



DC 400 DOUBLE HEAD ANGULAR CUTTING MACHINE

MANUAL USER



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1.GENERAL INFORMATION

1.1.INTRODUCTION

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

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

1.2. Information about the manufacturer



SÖNMEZ MAKİNE

**Araba yatağı mah. 1.Güçlü Sok.NO:40
16280 / Yıldırım / BURSA-TÜRKİYE**

Tel : 0224 367 04 41 pbx

Fax :0224 367 65 60

Email : sonmezpvc@hotmail.com

Web : <http://www.sonmakpvc.com>



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

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

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

AUTHORIZED TECHNICAL SERVICE CENTER ADRESS ;

Araba yatađı mah. 1.Güçlü Sok.NO:40 Araba Yatađı 16280 / YILDIRIM - BURSA

Tel : 0224 367 04 41 Pbx.

Fax : 0224 367 65 60

e-mail : hakan@sonmakpvc.com

rusian@sonmakpvc.com

web : <http://www.sonmakpvc.com>

For minimize the documantation,It is wery necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines.

***Machine's serial number**

***Date of purchase**

***Machine model**

***Average daily operation period**

***Voltage and freguency**

***Description of the machine fault**

***Name of dealer where machine was purchased**

1.3. WARRANTY

THE GUARANTEE CERTIFICATE

The NAME of FIRM of the : SÖNMEZ PVC ve ALÜMİNYUM İŞLEME
MANUFACTURER MAKİNELERİ SAN.TİC.LTD. ŞTİ
THE ADDRESS : ARABA YATAĞI MAH. 1.GÜÇLÜ SOK. NO:40 ARABAYATAĞI/16280 BURSA/TURKEY
TELEFON : +90 224 367 04 41 PBX
TELEFAX : +90 224 367 65 60
THE SIGNATURE AND
THE PRESS OF THE :
REPRESENTATIVE
OF FIRM
PRODUCTION KIND : DOUBLE HEAD ANGULAR CUTTING MACHINE
MARK : SÖNMEZ ,INTELLI-MACH
MODEL : DC-400
BANDIT ROLE and SERIES No :
DATE and DELIVERY PLACE :
GUARANTEE PERIOD : 2 YEARS
THE MAXIMUM TERM OF REPAIR : 30 WORKING DAYS
THE NAME OF THE AUTHORIZED
TRADING FIRM :

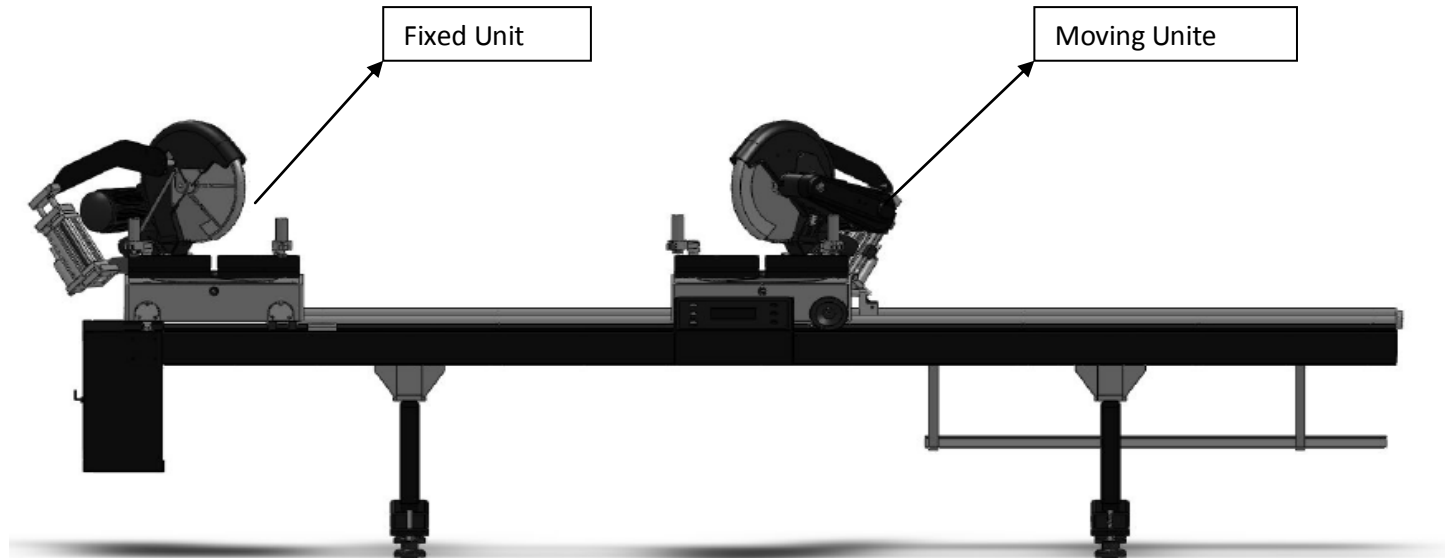
WARRANTY CONDITIONS

- 1.The warranty period is 2 years from the delivery date of the machine.
- 2.All parts of the machine are under the warranty of our company.
- 3.If the machine has a defect within the warranty period, the warranty period is extended by the repair period. The repair period of the machine is max. 30 working days. This period begins with the date of notification of the defect to the service station, or if there is no service station, to the authorized dealer, representative, agent, importer or manufacturer. If the defect cannot be repaired within 15 working days, the manufacturer or importer has to deliver the customer another machine with similar features until the repair has been completed.
- 4.If the machine has a defect due to material, workmanship and assembly fault, the repair will be carried out without any charge for parts, labor or any other charges.
5. The customer can request the replacement of the machine, or the return of the purchase price or discount in proportion with the fault if;- the same defect occurs more than twice within the stipulated warranty period after the delivery, or in case of more than four different defects within the stipulated warranty period., or if the total defects of different defects exceeds six defects, and makes the machine unusable, -the repair period for the machine is extended,- it is determined with a report of the service station, or in case that there is no service station, by the dealer, representative, agent, importer or manufacturer, that a repair of the machine is not possible,
- 6.Defects due to use of the machine in contrary with the features described in the machine's user's manual are excluded from the warranty.
7. In connection with any issues of the warranty certificate the customer may contact the General Directorate of

