Translation of the original operating instructions

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

ME 35

INSTRUCTION MANUAL

CE

SINGLE-SIDED EDGE BANDER FOR WORKING WITH WOOD AND MATERIALS WITH SIMILAR PHYSICAL CHARACTERISTICS



Rel. 6.0 / 05-2023 **00L0493884C** **EN**

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MANUFACTURER:	**SCM INDUSTRIA S.p.A.**
ADDRESS:	**Via Valdicella, 7 - 47892 - Gualdicciolo - Rep. San Marino**
DESIGNATION:	**SINGLE-SIDED EDGE BANDER FOR WORKING WITH WOOD AND MATERIALS WITH SIMILAR PHYSICAL CHARACTERISTICS**
BRAND:	**SCM**
TYPE:	**B-05**
MODEL:	**ME 35**
TYPE OF DOCUMENT:	**INSTRUCTION MANUAL**
DOCUMENT CODE:	**00L0493884C**
EDITION:	**Rel. 6.0 / 05-2023**
CONFORMITY:	CE

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DICHIARAZIONE “CE” DI CONFORMITA’

(AI SENSI DELL'ALLEGATO IIA DELLA DIRETTIVA 2006/42/CE
E DICHIARAZIONE "UE" AI SENSI DI ALTRE DIRETTIVE APPLICABILI)

"EC" DECLARATION OF CONFORMITY

(PURSUANT TO ATTACHMENT IIA OF DIRECTIVE 2006/42/EC
AND "EU" DECLARATION PURSUANT TO OTHER APPLICABLE DIRECTIVES)

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

DICHIARA CHE LA
DECLARES THAT

MACCHINA: *MACHINE:*	**BORDATRICE MONOLATO PER LA LAVORAZIONE DEL LEGNO E CON MATERIE CON CARATTERISTICHE FISICHE SIMILI** **SINGLE-SIDED EDGE BANDER FOR WORKING WITH WOOD AND MATERIALS WITH SIMILAR PHYSICAL CHARACTERISTICS**		
MARCA: *BRAND:*	***SCM***	N°DI SERIE: *SERIAL No.:*	
TIPO: *TYPE:*	***B-05***	ANNO DI COSTRUZIONE: *YEAR OF CONSTRUCTION:*	
MODELLO: *MODEL:*	***ME 35***		

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

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

2006/42/UE	**2006/42/EC**
2014/30/UE	**2014/30/EU**

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***,

*** IDENTIF CAZIONE FIRMATARIO ***
FIRMA AUTOGRAFA

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

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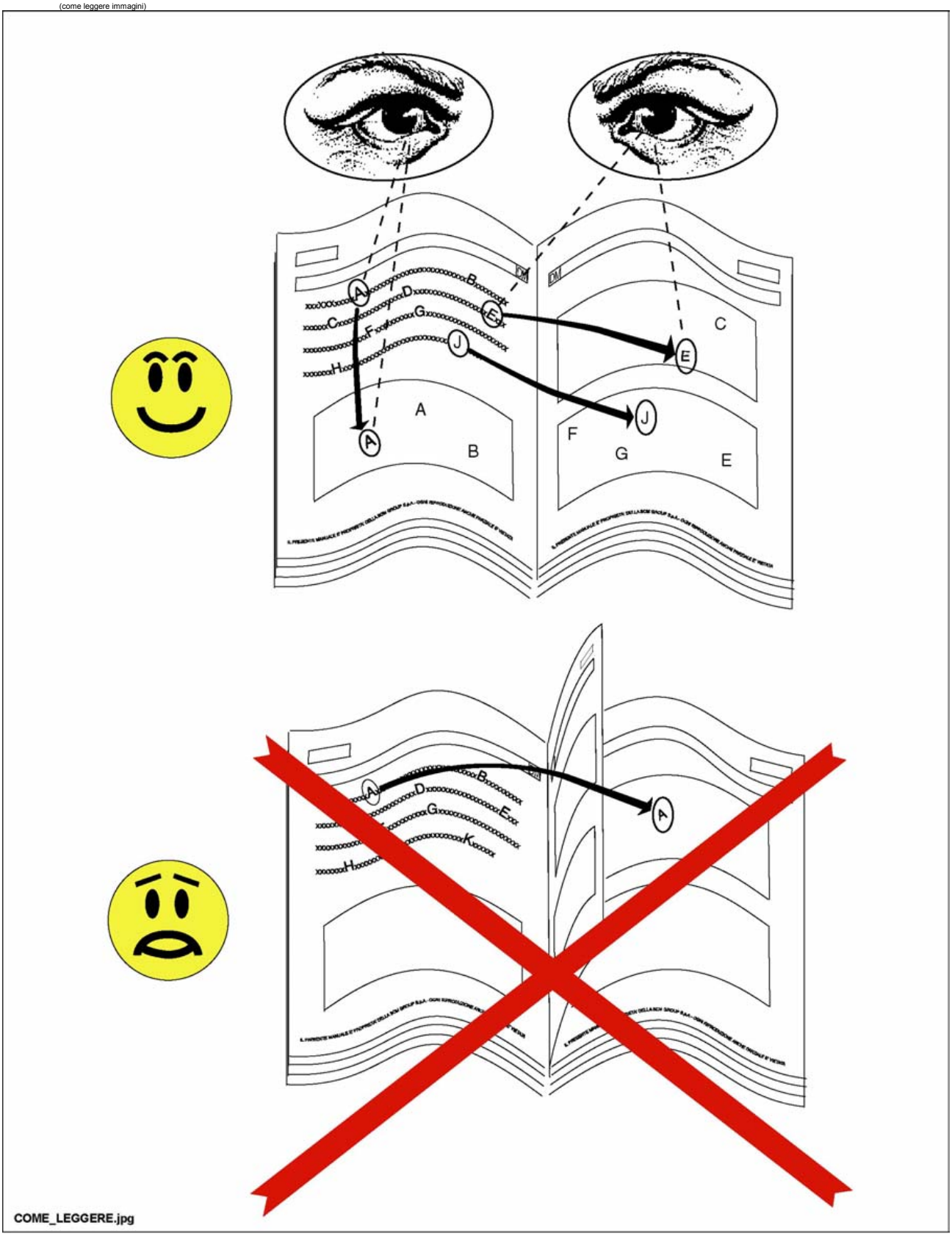
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(come leggere immagini)



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1.1 AIM OF THE HANDBOOK

(ad21_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.



DANGER-WARNING:
CAUTION: the machine is fitted with an electronic control used to program all the machining operations of the piece; the methods used are described in the attached manual.

For any technical problem apply to SCM dealer:

[2] The definition "machine" replaces "ME35" 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

(ad21_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

(ad21_1-3_0.0)

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.)
Web: www.scmgroup.com
Email: minimax@scmgroup.com

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

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

Spare Parts Department
from Italy: Tel. 0541/674706 - Fax. 0541/674720

from abroad: Tel. 0039 - 0541/674706 - Fax. 0039 - 0541/674720
E-mail: spareparts@scmgroup.com

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1.4 NOTES FOR THE USER

(ad21_1-4_0.0)

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

(ad21_1-4-1_0.0)

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

1.4.2 ENCLOSED DOCUMENTATION

(ad21_1-4-2_0.0)

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

- Electric and pneumatic circuit arrangements (read the number of the electrical diagram on the identification plate placed on the machine in the "W.D." line)
- Spare parts catalogue
- User and programming manual

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

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1.5 SYMBOLS USED IN THIS HANDBOOK

(ad21_1-5_0.0)

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.



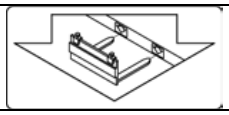
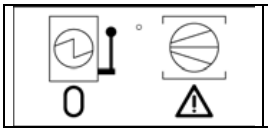
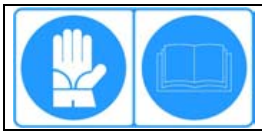
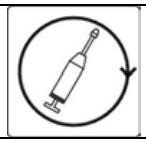
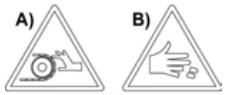
MANUFACTURER'S TECHNICIAN

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

(ad21_1-6_0.0)

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 -**
	***Indication of air pressure***	**- I -**
	***Grease the track with the machine started***	**- L -**
	***Danger:*** ***A) clamping and dragging, crushing and pinching upper limbs*** ***B) cutting fingers***	**- M -**

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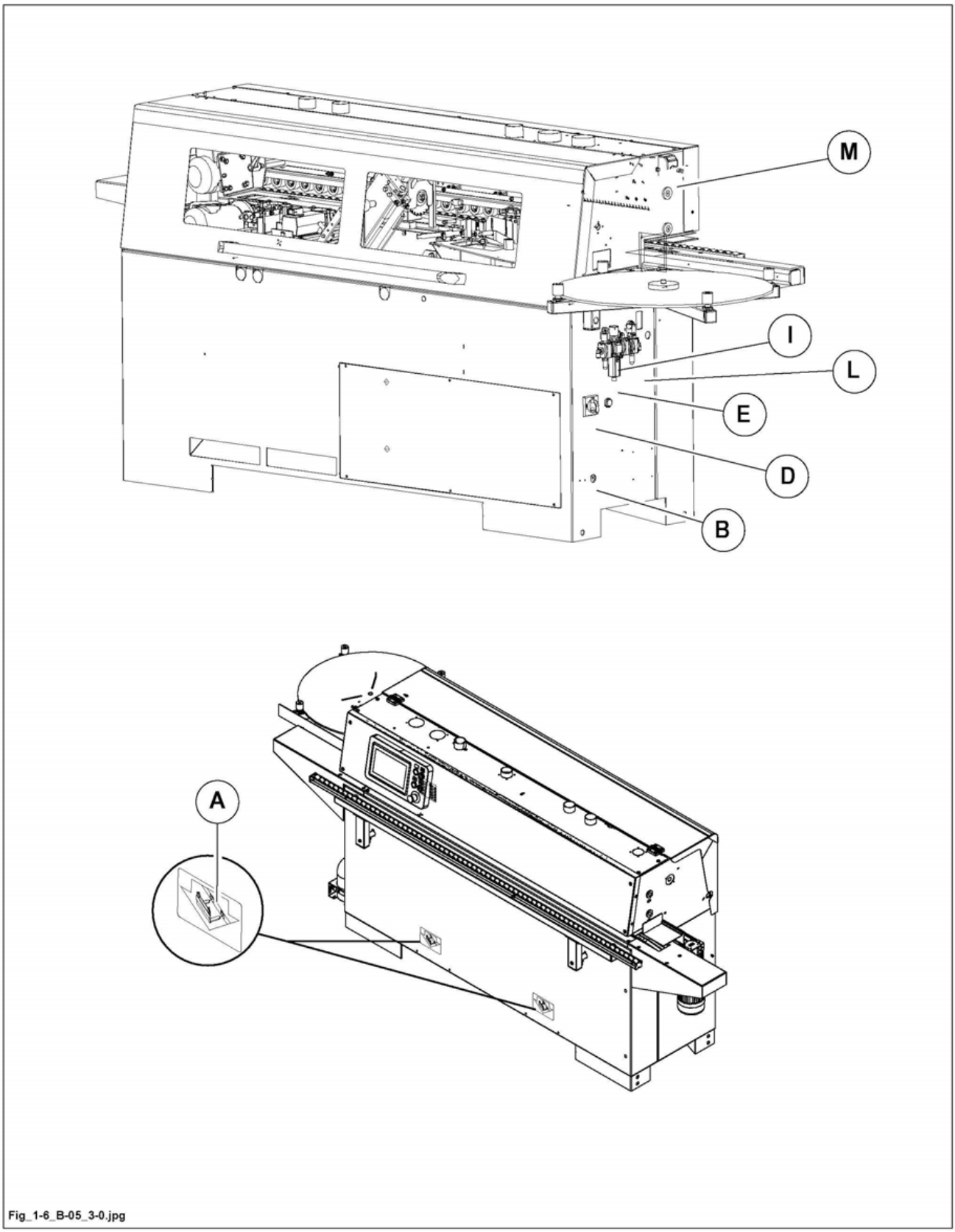
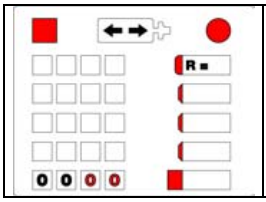
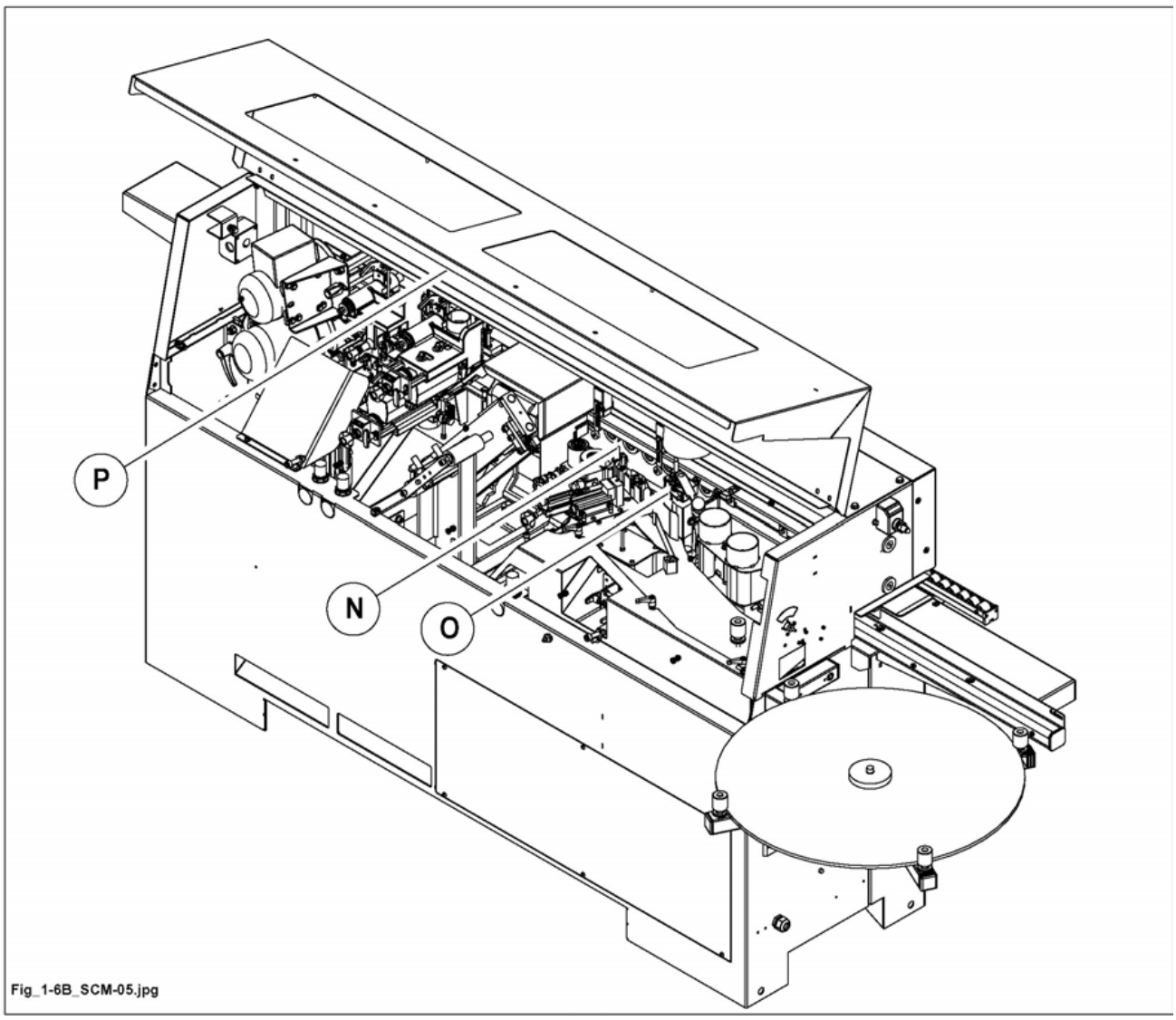


Fig_1-6_B-05_3-0.jpg

	***Adjusting the trimming unit***	**- P -**
	***Danger: cutting of upper limbs (rotating tools)***	**- N -**
	***Danger: hot surfaces***	**- O -**

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P
N
O
Fig_1-6B_SCM-05.jpg

1.7 MACHINE DESCRIPTION

(ad21_1-7_0.0)

The edge banding machine, from this point referred to as the machine, was designed and built to apply edging strips to straight wooden panels and faces perpendicular to one another with automatic feed.
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 - Panels feed track

2 - Pneumatic supply coupling

3 - Pneumatic components compartment

4 - Presser unit height adjustment

5 - Extraction fitting

7 - Infeed fence

8 - Worktable front extension

9 - Reel holder

10 - Protection guard

11 - Panel height numerical indicator

12 - Reel cutting shears

13 - Trimmer unit

14 - Edge feed unit

15 - Edge fence

16 - Commands panel

17 - End trimming unit (ME 35 - ME 35T)

18 - Presser rollers unit

19 - Glue tank unit

20 - Edge scraper unit (OPT)

21 - Brushes unit (OPT)

22 - Rectifier (OPT)

23 - Gluescraper unit (OPT)

24 - Grooves unit (OPT)

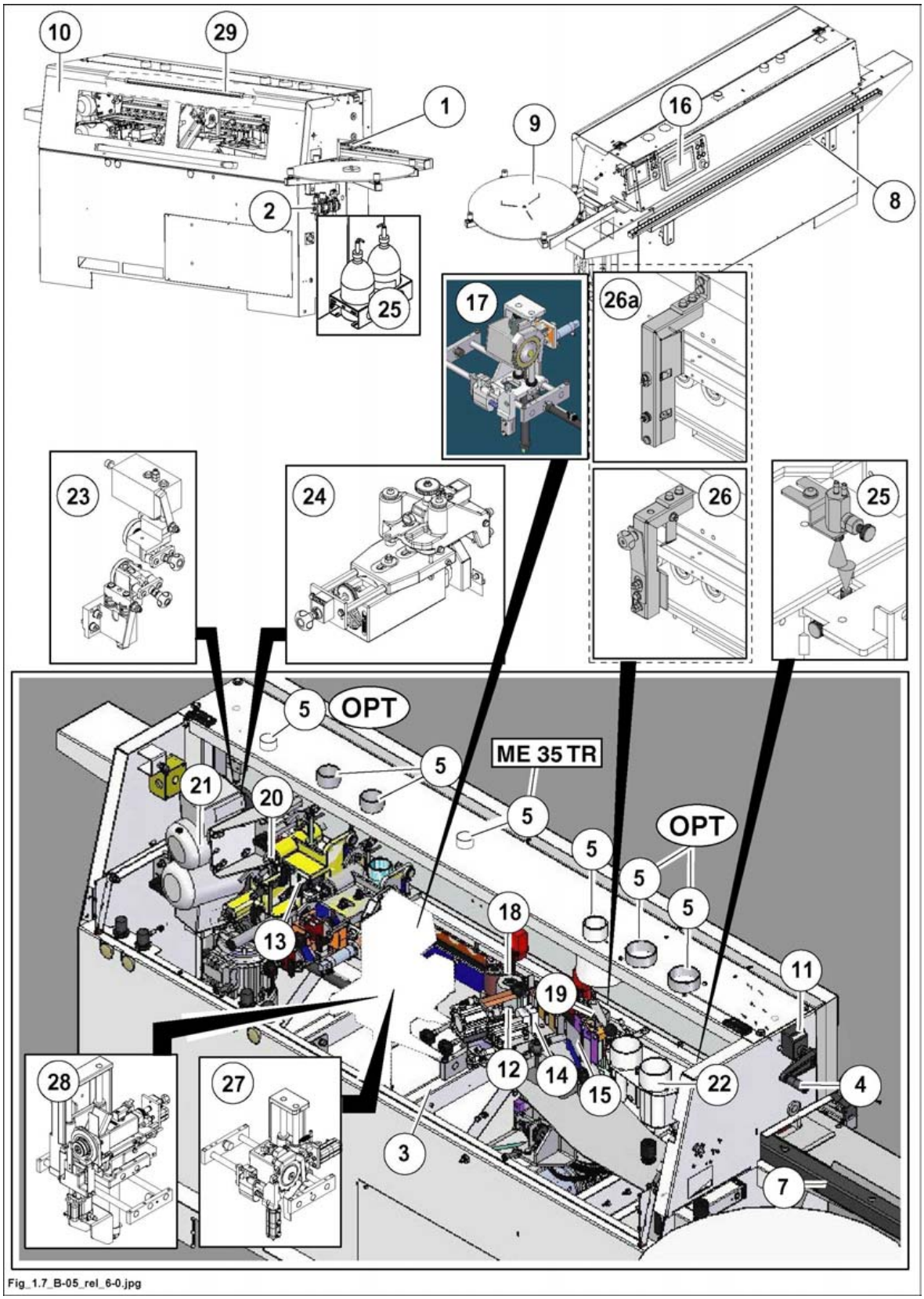
25 - Self adhesive liquid unit (OPT)

26 - Panel heating pad (OPT)

26a - Infrared ceramic lamp to heat the panel edge (OPT)
27 - Header unit with "spoking"-rounding function (OPT) **- (ME 35T)**
28 - End trimmer unit with rounding unit (ME 35TR)

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29 - Internal machine lighting (OPT)



1.8 CONDITIONS FORESEEN FOR THE USE

(ad21_1-8_0.0)

This machine was designed to apply edging strips (made of melamine paper, PVC, wood and the like) to wooden panels and panels made of its derivatives (chipboard, plywood, etc.). The machine performs edge banding only on panels with edges at 90°.

The following products are used for machining:
- [1]Straight panels in chipboard, MDF and honeycomb wood.
- Edging in paper, melamine, ABS, PP, PVC, various wood veneers and solid wood.
- Hot-melt glue ("EVA based" STD or polyurethane OPT).
- Liquid Riepe-LPZ/II ® , sprayed by the anti-adhesive unit AAR.

NOTE-INFORMATION:
It is MANDATORY TO USE ONLY PANELS and EDGES FREE of foreign bodies (nails, stones, metal parts, ETC.).
SUCH BODIES, WHICH CAN NOT ONLY DAMAGE THE MACHINE PARTS, CAN ALSO GENERATE SPARKS (BY COMING INTO CONTACT WITH THE MACHINING UNIT TOOLS) WHICH MAY ENTER THE EXTRACTION SYSTEM AND CAUSE FIRES AND/OR EXPLOSIONS.

NOTE-INFORMATION:
Before using the above described products, the operator must read and understand any safety data sheets supplied by the relative manufacturers, suppliers or dealers.

The client must request the relative specific data sheets from the manufacturers, suppliers and dealers and attach them to this manual to ensure that the assigned operators and maintenance personnel are properly informed.

[1]DANGER-WARNING:
THE PANEL SURFACES MUST NOT HAVE OPENINGS OR RECESSES THAT COULD CONSTITUTE A RISK OF ENTANGLEMENT / ENTRAPMENT DURING THE VARIOUS MACHINING PHASES.

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1.9 TOOLS WHICH MAY BE USED

(ad21_1-9_0.0)

The machine has been designed to use only tools proper for the material used.

Follow the instructions of the manufacturer for use, adjustment and repair of the tools.



FORBIDDEN:
permitted operating speeds are marked on the tools. Do not exceed these limits.

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

1.10 WORKING ENVIRONMENT

(ad21_1-10_0.0)

The machine can work under these conditions:

Max. altitudine sea level: 1000 m (in case of higher altitude apply to the machine manufacturer)

Temperature: Min. +18° C (32.4°F) ; Max. +35° C (63°F) (macchina in operation)
Temperature: Min. +05° C (9°F) ; Max. +35° C (63°F) (machine off, not in working condition)



NOTE-INFORMATION:
to achieve an optimal gluing finish follow the indications supplied by the glue manufacturer with the product technical sheet.

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.



NOTE-INFORMATION:
"ELECTROMAGNETIC COMPATIBILITY"
The machine complies with the requirements of standard CEI EN 50370-1:2006.

1.11 INCORRECT USE THAT CAN BE REASONABLY EXPECTED

(ad21_1-11_0.0)

- 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.3.1).
- DO NOT use one piece HSS blades (HIGH SPEED STEEL BLADES)
- 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.
- IT IS FORBIDEN remove waste, offcuts or workpiece parts from the machining areas while the machine is operating.

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

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1.11.1 TAMPERING

(me35_1-11-1_0.0)



FORBIDDEN:
DO NOT make modifications to the machine.



FORBIDDEN:
NEVER CARRY OUT VARIATIONS TO THE MACHINE CONFIGURATION PARAMETERS AND AT ANY RATE NEVER CARRY OUT ANY TYPE OF MODIFICATION TO THE MACHINE
IN THE EVENT OF TAMPERING, THE MANUFACTURER IS NOT RESPONSIBLE FOR DAMAGE TO PROPERTY OR PERSONS AND ANIMALS.



FORBIDDEN:
Do not under any circumstance install software different from the software installed by the manufacturer.
Software that has not been tested by the manufacturer could compromise correct operation of the machine.
The Manufacturer accepts no liability for defects or damage caused by a failure to comply with this warning.

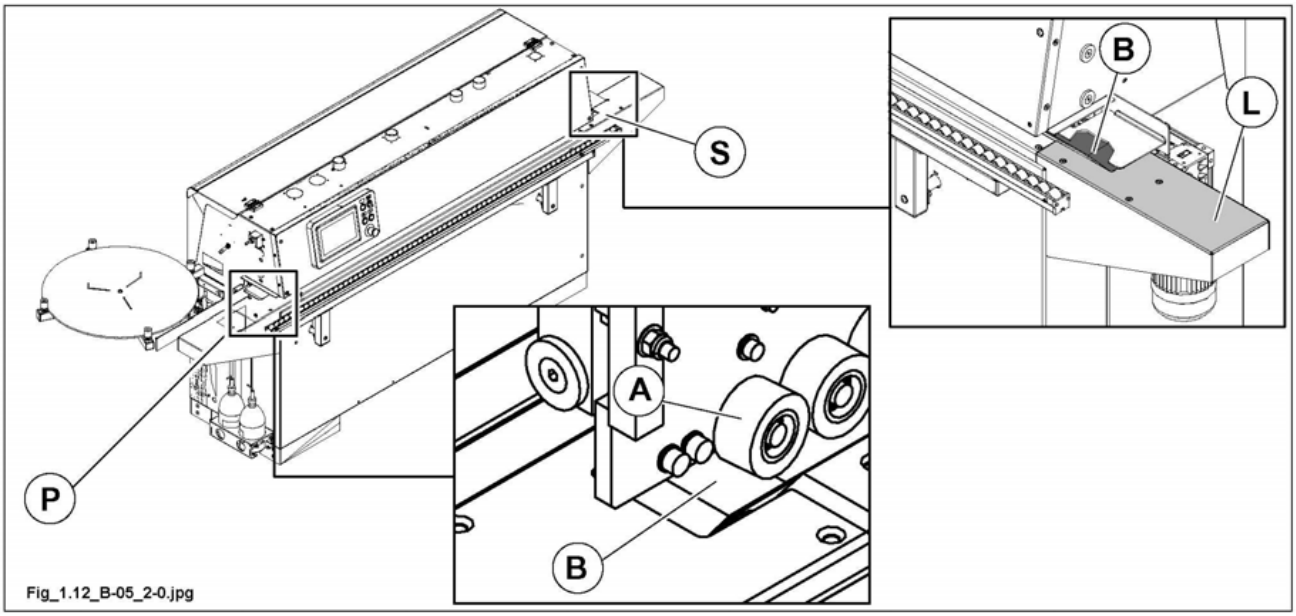
1.12 RESIDUAL RISKS

(ad21_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.

Despite observance of all the safety regulations, and use according to the rules described in this manual, residual risks may still be present, among which the most recurring are:



- **In the panels loading area (P)**
  gripping and dragging, crushing.
- **In the panel feed area:**
  gripping and dragging, shearing and cutting, if hands are inserted between the presser (A) and the feed track (B).
- **In the panel unloading area (S):**
  gripping and dragging, crushing, shearing and cutting if hands are inserted between the panel being machined and the support plate (L) or between the feed track (B) and the support plate.
- **Inhalation of wood dust produced during machining.**
- **Inhalation of toxic fumes produced by heated glue.**
- **Being hit by flying chips and/or small fragments of machining waste. Risk due to the possibility of non homogeneity of the materials machined.**
- **Grazing and/or cutting when in contact with the cutting edges of the tools installed on the machining units.**
- **Scorching and burning when in contact with the unit tools and/or motors.**
- **contact with tool**
- **contact with moving parts**
- **accidents due to wood splinters or fragments**
- **tool insert ejection**
- **electrocution from contact with live parts**
- **danger due to incorrect tool installation**
- **inverse tool rotation due to incorrect electrical connection**
- **danger due to dust inhalation in case of working without vacuum cleaner.**

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Bear in mind that the use of any machine tool carries risks.
Use the appropriate care and concentration for any type of machining (also the most simple).
The highest safety is in your hands.



DANGER-WARNING:
in case of failure on the energy source, the stopping time of the tools can exceed 10 sec, consequently, BE CAREFUL to the release of the cowling, the TOOLS MAY BE WORKING.



DANGER-WARNING:
AS FOR the RISKS CAUSED BY GLUE USAGE, PLEASE REFER TO THE corresponding SAFETY CARD.
The user is responsible for acquiring directly the safety sheets for the substances replaced during the life of the machine. Such sheets are subject to regular updates due to the evolution of the specific standard.



DANGER-WARNING:
Self adhesive liquid unit OPT
For the risks caused by "RIEPE-LPZ-II" liquids, please refer to the corresponding safety sheet.



DANGER-WARNING:
Infrared ceramic lamp OPT
Explosion risk
The infrared heaters cannot be installed and operated in potentially explosive environments.

Fire risk
The heater, during its operation, generates extreme temperatures (due to the infrared radiation) that affect parts close to the radiator.
If a fire is started while using the infrared heater, immediately cut off the electrical power supply. Use only CO2 or halogenated hydrocarbon extinguishers to put out the fire.

Burns risk
Parts close to the radiator and that receive the infrared radiation tend to heat up during use. Suitable protections must be installed based on how close the parts are to the heat source signalled with pictograms.

Infrared radiation risk
Infrared radiation is harmful to the human eye; use suitable means to reduce the diffused radiation and if possible avoid exposing people while the radiation is operating.
Supply personnel with Personal Protection Equipment to protect skin and in particular eyes, during the phases when they are exposed close to the radiators.
We recommend using infrared protective lenses to provide greater protection for the corneal epithelium and the ocular dioptric elements, such as the crystalline lens and the retina.

1.13 OPERATOR'S TRAINING

(ad21_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 the training shall include:
a) The principles of the right use and operation of the machine.
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

(ad21_1-14_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

(ad21_1-14-1_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

(ad21_1-14-2_0.0)



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

1- Before you start any work on the machine, check the working area for potential hazards. Check the efficiency of guards and safety devices at regular intervals.
2- Before you start the machine, ensure that all guards are firmly fixed in position and are fully efficient.
You must switch off and lock out the machine before starting to fit or adjust the guards.
3- Before you start the machine, ensure that there are no sawdust, woodshavings or extraneous objects on the worktable or inside the guards.
4- Do not machine workpieces which are too large or too small for the machine.
For details of workpiece dimensions, see section 3.1 "Workpiece dimensions".
5- Do not machine workpieces which are smaller than the size currently set on the machine.
6- Do not machine workpieces with clearly visible defects (excessive bending, splits, knots, metallic parts, ...).
7- Ensure that the guards are in position and fully efficient at all times.
8- When machining long workpieces, use suitable extension roller conveyors or tables (not supplied by SCM).
9- Ensure that the extractor hoods are connected to the extraction system at all times.
Before you start using the machine, ensure that the extraction system is switched on.
10- The guards must be fitted at all times when the machine is operating - even during test runs to check cutter block adjustment.
11- Do not attempt to remove waste, offcuts or workpiece parts from the machining areas while the machine is operating.
12- Fire hazard from sawdust and shavings. Remove sawdust and shavings at regular intervals. Switch off and lock out the machine before removing sawdust, shavings and waste.
13- Do not adjust machine settings while the machine is operating.



FORBIDDEN:
The use of the machine is not permitted if such conditions are not kept.
in case of long machining pauses or machine stops turn main switch to 0 and lock it.

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1.14.3 TOOLS SAFETY

(ad21_1-14-3_0.0)

1- Before fitting the tools, make sure that each support surface is clean, free from dents and perfectly flat.
2- The tools shall be fitted and set when the machine is off, STILL TOOLS and with proper instruments (gauge, comparator).
3- 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.
4- Fit the tools in the right working direction.
5- For fastening the saw blade to the spindle, the use of rings or bushes not prescribed by SCM is forbidden.
6- 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.
7- Use only tools in accordance with Norm.
8- Before starting the machine make sure that the tools do not touch the fixed parts of the machine.
9- Start working only when the tools have reached the right cutting speed.



1.14.4 WORKING AREA SAFETY

(ad21_1-14-4_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.

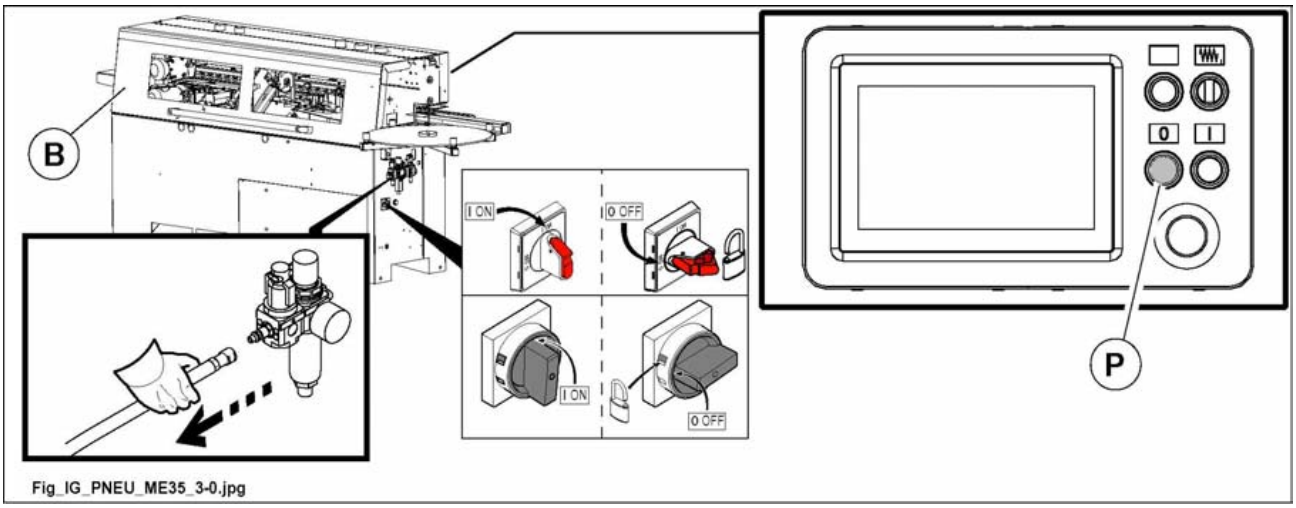
1.14.5 MAINTENANCE SAFETY

(ad21_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.

NOTE-INFORMATION:
to open the hood (fitted with a microswitch), proceed as follows:
- Switch the main ON-OFF switch to the "I" (ON) position.
- ONLY after pressing the (P) button, and after some seconds (20 sec. - motors stop) it is possible to open the protective cowling (B);
- Switch the main ON-OFF switch to the "0" (OFF) position.

1- Before performing cleaning, maintenance, adjustments, fitting or removing of any machine part, set the main ON/OFF switch to the zero (OFF) position and padlock it off, disconnect the compressed air tube at the filter unit infeed and place a sign indicating this situation on the machine.
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.

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1.15 EMERGENCY CONDITIONS

(ad21_1-15_0.0)

DANGER-WARNING:
in case of flooding of the room where the machine is housed, immediately disconnect the electric and pneumatic 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

(ad21_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

(ad21_1-16-1_0.0)

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.

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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)

(ad21_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).

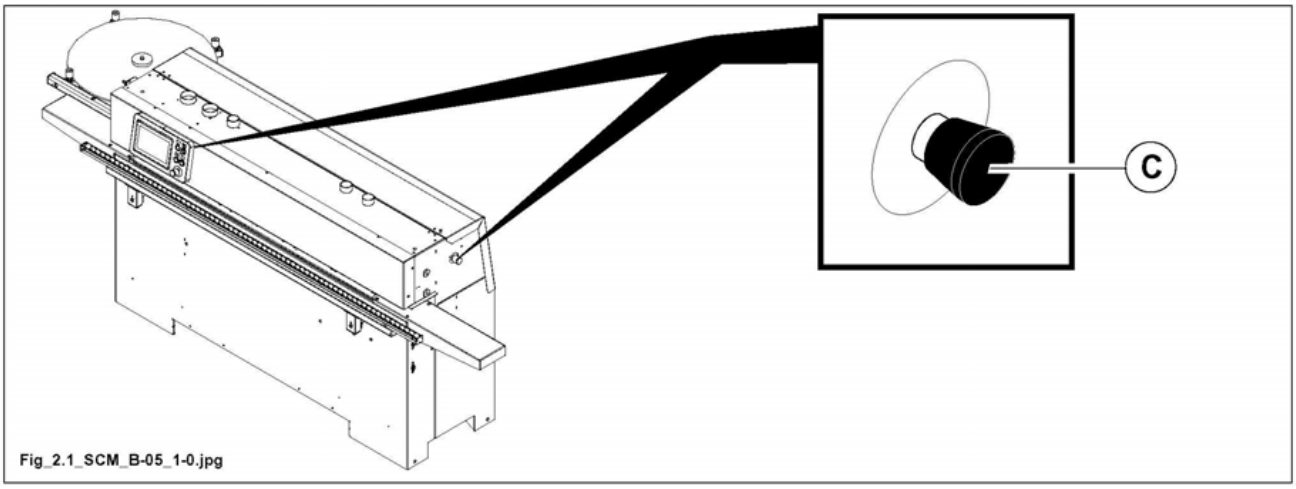
Description

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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C
Fig_2.1_SCM_B-05_1-0.jpg

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

(ad21_2-2_0.0)

Safety devices are special accident-prevention guards whereby the machine is protected against possibly dangerous situations.



DANGER-WARNING:
safety devices must never be removed or disconnected for no reason whatsoever ("Direttiva macchine" 2006/42/CE).

Description

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

B - Guard:
Prevents access to moving parts.

C - Door:
Screwed closed, prevents access to the electric panel

D - Safety strip preventing the infeed of workpieces which are too thick.

E - Hazard warning signage (triangle on yellow background) on various parts of the machine.
Obligatory plates (blue background) on various parts of the machine.

F - Extractor hoods.

M - Interlock microswitch on guard hood. This prevents opening of the hood while the machine is operating:
ONLY after pressing the (P) button, and after some seconds (20 sec. - motors stop) it is possible to open the protective cowling (B).

When the power supply is cut off, the tilting protection can only be opened by using the microswitch manually (M); using the appropriate key (W) rotate the screw clockwise (1) until it is released.
The machine is in safe conditions and the protection can be opened.



DANGER-WARNING:
before resuming machining, rotate the screw (1) anti-clockwise and close the guard (B).

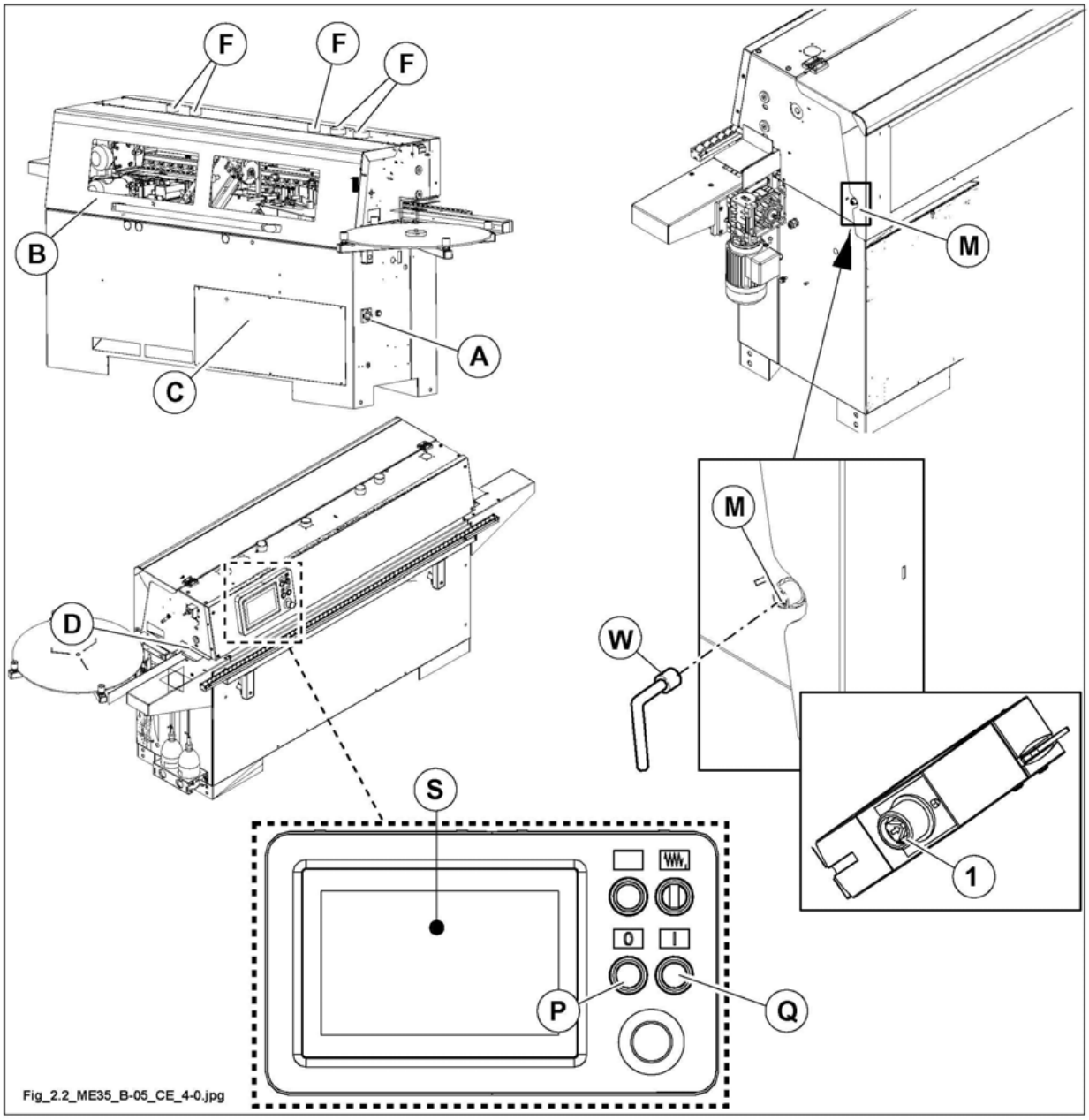


CAUTION:
periodically, check that the devices, listed above, are efficient.

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NOTE-INFORMATION:
the appearance of the alarm code "GEN003 - Hood open" (on the display S of the control panel) indicates the obligation to verify the correct operation of the safety microswitch of the hood (B). See Ch. 05 "Diagnostics" of the manual (attachment) of the ELECTRONIC CONTROL for a detailed report on the alarm reported (Type, Description, Start (date and time), Stop (date and time)).

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

(ad21_3-1_0.0)

DIMENSIONS OF WORKPIECE TO BE MACHINED			
A	Minimum length of edge for edging (ME 35 – ME 35T)	190	mm
A	Minimum length of edge for edging (ME 35TR)	120	mm
B	Minimum panel width	110	mm
C	Min. insertion distance between 2 panels	600	mm
Minimum machinable panel thickness		8	mm
Maximum machinable panel thickness		50	mm

⚠: never machine workpieces smaller than the measurements set out above

⚠: maximum length and width cannot be defined. We recommend to use table extensions (not supplied by SCM) at entry and exit side in case of panels longer than
- Max. length 1000 mm
- Max. width 600 mm

⚠: the panel that follows can only be inserted when the green arrow **F** appears on the machine display.

DANGER-WARNING:
the appearance of the alarm code "GEN001" (on the control panel display S) indicates that a panel that is too short has been put into operation, which is dangerous for correct operation of the machine.
See Ch. 05 "Diagnostics" of the manual (attachment) of the ELECTRONIC CONTROL for a detailed report on the alarm reported (Type, Description, Start (date and time), Stop (date and time)).

CAUTION:
PROFILES THAT CAN BE MACHINED WITH THE "NESTING" TRACK FELLER KIT (OPT)
To machine panels from the "Nesting" production cycle must comply with the indications contained in the figure below (detail 1), relative to:

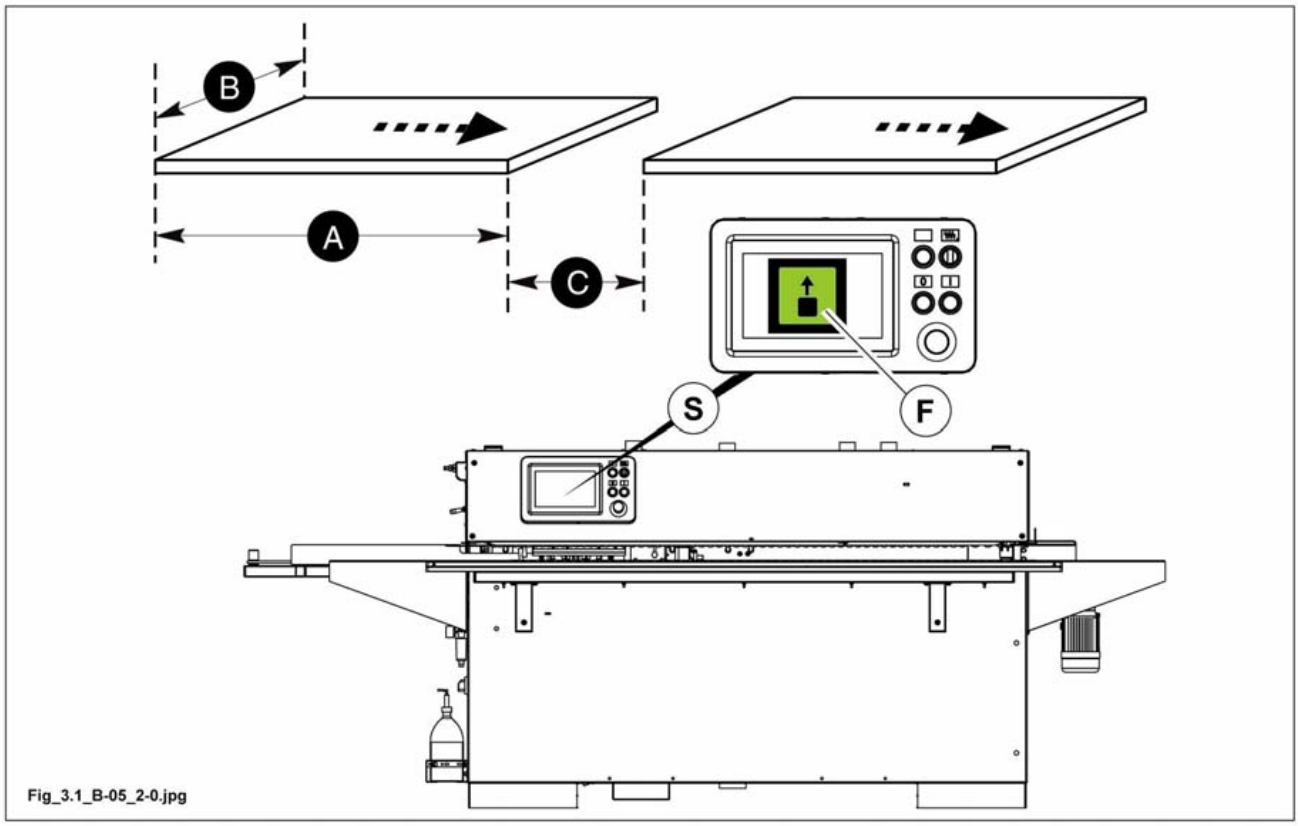
- MINIMUM distance of the holes of the hinges in relation to dimensions A and B of the panel;

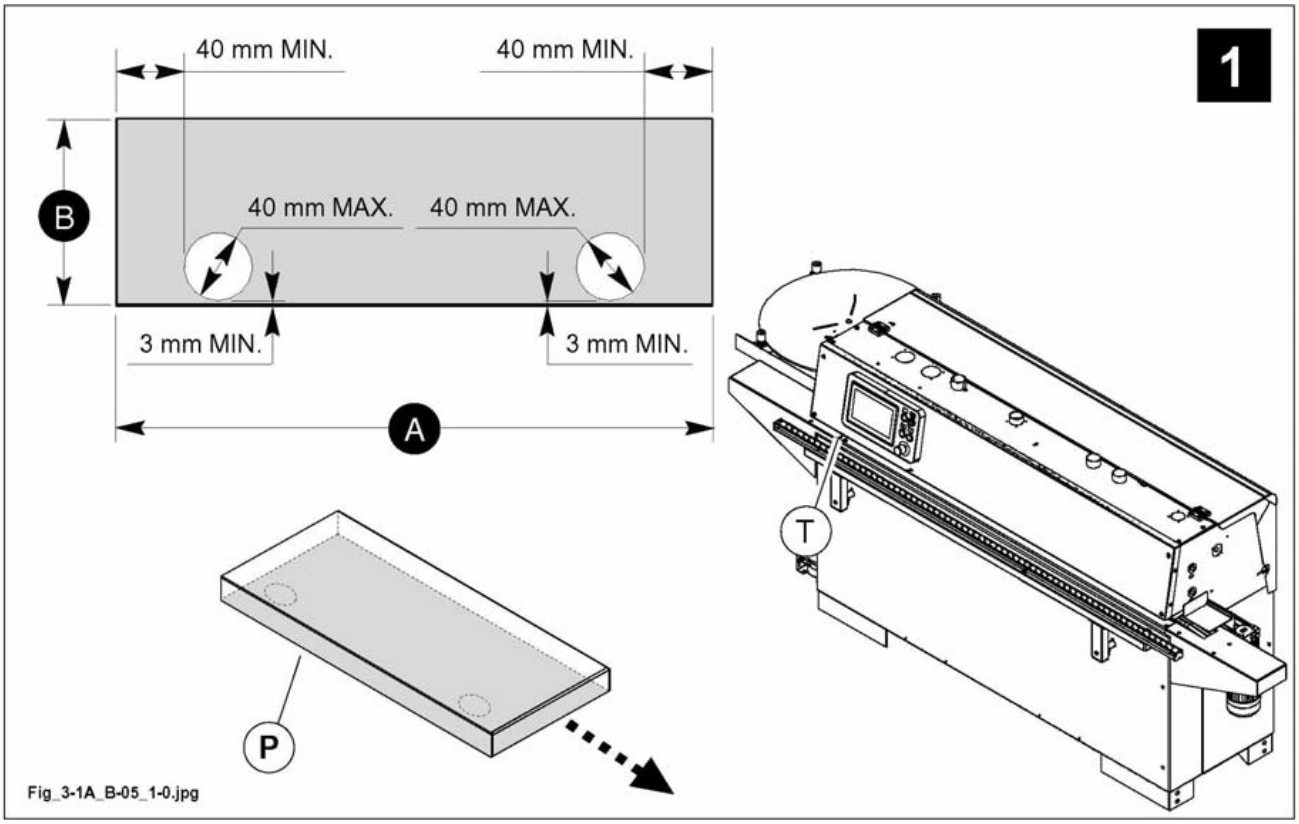
- panel position. The surface P with the hinges holes must be resting against the feed track T because the presence of the aforementioned holes, must be 'read' by the 3 points of the vertical track feeler installed on the lower unit.

When machining panels from the "Nesting" production cycle the LOWER GLUE SCRAPER must always be excluded (see Par. 6.12).

CAUTION:
if the indication above, for the correct position of the panel in the machine, is not complied with, the machining will certainly damage the panel.

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B
A
C
S
F
Fig_3.1_B-05_2-0.jpg


1
40 mm MIN.
40 mm MIN.
B
40 mm MAX.
40 mm MAX.
3 mm MIN.
3 mm MIN.
A
T
P
Fig_3-1A_B-05_1-0.jpg

3.2 TECHNICAL DATA

(ad21_3-2_0.0)

GENERAL TECHNICAL SPECIFICATIONS			
Worktable height		900	mm
Minimum /maximum coiled edging thickness		0,4 / 2	mm
Maximum coiled edging thickness (OPT)		3	mm
Minimum / maximum strips thickness		0,5 / 3	mm
Maximum strips thickness (OPT)		5	mm
Maximum strips pack on loader (OPT)		45	mm
Maximum reel diameter		Ø 700	mm
Panel feed speed		~ 7	m/min
Pneumatic system operating pressure		6,5	bar
Pneumatic system network operating pressure		8	bar
Air consumption for one panel L=3300mm		470	NL/min
Glue tank capacity		~ 1	Kg
Glue operating pressure		170 ÷ 220	°C
Working temperature of polyurethane glue (OPT)		120 ÷ 140	°C
Power drawn by the glue tank heating element		1,4	Kw
(*) – Glue tank motor power	50Hz	0,25	Kw
	60Hz	0,30	
(*) – Feed track motor power	50Hz	0,55	Kw
	60Hz	0,65	
	60Hz single phase (OPT)	0,9	
(*) – Upper brush motor power	50Hz	0,14	Kw
	60Hz	0,17	
	50Hz single phase (OPT)	0,12	
	60Hz single phase (OPT)	0,14	
(*) – Lower brush motor power	50Hz	0,14	Kw
	60Hz	0,17	
	50Hz single phase (OPT)	0,12	
	60Hz single phase (OPT)	0,14	
Net weight: see plate of machine identification			
Working voltage and frequency: see plate of machine identification			

Motors:
Technical data: see motor identification plate (*) – Type of service: S1 Service conditions: see Par. 1.10

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TECHNICAL SPECIFICATIONS		
Glue vapours connection tube diameter	Ø 60	mm
Trimmer extraction connection tube diameter (n.2)	Ø 60	mm
Rectifier extraction connection tube diameter (n.2) OPT	Ø 80	mm
Grooves unit extraction connection tube diameter (n.1) OPT	Ø 60	mm
Tube diameter suction connection group header - rounder (no.1) (ME 35TR)	Ø 60	mm
Suction air speed	20	m/sec
Suction air consumption [Ø 60 + Ø 60 + Ø 60]	(203x3) = 609	m³/h
Suction air consumption [Ø 60 + Ø 60 + Ø 60 + Ø 80 + Ø 80] OPT	1333	m³/h
Suction air consumption [Ø 60 + Ø 60 + Ø 60 + Ø 60] OPT	812	m³/h
Suction air consumption [Ø 60 + Ø 60 + Ø 60 + Ø 60 + Ø 80 + Ø 80] OPT	1536	m³/h

RECTIFIER UNIT TECHNICAL SPECIFICATIONS OPT			
Maximum rectifier stock removal		55	mm²
Maximum removable thickness		2	mm
Rectifier motor power	50 Hz	2.2	Kw
	60 Hz	3.0	Kw
Rectifier cutters rotation speed		7100	r.p.m.
Cutters shaft diameter		Ø 30	mm
Rectifier cutter Z2+2 (n.2)	diameter	Ø 80	mm
	height	56	mm
Extractor hoods (N. 2)		Ø 80	mm
Extracted air consumption		724	m³/h

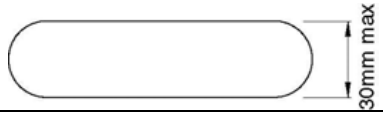
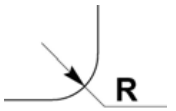
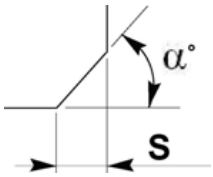
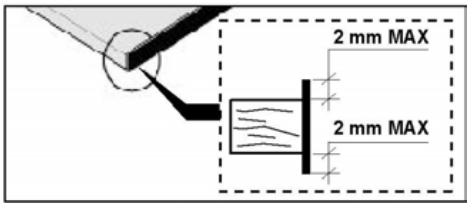
Motors:
Technical data: see motor identification plate Type of service: S6 – 40% (exempt from energy efficiency restrictions set out by regulation (EC) 640/2009) Service conditions: see Par. 1.10

END TRIMMER UNIT TECHNICAL SPECIFICATIONS (ME 35 – ME 35T) - STD			
Minimum /maximum coiled edging thickness		0,4 / 2	mm
Maximum coiled edging thickness OPT		3	mm
Minimum / maximum strips thickness		0,5 / 3	mm
Maximum strips thickness OPT		5	mm
Type of machining	Pneumatic work selected from the control panel		
End trimmer motor power	200 Hz	0,2	Kw
Trimmer blade rotation speed		12000	r.p.m.
End trimmer blade - Z 24 (alternate teeth)	diameter	Ø 125	mm
	thickness	3,2	mm
	Hole diameter	Ø 30	mm
Sensor		Front	

TECHNICAL DATA GROUP INTESTATOR WITH ROUNDING (ME 35T) - OPT			
Minimum /maximum coiled edging thickness		0,4 / 2	mm
Maximum coiled edging thickness OPT		3	mm
Minimum / maximum strips thickness		0,5 / 3	mm
Maximum strips thickness OPT		5	mm
Rounded end trimming	Radius STD	2	mm
	Radius OPT	3	mm
Type of machining	Pneumatic work selected from the control panel		
End trimmer motor power	200 Hz	0.2	Kw
Trimmer blade rotation speed		12000	r.p.m.
End trimmer blade - Z 12 (alternate teeth)	diameter	Ø 125	mm
	thickness	3.2	mm
	Hole diameter	Ø 30	mm
Sensor		Front	

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TECHNICAL DATA GROUP INTESTATOR - ROUNDING (ME 35TR)			
Minimum /maximum coiled edging thickness		0.4/3	mm
Type of machining	Pneumatic work selected from the control panel		
Motor power	200 Hz	0.35	Kw
Tool rotation speed		12000	r.p.m.
Tool	Work diametre	Ø 50	mm
	Hole diameter	Ø 16	mm
	No. of teeth	4	--
	Spoke radius (STD)	2	mm
	Spoke radius (OPT)	1 - 1.5 - 3	mm
Sensor		Front	

Workable panel				
Minimum thickness			8	mm
Maximum thickness	Straight thickness		50	mm
	Shaped thickness		30	mm
i : **maximum dimensions of the shaping.**			Rmax = 15	mm
			Smax = 10	mm
			α = 45°	
: **the applied edge must protrude no more than 2 mm from the panel.**				

NOTE-INFORMATION:
the panels and their corresponding coatings must be sufficiently resistant. If the panels and related coatings are deformed on contact with the copiers, the processing is compromised.
Solid wood edges are not workable.

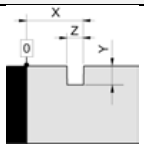
FORBIDDEN:
It is absolutely forbidden to machine metal edgings or edgings containing metal.

