

MOTORIZED GUILLOTINE SHEAR

USER MANUAL



**THIS USER MANUAL SHOULD BE READ CAREFULLY BEFORE USING THE
MOTORIZED GUILLOTINE SHEAR.**

Bu This user manual has been prepared for the purpose of operating, maintaining, and providing safety precautions for using the **MOTORIZED GUILLOTINE SHEAR**.

Fevzi akmak Mh. Elit San. Sit. 10757. Sok. No:5/J - 42050 KARATAY/ KONYA

Web: www.ostas.com.tr E-mail: export1@ostas.com.tr

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1. OSTAŞ BUSINESS INTRODUCTION

OSTAŞ MACHINERY; carries out production and marketing in the sheet metal processing machinery sector. Our company, which has adopted the principle of customer satisfaction and continuous development as the basic philosophy since the day it was founded, markets its products until today in our country Turkey and in many other countries in the world.

OSTAŞ machinery doesn't compromise on the principle of quality and trust, taking into consideration the importance of meeting the delivery times and the fast service.

Our company;

Our Manufacturing Range includes hydraulic Guillotine Shears, Hand Lever Guillotine Shears, Folding Machine, Pneumatic Lock Seaming Machine, wood breaking machines and other machines and equipment.

Our company, which has the Quality materials, experienced team and modern equipment aims to meet all delivery times and requested documents on time, as well as keeping its customer satisfaction constantly as a priority.

Our Mission;

Our mission is to be a leading company by keeping and increasing the principle of quality and absolute customer satisfaction in the sector we serve.

Our vision;

Adopting the highest quality service based on customer satisfaction in the sheet metal processing machinery sector, contributing to the economy with the products it offers to the market, and becoming a well-known brand worldwide.

COMPANY NAME: OSTAS MAKINA SAN ve TIC. LTD.STI

ADDRESS: Fevzi Çakmak Mh. Elit San. Sit. 10757. Sok. No:5/J - 42050 KARATAY

CITY: Konya

COUNTRY : TÜRKİYE

Web : www.ostas.com.tr

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2. GENERAL NOTES ABOUT THE MACHINE

Thank you for purchasing our OSTAŞ brand product. Please read this machine's user manual carefully so that you can be satisfied with our machine and work without any problems for years.

In this user manual you can find the following information;

- ***Introduction of machine functions***
- ***Using and operating instructions***
- ***Periodic and regular maintenance instructions***
- ***General safety and protection instructions***

WARRANTY CONDITIONS

1. The warranty period starts from the delivery date of the goods and is 2 years.

2. All machine parts, excluding electric motors, are all under OSTAŞ guarantee.

3. In case of any deflection of the machine within the warranty period, the time spent in the repair is added to the warranty period. The machine repair period is a maximum of 30 working days. This period starts from the date of notification of a defect in the machine to a seller, dealer, agency, representative, importer, or manufacturer of the machine. If the machine defect is not solved within 30 working days, the manufacturer or importer has to provide another machine with similar characteristics to the user until finishing the repair of the machine.

4. In case of any deflection of the machine within the warranty period, due to material or manufacturing, or assembly faults, it will be repaired without any charge under any labor cost, replacement part cost, or any other name.

5. In case the machine is still unable to be used as a result of repeating the same error more than twice or existing different defects more than four times within one year from the date of delivery of the machine provided that it remains within the warranty period:

- Exceeded the maximum time required for repair which is 30 days.
- In case the maintenance service is not available, and if it is determined that repairing the fault is not possible with an official report prepared by one of the distributors, agents, representatives, importers, or manufacturers, a free machine will be sent.

6. Defects resulting from the use of the machine contrary to the terms in the user manual are **NOT** covered by the warranty.

- Damages and defects caused by usage faults
- In case of deactivation of machine safety devices.
- When machine regular maintenance is not done
- If the machine is used over its capacity or incorrectly.
- When electrical connections and components are not made properly.
- Damages that occur during loading, transportation, loading and unloading the machine after delivery to the customer
- Low or excess voltage, no grounding, using a voltage different from the voltage written on the machine nameplate.
- Defects due to lack of regular lubrication.
- Damages related to fire and lightning strikes.
- Interfering with the defective part or product after delivery to the customer, exposure to destructive or chemical materials, accident, neglect, and other usage faults, damages that may occur to the machine's body.

Before using this machine, read carefully, understand, and follow the safety rules and operating instructions. Only authorized persons with sufficient training may operate this machine. This manual should be considered an indispensable part of your machine and should be with you every time you use the machine. In case of any damages, problems, or complaints that may occur in your machine, you can contact the address or telephone number mentioned in this manual and ask for help. you can ask for spare parts by informing the machine serial number and requested parts.

Potential danger and instructions related to the machine are indicated on the labels and stickers on the machine. It is important to read the information on these labels and stickers.

All stickers and labels match the following color codes:

Red Color ; Indicates a potential death hazard.

Orange Color; Indicates hazards that could cause serious injury.

Yellow Color ; Indicates hazards that may cause property damage and minor injury.

The authorized person should take the necessary precautions to keep these labels in good and readable condition.







Safety

Make sure that the person you are delivering the machine to is capable of meeting the safety requirements for use.

Avoid work that may cause danger, improper use may result in injury and property damage.

The printed user manual should always be with the user and can be found the machine's documentation box for safely & long life use, including when renting, lending or selling. make sure that all safety and hazard identification stickers or labels are attached and readable.

Definitions of Symbols and Danger Indicators

SYMBOL	DANGER	EXPLANATION
	Electric shock	Avoid direct or indirect contact with the live electrical parts
	Hands Protection	Do not put your hands between blades, tables and moving parts.
	Feet Protection	Pieces may fall on the foot, use safety shoes
	Danger	Attention
	Grounding	Grounding connection should be done
		Use the protective work clothes in the Workplace for safety

3. MACHINE DESCRIPTION AND USAGE

The Motorized Guillotine Shear is a machine produced to cut all kinds of DKP sheet products from 0.1 mm to 6 mm, and copper, aluminum, lead plates in the desired dimensions according to its technical specs.

Manual adjustment can be made on all the machine models and sizes.

- An operator is enough to run the machine and the control panel is fixed on the front of the machine, in an easily accessible place.
- The machine has a second emergency stop button other than the emergency stop button on the pedal.
- The machine noise is within the normal rate. However, if there is a loud noise caused by the environment, the operator may need to use safety earmuffs.
- All information on how to use the machine is detailed in this user manual. The operator must comply with the operating conditions and safety precautions.
- All electrical and hydraulic connections must be made by a certified technician. the output is taken from the electrical panel of the machine. All connections to the machine must be made by a licensed technician.
- The manufacturer is not responsible for injuries, damages, and accidents arising from a situation contrary to the operating conditions and safety precautions.

4. GENERAL SAFETY INSTRUCTIONS

Operators

Operators must be over 18 years of age and have been authorized to use by their employer after passing a health check and test of using the Motorized Guillotine Shear.

ATTENTION!

Only trained and experienced operators can use Motorized Guillotine Shears.

Two operators must work on the machine at least with the following conditions:



- ✓ If the workpiece to be loaded on the machine is large, it may be necessary to immediately intervene in any possible dangers.
- ✓ In case of any accident or mistakes, it may be necessary to take control.

Environment

Never use the machine in the following places:

- ✓ Do not use on soft, unstable, uneven ground.
- ✓ Do not use out of the allowable operating range.
- ✓ Do not use in areas where there is a risk of damage to electrical cables and wires.
- ✓ Do not use in explosive areas.
- ✓ Use the Motorized Guillotine Shears indoors and in places that will not be affected by external environments.
- ✓ Do not use the machine in areas where the lighting is insufficient.

