



SUP-800-NF

Instructions Manual

V.800-1904

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1. INTRODUCTION.

>>>

This instruction manual has been made in compliance with the requirements of the Legislation according to the Machine directive 2006/42/CEE and its subsequent amendments.

The instruction manual represents an integral part of the machine. It must be consulted before, during and after the machine is put into service, as well as whenever it is considered necessary, thereby respecting the content in each and every one of its parts.

This is the only way in which the fundamental objectives that have been established on the basis of this manual will be achieved, such as accident prevention and making optimal use of the machine features.

Within the framework of this manual, all aspects regarding safety and accident prevention on the job while using the machine have been considered in every detail, herein highlighting the information that is of greatest interest to the user.

 **ATENCIÓN**

Before installing the machine, read this manual carefully. The manual must be kept throughout the life of the machine, so that it is easy to find if necessary. In the event that the used machine is sold, the machine shall be sold together with this manual. In the event that the machine is scrapped, the identification plate and any other document supplied with the same must be destroyed.

1.1 Normativa aplicada en el proyecto y en la construcción.

- EN-12100-1** Machine Safety. Basic concepts, general design principles.
- EN-12100-2** Machine Safety. Basic concepts, general design principles.
- EN-13857** Safety distances to prevent dangerous zones from being reached by the upper extremities.
- EN-60204/1** Electrical equipment of industrial machines.
- EN-13850** Machine safety; emergency stop equipment.

and is in conformity with the Essential Requirements of the Directives:

- 2006/42/CE** on "Machine Safety"
- 2014/35/UE** on "Safety of Electrical Material."
- 2014/30/UE** on "Electromagnetic Compatibility."

2. GENERAL INFORMATION.

>>>

2.1. Machine identification data.

Model:..... **SUP-800 NF**

Serial number:

Manufacturing year:



NOTE

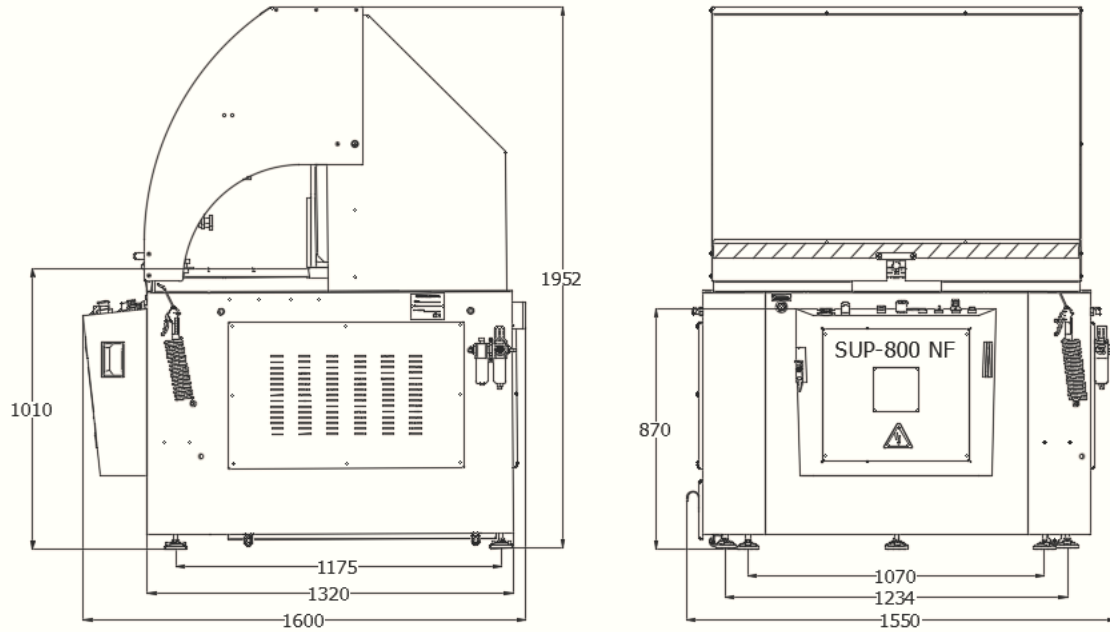
In order to request spare parts, whether covered by the warranty or not, always indicate the model and serial number of the machine, as well as the name of the part and the code that appear in the last chapter of the parts exploded views.

2.2. Technical data.

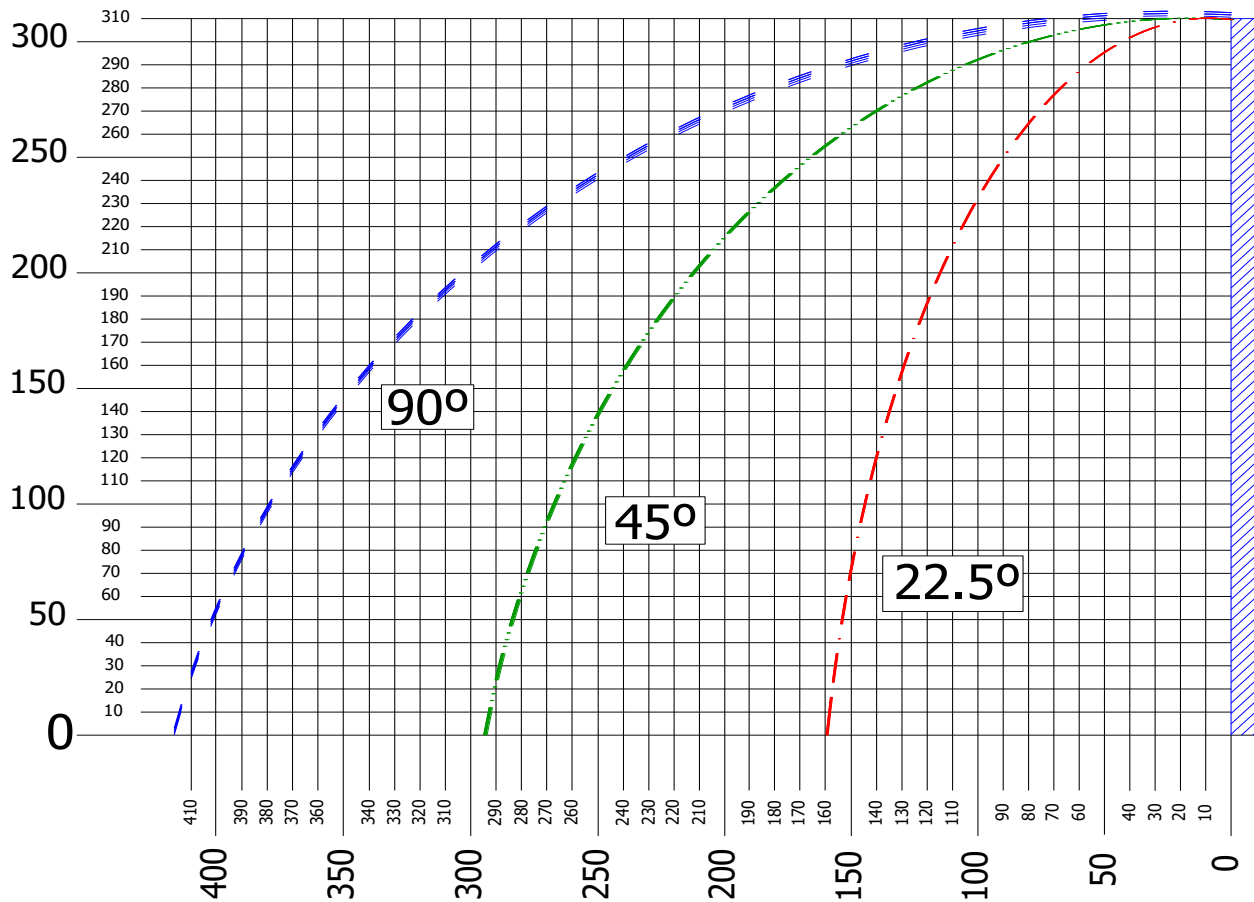
Characteristic	Dimension
Three phase motor	7,5 Kw / 10 HP, 220/380V
Motor speed	3000 RPM
Interior Ø of blade	2" / 50 mm
Maximum Ø of saw blade	Ø800 x Ø50 x 6/5 mm /31,5" x 2" x 0,23"
Cutting speed	30-70 m/seg
Turn	20° RIGHT – 90 - 20° LEFT
Working pressure	6-7 atm
Pneumatic hold-down clamps	2 vertical +2 horizontal
Lubrication system	Micro-Lubrication
Dimensions	1500 x 1600 x 2000 mm /59" x 63" x 78,7"
Weight	980 Kgs / 2160 lb

2.3. Dimensions of the machine.

SUP-800-NF



2.4. Cutting capacity.



2.5. Electrical data.

Power supply	Motor power	Total
220 V Three phase	7.5 kW / 10 HP	22 A
380 V Three phase	7.5 kW / 10 HP	15 A

2.6. Noise level.

At a distance of 60 cm

RUNNING OFF-LOAD

Leq 80 Db (A)

MACHINING A 70x50 PROFILE

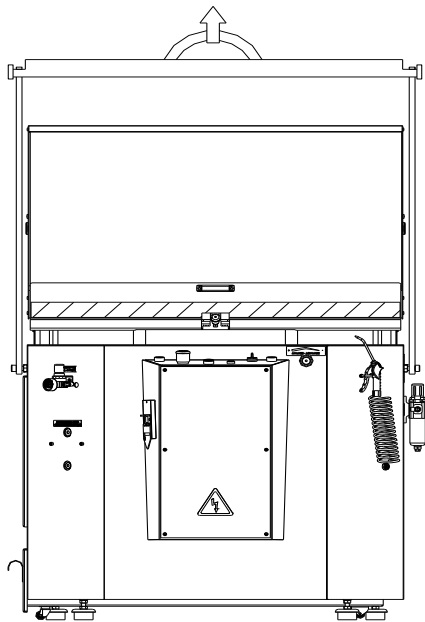
Leq 120 Db (A)



ATTENTION

When working with the machine, use individual hearing protection equipment.

