

WARRANTY STATEMENT

SOMMER & MACA Industries, Inc. (Seller) warrants products of its manufacture to be free from defects in materials and workmanship in normal use for six months from the date of shipment unless a shorter period is provided elsewhere in this document. Seller's obligation and Buyer's exclusive remedy shall be limited to the repair or replacement at Seller's option, of defective parts within warranty period, provided Buyer gives Seller immediate written notice of such alleged defects, and if requested by Seller, returns the defective parts to Seller's factory for Seller' inspection.

The warranties contained herein are in lieu of any other warranty expressed or implied, including any warranty of MERCHANTABILITY OR FITNESS FOR PURPOSE.

In the case of equipment furnished by Seller but not of Seller's manufacturer, Seller's liability to Buyer hereunder. Adjustment at the manufacturer thereof makes to Seller. Seller shall in no event be liable for consequential damages.

Warranties hereunder shall not apply to any equipment that shall have been damaged by misuse, neglect, failure to perform maintenance or accident after the shipment thereof by Seller. In addition thereto, this warranty shall be null and void if:

- 1. Machine is used in a manner contrary to instruction or after malfunction is noticed.
- 2. Buyer does not honor terms of payment.
- 3. Machine is modified or altered without the agreement of Seller.

PREFIX

We suggest to carefully follow the instructions in this manual and to regularly follow procedures of maintenance, which will allow you to obtain a higher degree of reliability, safety and durability of the product.

- This manual contains several advises and precautions for safety. We urge you to read them carefully. In this way you will avoid danger, injuries and eventual damage to the machine.
- * Exclusively trained personnel must do maintenance and repairs.

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1.) <u>TECHNICAL FEATURES</u>

1.1) <u>Machine dimensions</u>

Length	:	5000 mm (196.5")
Width	:	1300 mm (51")
Total height	:	2400 mm (94.5")
Worktop height	:	850 mm (33.5")
Weight	:	1300 Kg (2866.5 lbs)

1.2) <u>Electrical and pneumatic requirements</u>

Voltage	:	3-Phase/230Volts	+/- 10%
Frequency	:	60 Hz.	+/- 5%
Auxiliary service voltage	:	24Volts/60Hz.	
Pneumatic supply	:	6 Bars (87 psi).	
Installed power	:	12 kW (16) hp	+/- 10%

1.3) <u>Machine performance description</u>

Workable thickness	:	3 – 20 mm (1/8" - 3/4")
Working speed	:	0-3 m/min (0-9.84 ft/mn)
Adjustable removal	:	0 – 2.5 mm (0 – 0.098")
Coolant system	:	Closed circuit

2.) <u>SAFETY RULES</u>

The machine is provided with all devices of protection both mechanical (chain guard, shelters, etc.) and electrical (sensors, stops, etc.) in order to avoid any contact with moving parts by the operator.

It is absolutely prohibited for anyone to alter or remove any safety devices mentioned above with the power on!!

Any kind of verification, control, cleaning, maintenance, change or substitution of parts must be done with the power off and the main disconnect locked out. (see section 9)

The machine is moreover designed in conformity to **CE** as per the enclosed statement.

The manufacturer declines any and every responsibility for lack of following safety rules and of injury prevention described below. He moreover declines every responsibility of damages caused by an improper use of the equipment or changes made without authorization. It is also necessary for personal safety that no one beside the operator remains in proximity of the equipment when in use.