5. MACHINE NAMEPLATE EXAMPLE

  OSTAS MAKINA SAN ve TIC. LTD.STI Fevzi Çakmak Mh. Elit San. Sit. 10757. Sok. No:5/J - 42050 KARATAY/ KONYA Tel: 332 3454588 Website: www.ostas.com.tr			
NAME OF THE MACHINE MAKİNA İSMİ	GUILLOTE SHEAR WITH REDUCER REDÜKTÖRLÜ GİYOTİN MAKAS		
MODEL / TYPE		ELECTRIC POWER / ELEKTRİK GÜCÜ	Kw
YEAR / YIL		WORKING VOLTAGE ÇALIŞMA VOLTAJI	V
SERIAL NUMBER / SERİ NO		MAX CURRENT MAX.AKIM	Amp
WEIGHT / AĞIRLIĞI	Kg	FREQUENCY FREKANS	Hz

6. TECHNICAL SPECIFICATIONS

MODEL	ORGM 1050	ORGM 1350	ORGM 1550	ORGM 2050	ORGM 2550	ORGM 3050
Kesme Kapasitesi Shearing Capacity	3	3	3	3	2,5	2
Max. Kesme Kapasitesi Max. Shearing Length	1050	1350	1550	2050	2550	3050
Kesme Açısı Shearing Angle	2°30'	2°30'	2°30'	1°30'	1°30'	1°30'
Dakikada Kesme Sayısı Strokes Per Minute	35 d/d	35 d/d	35 d/d	35 d/d	35 d/d	35 d/d
Motor Gücü Motor Power	3 kw	3 kw	3 kw	3 kw	4 kw	4 kw
Tabla Geniřlięi Table Width	510 mm	510 mm	510 mm	510 mm	510 mm	510 mm
Tabla Yükseklięi Table Height	820 mm	820 mm	820 mm	820 mm	820 mm	820 mm
Arka Dayama Mesafesi Rear Gauge Distance	600 mm	600 mm	600 mm	600 mm	600 mm	600 mm
En width	2060 mm	2060 mm	2060 mm	2060 mm	2060 mm	2060 mm
Boy Length	1640 mm	1940 mm	2140 mm	2640 mm	3140 mm	3640 mm
Yükseklik Height	1210 mm	1210 mm	1210 mm	1210 mm	1210 mm	1210 mm
Yaklaşık Aęırlık Apporoximate Weight	1.100 kg	1.350 kg	1600 kg	1900 kg	2100 kg	2300 kg

3 mm Standard Features

Manual back-gauge with 600 mm Strock

- 800 mm Length ruler miter
- Foot Pedal with Emergency Stop
- Front Sheet Holding Arms
- Cutting line illumination
- Front, Rear Hand and Foot Protection Cages

3 mm Optional Equipment

- Pneumatic back sheet support system
- Optical safety Barrier
- 0-180° adjustable angular cutting device
- Motorized Back-gauge with 750 mm Strock with NC
- Cutting Counter

MODEL	ORGM 1050	ORGM 1350	ORGM 1550	ORGM 2050	ORGM 2550	ORGM 3050
Kesme Kapasitesi Shearing Capacity	4-5-6	4-5-6	4-5-6	4-5-6	4-5-6	4-5-6
Max. Kesme Kapasitesi Max. Shearing Length	1050	1350	1550	2050	2550	3050
Kesme Açısı Shearing Angle	2°30'	2°30'	2°30'	1°30'	1°30'	1°30'
Dakikada Kesme Sayısı Strokes Per Minute	29 d/d	29 d/d	29 d/d	29 d/d	29 d/d	29 d/d
Motor Gücü Motor Power	7,5 kw	7,5 kw	7,5 kw	7,5 kw	7,5 kw	7,5 kw
Tabla Geniřlięi Table Width	530 mm	530 mm	530 mm	530 mm	530 mm	530 mm
Tabla Yükseklięi Table Height	830 mm	830 mm	830 mm	830 mm	830 mm	830 mm
Arka Dayama Mesafesi Rear Gauge Distance	750 mm	750 mm	750 mm	750 mm	750 mm	750 mm
En width	2200 mm	2200 mm	2200 mm	2200 mm	2200 mm	2200 mm
Boy Length	1630 mm	1930 mm	2130 mm	2630 mm	3130 mm	3630 mm
Yükseklik Height	1280 mm	1280 mm	1280 mm	1280 mm	1280 mm	1280 mm
Yaklaşık Aęırlık Approximate Weight	1850kg	2150kg	2500kg	3100kg	3600kg	4100kg

4-5-6 mm Standard Features

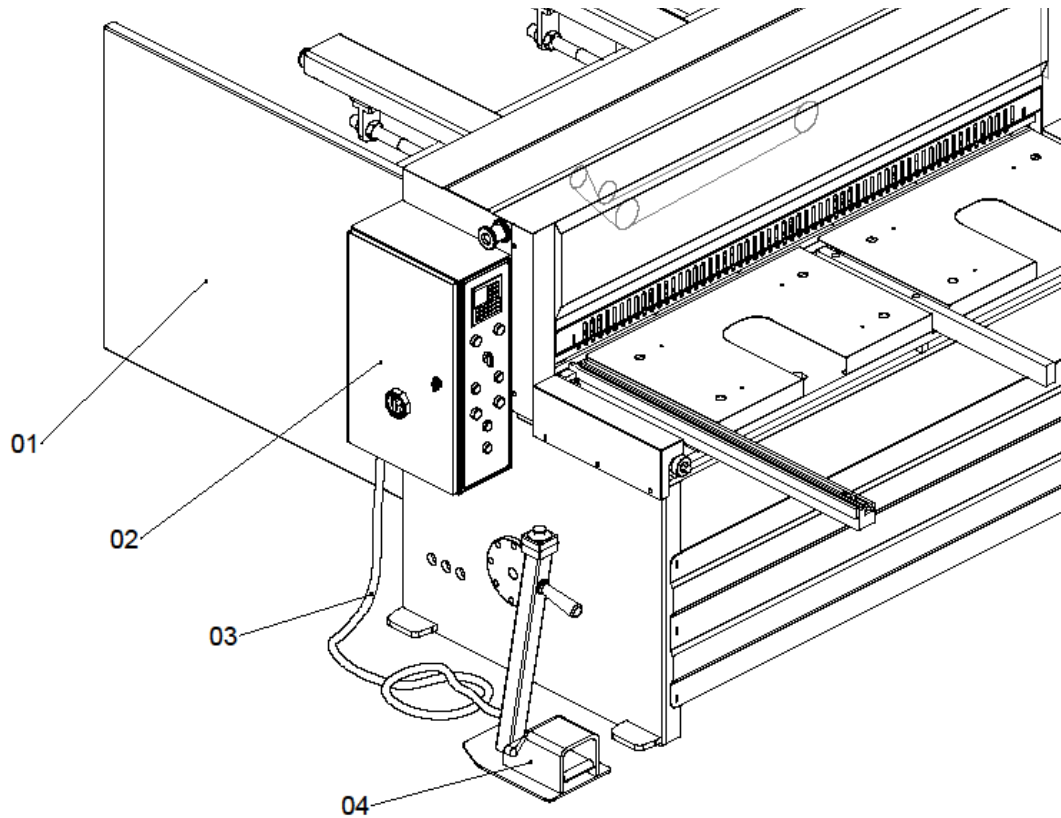
- Motorized Back-gauge with 750 mm Stroke + NC
- 1000 mm Length T ruler miter
- Foot Pedal with Emergency Stop
- Front Sheet Holding Arms
- Cutting line illumination
- Front, Rear Hand and Foot Protection Cages
- Cutting Counter

