

GARANTİ BELGESİ

İMALATÇI FİRMA : YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş
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İMZA-KAŞE :

ÜRÜNÜN CİNSİ : PVC KÖŞE TEMİZLEME MAKİNESİ
MARKASI : YILMAZ
MODEL KODU : CA 601
BANDROL/SERİ NO :
TESLİM TARİHİ :
GARANTİ SÜRESİ : 2 YIL
AZAMI TAMİR SÜRESİ : 30 İŞ GÜNÜ

YETKİLİ SATICI FİRMA :
ADRES :
TELEFON :
TELEFAX :
İMZA-KAŞE :

EC Declaration of Conformity

MANUFACTURER : *YILMAZ MACHINERY INDUSTRY &TRADE CO*
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tel: +90 0216 312 2828 fax: +90 0216 484 42 88
yilmaz@yilmazmachine.com.tr

Declare on our own responsibility that ;

CA 601 PVC CORNER CLEANING MACHINE


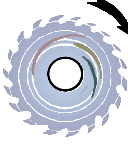
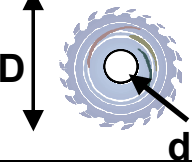

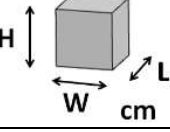


SERIAL NO;



Meets all the provisions of the 2006/42 EC Machinery Directive, 2006/95 EC Low Voltage Directive, and 2004/108 EC EMC Directive which apply to it



