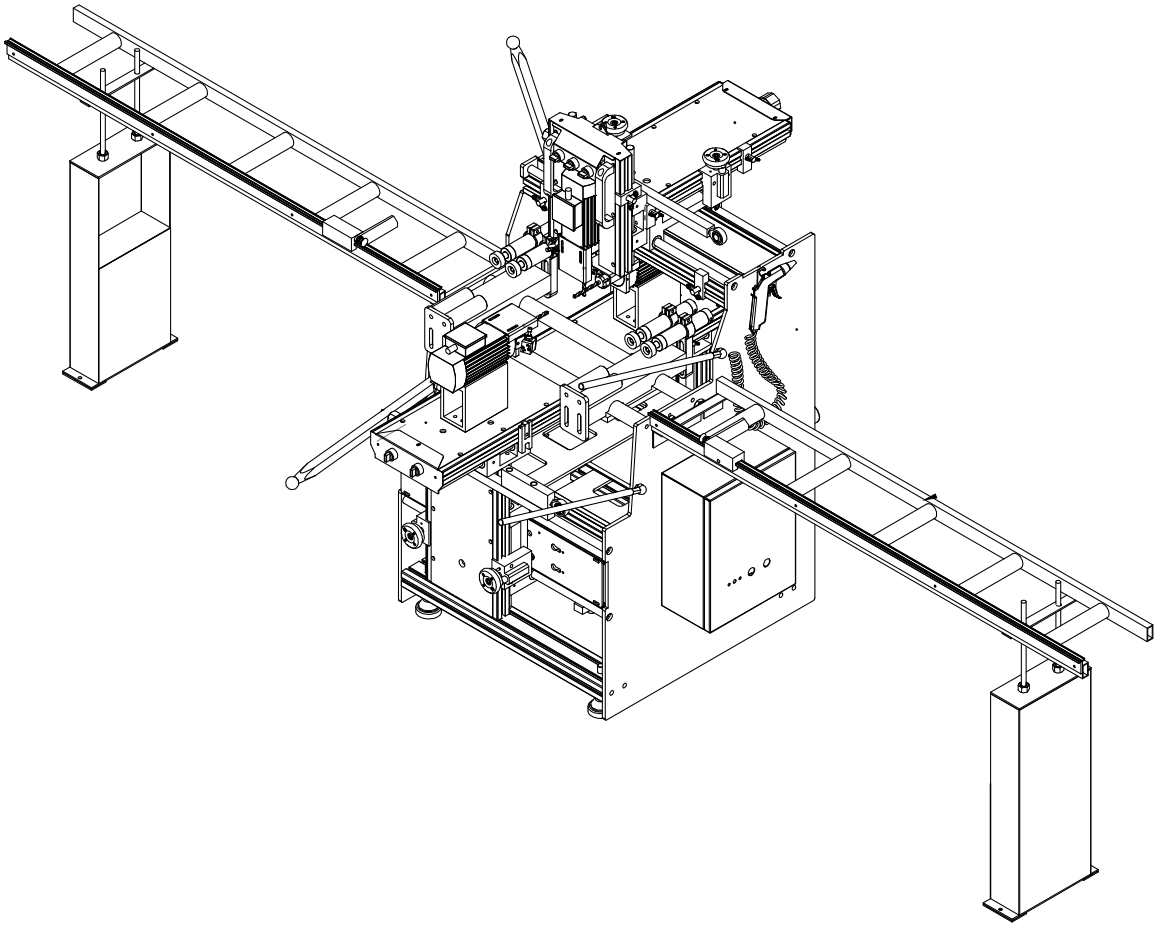
ÖZGENÇ MAKİNA



USER'S GUIDE

OMRM 127

3 MOTORIZED ALUMINUM COPY ROUTER

www.ozgencmakina.com.tr

CE

Contents

GENERAL INFORMATION

Includes general topics related to the user's guide.

1. DOCUMENT ISSUING INFORMATION

REVISION	
0	2016

1.1 After-sales Service

Address:

Nilüfer Organize Sanayi Bölgesi

113. Sk. No:23 Nilüfer

BURSA/TURKEY 16250

Contact:

TEL: +90 224 411 07 46

FAX: +90 224 411 07 49

E-mail: info@ozgencmakina.com.tr

Note: Spare parts are supplied by our below-mentioned company.

Any necessary spare parts are delivered by M.S.K MOTOR KOMPRESÖR MAKİNA SAN.TIC.LTD.ŞTİ.

Tel: +90 224 411 07 46

Fax: +90 224 411 07 49

1.2 Certification Process

The machine (OMRM 127) with the technical features described in the user's guide is compatible with CE norms. Safety measures are taken in line with CE norms. CE documents are provided upon request.

SZUTEST

CE

Reference No/*Referans Nu.*: OSE – 15-0419/06

SZUTEST TECHNICAL INSPECTION and CERTIFICATION

Rely on Experience

ATTESTATION OF COMPLIANCE

UYGUNLUK ONAYI

The technical file and test reports of the following product have been checked and found in compliance with the Parliament and Council Directive 2006/95/EC of 12 December 2006 on the harmonization of the laws of Member States relating to electrical equipment designed for use within certain voltage limits and Parliament and Council Directive 2006/42/EC of 17 May 2006 on the approximation of the laws of the Member States relating to machinery.

Teknik dosya ve test raporları incelenerek, belirtilen ürünün Avrupa Birliği Teknik Komisyonu tarafından 12 Aralık 2006 tarihinde yayınlanan 2006/95/AT Belirli Gerilim Sınırları Dahilinde Çalışmak Üzere Tasarlanmış Teçhizat ile İlgili yönetmeliği ve 17 Mayıs 2006 tarihinde yayınlanan 2006/42/AT Makina Emniyeti Yönetmeliğine uygunluğu saptanmıştır.

Applicant: *Başvuru Sahibi:*	**MSK Motor Komp. Makina San. Tic. Ltd. Sti.** *Nilüfer Organize San. Böl. 113. Sok. No.23 Nilüfer, Bursa, Türkiye*
Manufacturer: *Üretici:*	**MSK Motor Komp. Makina San. Tic. Ltd. Sti.** *Nilüfer Organize San. Böl. 113. Sok. No.23 Nilüfer, Bursa, Türkiye*
Product: *Ürün:*	**Copy Router with Triple Drilling Machines** *Freze Makinaları*
Type/Model: *Tip/Model:*	OMRM 117, OMRM 117P, OMRM 127, OMRM 118
Base of attestation: *Onay Dayanağı:*	**File of technical documentation, Test report Ref. No. 15-0419/06** *Teknik Dökümantasyon, 15-0419/06 numaralı Test Raporu*

*The referred technical file(s) shows that the product complies with standard(s) recognized as giving presumptionof compliance with the essential requirements listed EU Directive(s) above. Other relevant Directives have to be observed. This attestation does not abrogate the compulsory obligation of the manufacturer to issue the declaration of conformity.

**Diğer ilgili direktiflere uyulmalıdır. Referans teknik dosya ile ürünün yukarıda belirtilen AT Direktiflerinin temel gereklerine uygunluğu kabul edilir. Bu onay üreticinin uygunluk beyanı düzenleme zorunluluğunu ortadan kaldırmaz.*

İstanbul, Date/*Tarih* 2015-07-24

Valid to/Geçerli:2020-07-23

Mehmet Işıklar
General Manager

page1of1

SZUTEST Teknik Kontrol ve Belgelendirme Hizmetleri Tic. Ltd. Şti.
SZUTEST Plaza, Nato Yolu Cd. Çam Sk. No:7 Ümraniye, İSTANBUL, TÜRKİYE
Tel: +90 216 - 469 46 66 Faks: +90 216 469 46 67 info@szutest.com.tr | www.szutest.com.tr

ÜRETİCİ / PRODUCER	M.S.K MOTOR KOMP. MAKİNA SAN. TİC. LTD. ŞTİ.		
KOD / ADI / CODE / NAME	OMRM 127	3 Motorlu Kopya Freze Makinası 3 Spindle Copy Router for Aluminium Profiles	
SERİ NO / SERIAL NO	12F53108	ÜRETİM TARİHİ / PROD. DATE	2015
GÜÇ / POWER	2.5 kW	VOLTAJ / VOLTAGE	400 V
FREKANS / FREQUENCY	50 Hz	AKIM / CURRENT	10 A
HAVA BASINCI / AIR PRESSURE	6-8 Bar	HAVA TÜKETİMİ / AIR CONSUMPTION	9 lt / cyc
AĞIRLIK / WEIGHT	150 kg	M. S. K. MOTOR KOMP. MAKİNA SAN. TİC. LTD. ŞTİ.	CE
GENİŞLİK / WIDTH	720 mm		
BOY / LENGTH	1070 mm		
YÜKSEKLİK / HEIGHT	1540 mm	NOSAB 113. Sk. No:23 Nilüfer / BURSA Tel: +90 224 411 07 45 Pbx Fax: +90 224 411 07 49	
MENŞE-İ / MADE IN	TÜRKİYE		

1.3 Procedures to Follow

Warning symbols and phrases in this document should be taken into consideration.





These warning signs are intended to protect occupational health and avoid any hazard.

	Beware of risk of burning your hands in case of contact. Take necessary measures.
 Caution!	Warning sign to prevent machines from experiencing any damage.
 NOTE	Used for warning purposes for proper use of machine features.
 CONTROL	Shows warning messages of operators which are to be inspected.

2. SCOPE OF USER'S GUIDE

User’s guide is a document which must be read by the operating personnel before operating the machine. It covers all the required information for machine use. Information about how to provide long-term use of the machine and basic maintenance information is also contained in this document. This guide helps users making correct of use of the software and mechanical components. Although some equipment installed on the machine vary in shape, operating principles remain the same.

3. Machine Description

It is designed to process the 3 sides of the aluminum profiles without rotation and to open door barrel hole, door handle hole and latch slots.

General Specifications;

- Designed to process the 3 sides of the aluminum profile without rotation
- 1 x vertical and 2 x horizontal copy router motors are available.
- Vertical and horizontal pneumatic clamps for fixing milling depth
- Vertical and horizontal template following tips are pneumatic and available in 3 different diameters: 5, 8 and 10 mm.
- Horizontal and vertical templates containing standard shapes
- Smooth movement and high precision are developed using balls, dampers and an ergonomic handle design.
- 1.5 m right and left rolling conveyor system prevent scratches on the profile, ruler and support system are available on the right conveyor.
- Automatic cooling spray system
- Full safety against occupational accidents
- The power source protects the system from any sudden voltage change.

Options:

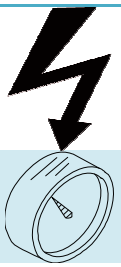
OMRM 127 3-motor aluminum copy router machine has no options.

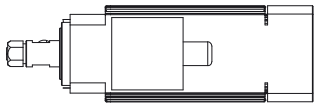
3.1 Machine Cutting Capacity

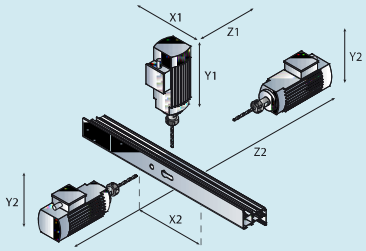
OMRM 127 3-motor aluminum copy router machine can open door barrel slots, door handle holes and latch slots with the desired template.

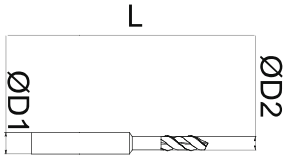
3.2 Machine Specifications

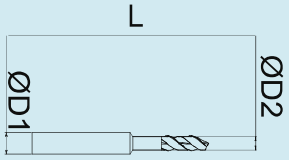
Operating Voltage	400	Voltage (V)
Total Power Drawn	2.5	Kilowatt (Kw)
Current Drawn	10	Ampere (A)
Operating Pressure	6-8	BAR
Total Air Consumption	9	L/Min
Motor Specifications		
Power Drawn	3 x 0,75	Kilowatt (Kw)
Operating Frequency	200	Hertz (Hz)
Rotation Speed	12000	RPM
Motor Movement Margins		
X1	380	mm
X2	330	mm
Y1	120	mm
Y2	150	mm
Z1	220	mm
Z2	250	mm
Horizontal Cutter Ends		
ØD1	10	mm
ØD2	10	mm
L	110	mm
Vertical Cutter Ends		
ØD1	5	mm
ØD2	8	mm
L	80	mm
Machinable Profile Dimensions		
h (min)	40	mm
h (max)	110	mm
a (max)	130	mm

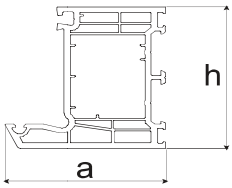








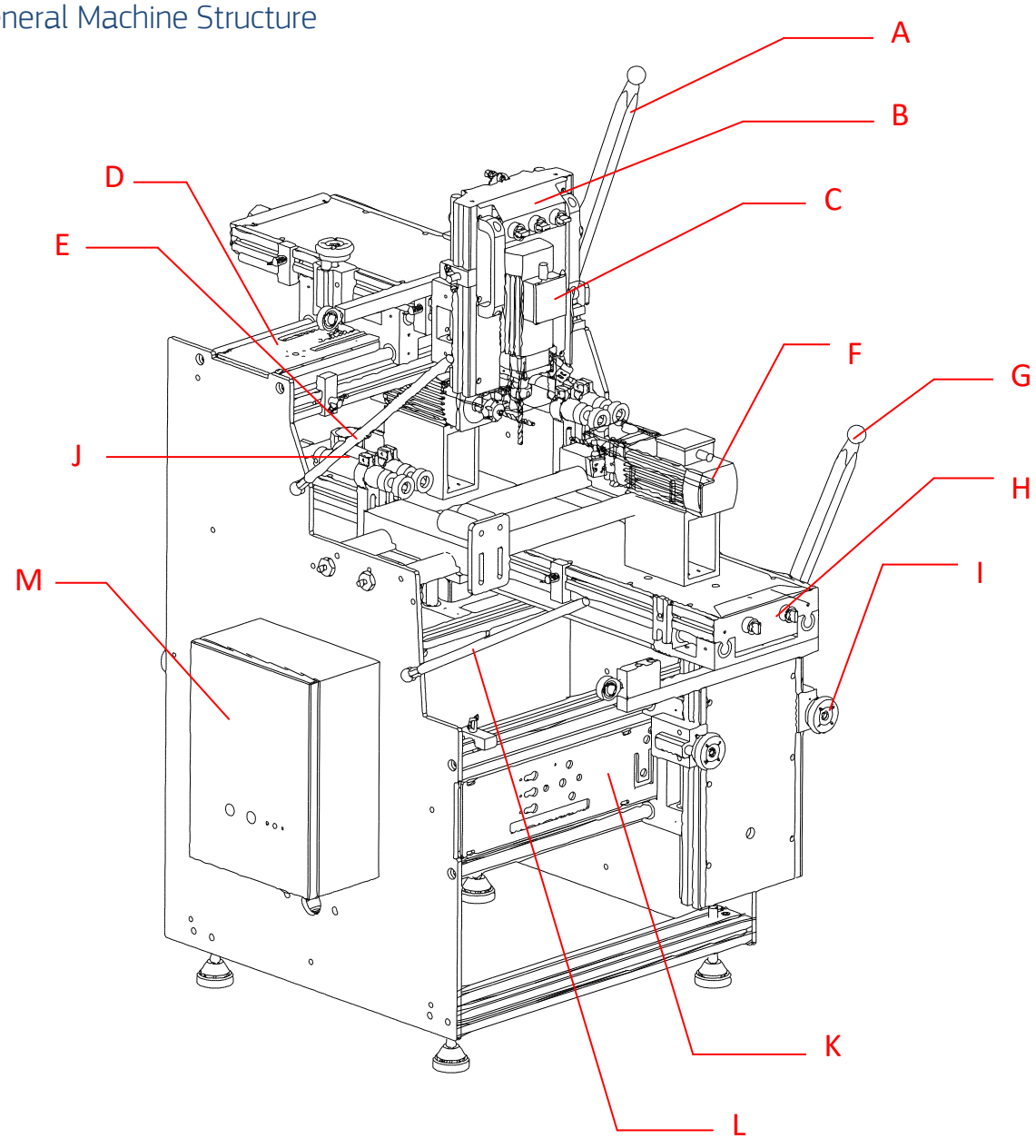




Machine Weight	150	Kilogram (Kg)	

