PLEASE READ CAREFULLY: IT IS VERY IMPORTANT

Before connecting up the machine, ensure that the factory voltage corresponds with that of the machine which is shown on the nameplate. If, for any reason, the voltage of the machine should be changed, it is imperative that the voltage to the transformer is also changed. To do that, it is enough to change the position of the plug in the voltage-changer (placed in the control box) to the right voltage.

1) CONNECTING UP OF THE MACHINE already filled with oil

The machine is delivered already tested at our works and the motor inside the base - is connected to the requested voltage; Access to the motor is gained by removing the front cover on the base. The pump is working in the right direction when, by switching on the motor - through the switch n. 10 -, the arm moves upward. If it does not (the arm does not move), change the polarity of the connections.

2) CONNECTING UP OF THE MACHINE without oil

1st quality hydraulic oil of 3,5°-4° Engler at 122° F. must be used (ISO46 type). The machine is normally delivered with a full complete-ment of oil. If it is not the case, you must fill the tank of the machine with 45 Kg. of oil about - through one of the side covers n. 15 - as follows:

a) fill the tank with the oil till it reaches the red line of maximum level.
b) release the lever n. 4 by moving it from the left towards the middle of the arm and then, by moving it back to the left, lock it again. (Setting-up of the stroke end). If the lever n. 4 is already released (this may happen during the transport) it is enough to move it to the left to lock it.
c) switch on the motor - through the switch n. 10 - and follow the same instructions described at paragraph 1).
Turn the handwheel n. 5 anticlockwise to the stop, so that the arm will move softly upward to the maximum limit.
d) operate the machine (which is now adjusted for the maximum stroke) by means of the pushbuttons n. 1 and n. 7 for some minutes, in order to exhaust all the air in the pipes and cylinders.
e) turn the handwheel n. 5 clockwise, till the arm - by lowering softly - arrives at 5 mm. about from the cutting table.
At this point (with the arm at 5 mm. from the cutting table) check the oil level in the tank; if necessary, add some further oil till it reaches the red line of maximum level.
This is the only way to be sure that the right quantity of oil is in the machine.

3) FUNCTIONS OF THE CONTROLS

a) the handwheel n. 5 raises and lowers the arm. By turning it anticlockwise the arm raises; by turning it clockwise the arm lowers. Operate the handwheel while the machine is running.
b) the lever n. 4 controls the stroke end of the arm, i.e. the cutting

c) Turn the handwheel n. 5 clockwise till the arm gently contacts the cutting knife. Be very careful in this operation.
d) Release the lever n. 4 by moving it from left to right. The stroke end device will set-up automatically; then lock the lever immediately by moving it from right to left.
e) Turn the handwheel n. 5 anti-clockwise till the arm - by raising - can turn freely over the cutting knife. In this operation consider also the thickness of the material that you will have to cut.
f) The machine is now ready for working with any cutting knife which has the same height as the one employed to adjust the machine.
g) Whenever you change the height of the cutting knife, you must readjust the machine as above described.

POSSIBLE TROUBLES AND THEIR ELIMINATION

1) Pressing the pushbuttons has no effect:
a) Check the pushbutton microswitches
b) Replace the printed circuit card inside the control box, on the right side of the machine.
To remove it, press the two hooks and slip the printed circuit card.

2) Breakage of the cable that sets the arm stroke through the handwheel n. 5:
The breakage of this small cable causes the immediate raising of the arm beyond the upper maximum limit and the motor n. 9 turns hardly.
Switch off the motor at once through the switch n. 10.
Replace the cable.

3) The arm comes down but does not cut:
a) Check whether the pipes inside the machine are losing pressure.
Access to the pipes is gained by removing the left cover n. 15.
b) Check the pump.

IMPORTANT

For the prompt supply of spare parts we need to know:
a) Type and Serial n. of the machine
b) Number of plate in catalogue
c) Reference number of the spare part
d) Quantity required.

For example: n. 2 pieces - Part n. N312 - Plate n. 3 for G/999 press

Serial n.

end. By moving it from left to right, you release the lever and the stroke end device sets-up. By moving it from right to left, you lock the stroke end device in the required position. During the cutting operation, this lever must always be locked to the left.

c) the arm can be moved both to the left and to the right (with a total rotation of 150° about) by means of the two handles.
The handle on the right of the arm has a pushbutton which operates the microswitch n. 7.
The handle on the left of the arm has three pushbuttons which operate the microswitches n. 1, n. 2, n. 3 - which are the selectors of the cutting stroke end delay (the operator has no longer to adjust the delay whenever he changes the size of the cutting knife. The advantage of this pushbutton system is well obvious).
In order to operate the machine you must press two pushbuttons: always the pushbutton n. 7 and, according to the size of the cutting knife, one of the 3 other microswitches:
- microswitch n. 1 (on the left of the handle) if the cutting knife is small and the material to cut is tender.
- microswitch n. 2 (in the middle of the handle) if the cutting knife is middle-sized and the material to cut is quite hard.
- microswitch n. 3 (on the right of the handle) if the cutting knife is large and the material to cut is particularly hard.