3. INDICATIONS REGARDING TRANSPORT AND STORAGE. >>>



➤ Recommendations:

- Store in the vertical position. Do not stack.
- If the machine remains stored for a long period of time, periodically lubricate.
- Do not expose to the elements.
- The packaging is made of properly designed and sized wood, and it is also supplied wrapped in plastic.



CAUTION

Do not improperly dispose of the packaging. Send this material to be recycled or disposed of in accordance with all legislation in force.

4. INSTRUCTIONS FOR ANCHORING AND SERVICE START-UP. >>>

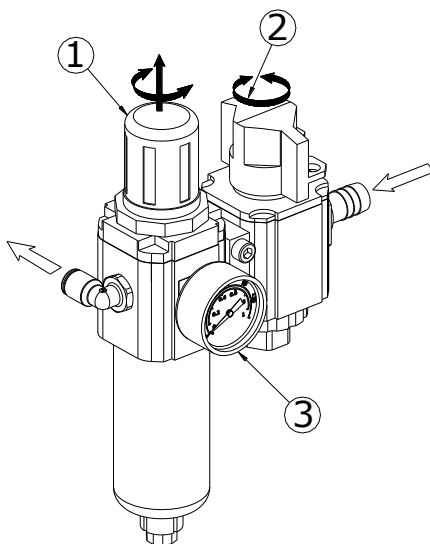
4.1. Instructions for anchoring.

Ensure that the machine has not suffered any damage during transport by making an initial visual inspection. If damage is observed, advise the manufacturer immediately.

The machine must be installed on a firm and level surface in order to thus reduce vibrations during operation and so that the machine operates within the parameters established by the manufacturer.

Verify that the power supply voltage corresponds to the voltage indicated on the specifications plate of the machine. Connect the cable to the power supply using a plug that is appropriate for the characteristics of the same, thereby respecting the colour codes. Once joined the machine, to verify the sense of rotation; if the rotation is not the suitable one, to change two phases of the plug.

4.2. Regulation of pressure regulators.

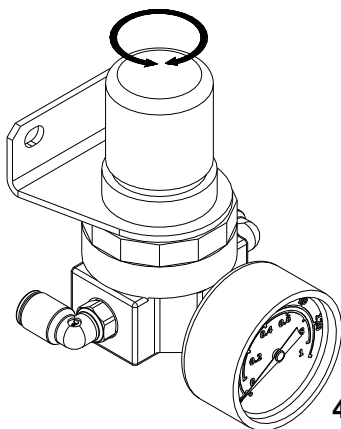


The machine is provided at the input of the pneumatic circuit with a filter control with shut-off valve. The aim of this set is to control the pressure of input in the machine between 6 and 7 bar.

The machine pressure is controlled by the upper Wheel (1) and could be observe in the manometer (3).

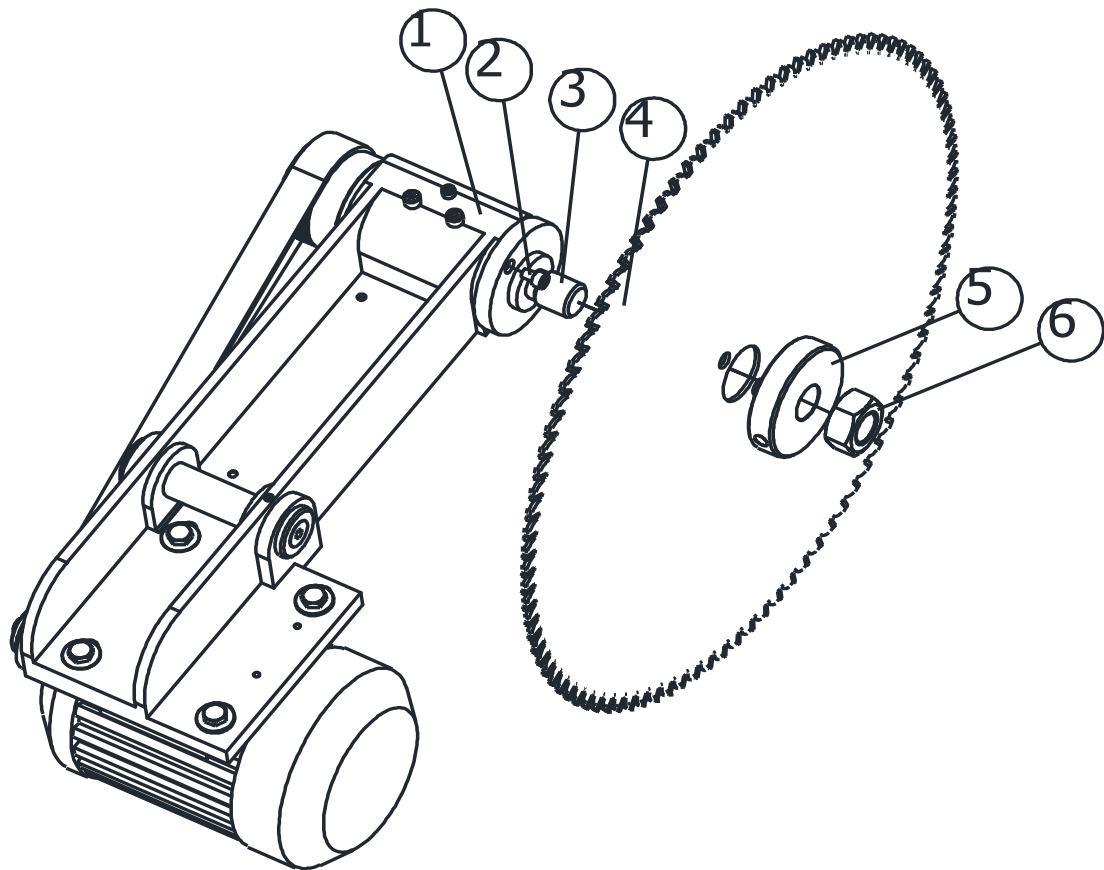
After work on the machine, we recommend you download the pneumatic circuit through the valve (2).

i **ATTENTION** _____
The pneumatic working pressure for vertical clamps must be between 6 and 7atm



i **ATTENTION** _____
The pneumatic working pressure for horizontal clamps must be between 3 and 4 atm

4.3. Instructions regarding blade installation.



To place the machine to 22,5 ° towards the left side and to fix with the automatic anchorage, there slackens the disc (4) with the bar and the fixed key sent with the machine. To do it with the bar and the fixed key sent with the machine. To place the new disc (4) in the axis (3), fitting it into the screw of dragging (2) mounted in the axis. To place the socket-pan (5) and to fix it by means of the bar, to press the nut (6) as Indian the figure. In order to accede to the disc using the lateral door of the machine, to make sure that the sense of the teeth of the mountain range agrees with the direction of rotation of the motor. Asegúrese also that the diameter of the disc is the adapted one for this machine (600mm).



ATTENTION

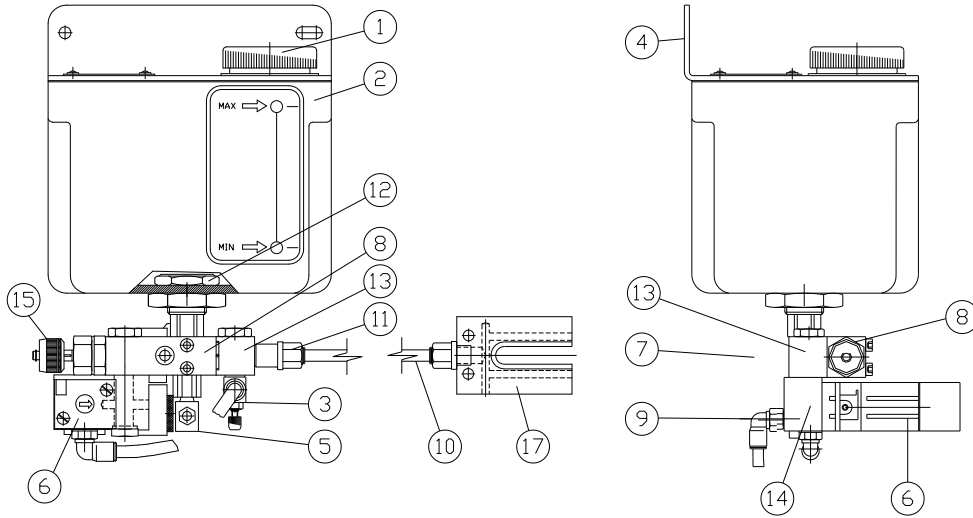
Assure that the blade is adapted for this machine (Diameter of the axis 50 mm.)



