of the rule shall never protude from the table end on side (F fig.7.14-2) but it shall reach a theoretical line (G fig.7.14-2) which starts on the axis of the saw blade and has a 45° slope forwards, in order to avoid that the teeth of the saw blade grip the piece and throw it against the operator.

Positions of rule (R fig. 7.14-2) after loosening lever (P fig. 7.14-2).

1) Vertical position with side (W fig. 7.14-2) turned to the workpiece.
2) Horizontal position (O fig. 7.14-2) for cutting thin pieces and slanting cuts.

DANGER-WARNING:
it is possible to move the piece forwards by using pusher (H fig. 7.14-2) supplied with the machine.

3) After carrying out every adjusting operation tighten lever (P fig. 7.14-2).

To increase or decrease the distance between the fence and the saw blade operate as indicated below.

- Release the lever (X fig. 7.14-2);
- manually slide the fence unit (T fig. 7.14-2) with reference to the metric ruler (E fig. 7.14-2).

Carry out the micrometric adjustment proceeding as follows:
- by pushing the knob (Y fig. 7.14-2) and turning it.
- Tighten the lever (X fig. 7.14-2) when the adjustment has been made.

DANGER-WARNING:
before starting machining, make sure that the guard is resting on the workpiece.

NOTE-INFORMATION:
for cutting large panels, position the guide (T fig. 7.14-2) on the tubular part (D fig. 7.14-2).
To disassemble the guide from the slide bar, rotate and pull the lever (X fig. 7.14-2).

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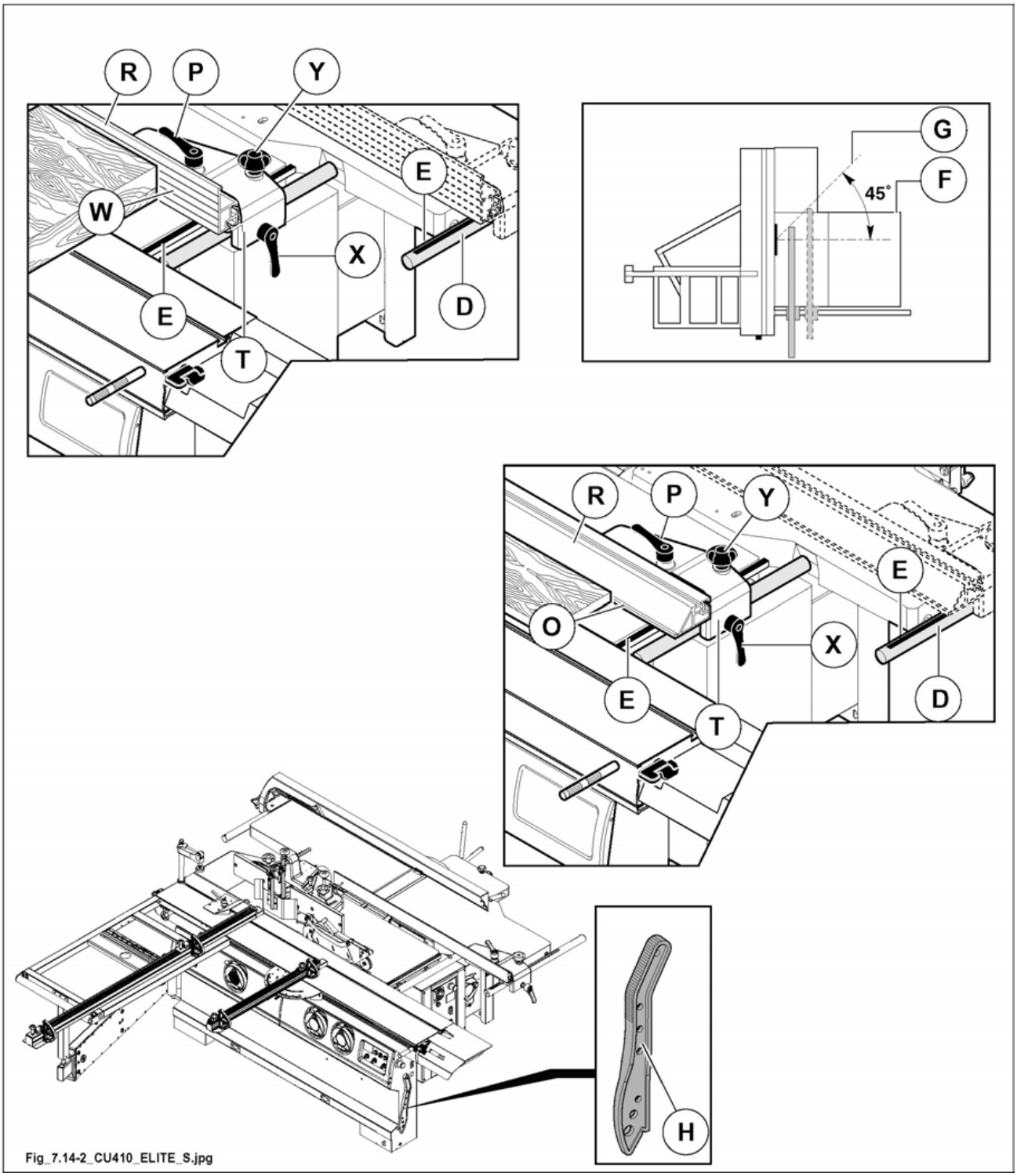


Fig. 7.14-2

DANGER-WARNING:
when for the execution of a peculiar working, the operator is obliged to put his hands near the tools, for safety reasons a proper pusher shall be used to move the workpiece forwards, to push it against the fence or to remove it after the cutting (see Chap.15).

USING THE PUSHERS

DANGER-WARNING:
before starting to work, ensure that the guard (D fig. 7.14-2A) is resting against the workpiece and, at the end of the operations, lower it until it comes into contact with the table.
To avoid getting too close to the blades with your hands, use the pusher (H fig. 7.14-2A) supplied with the machine.
After using this device return to its seating.

When you have to cut small workpieces and you have to push against the fence, you must use the pushers supplied with the machine.
The handle (A fig. 7.14-2A) is supplied as part of the equipment; it can be applied to pushers of various dimensions (see Section15).

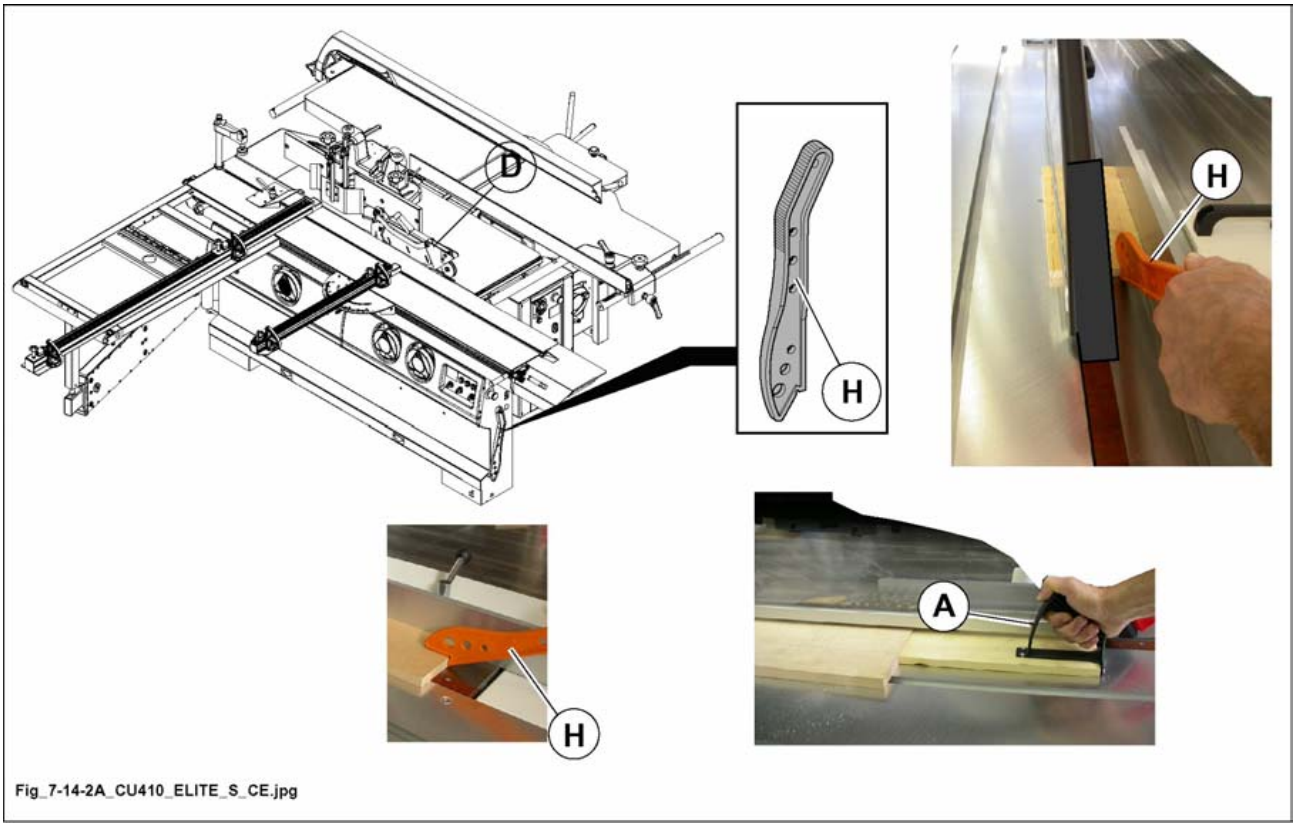


Fig. 7.14-2A

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(st_7-2)

7.23 USE OF SLIDING TABLE AND FRAME FOR LARGE PANELS

(ev_7-23_0.0)

7.23.1 ALUMINIUM SLIDING TABLE

(ev_7-23-1_0.0)

The aluminium sliding table moves on high precision slideways made of hardened steel in order to ensure the uniform and smooth motion with small friction, necessary for obtaining precise cuts.

The sliding table is locked and unlocked by means of lever (A fig. 7.23-1):

1) lever up: sliding table locked.
2) Lever down: sliding table unlocked.

The sliding table may be locked in 2 points:
- the lever (A fig. 7.23-1) is used to lock the wagon in the rest position (wagon closed) and in the loading position for the piece to be machined (wagon translated to right end stop).

Fasten the following devices:
- fit gib of column (D fig. 7.23-1) into groove of sliding table, fit arm (E fig. 7.23-1) to the column, then tighten handle (F fig. 7.23-1).
- Fit tile-shaped stop (G fig. 7.23-1) by inserting the gib into the groove of sliding table, hen tighten handle (H fig. 7.23-1).
- Fit handle (L fig. 7.23-1, supplied in the accessories bag) to sliding table to the desired position then screw down it.

The structure of device (G fig. 7.23-1) permits to perform precision stops also in pieces having an irregular stop surface.

DANGER-WARNING:
to move the sliding table ALWAYS use handle:
- L fig. 7.23-1 in case of small and middle size pieces.
- M fig. 7.23-1 in case of large pieces.

DANGER-WARNING:
move the sliding table only eith handles (L o M fig. 7.23-1) to avoid the possible squashing of the hands with the fixed part of the machine.

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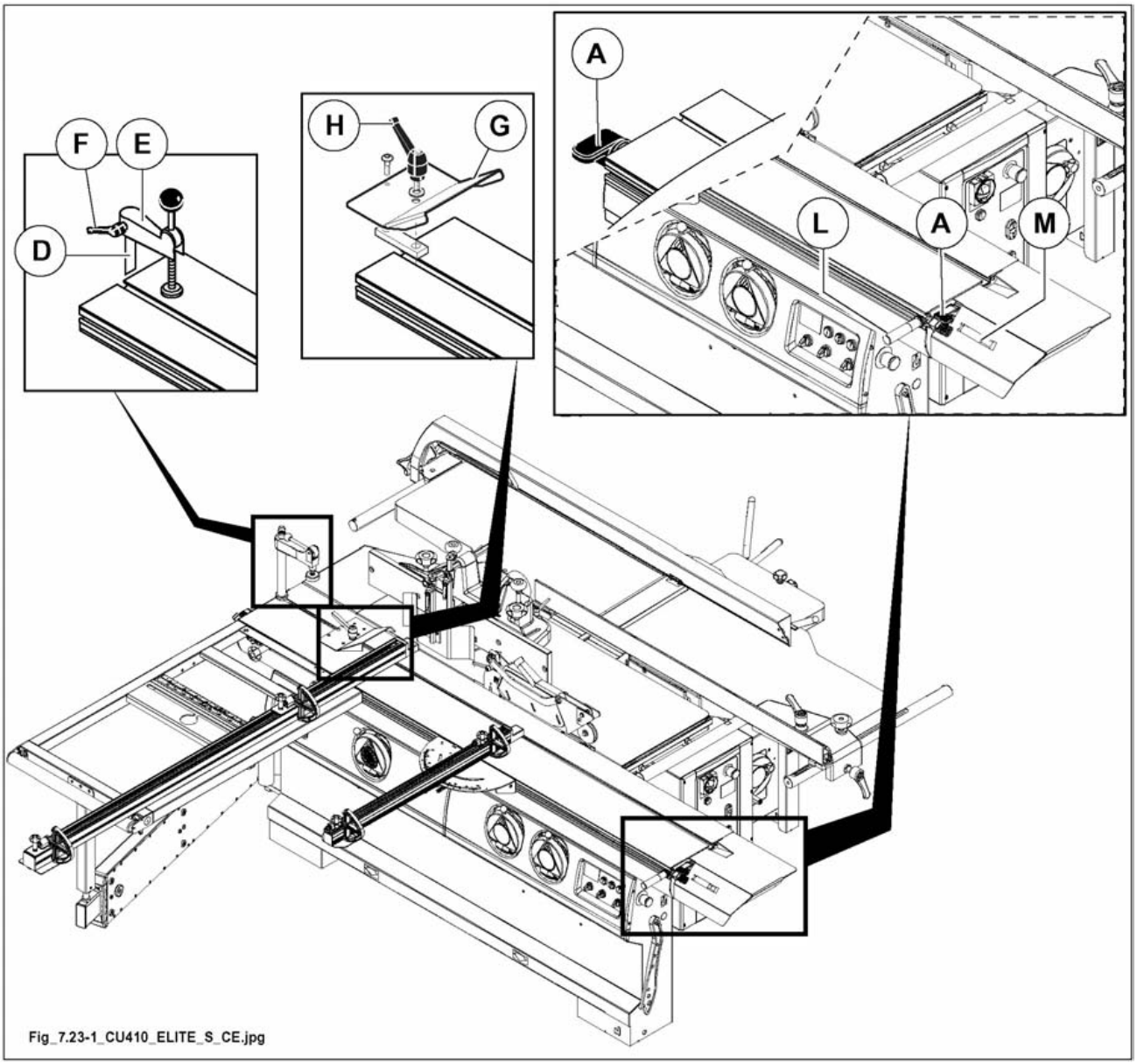


Fig. 7.23-1

7.23.6 USE OF THE PRESSER UNIT

(ev_7-23-6_0.0)

DANGER-WARNING:
to ensure a strong panel clamping, the foot shall be at a 1 mm height from the panel surface before lowering the lever.

- By means of lever (H fig. 7.23-6) lower foot (L fig. 7.23-6) for clamping the piece.

Wood stop unit
- Move stop (G fig. 7.23-6) to the required position;
- Tighten handle (A fig. 7.23-6) hard after adjustment.

NOTE-INFORMATION:
the structure of device (G fig. 7.23-6) permits to perform precision stops also in pieces having an irregular stop surface.

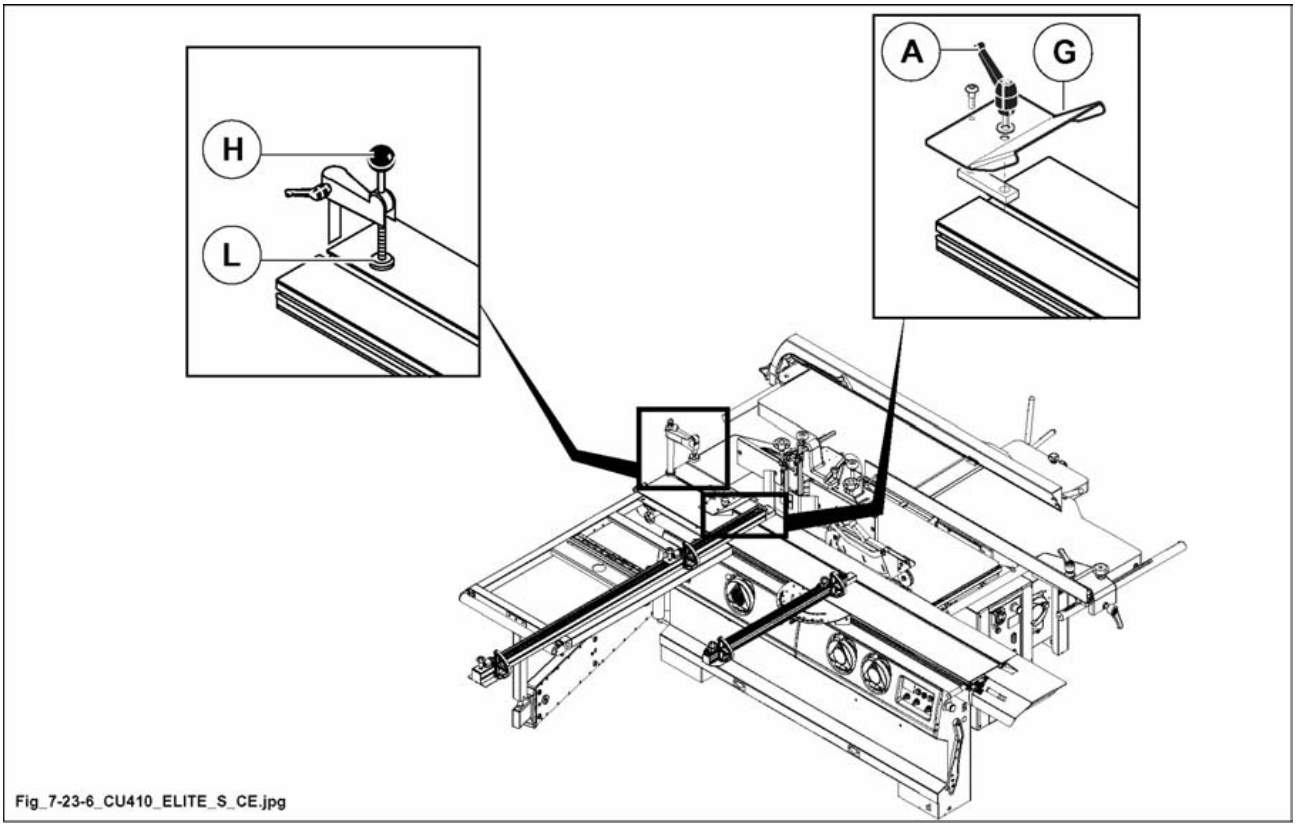


Fig. 7.23-6

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(st-7)

7.24 EXAMPLE: LONGITUDINAL CUT

(ev_7-24_0.0)

CAUTION:
when working with the saw completely close the router hole using the rings provided. After finishing work, completely lower the saw protection resting on the table.

The choice of the method to use to make a cut with the circular saw depends on the dimensions of the wood to be machined and the type of machining to be carried out.
For cutting ennobled wood, use of the engraver is indispensable to prevent chipping.
When the engraver is not needed, lower it completely underneath the table.
Adjust the saw and engraver assembly as described in Chap. 6.

DANGER-WARNING:
always secure the workpiece by means of the presser when a sliding wagon is used.
Always use supports when machining panels having great dimensions.

7.24.1 FIRST CUT

(ev_7-24-1_0.0)

When machining large panels, position the telescopic ruler and the squaring frame for thrust machining (see fig. 7.24-1); with this position maximum cutting length is obtained.
- Move the sliding table to the end of stroke (see fig. 7.24-1), lock lever (B fig. 7.24-1).
- Rest the panel on the sliding table and frame see fig. 7.24-1.
- Loosen handle (F fig. 7.24-1) and move the tile-shaped stop (D fig. 7.24-1) into the groove and rest it against the panel.
- Clamp the handle (F fig. 7.24-1).
- Move clamping device (E fig. 7.24-1) close to the panel.
- Unlock the sliding table by means of lever (B fig. 7.24-1).

DANGER-WARNING:
move the panel against the saw blade (set at the right height) by moving the sliding table by means of handle (C fig. 7.24-1).
When loading the piece onto the wagon, take care not to knock the saw blade.

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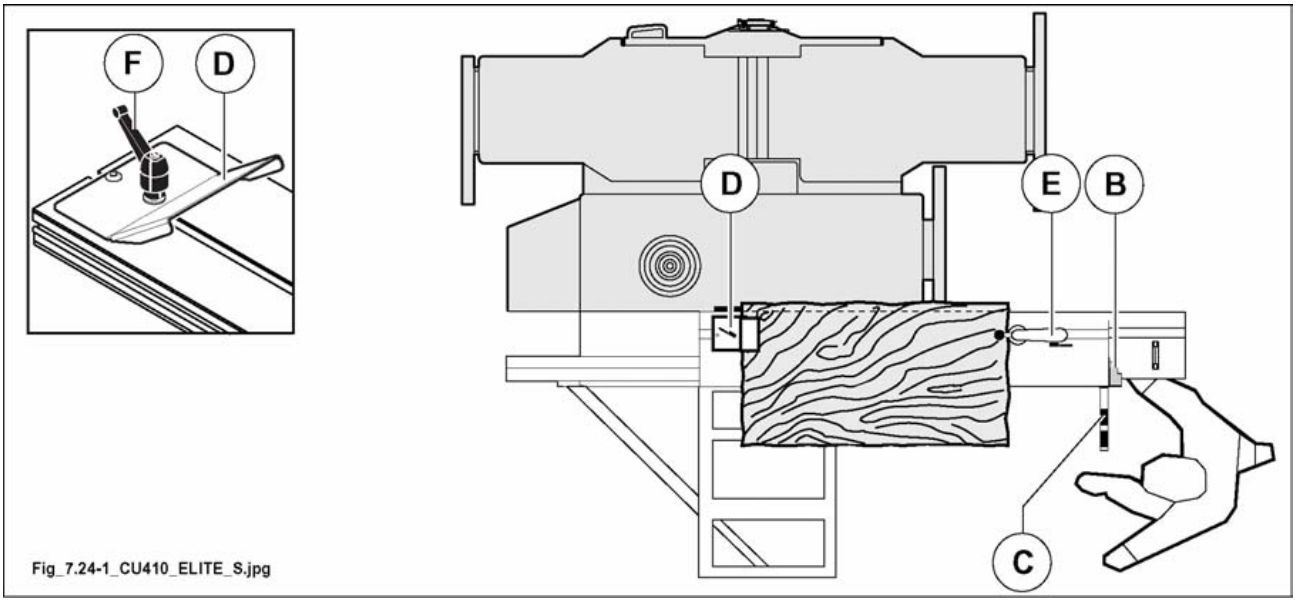


Fig. 7.24-1

7.24.2 SECOND CUT (SQUARING)

(ev_7-24-2_0.0)

- Move the sliding table to the end of stroke (see fig. 7.24-2), lock lever (L fig. 7.24-2).
- Turn the panel 90°. Rest the trimmed side (A fig. 7.24-2) against aluminium rule; lock the panel with clamping device (G fig. 7.24-2) then carry out cut (B fig. 7.24-2).

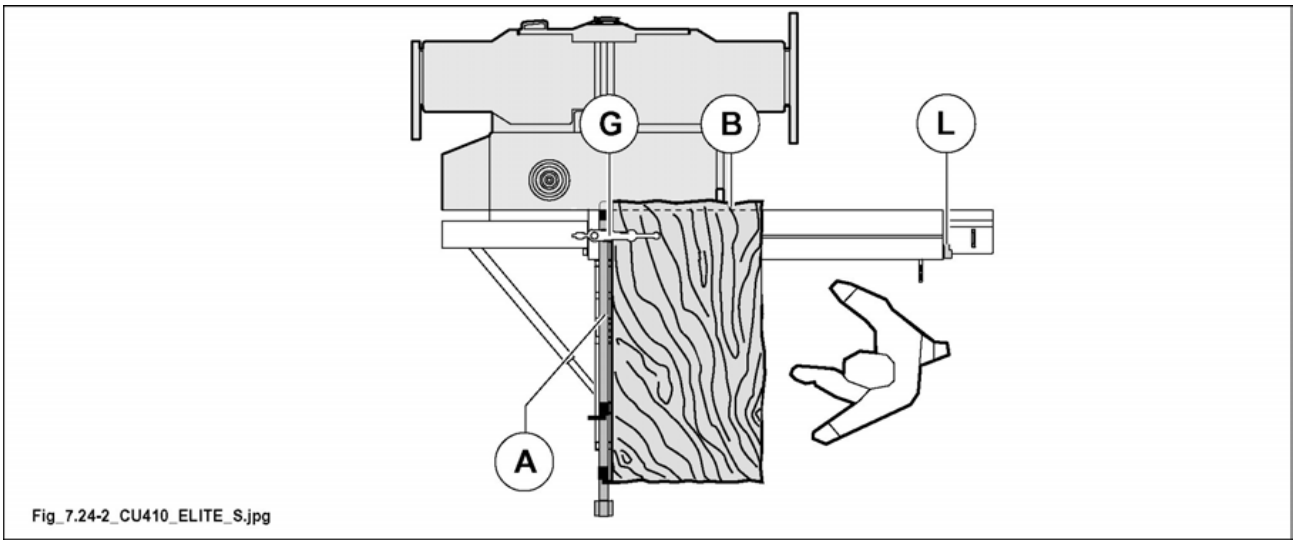


Fig. 7.24-2

7.24.3 THIRD CUT

(ev_7-24-3_0.0)

- Move the sliding table to the end of stroke (see fig. 7.24-3), lock lever (L fig. 7.24-3).
- Turn the panel 90° again. Rest side (B fig. 7.24-3) against aluminium rule and trimmed side (A fig. 7.24-3) against stop (T fig. 7.24-3) set to the cutting measure; lock the panel with clamping device (G fig. 7.24-3) carry out cut (C fig. 7.24-3).

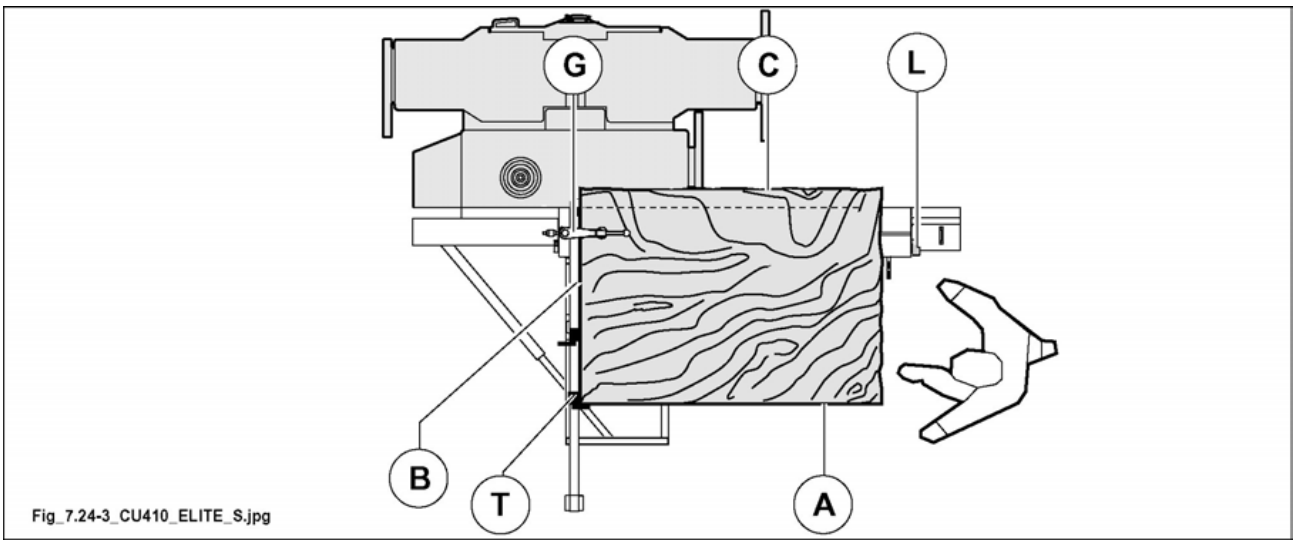


Fig. 7.24-3

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7.24.4 FOURTH CUT

(ev_7-24-4_0.0)

- Move the sliding table to the end of stroke (see fig. 7.24-4), lock lever (L fig. 7.24-4).
- Turn panel 90° again. Rest side (C fig. 7.24-4) against aluminium rule and side (B fig. 7.24-4) to stop (T fig. 7.24-4) set to the cutting measure required; lock the panel with clamping device (G fig. 7.24-4) then carry out cut (D fig. 7.24-4).

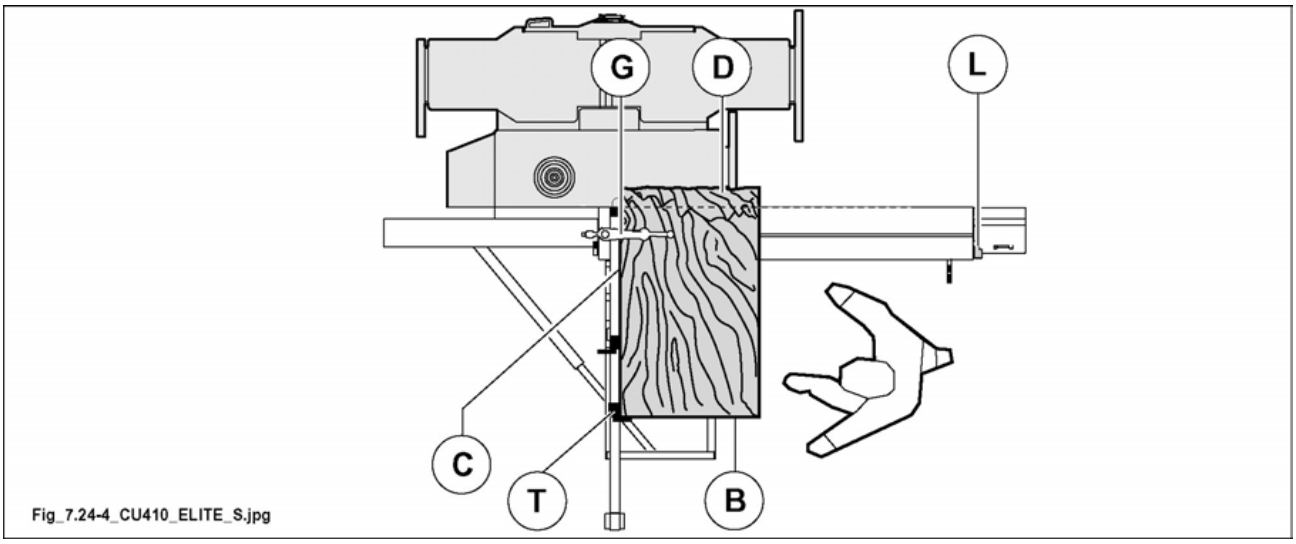


Fig. 7.24-4

NOTE-INFORMATION:
to cut smaller panels it is easier to work with the telescopic ruler positioned for bearing machining (see fig. 7.24-4A).

DANGER-WARNING:
working against the fence, with the scorer on, should be carried out with the utmost care because scorer rotation is executed at the same time as workpiece feeding which causes it to be carried along.

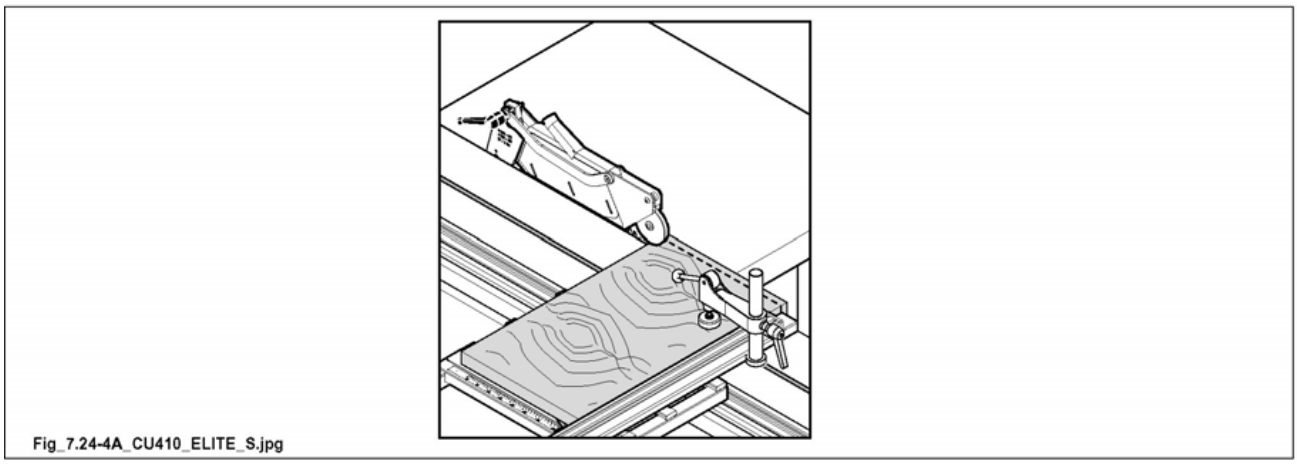


Fig. 7.24-4A

NOTE-INFORMATION:
when the dimension of the panel allows, it is better to carry out the first two cuts at tenoner (Par. 7.24.1 - 7.24.2) and cut the other sides with the parallel guide (L fig. 7.24-4B).

Small panels may also be cut with the device for angled cuts illustrated in figure (supplied on request).
For cuts at an angle with respect to slide stroke, position the telescopic fence (D fig. 7.24-4B) or the device for angled cuts (OPT) (E fig. 7.24-4B) according to the required tilt (refer to the millimetre scales (G fig. 7.24-4B) or (H fig. 7.24-4B) - respectively).

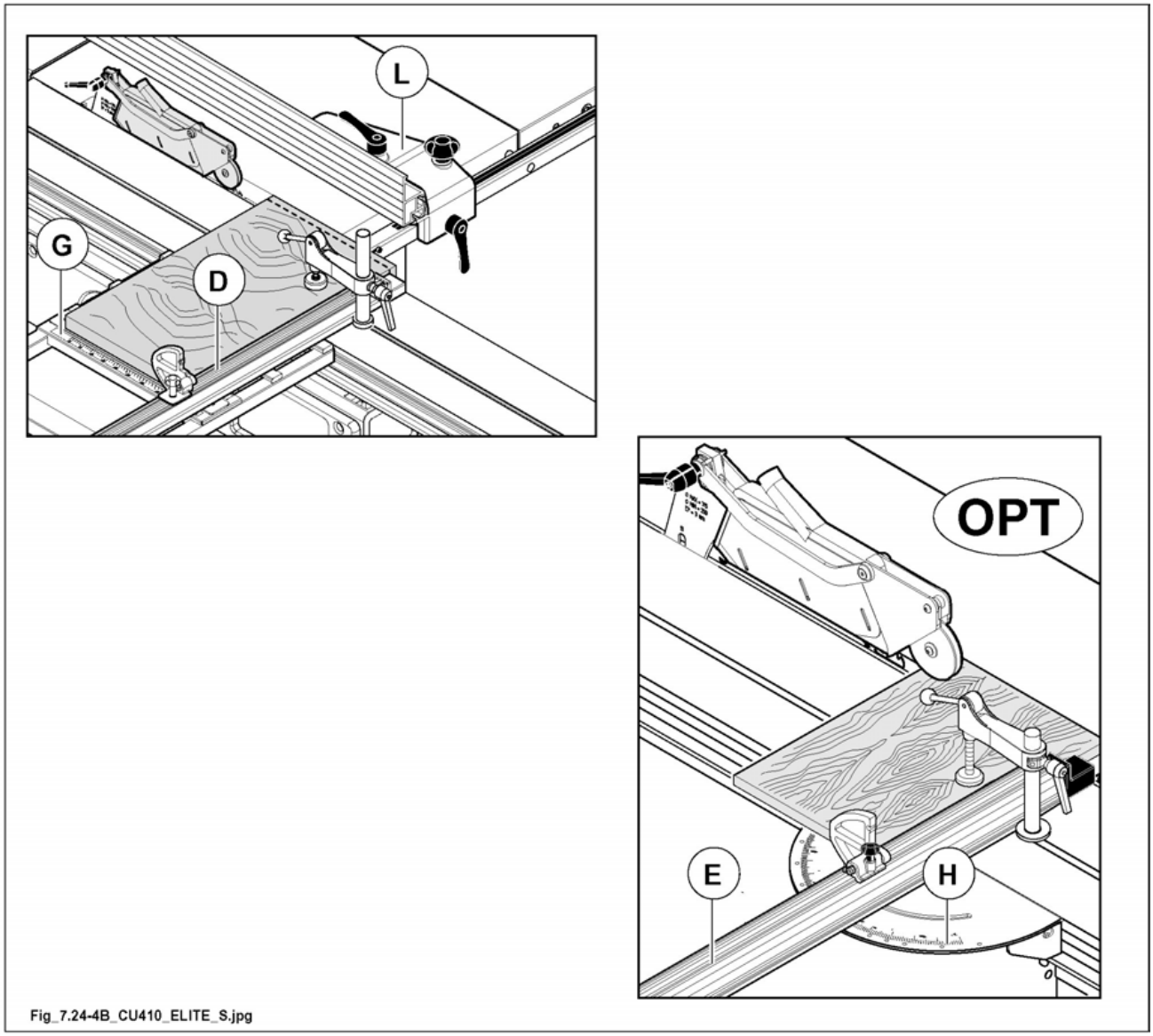


Fig. 7.24-4B

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7.24.5 CUT FOR OBTAINING PIECES WITH OPPOSITE SIDES PARALLEL

(ev_7-24-5_0.0)

To perform parallel cuts use fence (A fig. 7.24-5). To position and adjust, follow the instructions in Par. 7.14.2.
Position the wagon as shown in (fig. 7.24-5) and lock it with the knob (B fig. 7.24-5).
For positioning the workpiece against fence (A fig. 7.24-5) refer to scale (C fig. 7.24-5).

- Carry out the trimming cut (S fig. 7.24-5) as in the previuos way (first cut).
- Then carry out the parallel cut (M fig. 7.24-5) by resting trimmed side (S fig. 7.24-5) against aluminium rule of the saw carriage for parallel cut set to the measure required.
- Turn the panel 90° by resting trimmed side (M fig. 7.24-5) against rule; see fig. 7.24-5.
- Lock the panel by clamping device (G fig. 7.24-5) and carry out the third cut (N fig. 7.24-5).
- Turn the panel 180° by setting stop (F fig. 7.24-5) against trimmed side (N fig. 7.24-5) at the measure required.
- After locking the panel with clamping device (G fig. 7.24-5) carry out the last cut.

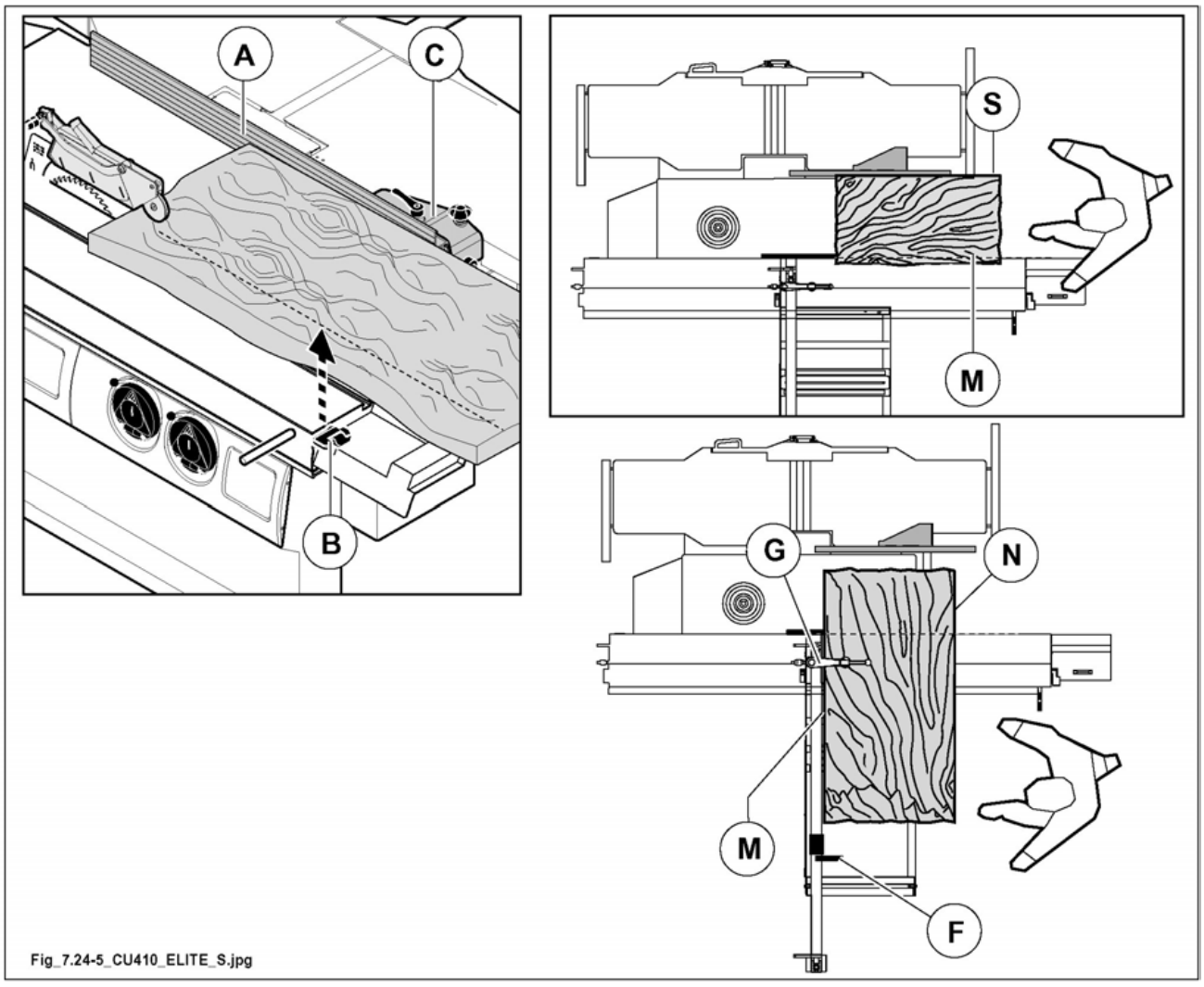


Fig. 7.24-5

DANGER-WARNING:
the front end of the rule shall never protude from the table end on side (X fig. 7.24-5A) but it shall reach a theoretical line (Y fig. 7.24-5A) which starts on the axis of the saw blade and has a 45° slope forwards, in order to avoid that the teeth of the saw blade grip the piece and throw it against the operator.

DANGER-WARNING:
never put the hands near the saw blade-engraver; always use a pusher.

The machine is supplied with a pusher (R fig. 7.24-5A) and with a knob (B fig. 7.24-5A). The knob (B fig. 7.24-5A) may be applied to pushers of different size, screwing it on with the screws provided.
Depending on the dimensions of the piece to be machined, select the most suitable type of pusher.

A Use for tall and narrow pieces.

B Use for short and narrow pieces.

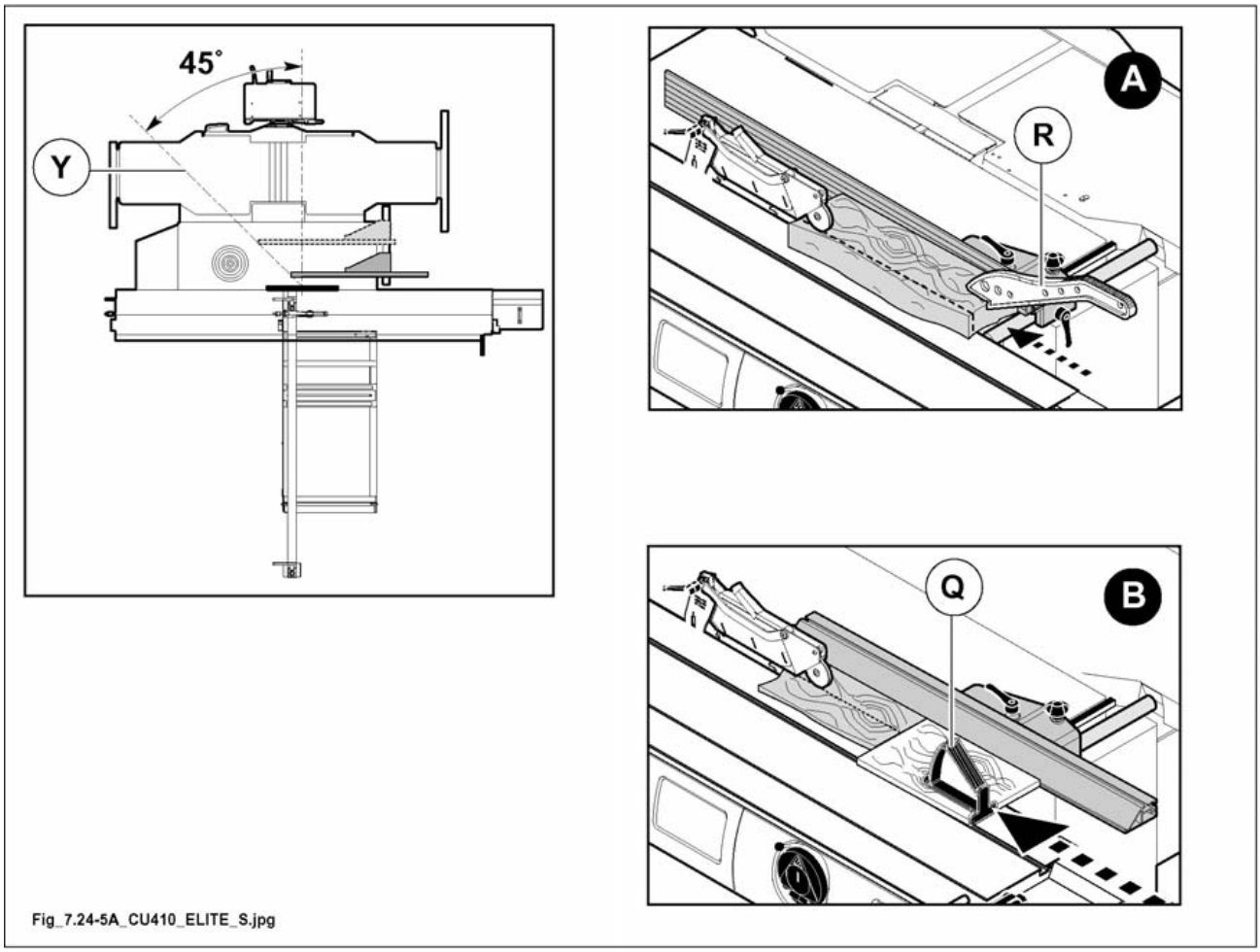


Fig. 7.24-5A

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7.24.6 RULE ADJUSTING FOR OBLIQUE CUTS

(hd_7.24.6_0.0)

- For oblique cuts, unscrew knobs (L fig. 7.24-6) to change position of rule (R fig. 7.24-6).
- For use, position the ruler referring to the plate (P fig. 7.24-6) and tighten the knobs (L fig. 7.24-6).

NOTE-INFORMATION:
the ruler is fitted with an extractable telescopic extension (H fig. 7.24-6), which may be lengthened as required after loosening the knob (G fig. 7.24-6).

When the chip guard (M fig. 7.24-6) is worn, bring it up to the saw blade by loosening the grub screw (N fig. 7.24-6).

The telescopic rule is supplied with the stops (B fig. 7.24-6). These can rapidly be positioned to rest on or push the workpiece during machining, by simply tipping them over.

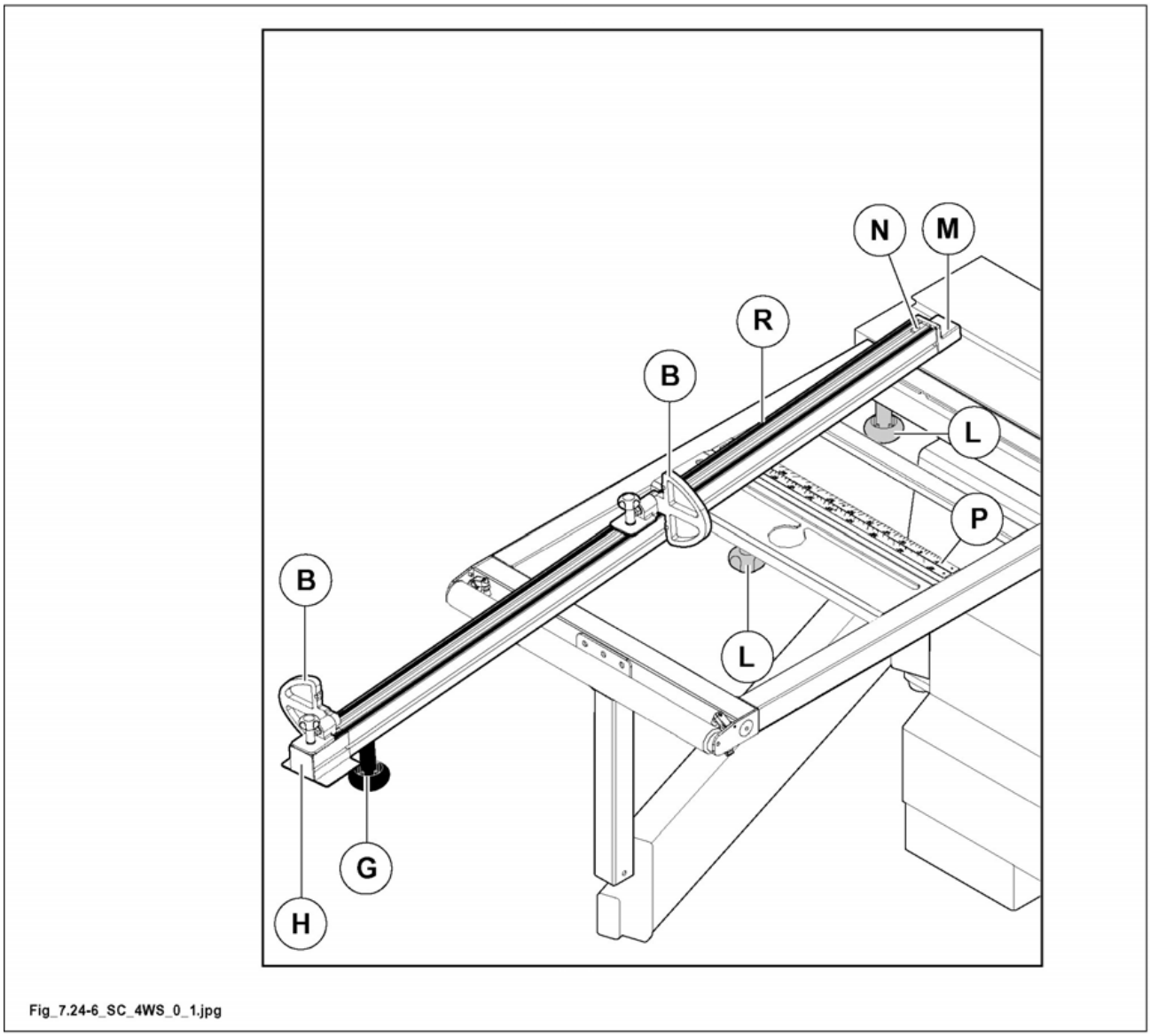


Fig_7.24-6_SC_4WS_0_1.jpg

Fig. 7.24-6

7.25 ADDITIONAL RULE FOR OBLIQUE CUTS WITH MILLIMETER RULE

(ev_7-25_0.0)

OPT

- Unlock the ruler assembly by turning (counterclockwise) the stud bolt (N fig. 7.25);
- loosen handle (F fig. 7.25);
- position the ruler assembly at the right distance from the saw blade;
- for mitre cuts turn the fence unit (A fig. 7.25) using scale (D fig. 7.25) as a reference;
- block by tightening handle (F fig. 7.25);
- position the presser up against the ruler assembly ensuring that the washer (Q fig. 7.25) is inserted into the groove;
- lock the ruler assembly by turning (clockwise) the stud bolt (N fig. 7.25).

The table has already been adjusted; to adjust proceed as follows:
- loosen levers (G fig. 7.25);
- adjust the dowels (S fig. 7.25) to ensure the table is parallel to the wagon;
- loosen screws (T fig. 7.25) and move the dowels (U fig. 7.25) to adjust the height position.

NOTE-INFORMATION:
when the chip guard (H fig. 7.25) is worn, move it after having loosened the retaining screws.

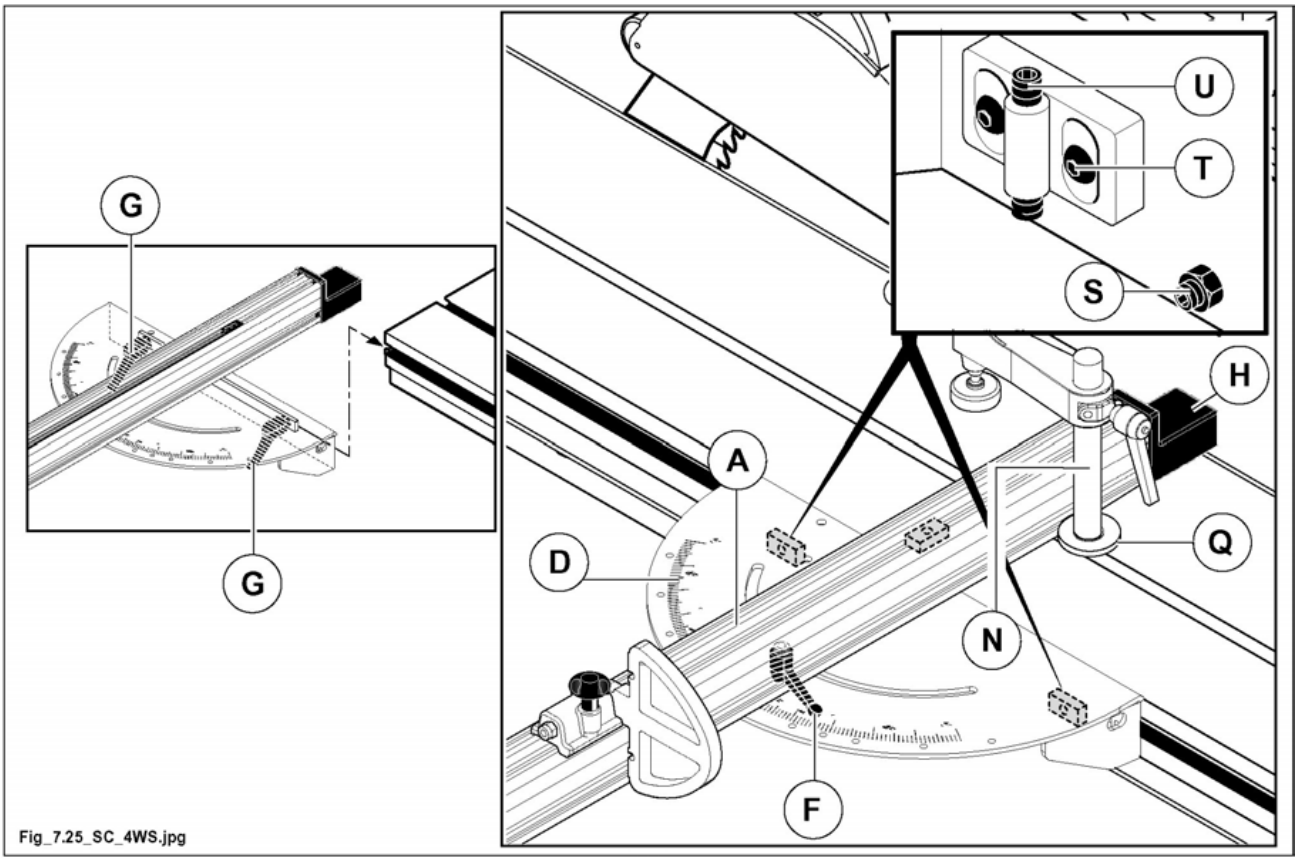


Fig. 7.25

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7A.1 KNIFE ADJUSTMENT

(fs_7-1_0.0)

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.
Exclusively mount knives of the same series (with the same height) to prevent unbalancing. Minimum permitted height: 18 mm.