Place / Date

Authorized

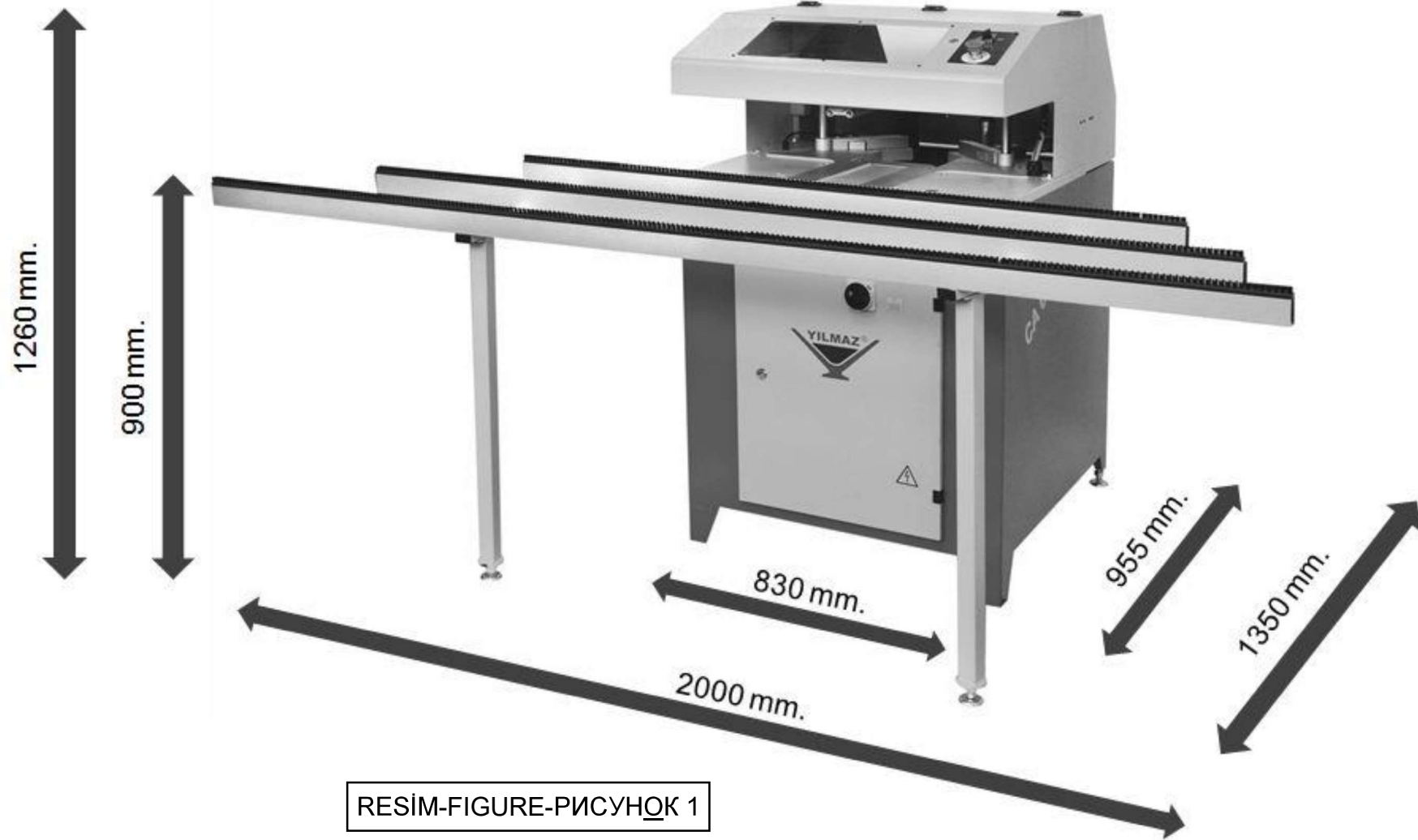
TEKNİK ÖZELLİKLER - TECHNICAL FEATURES - ТЕХНИЧЕСКИЕ ОСОБЕННОСТИ

									
CA 601	860 W 50 Hz 230 V AC P N PE	1200 W 50 Hz 400 V AC 3P PE	3000 D/dak. RPM	D = 215 mm max. d = 32 mm	6/8 Bar	36 Lt. / dak. Lt/min	W = 92 L = 101 H = 143	198	249