2. Machine's description and purpose of use

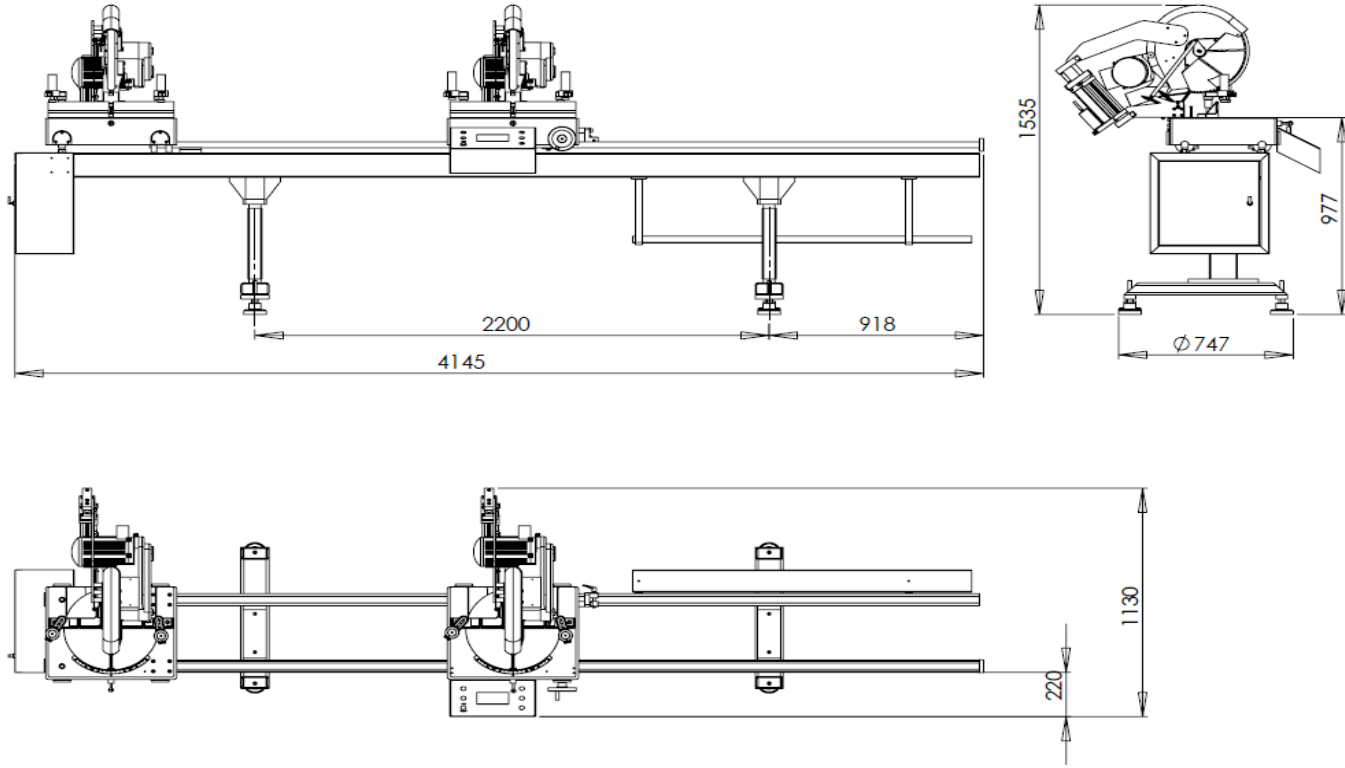
2.1 MAKİNENİN TANIMI

- PVC and Aluminium profiles, double and single, flat-Or-angle cutting operations designed to cut the desired size has double-sided circle saw cutting machine.
- progress in cutting hydro-pneumatic sawing according to the material and the desired feed rate precise adjustment is possible.Mengeneler
- Pneumatic two-hand safety and for the safety of the personnel available.
- Left cutting unit is still manual movement of the right cutting unit.
- Precise extent of degrees of 15°-22.5°-30°-45°-90° free-cutting other intermediate angles can be done with safety catch.
- machine is designed according to CE Directives.

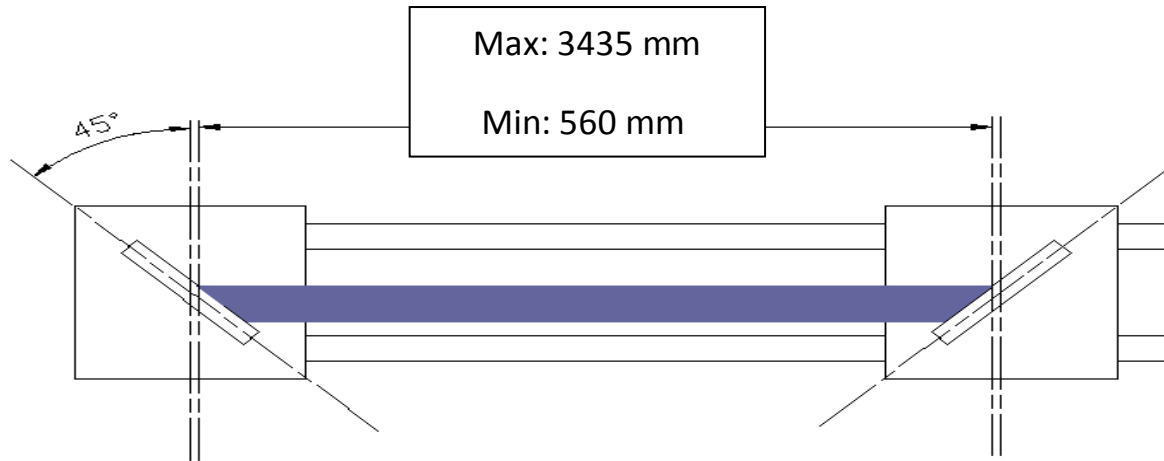


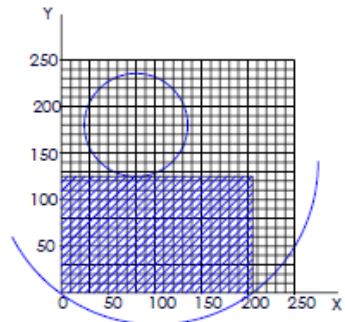
Şekil:1

							
2.2 kW	400V	3000	D: 400	46	6/8	W: 75	410
50/60Hz	AC 3 PE	D/dak	d: 30/32	Lt/dak.	Bar	L: 410	kg.
hız		RPM	mm			H: 170	
						cm.	