4-5-6 mm Optional Equipment

- Pneumatic back sheet support system
- Optical safety Barrier
- 0-180° adjustable angular cutting device

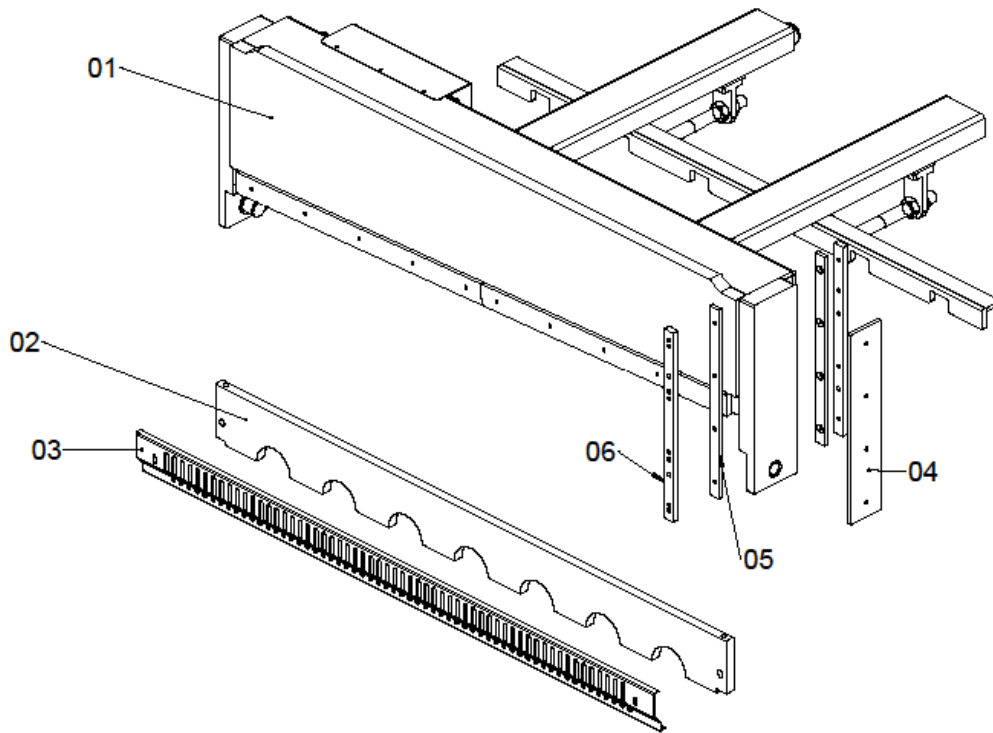
- Our Motorized Guillotine Shears are completely manufactured from steel as a monoblock body using Rigid welding techniques in all our products with high quality and precise work.
- The machine blades (lower and upper Blades) are manufactured from the materials K110 1.2379. All of our Blades are hardened and have a hardness level of 56-58 HRC.
- The back gauge is produced as standard in 750 mm length and can be manufactured to the desired size as an option.
- The brands used in our electrical circuit elements are Siemens, Telemecanique, Schneider, ABB or Merlin Gerin brand products. The control circuit is provided as 24V.
- The machine functions are provided with the help of an electric motor and reducer.
- The External surface of the machine is painted with protective paint against weather conditions.
- Our products are guaranteed for 2 years against manufacturing defects, excluding usage errors.