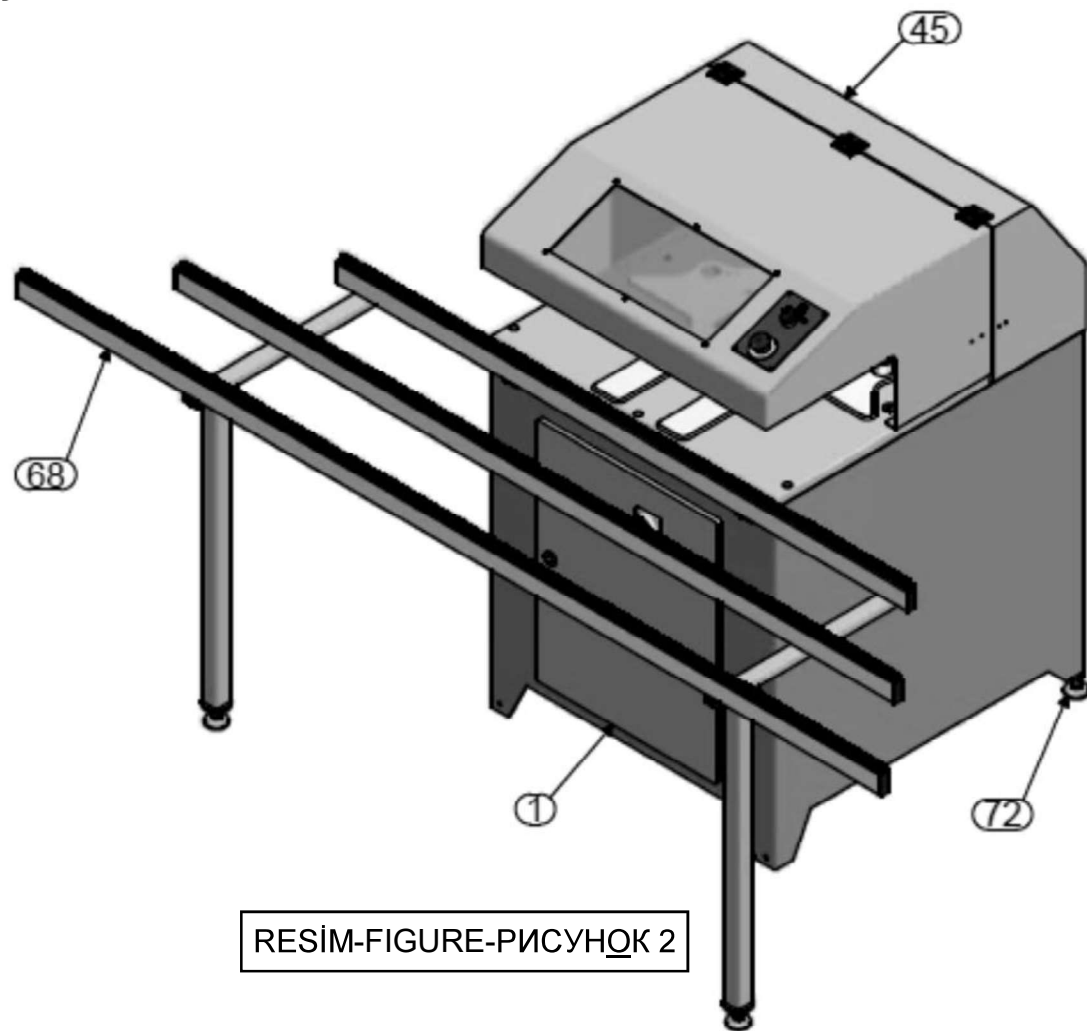
 YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş. Turgut Özal Bulvarı.No:173 Tasdelen 34788 Çekmeköy İSTANBUL-TÜRKİYE Tel: +90 (216) 312 28 28 (Pbx) Fax: +90 (216) 484 42 88 web : www.yilmazmachine.com.tr e-mail: yilmaz@yilmazmachine.com.tr					
MODEL TYPE MODEL	CA 601	RATED CURRENT NOMINAL AKIM	4,6 A		
SERIAL NO SERİ NO		IDLING REV. DEVİR SAYISI	3000 RPM		
PROD.DATE ÜRETİM TAR.		AIR CONSUMP. HAVA TÜKETİMİ	36 Lt / min		
TOTAL POWER TOPLAM GÜÇ	860 W	AIR PRESSURE HAVA BASINCI	6-8 BAR		
RATED VOLTAGE NOMİNAL GERİLİM	230V AC P N PE	WEIGHT AĞIRLIK	198 KG		

 YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş. Turgut Özal Bulvarı.No:173 Tasdelen 34788 Çekmeköy İSTANBUL-TÜRKİYE Tel: +90 (216) 312 28 28 (Pbx) Fax: +90 (216) 484 42 88 web : www.yilmazmachine.com.tr e-mail: yilmaz@yilmazmachine.com.tr					
MODEL TYPE MODEL	CA 601	RATED CURRENT NOMINAL AKIM	3,6 A		
SERIAL NO SERİ NO		IDLING REV. DEVİR SAYISI	3000 RPM		
PROD.DATE ÜRETİM TAR.		AIR CONSUMP. HAVA TÜKETİMİ	36 Lt / min		
TOTAL POWER TOPLAM GÜÇ	1200 W	AIR PRESSURE HAVA BASINCI	6-8 BAR		
RATED VOLTAGE NOMİNAL GERİLİM	400V AC 3P PE	WEIGHT AĞIRLIK	198 KG		