In pratice, the operator, after a short period of working on the machine, will choose instinctively the most suitable pushbutton for every cutting knife. The two pushbuttons must be kept depressed until the arm starts its upward movement.

d) the potentiometer n. 6 can increase even more - and gradually - the delay of the cutting stroke end when you press microswitch n. 3. Microswitches n. 1 and n. 2 are not connected to this device.
Anyway, the potentiometer must be employed only in special cases. For example, when you have to cut very hairy or very hard materials and consequently you need that the cutting knife penetrates a bit into the cutting pad - or - the cutting pad is much worn-out and therefore it is no longer flat. In the last case, it would be better to get the cutting pad planed instead of using the potentiometer.

e) the stroke end safety microswitch n. 13 has the function of avoiding that, owing to a breakdown in the stroke end, the arm - devoid of its control - keeps on lowering and plunging the cutting knife into the cutting pad with all the foreseeable consequences.
The operator, if the safety microswitch gets into action, will notice a jolting movement of the arm on the cutting knife when he keeps the two pushbuttons pressed - or - he will notice that the cutting knife plunges 1 mm. more than usual into the cutting pad and consequently he cannot remove the cutting knife by hand.

4) ADJUSTING OF THE STROKE END AND THE STROKE OF THE ARM

To adjust the stroke end of the arm, i.e. the cutting end, act as follows:

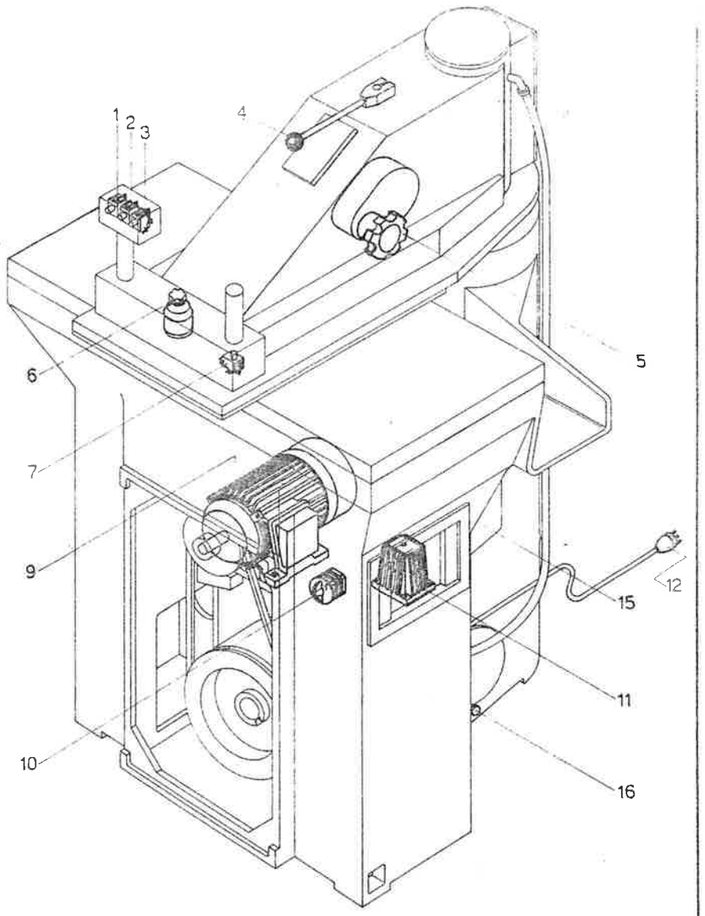
a) place the cutting knife in the middle of the cutting pad, without any material to cut.
b) Bring the arm over the cutting knife, but do not cover it completely so that you can see a part of it.

ISTRUZIONI PER L'USO

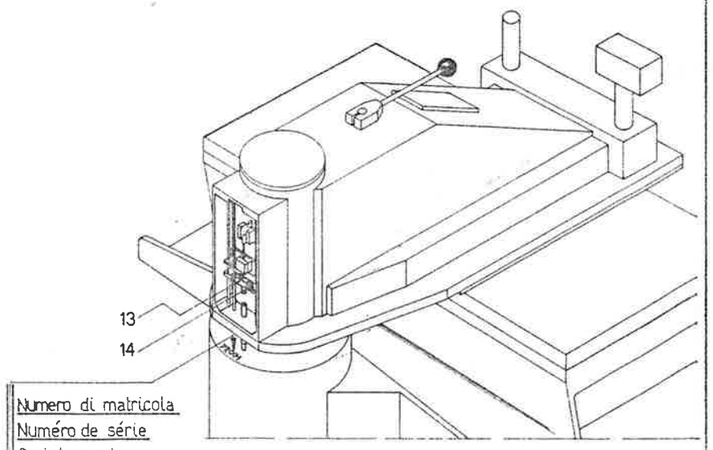
G.SSS ST. / 1000 x 500 / band. 600 / 25 tonn.

TAVOLA 1

1 Pulsante del selettore per fustelle piccole	1 Poussoir pour la découpe avec d'emporte-pièces petites	1 Cutting microswitch for small-sized knives
2 Pulsante del selettore per fustelle medie	2 Poussoir pour la découpe avec d'emporte-pièces moyennes	2 Cutting microswitch for middle-sized knives
3 Pulsante del selettore per fustelle grandi	3 Poussoir pour la découpe avec d'emporte-pièces grandes	3 Cutting microswitch for large-sized knives
4 Leva per regolazione fine corsa	4 Levier à régler la fin course	4 Arm stroke end adjusting lever
5 Volantino regolazione bandiera	5 Volant à régler la course du bras	5 Arm stroke adjusting handwheel
6 Ritardatore	6 Retardateur à potentiomètre	6 Potentiometer
7 Pulsante per uso macchina a due mani	7 Poussoir pour la découpe	7 Cutting microswitch
9 Motore pompa	9 Moteur pompe	9 Pump motor
10 Interruttore generale	10 Interrupteur général	10 Main switch
11 Elettromagnete	11 Electro-aimant	11 Electromagnet
12 Presa di corrente	12 Prise de courant	12 Plug
13 Microcontatto di sicurezza sul fine corsa	13 Microinterrupteur de sûreté de fin course découpe	13 Safety microswitch on cutting stroke end
14 Contatto di fine corsa	14 Pastille de contact de fin course découpe	14 Cutting stroke end contact
15 Riparo laterale	15 Couvercle lateral	15 Side cover
16 Tappo di scarico olio	16 Vis de décharge huile	16 Oil discharge screw plug