NOTE-INFORMATION:
for safety reasons the blades are completely inserted in the cutter block; before machining adjust them in accordance with the instructions below.

For adjusting the knife projection proceed as follows:

1) Press the emergency button (2 fig.7.1).
2) Turn selector (3 fig.7.1) to (brake release).
3) Remove the planing fence unit (A fig.7.1) from the table.
4) Slacken the lever (B fig.7.1); pull the lever (B fig.7.1) towards the outside (position 3) and contemporaneously lift the planing tables by using the handle (G fig.7.1).
5) Insert the knife in the special housing (D fig.7.1) respecting the sharpening angle orientation with reference to the rotation direction of the planer spindle (E fig.7.1).
6) Make sure springs are in good working order by exerting a light pressure on cutters: these should go deeper into their seats and then go back to their initial position.
7) Make sure cutters are centered in relation to cutterblock (E fig.7.1).
8) Position the cutter adjuster (F fig.7.1) as shown in figure.

NOTE-INFORMATION:
for a correct adjustment, check that the four supports of the cutter adjuster evenly stick to the cutterblock (fig. 1). In this way proper projection of the knife from the planer spindle is guaranteed (maximum 1 mm).

9) Tighten the locking screws using the special wrench (C fig. 7.1) and exerting pressure on the cutter adjuster.

In the same way mount all the knives.
When the operation has been completed, set up the machine for buzz planing or thicknessing following the instructions in Chapters 7A and 9.

After the adjusting all knives must be at the same height of the outlet table.
To check the knife adjusting rest a wood ledge on the outlet table first on the right side then on the left side, then manually turn the cutterblock: the knives shall lightly touch the wood ledge uniformly.

DANGER-WARNING
max. knife projection from the cutterblock: 1 mm.

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10) Take off the knife setting gauge.

11) Turn selector (3 fig. 7.1) to (brake locking).
12) Release emergency button (2 fig. 7.1).

If the knives are well adjusted, the finished workpieces are not convex without the step at their rear end.

IMPORTANT

Keep the knives and gibs always clean to ensure the best performance of the machine.
Remove resin residues, sawings and chips with a hard bristle brush and terpentine, kerosene or light oil.
Never use other different product or synthetic solvents.
Remove dirty then dry each part.
Clean the worktable with a dry cloth.

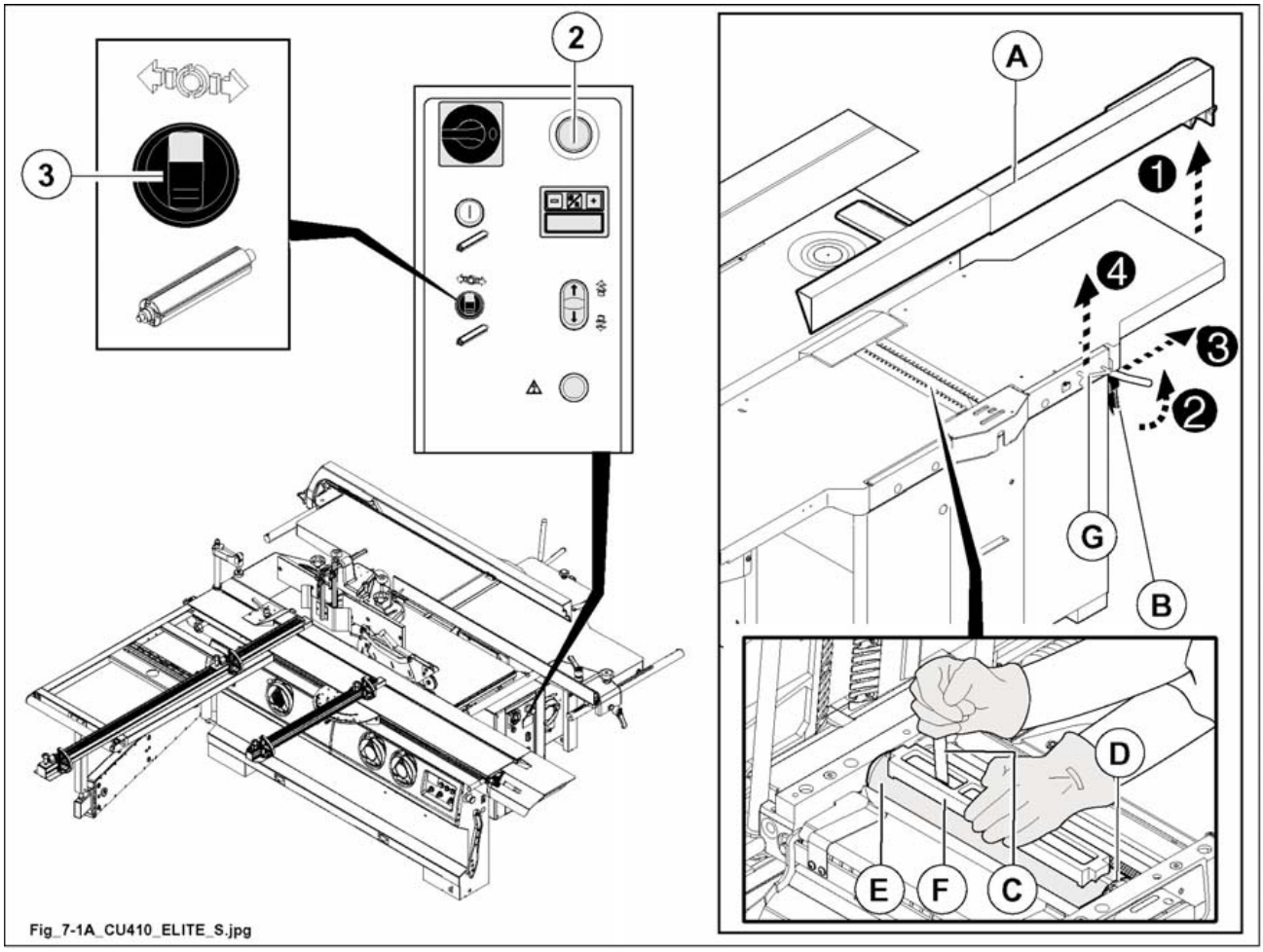


Fig. 7.1

7A.2 KNIFE REPLACING

(fs_7-2_0.0)

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

DANGER-WARNING
do not start the cutterblock motor when the knives are not fitted.

For replacing the knife projection proceed as follows:

1) Press emergency button (2 fig. 7.2).
2) Turn selector (3 fig. 7.2) to (brake release).
3) Remove the planing fence unit (A fig.7.2) from the table.
4) Slacken the lever (B fig.7.2); pull the lever (B fig.7.2) towards the outside (position 3) and contemporaneously lift the planing tables by using the handle (G fig.7.2).
5) Turn the cutterblock in order to bring the knife to be replaced to the top part.
6) Loosen screws (T fig.7.2) of the knives with the 7 mm wrench.
   The knives come out pushed by the internal springs.
7) Withdraw the knife and replace or grind it.
8) Fit the knives and adjust them; see the previous paragraph.
9) When the operation has been completed, set up the machine for buzz planing or thicknessing following the instructions in Chapters 7A and 9.
10) Turn selector (3 fig.7.2) to (brake locking).
11) Release emergency button (2 fig.7.2).

DANGER-WARNING
the knife grinding is permitted up to a min. width of 18 mm (fig.7.2). When this value has been reached, replace the knife.

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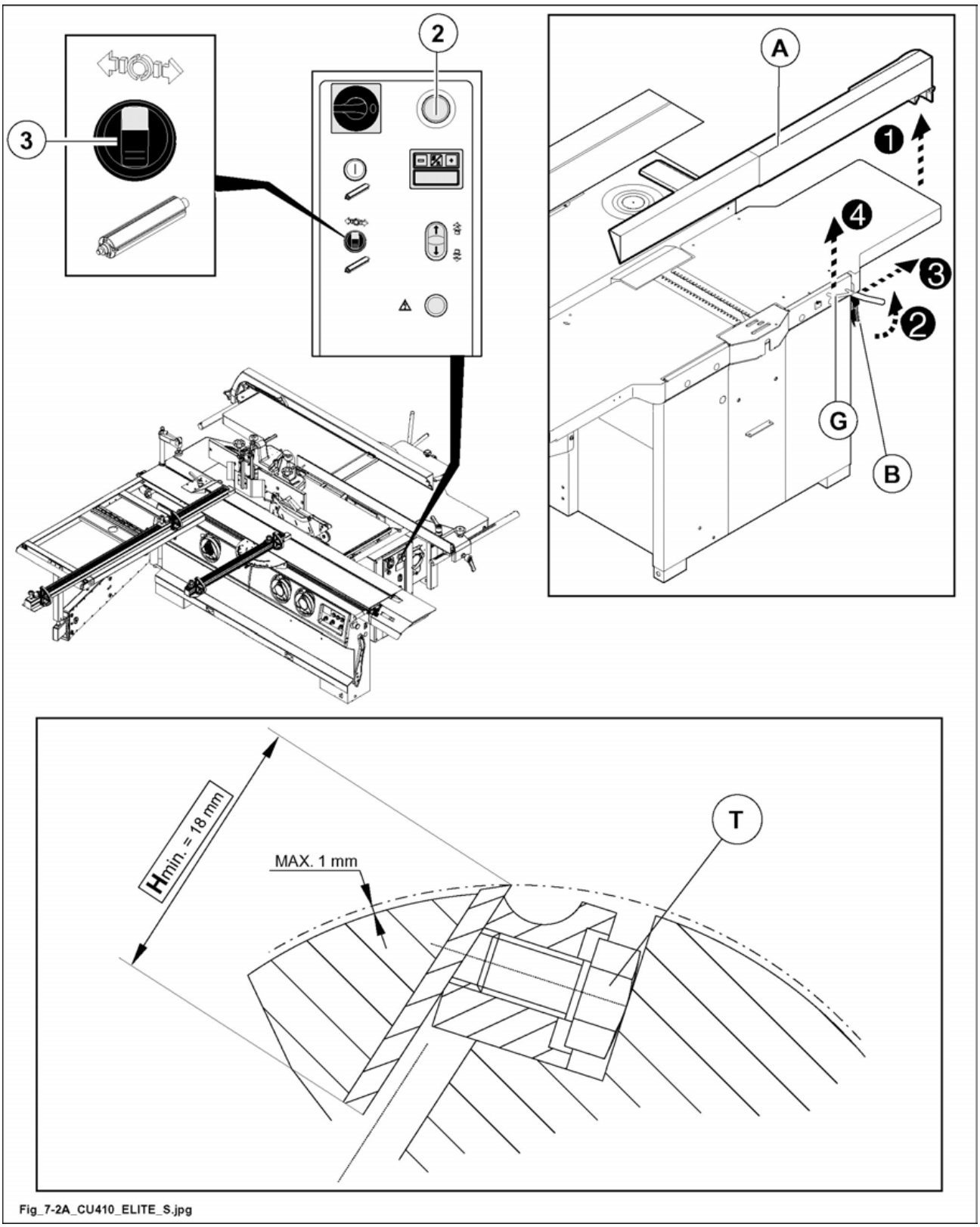


Fig. 7.2

7A.4 REPLACING THE THROW-AWAY KNIVES

(fs_7-4_0.0)

OPT

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

DANGER-WARNING
do not start the cutterblock motor when the knives are not fitted.
Do not unblock the screws (B fig. 7.4).

DANGER-WARNING
remove the planing fence unit (A fig.7.4) from the table.

1) Press the emergency button (2 fig. 7.4).
2) Loosen handle (M fig.7.4).
3) Lift the tables by laying them carefully in end of stroke position.
4) Turn selector (3 fig. 7.4) to (brake release).
5) Turn planer spindle (F fig. 7.4) until bring the knife to be changed next to the extraction hole (A fig. 7.4).
6) Loosen the gibs by exerting a light pressure with a wood or plastics hammer.
7) By using a screwdriver push the knife outwards.
8) Take hold of the knife with one hand and pull it out.
9) Fit the new knife (E fig. 7.4) or the old one after turning it; center the knife in length direction.
10) Turn selector (3 fig. 7.4) to (brake locking).
11) Place the machine accessories according to the working to be carried out
12) Release emergency button (2 fig. 7.4).
13) Starting machine, the gibs (U fig.7.4) position themselves automatically.

Take a piece of hard wood and plane it on its whole length for a few minutes, in order to get a better locking of the cutter-gib unit.

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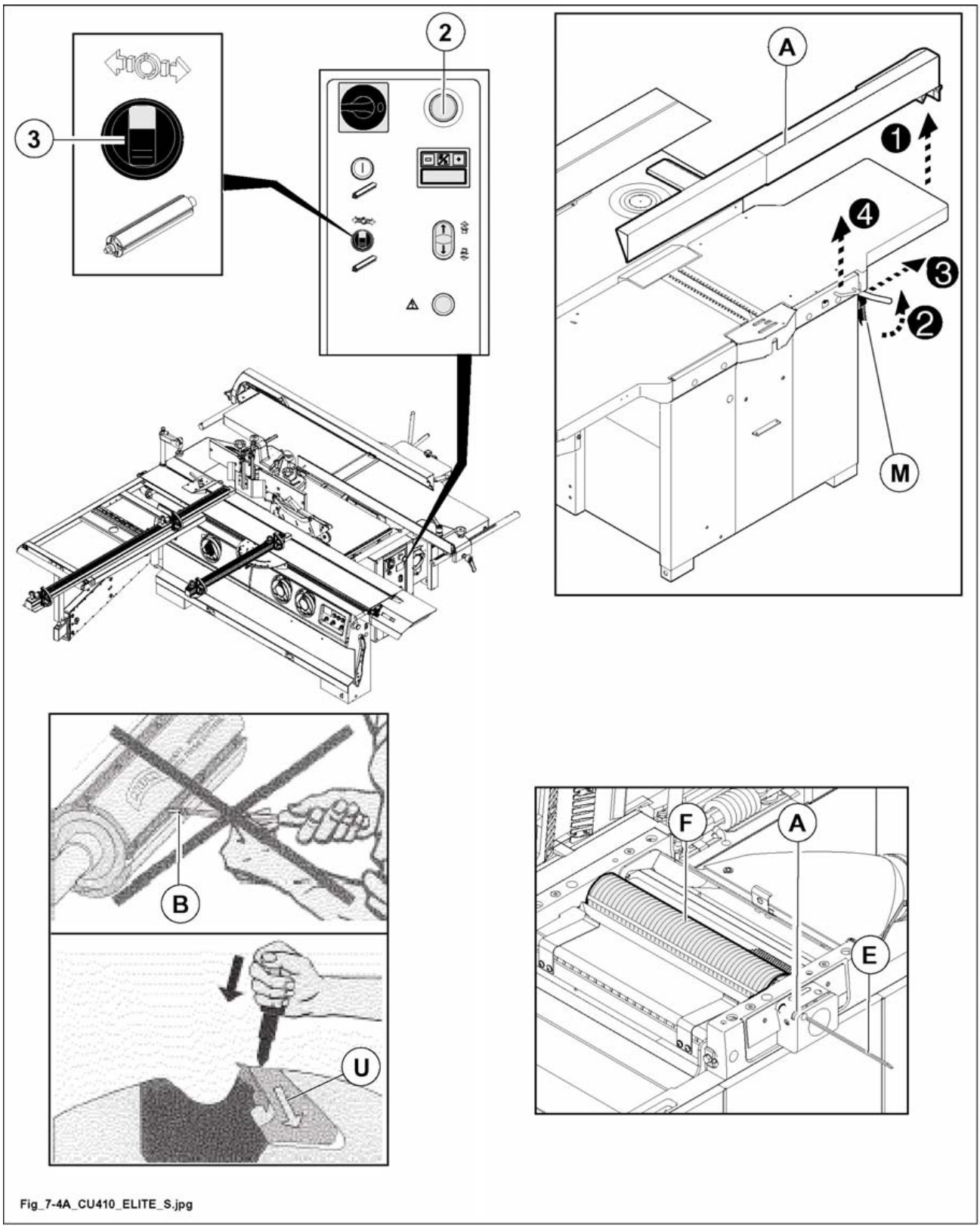


Fig. 7.4

7A.6 SURFACING TABLES ADJUSTING

(fs_7-6_0.0)

DANGER-WARNING
do not move the inlet table when the cutterblock is rotating.

DANGER-WARNING
before moving the inlet table, make sure that no object is between the inlet table and the fence.

7A.6.1 INLET TABLE

(fs_7-6-1_0.0)

- Operate on the lever (B fig. 7.6-1) in order to place the table (D fig. 7.6-1) depending on the chosen removal: read the traverse on the data plate (C fig. 7.6-1).

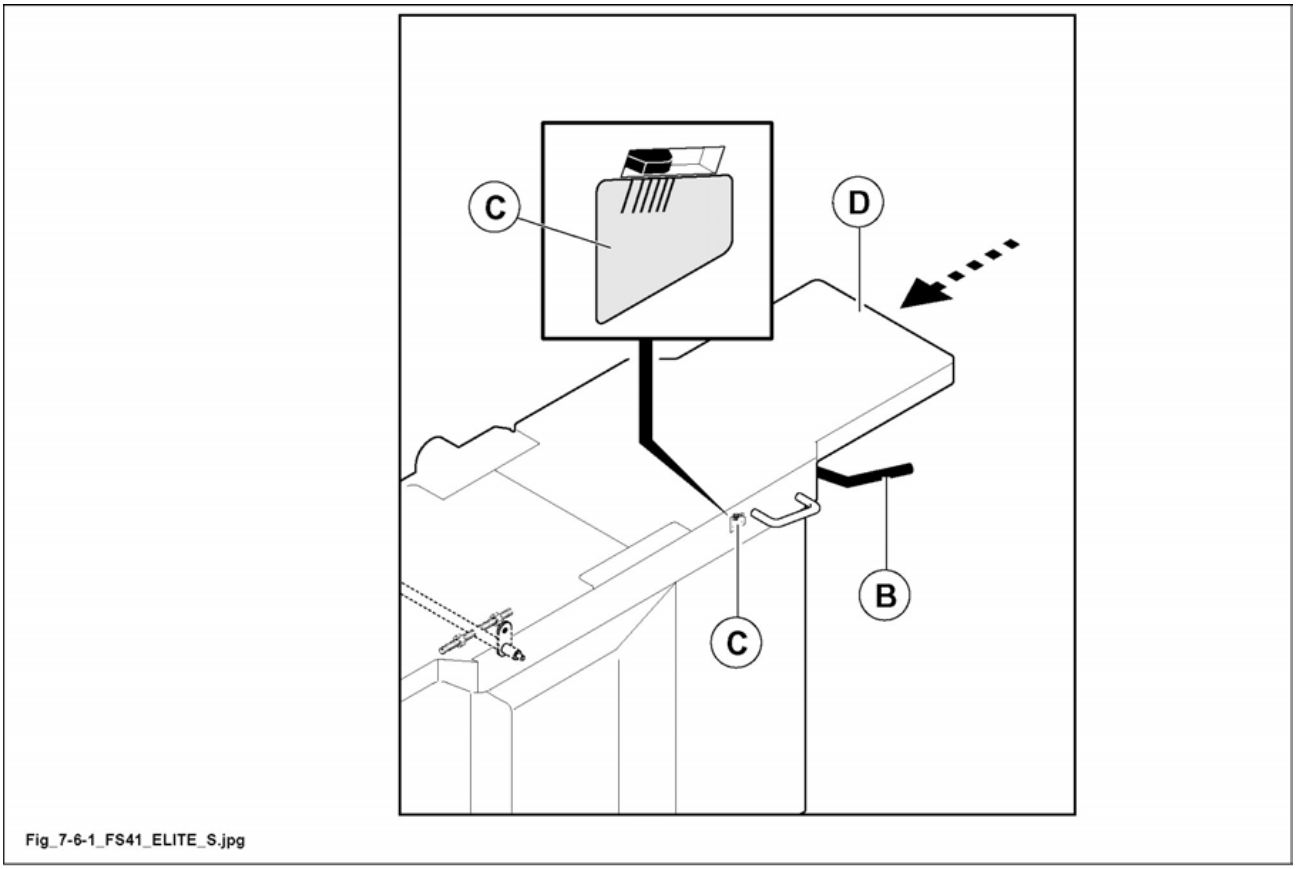


Fig. 7.6-1

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7A.6.2 OUTLET TABLE

(fs_7-6-2_0.0)

NOTE-INFORMATION:
the outfeed table (E fig. 7.6-2) is positioned level to the cutter block knife and does not need to be adjusted.

The table has been adjusted at factory during the machine test.

If it needs realigning, adjust the grub screws (F fig. 7.6-2) below the table. Tighten the nuts (G fig. 7.6-2) when the adjustment is complete.

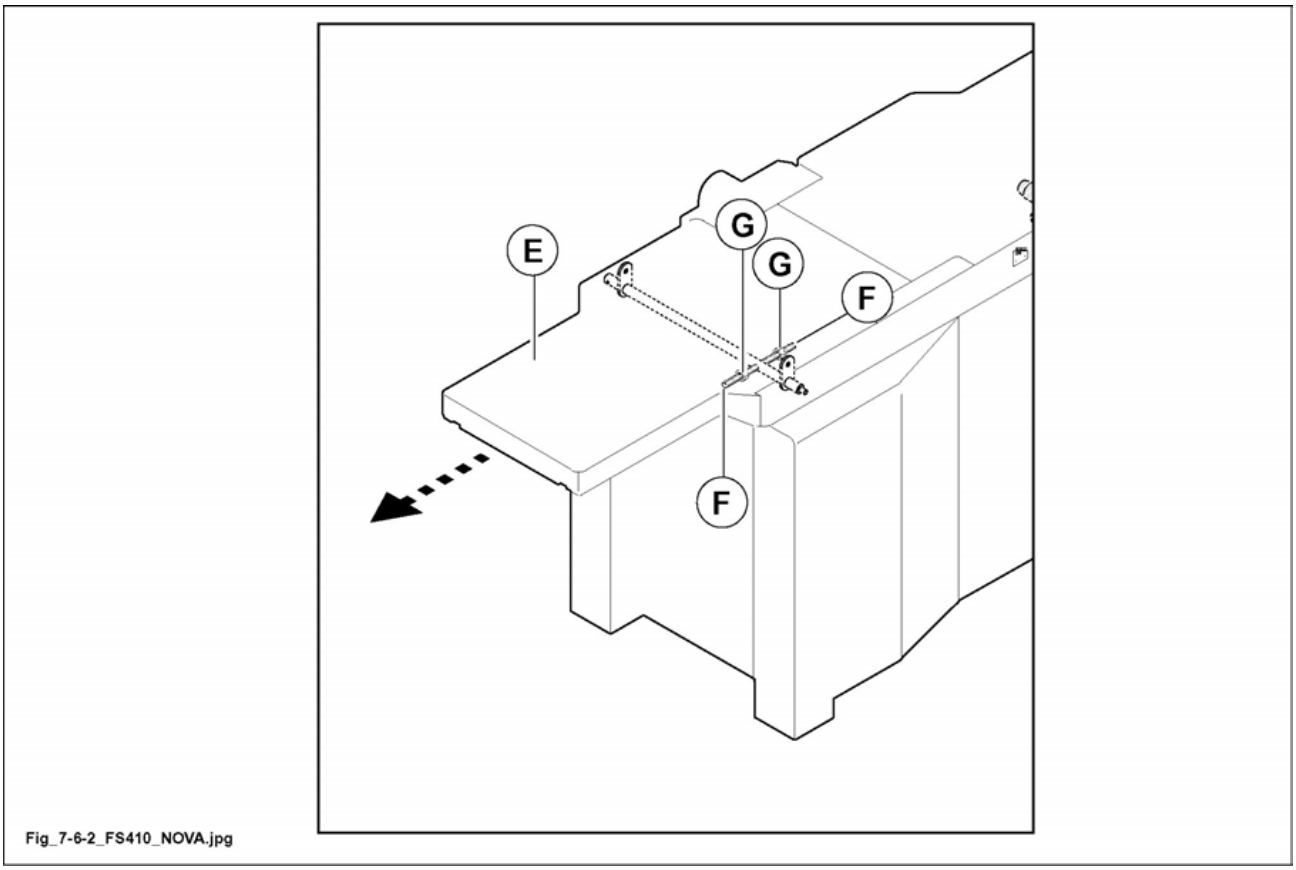


Fig. 7.6-2

7A.8 FENCE

(fs_7-8_0.0)

DANGER-WARNING
during the machining, the protections (F fig. 7.8) and (L fig. 7.8) must always be positioned on the cutterblock.

7A.8.1 LONGITUDINAL SHIFTING

(fs_7-8-1_0.0)

A Loosen lever (slacken the lever (A fig.7.8) (position 1); pull the lever towards the outside (position 2)) and manually move fence (B fig.7.8) to the desired position.

B Tighten lever (press the lever (A fig.7.8) to position 1 and rotate it to position 2.).

NOTE-INFORMATION:
check perfect cleanage of the sliding rod (E fig. 7.8).

7A.8.2 TILTING

(fs_7-8-2_0.0)

- To angle the fence from 90° to 45° loosen the locking device (C fig. 7.8) and adjust the fence, observing the value on the index (T fig. 7.8).
- As soon as the adjustment has been carried out, bring the fence lock (P fig. 7.8) to the stop on the surface unit fence (B fig. 7.8) and tighten knob (R fig. 7.8).

NOTE-INFORMATION:
fence (B fig. 7.8)may be tilted from 90° to 45° and in any intermediate position.

For eventual corrections of the stops for extreme positions (90° and 45°) operate on screw and counternut (D fig. 7.8) for 90° position and on screw and counternut (H fig. 7.8) for 45° tilting.

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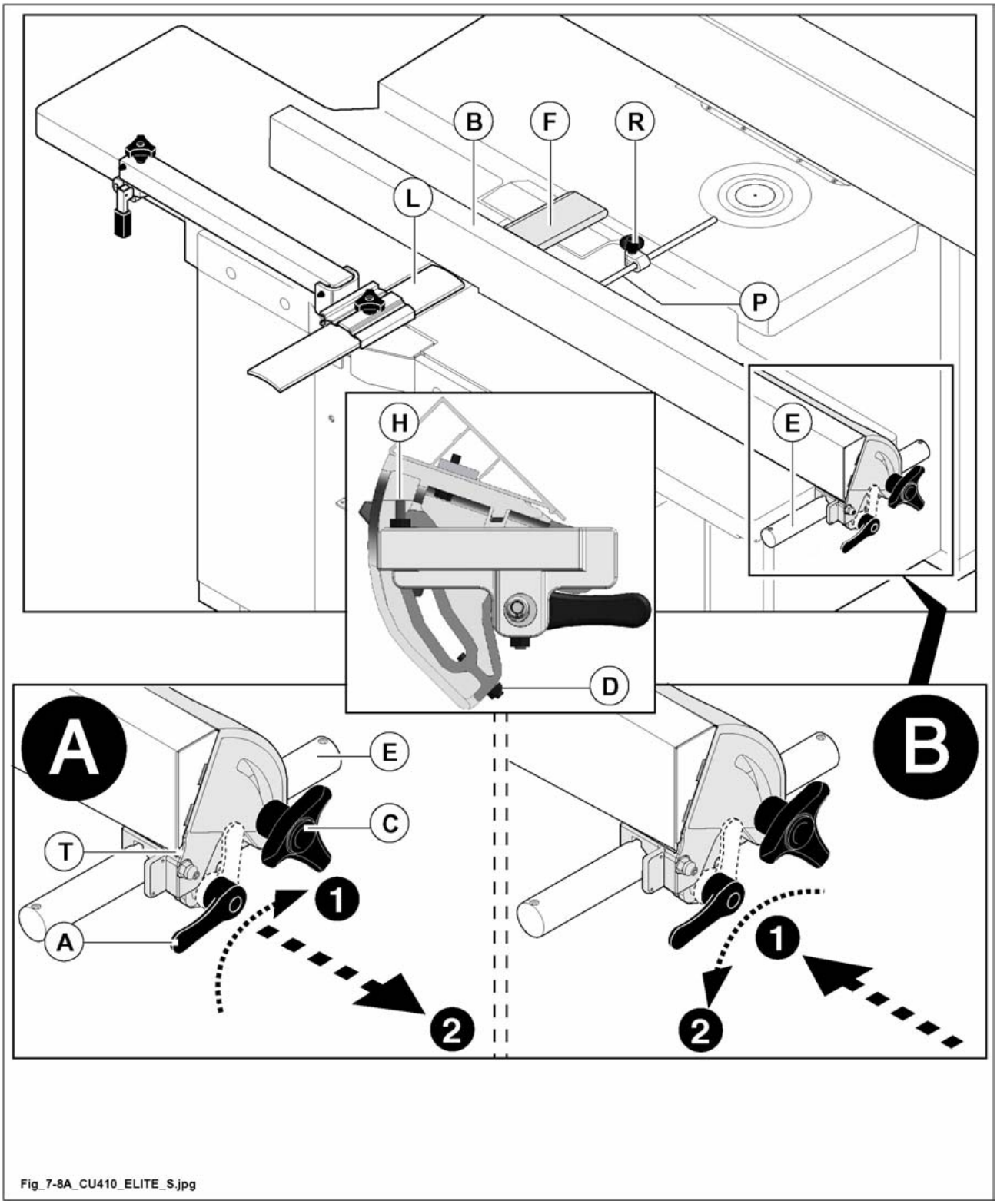


Fig. 7.8

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8.1 FITTING THE PARTS DEMOUNTED FOR TRANSPORT REASONS

(fs_8-1_0.0)

OPT

For packing and transport reasons some machine members are removed.

8.1.1 MORTISER FITTING

(fs_8-1-1_0.0)

OPT

DANGER-WARNING
all fitting and demounting operations require 2 persons.

Carry out the fitting as follows:

1) Prepare the screws (A fig. 8.1-1) and the relative grommets on the base of the machine.
2) Raise the mortiser (B fig. 8.1-1) and fit the dovetail slide (C fig. 8.1-1) on the heads of screws (A fig. 8.1-1).
3) Fit levers (H and S fig.8.1-1 usually demounted), for shifting in depth direction, in their seats: you have only to insert them.
4) Screw down the screws (A fig. 8.1-1) until joining the mortising machine to the base and adjust the parallelism of the table with respect to the bit (E fig. 8.1-1) (see "Spindle bits - assembly" par. 8.1.2) acting on the screws (D fig. 8.1-1) and on the four grub screws (F fig. 8.1-1).
5) Check proper adjustment by moving the working table transversally, and tighten the screws (A fig. 8.1-1).
6) Ensure that the four grub screws (F fig. 8.1-1) rest on the base.

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NOTE-INFORMATION:
ensure that the work table is a distance of 11mm from the point centre.

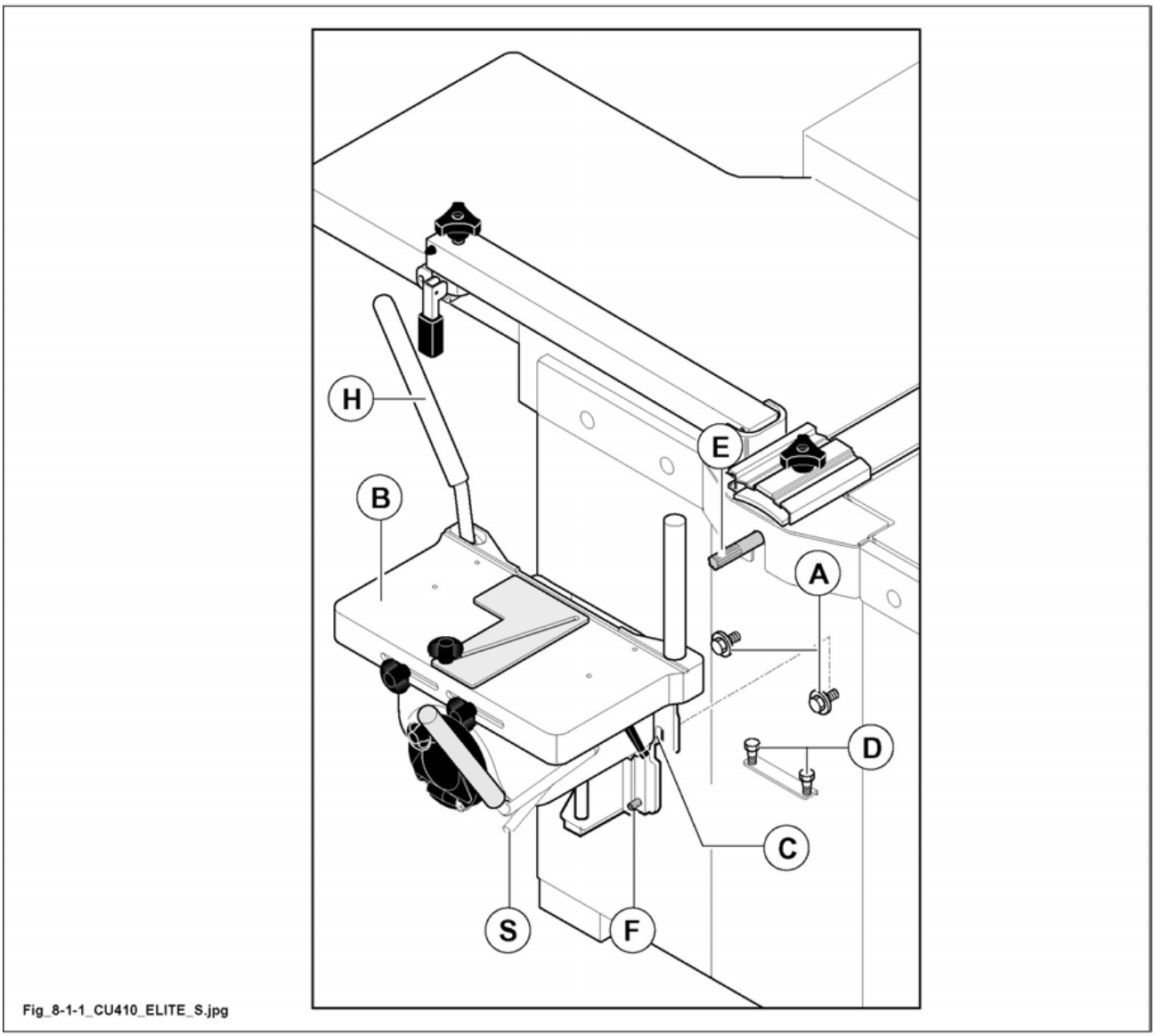


Fig. 8.1-1

8.1.2 SPINDLE BITS - ASSEMBLY

(fs_8-1-2_0.0)

DANGER-WARNING
use gloves for handling the bit.

1) Fixed spindle
Mounts 16 mm left bits which are locked by two screws.

2) Self-centering spindle OPT
Mounts from 3 to 16 mm left bits which are locked by a screw.

3) Collet spindle OPT
Fit bits with shanks of Ø 5 mm, Ø 10 mm, Ø 16 mm.

Fitting the tool (fixed and selfcentring spindle)
Release the lever (B fig. 8.1-2) and lift the guard (C fig. 8.1-2).
Tighten the tool (D fig. 8.1-2) though the holes (A fig. 8.1-2) din the spindle cover.

Fitting the tool (collet spindle)
Open the tables (only if the special spanner (G fig. 8.1-2) is utilized).
Tighten the tool (D fig. 8.1-2) using accessory pin (F fig. 8.1-2) and special key (G or H fig. 8.1-2) as indicated in figure.

DANGER-WARNING
it is prohibited to use abrasive grinding wheels.
When the slotter is not in use, it is necessary to disassemble the bit, as it rotates jointly with the surfacing table shaft and it cannot be protected.
The bits must be locked over the entire useful length of the spindle.

DANGER-WARNING
before you start machining, rest the guard (C fig. 8.1-2) on the table so that the cutter block is completely covered.

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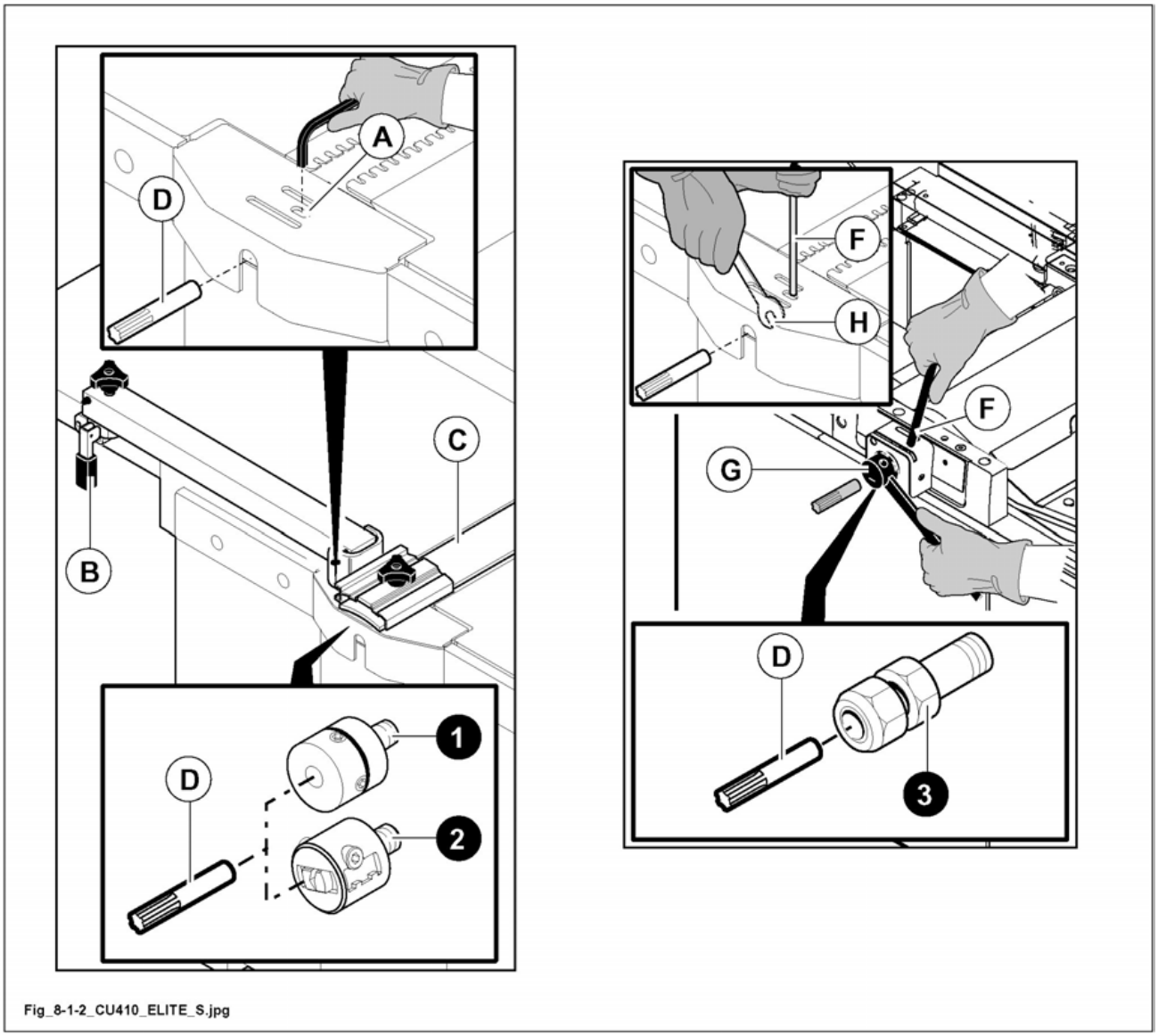


Fig. 8.1-2

8.2 MORTISER USE

(fs_8-2_0.0)

OPT

SAFETY OVER ALL

DANGER-WARNING
the tool must turn in the direction indicated by the arrow as shown in fig. 8.2.
Switch on the machine for a fraction of a second and check the direction of rotation. Should rotation be incorrect, follow the instructions listed in Chap. 4 "Electrical connection".
Mount the tool following the instructions and warnings listed in par. 8.1.2.
Check that the tool is well tightened.

DANGER-WARNING
always make sure that the workpiece is rightly clamped on the table.

For long workpieces use a support the height of which may be adjusted and eventually add a clamping device to the support (not supplied by SCM***).***

Work with moderate feed speed with small strokes because the bit is brittle.

Before starting working always make sure that the cutterblock is protected.

As the bit and cutterblock rotate together, after the use as a mortiser demount the bit as it is not protected.

DANGER-WARNING
completely lower the guard (E fig. 8.2) to rest against the surfacing table.

After adjusting the table stroke, set the workpiece against stop (B fig. 8.2)and clamp it with foot(Z fig. 8.2).

With levers (A and S fig. 8.2)start drilling in longitudinal direction with a drilling depth equal to 10 mm, then carry out the drilling in the traverse direction along the entire length of the slot desired.

The milling may be carried out with many adiacent holes, the slot is obtained with a traverse stroke.

This technique is necessary to avoid the bit rupture (tool always brittle), to permit the chips exhaust and to avoid the overheating of the tool which may be damaged so the working quality is not ensured.

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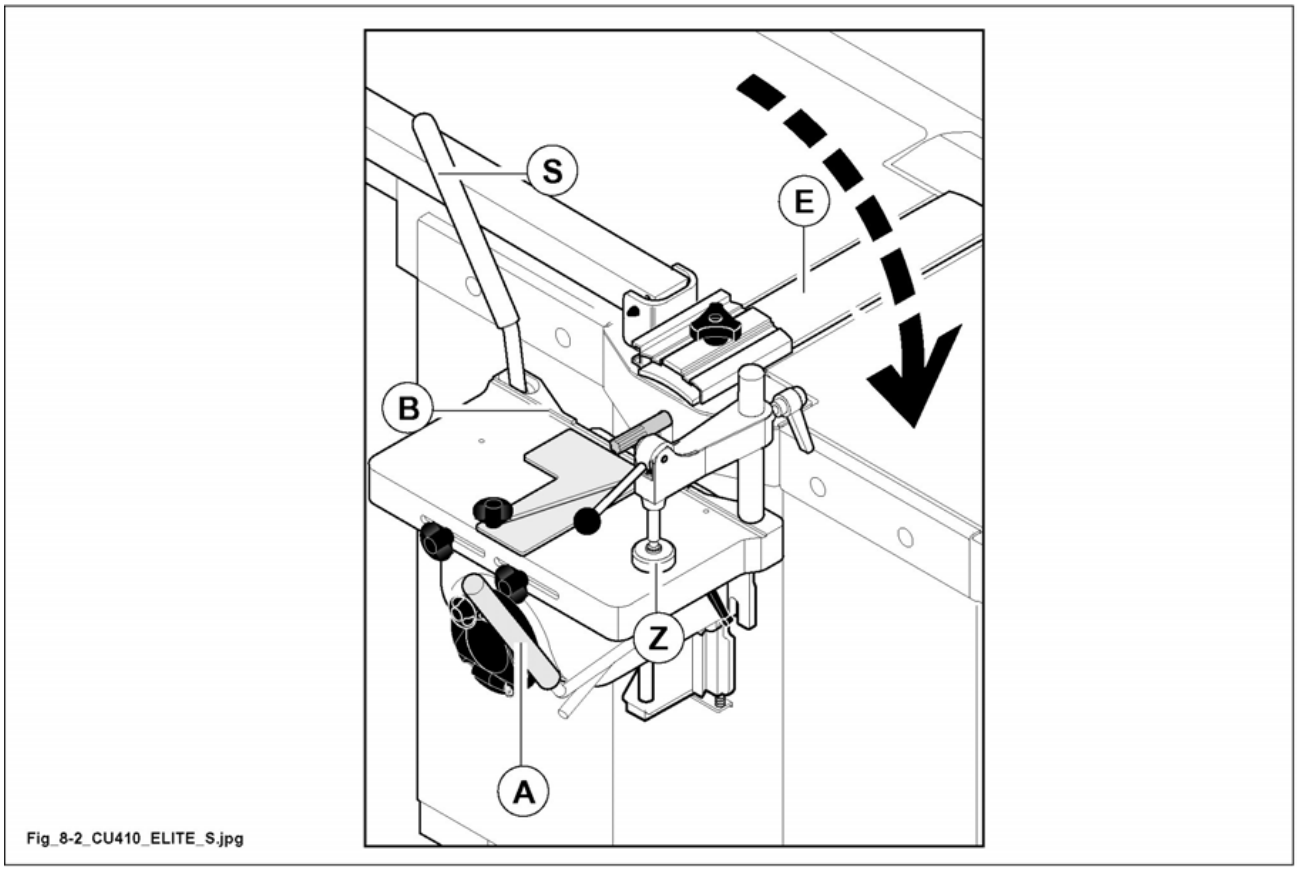


Fig. 8.2

8.3 ADJUSTMENTS

(fs_8-3_0.0)

OPT

With the use of slotter it is possible to carry out holes and slots both dead or through.

- Place the workpiece on the table, stopping it and securing it by means of the presser (B fig. 8.3).
- Position the stop (L fig. 8.3) against the workpiece to be machined and tighten the knob (M fig. 8.3).

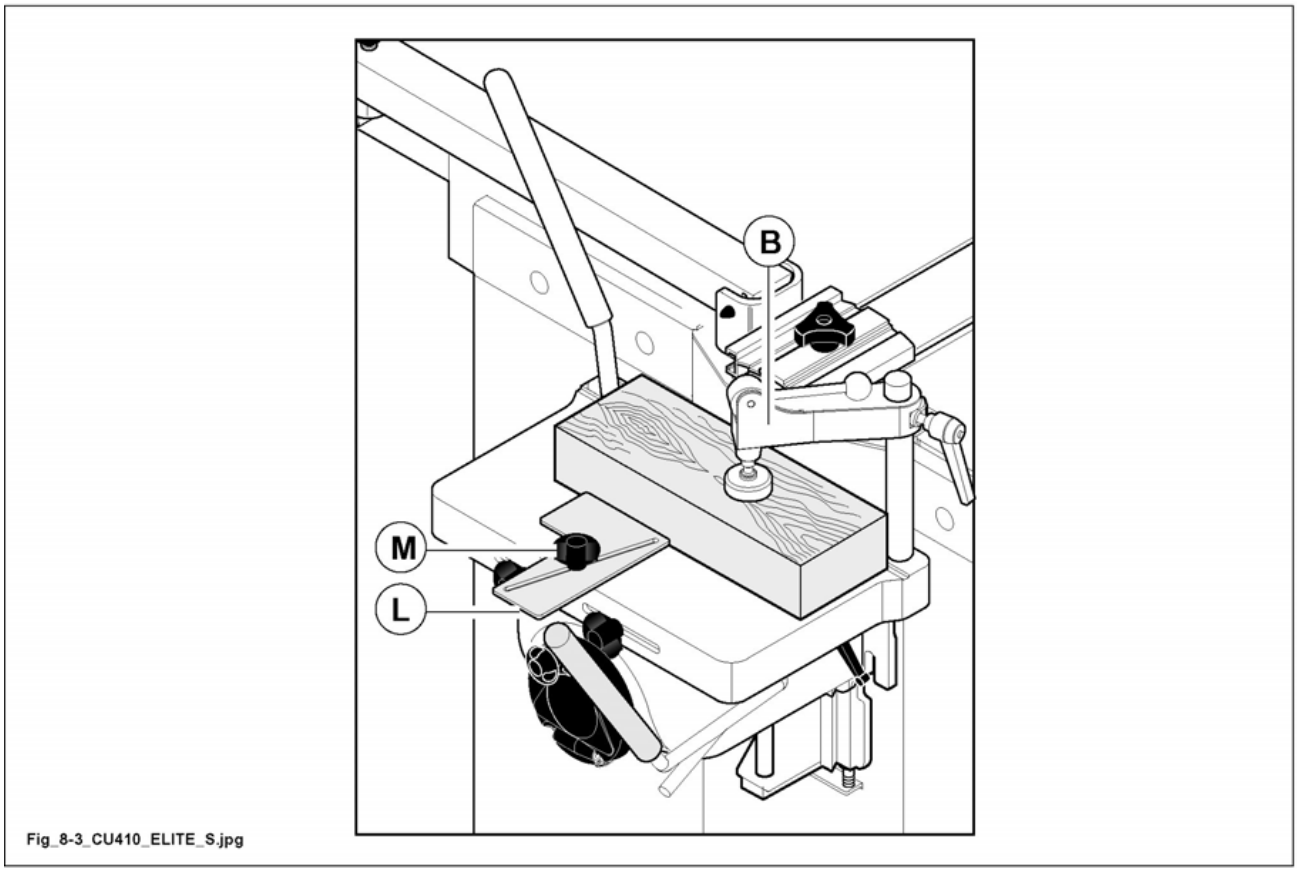


Fig. 8.3

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8.3.1 SLOT DEPTH LIMITATION

(fs_8-3-1_0.0)

In the case of dead holes you have to adjust the stroke of additional table (A fig. 8.3-1) (axis Z):

- try the forward stroke using lever (F fig. 8.3-1) and lock the depth stop by tightening lever (H fig. 8.3-1).

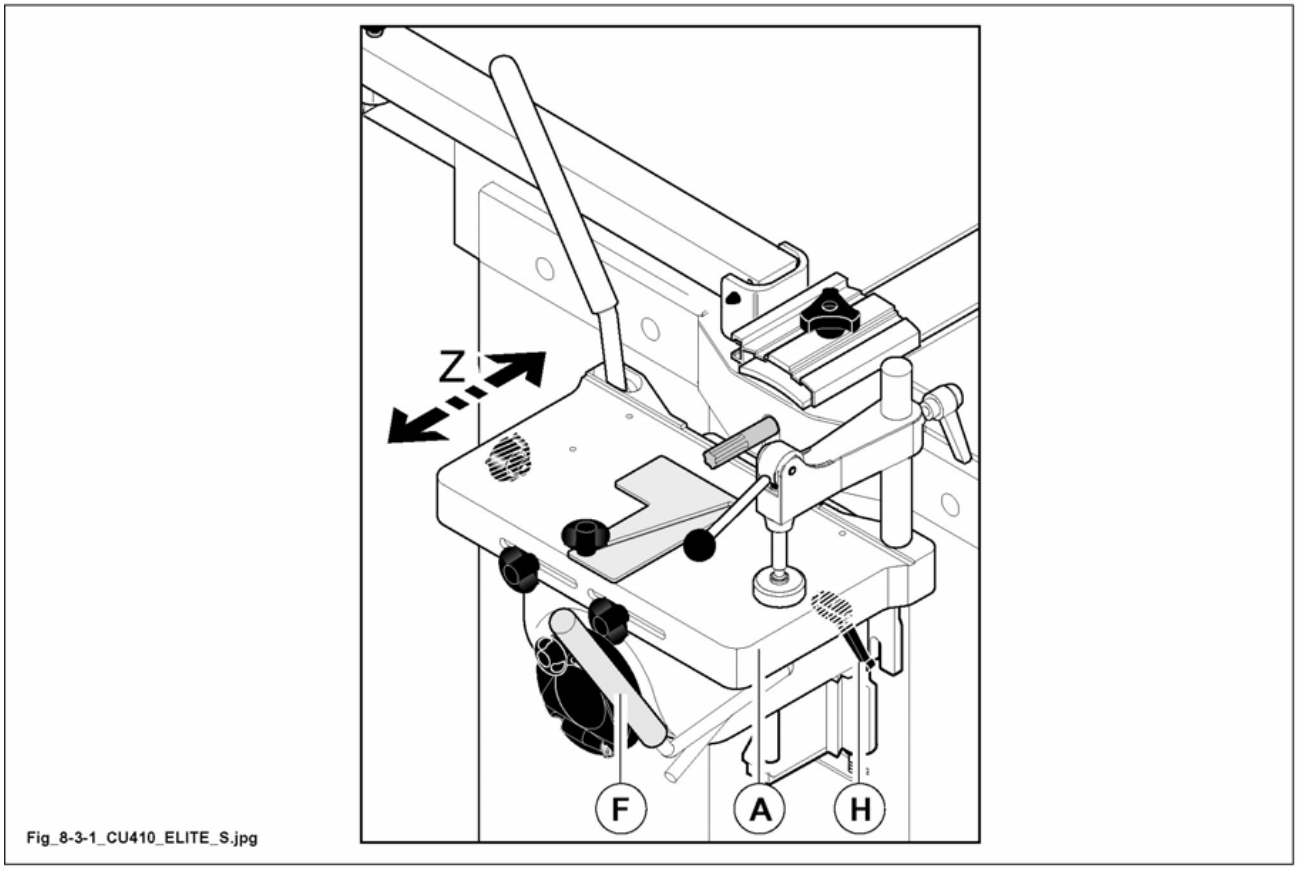


Fig. 8.3-1

8.3.2 SLOT WIDTH LIMITATION

(fs_8-3-2_0.0)

For mortising which does not go through the workpiece, adjust the depth of the stroke, as already indicated, and the transversal stroke of the table (X-axis):

- using a pencil, mark the position of the mortise to be cut on the workpiece (1 fig. 8.3-2).
- Test the transversal stroke using lever (D fig. 8.3-2) according to the mortise to be cut and adjust the side stops to suit, by tightening the knobs (E fig. 8.3-2).

NOTE-INFORMATION:
to carry out slots, it is necessary to drill a row of holes, then, moving the table by means of the lever (D fig. 8.3-2), the inside of the slot is thoroughly cleaned.

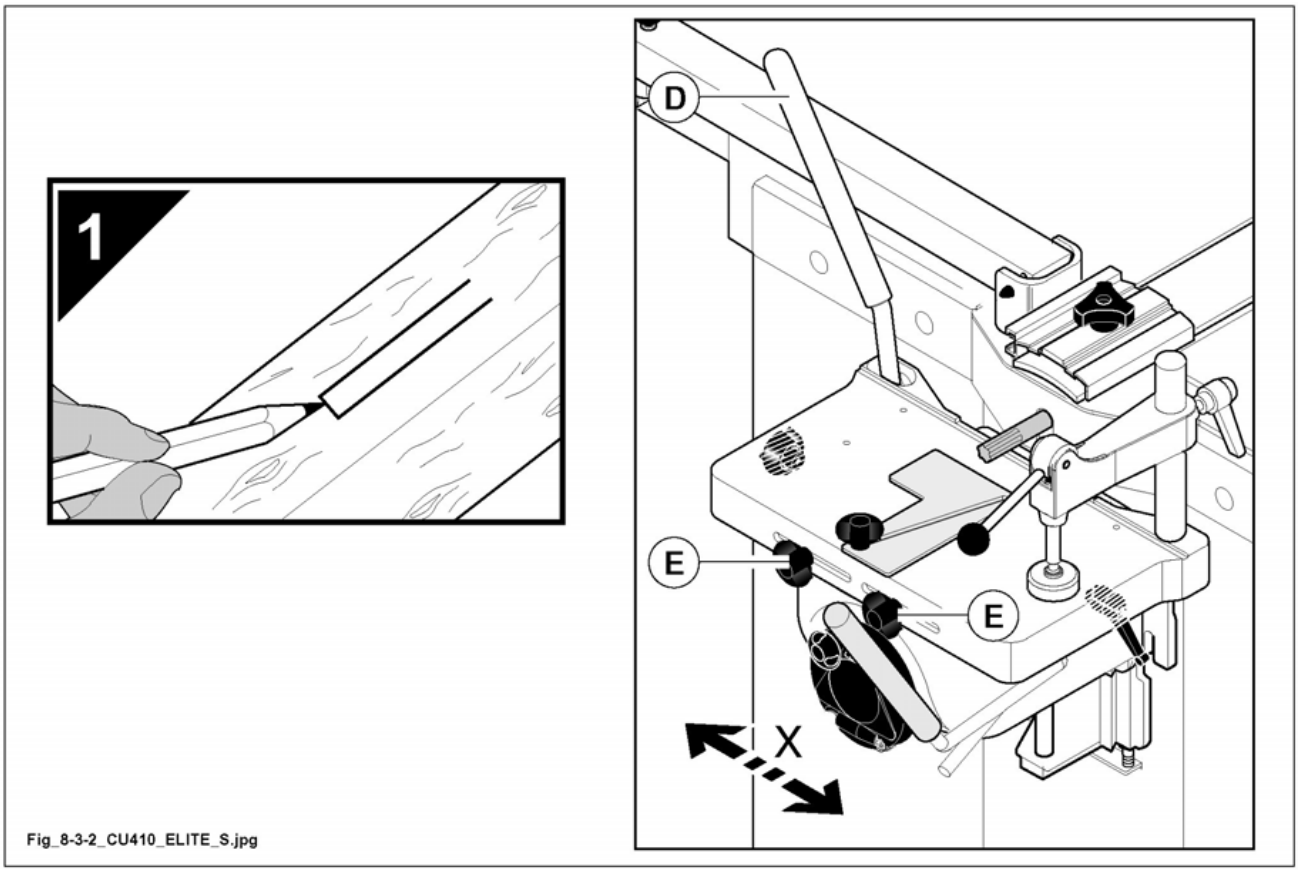


Fig. 8.3-2

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8.3.3 HEIGHT ADJUSTING

(fs_8-3-3_0.0)

- Position the table at the correct height using the accessory handwheel (C fig. 8.3-3); lock it in position by tightening the knob (G fig. 8.3-3).