2.1) General safety rules

When operating electric equipment, it is necessary to adopt the appropriate safety precautions to minimize the risk of electrical shock or injuries. Before operating the machine, read the manual carefully and memorize the following safety rules and save this booklet for future reference:

- Keep the work area clean and orderly, as unorganized work areas encourage accidents.
- Before starting, verify the condition of the machine. Check the standard operation and for broken and or damaged parts. Replace all broken or damaged parts by a competent and authorized service person.
- All repairs performed by unauthorized service personnel will void the warranty and will constitute operating the equipment in an unsafe manner leading to potential danger.
- It is absolutely prohibited to let children, outsiders, untrained, or people in poor health to touch or use this equipment.
- Verify that the electrical power source conforms to the electrical specifications before operating this machine.
- When installing the electrical power source, make sure that the machine is properly grounded.
- Check the outlet to be appropriate and compatible with the automatic protection switch in the machine.
- The extension cord if used must have a grounded receptacle, plug and cable as per code.
- Never stop the machine by disconnecting the power.
- Check periodically the condition of the cable and replace it should it become cut or frayed. This work is to be performed only by qualified personnel.
- Do not allow any personnel to come in contact with this cable.
- Do not ignore these advices. Such an act will constitute an unsafe use of this equipment and will create a potential danger.
- Personnel authorized by the manufacturer must make repairs.
- The manufacturer is available for immediate technical assistance to insure optimum performance and the maximum production of the machine.

3.) SHIPPING, MOVEMENT AND STORAGE

Specialized and competent personnel must perform all shipping operations of the machine.

3.1) Machine shipping and crating

The crated machine is easily transportable by a crane or a forklift with a minimum capacity of (3) tons and lifting eyes as shown on the machine assembly drawing in the Annex 0 section of this manual.

In the act of moving be very careful to avoid bumping or dropping the machine or causing excessive vibration to avoid damaging components.

3.2) Packing and unpacking

After unpacking, make sure of the condition of the machine while checking to see if there is any visible damage.

If in doubt, do not use the machine and call the manufacturer's customer's service.

3.3) Storage until installation

It is okay to store the machine in its original container providing that it is not stored in a place of high humidity.

In the case of a long or extended idle period or a period of nonuse after the machine has been used, it is necessary to disconnect the power source and provide protection to the machine with a plastic cover to avoid dust. Grease all parts that can be damaged by oxidation or moisture.

4.) INSTALLATION AND CONNECTIONS

4.1) <u>Environmental working conditions.</u>

The machine can work at temperatures between 41 and 113 degrees Fahrenheit.

4.2) Space requirements

Make sure that the clearance provided around the machine is sufficient to be able to open all doors completely and to perform all operations of maintenance.

4.3) <u>Machine installation requirements.</u>

Before placing the machine in its final location, proceed with the following checklist:

- \checkmark Check the ability of the floor to support the weight of the machine and its accessories.
- ✓ Check the lighting around the machine. It should be free from shaded areas, inconvenient high beams and or stroboscopic lights that could create dangerous conditions.
- \checkmark Check the condition of the machine for damage as a result of transportation.
- \checkmark Check to see that all feet of the machine are uniformly positioned on the floor.

After the machine has been placed in its working position, it must be correctly leveled using the adjustable feet.

4.4) <u>Electrical connection</u>

Work performed on electrical parts, electrical safety of this equipment is assured only when it is correctly connected and properly grounded as per federal, state, and local codes concerning the same.

It is mandatory to verify these basic safety requirements and when in doubt, ask for a check of the electrical circuit by professionally trained personnel.

The manufacturer is not responsible for damages caused by an improperly connected machine.

WARNING: Interruption capacity of main circuit breaker: < 6 kA

Verify that the short circuit capacity of the supply is compatible With the main circuit breaker.

4.5) <u>Pneumatic connection</u>

Compressed air is required and must be connected to the FRL (filter, regulator and lubricator) on the outside of the machine.

A shut off valve should be placed ahead of the FRL.

After pressurizing the pneumatic circuit, set the air pressure on the pressure gauge of the regulator to 6 bars which is approximately 90-psi minimum. Adjust the knob on the regulator to achieve the above value.