DANGER

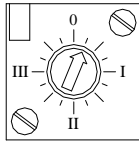
After changing the blade, put the sheet metal front back on.

4.4. LUBETOOL MICRO-LUBRICATION

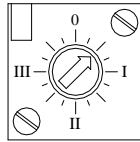


HOW TO ADJUST THE FREQUENCY GENERATOR WITH AIR AT 6 BAR

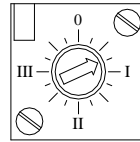
66 IMPULSOS xMINUTO
STROKES EVERY MINUTE



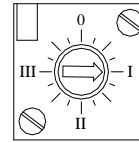
37 IMPULSOS xMINUTO
STROKES EVERY MINUTE



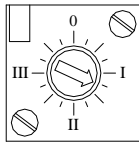
21 IMPULSOS xMINUTO
STROKES EVERY MINUTE



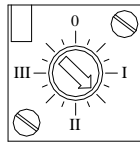
13 IMPULSOS xMINUTO
STROKES EVERY MINUTE



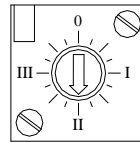
10 IMPULSOS xMINUTO
STROKES EVERY MINUTE



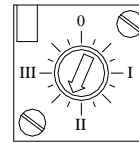
6 IMPULSOS xMINUTO
STROKES EVERY MINUTE



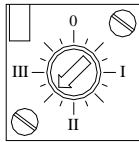
4 IMPULSOS xMINUTO
STROKES EVERY MINUTE



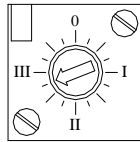
3 IMPULSOS xMINUTO
STROKES EVERY MINUTE



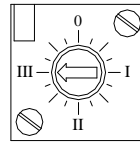
2,5 IMPULSOS xMINUTO
STROKES EVERY MINUTE



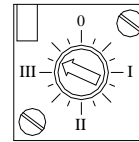
2 IMPULSOS xMINUTO
STROKES EVERY MINUTE



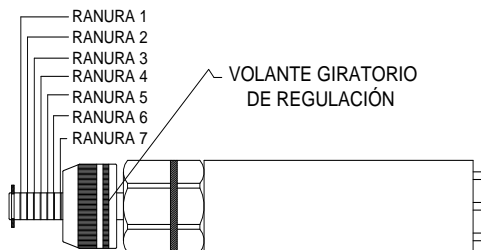
1,5 IMPULSOS xMINUTO
STROKES EVERY MINUTE



1 IMPULSOS xMINUTO
STROKES EVERY MINUTE



HOW TO ADJUST THE DISCHARGE



GROOVE N°	DISCHARGE
1	41 mm ³
2	30 mm ³
3	23 mm ³
4	16 mm ³
5	9 mm ³
6	2 mm ³
7	0 mm ³

PURE CUTTING OIL VISCOSITY ISO VG

22-48 (cST 40°C)

Manufacturer	 FIMITOL	 Brugarolas	 Castrol	 SHELL
Type	SPRAYLUB E 32	BESCUT 173	ILOCUT 106	SHELL GARIA

5. INSTRUCTIONS FOR USE.

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5.1. Proper and improper use.

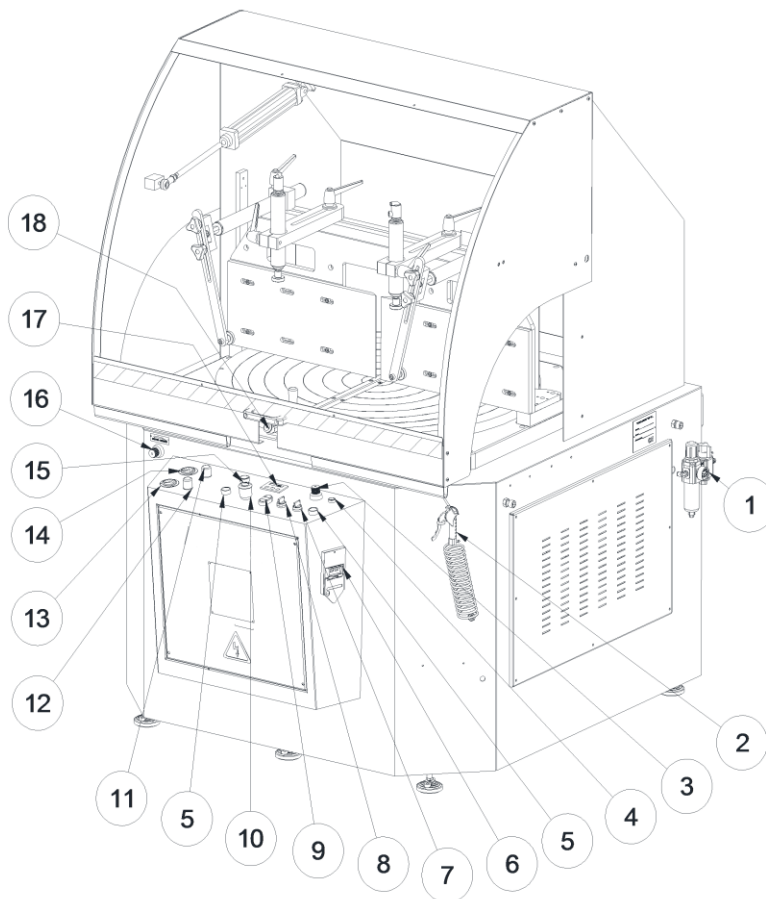
This is a semiautomatic cut-off machine especially designed for cutting aluminium profiles.

The use of the machine for cutting other materials is hereby prohibited. Such use may cause damage to the machine and put the health and safety of the worker at risk.



DANGER

We are not responsible for any possible accident caused by the failure to comply with the aforementioned.



!. Function of the operating mechanisms.

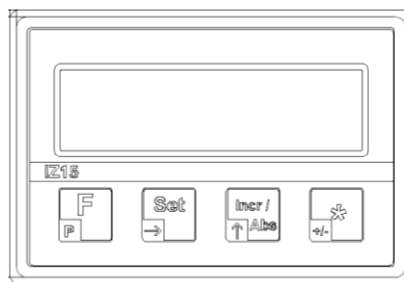
1. Filter + Regulator + shut-off valve.
2. Clearing gun with hose
3. Blade Speed regulator.
4. Green indicator 380V.
5. Raise blade - green button.
6. Main switch.
7. Protective shield.
8. Clamps 2-position selector.
9. Saw blade on-off.
10. Emergency.
11. Pressure regulator vertical clamps.
12. Pressure regulator horizontal clamps.
13. Manometer horizontal pressure.
14. Manometer vertical pressure.
15. Advanced regulator 3/8".
16. Advanced regulator 3/8".
17. Degrees digital display.
18. Angle Lock.



DANGER

**ALWAYS WORK WITH THE PROTECTIVE SHIELD LOWERED.
DO NOT DISCONNECT ANY SAFETY DEVICES.**

5.3. Instructions for the adjustment of the digital degrees.



- For placed to the zero of the book-keeper of degrees, pulsate of simultaneous form (F+Set).
- To change the way of reading of incremental to absolute, to touch (Incr/Abs).
- Change of the book-keeper parameters, contact to the manufacturer of the machine.



ATTENTION

Clean the book-keeper with the pistol of cleanliness, not to try to clean it with other utensils since the frame of plastic might be spoilt or grated, impeding the reading

5.3. General rules and safety checks.

- Before using the machine, check the efficiency and perfect operation of all safety devices, and check that the moving parts of the machine are not blocked, that there are no damaged parts and that all machine components are positioned and work correctly.
- It is entirely prohibited to manipulate the safety devices.
- It is entirely prohibited to work without the protective shield in position.
- It is mandatory to use gloves and protective eyewear.
- It is mandatory to use regulation work clothing (it must be worn fastened).
- Before starting work, the operator must ensure that all tools and wrenches used for maintenance or adjustment have been removed.
- In the event of a fire, use powder extinguishers and disconnect the machine from the electric system.

6. RECOMMENDATIONS AND MAINTENANCE. >>>

6.1. Type and frequency of inspections.

The operator's knowledge of the machine is one of the best ways of daily control of any possible problem. If any failure is detected, work must be stopped and qualified personnel must be informed immediately.



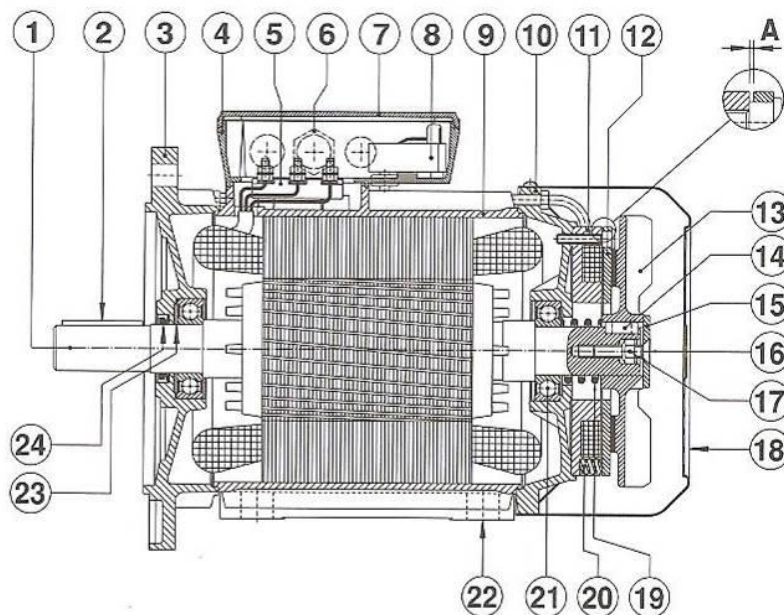
NOTE

Always clean the machine and the work area at the end of the workday.