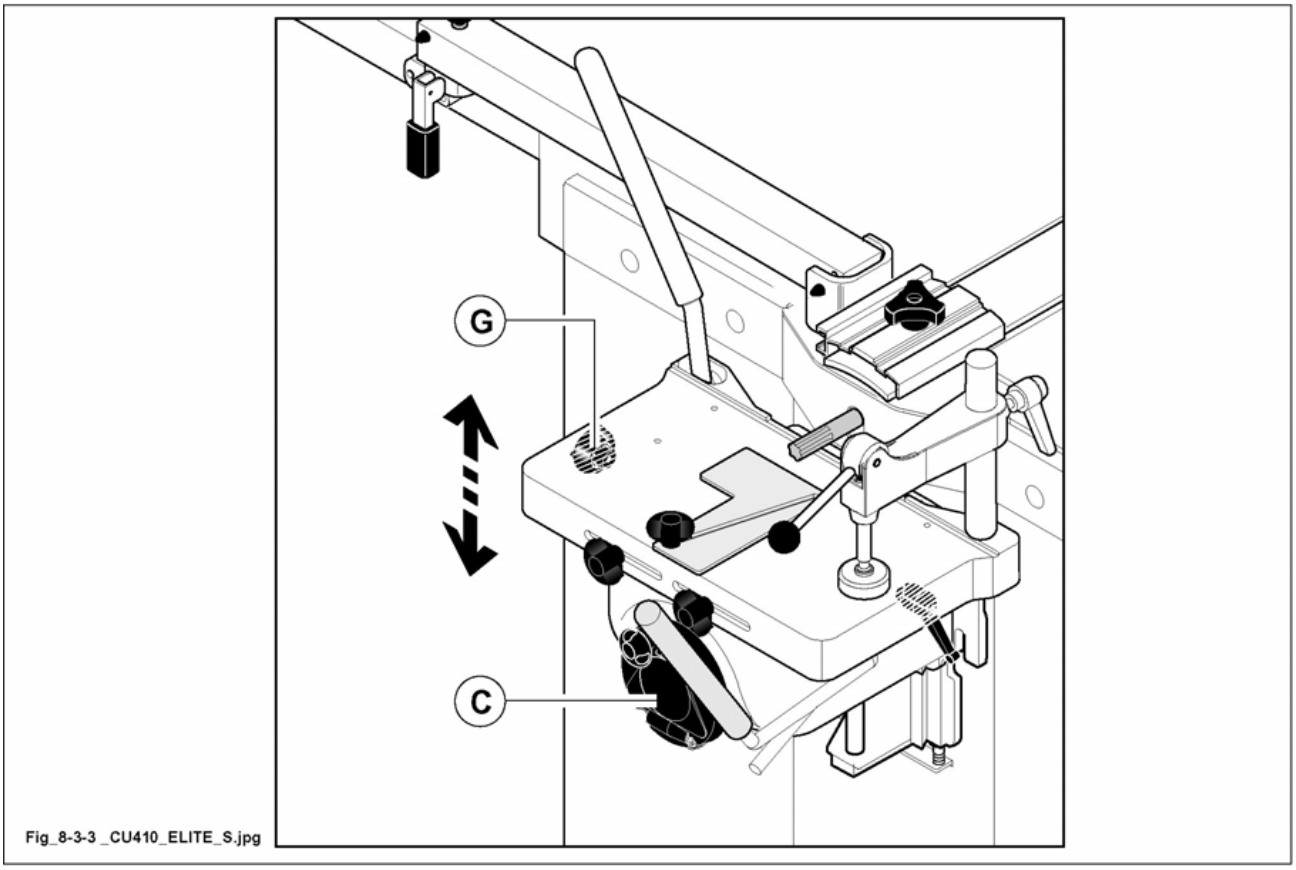


Fig. 8.3-3

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9.1 PRELIMINARY ADJUSTMENT FOR PASSING FROM PLANING TO THICKNESSING

(fs_9-1-0.0)

9.1.1 MACHINE WITH MANUAL TABLE LIFTING

(fs_9-1-1_0.0)

DANGER-WARNING
remove the planing fence unit (A fig. 9.1-1) from the table.

- Stop cutterblock motor.
- Wait for a few seconds until the cutterblock stops completely.
- Slacken the lever (B fig. 9.1-1); pull the lever (B fig. 9.1-1) towards the outside (position 3) and contemporaneously lift the planing tables by using the handle (G fig. 9.1-1);
  (the opening of the tables activates a microswitch that stops the machine from switching on).

CAUTION:
check that the block (N fig. 9.1-1) of the table opening is correctly positioned.

- Turn the chip conveyor protection guard (F fig. 9.1-1) upside down securing it by the spring (M fig. 9.1-1) (the rotation of the protection guard reacts again on the micro-switch, reactivating the machine).

NOTE-INFORMATION:
thicknessing can only be carried out if the safety guard (F fig. 9.1-1) is in position.
This position is checked by an electro-mechanical limit switch.

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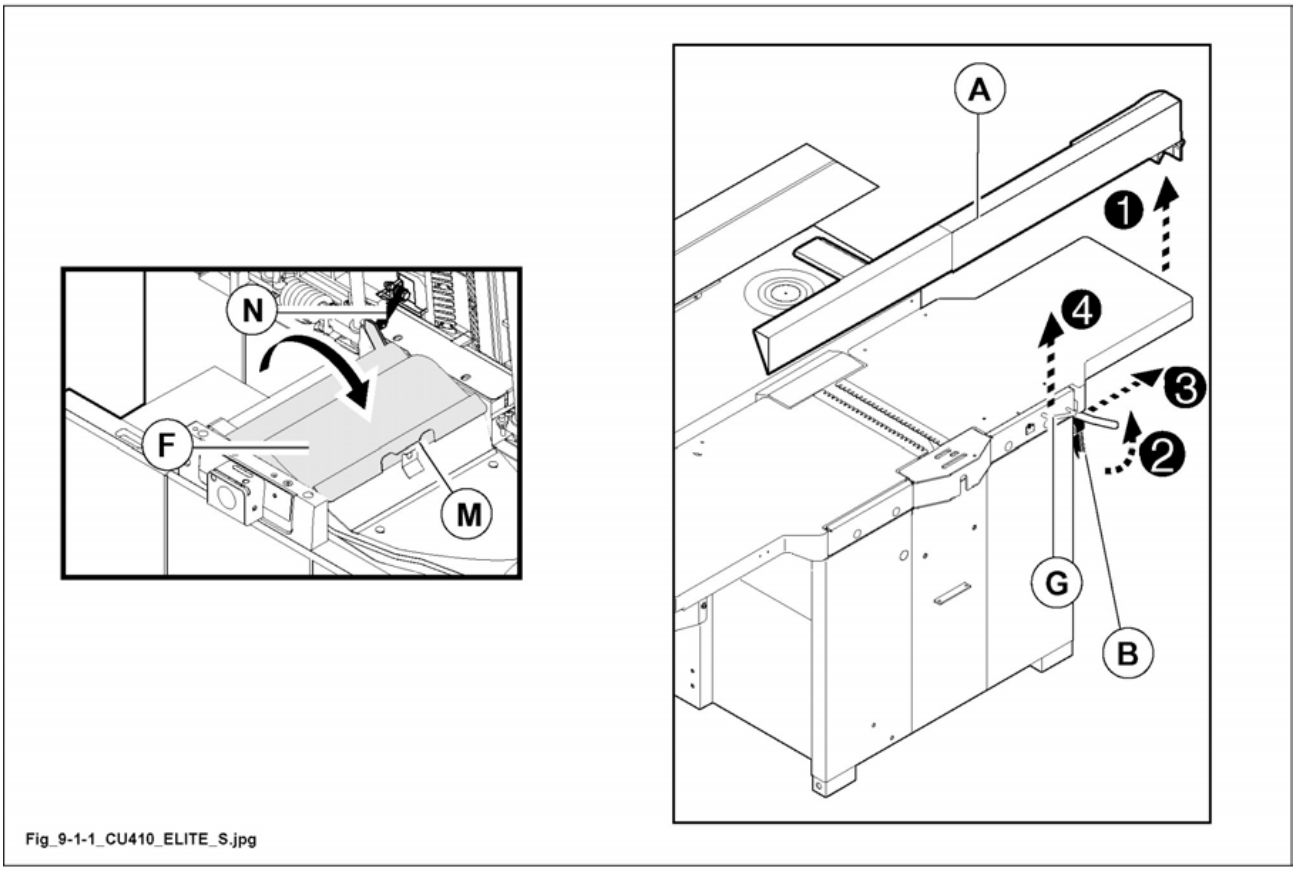


Fig. 9.1-1

9.2 ADJUSTMENT TO PASS FROM THICKNESSING TO SURFACE PLANING

(fs_9-2_0.0)

9.2.1 MACHINE WITH MANUAL TABLE LIFTING

(fs_9-2-1_0.0)

When the thicknessing is finished, to use the surfacing unit:

1) Stop planer motor.
2) Wait few seconds for the complete cutterblock stop.

CAUTION:
before lowering the planing tables, remember to open the chip conveyor guard (F fig. 9.2-1) and lower the thicknessing table to the red notch (M fig. 9.2-1) so as not to damage any element and return the lever (L fig. 9.2-1) to the "0" position (deactivation of the feeding rollers).

3) Disengage the block (N fig. 9.2-1) and close the tables.
4) Lower handle (B fig. 9.2-1) to lock tables.

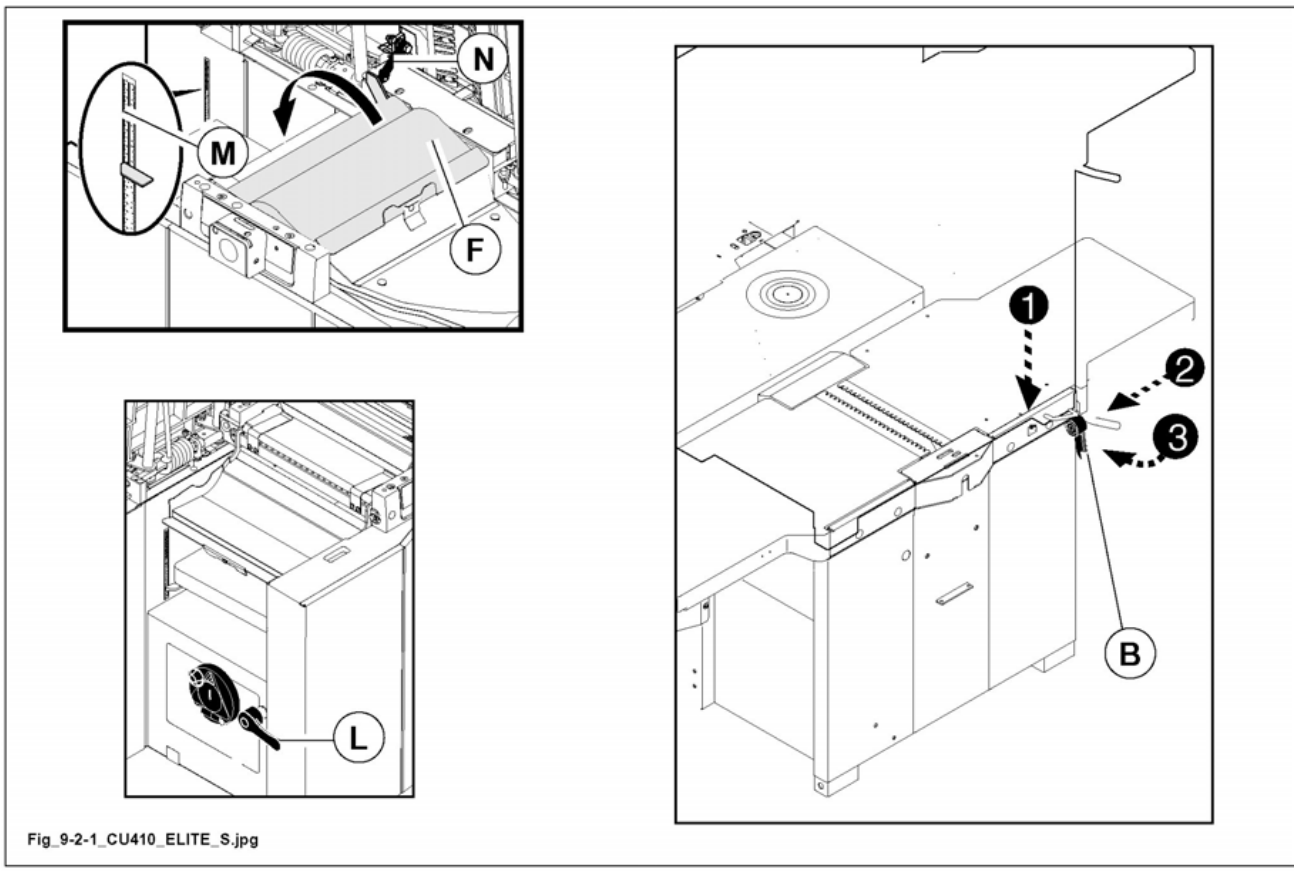


Fig. 9.2-1

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9.4 AUTOMATIC FEED AND SPEED CHANGE

(fs_9-4_0.0)

To switch on the feed turn lever (L fig. 9.5). Carry out this operation with the machine running.
2 speeds are available (6 - 12 m/min); between 2 speeds there is the idle position (feed unit standstill).

NOTE-INFORMATION:
the feed is possible only if the cutterblock is rotating.

DANGER-WARNING
never machine workpiece of length and thickness lower than the values permitted (L = 180 mm; thickness 3,0 mm), as in that case the system, which control the feed and the pressure on the workpiece, can not operate and causes dangerous conditions.

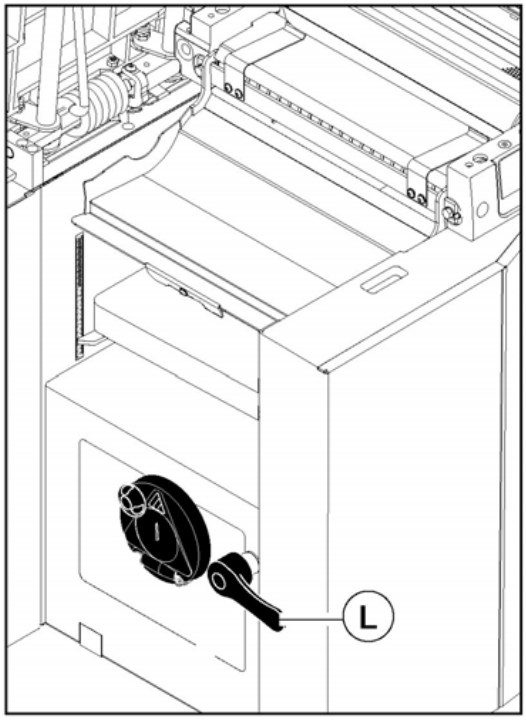


Fig_9-4_FS410_NOVA.jpg

Fig. 9.4

9.5 MANUAL ADJUSTING OF THICKNESSING TABLE

(fs_9-5-0.0)

DANGER-WARNING
Before lifting the thicknessing table make sure that there are no wood residures on the table, as in that case the system, which control the feed and the pressure on the workpiece, can not operate and causes dangerous conditions.

For thicknessing table lifing operate on handwheel (V fig. 9.5) after unlocking knok (P fig. 9.5).

Always reach the working height with table motion upwards to take up slack bewteen lead screws and lead nuts.

Turn the handwheel watching numeric gauge (L fig. 9.5).

After adjusting lock handwheel (V fig. 9.5) by knob (P fig. 9.5).

FORBIDDEN:
it is forbidden to move the table when the machine is running.

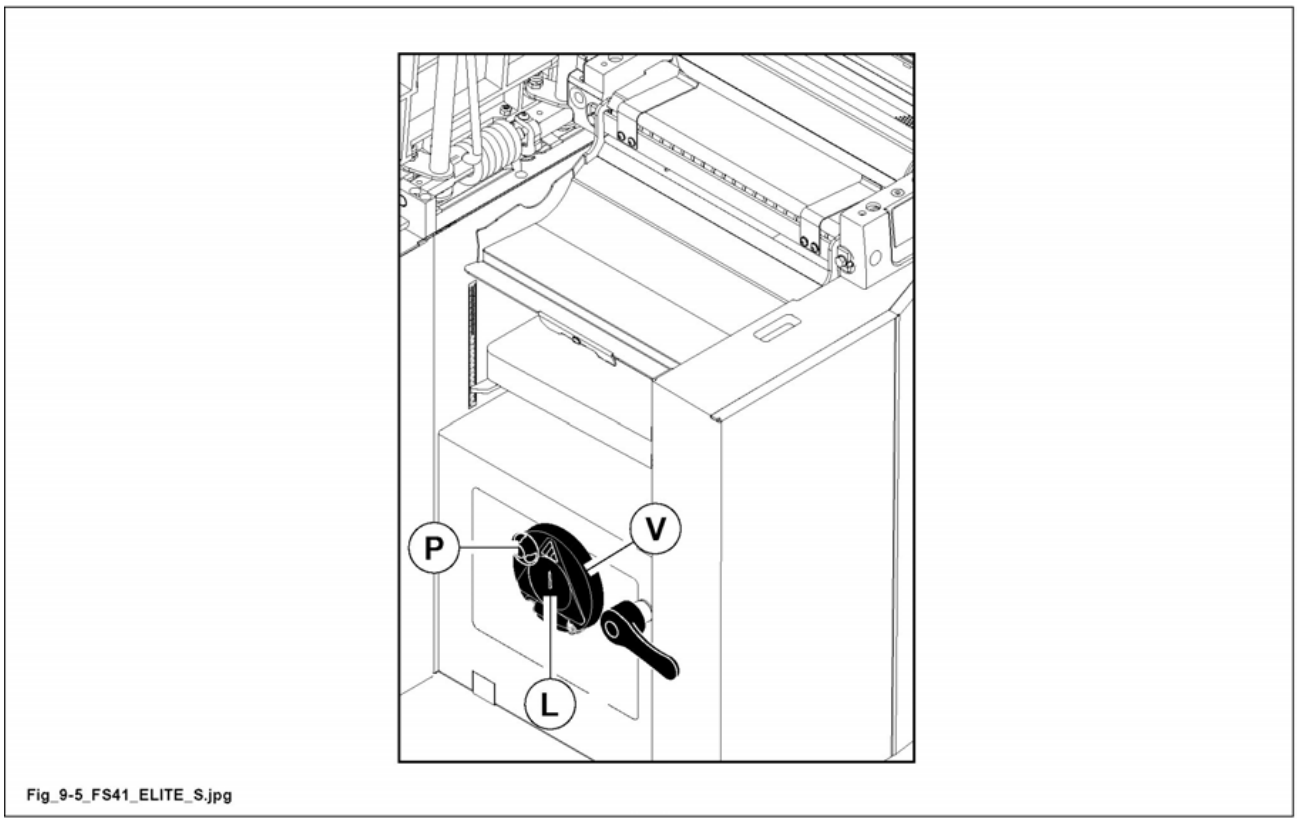


Fig. 9.5

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9.5.1 ADJUSTING STANDARD INDICATOR

(fs_9-5-1_0.0)

If the indicator (L fig. 9.5-1) gives an imprecise indication, restore adjustments as follows:

- unscrew screw (A fig. 9.5-1) and remove indicator.
- Manually rotate indicator until the pointer, which is always in a vertical position, does not coincide with 0° notch.

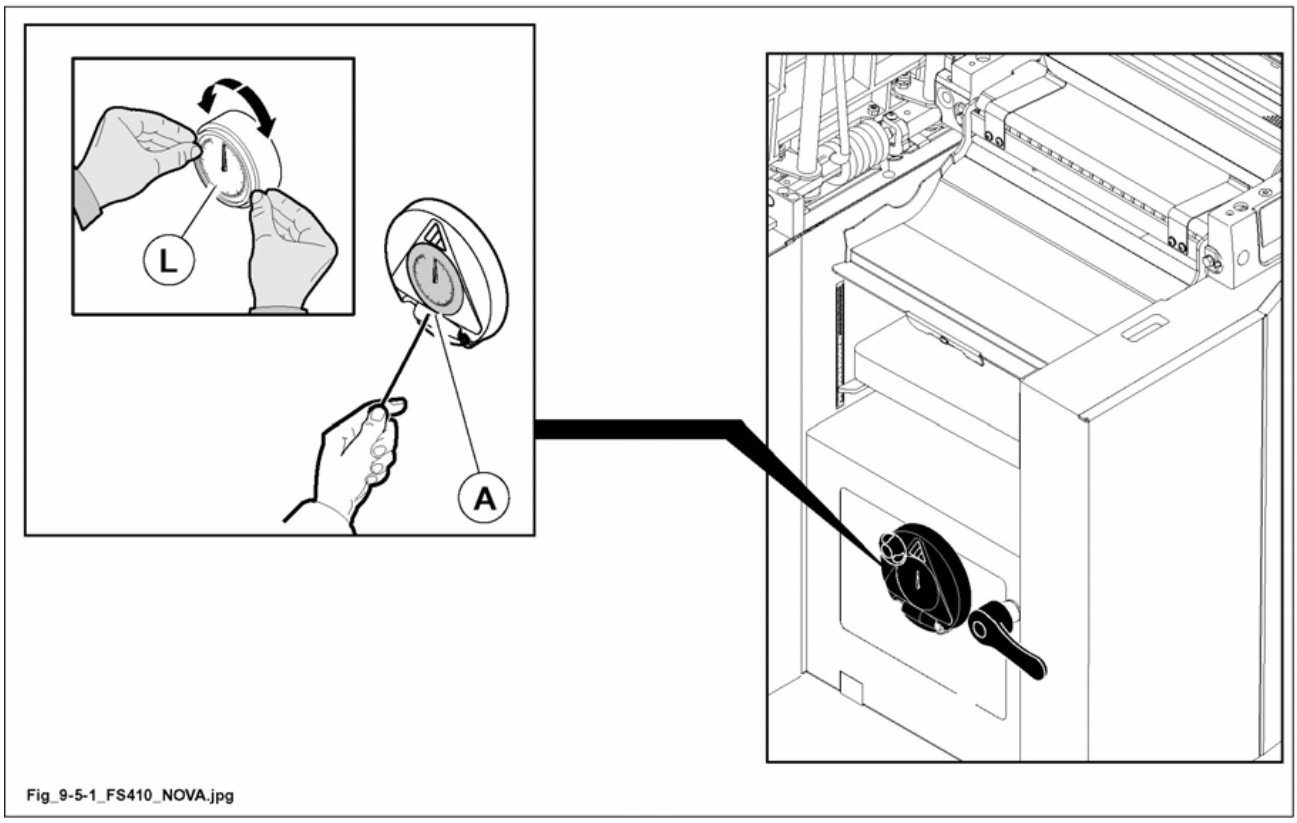


Fig. 9.5-1

9.6 POWER HEIGHT ADJUSTING OF THICKNESSING TABLE

(fs_9-6_0.0)

OPT

DANGER-WARNING
Before lifting the thicknessing table make sure that there are no wood residures on the table, as in that case the system, which control the feed and the pressure on the workpiece, can not operate and causes dangerous conditions.

To lift or to lower the thicknessing table operate on buttons (C-D fig. 9.6).
The table motion is slow for 2 seconds then it gets quicker.
Always reach the working height with table motion upwards to take up slack bewteen lead screws and lead nuts.

The working measure is indicated on display (I fig. 9.6).
With table fully up the min. working height is 3,0 mm corresponding to the min. workpiece thickness.

DANGER-WARNING
if the worktable is locked against the mechanic stops or against the piece owing to a wrong manoeuvre, the pilot lamp (ALARM) (L fig. 9.6) lights up and the motion stops.

Reverse the feed direction by proper button to reset the normal working conditions.
If the measure shown on display (I fig. 9.6) does not correspond to the real measure of the finished workpiece, read the instructions Chapter 16.

DANGER-WARNING
it is forbidden to move the table when the machine is running.

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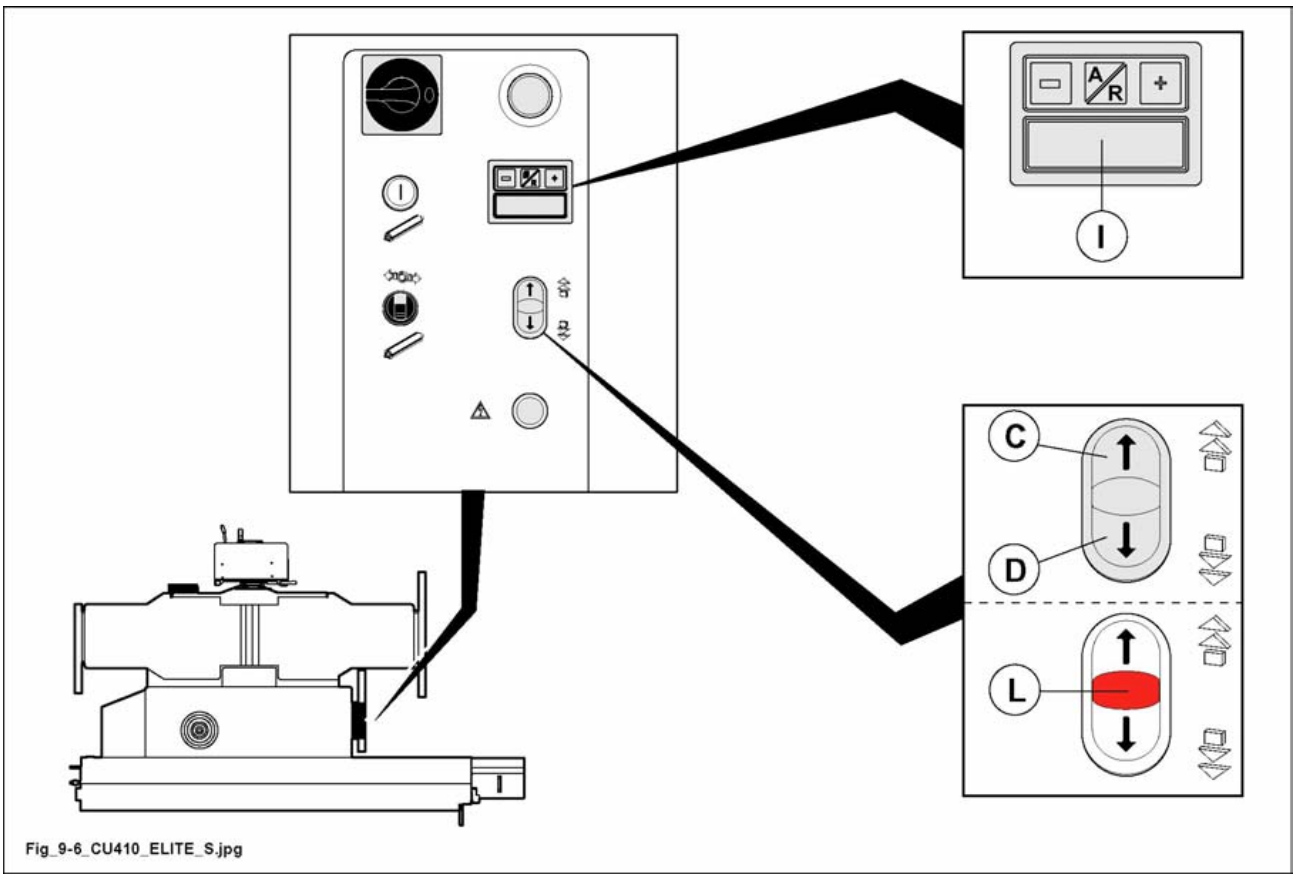


Fig. 9.6

9.8 PRESSURE ROLLERS ADJUSTING

(fs_9-8_0.0)

The spring pressure of the feed rollers is adjusted at factory during the machine test to ensure the right piece feed.
Only in peculiar cases set bushes (E fig.9.8) by means of Allen wrench.
Uniformly adjust the spring pressure of the same roller on both sides.

NOTE-INFORMATION:
pressure should be increased to machine hard wood and/or large sized workpieces.

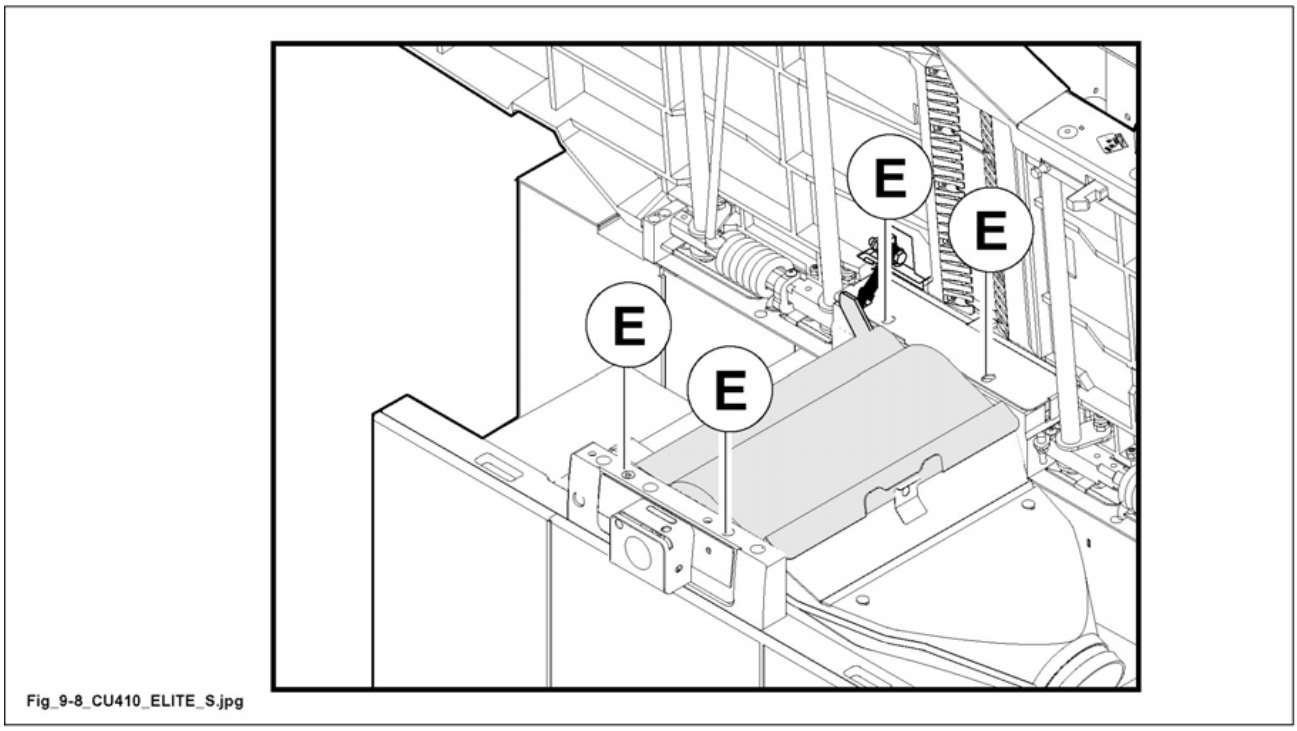


Fig. 9.8

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(fs_vuota_9-01)

9.9 SAFETY GUARDS

(fs_9-9_0.0)

- Anti-kickback fingers (T fig. 9.9) working with pieces of different thickness prevent the workpiece to be thrown back towards the operator, thus providing an effective protection.
- Before starting the working check that the fingers (T fig. 9.9) can rotate smoothly around their support shafts.
- The presence of chips and dust in position corresponding to anti-kickback fingers (T fig. 9.9) can compromise the good machine operation.
- The opening of anti-kickback fingers (T fig. 9.9) can cause the ejection of splints compromising the operator safety.
- To prevent binding or jamming of some fingers (T fig. 9.9), always keep clean them clean by removing the shavings fitted in the fingers.
- Remove resin residues by washing the unit with a brush and terpentine.
  NEVER OIL OR GREASE THE ANTI-KICK BACK FINGERS.
  Thicknessing can only be carried out if the safety guard is in position (A fig. 9.9).

FORBIDDEN:
the machine use is forbidden if these conditions are not ensured.

SAFETY WARNINGS

- Periodically press emergency button to verify the efficiency.
- Make sure that the motor brake stops the cutterblock within 10 seconds; otherwise adjust the brake (see Par.20-8).
- DO NOT process wood pieces with clefts, knots etc.
- **DO NOT feed boards with different thickness at the same time.**
- Select the feed speed according to the piece width and the depth of cut.
- Make sure that the feed rollers are free to rise in the right way.
- Never stay in front of the machine infeed side during the working and do not try to look inside the machine; there is the danger that the splinters are ejected.
- Never put your hands inside the machine to remove chips or splinters when the machine is running.
- **When a workpiece is locked in the machine, stop the cutterblock, lower the table, take off the piece.**
- DO NOT try to carry out depth of cut larger than the one specified.
- It is forbidden to move the table when the machine is running.
- **DO NOT workpieces of too large thickness or lower than 3.0 mm**
- **DO NOT workpieces of length lower than 180 mm**

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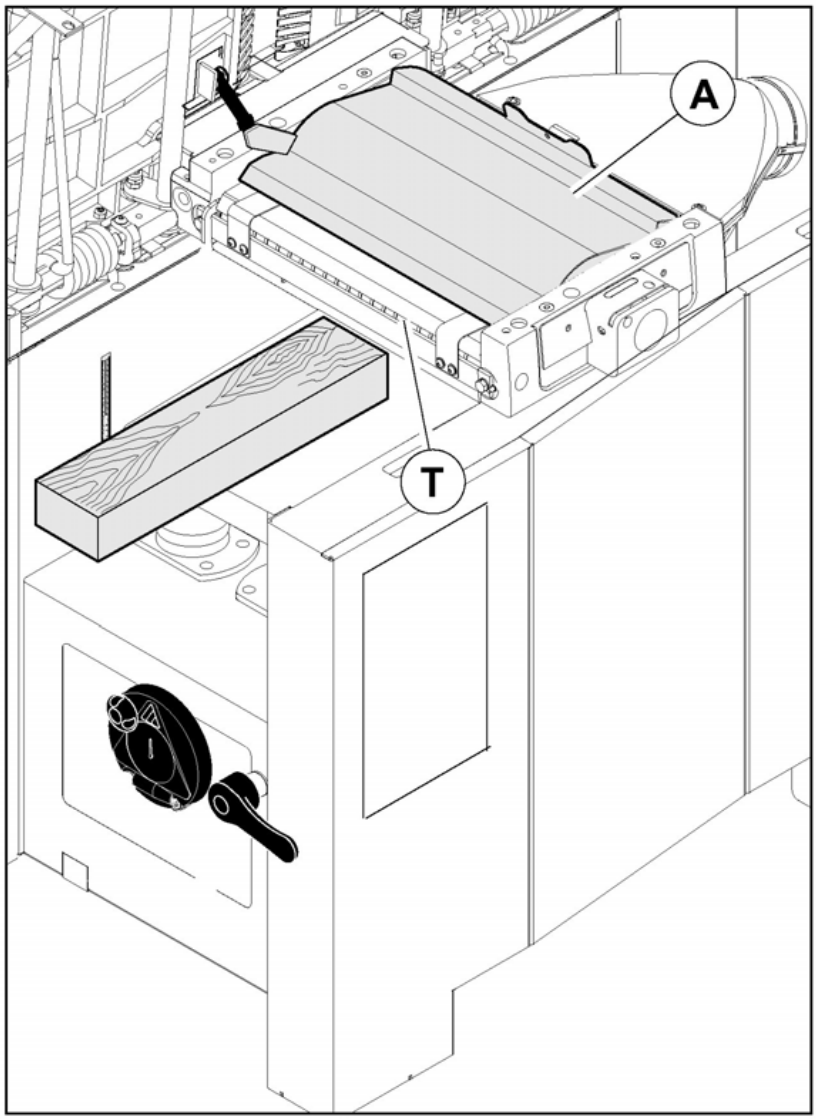


Fig_9-9_FS410_NOVA.jpg

Fig. 9.9

9.10 KNIFE ADJUSTMENT

(fs_9-10_0.0)

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

For adjusting the knife projection see Chapter 7a.

9.11 KNIFE REPLACING

(fs_9-11_0.0)

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

For adjusting the knife projection see Chapter 7a.

9.12 REPLACING THE THROW-AWAY KNIVES

(fs_9-12_0.0)

OPT

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

DANGER-WARNING
do not start planer spindle motor when knives are not fitted.

For adjusting the knife projection see Chapter 7a.

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9.13 LEVELLING THE THICKNESSING TABLE

(fs_9-13_0.0)

The manufacturer levels the thicknessing table with the screws (A fig. 9.13).
This work requires specific skill and equipment.

FORBIDDEN:
to avoid losing the levelling adjustment of the thicknessing table, do not touch the screws (A fig. 9.13) for any reason.

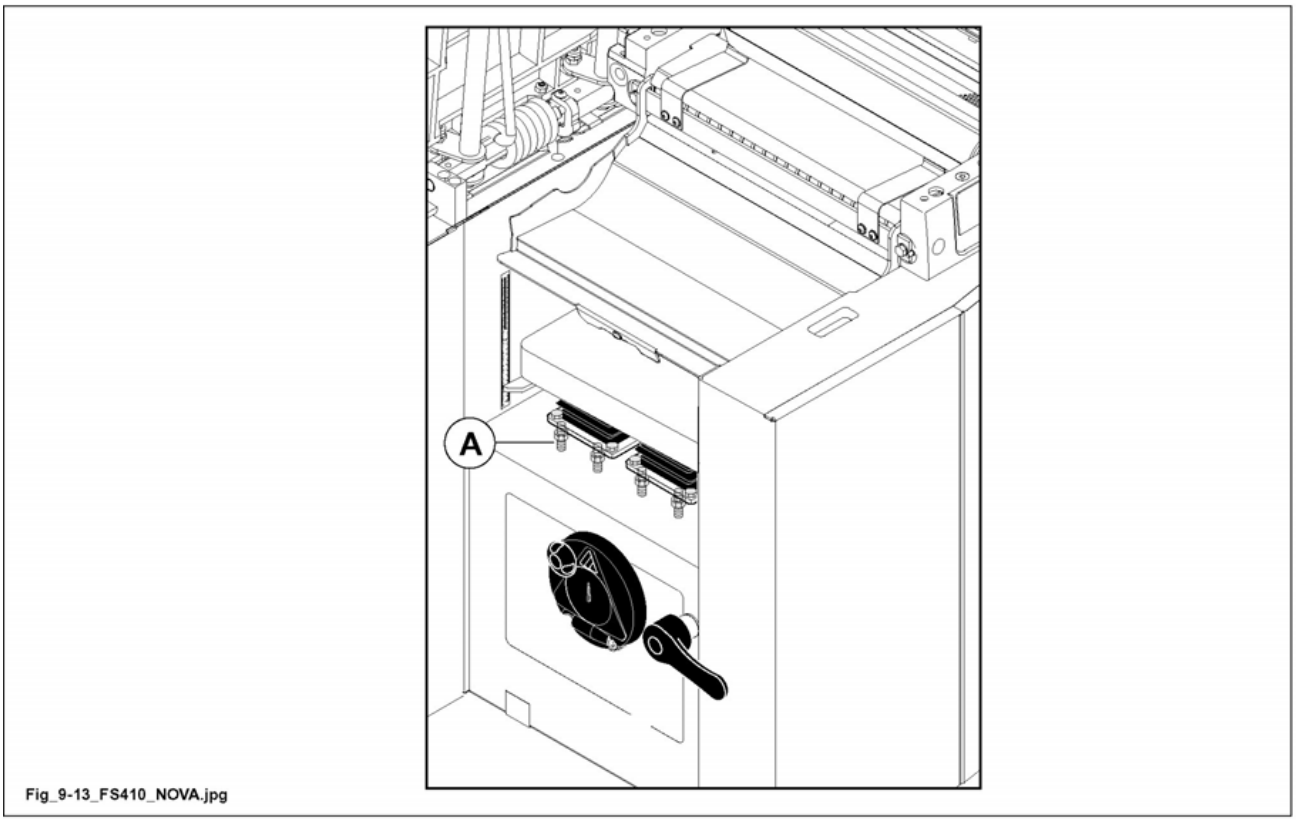


Fig. 9.13

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(st-9a)

9A.1 ADJUSTMENTS

(cu_9a-1_0.0)

DANGER-WARNING:
ensure that during shaft movement there is no interference with machine parts.

9A.1.1 SPINDLE HEIGHT ADJUSTING

(cu_9a-1-1_0.0)

It adjusts the tool to the worktable.

DANGER-WARNING:
the tool adjusting must be carried out with machine off.

9A.1.1.1 SPINDLE HEIGHT ADJUSTING

(cu_9a-1-1-1_0.0)

- The spindle height adjusting occurs by means of handwheel (A fig. 9.1-1-1).
- After any adjusting tighten knob (B fig. 9.1-1-1).
- Read out the height measure on display (I fig. 9.1-1-1).

DANGER-WARNING:
to take up slack you have to reach the right height always with motion upwards.

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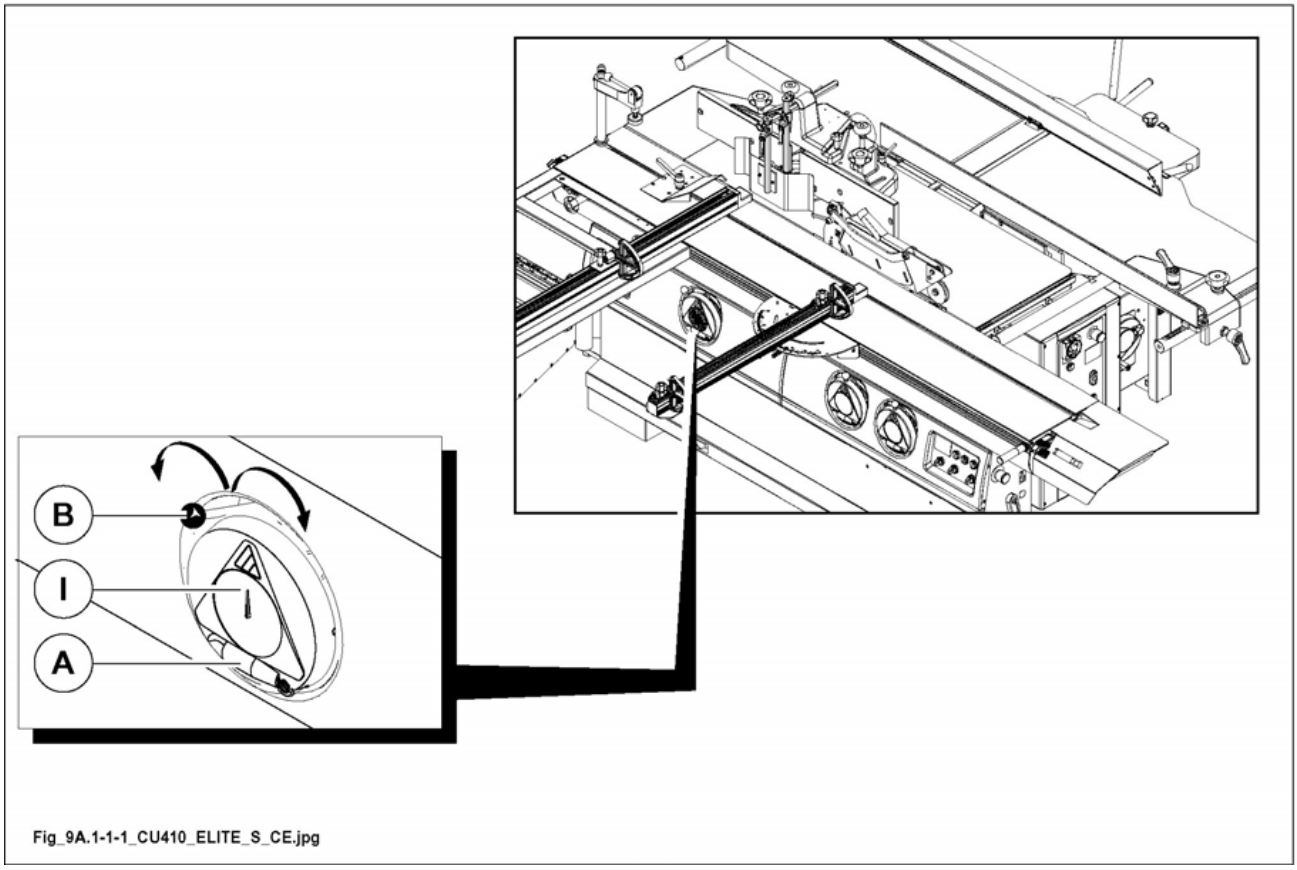


Fig. 9.1-1-1

9A.1.5 MOTORIZED SPINDLE HEIGHT ADJUSTING

(cu_9a-1-5_0.0)

OPT

It adjusts the tool to the worktable.

DANGER-WARNING:
ensure that during shaft movement there is no interference with machine parts.

DANGER-WARNING:
the spindle can only be adjusted with the tool stationary.

9A.1.5.1 MOTORIZED SPINDLE HEIGHT ADJUSTING

(cu_9a-1-5-1_0.0)

OPT

- For versions with electrical lifting, react on the control (M fig. 9.1-5-1) to adjust the height and check the entity of the shifting on the digital indicator (L fig. 9.1-5-1).

DANGER-WARNING:
for greater precision the required spindle position should only be reached on the upstroke, moving over the final stretch at a low speed.

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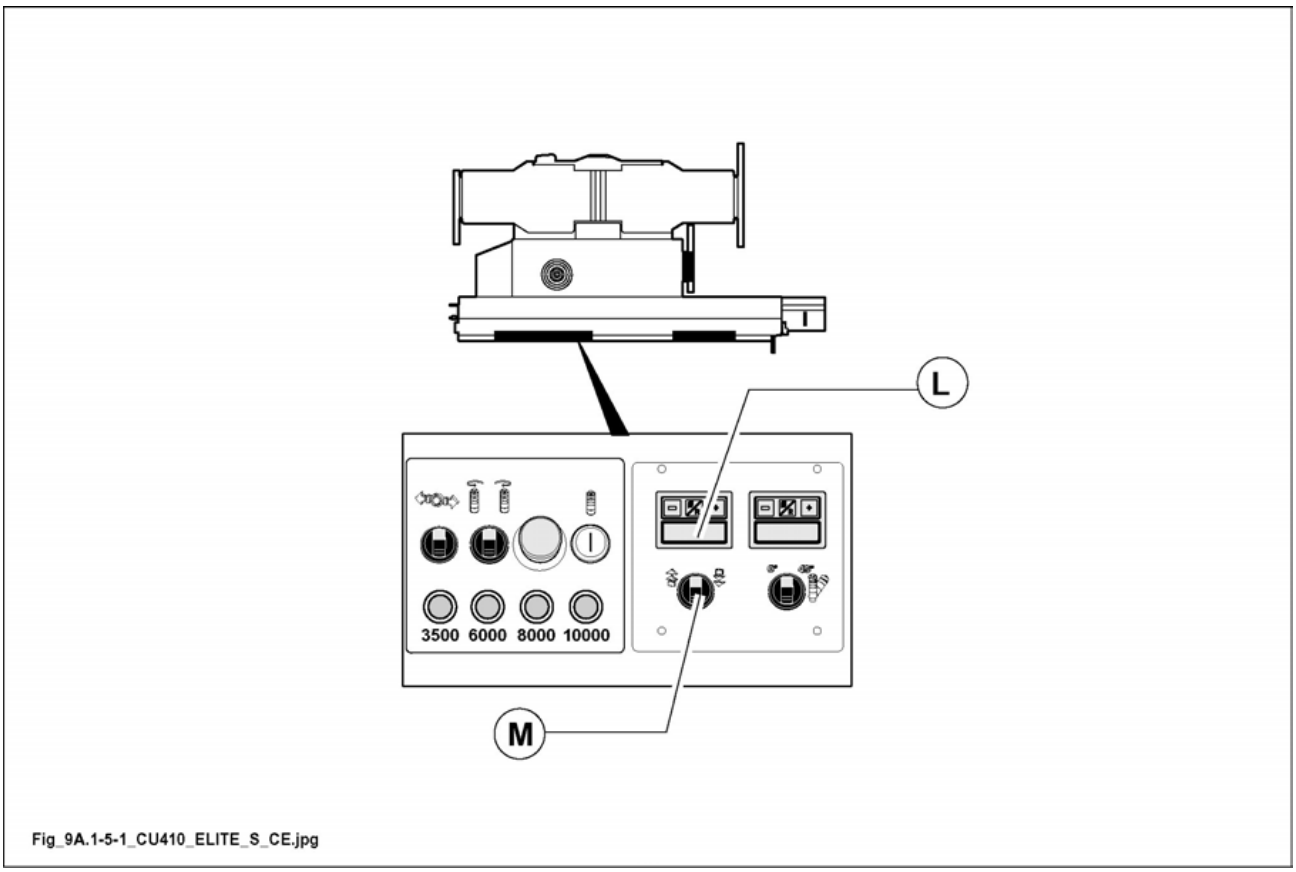


Fig. 9.1-5-1

9A.1.9 SPINDLE TILTING

(cu_9a-1-9_0.0)

OPT

DANGER-WARNING:
tilting is only possible with tools having a maximum diameter of 150 mm.

DANGER-WARNING:
the spindle can only be adjusted with the tool stationary.

DANGER-WARNING:
make sure that during spindle movement there is no interference with parts of the machine.

9A.1.9.1 SPINDLE TILTING

(cu_9a-1-9-1_0.0)

OPT

- Turn handwheel (C fig. 9.1-9-1) after loosening knob (Dfig. 9.1-9-1).
- After any adjustment, tighten knob (D fig. 9.1-9-1).
- Read out the measure on display (I fig. 9.1-9-1).

NOTE-INFORMATION:
the angle shown on the number indicator (I fig. 9.1-9-1) has a ± 0.25 mm error range; in the 45° and 90° positions, for a more precise reading use the mechanical end of stroke stops as a reference, turning the handwheel (C fig. 9.1-9-1) as far as possible.

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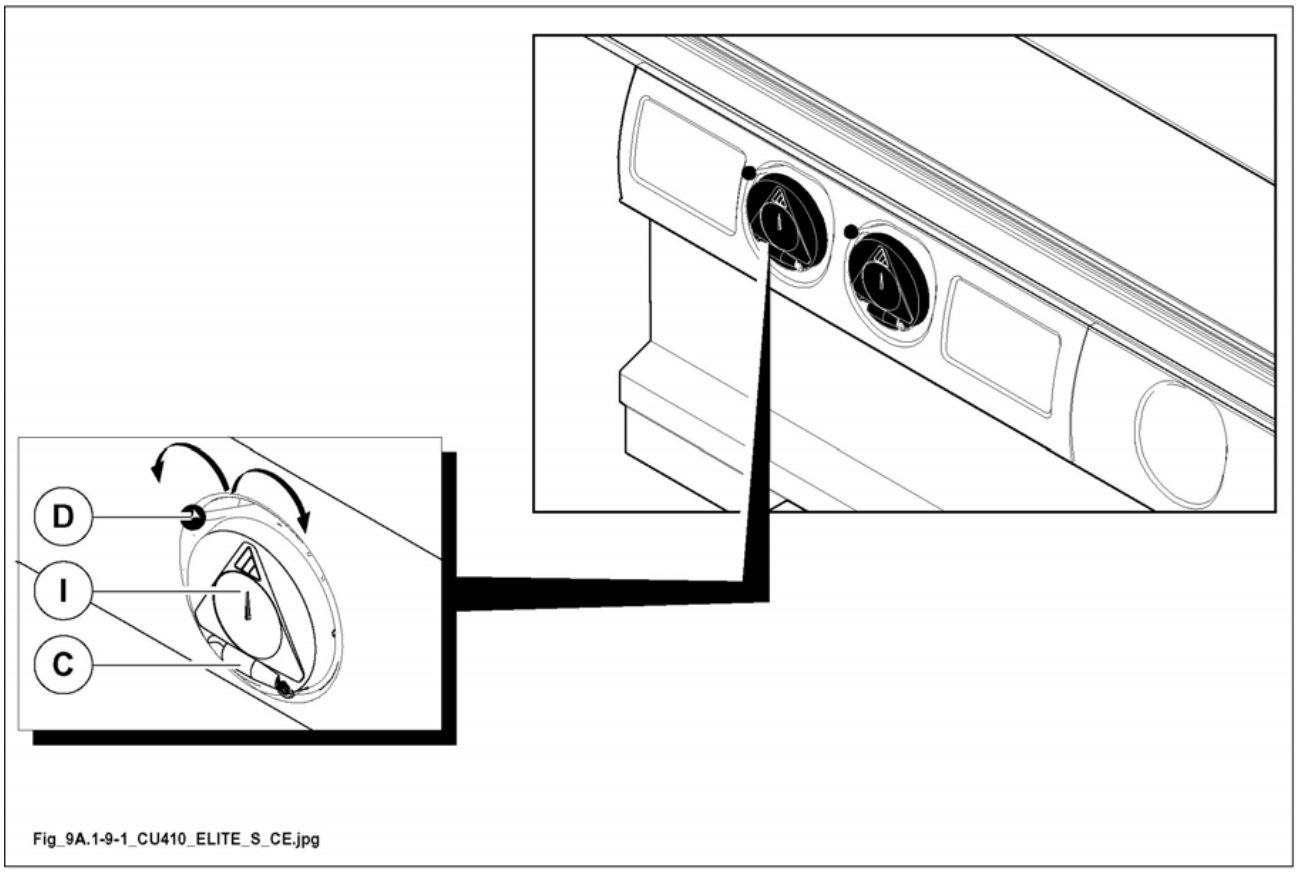


Fig. 9.1-9-1

9A.1.9.2 ELECTRICAL SPINDLE MOULDER ANGLE ADJUSTING

(cu_9a-1-9-2_0.0)

OPT

- For versions with electrical tilting, react on the control (M fig. 9.1-9-2) to adjust the angle and check the entity of the shifting on the digital indicator (L fig. 9.1-9-2).

DANGER-WARNING:
for greater precision go to "0" starting from negative positions (- sign) and move over the final stretch in jog mode, until the " -" sign disappears.