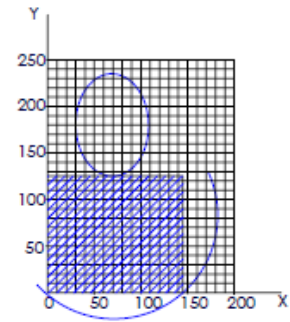


Shape:2

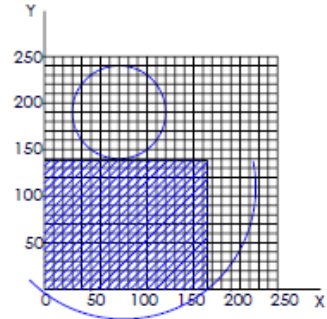




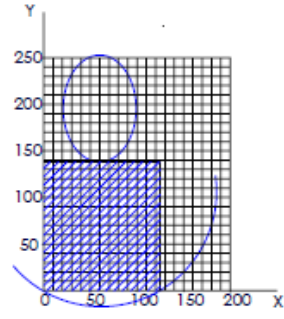
90° :205x138 mm



45° :145x125 mm

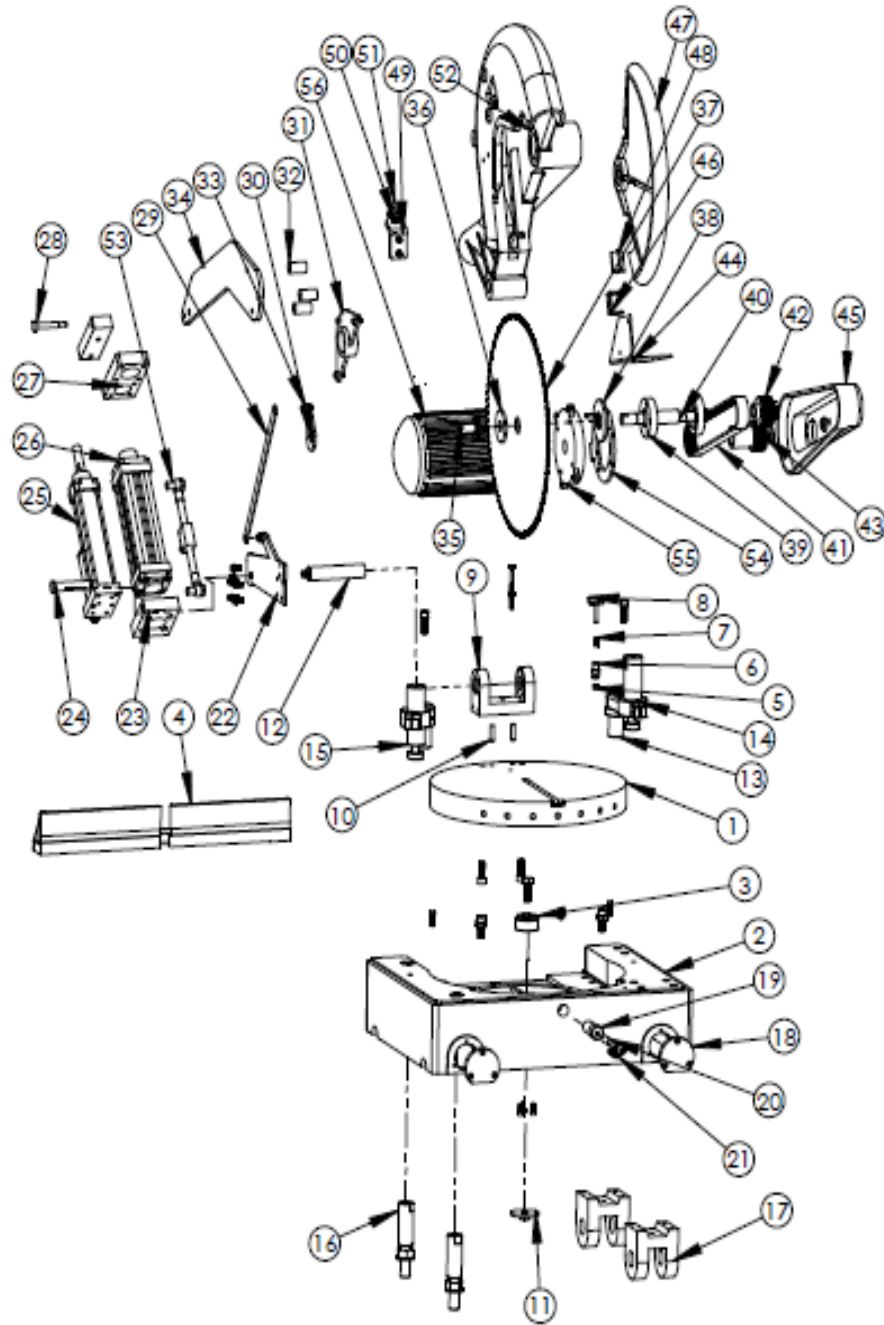


90° :175x138 mm



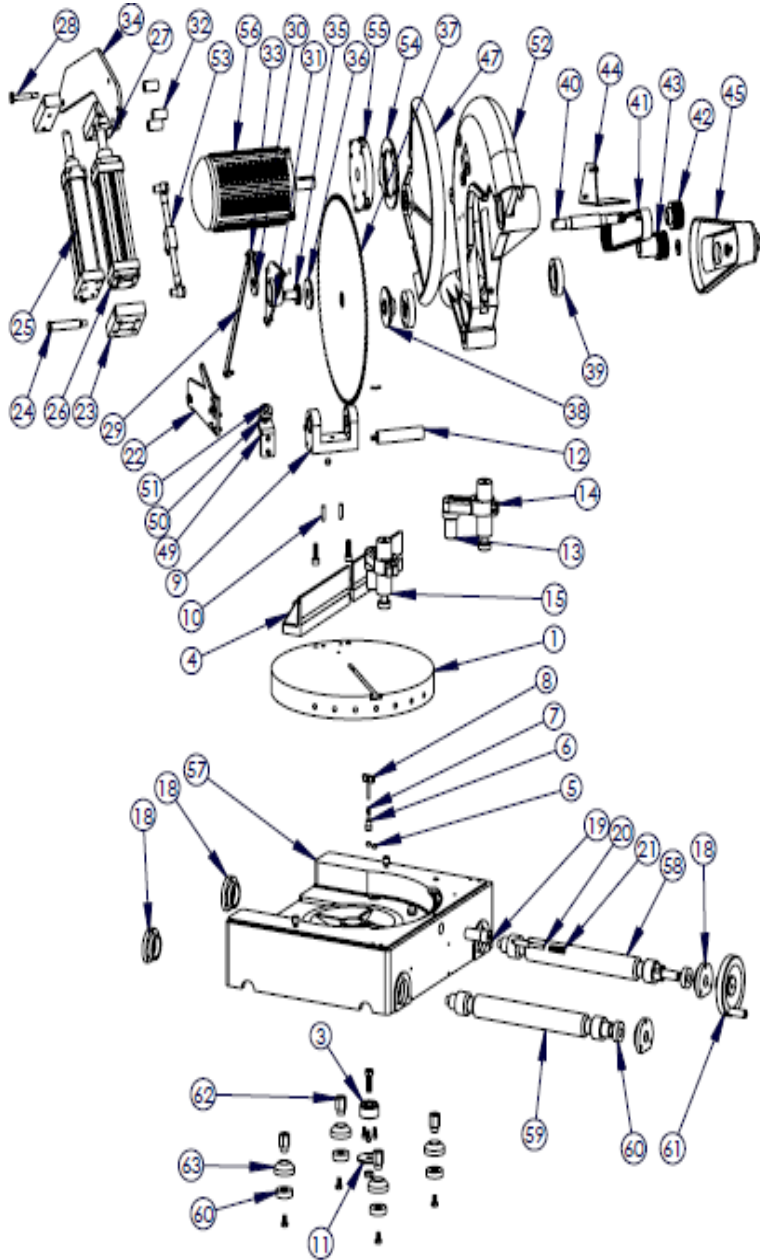
45° :125x138 mm

Fixing Unit



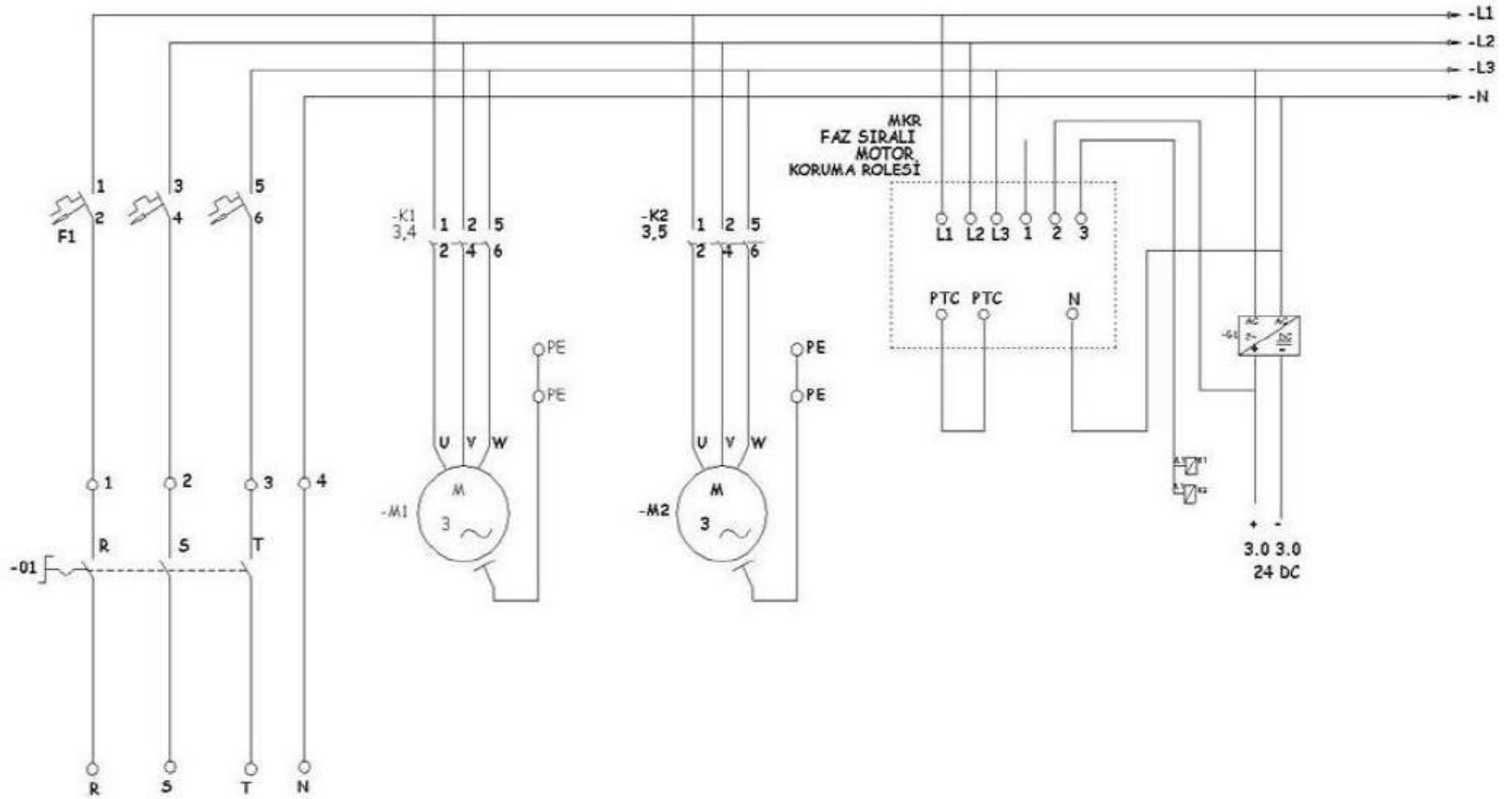
PARÇA NO	STOK NO	ADET
1	150.001.0301	1
2	150.001.0016	1
3	152.02.019-25	1
4	150.004.003	1
5	150.011.0097	3
6	152.02.019-03	1
7	152.02.019-32	1
8		1
9	150.001.0026	1
10		2
11	150.013.0017	1
12	150.02.019.49	1
13		2
14	150.001.0029	2
15	150.010.0009	2
16		2
17	150.001.0035	2
18		1
19	152.02.019.40	1
20	152.02.019.38	1
21	150.02.0188	1
22	150.013.0052	1
23		1
24		1
25	150.010.0052	1
26	150.010.0055	1
27		1
28		1
29		1
30		1
31	150.001.0017	1
32		3
33		2
34		1
35		1
36		1
37	150.011.0077	1
38		1
39		1