1 Pulsador del selector para troqueles pequeños	1 Mikroschalter zum Stanzen mit kleinen Stanzmessern
2 Pulsador del selector para troqueles normales	2 Mikroschalter zum Stanzen mit mittelgroßen Messern
3 Pulsador del selector para troqueles mas grandes	3 Mikroschalter zum Stanzen mit großen Stanzmessern
4 Palanca para regular el final de la carrera	4 Hebel zur Einstellung der Hubbegrenzung
5 Volante para regular el brazo	5 Handrad zur Einstellung der Hubhöhe
6 Regulador	6 Verzögerung fur Potentiometer
7 Pulsador para accionar la maquina a dos manos	7 Schalter für Zwihand-Auslösung
9 Motor de la bomba	9 Pumpenmotor
10 Interruptor general	10 Hauptschalter
11 Electromagnete	11 Elektromagnet
12 Presa de corriente	12 Steckdose
13 Microinterruptor de securidad del dispositivo de final de carrera	13 Sicherheitsmikroschalter für Hubbegrenzung
14 Contacto de final de carrera	14 Kontaktplättchen fur Hubbegrenzung
15 Cubierta lateral	15 Seitliche Abdeckung
16 Tornillo para descargar el aceite	16 Schraube für Ölwechsel

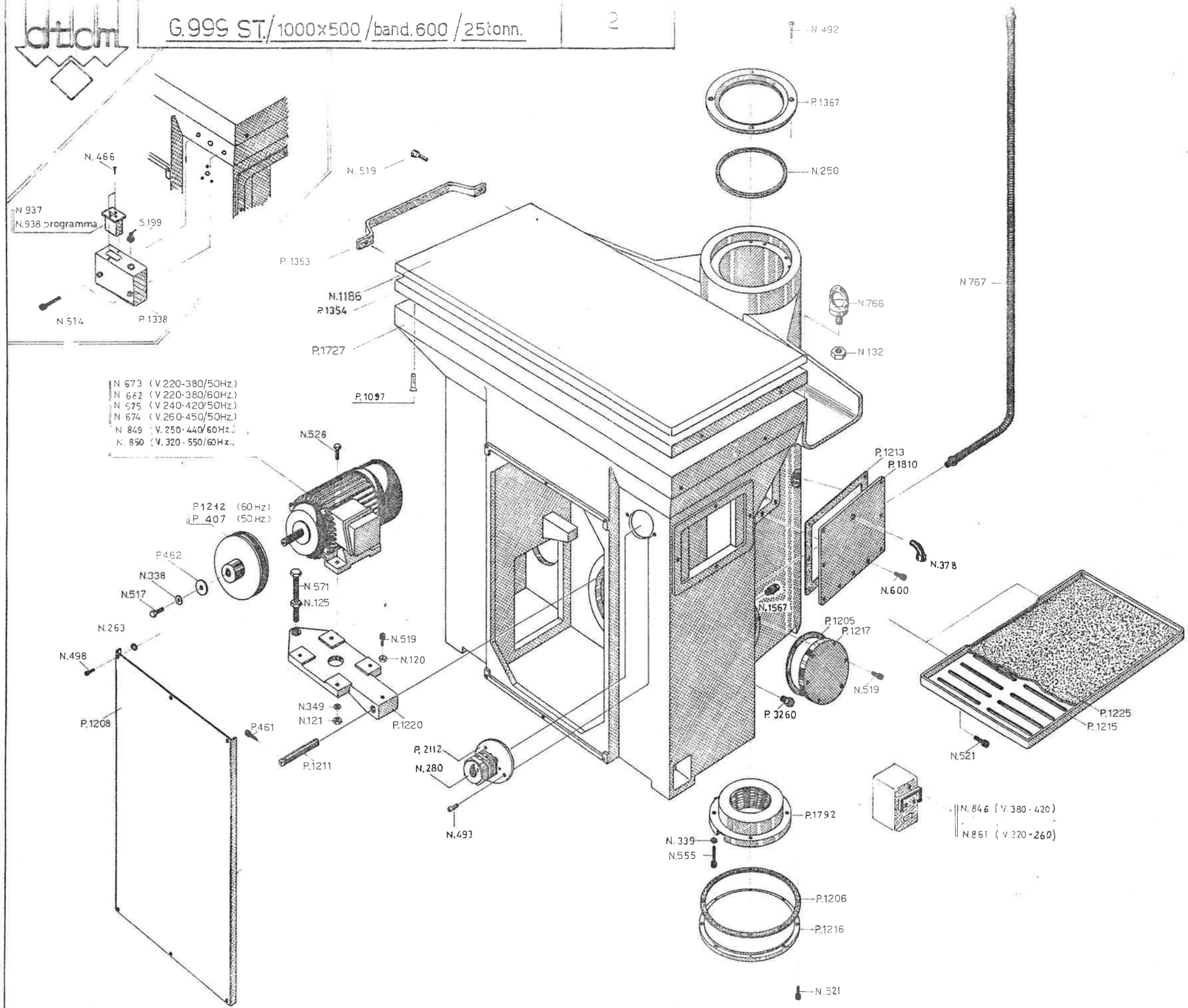


Numero di matricola
Numéro de série
Serial number
Numero de matricula
Maschinennummer

GRUPPO BASAMENTO

G.999 ST./1000x500/band.600/25tonn.