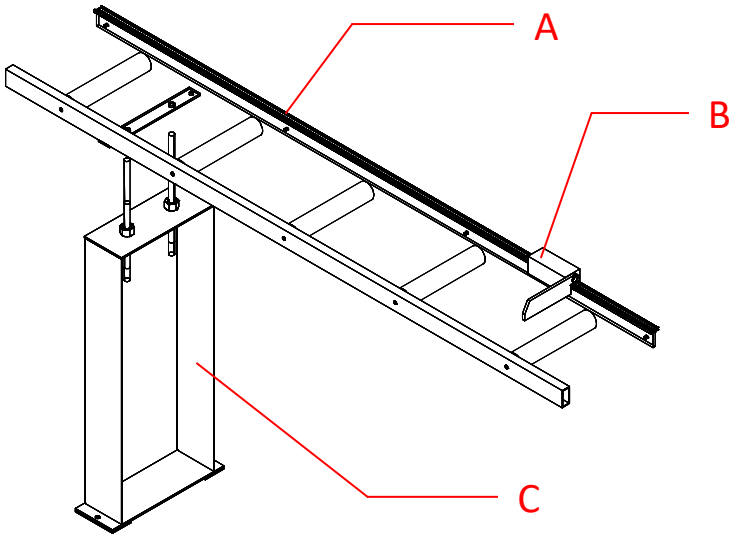
4. Machine Layout and Unit Structure

General Machine Structure



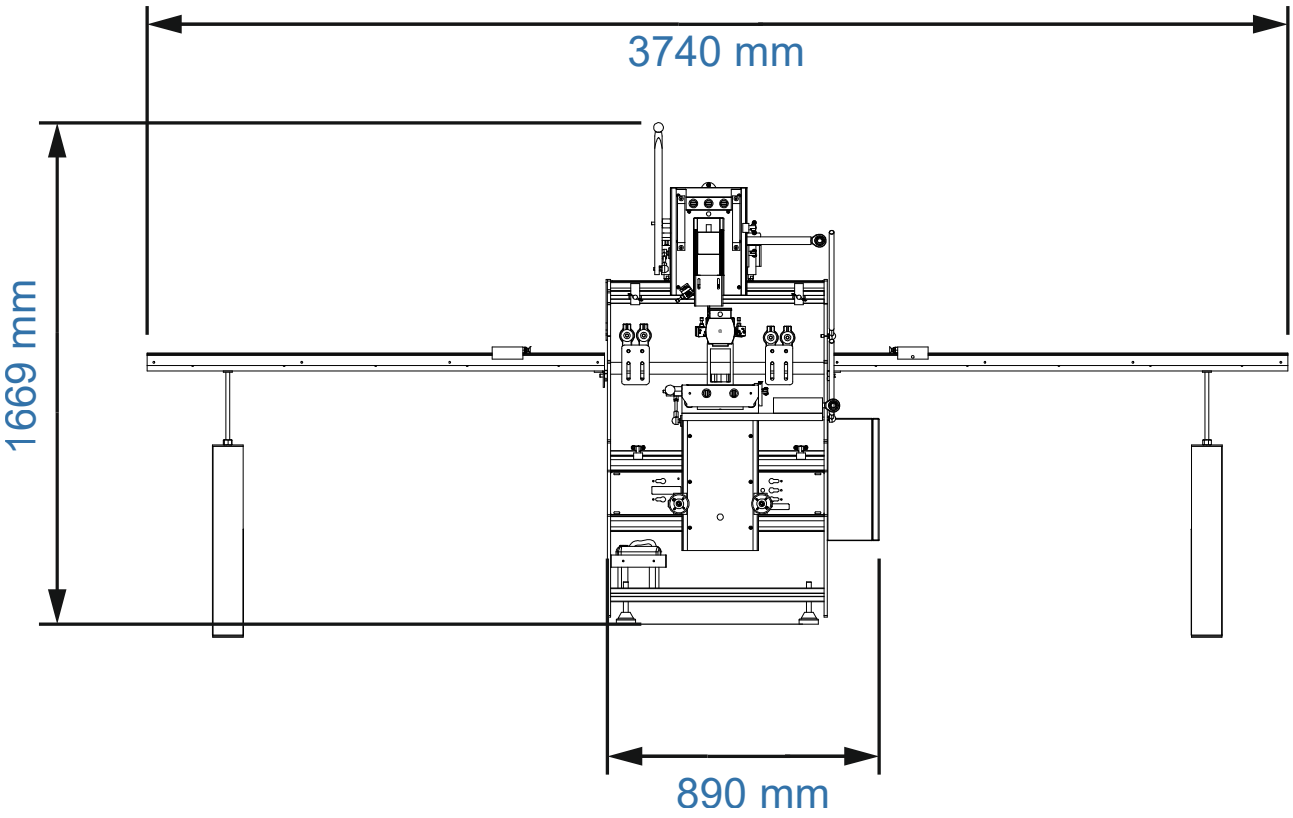
A- Vertical Cutter Operating Lever
B- Vertical Cutter Follower Control Panel
C- Vertical Cutter Motor
D- Top Template
E- Vertical Cutter Movement Lever
F- Horizontal Cutter Motors
G- Horizontal Cutter Operating Lever
H- Horizontal Cutter Follower Control Panel
İ- Template Followers
J- Pressure/Fixing Supports
K- Horizontal Template
L- Horizontal Cutter movement Lever
M- Electrical Panel

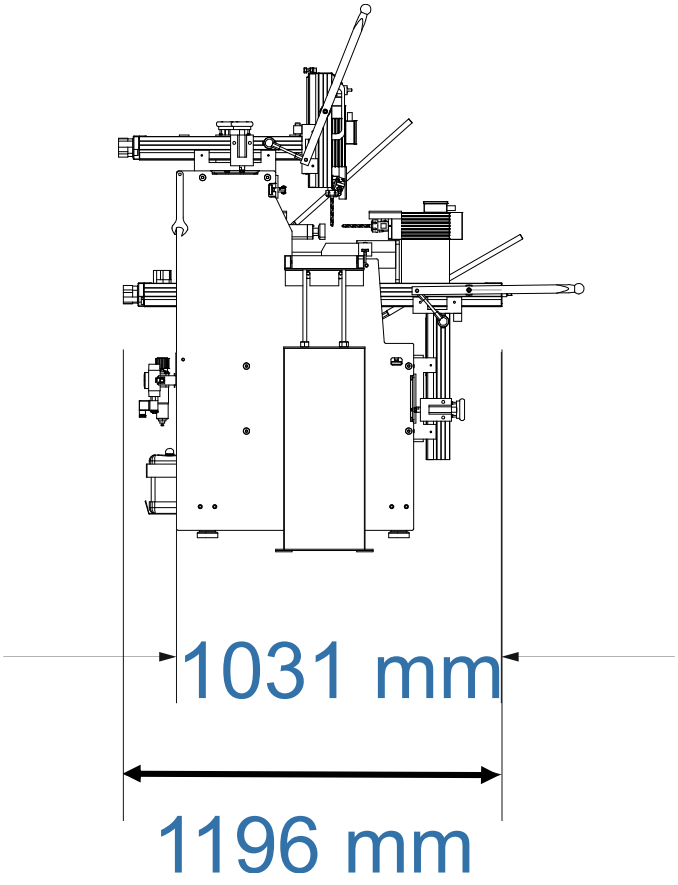
Conveyor Structure



A-	Measurement Tape
B-	Profile Support
C-	Conveyor Feet

4.1 General Machine Size





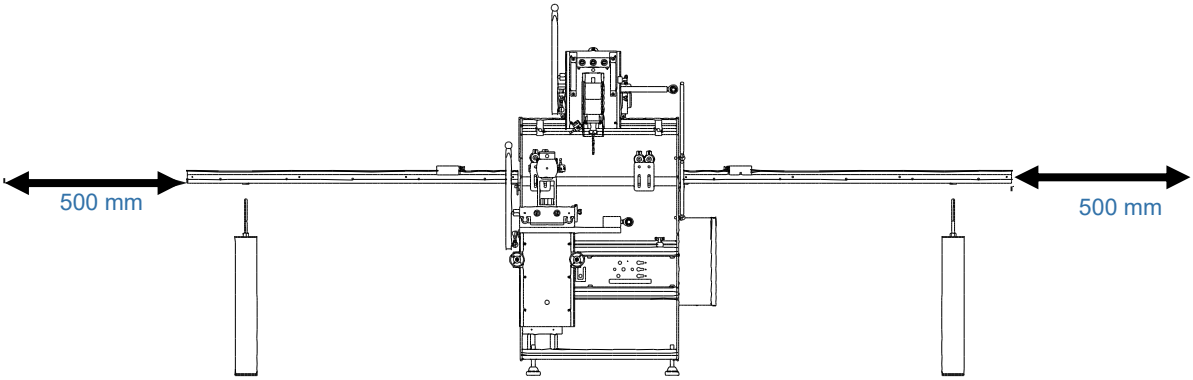
Machine Length: 3740 mm

Machine Width: 1196 mm

Machine Height: 1669 mm

4.2. Machine Placement

During machine installation, take the range of motion into account for Aluminum copy router cutting process. Also leave a suitable distance for machine panel doors for opening. Take following measures into account for safe operation.



5. OCCUPATIONAL SAFETY and MEASURES

5.1 Safety Switch

This section contains information required for safe use of the machine and general equipment.

5.2 Safety and Accident Measures

Required warning regarding accidents and measures to be taken are given in the User's Guide. Still, user is responsible for warning and guiding workplace employees for complying with occupational safety rules. Workplace officers are responsible for performing required practical follow-ups. Operator must have full command over safety rules of the machine before starting to operate it. Safety components at the time of machine delivery must be kept intact.

Manufacturing company cannot be held legally accountable for any accident and safety gap resulting from operation not compliant with use and safety requirements of the machine. Such risks shall also affect warranty conditions. Manufacturing company shall not be responsible for any accident and fault that may result from machine and equipment use outside instructions. Any critical part requiring replacement due to wearing etc. of the machine and other equipment must be immediately replaced.

Operator is responsible for use, cleaning, adjustment, operation, maintenance etc.

5.3 Machine Usage and Misuse

OMRM 127 3-motor Aluminum copy router machine is designed to open door barrel holes, door handle holes and latch slots. Any machine fault and occupational safety gap other than those resulting from procedures are under user’s responsibility.

5.4 General Safety Rules

OMR 127 3-Motor Aluminum Copy Router machine is suitable for only one single operator. Operator must not operate the machine in case of any lack of attention caused by drugs,

alcohol or medication. Operator must check the machine and components prior to operation. It should be ensured that the main switch is turned off during routine maintenance. Power and pneumatics must also be switched off. Any pressure must be discharged in case any hydro-pneumatic equipment is used. Do not replace the equipment and safety parts on the machine. Do not lift the safety device and barriers. Operator must wear a uniform suitable for machine and manufacturing requirements. Operator must not wear any rings, bracelets etc. which may cause an accident. Employees with long hair must use hair nets, if necessary. The machine must be installed in accordance with the training provided by M.S.K.

5.5 Maintenance Measures for Safety

All maintenance procedures must be performed by expert technicians who have command over the periodical technique. Use predefined equipment for machine maintenance.

5.6 Electrical Safety Rules

Severe occupational accidents and injuries may take place in case of failure to comply with the following safety rules. Any electrical intervention and maintenance must be performed by an engineer. All procedures must be performed using proper and isolated equipment. Take notice of safety signs and do not remove them. Do not make any addition and subtraction on the voltage line. Use original spare parts and equipment. Do not make any changes in circuits. Turn electrical hardware off prior to any cleaning procedure. Make sure that main cabinet and cabinet doors are closed. Cut the power from the main switch in case of fire. Use proper fire extinguisher.

Note: Hardware panel locks must remain with authorized staff.

5.7 Lighting Conditions

Operator must use the equipment with proper lighting conditions for his/her safety and health. Minimum lighting power must be 300 lux for machine use. For more technical information, please see EN 12464-1 Lighting Norm.

5.8 Connections

All necessary connections must be prepared at the layout site in line with the machine. Electrical power, pneumatics or similar demands must be at values meeting requirements, and compatible equipment must be kept available at the layout site. Take IEC 64-8 norm into consideration for the installation of electrical equipment.

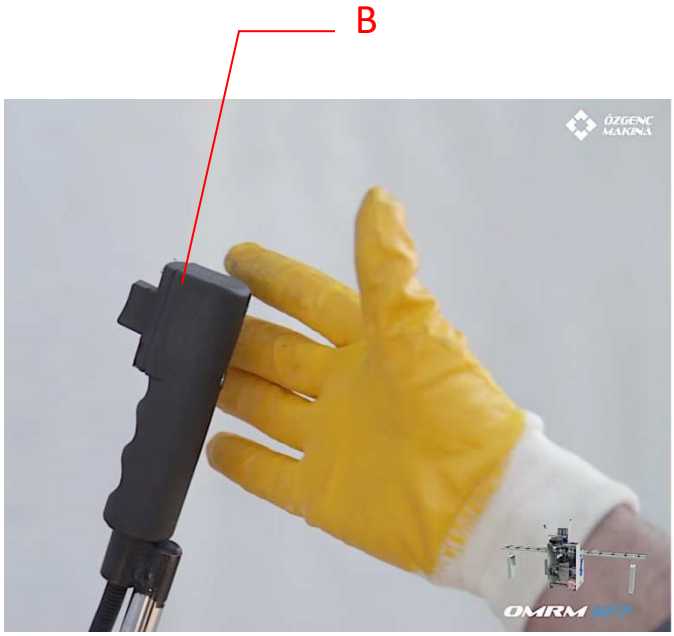
Note: If the system is equipped with a power supply, then it must have a 0.3A circuit-breaker and start-up procedures must be performed by experts.

5.9 Earthing Requirements

Earthing system must conform to standard features described in IEC 64-8. It must be compatible with IEC64 and IEC364 norms for low-voltage equipment. Earthing procedures must be performed in consideration of the voltage value. A stands for the marked point earthing inlet.

6. Safety Equipment

DANGER! It is not permitted to remove or deactivate safety measures taken for the machine and equipment.



A- Main Switch
B- Cutter Operation Buttons

6.1 Risky Areas and Warnings

Safety measures are taken on the machine through equipment, but it is also required to comply with additional visual safety measures at the operating site.

	• Contact with moving parts may lead to electric shock. • Do not use sharp objects on protective isolation equipment as they may do harm. • Do not use pointed objects that can penetrate into the protective isolation equipment. • Turn off the power supply prior to any maintenance or adjustment.
	• During the operation of machine, pay attention to moving equipment or to those used to fix a part. • Keep both hands away from equipment during operation. • Do not make any adjustments or do not perform maintenance during operation. • Do not grab moving parts with hands.
	• Do not put your hand in the area with hot equipment. • Do not hold hot equipment. • Use protective gloves to replace hot equipment. • Do not extend your hand to any heated plate etc.
	• Do not put your hand anywhere with a risk of jamming. • Do not keep your hands on machine except for buttons. • Take safety actions during maintenance and cleaning procedure. • Take measures to avoid cuts while replacing milling cutters and drilling bits.
	• This machine does not create a volume of sound detrimental to health.
	• Please read the relevant user's guide carefully. Try to understand the safety warnings. • Keep user's guide at a visible spot.

6.2 Noise Emission

There is no noise emitted by machine units with an impact on occupational health.

6.3 Disposal of Hazardous Substances

If the user uses lubrication and cooling equipment, then apply the methods indicated on respective labels.

7. Machine Start-up

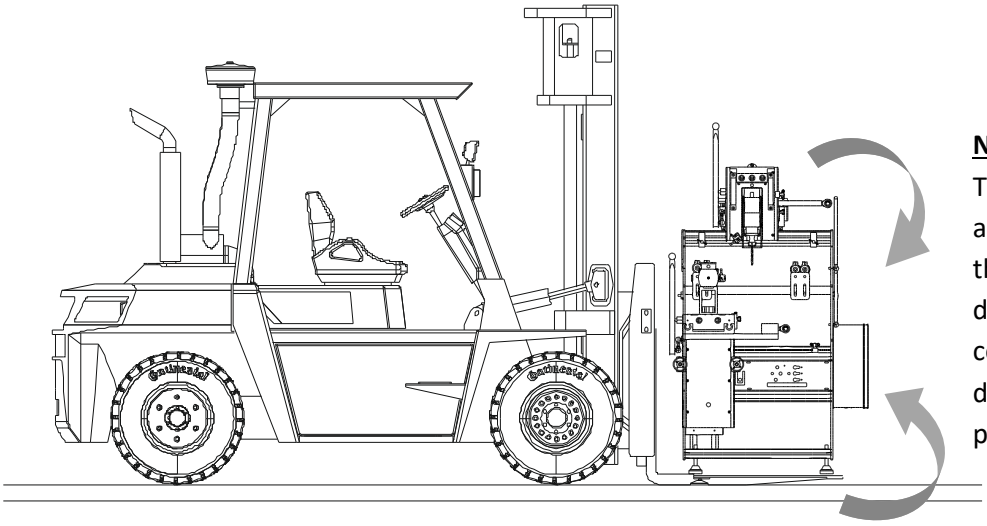
7.1 Domestic Shipping

Our machines are specially packed in accordance with the size and weight criteria. Main purpose of packaging is to safely deliver the product free-of-damage to our customer. Some parts may be shipped as disassembled in line with the agreements with customer. Prior to any shipment, a contract is signed between parties about all detailed criteria.

Transport methods adopted during loading must comply with the mechanical structure and weight of the machine. Otherwise machine may suffer damage.

Note: No equipment is demounted on the machine for domestic shipment. You are recommended to use a forklift. Our company shall not be held accountable for any accident that may arise.