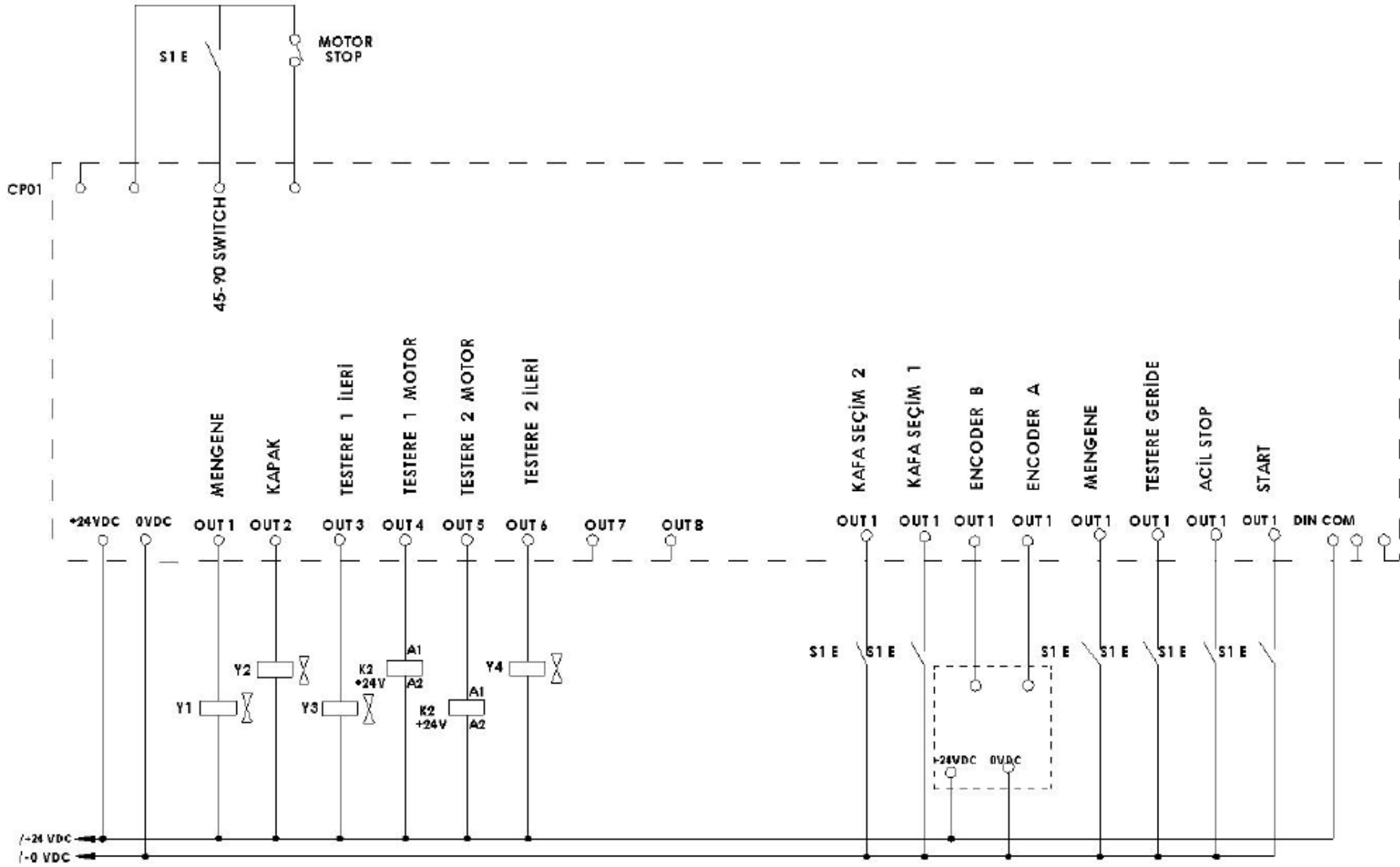
MOVING UNIT

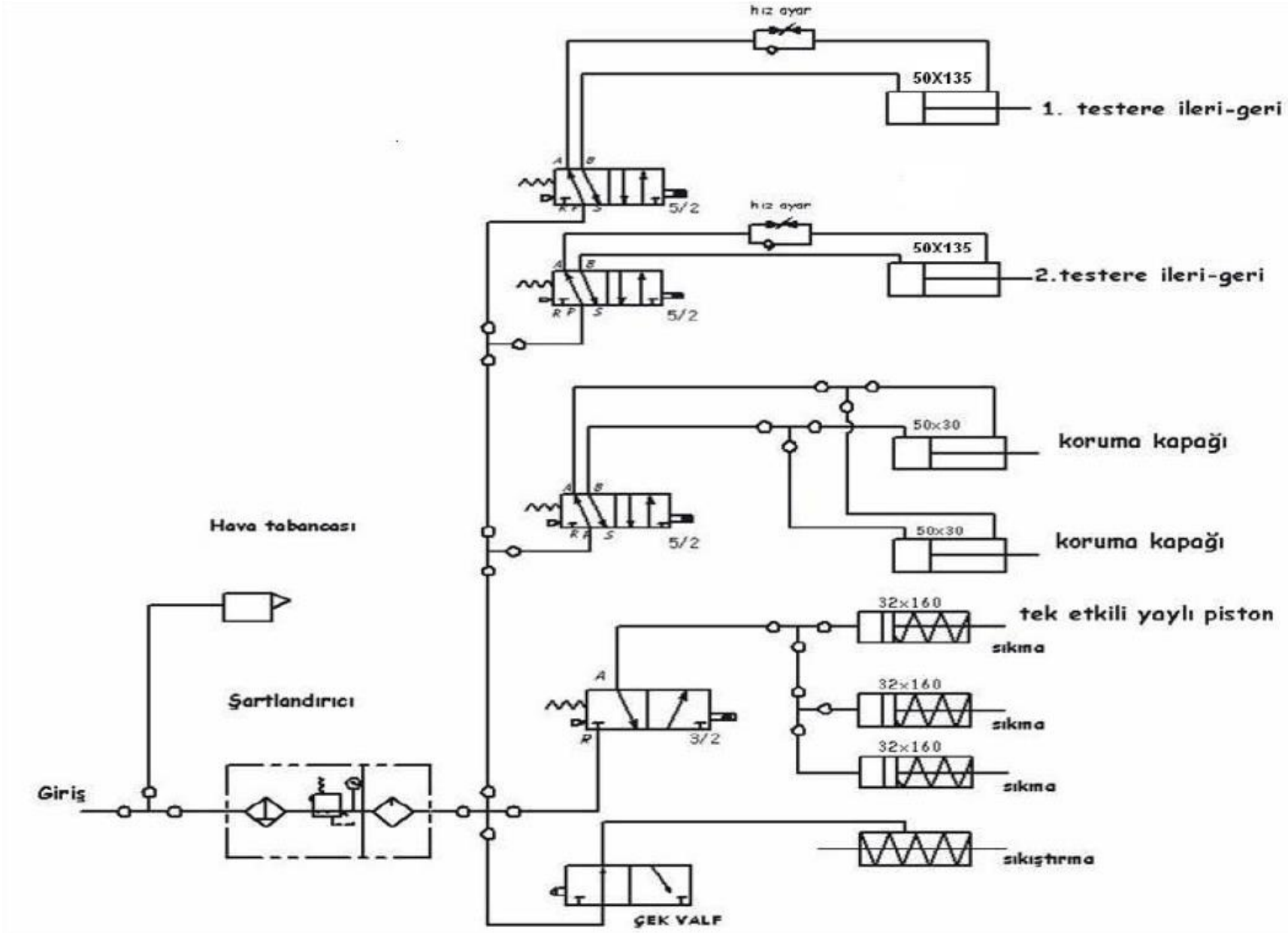


40		1
41	150.011.0074	1
42		1
43	152.02.0019-64	1
44		1
45	150.001.03.02	1
46		1
47	150.001.0007	1
48		1
49	150.001.0020	1
50		1
51		1
52	150.001.0303	1
53		1
54	150.013.0001	1
55		1
56	150.014.0015	1
57	150.001.0016	1
58		1
59		1
60		8
61		1
62		4
63		4

2.4 ELECTRIC AND PNEUMATIC TABLES







3.0 SAFETY

3.1. SAFETY INFORMATION

The symbols shown hereunder are necessary to be read with special attention. Not reading or observing of them may cause damage to the equipment or personal injury.

IMPORTANT

The IMPORTANT Symbol above is one telling to apply special care and to be careful at carrying out the specified operation.

CAUTION !

The CAUTION!Symbol above warns you against specific dangers,and requires to read the text.Not observing may cause damage to the equipment.



DANGER WARNING

The abovesymbol DANGER WARNING,warns you againstspecific dangers,and you have definitely to read them.Negligence may cause damage to the equipment and bodily injuri.

Read the user'smanual carefully before using the machine or carrying out maintenance works.



3.2. ACCIDENT PREVENTION

3.2.1. Our machines are manufactured in accordance with EN 60204-1 and EN 292-2 CE safety directives, which cover national and international safety directives.

3.2.2. 2 It is the task of the employer to warn his staff against accident risk, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.

3.2.3. Before starting to work with the machine, the operator should check the features of the machine, learn all details of the machine's operation.

3.2.4 . Machine should be operated only by staff members, who have read and understood the contents of this manual.

3.2.5. All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would

lead to the termination of the warranty.

3.3. GENERAL SAFETY INFORMATION

3.3.1. The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the and outlet sockets.



3.3.2. If the power cable should be damaged operation, don't touch and unplug it. Never use damaged power cables.

3.3.3. Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated valued..

3.3.4. Don't plase your hands between parts in motion .