TAVOLA 2



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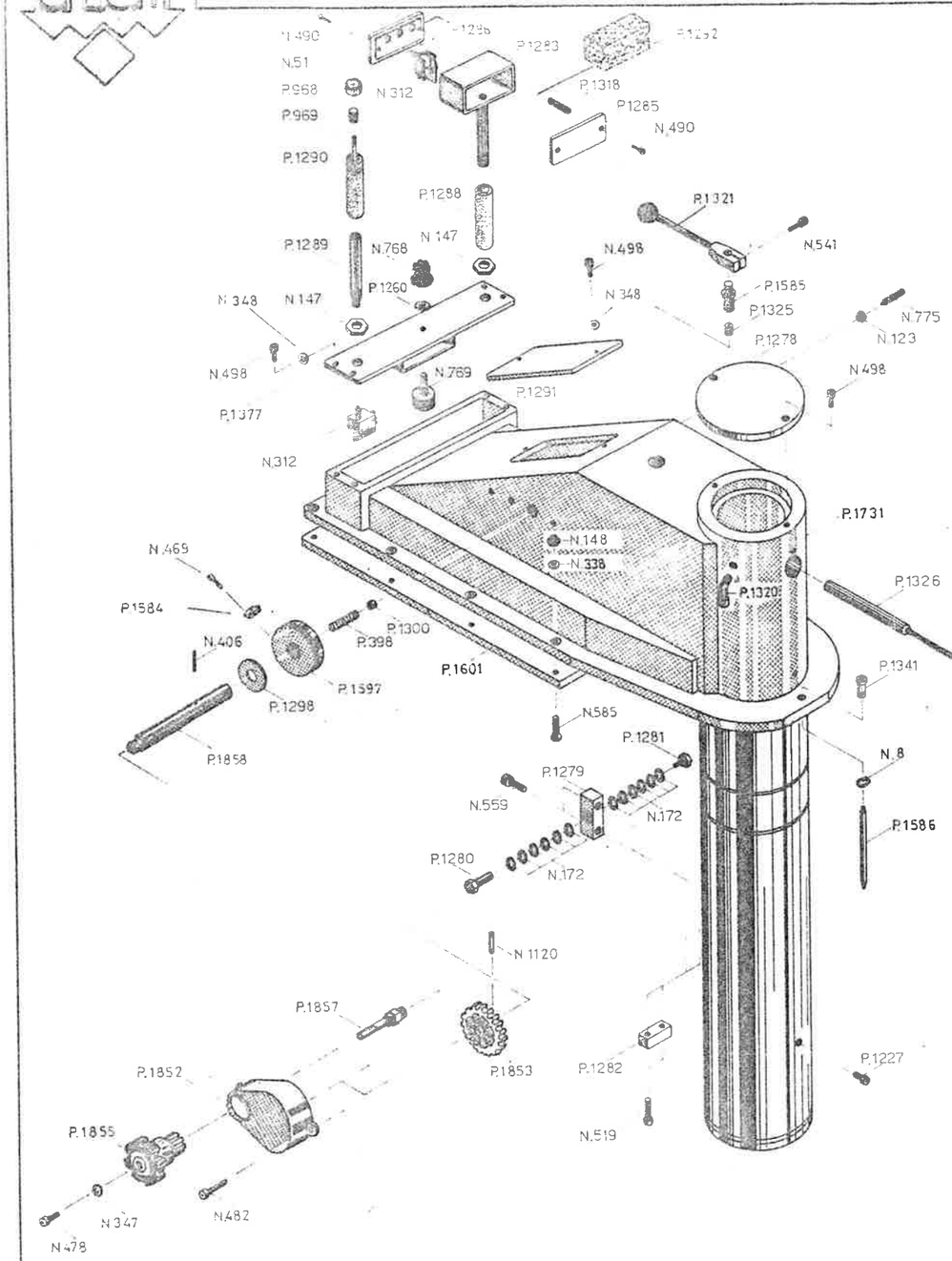
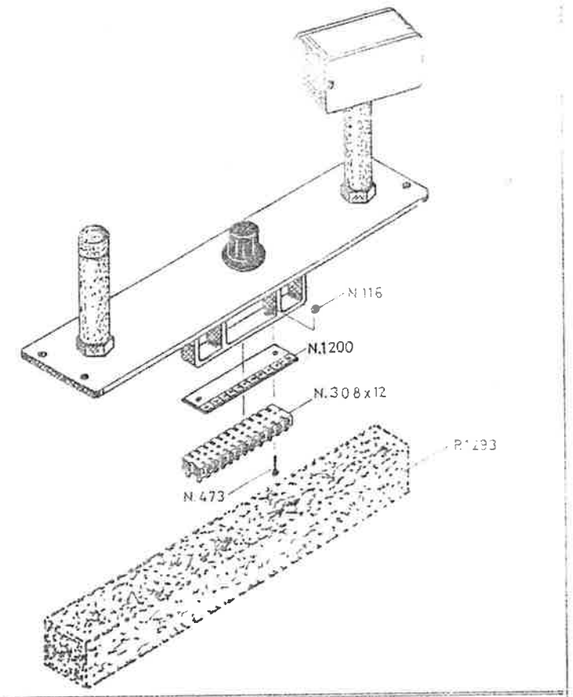
GRUPPO BANDIERA