TRIMMER UNIT TECHNICAL SPECIFICATIONS			
Minimum /maximum coiled edging thickness		0,4 / 2	mm
Maximum coiled edging thickness (OPT)		3	mm
Minimum / maximum strips thickness		0,5 / 3	mm
Maximum strips thickness (OPT)		5	mm
Trimmer motor power (n.2)	200 Hz	0,35	Kw
Trimmer unit cutters rotation speed		12000	r.p.m.
Tools: cutters (n.2)	diameter	Ø 55.3	mm
	height	21	mm
	hole diameter	Ø 16	mm
Rounded trimming:	radius (STD)	2	mm
	radius (OPT)	1 - 1,5 - 3	mm
Extractor hoods (n.2)		Ø 60	mm
Extracted air consumption		406	m³/h

EDGE SCRAPER UNIT TECHNICAL SPECIFICATIONS (OPT)			
Panel thickness		8 ÷ 50	mm
Edging thickness		Min. 1 mm Max. 3 mm	mm
Tools:	tips	12.6 x 12.6	mm
	thickness	3,18	mm
			mm
Rounded edging:	radius (STD)	2	mm
	radius (OPT)	1 - 1,5 - 3	mm

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GLUE SCRAPER UNIT TECHNICAL SPECIFICATIONS (OPT)			
Panel thickness		8 ÷ 50	mm
Edging thickness		Min. 0.5 mm Max. 3 mm	mm
Tools:	knife	14 x 14	mm
	thickness	2	mm

TECHNICAL SPECIFICATIONS GROOVES UNIT (OPT)				
	Maximum depth of the groove (**Y**)		8	mm
	Groove width (**Z**)		8	mm
	Blade horizontal movement (**X**) (including blade thickness)		0 - 20	mm
Motor power		200 Hz	1.1	Kw
Blade rotation speed			12000	r.p.m.
Blade - Z 4		diameter	Ø 100	mm
		thickness	4	mm
		hole diameter	Ø 30	mm
Extractor hoods			Ø 60	mm
Extracted air consumption			203	m³/h

ANTI-ADHESIVE UNIT TECHNICAL SPECIFICATIONS (OPT)		
Working pneumatic pressure	3	bar
Compressed air consumption	20	Nl/min
Liquid consumption (indicative)	1	l/5000 mt
Tank capacity	2	l
Name of the liquid: RIEPE – LPZ II		

3.3 STANDARD ACCESSORIES

(ad21_3-3_0.0)

Upper steel presser with two staggered rows of rubber pressure wheels.
Manual lifting of presser with automatic positioning of the machining head according to panel thickness.
Numerical thickness indicator of selected panel.
Panel support roller bed along full length of machine.
Dedicated glue fume extraction and centralised extraction of other residues.
Safety booth.
Temperature control of applied glue integrated on PLC.
Automatic lowering of glue tank temperature after machine remains idle for a set time.
Device for automatic recovery of unused glue.
Automatic loader for coiled edging with cutter for edges up to 3 mm thick.
Swivel coil holder diameter 700 mm.
Edge pressure rollers (2 rollers).
End cutting unit with motor for 90° cutting of excess edging, front and rear.
Trimmers unit with motor, equipped with horizontal and vertical pad feelers for perfect alignment of tools with machining point.
Infeed guide adjustable according to thickness of applied edging.
Feed track: chain fitted with self-lubricating nylon pads, covered in rubber with a high friction coefficient.
End trimmer unit with rounding unit (ME 35TR)
Glue tank unit

Trasformer for auxiliary circuit 110 V
Motor overload cutout

Set of tools and wrenches for use and maintenance

3.4 OPTIONAL ACCESSORIES

(ad21_3-4_0.0)

Edge scraper unit can be disabled for finishing of 2 mm or 3 mm PVC/ABS edging.
Cutter kit for R = 3 mm trimmers instead of R = 2 mm.
Cutter kit for R = 1,5 mm trimmers instead of R = 2 mm.
Cutter kit for R = 1 mm trimmers instead of R = 2 mm.
Brushes unit with two independent motors tilted and vertically adjustable to optimise edge cleaning/polishing action.
Automatic loader for edging slats with magazine.
The gluescraper unit.
Rectifier unit
Routing group - rounding unit (ME 35T)
Grooves unit
Self adhesive liquid unit
Panel heating pad
Infrared ceramic lamp for heating the panel edge
Machine internal lighting
Additional pair of diamond tipped cutters for trimmers R = 3 mm
Additional pair of diamond tipped cutters for trimmers R = 2 mm
Additional pair of diamond tipped cutters for trimmers R = 1.5 mm
Additional pair of diamond tipped cutters for trimmers R = 1 mm
Glue tank fast replacement kit
Spare glue tank
Replacement glue tank for POLYURETHANE glue with quick discharge

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3.5 NOISINESS LEVEL

(ad21_3-5_0.0)

DECLARED DUAL-NUMBER NOISE EMISSION VALUES in accordance with ISO 4871

Operating conditions – **Edge banding** (in compliance with EN ISO 18217:2015)					
Description of sizes measured		Reference norm	Uncertainty **K**	**Edging**	
Lop: acoustic pressure level at operator work station dB(A) and peak level [dB(C)]	Operator positions	EN ISO 11202:2010	4 dB	**VSA**	**LAV**
	INFEED			75	75 [92]
	OUTFEED			75	78 [95]
Lw: level of acoustic power emitted dB(A)		EN ISO 3746:2010	4 dB	96	97
The pondered **C** maximum instant acoustic pressure value is less than 130 dB(C).					
VSA : Idle working without suction		**LAV :** In operation			

With rectifier unit (OPT)

DECLARED DUAL-NUMBER NOISE EMISSION VALUES in accordance with ISO 4871

<table>
<tr><td colspan="6">Operating conditions – Edge banding (in compliance with EN ISO 18217:2015)</td></tr>
<tr><td colspan="2">Description of sizes measured</td><td>Reference norm</td><td>Uncertainty K</td><td colspan="2">Edging</td></tr>
<tr><td rowspan="3">Lop: acoustic pressure level at operator work station dB (A) and peak level [dB(C)]</td><td>Operator positions</td><td rowspan="3">EN ISO 11202:2010</td><td rowspan="3">4 dB</td><td>VSA</td><td>LAV</td></tr>
<tr><td>INFEED</td><td>79</td><td>80</td></tr>
<tr><td>OUTFEED</td><td>80</td><td>80</td></tr>
<tr><td colspan="2">Lw: level of acoustic power emitted dB (A)</td><td>EN ISO 3746:2010</td><td>4 dB</td><td>98</td><td>99</td></tr>
<tr><td colspan="6">The pondered C maximum instant acoustic pressure value is less than 130 dB(C).</td></tr>
<tr><td colspan="3">VSA : Idle working without suction</td><td colspan="3">LAV : In operation</td></tr>
</table>

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
- machine and tool maintenance
- proper use of ear protective means.
- **Proper means for ear protection.**

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3.5.1 DUST EMISSION

(ad21_3-5-1_0.0)

DUST EMISSION	
Operating conditions – **Edge banding**	
Reference regulations: **BG-GS-HO- 05**	Quantity of dust emitted [mg/m^3]
Operator position	< 2

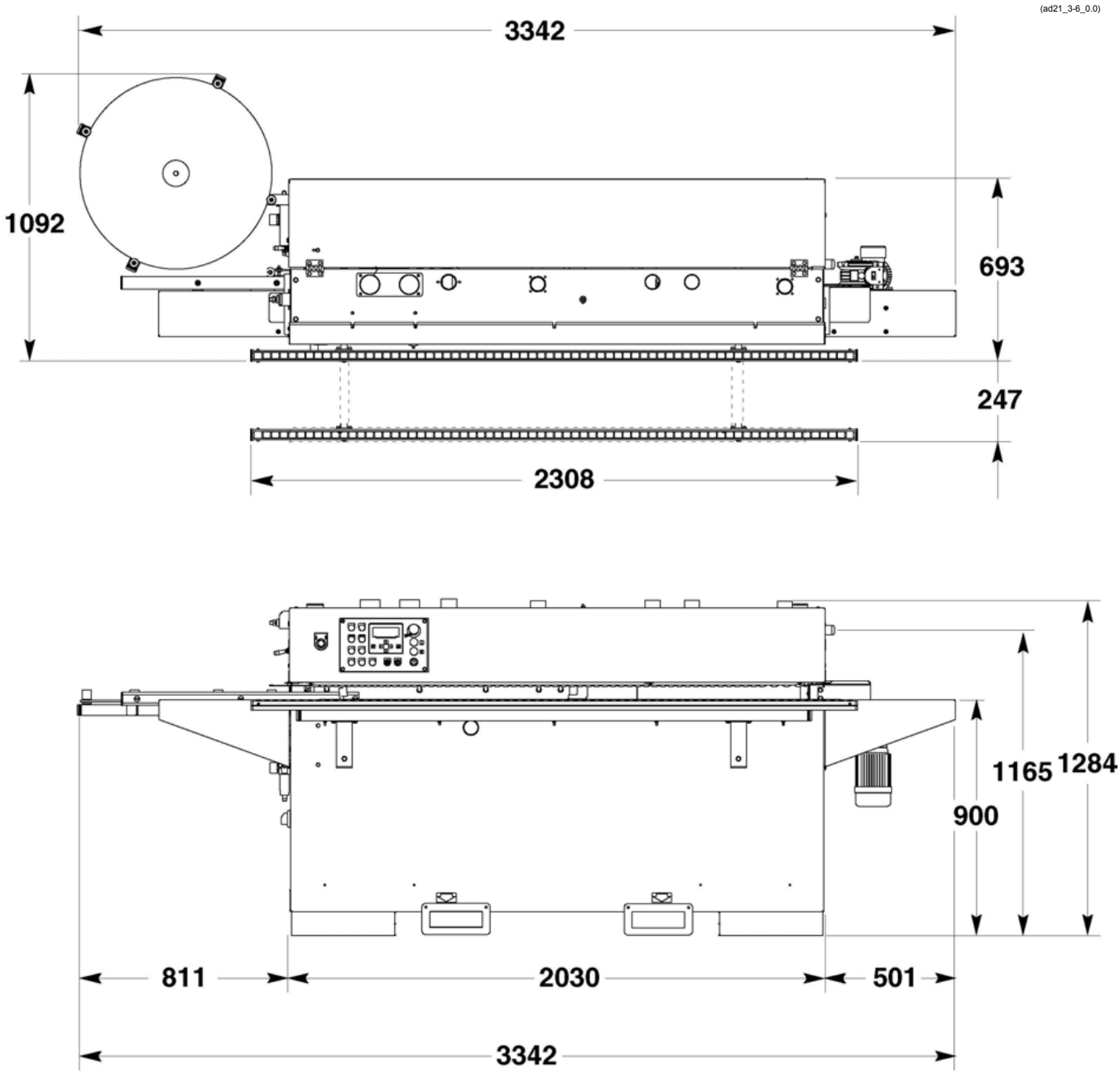
DANGER-WARNING:
HARDWOOD SAWDUSTS ARE HARMFUL TO YOUR HEALTH

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.

3.6 OVERALL DIMENSIONS

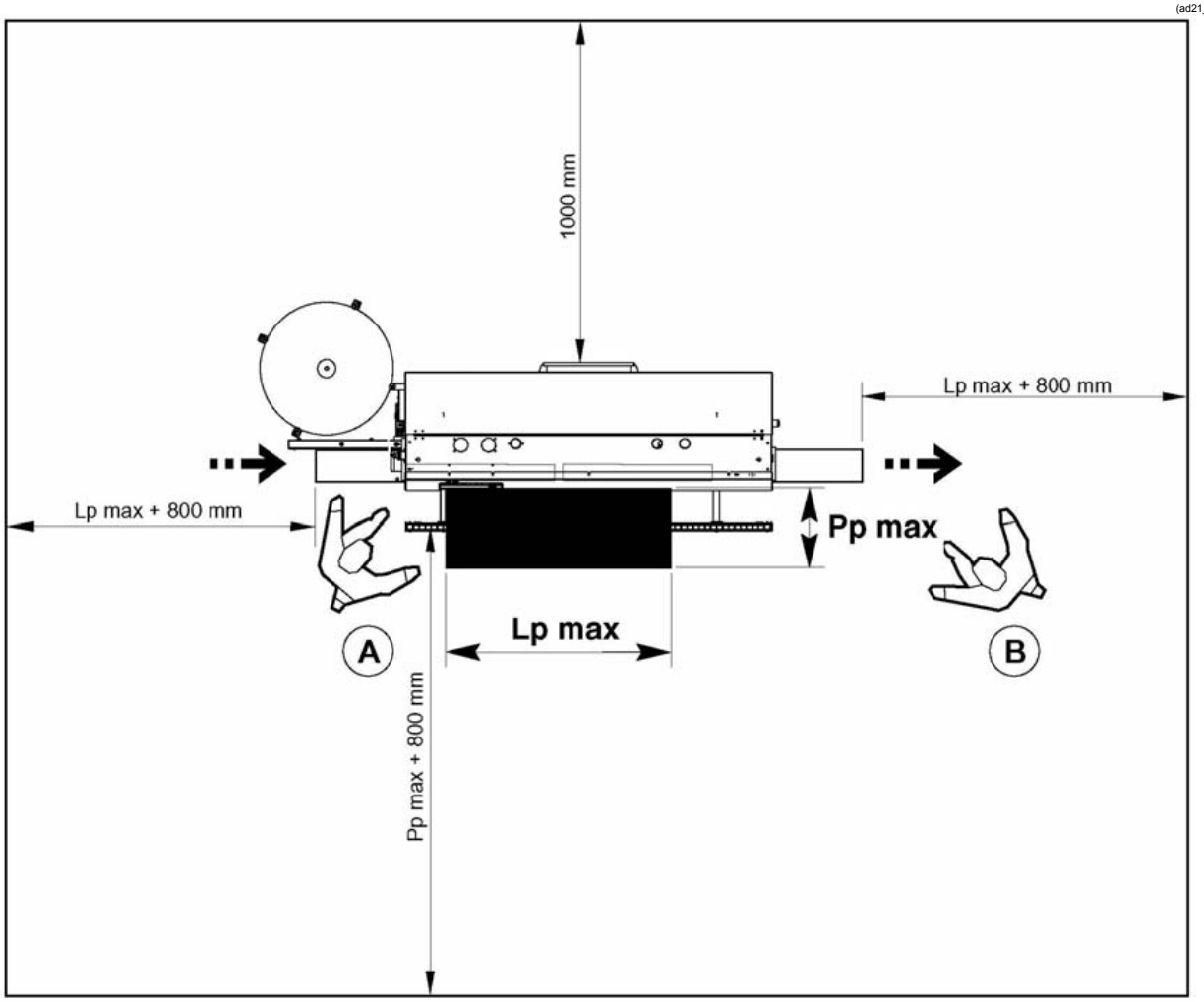
(ad21_3-6_0.0)



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3.7 WORKING AREA

(ad21_3-7_0.0)



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

Pp max / Lp max = Max. workpiece length.
A ***Operator zone for panel insertion.***
B ***Operator zone for pickup of finished panels.***

DANGER-WARNING:
failure to comply with the required spaces may lead to hazardous situations for the operator and personnel around the machine.
Do not place any kind of goods in the relevant area.

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

INDEX


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4.2 Machine positioning 4


4.3 Fitting the parts demounted for transport reasons 6

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4.3.2 Fitting the reel holder 8

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4.4.1 Requisites for the electricity supply system 14


4.4.2 Electric connection 20


4.4.3 Check the correct connection 20


4.5 Connection to the suction system 22


4.6 Connection to pneumatic system 24

4.1 UNLOADING THE MACHINE

(ad21_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 unloaded by a lift truck, by inserting the forks into proper spaces (A) indicated by the blue plates ; proceed with caution in order to prevent the machine overturning.
- Make sure that the lift truck is proper for the machine weight.
- During the machine raising avoid sudden movements .

CAUTION:
make sure that the forks exceed the rear part of the frame (B).

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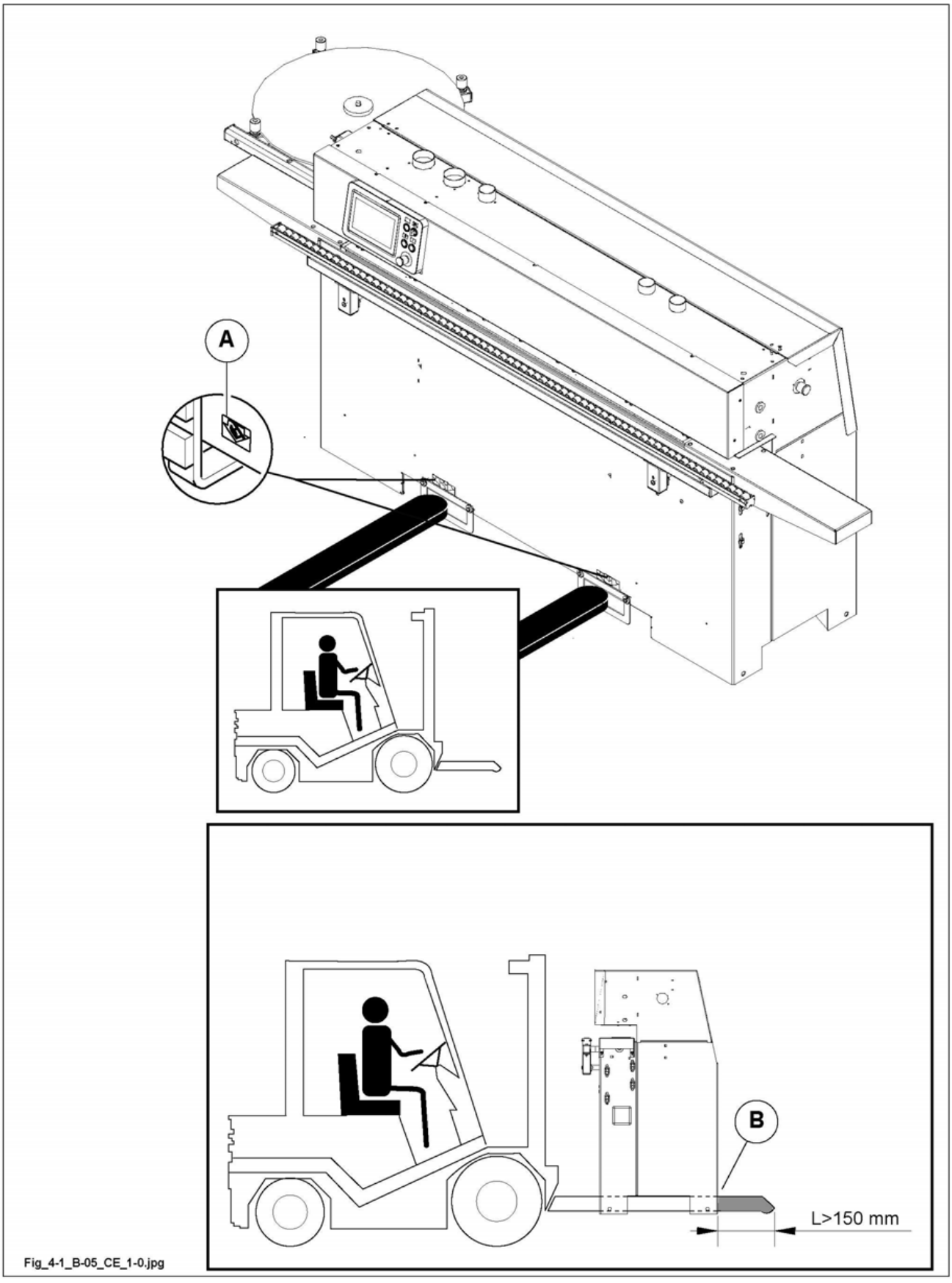


Fig_4-1_B-05_CE_1-0.jpg

4.2 MACHINE POSITIONING

(ad21_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.

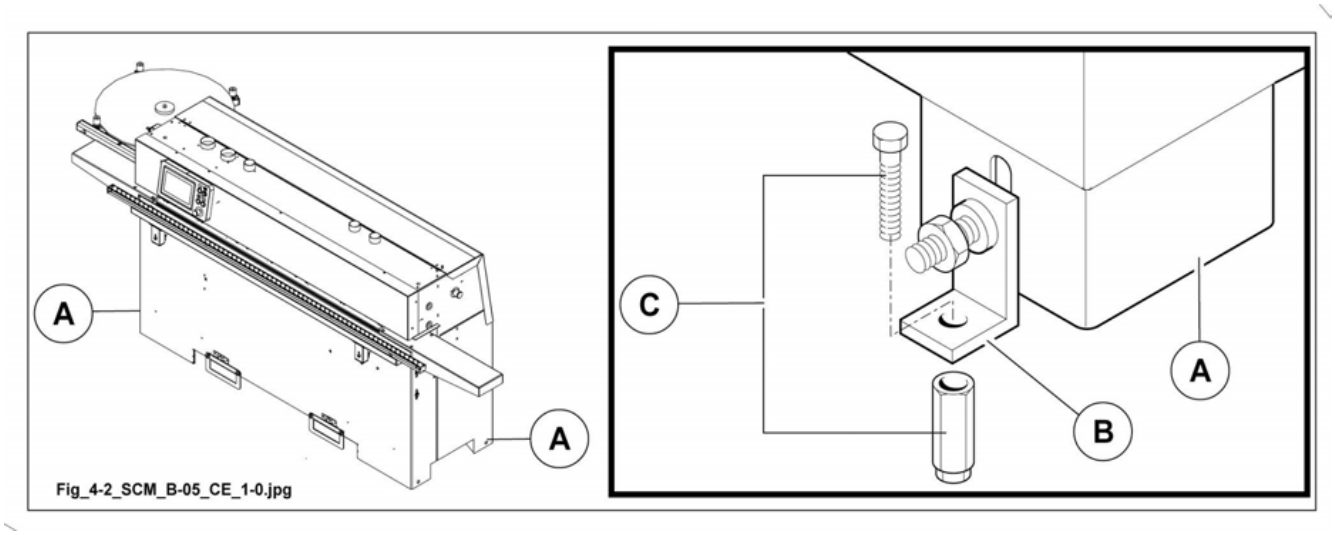
DANGER-WARNING:
during the machine positioning you have to consider that, in case of longer pieces, a sufficient room is required to avoid squashing points towards the fixed parts of the working envinronment as walls, columns etc... (see par. 3.7).

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

See par. 4.1.

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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(pag vuota)

4.3 FITTING THE PARTS DEMOUNTED FOR TRANSPORT REASONS

(ad21_4-3_0.0)

For packing and transport reasons some machine members are removed.

4.3.1 RELEASING MACHINING HEADS

(me25_4-3-1_0.0)

NOTE-INFORMATION:
to open the hood (fitted with a microswitch), proceed as follows:
- Switch the main ON-OFF switch to the "I" (ON) position.
- ONLY after pressing the (P) button, and after some seconds (20 sec. - motors stop) it is possible to open the protective cowling (B);
- Switch the main ON-OFF switch to the "0" (OFF) position.

When the power supply is cut off, the tilting protection can only be opened by using the microswitch manually (M); using the appropriate key (W) rotate the screw clockwise (1) until it is released.
The machine is in safe conditions and the protection can be opened.

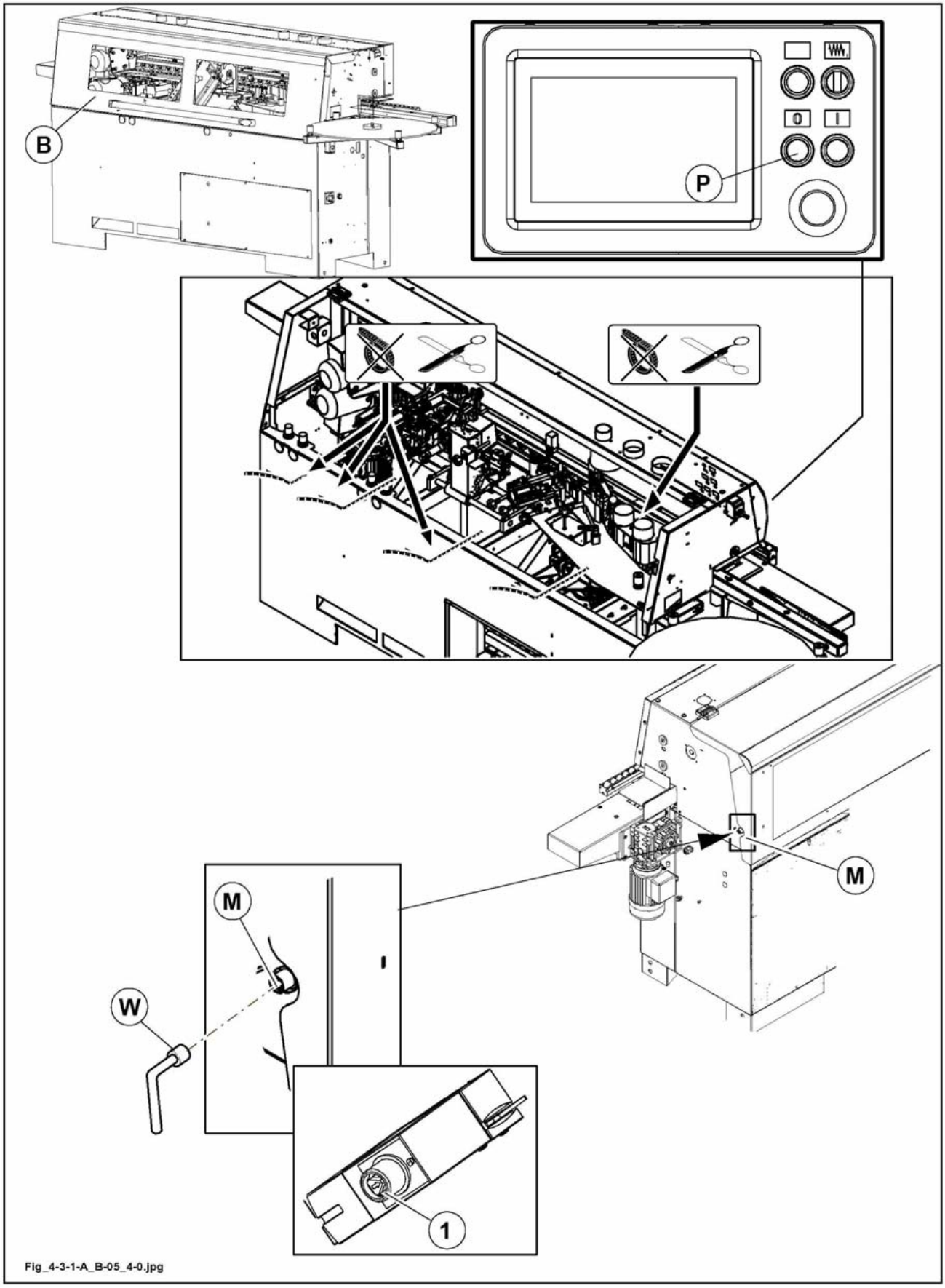
DANGER-WARNING:
before resuming machining, rotate the screw (1) anti-clockwise and close the guard (B).

NOTE-INFORMATION:
Some parts are locked to avoid damage during transportation.

Release them as indicated below:

Operating units blocking
- Remove the locking straps indicated.

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B
P
M
M
W
1
Fig_4-3-1-A_B-05_4-0.jpg

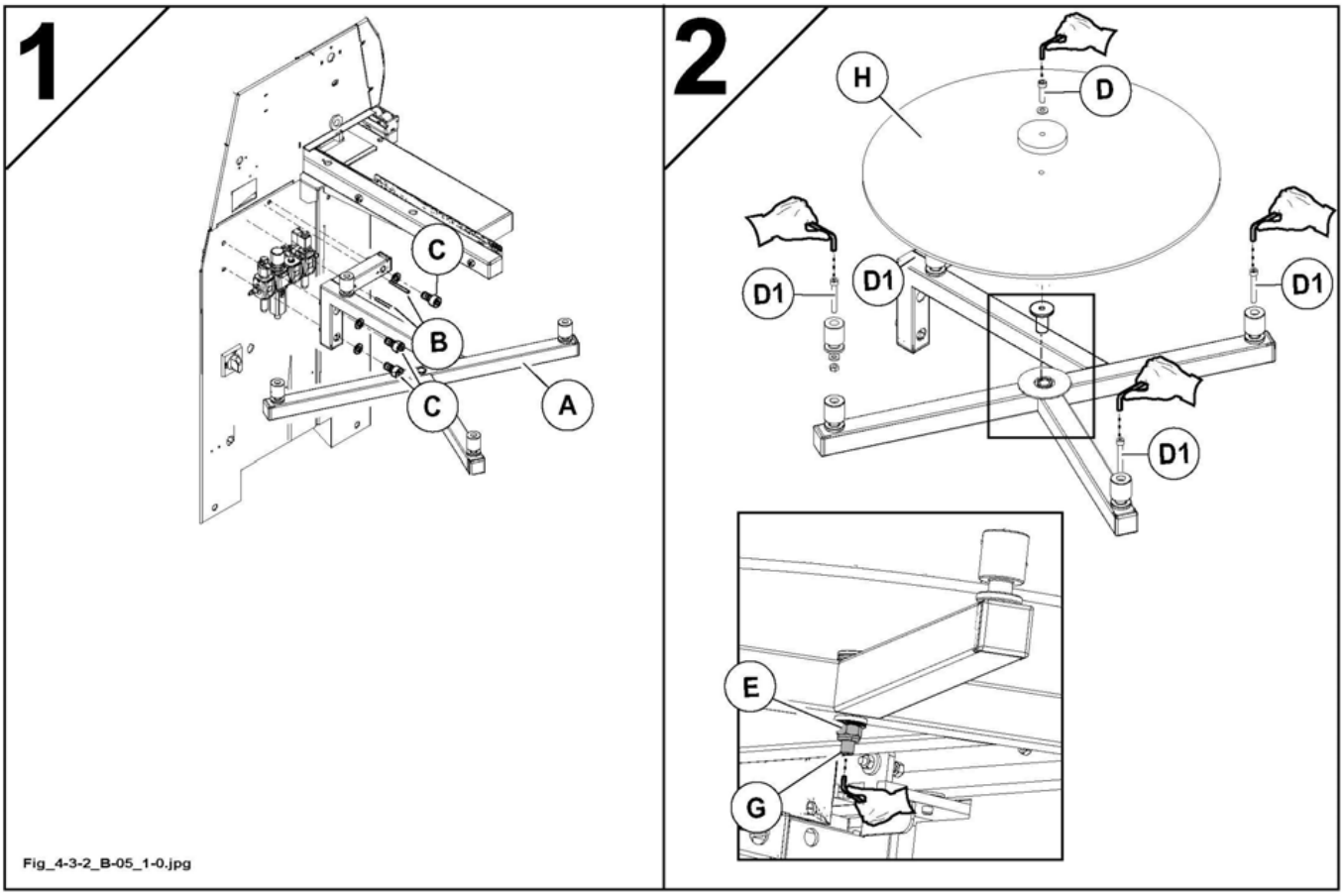
4.3.2 FITTING THE REEL HOLDER

(me25_4-3-2_0.0)

DANGER-WARNING:
for fitting these parts proper equipment and 2 persons are required.

Fit the support A by inserting the pins B in the special holes in the base and fix it with the relative screws C.
Complete assembly of the roll holder H on the support A by tightening the screws D, D1.

NOTE-INFORMATION:
if the friction of the rotation of the reel holder disc H needs to be increased, use the screw G and the nut E as shown below:
- Screw to "stiffen" the rotation.
- Unscrew to "decrease" the friction and make the rotation easier.



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(vuota000)

4.3.3 ASSEMBLY OF WORK TABLE EXTENSION AND INFEED GUIDE

(me25_4-3-3_0.0)

- Position the extensions A as indicated in figure and fix in place with the relative screws V.

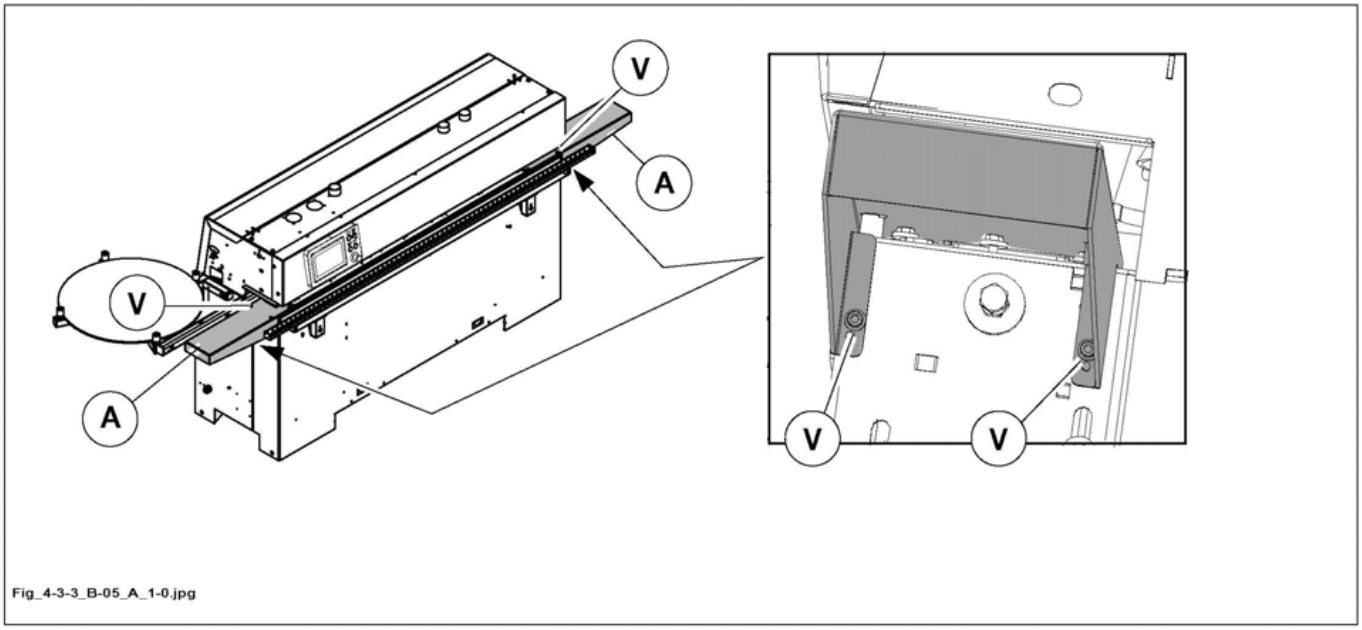


Fig_4-3-3_B-05_A_1-0.jpg

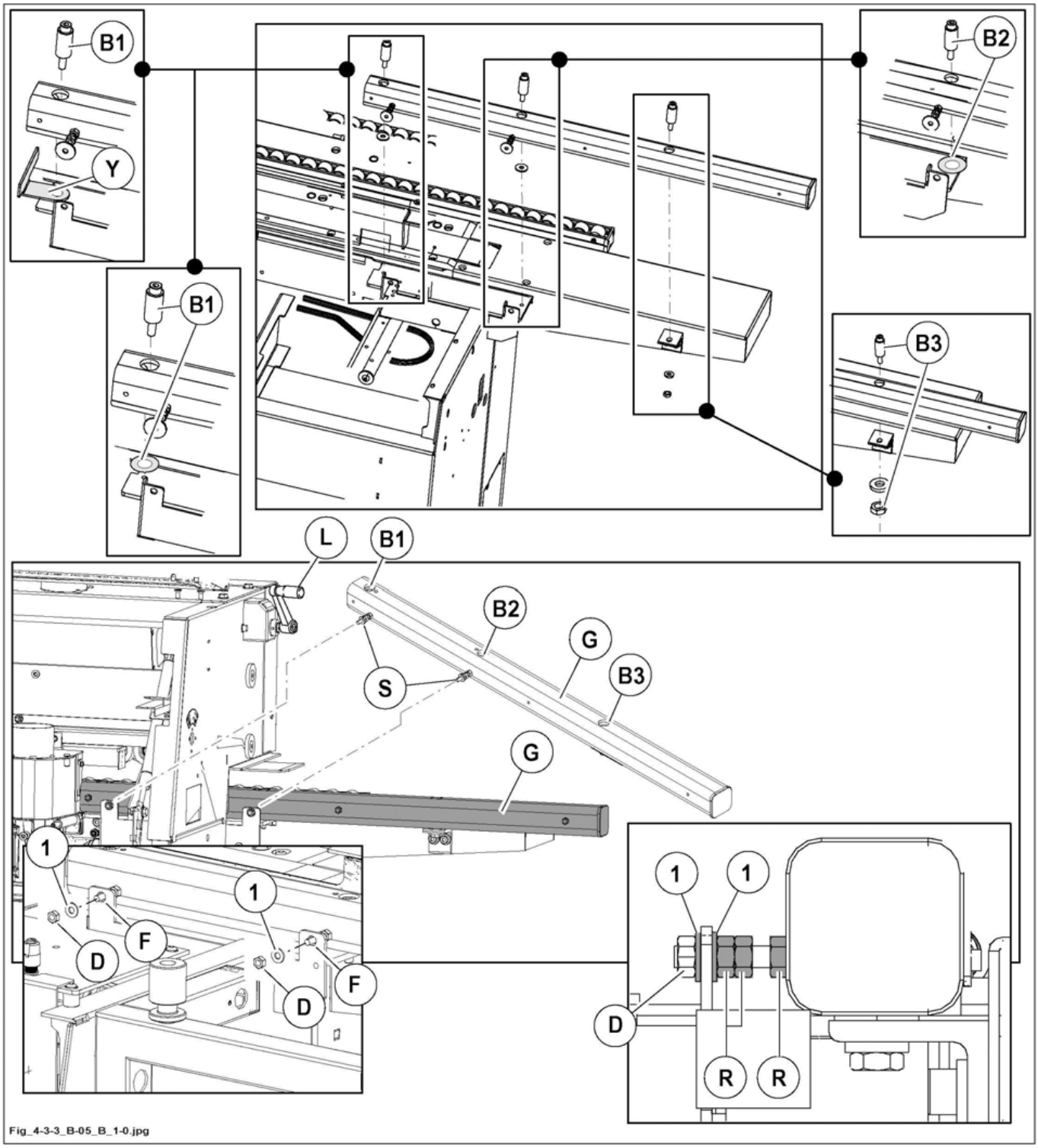
Lift the presser with the handle L.

Fit the guide G as set out below:
- insert the grub screws S in the holes F on the base, positioning the washers 1 as shown in the figure
- place the screws B1 and B2 with their spacers and B3 with the washer and nut
- tighten the nuts D
- secure the guide by tightening the screws B1, then B2 and finally B3.

DANGER-WARNING:
in the machine equipped with a RECTIFIER unit, with the screw B1 there is supplied the plate - thickness Y to be mounted as shown in the figure.

FORBIDDEN:
it is absolutely FORBIDDEN to use the machine without the plate - thickness Y.

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FORBIDDEN:
do not adjust the adjustment nuts R.

NOTE-INFORMATION:
if the G guide has been mounted correctly, tightening of the B3 screw should not cause the movement of the same guide.

4.3.5 ADDITIONAL GLUE TANK SUPPORT ASSEMBLY

(me35_4-3-5_0.0)

OPT

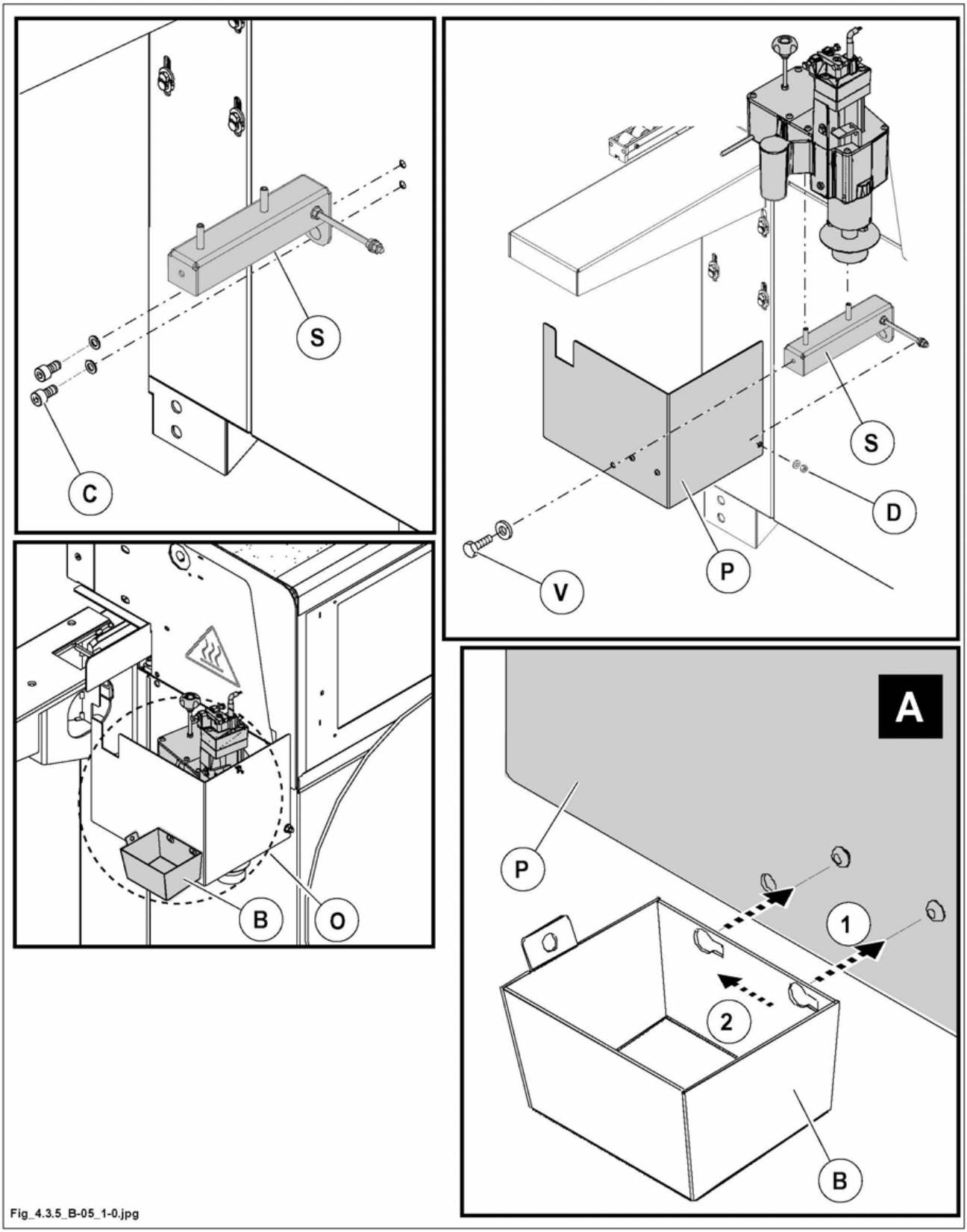
Fit the support S and fix it with the relative screws C.
Fit the protection grill P and secure it with the relative screw V and nut D.

NOTE-INFORMATION:
the tank B is supplied with the POLYURETHANE glue tank (OPT) with quick discharge.

Fix it on protection P as indicated in figure (detail A).

DANGER-WARNING:
"O": hot surfaces

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S
C
S
D
P
V
B
O
A
P
1
2
B
Fig_4.3.5_B-05_1-0.jpg

4.4 ELECTRIC CONNECTION AND GROUNDING

(st-el_4-4_0.0)

DANGER-WARNING:
The installation operations must be performed by SCM ***specialised technical personnel or personnel authorised by the manufacturer.***

4.4.1 REQUISITES FOR THE ELECTRICITY SUPPLY SYSTEM

(req_im_el_4-4-1_0.0)

INTRODUCTION

CAUTION:
For proper connection it is always mandatory to refer, in addition to the following, also to the wiring diagram and the plate on the electric panel of the individual machine.

The electrical panels of the machines are suitable to be powered to a single/three-phase network with/without neutral as indicated in the machine/plate electric panel/LAYOUT.

If the power supply voltage at the final client is different to the indications on the machine plate/electrical panel plate/LAYOUT, see the "machine electrical power supply specifications" section.

The input and connection of the power supply line inside the electrical panel must be carried out in compliance with the following instructions:

- connecting the cables to the input terminals of the main disconnection device of the electrical panel or, where present, to the connection terminal board located upstream of the switch (as also indicated in the electrical diagram)
- so as not to compromise the degree of protection IP54 of the electrical panel declared by the manufacturer by NOT drilling holes in the electrical panel carpentry;
- complying with the radii of curvature as indicated by the cable manufacturer;
- complying with the laying limits as indicated by the cable manufacturer;
- using the tightening torque indicated on the wiring diagram of the machine;
- without mechanically damaging the switch and the cable itself.

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SPECIFICATIONS OF THE ELECTRICAL SUPPLY OF THE MACHINE

- Distribution systems allowed: type TN-S / TN-C.
- Phases number (~) and neutral conductor: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Nominal voltage (Un) and tolerance when different from +/- 6%: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Voltage interruption: Power supply voltage interrupted or reset for a time not exceeding 3 ms, at any moment of the power cycle with more than 1 s between two successive interruptions.
- Voltage gaps: not exceeding 20 % of the peak supply voltage for more than one cycle with more than one second between two successive gaps.
- Frequency (f) and tolerance when different from +/- 1%: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Nominal machine current (In): see the indications on the machine plate/electrical panel plate/LAYOUT.
- Short circuit seal (Icc): see the indications on the machine plate/electrical panel plate/LAYOUT.
- Minimum neutral conductor section: see the indications on the electrical diagram/LAYOUT.
- Minimum earthing protection conductor section: see the indications on the wiring diagram/LAYOUT.



NOTE-INFORMATION:
The LAYOUT can be provided as a separate document, attached to the machine instruction manual, or integrated with it.



NOTE-INFORMATION:
When the distribution system and/or the supply voltage at the customer's premises are different from those provided for the machine, the following prescriptions apply:

- Distribution system type TN-C / TN-S in the presence of voltages other than those provided for the machine: the use of an autotransformer or transformer is required (not included in the standard supply, unless agreed otherwise).
- IT type distribution system: it is mandatory to use a three-phase transformer regardless of the supply voltage (not provided for in the standard supply unless otherwise agreed).
- TT type distribution system: in order to avoid disturbances and malfunctions it is mandatory to use a three-phase transformer regardless of the supply voltage (not provided for in the standard supply unless otherwise agreed).

The supply of a transformer/auto-transformer is ALWAYS understood as:

1) **Component not included in the standard supply and an integral part of the distribution system of the installation site.**
2) **Component external to the machine and not an integral part of it.**
3) **Component to be connected and protected by the client.**

MACHINE PROTECTION AGAINST INDIRECT CONTACTS:

The machine is equipped with a grounded earth circuit to the PE terminal.
It is up to the customer to complete the protection against indirect contact.
To this end, the customer must:

1) Use a qualified professional for the project and a qualified installer (both with the necessary requirements according to local legislation).
2) If there is a TN-S distribution system, install a differential current device (RCD) on the supply line with the following minimum specifications:
   - adjustable both in current and intervention time.
   - suitable for recognizing continuous or high frequency fault differential currents.
   - positioned outside the machine electrical panel
3) If there is a TN-C distribution system, install a differential current device (RCD) with the specifications indicated in point 2, after separating THE PEN conductor into the respective PE and N conductors upstream of the RCD itself.



DANGER-WARNING:
The installation of inadequate differential protection devices may result in unwanted untimely interventions during the use of the machine.
Any damage of any kind resulting from untimely interventions cannot be attributed to the Manufacturer of the Machine.



NOTE-INFORMATION:
Remember that in environments with greater fire risks, as expressed in IEC60364-4-42, to ensure the protection against fires caused by currents dispersed to the ground, the maximum value of the differential triggering current must be 300mA.



NOTE-INFORMATION:
The protection against such risks is the responsibility of the customer who, for this purpose, will have to use specialized personnel (electrician, installation personnel of electrical systems).
The CUSTOMER must COMPLETE the measures to guarantee the protection against electrocution risks due to indirect contacts, even if the machine includes an internal grounding system as far as the PE terminal.

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MACHINE PROTECTION AGAINST OVERCURRENTS

All branch circuits of the machine are protected against overcurrents (overload and short circuit).
It is up to the customer to ensure protection against short circuit overcurrents of the Feeder
(part of the circuit between the general disconnecting device of the machine and the bypass circuits).

To this end, the customer must:

1) Use a qualified professional for the project and a qualified installer. (Both with the necessary requirements according to local laws).

2) Protect the Feeder by installing a three-wire fuse supply line with the following minimum specifications:
   - Quick type.
   - Compatible with the Icc value required for the machine.
   - Positioned outside the machine electrical panel.
   - A size not exceeding that shown in the table.

POWER SUPPLY LINE PROTECTIONS COORDINATION

Nominal machine current (In) (A)	CABLE SECTION mm^2	Quick type fuse maximum size allowed (A) AM
---> 10	2,5	12
10 ---> 14	4	16
14 ---> 18	6	20
18 ---> 22	6	25
22 ---> 28	10	32
28 ---> 36	10	40
36 ---> 46	16	50
46 ---> 54	16	63
54 ---> 76	25	80
76 ---> 92	35	100
92 ---> 110	50	125



(A)

Voltage (Volt), current (I=ampere) are indicated on the machine identification plate.
When supplying with a transformer, see the transformer plate data.

CAUTION:
If the power cables extend from above, do not pass them near the monitor or PC.
Moreover do not use the electrical cabinet walls as a support for fixing the power cables.

MACHINE OVERVOLTAGE PROTECTION

The machine is NOT protected against overvoltages.
The electrical system may be subject to overvoltages caused by manoeuvres or faults on the electrical system or of atmospheric origin (phenomena of direct or indirect electrocution of the structure in which it is located or of the electrical line from which the machine is powered).
In the absence of specific requests or requirements from the customer, the Manufacturer of the machine cannot be held liable for damage to the electrical equipment of the machine caused by overvoltages of any kind.

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(st_04-04)

4.4.2 ELECTRIC CONNECTION

(st-el_4-4-2_0.0)

DANGER-WARNING:
before performing the connection disconnect the main line switch; in any case check that the electrical cable used for the machine connection is not live.

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

- Turn the main switch B in position "0FF".
- Open the door C of the electrical cabinet;
- insert the supply cable into proper terminal screw P;
- connect the 3 phases to terminals L1-L2-L3;
- connect the ground cable yellow-green, to terminal (⏚ / PE);
- if necessary connect neutral cable to terminal N;
- clamp terminal screw P.
- Close the machine door C.

4.4.3 CHECK THE CORRECT CONNECTION

(st-el_4-4-3_0.0)

DANGER-WARNING:
the machine is fitted with an electric device which prevents incorrect tool rotation.
If the machine does not reset at the first start-up (Sec. 5.4), immediately cut the power and invert two of the three phase wires 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.

NOTE-INFORMATION:
the documentation with wiring diagram and certificates is inside the accessories case.

NOTE-INFORMATION:
"ELECTROMAGNETIC COMPATIBILITY"
The machine complies with the requirements of standard CEI EN 50370-1:2006.

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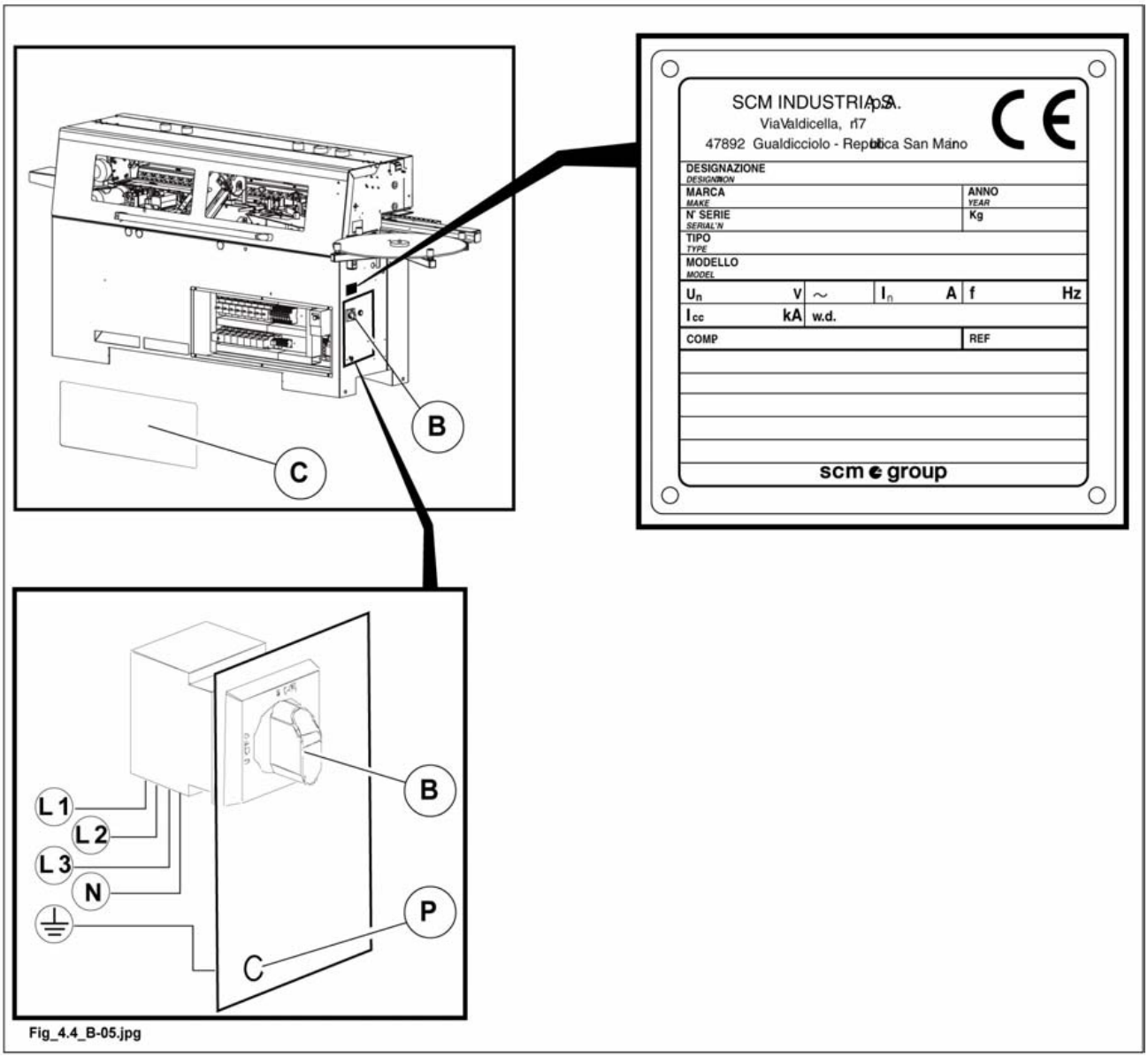


Fig_4.4_B-05.jpg

4.5 CONNECTION TO THE SUCTION SYSTEM

(ad21_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 UNI EN 12779:2016 or EN 16770:2018.

The glue tank vapour extractor system must NOT be the same as that for the dust and shavings. A dedicated systems must be used which complies with the regulations in force.

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 (n°3) - diameter 60 mm.
Clamp it with the proper metallic clip to ensure the contact between suction hood and hose.

The suction system shall ensure a flow equal to 609 m^3/h at a flow speed at least of 20 m/s.

Connect the hose to suction hood: A (n°3) - diameter 60 mm and B (OPT) (n°2) - diameter 80 mm and D (OPT) (n°1) - diameter 60 mm.
Clamp it with the proper metallic clip to ensure the contact between suction hood and hose.

The suction system shall ensure a flow equal to [A + B]1333 m^3/h / [A + D] 812 m^3/h / [A + B + D]1536 m^3/h at a flow speed at least of 20 m/s.

End trimmer unit with rounding unit (ME 35TR) - E = Ø 60 mm
Connect the hose to suction hood: A (n°3) - diameter 60 mm and B (OPT) (n°2) - diameter 80 mm and D (OPT) (n°1) - diameter 60 mm, E (n°1) - diameter 60 mm.
Clamp it with the proper metallic clip to ensure the contact between suction hood and hose.

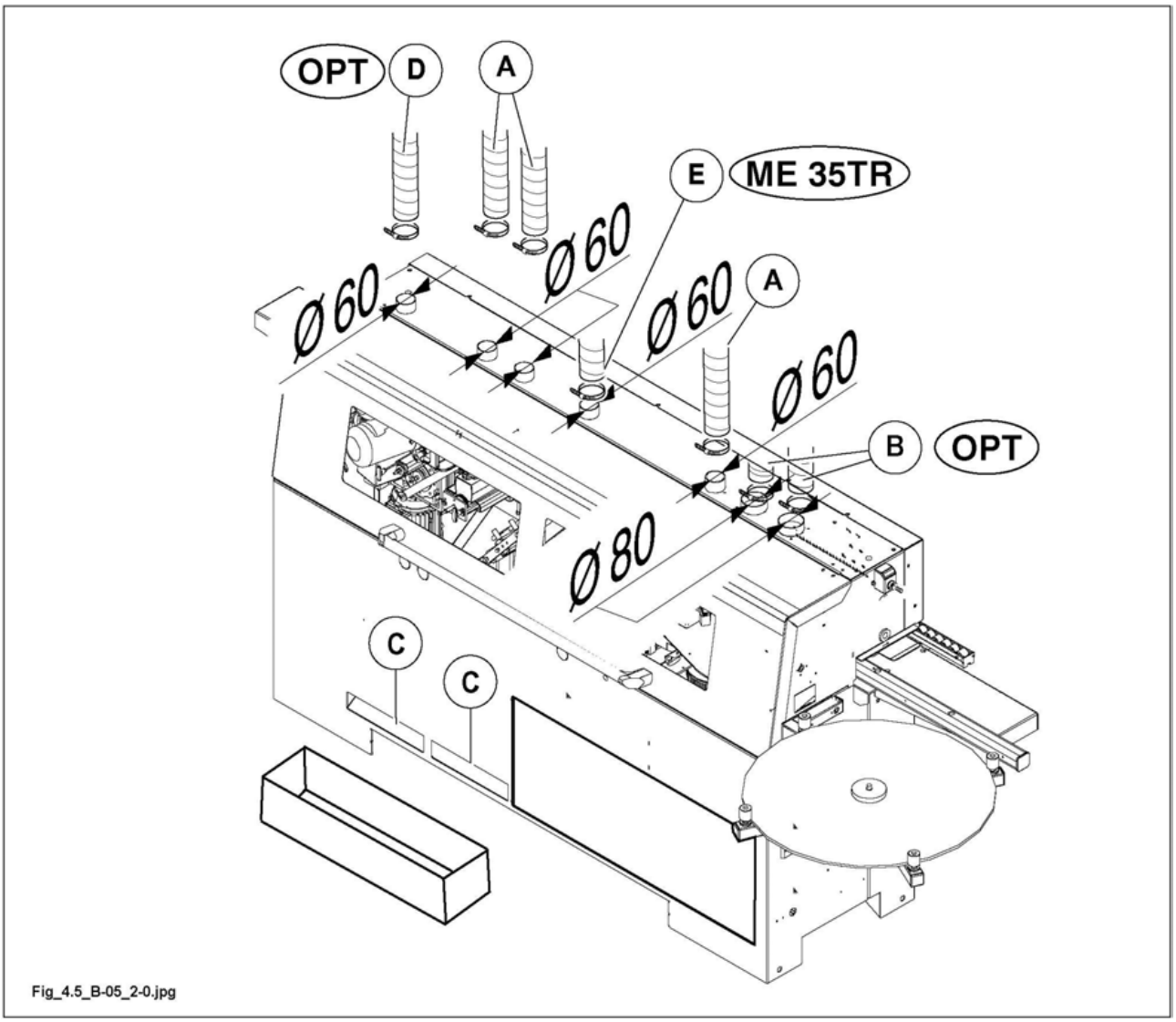
The suction system shall ensure a flow equal to [A + B + E] 1540 m^3/h / [A + D + E] 1020 m^3/h / [A + B + D + E] 1744 m^3/h at a flow speed at least of 20 m/s.

Place a shavings collection container at the outlets C.

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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OPT
D
A
E
ME 35TR
Ø 60
Ø 60
Ø 60
A
Ø 60
B
OPT
Ø 80
C
C
Fig_4.5_B-05_2-0.jpg

4.6 CONNECTION TO PNEUMATIC SYSTEM

(ad21_4-6_0.0)

- Connect feeding tube A though plug B.

FORBIDDEN:
for a correct machine operations, to not replace the quick release B of the feed pipe (external pipe diameter Ø no less than 10 mm) with fittings that reduce the inlet air flow.

- Adjust the pressure by means of knob (C): pressure gauge (D) of the pressure reducer shall indicate a value at least 6,5 BAR.

NOTE-INFORMATION:
adjust the pressure in increments (from 4 bar to 6.5 bar).

Make sure that in the compressed air system there is no water condensate or solid impurietes (residues, oil, emulsion, incrustations).
The pipes of delivery line shall have an external diameter not lower than 10 mm.
Make sure that there are no narrowing ahead of the filter/regulator unit.

The compressed air system mains pressure required is 8 bar.
Use dehumidified, non-lubricated, filtered air. Lubrication will damage the pneumatic system.

The machine has a device which prevents it from starting if the pressure supplied is less than ~ 4 bar.

DANGER-WARNING:
To interupt the pneumatic circuit press and turn element (E).
During the maintenance operations lock element (E) by inserting a padlock into slot (F).

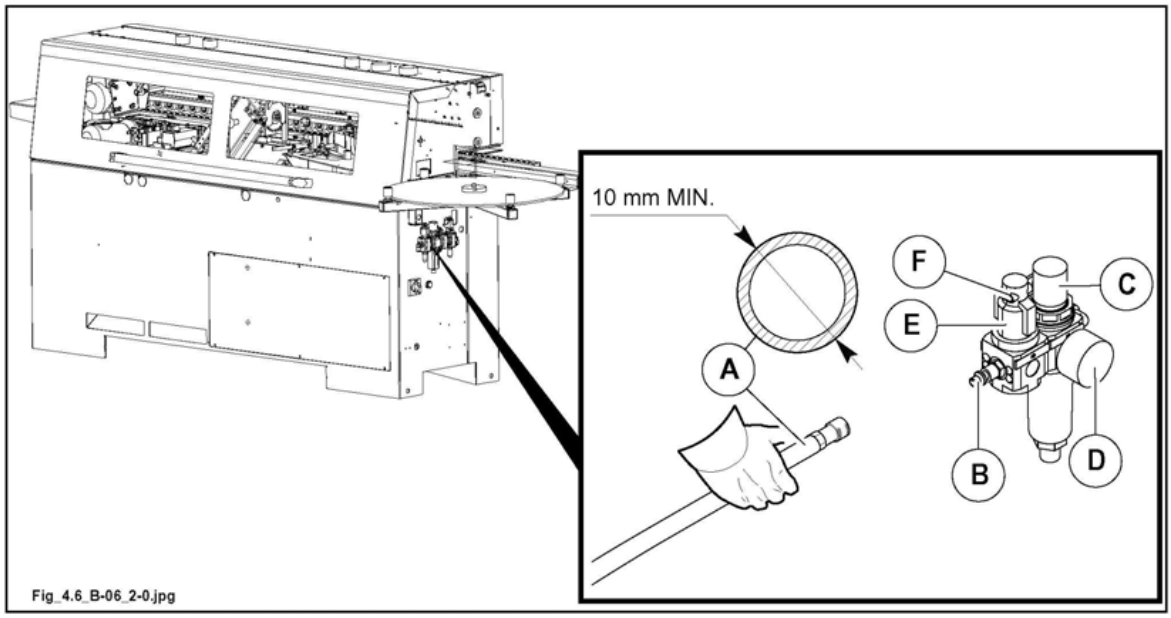


Fig_4.6_B-06_2-0.jpg

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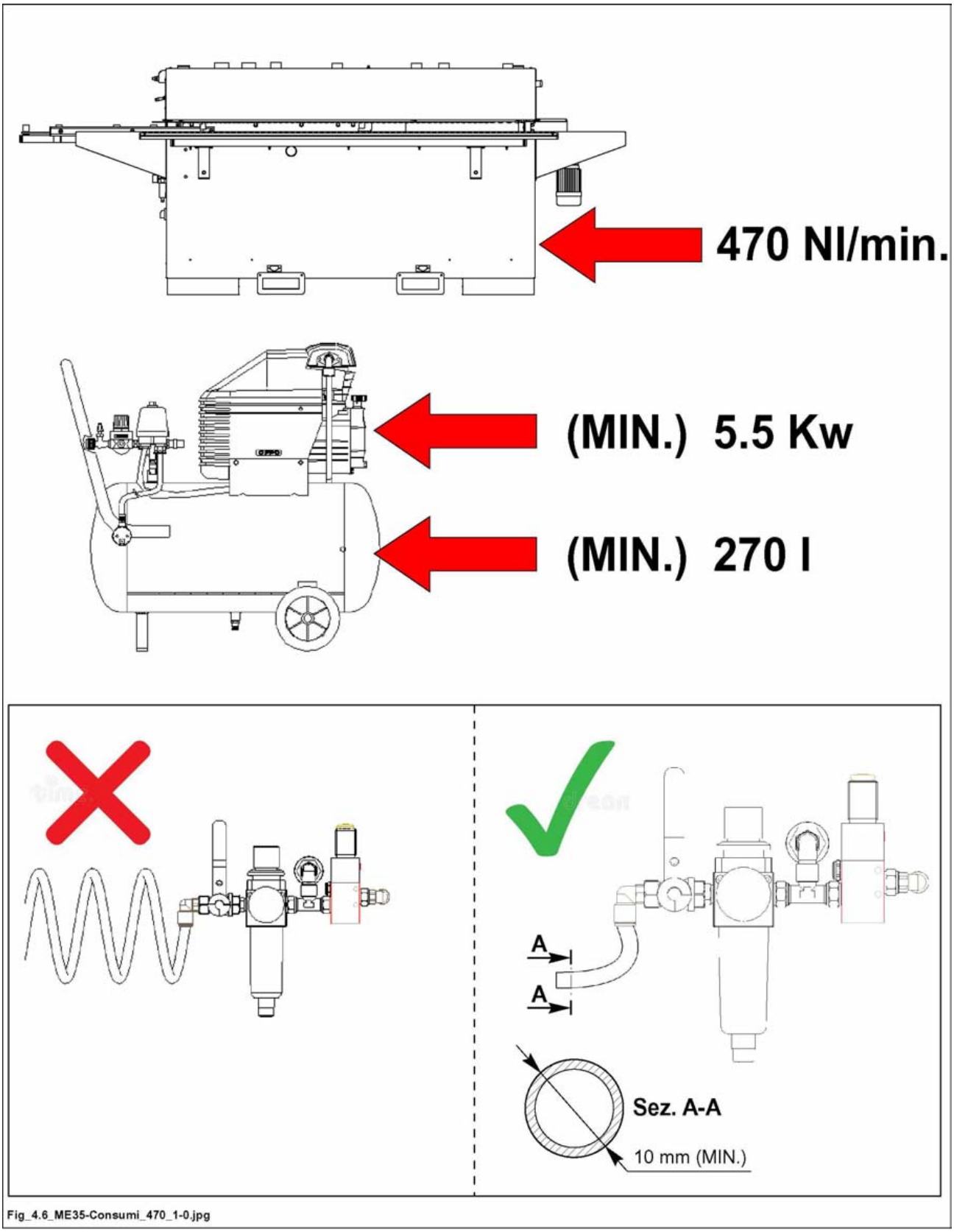


Fig_4.6_ME35-Consumi_470_1-0.jpg

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5.1 CONTROLS BOARD

(ad21_5-1_0.0)

The following sectors are arranged on the machine control panel:
A - Basic Module functions sector
B - electronic control sector (Touch screen)

In this chapter (Par. 5.1.1) the sector A functions are dealt with (these are the basic module controls).

The functions related to sector "B" are treated in a specific manual, supplied with the control.