3.3.5. Use protective eye glasses and ear plugs. Don't wear aversize clothes and jewerllery. These can be caught by moving parts



3.3.6. Keep your working plase always clean, dry and tidy for accident prevention and operation.

3.3.7. Use correct illumination fort he safety of the operator.(ISO 8995-89 Standart The lighting of indoor work system)

3.3.8. Don't leave anything on the machine.

3.3.9. Don't use any materials other than those recommended by the manufacturer for cutting operations on the machine.

3.3.10. Ensure that the work piece is clamped appropriately by the machine's clamp or vice.

3.3.11. ensure safe working position, always keep your balance.



3.3.12. Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let replace by a qualified electrician. Keep handles and grips free of any oil and grease.

3.3.13. Unplug first, before conducting and maintenance Works.

3.3.14. Ensure that any keys or adjument tools have been removed before operating the machine.

3.3.15.If you are required to operate the machine outside,use only appropriate extension cables.

3.3.16. Repairs should be carried out by qualified technicians only.Otherwise,accidents may occur.

3.3.17. Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer).

3.3.18. Don't use machines with improper functioning buttons and switches.

3.3.19. Don't keep flammable, combustive liquids and materials next to the machine and electric connections.

4.0 SAFE TRANSPORT OF THE MACHINE

IMPORTANT

* The transport should be done by qualified personnel only.

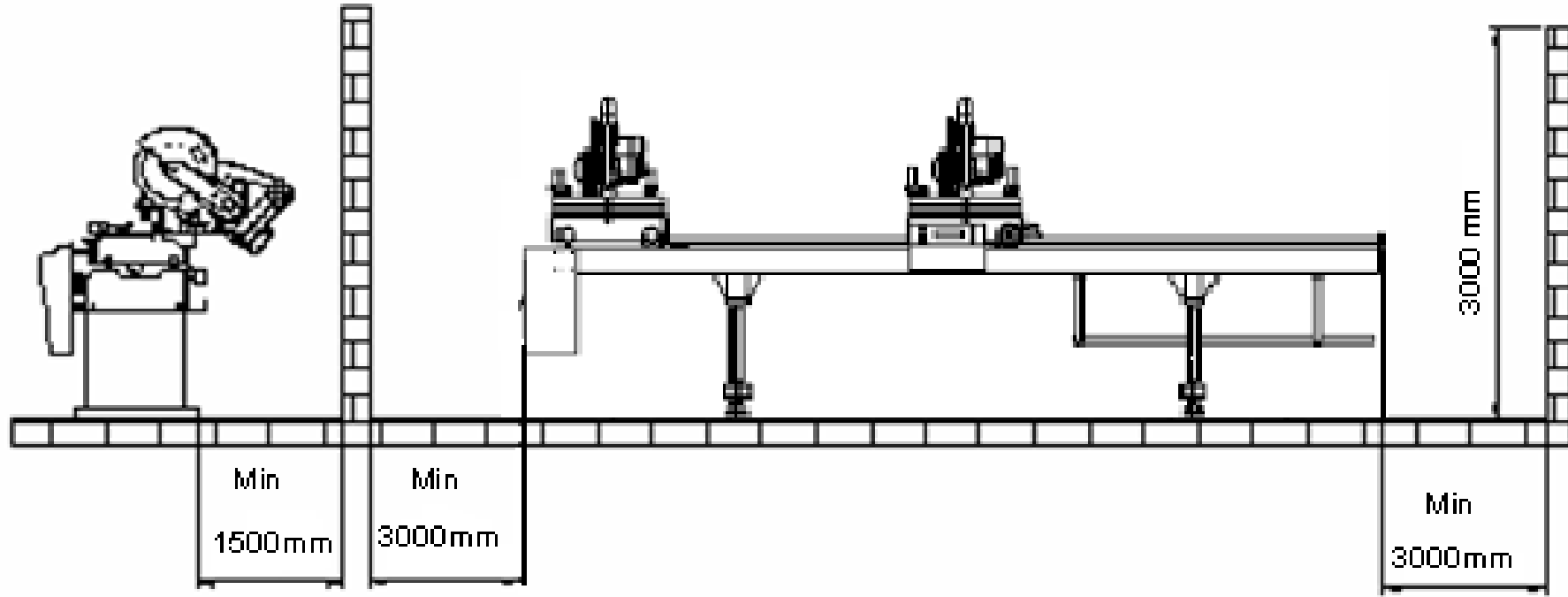
The machine should be transported by lifting with proper equipment (not touching the ground during the transport).

Don't lift the machine before ensuring that lifting devices or other equipment is placed properly under the machine.

5. MACHINE SETUP

Distance of at least 100 cm olmalıdır. Makinenin position of the machine at the back of the rear wall cut parts sawdust and chips bag collection port, hydro-pneumatic system, the cable channel places, with electrical power connection plug is counter ENCODER digital reader.

Be put into the machine surface is hard, smooth and carry the weight of the machine must have a ground.