5.) <u>EQUIPMENT DESCRIPTION</u>

There are four spindles equipped with:

- 1st diamond grinding wheel 150 mm dia. (M1)
- 2^{nd} grinding wheel for rear arris 100 mm dia. (M2)
- 3^{rd} grinding wheel for front arris 100 mm dia. (M3)
- 4^{th} polishing wheel for flat edge 150 mm dia. (M4)

The diamond grinding wheel spindle M1 have a locknut and a knurled knob (see enclosed drawing **MMD** on annex 4). One complete turn of the knob #3 on the drawing **MMD** will raise or lower the grinding wheel by **2 mm** or approximately .079". This knob has 40 grades; each grade is equal to variation of height of .002".

The spindles for the arris edges and the flat polishing wheels work pneumatically, and are controlled electronically to engage and disengage the operation of the electrovalves relative to every wheel.

6.) MAIN ASSEMBLIES

- 1) Lever to regulate glass removal
- 2) Dial indicator for reading of quantity to be removed
- 3) Adjustable feet to level the machine
- 4) Knurled knob for diamond grinding wheel adjustment
- 5) Diamond grinding wheel motor M1
- 6) Rear arris grinding wheel motor M2
- 7) Front arris grinding wheel motor M3
- 8) Polish wheel motor M4
- 9) Pneumatic cylinder
- 10) FRL group (filter, regulator and lubricator)
- 11) Base
- 12) Conveyor motor to advance glass
- 13) Anchors to lift and move the machine
- 14) Support structure
- 15) Control panel (see annex. #1)

7.) OPERATION CYCLE: COMMANDS AND FUNCTIONS

The machine operator is advised to do the following:

Warning: Always make sure the pump is ON, before you run glass. Otherwise a major damage could be caused to the machine.

The switching on of the spindles must be done progressively as follows:

1. Turn motor M1 on (diamond grinding wheel).

Note: The pump will be turned on automatically when you turn on M1

- 2. Turn motor M2 on (rear arris grinding wheel)
- 3. Turn motor M3 on (front arris grinding wheel)
- 4. Turn motor M4 on (regular flat polishing wheel)

	FOUR CUP MACH	INE WHEELS ARRANGEMENT	
WHEELS	GRIT	ТҮРЕ	PART#
M1	140-170 (.025inch DEEP)	FLAT EDGE CUP (DIAMOND)	3-97302-01
M2		AB 280 CUP	3-97301-02
M3		AB 280 CUP	3-97301-02
M4		10S40	3-97300-01

The adjustment of the amount of glass to be removed is located under the infeed glass conveyor side and is changed by operating the lever (0 - 0.4") as seen on the decimal dial indicator. <u>NOTE THAT MAXIMUM</u> <u>MATERIAL REMOVAL IS 0.098" (3/32")</u>

For optimum machine output, it is recommended to use these settings.

	WHEEL	S #2, #3 & #4 S	SETTING	
	mm	4 TO 8	8 TO 12	12 TO 20
GLASS MICKNESS	inches	1/8 TO 5/16	5/16 TO 1/2	1/2 TO 3/4
SPINDLE 2 & 3	bars	2	2	2
AIR CYLINDER PRESSURE	psi	29	29	29
SPINDLE 4	bars	3.5	3.5 TO 4.5	4.5 TO 5
AIR CYLINDER PRESSURE	psi	51	51 TO 66	66 TO 73
	m/mn	1.4 TO 1.8	1.3 TO 1.6	0.5 TO 0.8
CONVETOR SPEED	ft/mn	4.6 TO 5.9	4.26 TO 5.25	1.64 TO 2.62

NOTES:

ONLY METRIC CONVEYOR SPEED CAN BE ENTERED INTO CONTROL PANEL
 MINIMUM PRESSURE ON ALL CYLINDERS SHOULD BE 2 BARS
 LOWER PRESSURE ON M4 WHEN POLISHING SMALL TAIL STOCK

7.1) <u>Wheel replacement procedure</u>

When replacing grinding or polish wheels, insert spindle-locking wrench over the flats on the spindle hub. Place 30mm box wrench or 8mm Allen wrench on the spindle locking screw, hold firm and rotate the spindle clockwise. This will loosen locking screw. Reverse hub rotation to tighten locking screw.