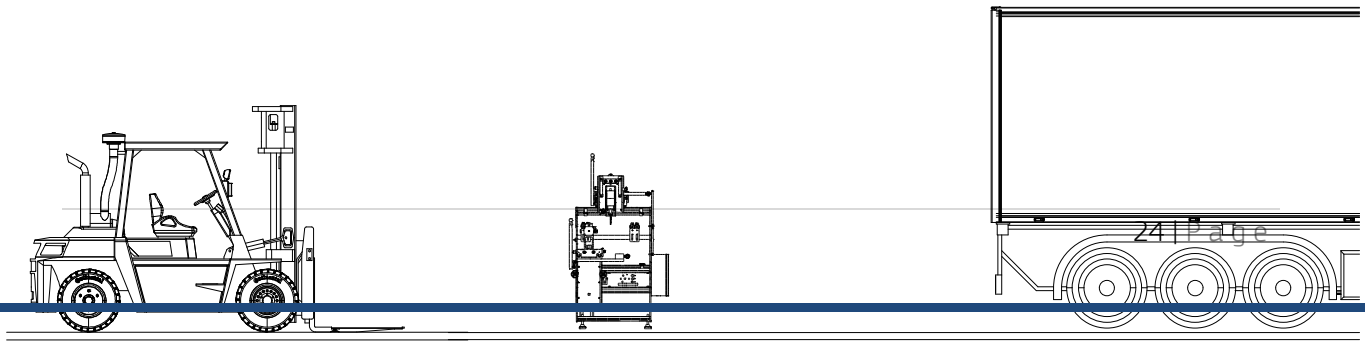
Any moving units must be fixated and taken under protection during shipment.

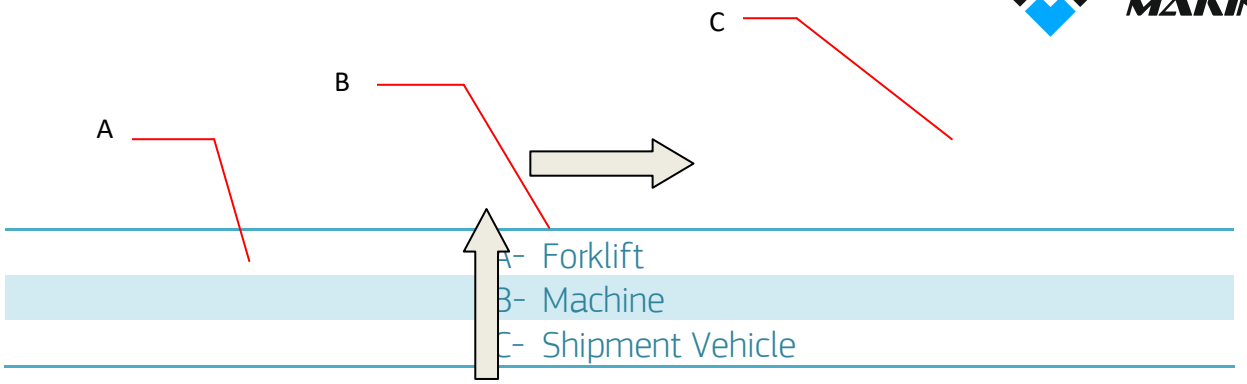


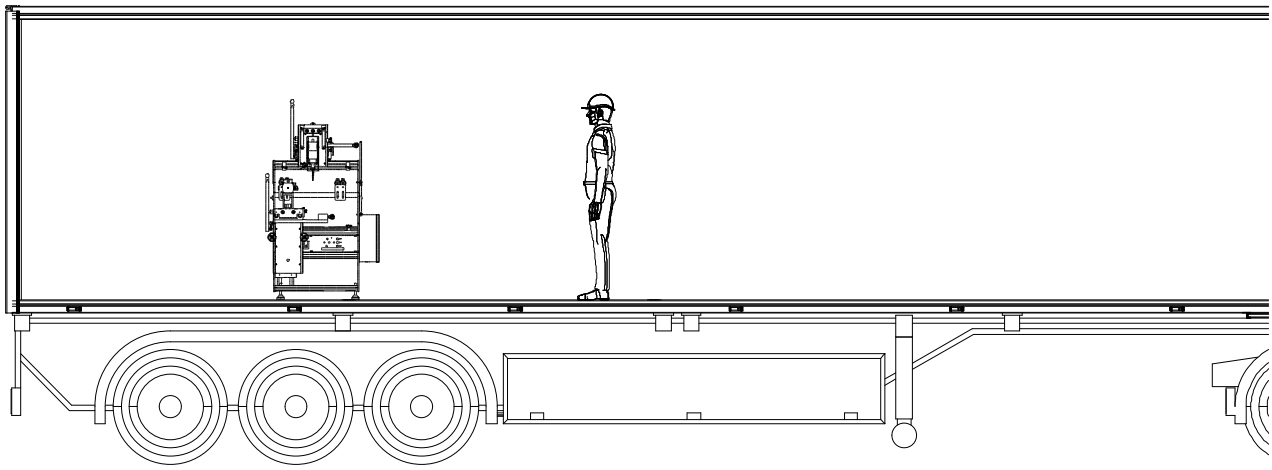
Note:
Take precautions against potential risks that may arise due to displacement of the center or gravity during any lifting procedure.

Important NOTE:

Remember to take off the protective wedge which is put to use during shipment, once you are done with placing the machine!



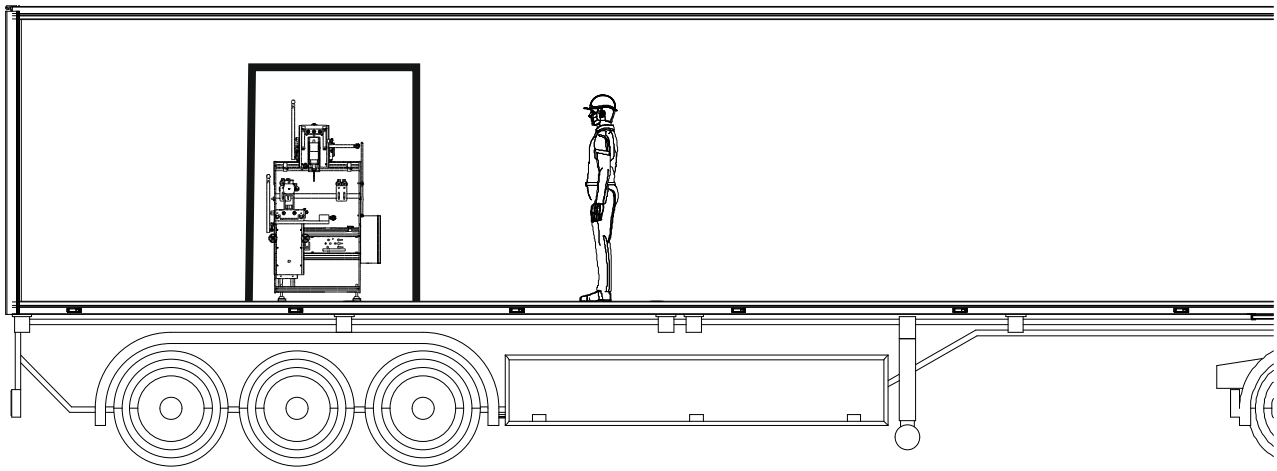




Take necessary precautions during the machine is being taken off the vehicle. Take action to avoid any skid. You must lift the machine without damaging its body at unloading stage. Any machine foot dismounted during shipment must be reassembled.

7.2 International Shipping

Any machine to be shipped abroad is packed in wooden boxes according to its size. Some environmental equipment with a risk of damage during packaging procedures must be demounted and separately packed.



7.3 Fault Control During Shipment

Check the machine for any fault and damage that may arise during shipment and report to the shipping company in case you encounter a problem.

8. Machine Installation

Expert M.S.K. personnel will carry out all procedures with regard to loading and unloading and conduct performance tests for assembly, mounting and start-up, if necessary. These procedures are evaluated on machine basis and carried out for products deemed necessary. Setting up of parts and equipment which should be prepared prior to machine use must be performed. Required operations will be explained below.

8.1. Machine Placement

Use predefined hanger lifting points to position the machine at the site described in the plant layout. You may adopt previously exemplified transport methods. Using any other method may damage your machine.

8.2 Fixing on Ground

The machine must be placed considering the maintenance and operating spaces. Rear and side spaces and spaces recommended for maintenance procedures are above-mentioned. An expansion bolt at a size of M12X50 mm is recommended for floor connection.

8.3 Start-up Preparation

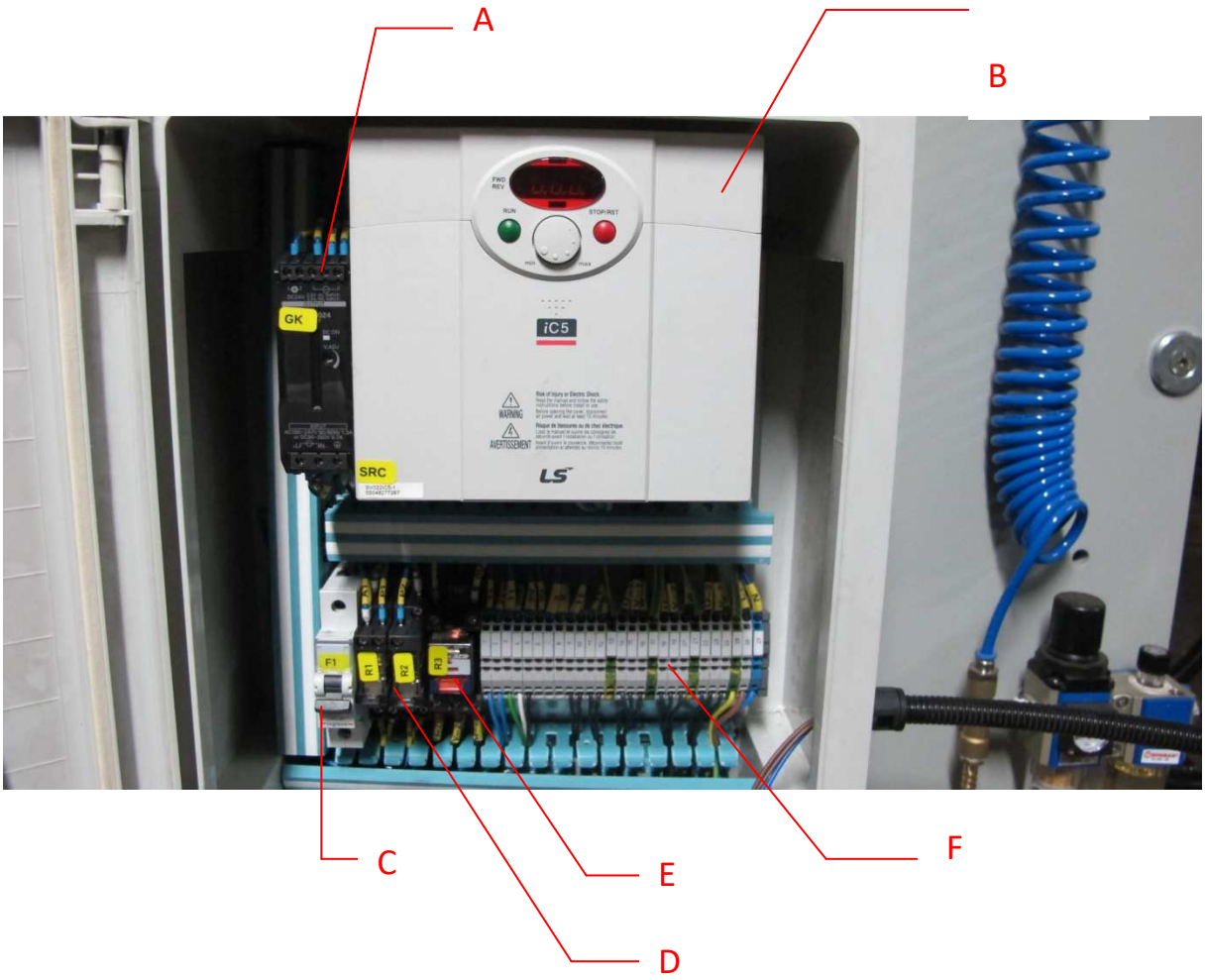
Moving parts of the machine are generally cleaned by an anti-rust oil. Power connection and pneumatic connection are made for the machine to function properly.

8.4 Electrical Connections

VOLT	400V
HERTZ	200Hz
CURRENT	10A
POLE	3P+N+E

8.5 Electrical Panel Scheme and Equipment Structure

This electrical panel scheme is provided solely for placement of components within the panel. See ANNEXES for an in-depth electrical scheme.



A-	Power Supply
B-	Driver
C-	6A Fuse
D-	Relays
E-	3-Contact Relay
F-	Electric Terminal Group

8.6 Pneumatic Connections

Ideal air pressure for the machine to properly function is 6 bar. Check the manometer.

Caution:

Make sure that your air supply is dry!

Solenoid Valve group controls the motion of current pneumatic equipment. Manual actions may also be performed by valves when necessary.

9. Machine Use

9.1 Machine Start/Stop

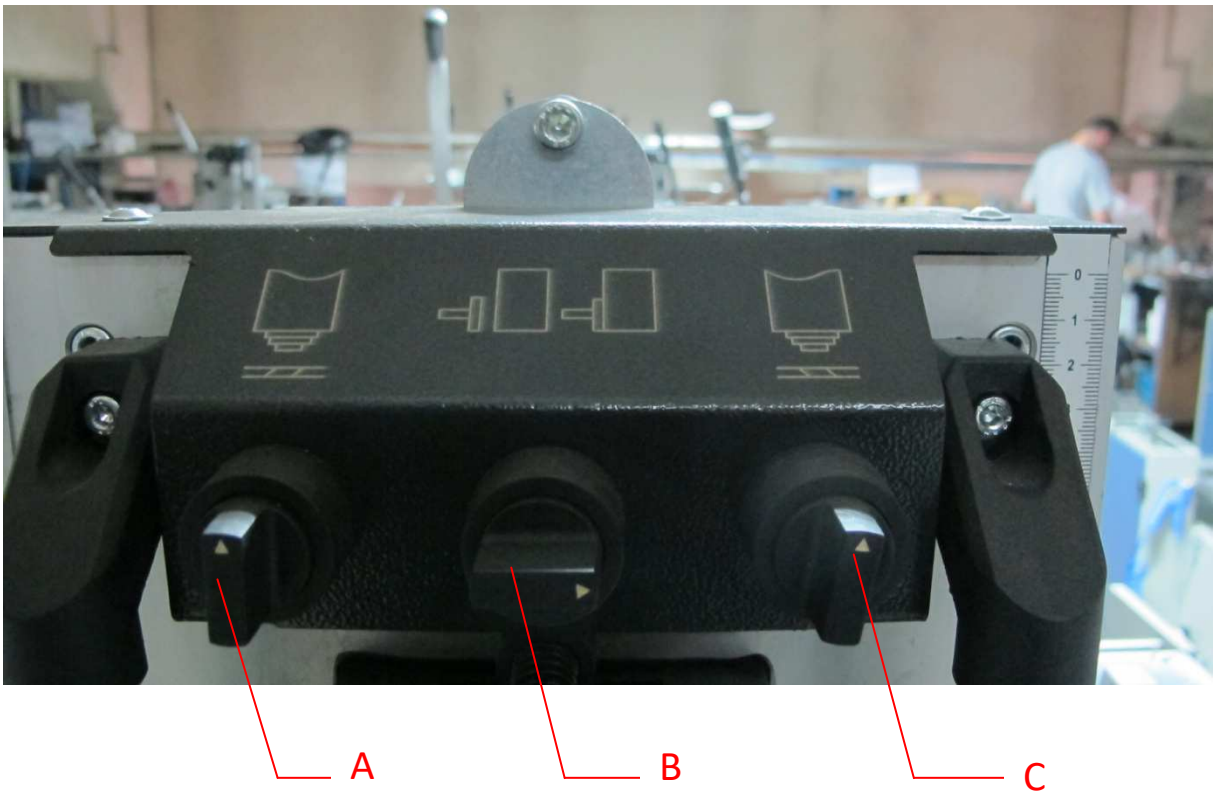
Make sure that there are no foreign objects on machine prior to operation.