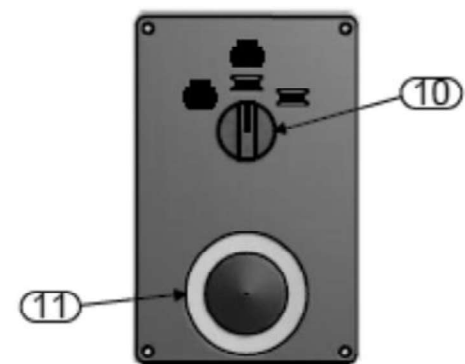
BOYUTLAR – DIMENSIONS – РАЗМЕРЫ



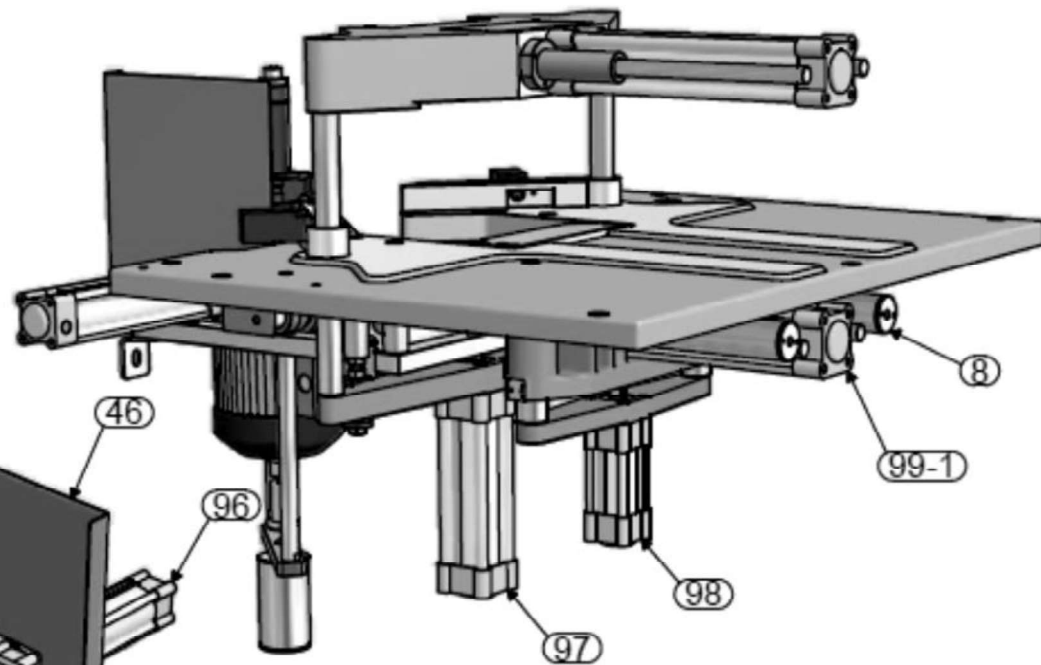
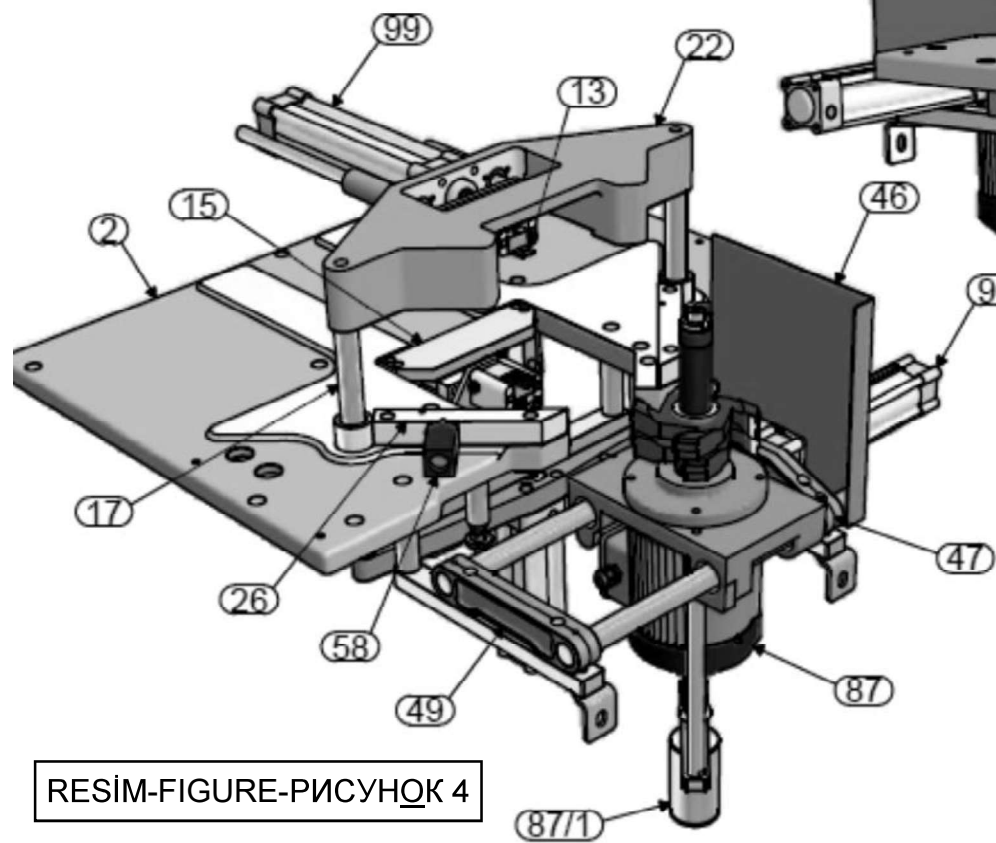
PARÇA LİSTESİ - PART LIST - ПЕРЕЧЕНЬ ДЕТАЛЕЙ