In the event you must replace the diamond grinding, proceed as follows:

- Lower the diamond-grinding wheel via the knurled knob as far as possible while leaving the locknut in its previous position.
- Remove the old wheel as mentioned above
- Install the new wheel
- Turn water on
- Turn motor M1 on if you working on spindle 1
- Adjust conveyor speed to minimum level
- Load a piece of glass into the machine
- Set the conveyor direction switch to forward
- Press the conveyor start button
- Wait until glass passes the grinding wheel, and set the conveyor direction switch to forward
- Remove glass and measure the amount of glass removed
- Raise the knurled knob until the desired amount of glass is removed and retighten locknut
- Gradually increase the glass conveyor speed to its desired level

In the event of glass breakage, press the emergency stop button

- Decrease speed control setting and remove the glass from the machine by reversing the glass travel direction.
- Correct the problem causing the breakage and resume operation.

7.2) <u>Necessary spacing between glass pieces</u>

- Leave 1 inch in between glass pieces of same thickness, so you can put your fingers between the two glass pieces to remove it from glass conveyor.
- Leave 8 inches in between glass pieces of different thickness, because that is the necessary distance for arris and polish spindle to retract and engage.

8.) <u>MACHINE CIRCUITS</u>

8.1)	<u>Electric circuit</u>		
	• Schematic and components		annex #2
	Control panel		annex #1
8.2)	Electrical specification		
A)	General electrical characterist	ics	
	 Machine voltage 	:	3 phase/230 volts +/-10%
	 Frequency of operation 	:	60 Hz +/-5%
	 Auxiliary service voltage 	:	24 volts/60 Hz
	 Pneumatic service voltage 	:	24 volts/60 Hz
B)	Motors		
	 Motor M1 	:	2 pole/380 volts/60 Hz/3 hp
	 Motor M2 	:	2 pole/380 volts/60 Hz/2 hp
	 Motor M3 	:	2 pole/380 volts/60 Hz/2 hp
	 Motor M4 	:	2 pole/380 volts/60 Hz/3 hp
	 Pump motor 	:	2 pole/380 volts/60 Hz/0.5 hp
	 Conveyor motor 	:	4 pole/380 volts/60 Hz/0.5 hp
			Complete with 160:1 reducer

8.3) <u>Pneumatic arrangement</u>

• Pneumatic circuit outline

Annex #3

9.) <u>MAINTENANCE</u>

WARNING!

Any kind of verification, cleaning, maintenance, replacement and substitution of parts must be performed with the power off and the main disconnect locked out. (see section 2)

OSHA 29 CFR 1910.147 standard requires the placement of a lockout on energy stored equipment in a manner that will render them safe to work on and prevent the inadvertent start up of such equipment, in accordance with an established procedure, and ensure that the energy-isolating device and the equipment being controlled cannot be operated, while it is being serviced or maintained, until the lockout device is removed.



9-1.) Preventive maintenance

- When switching the machine on, check the air pressure. It must be at or above 6 bars / 90psi.
- It is necessary to keep the machine clean from glass grindings regularly to prevent premature wear.
- It is also necessary to keep the machine inside of the spindle tub clean from broken glass to prevent damage to the water delivery system.
- It is necessary to continually check the condition of the grinding and polishing wheels and replace them as required.
- Every 40 hours of operation drain the condensation from the FRL group. Replenish oil reservoir with a good grade of Air Tool Oil (Mobil Almo 525 or equivalent). P/N 299-0148-0
- Every 200 hours of operation lubricate all of the ball bearing units with a NLGI #2 wheel bearing grease.