Şekil:3

IMPORTANT

5.1. PREPARATION

5.1.1. Remove the transportation safety fittings before starting the machine. Do not remove the parts of the electrical and pneumatic connections link to the safety of shipping.

5.1.2. Keep in mind you can use transportation safety connections removed in later shipments.

5.2. SECURE THE MACHINE CONNECTING THE POWER SOURCE

5.2.1. ELECTRICAL CONNECTION

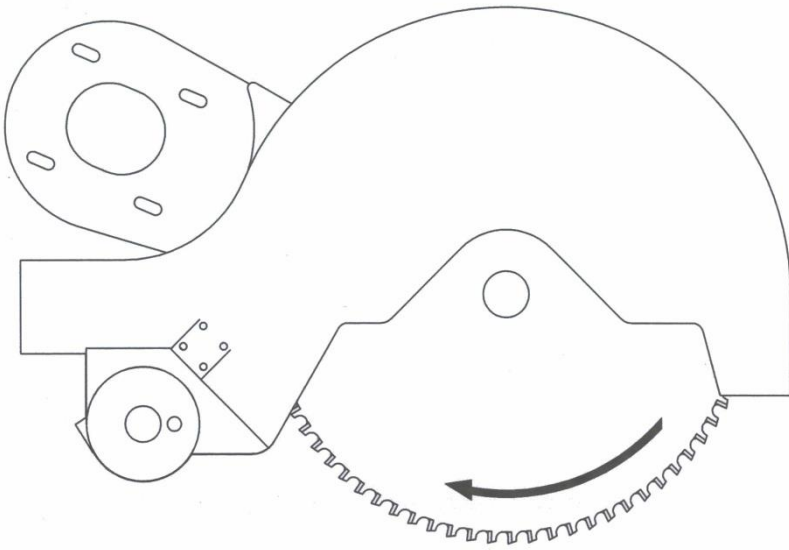
5.2.1.1. Apply the power cord from the machine using a cable H07RNF CE Standards.

5.2.1.2. Input energy to the machine, be sure to check before applying power.

CAUTION !

*** Electrical connections should be made by a licensed electrician in the machine running direction of rotation is observed in the opposite direction if the direction of rotation of the saw should be reviewed and the appropriate connection terminals must be.**

**** If you reverse the rotation direction of the saw could be dangerous for the operator and equipment. The teeth of the saw will cause deterioration and breakage.**



SHAPE:4

5.2.1.3. Connect the electrical power to verify direction of rotation of the saw machine, username, and follow the following applications.

a- Press the Start button.

b- Press the Stop button. Observe the direction of rotation of the circular saw blade enclosure in terms of open

c- Flat blade rotation direction is as shown in Figure 4.

This application is turned upside down blade is seen at the end of;

Revised and corrected by a licensed electrician electrical socket connections. Do not use the machine direction of rotation of the saw being tested.

5.2.2 AIR PRESSURE SETTING

Pneumatic air pressure to operate the system in a healthy 7-8 bar gerekmektedir.6 be less pressure bar set pressure and to control çalıştırmayınız.Hava conditioner read on the pressure gauge.

Air Pressure Settings for the following applications follow.

5.2.2.1 Pull up the adjustment knob Conditioner.

5.2.2.2 Adjustment knob is turned clockwise direction increases the pressure, the pressure is turned in the opposite direction reduced.

5.2.2.3 When you read on the pressure gauge 7-8 bar pressure adjustment knob lock conditioner.

5.2.2.4 Conditioner unit, the water in the pneumatic air system to avoid damage to the system kompenetlerine accumulates into the collection container. Periodically (the end of the working day) collected from pressing the button on the bottom to drain the water conditioner Drain water cylinder tank.

5.2.2.5 Used in the manufacturer's recommended oil conditioner TELLUS C 10 / BP ENERGOL HLP 10 / MOBILE DTE LIGHT / OIL OFFICE SPINDURA is 10

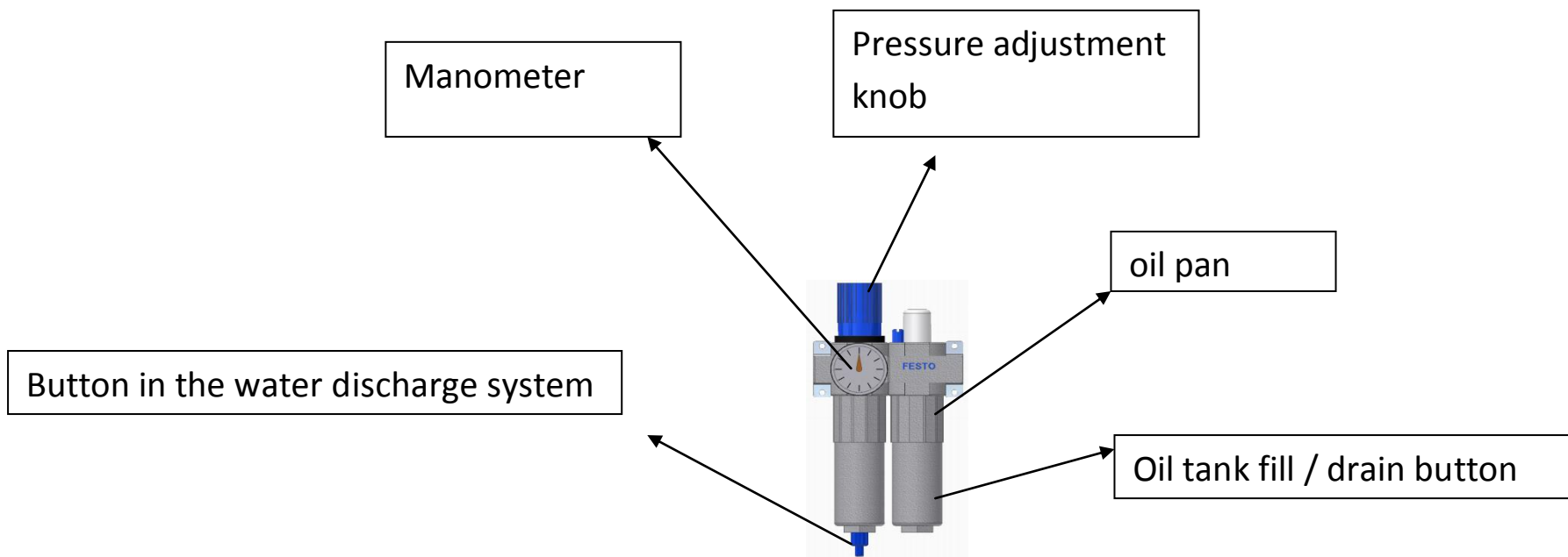


Figure:5

6. MECHANICAL SAFETY INFORMATION

6.1. Saw maintain protective safety equipment, such as by removing the cover and it is forbidden to work

6.2 400V ~ 50Hz 3 Phase machine is used. The machine is done by a licensed electrician for electrical installation

6.3 Lift the machine, insert, electric and pneumatic maintenance work to qualified and authorized personnel should be used.

6.4 Routine maintenance work scheduled maintenance by authorized and qualified personnel should be done after deactivation of electrical and pneumatic power sources.

6.5 Cleaning the machine before working on the machine, make sure that the test is made and maintained.

6.6 Safety equipment, electrical power cord and check the moving parts of the routine. If you see damage to equipment or parts to fulfill the functions of security with a new one without changing the machine operate.

6.7 Electric power connection and replace the air pressure cutting circular saw is definitely.

6.8 Keep foreign objects anywhere within the area of operation, do not insert your hands in between the moving parts.

IMPORTANT

To prevent loss or damage to equipment safety information tanımlanmıştır.Fiziki above, please read the safety instructions carefully and always keep in mind.

7. OPERATION

7.1. GENERAL INFORMATION

7.1.1. DC 400 Cutting machines with iron alloy of aluminum and hard plastic material products, made from wood cuts. According to the type and size of the cut-off saw operator cut the material progress of the settings. (Manually) Circular saw blades cutting edge interior and exterior ensures that you get high-quality smooth surface. Depending on the camera metering system and the size

of the material dimensions of digital reader (Display) system provides the ability to acquire precise measurement with a piece cut size.