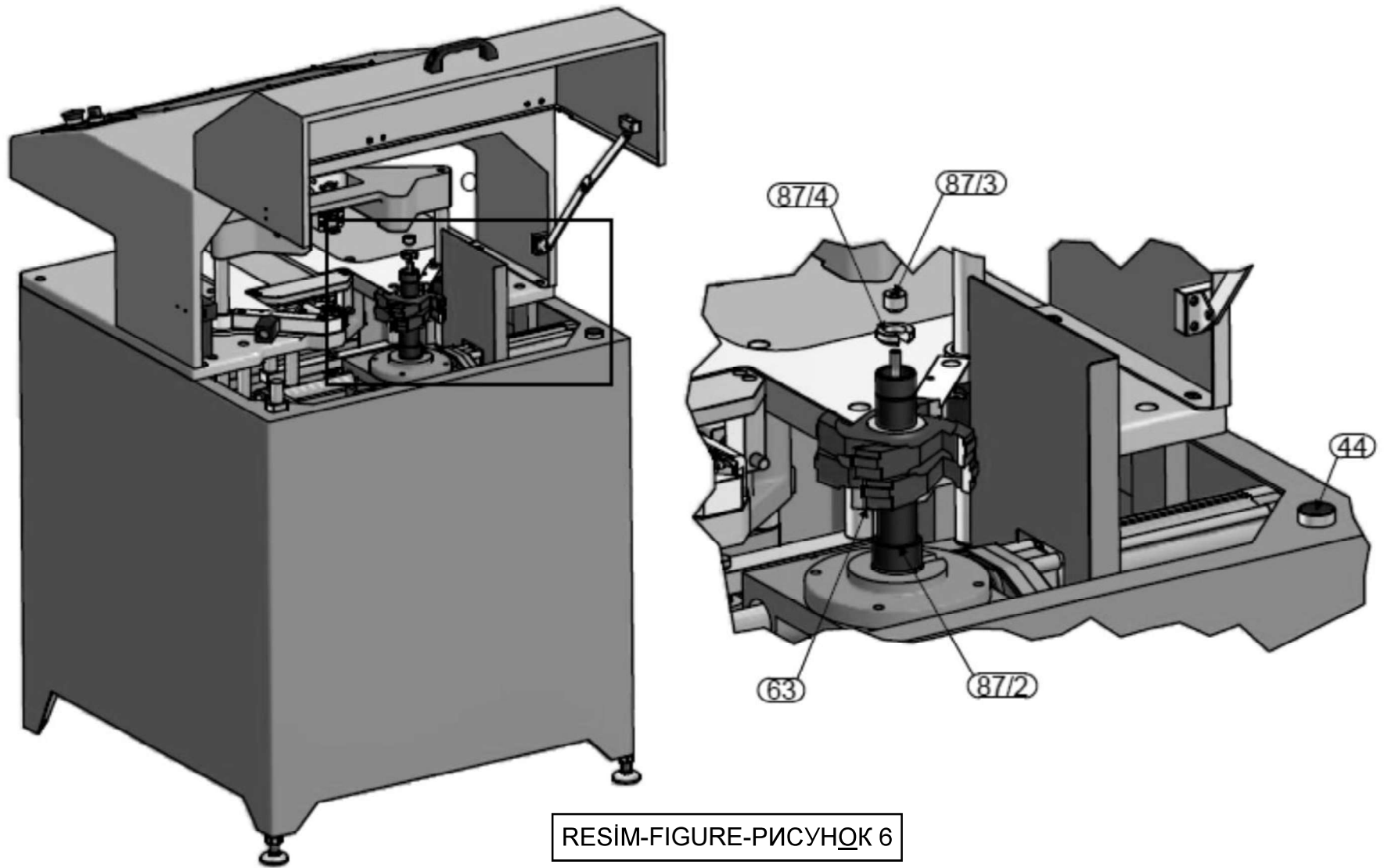


RESİM-FIGURE-РИСУНОК 2







RESİM-FIGURE-РИСУНОК 3





RESİM-FIGURE-ПИСУНОК 6

NO номер	STOK KODU STOCK CODE ПОРЯДОК КОД	ADET QTY КОЛИЧЕСТВО	NO номер	STOK KODU STOCK CODE ПОРЯДОК КОД	ADET QTY КОЛИЧЕСТВО
1	1SA010000-0053	1	87	3UA630030-0003	1
2	2TU012510-0328	1	87-1	3UA140030-0007	1
8	3UA060030-0014	2	87-3	2TU011110-0042	1
13	1SK060000-0004	2	87-4	2TU011110-0040	1
15	2TU011210-0474	1	96	1PN020000-0131	1
17	2TU014010-0116	1	97	1PN020000-0132	1
22	2TU012510-0332	1	98	1PN020000-0129	1
26	2TU012210-0054	1	99	1PN020000-0143	1
46	1SA050000-0185	1	99-1	1PN020000-0143	1
47	2TU012510-0337	1			
49	2TU012510-0338	1			
63	2TU011110-1101	1			
72	1SC170000-0007	1			

YEDEK PARÇA LİSTESİ / SPARE PART LIST / СПИСОК ЗАПАСНЫХ ЧАСТЕЙ			
PARÇA NO PART NO НОМЕР	RESİM PICTURE РИСУНОК	STOK KODU / CODE ПОРЯДОК КОД	PARÇA ADI – PART NAME НАИМЕНОВАНИЕ ДЕТАЛИ
1		1EL020000-0012	SWITCH XCKN2102G11 (LİMİT SWITCH) ВЫКЛЮЧАТЕЛЬ
2		1EL060000-0410	TERMİK T16-5.7 (4.2-5.7A) ABB THERMİK ТЕРМИЧЕСКИЙ