Somaca		VFE 4		Vendor	
Part Number	Fuse ID	Description	Vendor	Part Number	Qty
4700302002	4FU1	FUSE 1A 400V 10x38mm 120ka	Shawmut	16011-G	2
4700330102	4FU2	FUSE 6A 500V 10x38mm 120ka	Shawmut	16523-G	1
4700302001	3FU1	FUSE 4A 400V 10x38mm 120ka	Shawmut	16019-G	2
4700330103	1FU1	FUSE 32A 400V 10.3x38mm 100ka	Shawmut	16043-G	3
4700302004	1FUG	FUSE 50A 400V 14x51mm 100ka	Shawmut	17551-G	3

9-2.) Fuse list

10.) TROUBLE SHOOTING SOLUTIONS

PROBLEM	CAUSE	SOLUTION
Motors do not spin	Burnt fuse Thermal out Electrical interruption	Replace Reset Verify
No pneumatic movement	Not enough air pressure Solenoid valve broken or defective	Verify pressure At 6 bars / 90 psi. Minimum Check and replace
Water pump not working	Burnt fuse Thermal out Electrical interruption	Replace Reset Verify

11.) <u>ANNEXES</u>

Main Assembly	Annex#0
Control panel	Annex #1
Electrical circuit outline	Annex #2
Pneumatic circuit outline	Annex #3
Assemblies	Annex #4
Programming of "Mini-Job" Controller	Annex #5

























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10 Carter - Protection corter 8 Puleggio - Pulley 9 Sitte tendicinghia - Site lightening belt 7 Chephia - Belt 8 Moleare - Electric moloc 5 Distanzide - Distance r/ng 4 Compano - Cone 3 Nonio - "Nonio" 4 Compano - Cone 2 Mola a tazzo - "Beltaville" weaher 1 Deco - Nut 0 Deco - Nut 0 Deco - Nut 0 Muchan PRR 1 Deco - Nut 0 Deconfinition 1 Deco - Nut 0 Deconfinition 0 Deconfinition 0 Deconfinition	=	Distanzide - Distance ring
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4 Compone - Cone 3 Nonio - "Nanio" 4 Lonio" 2 Maile al Lazzo - "Ballaville" veaker 1 Dodo - Nut 0 Dodo - Nut 1 Maxani 1 Maxani<		Distanzida – Distance ring
3 Nonio - "Ionio" 2 Vala o Lazzo - "Balteville" vesiter 1 Dodo - Nut 05 DESCRIZIONE 05 DESCRIZIONE 05 DESCRIZIONE 05 DESCRIZIONE 06 Nut 1 Dodo - Nut 1 Dodo - Nut 05 DESCRIZIONE 06 DESCRIZIONE 1 NACORNA PER	+	Compane - Cone
2 Molto a tarzo - "Beñavilia" washer 1 Dedo - Nut 05 Descoremony 1 Naccentral 1 Marchine 1 Marchine 1 Marchine 1 Descoremony	-	Nonio — "Nonio"
1 Dodo - Nut 05 Descentarione 05 Descentarione 06 Nacomine and an an and an	8	Molia a tazza - "Bullavilla" washer
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37 Cuscinetto - Bolt bearing
36 Distantial - Distance ring
35 Wie - Scree