LUBRICATION POINTS	TYPE OF GREASE/OIL	FREQUENCY
Turret travel rail	SAE 30 LUBRICATING OIL	WEEKLY
Rocker bearings (Fig. 7.4)	ROLLER BEARINGS	ANNUALLY
CHECK POINTS		FREQUENCY
Machine cleaning		WEEKLY
Condition of the transmission belt		ANNUALLY

BRAKE MOTOR ADJUSTMENT

The adjustment of fair gap A (whose value can range 0,2 / 0,4mm) occurs by acting on the screw 17, placed at the end of the shaft.



6.2. Qualified personnel for maintenance and repair work.

- All repairs shall be made exclusively by qualified personnel, thereby always using original replacement parts. If not, the machine may be damaged or the user may be injured.

6.3. Manufacturer recommendations.

- ⇒ In the event that the machine is broken down or the saw blades must be replaced, place a padlock on the protection switch and place the keys under the care of qualified personnel.
- ⇒ Before working on any electrical devices, disconnect the plug from the power supply.
- ⇒ If extension cords are used, ensure that the cable has the appropriate cross-section for the power of the machine.
- ⇒ Whenever any part has to be replaced, use an original replacement part and endeavour to use the oil recommended by the manufacturer.



NOTE

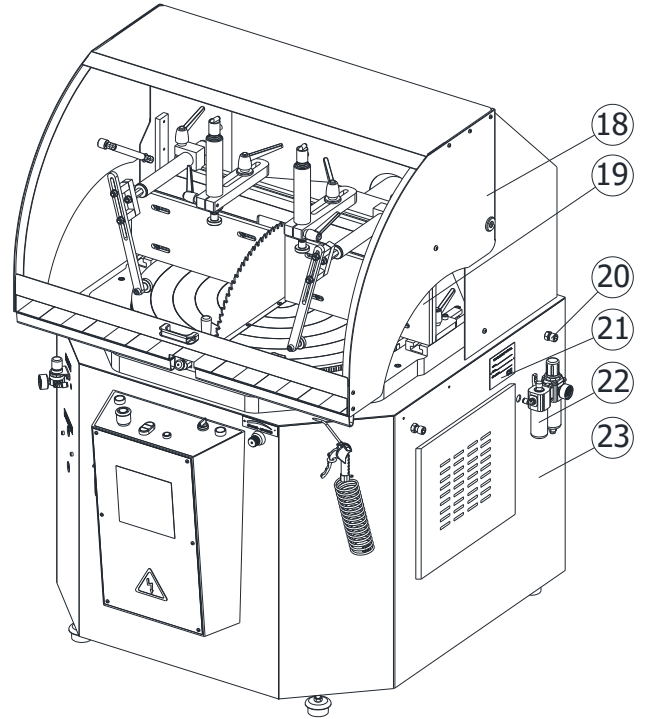
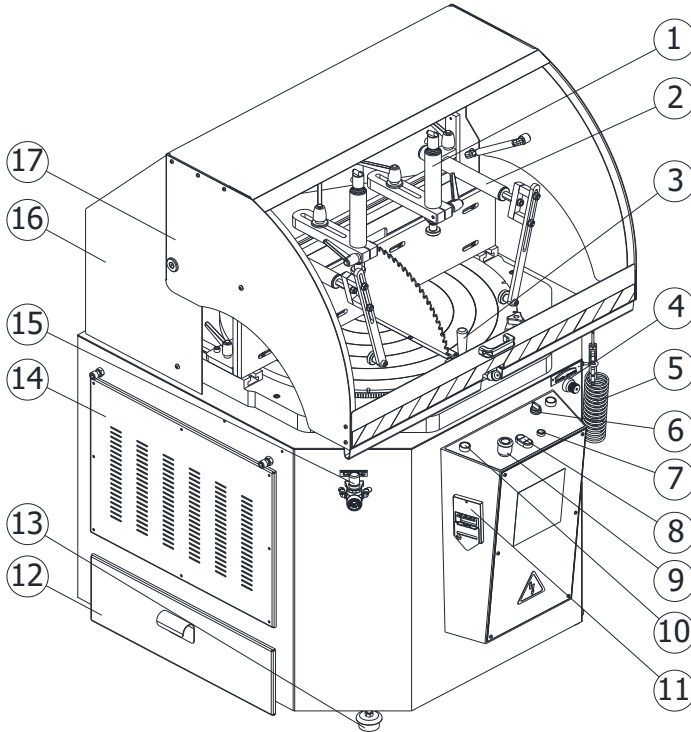
In case of any doubt or problem, do not hesitate to consult the manufacturer.



ATTENTION

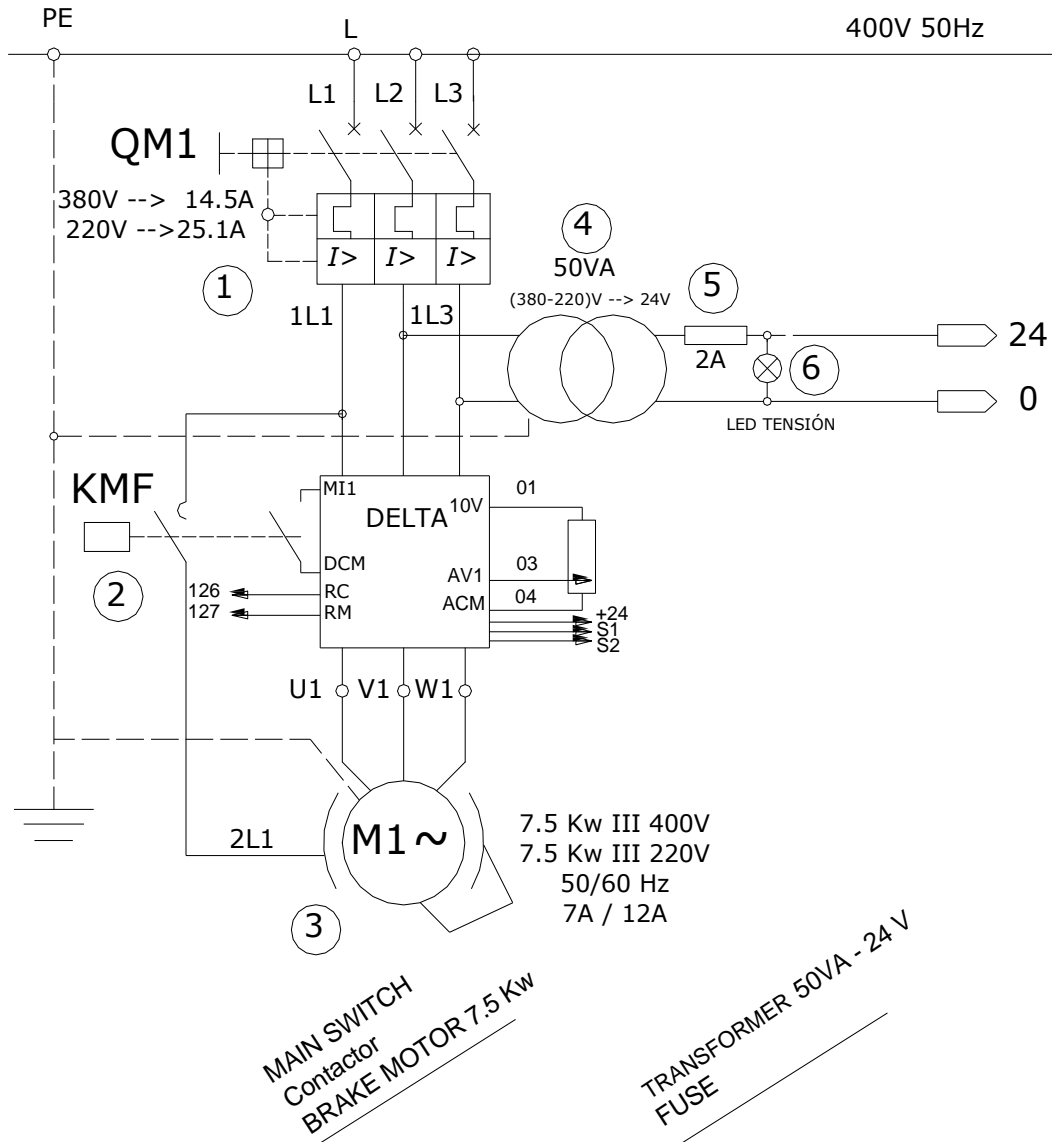
The manufacturer hereby guarantees the supply of each one of the parts or components for at least 3 years as from the manufacturing date of the machine.