7.2 SIZE and SET INSTANCE

DC 400 electrical and pneumatic connections are secure cutting machine cutting lengths after the completion of the application is appropriate tolerances, the dimensions and angles;

a) Height adjustment and

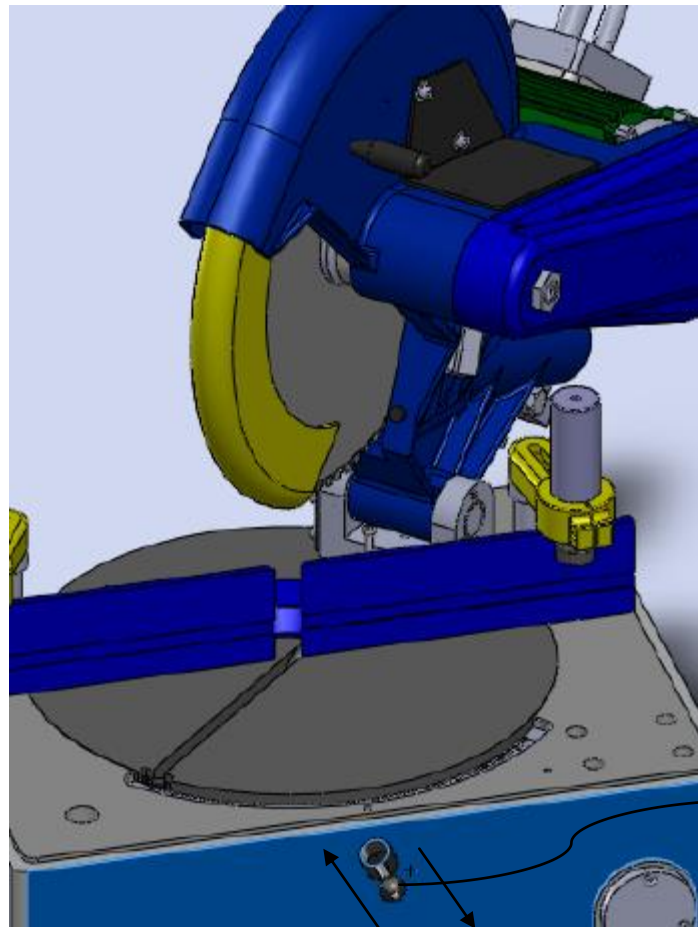
b) Provided with appropriate adjustment to degrees.

a-) Distance setting to 90 ° segments

Moving head unless otherwise requested, using the measuring system to be rude turn feature on the chassis. Moving the metering head on the rotating flywheel is located on the right or left lens and precisely with the aid of a digital reader (+ / - 0.1) of the desired scratches.

b-) Grade sections of the

Each head rotary tables on the distance between 15 ° -22.5 ° -30 ° -45 ° securing with safety catch. Taking measurements at 90 ° of the application process is the same.



Grade fixing safety catch shaft

7.2.1 Pull the safety catch shaft Snap slot.

7.2.2 The desired degree turntable (cutting head) to the right or to the left by pushing the set.

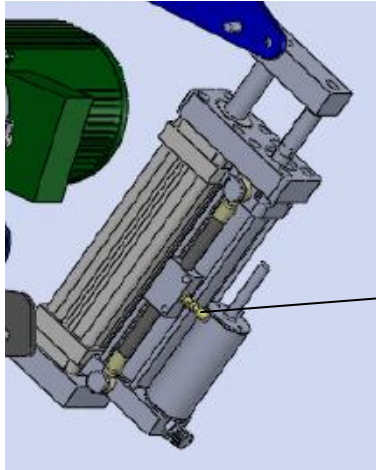
7.2.4 15°-22.5°-30°-45° degrees snaps into the slot by pushing the safety catch shaft.

7.3 CUTTING SPEED ADJUSTMENT

7.3.1 DC 400 Double head cutting machine saw blade cutting speed setting, and the two groups to work simultaneously and reduce the loss of time is important in order to ensure the smoothness of the surface of the workpiece

7.3.2 Hydro-pneumatic system with two on each set of cut-off valves on the choke by means of the set of two blades can be separately adjusted independently of each other.

7.3.3 With Saw Cutting feed speed throttling speed is set by tightening the adjustment screw until the desired progress is achieved.

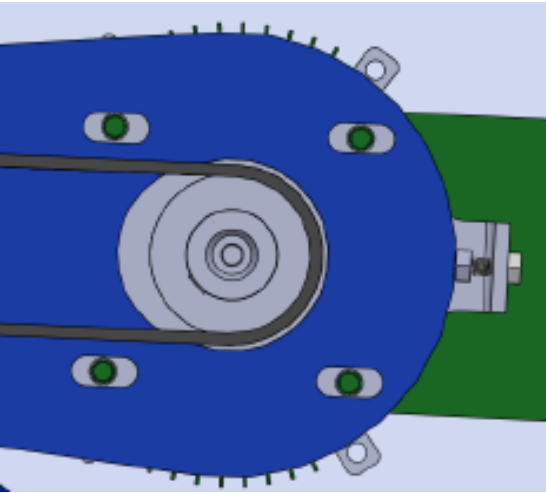


Speed adjusting
screw

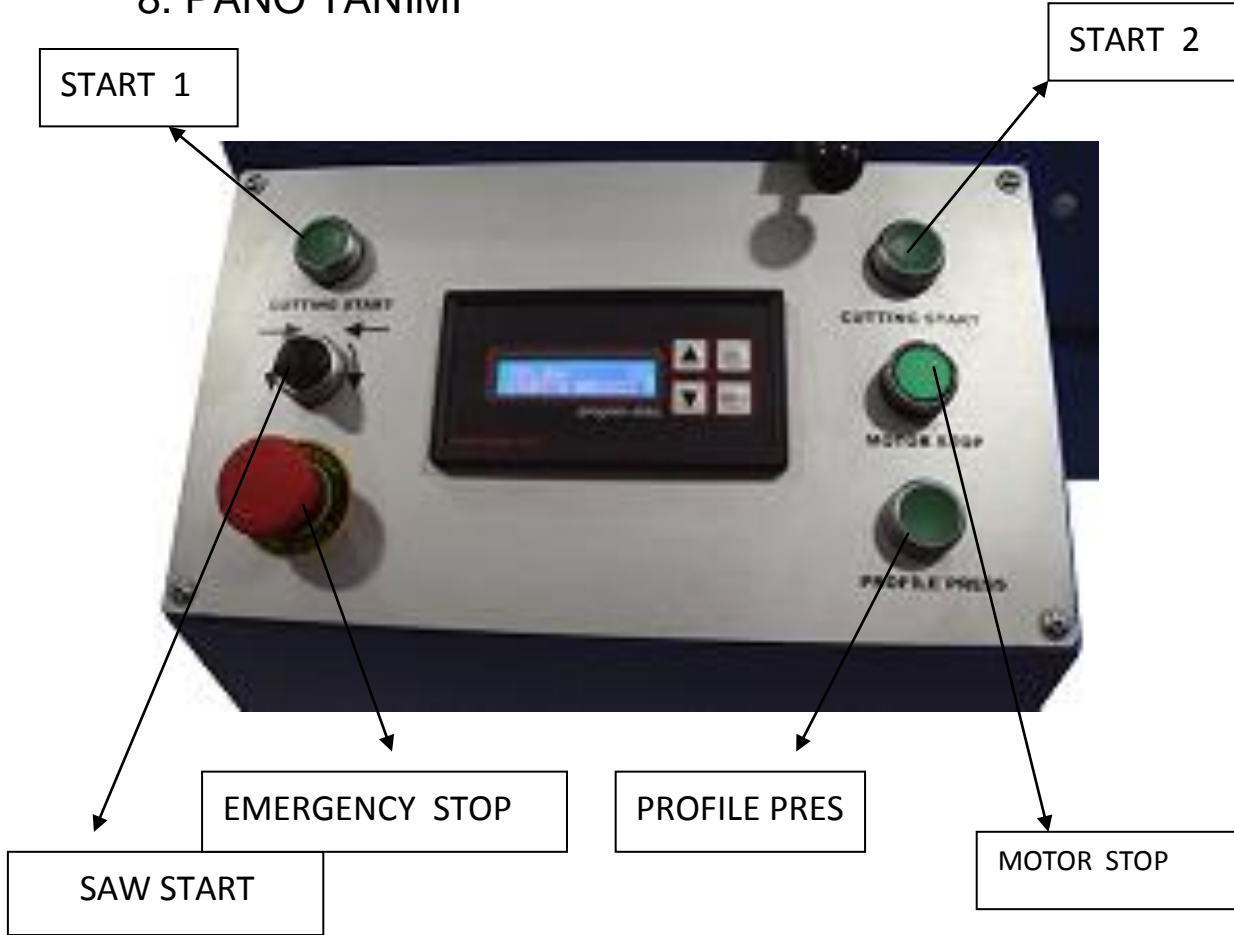
7.3.4 The inverse of the above article please slow progression of cutting band saw blades and saw both the head group to run concurrently with each other, provide.