Chiero - Ring nut

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III Wise officers + Seeger - Breas acres + 'Seeger' B0 Cuschaltil - Baft beachiga B1 Kiero - Stopped acres B2 Seeger - 'Seeger' B3 Cuschaltil - Baft beachiga B4 Nie di (armo - Stopped acres B3 Cuschaltil - Baft beachiga B4 Cuschaltil - Baft beachiga B3 Cuschaltil - Baft beachiga B4 Cuschaltil - B	23	Monometro – Preseure gauge
A Curcinatiti - Bati bacaringa B Seeger - "Seeger" Curcinatiti - Bati bacaringa Curcinatiti - Bati bacaring Carpo mondrino - Spinda body Carpo mondrino - Spinda body Conclusti - Bati bacaring Connotto - Senda bacaring Duarnidiona - Canket Duarnidiona - Canket Connotto - Spinda boaring Connotto - Spinda boaring Duarnidiona - Canket Duarnidiona - Canket Control - Key Control - Key Duarnidiona - Canket Duarnidiona - State and Duarnidiona - Canket Duarnidiona - Canket Duarnidiona - Canket Determidiona - State and Duarnidiona - Mati auport Duarnidiona - Canket Duarnidiona - Canket Duarnidiona - State and Duarnidiona - State and Duarnidion	-	Vie oltone + Seeger - Bross screw + "Seeger"
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8 Mie di fermo - Stopped actew 7 Cuecheilt - Bidi beochega 8 Cuecheilt - Bidi beochega 10 Cuecheilt - Bidi beochega 11 Cannoticha - Spindla body 12 Cuecheilt - Bidi beochega 13 Cuecheilt - Bidi beochega 14 Chiowella - Spindla all body 15 Pottiatia perio mola - Lociching worther 16 Albee mandoho - Spindla aluport 17 Dodo bloccoggio mola - Lociching worther 18 Randatis bloccoggio mola - Lociching worther 19 Ouomitione - Gankati 10 Conter - Protoccina - Autobalici alonit 11 Cuecheilio - Siloi tegening 12 Duentidie - Distance ring 13 Jounnitoine - Gankati 14 Conter - Protoccina corter 15 Distanciale - Distance ring 16 Conter - Protoccina corter 17 Dueomitole - Distance ring 18 <td></td> <td>Saager - "Saager"</td>		Saager - "Saager"
17 Curechastit - Bait bacringa 18 Puleggia - Pulley 18 Curechastit - Bait bacring 19 Curechastit - Bait bacring 11 Curechastit - Bait bacring 12 Curechastit - Bait bacring 13 Curechastit - Bait bacringa 14 Curechastit - Bait bacringa 15 Curechastit - Bait bacringa 16 Curechastico casted 17 Conontio - Spinda body 18 Albare mandrino - Spinda body 19 Curechastico - Sevida anoti 11 Conceptio molo - Spinda anoti 12 Contentione - Gasket 13 Routatione - Gasket 14 Chlowello - Key 15 Pottatits perta molo - Demond what support 16 Conontrione - Gasket 17 Dode bloccoggio molo - Lecking vasher 18 Pottatione - Gasket 19 Quentitione - Key 10 Canin antireturatione - And beering 11 Curetar - Protection carter 12 Duetonatide - Distonce ring 13 Duetonatide - Distonce ring 14 Londra proventico - Sida tighteming betit 15 Carter - Protection carter 10 Carter - Protection carte		Vite di fermo - Stopped acrew
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Classifieratio casicia - Axiel bearing Corportatione - Spindle body Carrentia - Seever Carrentia - Seever Carrentia - Stever Abere mendolno - Spindle body Pottale beccoggia mola - Nuti Pottale porta mola - Dismond wheat support Pottale porta mola - Dismond wheat support Chlowella - Stever Connotatione - Geatest Data blaccoggia mola - Locking wather Pottale porta mola - Dismond wheat support Chlowella - Kara Data blaccoggia mola - Locking wather Data blaccoggia - Putalellon dowel Data blaccoggia - Putale Sille tendelengine - Siles tightering beil Carai exitractione - Care Data blaccoggia RETRUME Molare - Beach Data blaccoggia RETRUME Polare - Beach Data blaccogia RETRUME Polare - Beach	=	Ouschetti - Boli bearing
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20 Cuschatti - Bolt baorhga 8 Quomitione - Gaikat 17 Dodo bloccopgio molo - Sphale shoft 18 Albere mandrino - Sphale shoft 19 Dodo bloccopgio molo - Locking washer 10 Rendate bloccopgio molo - Locking washer 11 Dodo bloccopgio molo - Locking washer 12 Plottelle porto molo - Diamond what support 13 Quomitione - Gasteti 14 Chlowito - Kay 15 Distanzide - Distance ring 16 Grant entirotazione - Antretation dovel 11 Cuerter - Protection corter 12 Distanzide - Distance ring 13 Distanzide - Distance ring 14 Motore - Electric motor 15 Carler - Protection corter 16 Grante - Bastic motor 17 Puteogio - Puteo 18 tatomatico - State ring 2 Carryan - Bastic 3 Distanziole - Distance ring 13 Distanziole - Distance ring 14 Motore - Electric motor 15 Carryan - Bastic 16 Carler - Protection corter 17 Carler - Protection corter 18 Bastic Holder 19 Distanziole - Distance ring <td>-</td> <td>Connotto - Seeve</td>	-	Connotto - Seeve
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8 Cartar - Protection cortar 7 Puisagio - Puiley 8 Sitta tandichrghio - Sida tightening beit 8 Cheghio - Batt 9 Lotore - Bactir molor 1 Uotore - Bactir molor 2 Campona - Carie 3 Distornation - Distorce ring 1 Clindre pnaumetice - Presumetic cylinder 0 Clindre pnaumetice - Presumetic cylinder		Distanziale - Distance ring
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1 Clindre preumetteo - Preumette cylinder 05 DESCRIZIONE 05 DESCRIZIONE 05 DESCRIZIONE 05 DESCRIZIONE 06 DESCRIZIONE 07 Maximum 1 Maximum	~	Campana - Cans
05. DESCRIZTORE 05. DESCRIPTION 1 PLN 1	-	Clindro pneumetico - Pneumatic cylinder
Image constrained constrained I VACCHIMA PER INOCIONA PER NOCIONA P	S S	DESCRIZIONE
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Programming of "Mini-Job" Controller