7.1. General schematic.

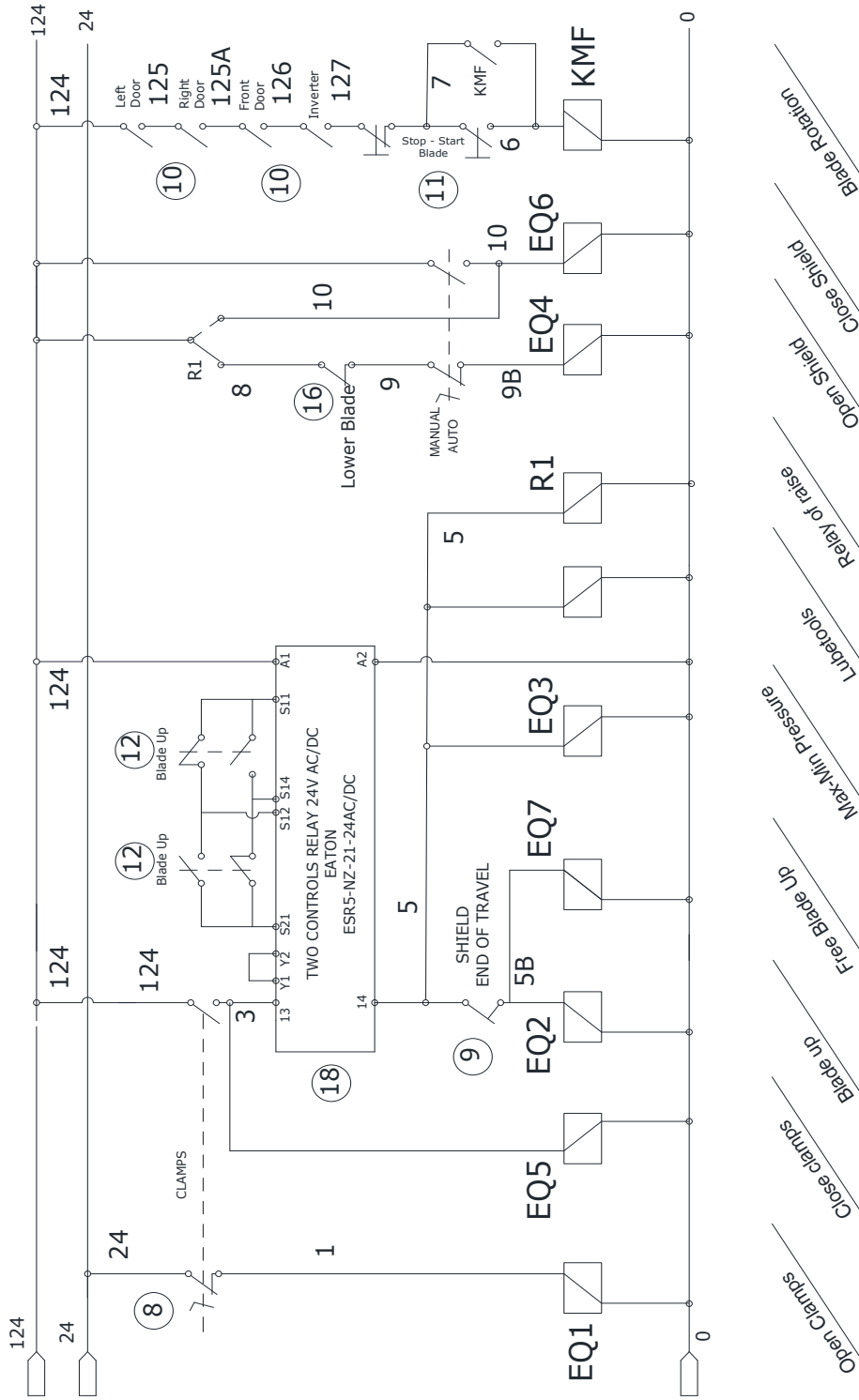


N°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
1	Ø55 PNEUMATIC HOLD-DOWN CLAMP	2008005212	14	LEFT DOOR	
2	HORIZONTAL CLAMPS ØEXT 40	N03PT14050	15	PRESSURE REGULATOR	N000000030
3	ANGLE LOCK	2040000482	16	PROTECTIVE SHIELD SUPPORT	
4	ADVANCE REGULATOR		17	PROTECTIVE SHIELD	
5	BLOW AIR DUSTER		18	SHIELD END-OF-TRAVEL STOP	E00000BD25
6	2- POSITION SELECTOR		19	TURRET	
7	GREEN INDICATOR	E0000000030	20	M20 SCREW + M20	
8	SAW BLADE ON-OFF		21	CE IDENTIFICATION	
9	EMERGENCY		22	FILTER+REG+SHUT-OFF VALVE	N000000A17
10	GREEN VERTICAL ALIGNMENT BUTTON		23	SHEET METAL BASE	
11	GENERAL SWITCH				
12	SIDE DRAWER. CUTTINGS				
13	FEET LEVELERS				

7.2. Power circuit.



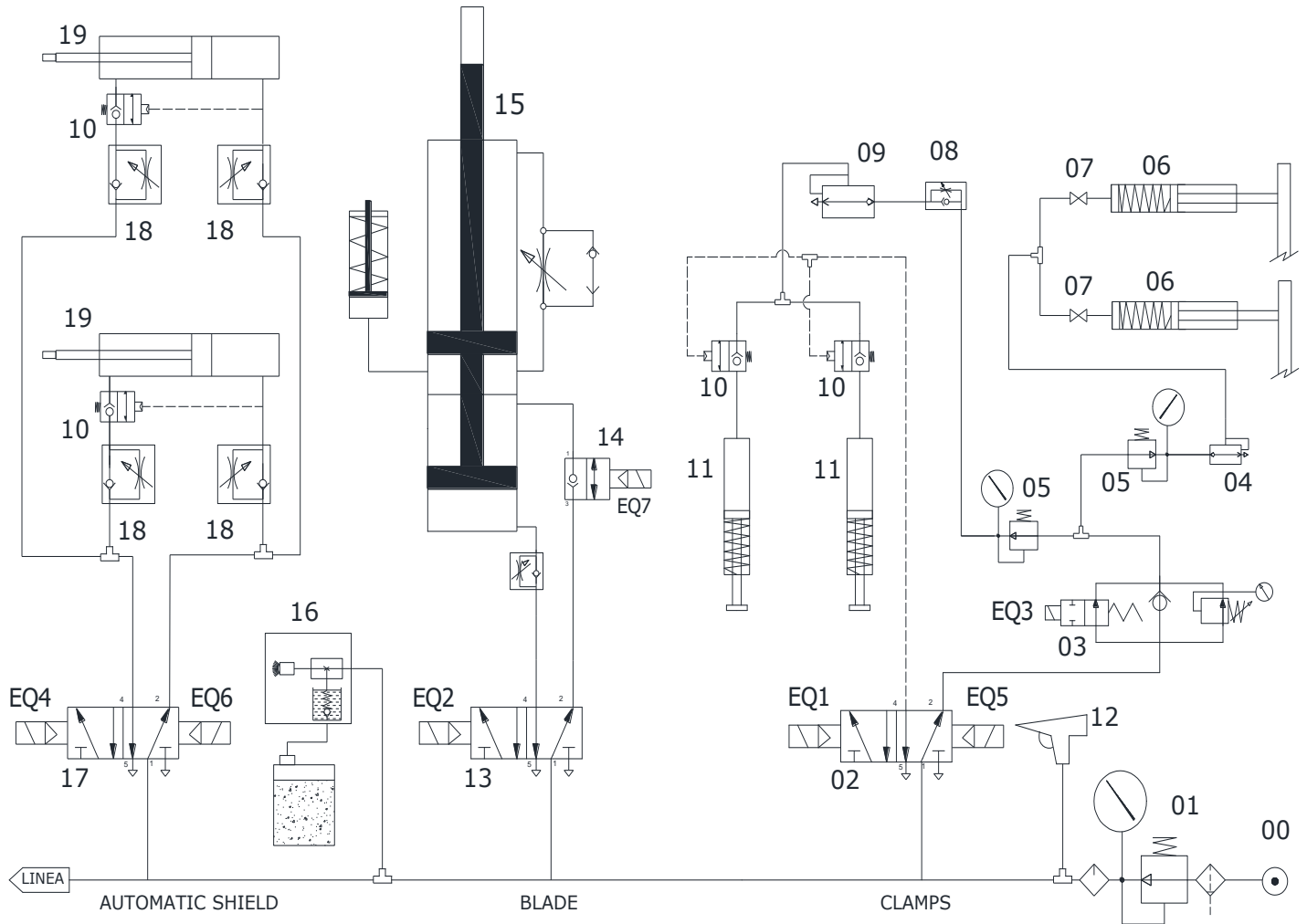
Nº	DESCRIPTION	CODE	Nº	DESCRIPTION	CODE
1	MAIN SWITCH 10A MAIN SWITCH 16A	E000000004 E000000005	4	TRANSFORMER 50VA - 24V	E000000014
2	CONTACTOR TKC12 24V 50/60HZ		5	FUSE 2A	E000000024
3	7.5 KW BREAK MOTOR III 400V 7.5 KW BREAK MOTOR III 220V		6	GREEN INDICATOR Ø17 VERDE 24V	E000000030



°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
8	2-POSITION SELECTOR	E000000G71	14	HIGH + LOW PRESSURE NEUMATIC	N000000069
9	SHIELD END-OF-TRAVEL STOP	E00000BD25	15	TKC9 CONTACTOR 24V 50/60 Hz	E000000034
10	END-OF- TRAVEL M-12	E000000015	16	MAGNETIC SENSOR MAGI 6,2	ECNKT50RQD
11	SAW BLADE , ON-OFF	E000000G75	17	RELAY BORNA 6MM + BASE 24VAC/DC	E000000095
12	GREEN PUSH-BUTTON NO	E000000G50	18	BIMANUAL SECURITY MODULE	CE0000EBD52
13	5/2 WAYS MONO. ELECTROVALVE	N000000A34			