3.999 ST. 1000x500 / band. 600 / 25 tonn.

TAVOLA 3

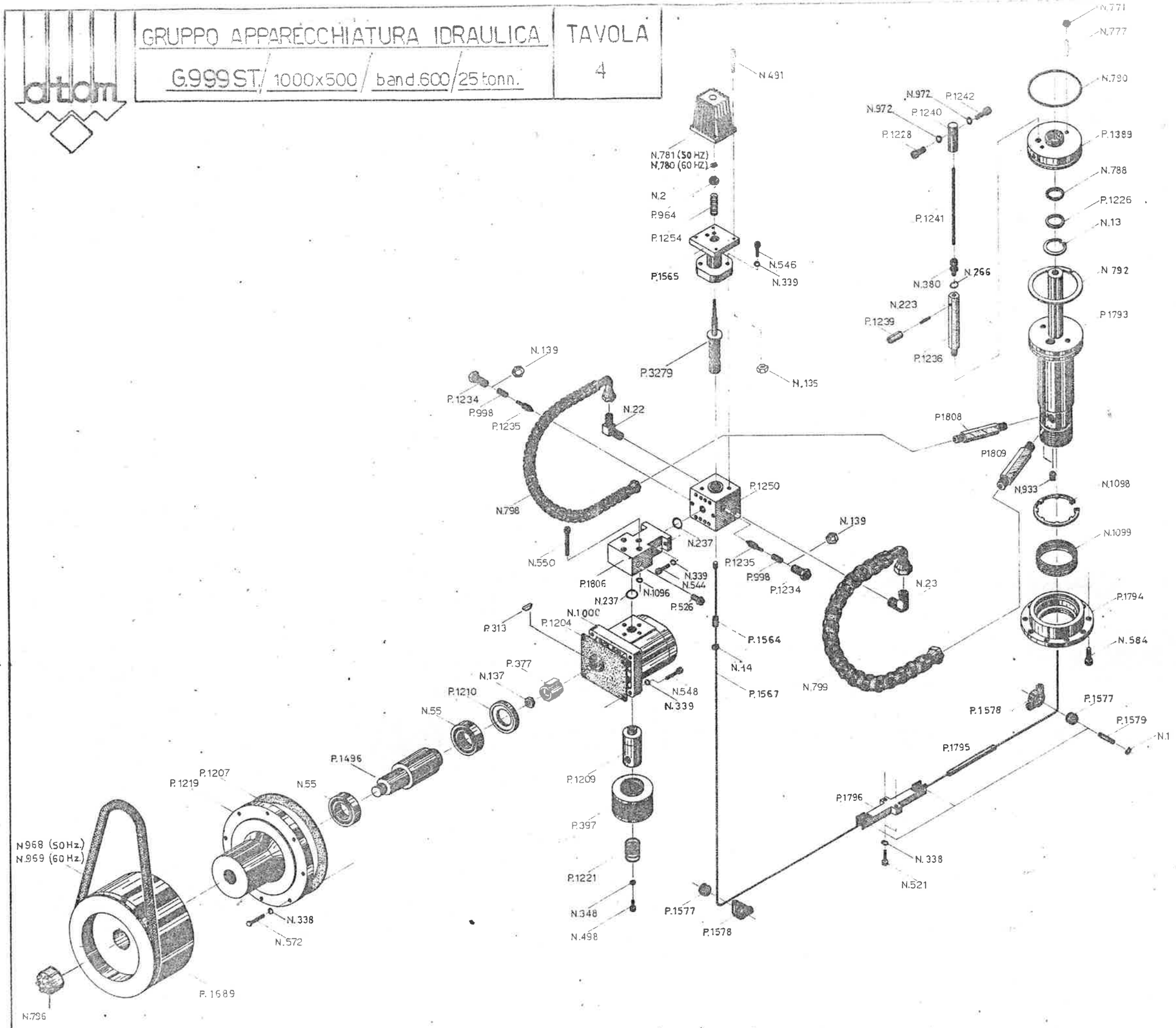




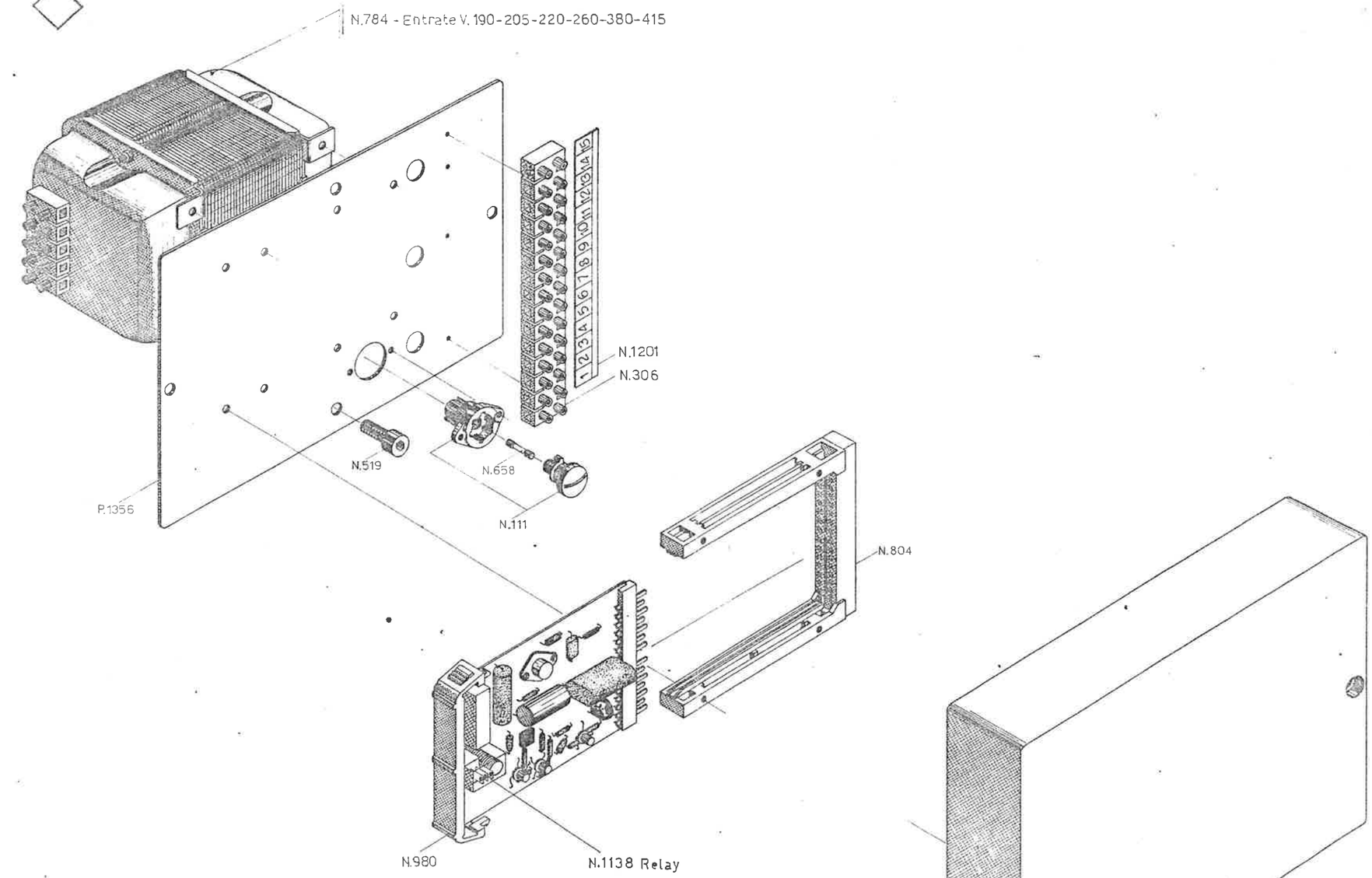
GRUPPO APPARECCHIATURA IDRAULICA

G.999 ST / 1000x500 / band.600 / 25 tonn.