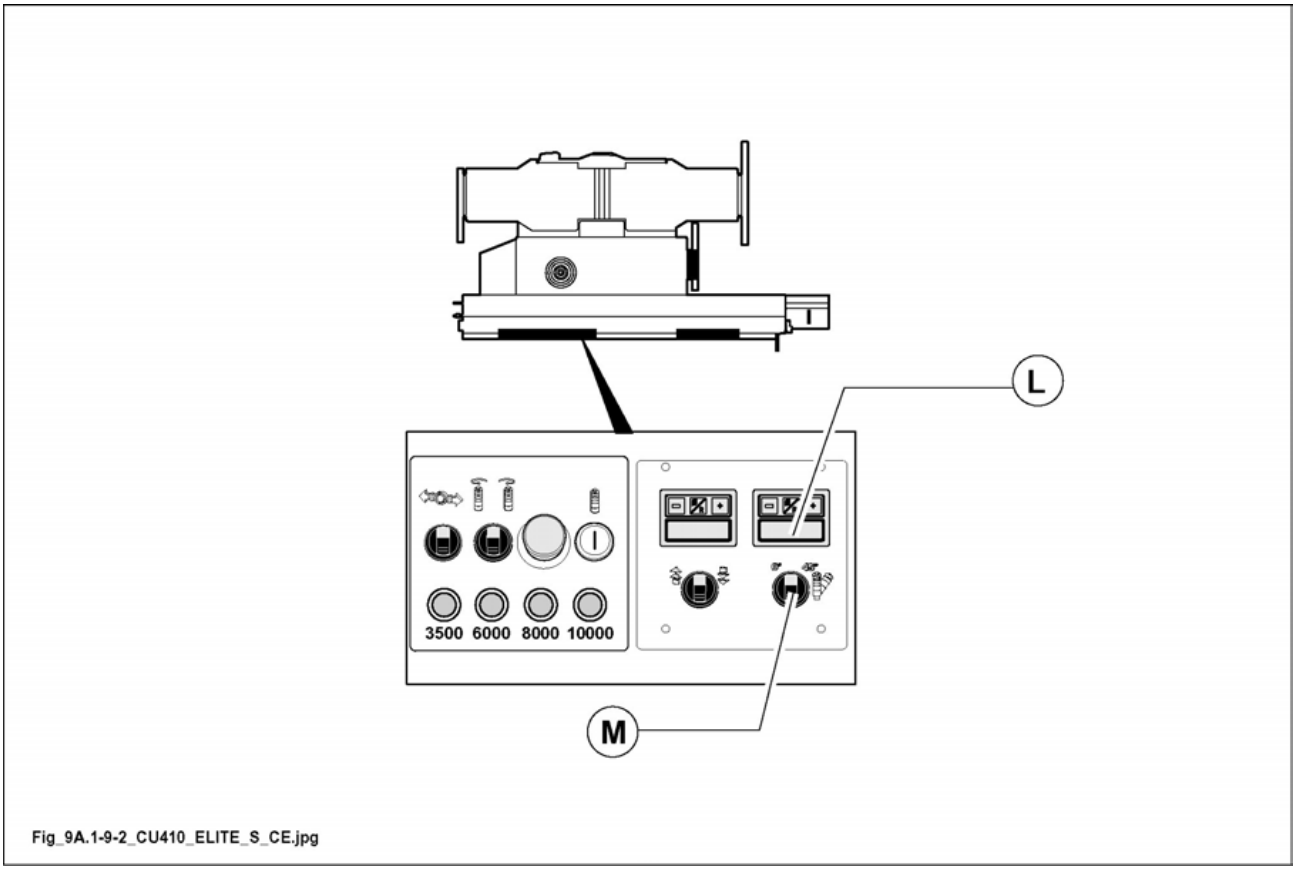


Fig. 9.1-9-2

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9A.3 SPINDLE SPEED SELECTION

(cu_9a-3_0.0)

Select the spindle speed according to the tool, the wood and the working.

Diagram (fig. 9.3A) indicates how to select the speed (rpm) according to the rim speed and the tool diameter tool diameter (with tool Ø 150 mm and surface speed 60 m/s, the speed to be set is 8000 rpm).

DANGER-WARNING:
tenoning must exclusively be carried out with a spindle rotation speed of 3500 rpm.

DANGER-WARNING:
do not select values different from the ones indicated in diagramm (fig. 9.3A), or rotation speed higher than the speed indicated on the tool.
There is the risk of piece kickback or tool rupture.

DANGER-WARNING:
in case of more tools fitted to the spindle, the lowest maximum rotation speed tool is to be considered as a reference. (e.g.: never exceed 6000 rpm, if you use 2 tools, one tool with max. speed 8000 rpm the other tool with max. speed 6000 rpm).

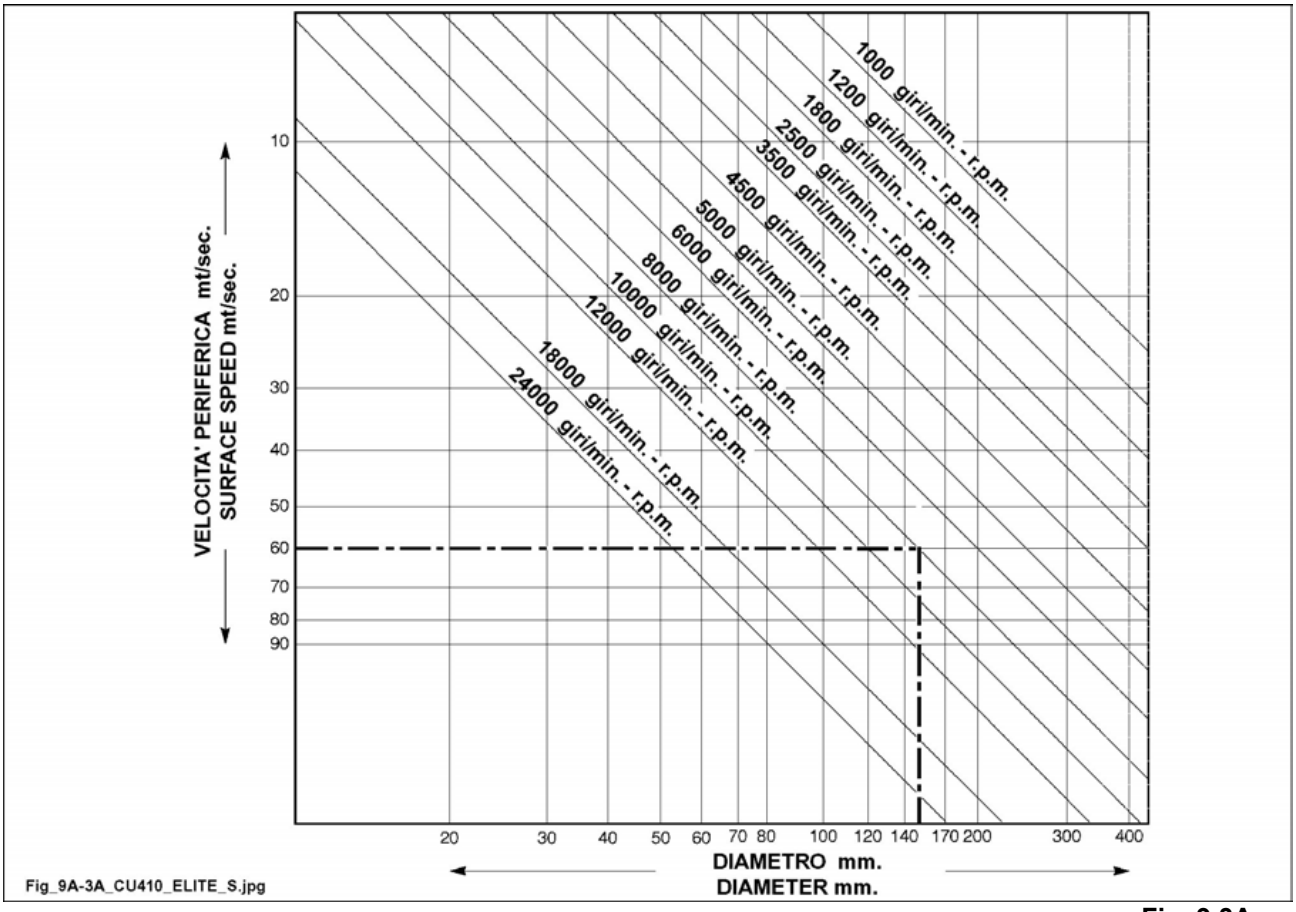


Fig. 9.3A

The table gives the approximate values of the rim speed according to the material to be milled.

MATERIAL	HSS (m/s)	HM (m/s)
Hard wood	50/70	50/70
Soft wood	42/60	45/70
Chipboard		50/70
Fiber board (MDF)		35/50

Diagrams (1, 2, 3 fig. 9.3B) give the speed selection according to:

- the cutter height position (L or L1 fig. 9.3B);
- cutting height (S fig. 9.3B);
- tool cutting edge diameter (Ø fig. 9.3B).

When selecting the diagram, bear in mind that (L fig. 9.3B) refers to the fixed shafts and (L1 fig. 9.3B) to the interchangeable shafts. For cutter height positions different from L or L1, refer to the diagram with the nearest whole number below the true measurement. For example, with a cutter in position L=120 mm refer to the diagram in (1 fig. 9.3B).



DANGER-WARNING:
it is prohibited to exceed the speed obtained from the diagram.

In the diagram (1 fig. 9.3B), with a cutter D=190, S=55 mounted at the upper end of the router shaft (L=125 or L1=90), the maximum operating speed is ~7500 rpm. Set the speed to the nearest whole number below but never above (6000 rpm).

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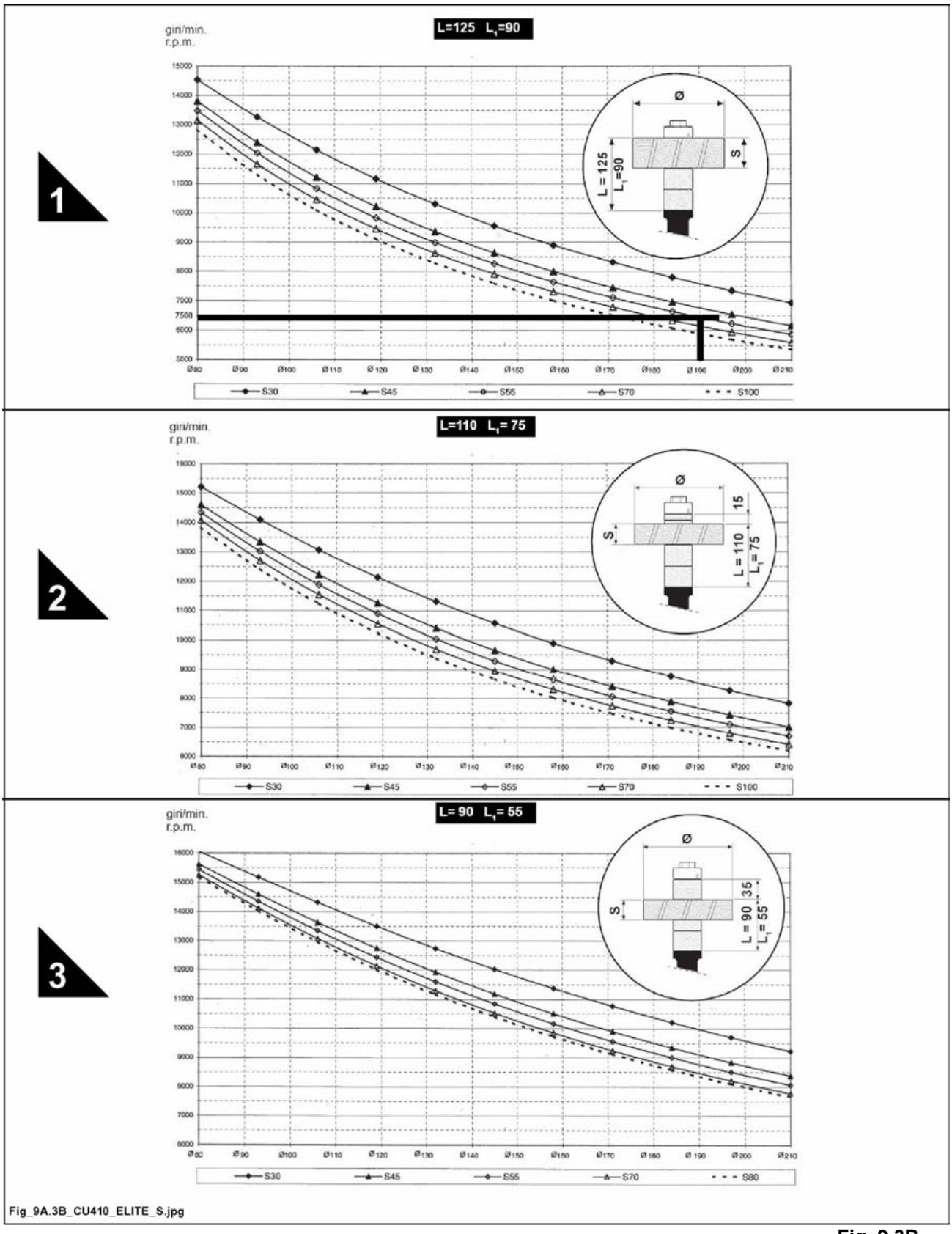

1
giri/min.
r.p.m.
L=125 L1=90
Ø
S
L = 125
L1=90
S30
S45
S55
S70
S100
2
giri/min.
r.p.m.
L=110 L1= 75
Ø
S
15
L = 110
L1= 75
S30
S45
S55
S70
S100
3
giri/min.
r.p.m.
L= 90 L1= 55
Ø
S
35
L = 90
L1= 55
S30
S45
S55
S70
S80
Fig_9A.3B_CU410_ELITE_S.jpg

Fig. 9.3B

(vuota_cu_01)

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9A.3.1 SPEED CHANGE

(cu_9a-3-1_0.0)

The spindle speeds are (50 Hz): 3.500 - 6.000 - 8.000 - 10.000 rpm. - (60 Hz): 4.000 - 7.000 - 9.000 - 12.000 rpm.

Positions and relative speed are given on the plate (B fig. 9.3-1).
To select the speed move the motor belt into the proper race corresponding to the speed desired, proceeding as follows.

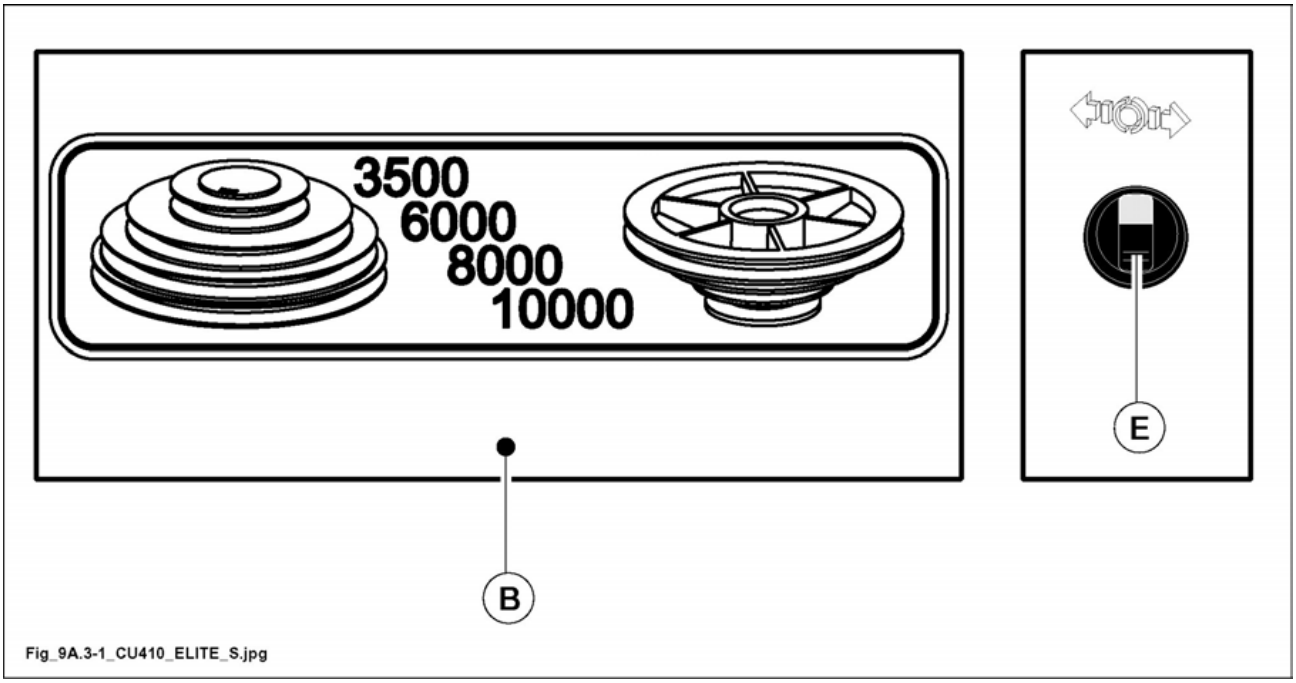


Fig. 9.3-1

DANGER-WARNING:

with selector (E fig. 9.3-1) turned to ( ) (pilot lamp lit) the machine is under safe condition.

Before starting the machine make sure that the rotation speed you have selected is proper for the working, the wood type and for the tool used on the machine.

9A.3.1.1 SPEED CHANGE

(cu_9a-3-1-1_0.0)

1) Press the emergency stop push-button.

2) Release the brake by turning the selector (E fig. 9.3-1-1) to the ( ) position (pilot lamp lit).

3) Open the door (g fig. 9.3-1-1) (activating a limit switch which sets the machine to safety conditions).

4) Pull lever (L fig. 9.3-1-1) into position (2 fig. 9.3-1-1) to slacken the tension of the belts.

5) Rotate selector (M fig. 9.3-1-1) in relation to number of revs you want to set.
On the speed indicator (V fig. 9.3-1-1) the warning light comes on at the selected speed.

NOTE-INFORMATION:
ensure manually that the belt is in the pulley sheaves relative to required rotation speed. If necessary position them correctly.

6) Push lever (L fig. 9.3-1-1) into position (1 fig. 9.3-1-1) to tension the belts.

NOTE-INFORMATION:
push the lever until a click is heard. This means that the dead point has been reached.

7) Tension the belt if necessary (see sec. 20.23).

8) Close the door.

9) Lock the brake by turning the selector (E fig. 9.3-1-1) to the ( ) position.

10) Release the emergency stop push-button.

To view speed, look at the position of the belt on screen (H fig. 9.3-1-1) or using warning lights on panel (V fig. 9.3-1-1).

Positions and speed values are shown on the data plate (B fig. 9.3-1-1).

DANGER-WARNING:

with selector (E fig. 9.3-1-1) turned to ( ) (pilot lamp lit) the machine is under safe condition. Before starting the machine make sure that the rotation speed you have selected is proper for the working, the wood type and for the tool used on the machine.

DANGER-WARNING:
use of tenoner hood Ø 320 mm (OPT) is enabled only at speed of 3500 revs/min - 4000 revs/min (60 Hz). If, with hood fitted, the speed is not set to this number of revs the machine does not start.

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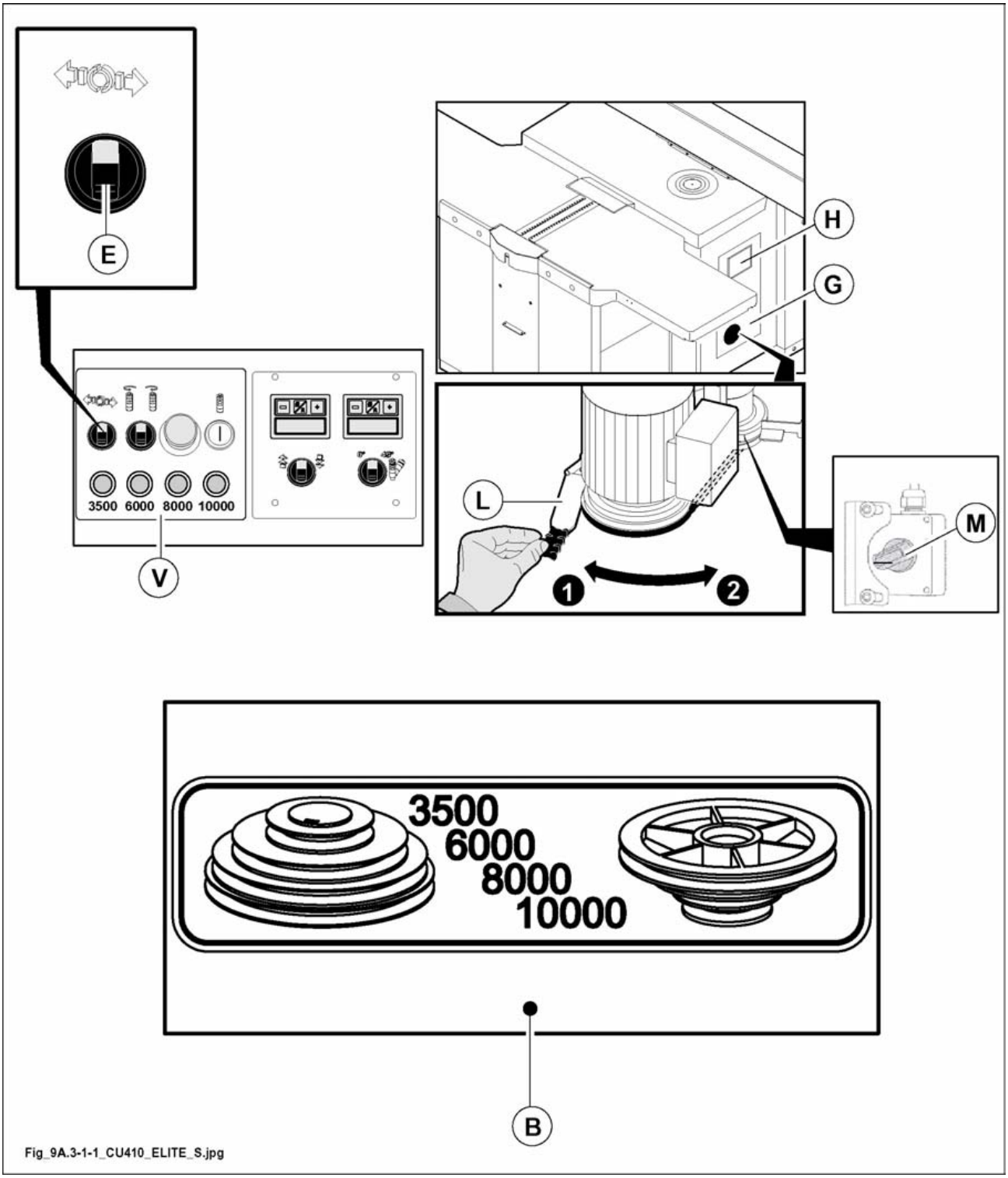

E
H
G
3500 6000 8000 10000
V
L
M
1
2
3500
6000
8000
10000
B
Fig_9A.3-1-1_CU410_ELITE_S.jpg

Fig. 9.3-1-1

9A.6 TELESCOPIC RULE ON TENONING TABLE

(cu_9a-6_0.0)

OPT

NOTE-INFORMATION:
the splinter guard is fixed to the rule with screws (V fig. 9.6).
If the splinter guard becomes worn, move it towards the tool by slackening the securing screws.
If you need to replace it, see Chapter 20.

9A.6.1 RULE ROTATION

(cu_9a-6-1_0.0)

A

1) Loosen the knobs (F fig. 9.6).
2) For use, position the ruler referring to the plate (P fig. 9.6).
3) Tighten the knobs (F fig. 9.6).

9A.6.2 TO MOVE THE RULE UP TO THE TOOL

(cu_9a_6-2_0.0)

B

1) Loosen the knobs (F fig. 9.6).
2) Position the telescopic ruler (R fig. 9.6) at the right distance from the tools (U fig. 9.6).
3) Tighten the knobs (F fig. 9.6).

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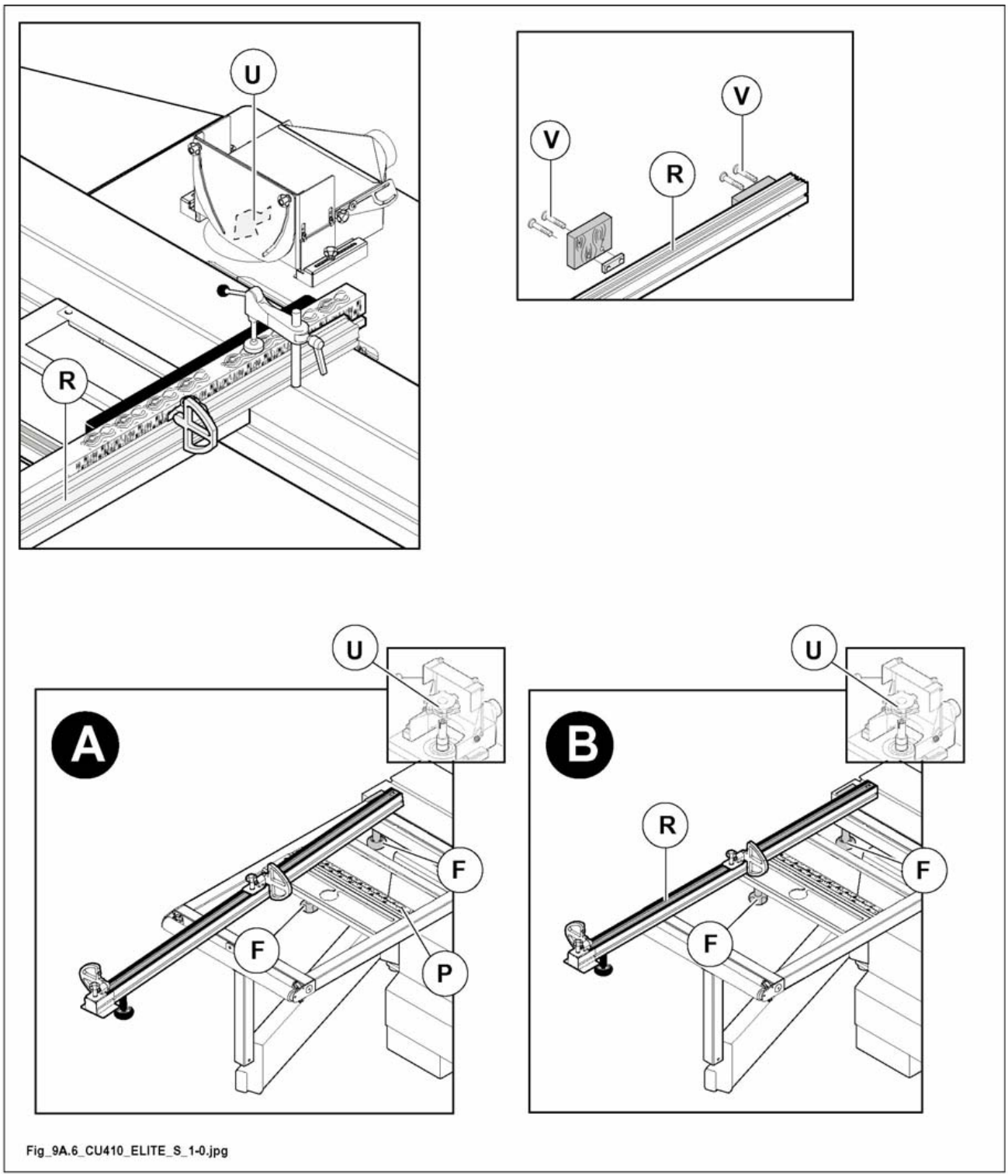


Fig. 9.6

9A.8 USING THE TENONING TABLE

(cu_9a-8_0.0)

OPT

Tenoning is a head milling operation (against the grain) which is carried out to obtain joints between male tenons (A fig. 9.8) and female tenons (B fig. 9.8).
Carry out this operation with sliding table after fitting additional table OPT (O fig. 9.8).

DANGER-WARNING:
tenoning must exclusively be carried out with a spindle rotation speed of 3500 rpm (50 Hz) - 4000 rpm (60 Hz).

For a better assembly:
- *adjust the tenon depth 0,5 mm less than the jamb width (X fig. 9.8);*
- *adjust the slot depth 0,5 mm less than the crosspiece width (Y fig. 9.8).*

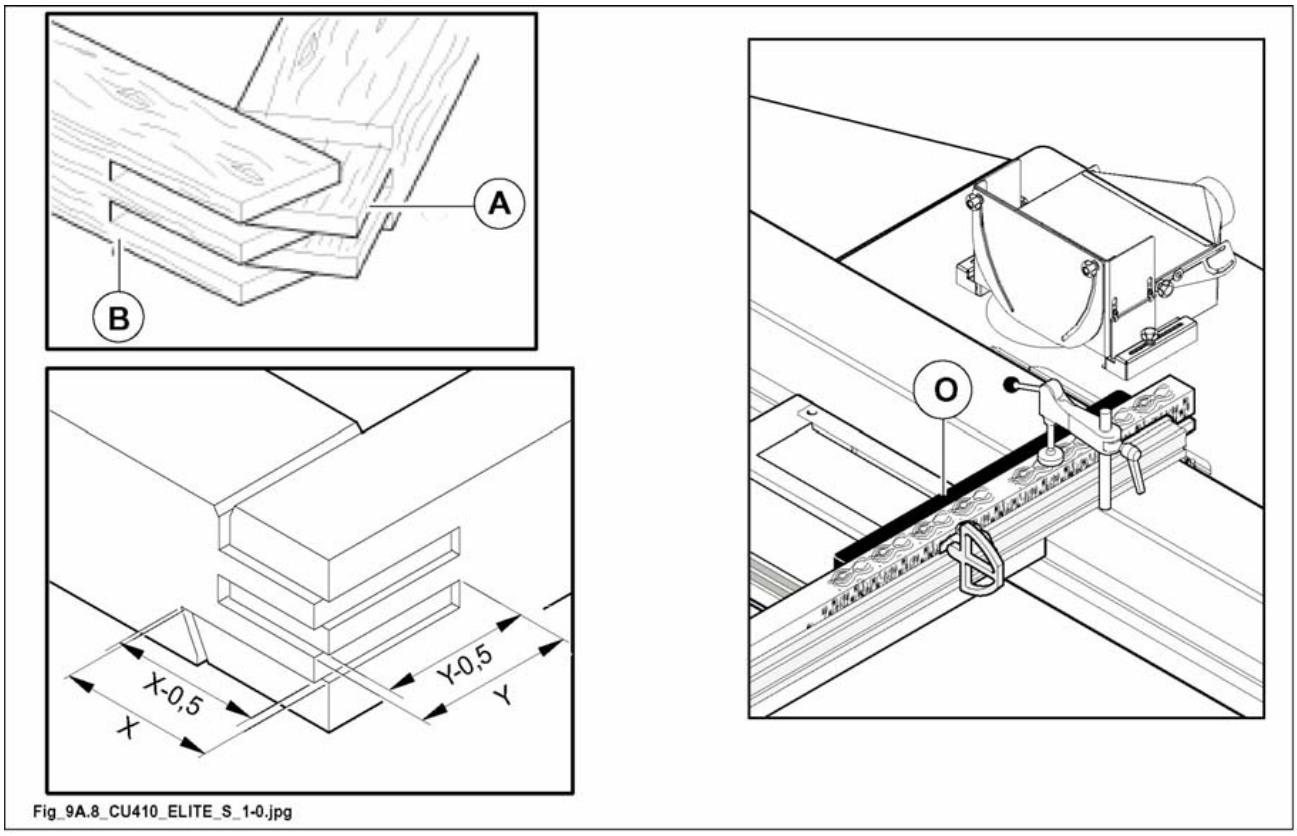


Fig. 9.8

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(vuota_cu_02)

9A.8.1 TENONING

(cu_9a-8-1_0.0)

- Fit the tenoning hood and set it as described in paragraph 9.44.
- Rule (G fig. 9.8-1) is in the right position to get straight tenons when it is against pivot (R fig. 9.8-1).
  To move the rule loosen handles (M fig. 9.8-1).
- Rest the workpiece against rule (G fig. 9.8-1), so that its projection to the tool is larger than the tenoning depth.

DANGER-WARNING:
make sure that no contact between tenoning table and tool is possible.

- Clamp the workpiece with the presser foot (P fig. 9.8-1) by lowering the lever (D fig. 9.8-1).

9A.8.1.1 CLAMPING ARM USE

(cu_9a-8-1-1_0.0)

- For height adjusting loosen handle (C fig. 9.8-1).
- By means of lever (D fig. 9.8-1) lower foot (P fig. 9.8-1) to clamp the piece.

DANGER-WARNING:
always lock the piece using the presser provided.

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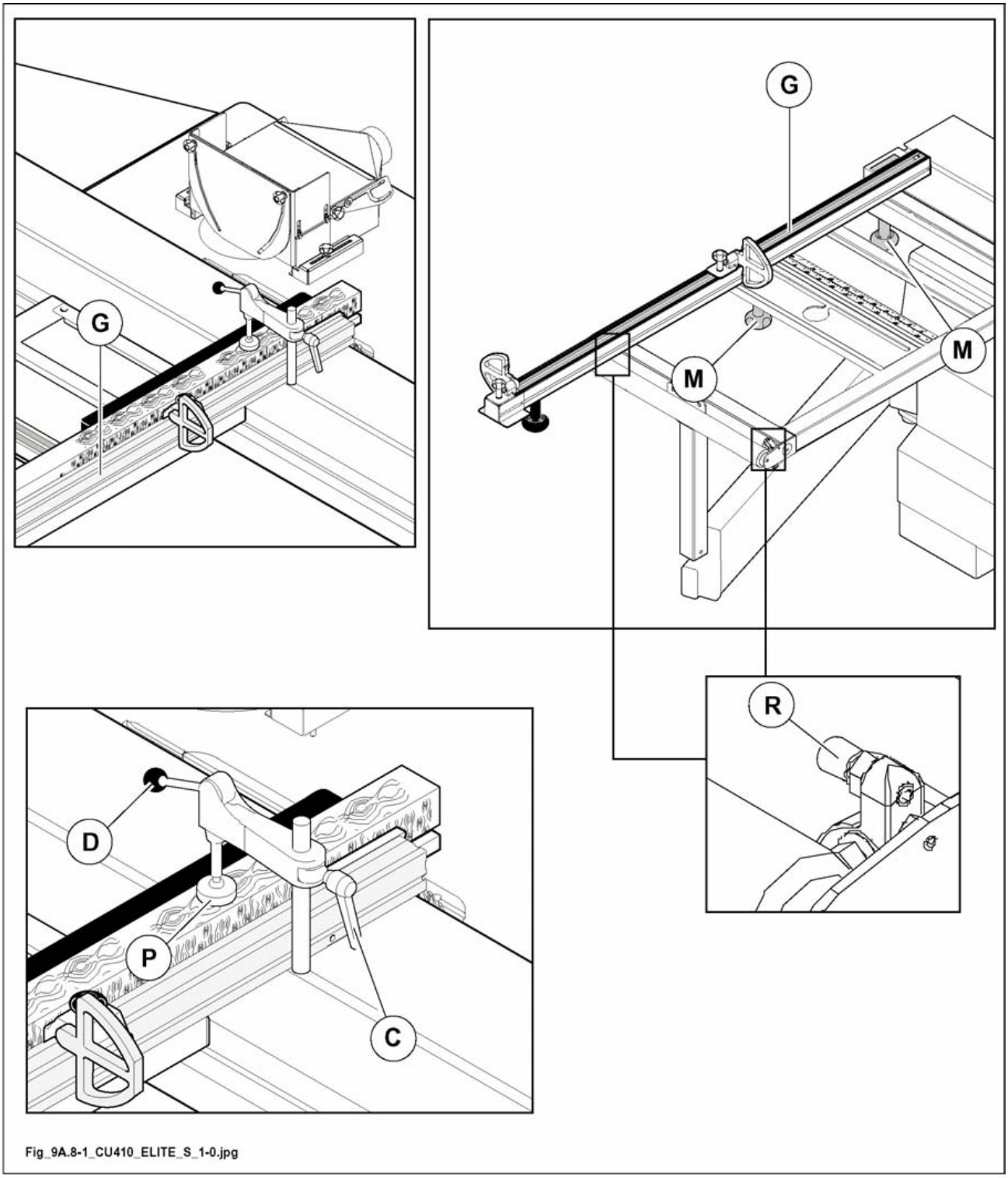


Fig. 9.8-1

9A.8.2 OBLIQUE TENONS

(cu_9a-8-2_0.0)

The working of oblique tenons is quick, because it is sufficient to turn telescopic rest rule (G fig. 9.8-2) clockwise or counterclockwise.

- Loosen the knobs (F fig. 9.8-2).
- Turn the rule to the desired angle clockwise (+ / index 1) or counterclockwise (- / index 2) then read the value directly on scale (T fig. 9.8-2) applied on the table.
- Tighten the knobs (F fig. 9.8-2).

The rule (G fig. 9.8-2) can slide if the two handles are released (F fig. 9.8-2).
This adjustment may be needed to suit the various cutter diameters.

9A.8.2.1 CLAMPING ARM USE

(cu_9a-8-2-1_0.0)

- For height adjusting loosen handle (C fig. 9.8-2).
- By means of lever (D fig. 9.8-2) lower foot (P fig. 9.8-2) to clamp the piece.

DANGER-WARNING:
always lock the piece using the presser provided.

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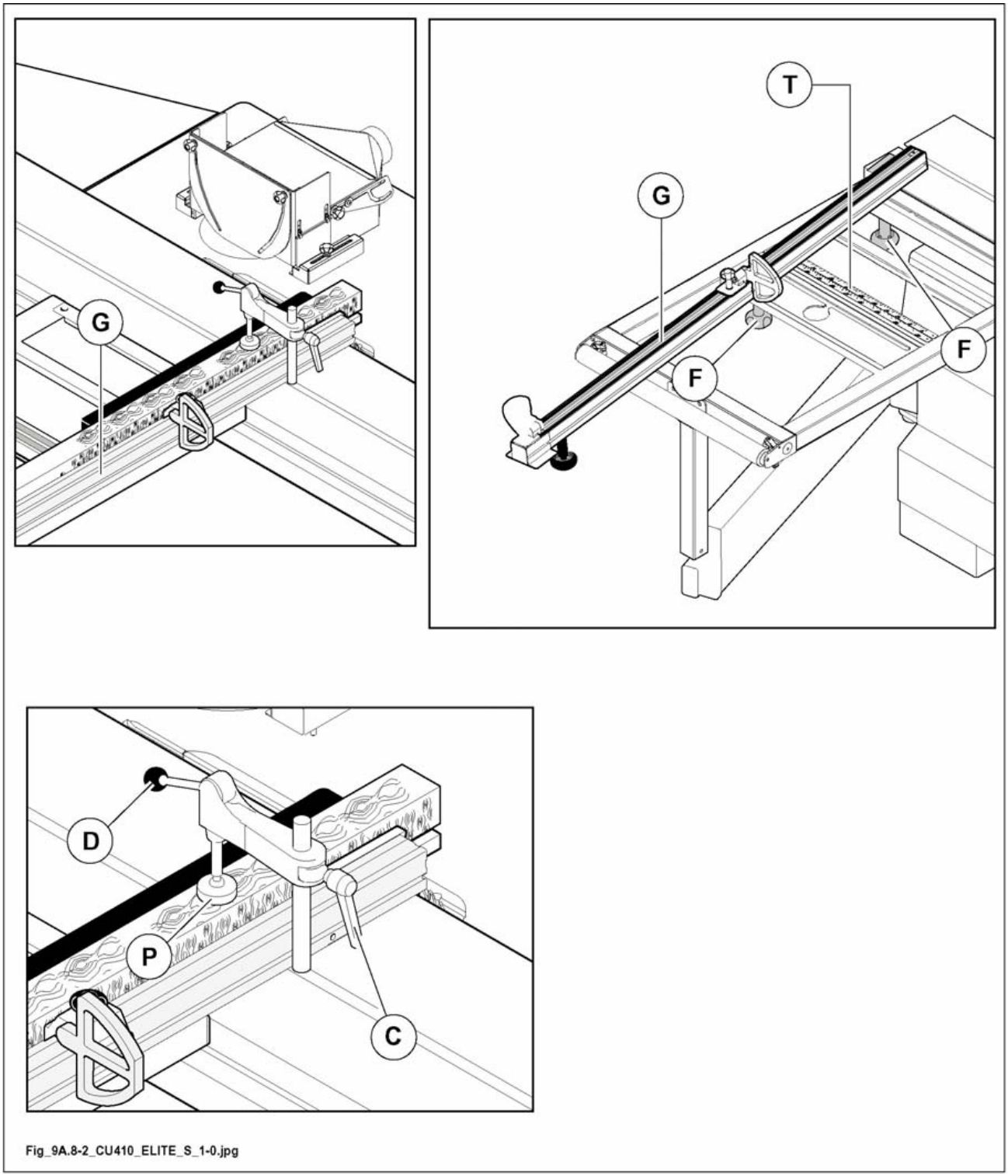


Fig. 9.8-2

(st-9c)

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9A.33 ADJUSTABLE HOOD-FENCE UNIT

(cu_9-33_0.0)

SAFETY OVER ALL

DANGER-WARNING:
all adjusting operations shall be carried out with standstill spindle.

DANGER-WARNING:
Check that the spindle speed does not excede the max. speed permitted for the used tool. Otherwise see paragraph about speed change.

The tool shall rotate in the right direction.
The pilot lamp on the control board lights up when the tool rotates clockwise.

The operator shall make sure that the spindle can rotate in the direction desired and that the piece feed occurs in the direction contrary to the spindle rotation one.

Use roller conveyors or extension tables (not supplied by SCM***) when machining very long pieces.***

Before working always adjust vertical and horizontal pressure shoe to form a protection of the hands and against eventual ejection of splits and tool parts (see paragraph 9.50).

Before starting the machine make sure that the tools do not touch the parts of the machine.

After every adjustment always close the top cover of moulder hood.

It is prohibited to mount tools with a diameter greater than indicated in Chap. 3.

Machining with the router fence hood should be carried out while keeping the two support tables in their closest possible position, to prevent the tool from carrying the workpiece along. Before proceeding with machining, adjust the router hood and the pressers as indicated (Par. 9A.33).

The positioning and adjustment of the spindle moulder fence changes according to the type of operation to be carried out.

When profiling the entire side of workpiece half-fence (B) shall be alignad with tool (1 fig. 9.33A)

If profiling is not done on the entire side, but only on a part, the two fences A and B must be aligned (2 fig. 9.33A)

Adjust the guides A and B on the basis of the processing as indicated as follows.
Position the hood on the working table and screw the two knobs (C,G fig. 9.33A) into their special holes.

DANGER-WARNING:
the two fences must be adjusted so the workpiece is stable at both infeed and outfeed.

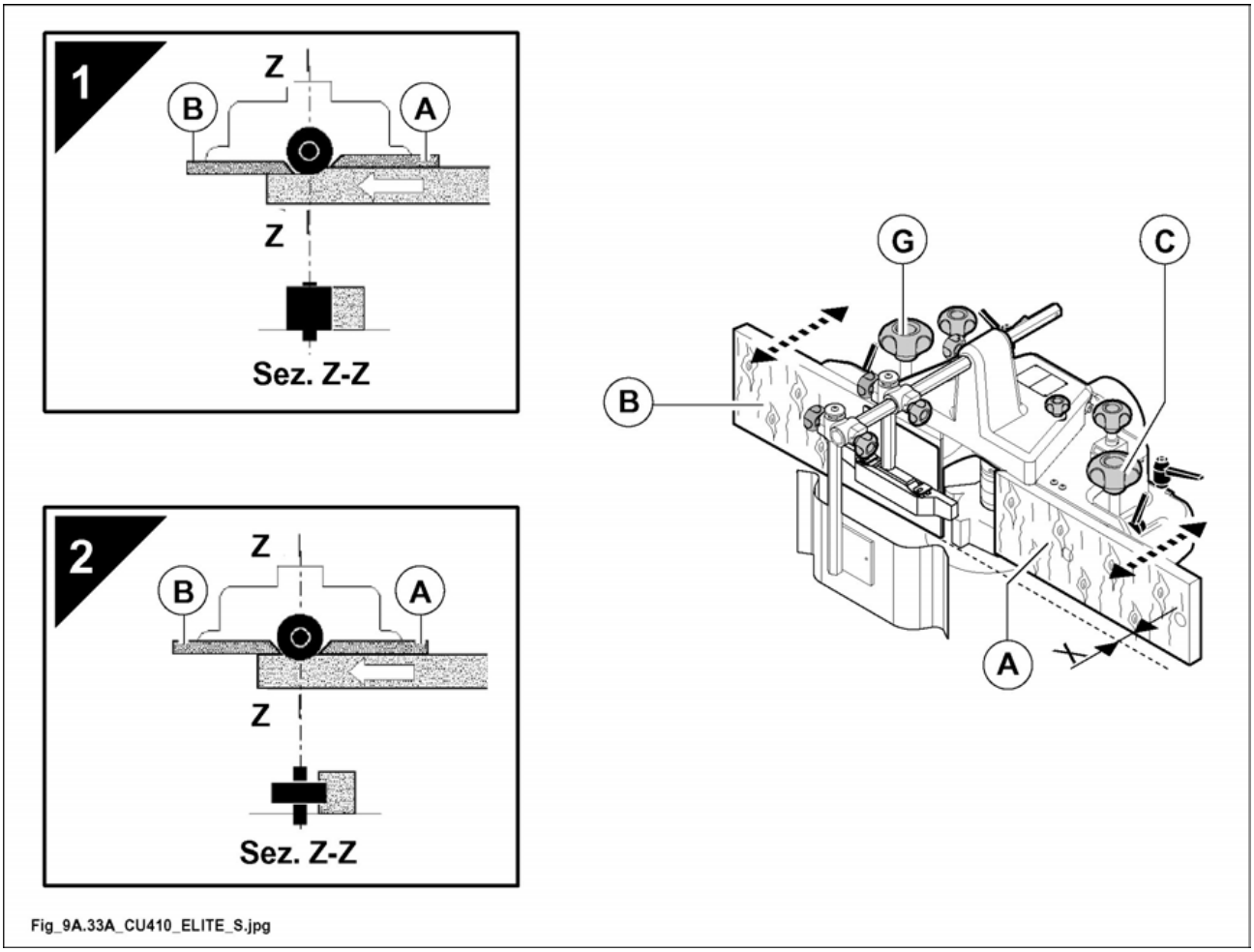


Fig. 9.33A

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9A.33.1 ADJUST SPINDLE MOULDER HOOD GUIDE FOR MOULDING WITHOUT REMOVAL

(cu_9a-33-1_0.0)

Simultaneous adjustment of the guides A and B (fig. 9.33-1).

- Check that the lever H and the knob E are blocked (fig. 9.33-1).
- Slacken the knobs G and C and the lever L (fig. 9.33-1).
- Adjust the guides via the knob F (fig. 9.33-1).

- The fence halves (A and B fig. 9.33-1) must be as near the tool as possible (about 2-3 mm). To make this adjustment loosen handles (D fig. 9.33-1) behind the fence halves.

NOTE-INFORMATION:
for this operation the fence halves shall be aligned with one another.
The value visualized on the indicator (U fig. 9.33-1) corresponds to the distance from the centre of the spindle moulder to the panel (B fig. 9.33-1). If the tool is level with the panel (B fig. 9.33-1) this measurement coincides with its radius.

- When the adjustment has been carried out, tighten the knobs C and G and the lever L (fig. 9.33-1).

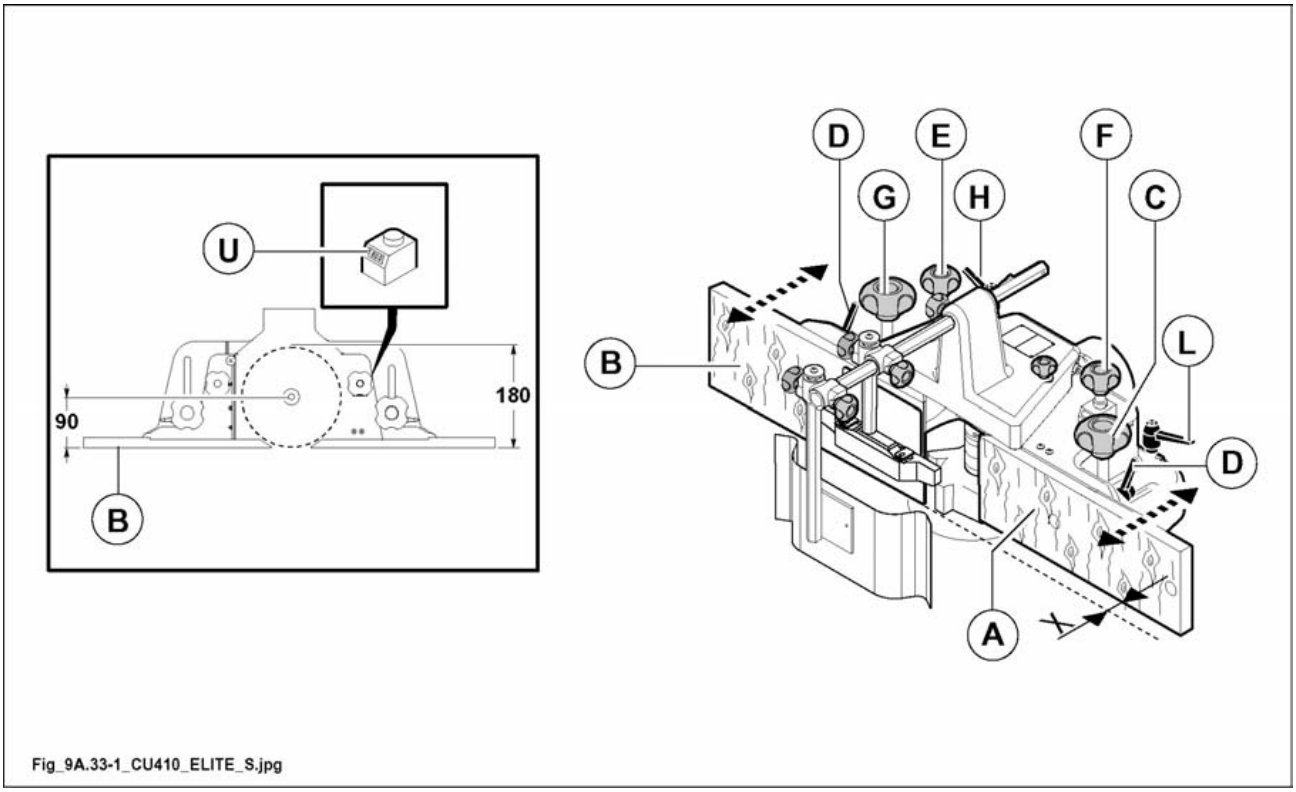


Fig. 9.33-1

9A.33.2 ADJUST SPINDLE MOULDER HOOD FOR MOULDING WITH REMOVAL.

(cu_9a-33-2_0.0)

- After loosening knobs (G, C fig. 9.33-2) move the entire hood- fence unit to the most suitable position for the depth of cut required, then tighten the knobs.

- The fence halves (A and B fig. 9.33-2) must be as near the tool as possible (about 2-3 mm). To make this adjustment loosen handles (D fig. 9.33-2) behind the fence halves.

For further micrometric adjustment of the depth of cut set the fence half (A fig. 9.33-2) as follows:

- check that the lever (H fig. 9.33-2) and the knob (G fig. 9.33-2) are locked.
- Slacken the knob (C fig. 9.33-2) and the lever (L fig. 9.33-2).
- Turn knob (F fig. 9.33-2) to find the correct position: indicator (U fig. 9.33-2) indicates the adjusting measure.
- When the adjustment has been carried out, tighten the knob (C fig. 9.33-2) and the lever (L fig. 9.33-2).

For micrometric adjustment of fence half (B fig. 9.33-2):

- check that the lever (L fig. 9.33-2) and the knob (C fig. 9.33-2) are locked.
- Slacken the knob (G fig. 9.33-2) and the lever (H fig. 9.33-2).
- Turn knob (E fig. 9.33-2) and with a bar check the alignment of the fence half with the tool.
- When the adjustment has been carried out, tighten the knob (G fig. 9.33-2) and the lever (H fig. 9.33-2).

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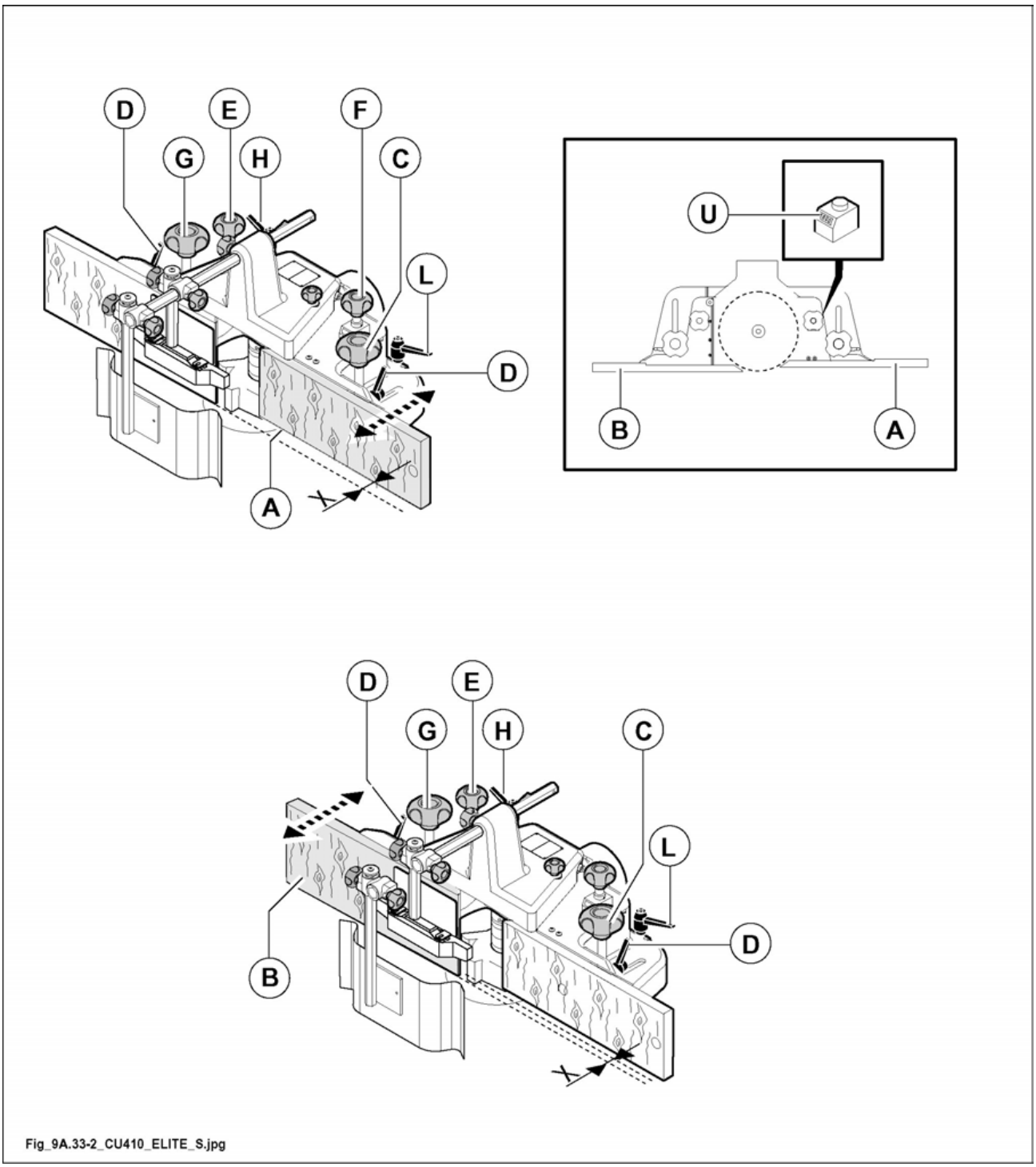


Fig. 9.33-2

9A.33.3 USE OF HOOD-FENCE FOR SMALL PIECES

(cu_9a-33-3_0.0)

When repetitive or special operations must be carried out, it is recommended to make a counterfence to be applied to the router hood, opened to let the tool through. The counterguide must be secured to the two tables by means of the 2 convex-head screws and 2 m8 nuts (fig. 9.33-3).

To mill the passage opening proceed in this way:

- **set horizontal pressure shoe (C fig. 9.33-3) in order to protect the operator against eventual ejection of splits and tool parts.**
- **Move the entire hood-fence unit backwards very slowly, up to opening of passage.**

DANGER-WARNING:
do not use inserts with openings larger than the tool thickness.

DANGER-WARNING:
after each adjustment, always remember to close the upper cover on the moulder hood and position the pressers unit (see par. 9.50).