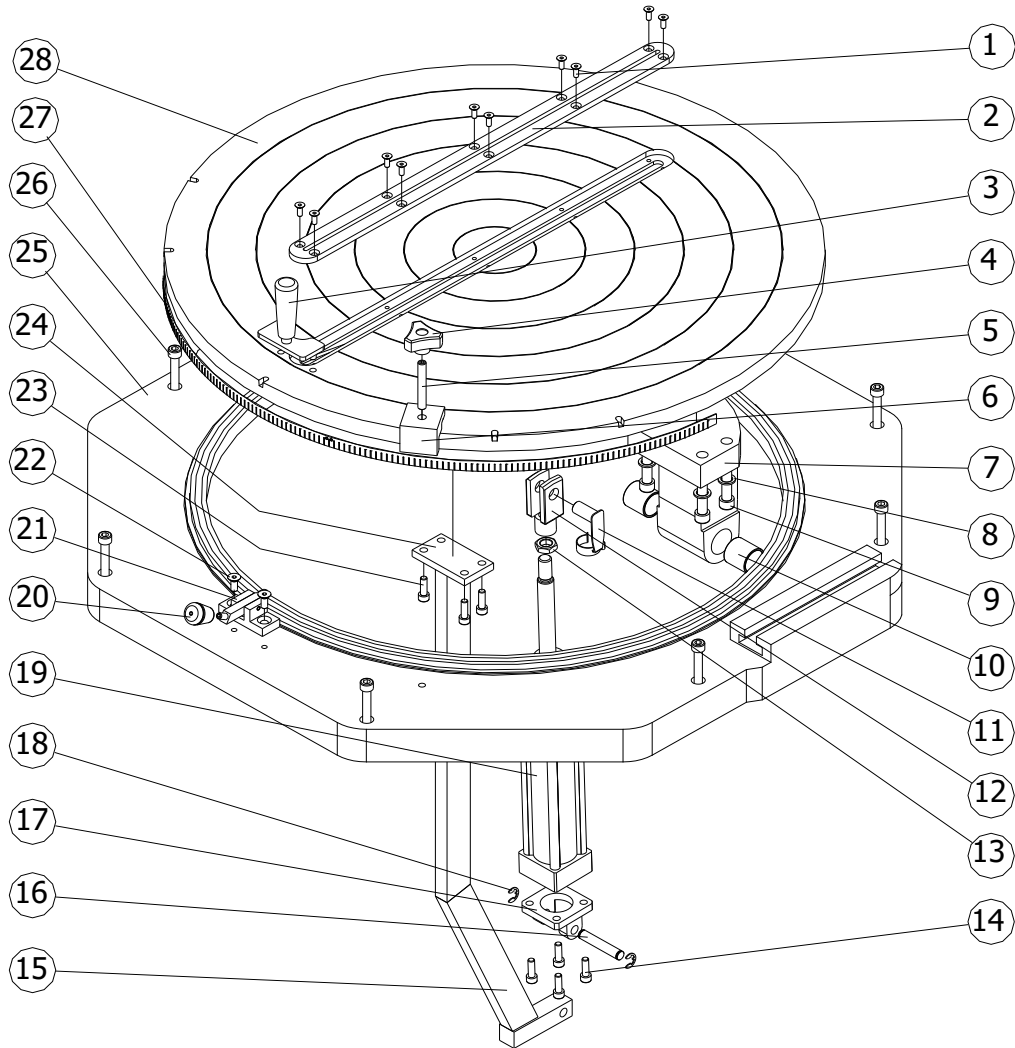
SUP-800-NF

7.3. Pneumatic schematic.



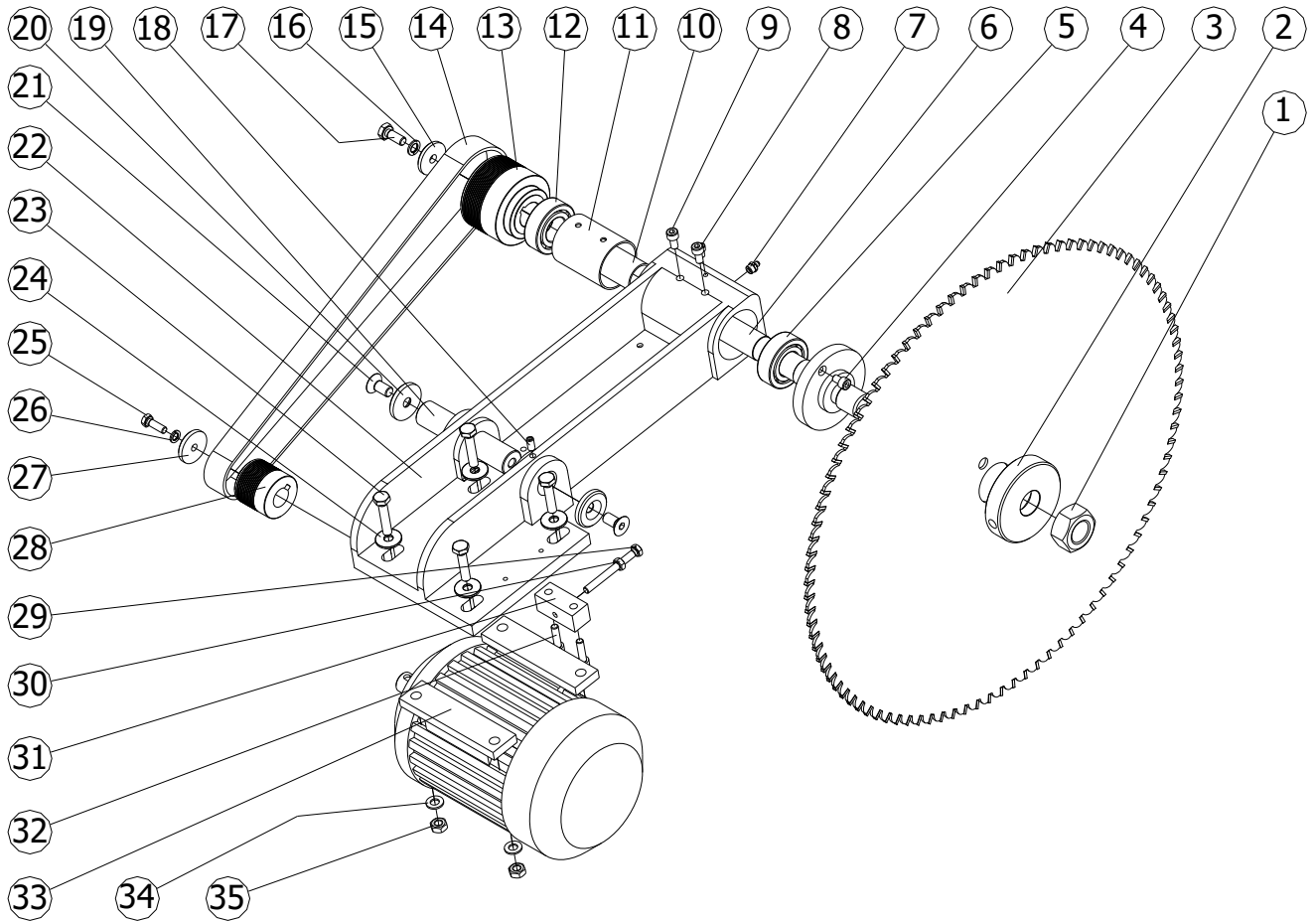
N°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
00	LINE	-----	10	UNI DIRECTIONAL VALVE 2/2 1/8"	N000000015
01	FILTER+REG+SHUT-OFF VALVE	N00000A170	11	VERTICAL CLAMPS Ø55	2008005212
02	5/2 WAYS BIEST. ELECTROVALVE	N00000AB34	12	BLOW AIR DUSTER	N000000010
03	HIGH+LOW PRESSURE NEUMATIC	N000000069	13	5/2 WAYS MONO. ELECTROVALVE	N000000A34
04	QUICK EXHAUST VALVE 1/8"	N000000038	14	CYLINDER BLOCK VALVE	
05	PRESSURE REGULATOR ¼"	N000000030	15	80x200 CYLINDER WITH REGULATOR	N000080200
06	CLAMPING CYLINDER Ø40x450	N03PTI4050	16	LUBETOOLS	EN0TLLUBET
07	MINI BALL VALVE 1/8" M-H	2K20000281	17	5/2 WAYS BIEST. ELECTROVALVE	N00000AB34
08	FLOW REGULATION 1/8" Ø6 CIL.	N0CCRC1806	18	FLOW REGULATION 1/8" Ø6 CIL.	N0CCRC1806
09	QUICK EXHAUST VALVE 1/8"	N000000038	19	40x250 CYLINDER	N000040250