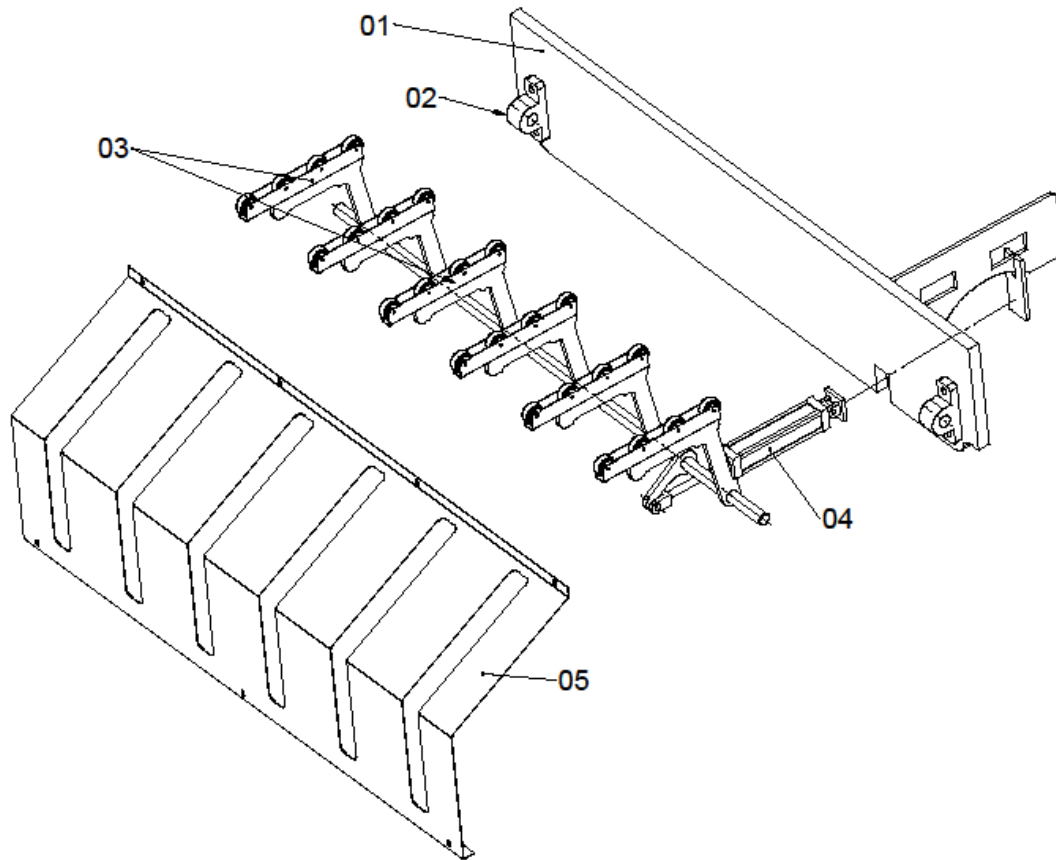
7. EXPLODED VIEW OF THE MACHINE



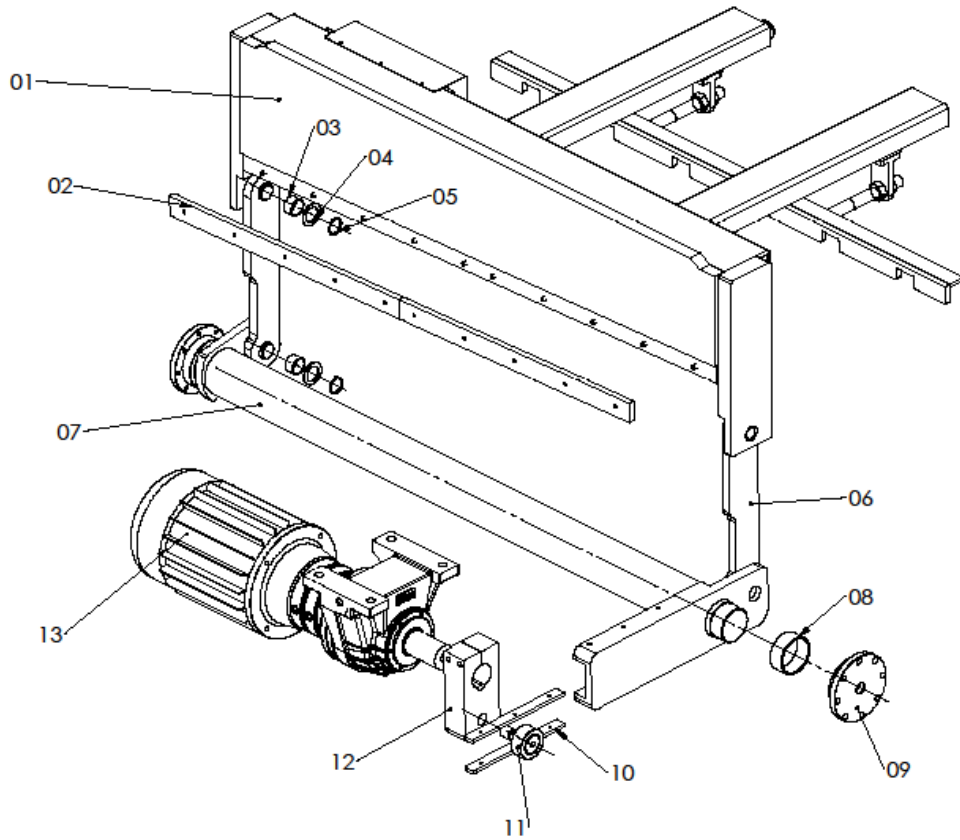
No	Part Name	Mentioned No.	Material
1	Electric Pedal	4	-
1	Cable	3	-
1	Electric Panel	2	-
2	Back side protection cages	1	St 37

No	Part Name	Mentioned No.	Material
4	Front-Rear Sliding Plate connection part	6	Ç1040
4	Front-Rear Sliding Plate of the upper body	5	Castermid
2	Sliding plate of the side of the upper body	4	Castermid
1	Front guards of the upper blade	3	St 37
1	Clamping Table	2	St 52
1	Upper blades body	1	St 37



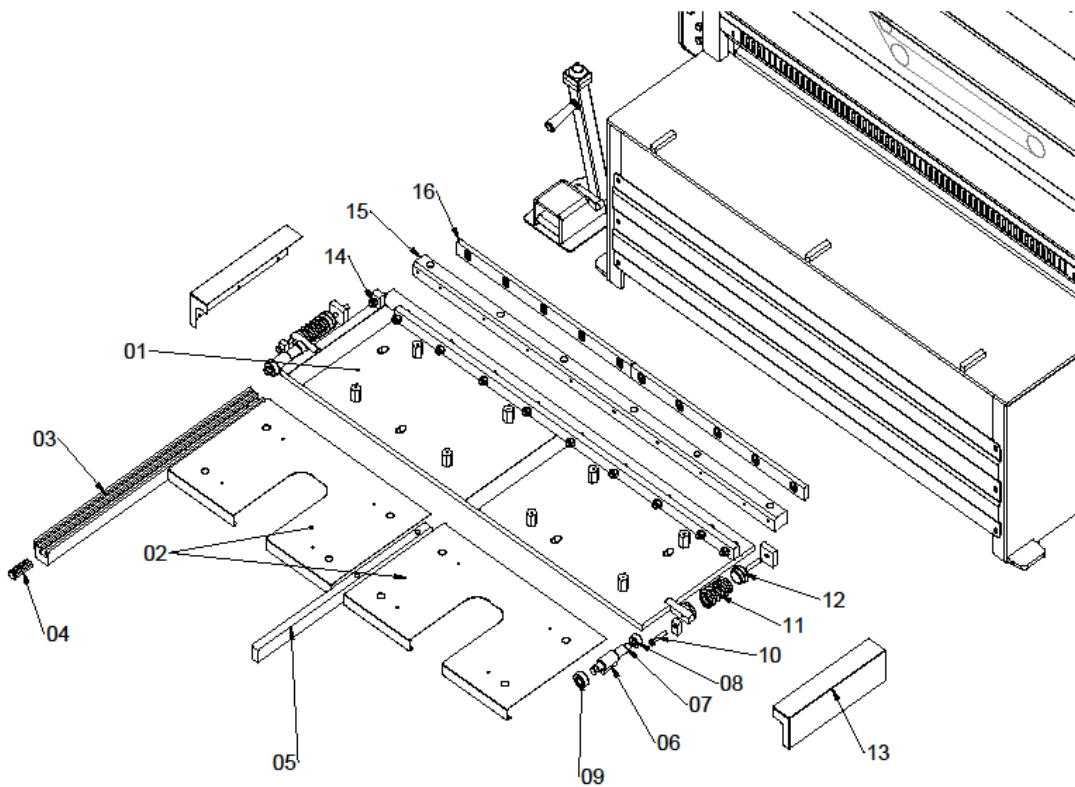


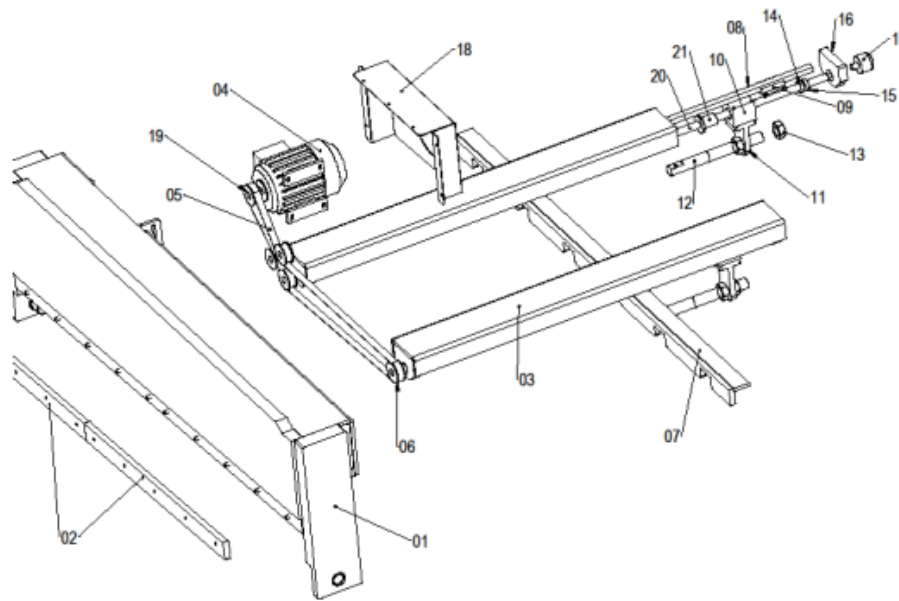
No	Part Name	Mentioned No.	Material
1	Protective cage for Pneumatic parts	5	St 37
1	Pneumatic Piston	4	Ready
6	Supporting Arms and wheels	3	St 37 - Plastic
2	Fixed Bearing rollers	2	Ready
1	Main Body	1	St 52



NO	Part Name	Mentioned No	Material
1	Reducer - Motor	13	Ready
1	Eccentric Lever	12	Ç 1040
1	Bearing	11	Ready
2	Slide	10	Ç 2080
2	Palier	9	Ç 1040
2	Bush	8	Ready
1	Main Shaft	7	Ç 1040
2	Connecting Rod	6	St 37
4	Safety ring	5	Ready
4	Special flake	4	Ç 1040
4	Bush	3	Ready
2	Upper blade	2	Ç 2379
1	Upper blade Body	1	St 52