TAVOLA 4



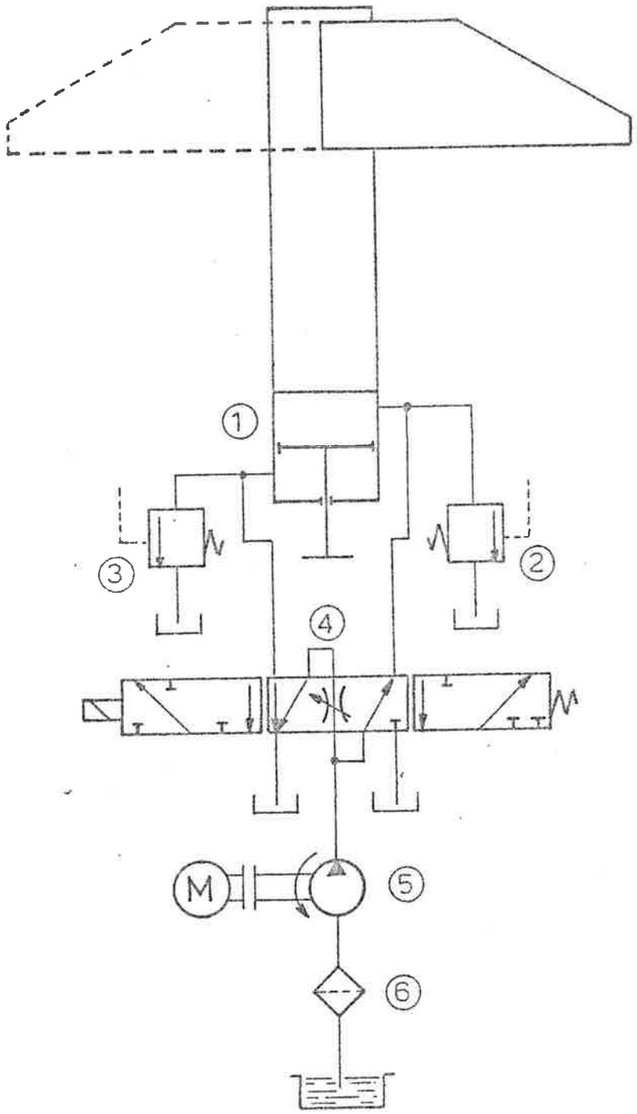
	GRUPPO APPARECCHIATURA ELETTRICA	TAVOLA
ctcm	G.999 ST. / 1000x500 / band. 600 / 25 tonn.	5



SCHEMA CIRCUITO OLEODINAMICO

G999 ST./1000x500/band.600/25 tonn.