9.2 Turning on the Machine

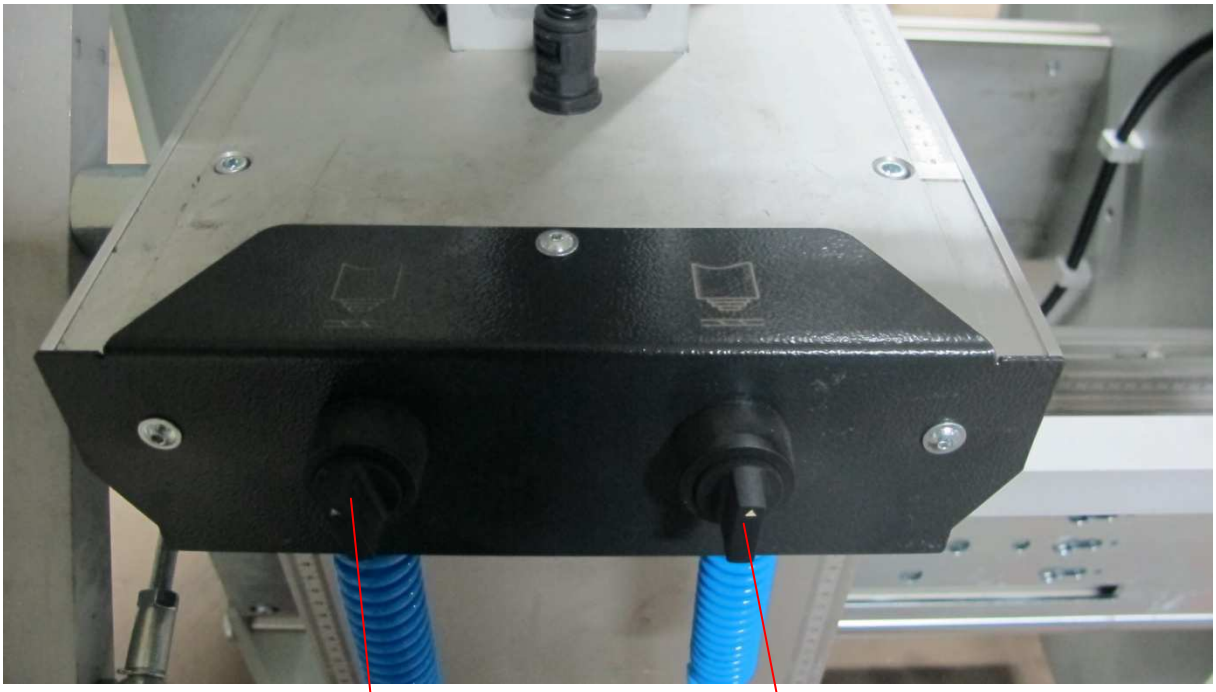
Rotate the main switch clockwise until it slots into its place.

9.3 Control List

Main Switch: It completely cuts off the power supply from mains.



A-	Activates Left Follower on the Vertical Cutter
B-	Activates Press/Fixing Supports
C-	Activates Right Follower on the Vertical Cutter



A- Activates Left Follower on the Horizontal Cutter

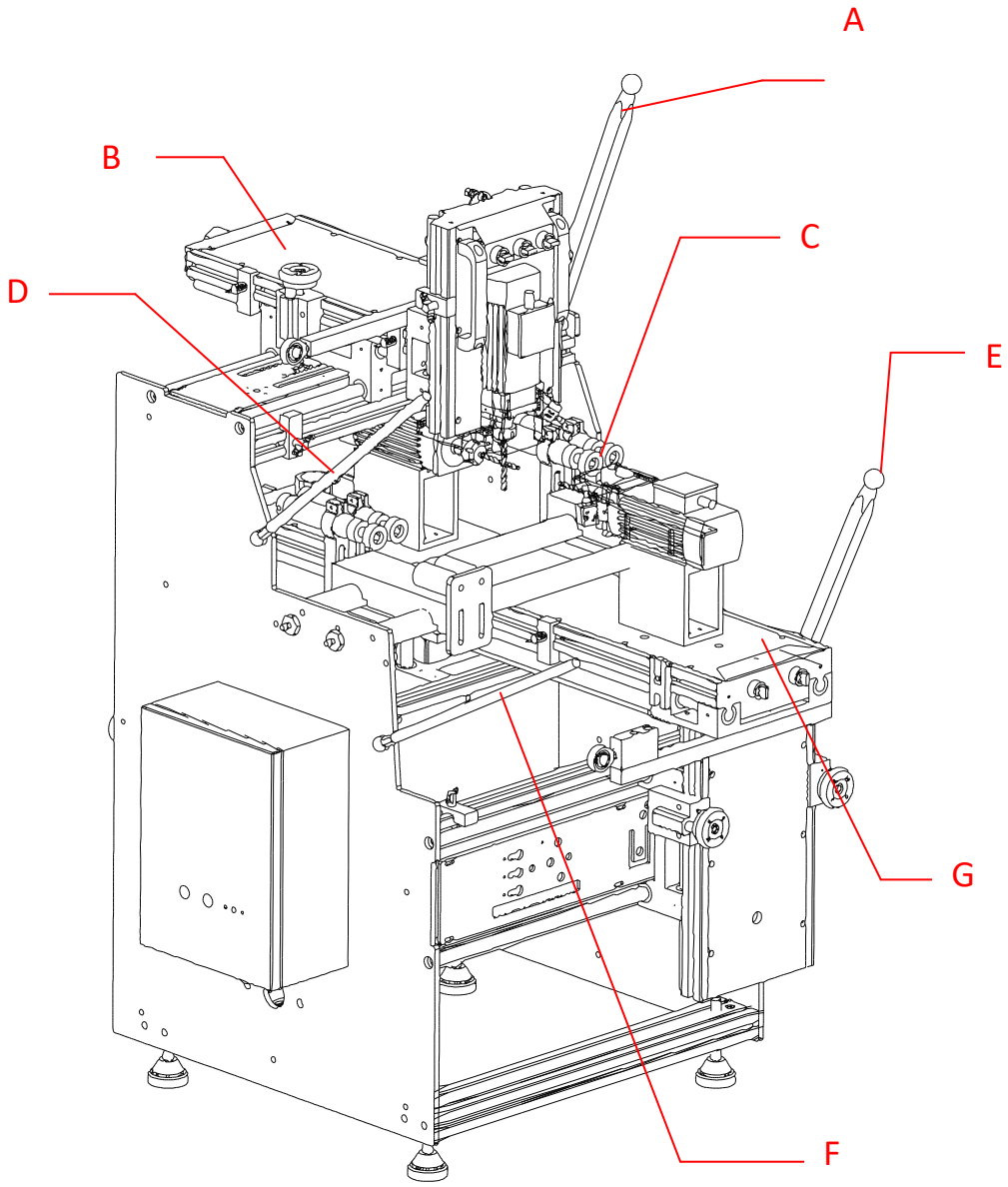
B- Activates Right Follower on the Horizontal Cutter

- Contact with moving parts may lead to electric shock.
- Do not use sharp objects on protective isolation equipment as they may do harm.
- Do not use pointed objects that can penetrate into the protective isolation equipment.
- Turn off the power supply prior to any maintenance or adjustment.

Important Note:

If the machine is relocated for any reason, it may not operate at the site it is plugged in. The reason for non-operation is that the phases in plug sockets are reverse. Saws of the machine are protected by a phase sequence relay to avoid rotation at a reverse phase. The machine may be operated again when the phases in machine's plug are changed by an electrician.

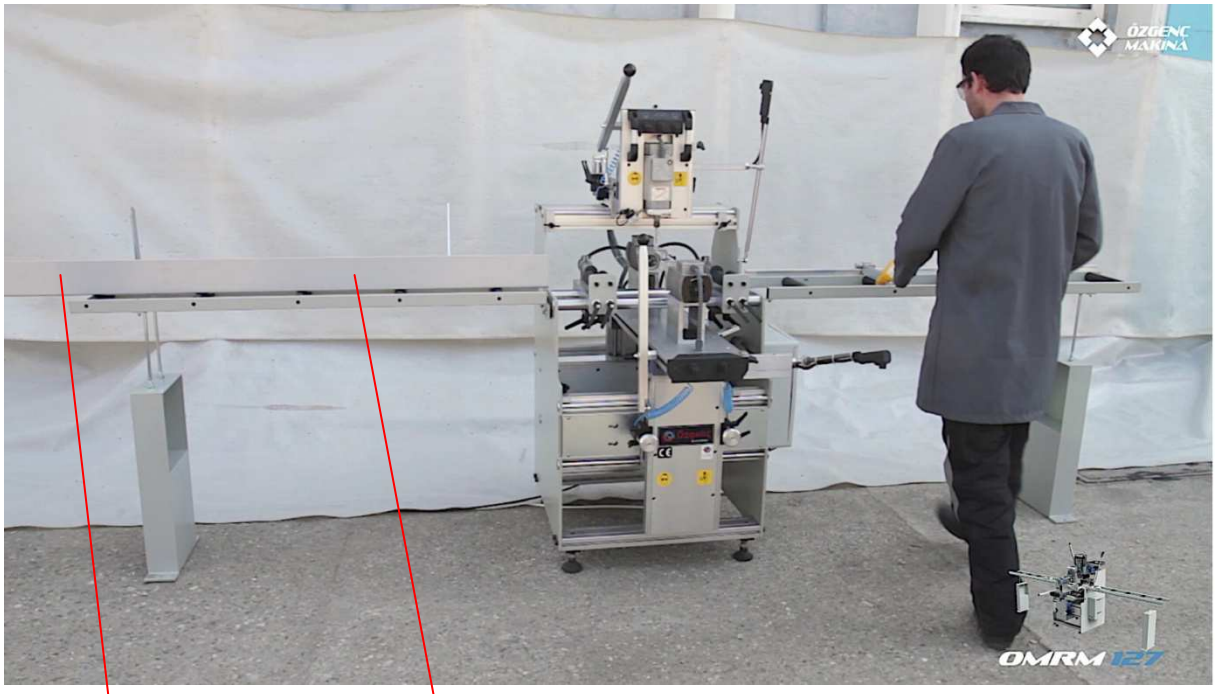
9.4 Moving Equipment on Machine



A- Vertical Cutter Operating Lever
B- Vertical Cutter Movement Tray
C- Pressure/Fixing Supports
D- Vertical Cutter Movement Lever
E- Horizontal Cutter Operating Lever
F- Horizontal Cutter movement Lever
G- Horizontal Cutter Movement Tray

9.5 OMRM 127 3-Motor Aluminum Copy Router Machine and Machine Settings

- Before working on OMRM 127 3-motor aluminum copy router, make sure the tray and all parts are clean and dry.
- Remove all foreign objects and burrs on all surfaces of the machine.
- Check that cutting ends are safely tightened.
- Place the profile to be processed on the conveyor



Conveyor Profile

- Adjust the length of the profile to be processed using the measuring reel available on the side of the conveyor and then fix the support.

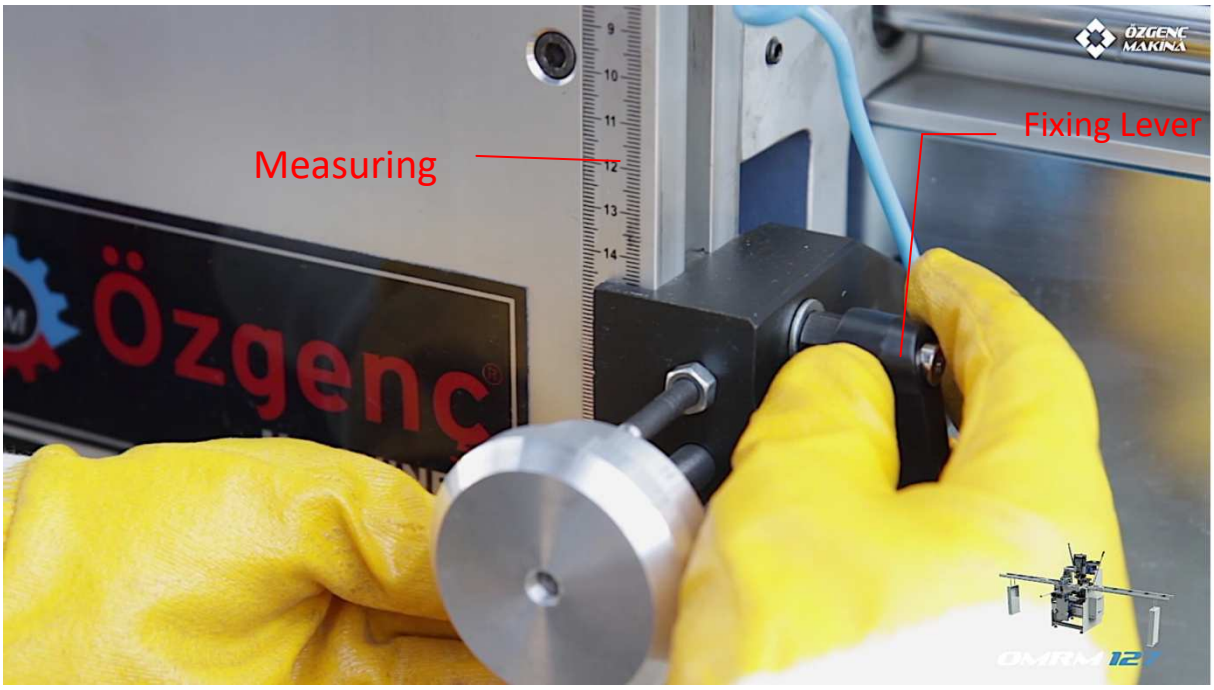
Measuring Reel

Support

- After placing the profile rotate the Press/Fixing support button on the vertical cutter control panel to activate the supports.

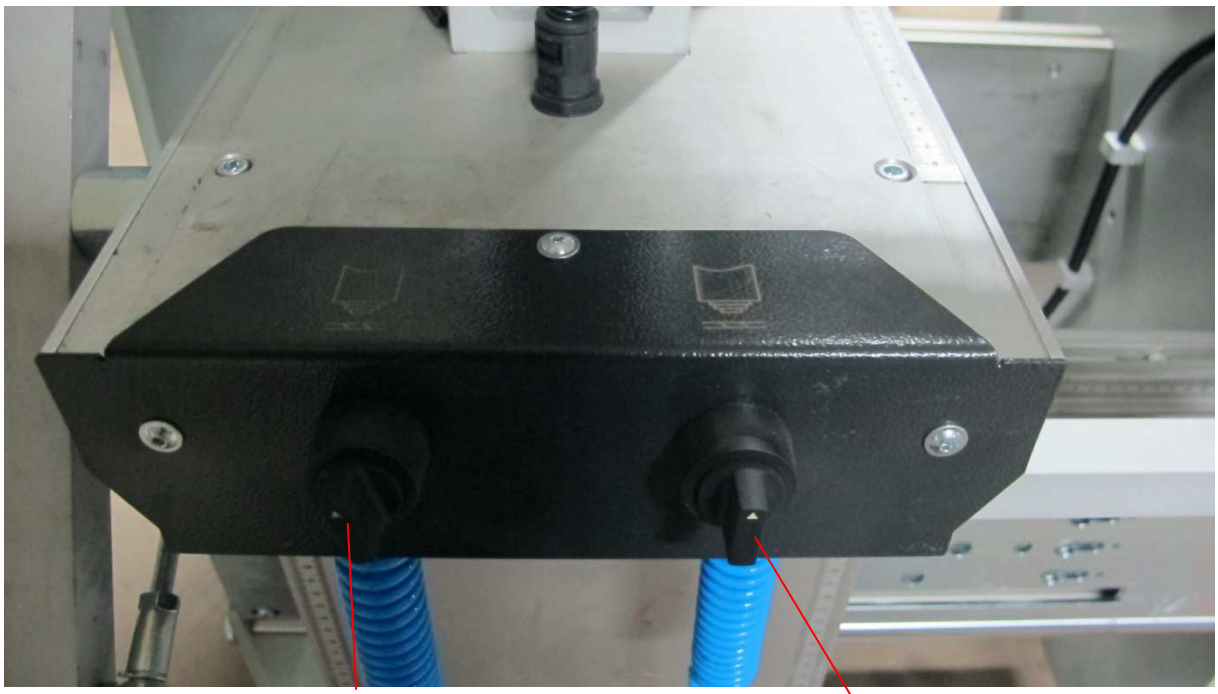
Supports will be activated and the profile will be fixed.

Horizontal Cutter Operation



- Loosen the fixing levers found on the sides of the follower to adjust the cutting depth checking the measuring reel available on the horizontal cutter group

- After placing the horizontal cutter follower on the template rotate the follower activation button on the horizontal cutter control panel

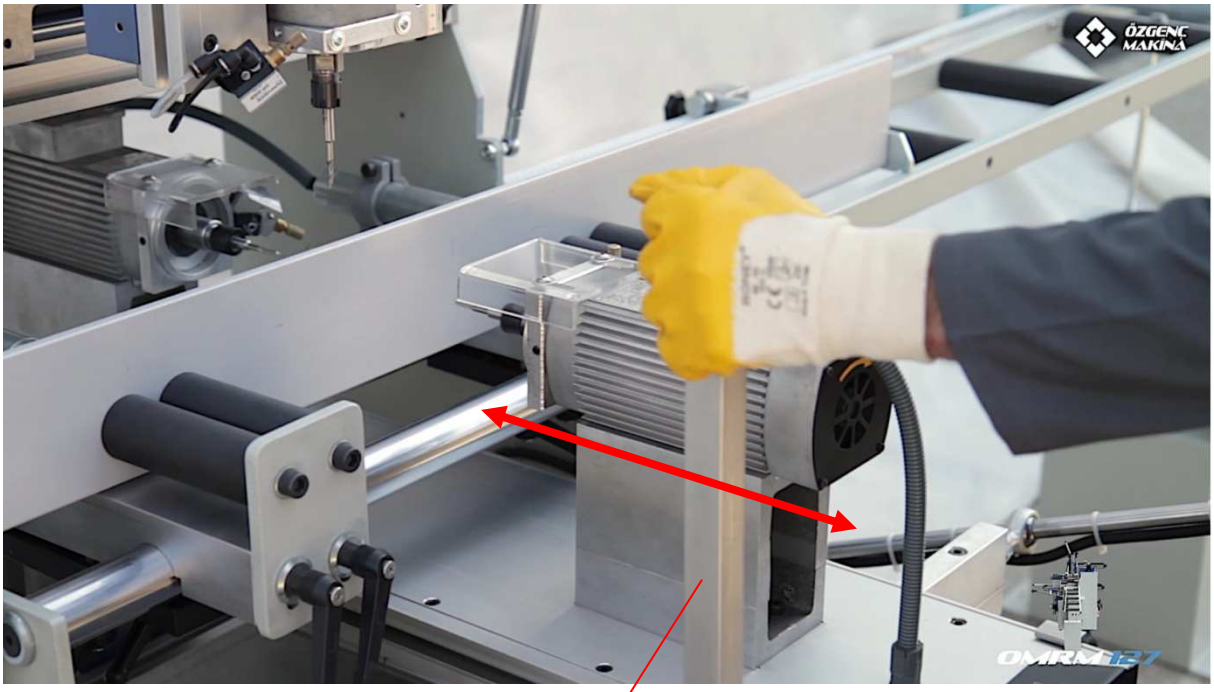


Horizontal Cutter Left Follower Activation Button

Horizontal Cutter Left Follower Activation Button

- Press and hold the horizontal cutter activation button (Horizontal Cutter will be activated)

- While holding the horizontal cutter operation button pressed, push the horizontal cutter movement lever forward to process on side of the profile and then pull back the movement lever to process the other side of the profile.