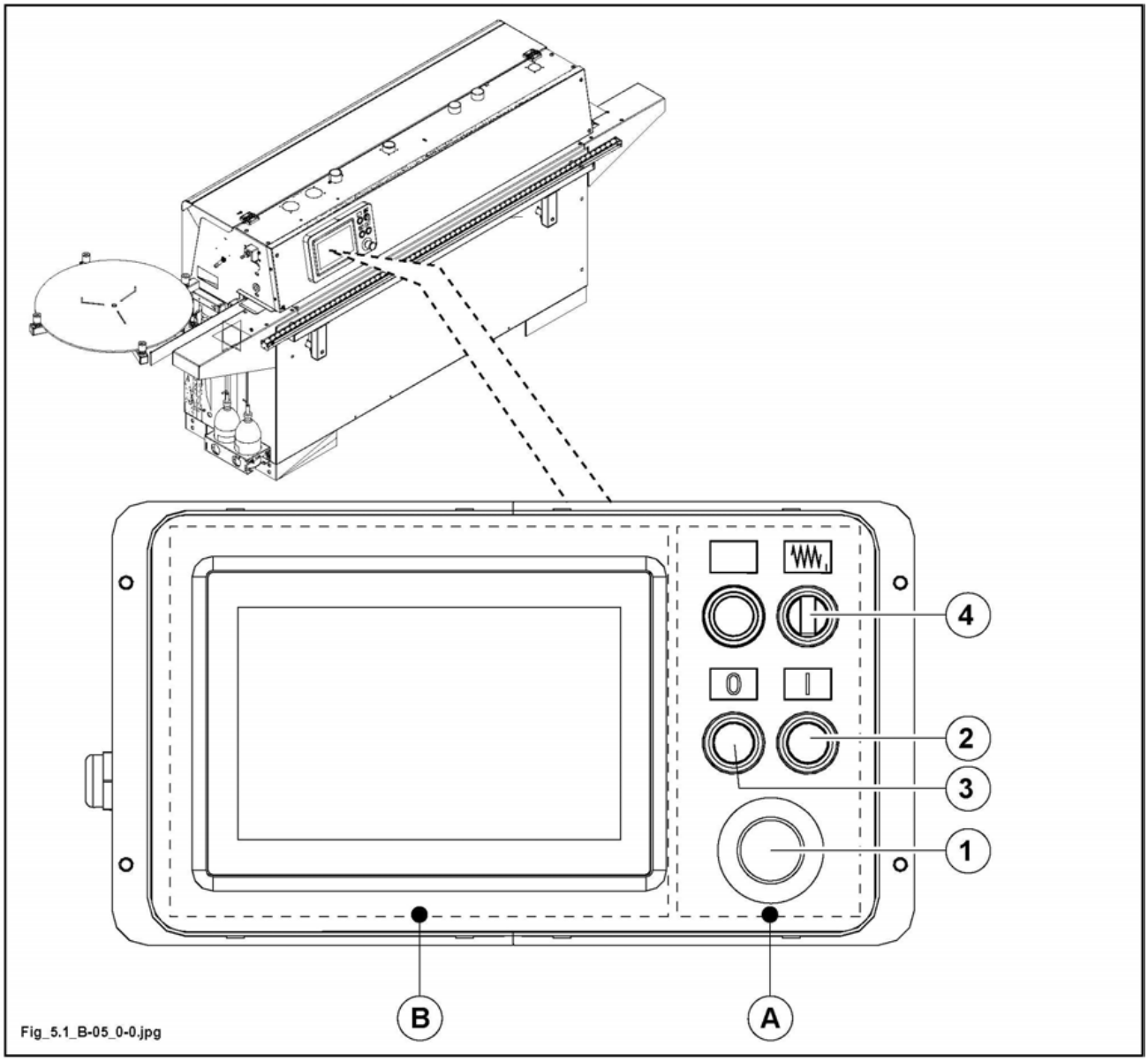
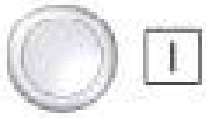


Fig_5.1_B-05_0-0.jpg

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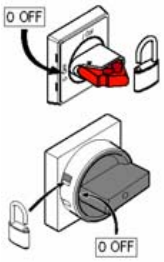
5.1.1 BASIC CONTROL FUNCTIONS

(me35_cn_5-1-1_0.0)

Ref.	Image	Description / Function	Use and/or indication
1		Emergency pushbutton Immediately cuts off the power supply in emergency situtations Mechanical retention pushbutton. To reset rotate the pushbutton clockwise	Pressed: machine in emergency condition. Reset by turning the button to the arrow direction.
2		White luminous RESET pushbutton. When on it indicates that the machine is active and ready for machining. When off it indicates that the machine is in emergency condition. After having reset the emergencies used to reactivate the machine (when pressed it must switch on).	Press to reactivate the machine Light on = power on : **IN CASE OF PILOT LAMP TROUBLE REPLACE IT IMMEDIATELY!**
3		Stop pushbutton When pressed the machine is not ready for machining	Press to disable the machine reset
4		Feed track command selector	Pos. **I** = feed (unstable position)

5.1.2 CONTROLS OUTSIDE THE PANEL

(me35_cn_5-1-2_0.0)

Ref.	Image	Description / Function	Use and/or indication
IG		**Thermomagnetic / Padlockable main electric switch**. Machine supply voltage switching on/off Possible locking to "0" by padlock.	**0** = machine off **I** = machine on

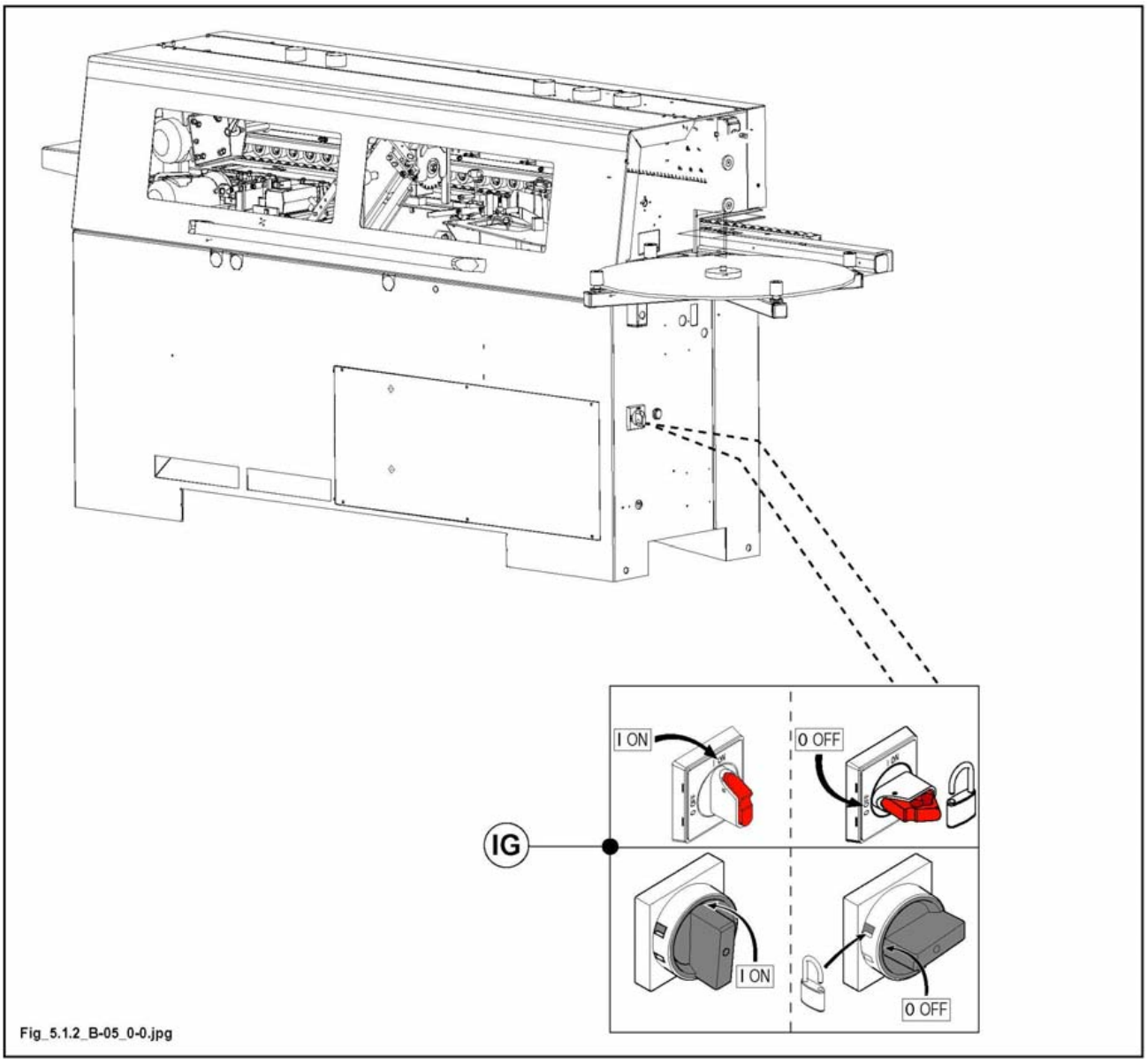


Fig_5.1.2_B-05_0-0.jpg

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(pagina_bianc_00)

5.2 EMERGENCY BUTTONS

(ad21_5-2_0.0)

Buttons arranged on the machine:
- one button on the control board (E1);
- one button at the workpiece exit side (E2).

DANGER-WARNING:
Periodically press the emergency buttons to check whether they are efficient;

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.**

5.3 ACCESS TO THE ELECTRIC HOUSING

(me25_5-3_0.0)

DANGER-WARNING:
only a skilled electrician may reach the electric housing.

Control cubicle
Switch off the mains voltage then indicate this with a sign.
Turning the main switch (A) to 0 (OFF) lock it then indicate this with a sign.
Remove the screws (V) of the control board.

Control board
Switch off the mains voltage then indicate this with a sign.
Turning the main switch (A) to 0 (OFF) lock it then indicate this with a sign.

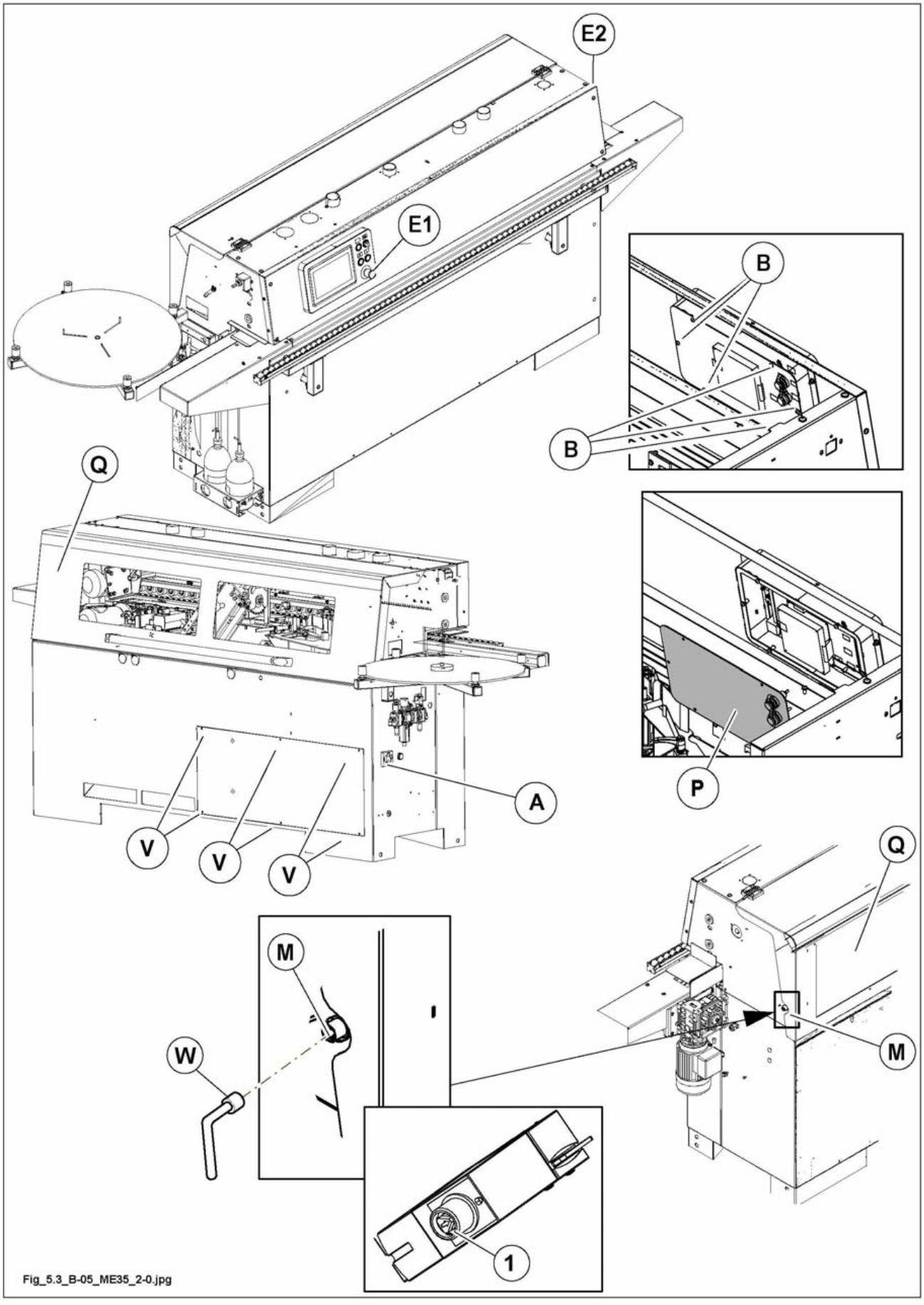
NOTE-INFORMATION:
When the power supply is cut off, the tilting protection can only be opened by using the microswitch manually (M); using the appropriate key (W) rotate the screw clockwise (1) until it is released.
The machine is in safe conditions and the protection can be opened.

Unscrew the screws (B) to open the control board (P).

DANGER-WARNING:
before restarting the machine, always close the panel (P) of the control panel.

DANGER-WARNING:
before resuming machining, rotate the screw (1) anti-clockwise and close the guard (Q).

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E2
E1
B
B
Q
P
A
V
V
V
Q
M
W
M
1
Fig_5.3_B-05_ME35_2-0.jpg

5.4 GENERAL CONTROLS BEFORE MACHINE STARTING

(ad21_5_4_0.0)

Make sure that:
- The tools are clamped.
- Cowling (C) is closed.
- The machine is connected to the suction system.
- The machine is connected to the pneumatic system; turn knob (D) clockwise
- The emergency buttons (E) are in right position (eventually release them).
- Main switch (A) is turned to I (ON).

NOTE-INFORMATION:
with the switch(A) in position ON check that the inside of the cabin is illuminated, if there is the internal machine lighting (OPT)***.***

DANGER-WARNING:

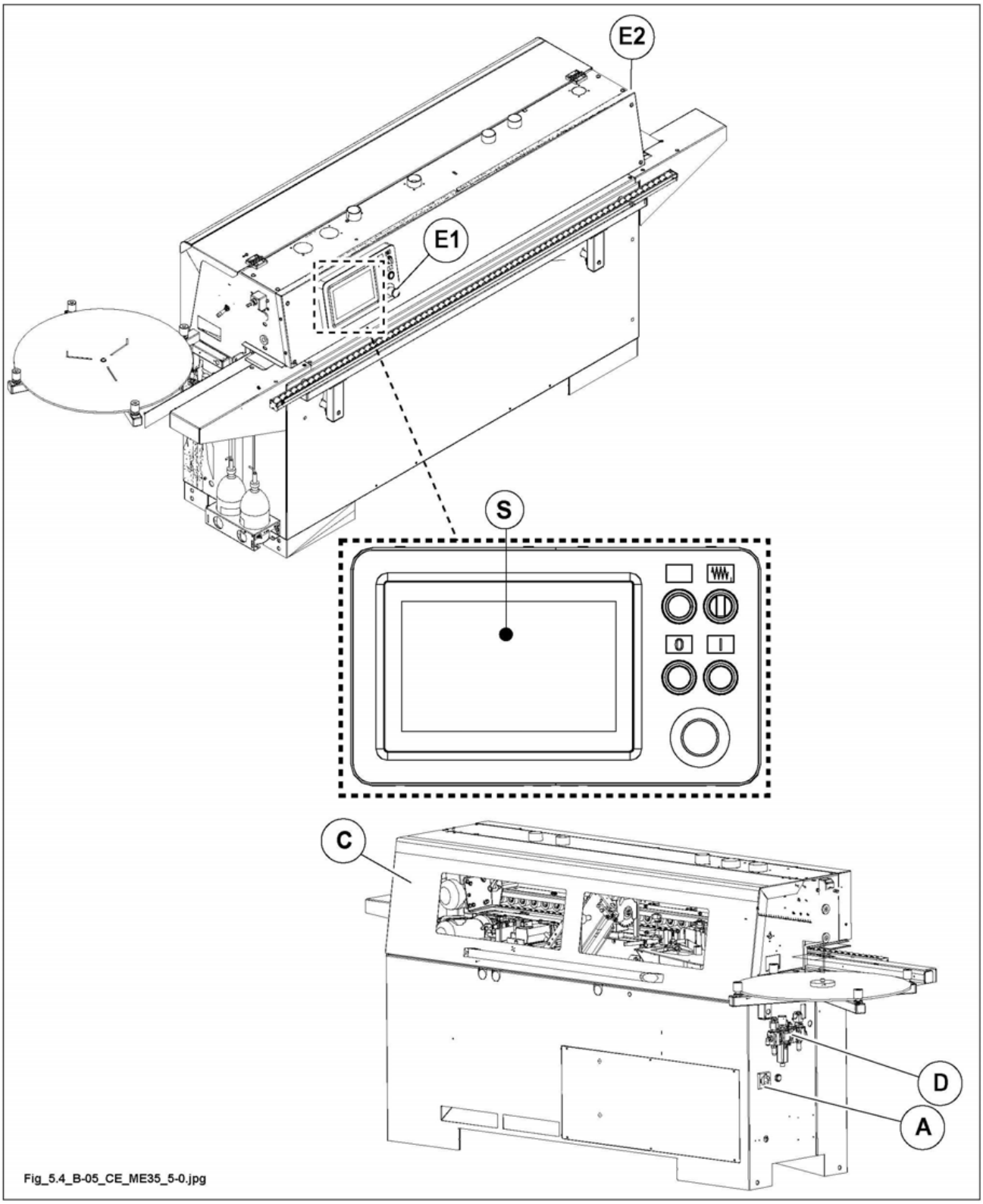
any anomalies found during the control of these devices, must be reported promptly to the manager, who will put the machine out of service and call the electrical, mechanical maintenance personnel or the SCM ***Support Service.***

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

NOTE-INFORMATION:
at the first start-up, on some machine compositions, the cutting unit may perform an empty cycle sequence. These operations are used to overcome any mechanical play due to machine downtime.

NOTE-INFORMATION:
the appearance of the alarm code "GEN003 - Hood open" (on the display S of the control panel) indicates the obligation to verify the correct operation of the safety microswitch of the hood (C). See Ch. 05 "Diagnostics" of the manual (attachment) of the ELECTRONIC CONTROL for a detailed report on the alarm reported (Type, Description, Start (date and time), Stop (date and time)).

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E2
E1
S
0
I
C
D
A
Fig_5.4_B-05_CE_ME35_5-0.jpg

5.5 MACHINE START - STOP

(ad21_5_5_0.0)

All the controls refer to the control panel described in paragraph 5.1.

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

Before starting the machine, make sure that there are no panels inserted in it.

Machine Start procedure

- Press the push-button (1) to rearm the machine and ensure that the lamp is on.

NOTE-INFORMATION:
refer to the manual (attached) of the ELECTRONIC CONTROL for the configuration of the machine and the materials to be used (selection of work groups, edges and glue) depending on the desired machining.

- Rotate the feed track start selector (2).

Load the panels

Machine in stand by

NOTE-INFORMATION:
refer to the manual (attached) of the ELECTRONIC CONTROL for the management of the machine and the materials used (edges and glue) depending on the desired machining.

NOTE-INFORMATION:
at the first switch on, after resetting the machine with the push-button (1), wait approx. 15 minutes for the glue to reach the operating temperature.

Machine Stop procedure

- Make sure that no panels are being machined.

NOTE-INFORMATION:
please refer to the manual (attached) of the ELECTRONIC CONTROL for the management of the machine. In particular in field "D" of Par. 2.1.2 "Production Panel".

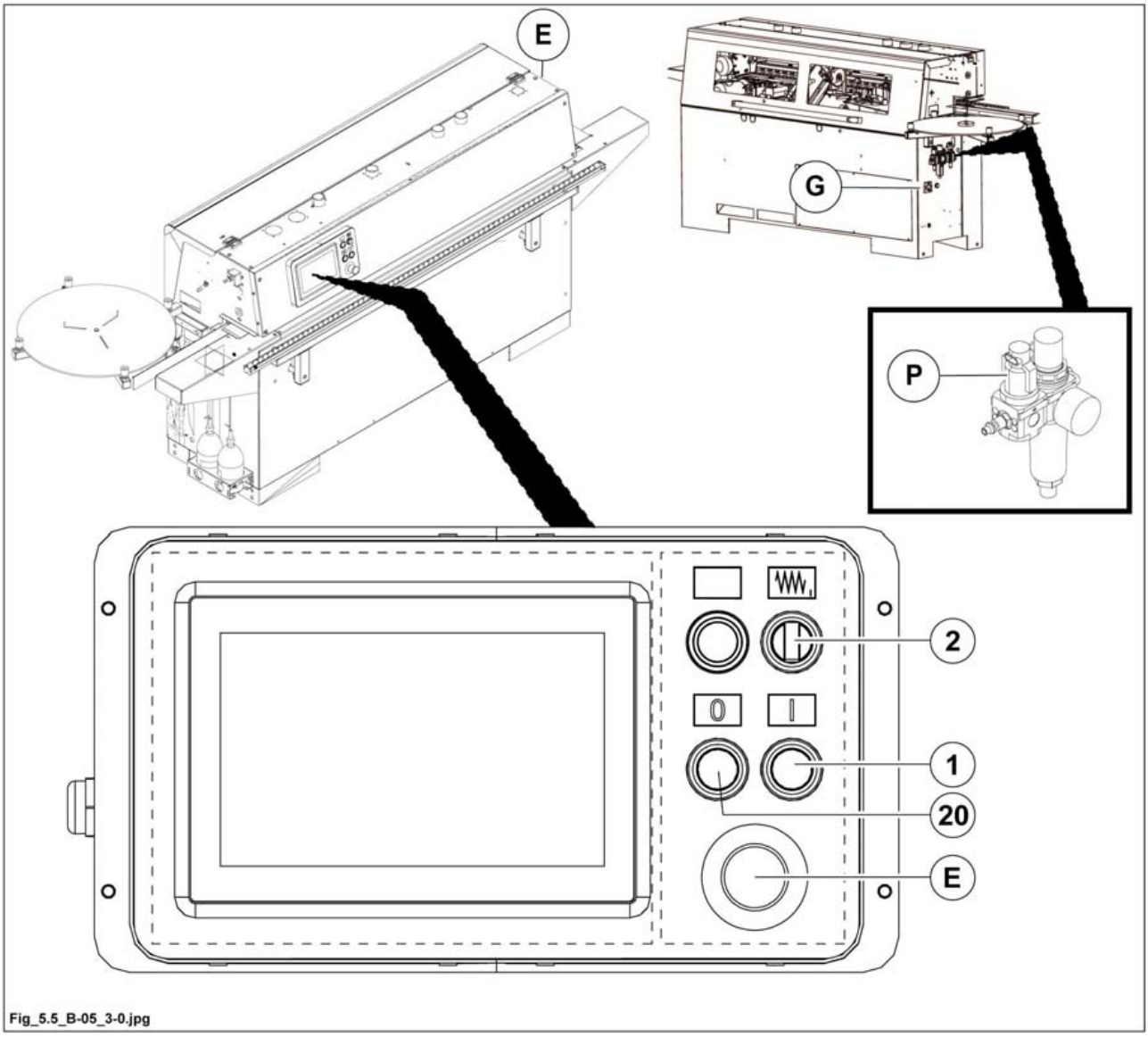
DANGER-WARNING:
do not use this stop way in case of dangerous conditions.
Every time there is a dangerous condition use emergency button (E)

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End of machining procedure

- Press the pushbutton (20) to remove the machine rearming.
- Rotate the main switch (G) to position 0.
- Cut off the pneumatic circuit by turning the knob (P).

DANGER-WARNING:
in case of failure on the energy source, the stopping time of the tools can exceed 10 sec, consequently, BE CAREFUL to the release of the cowling, the TOOLS MAY BE WORKING.



5.5.1 SETTING THE GLUE AND STAND BY TEMPERATURE

(me25_5-5-1_0.0)

The stand-by and work temperatures are set but they can be modified depending on requirements.

NOTE-INFORMATION:
see chap. 3 "Tooling page" of the manual (attached) of the ELECTRONIC CONTROL.

CAUTION:
every operation must be carried out by the machine operator or by qualified technicians only.

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5.5.2 OVERFLOW SETTING - OFFSET

(me35_5-5-2_0.0)

NOTE-INFORMATION:
these parameters have been set during the testing phase, however they may need to be modified. Make changes to a few units so as not to cause problems with the operation of the machine.

NOTE-INFORMATION:
every time that the machine is switched off, move the main switch to the "0"/"OFF" position. Any changes made to the aforementioned parameters are reset automatically.

1) CONTROL EXTRABORD (OFFSET COIL) setting

Pressing the "4" icon ("Gluing unit") displays the screen (L) thanks to which we can set the edge excess.
- Change the value in field (a) to increase or decrease the front edge excess (side "1").
- Change the value in field (p) to increase or decrease the rear edge excess (side "2").

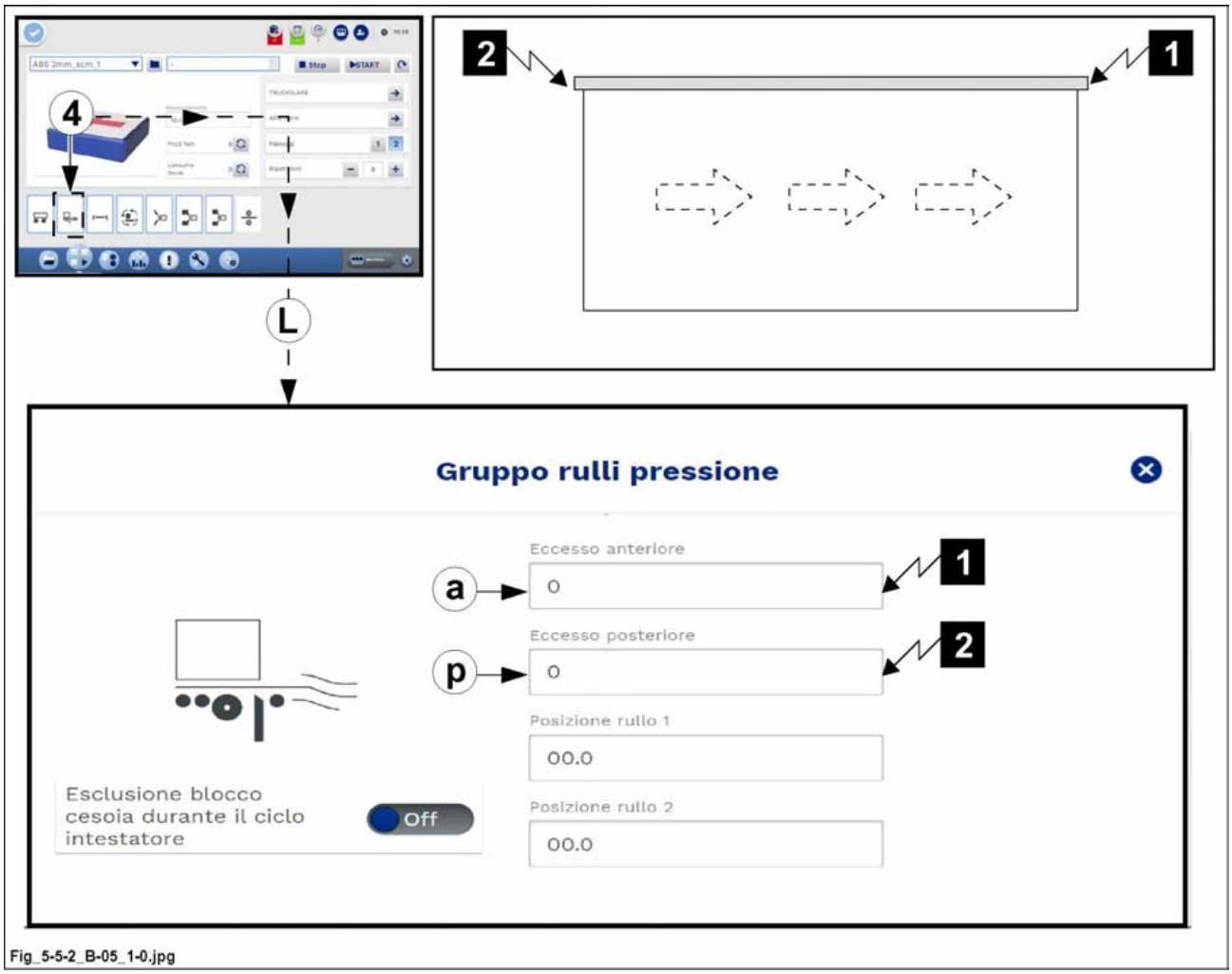


Fig_5-5-2_B-05_1-0.jpg

2) Setting EXTRABORDO Ledge

Pressing the "4" icon ("Gluing unit") displays the screen (L) thanks to which we can set the edge excess.

- Change the value in field (a) to increase or decrease the front edge excess (side "1").

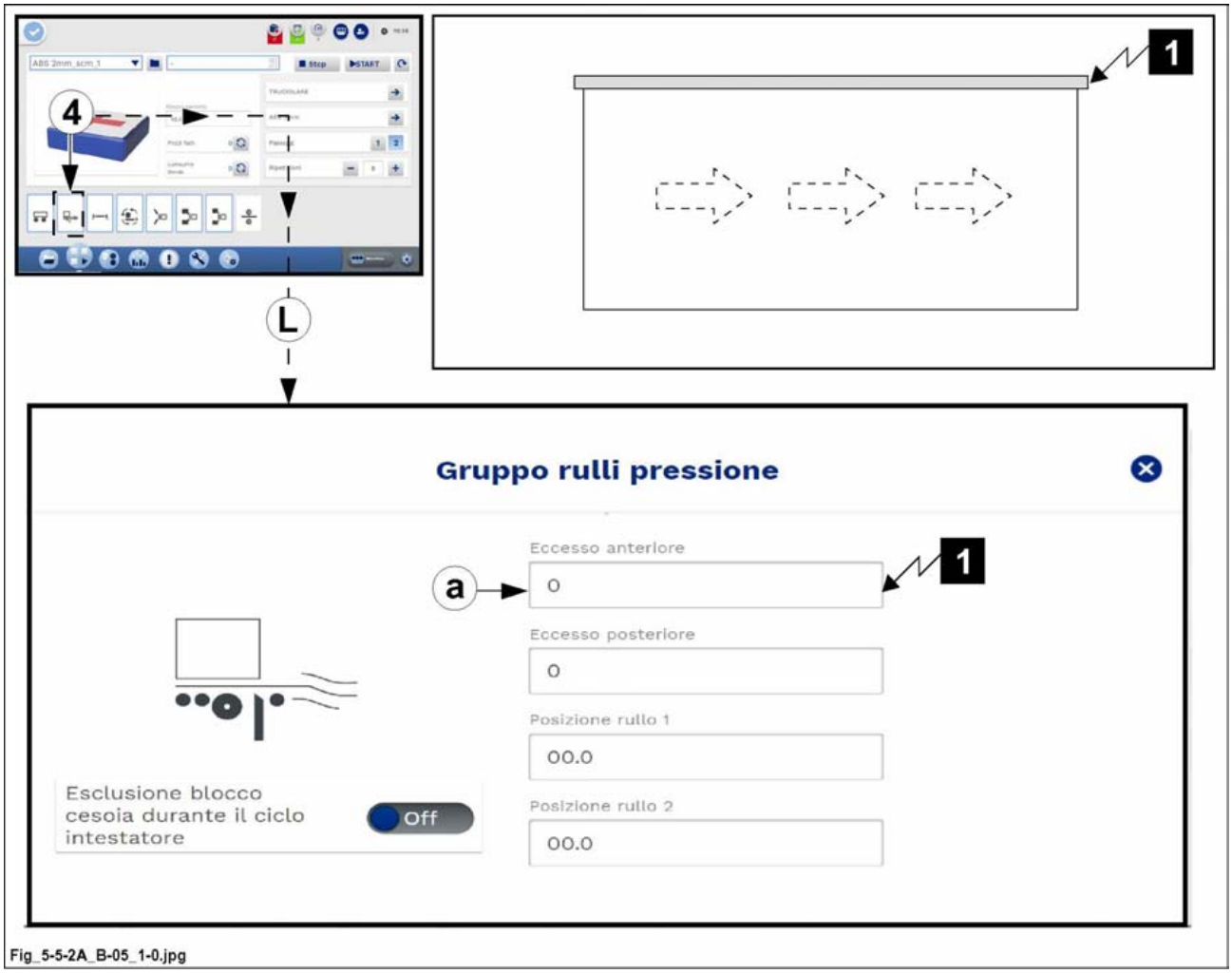


Fig_5-5-2A_B-05_1-0.jpg

NOTE-INFORMATION:
always carry out a border test to verify the machine is adjusted correctly.

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6.0 INTRODUCTION

(me35_6-0_0.0)

NOTE-INFORMATION:
the machine is fully tested before it leaves our production facility.

Pre-delivery testing includes:
- test and adjustment of unit alignment.
- Functional testing with test panels.
- Functional testing of safety devices.

6.0.1 CHANGING LANGUAGE

(me35_6-0-1_0.0)

Only after having LOGGED IN the user can proceed to change the language.

NOTE-INFORMATION:
for the USER LOGIN and the language change, please refer to Cap. 01 "Description of the interface" of the ELECTRONIC CONTROL manual (annex).

6.0.2 COUNTERS

(me35_6-0-2_0.0)

NOTE-INFORMATION:
to access the "Machine information", see Par. 1.2.1.2 of Chapter 01 "Description of the interface" of the ELECTRONIC CONTROL manual (annex).

Press the "C" button to access the total counters of your machine ("L" screen).

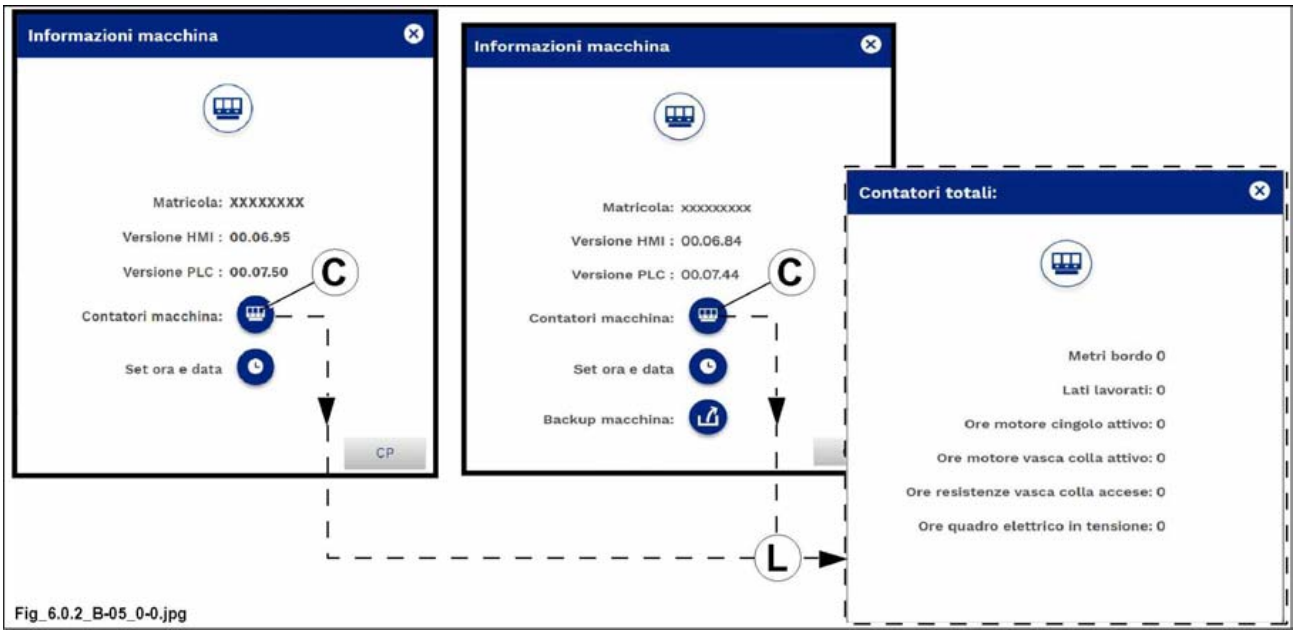


Fig_6.0.2_B-05_0-0.jpg

6.1 ADJUSTING THE PRESSURE OF THE PNEUMATIC SYSTEM

(me25_6-1_0.0)

The operating pressure must be ~6.5 bar; this is already set by our technicians. If necessary, adjust it as indicated in Sec. 4.6.

NOTE-INFORMATION:
adjust the pressure in increments (from 4 bar to 6.5 bar).

To drain off condensation, press the cap E with the pressurised regulator filter upwards.

The machine has a device which prevents it from starting if the pressure supplied is less than ~ 4 bar.

FUNCTION ADJUSTMENT

A1 - Edge drive roller for wooden slats loader (OPT) ~ 6 bar.
A - Edge pressure cylinder ~ 3,5 ÷ 4,0 bar.
B - End cutter horizontal outward stroke ~ 3,5 ÷ 4,0 bar.
C - End cutter horizontal return stroke ~ 1,5 ÷ 2,0 bar.
D - Header group descent - rounder (ME 35TR) ~ 1 bar.
F - Clamping group heading - rounder (ME 35TR) ~ 3.5 bar.

NOTE-INFORMATION:
the operating pressure of the individual functions is already set by our technicians. Contact the Support Service SCM **for any faults or adjustments.**

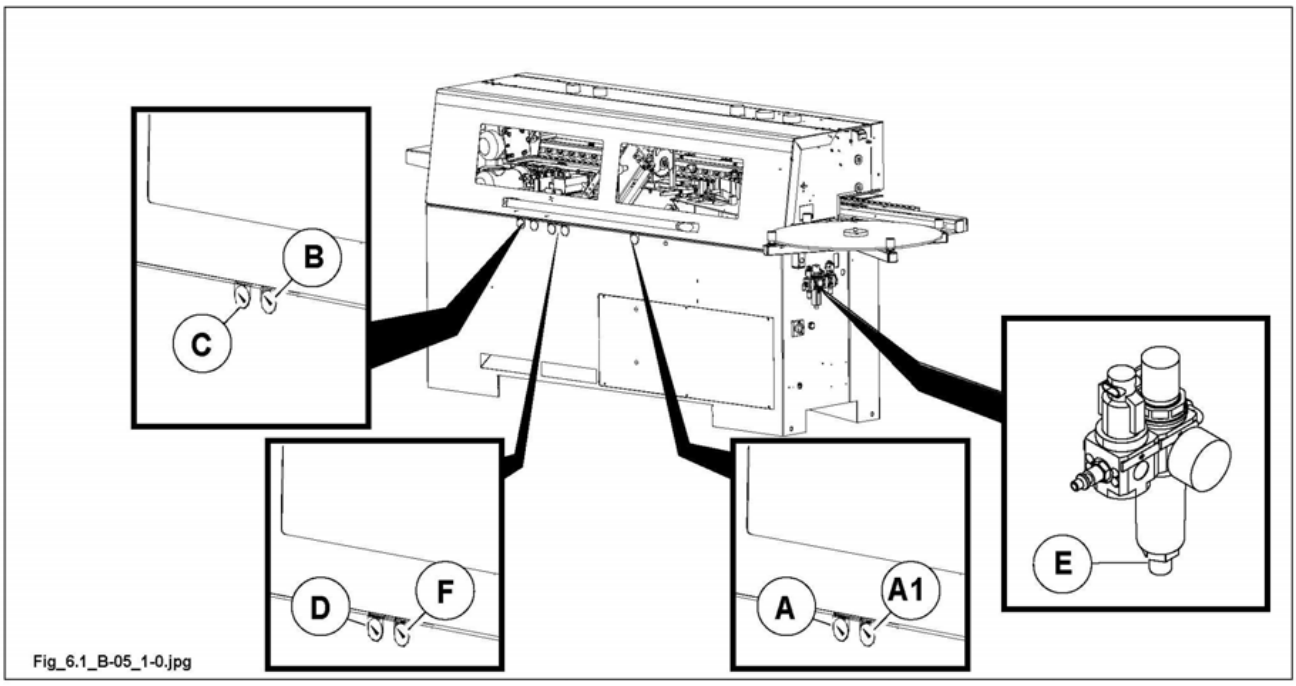


Fig_6.1_B-05_1-0.jpg

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(white)

6.2 INFEED GUIDE

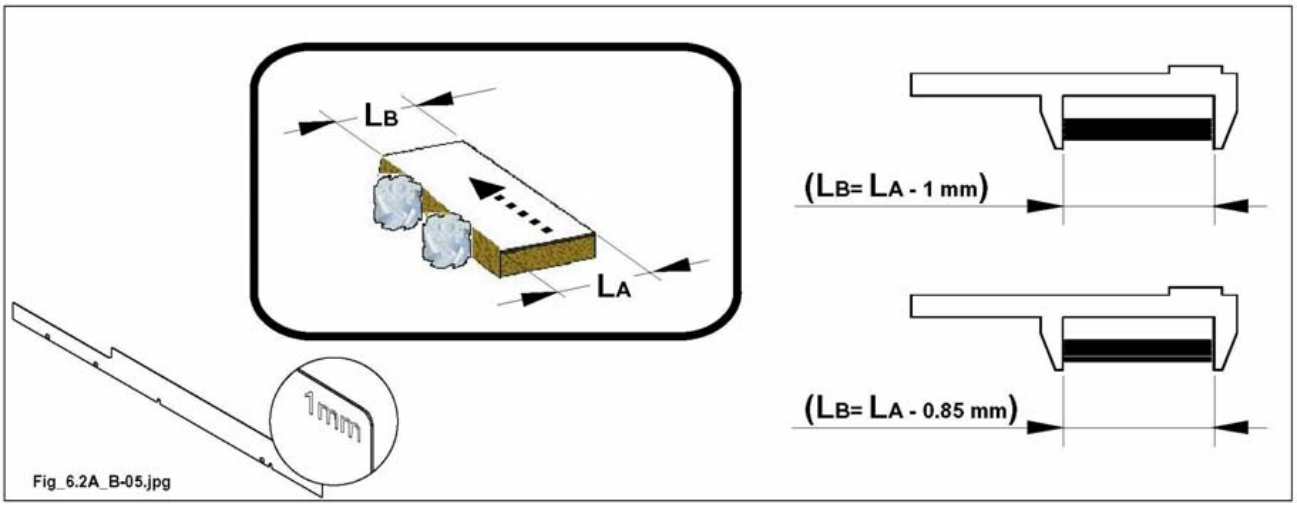
(me35_5-2_0.0)

The infeed guide is fixed and does not adjusting.

RECTIFIER OPT

If there is the rectifier unit, use the sheets supplied to adjust the cutters stock removal.
If no sheet is fitted there will be the maximum stock removal (2 mm).
Based on the machining requested fit the desired sheet supplied.

NOTE-INFORMATION:
the value shown on the sheet is the thickness removed in relation to the maximum possible of 2 mm (e.g.: sheet = 1.0 mm, value removed = 1.0 mm).
The working tolerance is: 0 / - 0.15 mm.



DANGER-WARNING:
before you start any cleaning, maintenance, adjustment or part substitution, switch off and lock out the main ON-OFF switch. Attach a warning notice to the switch.

Insert the sheet (B) in its seating and block it with the magnets.

DANGER-WARNING:
position the sheets correctly before every use.
Position just one sheet per machining operation.
Use only sheets supplied with the machine.
Always return the sheets in their storage position (A) when not in use.
Make sure that there are no shavings or dirt between the sheets and the magnets.

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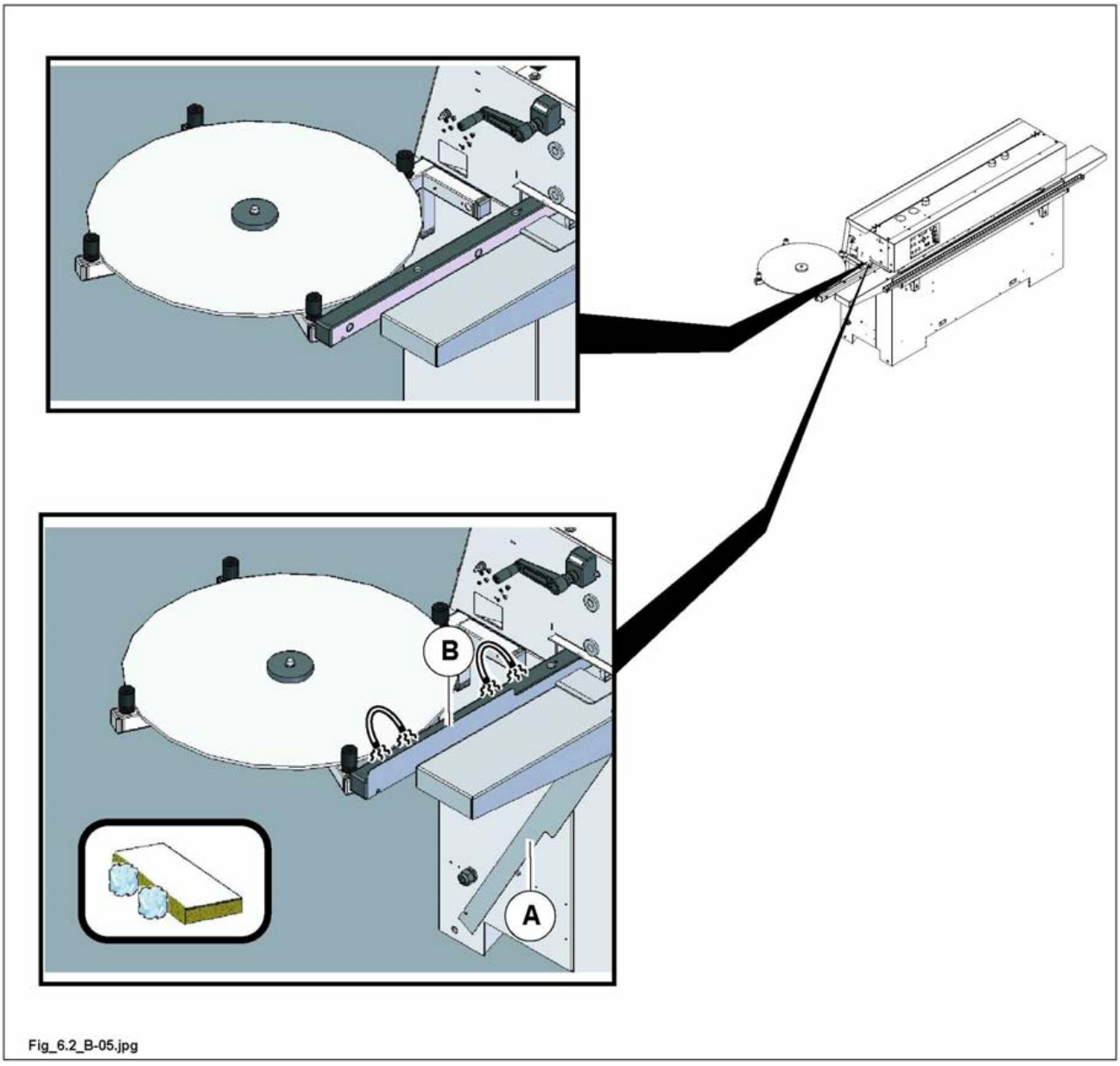


Fig_6.2_B-05.jpg

6.3 FITTING THE EDGING STRIP

(me25_6-3_0.0)

Check that the edge is the right size for the thickness of the panel.

DANGER-WARNING:
before you start any cleaning, maintenance, adjustment or part substitution, switch off and lock out the main ON-OFF switch. Attach a warning notice to the switch.

NOTE-INFORMATION:
The edge, relative to the height of the panel, must not protrude by more than 2 mm per side.

COILED EDGING

- Position the reel H on the reel-holder respecting the direction indicated.
- Lift the two regulators A and B to maximum and block them;
- Insert the edging N between the edging guide D and the spring C, making sure it is fed through close to the roller E;
- Regulate the two regulators A and B in height leaving about 0.5 mm of play in order for the edge to run.
- Retract the edge N until it is aligned with the knife O of the edge cutting shears.

NOTE-INFORMATION:
For correct adjustment it is very important that the edging strip is aligned with the shears.
Regulation is excellent when the edge remains in the guide and runs freely.

The edge is ready for working in this position.

STRIP OF WOOD

When machining with wooden slats the slats must be positioned the same way as the coiled edging but the spring C must rest against the wooden slat P with as little pressure as possible.

NOTE-INFORMATION:
Slat length must not exceed panel length by more than 25/30 mm.
Example:
Panel length: 300 mm
Slat length: 330 mm
Maximum slat length per side: 15 mm

To increase or decrease the edge excess on the panel (OFFSET EDGE), refer to the instructions given in Par. 5.5.2.

NOTE-INFORMATION:
After gluing the wooden edging strip, clean any wood residues from the edging strip feed roller.

MAX THICKNESS SLAT: 3 mm

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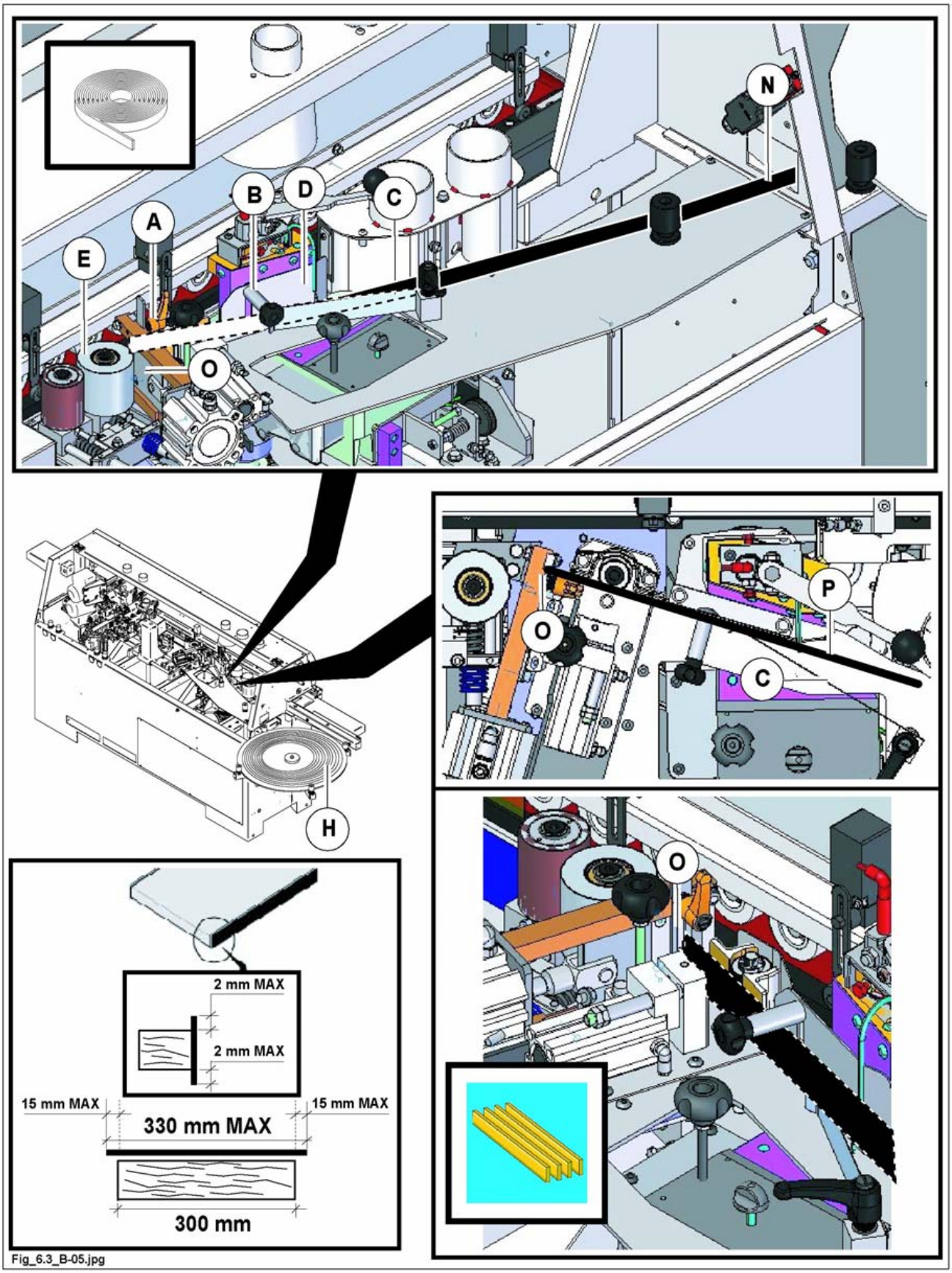


Fig_6.3_B-05.jpg

6.3.1 WOODEN SLAT LOADER

(me25_6-3-1_0.0)

OPT

Check that the edge is the right size for the thickness of the panel.

DANGER-WARNING:
before you start any cleaning, maintenance, adjustment or part substitution, switch off and lock out the main ON-OFF switch. Attach a warning notice to the switch.

NOTE-INFORMATION:
The edge, relative to the height of the panel, must not protrude by more than 2 mm per side.

COILED EDGING

- Position the reel H on the reel-holder respecting the direction indicated.
- Lift the two regulators A and B to maximum and block them.
- Insert the edging N between the edging guide D and the spring C, making sure it is fed through close to the roller E.
- Regulate the two regulators A and B in height leaving about 0.5 mm of play in order for the edge to run.
- Retract the edge N until it is aligned with the knife O of the edge cutting shears.

STRIP OF WOOD

- Lift the two regulators A and B to maximum and block them.
- Insert the slats between the edging guide D and the spring C: the spring C must rest against the wooden slat with as little pressure as possible.
- Regulate the two height adjusters A and B, leaving about 0.5 mm of play for slat through-flow.

NOTE-INFORMATION:
for edging thickness greater than 3 mm, use the ring nut N and move the roller F in the direction of arrow T1, to allow the edging to slide freely.

- Align the slats up to the adjuster R.
- Adjust the stop R as a function of slat thickness and lock the knob L in place.
- Check for proper smoothness of flow and make sure the stop only lets slats be fed one at a time.

NOTE-INFORMATION:
Slat length must not exceed panel length by more than 25/30 mm.
Example:
Panel length: 300 mm
Slat length: 330 mm
Maximum slat length per side: 15 mm

To increase or decrease the edge excess on the panel (OFFSET EDGE), refer to the instructions given in Par. 5.5.2.

NOTE-INFORMATION:
After gluing the wooden edging strip, clean any wood residues from the edging strip feed roller.

MAX THICKNESS SLAT: 5 mm

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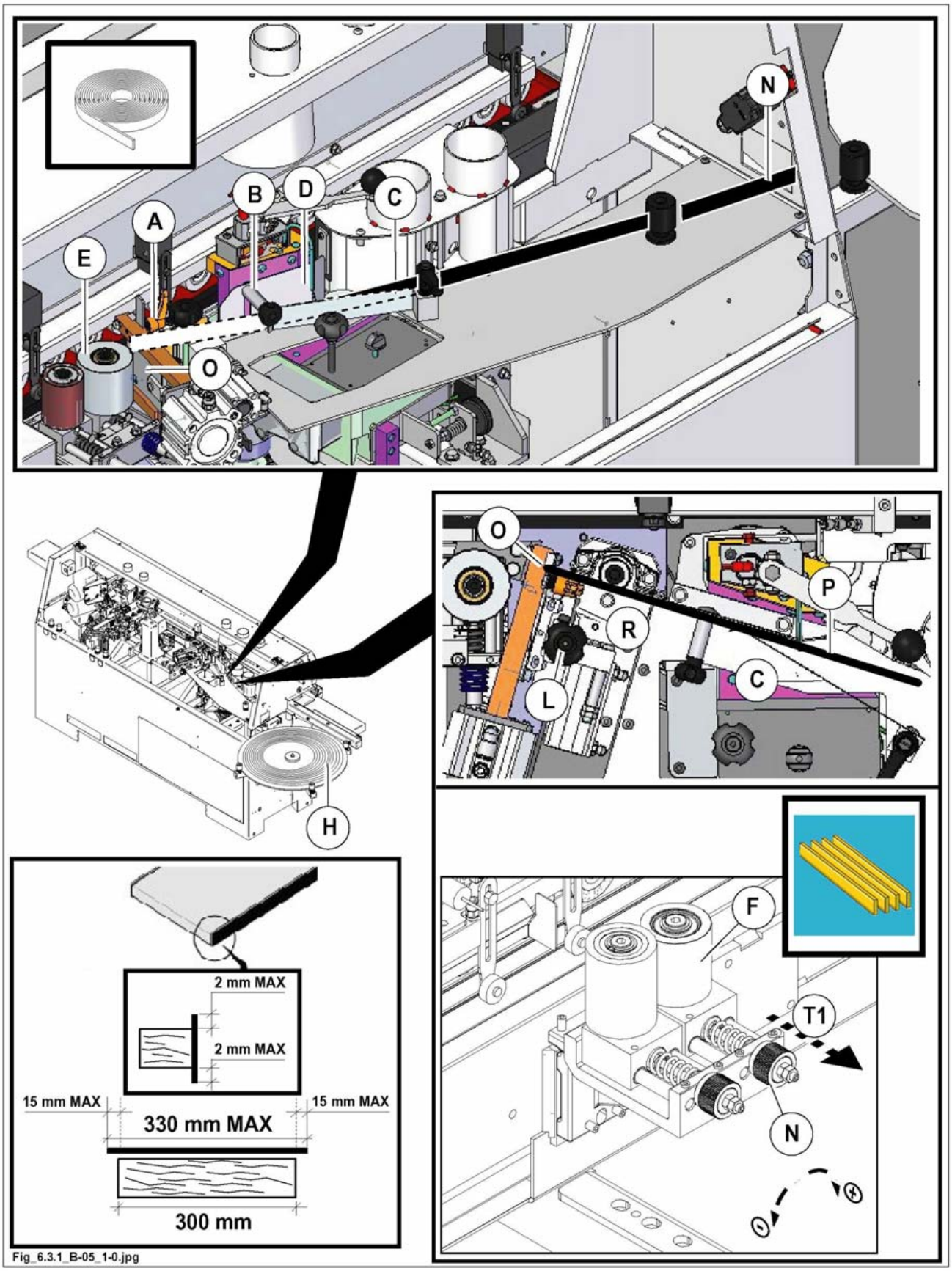


Fig_6.3.1_B-05_1-0.jpg

6.4 ADJUSTING THE FEED UNIT

(me20_6-4_0.0)

Regulate the height of the feeder until the indicator C displays the same measurement of the thickness as the panel to be edged (the black numbers correspond to millimetres, while the red ones correspond to tenths of millimetres).

NOTE-INFORMATION:
By using an appropriate tool, always measure the real thickness S of the panel to be processed.

NOTE-INFORMATION:
Incorrect adjustment of the unit height may result in faulty feed of the panel, compromising correct machine operation and machining.

Adjust the working position by positioning from the top to bottom to eliminate any mechanical play.

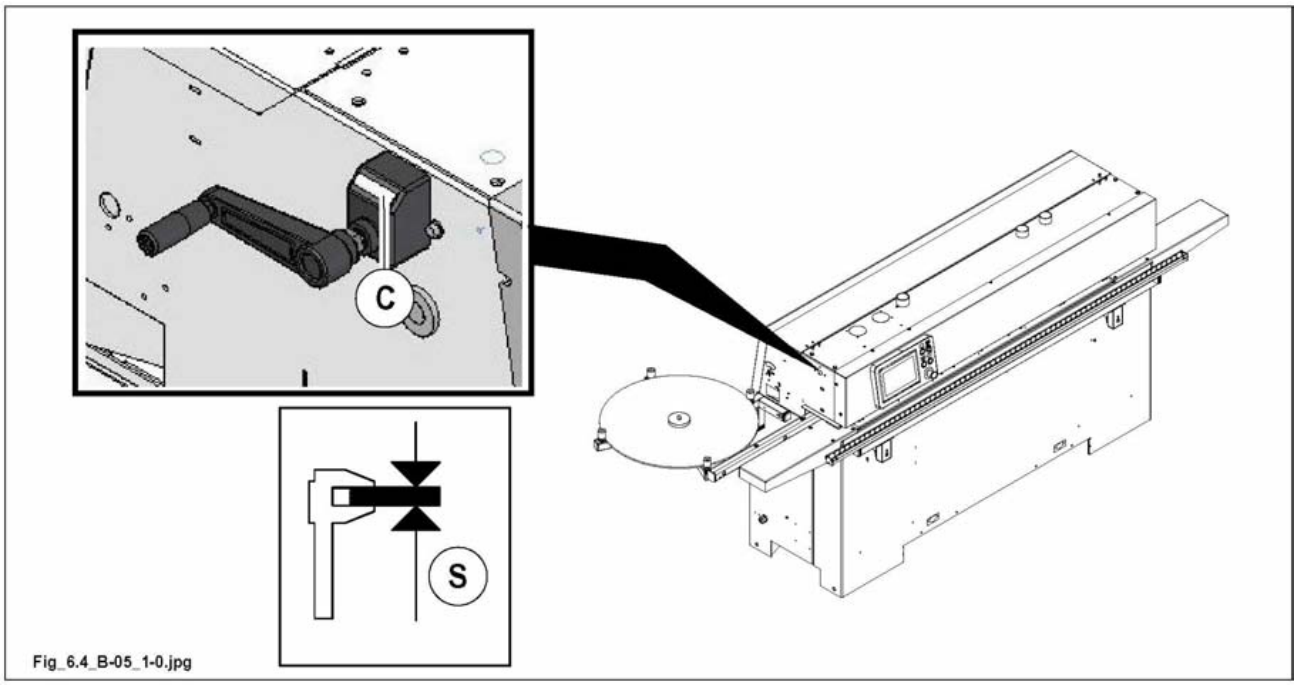


Fig_6.4_B-05_1-0.jpg

DANGER-WARNING:
do not operate said control during the machining of the workpiece.

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6.5 ADJUSTING THE ADJUSTABLE INFEED PRESSER ROLLER UNIT

(me25_6-5_0.0)

To adjust the presser rollers, use the ring nuts A and B as follows:

- unscrew both ring nuts A and B (in the direction of arrow "T1")
- take a piece of the edge "S" used and position it in the free light L between the ring nuts A, B and the roller support R, resting on the support itself
- screw the ring nut A and the ring nut B (in the direction of arrow "T2") until both rest on the edge "S". Tighten them slightly to lock the "S" edge section between the ring nuts and the R roller support.
- Recording of the infeed presser rollers has ended.

NOTE-INFORMATION:
if the thickness of the edge used is changed, it is necessary to proceed with a new adjustment of the presser rollers.
Repeat the sequence of operations described above by replacing the "S" slice with an edge slice having the new thickness.