No	Part Name	Mentioned No	Material
2	Lower Blade	16	Ç 2379
1	Lower Blade Connection Part	15	Ç 1040
10	Lower Blade Adjustment Screw	14	Ç 1040
2	Protection case for springs	13	St 37
2	Adjustable Flange for springs	12	Ç 1040
2	Sentinel Compression Spring	11	Springs steel
2	Table Adjustment Screws	10	Ready
2	Feeler gauge Indicator Wheel	9	Ç 1040
2	Feeler gauge bolts	8	Ç 1040
2	Feeler gauge screw (Special)	7	Ç 1040
2	Feeler gauge screw barrel	6	Ç 1040
1	Front Support Arm	5	Ç 1040
1	Ruler pawl	4	Ç 1040
1	Miter - Ruler	3	Ç 1040
2	Metal cage	2	St 37
1	Lower blade tray	1	St 52





NO	Part Name	Mentioned No	Material
2	Ball Screw Nut	21	Ready
2	ball screw	20	Ready
1	Motor Pulley	19	Ready
1	Motor Protection	18	St 37
1	Encoder	17	Ready
4	Palier	16	St 37
2	Special Nut	15	Ç 1040
4	Ball bearing	14	Ready
4	Gauge Adjusting Nut	13	Ready
2	Gauge Adjusting shaft	12	Ç 1040
2	Connection Apparatus	11	Ç 1040
2	Carriage Connection Part	10	Ç 1040
2	Carriage	9	Ready
2	Ray	8	Ready
1	Sheet Supporting part	7	St 37
4	Timing Pulley	6	Ready
1	Timing belt	5	Ready
1	Motor	4	Ready
2	Digital Bearing	3	St 37
2	Upper Blade	2	Ç 2379
1	Upper Blade Body	1	St 52

8. ELECTRICAL PARTS LIST

MOTORIZED GUILLOTINE SHEAR

Part Name	Pcs / Meters
EMERGENCY STOP	2 Pcs.
1X10 OTOMAT - SIEMENS	2 Pcs.
16-25 ENGINE PROTECTION - SCHNEIDER	1 Pcs.
LC1E2510 CONTACTOR	2 Pcs.
PHASE SEQUENCE RELAY	1 Pcs.
0,75 KW ACTUATOR - DELTA	1 Pcs.
RXG12BD RELAY – SCHNEIDER	5 Pcs.
LED TRANSFORMER MVET	1 Pcs.
220 VOLT 24 VOLT TRANSFORMER	1 Pcs.
LED STRIP	1 M.
BAREL POSITION CONTROL	1 Pcs.
ENCODER 100 PULSE	1 Pcs.
RAY TERMINAL	40 Pcs.
RAY W OTOMAT	2 M.
CABLE CHANNEL	3 MT.
MAKARALI SWITCH	3 Pcs.
PAKO SWITCH – OPAŞ	1 Pcs.
LATCH BUTTON – EMAS	2 Pcs.
BUTTON – EMAS	5 Pcs.
SIGNAL LAMP – EMAS	1 Pcs.
SOCKET 5 PLUGS – SCHNEIDER	1 Pcs.
SOCKET PLUGS - 5	1 Pcs.
FITTING	5 Pcs.
4 X 2,5 TTR CABLE	-
PEDAL AND CASE – EMAS	1 Pcs.
SOCKET 16 LI – SCHNEIDER	1 Pcs.
PLUGS 16 LI – SCHNEIDER	1 Pcs.
SAFETY SENSOR	1 Pcs.
REFLECTOR	1 Pcs.
OPTICAL BARRIER	2 Pcs.

9. ELECTRICAL DRAWINGS

The electrical circuit diagram of the Motorized Guillotine Shear is given in the appendix.

10. RUNNING THE MACHINE



1- The machine is powered by energy.

2- The main switch on the electrical panel is switched from 0 to 1 position. The panel is energized. The lamp on the panel lights up. The green lamp indicates that the main engine is running.

3- Select manual or automatic mode using the switch.

4- With the Reset button, the tray moves up if there is an interruption in the cutting. By pressing the button, the tray is moved to the top reference point.

5- The emergency stop button is used to stop the machine in an emergency.

6- Cutting operation:

a- Manual Cutting: First, the selection button is turned to the right (manually). Cutting is done by pressing the down button. As long as the button is pressed, the operation continues. The operation is interrupted if you stop pressing the button. The operation is completed if requested with the Up button. (If any problem is encountered during cutting with the down button, the upper jaw can be set to the zero reference position with the up button.)

b- Pedal Cut: (Auto Cut): First, the selection button is turned to the left (auto position). When the foot pedal is pressed once (at least 2 seconds), the machine completes the cutting process and stops, and returns to the top reference center. As long as the foot pedal is pressed, the cutting process continues by continuously moving up and down.



7- In automatic or manual cutting Operation; in case of any Power outage; When the power is restored, the machine does not proceed to the next operation, the top jaw goes to the top reference point.

8- In automatic or manual cutting operation; In case of any power outage, if the machine does not work even though the main switch is turned on and the machine is energized, then the upper jaw needs to be moved to the upper reference point with the reset button.

9- Back gauge: In NC Controlled scissors, use the (+) and (-) buttons to approach the desired value. precise adjustment is located at the front of the machine.

11. MACHINE SAFETY INSTRUCTIONS

The safety measures we take in the machines we manufacture are as follows:

- An automatic pressure system is activated automatically at the time of cutting and prevents the sheet from slipping.
- Optional safety equipment (optical barrier, if desired instead of rear cage, etc.)
- Safety measures are provided at the highest technological level in our production, which is equipped with protective cages where the cut material falls.

In addition, despite all this, you should carefully consider the following safety Precautions for the safety of you and your employees:

- 1-** Check that the machine is fixed on stable & appropriate ground. (the machine needs to be adjusted with screws on its feet and anchored to the ground after it is leveled.)
- 2-** Check that the electrical connection systems work correctly.
- 3-** Check that the grounding connection is installed and working.
- 4-** The machine should be operated by an authorized person who has been trained.
- 5-** When the machine is used by two operators, they should be careful not to get their hands caught in the mouth of the machine, especially when the upper jaw is closing.
- 6-** No mechanical or electronic safety parts on the machine should be removed.
- 7-** Check the machine regularly and replace any parts that need to be changed.
- 8-** Do not use the machine on wet ground.
- 9-** provide good lighting of the working area.
- 10-** Don't overload the machine.

11. MOVING & LOADING THE MACHINE

During loading and unloading the machine, it has to be lifted by rope, chain, or fiber rope from the lifting hooks of the machine as shown in the picture. you can load and unload the machine using the crane and be sure that nobody is standing under the machine or beside it once you lift it up.




Note: The ropes used during the transport of the machine must have the capacity to carry at least 2-3 times the weight of the machine.

If spare parts or sub-assemblies have not been assembled after delivery, they should be stored in places protected from humidity and dust. you should be careful not to stack sensitive spare parts on each other during storage and shipping. In addition, packaging should be done so that dust and moisture do not enter the machine.

 ***the warnings stickers and precaution signs on the package should be readable and considered well.***



DON'T USE THE FORKLIFT TO LOAD OR UNLOAD THE MACHINE.

 ***It is strictly forbidden to stand under the machine after it is lifted during transportation.***

12. STORING THE MACHINE

The machine is delivered from the factory to the buyer or the carrier by being packaged and protected in such a way that it will not be damaged during shipment.

The machines we keep in stock to be ready-to-sale are packed with protective oil and dehumidifiers.

In cases where the machine is stored or not used for a long time, the following conditions should be considered:

1. The machine should be protected from excessive sunlight.
2. Storage should not be done in open areas (rainy and snowy conditions).
3. if you want to store the machine directly, leave the machine as it's packaged from the factory.
4. Protective oil should be used to prevent the upper and lower blades from rusting.
5. If the machine is to be stored in a humid environment, dehumidifiers should be placed in the environment to prevent the electrical components from being affected by moisture.