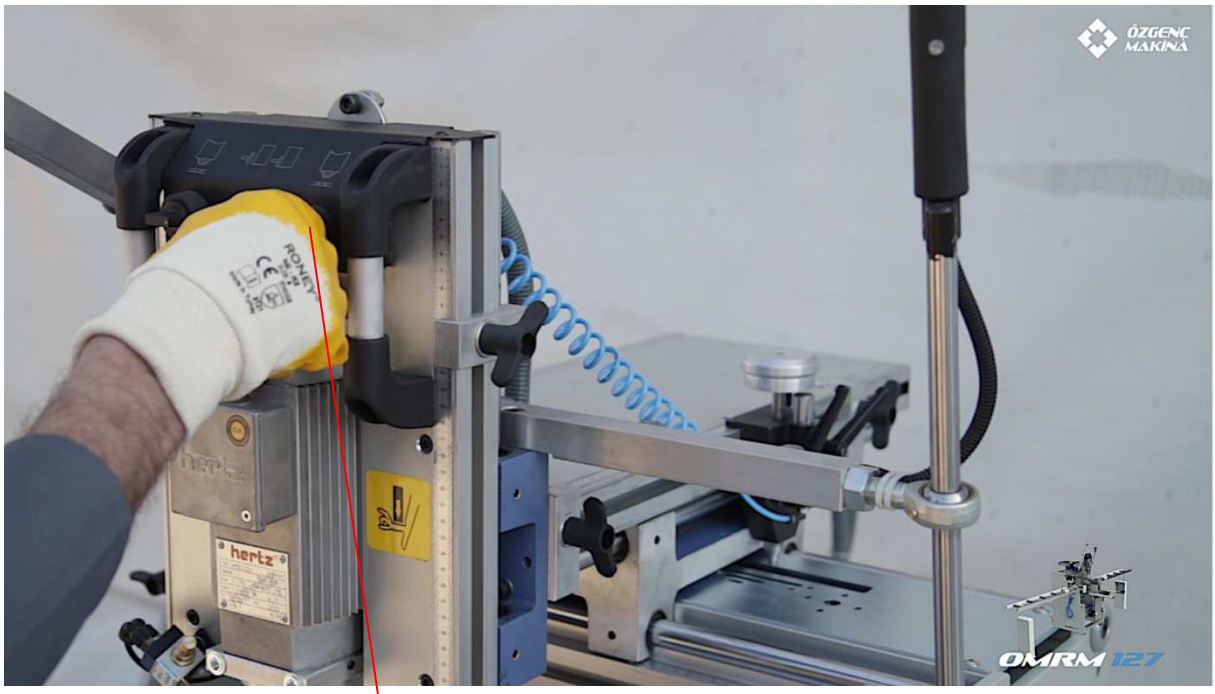


Horizontal cutter movement lever

Vertical Cutter Operation

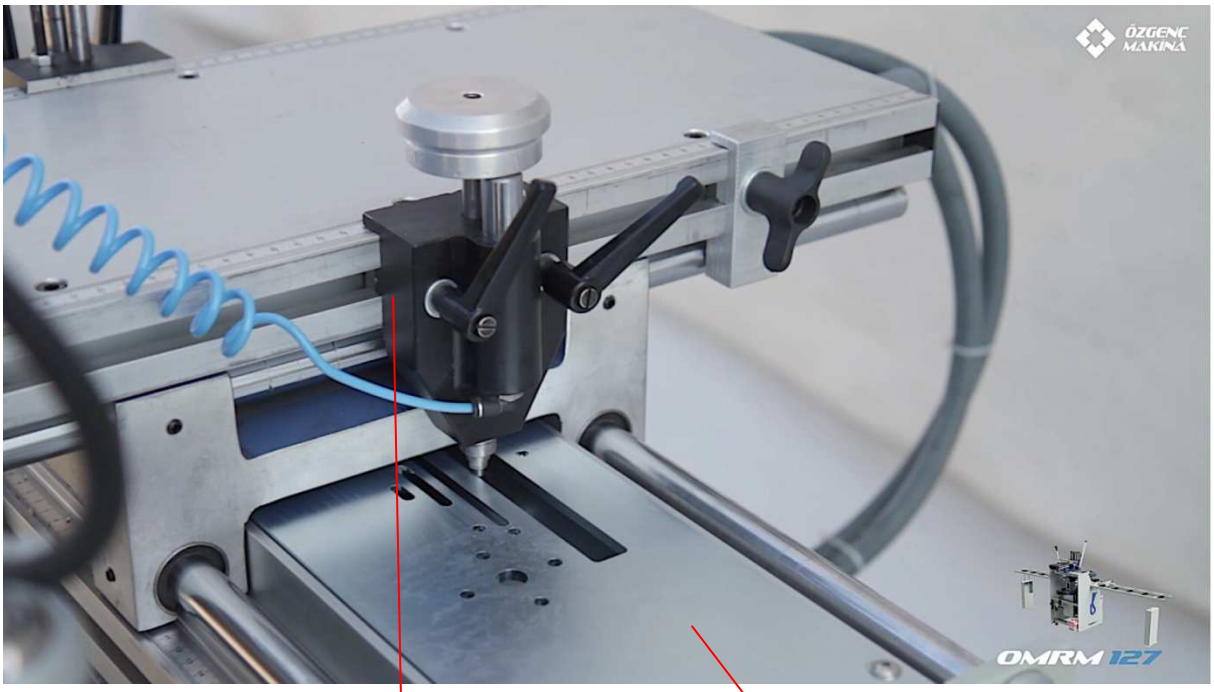
- Before operating the vertical cutter fix the horizontal cutter tray

Horizontal Cutter Tray Fixing Punch



Vertical Cutter Follower Activation Button

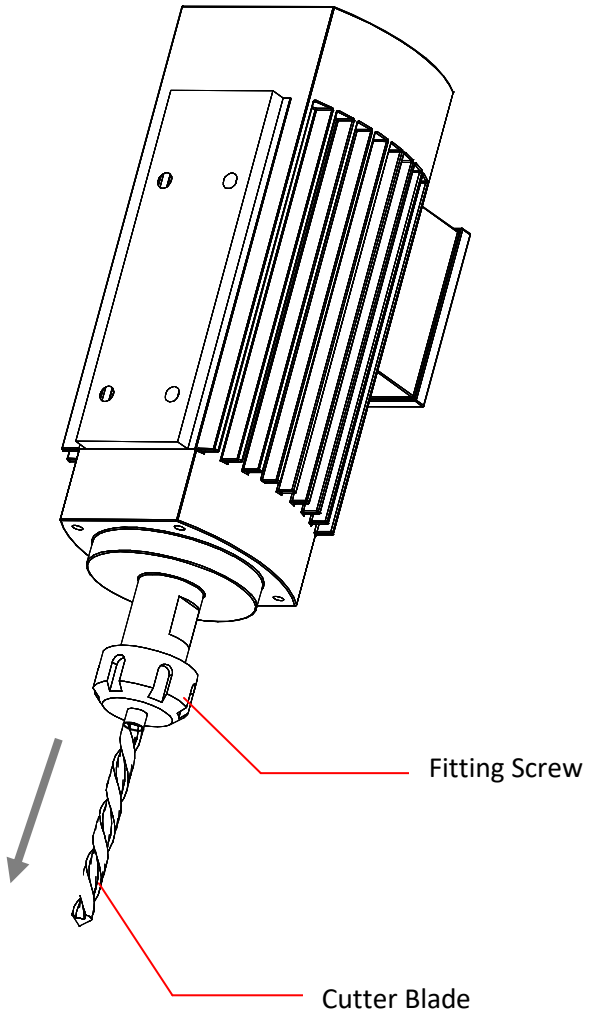
- After placing the vertical cutter follower on the template, rotate the follower activation button on the horizontal cutter control panel



- Press and hold the vertical cutter activation button (Vertical Cutter will be activated)

- While holding the vertical cutter operation button pressed, pull the vertical cutter movement lever downwards and complete the cutter operation.
- After completing the cutter operation, rotate the Press/Fixing support button on the vertical cutter control panel to deactivate the supports and remove the profile.
- Repeat same actions for other profiles

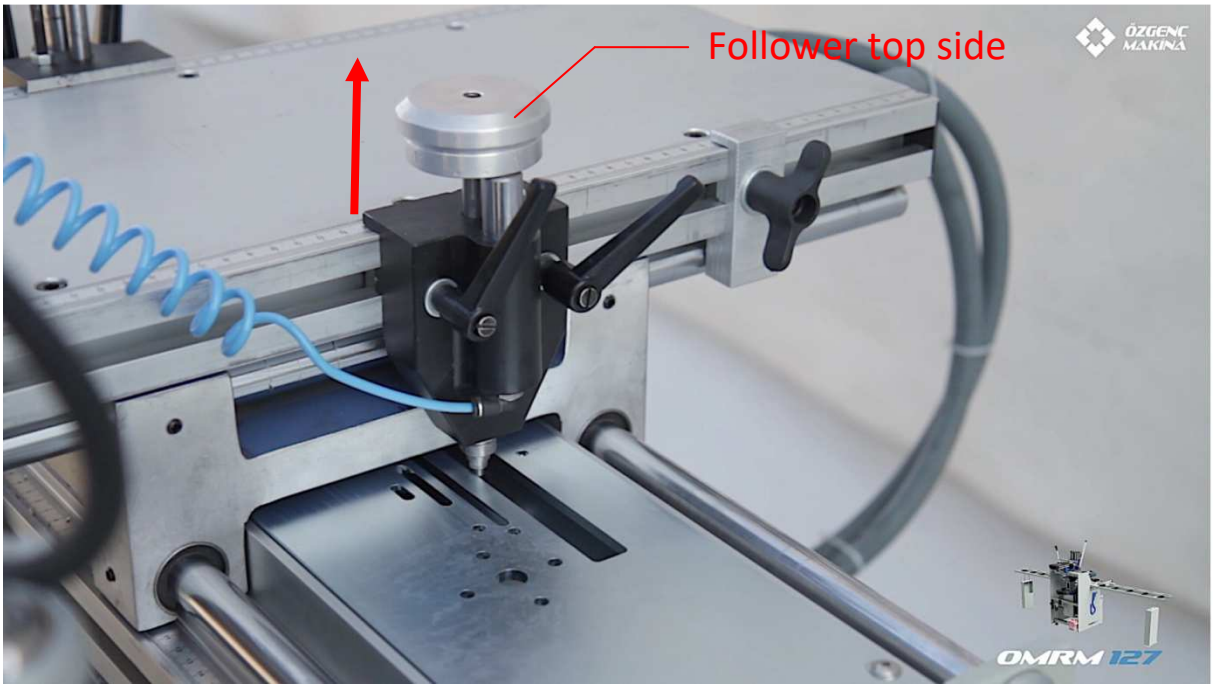
9.6 Replacing Cutter Ends



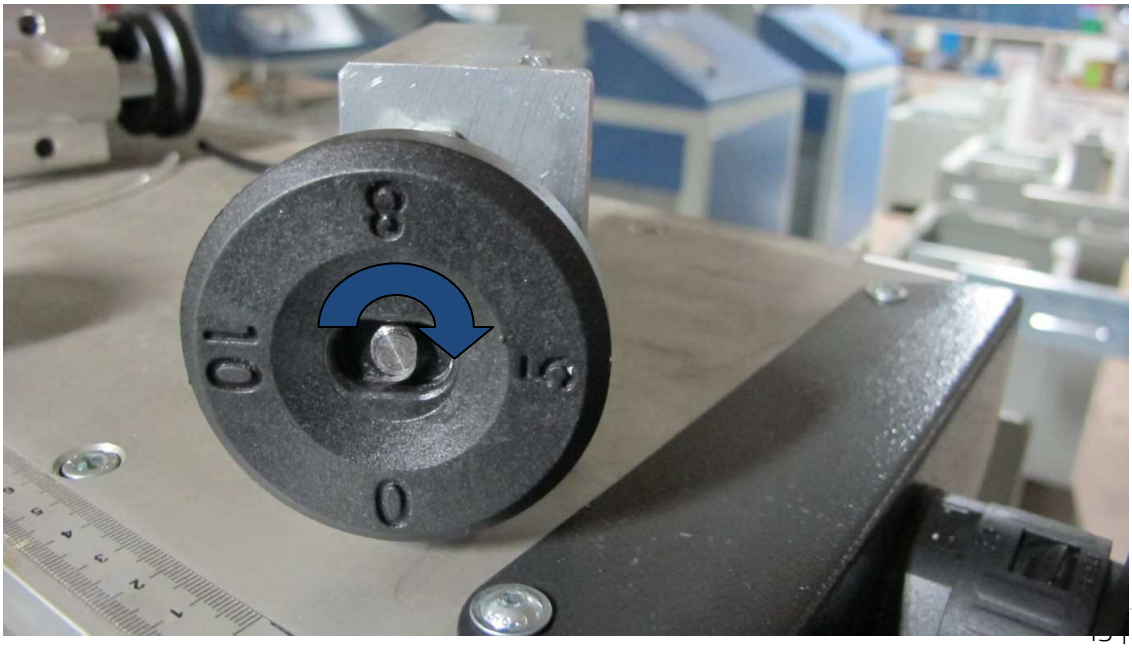
1. Turn off main switch before replacing cutter blades
2. Remove the fitting screw using a switch
3. Pull and remove the milling cutter
4. Place the new blade
5. Re-tighten the fitting screw

9.7 Adjusting Follower Dimension

- Ensure that the relevant control panel follower deactivation button of the follower for which dimension will be adjusted is closed.
- Pull the follower from the top side towards yourself



- Rotate the stage dial (5-8-10 mm) on the top of the follower to the desired setting and then pin it down.



10. General Maintenance Issues

10.1 General Maintenance

REMARKS	DAILY	WEEKLY	MONTHLY
Cleaning top and surroundings of machine	✓		
Cleaning of oil and other wastes	✓		
Cleaning of moving parts	✓		
Cleaning of slides and threaded rods	✓		
Conditioner control (water, oil)	✓		
Lubrication points		✓	
Weekly maintenance		✓	✓

Note:

Slides and moving parts of the machine must be cleaned of dust and sawdust using compressed air.

10.2 Conditioner Water Level Control

There must be no water in the glass tube on the left side of conditioner (reservoir no. 1). Any accumulated water should be discharged.

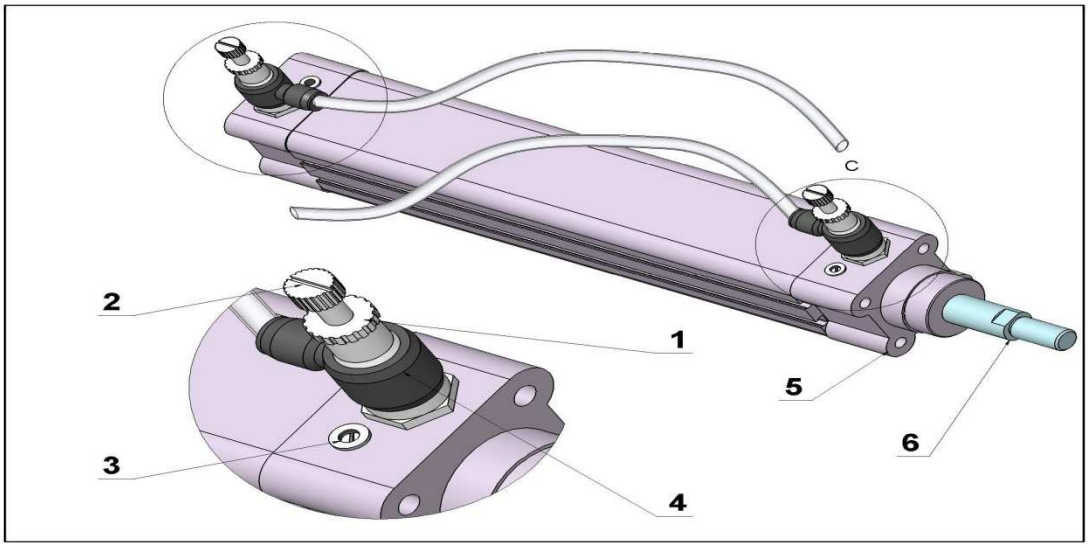
For this, press the plug under the tube upward or rotate it, depending on the type of the conditioner used for the machine.