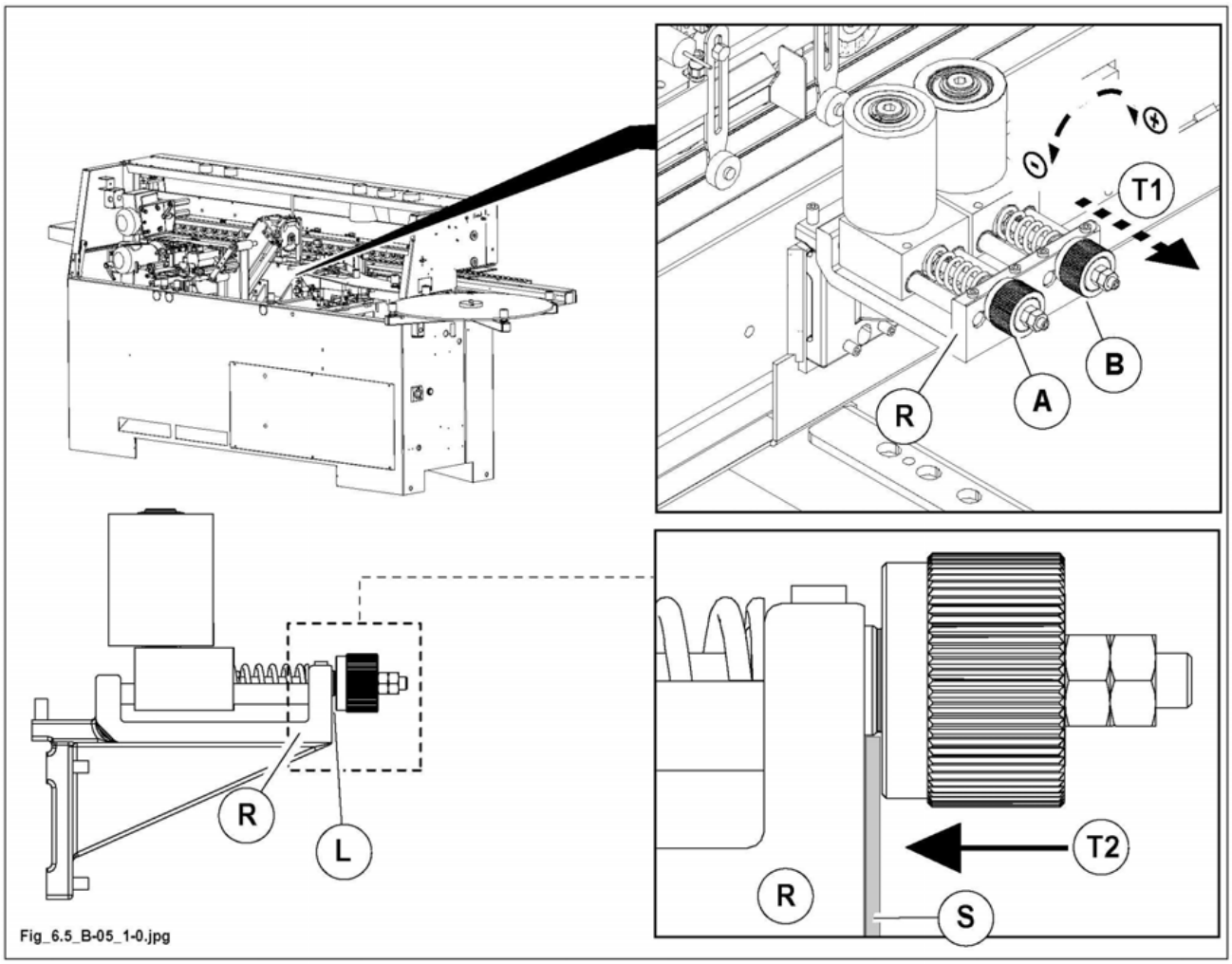


Fig_6.5_B-05_1-0.jpg

6.6 END TRIMMING REGULATION

(me25_6-6_0.0)

The edge trimmer cuts the excess edging from the start and the end of the panel.
The end trimmer does not need to be adjusted as the edging changes.

6.6.1 END CUTTING UNIT ADJUSTMENT

(me25_6-6-1_0.0)

(ME 35 - ME 35T)

NOTE-INFORMATION:
The feeler is adjusted in the factory and requires no additional adjustment; since adjustment is a delicate task it must only be carried out if you are sure the malfunction is due to the feeler (first go through the troubleshooting procedure illustrated in chap. 20).

If there is a FRONT or REAR edge end cutting defect align the blade with the panel feeler as follows:

FRONT FEELER ADJUSTMENT
Loosen the nut E and act on the nut F until blade A is aligned with feeler B.

REAR FEELER ADJUSTMENT
Loosen the nut D and act on the nut C until blade A is aligned with feeler B.

If the cutting depth Z of the end trimmer A needs to be adjusted, proceed as follows:
- loosen the nut H.
- Use the screw V to decrease or increase the blade position.
- Tighten the nut H.

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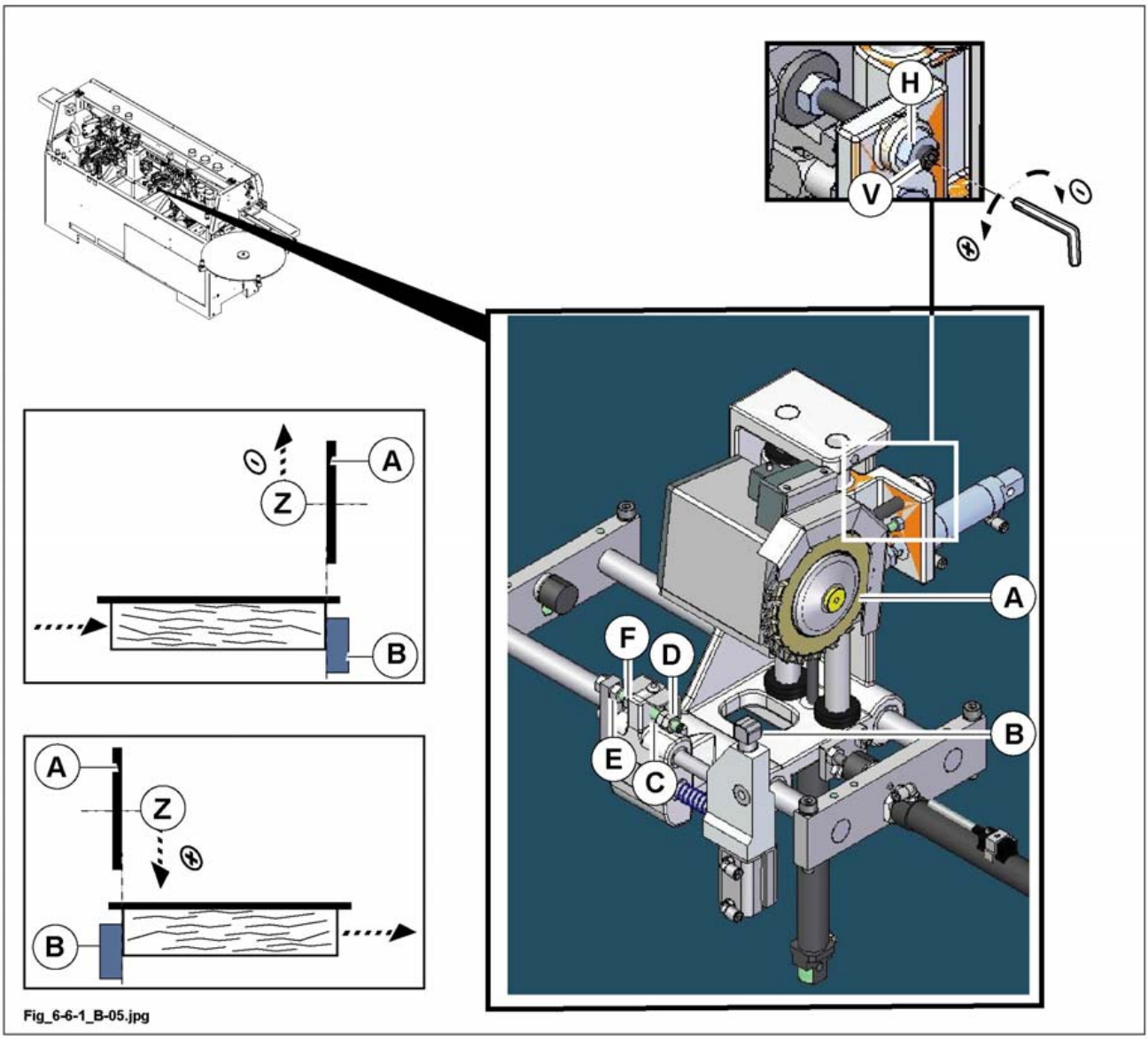


Fig_6-6-1_B-05.jpg

6.6.2 HEADING UNIT WITH ROUNDING FUNCTION

(me35_6-6-2_1.0)

(ME 35T)

OPT

The unit cuts the board in excess (end trimming) on the front and rear side of the panel.

Pressing the "6" icon ("End trimming unit") displays the screen (L) thanks to which we can set the edge end trimming.

Combining the activation (ON) and deactivation (off) of the fields on the screen (L)

- head (t)
- queue (c)
- Head ray (Rt)
- Tail radius (Rc)

we can end the panel first on two parallel sides (step 1) and then on the other two (step 2).

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Example:

Press the pushbutton (A) to enable the Step **1**

If
- (t) = ON
- (c) = ON
- (Rt) = off
- (Rc) = off

we will have a straight end trim, in head (t) and in tail (c), on the two parallel sides (1) and (2).

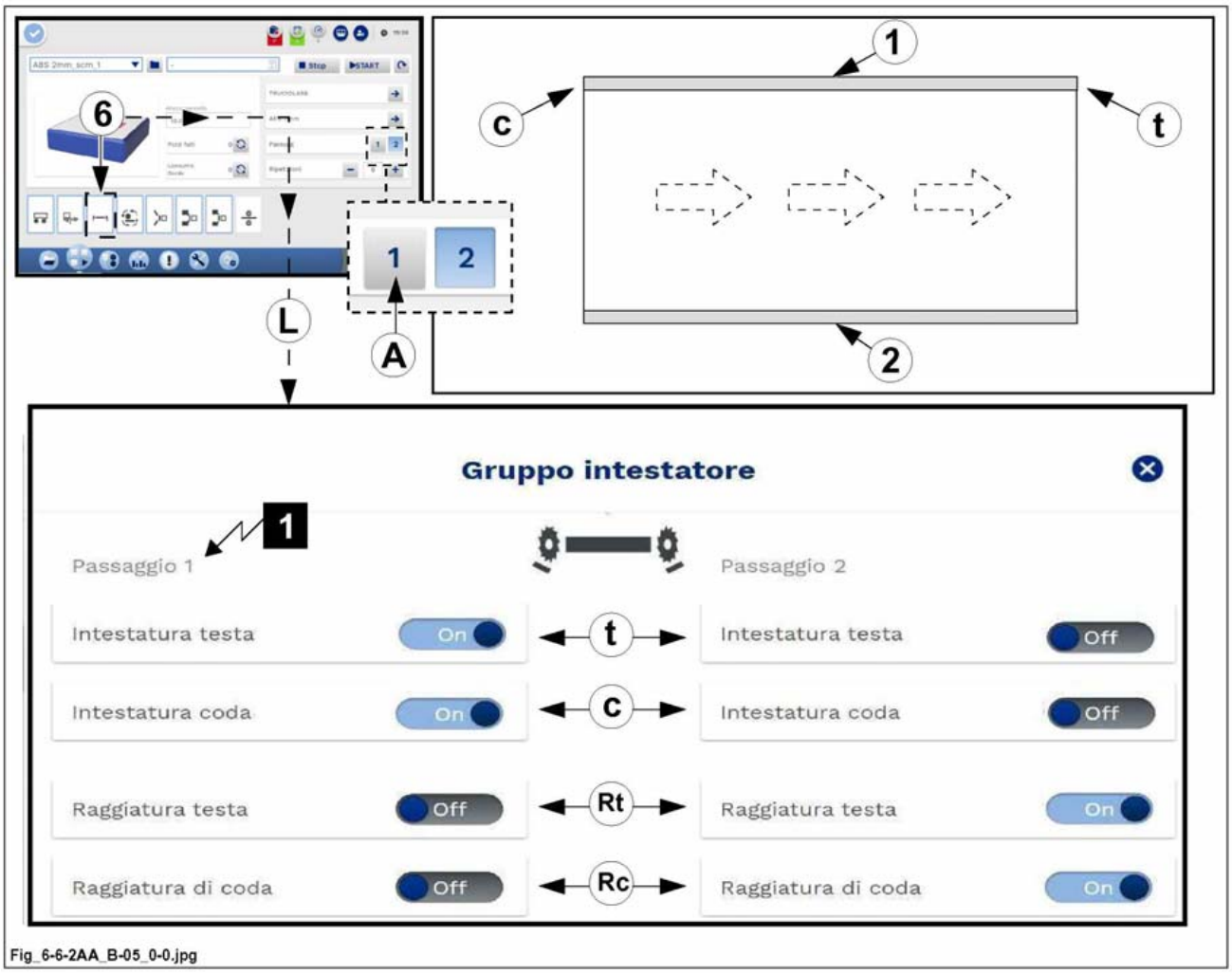


Fig_6-6-2AA_B-05_0-0.jpg

NOTE-INFORMATION:
If you want to edge the four sides, turn the panel by 90° and complete the edging (with radiused header), head and tail, performing the step 2.

Press the button (B) to enable Step **2**

If
- (t) = off
- (c) = off
- (Rt) = ON
- (Rc) = ON

we will have a radiated end, at the head (Rt) and at the tail (Rc), on the other two parallel sides (3) and (4).

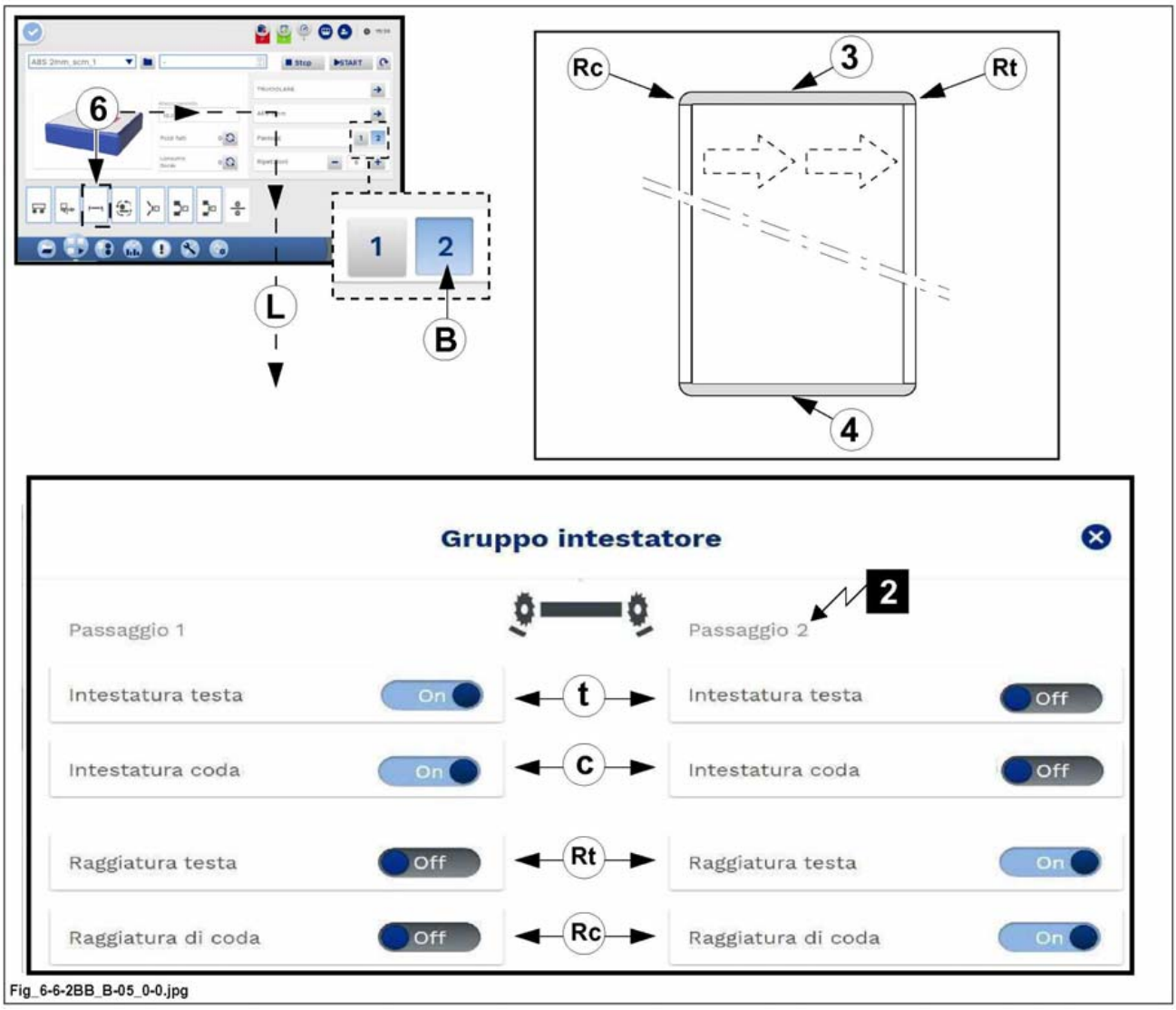


Fig_6-6-2BB_B-05_0-0.jpg

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6.6.2.1 OPERATING SEQUENCE:

(me35_6-6-2-1_0.0)

NOTE-INFORMATION:
These commands can be activated only when there are no panels being machined.

If the fields

- (t) = off
- (c) = off

the end cutting unit is disabled. In this way the panel passes without being cut in both "step 1" and "step 2".

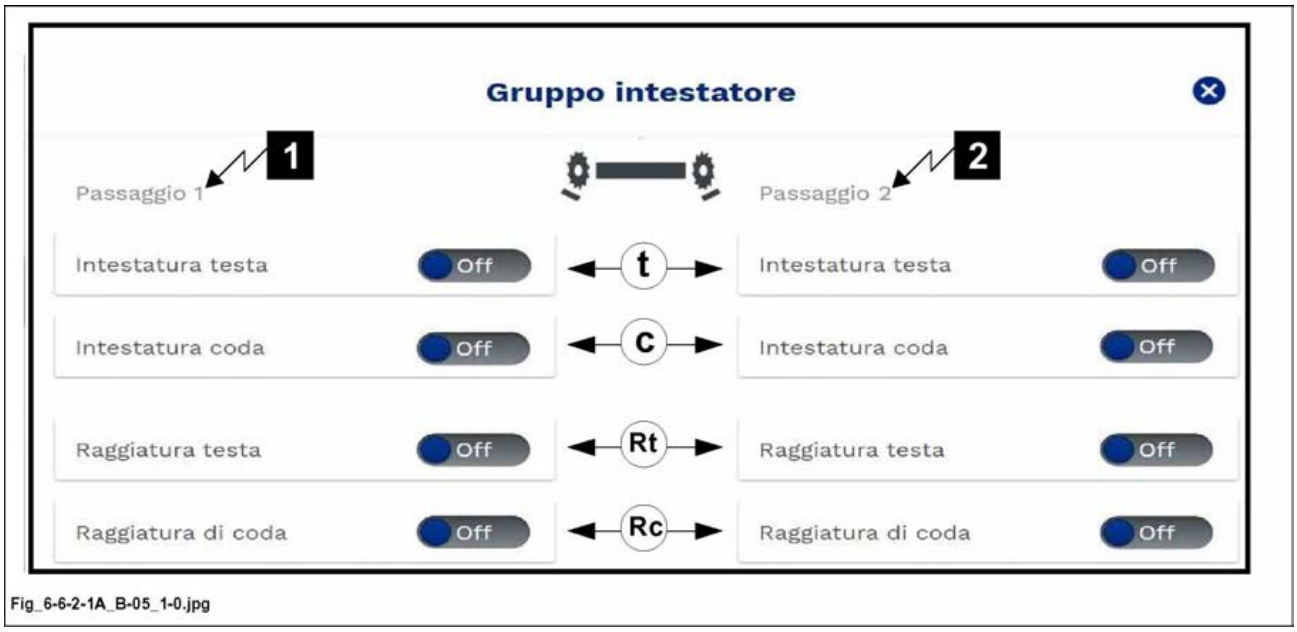


Fig_6-6-2-1A_B-05_1-0.jpg

If the fields

- (t) = ON
- (c) = ON
- (Rt) = off
- (Rc) = off

Saw blades for straight cutting/ the end cutting unit is on. The unit is ready to cut the excess edge, front and back both in the "passage 1" and in the "passage 2".

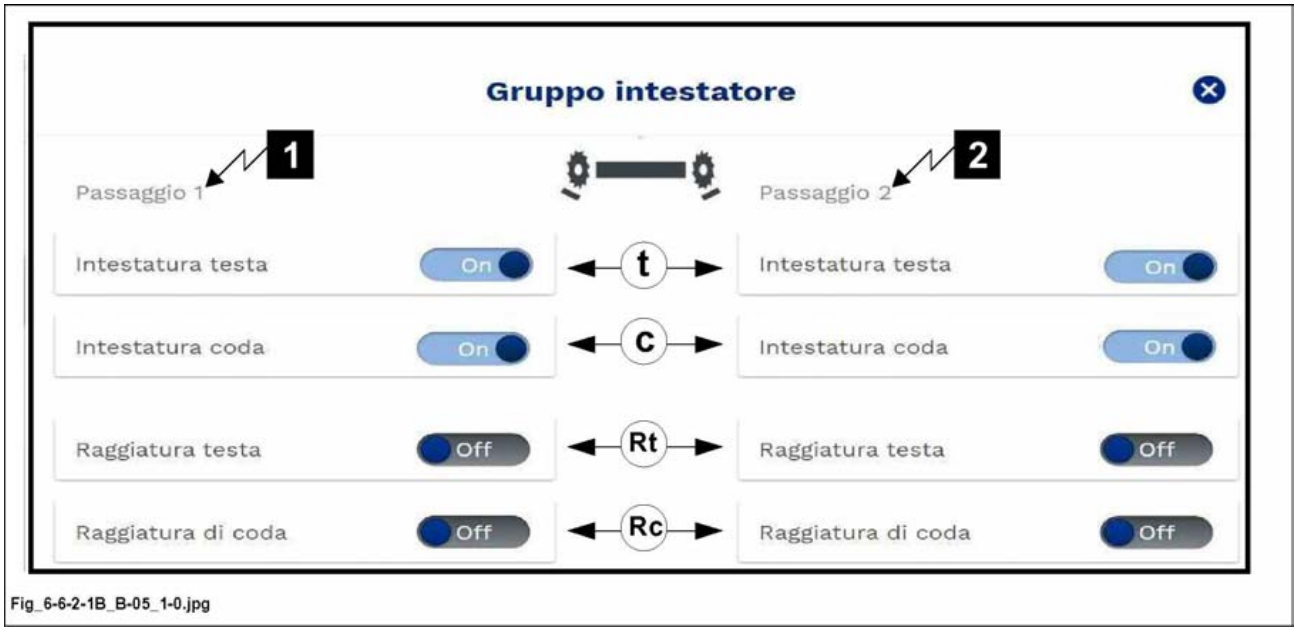


Fig_6-6-2-1B_B-05_1-0.jpg

NOTE-INFORMATION:
in case wooden beads are cut, this cut may only be straight.

NOTE-INFORMATION:
to have the best working quality, when you have to execute a radius end trimming, always use the rectifier.

NOTE-INFORMATION:
On the control panel, select the use of the end trimmer
Once the end trimmer is activated, the unit is ready to cut the excess edge.

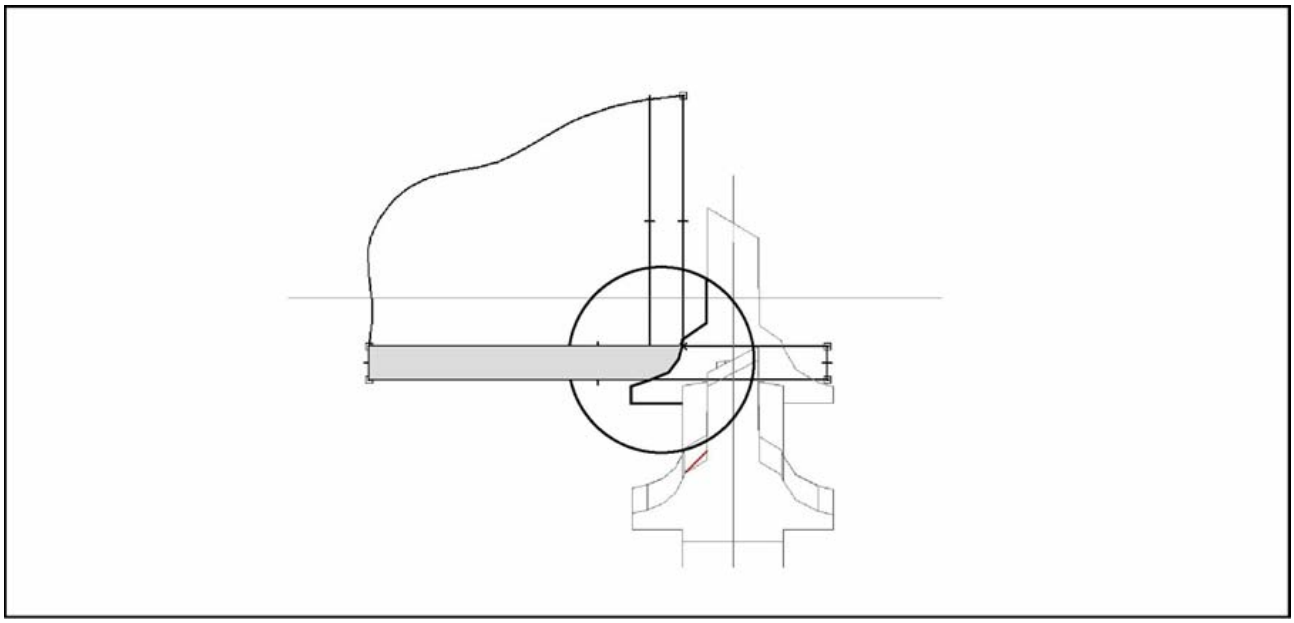
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6.6.2.2 HEADER ADJUSTMENT WITH ROUNDING FUNCTION

(me35_6-6-2-2_1.0)

NOTE-INFORMATION:
The Group is registered in the factory and does not require any further adjustments; adjustment is delicate, so only intervene if you are sure the malfunction is due to the operating group (first check all the faults listed in chapter 20).

The following figure shows the perfect end trimming condition.



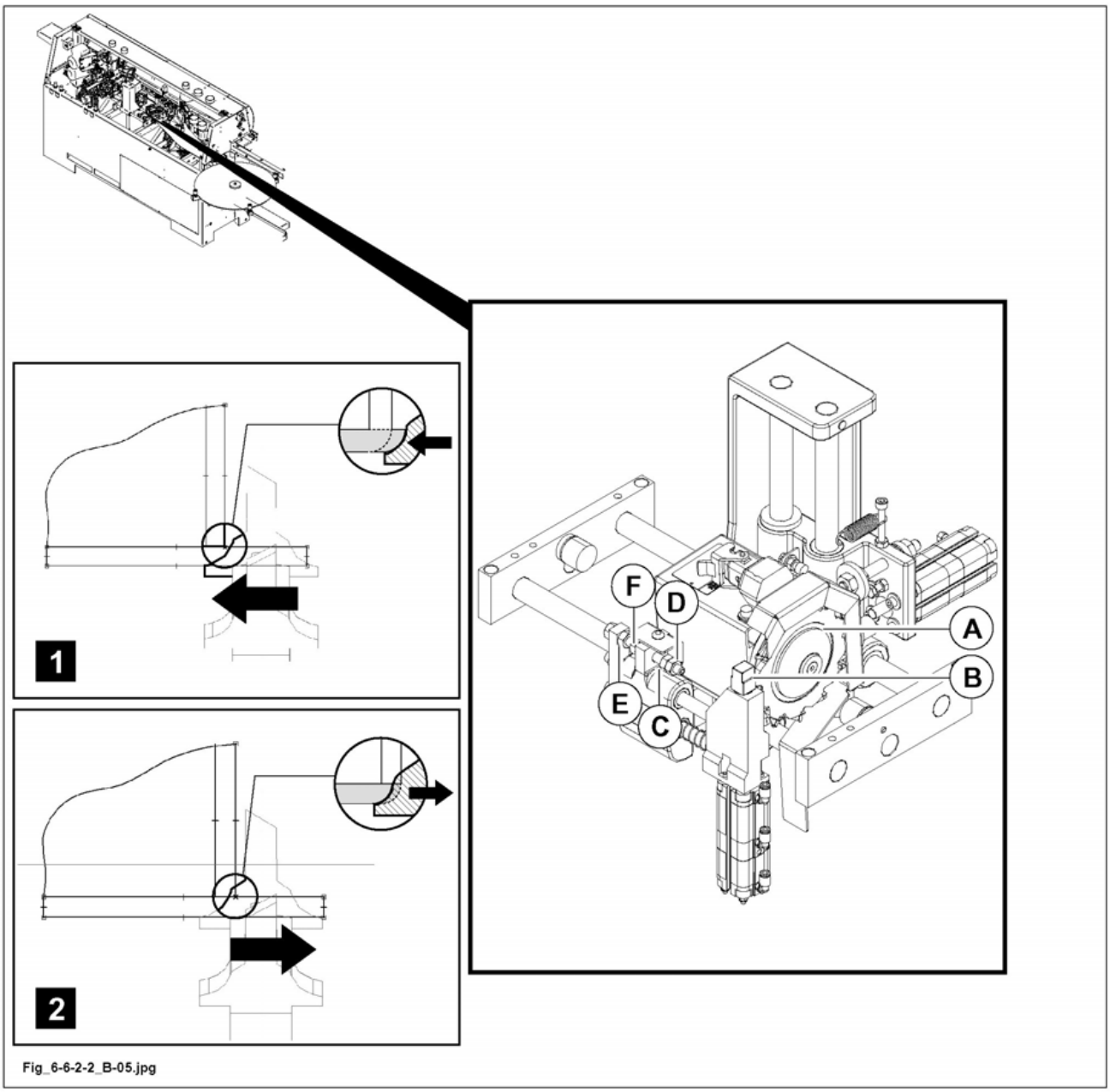
If there is a FRONT or REAR edge end cutting defect align the blade with the panel feeler as follows:

FRONT FEELER ADJUSTMENT
Loosen the nut E and act on the nut F until blade A is aligned with feeler B.

If the F nut is unscrewed, the blade approaches to the panel (case **1**) , if on the contrary, it goes away (case **2**).

REAR FEELER ADJUSTMENT
Loosen the nut D and act on the nut C until blade A is aligned with feeler B.

If the C nut is unscrewed, the blade approaches to the panel (case **1**) , if on the contrary, it goes away (case **2**).



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If the cutting depth Z of the end trimmer A needs to be adjusted, proceed as follows:

- loosen the nut H.
- Use the screw V to decrease or increase the blade position.
- Tighten the nut H.

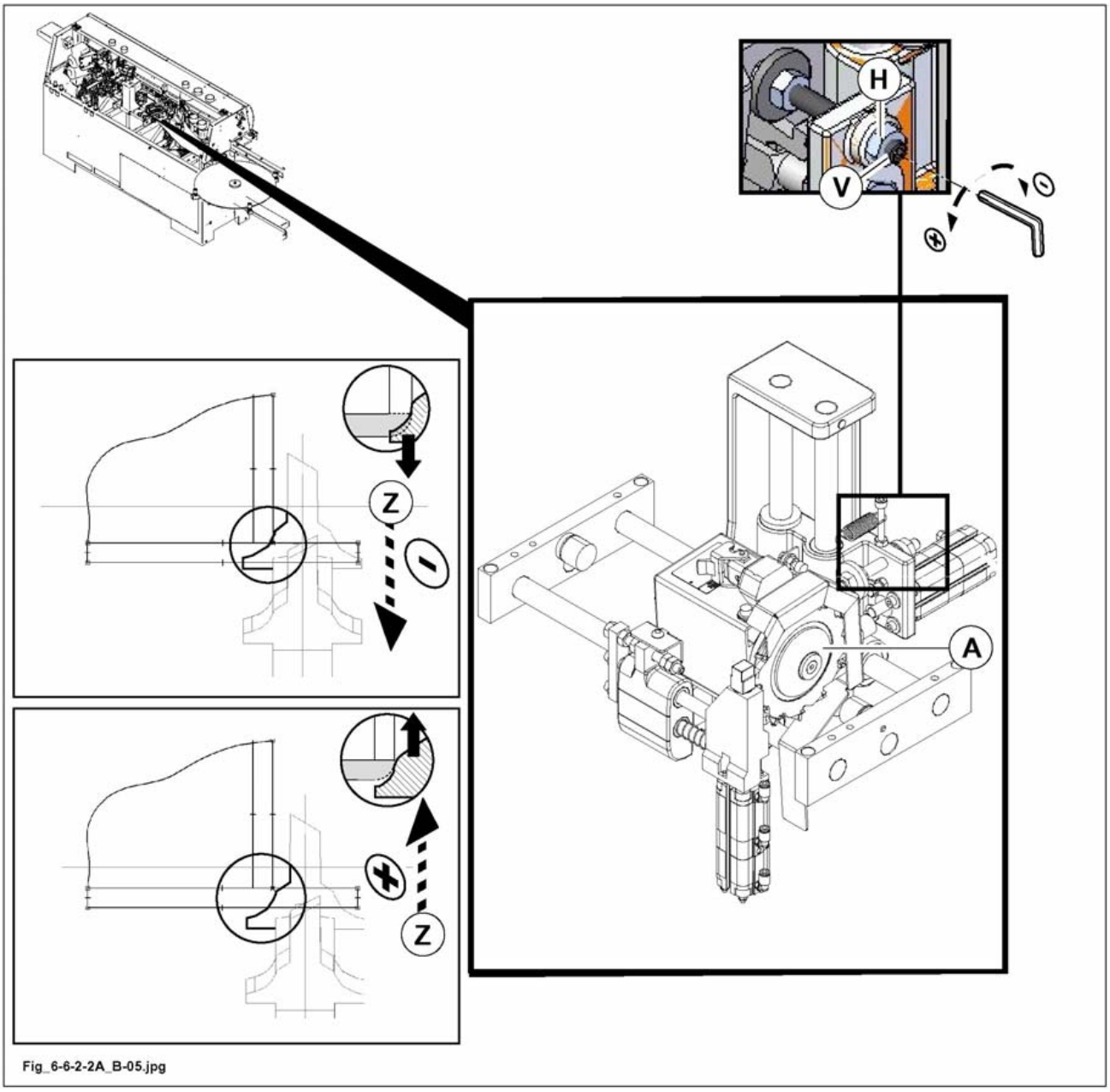


Fig_6-6-2-2A_B-05.jpg

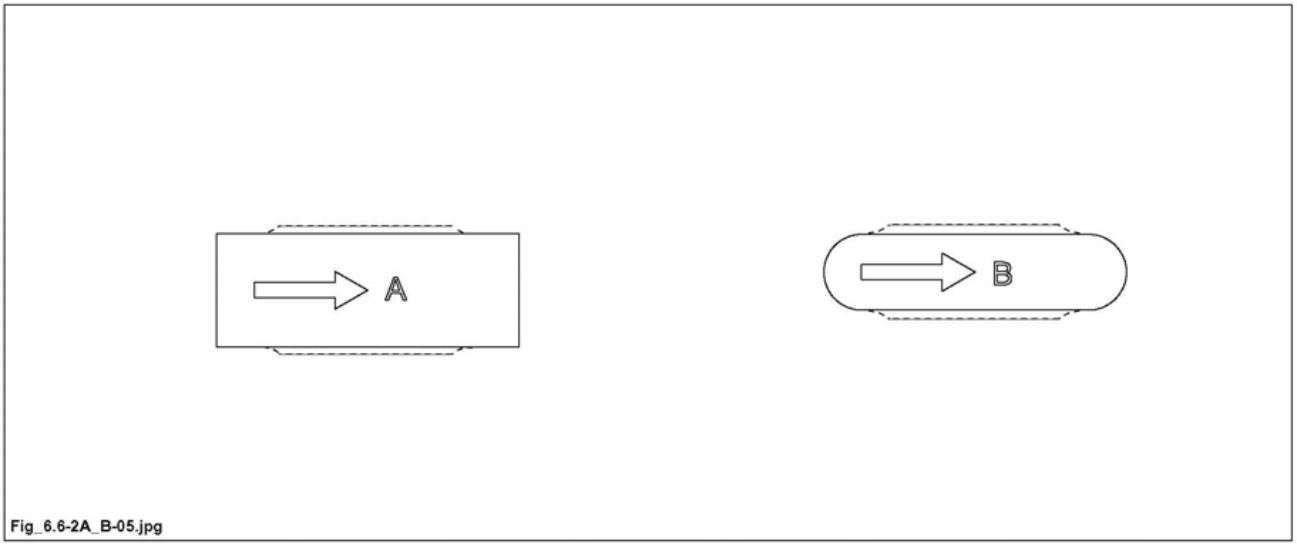
6.6.3 END CUTTING UNIT ADJUSTMENT

(me35_6-6-3_0.0)

(ME 35TR)

The "Intestatore - Arrotondatore" combined group performs the following functions:

- heading and rounding the joint angles of the two sides edged at the head and in the tail, with straight panels (A);
- profiling head and tail edgings on shaped panels.



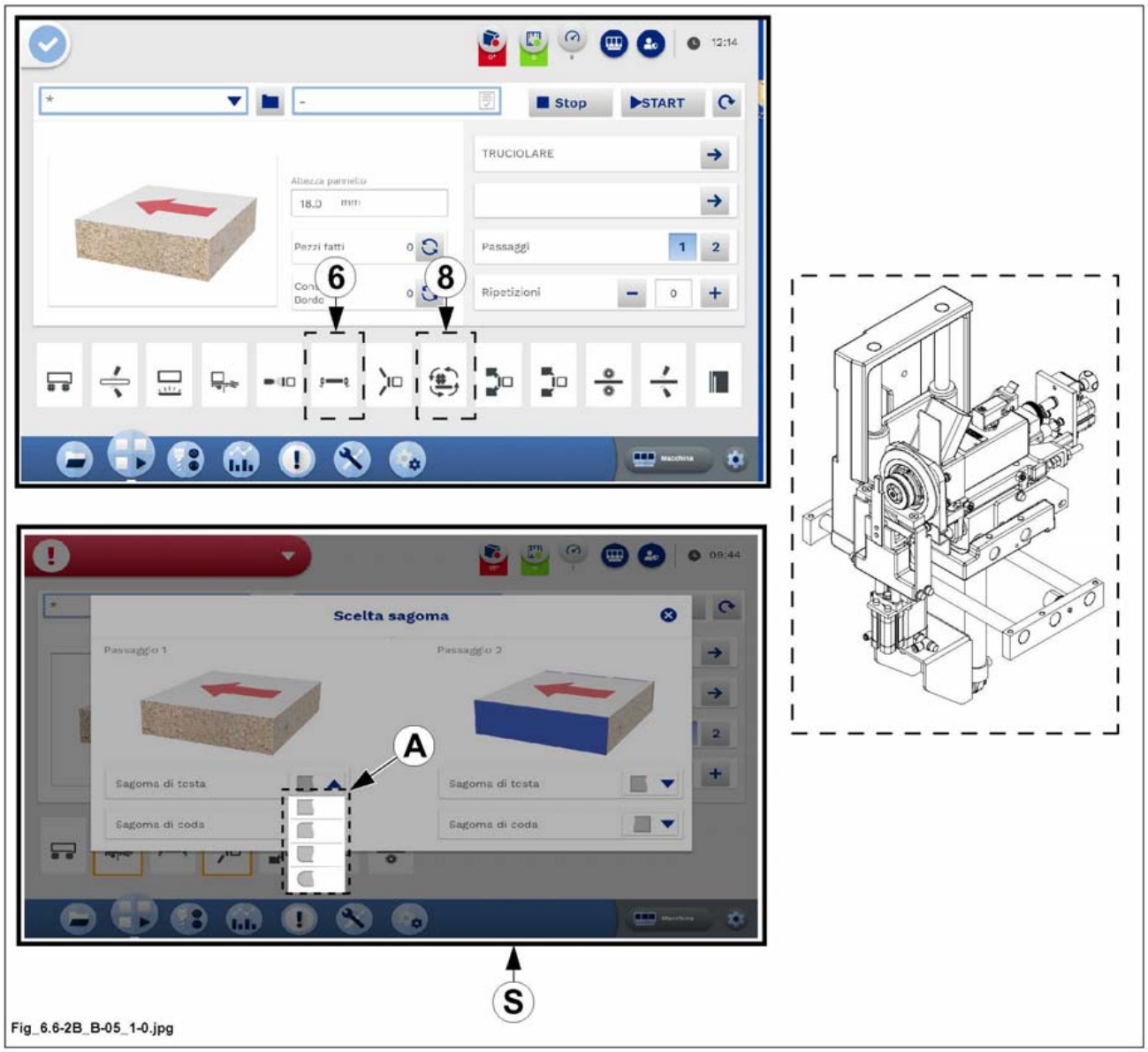
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The unit allows the following machinings (without replacing any parts):
- thin edging;
- thick board.

The transition from processing for

- STRAIGHT laying (icon 6)
- ROUNDED LACING (icon 8)
- MACHINING for laying of SHAPED PANELS
  (for the choice of panel SHAPE (detail "A" of screen "S") see Par. 2.1.2.1 on the attached ELECTRONIC CONTROL manual)

is performed pneumatically.



6.6.3.1 OPERATING SEQUENCE

(me35_6-6-3-1_1.0)

NOTE-INFORMATION:
These commands can be activated only when there are no panels being machined.

NOTE-INFORMATION:
the panels and their corresponding coatings must be sufficiently resistant. If the panels and related coatings are deformed on contact with the copiers, the processing is compromised.
Solid wood edges are not workable.
ONLY FOR "ME35TR" VERSION:
To avoid panel cutting errors and ensure optimal processing, it is always a good idea to use the rectifier function.

If the fields

- (t) = off
- (c) = off

the end cutting unit is disabled. In this way the panel passes without being trimmed both in the "step **1**" (pressing the - A - key) and in the "step **2**" (pressing the - B - key).

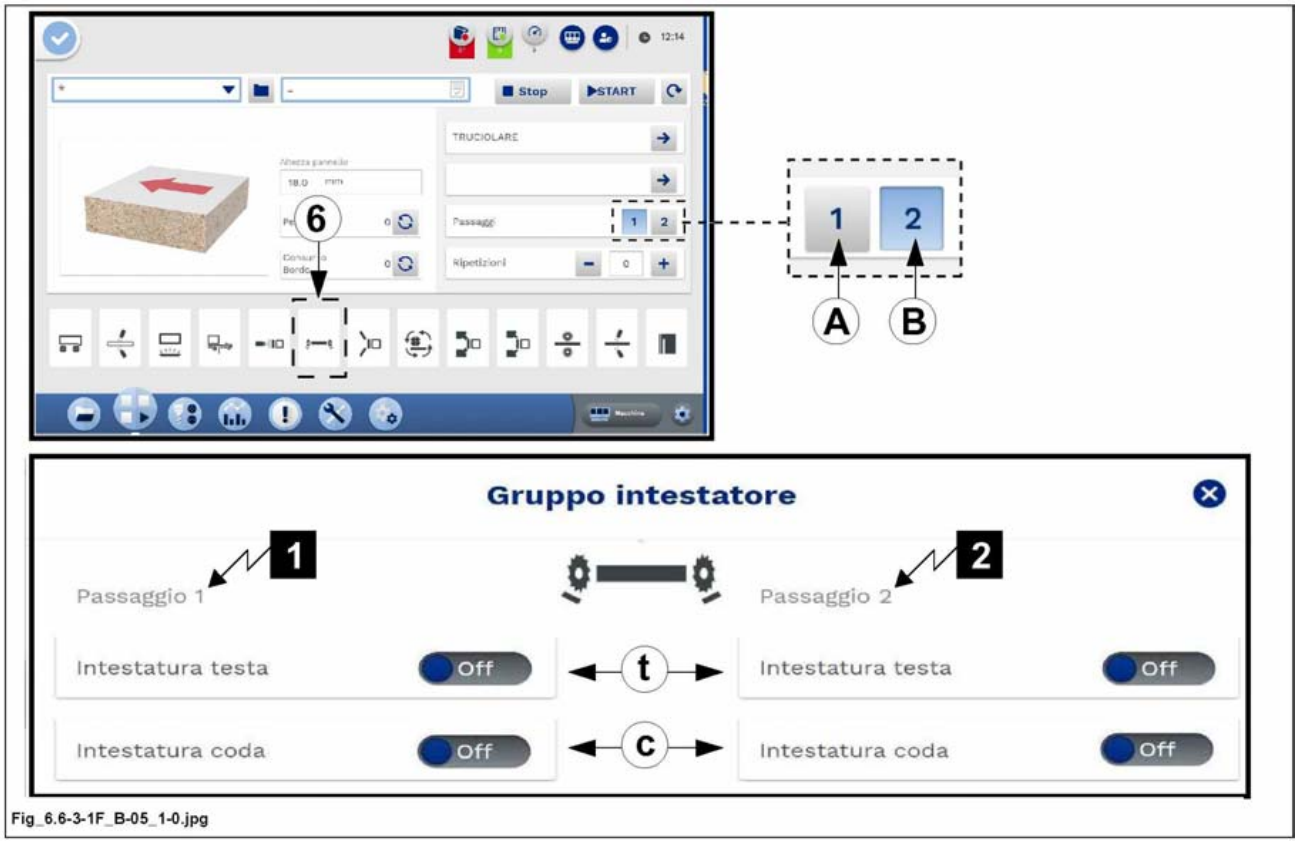


Fig_6.6-3-1F_B-05_1-0.jpg

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If the fields

- (t) = ON
- (c) = ON
- (Rt) = off
- (Rc) = off

Saw blades for straight cutting/ the end cutting unit is on. The unit is ready to cut the excess edge, on the front and on the back, both in the "step 1" (pressing the - A - key) and in the "step 2" (pressing the - B - key).

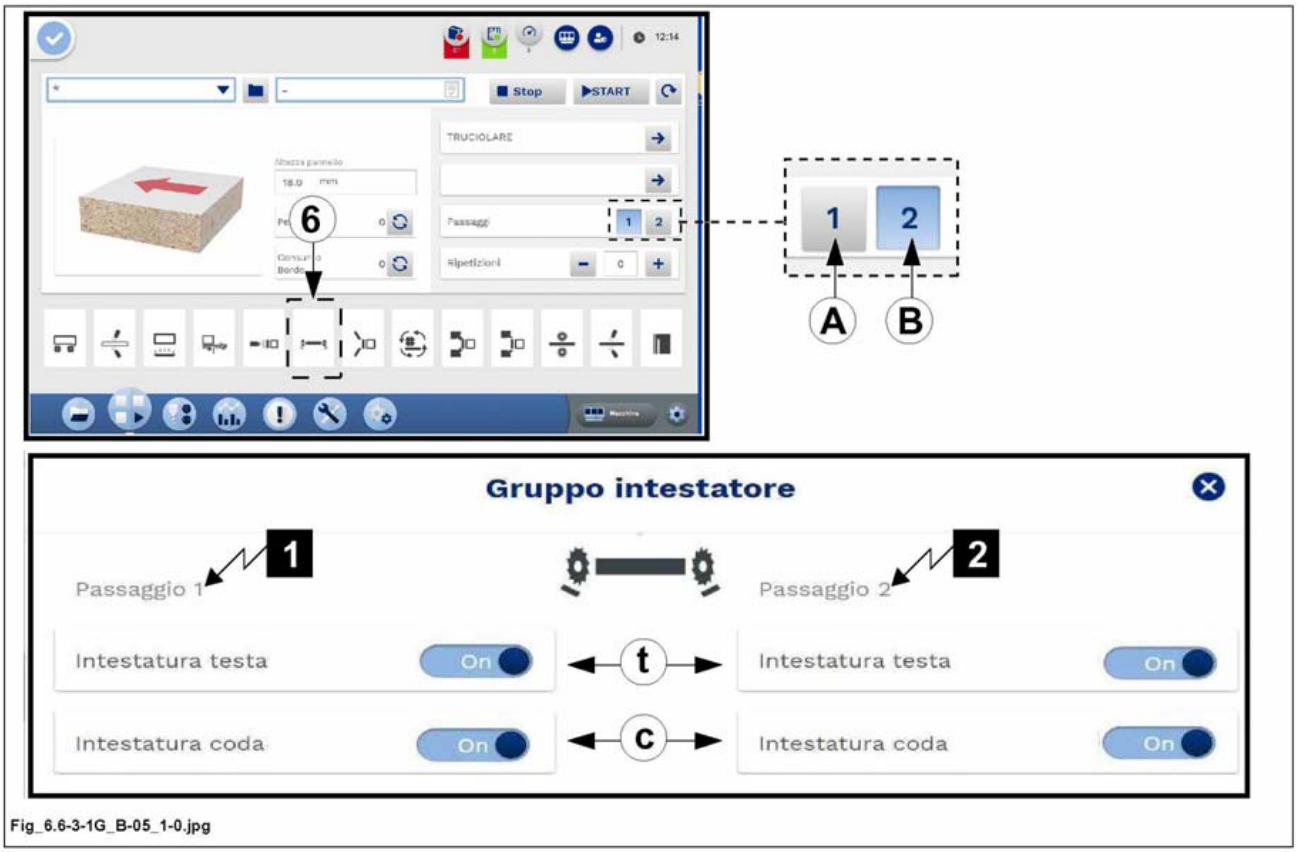


Fig_6.6-3-1G_B-05_1-0.jpg

By pressing the "8" icon ("Rounding unit") the screen (L) is displayed:
tool with rounding / the end trimming unit is on. The unit cuts the excess board creating a radius on the edge, or a small chamfer on thin edges.

Combining the activation (ON) and deactivation (off) of the fields on the screen (L)

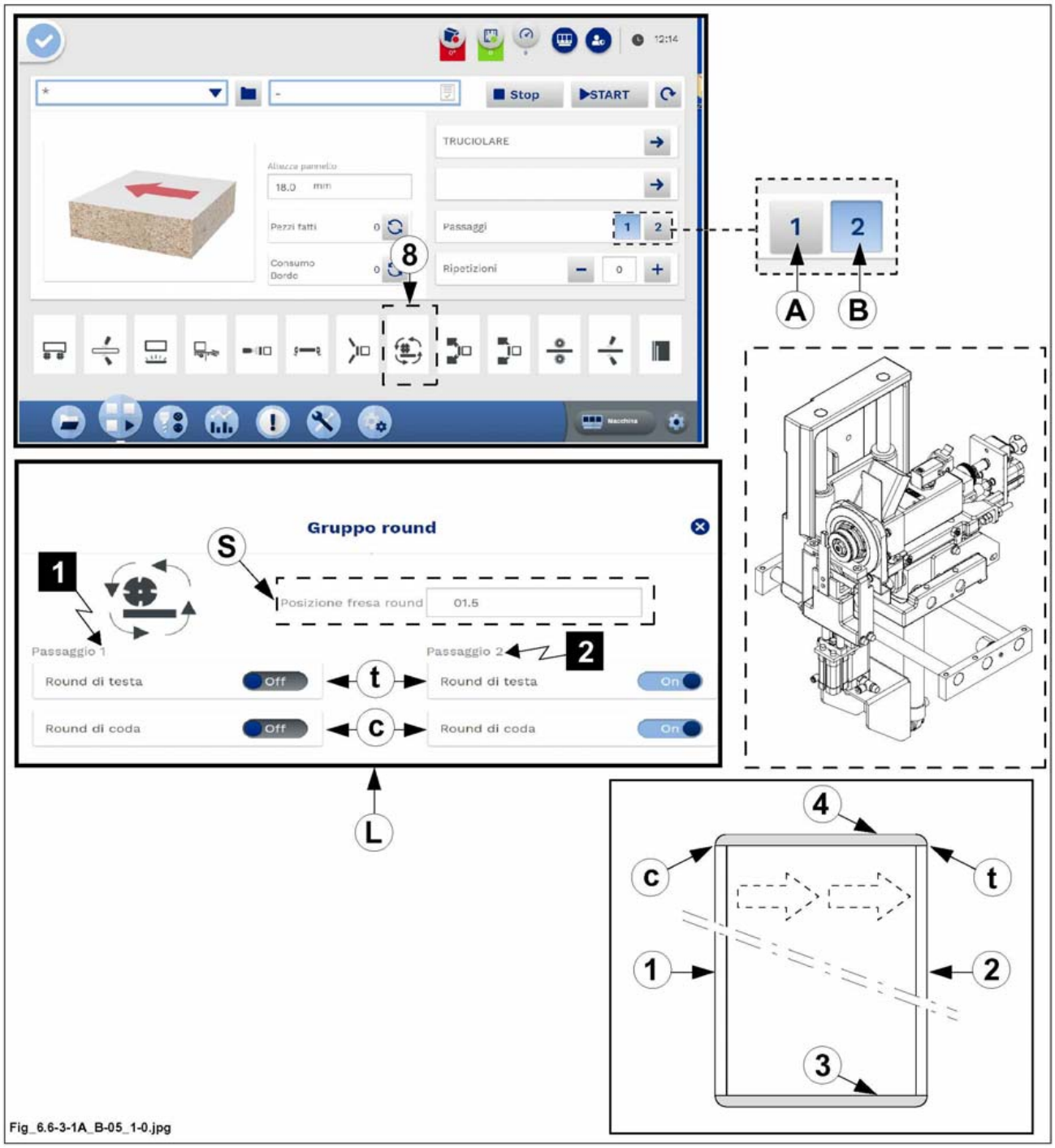
- Head round (t)
- Round of tail (c)

we can end/round the panel first on the two parallel sides (1) and (2) in the "step 1" (pressing the - A - key) and then on the other two parallel sides (3) and (4) in the "step 2" (pressing the - B - key).

The Figure shows the machining, resulting from the settings of the fields (t) and (c) of the screen (L).

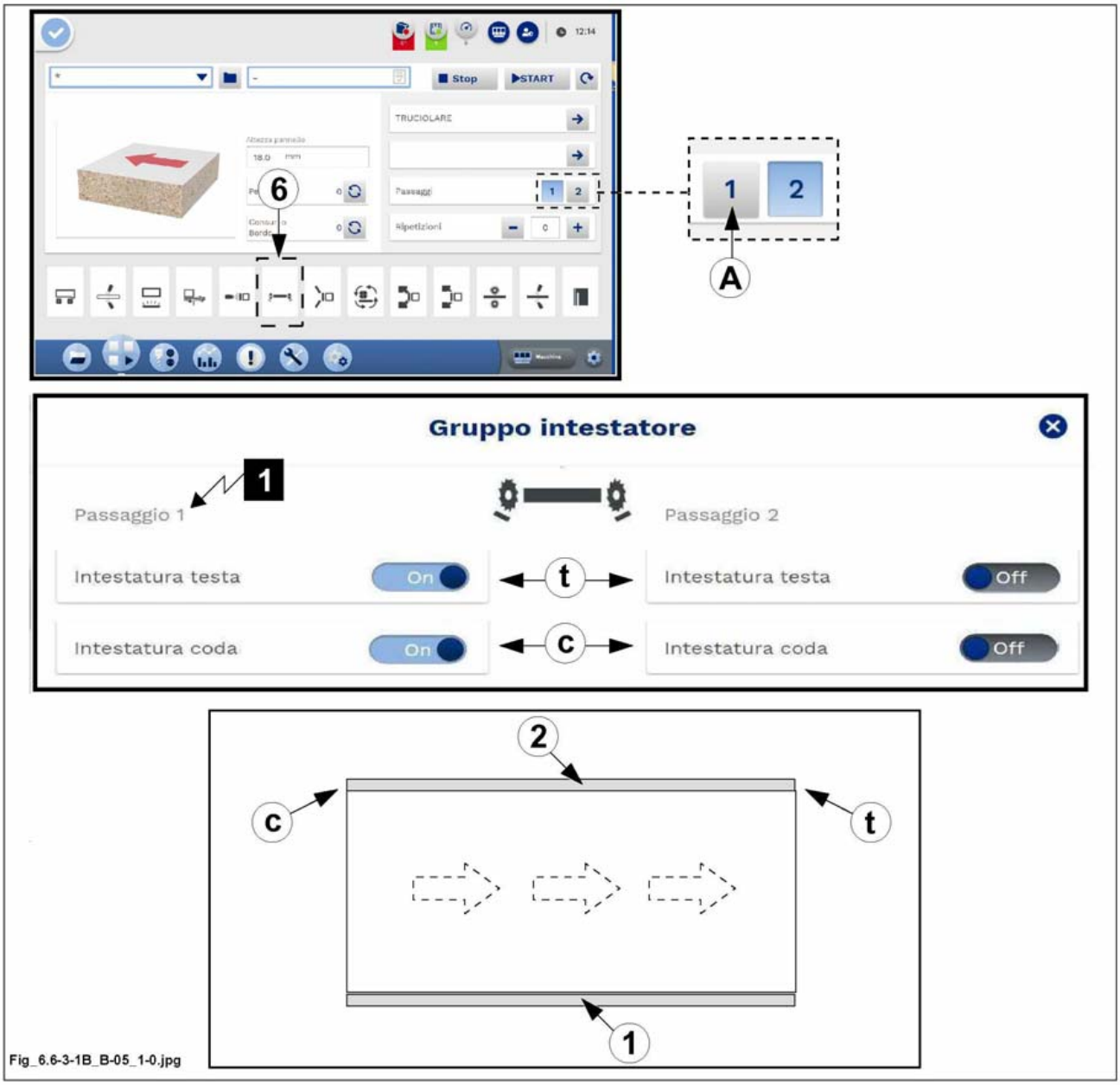
NOTE-INFORMATION:
if the edge used has a thickness lower than the cutter radius, perform the "thin edge adjustment" as indicated in Par. 6.6.3.3 and insert this data in the "S" field.
If the program thus modified is saved, the modification made is permanent (for the management of work programs see Chap. 2 "Home management page" of the attached ELECTRONIC CONTROL manual).
Upon subsequent reuse of the aforementioned work program, the ELECTRONIC CONTROL will perform a check between what is required by the program and the machine fixturing, highlighting all possible inconsistencies on the screen, to the operator.

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NOTE-INFORMATION:
to have the best working quality, when you have to execute a radius end trimming, always use the rectifier.

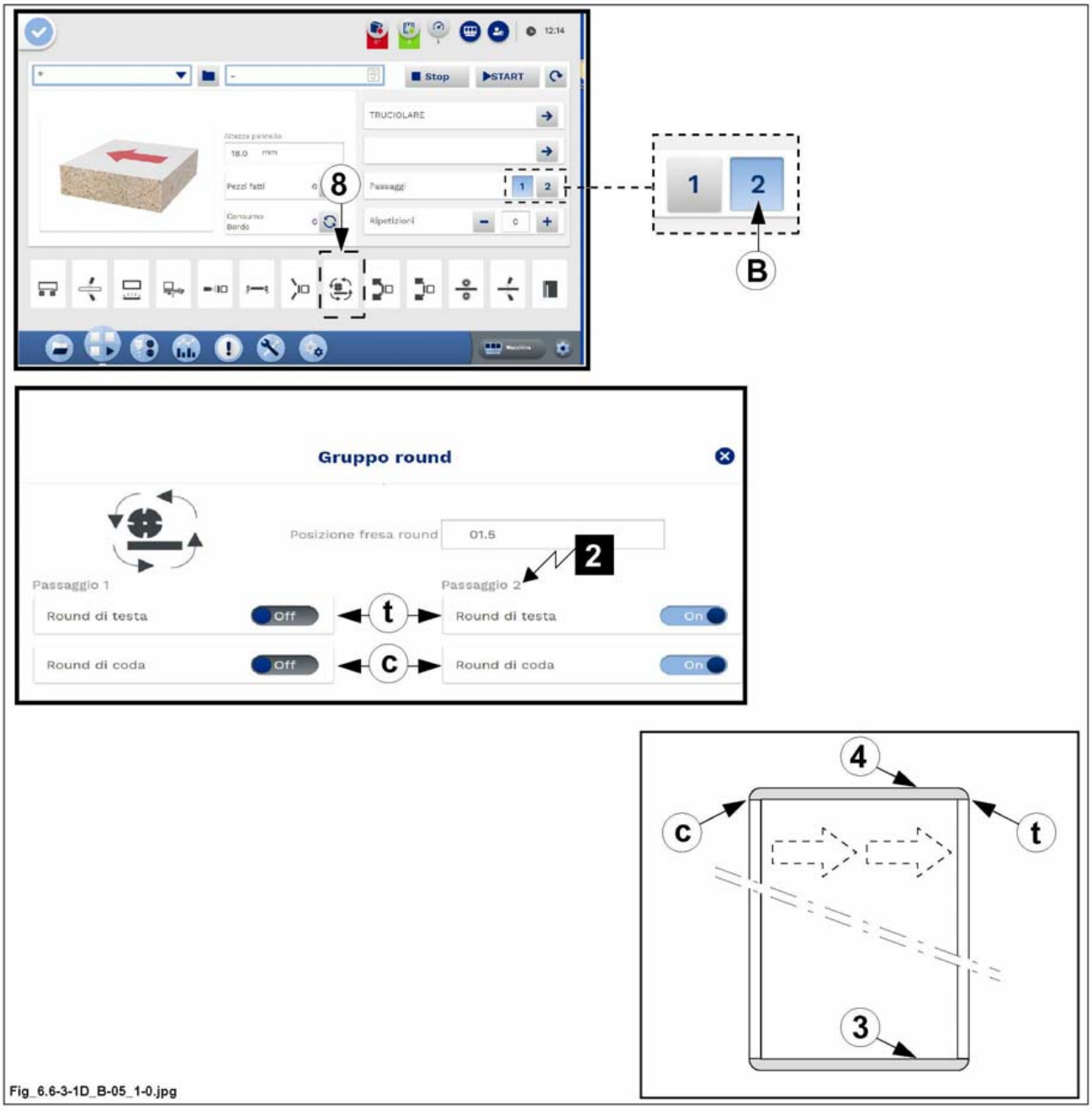
- Press the pushbutton (A) to enable Step **1**
  we will have a straight end trim, in the head (t) and in the tail (c), on the two parallel sides (1) and (2).



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NOTE-INFORMATION:
If you want to edge the four sides, turn the panel by 90° and complete the edging (with radiused header), head and tail, performing the step 2.

- Press the button (B) to enable Step **2**
  we will have a header - rounding, in the head (t) and in the tail (c), on the two parallel sides (3) and (4).

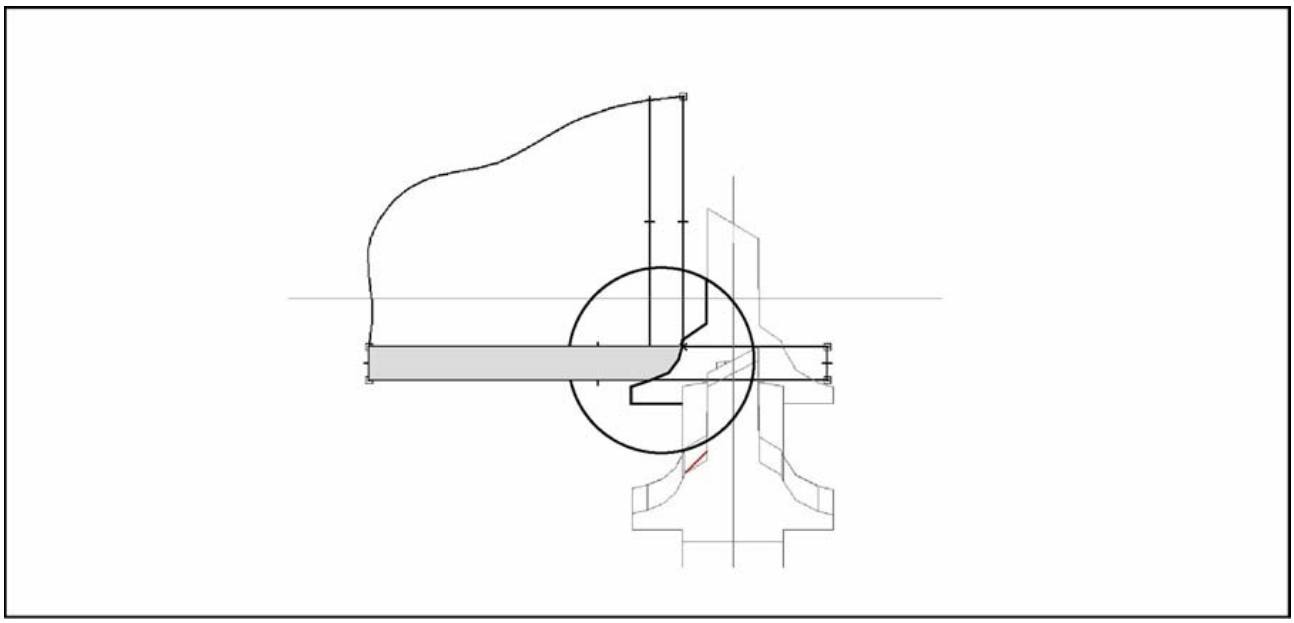


6.6.3.2 END CUTTING UNIT ADJUSTMENT

(me35_6-6-3-2_0.0)

NOTE-INFORMATION:
The Ending-Rounding Group is registered in the factory and does not require any further adjustments; adjustment is delicate, so only intervene if you are sure the malfunction is due to the operating group (first check all the faults listed in chapter 20).