TAVOLA



1	Cilindro di taglio
2	Valvola limitatrice di bassa pressione
3	Valvola limitatrice di alta pressione
4	Valvola per cilindro di taglio
5	Motopompa a ingranaggi
6	Filtro di aspirazione pompa

1	Cylindre découpe
2	Soupape limit basse pression
3	Soupape limit haute
4	Soupape cilindre découpe
5	Pompe à engrenages
6	Filtre

1	Cutting cylinder
2	Low pressure relief valve
3	High pressure relief valve
4	Cutting cylinder valve
5	Gear pump
6	Filter

1	
2	
3	
4	
5	
6	

1	
2	
3	
4	
5	
6	

Simbologia sistema CETOP/ISO

Symbolique CETOP/ISO

CETOP/ISO Symbols

Dalla matricola 76026 alla matricola ____

Dalla matricola ____ alla matricola ____

Data di apertura tavola 6-1-81 data di chiusura tavola ____

alcuni esemplari sono stati costruiti anche negli anni precedenti

Dalla matricola 76026 alla matricola

Data apertura tavola 6-1-81 Data chiusura tavola

B.Valli

SCHEMA IMPIANTO ELETTRICO

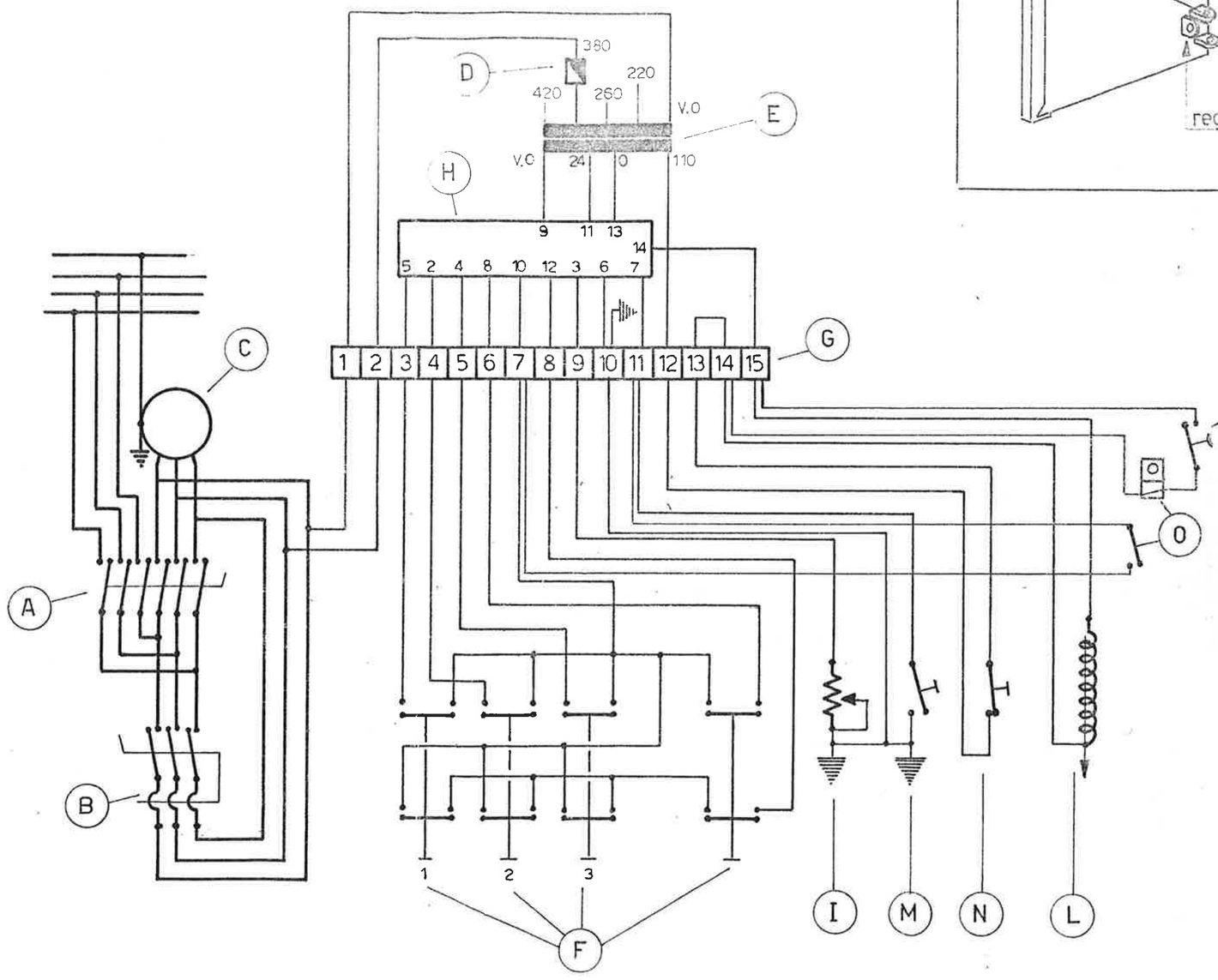
G.999 ST.

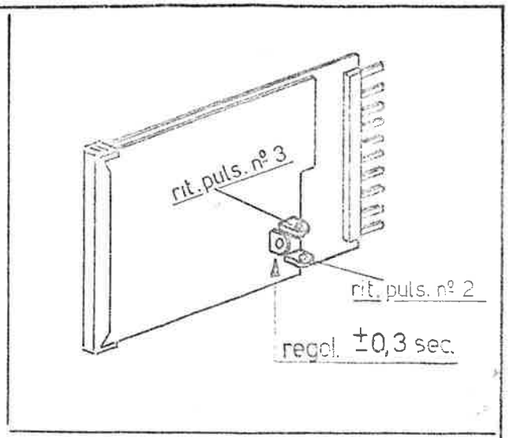
Nº 71/6

A - Interruttore generale
B - Interruttore termico
C - Motore
D - Cambio tensione
E - Trasformatore
F - Pulsanti
G - Morsetti
H - Scheda elettronica
I - Potenziometro
L - Elettromagnete
M - Fine corsa taglio
N - Microcontatto di sicurezza