13. INSTALLATION OF THE MACHINE

After deciding the place that the machine will be installed in, the suitable dimensions and the holes positions will be determined according to the holes prepared in the machine feet. After that, the machine will be installed to the ground with steel screws or anchor bolts in the installation place.

According to our installation plan, the floor where the machine will be installed on should be emptied and prepared previously. In order to balance the machine, there must be a stable and smooth surface.

In order to make the machine fully leveled and to prevent vibrations, the empty spaces under the machine feet should be filled by hard rubber.

During the installation, the machine needs to be leveled with a very sensitive balance device, the leveling is made according to the bottom table of the lower blade there you place the sheets. Then the other parts will be balanced accordingly.

IMPORTANT NOTES

1. Never operate the machine without reading the user manual.
2. Leave enough space for use and maintenance the machine.
3. Leave sufficient entry distance for maintenance.
4. Place the machine on a flat Ground.
5. Never operate the machine without leveling and balancing.
6. Do not operate machines on pallets.
7. The electrical connection of your machine must be made by a licensed operator.
8. Connect the electrical cable connections properly and in accordance with the terminal numbers.
9. Since the electrical thermal relay settings are important, adjust these settings according to the motor load current. Don't take a value higher than the standards of thermal relay.
10. Do not work without grounding the machine.
11. Make sure to lubricate the parts of the machine need to be lubricated.
12. If the protective cages in your machine have been removed, make sure to connect them.

14. MACHINE ELECTRICAL CONNECTION

the machine was manufactured to fit the area where it should work and all the mechanical and electrical parts were checked well before loading the machine.


Then, by taking into consideration the values specified in the electrical diagram, the electrical connection is made and operated by the authorized electrician to check whether all mechanical and electrical components work properly.


IMPORTANT NOTE:


Do not operate without connecting the grounding line.


Be sure to read & follow the electrical warnings and safety stickers.


15. SAFETY WARNINGS


 **Firts Installation:** Install the motorized Guillotine Shear in a suitable place in your factory.


 **Normal Stop:** Normal stop should be done from the panel on the machine itself.


 **Emergency Stop:** Emergency stop can be done from the main control panel on the machine and by the foot pedal.

 **Electrical current:** In case any breakdown happen or having maintenance, no work should be done on the machine without cutting off the electrical current and taking the necessary precautions.

 **Maintenance service:** After completing the cutting operation on the machine, it is checked in general, the sheets on it and in the back area are removed, the necessary places are lubricated.

 Absolutely nothing should be left on the Guillotine Shears, blades or tables.

 Children and non authorized people should not be allowed to use the machine.

 Pay attention to the and warnings labels on the machine and never remove the labels, warning signs of the machine.

 Never dismantle the safety devices on the Motorized Guillotine Shear.

16. MACHINE SAFETY INSTRUCTIONS

ATTENTION: Before operating the Motorized Guillotine Shears, read carefully the warning and operating instructions. Keep the operating instructions very well.

Make sure to read and understand the instructions to prevent work accidents.

1. Consider Environmental Conditions: Keep fixed materials, movable parts or stored materials around the machine at least 750 mm away. Do not keep your machine in a humid, rainy and dirty environment. Provide good lighting when you run the machine.

2. Keep Your Work Environment Clean and organized: Working in a dirty, an unclean, dirty, and greasy area always poses a risk of accident and limits your working Capacity.

3. Keep Unauthorized Persons Away: Keep unauthorized persons, children and animals away from the work area, which may unintentionally cause accident, work disorder, distract you.

4. Wear a suitable work clothes for your job: Do not work in the workplace with loose clothing, jewelry (ring, necklace, bracelet, etc.). These can be caught by the moving parts of the machine and cause an accident. Wear gloves on your hands while processing the sheet metal. Wear safety work shoes (steel-toe shoes) to prevent your feet from being damaged by cut sheets and materials on the ground.

5. Pay attention to the correct installation of the machine: Place the machine on suitable ground. When placing the machine, make sure that there are enough and open spaces around it so that you can work comfortably and safely. Adjust and control your machine as described in the machine operating instructions.

6. Do not force the machine: You can be more safely if you work in the size and efficiency specified in the machine catalogs without overloading the machine.

7. Pay attention for your own safety while working: Use the machine so that you can see the cut area. Do not put your hands close between the blade and the press body.

8. Before operating your machine, make regular maintenance and checks: Keep your blades clean and sharp so you can work more comfortably and efficiently. Make sure that your operating apparatus is dry and oil-free so that your hands and feet do not slip. If the blade becomes blunt, ask for service.

9. Focus on the machine and your work: Focus on your work. Do not use the machine when you cannot focus on work. Do not try to hold the cut parts with bare hands. Use earplugs when parts fall on the ground or on top of each other and produce noise when you do a lot of cutting.

10. Meet your training needs: It should be ensured that those who will work on the machine receive very good training and comply with the user manual instructions.

11. Check for malfunction: Before starting work, check whether there is a malfunction in the machine. Before starting work, check whether the parts that will affect the operation of the machine are intact and fulfill their functions, whether the parts are broken, whether all parts of the machine are assembled perfectly, and whether all the conditions are met for the machine to work properly.

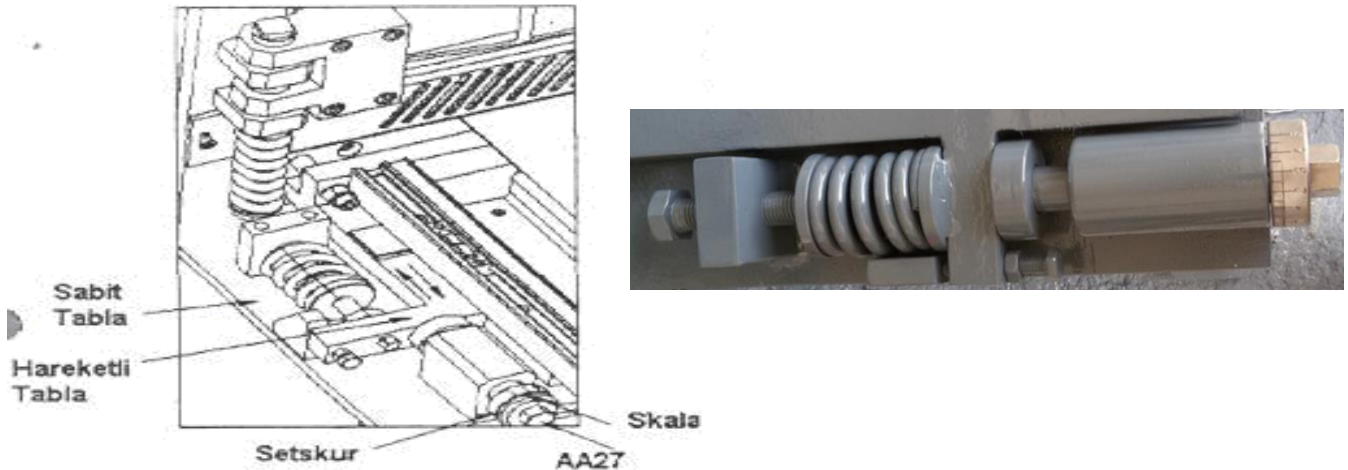
Don't run the machine if you have any broken, damaged parts, ask for new parts and wait until you change the broken ones.

12. Don't use any external parts not included in the machine: For the safety of the working Staff, the parts you will use other than the parts specified in the machine user manual and brochures may be risky for you.

IMPORTANT NOTE: Never operate the machine without reading and understanding the machine safety instructions well.