10.3 Conditioner Oil Level Control

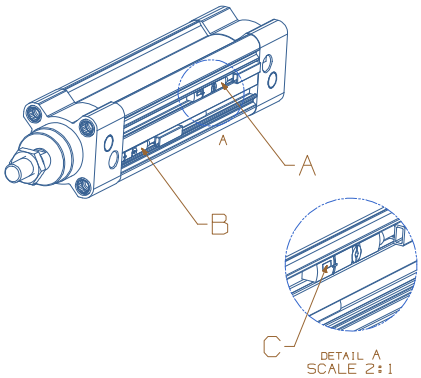
Check oil level within the transparent tube located on the right hand side of conditioner. If the oil runs out, cut the air of the machine and put oil into the conditioner. When oil amount is low, replenish using oil types equivalent to Shell TELLUS C 10.

10.4 Cylinder Settings

Loosen nut no. (1). Tighten or loosen bolt no. (2). This helps to adjust the pressure on the piston (6) within the cylinder (5) and to determine the speed of the cylinder to drive the engine. Loosening screw no. (3) can help to perform padding settings.



10.5 Cylinder Sensor Settings



A- Cylinder BACKWARD position sensor

B- Cylinder FORWARD position sensor

C- Sensor LED indicating light

Note:

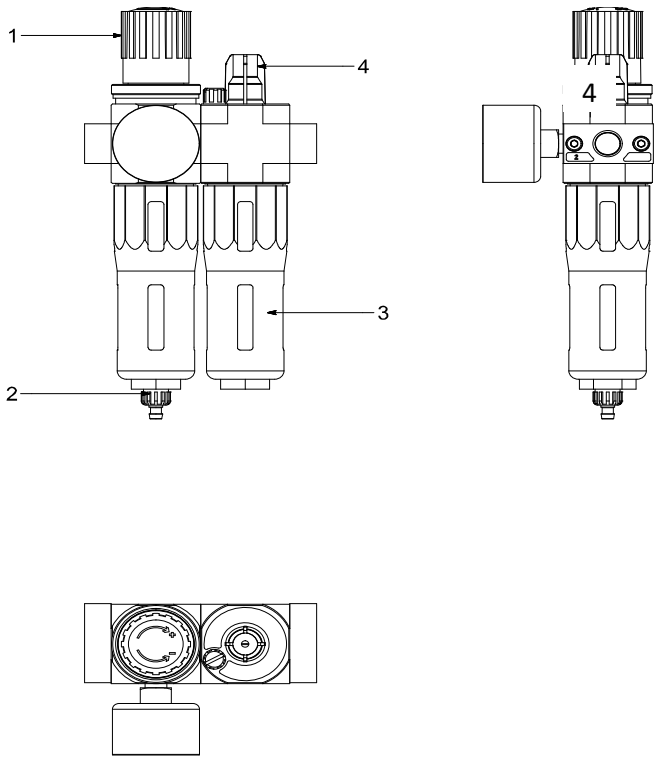
In normal standby position of the machine, backward and forward sensors of LED lights in relation to the cylinder position should be lit. You can adjust sensor settings using the special allen key located in the spare part box.

10.6 Filter Maintenance

For pressure settings: Pull up the regulator cap "1". If you rotate it clockwise, then outlet air pressure of conditioner increases. If you rotate it counter clockwise, then pressure decreases.

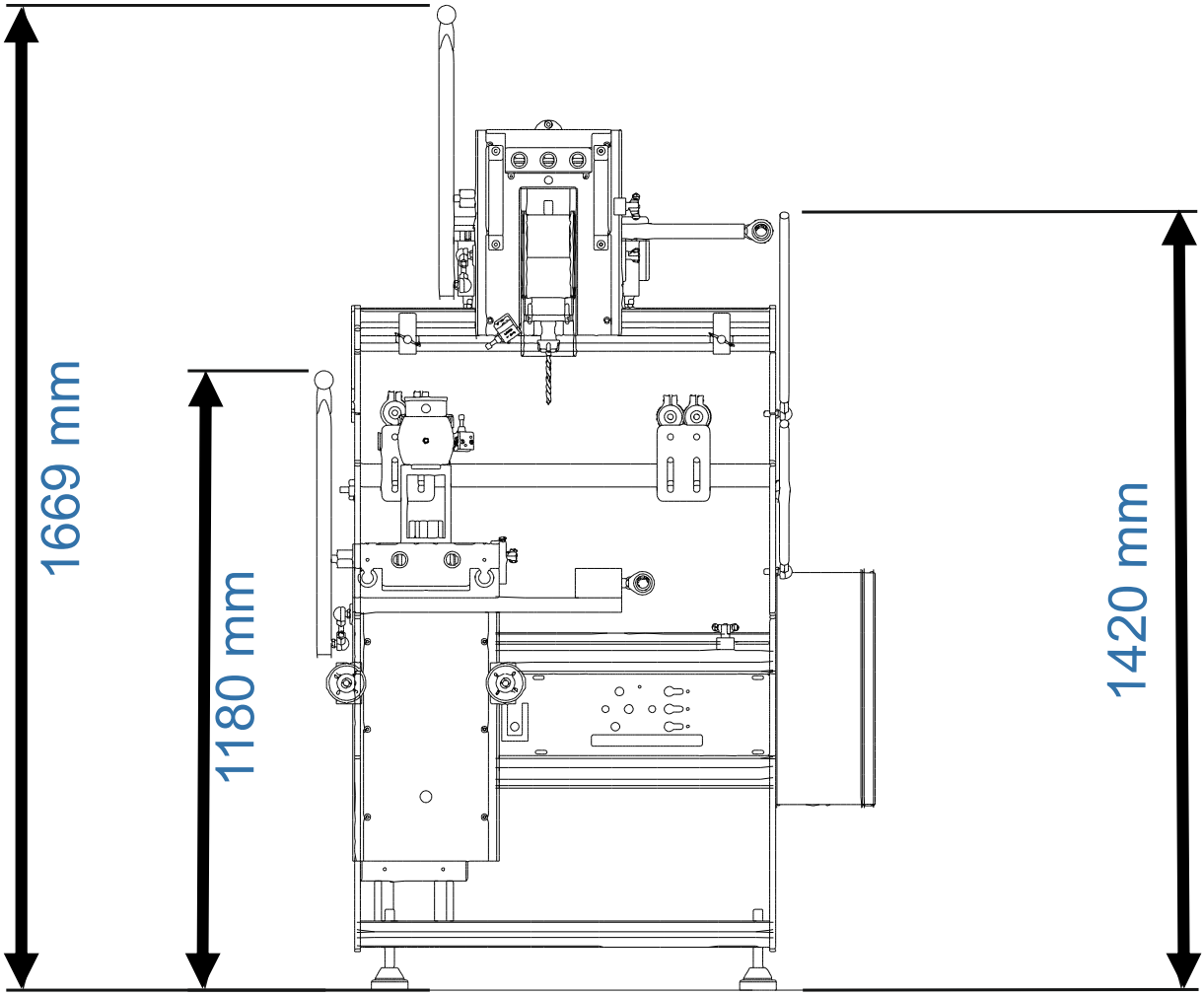
Discharging condensation fluid. Press or rotate the discharge screw "2" to discharge the water.

Putting oil into conditioner: Take off the oil container of conditioner "3" by rotating it clockwise and put pneumatic oil into container. Speed settings for lubricant: Turn adjusting screw “4” clockwise and thus you can reduce flow (dripping) rate of lubricant and decrease it by turning in the opposite direction.



10.7 Ergonomics

The machine is compliant with operating ergonomics. Operator's panel height and access to manually adjusted equipment are compliant. Electric and pneumatic panel access is viable. Ergonomic conditions for sampling, loading and pre-preparation are suitable.



11. Problem Detection Chart

FAILURE	CAUSE	SOLUTION
Machine Fails to Draw Power	• Main board switch Turned off	• Turn on main switch
Pneumatic Equipment Do Not Operate	• Machine fails to draw air	• Check the compressor line
Pistons Do Not Mangle	• Low pneumatic pressure	• Check regulator pressure settings
Cutter Blade does not rotate	• Cutter Blade Operation button does not work	• Check button failure
If the button is broken	• Dust may have been accumulated in contacts • Cable ends might be loose • It may arc and be adherent	• Clean by air • Tighten ends • Replace the button

In case valve is broken	• Valve coil may have been dislocated • Coil cables may be loose or burnt • Valve may have run out of oil • Dirt may have penetrated into reducers	• Remount the coil • Tighten or replace cables • Oil the valve • Check hose • If failure is not eliminated despite above-mentioned actions, then you must replace the valve
Low Surface Quality	• No cooling on the cutter cutting surfaces • Faulty cutting blade or cutting blade cutting shields are worn	• Increase the coolant spray rate setting

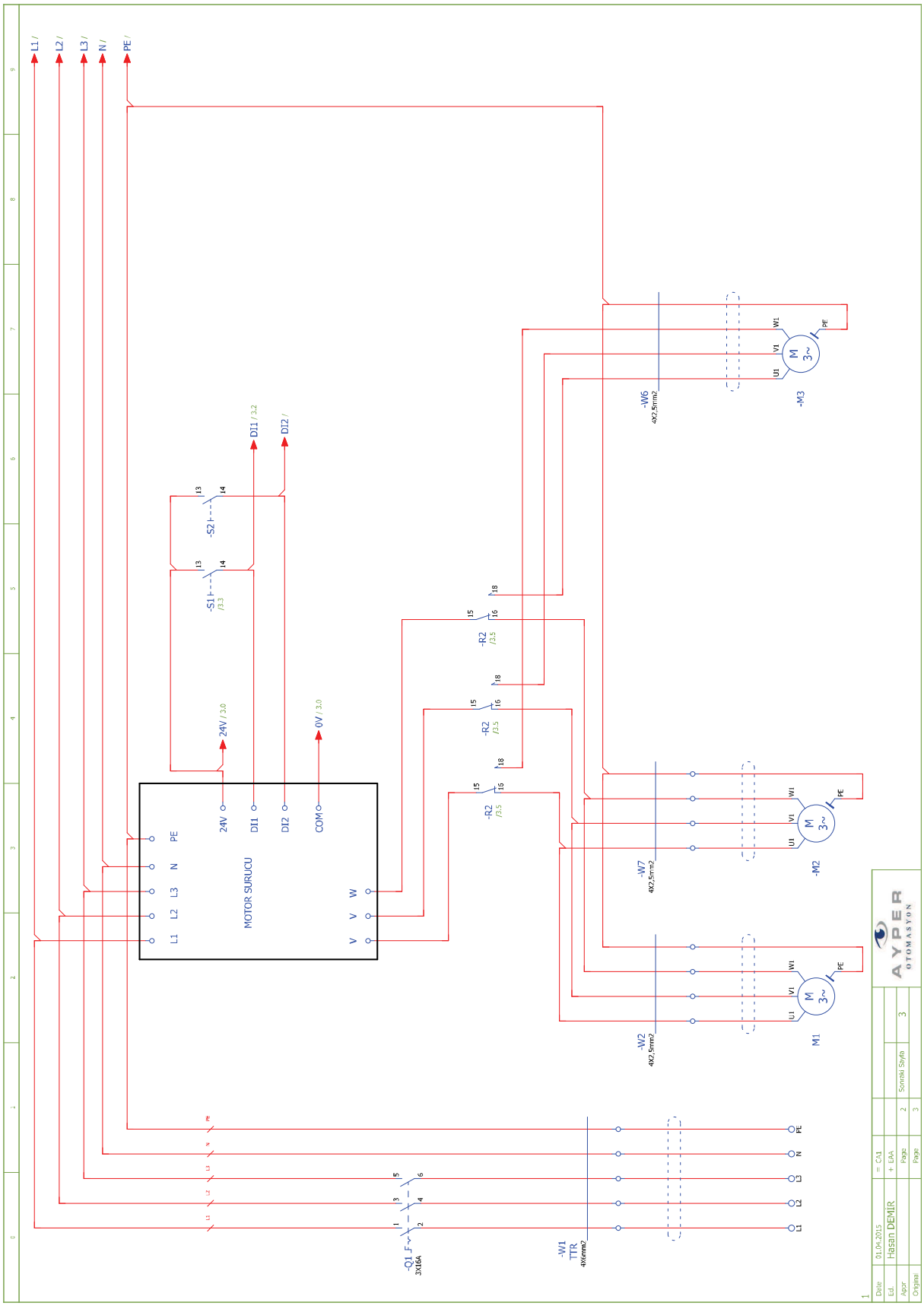
12. Warranty Disclaimer

The term of warranty starts as of the invoice date and it is 2 years.
The machine is under our company's warranty for any manufacturing and material-related defects.
If the machine breaks down within the term of warranty, the period of time spent to repair is added to the term of warranty.
The time to repair the machine is maximum 30 business days. This period starts as of the failure report date to the service center.
M.S.K. service officer or an authorized service agent decides whether the defected part and/or equipment is under warranty.
If the machine is guided by a technical service officer within the term of warranty, then transport, visa and accommodation expenses are covered by the buyer.
If the machine malfunctions due to any faulty material, workmanship or assembly within the term of warranty, it will be repaired without charging any fees including those for workmanship and replaced parts.
Manufacturing company is responsible for supplying parts and fault clearance and cannot be held accountable for labor loss.
Expenses for shipment and customs duty are covered by the buyer.
Terms of payment for the buyer are not affected by machine's warranty situation.
Buyer cannot claim compensation in any fault case and does not reserve the right to delay or cancellation of payment or cancel the order or claim compensation for labor loss. The warranty covers manufacturing and material-related defects, not the operating function of the machine.
Consumables required for machine setting are supplied by the buyer.
All warranty requests must include serial and model numbers.

12.1 Out of Warranty Situations

Consumables (milling, drilling bits, saws, teflon, etc.) are out of warranty.
Damages to arise during shipment.
Defects resulting from use of non-original parts.
Defects resulting from user's lack of attention or knowledge.
The machine must be initially started up by the service officer.
This machine is out of warranty for any defects resulting from the conditioner running out of lubricant and failure to use proper lubricants.
From mains voltage and
a. Phase gap
b. Reverse phase
c. Overcurrent
d. Lack of current
e. A machine damaged by overvoltage etc. is not considered under warranty.

13.Annexes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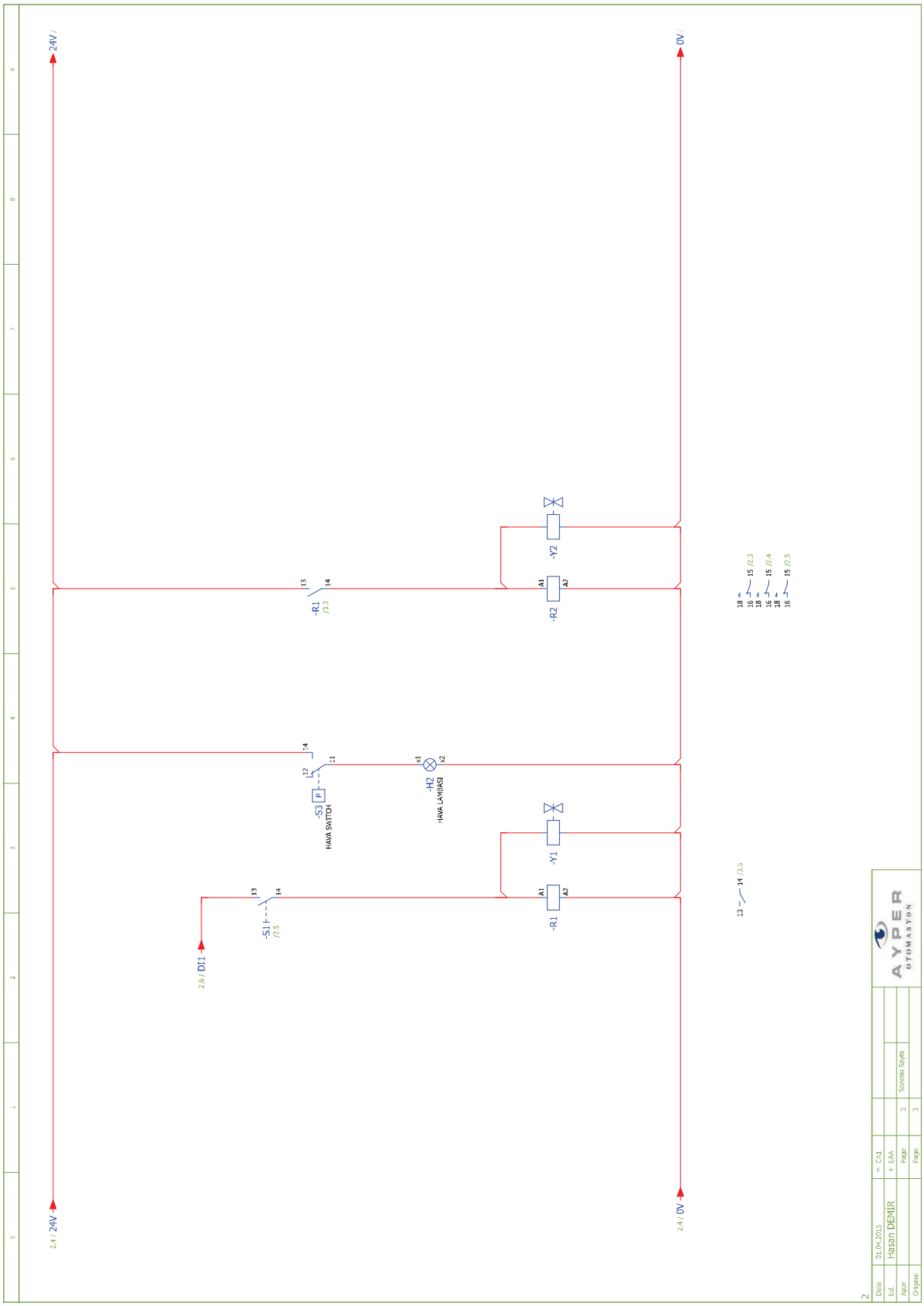
DI1
DI2
COM
0V
-S1
-S2
-R2
-W1
-W2
-W6
-W7
-M1
-M2
-M3
-Q1
AYPER
OTOMASYON
Hasan DEMİR
01.04.2015