3		1EL040000-0405	KONTAKTÖR ASL09-30-10-81 (24V DC 50-60) CONTACTOR КОНТАКТОР
4		1EL090000-0001	XB4-BS8442 ACİL STOP BUTONU EMERGENCY STOP BUTTON КНОПКА АВАРИЙНОЙ ОСТАНОВКИ

5		1EL090000-0010	<p>XB4-BD33 SEÇMELİ BUTON SELECTIVE BUTTON КНОПКА СЕЛЕКТИВНЫЙ</p>
6		1EL180000-0042	<p>TRAFO 85349 24V DC/1 A 24W (+15 - 0- -15 -230 -400) TRANSFORMER ТРАНСФОРМАТОР</p>
7		1EL200000-0037	<p>SENSÖR RZT6-03ZUS-KWO NO (1025522) (SICK) SENSOR ДАТЧИК</p>
8		1SK060000-0004	<p>KAZIMA BIÇAĞI-ÇIKINTILI SCRAPER CUTTER СКРЕБОК РЕЗАК</p>

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1. GENERAL INFORMATION

1.1. Introduction

The user's manual given by the manufacturer contains necessary information about the machine parts. Each machine operator should read these instructions carefully, and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following the instructions contained in this manual. The technical drawings and details contained in this manual constitute a guide for the operator.