17. MACHINE SETTINGS

17.1. BLADE GAP ADJUSTMENT



The cutting gap is adjusted by turning the adjustment bolt to the left according to the thickness of the sheet to be cut. When the scale is set to 1 as shown in the table below, the gap between the blades is 0.1 mm. is When the scale is 2, the gap between the blades is 0.2 mm, and so on.

If any problems happen in the gap adjustment, the bolts on the middle of the body should be loosened first and then tightened with. If the bolts are tightened too much, it may cause a problem in the gap adjustment.

The values given in the table below are for the cutting gap between the blades.

NUMBER	SCALE
1	0,10 mm
2	0,20 mm
3	0,30 mm
4	0,40 mm
5	0,50 mm

17.2. PRESSURE ADJUSTMENT

Press Body: The Pressing body No. 1 has to be above the lower blade twice the thickness of the sheet to be cut. When the upper table is moved, the pressing plate presses the sheet beforehand. Thus, as compression is ensured while cutting, the slip of the sheet is prevented.

There are springs No. 3 at the bottom of the pressure shaft No. 2 on the right and left of the machine. To stretch these springs, if we turn the nut No. 4 to the right, we will increase it, if we turn it to the left, we will decrease it.

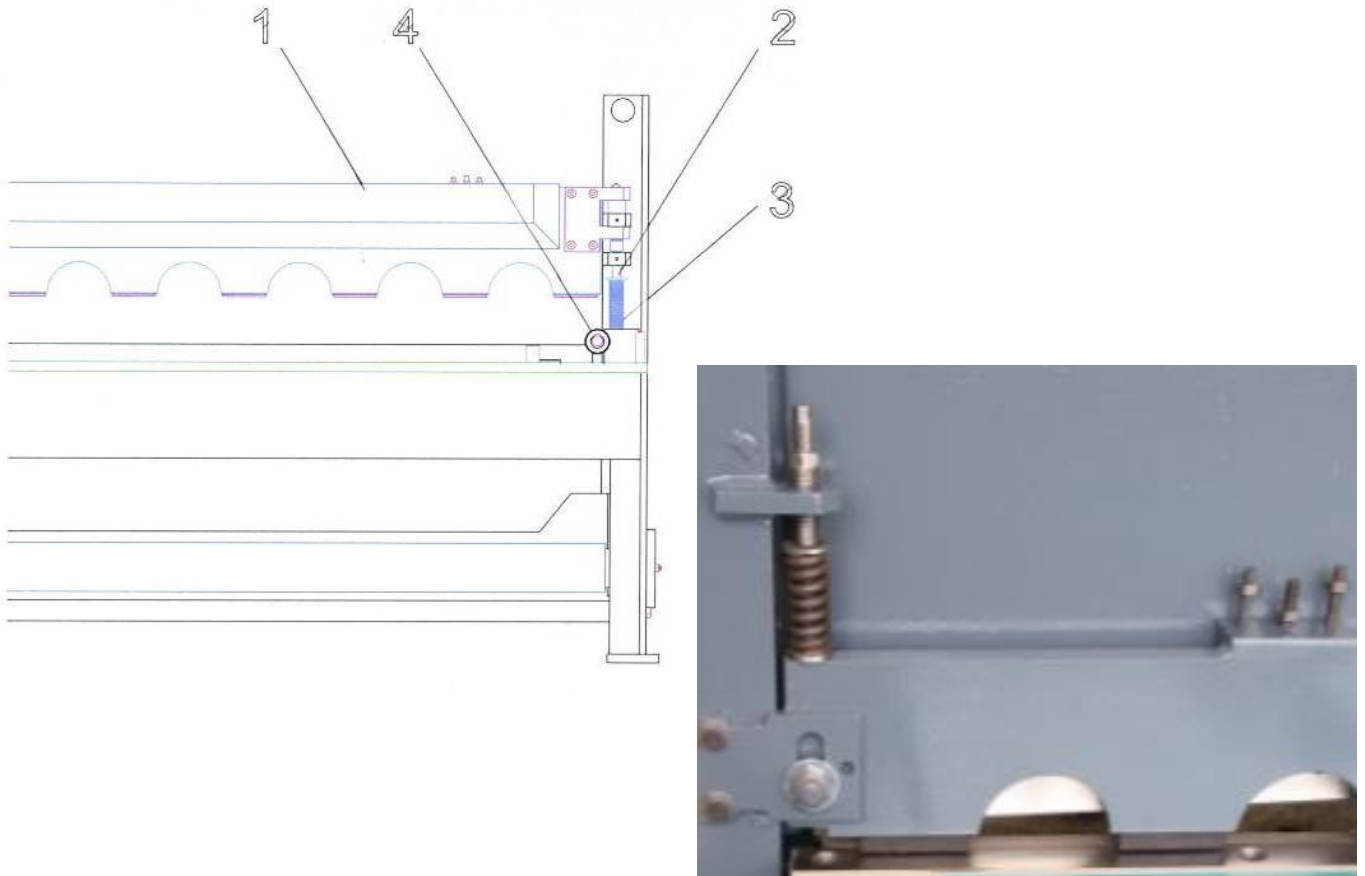


Figure 1

The capacity of the **Backgauge** (Part No.1) is 750 mm, it is adjusted with a motorized forward-backward movement..

Precise adjustment device: It is made of nuts on shafts of the back-gauge (Part no 2). The back gauge bumper is moved forward until it touches the lower blade surface. If one side is forward or behind, it is adjusted by adjusting nuts and brought to the same level. (Figure 2)

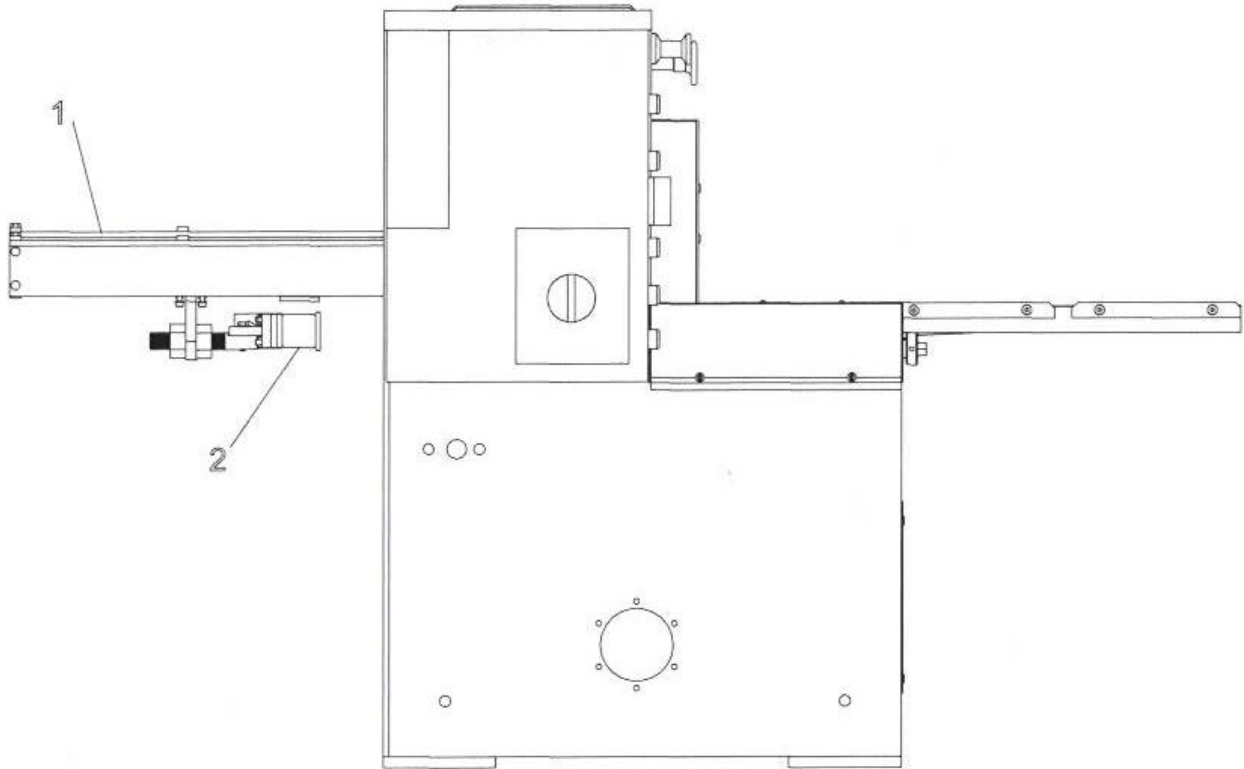


Figure 2

If any curve happens after running the back gauge bumper, you can fix it by the tensioning bolts on the back gauge.