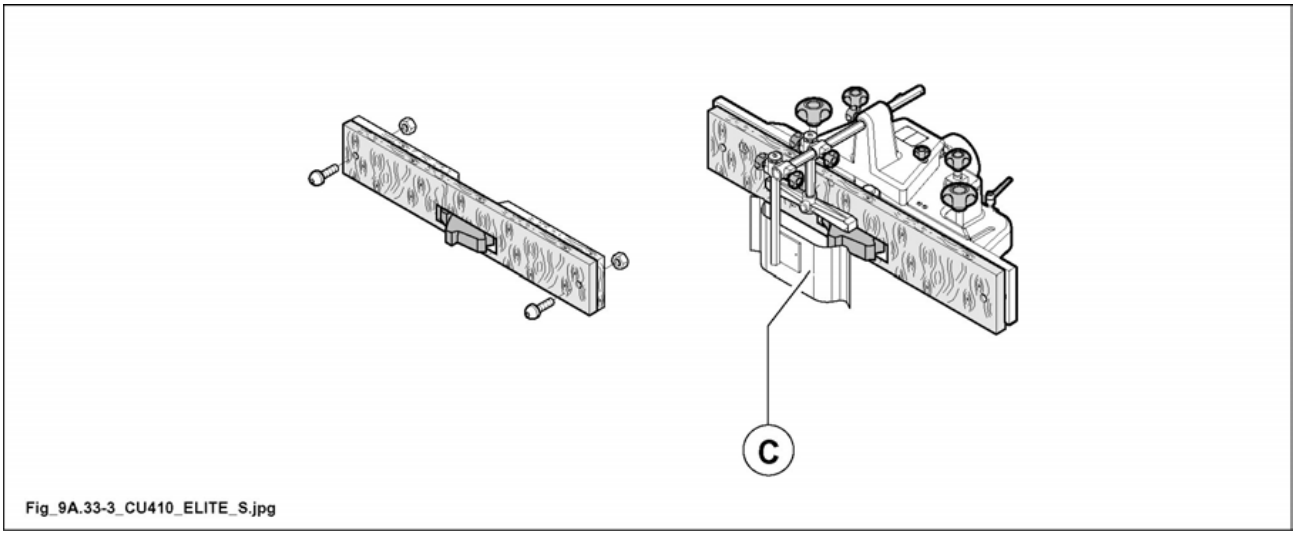


Fig. 9.33-3

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9A.33.4 HOOD-FENCE ADJUSTING FOR PROFILING WITH ROTATION DIRECTION REVERSAL

(cu_9a-33-4_0.0)

DANGER-WARNING:
the machine is equipped with spindle rotation reversal (spindle rotation clockwise).

NOTE-INFORMATION:
the pilot lamp on the control board lights up when the tool rotates clockwise (that is in feed direction).

DANGER-WARNING:
this rotation direction (fig. 9.33-4) is to be avoided as much as possible; as the cutter rotates in "feed direction".
Make sure that the workpiece feed occurs in the direction opposite to the cutter rotation direction..

DANGER-WARNING:
NEVER make the workpiece feed in the tool rotation direction because there is the risk that the workpiece is withdrawn by the pressure shoe.

DANGER-WARNING:
all adjusting operations are to be carried out with standstill spindle.
Adjust pressure shoes (see paragraph 9.50).

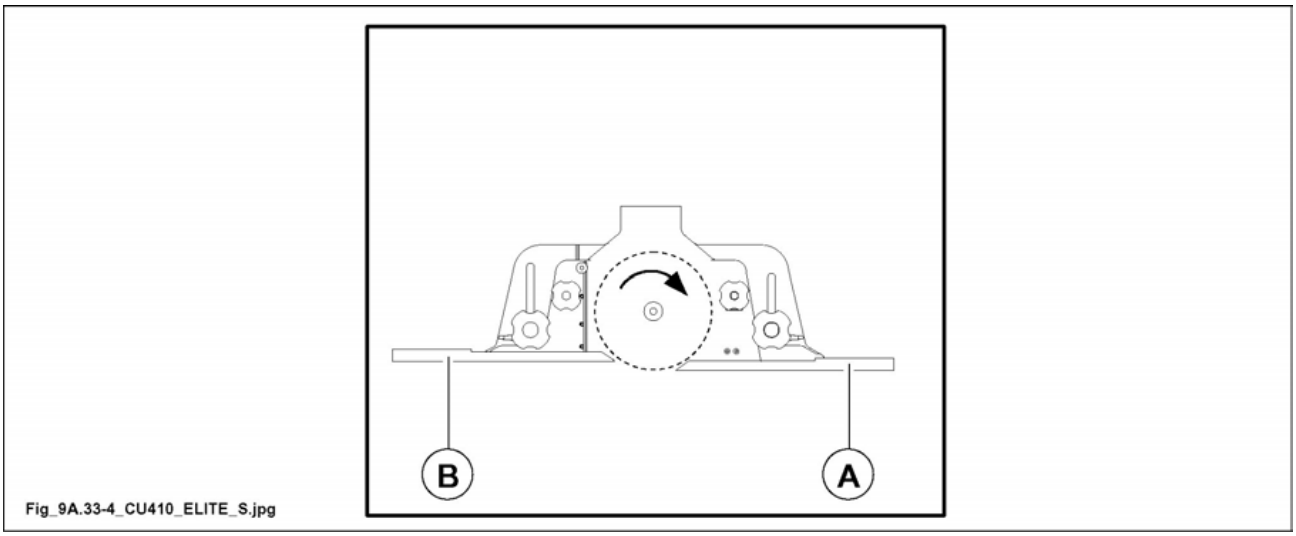


Fig. 9.33-4

In this case, the output guide (B fig. 9.33-4A) can be retracted to 5 mm.

- After loosening knobs (G, C fig. 9.33-4A) move the entire hood- fence unit to the most suitable position for the depth of cut required, then tighten the knobs.

- The fence halves (A and B fig. 9.33-4A) must be as near the tool as possible (about 2-3 mm). To make this adjustment loosen handles (D fig. 9.33-4A) behind the fence halves.

For a further micrometric adjustment of the depth of cut, set fence half (B fig. 9.33-4A) as follows:

- loosen the handle (T fig. 9.33-4A).

- unscrew the regulator by rotating the knob (R fig. 9.33-4A) counter-clockwise.

- Turn knob (P fig. 9.33-4A) clockwise to retract the guide (B fig. 9.33-4A) as required.

- Tighten the handle (T fig. 9.33-4A).

For micrometric adjustment of fence half (A fig. 9.33-4A):

- check that the lever (H fig. 9.33-4A) and the knob (G fig. 9.33-4A) are locked.

- Slacken the knob (C fig. 9.33-4A) and the lever (L fig. 9.33-4A).

- Turn knob (F fig. 9.33-4A) and with a bar check the alignment of the fence with the tool.

- When the adjustment has been carried out, tighten the knob (C fig. 9.33-4A) and the lever (L fig. 9.33-4A).

To re-align the guides:

- loosen the handle (T fig. 9.33-4A).

- Rotate the knob (P fig. 9.33-4A) counter-clockwise as far as the end stop.

- Rotate the knob (R fig. 9.33-4A) clockwise as far as the end stop.

- Retract the guide (B fig. 9.33-4A) by rotating the knob (P fig. 9.33-4A) clockwise as far as the end stop.

- Tighten the handle (T fig. 9.33-4A).



DANGER-WARNING:
the two fences must be adjusted so the workpiece is stable at both infeed and outfeed.

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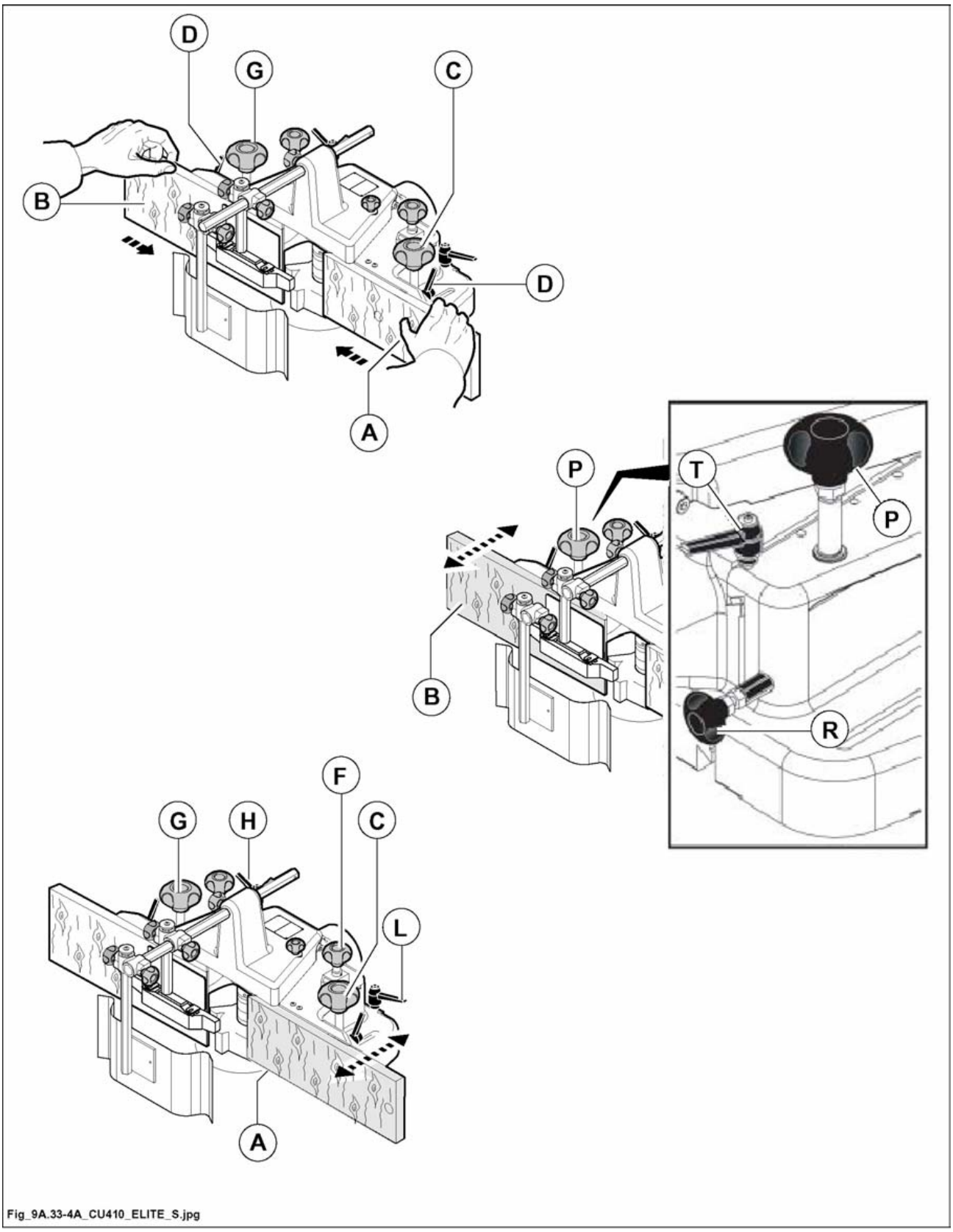


Fig. 9.33-4A

9A.33.5 WORKING EXAMPLES

(cu_9a-33-5_0.0)

Profiling

It is carried out along the wood grain on straight pieces. During the feed motion the entire workpiece shall be in contact with both half-fences of the moulder fence.

CAUTION:
before proceeding with machining, adjust the router hood and the pressers as indicated in paragraph 9A.33.
Before starting work check the various fittings.
Connect fitting (4 fig. 9.33-5A) to the suction system.

DANGER-WARNING:
the piece being machined must always be fed using the wood thrust provided (A fig. 9.33-5A).

Start the system and machine asample workpiece. Check the profile height and depth using a gauge. A good finishing requires a milling with constant feed.

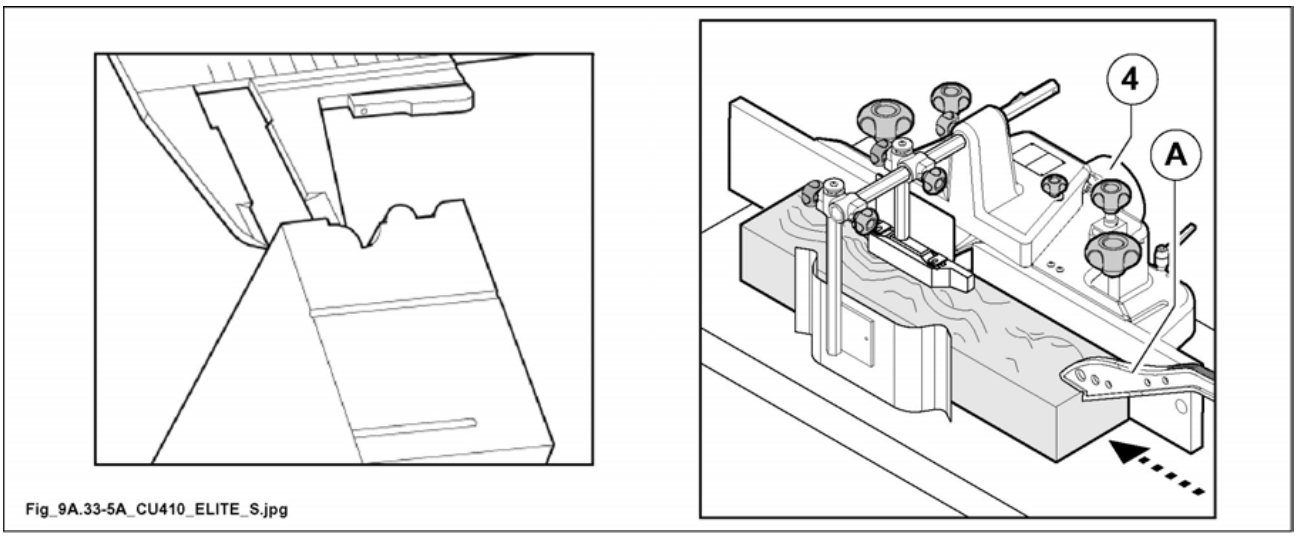


Fig. 9.33-5A

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Profiling with tilted shaft (OPT)

This type of processing permits the production of different profiles using the same tools. This allows machining of different profiles using the same tools.

Set up the machine in the following way:

- fit the hood (G fig. 9.33-5B);
- remove if necessary the rings on the table hindering shaft tilting;
- mount the tools on the shaft (see chapter 4).

DANGER-WARNING:
machining with inclined spindle must exclusively be carried out with a tool of maximum 150 mm diameter.

- Adjust the height and the inclination of the router spindle (Chap.9a);
- adjust working depth using the moulder fences (see chapter 9a).

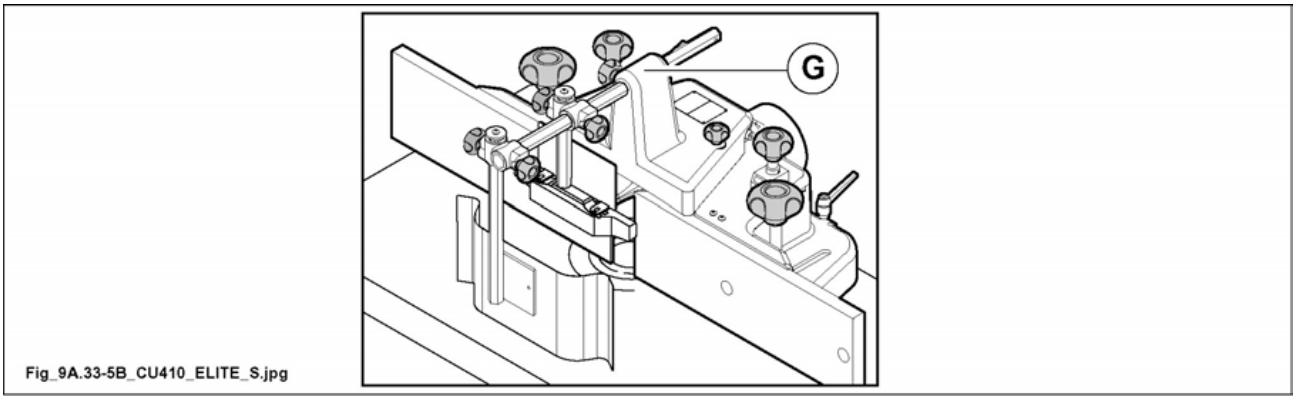


Fig. 9.33-5B

+45° tilt (OPT)***: profiling of flitch (K fig. 9.33-5C) in wings***

Adjust the shaft so that it is perpendicular to the table and using the specially shaped tool (U fig. 9.33-5C) verify that:

- the tool rim speed at point (B fig. 9.33-5C) is much higher than at point (A fig. 9.33-5C), because R1 < R2.

This might lead to a difference in finishing all over the A - B surface or even to burns. When the shaft is tilted to +45° (1 fig. 9.33-5C), this difference is minimized because R1 ~ R2, if a specially shaped tool is used.

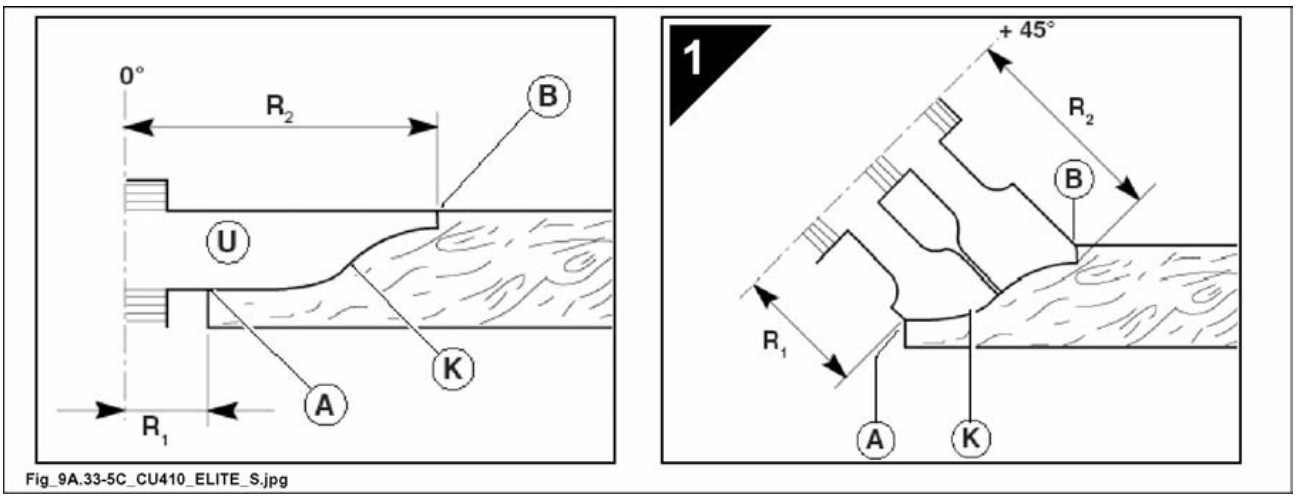


Fig. 9.33-5C

For dead milling cuts (H fig. 9.33-5D) and the machining of short pieces, it is necessary to fi t the stops (A fig. 9.33-5D) and (B fig. 9.33-5D) (not supplied) onto the input fence and the half–fence.
The stops must be fastened ontothe fences (D fig. 9.33-5D) by means of the screws (C fig. 9.33-5D).

To perform the machining, proceed as follows:
- prepare the machine;
- start the moulder shaft;
- rest the wood piece against the stops (A fig. 9.33-5D) and push it against the milling cutter;
- move the piece forward to the stop (B fig. 9.33-5D).

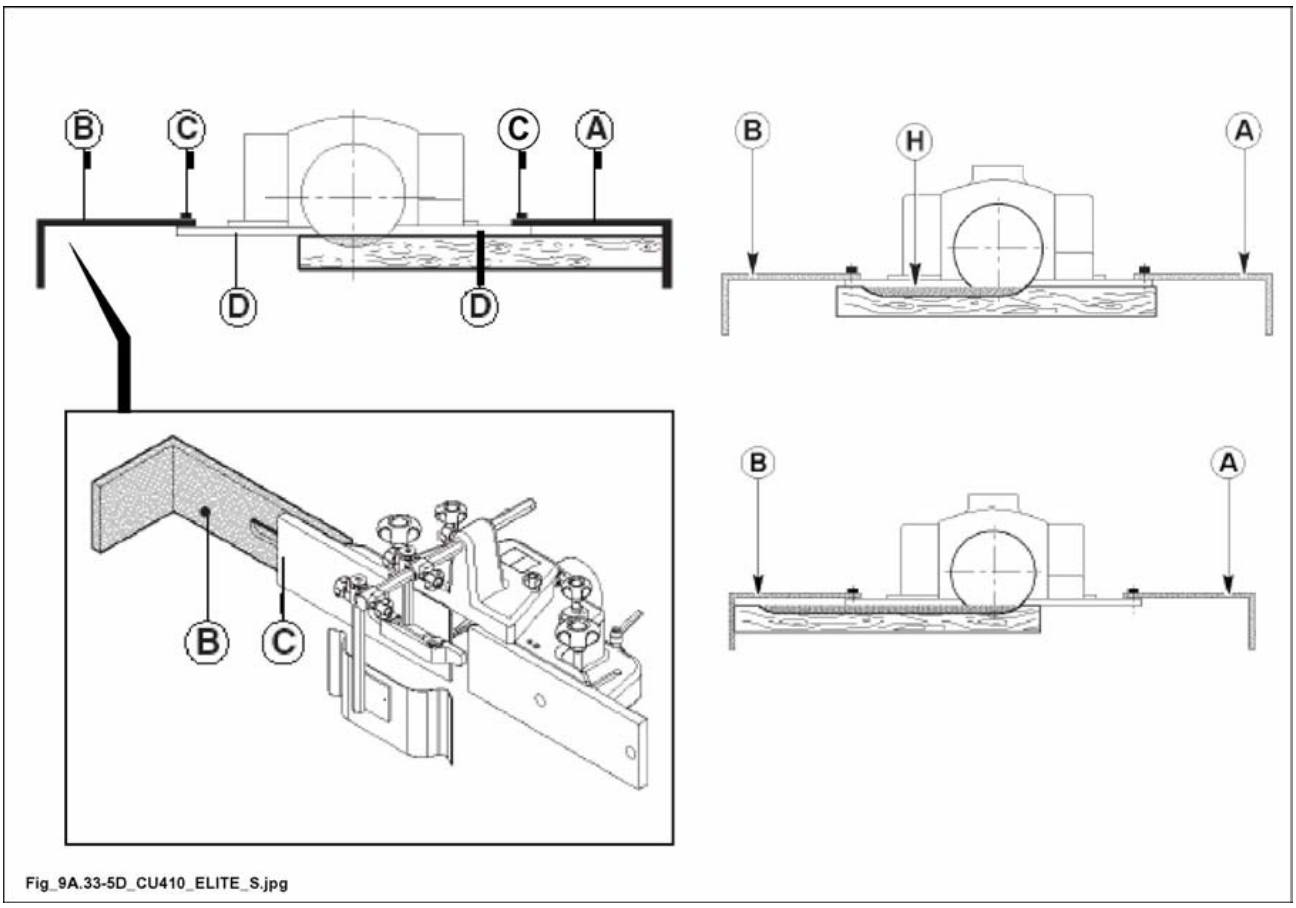


Fig. 9.33-5D

Sanding
This operation requires low moulder spindle rotation speed.

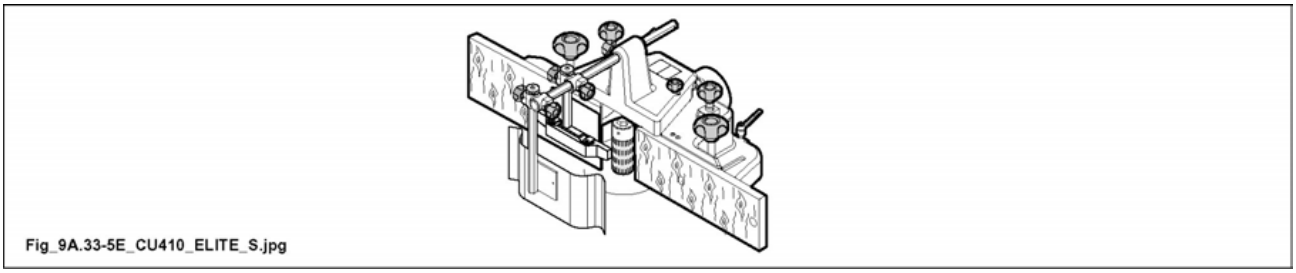


Fig. 9.33-5E

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Rabbeting

It is the external profiling (P fig. 9.33-5F) of a frame. This operation may be carried out with the workpiece on the machine table and against the moulder fence or clamped to the sliding table.

It is better to begin from a crosspiece then turn the frame 90° every time in order to eliminate the chipping obtained in the previous stroke, then work the jamb in the wood grain direction (1 fig. 9.33-5F).

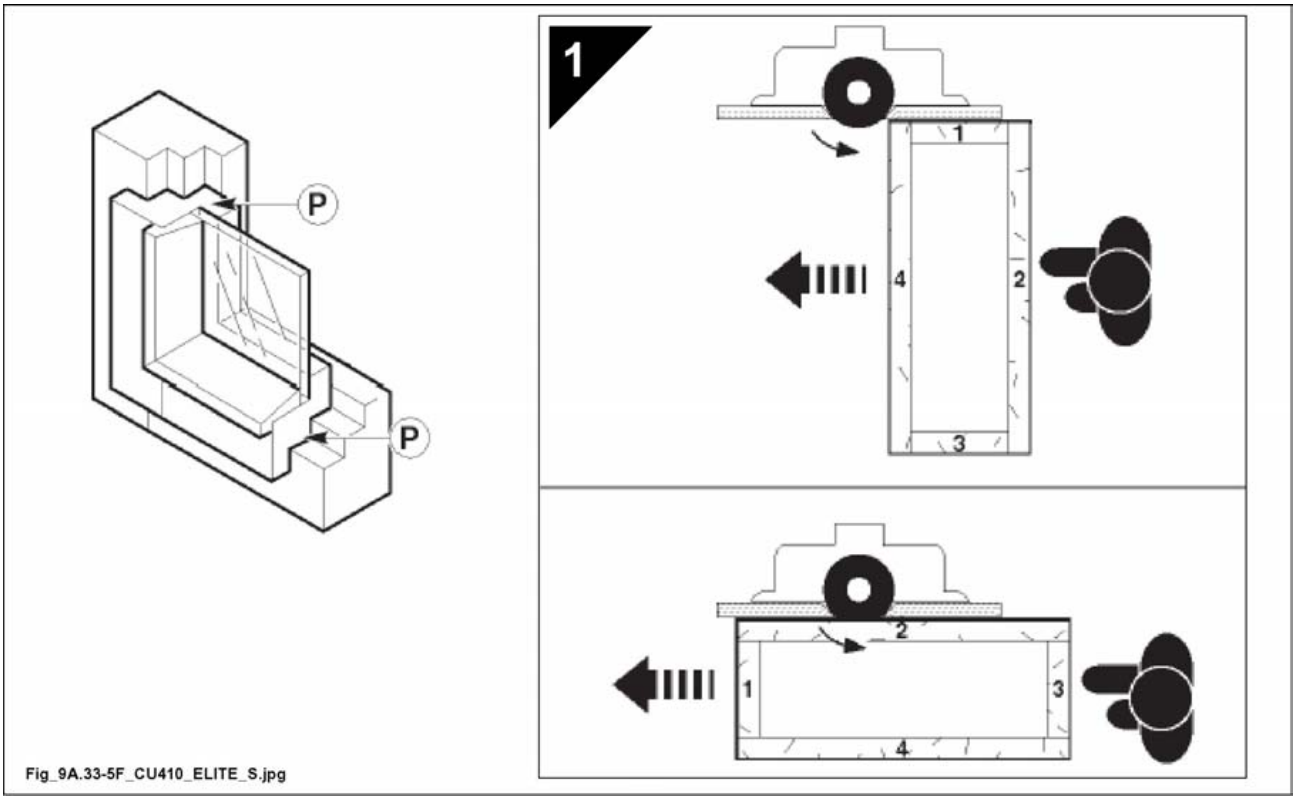


Fig. 9.33-5F

9A.44 TENONING HOOD

(cu_9a-44_0.0)

OPT

COMPONENTS

(1 fig. 9.44) - Knobs for locking the hood on the table

(2 fig. 9.44) - Knobs for locking the shield

(3 fig. 9.44) - Cover

(4 fig. 9.44) - Ø 120 mm suction pipe

(5 fig. 9.44) - Shield

(6 fig. 9.44) - Knobs for locking the cover

DANGER-WARNING:
take off the hood-fence unit (we recommend the help of another person) in order to rest the tenoning hood on the table.

9A.44.1 ADJUSTING

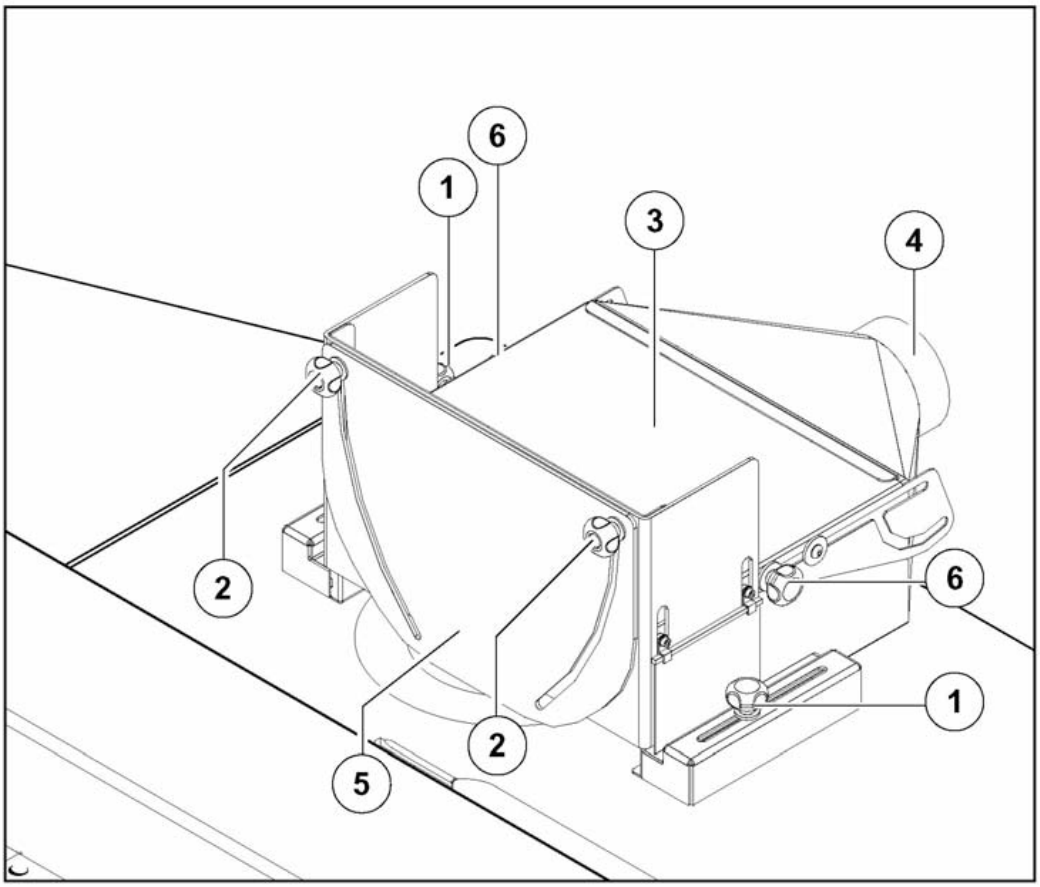
(cu_9a-44-1_0.0)

OPT

- Rest the hood on the table in the position proper for the milling depth required, the fasten it by tightening knobs (1 fig. 9.44).
- To protect the upper part of the tool adjust the upper part of the hood by turning the knobs (6 fig. 9.44).

DANGER-WARNING:
before starting the machine close cover (3 fig. 9.44).
Make sure that the tools do not touch any machine part.

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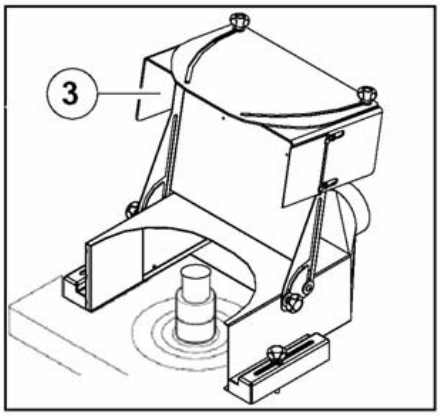


Fig_9A.44_TI_105_PS_NOVA.jpg

Fig. 9.44

9A.50 PRESSURE UNIT FOR PROFILING

(cu_9a-50_0.0)

Components (fig. 9.50):

1) - Horizontal pressure shoe

2) - Vertical pressure shoe

3) - Support

4) - Knobs for presser adjusting

5) - Knobs for presser adjusting

6) - Knobs for presser adjusting

7) - Pusher

4) - Knobs for presser adjusting

5) - Knobs for presser adjusting

6) - Knobs for presser adjusting

DANGER-WARNING:
the vertical and horizontal pressure shoes , fastened to the support, are an efficient protection for the operator's hands and against the eventual ejection of splits or tool parts.

DANGER-WARNING:
all adjustments must be carried out with the shaft stopped.

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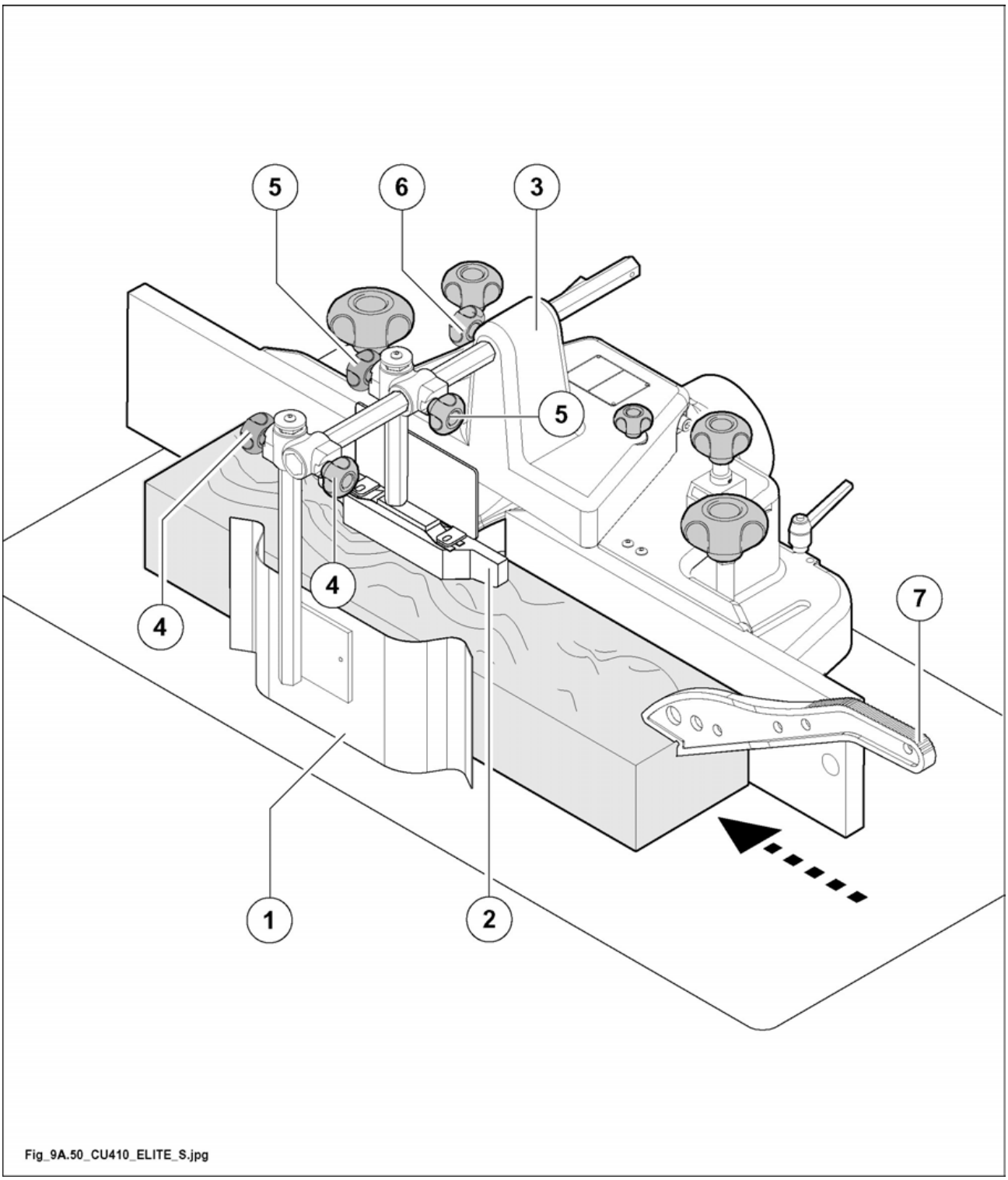


Fig. 9.50

9A.50.1 ADJUSTING

(cu_9a-50-1_0.0)

Before working adjust the pressure exerted by vertical and horizontal pressure shoes.

The workpiece shall easly move without shocks between pressure shoes and fence halves, therefore the pressure shall be not too strong.

- Adjust fence halves (A e B fig. 9.50-1) according to the external cutter diameter.

Adjust the position of the horizontal presser (1 fig. 9.50-1) and the vertical presser (2 fig. 9.50-1) resting it on the piece to be machined and proceed as follows:

- slacken the knob (G fig. 9.50-1) and transversally adjust the presser belt (1 fig. 9.50-1) on the basis of the width of the wood to be processed.
- When the adjustment has been carried out, tighten the knob.
- Loosen the knobs (L fig. 9.50-1) and (M fig. 9.50-1) and position the vertical presser (2 fig. 9.50-1) on the wood maintaining it is close as possible to the cutter.
- Lock the knobs (L fig. 9.50-1) and (M fig. 9.50-1) when the adjustment has been completed.

Adjust the pressure shoes in order to protect the operator against eventual ejection of splits or tool parts.

NOTE-INFORMATION:
after every adjustment make sure that the knobs are tight.

DANGER-WARNING:
use flat pusher (9 fig. 9.50-1) to make the piece passage under horizontal pressure shoe (1 fig. 9.50-1) easier.

NOTE-INFORMATION:
the min. section of the workpiece which may be pressed is 8x8 mm on the entire length.

CAUTION:
release the spindle motor brake.
Turn the tool after carrying out all adjustments in order to avoid any contact with machine parts or with the guard.
Lock the motor brake again.

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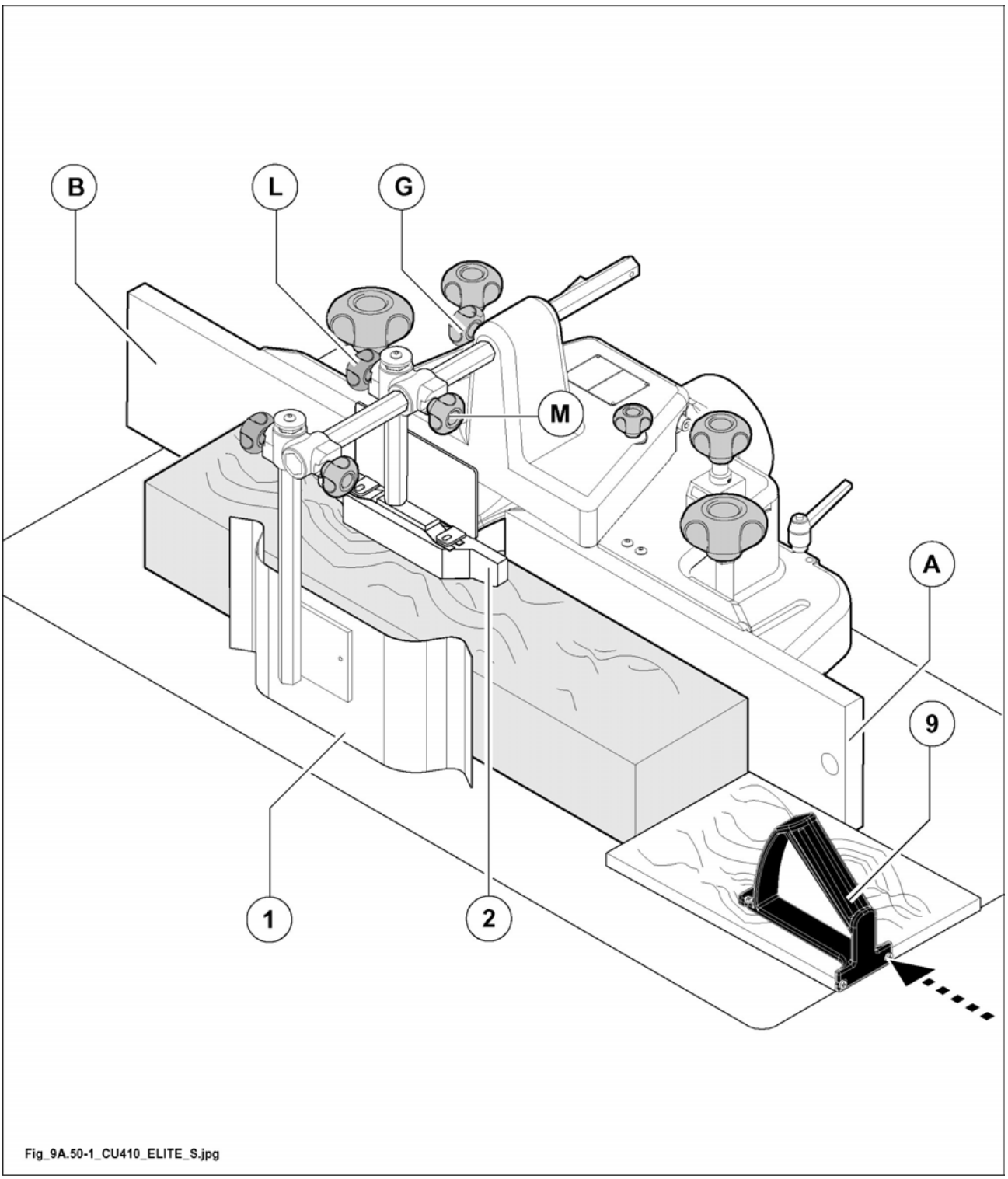


Fig. 9.50-1

9A.55 GUARD FOR MILLING AT THE SPINDLE

(cu_9a-55_0.0)

SAFETY OVER ALL

This device (supplied as a STD accessory) is used for milling pieces with shaped, curved edges or ring-shaped edges.

The right use permits shaping operations in safe conditions.

BEFORE STARTING THE WORKING YOU MUST HAVE ON THE FOLLOWING PERSONAL PROTECTIVE MEANS:

A - Proper aprons, e.g: aprons made of double leather with synthetic fiber cloth insertion (not supplied by SCM) to protect the operator in case of splinters ejection.
B - Glasses or protective shields for your eyes.

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9A.55.2 ADJUSTING

(cu_9a-55-2_0.0)

DANGER-WARNING:
all adjusting operations are to be carried out with standstill spindle.

WORKING DEPTH

Version for spindles with max. 40 mm diameter
- loosen the knob (H fig. 9.55-2A) and act on the knob (M fig. 9.55-2A) to make micrometric adjustments;
- tighten the knob (H fig. 9.55-2A).

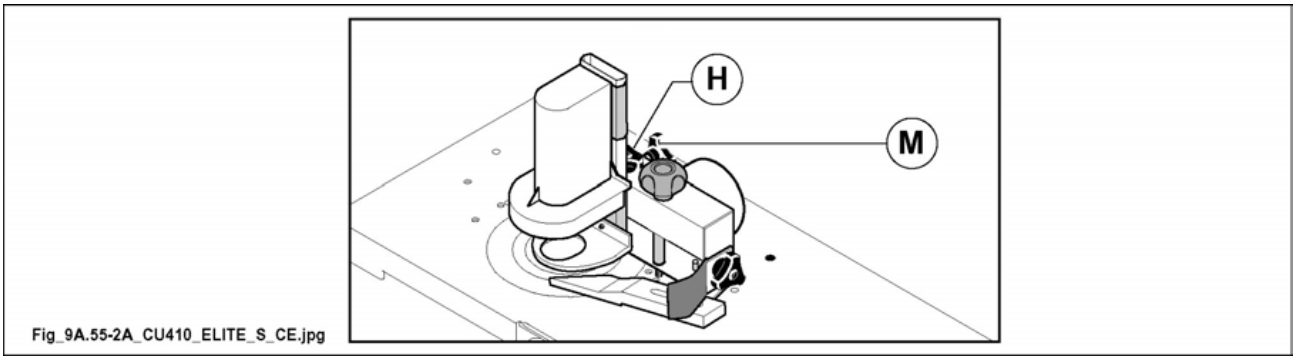


Fig. 9.55-2A

Version for spindles with 50 mm diameter
- loosen the knobs (H fig. 9.55-2B) and (L fig. 9.55-2B) and manually translate the hood in the desired position;
- tighten the knob (H fig. 9.55-2B) and turn the knob (M fig. 9.55-2B) to do the micrometric adjustment;
- tighten the knob (L fig. 9.55-2B).

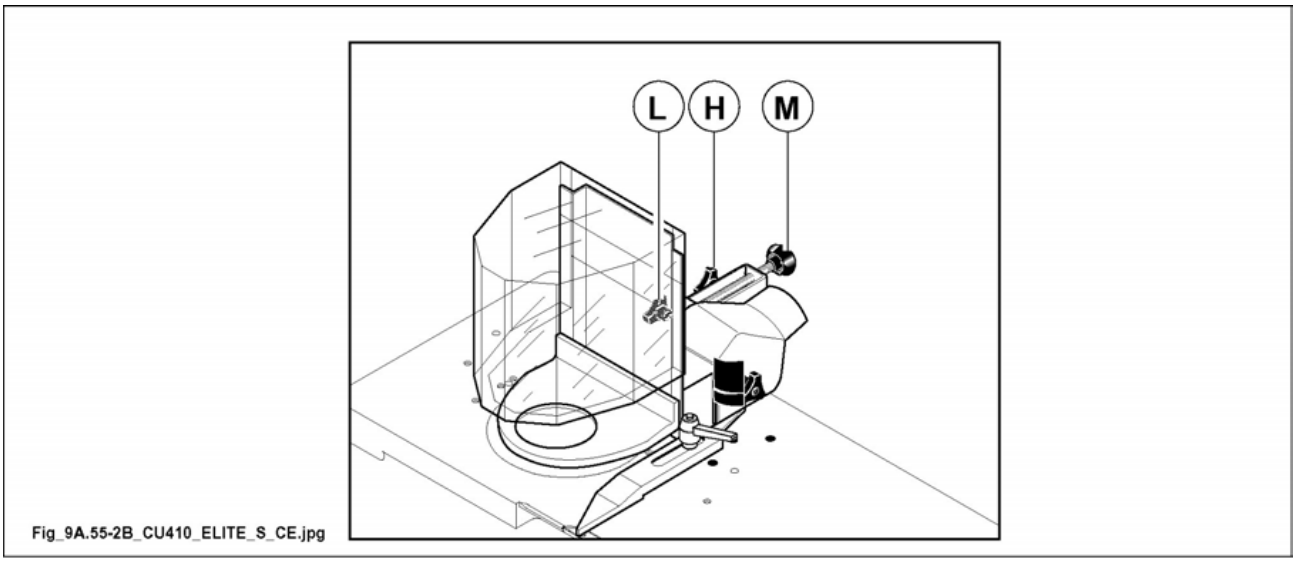


Fig. 9.55-2B

TRACER RESTS - HEIGHT ADJUSTMENT

- loosen the knob (C fig. 9.55-2C) or the screws (B fig. 9.55-2C) and adjust the rest (D fig. 9.55-2C) to the desired height;
- relock when adjustment has been completed.

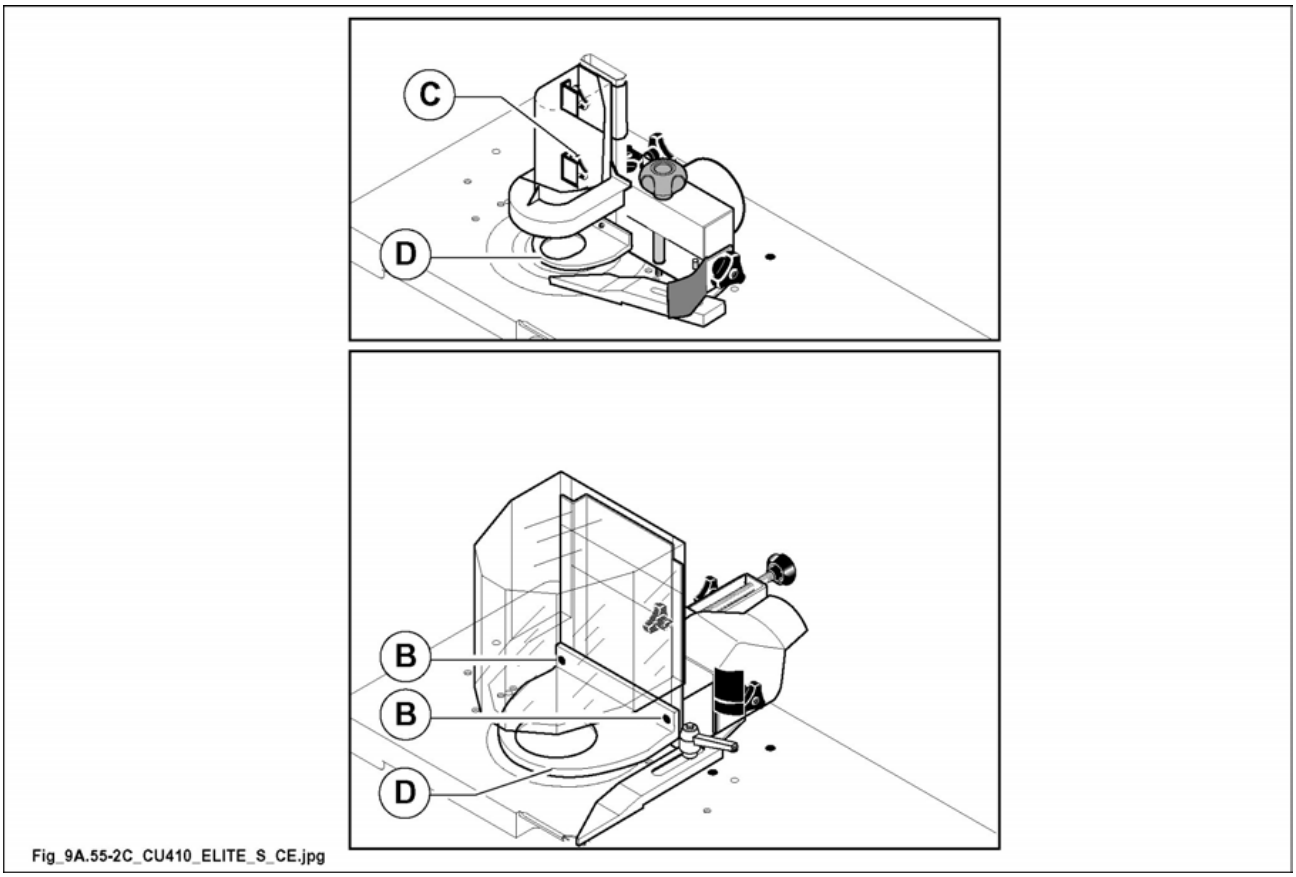


Fig. 9.55-2C

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PRESSER

- loosen the knob (E fig. 9.55-2D) or the screws (A fig. 9.55-2D) and adjust the presser (G fig. 9.55-2D) in such a way that it exercises slight pressure on the piece to be machined;
- relock when adjustment has been completed.

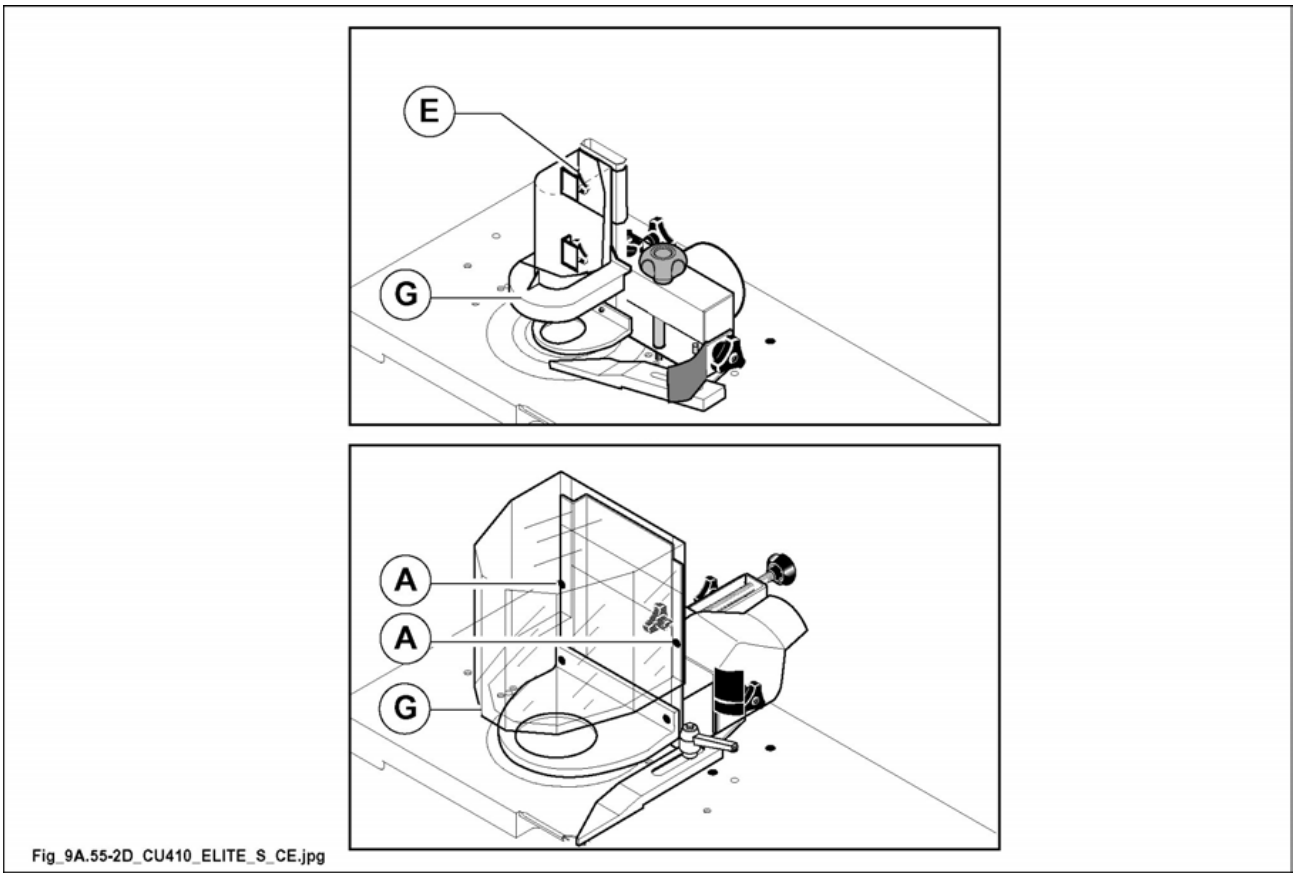


Fig. 9.55-2D

9A.55.3 WORKING EXAMPLES

(cu_9a-55-3_0.0)

This operation is carried out for obtaining profiles along bent lines. The shaping is carried out by means of the milling cutter (A fig. 9.55-3) and the copying ring (D fig. 9.55-3) fitted on the hood (C fig. 9.55-3).

CAUTION:
adjust the hood as indicated in paragraph 9A.55-2.
Before starting work check the various fittings and turn the tool manually to prevent possible contact with fixed parts.
Connect fitting (4 fig. 9.55-3) to the suction system.

For machining proceed by placing the profile on the guide (E fig. 9.55-3), firmly fixed to the support and push it up to the reference (H fig. 9.55-3) stamped on the rest.
Thus progressive attachment is obtained until maximum cutting depth.

The reference (H fig. 9.55-3) indicates the point of maximum cutting depth.

The fence may be fixed to the support both on the right side and on the left side of the operator according to the spindle rotation direction.

NOTE-INFORMATION:
to obtain regular removal the whole machining process must be carried out in correspondence to the reference (H fig. 9.55-3).
As a material for the template (P fig. 9.55-3) use a multilayer panel; the template shall be equipped with clamps (S fig. 9.55-3).

Machine with reversal of rotation
- Mount the bracket (G fig. 9.55-3) as indicated in Par. 4.3.73.5.
- Move guide (E fig. 9.55-3) to opposite side (B fig. 9.55-3) after loosening knob (K fig. 9.55-3).

DANGER-WARNING:
set the clenched fists flat on the piece and push it forward by resting it against fence (E fig. 9.55-3) or against the straight part of the steady rest.