7.4. Exploded view cast iron table and disc assembly.



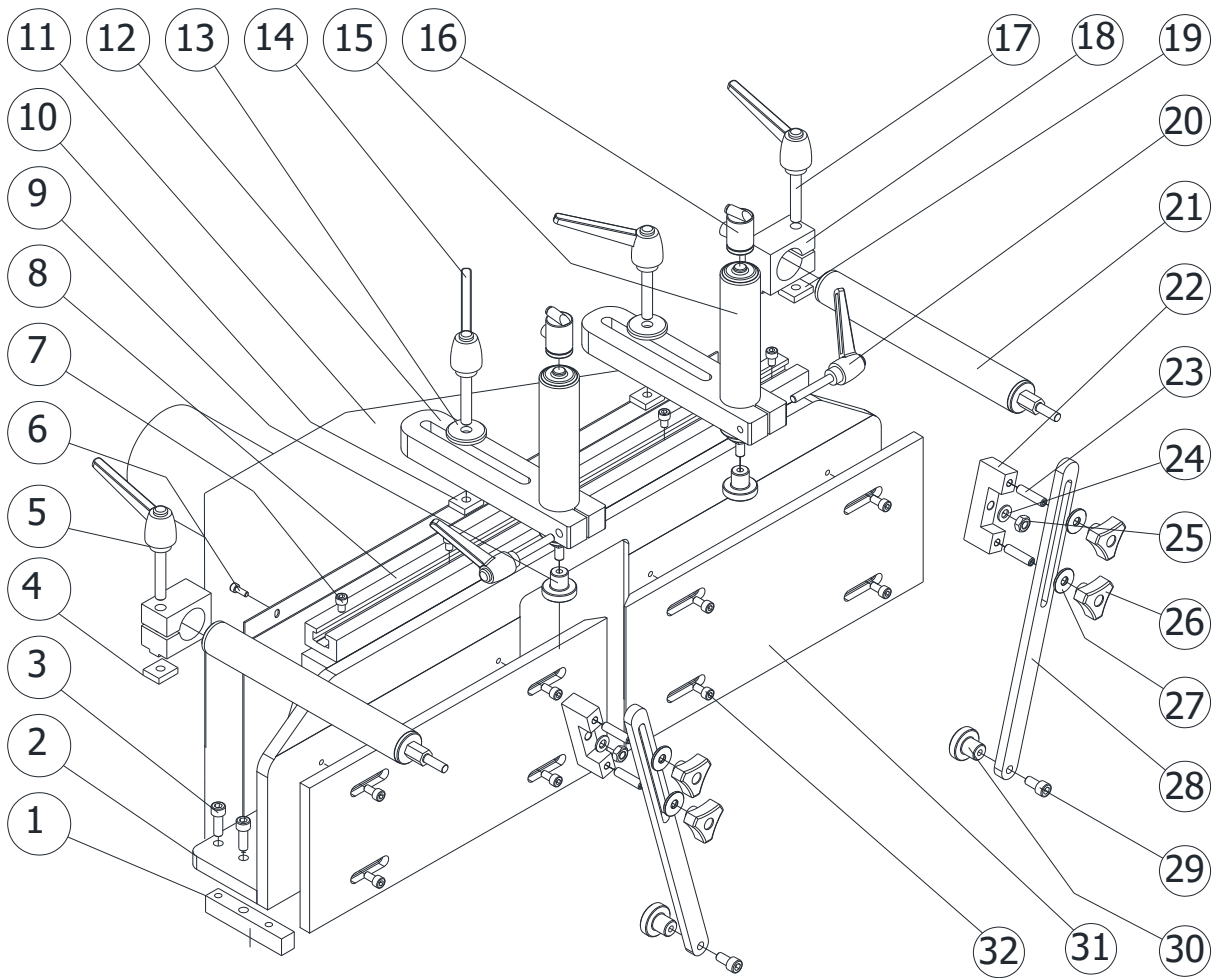
N°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
1	DIN 7991 M6x16 SCREW	TD79910616	15	POST	-----
2	BLADE GROOVE	2180000522	16	ISO 80 CYL. YOKE	N000008059
3	DEGREES TURN LEVER	2352000171	17	ISO 80 CYL. YOKE	N000008059
4	HANDLE TRISTAR M10	B0000000H2	18	16 STOP COLLAR	TD47100116
5	DIN 913 M10x70 SCREW	TD91310070	19	80x200 CYLINDER WITH REGULATOR	N000080200
6	BRAKE OF DEGREES	-----	20	M8 KNOB	B000000011
7	ROCKER SUPPORT	2180000322	21	ANGLE LOCK	2040000482
8	DIN 128 Ø12 WASHER	TD12800012	22	DIN 7991 M8x20 SCREW	TD79910820
9	DIN 912 M12x50 SCREWS	TD91212050	23	DIN 912 M8x25 SCREW	TD91208025
10	AUTOLUBRICATED TIP 30-35-35	2040000C30	24	LEVER SUPPORT	-----
11	ISO 80 CYL. FEMALE PIN JOINT	N000008057	25	CAST IRON TABLE	218000F012
12	ISO 80 CYL. FEMALE PIN JOINT	N000008057	26	DIN 912 M10x50 SCREW	TD91210050
13	M20 NUT		27	MAGNETIC TAPE	204D000E31
14	DIN 912 M10x25 SCREW	TD91210025	28	CAST IRON DISC	2180000022

7.5. Exploded view rocker assembly.



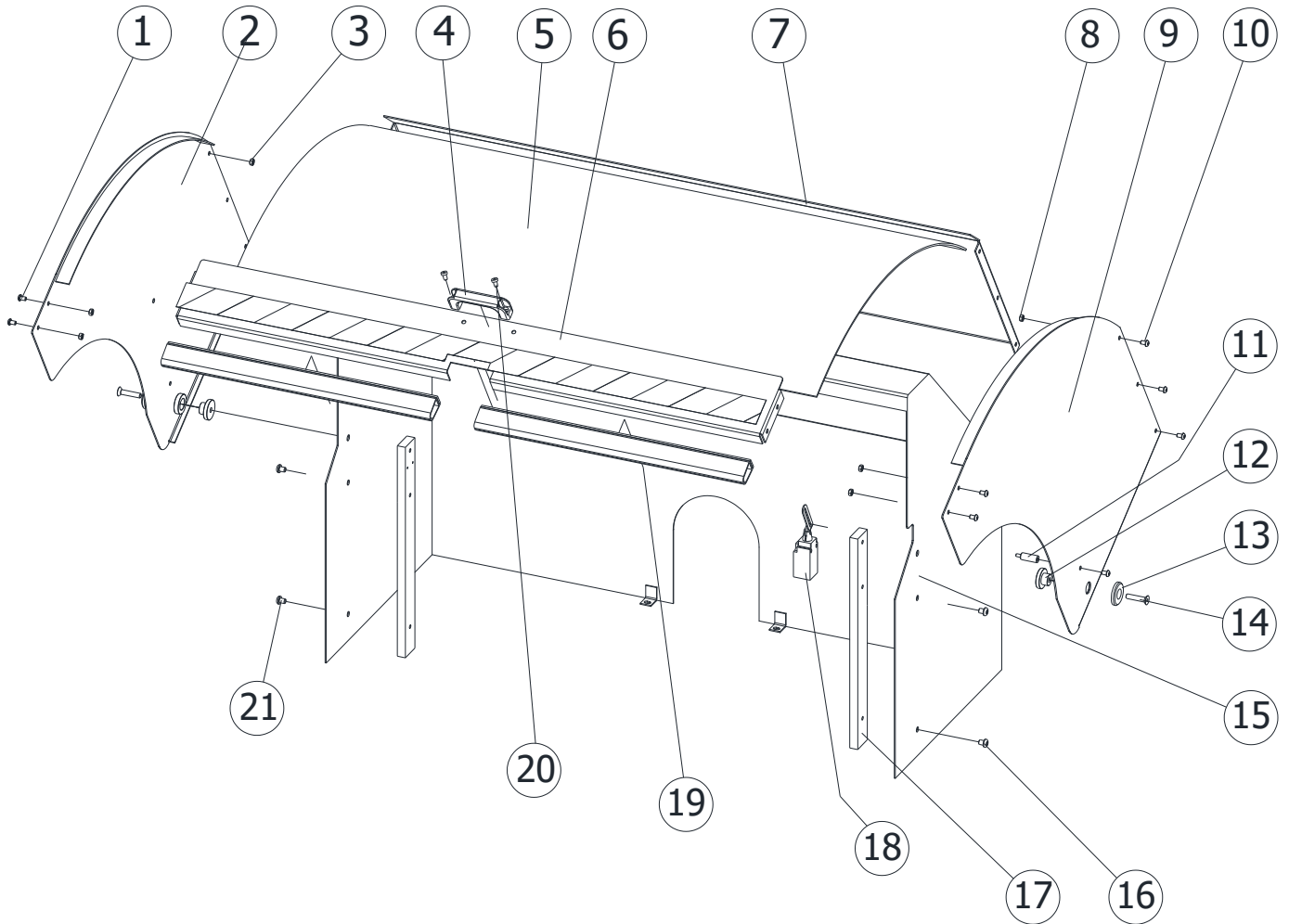
N°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
1	DIN 934 M30 NUT	TD93400030	19	CONNECTING ROD PIN	2040000072
2	Ø116 BLADE WASHER	2180000042	20	Ø45x7 AVELL. M12 WASHER	216000A452
3	WIDIA BLADE Ø800xØ80x5	205DW80050	21	DIN 7991 M12x25 SCREW	TD79911225
4	DIN 912 M8x12 SCREW	TD91208012	22	CAST IRON ROCKER TL-800	2180000032
5	4207 BEARING	2180004207	23	DIN 933 M10x50 SCREW	TD93310050
6	Ø35 SHAFT	P2180000102	24	Ø10 INT. PISAD. WASHER	204000A401
7	LUBRICATOR 1/8"	2070000012	25	DIN 933 M8x25 SCREW	TD93308025
8	DIN 912 M6x10 SCREW	TD91206010	26	DIN 128 Ø8 WASHER	TD12800008
9	DIN912 M8x16 SCREW	TD91208016	27	Ø40xØ8x 6mm WASHER	204000A402
10	Ø40 SEPARATOR	2180004082	28	MOTOR PULLEY	2180004142
11	Ø70 SEPARATOR	2180070662	29	DIN933 M8x80 SCREW	TD93308080
12	4207 BEARING	2180004207	30	DIN934 M8 NUT	TD93400008
13	ROCKER SHAFT PULLEY TL-800	2180000132	31	BELT TENSION ADJUSTER	-----
14	POLY-V BELT 1355 J20	2180000012	32	DIN 912 M8x30 SCREW	TD91208030
15	Ø40xØ10x6mm WASHER	204000A401	33	10HP III PHASE MOTOR 112-B3	21800000M3
16	DIN 128 Ø10 WASHER	TD128000010	34	DIN 125 Ø10 WASHER	TD125000010
17	DIN 933 M10x25 SCREW	TD93310025	35	DIN 934 M10 NUT	TD93400010
18	DIN 913 M8x16 SCREW	TD91308016			