A - Main switch
B - Thermal cutout
C - Motor
D - Change-voltage unit
E - Trasformer
F - Double microswitch
G - Terminal board
H - Printed circuit card
I - Potentiometer
L - Electromagnet
M - Cutting stroke end
N - Safety microswitch

A - Interrupteur général
B - Interrupteur termique
C - Moteur
D - Changeur de tension
E - Trasformateur
F - Microinterrupteur double
G - Bornes
H - Circuits imprimés
I - Potentiomètre
L - Electro-aimant
M - Fin course découpe
N - Microinterrupteur de sûreté





O - Contaimpulsi a programma
P - Interruttore per contaimpulsi

O - Scheduled cut-counting device
P - Switch for cut-counting device

O Compte-coups à programmer
P Interrupteur pour compte-coups

alcuni esemplari sono stati costruiti anche negli anni precedenti

Dalla matricola 76026 alla matricola

Data apertura tavola 6-1-81 Data chiusura tavola

bVALLI

SCHEMA IMPIANTO ELETTRICO G.999 ST.

Nº 71/6

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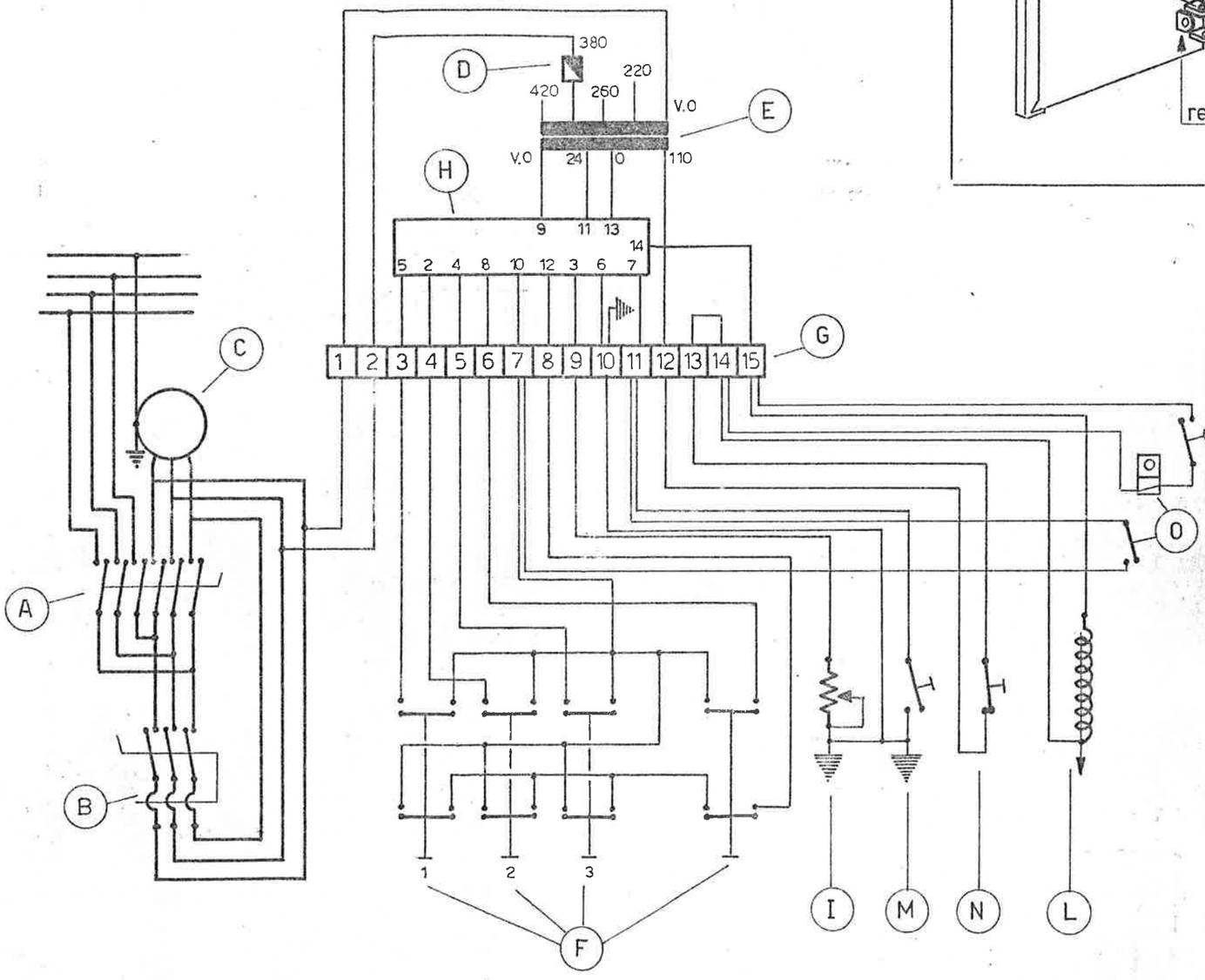

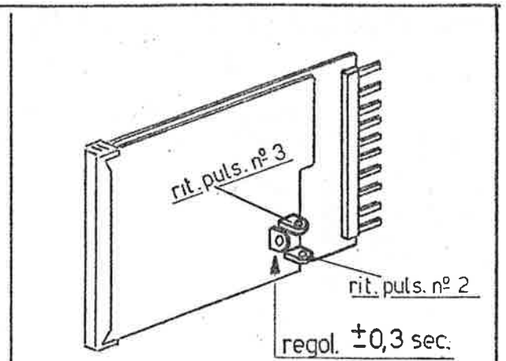

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