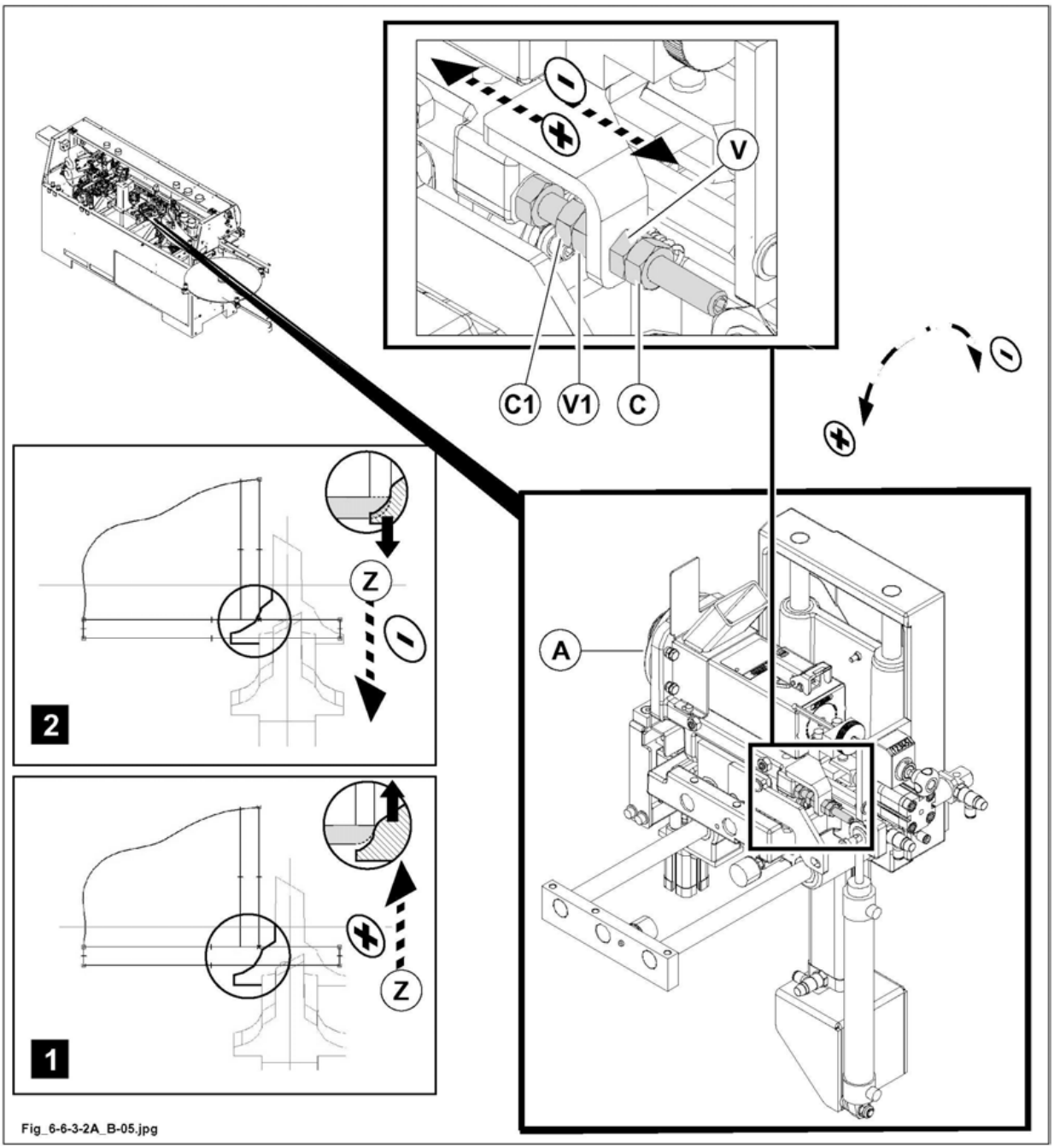
The following figure shows the perfect end trimming condition.



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If the cutting depth Z of the end trimmer A needs to be adjusted, proceed as follows:

- loosing nut C1 and work on nut V1.
- Act on the nut V1 clockwise to increase removal of the edge (case **1**) and counterclockwise to decrease it (case **2**).
- Once the adjustment is complete, tighten nut C1 on nut V1.



NOTE-INFORMATION:
always carry out a border test to verify the machine is adjusted correctly.

6.6.3.3 THIN EDGE ADJUSTMENT

(me35_6-6-3-3_0.0)

If the edge used has a thickness lower than the cutter radius, perform the "thin edge adjustment" as follows:

- loosen the ring nut F and turn the knob G:
  - Turn clockwise to reduce the amount of material removed.
  - Turn anti-clockwise to increase the amount of material removed.

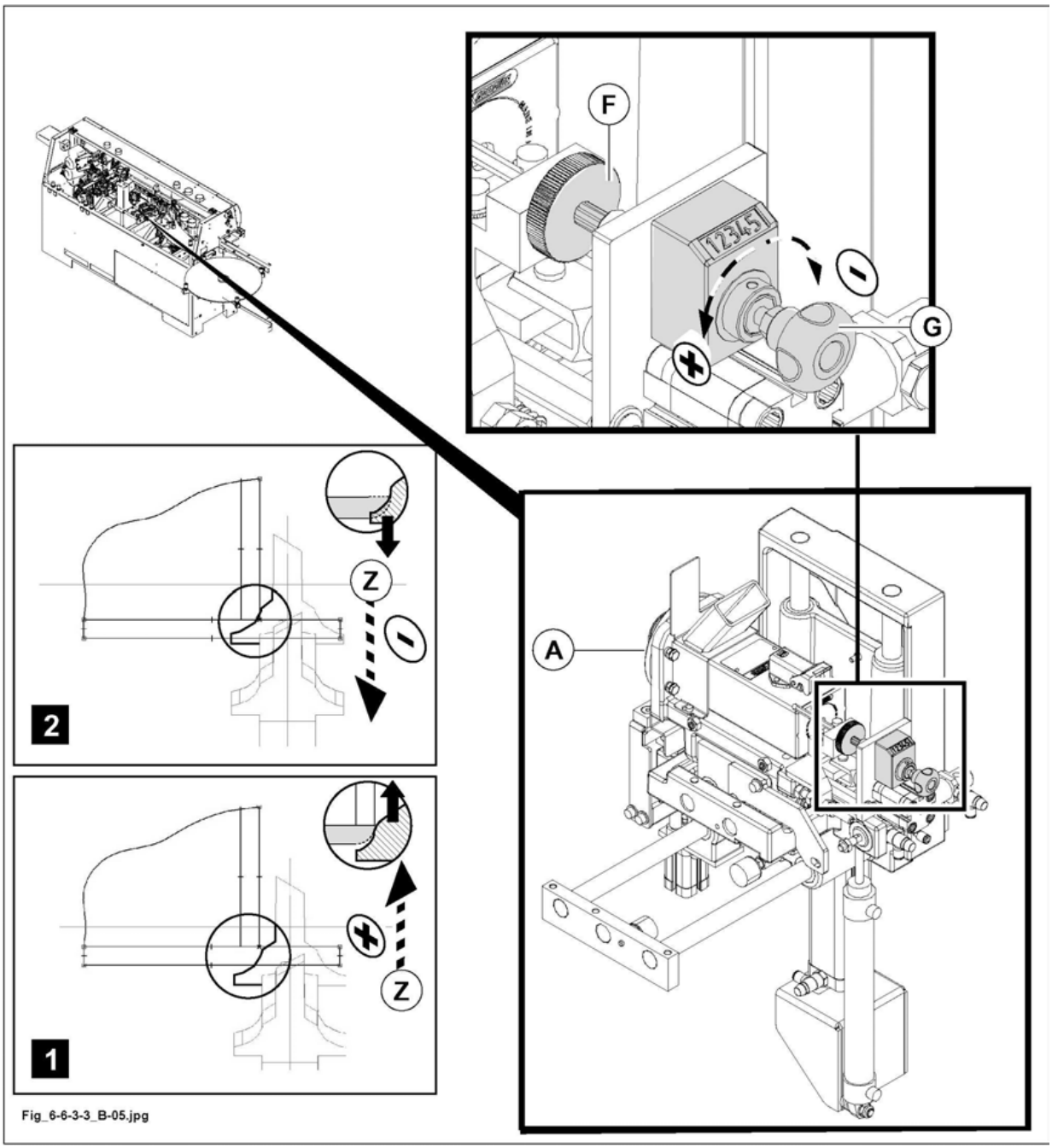


Fig_6-6-3-3_B-05.jpg

NOTE-INFORMATION:
always carry out a border test to verify the machine is adjusted correctly.

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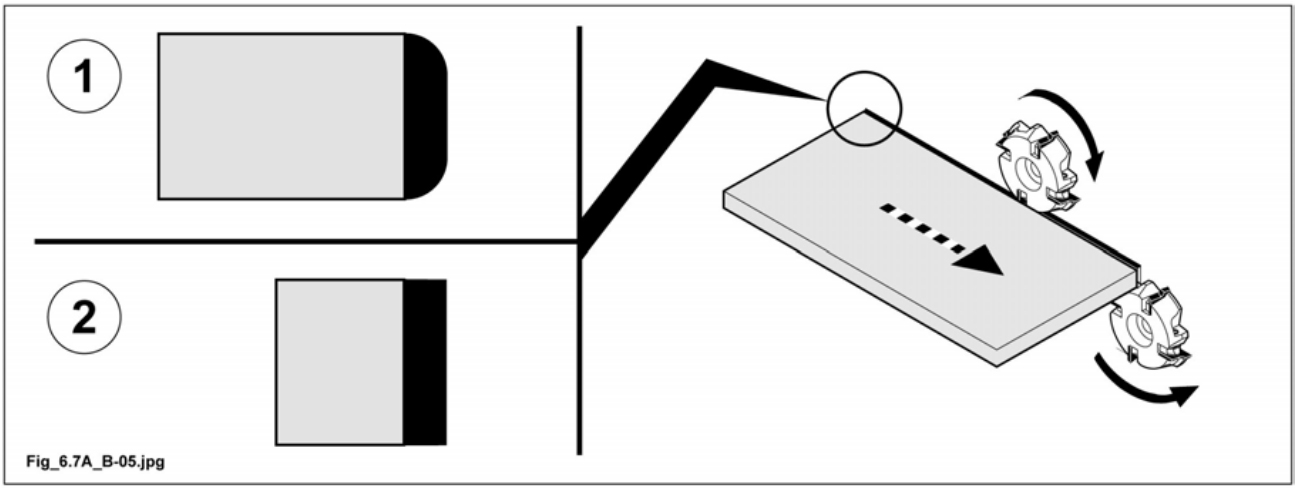
(st_06-02)

6.7 TRIMMING REGULATION

(me25_6-7_0.0)

DANGER-WARNING:
during machining the unit is protected by the cabin; moreover the cabin is fitted with a device that prevents the opening before a set time has elapsed from the stop command.
When the cabin is open, the unit cannot be operated.

The trimmers cut the excess edge from the two sides of the panel; the following can be obtained:
1 - Rounded trimming:
STD R=2 mm
OPT (R=1 mm ; R=1,5 mm ; R=3 mm)
2 - Sharp-edged trimming as a function of trimming depth adjustment.



UNIT EXCLUSION
To exclude the unit pull the handle D until the lever C is inserted automatically.
GROUP INSERTION
To insert the unit use the lever C, moving the unit with the handle D.

The trimming depth must be regulated on the basis of the thickness of the edge by acting on the knobs E after having loosened the lock nut B.
- Turn clockwise to reduce the amount of material removed.
- Turn anti-clockwise to increase the amount of material removed.
- The trimming depth value is indicated on the numerical indicator A.

NOTE-INFORMATION:
inside the cowling, on each trimmer unit, a plate has been glued.
A ***upper trimmer***
B ***lower trimmer***
The manufacturer's technicians fill in the first two lines when testing.
The first line indicates the cutter radius
The second line indicates the thinnest thickness of coiled edging used.
The third and fourth line can be used by the client
The fifth line indicates the position of the cutter to cut the edging in strips.

If necessary adjust the removal of the edge in the direction of the arrow, regulating the trimming depth using the knobs E.

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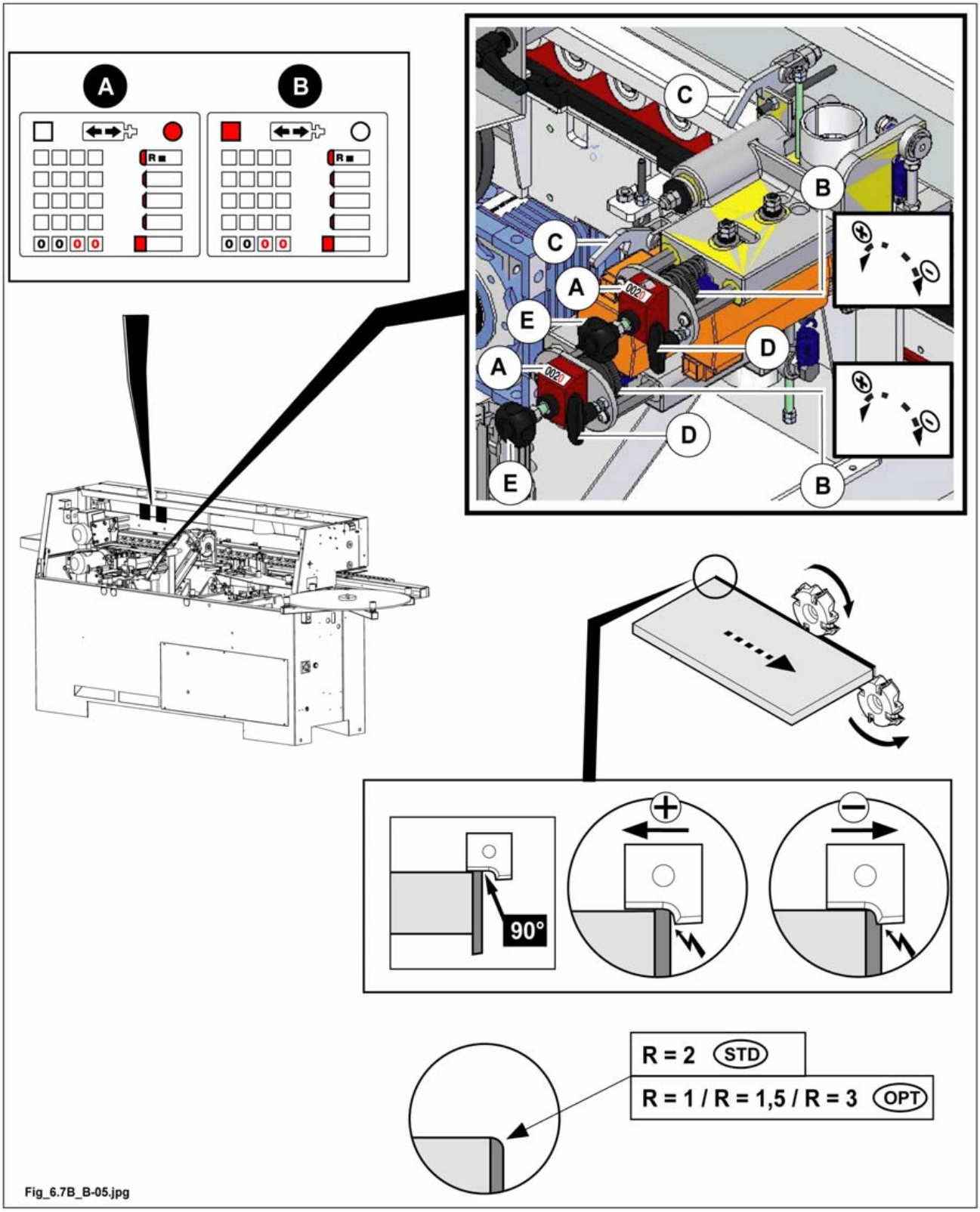


Fig_6.7B_B-05.jpg

6.7.1 ADJUSTING THE FEELER PIN OF THE BOARD CUTTER

(me25_6-7-1_0.0)

Feeler adjustment acts on the height of the cutter above the panel, thus increasing or decreasing edge removal.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions. Regulation is delicate, therefore only intervene if you are sure that the malfunctioning is due to the feelers (first check all problems given in chap 20).

1 ***Upper Feeler***

- Loosen the nut A.
- Turn the screw V of the upper feeler anti-clockwise to increase removal of the edge and clockwise to decrease it.
- Tighten the nut A.

2 ***Lower Feeler***

- Loosen the nut B.
- Turn the screw W of the lower feeler clockwise to increase removal of the edge and anti-clockwise to decrease it.
- Tighten the nut B.

If necessary, adjust suction in the direction of the arrows by regulating the feelers.

ADJUSTING THE ALIGNING PRESSURE
- This operation is carried out at factory during the machine test.
- If necessary operate on nut D to increase or decrease the unit pressure.

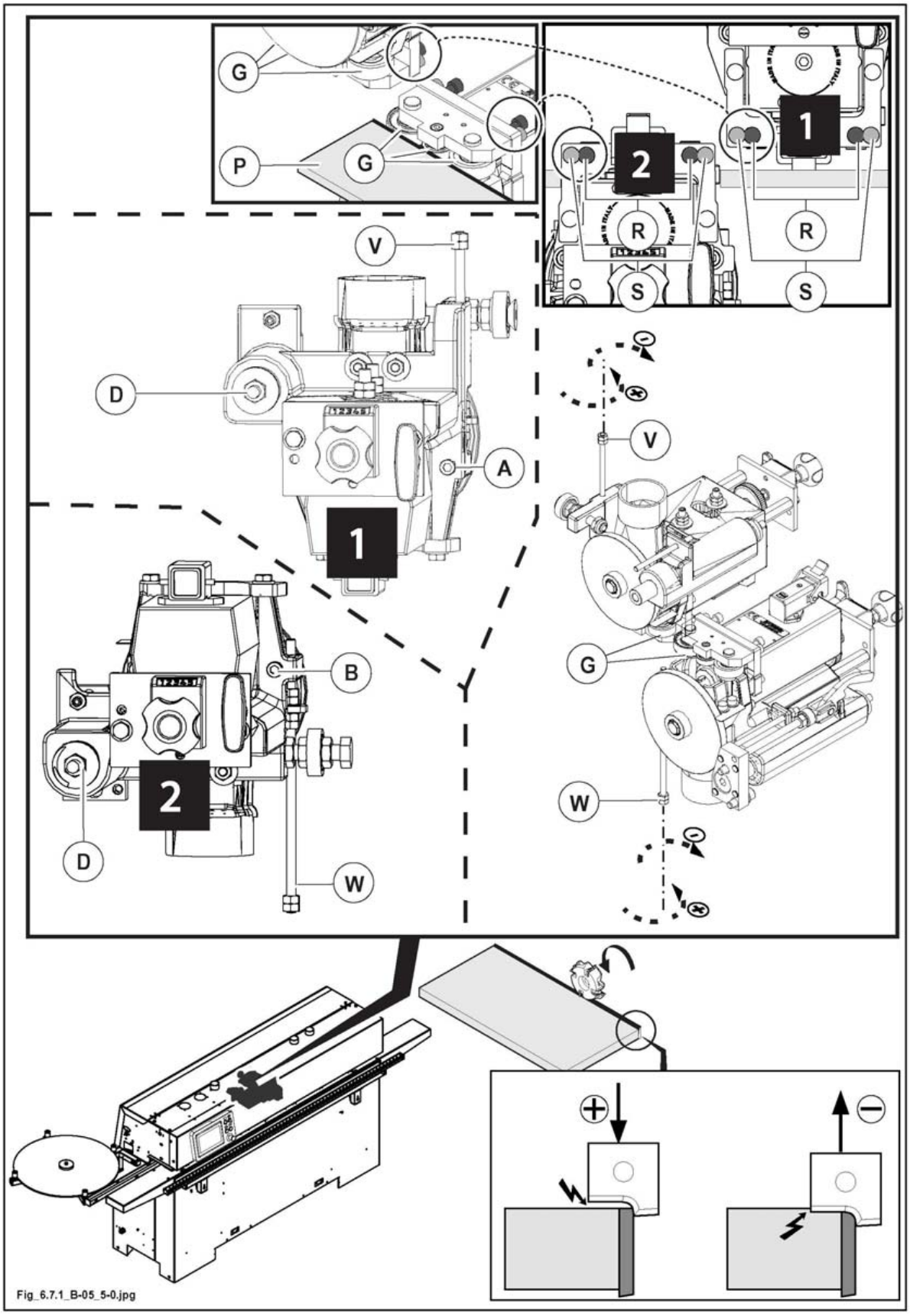
Rotating horizontal feelers G
They consist of 3 bearings adjusted so that they are in contact with the panel edge P.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions.

If the three bearings G need to be realigned, to ensure that they come into contact with the panel P at the same time, proceed as follows:
- loosen the screws S
- use the screws R until the three bearings come into contact with the panel edge P
- tighten the screws S.

NOTE-INFORMATION:
To adjust horizontal removal do not tamper with the feeler G; act on the horizontal movement of the cutters.

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G
P
G
2
1
R
R
S
S
V
D
A
1
V
G
B
2
D
W
W
Fig_6.7.1_B-05_5-0.jpg

6.7.1.1 NESTING TRACK FEELER KIT FOR TRIMMER UNIT

(me35_6-7-1-1_0.0)

OPT

A vertical track feeler T is installed on the lower unit 2 of the trimmer unit with 3 rotating contact points to replace the disc track feeler supplied as standard.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions. Regulation is delicate, therefore only intervene if you are sure that the malfunctioning is due to the feelers (first check all problems given in chap 20).

If necessary, adjust suction in the direction of the arrows by regulating the feelers.

Proceed as follows:

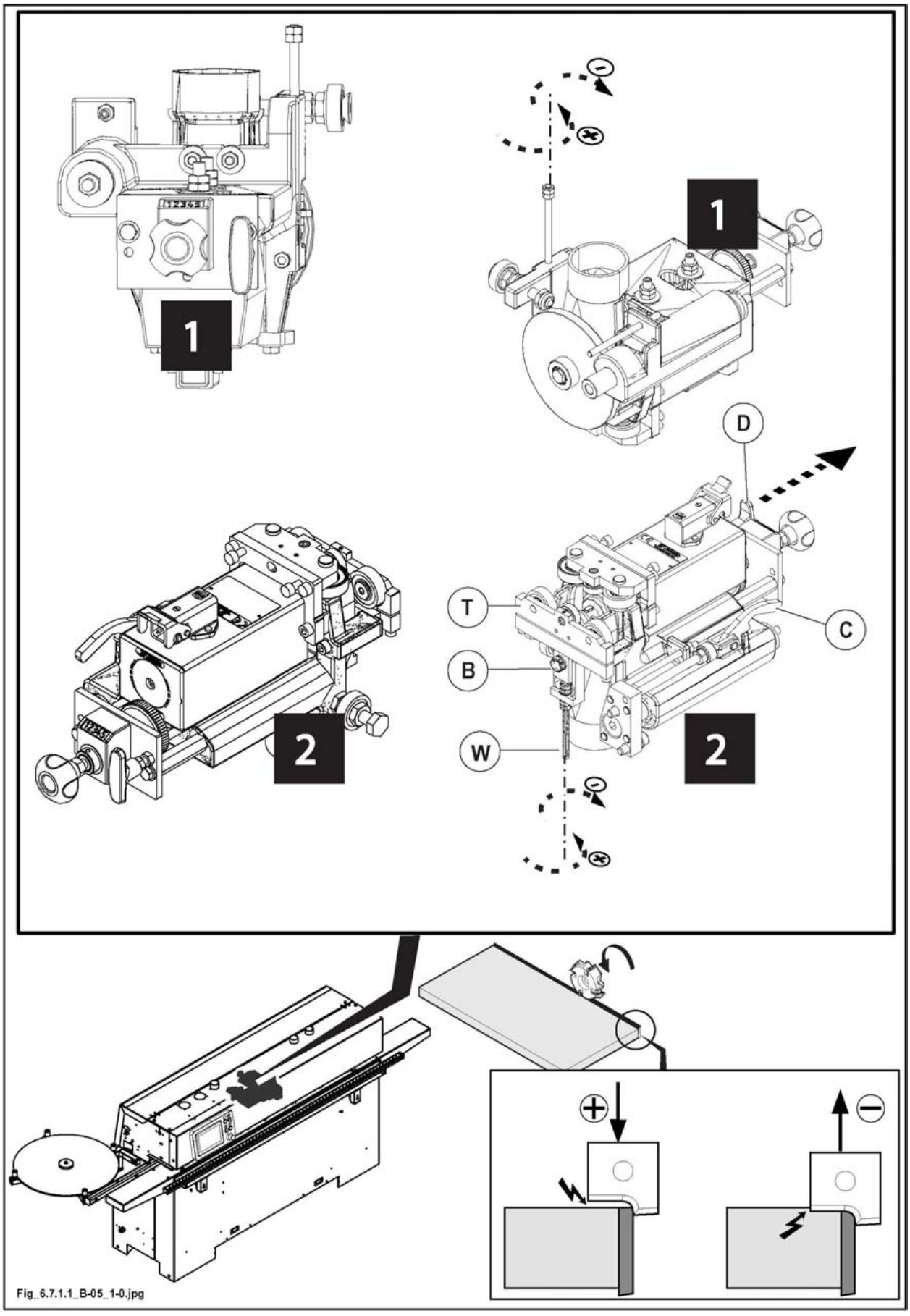
UNIT EXCLUSION
To exclude the unit pull the handle D until the lever C is inserted automatically.

- Loosen the screw B.
- Turn the screw W of the lower feeler clockwise to increase removal of the edge and anti-clockwise to decrease it.
- Tighten the screw B.

GROUP INSERTION
To insert the unit use the lever C, moving the unit with the handle D.

CAUTION:
PROFILES THAT CAN BE MACHINED WITH THE "NESTING" TRACK FELLER KIT OPT
To machine panels from the "Nesting" production cycle, follow the indications in Par. 3.1.

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1
1
D
T
C
B
W
2
2
Fig_6.7.1.1_B-05_1-0.jpg

To obtain the correct machining, the 3 rotating contact points of the vertical track feeler T, consisting of 3 bearings G, are adjusted so that they can be in contact with the panel edge P.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions.

If the removal has defects, the three bearings G must be realigned.

If the three bearings G need to be realigned, to ensure that they come into contact with the panel P at the same time, proceed as follows:

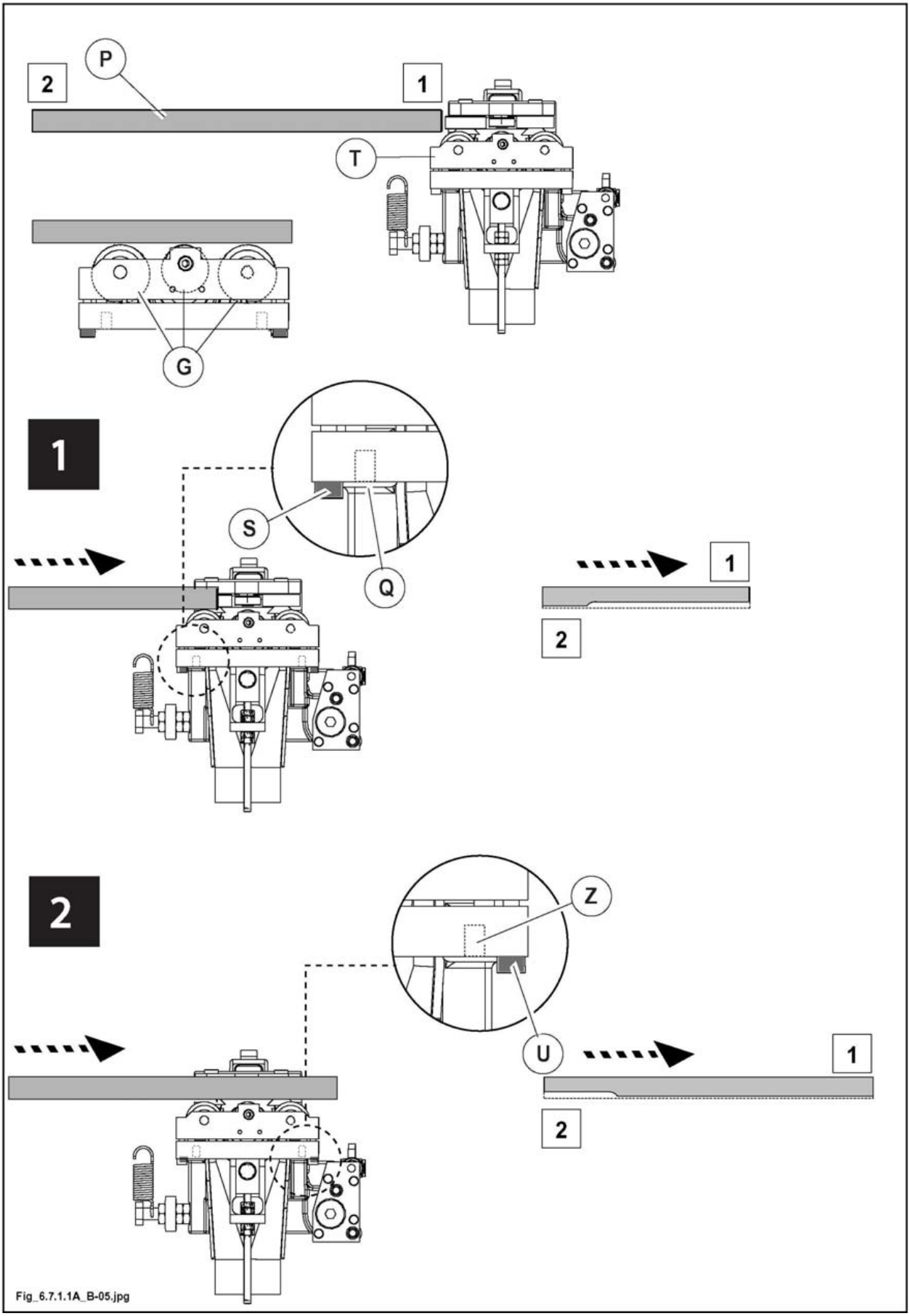
CASE **1**
excessive removal at the panel infeed (1) and not at the outfeed (2).

The line of bearings in infeed must be raised. To do this:
- loosen the screw S
- adjust the grub screw Q to raise the vertical track feeler T, on the panel INFEED side.
  1 screw turn = 1 mm of lifting
- tighten the screw S.

CASE **2**
excessive removal at the panel outfeed (2) and poor removal at the infeed (1).

The line of bearings in outfeed must be raised. To do this:
- loosen the screw U
- adjust the grub screw Z to raise the vertical track feeler T, on the panel OUTFEED side.
  1 screw turn = 1 mm of lifting
- tighten the screw U.

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P
2
1
T
G
1
S
Q
1
2
2
Z
U
1
2
Fig_6.7.1.1A_B-05.jpg

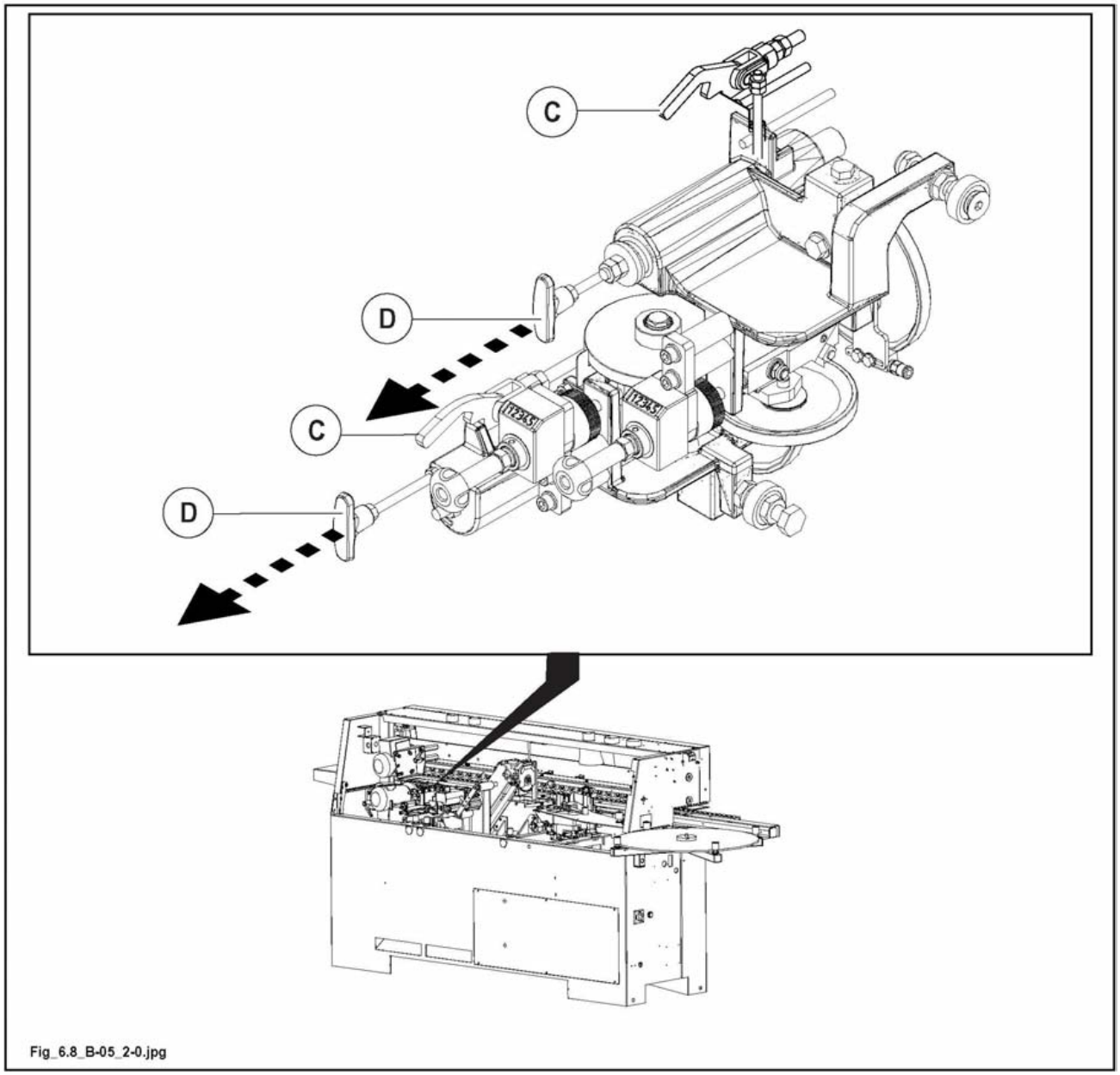
6.8 EDGE SCRAPER UNIT

(me25_6-8_0.0)

OPT

The edge scraper unit trims the edging.

UNIT EXCLUSION
To exclude the unit pull the handle D until the lever C is inserted automatically.
GROUP INSERTION
To insert the unit use the lever C, moving the unit with the handle D.



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(vuota001)

6.8.1 EDGE SCRAPER ADJUSTMENT

(me25_6-8-1_0.0)

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions. Regulation is delicate, therefore only intervene if you are sure that the malfunctioning is due to the feelers (first check all problems given in chap 20).
Trimming quality depends directly on panel characteristics. If the panel is concave, convex or with edges not at 90°, do not intervene on the regulations of the machine, as no results are obtained.

If necessary, adjust suction in the direction of the arrows by regulating the feelers.

The edge scraper device consists of two symmetric working units.

1) Top working unit: it scrapes the top panel edge by means of a shaped knife.
Equipped with vertical feeler T and horizontal feeler F, both adjustable and with a small blade R to break the chip at rear end of the panel.

Feeler T
- Loosen the screw A.
- Turn the screw V of the upper feeler anti-clockwise to increase removal of the edge and clockwise to decrease it.
- Tighten the screw A.

NOTE-INFORMATION:
to adjust horizontal removal do not tamper with the feeler F; act on the horizontal movement of the tool.

Feeler F
- Loosen the ring nut K and turn the knob G:
- Turn clockwise to reduce the amount of material removed.
- Turn anti-clockwise to increase the amount of material removed.
- The removal depth value is indicated on the numerical indicator D.
- Tighten the ring nut K.

2) Bottom working unit: it scrapes the bottom panel edge by means of a shaped knife.
Equipped with vertical feeler T and horizontal feeler F, both adjustable and with a small blade R to break the chip at rear end of the panel.

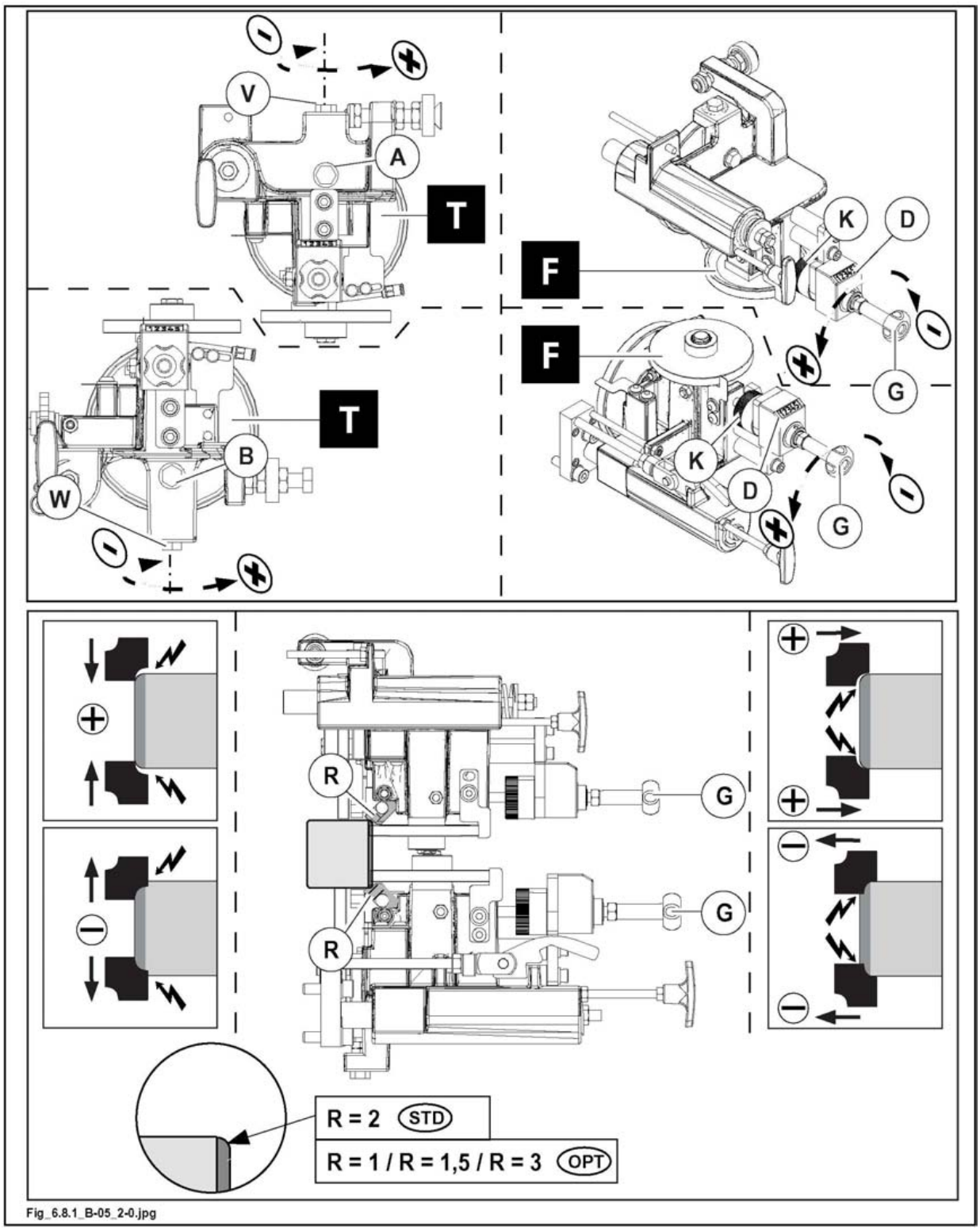
Feeler T
- Loosen the screw B.
- Turn the screw W of the lower feeler clockwise to increase removal of the edge and anti-clockwise to decrease it.
- Tighten the screw B.

NOTE-INFORMATION:
to adjust horizontal removal do not tamper with the feeler F; act on the horizontal movement of the tool.

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Feeler F

- Loosen the ring nut K and turn the knob G:
- Turn clockwise to reduce the amount of material removed.
- Turn anti-clockwise to increase the amount of material removed.
- The removal depth value is indicated on the numerical indicator D.
- Tighten the ring nut K.



6.8.1.1 NESTING TRACK FEELER KIT FOR EDGE SCRAPER UNIT

(me35_6-8-1-1_0.0)

OPT

A vertical track feeler T is installed on the lower unit 2 of the edge scraper unit with 3 rotating contact points to replace the disc track feeler supplied as standard.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions. Regulation is delicate, therefore only intervene if you are sure that the malfunctioning is due to the feelers (first check all problems given in chap 20).

If necessary, adjust suction in the direction of the arrows by regulating the feelers.

Proceed as follows:

UNIT EXCLUSION
To exclude the unit pull the handle D until the lever C is inserted automatically.

- Loosen the screw B.
- Turn the screw W of the lower feeler clockwise to increase removal of the edge and anti-clockwise to decrease it.
- Tighten the screw B.

GROUP INSERTION
To insert the unit use the lever C, moving the unit with the handle D.

CAUTION:
PROFILES THAT CAN BE MACHINED WITH THE "NESTING" TRACK FELLER KIT OPT
To machine panels from the "Nesting" production cycle, follow the indications in Par. 3.1.

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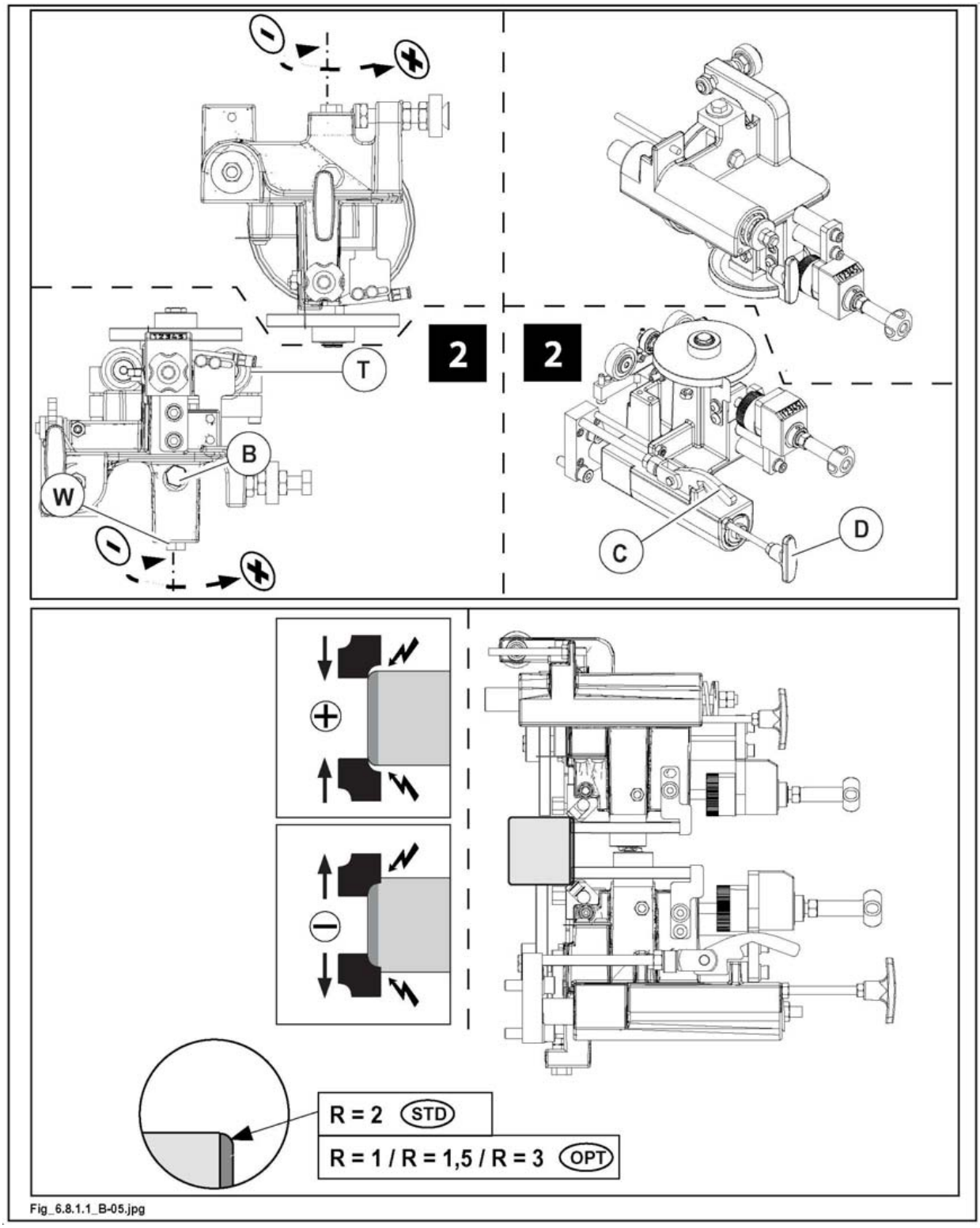


Fig_6.8.1.1_B-05.jpg

To obtain the correct machining, the 3 rotating contact points of the vertical track feeler T, consisting of 3 bearings G, are adjusted so that they can be in contact with the panel edge P.

NOTE-INFORMATION:
The feelers are regulated in the factory and does not require further interventions.

If the removal has defects, the three bearings G must be realigned.

If the three bearings G need to be realigned, to ensure that they come into contact with the panel P at the same time, proceed as follows:

CASE **1**
excessive removal at the panel infeed (1) and not at the outfeed (2).

The line of bearings in infeed must be raised. To do this:
- loosen the screw S
- adjust the grub screw Q to raise the vertical track feeler T, on the panel INFEED side.
  1 screw turn = 1 mm of lifting
- tighten the screw S.

CASE **2**
excessive removal at the panel outfeed (2) and poor removal at the infeed (1).

The line of bearings in outfeed must be raised. To do this:
- loosen the screw U
- adjust the grub screw Z to raise the vertical track feeler T, on the panel OUTFEED side.
  1 screw turn = 1 mm of lifting
- tighten the screw U.

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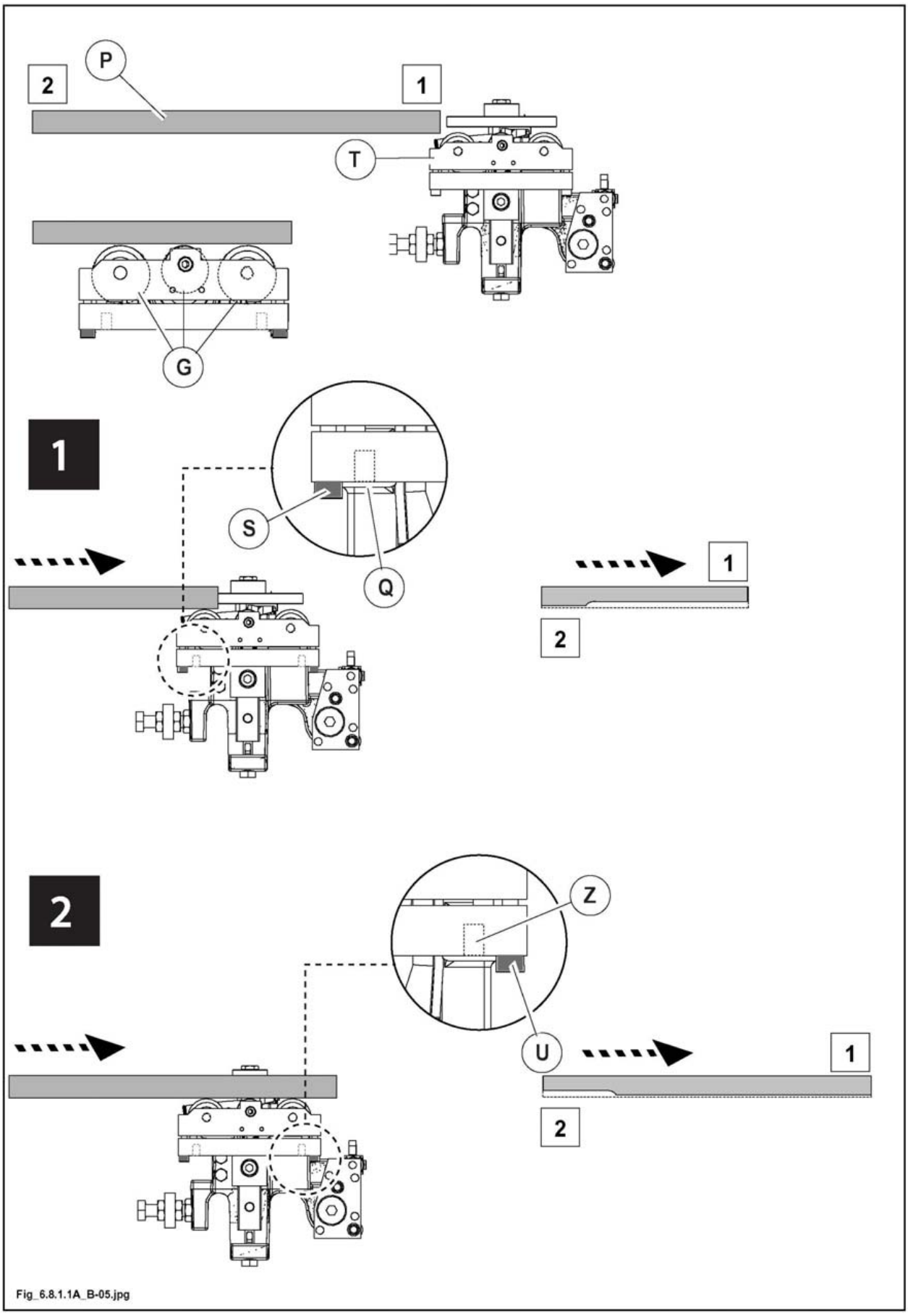


Fig_6.8.1.1A_B-05.jpg

6.9 BRUSHES UNIT ADJUSTMENT

(me25_6-9_0.0)

OPT

The pressure of the brushes on the panel must be adjusted if their intervention is insufficient or excessive or if they are worn.

The brushes polish and clean the edging from any machining residue.

UPPER BRUSH
- To increase and decrease the upper brush angle on the workpiece, loosen lever A and use the support B (turn clockwise to reduce; turn anti-clockwise to increase).

Once the adjustment is complete block lever A.

LOWER BRUSH
- To increase or decrease the angle of the lower brush on the piece loosen the lever D and act on the knob V (turn clockwise to reduce; turn anti-clockwise to increase).

Once the adjustment is complete block lever D.

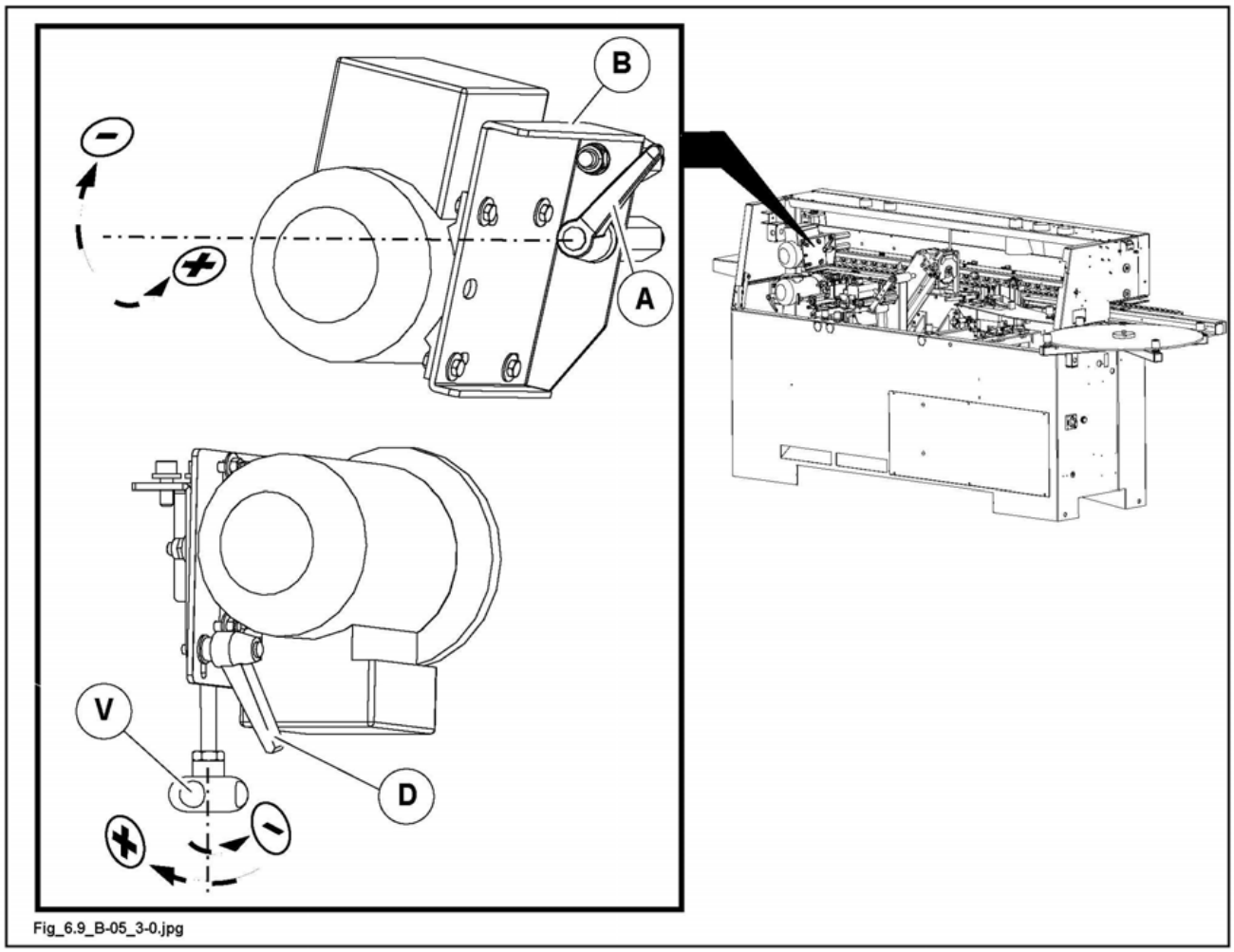


Fig_6.9_B-05_3-0.jpg

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(vuota002)

6.10 ADJUSTING THE AMOUNT OF GLUE ON THE PANEL

(me25_6-10_0.0)

- Make sure that no panels are being machined
- Stop the machine by pressing 

ONLY after (20 sec.) having pressed  can the cowling (C) be opened (motors stopped).

GLUE TANK LOADING



DANGER-WARNING:
Always use gloves in order to prevent burns.
Perform reloading operations with a maximum temperature of ~ 50°. Check the temperature on the programmer display.

- Open the cover F and load the glue.
- Close the cover F
- Close the cowling C.



NOTE-INFORMATION:
Always check the amount of glue in the tank before starting work.

Use EVA glue which melts when heated
DO NOT use POLYURETHANE GLUE.
When the machine use is extended, the glue must be supplied in order to influence on the thermal equilibrium of the melted glue as less as possible.
We recommend filling up frequently with small amounts of glue. In case of machine stop, to ensure that the glue is still still, press the "stand-by" icon (R).
Furthermore, the machine is fitted with an additional automatic glue protection system. After a certain time of machine stoppage, the protection system keeps the glue tank warm ("Stand-by temperature"), ready to be activated (see Par. 3.4 "Glue parameters" of the attached ELECTRONIC CONTROL manual).

GLUE DOSING ON PANEL ADJUSTMENT

The glue is applied to the panel to be edge banded using roller A.
Adjust the amount of glue according to the density of the wood (increase the amount of glue for increased porosity of the surface to be edge banded).

- TO INCREASE the amount of glue applied to the panel:
- loosen the nuts B and D
- unscrew the screw D1
- Tighten the screw B1 on the lever R
- tighten the nuts B and D

- TO DECREASE the amount of glue applied to the panel:
- loosen the nuts B and D
- Unscrew the screw B1
- Tighten the screw D1 on the lever R
- tighten the nuts B and D

- Close the cowling C.

Start the machine again and make sure the result is satisfactory; if necessary repeat the operation.

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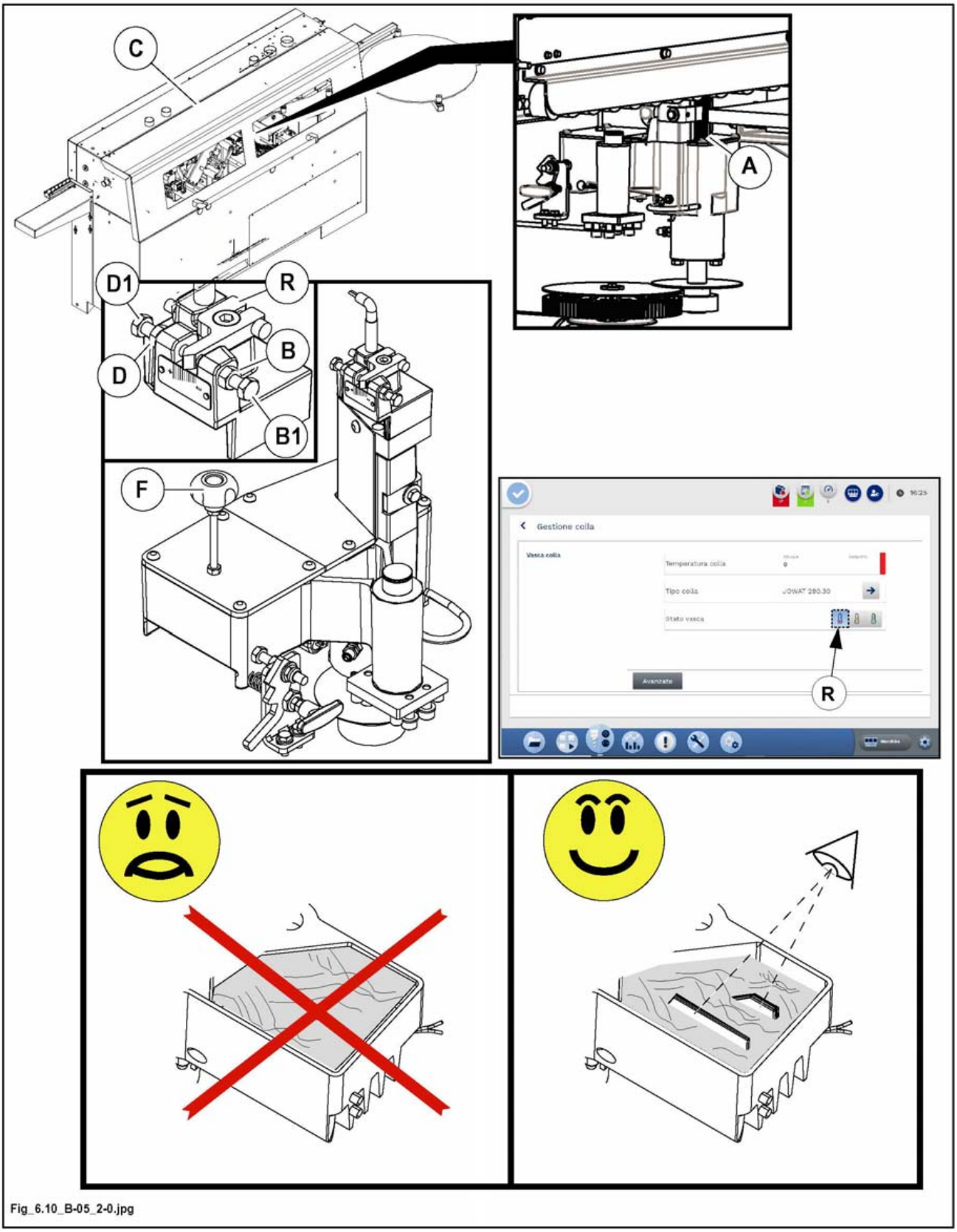


Fig_6.10_B-05_2-0.jpg

NOTE-INFORMATION:
the environmental humidity conditions can affect the behaviour of the glue, as well as the brand of the product used.

NOTE-INFORMATION:
the temperature shown on the display on the control panel is the one of the glue inside the tank.

The temperature of the glue shown on the display can differ from reality for about +/- 5%.

When some long panels are machined, some differences can be seen on the value of the temperature shown.

At first switch on, after a long period of stop, after the glue has achieved the temperature set, it is better to wait some minutes before starting a new working cycle.

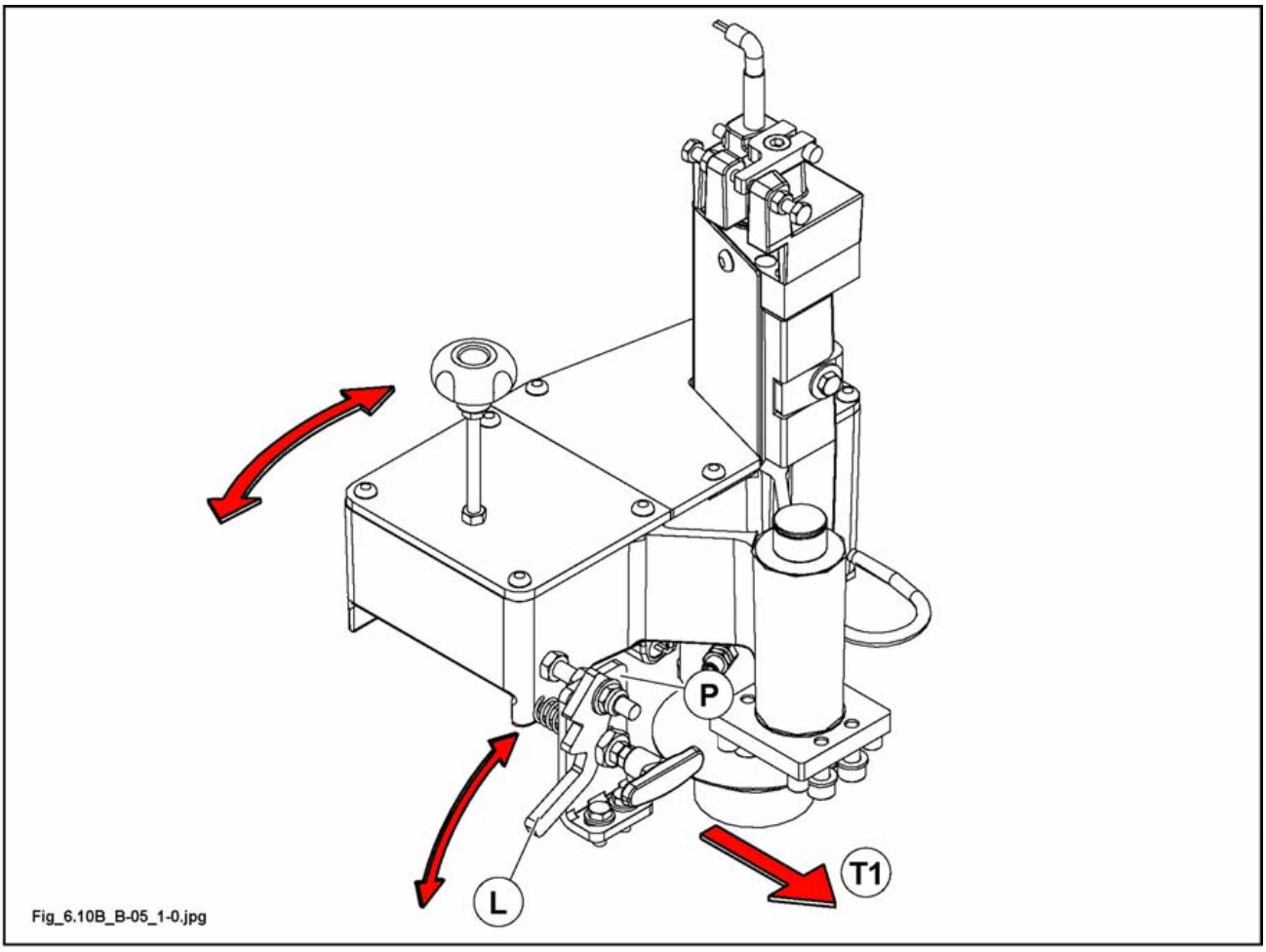
NOTE-INFORMATION:
Follow the stop procedure indicated in Par. 5.5.
In normal working conditions,in order to stop temporarily your work, NEVER use the emergency push-button to stop the machine.
In this way the glue heating function is not stopped, thus maintaining a more stable and unvarying temperature.
It is good not to change too often or too shortly the set temperature. This allows the glue to achieve and maintain a stable temperature level.