In case of milling against the wood grain or in tranverse direction to the wood grain (dangerous situation), you have to reduce the feed motion to avoid the wood fiber rupture.

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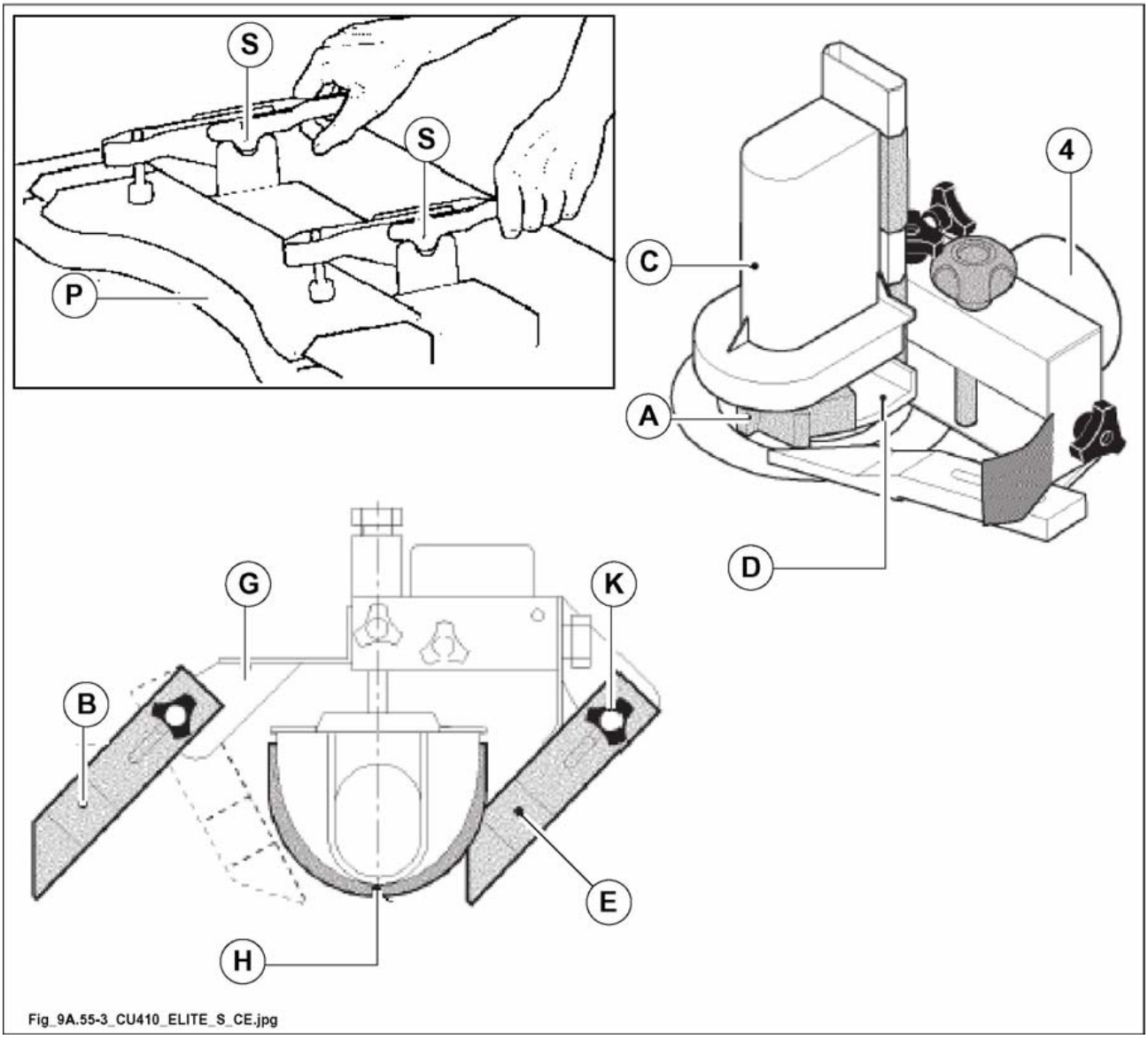


Fig. 9.55-3

9A.55.4 MAINTENANCE

(cu_9a-55-4_0.0)

Replace the worn or damaged parts.

Keep the guard always clean and check its good conditions.

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10.1 CUTTERBLOCK GUARD

(fs_10-1_0.0)

It protects the cutterblock during the surfacing.

The machine is equipped with two protections on the planer:
A - protection behind the planer guide
B - bridge-type protection

10.1.1 DESCRIPTION

(fs_10-1-1_0.0)

NOTE-INFORMATION:
this protection is easily adjustable on the whole length of the cutterblock.

A - Protection behind the planer guide

This is an articulated protection which always covers the planer shaft in both the guide positions, 90º and 45º respectively.

B - Bridge-type protection

1) Bridge (B fig. 10.1).
2) Bridge locking knob (C fig. 10.1).
3) Height adjusting knob (D fig. 10.1) (max. height which may be reached: 75 mm).
4) Arm (E fig. 10.1).
5) Protection locking lever (F fig. 10.1).

10.1.2 GUARD ADJUSTING

(fs_10-1-2_0.0)

B - Bridge-type protection

To adjust the height, operate the knob (D fig.10.1); the right position is maintained by the shock absorber.

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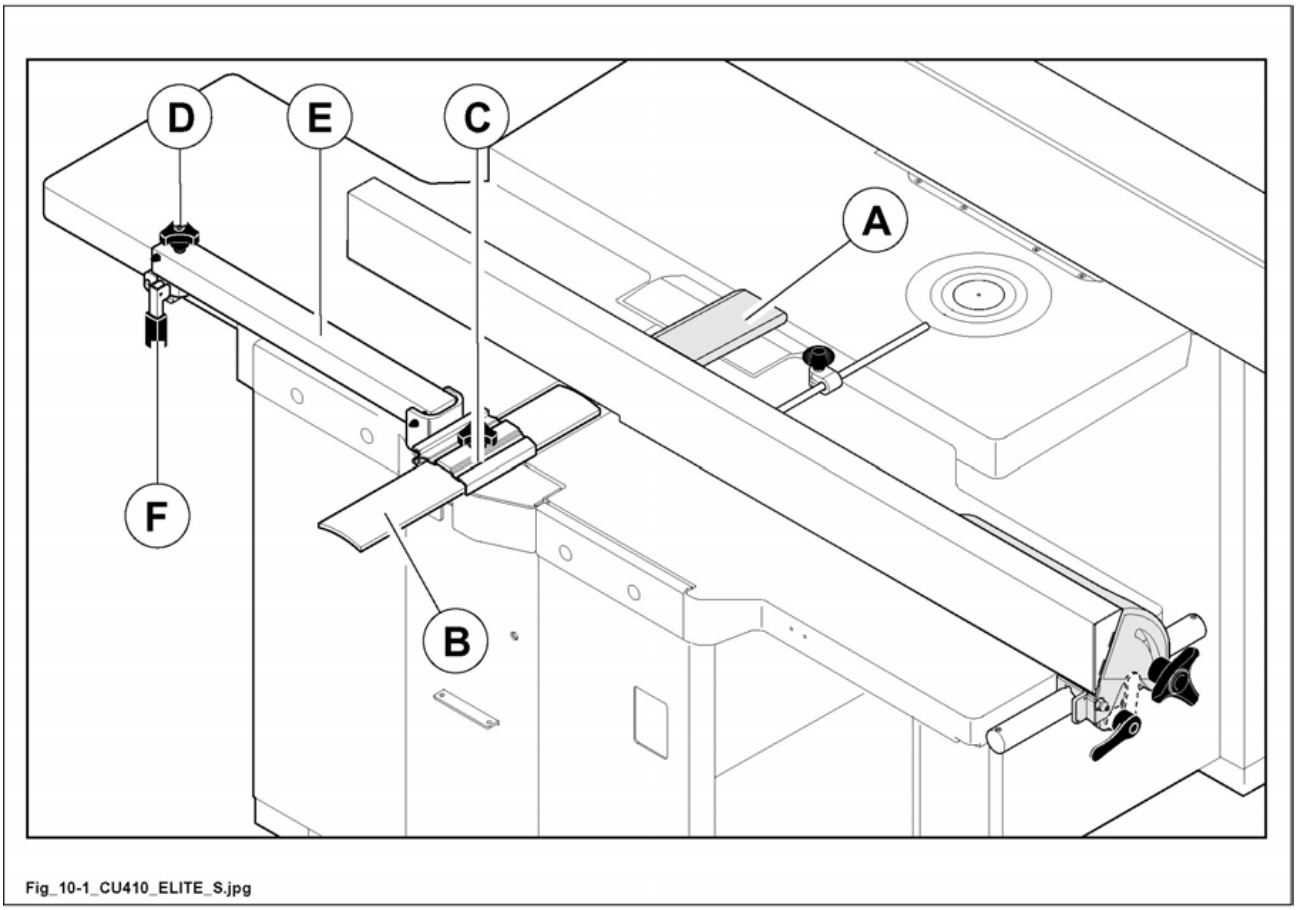


Fig. 10.1

10.3 PROCEDURES FOR SAFE WORKING

(fs_10-3_0.0)

DANGER-WARNING
the guard adjusting shall always be carried out with the motor off.

DANGER-WARNING:
do not machine workpieces too small or too big for the machine.
See relative paragraph 3.1 "Dimensions of workpiece to be milled".

DANGER-WARNING:
adjust the guard so that it covers the planer spindle completely.

DANGER-WARNING:
never put your hands near the cutterblock. Never forget to move the protection to its right position, to protect the tool-holder shaft between two working phases.

10.3.1 EXAMPLES

(fs_10-3-1_0.0)

10.3.1.1 SURFACING WORKPIECES OF THICKNESS LESS 75 MM

(fs_10-3-1-1_0.0)

- Loosen knob (C fig.10.3-1-1) and rest bridge (A fig.10.3-1-1) against fence (G fig. 10.3-1-1); lift bridge (A fig.10.3-1-1) by means of knob (B fig.10.3-1-1) at the height equal to the workpiece thickness.
- Rest the workpiece against the fence and move it forwards with the right hand in order to fit it under the bridge (1 fig.10.3-1-1).
- Push the workpiece forwards(from the inlet table side)(2 fig.10.3-1-1) by keeping the hands flat on the workpiece, let one hand and then the other hand climb over the guard bridge.
- As soon as possible press both hands on the workpiece on the outlet table side to continue the workpiece feed (3 fig.10.3-1-1).

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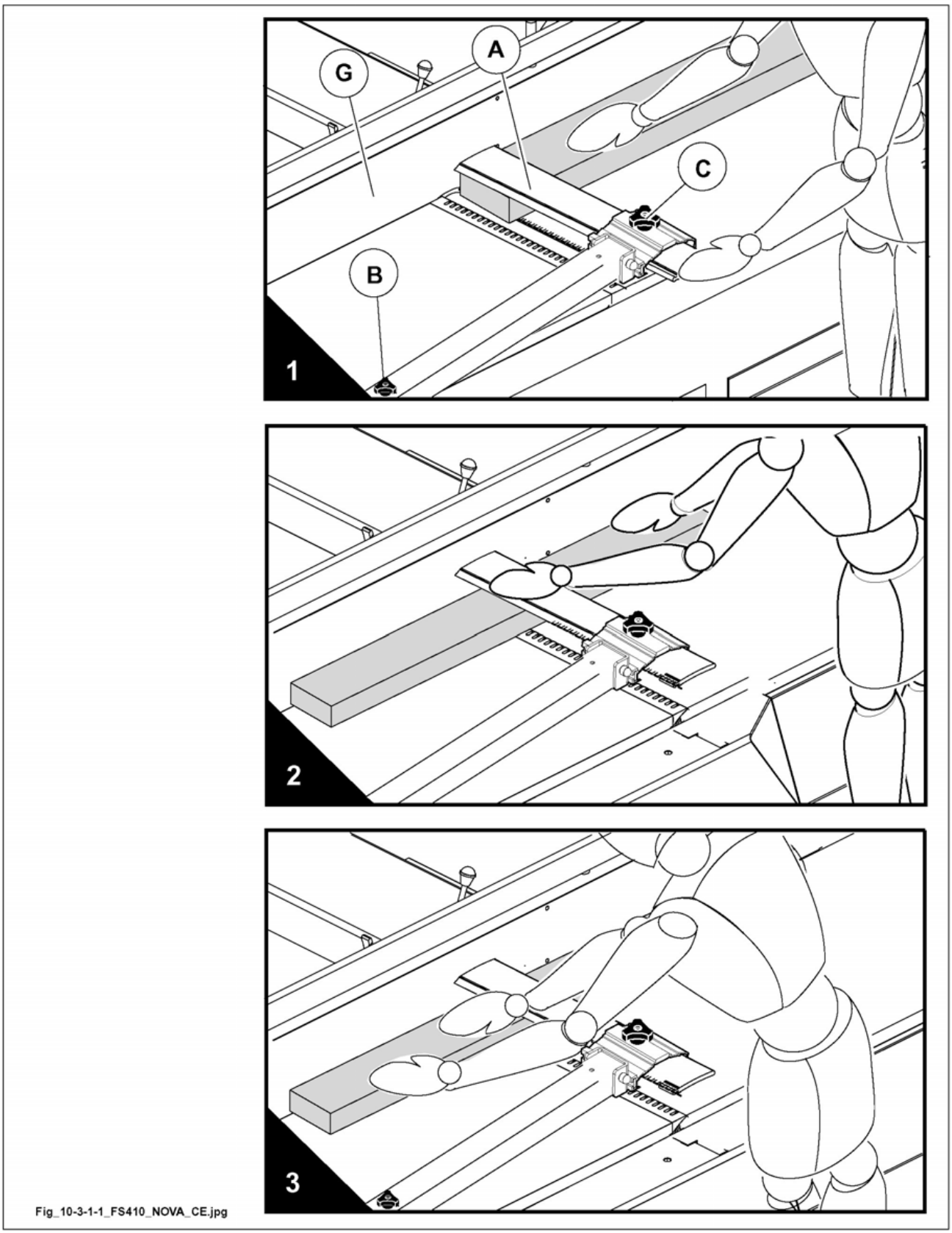


Fig. 10.3-1-1

10.3.1.2 STRAIGHTENING

(fs_10-3-1-2_0.0)

Adjusting the guard for straightening:

the bridge guard must be lowered on the tables and adjusted horizontally relative to the workpiece.

1 - Rest the bridge onto the table by means of the knob (B fig. 10.3-1-2) and expose the shaft as it is enough to let the piece to be machined pass by pulling the bridge away (A fig. 10.3-1-2), after releasing the knob (C fig. 10.3-1-2) (lock the bridge again, then).

- Press the piece against the fence towards the outlet table by keeping the left hand for example with the clenched fist and the thumb on the piece.
  With the right hand move the piece forwards in order to get a regular motion (for example cleched fist and thumb on the piece) (2 fig. 10.3-1-2).

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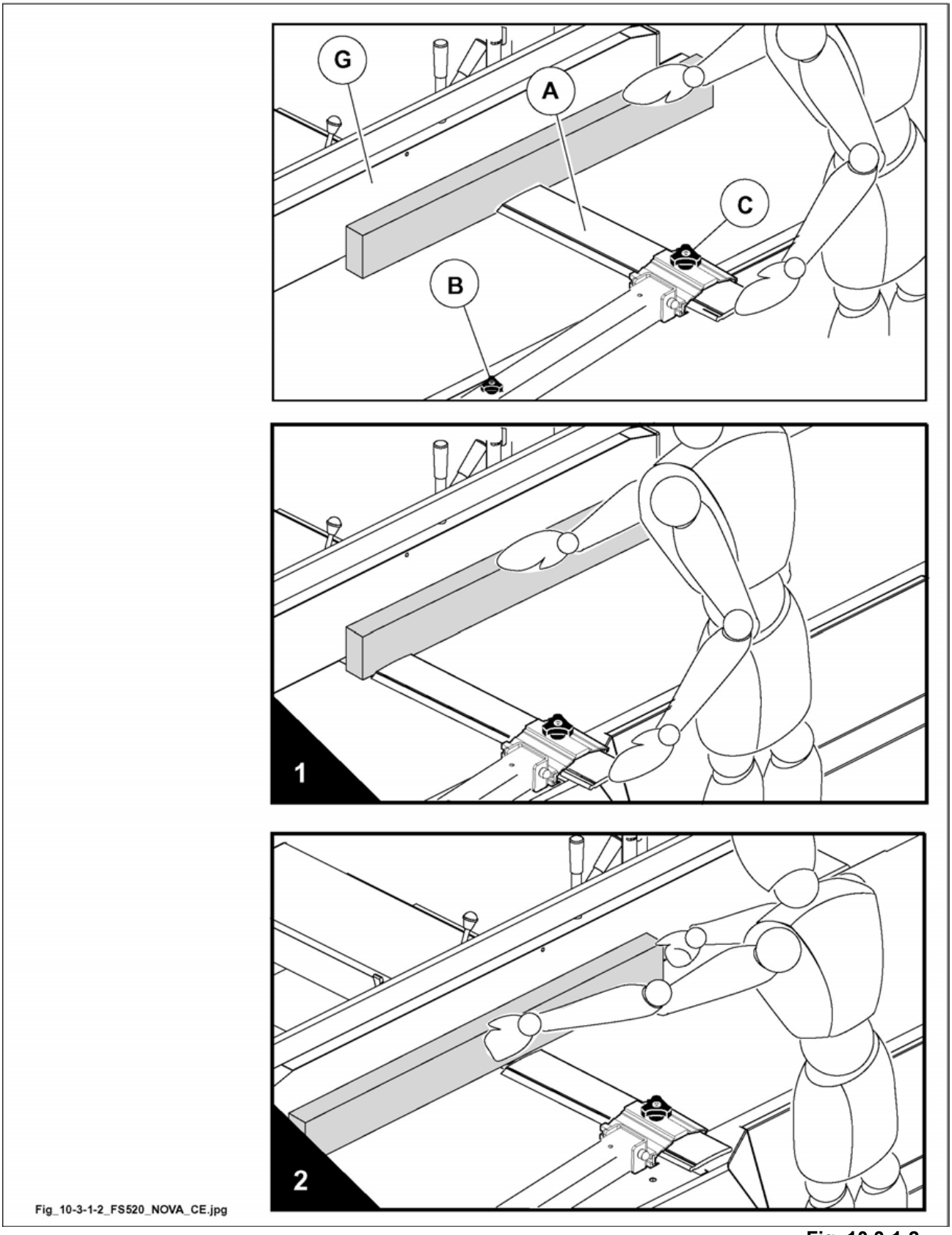


Fig. 10.3-1-2

10.3.1.3 SURFACING AND STRAIGHTENING PIECES THICKER THAN 75 MM

(fs_10-3-1-3_0.0)

The bridge of the guard shall be lower on the tables and horizontally adjusted to the piece.

1 - Rest the bridge onto the table by means of the knob (B fig. 10.3-1-3) and expose the shaft as it is enough to let the piece to be machined pass by pulling the bridge away (A fig. 10.3-1-3), after releasing the knob (C fig. 10.3-1-3) (lock the bridge again, then).
2 - Press the guard so that it rests on the outfeed table (1 fig. 10.3-1-3).

- Move the piece along the fence with regular motion by keeping the hands flat on the piece (2 fig. 10.3-1-3).

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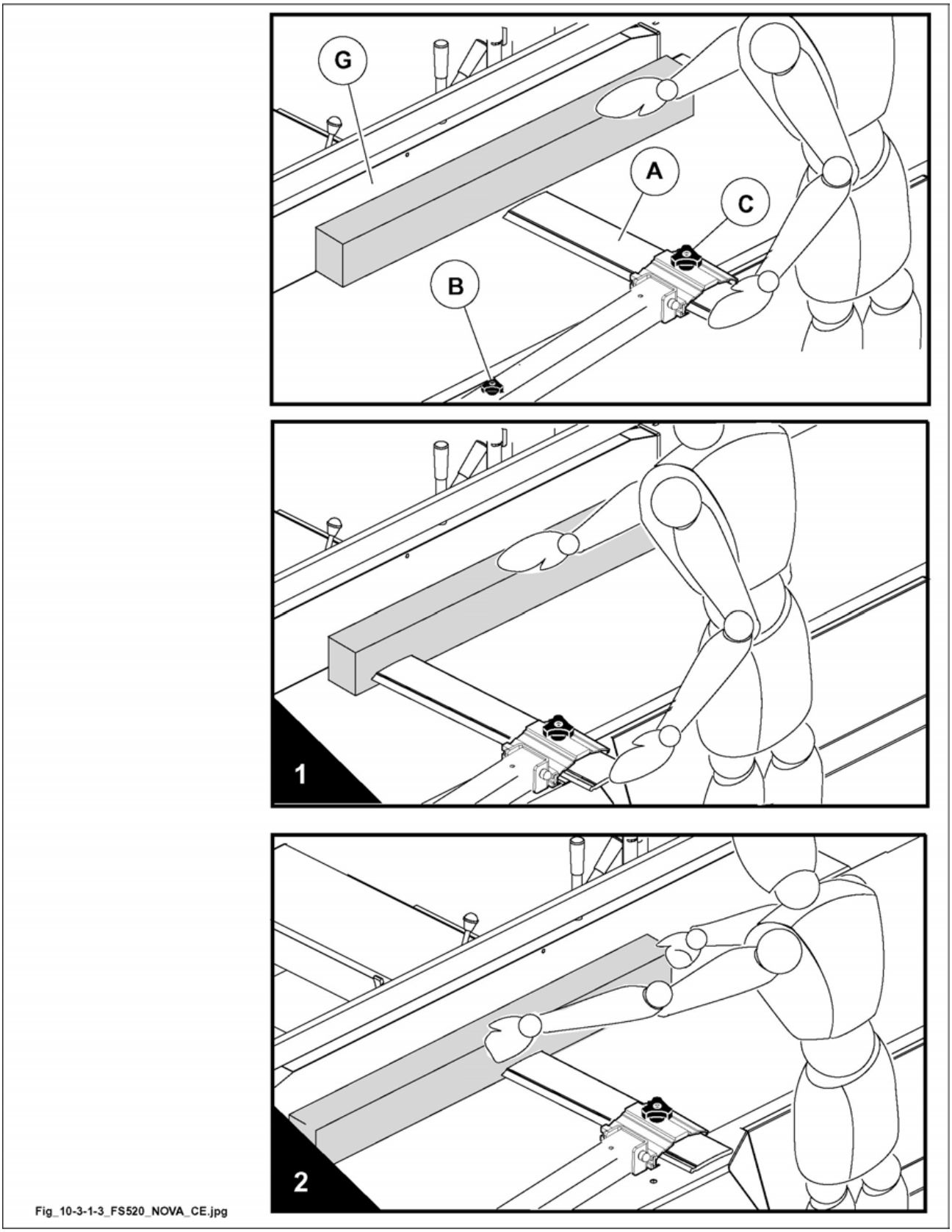


Fig. 10.3-1-3

10.3.1.4 SURFACING PIECES OF SQUARE SECTION

(fs_10-3-1-4_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

- the bridge guard must rest on the workpiece (fig. 10.3-1-4) and against the fence.
- Move the piece forwards by keeping the fingers bended.

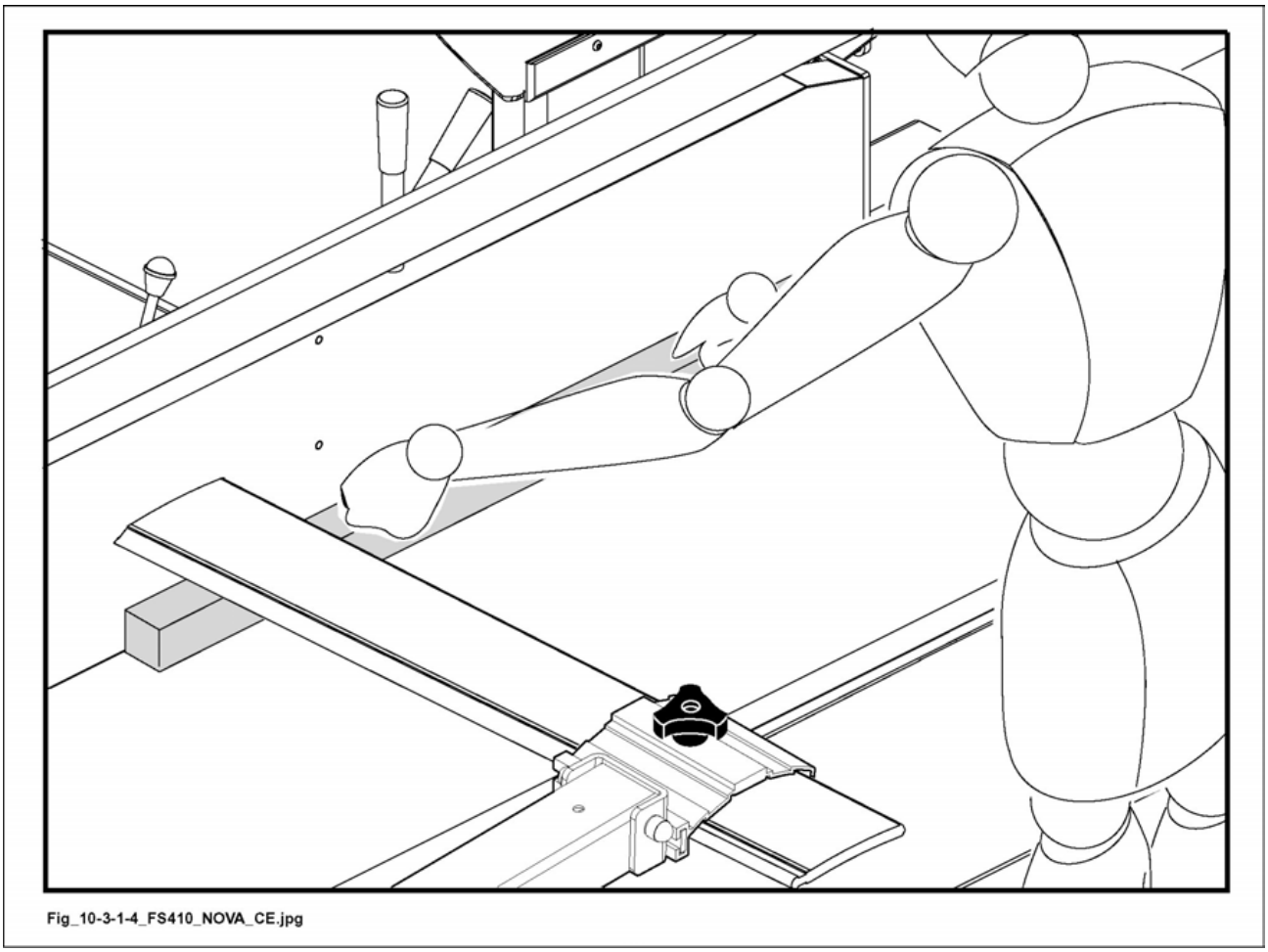


Fig. 10.3-1-4

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10.3.1.5 SURFACING SHORT PIECES

(fs_10-3-1-5_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

- Press the guard bridge on the piece by keeping the hand flat and move the piece forwards with the right hand by using a pusher.
- Rest the left hand on the guard bridge and as soon as the piece rests on the outlet table.
- The pusher shall be thinner than the workpiece.

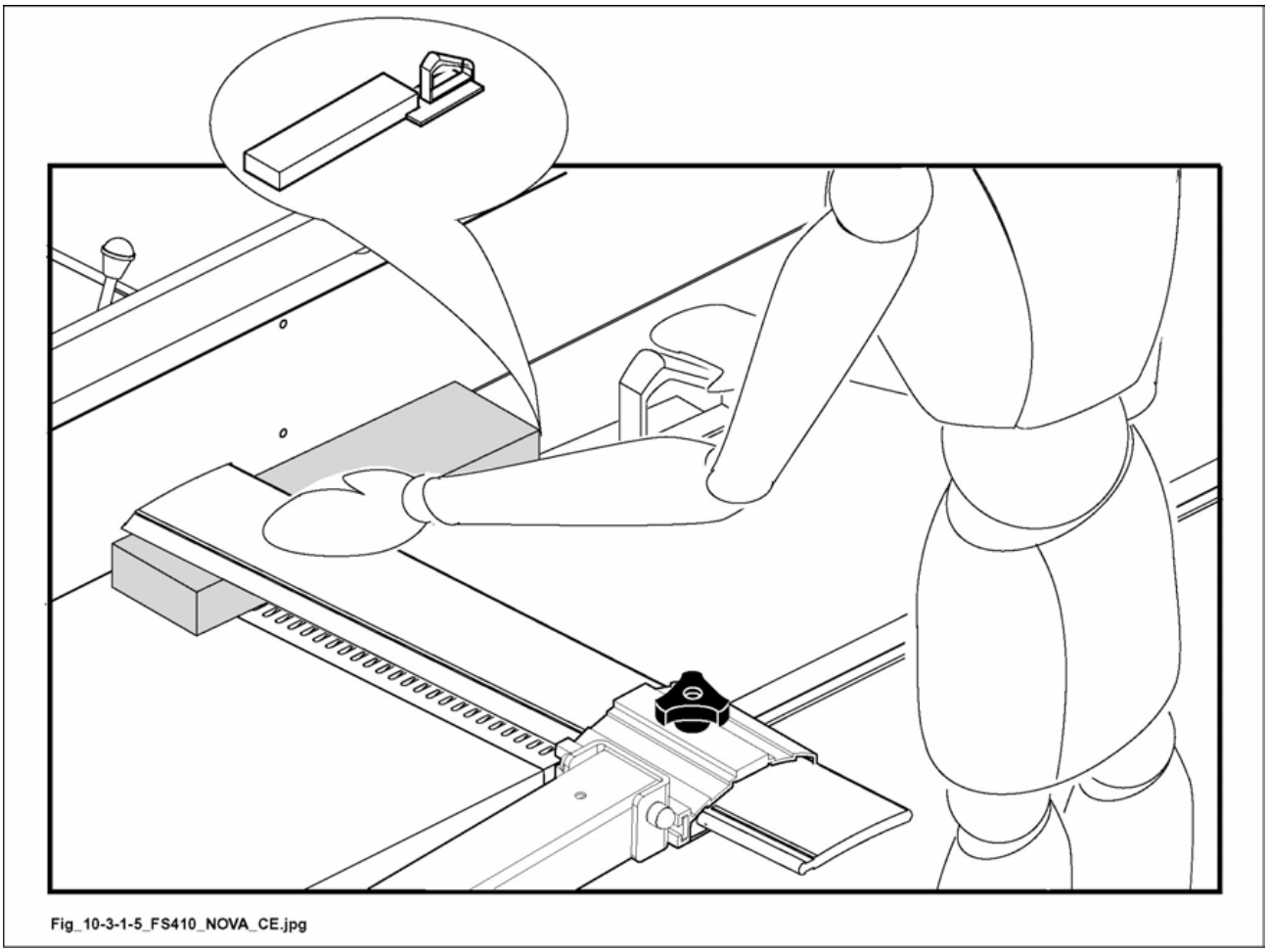


Fig. 10.3-1-5

10.3.1.6 STRAIGHTENING SHORT PIECES

(fs_10-3-1-6_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

- Move the piece along the fence and towards the outlet table by keeping the left hand with clenched fist, then with the right hand push the piece by using a pusher.

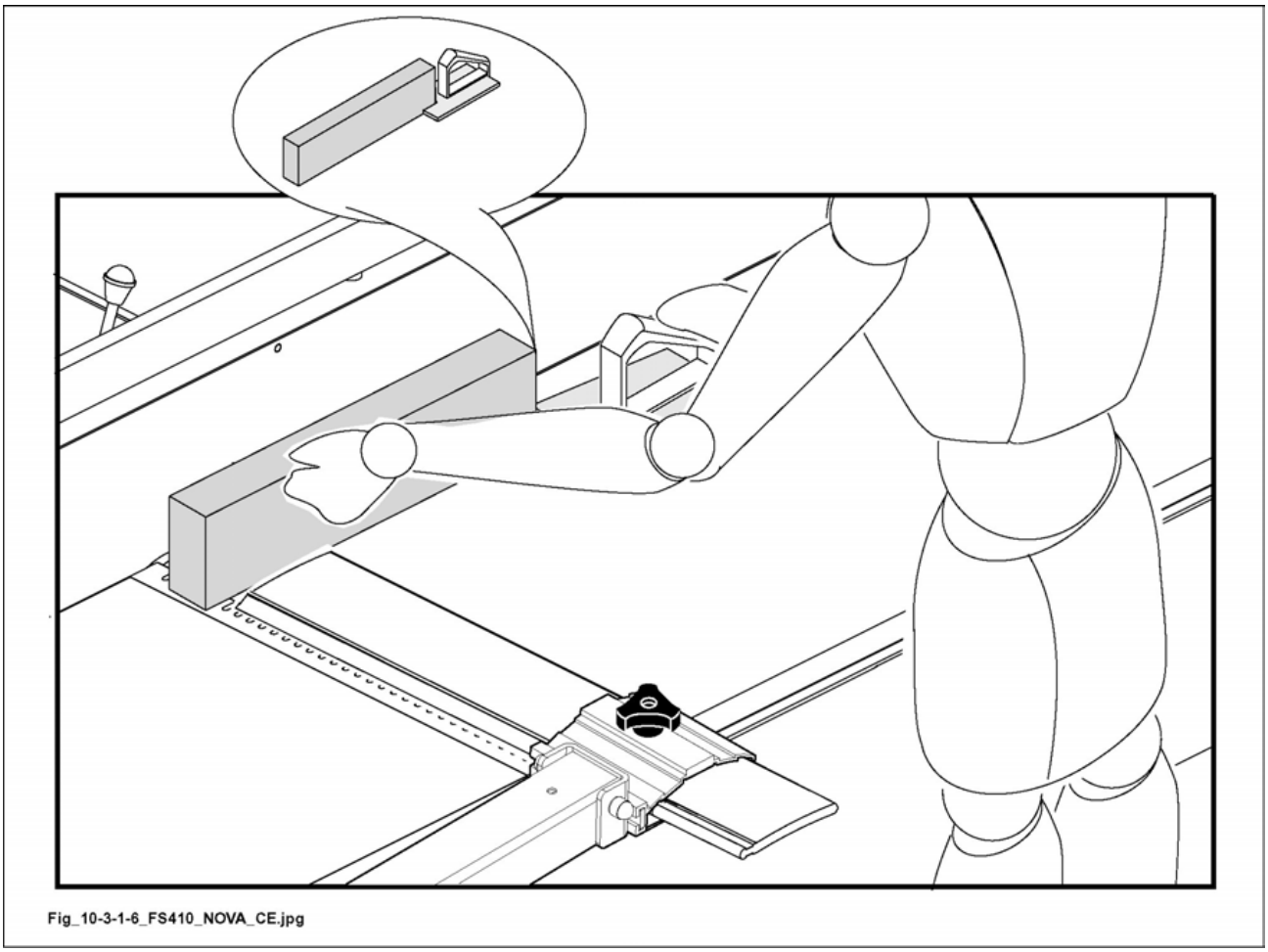


Fig. 10.3-1-6

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10.3.1.7 CHAMFERING ALONG THE FENCE

(fs_10-3-1-7_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

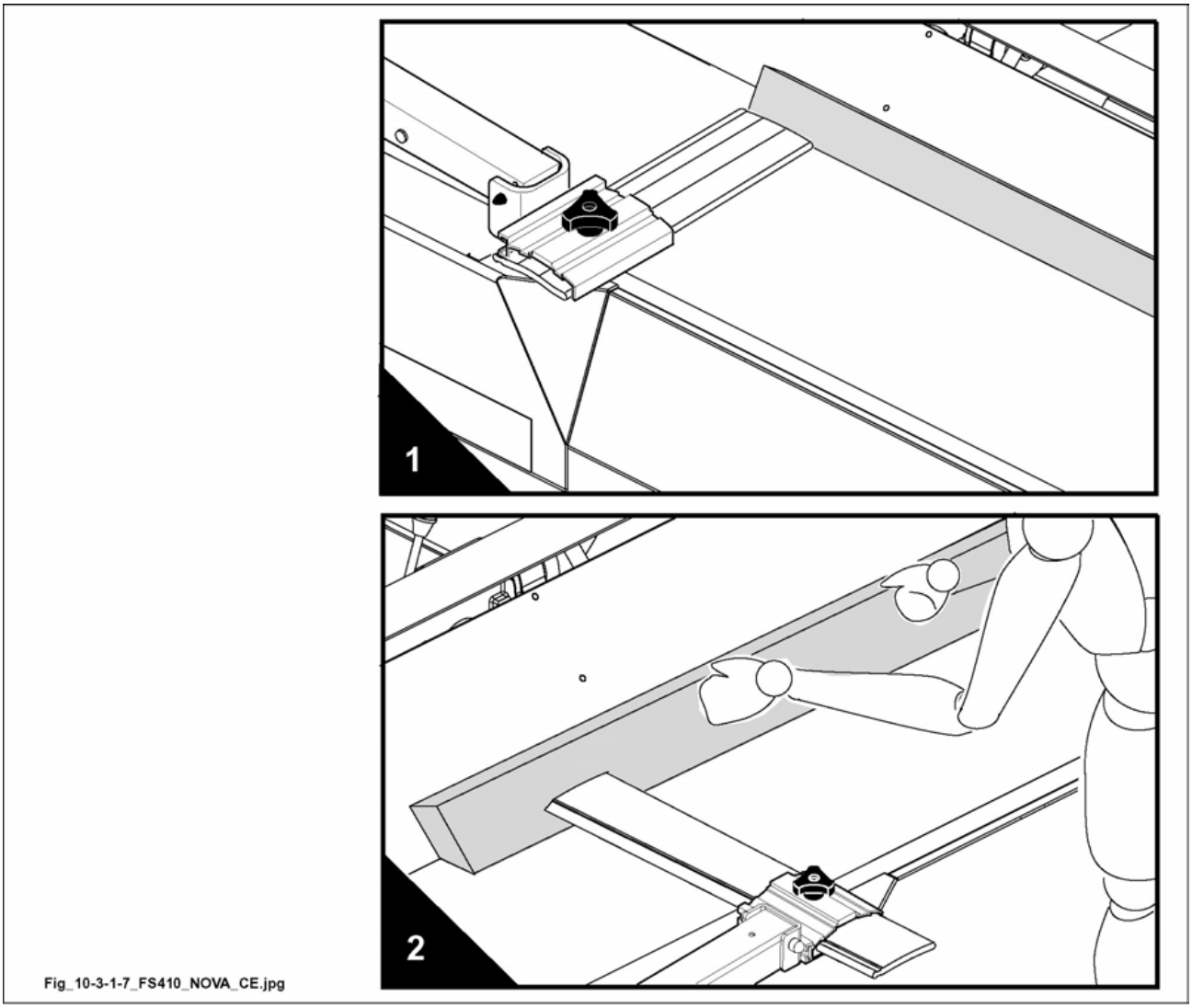


Fig. 10.3-1-7

10.3.1.8 SURFACING WORKPIECES WITH SMALL SECTION

(fs_10-3-1-8_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

Push the workpiece forwards with spread hands (fig.10.3-1-8), like in the case of workpieces with thickness lower than 75 mm (see par.10.3.1.1).

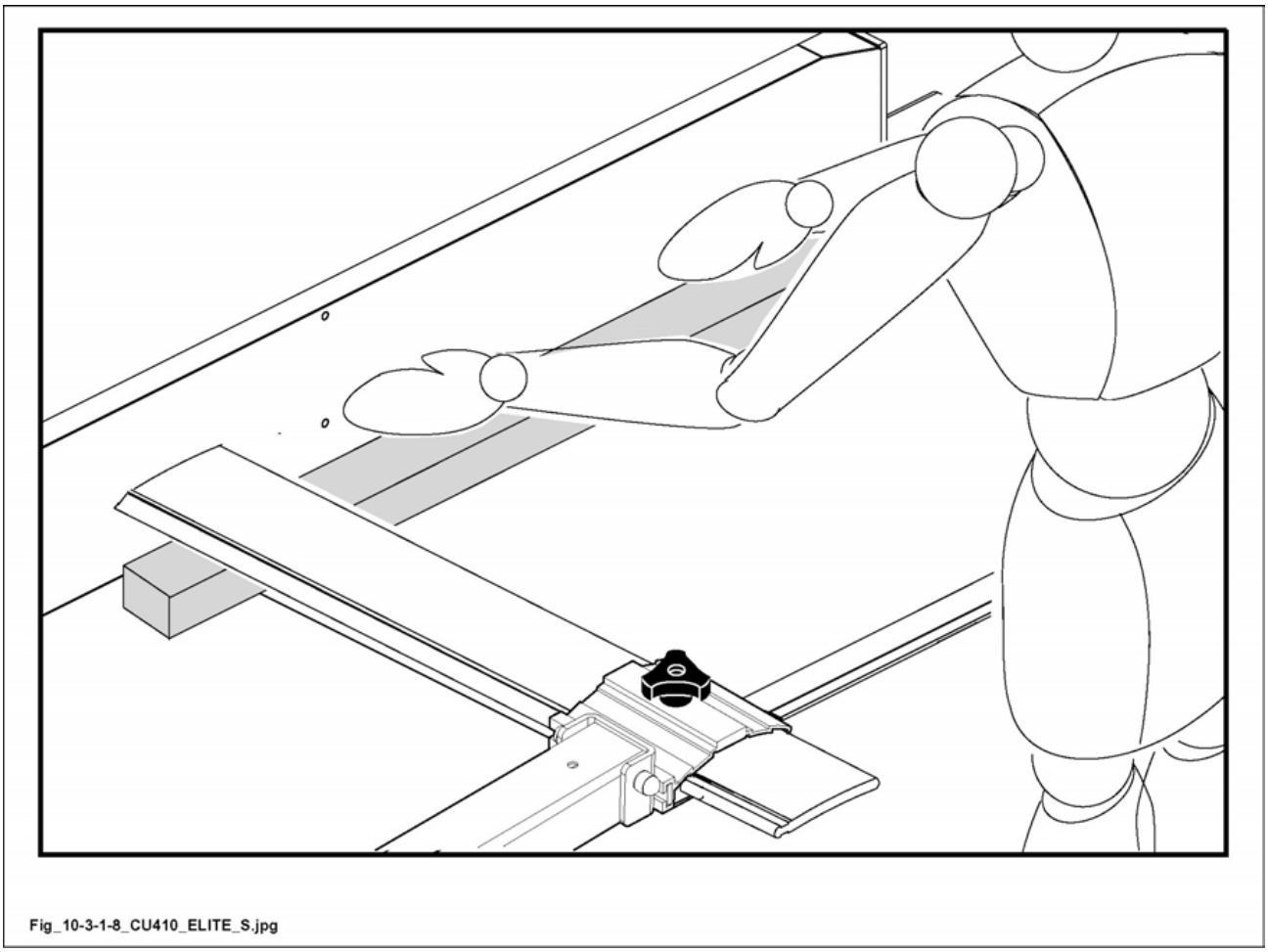


Fig. 10.3-1-8

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10.3.1.9 STRAIGHTENING WORKPIECES OF SMALL SECTION

(fs_10-3-1-9_0.0)

NOTE-INFORMATION:
adjust the bridge guard as described in the previous sections.

Press the workpiece with the hands (clenched fist) against the rule and the table (fig.10.3-1-9)and push it forwards. The guard is adjusted in horizontal direction against the fence and rests on the workpiece.

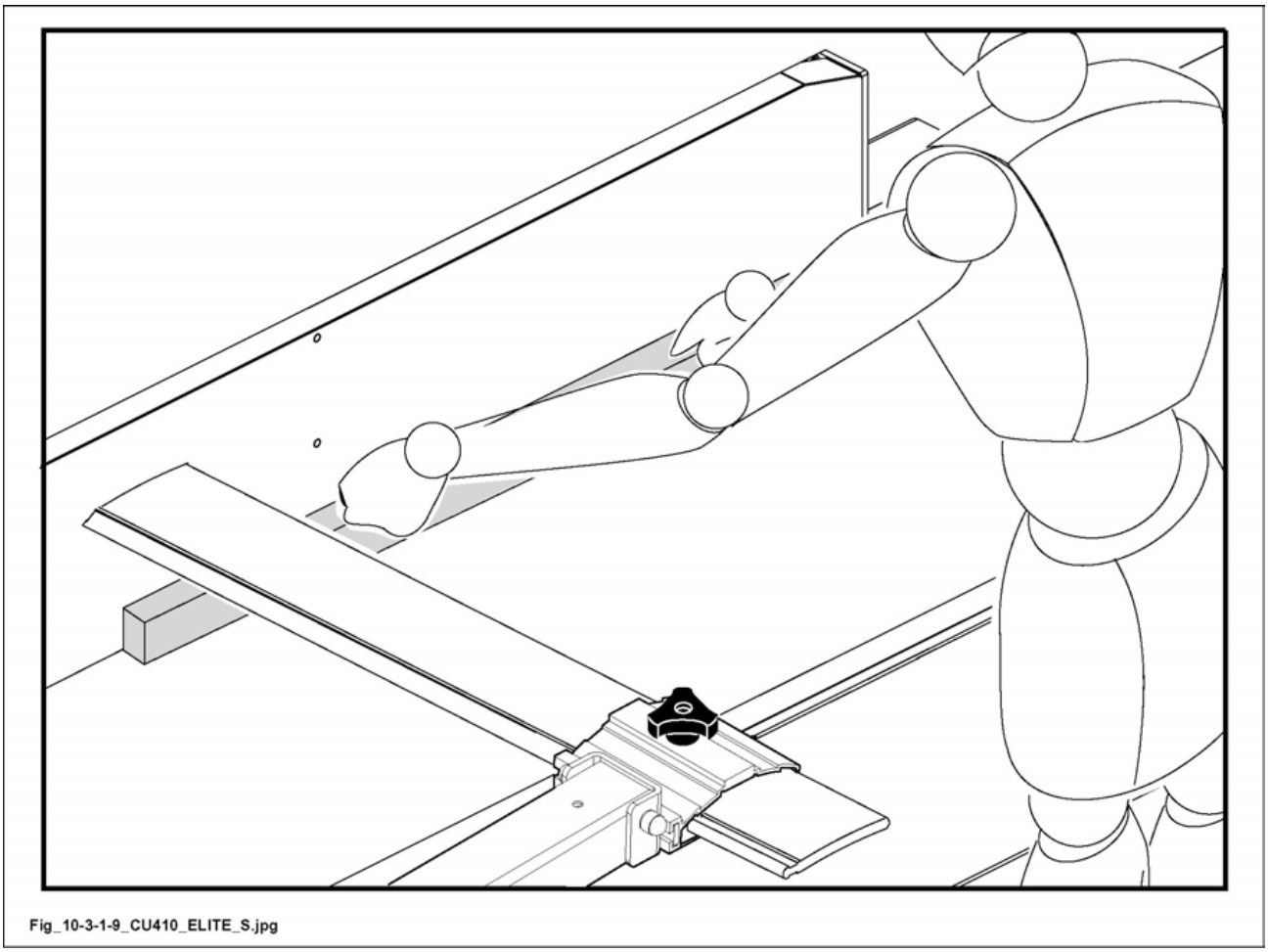


Fig. 10.3-1-9

10.5 SAFETY NOTES

(fs_10-5_0.0)

SAFETY OVER ALL

DANGER-WARNING
keep the machine edges clean and free. Take a safe position to carry out the working.

Remove the chips from the tables by using a wood piece better than your hands.

Set the guard bridge in contact with the tables.

When working the last part, the hand should always be positioned after the plane arbor, on the exit table.

The feed speed of the wood must always be proportionate to the thickness to be removed.

DANGER-WARNING
in case of seepage of chips inside the machine or in the suction hood before intervening switch off the machine and lock the main switch.

DANGER-WARNING
to improve the sliding of the workpieces treat the tables with paraffin or other proper product.

The guard serves as a safety shield, the workpiece is pressed at the outlet table level and not on the guard bridge.

Rest the concave part of the workpiece on the tables and do not machine workpieces with arched shape arcs and other too evident defects (clefts, knots etc.) or foreign bodies (nails, clips etc.).

Make sure that the workpieces are firm and use a support (not supplied by SCM***) positioned behind the the outlet table for long workpieces.***

During the working of workpieces with big thickness (panels) against the fence, lock the guard bridge as near the panel as possible to hinder the panel turnover.

Use the knob. The knob (see Section15) may be applied to pushers of different size, screwing it on with the screws provided.

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15.1 Pusher 2

15.1 PUSHER

(ev_15-1_0.0)

DANGER-WARNING:
when for the execution of a peculiar working, the operator is obliged to put his hands near the tools, for safety reasons a proper pusher shall be used to move the workpiece forwards, to push it against the fence or to remove it after the cutting.

Handle (A fig. 15.1) is supplied for this purpose and can be applied to pushers (D fig. 15.1) of different size by means of screws (B and C fig. 15.1).

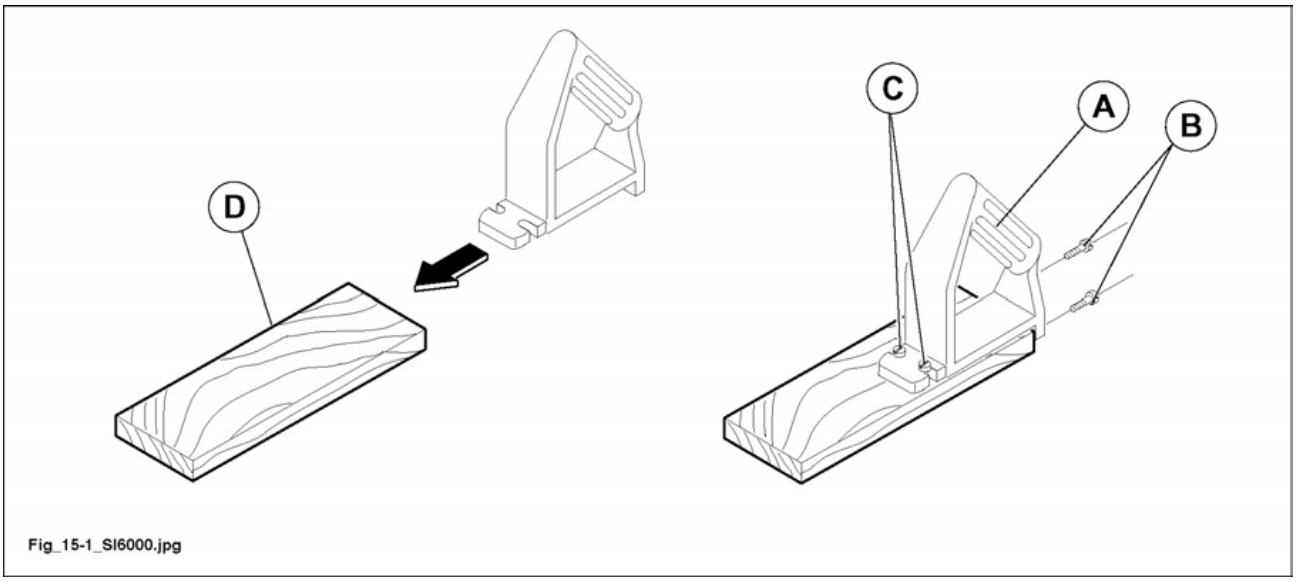


Fig. 15.1

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16.A.2 Instructions only for skilled technician authorized by SCM 2

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16.A.3 Tilting correction constant input 4

EV 200

(cu_titolo_ev 200)

ADJUSTING THE ELECTRONIC INDICATOR (Lifting only)

16.A.1 ENTERING A NEW DISPLAY NUMBER

(he_16.a.1_0.0-ce)

If the indicator gives an imprecise indication, restore adjustments as follows.

The function of the 3 front keys is hindered until you press "A/r" for more than 8 seconds.

"--------" is displayed.

Within 5 seconds press "+" and " -" key to enter the new number or press "A/r" key to set to zero (if within 10 seconds you do not press the keys, you return to the normal operation).
The value, you have entered, is stored, if for 10 seconds no key is pressed (and the message “end” is displayed to confirm this).

16.A.2 INSTRUCTIONS ONLY FOR SKILLED TECHNICIAN AUTHORIZED BY SCM

(he_16.a.2_0.0_ce)

CONSTANT INPUT

1) Within 60 seconds after switching on the display, press “+” and “-“ keys at the same time and hold them pressed until “P1” appairs.

2) Press “A/r” key: the constant, you have set, appairs on the display; by means of “+” and “-“ keys input the required constant value.

3) Press “A/r” key: the constant is stored, “P2” appairs on the display. Press “A/r” key again: the correction value is displayed.
By means of “+” and “-“ keys input the required correction value.

4) Press “A/r” key: the correction value is stored, “P2” appairs on the display. Press “A/r” key again the point position is displayed.
By means of “+” and “-“ keys move the point to the required position (0 - 0.0 - 0.00 - 0.000 - 0.0000).

5) Press “A/r” key to store the point position.

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LIST OF FACTORY SET CONSTANT				
Variables	**Moulder**		**Thicknessing**	
	mm	**Inch**	**mm**	**Inch**
P1	38	97	30	77
P2	10000	10050	0,9868	0,9972
P3	0.0	0.00	0.0	0.00

If necessary, it is possible to activate the absolute Zero function or relative Zero. Absolute Zero refers to the zero dimension determined by the worktable. Relative Zero refers to the zeroing effectuated by the operator on the basis of his requirements.

- Press the key “A/r” for at least 0.5 seconds; on the first display the letter “r” appears and the dimension is zeroed. It is possible to perform relative movements.
- To pass to absolute Zero again, press “A/r”.

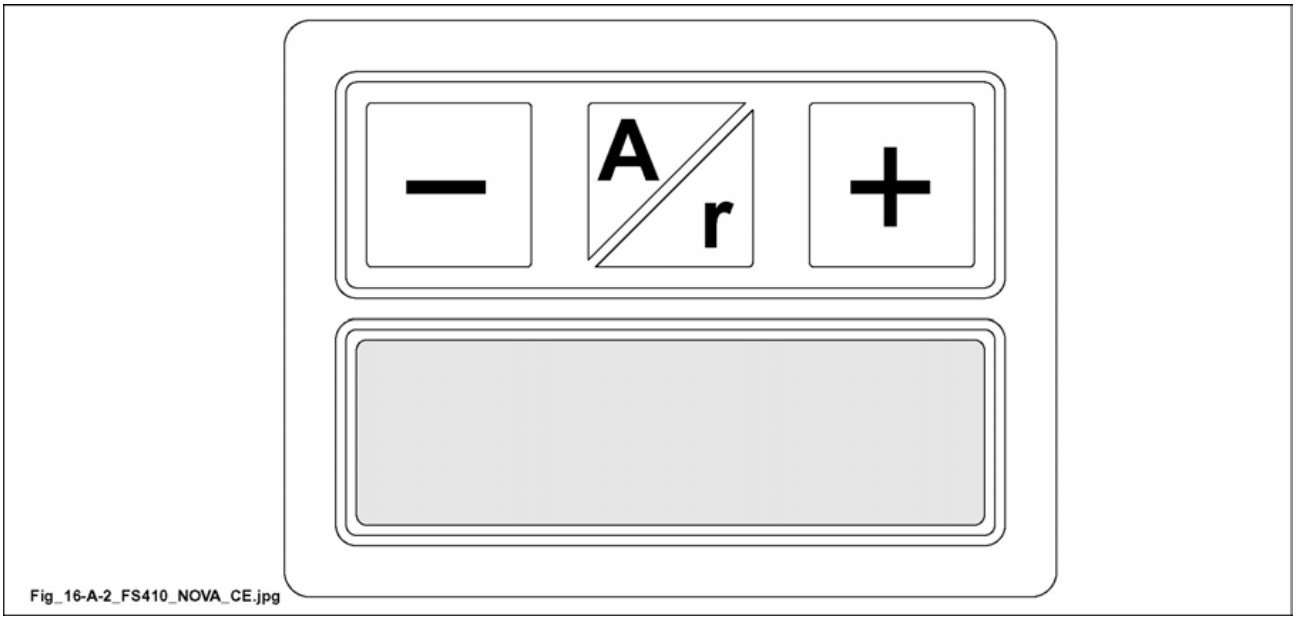


Fig. 16.A.2

EV 202

(lab_titolo_ev202)

16.A.3 TILTING CORRECTION CONSTANT INPUT

(he_16.a.3_0.0_ce)

If the indicator gives an imprecise indication, restore adjustments as follows.