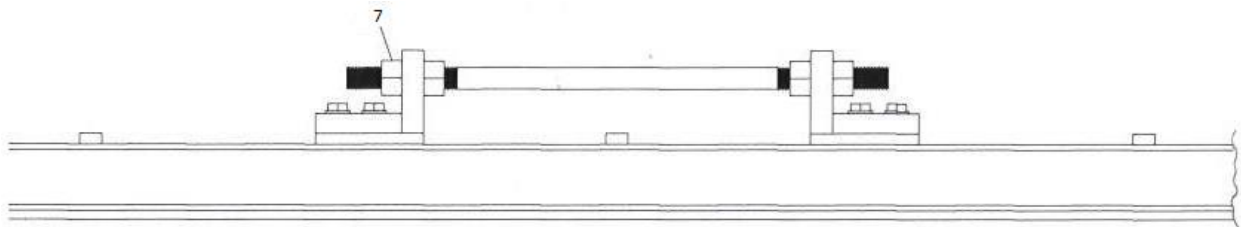


Figure 3

17.3. ASSEMBLY AND ADJUSTMENT OF THE BLADES

Blade Type: Upper and lower blades are different in structure. Upper blade edges are inclined 5°. The upper blade has two cutting edges. The lower blade is not angled and has 4 cutting edges. The blades should be sharpened when the cutting edges become dull.

ATTENTION: The replacement, disassembly, and adjustment of the blades must be done carefully and in accordance with the safety conditions. When installing a sharpened or new blade, install the screws and bolts in their places but do not tighten unless the blade fits vertically on the table surface and tighten all bolts.



After changing the blade, the adjustment of the bearings should be checked from the bolt.

ATTENTION: This work should only be done by qualified persons and operators.

After the blade replacement is completed, the upper table is lowered gradually by pressing the manual button on the electrical panel to adjust the gap between the blades. It is taken down until it reaches the lower blade at the left head and the gap adjustment mechanism is rotated from left to right to reset the blades on the left side. The blades are reset by taking the upper table a little lower and turning the right side of the gap adjustment mechanism from left to right. The stop operation is done with the button. Then, put a thin newspaper paper and cut it. Mark the side where the paper is not cut and make adjustments in that part again.

Adjusting the gap between the blades:

The adjusting screw is fixed at the 0 reference point.

The bolts of the front protection plate are removed and the protection plate is taken out.

By removing the nut bolts, the cover is taken out.

The bolts are removed and the pressing plate is taken.

The upper table is lowered ~ 20 mm.

The connection bolts of the blade wedge to the table are loosened.

By loosening the bolts, the distance between the lower and upper blades is adjusted with a 0.05 mm feeler gauge set.

Adjustment is made sequentially by lowering the upper plate step by step. After the camber adjustment between the blades is completed, the process is reversed.

After resetting the blades, the nut is loosened. Lock the bolt with the nut by turning it until it touches the wedge. Bring the adjusting screw to "0" and fix it with a screwdriver.

After loosening the spring stud nut and the lock nut; The spring is squeezed by turning it to the left. After that, the counter nut bolt is tightened. This should be done both on the right of the machine and on the left of the machine.

After the adjustment process is completed, all the adjustment bolts are fixed. The upper table is moved to the upper position..

The pressing sheet is mounted in place and the special nut is tightened to the end.

To increase the compression force of the pressing sheet, the nut under the spring should be tightened.

18. MACHINE MAINTENANCE

In order to keep your Motorized Guillotine Shear works efficiently with higher capacity, do checks after the cutting operation is completed, remove the sheets on the front and the back area, and lubricate the necessary places.

To keep your Motorized Guillotine Shears serving for a longer time making precise and quality cutting, important moving parts such as upper table slides, back tables, trays, back gauge shaft, joint grease nipples should be lubricated.

It is strongly recommended to lubricate these points with a grease pump at least twice a week.

NO	QNT	THE POSITION IN THE MACHINE	PERIOD	OIL
1	2	Grease nipples of the upper plate slide NOTE: The upper plate must be in the upper position.	2 times a week	RUBBER GREASE
2	2	Nuts of the Back gauge shafts	2 times a week	GREASE
3	2	knuckle arm grease nipples	2 times a week	RUBBER GREASE
4	1	Reducer eccentric ball bearing	2 times a week	RUBBER GREASE

19. FAULTS AND SOLUTIONS

FAULT	REASON	SOLUTION
There are burrs on the cut parts	<ul style="list-style-type: none"> - Feeler setting isn't suitable. - The blades are blunted. 	<ul style="list-style-type: none"> - Adjust the feeler setting. - Sharpen the blades.
The jaw drops down.	<ul style="list-style-type: none"> - There is a fault in the brake system. 	<ul style="list-style-type: none"> - Fix it by a qualified electrician. - Ask for service.
The jaw doesn't rise.	<ul style="list-style-type: none"> - There is a fault in the reducer. 	<ul style="list-style-type: none"> - Check the reducer by a qualified person. - Ask for service.
There is an oil leak in the gearbox.	<ul style="list-style-type: none"> - There is Loosening 	<ul style="list-style-type: none"> - Tighten well.
The upper pressing sheet is leaking.	<ul style="list-style-type: none"> - There is Loosening. - the surface where you place the sheet on is not in a parallel position to the table. - Baskı yayı kırılmıştır. 	<ul style="list-style-type: none"> - Tighten the pressure springs. - check the parallelism. - Replace the broken springs.

20. SERVICE FORM



MACHINE NAME			
MODEL /TYPE		SERIAL NUMBER	20...-.....
Customer: Company Name: Address:	:		
Authorized Name: Phone:	:		
<input type="checkbox"/> Under Warranty		<input type="checkbox"/> Not Under Warranty	
Warranty Review (If not under warranty, cause of the malfunction, etc.)			
Things to do :			
REQUESTED SERVICE -	NAME, SURNAME	-	SIGNATURE
THE RESULT AFTER SERVICE CHECKING:			
<input type="checkbox"/> Service Provided Effectively		<input type="checkbox"/> Service Has Not Been Effectively Provided	
IF THERE IS NON-CONFORMITY/ ACTION TAKEN			
<input type="checkbox"/> Service Provided Effectively		<input type="checkbox"/> Service Has Not Been Effectively Provided	
BASED ON THE RESULTS PROVIDED BY THE TECHNICAL EXPERTS, THE MACHINE HAS BEEN COMPLETELY FIXED WITHOUT ANY DEFECTS OR PROBLEMS AND DELIVERED IN GOOD WORKING CONDITIONS.			
CHECKED BY		CUSTOMER	
Name, Surname		Company Name	
Company		Company Representative	
Signature – Date		Signature – Date	