After modifying the glue temperature value and after the display has shown the new set value, wait for some minutes before starting the edge banding.

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UNIT EXCLUSION
Pull the unit in the direction indicated T1 until the lever L hooks the bracket P.

GROUP INSERTION
Pull the unit in the direction indicated T1 until the lever L releases the bracket P; then release.



MACHINING WITH "GLUE TANK EXCLUSION"

Machining with the GLUE TANK EXCLUSION allows machining without the glue tank in temperature.

The glue tank can be switched off, to simply, for example, rectify the panel.

Proceed as follows:

- press the icon (4) and follow the indications that will appear on the screen.

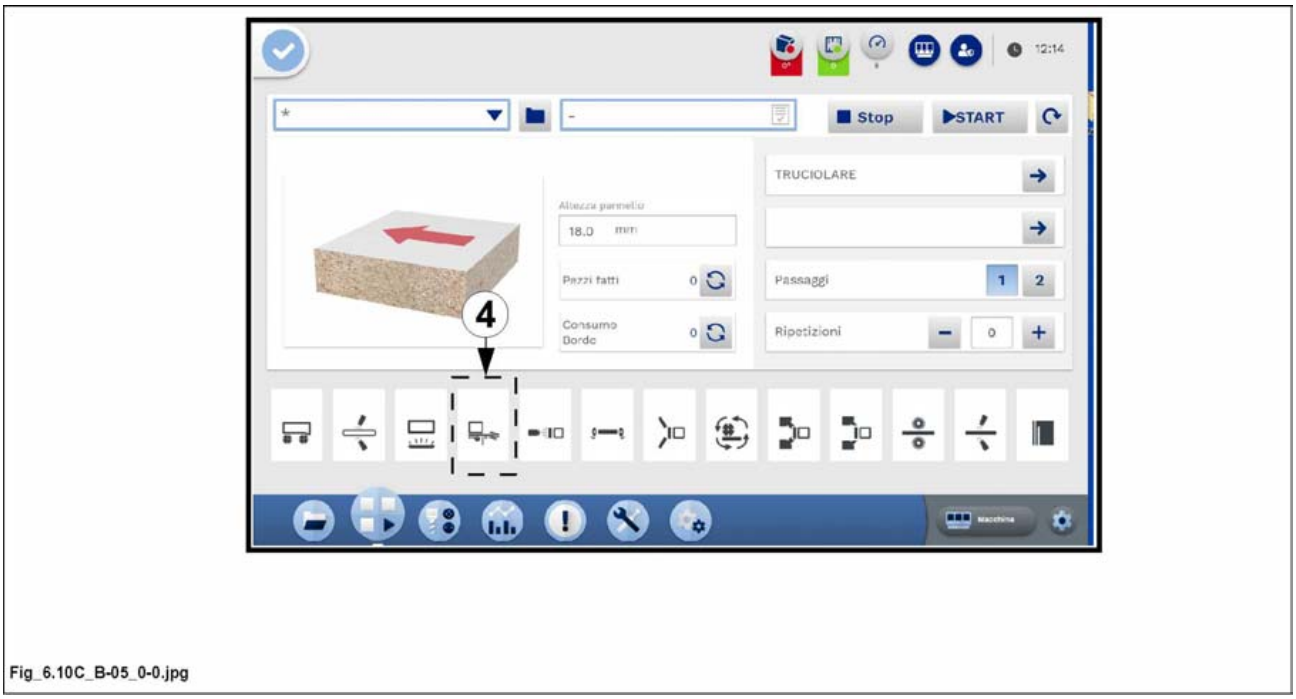


Fig_6.10C_B-05_0-0.jpg

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(vuota003)

6.10.1 GLUING UNIT WITH INTERCHANGEABLE GLUE TANK

(me35_6-10-1_0.0)

OPT

The device allows a quick replacement of the glue tank.

The glue tank test includes the adjustment of the perpendicularity of the glue spreading shaft.
The adjustment remains on the unit so that each time the tank is changed or replaced there is no need for another adjustment.

DANGER-WARNING:
every operation must be carried out by the machine operator or by qualified technicians only.

DANGER-WARNING:
On the programmer display make sure that all machine parts are cold.

Before performing cleaning, maintenance, adjustments, fitting or removing of any machine part, set the main ON/OFF switch to the zero (OFF) position and padlock it off, disconnect the compressed air tube at the filter unit infeed and place a sign indicating this situation on the machine.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

DANGER-WARNING:
Always use gloves in order to prevent burns.

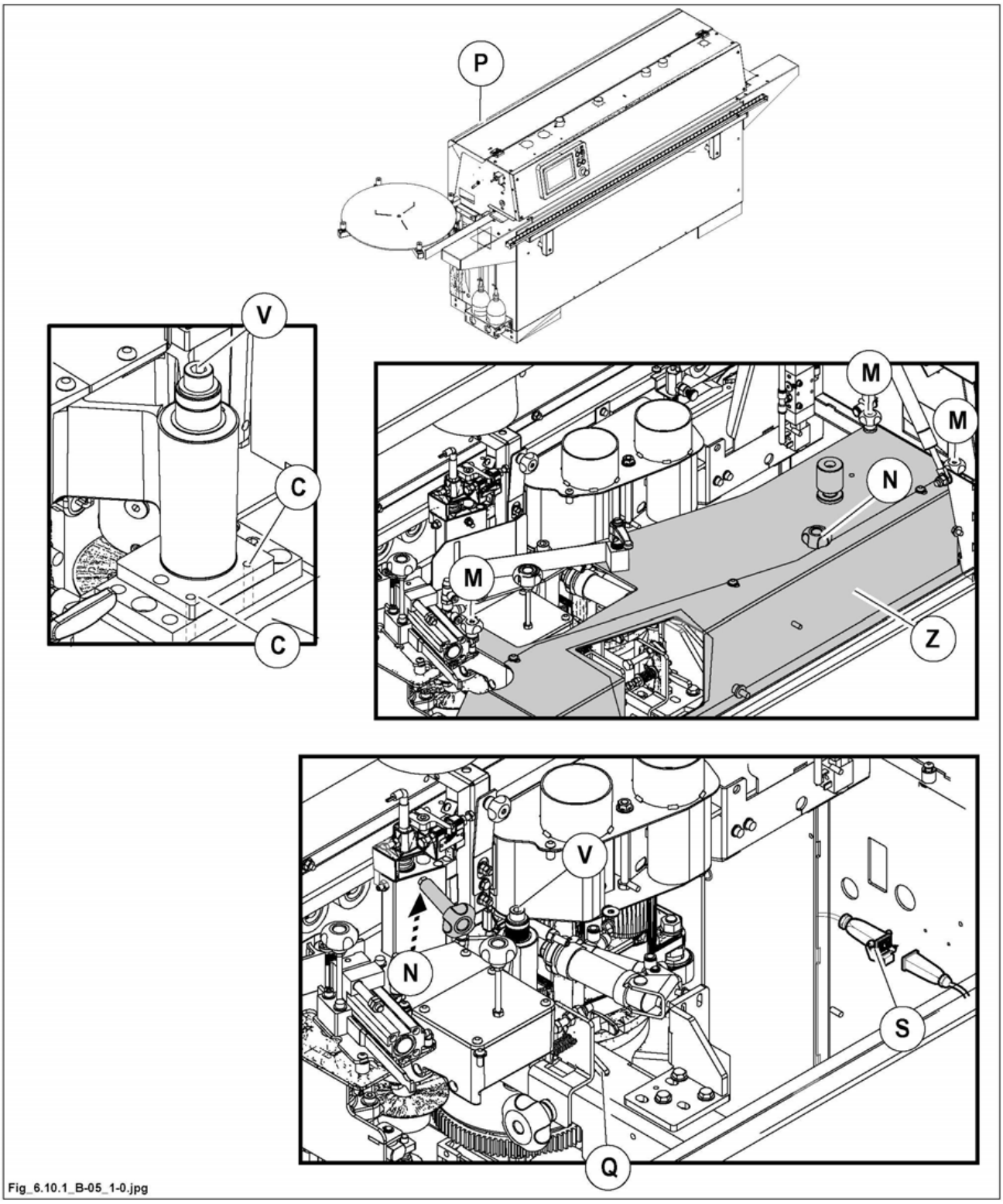
QUICK CHANGE SYSTEM
After a few seconds from the machine stop the protection hood (P) can be opened.
- Unscrew the knobs (M) and remove the sheet metal (Z).
- Release the pin (S) of the glue tank.
- Screw the knob (N) in the position indicated in the figure.
- Loosen the knob (Q) and use the hex wrench in the accessories pack to unscrew completely the screw (V), whilst supporting the tank with the knob (N).
- Use the grip knobs (Q) and (N) remove the glue tank.

After having removed the glue tank, carefully insert the selected tank, making sure that the two pins (C) are in the position shown in the figure.

Repeat the operations described above in reverse to reposition all the parts disassembled correctly.
Restart the machine as described in Chapter 5.

With interchangeable glue tank OPT it is possible to select different heating temperature intervals, as described in Chapter 3 "Equipment Page" of the attached ELECTRONIC CONTROL manual.

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P
V
C
C
M
M
N
M
Z
V
N
S
Q
Fig_6.10.1_B-05_1-0.jpg

6.10.1.1 ADDITIONAL GLUE TANK

(me35_6-10-1-1_0.0)

OPT

Available only on machines fitted with the interchangeable glue tank device OPT.

The device allows for a fast replacement of the glue tank, which is useful when switching the gluing system from EVA to polyurethane (PUR) hot-melt glue OPT, and for maintenance purposes (replacing with the same type of tank).

DANGER-WARNING:
"O": hot surfaces
Always use gloves in order to prevent burns.

The additional glue tank is supplied with the support (S), and the protection grill (P) on which to position the reserve glue tank (R).

NOTE-INFORMATION:
the tank B is supplied with the POLYURETHANE glue tank OPT with quick discharge.

Fix it on protection P as indicated in figure (detail A).

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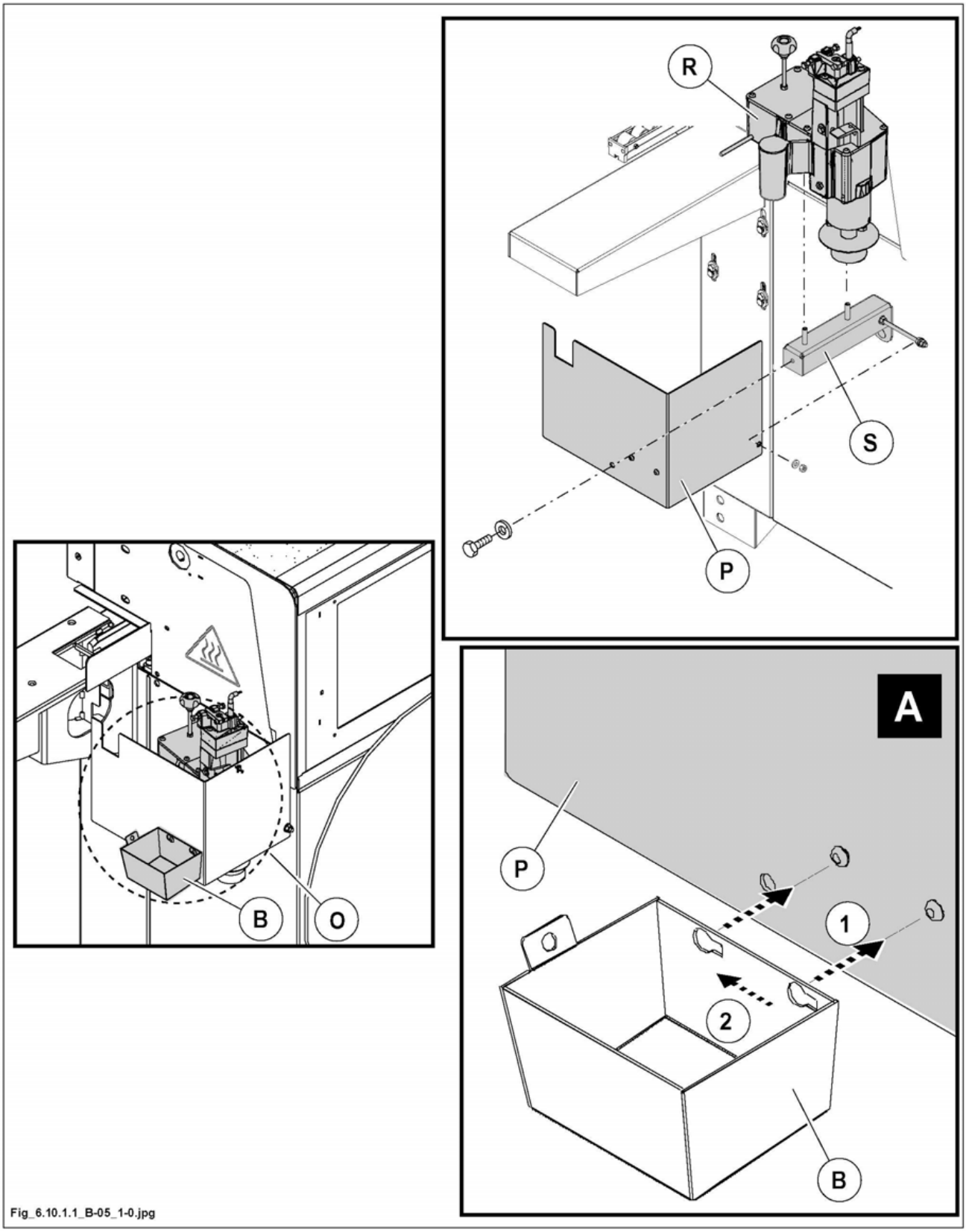


Fig_6.10.1.1_B-05_1-0.jpg

6.10.1.2 GLUE TANK FOR POLYURETHANE GLUE

(me35_6-10-1-2_0.0)

OPT

Available only on machines fitted with the interchangeable glue tank device OPT.

The polyurethane glue PUR must be used at a temperature between 120 /140°C.

NOTE-INFORMATION:
The glue tank must be cleaned with the intervals indicated by the manufacturer of the glue used and each time it is deemed necessary.

DANGER-WARNING:
Clean the glue tank using wooden spatulas.
Not cleaning the glue tank could irreparably damage the gluing device and require its replacement.

To empty the glue tank completely, and change it, proceed as indicated below.

CHANGING THE GLUE

- make sure that the container (B) is installed correctly (operation "1 and 2" of detail A in the figure).
- Heat the glue to the operating temperature (120/140°C).
- Rotate the lever (L) to position (O), in order to open the slit so that the glue can come out of the glue tank (R) .
- Make sure that all the glue has come out (use a wooden spatula to remove all the glue).
- Once all the glue has come out, rotate the lever (L) in position (C) to close the slit.
- Based on the indications of the manufacturer of the glue used, insert a cleaner in the tank, making sure that the glue tank is completely covered.
- Now switch off the machine.

DANGER-WARNING:
to empty the tank (B) make sure that the glue has cooled and solidified, forming a block (solid and cold). Use the grip (M) to disassemble the tank (B) (operation "3 and 4" of detail B in the figure). Now turn over the tank and use a strong blow to knock the residual glue out.

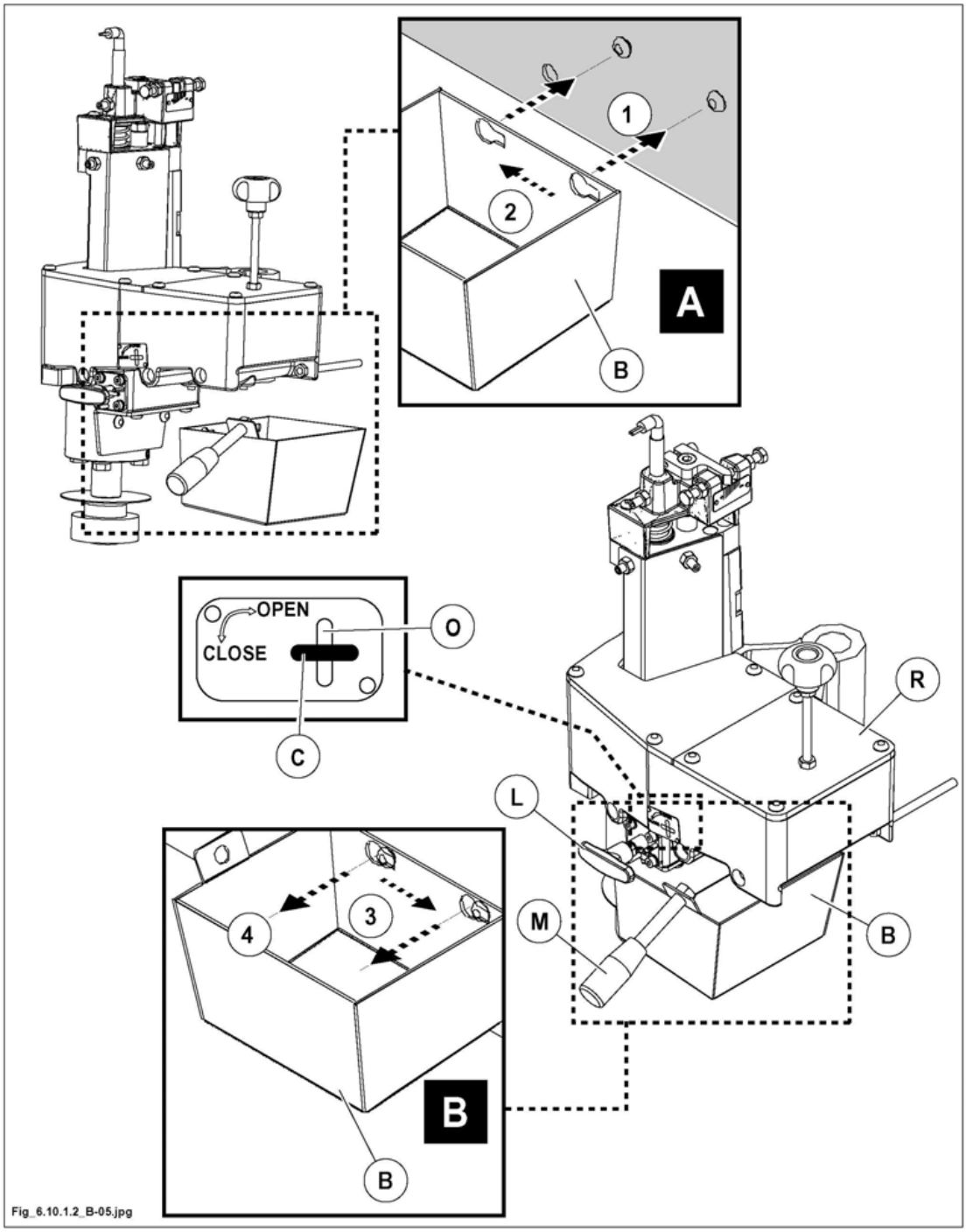
When restarting the machine, complete the glue tank cleaning operation, by following the indications below:

INSERTING NEW GLUE

- Start the machine and bring it to the operating temperature (120/140°C) so that the cleaner is completely melted.
- make sure that the container (B) is installed correctly (operation "1 and 2" of detail A in the figure).
- Rotate the lever (L) to position (O), in order to open the slit so that the cleaner can come out of the glue tank (R) .
- Make sure that all the cleaner has come out (use a wooden spatula to remove all the cleaner).
- Once all the cleaner has come out, rotate the lever (L) in position (C) to close the slit.
- Now insert new polyurethane glue PUR and execute test panels to make sure that the cleaner has disappeared completely.

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DANGER-WARNING:
to empty the tank (B) make sure that the cleaner has cooled and solidified, forming a block (solid and cold). Use the grip (M) to disassemble the tank (B) (operation "3 and 4" of detail B in the figure).
Now turn over the tank and use a strong blow to knock the residual cleaner out.



6.10.A PANEL HEATING PAD

(me35_6-10-a_0.0)

OPT

The panel heating pad unit (T) is located upstream of the gluing unit (G).

It heats the surface of the panel on which the glue will be applied.

NOTE-INFORMATION:
The "panel heating pad" (T) starts only if the glue tank unit (G) is operating.

DANGER-WARNING:
The microswitch (M) acts as the emergency stop device.
If the tow stops and the microswitch (M) is still excited (the work piece is in the pre-heating position), the microswitch cuts off the power supply and sets the machine in emergency.

UNIT EXCLUSION
Machining without pre-heating the edging is made possible thanks to the mechanical exclusion of the device (T).
Use the handle (H) to move the hot surface (S) away from the panel edge (P).

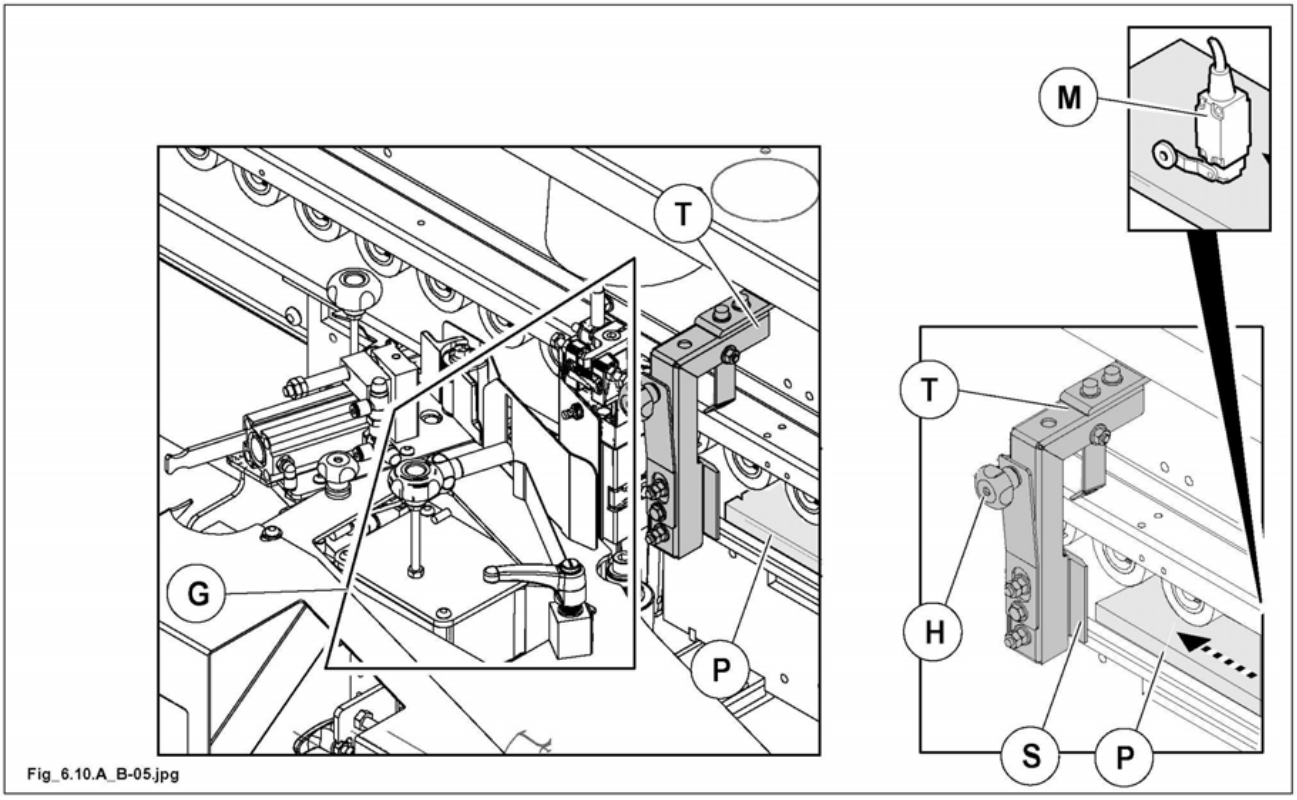


Fig_6.10.A_B-05.jpg

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(vuota_6_00)

6.10.B INFRARED CERAMIC LAMP FOR HEATING THE PANEL EDGE

(me35_6-10-b_1.0)

OPT

It heats the surface of the panel on which the glue will be applied.

Improves the gluing quality in case of low environment temperatures.

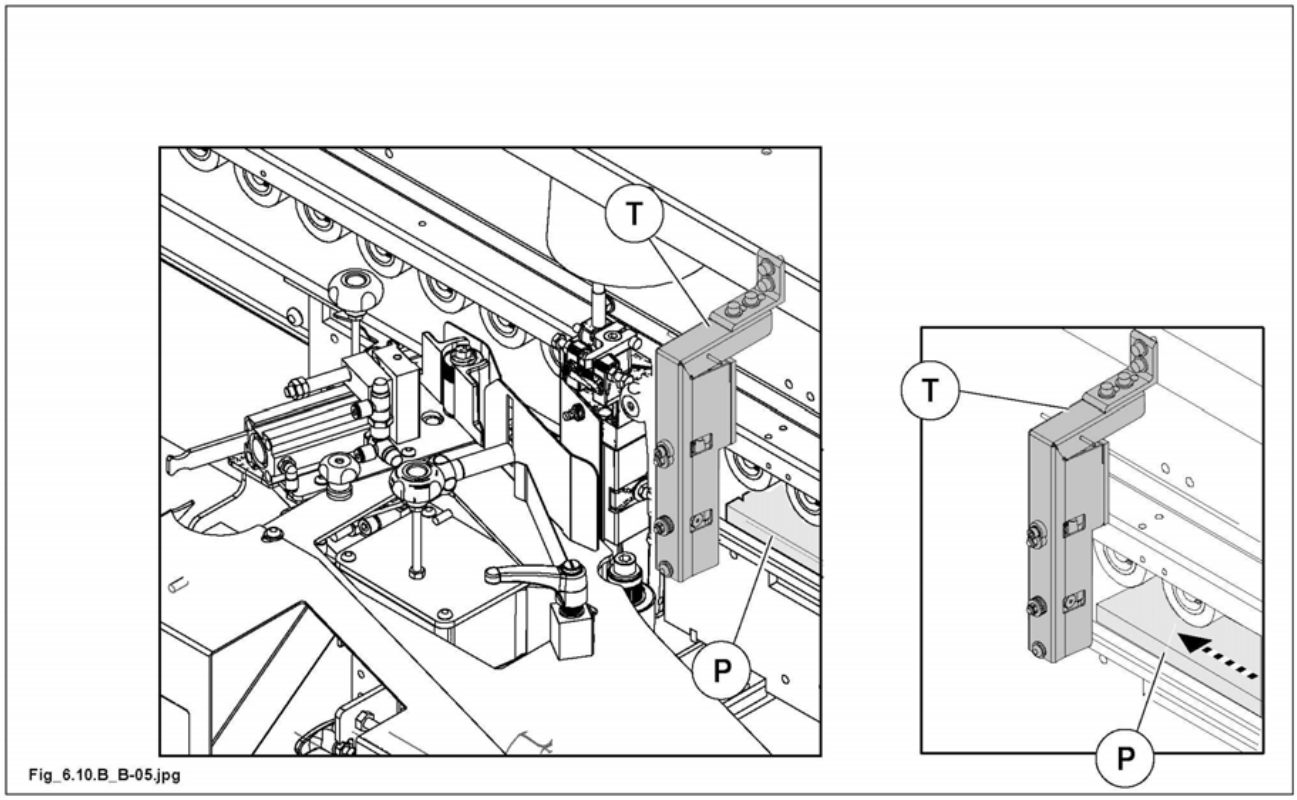


Fig_6.10.B_B-05.jpg

NOTE-INFORMATION:
the IR lamp is guaranteed for a minimum duration of 50,000 cycles (switch on/ switch off).
Any use not described in this manual and/or maintenance carried out incorrectly, void the product warranty.

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OPERATING SEQUENCE

Proceed as follows:
- press the icon (3) to activate / deactivate the infrared lamp "IR" for heating the panel edge.

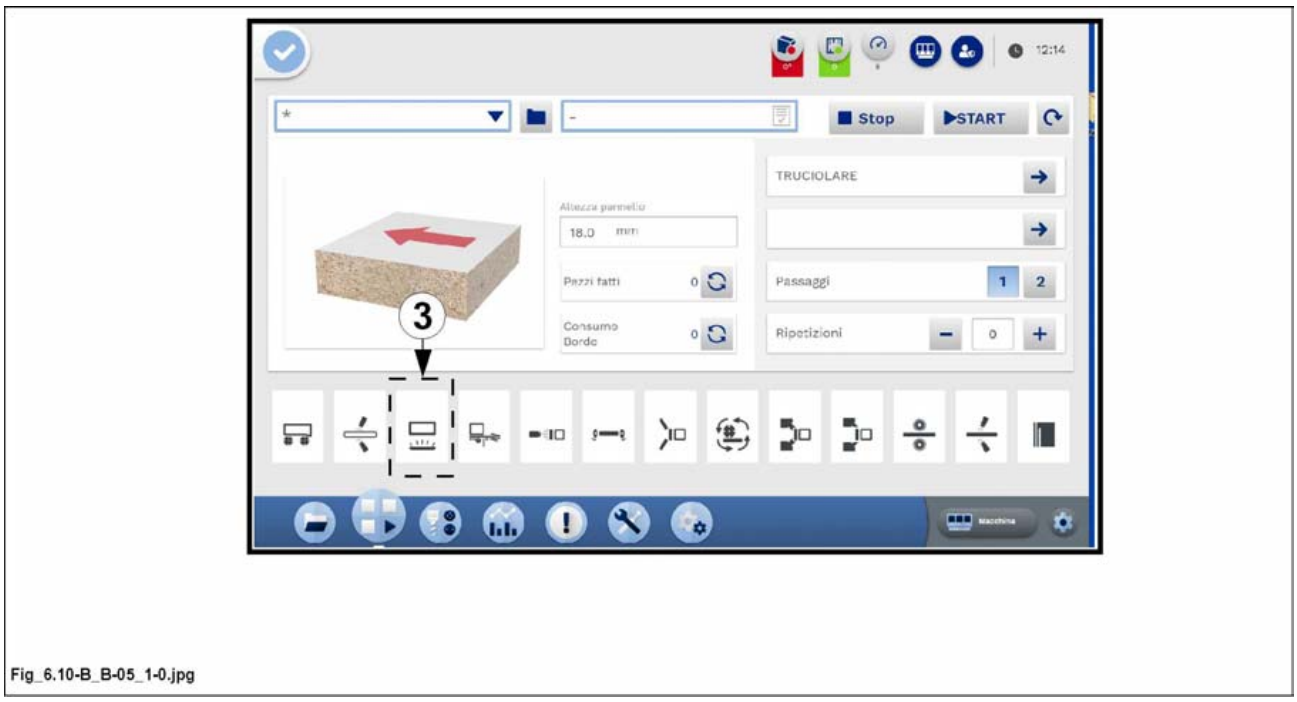


Fig_6.10-B_B-05_1-0.jpg

6.11 RECTIFIER UNIT

(me35_6-11_0.0)

OPT

The rectifier unit (R) is positioned before the gluing unit and trims the edge of the panel to provide a surface that is optimal for the gluing phase.
When necessary select the unit with the pushbutton on the control panel.
The rectifier unit has a fixed preset stroke. Remove or place the spacers on the infeed guide based on the desired stock removal (see Chap. 6.2).

NOTE-INFORMATION:
When the cutters start to splinter the panel being machined remove one spacer (S) to achieve the optimal cutting quality. The second spacer (S) can be removed later.
Once the two spacers have been removed resharpen the worn cutters or replace them with new ones (see Par. 20.10.6).

TOOLS ADJUSTMENT
To adjust the cutters alignment (F) use the grub screws (P) after having loosend the nuts (D).

This operation allows the cutters to be realigned to achieve an optimal cut and is required:
- when the cutters start to wear
- when the cutters wear is uneven
- after sharpening.

Tighten the nut (D) when the adjustment has been made.

NOTE-INFORMATION:
The cutters have been adjusted at the factory during final testing to ensure perfectly linear trimming, without any steps or notches.
Tool wear can lead to misalignment of the cutters. In this case proceed as described above.

To get a quality edge finish, it is good, with the grinding of the edge, to remove a thickness of material equal to the thickness of the edge you want to apply (if the edge thickness = 0.5 mm, remove = 0.5 mm).

DANGER-WARNING:
- ***DO NOT machine panels with metal parts.***
- ***DO NOT exceed the maximum stock removal section 55 mm^2***
- ***DO NOT machine panels thinner than 110 mm***

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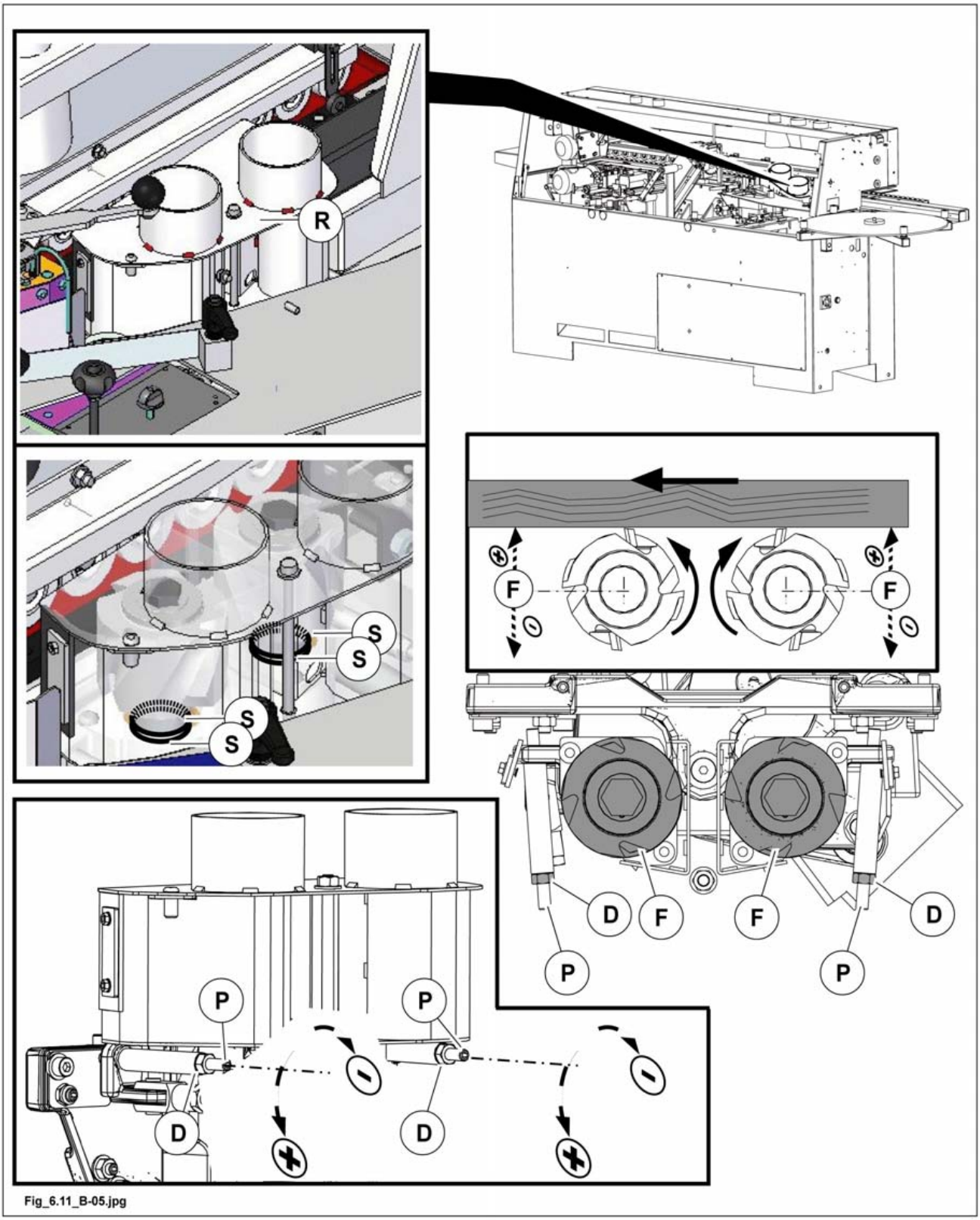


Fig_6.11_B-05.jpg

6.11.A SELF ADHESIVE LIQUID UNIT

(me35_6-11-a_0.0)

OPT

The unit is located upstream of the gluing unit.

The anti-sticking unit sprays "RIEPE-LPZ-II" liquid on the upper and lower surface of the panel.
Ensures that the glue does not stick to the upper and lower surfaces of the panel.

It consists of the following main parts:

- Tank (1) of the liquid for the lower nozzle (at the machine infeed)
- Tank (2) of the liquid for the upper nozzle (at the machine infeed)
- Pressure regulator (3) (3 BAR)
- Pressure gauge (M)
- Lower nozzle (4), operates on the lower panel surface
- Lower nozzle flow regulator (L)
- Upper nozzle (5), operates on the upper panel surface
- Upper nozzle flow regulator (U)

NOTE-INFORMATION:
press the icon (A) to activate / deactivate the Anti-Adhesive Unit.

NOTE-INFORMATION:
The spraying device starts only if the rectifier unit is operating.

LIQUID ADJUSTMENT
For adjustment of the self-adhesive liquid, act on (U, L).

Unit cleaning
Every 8 work hours and whenever else it is necessary, remove dust and shavings from the unit using a vacuum cleaner with a suitably shaped nozzle.
Complete the cleaning process using a dry cloth

DANGER-WARNING:
The disposal of the "RIEPE-LPZ-II" liquid residues must be compulsorily carried out in compliance with the applicable standards concerning safety and environmental protection (s. safety data sheet).

Resetting the "RIEPE-LPZ-II" liquid level
The tanks must be replaced. Proceed as follows:
- remove the cap, complete with infeed pipe, from the empty tank;
- screw the cap on the new tank.

DANGER-WARNING:
Storage, use and disposal of the "RIEPE-LPZ-II" liquid must be carried out in compliance with the applicable standards concerning safety and environmental protection (s. safety data sheet).

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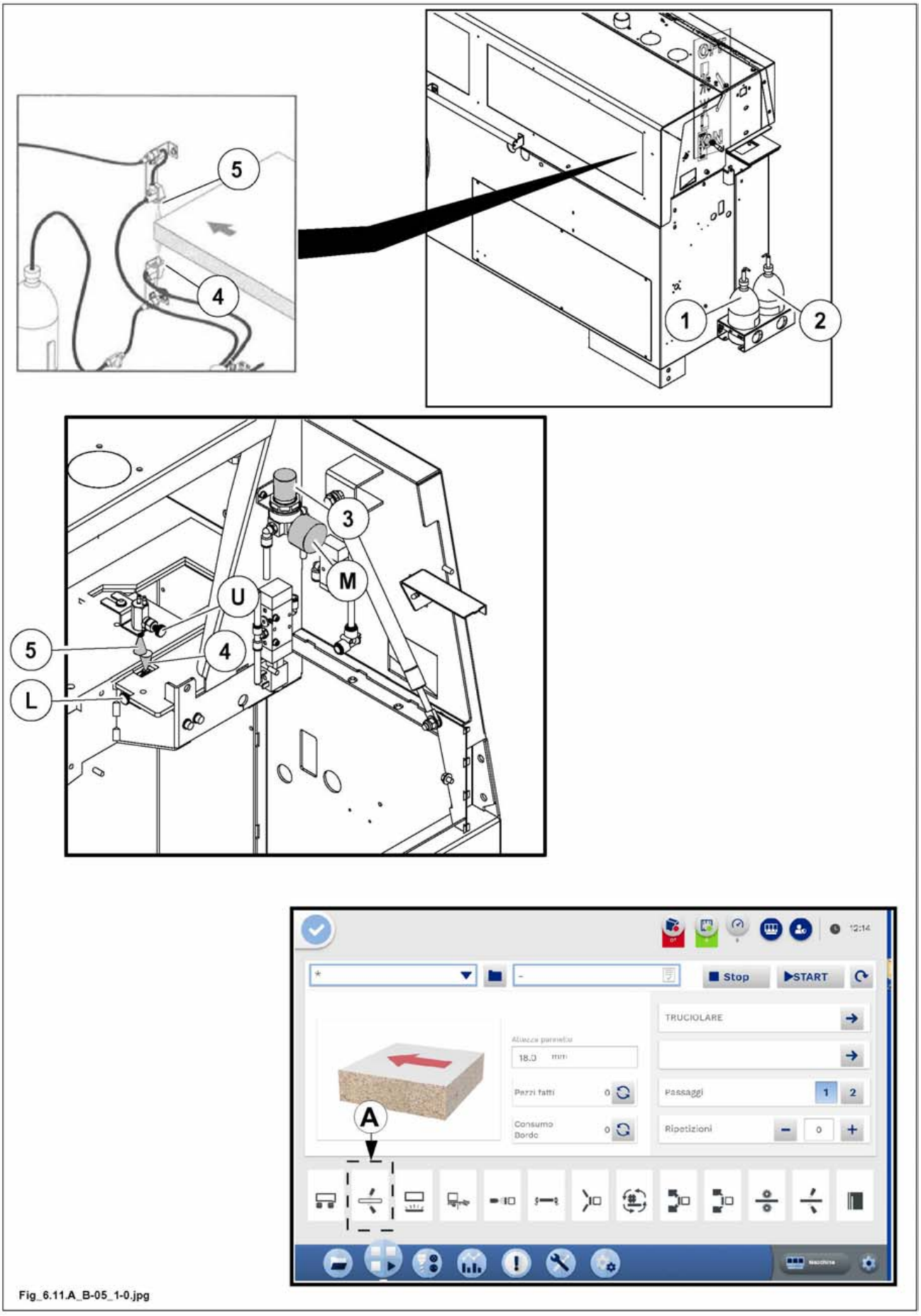


Fig_6.11.A_B-05_1-0.jpg

Fig. 6.11.A

EURO Safety Data Sheet

Product name: Release agent Riepe-LPZ/II® for adhesive
Product No.: 001
Issue: September 2007

1. Substance / Preparation and Company Description

A special oil dissolved in a mixture of aliphatic hydrocarbons / Ethanol

Manufacturer / Supplier Information

Manufacturer / Supplier:	Riepe GmbH & Co. KG		
Street Adress / PO Box:	Postfach 2624		
Country ID / City, State / Zip Code:	D-32226 Bünde		
Phone:	(+49 52 23) 6 09 90 u. 6 13 33		
Area providing information:	Laboratory	**Phone:**	(+49 52 23) 6 09 90
Emergency Information:	Poison Control Center Bonn	**Phone:**	(+49 2 28) 2 87 32 11
		Telefax:	(+49 2 28) 2 87 33 14

2. Possible Dangers during Preparation

Hazard designation: F = Easily flammable
Special hazard warnings for humans and the environment
R11= Easily flammable S16 = Keep away from sources of ignition – no smoking

3. Composition / Component Information

Chemical characterization: Mixture of aliphatic hydrocarbons/Ethanol
Hazardous components:

CAS-No.	Designation acc. to EEC Directive	Content	Unit	Characteristic letter	R-Codes
64-17-5	Ethanol EINECS: 200-578-6	> 85	%	F	R 11

Note:
The danger notes listed here are explained in greater detail in Chapter 15.
(Comment P of the EC-Material list / Annex I of Directive 67/548/EEA)

4. First Aid Measures

Note: In case of eye contact, rinse with clean, running water and seek medical attention, If swallowed, consult a doctor immediately. Keep victim calm. Do not induce vomiting. Drink water with activated carbon.

5. Measures in Case of Fire

Suitable extinguishing agents: Foam (alcohol-resistant), carbon dioxide, powder

6. Measures in Case of Accidental Release

Person-related safety measures: Keep away from sources of ignition, ensure free circulation of air.
Environmental protection measures: Do not allow to escape into the sewage system.
Procedure for cleaning / adsorption: Confine leaked material with fire-proof absorbent agent, e. g. sand, soil, diatomite, vermiculite and collect in the containers provided for removal according to local regulations.

7. Handling and Storage

Avoid exceeding the MAK limit values and keep the product stored in the original drums at all times.
Fire and explosion protection: Keep away from sources of ignition – no smoking. Take measures to prevent electrostatic charging.
Storage: Keep it away from direct sunlight and other sources of heat and ignition.
Store it in firmly-sealed, cool, dry drums.
Storage rooms and containers: Comply with the laws and regulations governing the storage and use of materials which are hazardous to water.
Instructions on storing materials together:
Comply with the instructions in the Flammable Liquids Decree (VbF), keep the containers firmly sealed, store it in firmly-sealed, cool, dry drums. Comply with the VbF regulations and the TRbF technical rules associated with it.
Storage class: 3 A (VCI-concept, 1998)
Classification in accordance with the Industrial safety regulation (BetrSichV): easily flammable

8. Limitation of exposure and personal protectiv equipment

Technical Security Measures:
Avoid exceeding MAK values
Components with workplace-related limit values to be monitored:

CAS-Nr.	Description	Type	Value	Unit
64-17-5	Ethanol	MAK	980	mg/cbm

The values specified are taken from the lists that were valid at the time this safety data sheet was created (e. g. TRGS 900 for the Federal Republic of Germany).

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Product name: Release agent Riepe-LPZ/II® for adhesive
Product No.: 001
Issue: September 2007

Personal protective equipment:
General protective and sanitary measures: Wash hands before breaks and at the end of work. Avoid touching the eyes and skin. Do not inhale vapors. Remove soiled, saturated clothing immediately. Keep away from beverages, food and animal feed.
Breathing protection: Breathing protection required when ventilation/evacuation is inadequate
Hand protection: Protective gloves made from butyl or fluorine rubber (Viton) which can resist solvents
Eye protection: Airtight protective goggles
Body protection: Standard protective work clothing, chemical-resistant safety shoes or boots. If skin contact is likely to occur, wear protective clothing that is impermeable for this solution.

9. Physical and Chemical Properties

Form: liquid | **Colour:** colourless | **Smell:** alkohol like

		Value:	Unit:	Method:
Flashpoint:		< 21	°C	DIN 53213
Ignition temperature:		425	°C	DIN 51794 for pure Ethanol
Selfignitability:		non selfignitable		DIN 51794 for pure Ethanol
Viscosity:	at 20°C	1,19	mPas	
Density:	at 20°C	0,790	g/cbcm	DIN 51757
Vapour pressure:	at 20°C	59	mbar	
Lower ex-limit:		3,5	Vol. %	Literature values
Upper ex-limit:		15,0	Vol. %	Literature values
Solubility in water:		partly soluble		
Solvent concentration:		approx. 90 organic solvents	%	

10. Stability and Reactivity
When the recommended regulations on storage and handling are applied, no dangerous decomposition products can be produced.

11. Information on Toxicology
Slightly irritating, has an astringent effect on the skin. Vapors in high concentrations can cause drowsiness.

12. Information on Ecology
The product is slightly hazardous to waters - Water hazard class 1. Due to the rapid evaporation from the solution and from water surfaces, the product does not represent a significant threat to aquatic life. Must not enter the ground water, bodies of water or the sewage system.

13. Instruction for Disposal
Must not be disposed of with the household garbage. Do not allow to escape into the sewage system. If possible, take to recycling. Otherwise, burn or dump at an approved facility. Since January 1, 1999, most waste code numbers relate to application as well as the product. The waste code number valid for this application is listed in the European Waste Catalogue. Dispose of uncleaned packaging in accordance with official regulations.

14. Information on Transport
Transport only in accordance with transport regulations for street (ADR) and rail (RID)
Land transport ADR / RID and GGVS/GGVE (transnational/domestic)

ADR / RID-GGVS/E Cl. 3	**F1 Flammable fluids**
Number/Letter:	**F1 II**
Number of danger designation (Kemler-Number):	33
UN-Number:	1170
Packaging group:	II
Label:	3
Proper Shipping Name:	ETHANOL-Solution

Transport by sea IMDG/GGVSee		**Transport by Air ICAO-TI and IATA-DGR**	
IMDG/GGVSee-Cl.:	3	**ICAO/IATA-Cl.:**	3
UN-Number:	1170	**UN/ID-Number:**	1170
Label:	3	**Label:**	3
Packaging Group:	II	**Packaging Group:**	II
EMS-Number:	F-E, S-D		
Proper Shipping Name:	ETHANOL-Solution	**Proper Shipping Name:**	ETHANOL-Solution

15. Regulations:
Designation according to the Ordinance on Hazardous Substances
Identifier and hazard designation of the product:
F = easily flammable
R-Sets:
R11 = easily flammable
S-Sets:
S16 = keep away from sources of ignition – no smoking
Information according to the Water Resources Act: Water hazard class: WGK 1 (low hazard to water)
Statutory order on hazardous incidents: Substance group 2 (F = easily flammable liquid)

16. Additional Information:
The information is correct to the best of our knowledge but should not be taken as a warranty of specific product characteristics and does not represent a contractually-binding relationship.

6.12 GLUESCRAPER UNIT

(me35_6-12_0.0)

OPT

This unit, used to remove any glue residue to clean the panel perfectly, consists of an upper 1 and lower 2 gluescraper.
The unit consists of 2 small scraping knives C in widia and 2 feelers F.
The knife is fitted on a support complete with a blower device used to clean glue residue from the knives.

The track feelers F are rolling, consisting of non-adjustable fixed wheels. The glue removal is adjusted with the tools.

GLUESCRAPER UNIT ADJUSTMENT

NOTE-INFORMATION:
The removal is adjusted at the factory and does not require any further adjustments; adjustment is delicate, so only intervene if you are sure that the malfunction is due to the GLUE SCRAPER UNIT (first check all the faults listed in chapter 20).

1 Upper tool adjustment

- Loosen the screw A.
- Act on the knob H to modify removal:
- Turn clockwise to reduce the amount of material removed.
- Turn anti-clockwise to increase the amount of material removed.
- Tighten the screw A.

2 Lower tool adjustment

- Loosen the screw B.
- Act on the knob J to modify removal:
- Turn clockwise to reduce the amount of material removed.
- Turn anti-clockwise to increase the amount of material removed.
- Tighten the screw B.

KNIVES ADJUSTMENT

DANGER-WARNING:
handle the tools with protective gloves.

The knife can be used on all four sides. When the knife is worn:
- undo the screw E
- turn the knife C
- re-tighten the screw E.

CAUTION:

When machining panels from the "Nesting" production cycle the LOWER GLUE SCRAPER 2 must always be excluded (as indicated below).

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Both units can be excluded.

1 *Upper Feeler*

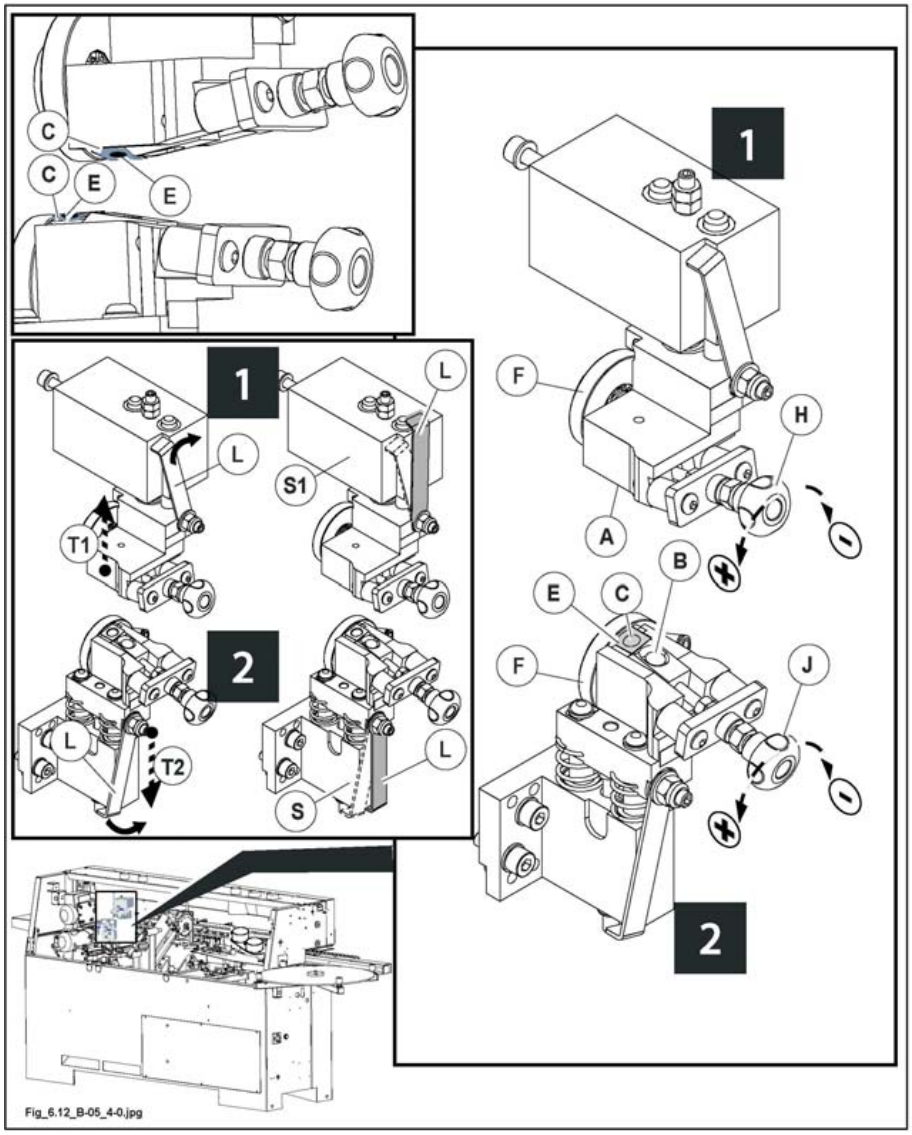
UNIT EXCLUSION
Push the unit in the direction indicated T1 until the lever L hooks the support S1.

GROUP INSERTION
To insert the unit release the lever L from the support S1.

2 *Lower Feeler*

UNIT EXCLUSION
Push the unit in the direction indicated T2 until the lever L hooks the support S.

GROUP INSERTION
To insert the unit release the lever L from the support S.



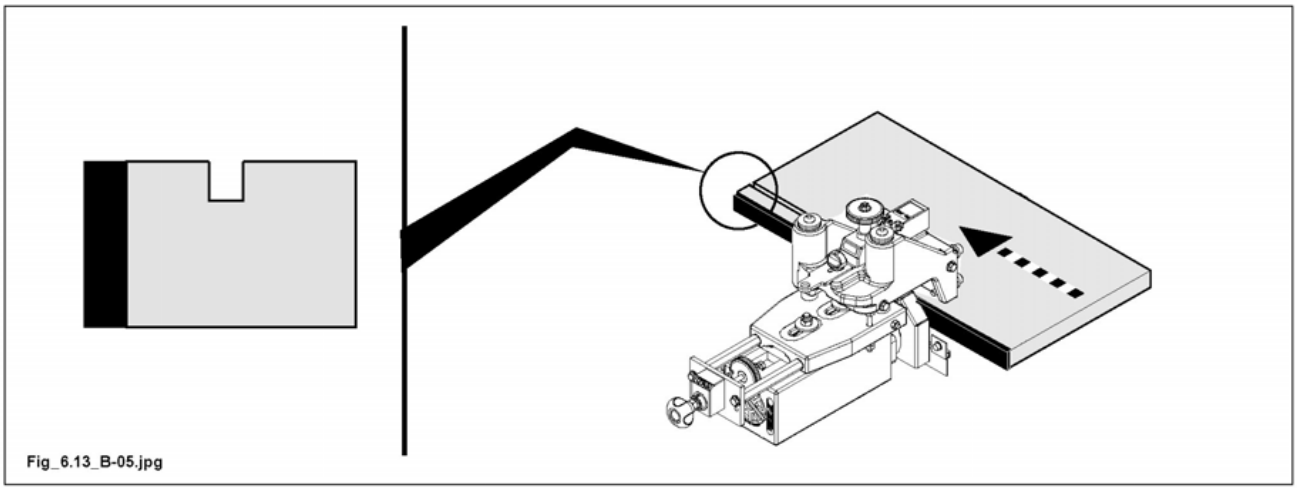
6.13 GROOVES UNIT

(me35_6-13_0.0)

OPT

DANGER-WARNING:
during machining the unit is protected by the cabin; moreover the cabin is fitted with a device that prevents the opening before a set time has elapsed from the stop command.
When the cabin is open, the unit cannot be operated.

This device creates a longitudinal groove for the complete length of the panel.



NOTE-INFORMATION:
The unit is registered to make grooves on up to 12 mm thick panels.

DANGER-WARNING:
We recommend to use table extensions (not supplied by SCM***) at entry and exit side in case of panels longer than***
- Max. length 1000 mm
- Max. width 600 mm

NOTE-INFORMATION:
press the icon (13) to enable / disable the Cave Group machining (the "L" screen will appear).

NOTE-INFORMATION:
the cave group does not switch on/off with any of the keys on the control panel.
Its INCLUSION or its EXCLUSION from the machining process can only be done manually, as described below.

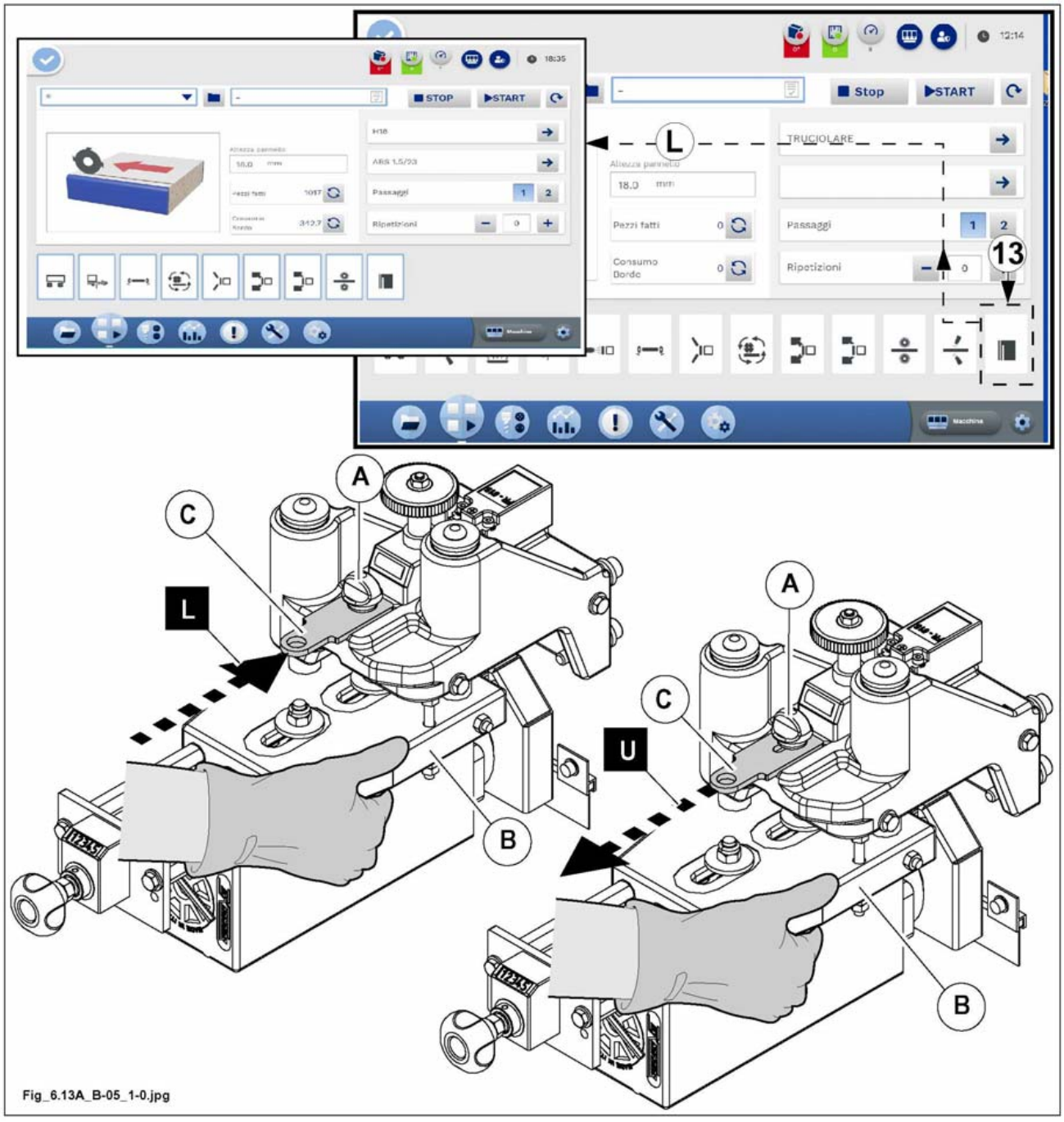
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UNIT EXCLUSION

- loosen the knob A
- lift the B support and move the sheet C in the direction indicated from the arrow L
- block the knob A
  Now the unit is excluded.

UNIT INCLUSION

- loosen the knob A
- hold the grooves unit with a hand, move the sheet C in the direction indicated from the arrow U and lower the support B.
- block the knob A.
  Now the unit is included.



6.13.1 GROOVES UNIT ADJUSTMENT

(me35_6-13-1_0.0)

The grooves unit needs two adjustments:
(Y) - groove depth
(X) - position of the cave as regards the edge of the panel.

(Y) - Groove depth

- Turn the knob D anti-clockwise to increase the groove depth, clockwise to reduce the depth (Y value indicated in the figure).
- The groove depth value is indicated on the numerical indicator E.

Example:
if on the indicator E you read 008.0, the groove depth (Y quota) will be 8 mm.

NOTE-INFORMATION:
the maximum groove depth is 8 mm (value corresponding to Y).

(X) - position of the cave as regards the edge of the panel.

- Loosen the ring nut F and turn the knob G clockwise to reduce the distance from the edge; turn the knob G anti-clockwise to increase the distance from the edge.
- The distance from the groove value from the panel edge (X quota) is indicated on the numerical indicator H.

Example:
if on the indicator you read 0010.0, the groove distance from the edge of the panel(Y quota) will be 10 mm.

NOTE-INFORMATION:
the maximum blade movement allowed from the edge of the panel is 16 mm (value corresponding to X).