The function of the 3 front keys is hindered until you press "A/r" for more than 8 seconds.
"--------" is displayed.
Within 5 seconds press "+" and " -" key to enter the new number or press "A/r" key to set to zero (if within 10 seconds you do not press the keys, you return to the normal operation).
The value, you have entered, is stored, if for 10 seconds no key is pressed (and the message “end” is displayed to confirm this).

CONSTANT INPUT

The constants are entered during the machine test at factory.

Only in case of counter replacement proceed as follows:

1) Within 60 seconds after switching on the display, press “+” and “-“ keys at the same time and hold them pressed until “P” appairs.

2) By means of “+” and “-“ keys move to the required correction value:

Operating unit	Correction constant
Saw blade tilting	**« P1 »**
Spindle moulder tilting	**« P0 »**

3) Press “A/r” key to store the chosen value.

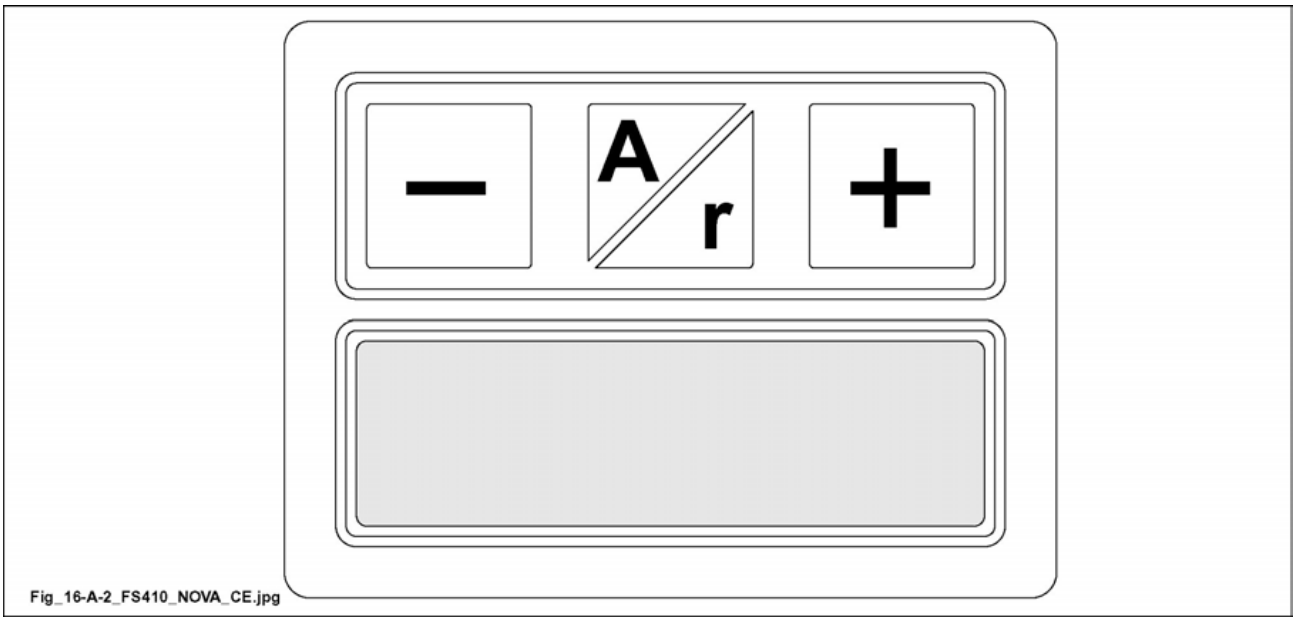


Fig. 16.A.3

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18.1 How to replace the card for D.C. motor drive 2

18.2 Card for SEPRI CMR D.C motor control 4

18.1 HOW TO REPLACE THE CARD FOR D.C. MOTOR DRIVE

(fs_18-1_0.0)

1) Shut off the power by means of main switch QS on the electric cubicle.

2) Open the door of electric cubicle by unscrewing the fixing screws and make the access to the card inside the electric box free.

3) Take off the card (S fig. 18.1) from the 4 plastic supports by bending the locking tooth; we suggest to use a small plastic pipe of proper diameter (e.g. a body pen see fig. 18.1).

4) Disconnect the 3 connectors on the card.

5) Position the dip-switches; see diagram fig. 18.1.

6) Connect the new card according to the wiring diagram, fasten the card to the door of the electric box, shut the electric cubicle before putting the machine under voltage.

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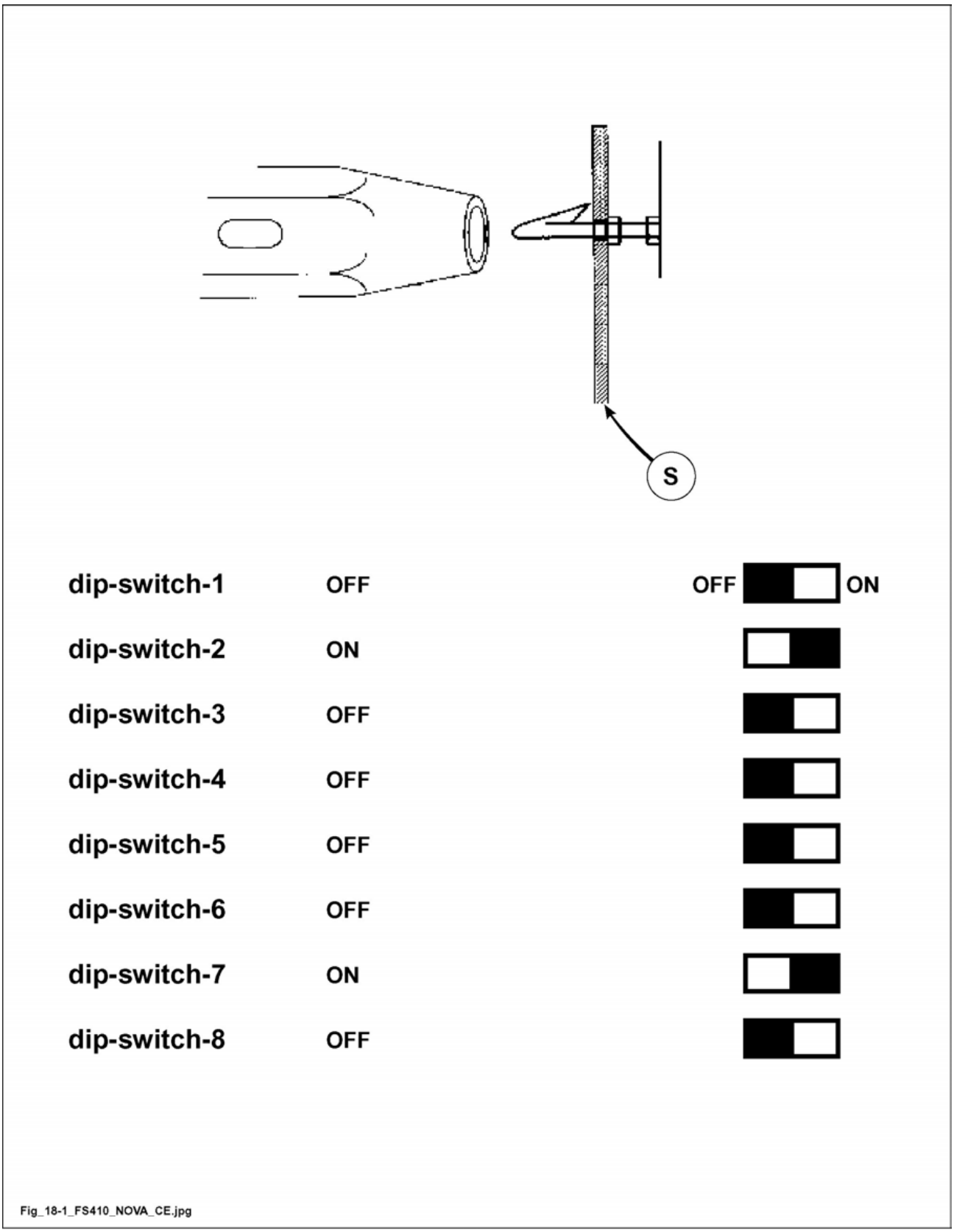

S
dip-switch-1 OFF
dip-switch-2 ON
dip-switch-3 OFF
dip-switch-4 OFF
dip-switch-5 OFF
dip-switch-6 OFF
dip-switch-7 ON
dip-switch-8 OFF
OFF
ON
Fig_18-1_FS410_NOVA_CE.jpg

Fig. 18.1

18.2 CARD FOR SEPRI CMR D.C MOTOR CONTROL

(fs_18-2_0.0)

NOTE-INFORMATION:
check the conditions for the right operation of the card.

Make sure that the following voltage values are present on the card (fig. 18.2):

1) 30 V a.c between terminals 1 and 2 of the terminal board with 10 terminals (fig. 18.2);

2) if the fuse is OK, these are the conditions to have 24 V d.c at output between terminals 3 and 4 of the same terminal board, by sending 110 V voltage (high potential) to channel A (fig. 18.2) or to channel B (fig. 18.2) of the terminal board with 8 terminals.

Otherwise, replace the card and send the defective one to SCM Technical Service.

3 leds are present on the card (E fig. 18.2) :

- red light lit: fuse of the card interrupted;
- green light lit: intervention of motor overvoltage cutout;
- yellow light lit: intervention of motor overload cutout.

CMR CONTROL CARD LEGEND	
Reference	**Description**
A	CHANNEL A - 110 V high
B	CHANNEL B - 110 V high
C	110 V low
D	EMERGENCY
E	LEDS
V a.c.	Volt - alternate current
V d.c.	Volt - direct current

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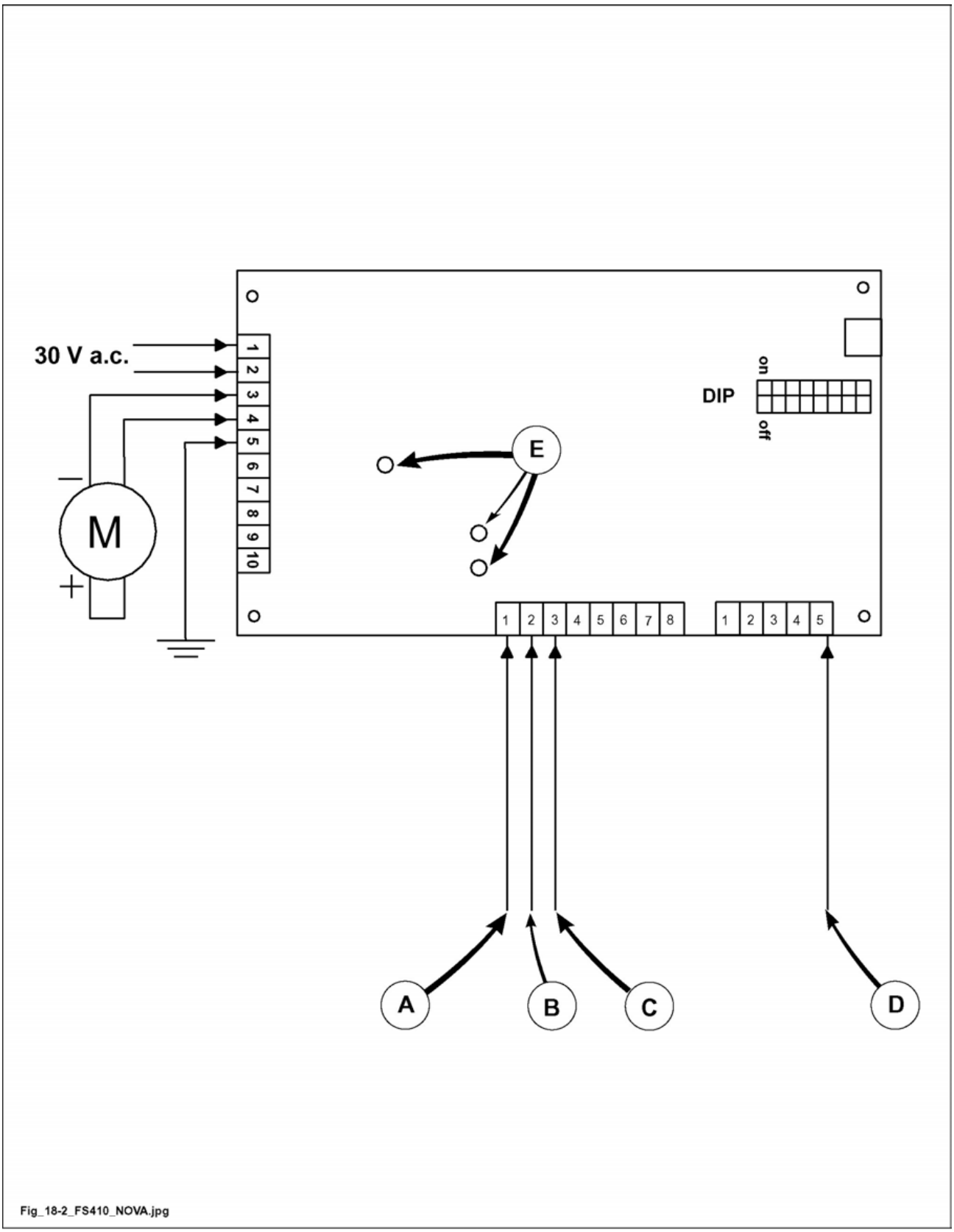

30 V a.c.
1
2
3
4
5
6
7
8
9
10
M
DIP
on
off
E
1
2
3
4
5
6
7
8
1
2
3
4
5
A
B
C
D
Fig_18-2_FS410_NOVA.jpg

Fig. 18.2

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(vuota_20-01)

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20.1 MACHINE CLEANING

(ev_20-1_0.0)

DANGER-WARNING:
all cleaning operations are to be carried out by the machine operator or by skilled technician.

DANGER-WARNING:
stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

DANGER-WARNING
to handle the knives and the cutterblock you shall wear safety gloves.

FORBIDDEN:
DO NOT USE COMPRESSED AIR; by blowing with a strong air jet (fig. 20.1) chips,dust and dirt of any type may enter into the moving members, so the machine is no more efficient.



Fig. 20.1

The general cleaning ensures the long life of the machine and is an important safety factor.

NOTE-INFORMATION:
the frequency of cleaning interventions is determined by the room in which the machine is installed and by the machined material.



Fig. 20.1A

Rules for a correct machine cleaning

SAW - MOULDER

By using a power dust aspirator (fig. 20.1A) clean:

- the tables and all cavities where you see chips and dust.
- Suction hoods (T fig. 20.1B) by checking that the are no occlusions.
- With the sliding table in position 1 (totally at entry) fig. 20.1B, then in position 2 (totally at exit), its bottom guides and specially the points indicated by arrows (H fig. 20.1B) for a 15 mm depth.
- Guides (A fig. 20.1B) of squaring frame.
- Rod (L fig. 20.1B) of the fence.
- Slideways (S fig. 20.1B) of the sliding table and (B fig. 20.1B) of the rail.
- Extension (D fig. 20.1B) of pivoting arm.
- Groove (C fig. 20.1B), tile-shaped stop and presser with a brush or cloth drunken with not dangerous solvent.

- Spindle sliding cylinder (F fig. 20.1B).
- Presser unit sliding rods (G fig. 20.1B).
- Moulder spindle lifting screw (V fig. 20.1B).

Then by using a cloth or a brush drunken with a proper and not dangerous product,
clean all moving parts specially the ones exposed to the resin and dust.

DANGER-WARNING:
do not oil, do not grease:
- the guides of sliding table (S fig. 20.1B) and of rail (B fig. 20.1B) .

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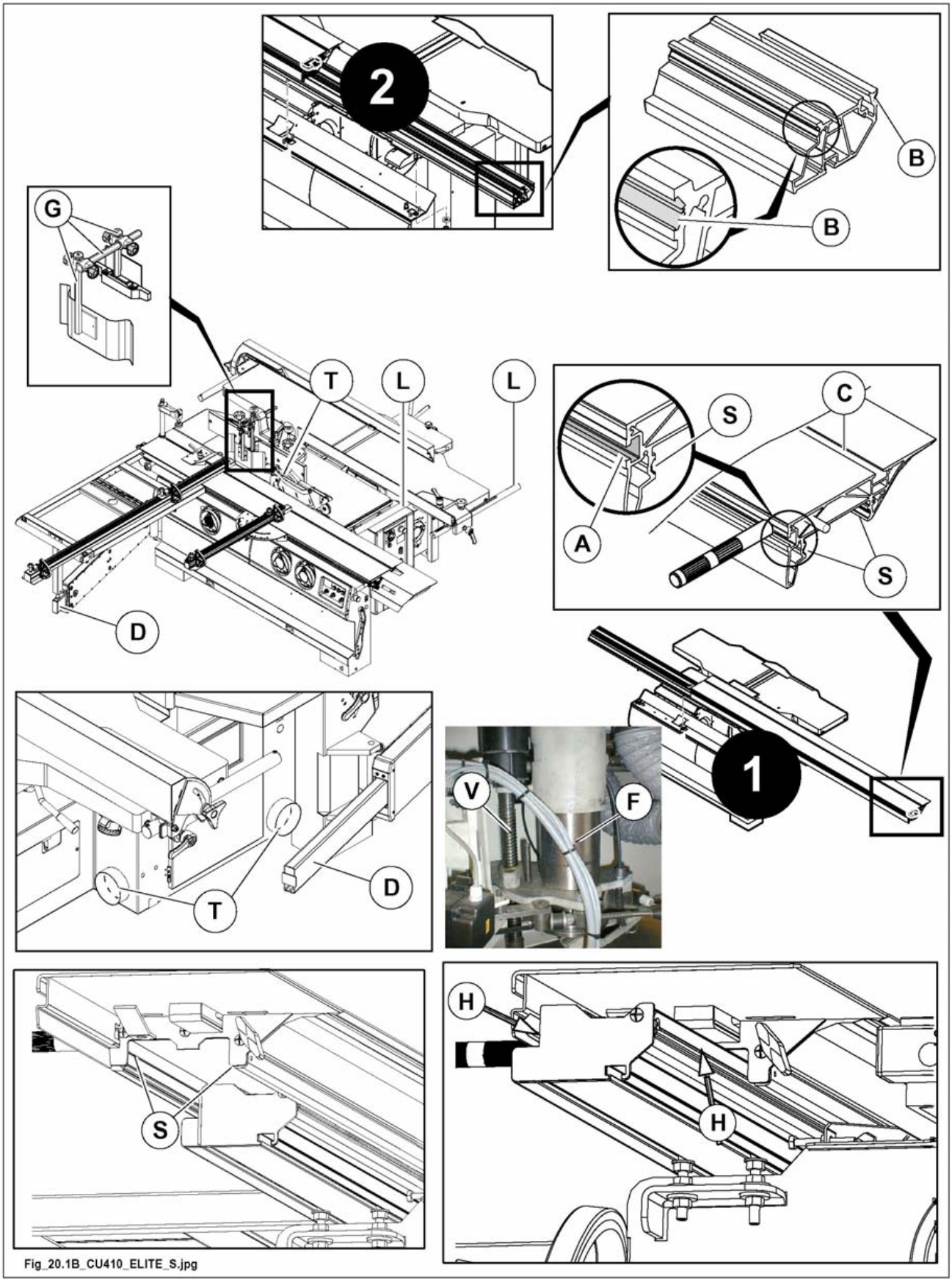


Fig. 20.1B

Rules for a correct machine cleaning

SURFACE PLANING AND THICKNESSING MACHINE

Every evening by using a proper aspirator clean:
- the table, cutterblock, anti kickback fingers and the cavities where you see dust and chips seepage;
- periodically clean the rubber rollers by using not dangerous products; never use acid products;
- suction hoods (C fig.20.1) by checking that there are no occlusions.

Never use acid products.

After sucking chips or dust, with a cloth drunken with a not dangerous solvent clean:
- all moving parts, particularly the ones exposed to the resin and to the dust;
- knives (B fig. 20.1C) of the cutterblock;
- sliding rod (D fig. 20.1C) of planer guide;
- dovetail elements (E fig. 20.1C) for mortiser sliding (OPT);
- sliding rods (P fig. 20.1C) of mortising table (OPT);
- Screw (V fig. 20.1C) for (OPT) mortiser height adjusting.



FORBIDDEN:
NEVER OIL OR GREASE THE ANTI-KICK BACK FINGERS.

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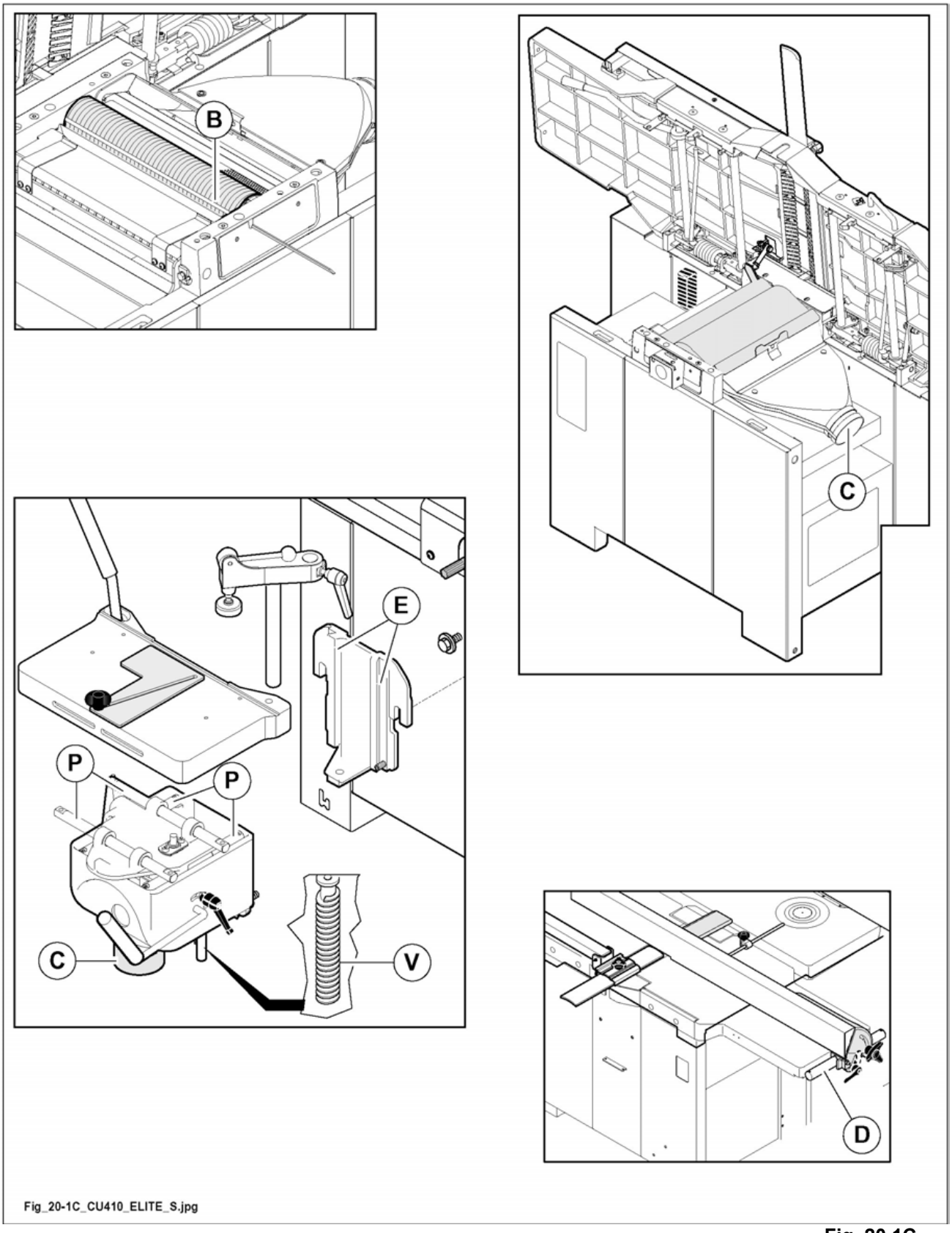


Fig. 20.1C

20.2 SCHEDULED MAINTENANCE

(ev_20-2_0.0)

Scheduled maintenance is of the utmost importance to obtain the best performance as well as a safe operation of the machine.

SAW - MOULDER

DESCRIPTION	INSPECTION	INTERVALS	OPERATIONS
General machine cleaning	Visual inspection	Daily	- Clean with a vacuum cleaner (Par.20-1).
Slideways (S fig. 20.1B) of the sliding table	Visual inspection	Weekly	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product. - **Do not oil, do not grease.**
Guides (A fig. 20.1B) of squaring frame	Visual inspection	Daily	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product.
Slideways (B fig. 20.1B) of the rail	Visual inspection	Weekly	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product. - **Do not oil, do not grease.**
Cleaning the suction hoods (T fig. 20.1B)	Visual inspection	Weekly	- Disconnect the hoses from the suction hoods, make sure that there are no occlusions and clean by means of an aspirator.
Extension (D fig. 20.1B) of swinging support	Visual inspection	Weekly	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product.
Rod (L fig. 20.1B) of the fence	Visual inspection	Daily	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product.
Elements (C fig. 20.3) of scorer unit	Visual inspection	Every 2 weeks	- With aspirator remove chips and dust (Par. 20.1); then lubricate with grease (Par. 20.3).
Wroms (A fig. 20.3) for height adjusting and tilting	Visual inspection	Weekly	- Lubricate with grease (Par. 20.3).
Right and left guides (D fig. 20.3) for the saw blade tilting.	Visual inspection	Weekly	- Lubricate with grease (Par. 20.3).
Guides (E fig. 20.3) for height adjusting of the saw blade	Visual inspection	Weekly	- Lubricate with grease (Par. 20.3).

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DESCRIPTION	INSPECTION	INTERVALS	OPERATIONS
Sliding cylinder (F fig. 20.1B) of the spindle.	Visual inspection	Daily	- With aspirator remove chips and dust (Par. 20.1).
Sliding rods (G fig. 20.1B) of presser unit.	Visual inspection	Daily	- With aspirator remove chips and dust (Par. 20.1). - With a cloth or a brush drunken with proper and not dangerous product.
Worm (V fig. 20.1B) for spindle height adjusting	Visual inspection	Weekly	- Lubricate with grease (Par. 20.3).
Saw driving	Tensioning and wear check	Every 6 months	- Tension properly or replace whenever necessary (Par. 20.23 - 20.18).
Safety and emergency devices (Chap. 2)	Visual check and operation test	Every 2 weeks	- Carry out some stopping tests (Par. 20.7).

SURFACE PLANING AND THICKNESSING MACHINE

DESCRIPTION	INSPECTION	INTERVALS	OPERATIONS
General machine cleaning	Visual inspection	Daily	- By using an aspirator remove dust or chips (Par. 20.1).
Tools (B fig. 20.2) of the planer unit	Visual inspection	Daily	- By using an aspirator remove dust or chips (Par. 20.1). - Clean with a cloth or brush soaked in a suitable product which is not dangerous.
Sliding rod (D fig. 20.2) of planer guide	Visual inspection	Weekly	- By using an aspirator remove dust or chips (Par. 20.1). - Clean with a cloth or brush soaked in a suitable product which is not dangerous. - Lubricate with oil (Par. 20.3).
Cleaning of suction hoods (C fig. 20.2)	Visual inspection	Weekly	- Disconnect the flexible tubes from suction hoods, check that there are no occlusions and clean by sucking.
Dovetail elements (E fig. 20.2) for sliding mortiser (OPT)	Visual inspection	Weekly	- By using an aspirator remove dust or chips (Par. 20.1). - Clean with a cloth or brush soaked in a suitable product which is not dangerous. - Lubricate with oil (Par. 20.3).
Sliding rods (P fig. 20.2) of mortiser table (OPT)	Visual inspection	Weekly	- By using an aspirator remove dust or chips (Par. 20.1). - Clean with a cloth or brush soaked in a suitable product which is not dangerous. - Lubricate with oil (Par. 20.3).
Screw (V fig. 20.2) for motiser height adjusting (OPT)	Visual inspection	Weekly	- By using an aspirator remove dust or chips (Par. 20.1). - Clean with a cloth or brush soaked in a suitable product which is not dangerous. - Lubricate with grease (Par. 20.3).
Thicknessing table (H fig. 20.2)	Visual inspection	Daily	- Clean with a vacuum cleaner.

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DESCRIPTION	INSPECTION	INTERVALS	OPERATIONS
Cleaning the moving parts, particularly the ones exposed to the resin and to the dust	Visual inspection	Weekly	- Clean with proper detergents.
Table lifting chain	Visual inspection	Weekly	- Clean and lubricate (Par. 20.3).
Feed rollers	Visual inspection	Daily	- Clean with proper detergents.
 Anti kickback fingers (L fig. 20.2)	Visual inspection	Daily	- By using an aspirator remove dust or chips (Par. 20.1). Clean with proper detergents. - **Do not oil, do not grease.**
	Visual inspection	After 1 working hour	- **Check that the anti-kick back fingers are efficient.**
Operator units' belts (O fig. 20.2)	Check tensioning and wear	Every 1000 hours	- Tension correctly (Par. 20.28) or replace (Par. 20.18) if necessary.
Safety and emergency devices (Chapter 2)	Visual check and check functioning	Every 2 weeks	- Perform stop tests (Par. 20.4).

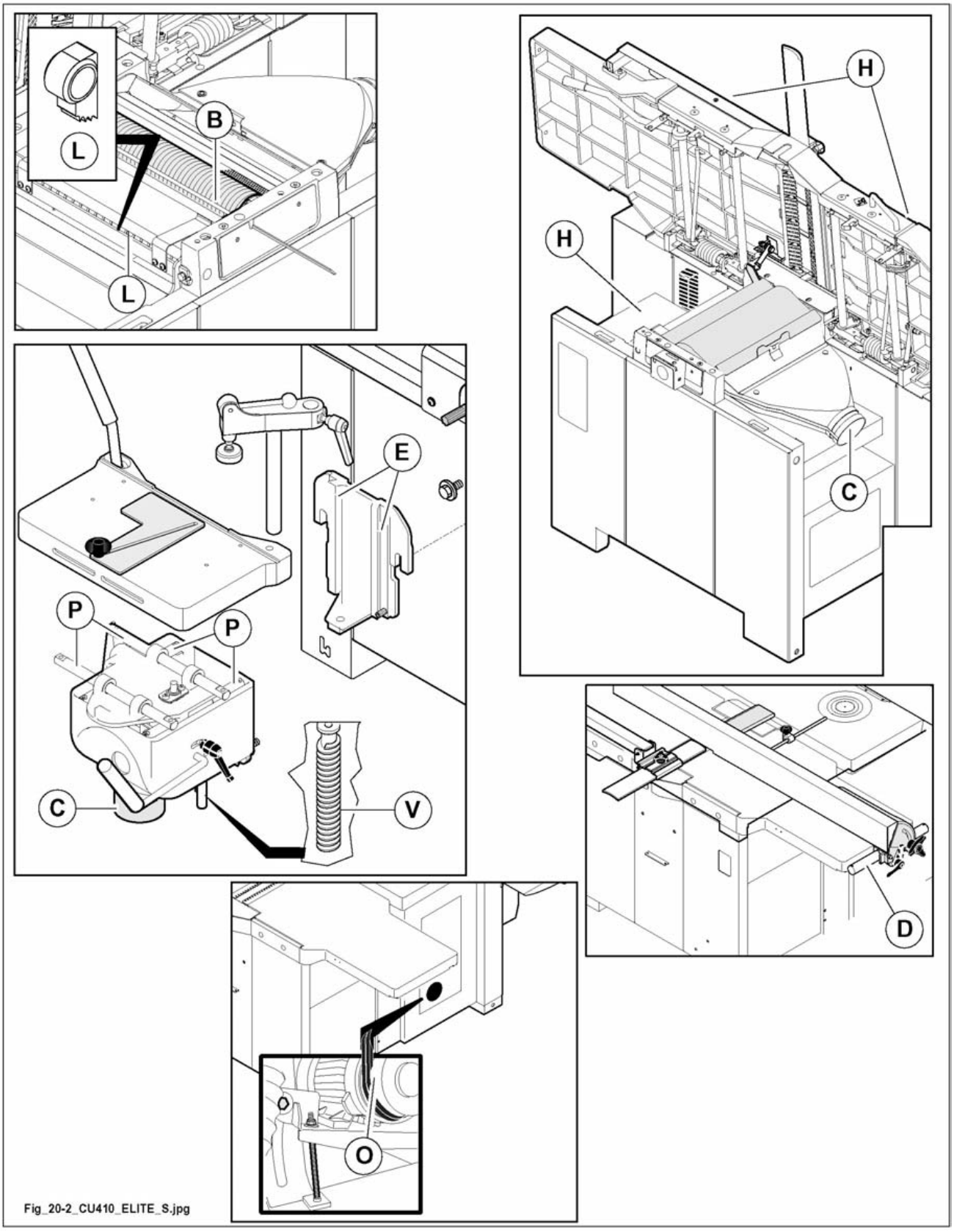


Fig. 20.2

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(vuota_cu_20-02)

20.3 LUBRICATION

(ev_20-3_0.0)

The accurate lubrication ensures the long life as well as the best performance of the machine.

SAW - MOULDER

Weekly lubricate with grease:

Manufacturer	Lubricant name
AGIP	GR MU EP1
ARAL	ARALUB HL1
BP	GREASE LTX1
SHELL	SUPER GREASE EP1
MOBIL	MOBILPLEX 46
KLÜBER	CENTOPLEX 1
ESSO	BEACON EP0

1) worms (A fig. 20.3) for height adjusting and tilting of the saw blade.
2) Right and left guides (D fig. 20.3), for the saw blade tilting.
3) Guides (E fig. 20.3) for height adjusting of the saw blade.
4) Moulder spindle lifting screw (V fig. 20.3)
5) Moulder spindle inclination screw (W fig. 20.3) OPT

DANGER-WARNING:
do not oil, do not grease:
- the guides of sliding table (S fig. 20.1B) and of rail (B fig. 20.1B) .

NOTE-INFORMATION:
- as all bearings are sealed and lubrificated-for life, they do not require any maintenance;
- when you have to replace these bearings directly apply to SCM ***spare parts department;***
- bearings of other makes, with corresponding names, are NOT suitable.

NOTE-INFORMATION:
protect all belts and pulleys to avoid contamination with oil.

NOTE-INFORMATION:
the top bearings of the spindle are special.

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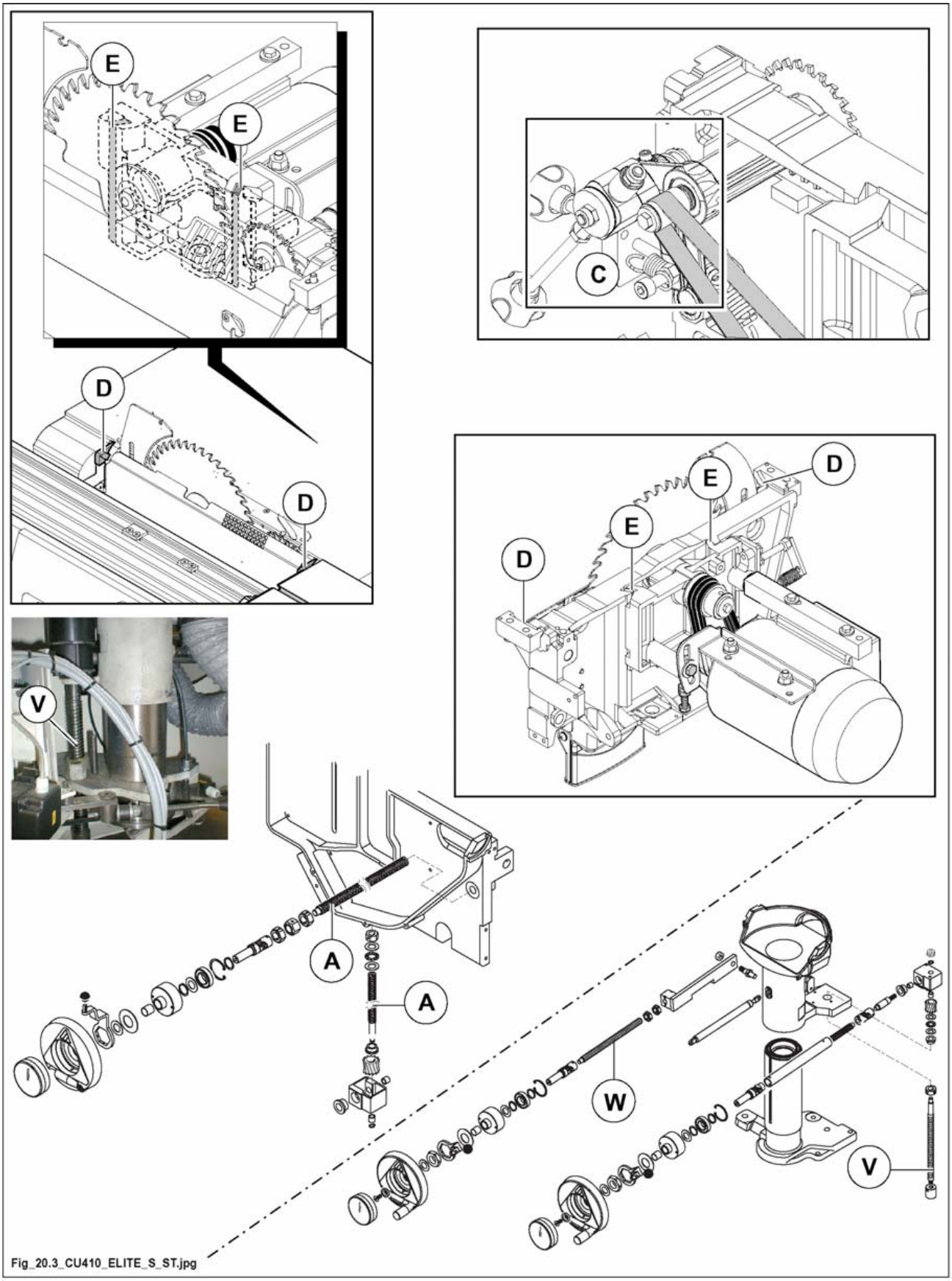


Fig. 20.3

SURFACE PLANING AND THICKNESSING MACHINE

Weekly lubricate with grease:

Manufacturer	Lubricant name
AGIP	GR MU EP1
ARAL	ARALUB HL1
BP	GREASE LTX1
SHELL	SUPER GREASE EP1
MOBIL	MOBILPLEX 46
KLÜBER	CENTOPLEX 1
ESSO	BEACON EP0

1) worm (V fig.20.3A) for lifting the mortiser (OPT).

Lubricate with oil here indicated:

Manufacturer	Lubricant name
AGIP	EXIDIA 220
ARAL	DEGANIT B 220
BP	ENERGOL GHL 220
SHELL	TONNA OIL T220
MOBIL	VACTRA OIL N° 4
KLÜBER	LAMORA SUPER POLADD 220
ESSO	FEBIS K 220

1) sliding rod (D fig. 20.3A) on planer guide.
2) Dovetail elements (E fig. 20.3A), for mortiser to slide (OPT).
3) Sliding rods (P fig. 20.3A) of mortiser table (OPT).
4) Transmission chain (A fig. 20.3A) of the motion to the feed rollers.
5) Table lifting chain (N fig. 20.3A).

NOTE-INFORMATION:
- as all bearings are sealed and lubrificated-for life, they do not require any maintenance;
- when you have to replace these bearings directly apply to SCM ***Ufficio Ricambi;***
- bearings of other makes with corresponding names are NOT suitable.

NOTE-INFORMATION:
protect all belts and pulleys to avoid contamination with oil.

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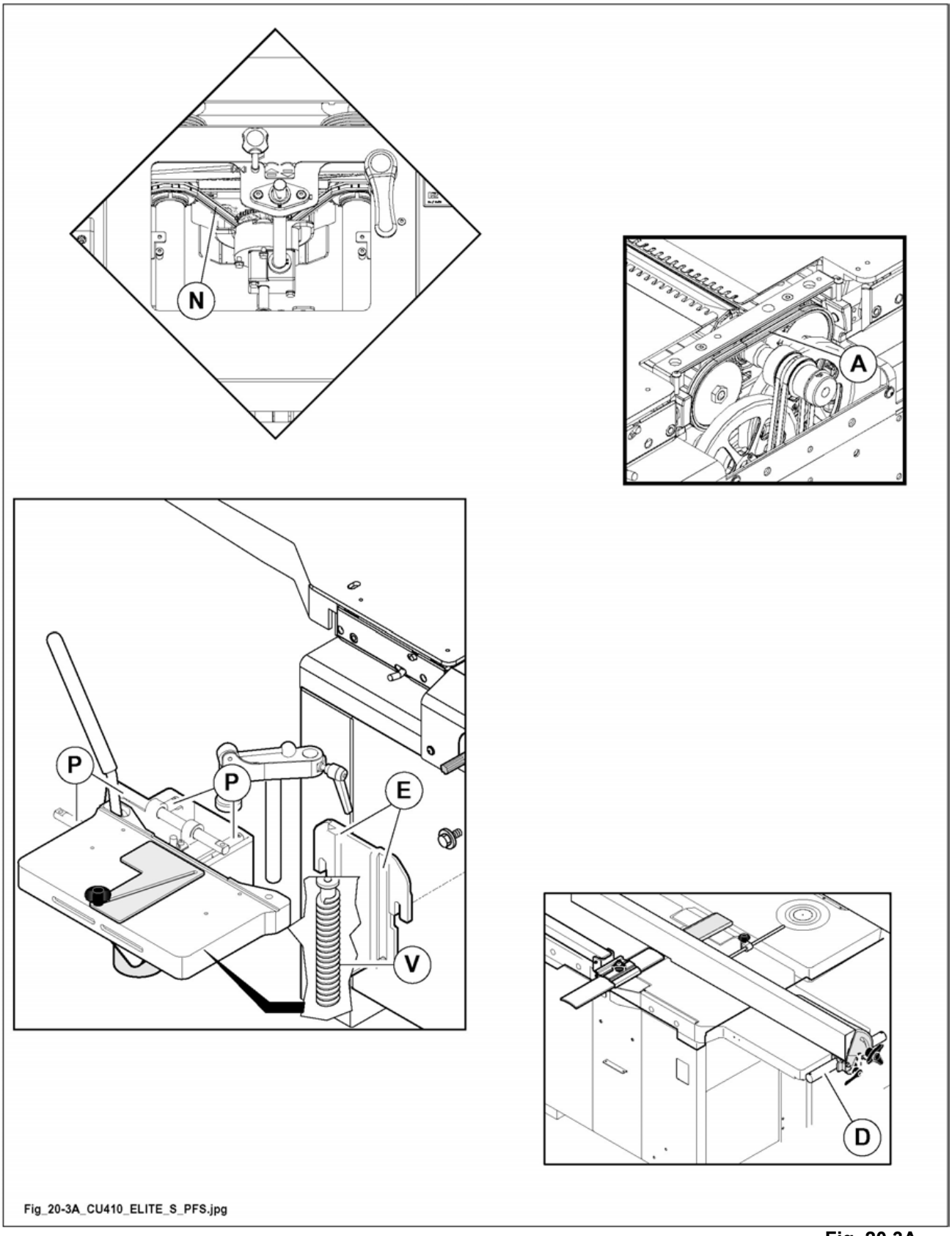


Fig. 20.3A

20.7 CHECK OF SAFETY DEVICES

(ev_20-7_0.0)

The machine is equipped with safety devices described in Chapter 2 which ensure tha safe machine operation.

Every 2 weeks check the controls for emergency stops with a test.
With the machine under normal operating conditions press the emergency buttons arranged on the machine one at a time; the motor shall stop.

Every 2 weeks check that micro switches on the bottom saw blade guard:
with open guard, the saw motor shall not start.

Every 2 weeks check that the moulder splindle block microswitch is operating efficiently. With the splindle blocked the spindle moulder motor should not start up.

Every 2 weeks check that the microswitches are efficient.
With the machine under normal operating conditions, by opening the door of the motor housing the spindle motor shall stop.

Every 2 weeks check that the microswitches are efficient.
Plane microswitch: stops machine when planing tables tip.
Enable the planer operating unit for processing to the thickness if the chip conveyor protection is turned upside down.

WITH (OPT) 2 SPEEDS
Every 2 weeks check the microswitches under the cover in the belt change area, with open cover the saw motor shall not start.

NOTE-INFORMATION:
- the belt slackening may cause an increase of the braking time, therefore make sure that the belts are stretched and in good conditions (see par. 20.23).

- Every 2 months or approx. every 500 brakings check the motor braking time (max. time to stop the motor: 10 sec); in case of brake adjusting, see par. 20-8.

At the beginning of each working shift make sure that the guards on all sides of the machine are efficient and ensure a valid protection.

Periodically check that the guards are efficient and that the plates in particular the ones with yellow ground are in good state.

DANGER-WARNING:

the responsible technician is to be informed about eventual troubles during the test; in that case he shall shut off the machine and apply to Technical Service of SCM ***dealer.***

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20.7.1 SPARE PARTS THAT AFFECT THE OPERATOR'S HEALTH AND SAFETY

(mmax_20-7-1_0.0)

The previous section "Checking safety devices" indicates the operations which the user must perform and the respective frequency.
Such operations allow early identification of any malfunctions in machine safety systems.

NOTE-INFORMATION:
if a malfunction is detected, the user must contact the Assistance Centre authorised by SCM***.***

FORBIDDEN:
never attempt any work on the devices unless otherwise indicated in this manual.

The SCM assistance centre will identify which safety system component needs substituting and will substitute it (or will provide instructions on how to proceed).

NOTE-INFORMATION:
the user (or a specialised user technician) is only authorised to carry out the work described in this Instruction manual.

NOTE-INFORMATION:
when carrying out any maintenance tasks original spare parts supplied by the SCM ***(manufacturer) must always be used). The manufacturer is not responsible for damages due to the use of not original parts.***

NOTE-INFORMATION:
the entire machine electrical/electronic system is essential to machine safety. Therefore, the user is not authorised to carry out any repair/substitution of electrical or electronic components, except what is indicated in this manual.

DANGER-WARNING:
the user must also comply with the substitution times for the various safety devices, always using the SCM ***Assistance service to identify the correct spare part and to install it (unless otherwise indicated in this manual).***

SPARE PARTS THAT CAN BE INSTALLED BY THE USER

NOTE-INFORMATION:
in the spare parts catalogue the letter "C" indicates the codes of spare parts which affect operator health and safety.

These spare parts can be installed by expert personnel instructed by the user.

DANGER-WARNING:
for all other spare parts contact the Manufacturer's Dealer SERVICE or contact the Manufacturer's SERVICE directly.

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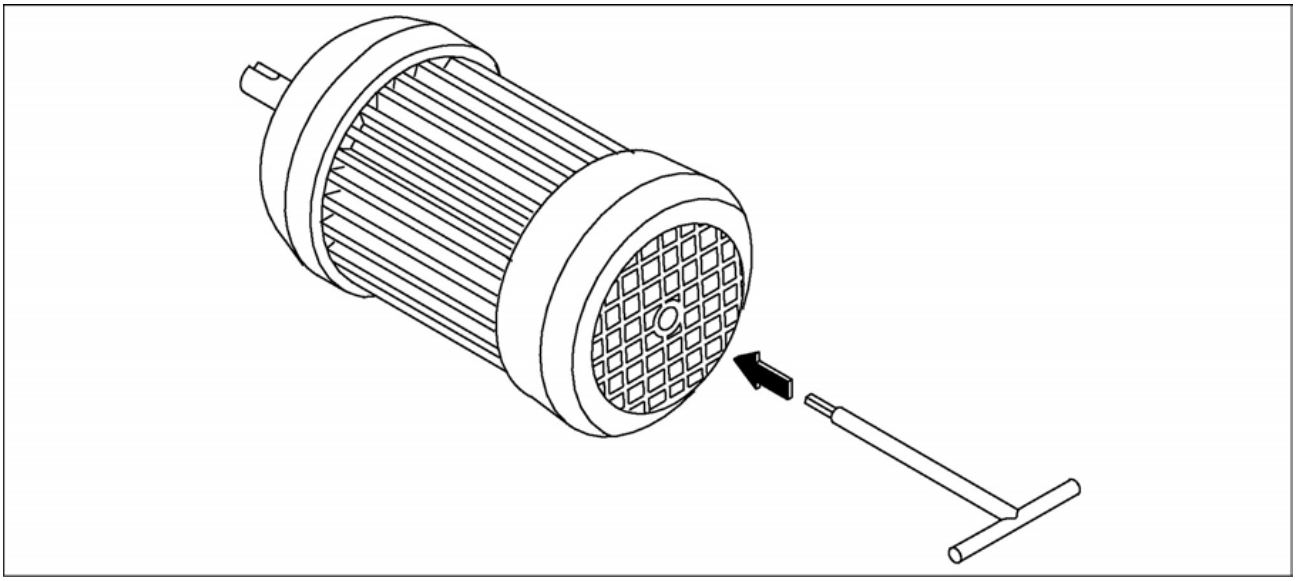
20.8 AUTO-BRAKE MOTOR

(ev_20-8_0.0)

At least every 2 months or 500 stops, check and adjust the electromechanic braking device.
Before carrying out any intervention on the motor, shut off the power by turning the padlockable main switch to 0 - OFF.

Electromagnet brake clearance
Distance between electromagnet and mobile core is called “air gap” and is adjusted during device construction.
Adjustment is required only in case of replacement of mobile core having glued to its surface a brake disk of friction material being subject to wear .
Wear limit of friction disk is 3 mm.
Replacement is to be carried out only by technicians of SCM dealer.

Adjustment of braking unit
Braking efficacy reduction can be noticed by the increase of the time required to fully stop the cutterblock/spindle (max. time 10 seconds) in case of tool of max. size and at the maximal permitted speed.
To reset the best braking torque proceed as follows:
- insert an Allen wrench into the hole on cover for the fan in order ot reach the adjusting screw;
- progressively screw down screw in order to join the mobile elements and to eliminate distance (brake clearance);
- unscrew screw by min.1/4 turn (max.1/3 turn) (corresponding to about 0.4 mm air gap);
- start and stop the motor a few times to check the correct running.



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20.18 REPLACING THE BELTS

(ev_20-18_0.0)

DANGER-WARNING:
check the belt tension after the first 10 hours of machine operation.
At least every 6 months, it is necessary to perform a periodical check on the belt.
Do not overstretch the belts not to overload the bearings.
Overstretching may overheat and destroy the belts.
At least once a month check the stopping time of the saw blade. If the stopping time exceeds 10 seconds, tighten or replace the belt (if it is ruined) as described in the following paragraphs.
When the adjustment has been carried out, again check the stopping time.

20.18.1.ASAW BLADE SPINDLE

(he_20.18.1.a_0.0)

DANGER-WARNING:
stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

Remove the motor panel (A fig. 20.18-1A) to access the belts and proceed as described below:

- Completely lower the saw assembly and incline it by 45° (see Chapter 6).
- Loosen the screw (B fig. 20.18-1-A) and (C fig. 20.18-1-A).
- Push the motor upwards and tighten the screw (B fig. 20.18-1-A).
- Proceed with the substitution of the belts
- Re-slacken the screw (B fig. 20.18-1-A) and tension the belts via the screw (C fig. 20.18-1-A) (see Par. 20.23).
- Tighten the screw (B fig. 20.18-1-A) and the locknut of screw (C fig. 20.18-1-A).

NOTE-INFORMATION:
if only one belt is wear, you have to replace all belts.

FORBIDDEN:
- never couple belts of different make;
- never use a new belt and an old one, because in that case the new belt tramsmits the entire power by itself and so it is damaged in short time.

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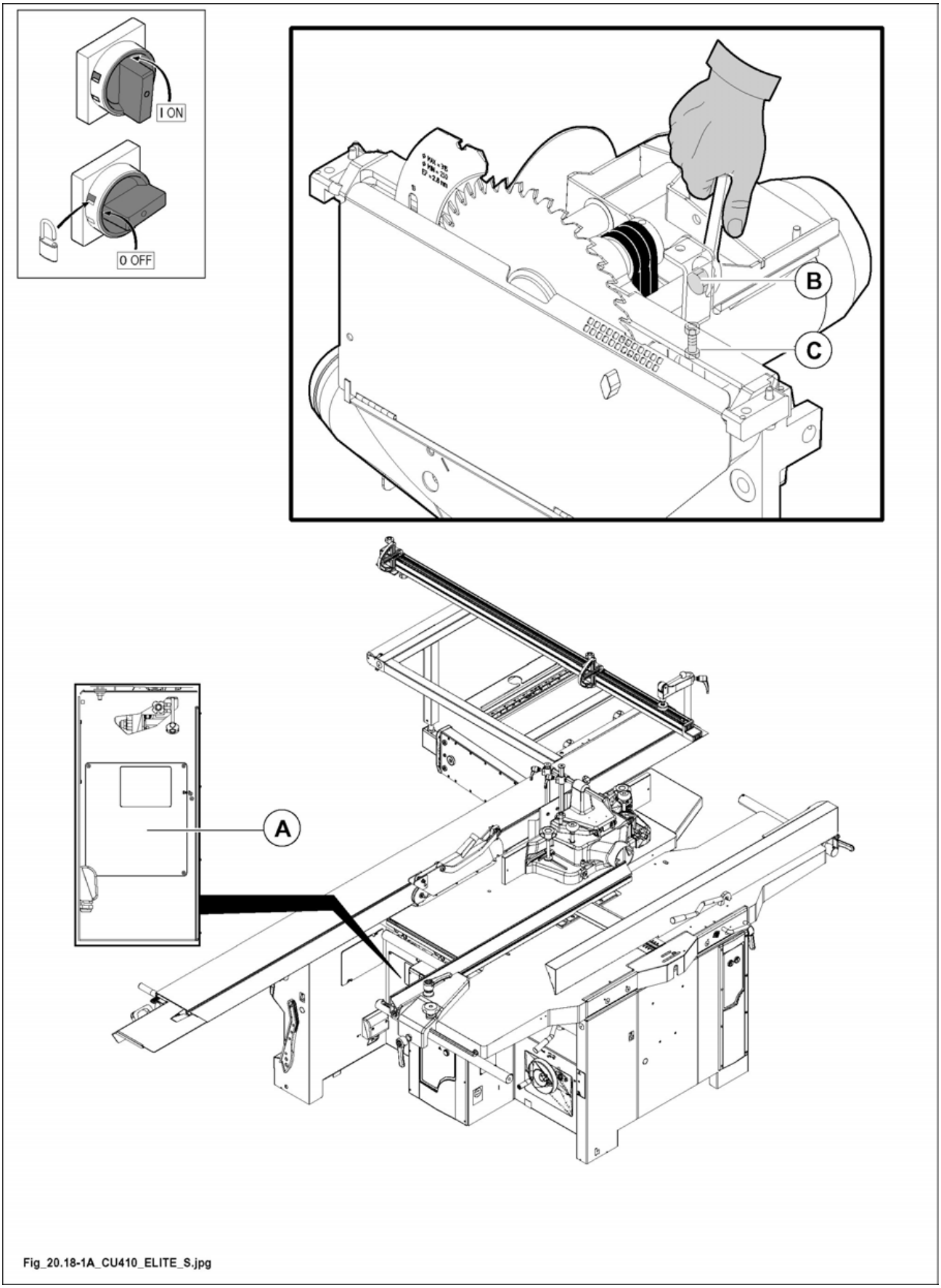


Fig. 20.18-1-A

20.18.1 SAW BLADE SPINDLE

(ev_20-18-1_0.0)

WITH OPT 2 SPEEDS

DANGER-WARNING:
stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

- Completely lift saw unit (see Chapter 6).
- Remove safety guard (A fig. 20.18-1), interlocked by micro-switch (E fig. 20.18-1).
- Loosen screw (B fig. 20.18-1).
- Lift motor unit support using handle (C fig. 20.18-1).
- Tighten screw (B fig. 20.18-1).
- Replace the belts (D fig. 20.18-1).
- Unscrew screw (B fig. 20.18-1) again, tension the belts by pressing lightly on handle (C fig. 20.18-1) (vedi Par. 20.23) and tighten screw (B fig. 20.18-1).