7.4 Fixing BELT TENSION

Approximate distance of 10mm from the top with your fingerpressing the belt tension set so that the belt stretch and tighten the bolt.



8. PANO TANIMI



- 1- **START 1** and **START 2** buttons is pressed, the machine starts to work at the same time.
- 2- **ENGINE STOP**: Engines used to stop.
- 3- **PROFILE PRESS** pvc profiles used to compress placed on the machine.
- 4- **EMERGENCY STOP** button is pressed, the machine stops the process. This button is used in emergency situations.
- 5- **CARD DISPLAY** is used to enter the parametric settings.
- 6- **SAW START** çalıştırır.Ortada saw for a single unit, while the two testereyide runs.

9 PARAMETERS

Enter the required parameters can only stay if.

_ Disconnect energy of the machine tool.

_ Hold pressed the Menu button.

_ Pressing the Menu, connect energy.

VICE IN

Pressing the Start girisZamanı clamp circuit. 1 machine is time. Unit 1/10 sec. For example, enter a value of 10 for 1 second to enter the

COVER IN
5

Time of actions of covers of safety. Time of 2 actions work
Unit is 1/10 sec . For example to enter 1 cek put 10 valude

MOTOR START
5

Motor operating time. Time of 3 actions work.

MOTOR NEXT
10

Time after the beginning of work of the motor, movement in saw before. Time of 4 actions work

MOTOR BACK
45

Time after the beginning of work of the motor, movement back. Time of 5 actions work

COVER EXIT
5

Return action of covers of safety . Lately machine tool Works.

VICE OUT
1

Back to clamp the output time.

BÖLEN
1

Value of the digital sizes a card.

OFSET
500.0mm

The maximum value of the sizes a card

45-90 OFSET
8mm

The minimum value of the sizes a card

EMERGENCY STOP
BUTON
NO / NC

Choice at the discretion of used type the emergency stop button

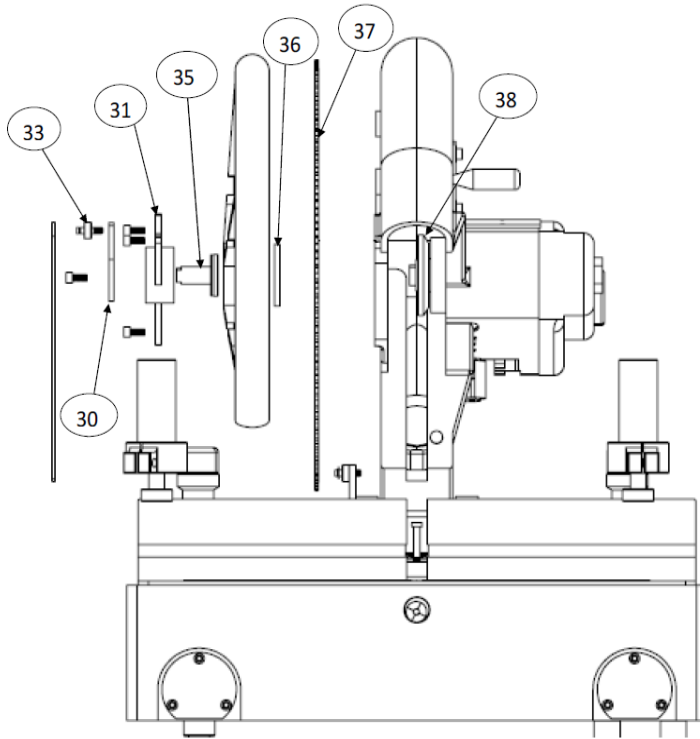
NO (in norm Incl.) or NC (in norm Off)

ÇARPAN
1

Extremely precise measurement value



This parameter changes language standart languages are Turkish.English and Russian.Optional you can have Romanian, French and Spanish versions available when you change language all menu Messages change.



10. SAW SAFE INSTALLATION

- 1Bolts by turning them counterclockwise take it out.
2. No. 31-35-36 Remove the parts in an orderly manner
3. Carefully remove the saw.
4. Insert the correct direction of rotation on the shaft, making sure that the saw.
5. Connect with other parts of the sequence.
6. Please tighten the Bolts last checkups.

11. MAINTENANCE

11.1. ROUTINE CHECKS and MAINTENANCE

11.1.1 STARTING



11.1.1. In any part of the table and make sure it is clean and dry. Clean and dry the oil tray. In particular make sure that the foundation of retaining lugs and cleaning.

11.1.2. Clean all surfaces of the grinding machine, chips and foreign materials. Use goggles to protect against harmful substances.



11.1.3. The saw blade before each use for wear, warping, cracking and check against breakage. If the saw blade is damaged, replace it.

11.1.4. If you need to check the air pressure in the air pressure system, pressure 7-8 bar set around

11.1.5. Air pressure filters and the amount of fat is missing please check the oil level şartlandırıcıdaki complete.



All of these procedures before making connections to the electrical power connection and air pressure off.

11.2. END OF DAY CARE BUSINESS

11.2.1. Electrical and pneumatic power connections off.

11.2.2. All surfaces of the machine burrs, chips, and clean foreign materials. Use goggles to protect against harmful substances.

11.2.3. Clean the tray and wipe it dry.

11.2.4. Tray with a thin layer of engine oil to protect against rust creep. If you are a protective grease to be used for a long time.

11.2.5. To protect against corrosion the surface of both sides of the saw machine with a protective lubricant oil or grease.

12. POSSIBLE ERRORS AND REMOVAL

PROBLEMS	REASONS	SOLUTION PROPOSALS
Low surface quality (aluminum and similar materials): Rough Surface, Rough, Inhomogeneous surface, Saw marks a very significant	Saw cutting surfaces of the cold in	Saw cutting surfaces of the oil expulsion, The use of the coolant
	Faulty or worn incisors to use the saw	Check the saw teeth can be broken teeth. If you find an error Replace the saw.
	Saw a very fast cutting feed	According to the material advancement of cutting more. Delay time for cutting feed.
Engine Inoperative (down the engine start button does not work)	The machine has no connection to electrical power	Check wiring and connections.
Engine runs, but the group saw Despite the cut-off come down to pressing the start button.	Air power supply connections are missing or incorrect Moving cutting unit has not been activated on the brake system. Position of Vice-tightening is not	Check the connections for air compressor Adjust the air pressure from 6-8 bar on the machine şartlandırıcıdan Moving cutting unit is activated by turning the button on the brake system to squeeze getirin.Mengenelerin Provide material.
Saw turns in the opposite direction.	Electrical connections, power cord or faulty connection panel	Electrical connections must be done by a qualified electrician licensed and.
Profile clamps work pitfall	Air power connector is missing or air pressure is low Moving cutting unit has not been activated on the brake system.	Review the air connections. Moving cutting unit by turning the button in the active position of the brake system.