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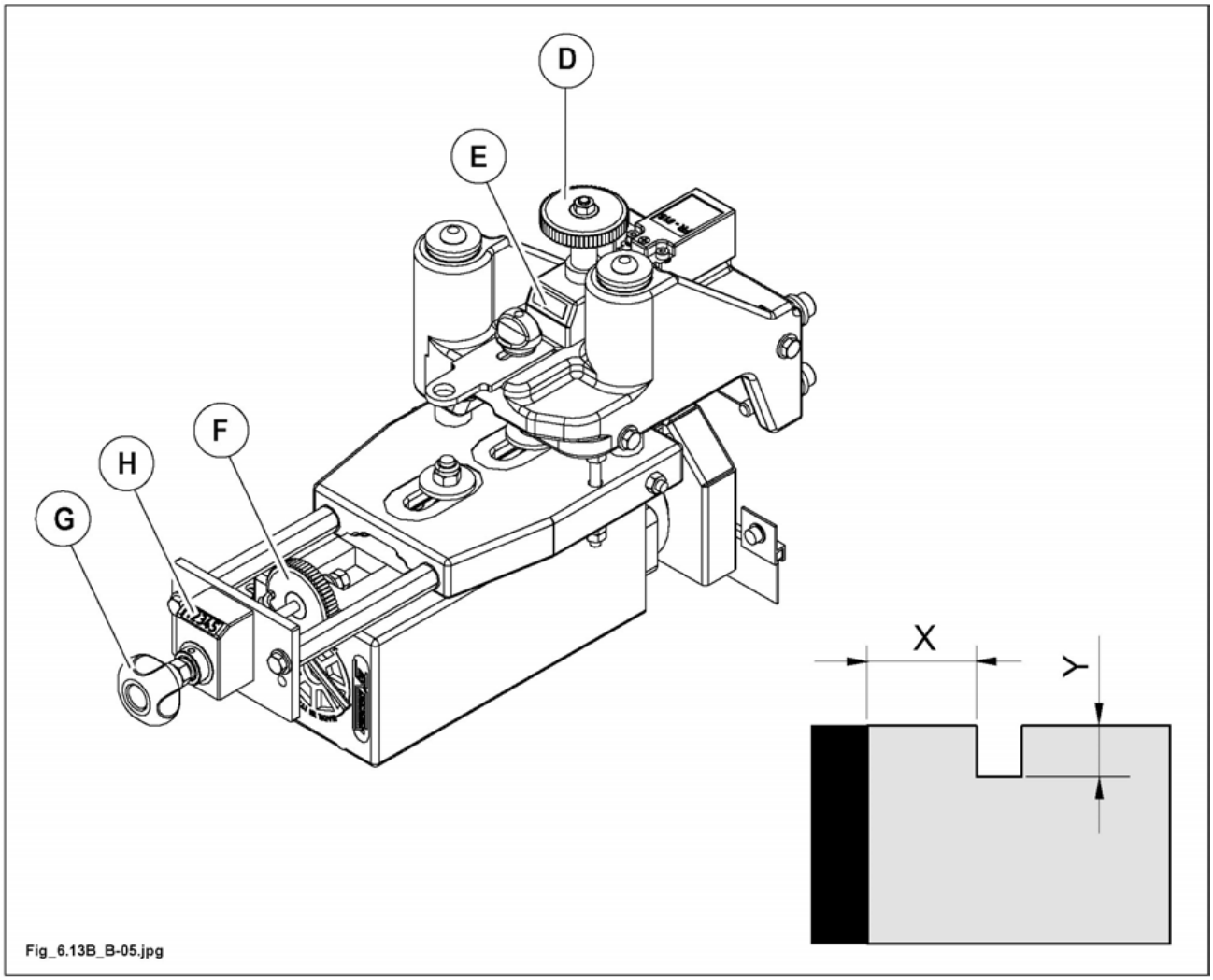


Fig_6.13B_B-05.jpg

6.15 PREPARING AND USING THE MACHINE

(me25_6-15_0.0)

6.15.1 PREPARING THE MACHINE

(me25_6-15-1_0.0)

EDGING STRIP OR WOODEN STRIP
- Check that the height and type of edging is suitable for the panel to be processed.
- Fit the edging strip or strip of wood and make the adjustments (Sec. 6.3).

INFEED GUIDE
- Adjust the infeed guide based on the thicknees being removed with the rectifier (OPT) (See chap. 6.2).

ADJUSTING THE ROLLERS
- Adjust the presser rollers according to the thickness of the utilised edging (See. 6.5).

ADJUSTING THE TRIMMERS
- Adjust the depth of the trimmers using the knobs E depending on the thickness of the edging. Consult the table next to the number readouts (Sec. 6.7).

EDGE SCRAPER UNIT ADJUSTMENT
- If necessary activate the edge scraper unit (OPT) (See chap. 6.8).

BRUSH ADJUSTMENT
- Adjust the brushes (OPT) (See chap. 6.9).

ADJUSTING THE FEED UNIT HEIGHT
- Regulate the height of the feeder until the indicator C displays the same measurement of the thickness as the panel to be edged (the black numbers correspond to millimetres, while the red ones correspond to tenths of millimetres) (See chap. 6.4).

GLUESCRAPER UNIT ADJUSTMENT
- Activate, if necessary, the gluescraper unit (OPT) (See chap. 6.12).

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6.15.2 USING THE MACHINE

(me25_6-15-2_0.0)

- Check the level of glue in the tank.

- Close the machine door.

- Set the PLC based on the type of processing and start the machine (Sec. 5)

- Wait for the glue to reach its temperature.

NOTE-INFORMATION:
The machine will not work until the glue reaches the temperature set.

NOTE-INFORMATION:
work at an ambient temperature NO lower than 18 °C (32.4 °F).

- Adjust the quantity of glue.
- Send the panel against the infeed fence and accompany it on the feed track, keeping it against the fence.
- The machine feeds the workpiece automatically and applies the edging as indicated.
  The rectifier unit (OPT) is positioned before the gluing unit and trims the edge of the panel to provide an optimal surface for the gluing phase.
- The panel pushed by hte feeder lowers the micro switch R that controls the intervention of the rectifier.
- The panel pushed by the feeder lowers the micro switch R that controls the intervention of the rectifier.
- The panel is glued with the edging in point B.
- The panel passes the presser rolls unit G, which hold the edge pressed to the panel, and goes into contact with the feeler H , which leads the end trimming unit to perform its task at the front and then at the rear.
- The rectifier unit P is regulated automatically based on the height of the panel with the feelers N and removes the upper and lower excess part of the edging.
- When the panel releases the micro switch (1), the shears cut the edge.
- When the panel releases the micro switch (2), the end trimmer follows the panel and performs the cut.
- The panel passes through the edge scraper unit which, when required, automatically self-adjusts to panel thickness. The edge scraper can be excluded if edges with the same plate radius are not carried out.

- Where applicable, the brushes automatically self-adjust to panel height. They can be excluded via the relative command.

- The gluscraper unit automatically adjusts itself based on the panel height. It can be excluded with the relative device.

- Continue applying the edging on the remaining sides, inserting the panel in the feed unit again.

NOTE-INFORMATION:
After preparing the machine for machining, always edge band a test panel to check that adjustments are correct.

6.15.3 EDGES FOR SMALL SIZE PANELS

(me25_6-15-3_0.0)

When the panel to be edged is small it is advisable to use a pusher panel A, of the same thickness, fitted with a drive tooth (max 10 x 15 mm).

NOTE-INFORMATION:
Keep the pusher (A) against the panel. Ensure that it makes contact with the infeed guide and accompany it under the belt, keeping it in contact.

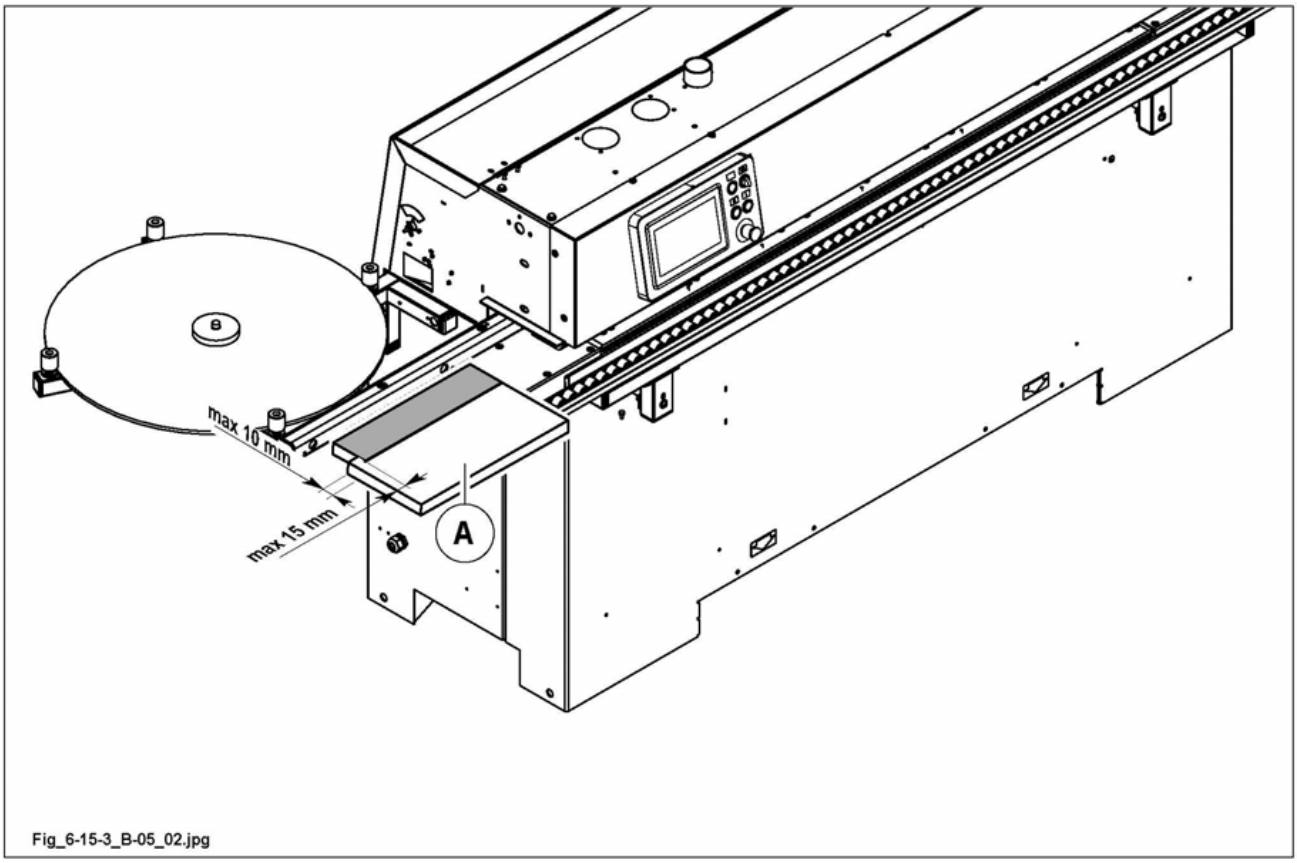


Fig_6-15-3_B-05_02.jpg

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6.15.4 SUGGESTIONS FOR USE

(me25_6-15-4_0.0)

To obtain good edge results it is necessary to remember a good number of variables that can be summarized in 3 groups, each of which contributes to the final result.

1 - PANELS TO BE EDGE BANDED:

- We recommend using good quality panels with a sufficiently high density.
- The cut must be net, without any chips and a straightness of at least ± 0.1 mm per linear meter.
- The area to be edged must be free from dust and humidity.
- The cut must be squared (90°) in relation to the surface and to the thickness.
- The panels must be stored at a temperature NO lower than 18 °C (32.4 °F).
- The panel thickness must have a uniformity of at least ± 0.2 mm, especially in the cutting area.
- The materials used for the edging (panels and edges) must have a humidity content NO higher than (8 % - 10 %).

2 - HOT-MELT GLUES [1]:

- Check that the glue is spread evenly on the panel.
- Use hot-melt glues suitable for the machine (operating temperature ~190° and panel speed ~7 m/min.).
- Change the amount of glue according to panel porosity.
- Over time the glue deteriorates and loses its adhesive properties. If you only use the machine infrequently, keep the glue level in the tank low and change when needed (see sec. 20).
- Work at an ambient temperature NO lower than 18 °C (32.4 °F).

3 - ADJUSTING THE MACHINE:

- Start the machine, start the extractor system, then carry out edge banding tests, checking these points:
- Operating pressure setting (6.5 bar);
- Glue melting temperature; to increase it act via the PLC as indicated in chap. 5.5.1.
- Check glue quantity in the tank;
- Check the edging variables described in the previous paragraphs (Par. 6.1÷ 6.12).

[1]NOTE-INFORMATION:
to achieve an optimal gluing finish follow the indications supplied by the glue manufacturer with the product technical sheet.

NOTE-INFORMATION:
The machine is regulated by our technicians to work with edges from 0.4÷2 mm in the standard version, or 3 mm in the version with cutters R=3 mm, maximum R=5 mm for use with wooden slats and (OPT) automatic edges loader.

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20.1 MACHINE CLEANING

(ad21_20-1_0.0)

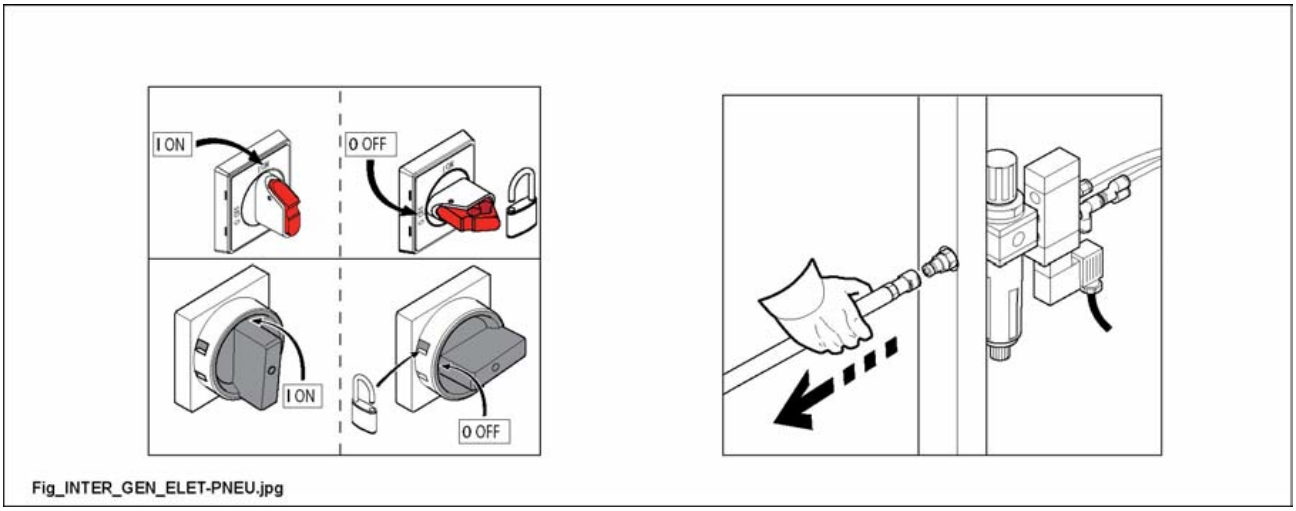
DANGER-WARNING:
all cleaning operations are to be carried out by the machine operator or by skilled technician.

Whenever cleaning the machine utilize glasses and musk as dust and chips preventer protections.

DANGER-WARNING:
Before performing cleaning, maintenance, adjustments, fitting or removing of any machine part, set the main ON/OFF switch to the zero (OFF) position and padlock it off, disconnect the compressed air tube at the filter unit infeed and place a sign indicating this situation on the machine.
The operator who carries out the machine set up, maintenance and cleaning shall keep the only key.

On the programmer display make sure that all machine parts are cold.

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

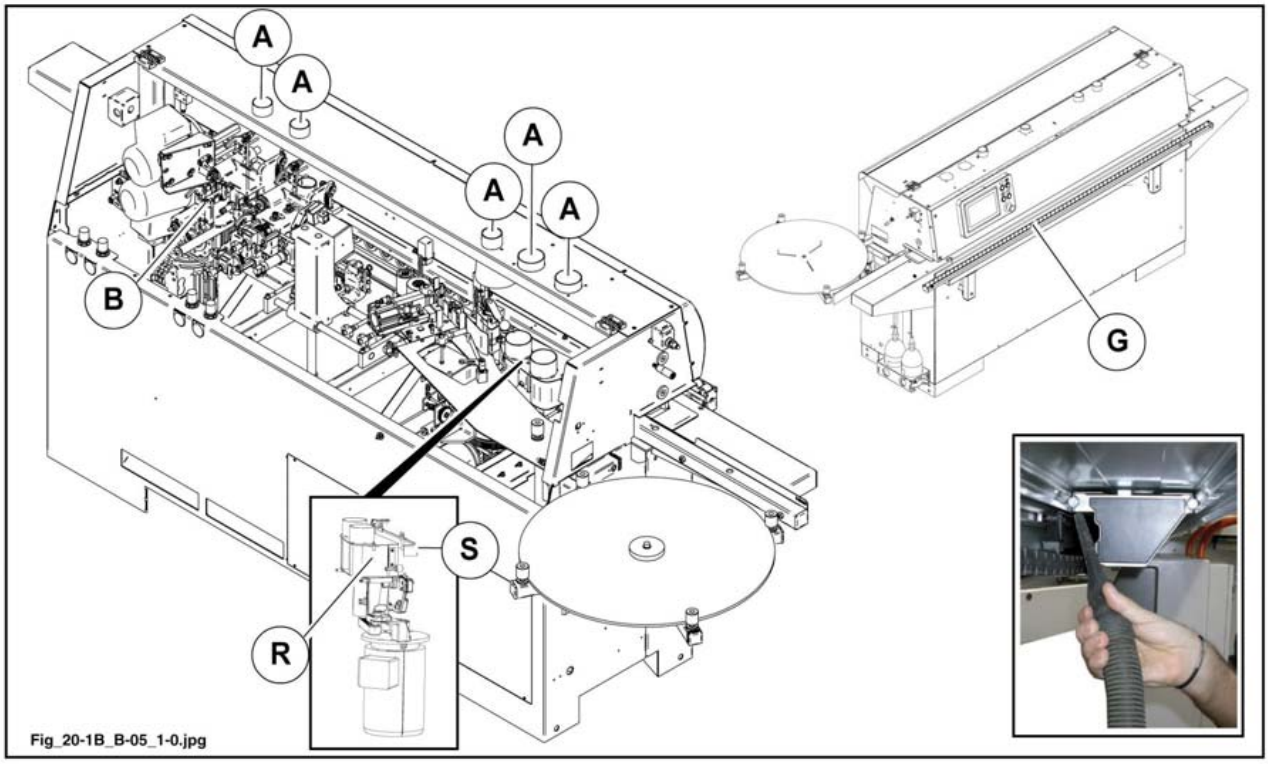


Fig_INTER_GEN_ELET-PNEU.jpg

FORBIDDEN:
DO NOT USE COMPRESSED AIR; by blowing with a strong air jet chips,dust and dirt of any type may enter into the moving members, so the machine is no more efficient.

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.



Rules for a correct machine cleaning

By using a power dust aspirator clean:

- The tables and all the cavities where dust or shaving residues are noted.
- The extraction hoods (A), checking there are no obstructions.
- Remove chips or dust from inside the machine.
- The end trimming unit (ME 35 - ME35T).
- The trimming unit.
- The feed track (G).

- End trimming unit - rounding unit (ME 35T - OPT)
- End trimmer unit with rounding unit (ME 35TR)
- The edge scraper unit OPT, especially in the chipping extraction hood (B).
- The brushes unit OPT.

- The rectifier unit (R) OPT.
  The rectifier cleaning brush (S).
- The grooves unit OPT.
- The gluescraper unit OPT.

Clean off any glue residues along the panel feed path, using a suitable non-hazardous detergent. Ask your glue supplier for advice on cleaning products. Always wear a mask.

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.

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20.2 SCHEDULED MAINTENANCE

(ad21_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.

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
General cleaning of the machine.	Visual inspection	Daily	Use a vacuum cleaner to remove any dust or shavings (Par. 20-1)
Extractor hoods	Visual inspection	Daily	Use a vacuum cleaner to remove any dust or shavings (Par 20.1)
The table and all holes containing residue of dust and shavings, in particular in the motors cooling zone.	Visual inspection	Daily	Use a vacuum cleaner to remove any dust or shavings (Par 20.1)
Inside the electric panel	Visual inspection	About 1000 hours	Use a vacuum cleaner to remove any dust or shavings (Par 20.1)
Sliding table	Visual inspection	Daily	Clean glue residue (Par 20-1)
Edging feed and pressure rollers	Visual inspection	Daily	Clean glue residue (Par 20-1)
Horizontal and vertical edge guide	Visual inspection	Daily	Clean glue residue (Par.20-1)
Internal glue tank cleaning	Visual inspection	Daily	-Open the glue tank cover -Clean with a wooden brush -Close
Glue roller	Visual inspection and operation check	Daily	Check that the shaft of the glue roller rotates uniformly and regularly. If any fault is found contact the area SCM dealer.
Compressed air regulator filter	Tank and filter check	Weekly	Remove any condensation In tank (Par 6.1)
Reel cutting shear knife	Visual inspection and operation check	Weekly	If there are faults in the edging cuts contact the area SCM dealer (Par 20.10.1)
Emergency and safety devices	Visual inspection and operation check	Every 2 weeks	Perform stop tests (Par. 20.7)
Feed track chain cleaning	Visual inspection	Every 40 operating hours and whenever it is necessary	Use a vacuum cleaner to remove any dust or shavings (Par. 20-1)

DESCRIPTION	INSPECTION / FREQUENCY	ACTION
Safety circuit	20 years	Contact the manufacturer

RECTIFIER UNIT OPT

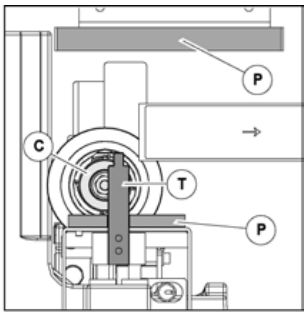
DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Unit cleaning	Visual inspection	Weekly	Use a vacuum cleaner with an adequately shaped mouth to remove any dust or shavings (Par.20.1) Remove glue residue from the tools with suitable and non-harmful detergents (Par. 20.3)
Brush cleaning	Visual inspection	Weekly	Use a vacuum cleaner with an adequately shaped mouth to remove any dust or shavings (Par.20.1)
Belt driving	Tensioning and wear check	Weekly	- Carry out some stopping tests (Par. 20.7). - Tension properly or replace whenever necessary (Par. 20.4.4 - 20.4.4.1).

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END TRIMMING UNIT (ME 35 - ME 35T) - TESTING GROUP - ROUNDING UNIT (ME 35T - OPT)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Cleaning the unit	Visual check	Weekly	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1) Eliminate glue residue from tools using suitable non-dangerous detergents. (Sect. 20.3)
Horizontal and vertical slide guides	Visual check	Weekly	Clean with a soft cloth and lubricate them (do not use greases) (Sect. 20.3)
Feeler	Visual check	Daily or when seen to be necessary	Make sure there are no edge or slat chippings interfering with proper unit operation. CHECK SLAT MACHINING MORE FREQUENTLY. Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1)

END TRIMMING UNIT with rounding function (ME 35TR)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Cleaning the unit	Visual check	Weekly	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1) Eliminate glue residue from tools using suitable non-dangerous detergents. (Sect. 20.3)
Horizontal and vertical slide guides	Visual check	Weekly	Clean with a soft cloth and lubricate them (do not use greases) (Sect. 20.3)
Feeler (**T)**  Copier (**C)** and anti-rotation shoes (**P)**	Visual check	Daily or when seen to be necessary	Check that there are no scraps that could interfere with proper functioning of the group. Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1). Using a cloth soaked in a suitable, non-hazardous solvent, clean the adhesive residues.

TRIMMING UNIT

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Cleaning of unit, extraction hoods and motor cooling zone	Visual check	Daily or when seen to be necessary	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1)
Slide guides	Visual check	Weekly	Clean the slide guides with a soft cloth and lubricate them (do not use grease) (Sect. 20.3)
Vertical and horizontal feelers	Visual check	Weekly	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1)

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EDGE SCRAPER UNIT (OPT)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Edge scraper unit	Visual check	Daily or when seen to be necessary	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1)
Slide guides	Visual check	Weekly	Clean the slide guides with a soft cloth and lubricate them (do not use grease) (Sect. 20.3)
Vertical and horizontal feelers	Visual check	Weekly	Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1)

BRUSHES UNIT (OPT)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Brushes unit	Visual check	Daily or when seen to be necessary	Check the brushes for wear. Using a vacuum cleaner with an appropriately shaped nozzle remove any dust or chippings. (Sect. 20.1).

GLUESCRAPER UNIT (OPT)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Glue scraper unit	Visual inspection	Daily or when necessary	Use a vacuum cleaner with adequately shaped mouth to remove any dust or shavings (Par.20.1)
Vertical sensor	Visual inspection	Weekly	Use a vacuum cleaner with adequately shaped mouth to remove any dust or shavings (Par.20.1)

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GROOVES UNIT (OPT)

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Unit cleaning	Visual inspection	Weekly	Use a vacuum cleaner with an adequately shaped mouth to remove any dust or shavings (Par.20.1) Remove glue residue from the tools with suitable and non-harmful detergents (Par. 20.3)

INFRARED CERAMIC LAMP (OPT)

A regular and prompt maintenance, performed in compliance with the procedures and instructions set out in this manual, can guarantee the maximum performance throughout the life of the infrared radiator.
The quartz infrared radiators do not require a specific maintenance. Simply check that the quartz glass is clean regularly.

DANGER-WARNING:
all the interventions must be carried out by competent and qualified personnel, in compliance with the applicable local regulations.

Always handle the radiators:
- ***with cloth gloves. Fingerprints on the quartz glass cause its vitrifications and consequent radiation losses and mechanical failures.***
- ***With both hands. Do not grip the radiators only on one side and not from the power supply cables.***

DANGER-WARNING:
before carrying out any intervention, set the radiator in safety.
Maintenance interventions can be performed on the radiator only when:
A - the electrical power supply has been cut off
B - the external temperature has reached the ambient temperature or in any case it is < 50°C

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Unit cleaning	Visual inspection	Daily	If the glass is dirty clean it with a natural cloth soaked in alcohol. Rub the part of quartz glass not covered with gilding to remove any impurities or fingerprints from the surface. Pay particular attention to the gilding that must never be cleaned. Use a vacuum cleaner with an adequately shaped mouth to remove any dust or shavings (Par.20.1).

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20.3 LUBRICATION

(ad21_20-3_0.0)

The accurate lubrication ensures the long life as well as the best performance of the machine.

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

Whenever cleaning the machine utilize glasses and musk as dust and chips preventer protections.

NOTE-INFORMATION:
all the operations have to be executed by the operator in charge of maintenance or by technical and qualified personnel.
The intervals between maintenance operations are approximate and may vary according to the working environment of the machine and the type of material being machined.

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.

Weekly, lubricate with grease type:

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 T for lifting.

2) Every 40 hours of operation lubricate the chain of the feed track, with the lubricators (N).

DANGER-WARNING:
MACHINE STATE: on with feed track in motion and empty (without panels).

DANGER-WARNING:
Insufficient lubrication may cause premature chain wear; excessive lubrication may soil the panels

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) Transmission chain S of the motion to the feed roller of the edging strip.

MOBILE MACHINING HEADS
Lubricate the slide guides weekly with a penetrating fluid spray.
- End cutting unit B (ME 35 - ME 35T).
- Trimmer unit C.
- Edge scraper unit D.
- Frontal extension E.
- End trimming unit - rounding unit (ME 35T -OPT)
- End trimmer unit with rounding unit G (ME 35TR)
- Gluescraper unit R.
- Presser rollers P.

NOTE-INFORMATION:
During the cleaning operations indicated cover the feed track with sheets of absorbent cardboard, to prevent damaging it by coming into contact with the cleaning products.
Do not use grease to lubricate the guides.
Use spray lubricant.
Protect all belts and pulleys to avoid contamination with oil.

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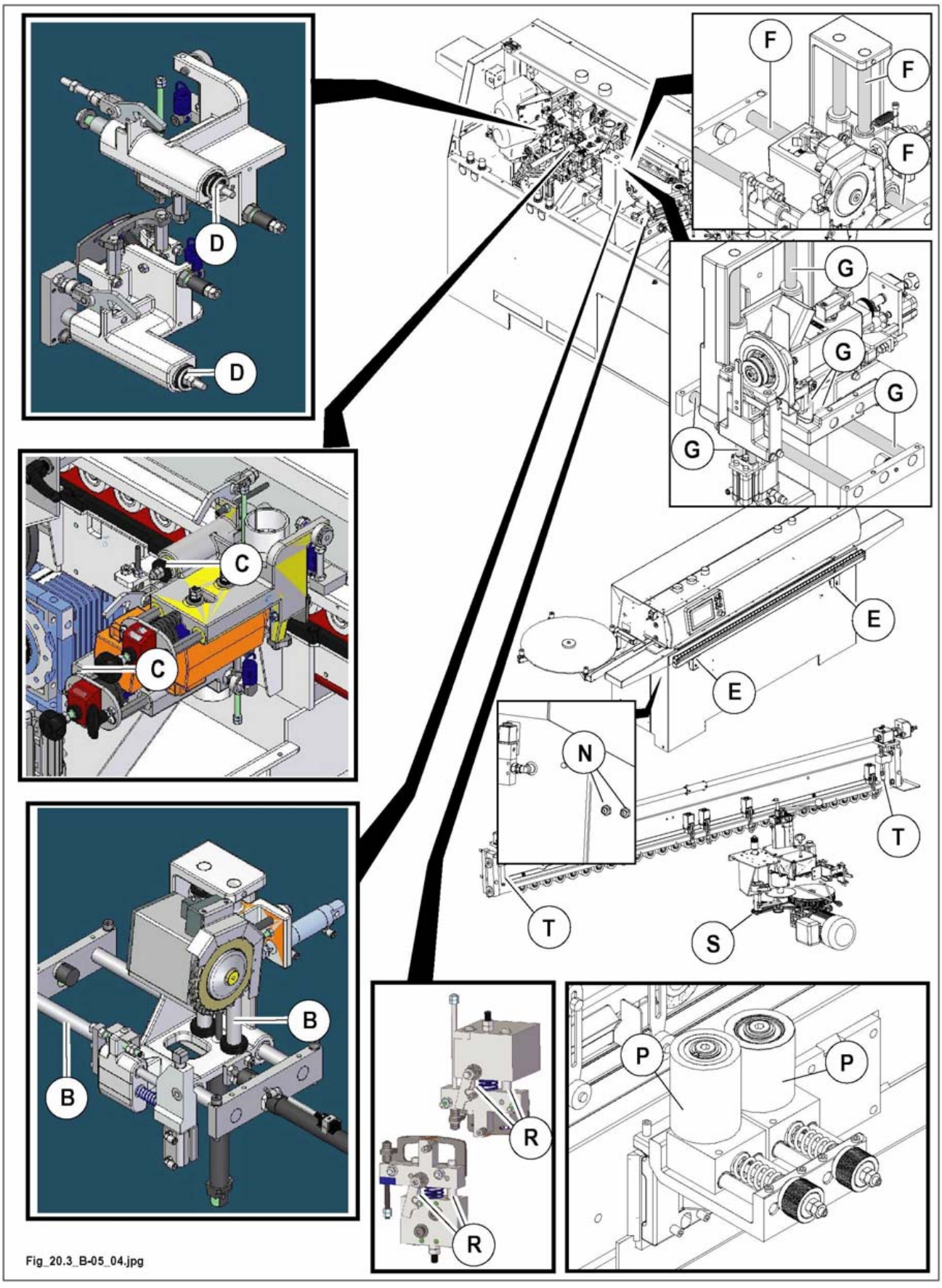


Fig_20.3_B-05_04.jpg

20.4 SUBSTITUTING AND ADJUSTING BELTS

(me25_20-4_0.00)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

20.4.4 RECTIFIER BELT TENSION ADJUSTMENT

(me35_20-4-4_0.0)

OPT

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

NOTE-INFORMATION:
Check the state of the belt after the first 10 functioning hours of the machine.
Checks must be made on the belt every month.
Check the belt tension after the first 10 hours of machine operation.
Do not overstretch the belts not to overload the bearings.
Overstretching may overheat and destroy the belts.
At least once a week check the stopping time. 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.

To tension the belt proceed as follows.
- Loosen the nut A and adjust the eccentric pin B to tension the belt.
- Once adjusted tighten the nut A.

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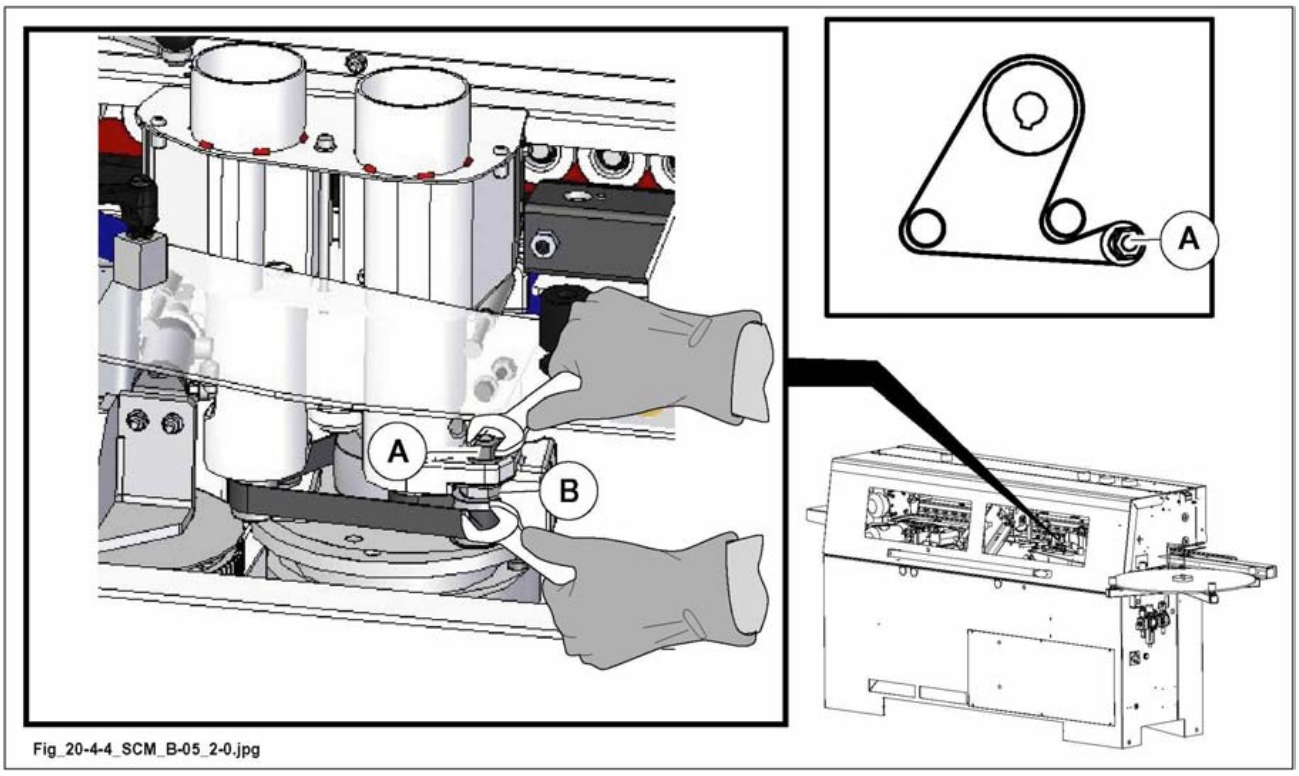


Fig_20-4-4_SCM_B-05_2-0.jpg

20.4.4.1 RECTIFIER BELT REPLACEMENT

(me35_20-4-4-1_0.0)

OPT

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

NOTE-INFORMATION:
Check the state of the belt after the first 10 functioning hours of the machine.
Checks must be made on the belt every month.

To replace the belt proceed as follows.
- Loosen the nut A and loosen the belt tension with the eccentric pin B.
- Replace the belt C.
- Tighten the nut A after having tensioned belt with the eccentric pin B.

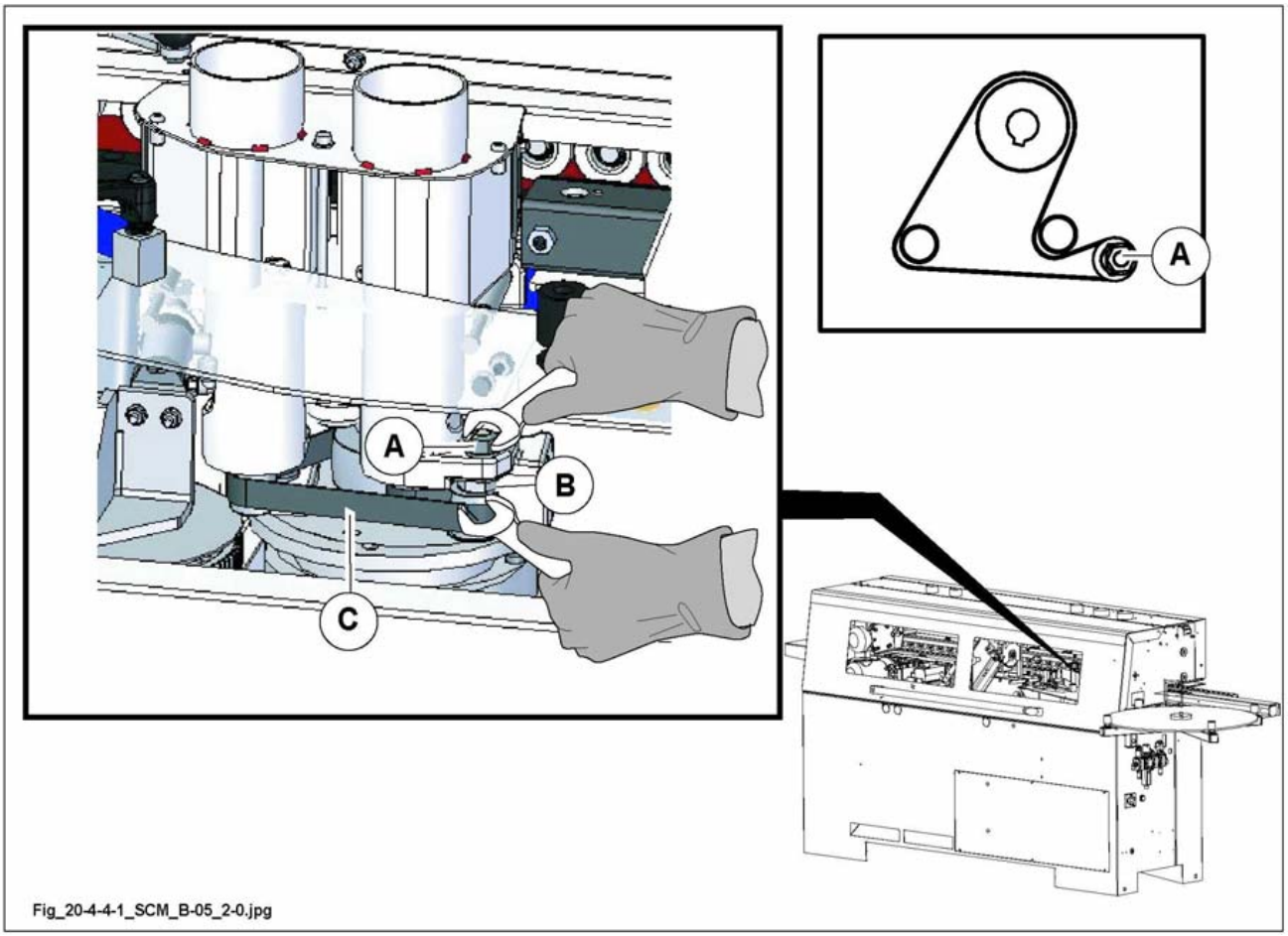


Fig_20-4-4-1_SCM_B-05_2-0.jpg

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20.5 CHAIN SUBSTITUTING AND ADJUSTING

(me25_20-5_0.00)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

20.5.1 ADJUSTING THE TENSION OF THE CHAIN

(me25_20-5-1_0.00)

DANGER-WARNING:
the correct engraver chain tension is assured by the spring (G) and it does not require any adjustment.

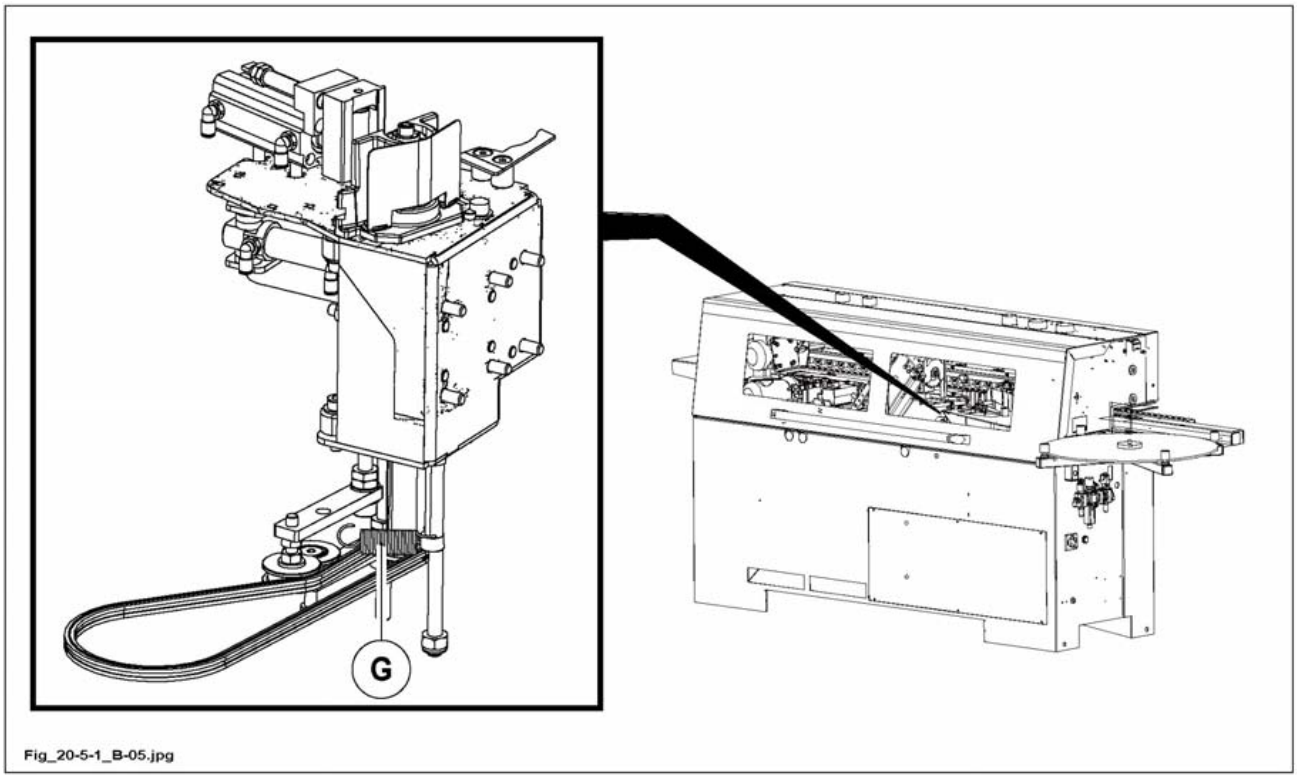


Fig_20-5-1_B-05.jpg

20.5.1.1 CHAIN REPLACEMENT

(me35_20-5-5-1_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

To replace the chain proceed as follows.
- Release the spring M from the chain tensioner T to loosen the chain C.
- Remove the screw V and remove the disc D.
- To find the correct assembly position again mark the position of the screws M with the marks Z; loosen the screws M and move the motor in the direction indicated
- Replace the chain C.
- Reposition the motor making sure that the screws M return to the position of the marks Z.
- Tighten the screws M.
- Reposition the disc D and block it with the screw V.
- Reposition the chain C on the pinions and reassemble the chain tensioner T with its spring M.

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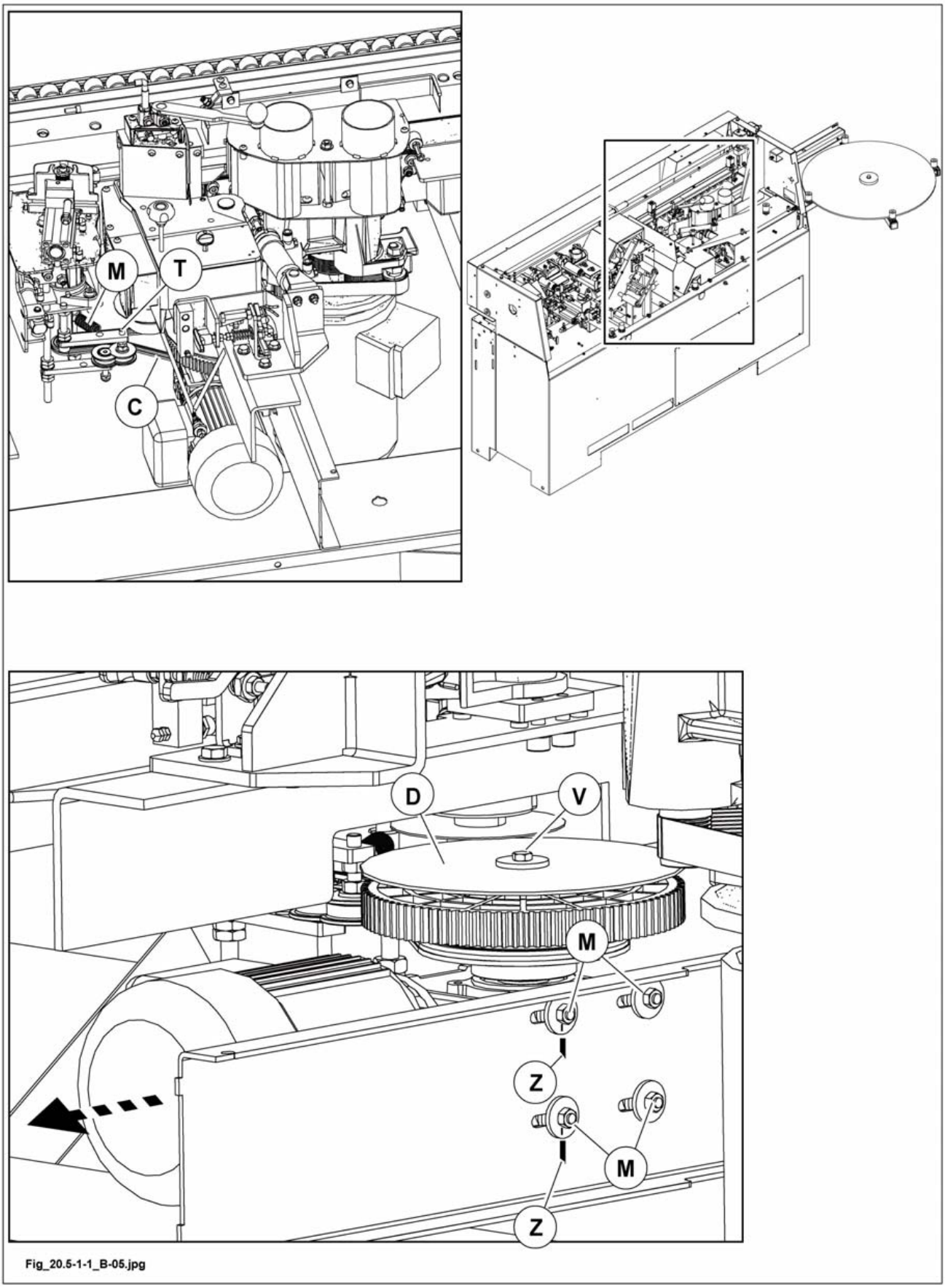


Fig_20.5-1-1_B-05.jpg

20.5.2 FEED TRACK CHAIN TENSION ADJUSTMENT

(me35_20-5-2_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

If necessary, adjust the tension of the feed track chain as indicated below:
- Disassemble the extension A.
- Loosen the screws B.
- Loosen the nut C and use screw D to tension the belt.
- Once adjustment has been completed, tighten the screws and the nuts, and refit the extension A.

CAUTION:
do not tension the chain of the feed track excessively to avoid wearing the feed track and the feed and tensioning parts prematurely; we therefore recommend using a torque wrench and pay attention not to exceeds the maximum torque values indicated in the table.

Torque maximum values

Machine version		Maximum torque	
ME35		**2 Nm**	**0,2 Kpm**

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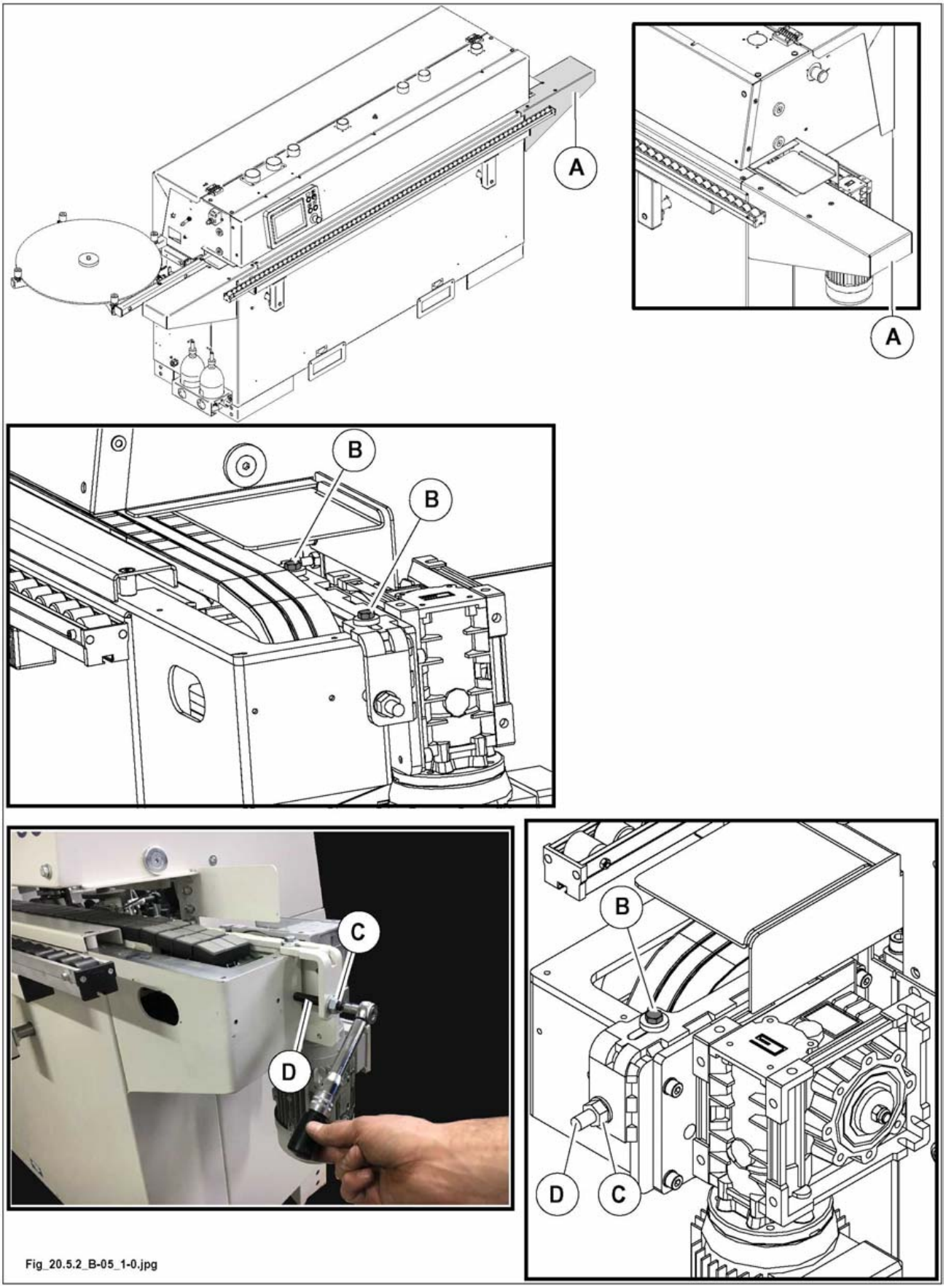


Fig_20.5.2_B-05_1-0.jpg

20.5.2.1 FEED TRACK CHAIN REPLACEMENT

(me35_20-5-2-1_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

Move the pad (P), on the connecting link of the feed chain and recognisable for the red mark (Y), close to the motor pinion (M).

DANGER-WARNING:
MACHINE STATE: off, with the main switch in the "OFF" position and locked and compressed air cut-off valve closed and locked.

Proceed as described below:

- Lift the presser unit to the maximum (with the handle H).
- Disassemble the extension (E) and the extension (E1).
- Disassemble the protections (F) and (G).
- Loosen the screws (B).
- Loosen the nut (C) and use the screw (D) to loosen the feed track chain.

- Insert a flat screwdriver between the chain and the pad (P).
  Once the pad (P) is removed, you can access the connecting link (S).
- Remove the link stop (L) and open the closed ring of the chain, by removing the connecting link (S).

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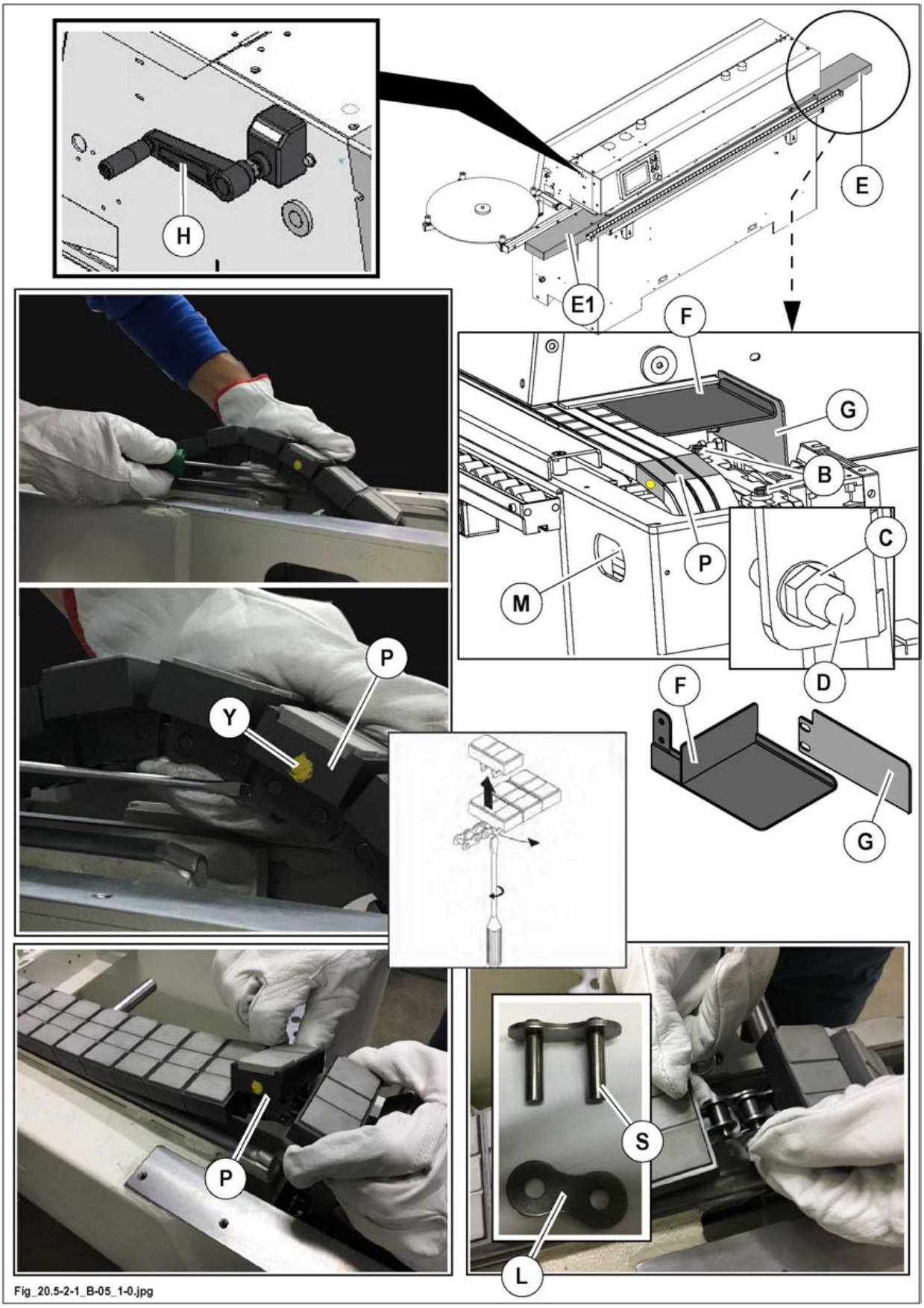


Fig_20.5-2-1_B-05_1-0.jpg

- **Free the short section (1) of the feed track chain from the teeth of the motor pinion (M).**
- **Move the upper long section (2), of the feed track chain out of the machine from the panel infeed side.**
- **Then remove the lower part (3) of the feed track chain from the guide tubular section in the base.**

To re-mount, repeat the removal operations in the reverse order.

DANGER-WARNING:
follow the pads (P) assembly position.
The feed track chain is installed correctly when the semicircular shape in the body of the pads (P) slides on the single track of the guide (Z), as shown in the figure.

- Insert the end (1) of the feed track chain in the guide tubular section (T) and push the part (3) until the end (1) comes out of the motor pin side (M).
- Extend the section (2) of the feed track chain on the guide track and pull until the free ends of the chain come into contact.
- Insert the connecting link (S) and close the chain by inserting link stop (L).
- Reassemble the pad (P).
- **Tension the chain as indicated in chap. 20.5.2.**

- Reassemble the protections (G) and (F).
- Reassemble the extension (E) and the extension (E1).

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

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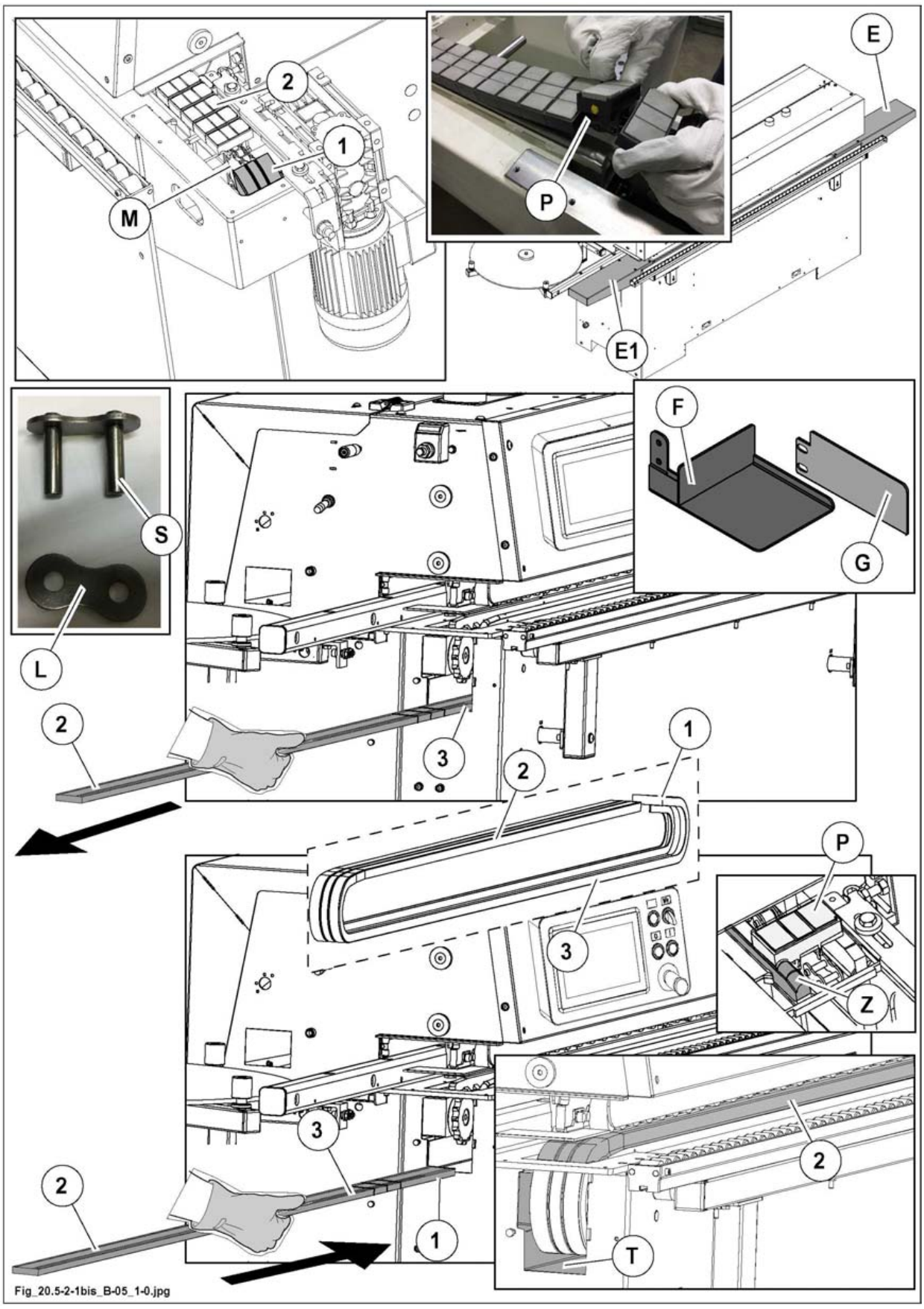


Fig_20.5-2-1bis_B-05_1-0.jpg

20.5.2.2 REPLACING A PAD OF THE FEED TRACK CHAIN

(me35_20-5-2-2_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

Position the pad (P) to be changed by the motor pinion (M).

DANGER-WARNING:
MACHINE STATE: off, with the main switch in the "OFF" position and locked and compressed air cut-off valve closed and locked.

Proceed as described below:

- Lift the presser unit to the maximum (with the handle H).
- Disassemble the extension (E).
- Disassemble the protections (F) and (G).
- Insert a flat screwdriver between the chain and the pad (P).
- Replace the pad (P).

- **Tension the chain as indicated in chap. 20.5.2.**

- Reassemble the protections (G) and (F).
- Reassemble the extension (E).