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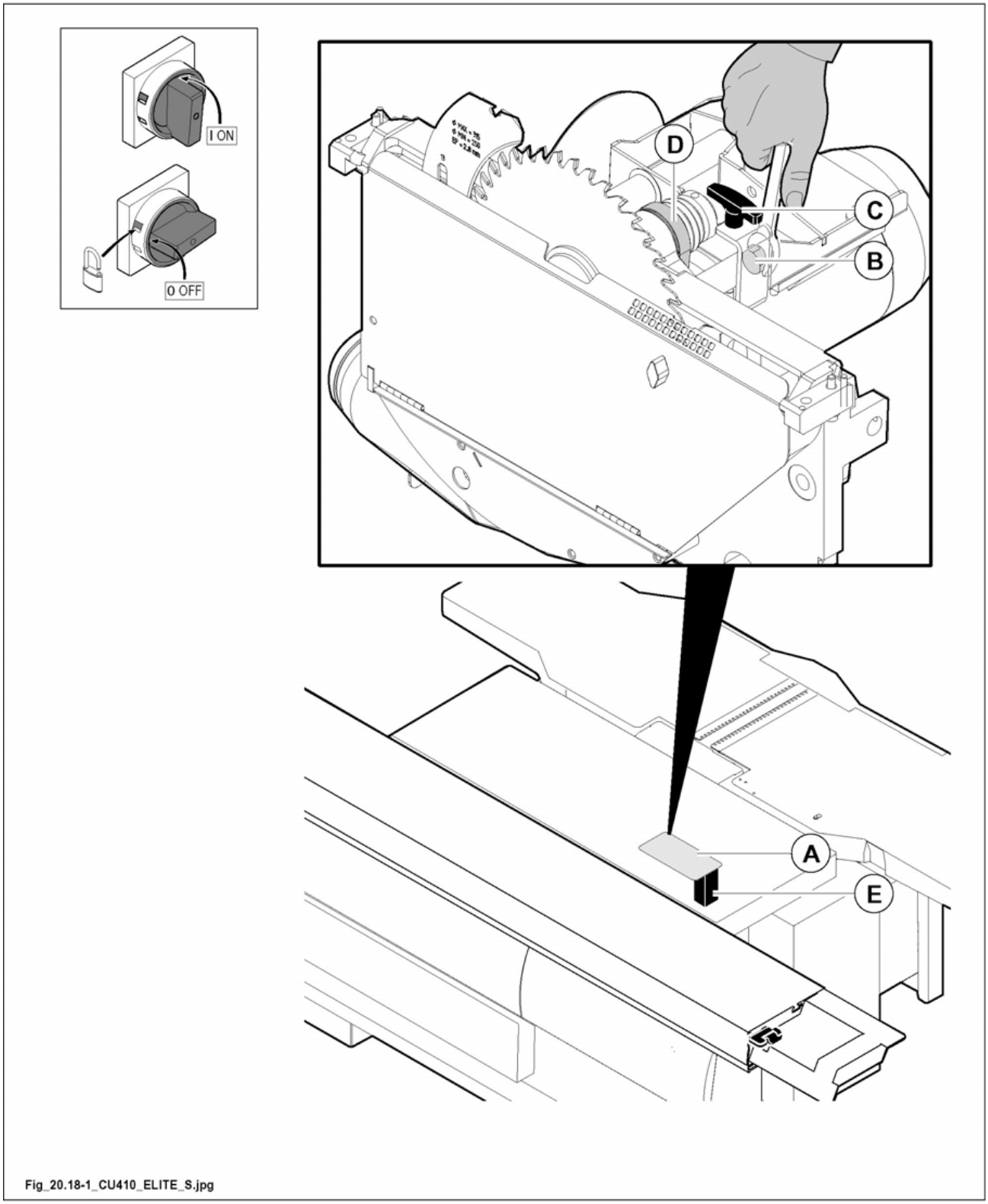


Fig. 20.18-1

20.18.2 SCORER SPINDLE

(ev_20-18-2_0.0)

DANGER-WARNING:
stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

Remove the motor panel (A fig. 20.18-2) to access the belts and proceed as described below:

- incline the saw assembly by 45° (see Chapter 6).
- Lift motor (M fig. 20.18-2, weight approx. 10 kg) and support it (e.g. with a wood traverse): in this way it is possible to replace the belt.
- Fit the new belt.
- Lower the motor.
- Manually turn the belt, ensuring that it is positioned in the centre of the pulleys.
- Fit the rear door again (A fig. 20.18-2).

NOTE-INFORMATION:
the scorer belt always remains stretched by the motor weight.

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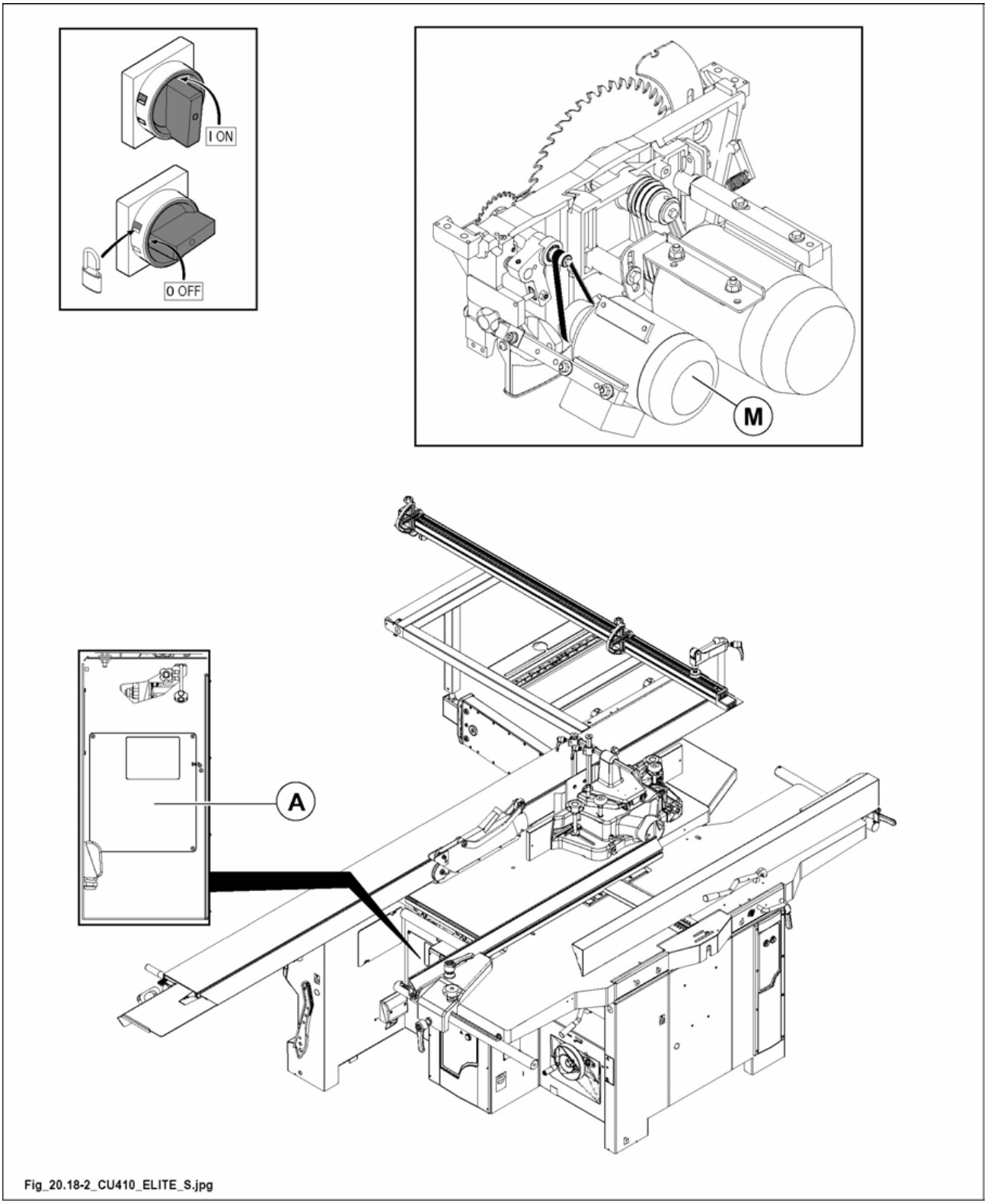


Fig. 20.18-2

20.18.3 MOULDER

(cu_20-18-3_0.0)

- Stop the machine see Chapter 5; turn the main switch to 0, then lock it and indicate this with a sign.
- Open the door (A fig. 20.18.3) (a limit switch ensures the safe machine condition).
- Pull lever (L fig. 20.18.3) into position 2 to slacken the tension of the belts.
- The belt (C fig. 20.18.3) is now slackened and can be substituted.
- Insert belt into pulley sheaves on the basis of the speed required using selector (B fig. 20.18.3).
- Check manually that the belt is inserted correctly and push lever (L fig. 20.18.3) to position 1 to tension the belts.
- Close the door (A fig. 20.18.3).

NOTE-INFORMATION:
push the lever until a click is heard. This means that the dead point has been reached.

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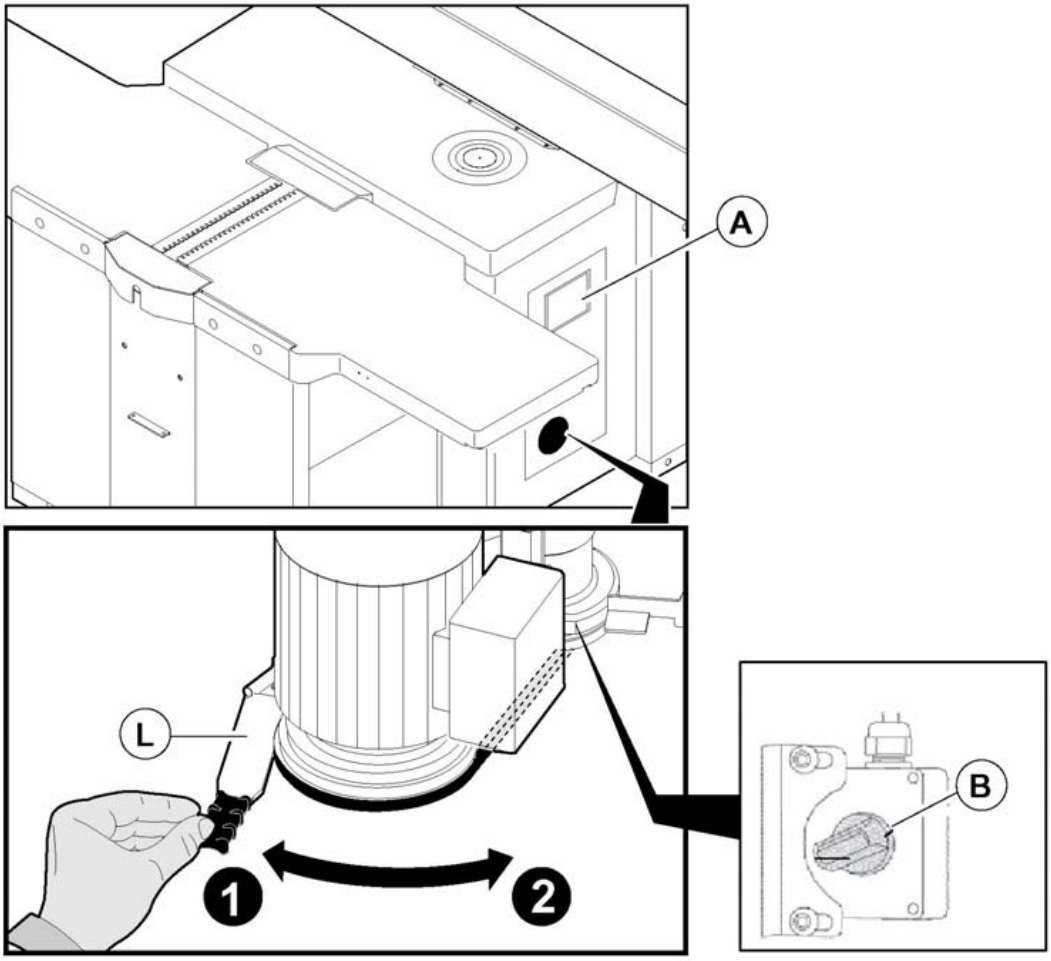


Fig_20.18-3_CU410_ELITE_S.jpg

Fig. 20.18-3

20.18.4 BELTS REPLACING

(fs_20-18_0.0)

If only one belt is worn or too long, you have to replace all belts.

1) Stop the machine (see Chapter 5); turn the main switch to 0, lock it and indicate it with a sign.
2) Open the spindle moulder door (A fig. 20.18-4) and remove the guard (D fig. 20.18-4).
3) Slacken the fixing screw (B fig. 20.18.-4).
4) Slacken the nut (C fig. 20.18-4) and lift the motor support.
   By using a lever lift the motor and keeping it in this position withdraw the worn belts (E fig. 20.18-4), then fit the new ones.
5) Stretch the belts as described (see par. 20.23).
6) When the adjustment has been carried out tighten the screw (B fig. 20.18.-4).
7) Fit guards (A, D fig. 20.18-4) again.

FORBIDDEN:
- never pair belts of different makes;
- never use a new belt and an old one, because in that case the new belt tramsmits the entire power by itself and so it is damaged in short time.

DANGER-WARNING
the cover and door are fixed safety guards and must be reassembled before operating.

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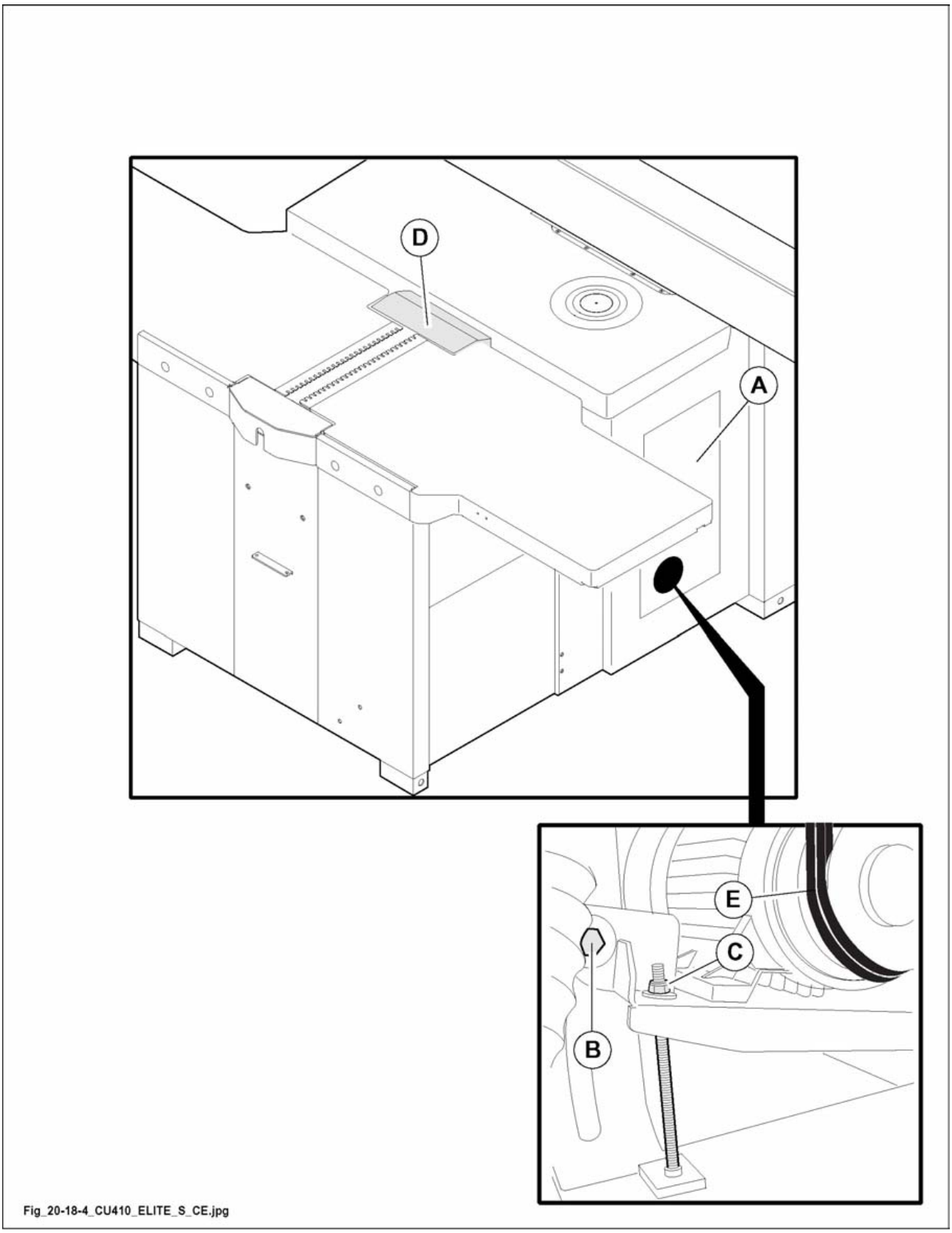


Fig. 20.18-4

20.23 BELT STRETCHING

(ev_20-23_0.0)

DANGER-WARNING:
check the belt tension after the first 10 hours of machine operation.
At least every 6 months, it is necessary to perform a periodical check on the belt.
Do not overstretch the belts not to overload the bearings.
Overstretching may overheat and destroy the belts.
At least once a month check the stopping time of the saw blade. If the stopping time exceeds 10 seconds, tighten or replace the belt (if it is ruined) as described in the following paragraphs.
When the adjustment has been carried out, again check the stopping time.

20.23.1.ASAW BLADE SPINDLE

(he_20.23.1a)

Remove the motor panel (A fig. 20.23-1A) to access the belts and proceed as described below:

- Completely lower the saw assembly and incline it by 45° (see Chapter 6).
- Stop the machine see Chapter 5; turn the main switch to 0, then lock it and indicate this with a sign.
- Loosen the screw (B fig. 20.18-1-A).
- Unloose nut (D fig. 20.23-1-A) and adjust screw (C fig. 20.23-1-A) to stretch the belt.
- Tighten the nut (D fig. 20.23-1-A) when the adjustment has been made.
- Tighten screw (B fig. 20.23.1-A).

CAUTION:
an excessive belt tightening will cause both functioning failures and belts wear beforehand.
By exerting a force P in the middle of a belt, the latter must have a yielding f as shown in the table.

Force P		Yielding f (mm)
N	Kp	
24 ÷ 26	2,4 ÷ 2,6	2 ÷ 4

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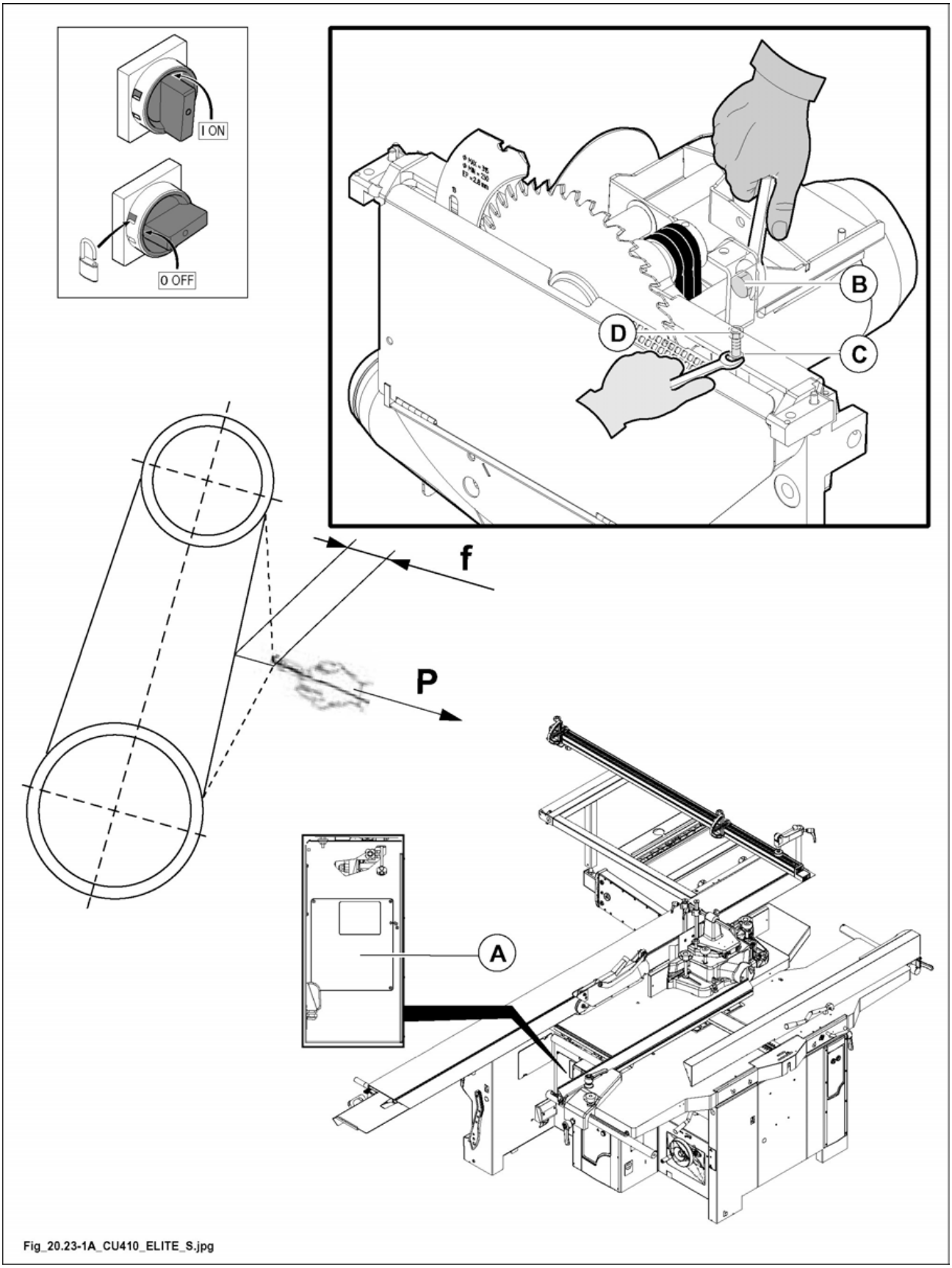


Fig. 20.23-1-A

20.23.1 SAW BLADE SPINDLE

(ev_20-23-1_0.0)

WITH OPT 2 SPEEDS

To stretch the belts proceed as follows.
- Completely lift saw unit (see Chapter 6).
- Stop the machine see Chapter 5; turn the main switch to 0, then lock it and indicate this with a sign.
- Remove safety guard (A fig. 20.23-1), interlocked by micro-switch (E fig. 20.23-1).
- Loosen screw (B fig. 20.23-1).
- Tension the belts by pressing lightly on handle (C fig. 20.23-1) and tighten screw (B fig. 20.23-1).

CAUTION:
an excessive belt tightening will cause both functioning failures and belts wear beforehand.
By exerting a force P in the middle of a belt, the latter must have a yielding f as shown in the table.

Force P		Yielding f (mm)
N	Kp	
25 ÷ 35	2,5 ÷ 3,5	2 ÷ 3

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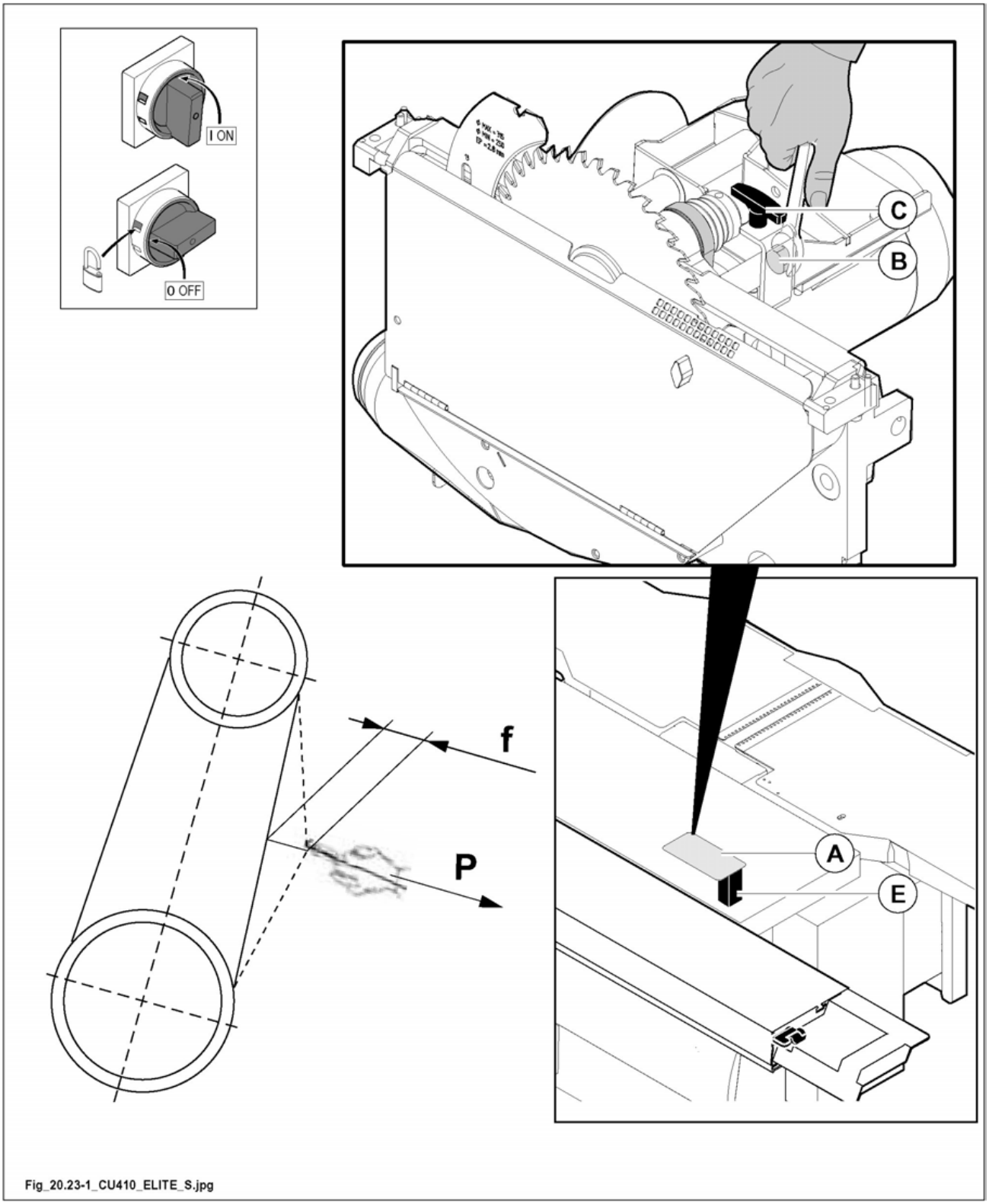


Fig. 20.23-1

20.23.2 SCORER SPINDLE

(ev_20-23-2_0.0)

NOTE-INFORMATION:
the scorer belt remains always stretched by the motor (M fig. 20.23-2) weight.

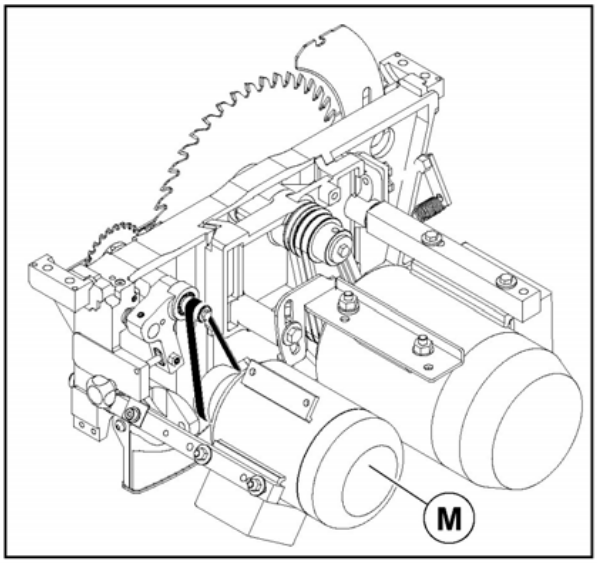


Fig_20.23-2_CU410_ELITE_S.jpg

Fig. 20.23-2

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(st-10)

20.23.3 MOULDER

(cu_20-23-3_0.0)

- Stop the machine see Chapter 5; turn the main switch to 0, then lock it and indicate this with a sign.
- Open the door (A fig. 20.23.3) (a limit switch ensures the safe machine condition).
- Pull lever (L fig. 20.23.3) forward. The belt (C fig. 20.23.3) now is slack.
- For the optimal belt stretching, operate on the nuts (S and N fig. 20.23.3), with slack belt.
- Push lever (L fig. 20.23.3) back. The belt is stretched.
- Close the door (A fig. 20.23.3).

Periodically every 6 months check the belt tension.

CAUTION:
an excessive belt tightening will cause both functioning failures and belts wear beforehand.
By exerting a force P in the middle of a belt, the latter must have a yielding f as shown in the table.

Force P		Yielding f (mm)
N	Kp	
24 ÷ 26	2,4 ÷ 2,6	5,0 ÷ 6,5

DANGER-WARNING:
before starting the machine make sure that you have selected the speed of rotation proper for the working to be carried out, for the wood type and for the tool used on the machine.

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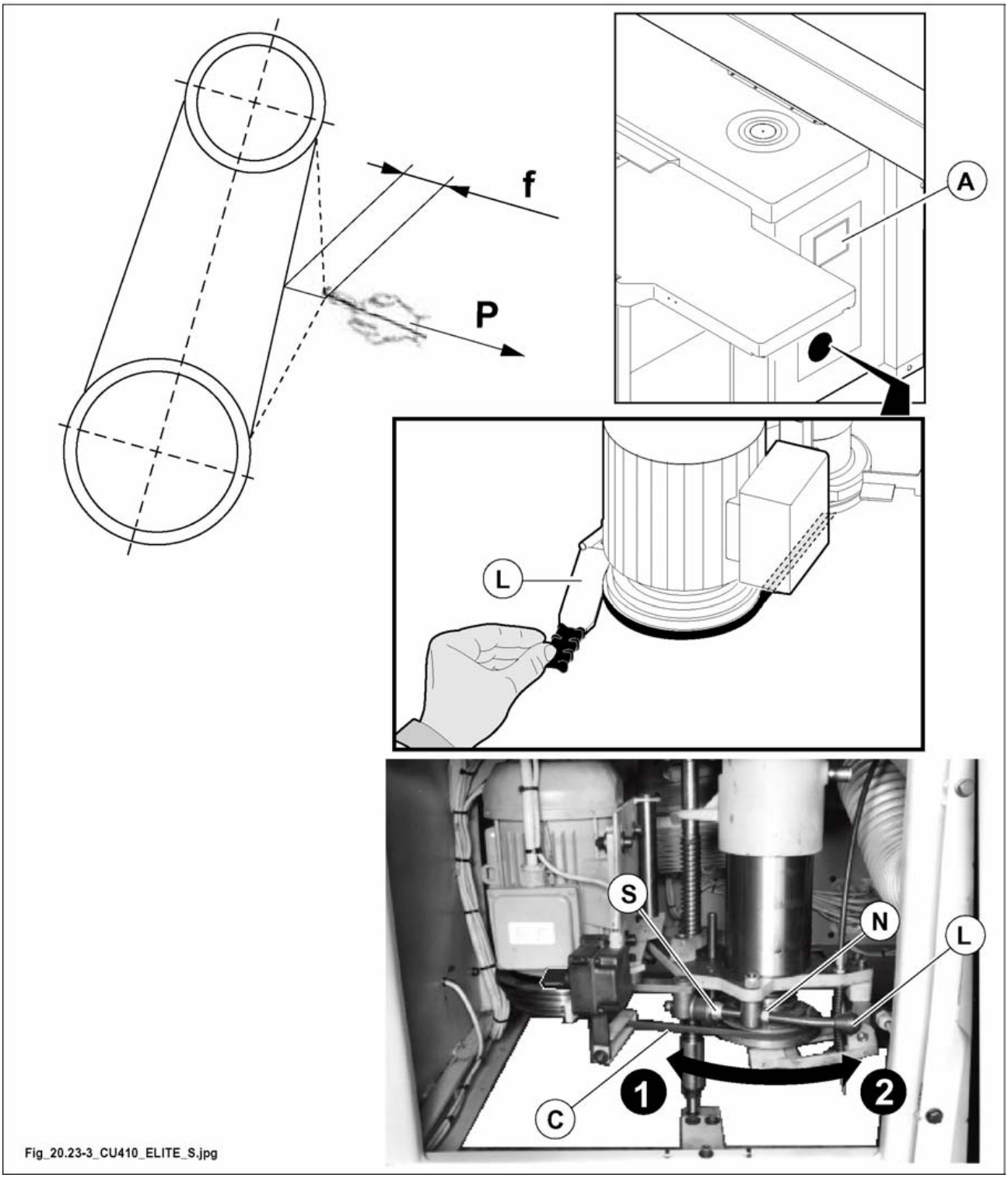


Fig. 20.23-3

20.23.4 BELT TENSION ADJUSTING

(fs_20-28_0.0)

DANGER-WARNING
after the first working days or after many working hours the belts get slack; the time required for saw blade stop gets longer.

NOTE-INFORMATION:
at least three time a year check the cutterblock belts.

To stretch the belts proceed as follows.
1) Stop the machine (see Chapter 5); turn the main switch to 0, lock it and indicate it with a sign.
2) Open the spindle moulder door (A fig. 20.23-4).
3) Slacken the fixing screw (B fig. 20.23-4).
4) Screw in the nut (C fig. 20.28) to tension the belts.
5) When the adjustment has been carried out tighten the screw (B fig. 20.23-4).
6) Close the spindle moulder door (A fig. 20.23-4).

CAUTION:
an excessive belt tightening will cause both functioning failures and belts wear beforehand.
By exerting a force P in the middle of a belt, the latter must have a yielding f as shown in the table.

Force P		Yielding f (mm)
N	Kp	
24 ÷ 26	2,4 ÷ 2,6	13 ÷ 14

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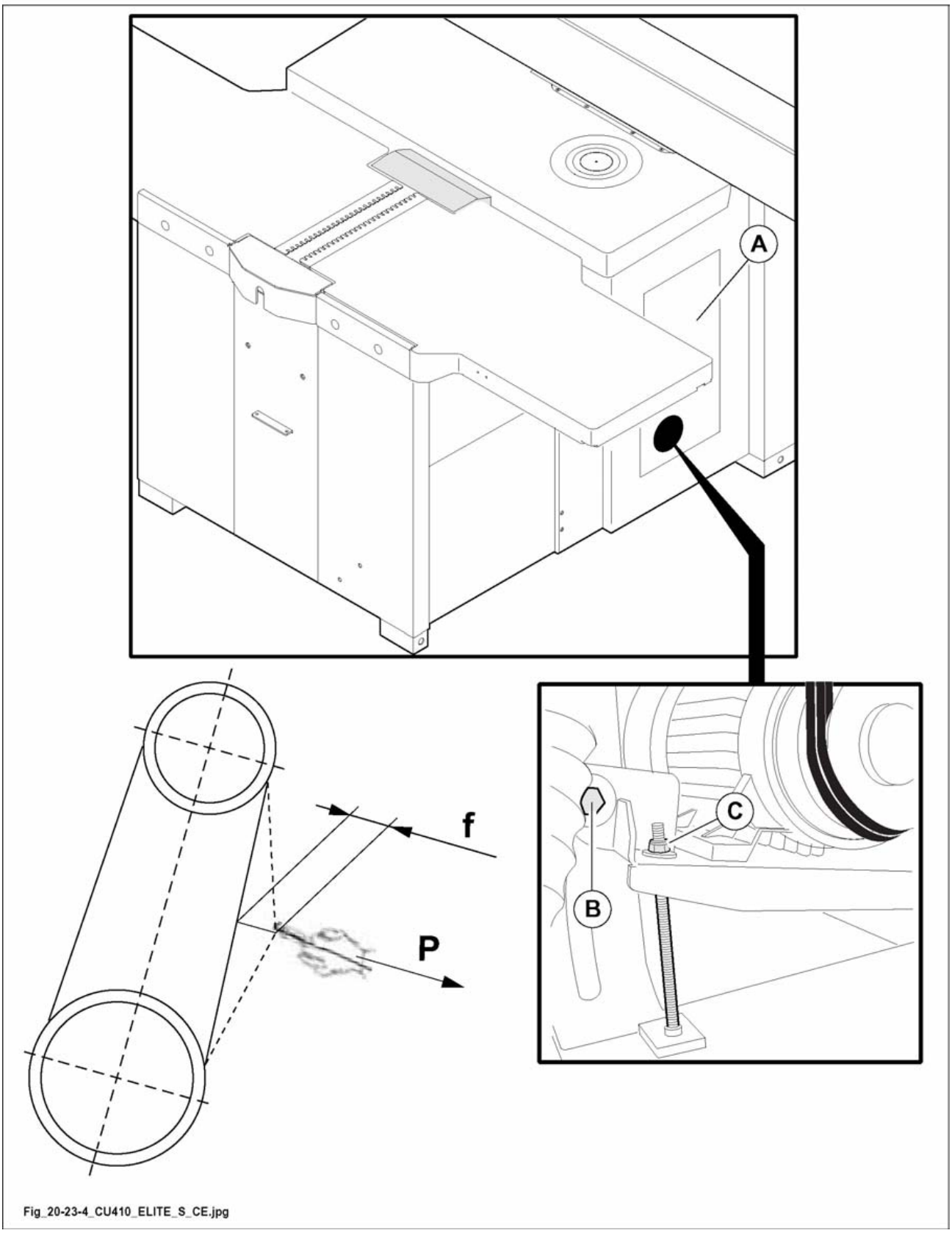


Fig. 20.23-4

20.28 MAKING THE PARTS WHICH GET WORN

(ev_20-28_0.0)

20.28.1 REPLACING THE CHIP BREAKER

(ev_20-28-1_0.0)

Rule for 90°-cuts

If you have to replace wood part (M fig. 20.28-1), request it:

- to SCM dealer;
- or to SCM Spare Parts Department,

or make it by using beech; figure 20.28-1 indicates the measures.

Rule for tenoning table and guard

If you have to replace wood part (K fig. 20.28.1), request it:

- to SCM dealer;
- or to SCM Spare Parts Department,

or make it by using beech; figure 20.28.1 A indicates the measures.

To replace the worn splinter guard, use the screws (X fig. 20.28.1).
Reassemble the new splinter guard and tighten the screws (X).

NOTE-INFORMATION:
for the adjustments see sect. 7.1.3.

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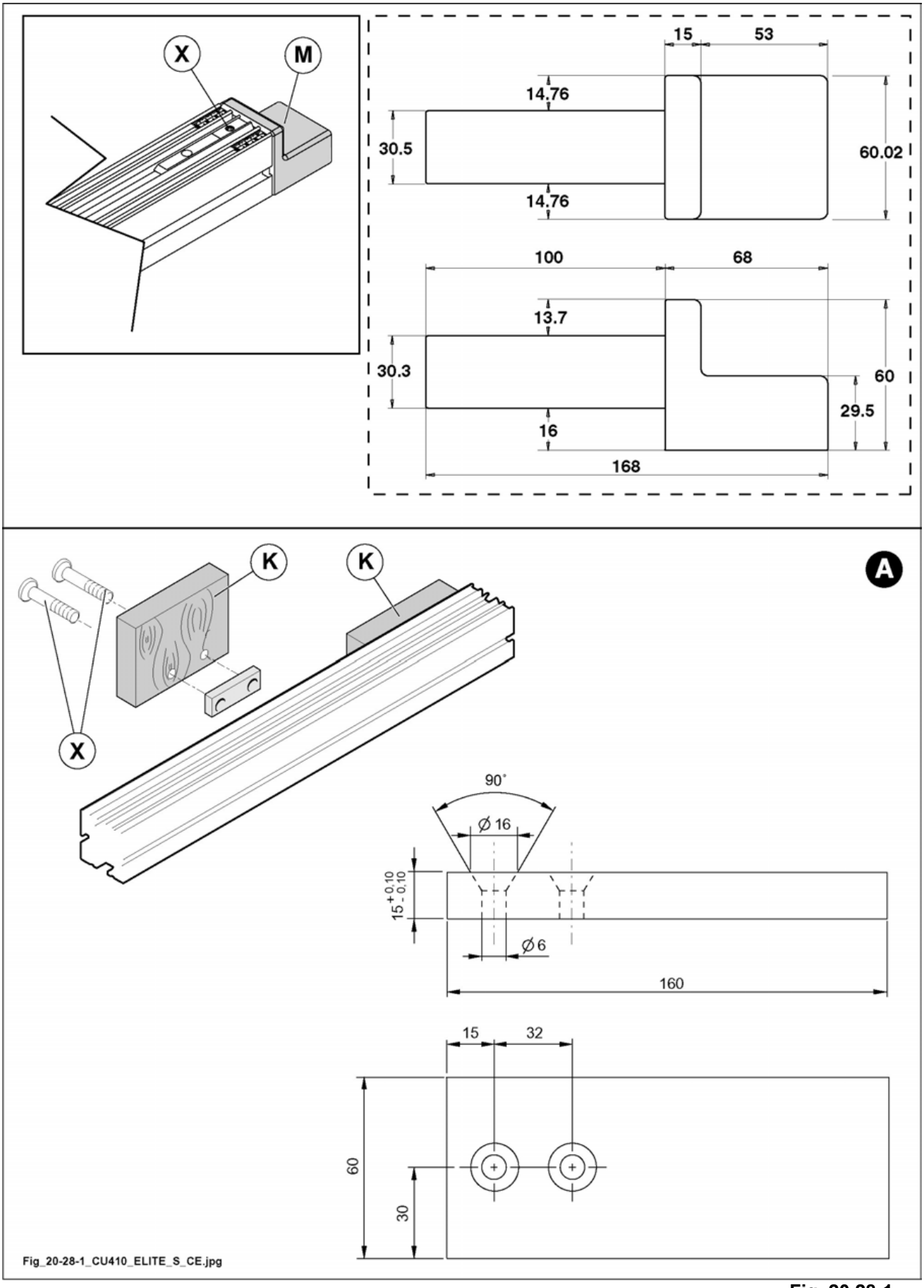

X
M
15
53
14.76
30.5
60.02
14.76
100
68
13.7
30.3
60
29.5
16
168
K
K
X
A
90°
Ø 16
15 +0.10 -0.10
Ø 6
160
15
32
60
30
Fig_20-28-1_CU410_ELITE_S_CE.jpg

Fig. 20.28-1

20.37 TROUBLES - CAUSES - WHAT TO DO

(ev_20-37_0.0)

This section indicates how to solve problems which may rise during the machine use.

Carry out interventions only after carefully reading all that concerns the problem indicated in this handbook.

For problems not described in the handbook apply to SCM Technical Service.

PROBLEM	CAUSE	REMEDY
The machine does not start		
	No electrical energy on one or more phases of the line.	Check with a tester there is voltage in the three phases.
	The fuses of the auxiliary circuit are interrupted or the fuse block cover is open.	Close the fuse block cover (located inside electric cabinet). If the machine does not start: 1- Open the fuse block cover. 2- Check the integrity of fuse, if necessary, replace them.
	Emergency on.	Switch off the button by turning it.
	Blade belt change zone cover open.	Close the cover.
	Guards not in right position.	Check that the guards are in right position: - planer: all tables closed and tipper open. - thicknesser: tipper closed.
	Overload switch (**A** fig. 20.37A) triggered because of: - an excessive absorption of current due to improper machine use (task too heavy for power of machine) - insufficient cable size for power of machine (see electrical connection references in chap. 4) - voltage failure due to excessive power supply cable length - short circuit in electrical system.	Solve the problem, wait for the overload switch to cool down and restart the machine.
	Moulder motor brake off.	Turn selector (**B** fig. 20.37A) for brake release to (brake locked).
	Safety microswitch on.	Check that the protection hatch for access to the spindle moulder is closed, that the spindle moulder blocking for tool change is disconnected and that the ø 320 mm spindle moulder hood is mounted with rotation speed different to 3500 rpm.
	Main ON/OFF switch can be padlocked in position **0** (OFF).	Rotate main ON/OFF switch to **I** (ON).
The machine stops during machining.		
	No electrical energy on one or more phases of the line.	Check with a tester there is voltage in the three phases.

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PROBLEM	CAUSE	REMEDY
	The fuses of the auxiliary circuit are interrupted or the fuse block cover is open.	Close the fuse block cover (located inside electric cabinet). If the machine does not start: 1- Open the fuse block cover. 2- Check the integrity of fuse, if necessary, replace them.
	Too heavy operation in relation to the power of the motor.	Wait for the cooling of the thermal cut out protection. Reactivate it after a few minutes.
	The motor belt is loose or ruined.	Tighten the belts or change them as described in sections 20.18 and 20.23.

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MOULDER

PROBLEM	CAUSE	REMEDY
The motor turns but the tool stops when it comes into contact with the workpiece.		
	The motor belt is loose or ruined.	Tighten the belt or change as described in sections 20.18 and 20.23.
The spindle does not move vertically and does not incline.		
	Machine not live.	Check with a tester there is voltage in the three phases.
	Gearmotor faulty.	Contact the technician of your area agent.
	Intervention of the electrical control stops (max. and min. stroke).	Reverse the direction until the control stop is freed.
The digital display indicates an unreal quota.		
	Display irregular.	Read chapter 16 to restore display.

SAW

PROBLEM	CAUSE	REMEDY
The scorer does not start.	The saw motor is not on.	Start the saw motor.
When brake release selector is turned to  brake release the brake does not release.	The fuses of the auxiliary circuit are interrupted or the fuse block cover is open.	Close the fuse block cover (located inside electric cabinet). If the brake is not released: 1- Open the fuse block cover. 2- Check the integrity of fuse, if necessary, replace them.
The motor rotates but the saw blade stops when it is in contact with the piece.	The motor belt is loose or ruined.	Tighten the belt or change as described in sections 20.18 and 20.23.
The panel slides with difficulty during cuting (it is tight betwen the fence and the blade) or is not cut with sides paralel.	La guida per tagli paralleli si è sregolata (deve essere parallela alla lama con una leggera apertura di uscita di 0,10mm).	Contact our Service Centre (phone number in chap.1).
The telescopic rule does not position correctly at 90°.	The **B** stops on the telescopic rule are not adjusted correctly.	Slacken the locknut **G** and adjust the stops until the telescopic rule is positioned correctly at 90° (fig. 20.37A).

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SURFACE PLANING AND THICKNESSING MACHINE

PROBLEM	CAUSE	REMEDY
The thicknesser table does not lift or lower.		
	CMR card faulty.	Carry out section 18 checks; if necessary change it.
	The lifting screws are jammed with dust and resin and after lifting for a few mm the red warning light comes on.	Clean carefully; check the state of the chain.
The wood is not fed.		
	Advancing speed too slow.	Change speed (see paragraph9.4).
	Roller pressure too low.	Adjust rollers (see paragraph 9.8).
	The thicknesser table is adjusted to a measurement greater than the thickness of the wood.	Move the table to the right height (see section 9.5; 9.6).
	The chain is broken	To replace it call your Dealer's Technical Assistance Office [manufacturer].
The tables do not close		
	Tipper closed.	Open cutter block safety tipper completely.
The motor operates but the spindle stops when it is in contact with the workpiece.		
	The motor belt is loose or ruined.	Tighten the belt or change as described in sections 20.18 and 20.23.
The digital display indicates an unreal quota.		
	Display irregular.	Read chapter 16 to restore display.

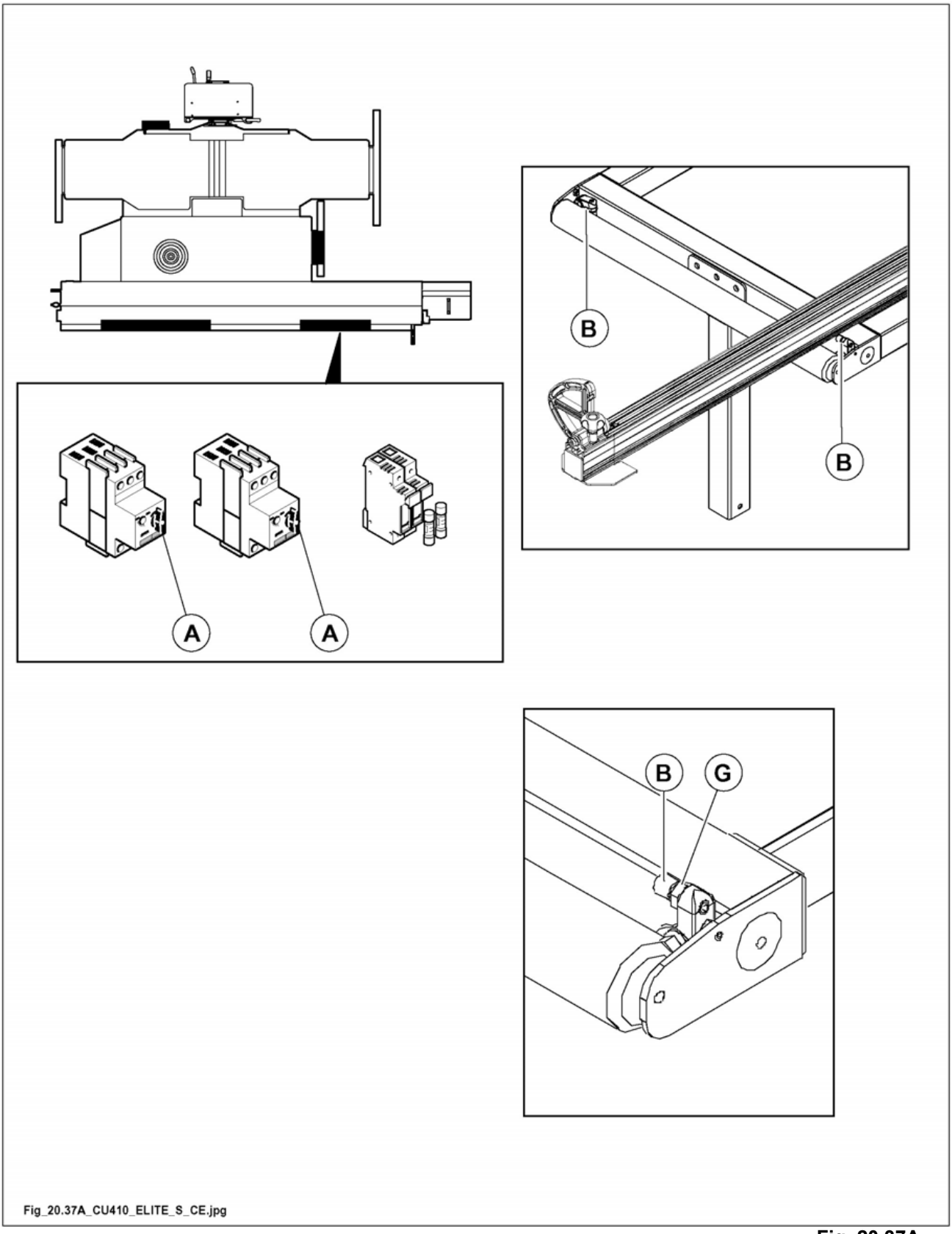


Fig. 20.37A

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20.60 UNSCHEDULED MAINTENANCE

(mmax_20-60-0.0)

All tasks not expressly listed in this manual, such as:

- tasks to be carried out following component or electric motor faults
- tasks to be carried out following mechanical system component faults

shall be considered unscheduled maintenance tasks.

These tasks require specific skills and must only be carried out by qualified personnel authorised by the machine manufacturer.

DANGER-WARNING:
never attempt to carry out makeshift repairs or replacements; this could result in dangers of a serious nature for exposed personnel and the machine itself.

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A-2 Start up - Stop from feeder.....2

APPENDIX - A

(appendice - a)

A-1 FEEDER SPECIFICATIONS

(a-trasc_a-1)

FEEDER NOT SUPPLIED BY SCM

NOTE-INFORMATION:
connect the feeder to the relative socket (A fig. A.1 max. power 0.75 kW) .

The feeder can be fitted:
- by requesting, to SCM, the feeder adapter kit (OPT) which support and could switch off it

The feeder must have the following specifications.
- It must have a CE marking, as interchangeable equipment in compliance with directive 2006/42/EC or earlier.
- The feeder instructions manual must indicate that it can be fitted on SPINDLE MOULDER, SAW, SURFACE PLANING
- Max weight: 50 kg
- Max power: 0.75 kW

A-2 START UP - STOP FROM FEEDER

(a-trasc_a-2)

DANGER-WARNING:
when there is a feeder emergency stop press pushbutton (N fig. A.1).

DANGER-WARNING:
to connect the feeder (not supplied by SCM ***), use only the socket (A fig. A.1 power max. 0,75 kW), because when the emergency pushbutton is pressed, the power supply to the socket (A) is also interrupted, thus blocking the feeder.***

NOTE-INFORMATION:
the feeder can be started when the spindle moulder motor has reached the right number of rpm.

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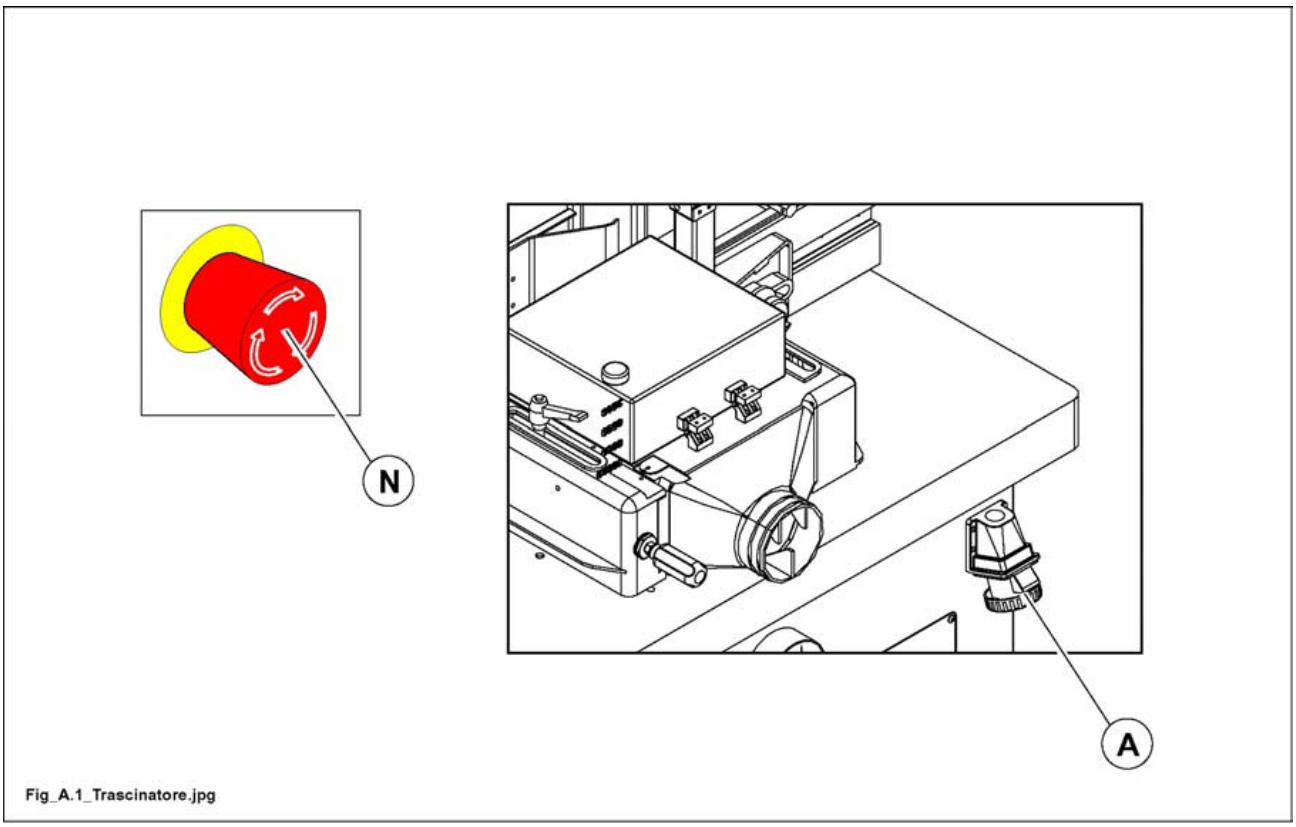


Fig. A.1