<u>Caution: Parameters have been factory set. Changes to these settings without consulting supplier may void</u> <u>warranty.</u>

The procedure for making program or parameter changes of the distance settings from the glass micro switch are as follows:

- 1. Insert the proper key into the keyed switch and turn the key clockwise to switch to programming mode.
- 2. Press **F** and then **1**. The word **ACCES** will appear at this time.
- 3. Press C and in sequence the numbers 14863.
- 4. Press **M** to confirm the parameter settings. The first parameter that will appear on the screen is the **CC**, which is the ratio between the encoder and the shifting of glass; it is always fixed at **2300**.
- 5. Press **M**, The second parameter is **LO**, which is always set at **60**.
- 6. Press M. NL will display.
- 7. Enter 1 to program NL1, which is the set of parameters to program the distance between the first seam wheel (spindle M2) and the glass micro switch of entrance.

<u>Notes:</u> it is possible to program NL1, 2, 3 or 4 in different modes, in our case all parameters are to be set in AUT.

- 8. Press the M key to select AUT.
- Press M. The will automatically see DS, which is the distance of the grinding wheel to the glass micro switch of entrance, then enter value of (360) (see Figure1 & 2).
- 10. Press **M**, you will automatically see **E1**, then enter the pre-insertion value of "-25" (see **Figure1 & 2**).
- 11. Press **M** and you will automatically see **E0**, then enter the grinding wheel post-release value of "40" (see Figure1 & 2).

- 12. Press **M** to memorize and the display will show **END**
- 13. Wait for 5-7 seconds. After NL will display again, enter 2 to set NL2 or 3 to set NL3.
- 14. After you entered **NL1**, **NL2 and NL3**, you need to switch to operating mode. After the waiting period of 5-7 seconds that precedes the display of **END**, enter **F**, enter **6** then switch and turn the key counter-clockwise to switch from programming to operating mode.

VFE-6 PROGRAMMING PARAMETERS							
	SPINDLE	DS	E1	E0			
NL1	M3	360	-25	40			
NL2	M4	518	-25	40			
NL3	M5	760	-15	30			
Figure 1							





Figure2