7.6. Exploded view turret assembly.



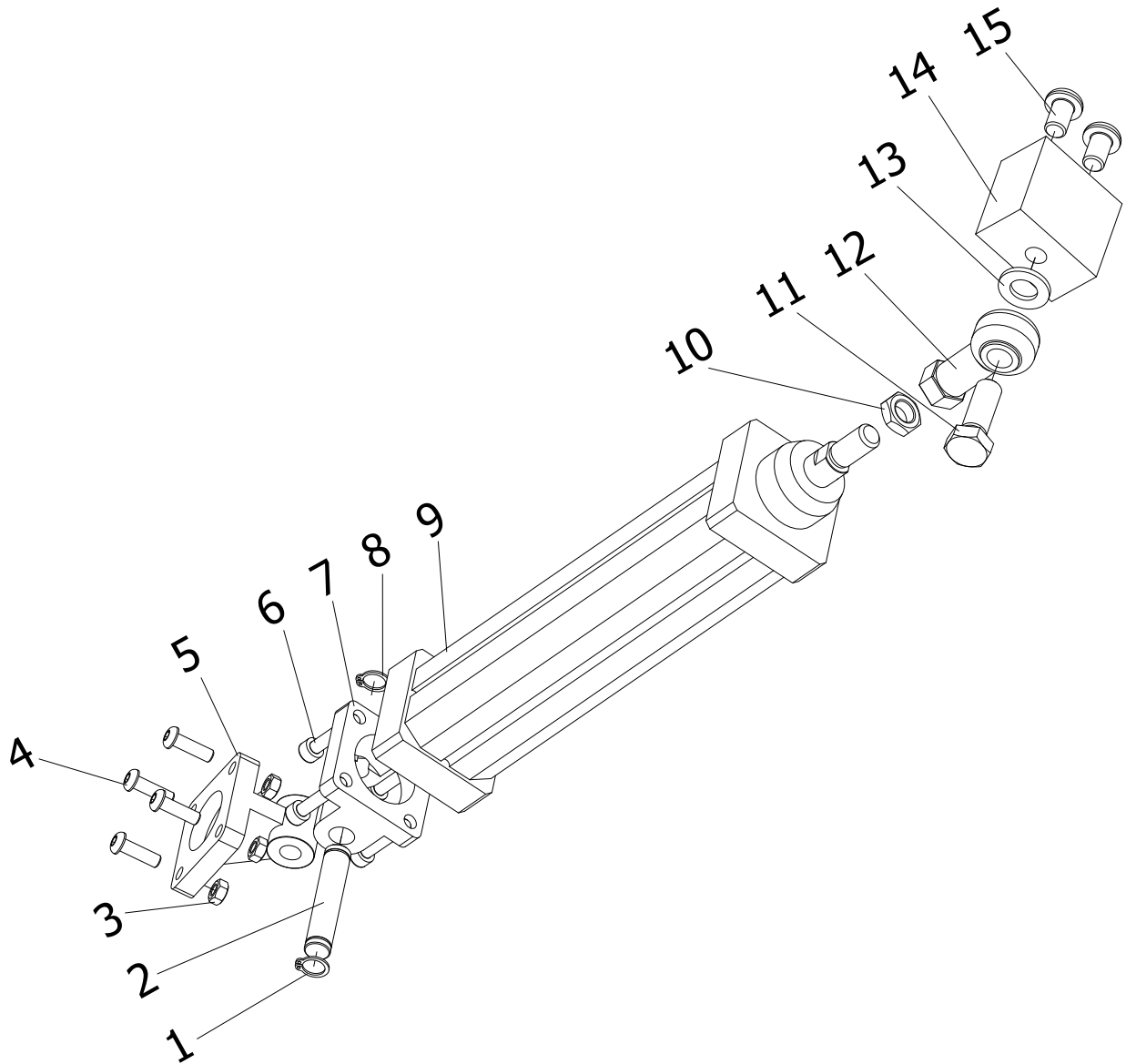
°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
1	TURRET SUPPLEMENT		17	M12x70 LEVER	B0000P1270
2	IRON TURRET	P2180000026	18	ALUMINIUM ROD. HOR. CLAMP	204000A502
3	DIN 912 M12x70 SCREW	TD91212070	19	FLAT NUT M12	
4	FLAT NUT M12		20	M12x70 LEVER	B0000P1270
5	M12x70 LEVER	B0000P1270	21	HORIZONTAL CLAMP Ø40x450	N03PT14050
6	DIN 912 M6x16 SCREW	TD91206016	22	SUPPORT OF DRAWER.	
7	DIN 912 M8x20 SCREW	TD91208020	23	D913 M10x40	TD93310040
8	CLAMPS ALUMINIUM GUIDE		24	D125 Ø10 WASHER	TD12500010
9	NYLON CLEAT BLACK M16	2180000028	25	D934 M10 NUT	TD93400010
10	FLAT NUT M12		26	HANDLE TRISTAR HEMBRA M10	B0000000H2
11	TURRET PROTECTOR		27	Ø20-Ø10 WASHER	2130000011
12	Ø55 ALUMINIUM ROD	2180000011	28	HORIZONTAL CLAMPS ARM	2180001492
13	Ø45-Ø12 WASHER	204000A401	29	DIN 912 M10x20 SCREW	TD91210020
14	M12x70 LEVER	B0000P1270	30	NYLON CLEAT BLACK M10	2350000131
15	PNEUMATIC CLAMPS Ø55x400	2008005212	31	ALUMINIUM PLATES TL-800 (2)	2180000027
16	SECURITY VALVE	N000000015	32	DIN 912 M8x16 SCREW	TD91208016

7.7. Exploded view protective shield.



N°	DESCRIPTION	CODE	N°	DESCRIPTION	CODE
1	ISO-7380 M6x10 SCREW	T173800610	12	CONNECTING ROD PIN P. SHIELD	-----
2	LEFT PROTECTIVE SHIELD	-----	13	Ø40x6 AVELL. M8 WASHER	204000A401
3	DIN-934 M6 NUT	TD93400006	14	DIN 7991 M8x40 SCREW	TD79910840
4	M8 HANDLE	B000000L17	15	PROTECTIVE SHIELD SUPPORT	
5	1329x1005x3 METHECRYLITE	2180000142	16	ISO-7380 M8x10 SCREW	T173800810
6	FRONT CLOSING	-----	17	SHIELD POST	
7	TOP CLOSING		18	END OF TRAVEL	E00000BD25
8	DIN-934 M6 NUT	TD93400006	19	PROTECTIVE SHIELD PVC	
9	RIGTH PROTECTIVE SHIELD		20	DIN 912 M6x16 + DIN 934 M6	TD91206016
10	ISO-7380 M6x10 SCREW	T173800610	21	ISO-7380 M8x10 SCREW	T173800810
11	FINAL GUIDE OF END-OF-TRAVEL				

7.8. Exploded view of protective shield of cylinder set (x2).



Nº	DESCRIPCIÓN	CÓDIGO	Nº	DESCRIPCIÓN	CÓDIGO
1	DIN 471 Ø12 RING	-----	9	ISO 40x250 CYLINDER	CN00040250
2	BOLT ISO 40	-----	10	ISO8675 M10 NUT	-----
3	DIN 934 M6 NUT	TD93400006	11	DIN 931 M12x35 SCREW	TD93112035
4	ISO 7380 M6x20 SCREW	TI73800620	12	M12 CIL ISO 40 BALL JOINT	-----
5	SIDE SUPPORT 90º CIL. ISO 40	CN000904059	13	DIN 125 Ø12 WASHER	TD12500012
6	DIN 912 M8x25 SCREW	TD91208025	14	BALL JOINT SUPPORT	2150000502
7	HINGE HEMBRA CIL. ISO 40	CN000004059	15	ISO 7380 M10x16 SCREW	TI73801016
8	DIN 471 Ø12 RING	-----			