24V /
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-R2
-R1
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-S3
HAVA SWITCH
-H2
HAVA LAMBASI
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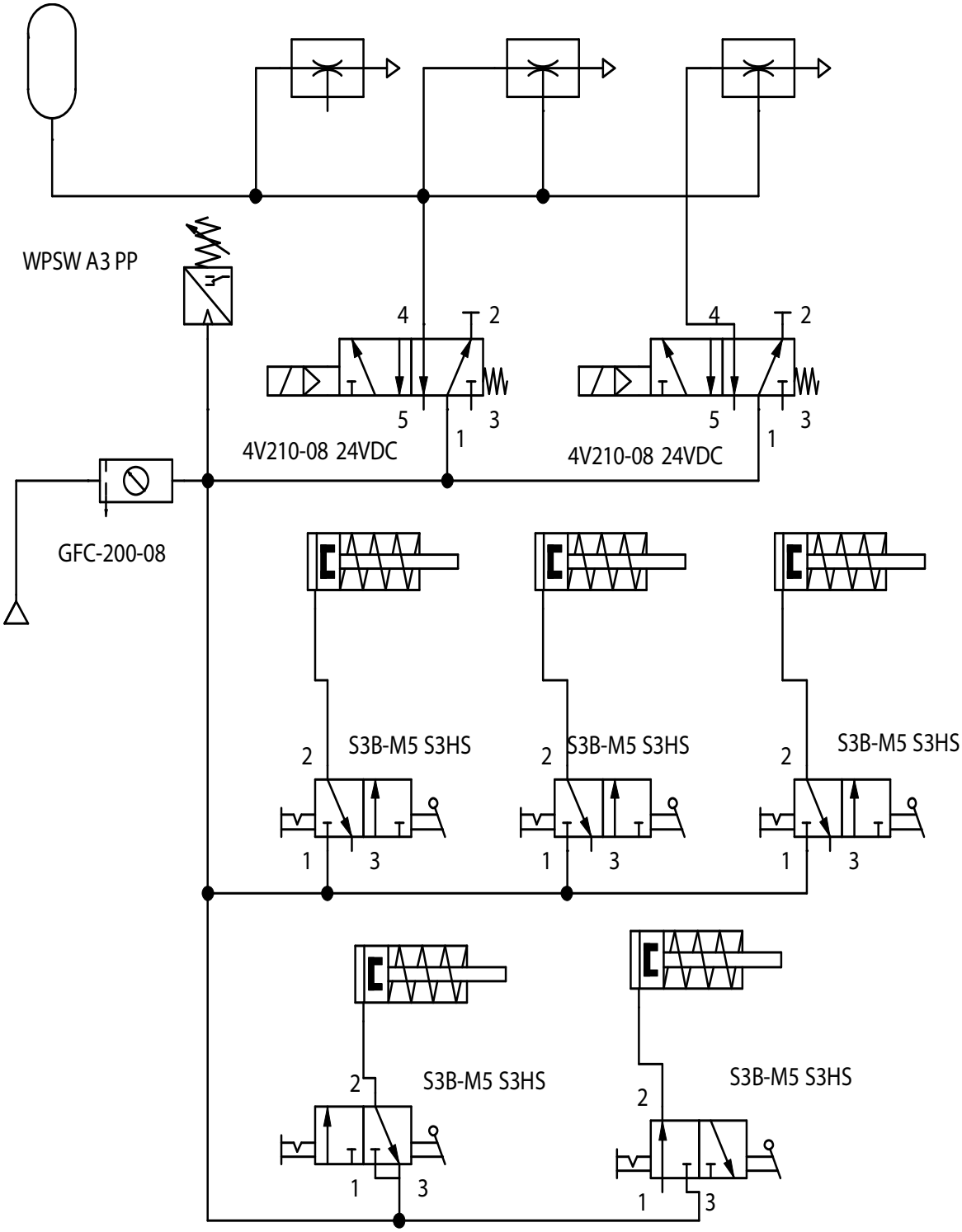
OTOMASYON
Date
01.04.2015
Ed.
Hasan DEMİR
Appr.
Original
Sonraki Sayfa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4V210-08 24VDC
GFC-200-08
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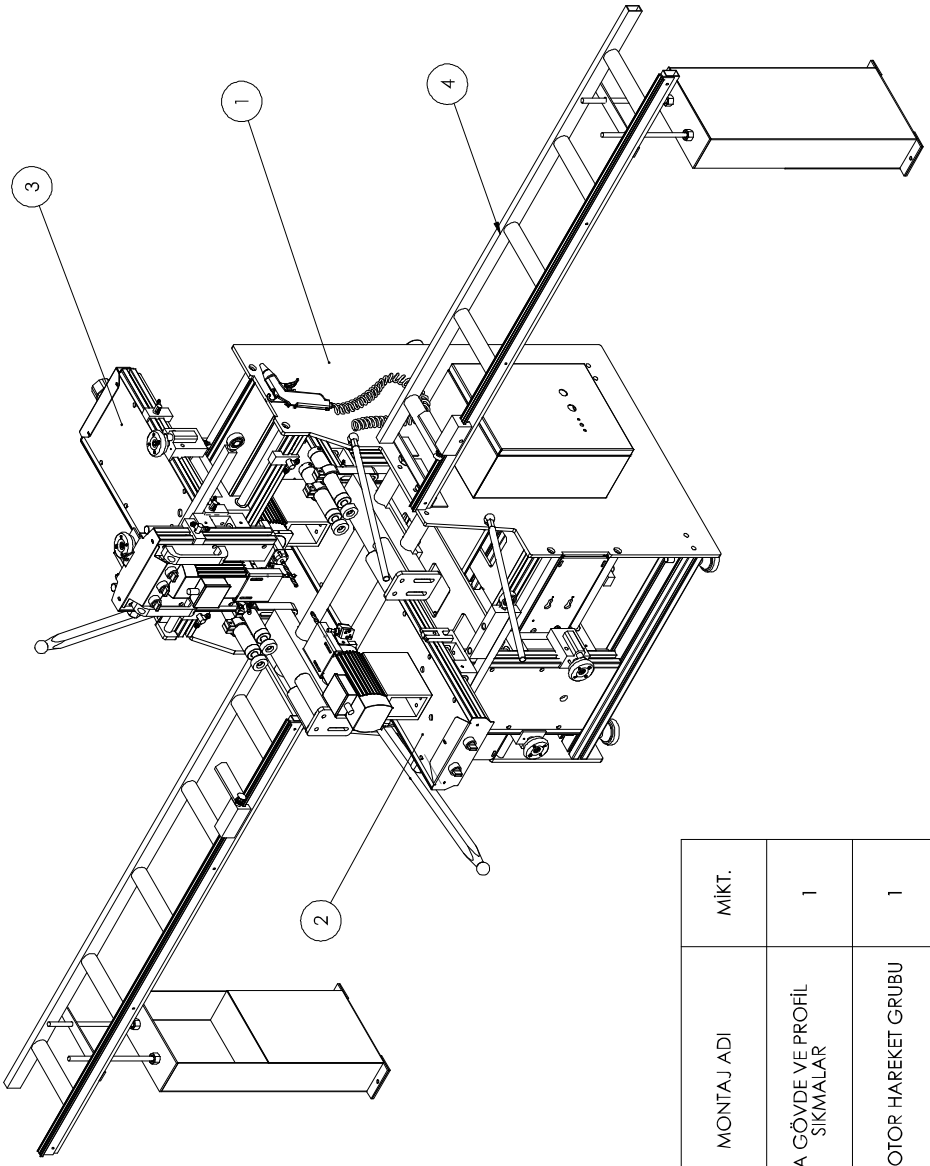
S3B-M5 S3HS
S3B-M5 S3HS



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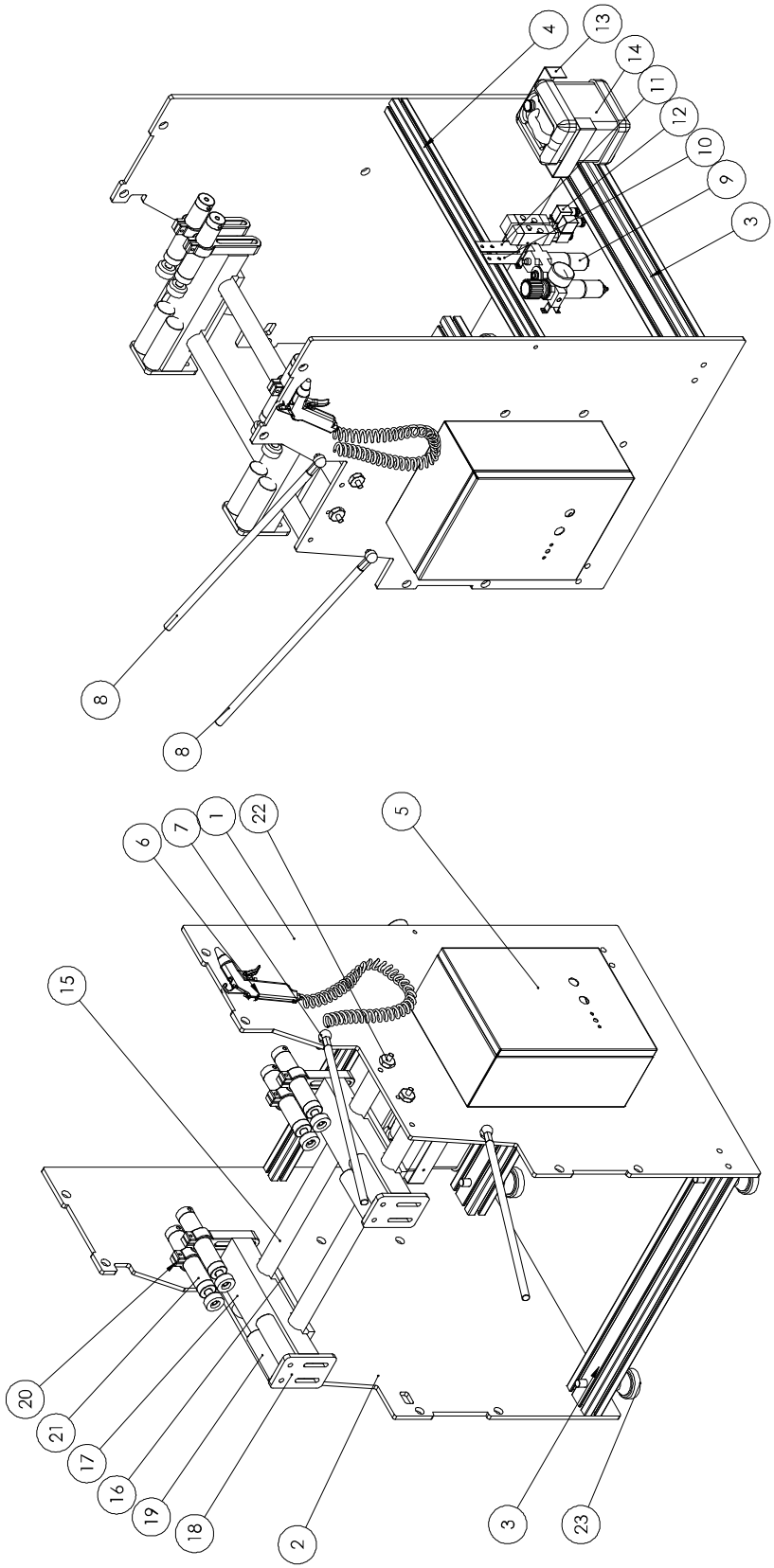
1	127.401.002.0	ANA GÖVDE VE PROFİL SIKMALAR	1
2	127.405.001.0	ALT MOTOR HAREKET GRUBU	1
3	127.404.001.0	ÜST MOTOR HAREKET GRUBU	1
4	127.417.000.0	PROFİL SÜRME VE DAYAMA BANTI	1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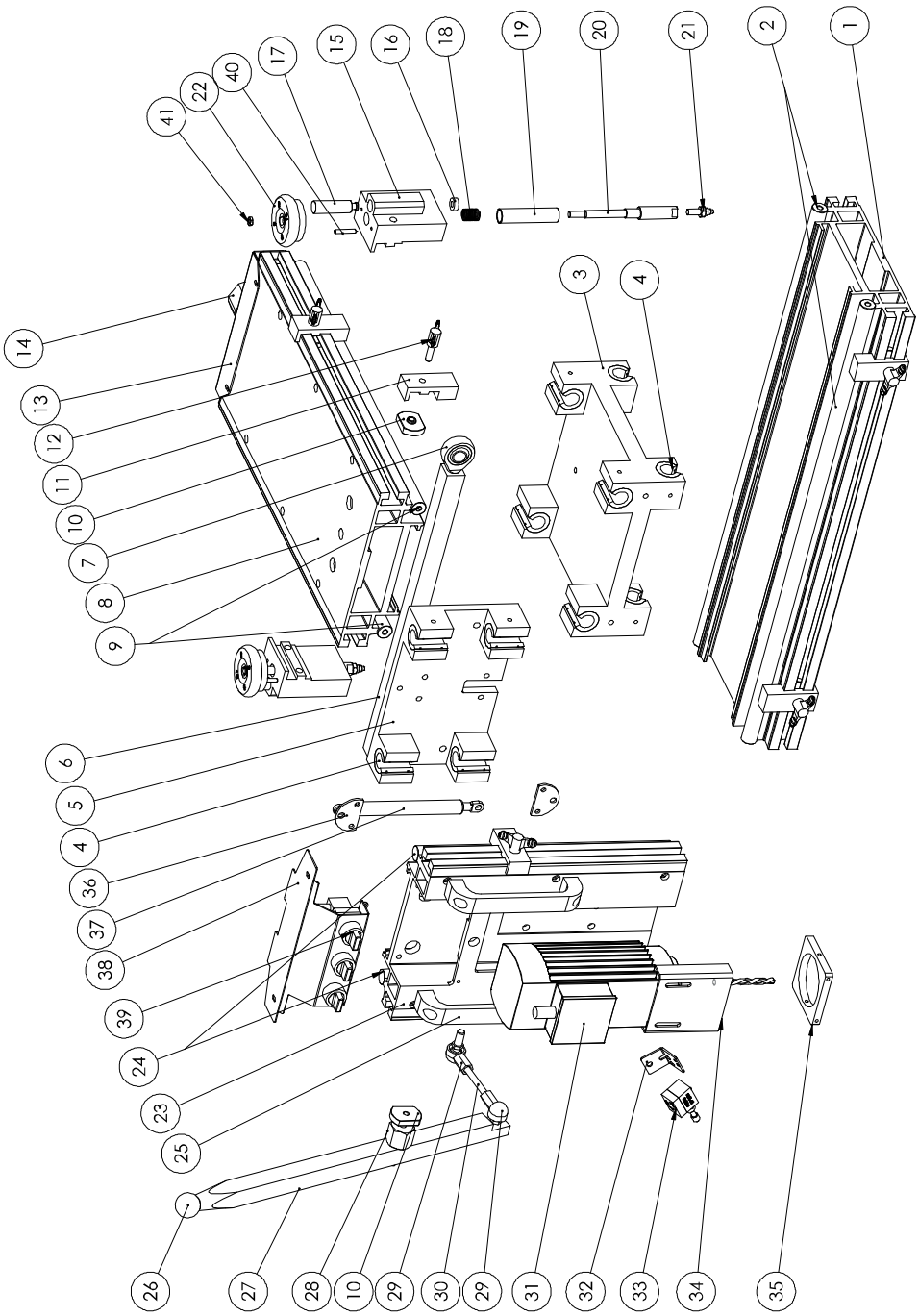
1	31.701.022.0	GÖVDE YAN PLAKA	1
2	31.701.002.0	GÖVDE YAN PLAKA	1
3	127.HZP.17	SİGMA PROFİL	2
4	127.HZP.18	SİGMA PROFİL	1
5	127.HZR.01.0	PANO	1
6	127.HZP.16	HAVA TABANCASI	1
7	127.HZP.04	HAREKETLİ ROD	2
8	31.700.006.0	HAREKET KOLU	2
9	127.HZP.20	ŞARTLANDIRICI	1
10	31.700.025.0	VALF SABİTLEME SACI	1
11	31.700.026.0	VALF BAĞLANTI SACI	1
12	127.HZP.21	TEK BOBİN VALF	2
13	31.712.001.0	DEPO SABİTLEME SACI	1
14	127.HZP.23	SOĞUTMA SUYU DEPOSU	1
15	31.701.017.0	PROFİL SIKMA BAĞLANTI MİLLERİ	2
16	31.701.021.0	MİL SIKMA PARÇASI	2
17	31.701.024.0	MİL SIKMA ÜST PARÇA	2
18	31.701.018.0	RULO BAĞLANTI SACI	2
19	31.701.020.0	RULO	4
20	31.701.025.0	PİSTON SIKMA PABUCU	4
21	127.HZP.22	SIKMA PİSTONU	4
22	31.700.023.0	BANT SABİTLEME CİVATASI	4
23	127.HZP.19	PLASTİK AYAK	4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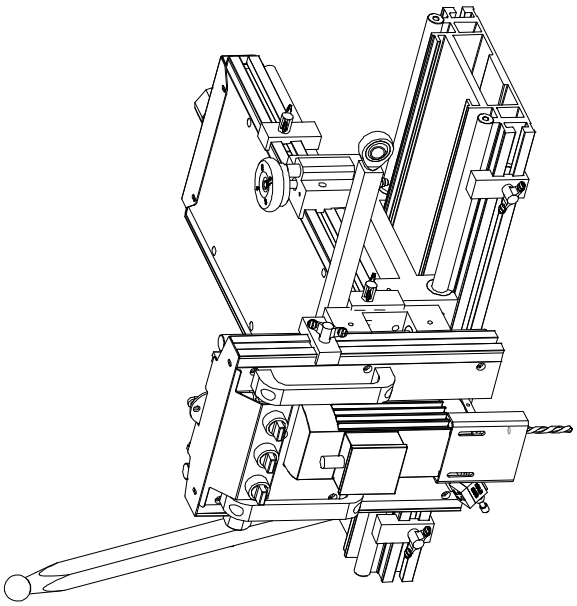