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

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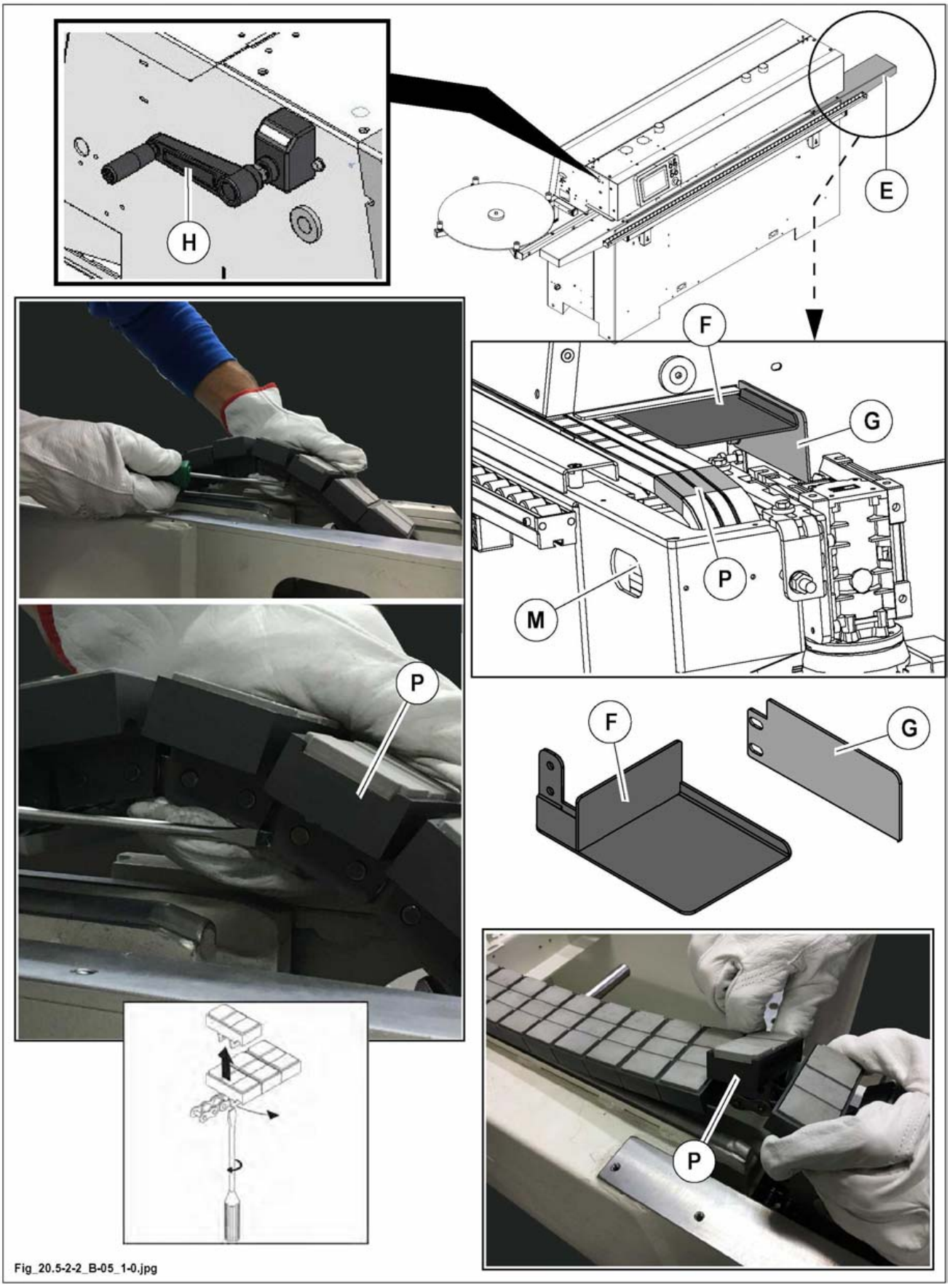


Fig_20.5-2-2_B-05_1-0.jpg

20.7 CHECK OF SAFETY DEVICES

(ad21_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.

a) With the machine running in standard operating mode, press the emergency stop pushbutton (E1) on the control panel. All machine functions should stop.
b) With the machine running in standard operating mode, press the emergency stop pushbutton (E2) on the workpiece outfeed side. All machine functions should stop.

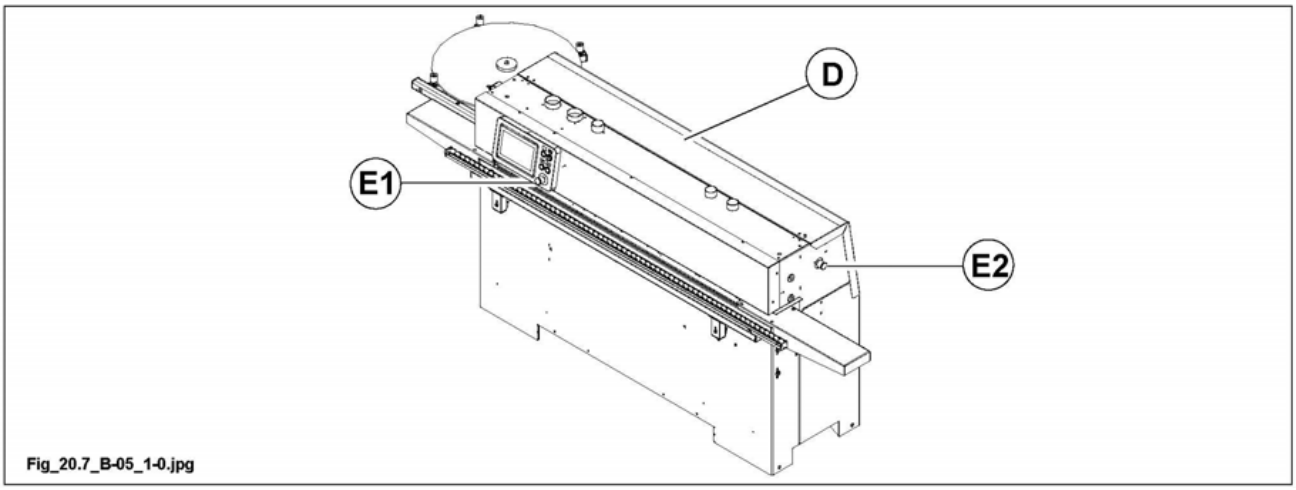
Once every 2 weeks, check that the micro-switche on the panel D functions correctly;
if the panel is open, the motor should not start.
With the machine restored the door D must not be opened.

Periodically check that the guards are efficient and that the plates in particular the ones with yellow ground are in good state.

NOTE-INFORMATION:
RECTIFIER
every week check the motor braking times (maximum stop time 10 sec). Tension properly or replace whenever necessary (Par. 20.4.4 - 20.4.4.1). For high frequency motors contact the technical support service SCM***.***

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.***
Every 20 years the safety circuit must be overhauled. Contact the manufacturer.



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20.7.1 SPARE PARTS THAT AFFECT THE OPERATOR'S HEALTH AND SAFETY

(ad21_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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20.10 SUBSTITUTING TOOLS

(me25_20-10_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

NOTE-INFORMATION:
periodically check tools for proper sharpness and if necessary have them sharpened or replaced.

20.10.1 REPLACING THE REEL CUT SHEAR KNIFE

(me25_20-10-1_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

- Replace the knife by acting on screws A.

Regularly check the sharpness of the tools.

NOTE-INFORMATION:
Fully tighten the screws and make sure that the tool is in its seat.
The shears knife must be sharp only on the oblique side.

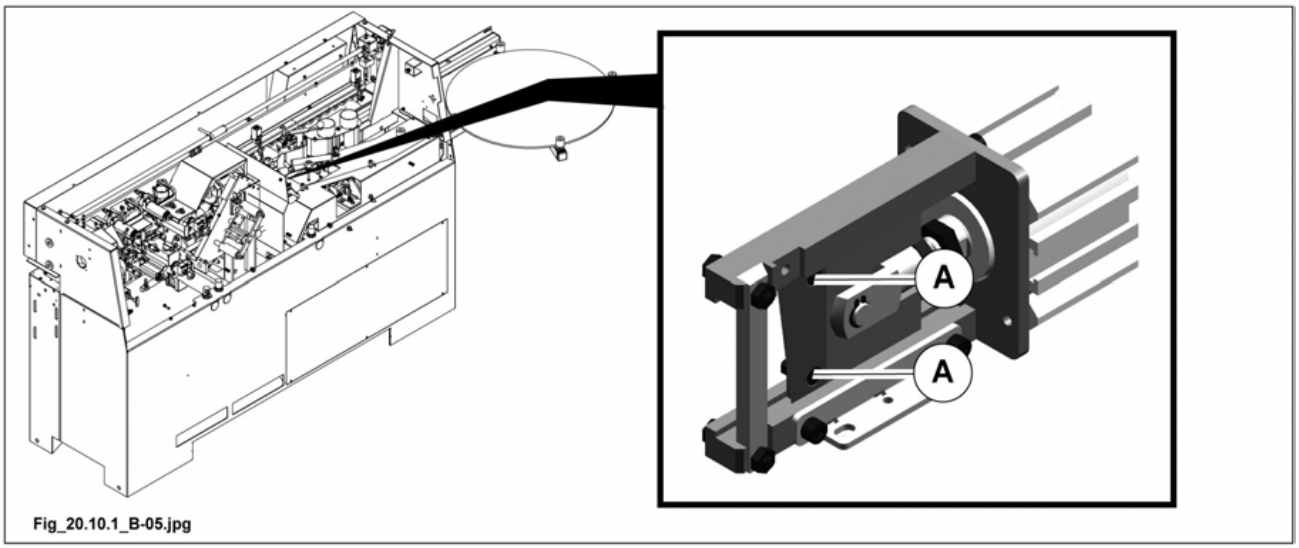


Fig_20.10.1_B-05.jpg

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20.10.2 REPLACING THE END TRIMMER BLADE

(me25_20-10-2_0.0)

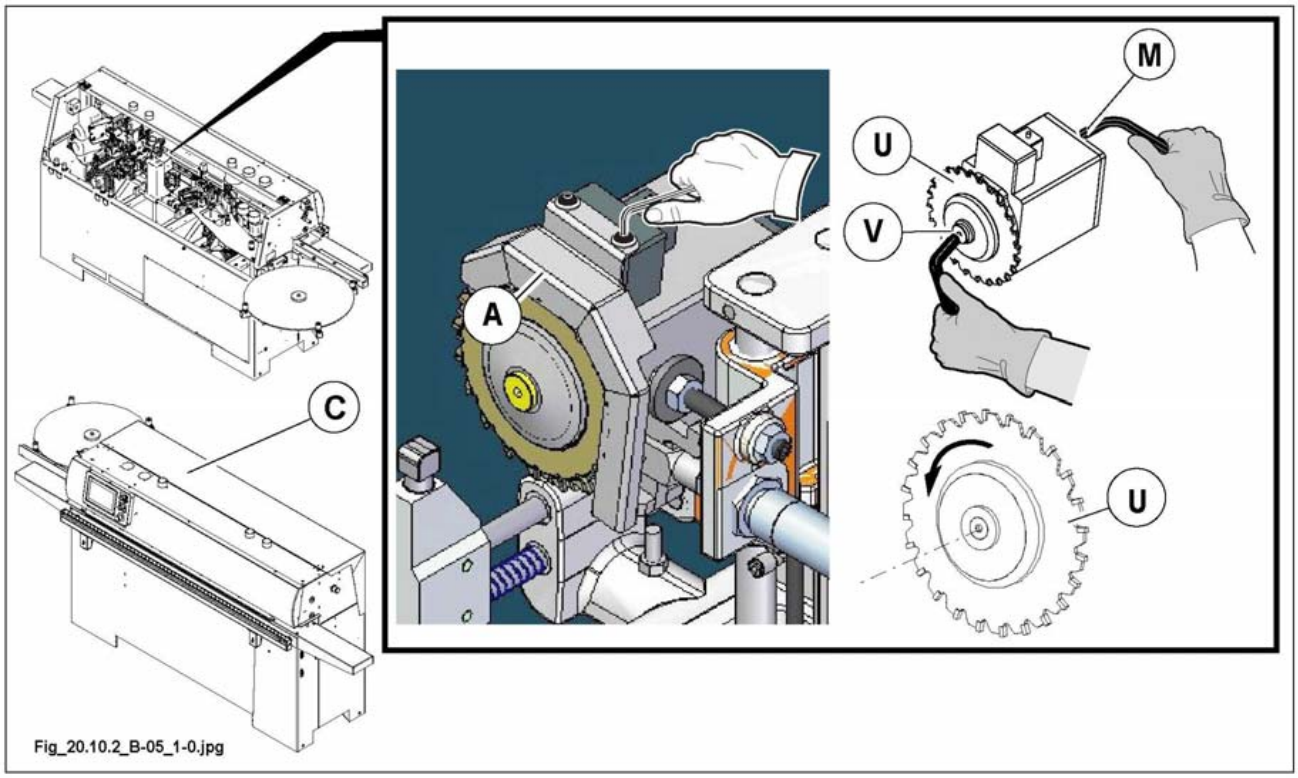
DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

To replace the blades proceed in this way: (it is not necessary to take off the trimming unit motor).
- Make sure that no panels are processed.
- Stop the machine by pressing STOP button
- Press emergency button.

  ONLY after pressing the emergency button and after waiting some seconds (for motor stop) it is possible to open cowling (C).

- remove the casings (A)
- insert a 4 mm Allen key into the screw (V) that secures the blade
- insert a 5 mm Allen key into the rear part of the motor (M)
- unscrew the screw (V) that secures the blade
- replace the blade (U) making sure that it is replaced in the correct rotation direction
- retighten the screws (V)
- Fit cover (A)



20.10.3 SUBSTITUTE BLADES IN UPPER AND LOWER BOARD CUTTING KNIVES

(me25_20-10-3_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

CAUTION:
The cutters must be replaced by a specialised technician as numerous adjustments are required.

Check the correct assembly of the cutters; the upper cutter is right and the lower on is left.

Proceed with the cutters replacement by operating on one cutter unit at the time. Once it is completed move to the second unit.

Make sure that the screws and wrenches supplied are not lost during the disassembly and assembly.

Make sure that the motor cables are not inverted. This could rotate the motors in the opposite direction and cause considerable damage.

MOTOR DISASSEMBLY
- Lift the presser unit as far as possible.
- Move the unit back and exclude it (Chap 6.7)
- Remove the hood A with the screw B
- Disconnect the motor with the connector C
- Loosen the 4 screws keeping the motor suspended (three screws with 4 hex wrench, one (V) countersunk used to adjust with 3 hex wrench)
- Remove the motor

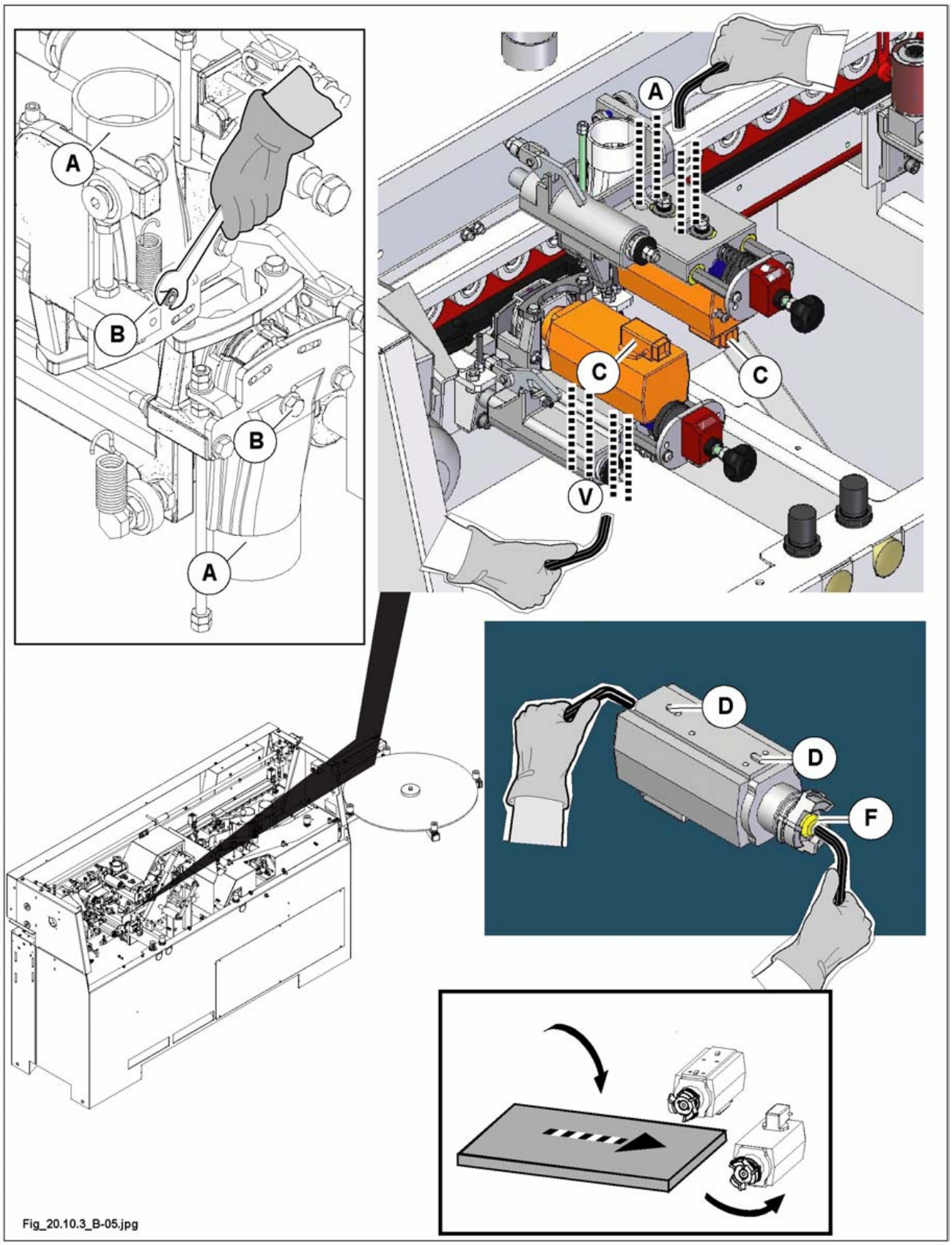
CUTTERS REPLACEMENT
- Insert a hex wrench in the rear part of the motor and a second screw in the front part (F) and use it to disassemble the cutter.
- Replace the cutter and tighten the fixing screw (F) blocking the motor shaft as described above.

MOTOR ASSEMBLY
- Return the motor to its seating and make sure that the keys (D) are positioned correctly.
- Insert the 4 screws of the supports
- Firstly tighten the countersunk screw A and then the other 3 screws
- Reassemble the extractor hood A blocking the nut B
- Make sure that the cutters do not scrape the extractor hoods
- Reconnect the motor with the connector C

DANGER-WARNING:
PAY ATTENTION TO THE DIRECTION OF ROTATION: THE TOOL CUTTING EDGES SHALL WORK AGAINST THE PANEL FEED.

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NOTE-INFORMATION:
regularly check the sharpness of the tools.



20.10.4 REPLACING EDGE SCRAPER INSERTS

(me25_20-10-4_0.0)

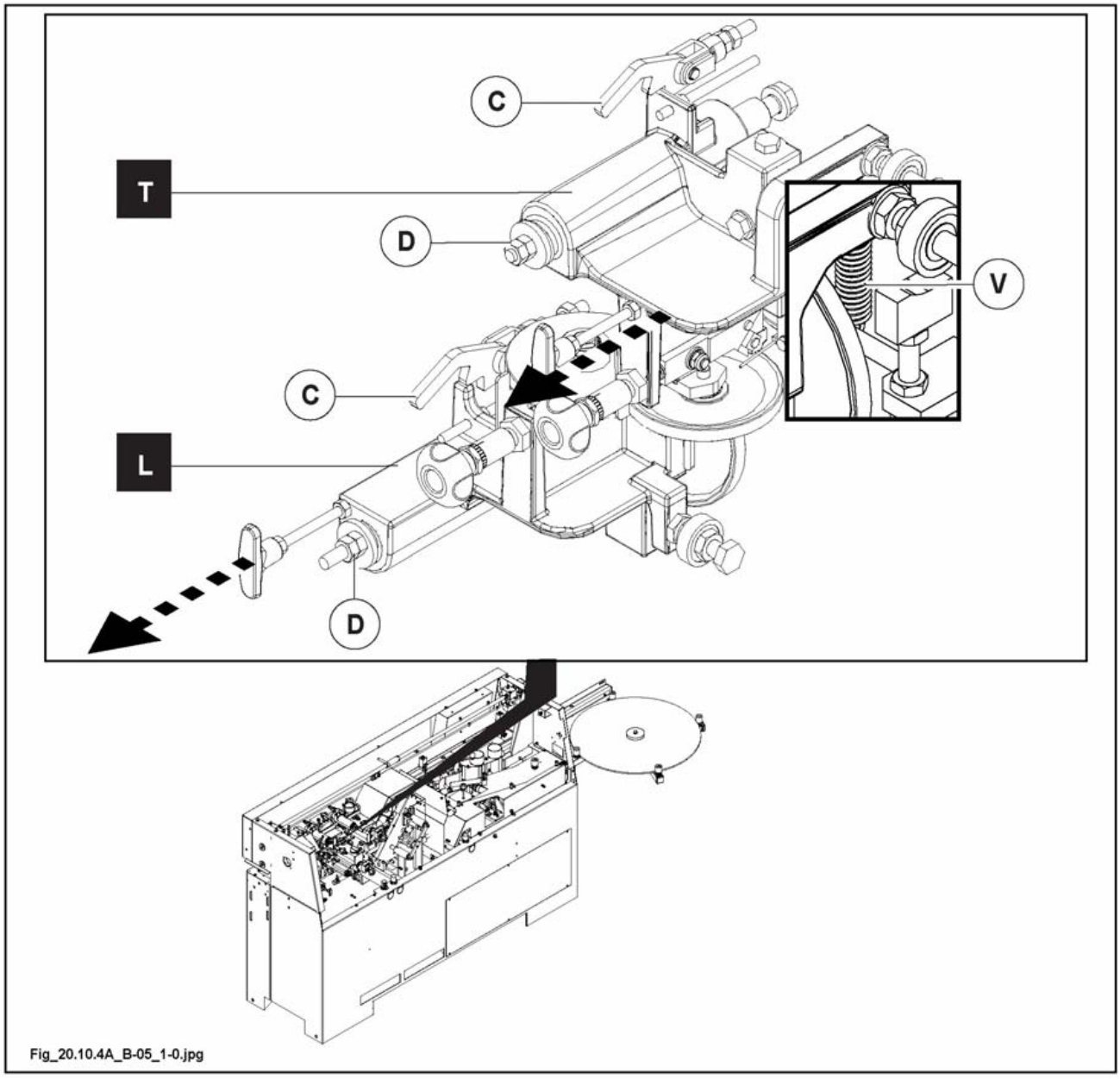
DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

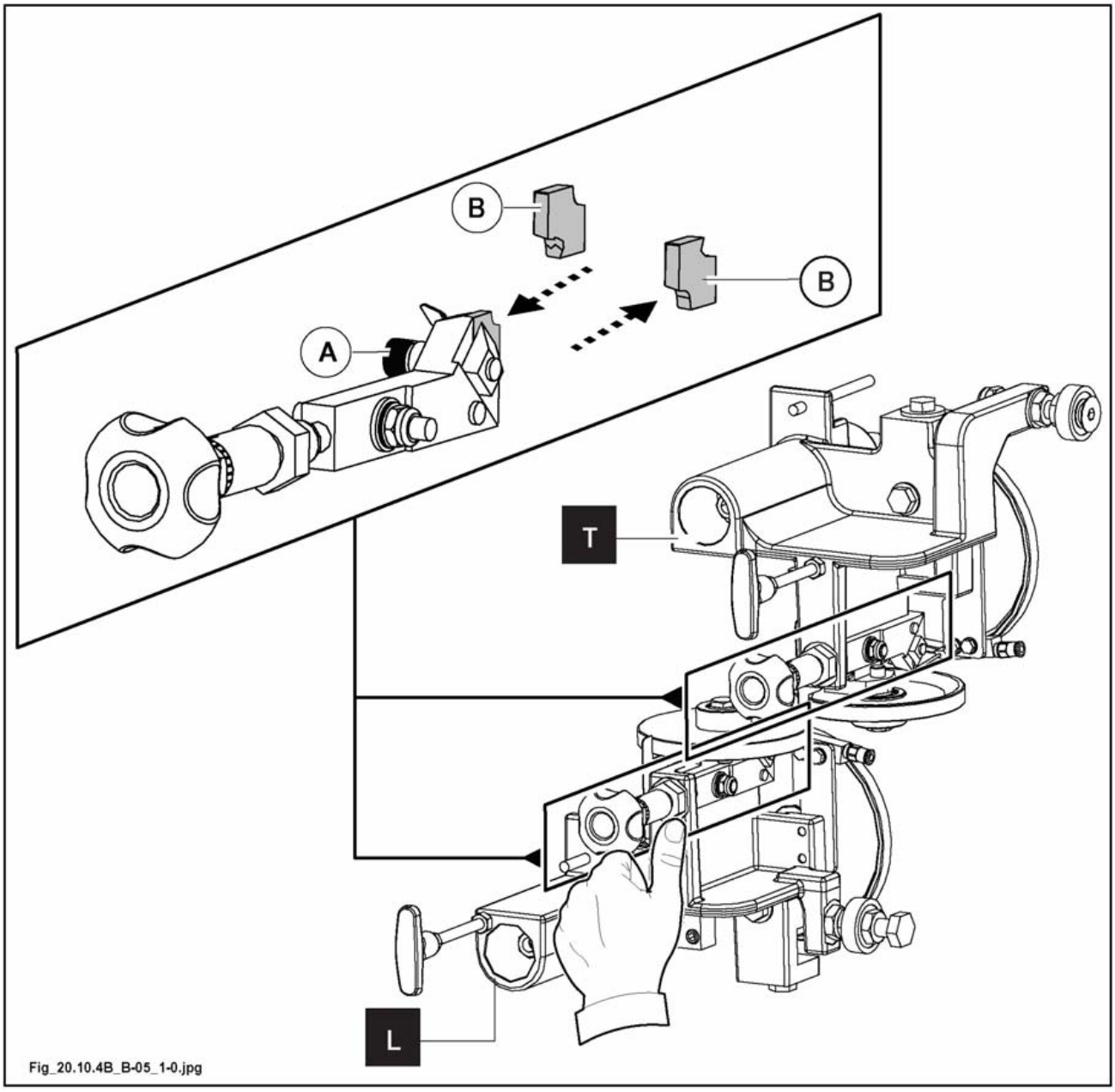
CAUTION:
Edge scraper replacement must only be carried out by a specialised technician.
Make sure the insert is assembled correctly; it must be oriented correctly and perfectly inserted in its seat.

- Remove the nuts D
- Release the spring V
- Lift the lever C and remove the upper (T) and lower (L) gluescraper units

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C
T
D
V
C
L
D
Fig_20.10.4A_B-05_1-0.jpg

- Loosen the screw A, replace the insert B.
- After correctly positioning the insert all the way in, tighten the screw A.
- Reassemble the upper (T) and lower (L) gluescraper units



NOTE-INFORMATION:
regularly check the sharpness of the tools.

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20.10.5 REPLACING THE BRUSHES

(me25_20-10-5_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

- Unscrew the brush lock screw B using the wrench and accessory pin supplied with the machine.
- Replace the brush and tighten it using the relative screw.

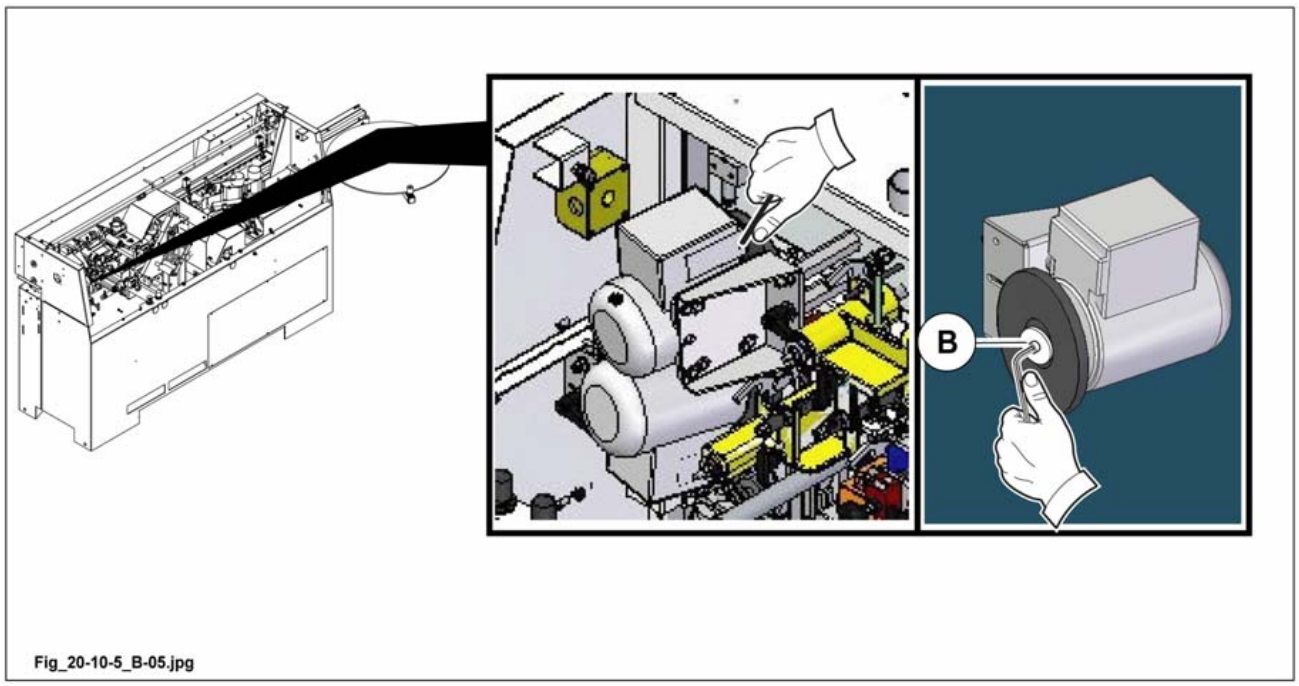


Fig_20-10-5_B-05.jpg

20.10.6 REPLACEMENT CUTTER RECTIFIER

(me35_20-10-6_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

Remove the upper hood by firstly unscrewing the screws (A) and then the nut (B).
Insert the pin (C) in the slot (E) of the hood abd block the rotation of the cutter shaft.
Unscrew the nut (F) and replace the cutter.
Repeat the procedure for the second cutter, by inserting the pin (C) in the slot (E).

For the reassembly repeat the disassembly operation in reverse.

NOTE-INFORMATION:
Regularly check the sharpness of the tools.

NOTE-INFORMATION:
Fully tighten the screws and make sure the tool is in its seating.
Make sure that the spacers supplied are positioned correctly (see chap. 6.10).

DANGER-WARNING:
When new or re-sharpened cutters are inserted, reassemble the two spaceers.
Pay attention to the rotation direction of the tools.

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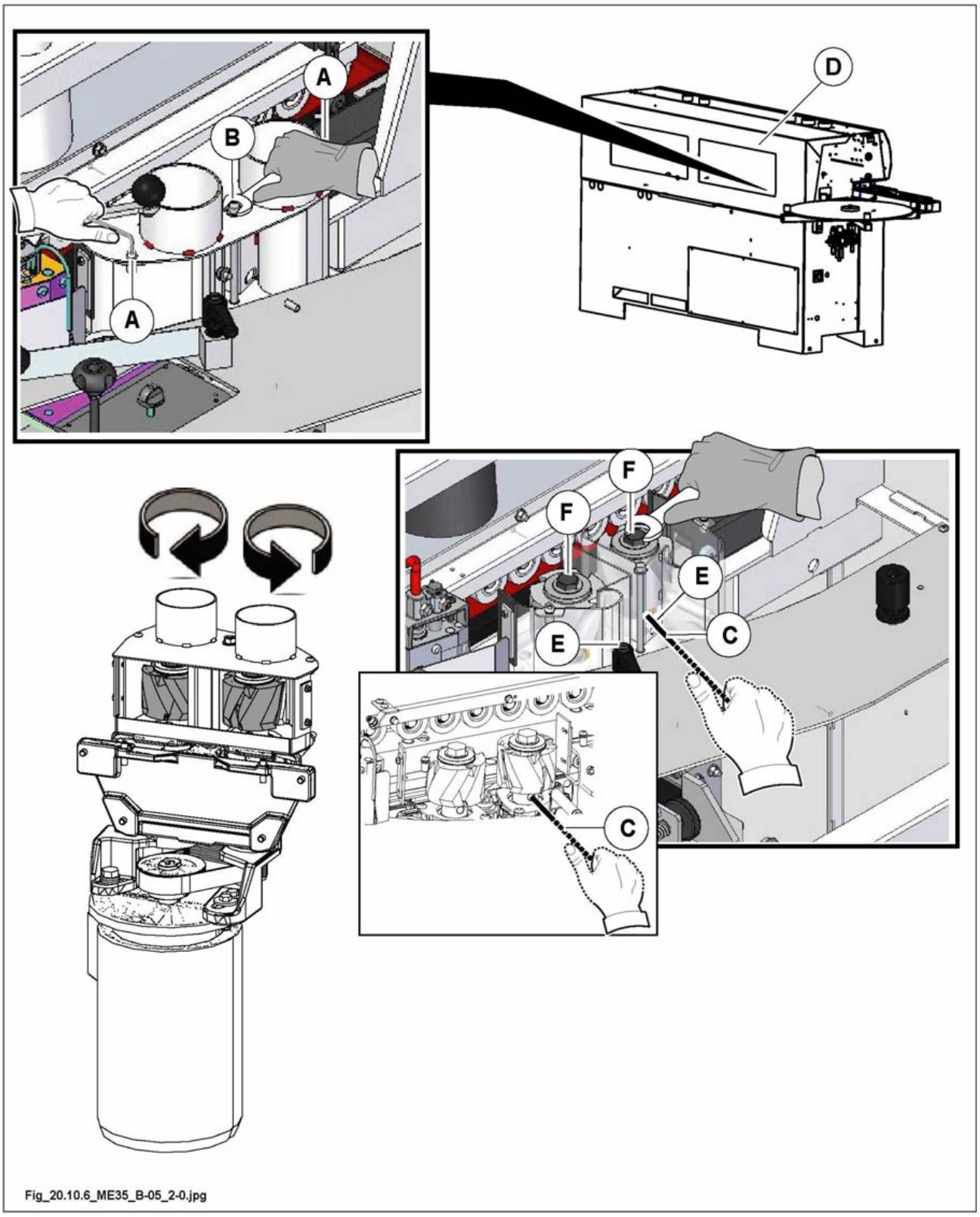


Fig_20.10.6_ME35_B-05_2-0.jpg

20.10.7 GROOVES UNIT REPLACEMENT

(me35_20-10-7_0.0)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

MOTOR DISASSEMBLY

By using the handle S, lift the feeder unit until you see 50 mm on the indicator T.

- Disconnect the motor using the connector A
- Retreat the ring nut B
- Completely unscrew the two screws C
- Completely unscrew the two bolts D so as the motor is supported
- Remove the motor

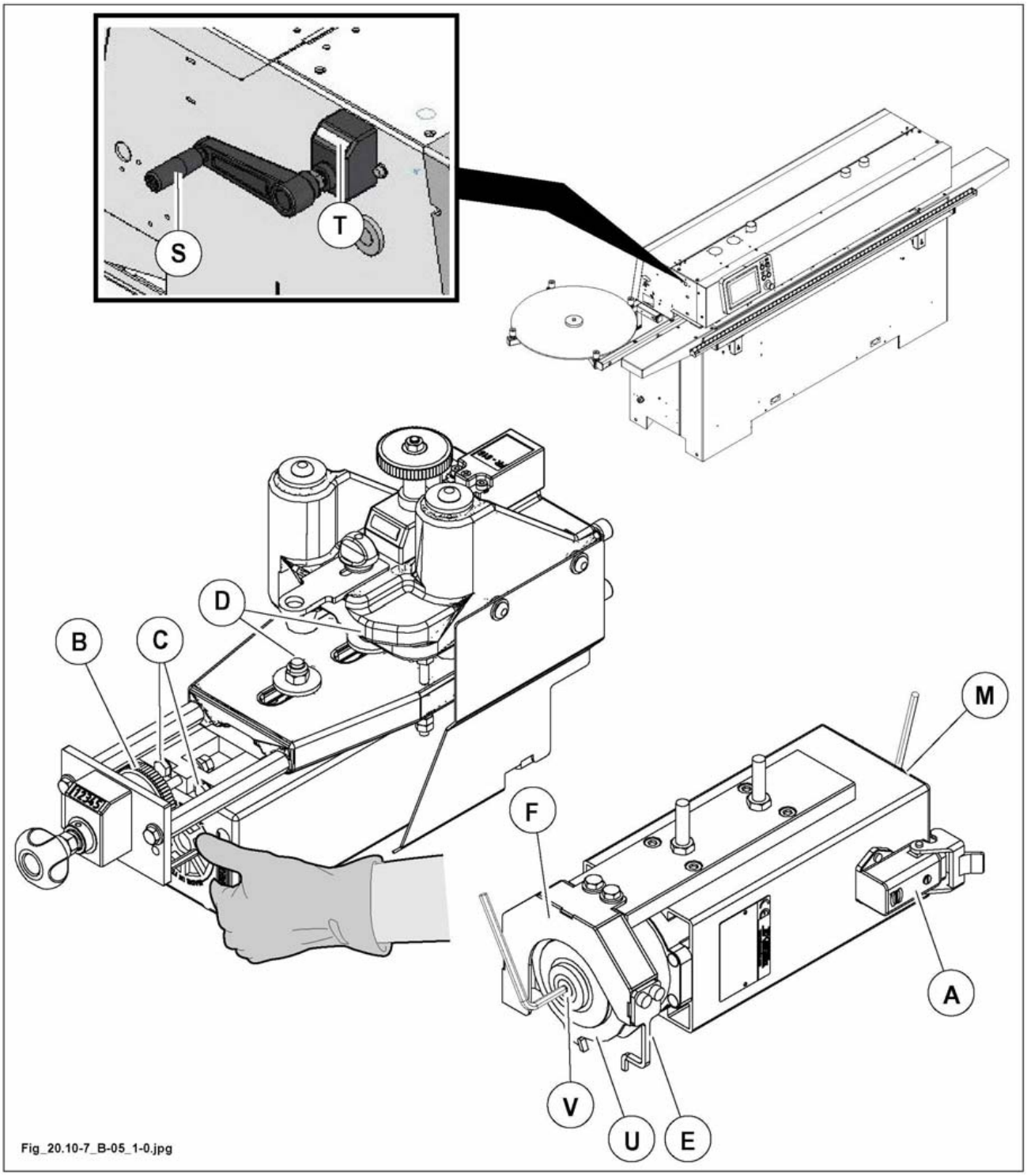
BLADE REPLACEMENT
- insert a 4 mm Allen key into the screw (V) that secures the blade
- insert a 6 mm Allen key into the rear part of the motor (M)
- unscrew the screw (V) that secures the blade
- replace the blade (U) making sure that it is replaced in the correct rotation direction
- retighten the screws (V)

NOTE-INFORMATION:
the items (E - F) MUST NEVER be dismantled.

MOTOR ASSEMBLY
Insert the engine into its
- Screw the nuts D
- Tighten the screws C
- Reconnect the motor using the connector C

NOTE-INFORMATION:
adjust the locking of the self-locking nuts D so as the grooves unit can slide horizontally without hardening reactions.

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S
T
D
B
C
M
F
A
V
U
E
Fig_20.10-7_B-05_1-0.jpg

20.10.8 REPLACEMENT CUTTER RECTIFIER

(me35_20-10-8_0.0)

(ME 35TR)

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

DANGER-WARNING:
handle the tools with protective gloves.

By using the handle S, lift the feeder unit until you see 50 mm on the indicator T.

- Lift the operator unit manually to be able to lock the mobile part (C) to the fixed part (D) of the same, by inserting the accessory pin (F) into the matching holes, obtained on the mobile part (C) and on the fixed part (D).
- Disconnect the motor using the connector A

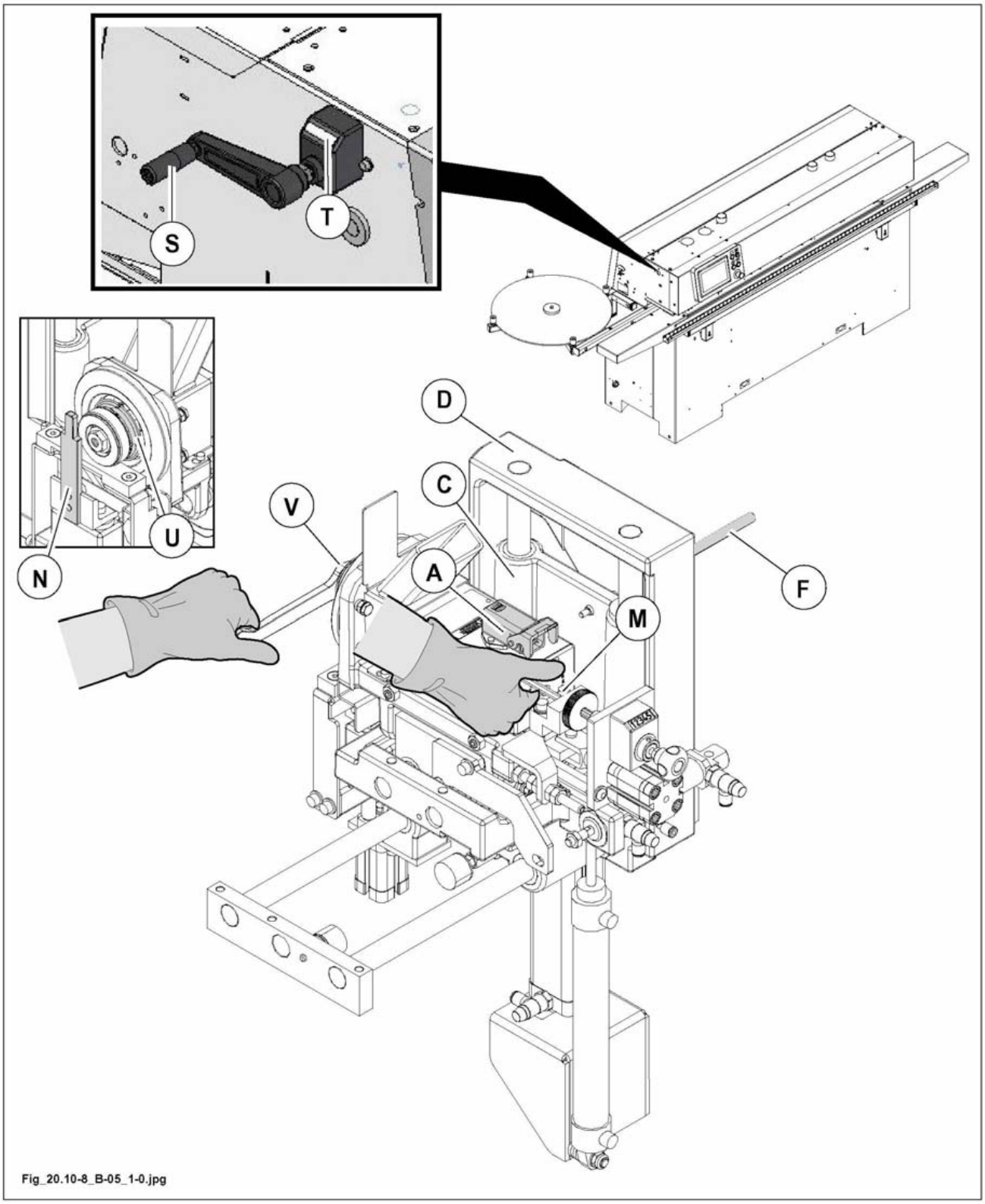
CAUTION:
make sure that the probe (N) is in the low position.

- Insert a 5 mm Allen key into the rear part of the motor (M)
- unscrew the screw (V) that secures the blade
- replace the blade (U) making sure that it is replaced in the correct rotation direction
- retighten the screws (V)
- **Unblock the operator unit by removing the accessory pin (F).**
- Reconnect the motor using the connector A

NOTE-INFORMATION:
if, due to machining requirements, you want to use spokes other than those of the tool supplied with the machine, you should contact the Manufacturer.

NOTE-INFORMATION:
Regularly check the sharpness of the tools.

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S
T
N
U
V
D
C
A
M
F
Fig_20.10-8_B-05_1-0.jpg

20.11 SUBSTITUTING THE GLUE

(me25_20-11_0.0)

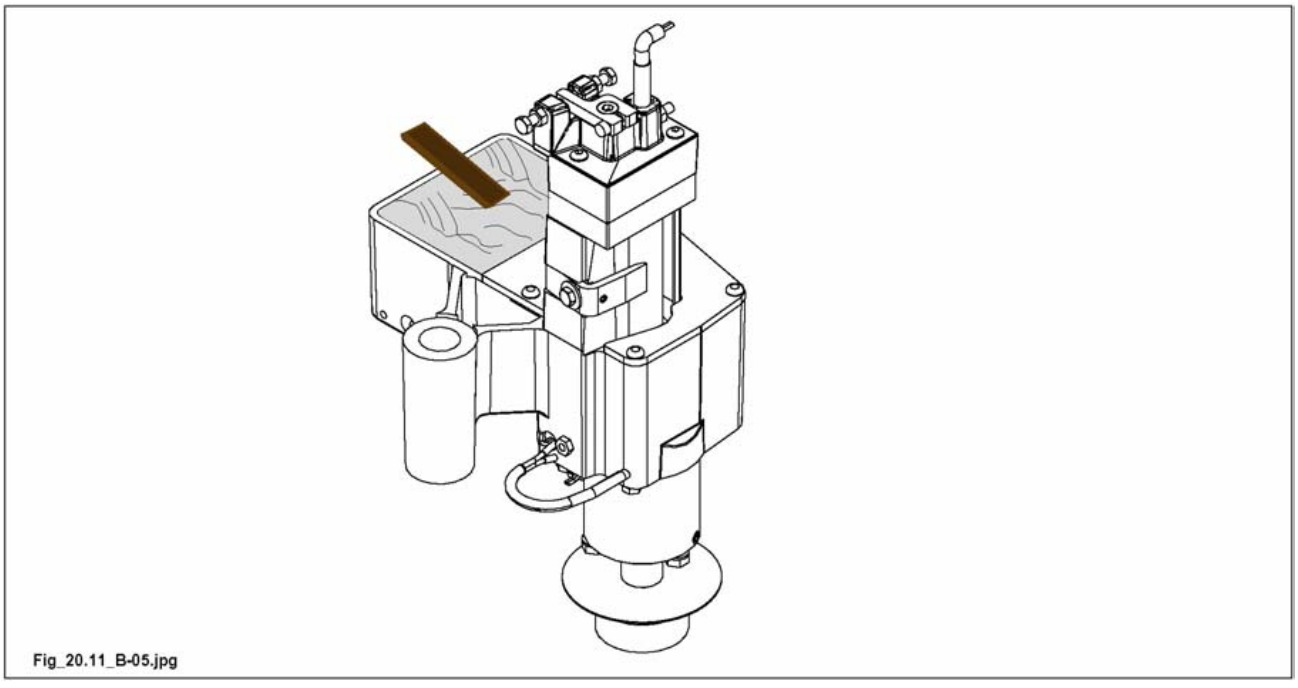
DANGER-WARNING:
Always use gloves in order to prevent burns.

DANGER-WARNING:
during maintenance, cleaning and lubrication operations, make sure that the power supply and compressed air are switched off and cannot be accidentally switched on (See Sec. 20.1).

Do not clean the glue tank with metal tools, since they will damage it. Use a wooden scraper.

Over time the glue deteriorates and loses its adhesive properties; proceed as follows to completely empty the glue tank and change the glue:

- bring the glue to the operating temperature and insert a piece of wood in the tank, immersed right through the glue with one end projecting approx. 10-15 cm from the tank;
- wait until the glue is completely cold, switch on the machine again and reheat the glue until it can be extracted with wood (recommended extraction temperature ~ 90°÷110°);
- the glue remaining on the walls of the tank can easily be removed when it is tepid (recommended temperature ~ 40°).


Fig_20.11_B-05.jpg

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20.37 TROUBLES - CAUSES - WHAT TO DO

(ad21_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.

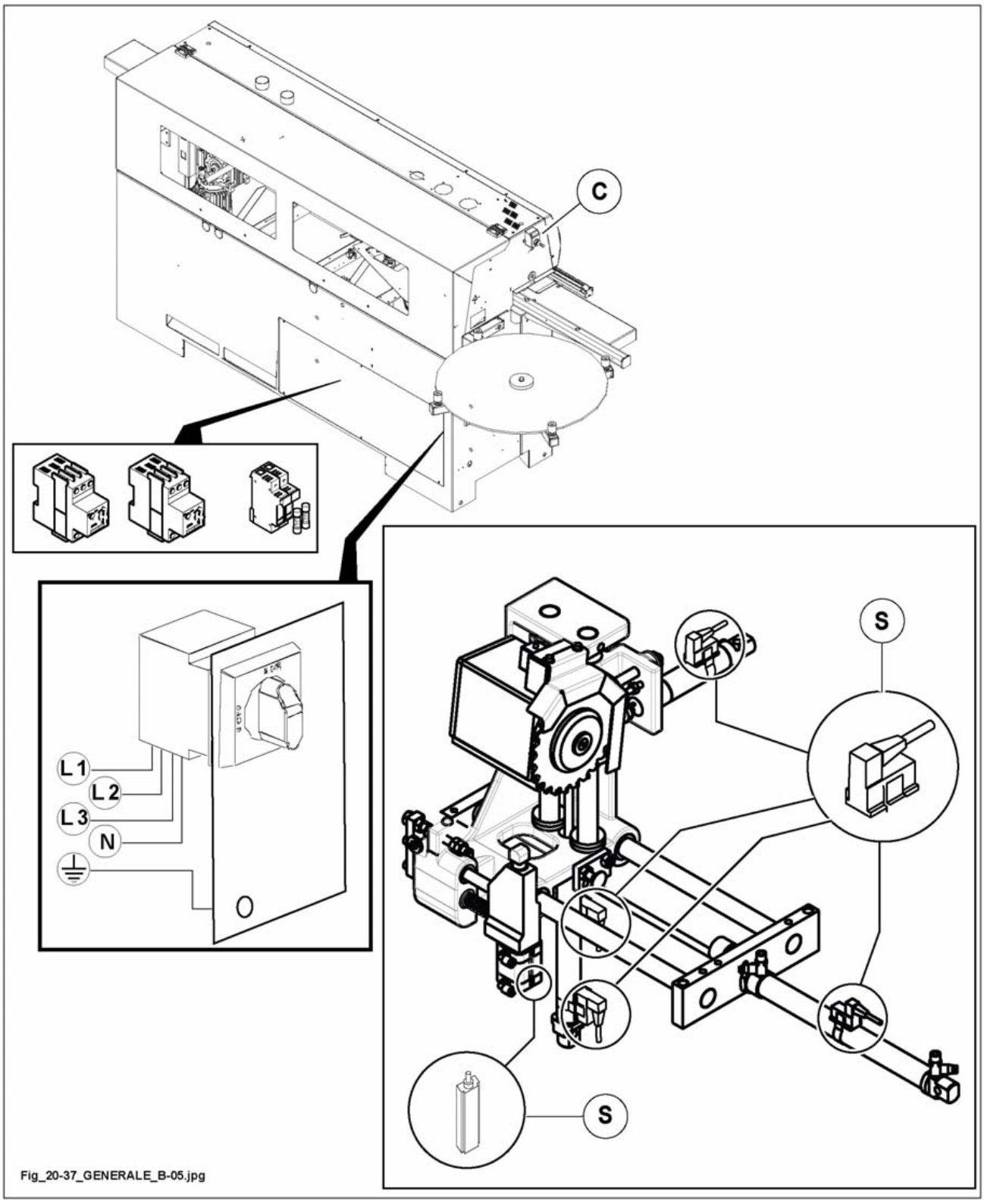
For problems not described in the handbook apply to SCM Technical Service.

NOTE-INFORMATION:
an error message appears on the electronic controller. See Chap. 20.42.

PROBLEM	CAUSE	REMEDY
The machine does not reset	Main switch turned to **0** (OFF).	Turn it to **I** (ON).
	No electrical energy on one or more phases of the line.	Check with a tester there is voltage in the three phases.
	Phases sequence inverted	The machine is fitted with an electrical device that prevents the incorrect rotation of the tools. If the machine is not reset at the first switch on, cut off the power supply immediately and invert two of the three phases on the terminals (L1-L2-L3).
	Auxiliary circuit fuses protecting the transformer interrupted; or fuse holder cover open.	1 – Close the fuse holder Cover. If the machine does not start: 2- open the fuse holder Cover. 3- Check the integrity of the fuses and if necessary replace them. 4- Adjust the braking unit as described in section 20.8.
	Intervention of the thermomagnetic due to: - cable section insufficient in relation to the power of the motors; - voltage drop due to excessive length of the power supply cabe; - electric part in short circuit.	- The thermomagnetics are positioned inside the electric panel and protect the motors. - Resolve the cause of the machine stop and press the black pushbutton of the disabled thermomagnetic.
	Emergency on.	Switch off the button by turning it.
	Cowling open.	Close the cowling fully so that it triggers the safety micro.
	Lack of compressed air.	Open the sectioning valve Connect the pneumatic system.
	Compressed air insufficient.	Operate on pressure regulator. Check the compressed air supply line upstream of the machine.
	An error message appears on the electronic controller	See Chap. 20.42
The panel does not slide	The height of the feeder presser is not adjusted for the panel thickness.	Adjust the height of the feeder Presser based on the thickness of the panel, checking the measurement on the indicator C.
The machine does not start.	Panel still inside from previous machining	Remove the panel. The panels must only be inserted with the machine on. (Chap. 6.15.2)
The machine switches off during machining	Second panel inserted too soon	Insert the second panel only when the previous one has been trimmed

PROBLEM	CAUSE	REMEDY
The feed track does not start	The motors of the units have not yet reached the right speed.	Wait
The machine switches off during machining and goes in emergency	A piece of scrap is jammed	Clean the end trimmer unit from any machining residue or scrap that prevent the correct movement of the unit.
	Sensor S not in position or broken	Check the operation of the sensors S. The led on each sensor must switch on at the correct passage on each magnetic cylinder. Reposition or replace.

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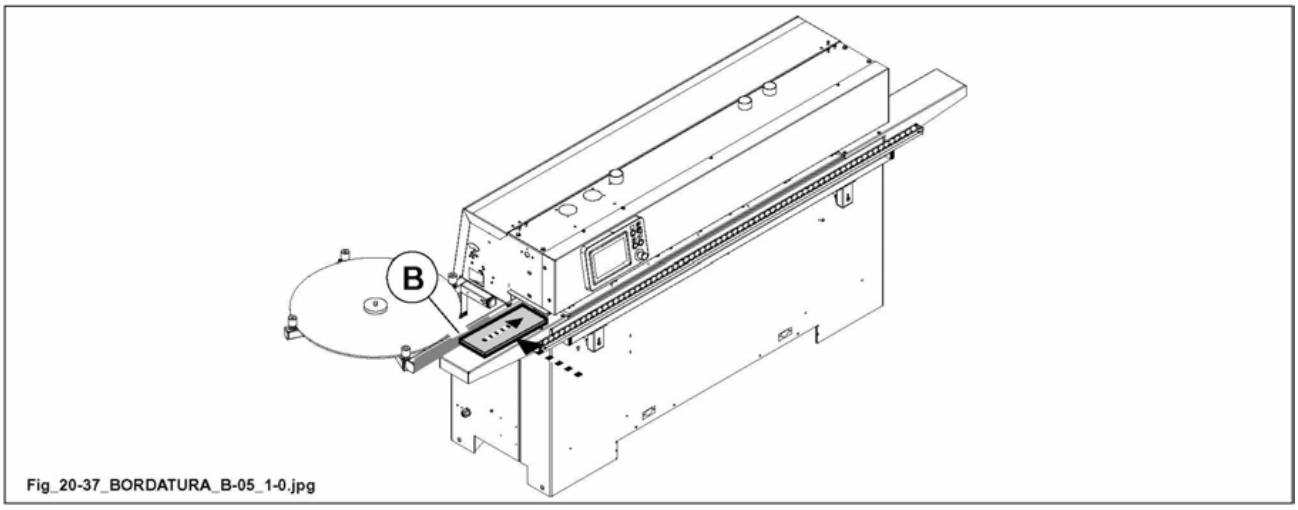

C
L 1
L 2
L 3
N
O
S
S
Fig_20-37_GENERALE_B-05.jpg

EDGE BANDING

PROBLEM	CAUSE	REMEDY
No glue on the rear of the panel.	Wrong panel insertion into the machine.	Keep the panel inserted in contact with the infeed guide.
The glue tank does not reach the set temperature.	1 or more heating elements burned out.	Check that the draw matches the one applied.
	The electric control is not working. The thermic probe does not operate	Check the operation and then replace it.
Too little glue on panel.	Closing of the doctor of the dosing device excessive	Open the doctor increasing the glue flow (Par: 6).
Glue quantity on the panel excessive.	Glue dosing device doctor too open	Close the doctor to decrease the glue flow (Chap. 6)
Irregular spreading.	Glue temperature set too low for the type of glue.	Consult the glue manufacturer and if necessary change the operating temperature.
	1 or more heating elements burned out. The electric control is not working.	Check that the draw matches the one applied.
	The electric control is not working. The thermic probe does not operate	Check the operation and then replace it.
Position not centred in the edging in relation to the panel.	Edging vertical stop adjustment too high in relation to edging to apply.	Adjust (Chapter 6)
The edging tears.	Edging vertical stop adjustment too low in relation to edging to apply.	Adjust (Chapter 6)
	Edge too dry.	Replace (Chap. 6)
	Presence of obstacles in the edging unwinding.	Check the unwinding, check and remove any blockages or faults.
Edging not regularly cut.	Insufficient pressure in the shear pneumatic circuit.	Adjust (see Chapter 6)
	Shear defective.	Check that the shear blade is sharp and if necessary replace it.
		Check operation of the electric and pneumatic system of the shear and if necessary replace the faulty part.
Edge gluing not uniform.	Insufficient pressure of the rollers on the edging.	Adjust (see Chapter 6)
Edge gluing not perfect.	Glue temperature wrong	Consult the glue manufacturer and if necessary change the operating temperature.
	Panel with non linear or not perpendicular edges.	The cut must be sharp, with no splintering and with a straightness of at least ± 0.1 mm per linear metre. The cut must be square (90°) both in relation to the surface and the thickness.
	Dust and humidity on the panel edges.	Keep the panels in a dry and clean environment.
	The temperature of the edge and/or the panel is too low.	Edges and panels must be kept at a temperature NO lower than 18 °C (32.4 °F).
	Large sized panels.	Support the panels and accompany them unit the machining is completed.
	Glue applied to the panel insufficient.	Increase the quantity of glue when the porosity of the surface increases.

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PROBLEM	CAUSE	REMEDY
	Glue perished.	The glue perishes over time losing the adhesive properties; change the glue.
	Glue in the tank finished.	Insert glue in the tank.
	The presser rollers unit is incorrectly adjusted.	Adjust (see Chapter 6)
	The electric control is not working. The thermic probe does not operate.	Check the operation and then replace it.
The edging does not slide.	Incorrect panel insertion.	The panel must be inserted by keeping it against the guide B and accompanying it as far as the feeder.
	Edging jammed.	Adjust (see Chapter 6)
	The edging feed rollers is dirty.	If wooden slats have been machined clean the roller from any residue.



END TRIMMING UNIT (ME 35 - ME 35T) - TESTING GROUP - ROUNDING UNIT (ME 35T - OPT)

PROBLEM	CAUSE	REMEDY
Imperfect cut	Glue residue on the tools or the track feelers	Remove the glue residue and clean the area
	Tools not sharp	Replace the tools (Par. 20.10.2)
The end trimmer unit does not start	The units have not been selected from the commands board and the control	Select
FRONT or REAR edging end trimming faults	The blade is not aligned to the panel sensor	Adjust the sensor (Chap. 6.6.1 – 6.6.2.2)

END TRIMMING UNIT with rounding function (ME 35TR)

PROBLEM	CAUSE	REMEDY
Imperfect cut	Inadequate copying value	Adjust the horizontal copy value (Par. 6.6.3.2)
	Glue residue on the tools or the track feelers	Remove the glue residue and clean the area (Par. 20.1)
	Tools not sharp	Replace the tools (Par. 20.10.8)
The end trimmer unit does not start	The units have not been selected from the commands board and the control	Select (Par. 5.5)
FRONT or REAR edging end trimming faults	Incorrect tool position	Adjust the operator group (Par. 6.6.3.2 - 6.6.3.3)

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TRIMMING

PROBLEM	CAUSE	REMEDY
Incorrect cross ways trimming	Incorrect cutters adjustment	Adjust the position of the cutters (Chap. 6.7)
Incorrect vertical trimming	Incorrect vertical sensor adjustment	Adjust the vertical sensors (Chap. 6.7.1)
Trimming not constant on the whole length of the panel	Track feelers do not constantly follow the panel surface	Increase the track feeling pressure (Chap. 6.7.1)
Imperfect trimming at the beginning of the panel	Incorrect copying units tilting	Adjust the track feeling pressure (Chap. 6.7.1)
Unit vibration	Incorrect installation or unbalanced tool	Check that tool is correctly fitted and balanced. (Chap. 6)
Edge chipped	The tool cutting edges are worn	Check that the tools are sharp (Chap. 20.10.3)

EDGE SCRAPER

PROBLEM	CAUSE	REMEDY
Edge machined badly	The edge scraper inserts are worn	Replace (Chap.20.10.4)
The edge scraper operates incorrectly in the horizontal direction	Incorrect edge scraper adjustment	Adjust the edge scraper (Chap. 6.8.1)
The edge scraper operates incorrectly in the vertical direction	Incorrect edge scraper adjustment	Adjust the edge scraper (Chap. 6.8.1)
Non-constant panel machining	Track feelers do not constantly follow the panel surface.	Increase the track feeling pressure (Chap. 6.8.1)

BRUSHES

PROBLEM	CAUSE	SOLUTION
The brushes no longer polish the edge	Brushes worn	Change the brushes (Chap. 20.10.5)
The brushes polish the edge excessively	Incorrect adjustment	Adjust the position of both brushes (Chap. 6.9)
One or both brushes are not working	Overload cut-out switch tripped	Reset the overload cut-out device (Chap. 20.37)

GLUE SCRAPER

PROBLEM	CAUSE	REMEDY
The glue is not removed	Vertical sensor incorrectly adjusted	Adjust the sensor (Chap. 6.12)
	Knife worn	Replace the knife (Chap. 6.12)
	Unit off	Insert the unit (Chap. 6.12)
	Glue residue on sensors or tool	Clean the unit (Chap. 20.1)
The tool marks the panel	Gluescraper unit not adjusted	Adjust (Chap. 6.12)

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RECTIFIER

PROBLEM	CAUSE	REMEDY
Panel splintered	Tools not sharp	Replace the tools (Par. 20.10.6)
Machined profile not linear	Feed track dirty	Clean the feed track (Chap. 20.1, Chap. 20.2)
	The cutters are not aligned with each other	Reset the alignment (Chap. 6.11)
Dust residue on the machined panel	Dust extractor system ineffective	Clean the unit (Chap. 20.1)

GROOVES UNIT

PROBLEM	CAUSE	REMEDY
Imperfect cut	Tools not sharp	Replace the tools (Par. 20.10.7)
The grooves unit doesn't start	The connector on the motor is disconnected	Connect the connector to the engine
	The grooves unit is excluded	Insert the grooves unit (Par. 6.13)
	The electric micro is not working.	Check the micro and the electric connection and replace it if necessary (Par. 20.7.1)
Dust residue on the machined panel	Dust extractor system ineffective	Clean the unit (Chap. 20.1)

SELF ADHESIVE LIQUID UNIT

PROBLEM	CAUSE	REMEDY
From one of the nozzles there is only air coming out	“Lc 2/10 Trinnmittel Gelb” liquid finished	Replace the tank (see paragraph 6.11.A)
	The liquid supply pipe is disconnected or damaged.	Connect or replace the pipe.
	The liquid supply pipe has insufficient suction lift.	Restore the correct suction lift.
Irregular liquid spraying	The operating pneumatic pressure is incorrect.	Adjust the pressure with the pressure regulator (3 BAR) (see paragraph 6.11.A).

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20.42 ELECTRONIC CONTROL ALARMS

(me35_20-42_0.0)

NOTE-INFORMATION:
When an ALARM SIGN first appears on the electronic control display, follow the indications below:
- ***switch off the machine (main switch OFF) and remove the piece to be machined***
- ***wait for 30 seconds and then switch it on again (main switch ON)***
- ***if the alarm persists, check the CAUSES and use the SOLUTIONS indicated in Chap. 5 "Diagnostics" of the attached manual of ELECTRONIC CONTROL.***
- ***if the alarm still persists, contact the assistance*** SCM***, always indicating the alarm number (see Chap. 5 "Diagnostics" of the attached ELECTRONIC CONTROL manual).***

20.60 UNSCHEDULED MAINTENANCE

(ad21_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.