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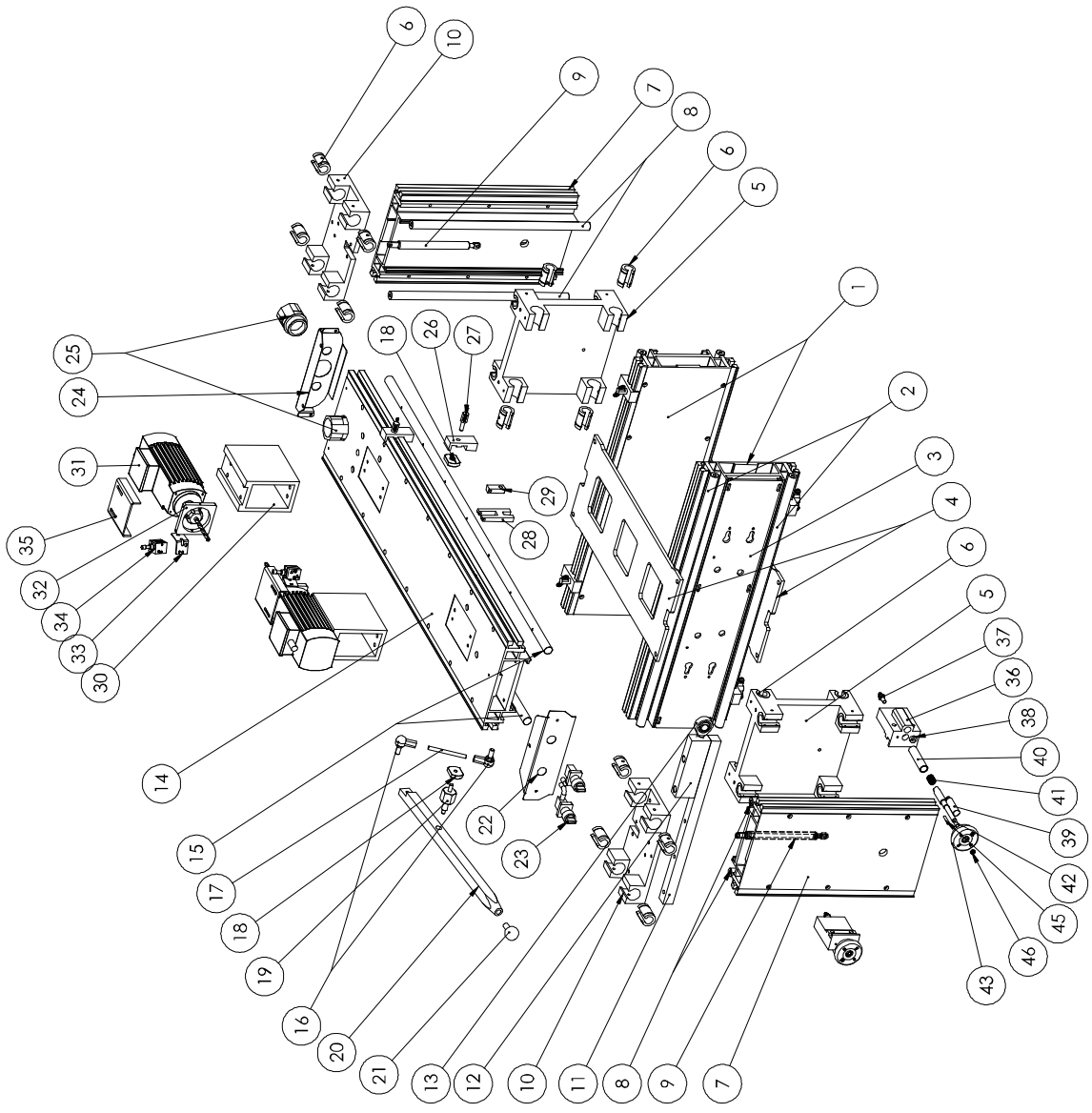
2	31.701.005.0	X EKSENİ HAREKET MİLİ	2
3	31.701.001.0	X VE Y EKSEN RULMAN YATAĞI PROFİLİ	1
4	127.HZP.01	LME 20 UU YARIK RULMAN	12
5	31.701.008.0	Z EKSEN RULMAN YATAĞI PROFİLİ	1
6	31.700.014.0	ROD BAĞLANTI KOLU	1
7	127.HZP.03	M 16 ROD	1
8	31.701.010.0	X EKSEN HAREKET PROFİLİ	1
9	31.701.011.0	X EKSEN HAREKET MİLİ	2
10	31.700.008.0	YATAKLI PUL	6
11	31.700.016.0	HAREKET AYAR LAMASI	5
12	31.700.018.0	SIKMA KELEBEĞİ	5
13	31.701.026.0	SAC KAPAK	1
14	31.709.001.0	KABLO SABİTLEME PLASTİĞİ	1
15	31.705.004.0	İZLEYİCİ YATAKLAMA PARÇASI	2
16	127.HZP.09	PİSTON KEÇESİ	2
17	31.705.001.0	PİSTON MİLİ	2
18	127.HZP.10	YAY	2
19	31.705.006.0	YATAK BURCU	2
20	31.705.002.0	HAREKET MİLİ	2
21	31.705.007.0	İZLEYİCİ UÇ	2
22	31.705.003.0	İZLEYİCİ AYAR ELCİĞİ	2
23	31.701.012.0	Y EKSEN HAREKET PROFİLİ	1
24	31.701.013.0	Y EKSEN HAREKET MİLİ	2
25	127.HZP.14	TUTAMAK KOLU	2
26	127.HZP.05	M12 TOPUZ	1
27	31.700.010.0	HAREKET KOLU	1
28	31.700.022.0	YATAKLAMA CİVATASI	1
29	127.HZP.04	HAREKETLİ ROD	2
30	31.700.009.0	AYAR GİJONU	1
31	127.HZP.07	HERTZ MOTOR	1
32	31.702.008.0	YAĞLAYICI BAĞLANTI PARÇASI	1
33	31.702.009.0	YAĞLAYICI	1
34	31.702.006.0	TALAŞ KORUMA CAMI	1
35	31.702.007.0	MOTOR FLANŞI	1
36	31.702.005.0	AMORTİSÖR BAĞLANTI PARÇASI	2
37	127.HZP.15	GAZLI AMORTİSÖR	1
38	31.700.012.0	BUTON BAĞLANTI SACI	1
39	127.HZP.06	AÇMA KAPAMA BUTONU	3
40	127.HZP.13	AYAR CİVATASI	2
41	127.HZP.30	M6 SOMUN	2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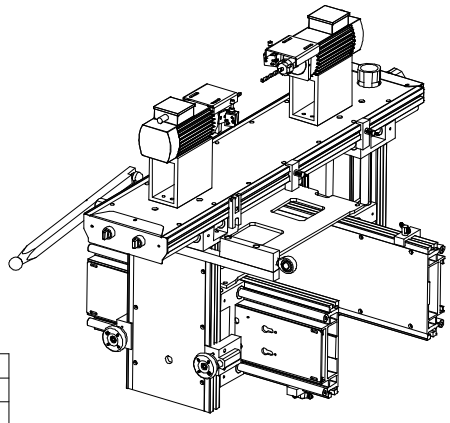

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3	31.700.020.0	AKSESUAR ŞABLONU	1
4	31.701.029.0	PROFİL BAĞLANTI LAMASI	2
5	31.701.001.0	X VE Y EKSEN RULMAN YATAĞI PROFİLİ	2
6	127.HZP.01	LME 20 UU YARIK RULMAN	24
7	31.701.027.0	Y EKSEN HAREKET PROFİLİ	2
8	31.701.028.0	Y EKSENİ HAREKET MİLİ	4
9	127.HZP.02	GAZLI AMORTİSÖR	2
10	31.701.008.0	Z EKSEN RULMAN YATAĞI PROFİLİ	2
11	31.700.007.0	HAREKET KOL BAĞLANTI LAMASI	1
12	31.700.005.0	ROD BAĞLANTI TAKOZU	1
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19	31.700.022.0	YATAKLAMA CİVATASI	1
20	31.700.010.0	HAREKET KOLU	1
21	127.HZP.05	M12 TOPUZ	1
22	31.700.011.0	BUTON BAĞLANTI SACI	1
23	127.HZP.06	AÇMA KAPAMA BUTONU	2
24	31.700.024.0	PROFİL MUHAFAZA SACI	1
25	31.709.001.0	KABLO SABİTLEME PLASTİĞİ	2
26	31.700.016.0	HAREKET AYAR LAMASI	6
27	31.700.018.0	SIKMA KELEBEĞİ	6
28	31.701.033.0	HAREKET KİLİTLEME PARÇASI	1
29	31.701.034.0	HAREKET KİLİTLEME YATAKLAMA PARÇASI	1
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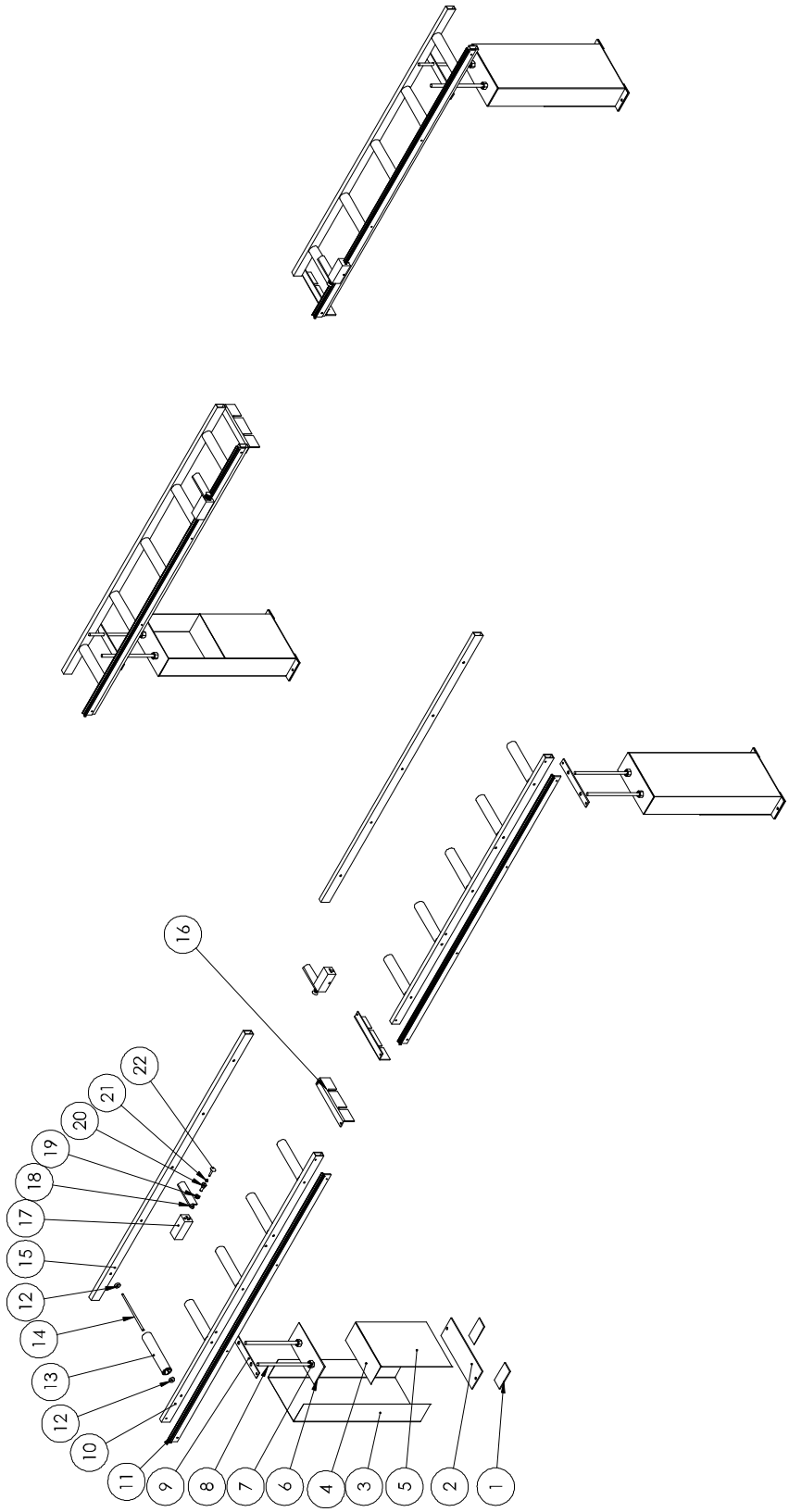
31	127.HZP.07	HERTZ MOTOR	2
32	31.702.007.0	MOTOR FLANSI	2
33	31.702.008.0	YAĞLAYICI BAĞLANTI PARÇASI	2
34	31.702.009.0	YAĞLAYICI	2
35	31.702.006.0	TALAŞ KORUMA CAMI	2
36	31.705.004.0	İZLEYİCİ YATAKLAMA PARÇASI	2
37	31.705.007.0	İZLEYİCİ UÇ	2
38	127.HZP.09	PİSTON KEÇESİ	2
39	31.705.001.0	PİSTON MİLİ	2
40	31.705.006.0	YATAK BURCU	2
41	127.HZP.10	YAY	2
42	31.705.002.0	HAREKET MİLİ	2
43	31.705.003.0	İZLEYİCİ AYAR ELCİĞİ	2
45	127.HZP.13	AYAR CİVATASI	2
46	127.HZP.30	M 6 SOMUN	2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ÖĞE NO.	PARÇA NUMARASI	PARÇA ADI	MİKT.
1	31.417.014.0	BANT AYAK TABAN ALT SACI	4
2	31.417.007.0	BANT AYAK TABAN SACI	2
3	31.417.001.0	BANT AYAK ANA SACI	2
4	31.417.006.0	BANT AYAK ARA SACI	2
5	31.417.015.0	BANT AYAK KAPAK SACI	2
6	31.417.013.0	BANT AYAK ÜST SACI	2
7	31.417.010	M 16 SOMUN	8
8	31.417.012.0	BANT BAĞLANTI SAPLAMASI	4
9	31.417.011.0	BANT AYAK BAĞLANTI	2
10	31.417.009.0	T YATAK SACI	2
11	31.417.008.0	T METRE YATAĞI	2
12	127.HZP.24	608 ZZ RULMAN	20
13	31.417.003.0	BANT RULOSU	10
14	31.417.002.0	MAKARA SAPLAMASI	10
15	31.417.005.0	T YATAK BAĞLANTI PROFİLİ	2
16	31.417.004.0	GÖVDE BAĞLANTI SACI	2
17	127.ALM.01.0	KIZAK ALUMINYUMU	2
18	127.LK.01.0	DAYAMA PARÇASI	2
19	127.YM.03.0	YATAKLAMA YÜZÜĞÜ	2
20	127.YM.01.0	M 10 CİVATA	2
21	127.HZP.05	M 6 SOMUN	2
22	127.YM.02.0	MESAFE OKUMA PARÇASI	2