1.2. Service Information

In case of any technical problem please contact your nearest YILMAZ dealer, or YILMAZ head office through the above mentioned phone, fax or e-mail address.

Technical labels with the model description of the machine are fixed onto the front side of each machine.

The machine's serial number and manufacturing year are stipulated on the technical label.

Average life usage of production is 10 years. If you have any further failure and complaint, please inform to our below mentioned technical service by verbal or written

AUTHORIZED TECHNICAL SERVICE CENTER ADDRESS

TAŞDELEN MH. ATABEY CD. No 9 34788 ÇEKMEKÖY – İSTANBUL / TÜRKİYE

Tel 0216 312 28 28 Pbx.

Fax 0216 484 42 88

E-mail service@yilmazmachine.com.tr













Web www.yilmazmachine.com.tr

For minimize the documantation, It is wery necessary to mention below details at the agreements signed with suppliers and dealers of the purchased machines

- | | |
|------------------------------------|--|
| • Machine model | • Voltage and frequency |
| • Machine's serial number | • Date of purchase |
| • Description of the machine fault | • Name of dealer where machine was purchased |
| • Average daily operation period | |

2. SAFETY

2.1. Safety Symbols and Their Meanings

	Read the user guide		Ensure safe working position, always keep your balance.
	Wear ear protectors		Elektrical excitation
	Wear safety goggles		Don't place your hands between parts in motion..
	If the power cable should be damaged during operation, don't touch and unplug it. Never use damaged power cables.		High temperature warning
	During saw blade change operations, use protective gloves		Keep your fingers clear of the movable parts of the glide arm.
	The above symbol DANGER WARNING , warns you against specific dangers, and you have definitely to read them..		The IMPORTANT symbol above is one telling to apply special care and to be careful at carrying out the specified operation

2.2. Accidents Prevention

- 2.2.1** Our machines are manufactured in accordance with CE safety directives, which cover national and international safety directives.
- 2.2.2** It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.
- 2.2.3** It is the task of the employer to warn his staff against accident risks, to train them on prevention of accidents, to provide for necessary safety equipment and devices for the operator's safety.
- 2.2.4** Machine should be operated only by staff members, who have read and understood the contents of this manual.
- 2.2.5** All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty

2.3. General Safety Information

- 2.3.1** The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care has to be taken regarding the inlet and outlet sockets
- 2.3.2** Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance with the stipulated values.
- 2.3.3** Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The lighting of indoor work system)

- 2.3.4** Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The lighting of indoor work system)
- 2.3.5** Don't use any materials other than those recommended by the manufacturer for cutting operations on the machine.
- 2.3.6** Ensure that the work piece is clamped appropriately by the machine's clamp or vice
- 2.3.7** Ensure safe working position, always keep your balance.
- 2.3.8** Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let it replace by a qualified electrician. Keep handles and grips free of any oil and grease.
- 2.3.9** Unplug first, before conducting and maintenance works.
- 2.3.10** Ensure that any keys or adjustment tools have been removed before operating the machine..
- 2.3.11** If you are required to operate the machine outside, use only appropriate extension cables.
- 2.3.12** Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur.
- 2.3.13** Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer).
- 2.3.14** Don't use machines with improper functioning buttons and switches
- 2.3.15** Don't keep flammable, combustive liquids and materials next to the machine and electric connections.

3. MACHINE'S DESCRIPTION

After welding clean up down and corner sides of 90° PVC Profiles after welding.

- Adjustable to different PVC profile types
- Equipped with centralizing guide ensuring correct placement of profiles onto the set square.
- Stops automatically after the corner cleaning operation.
- Maximum profile processing height is 130 mm. (1165 mm profile processing height is provided as option)
- PLC System, with serial change of blade groups.

STANDARD ACCESSORIES	OPTIONAL ACCESSORIES
Air Gun	
Stand	
User's manual	

4. TRANSPORT OF THE MACHINE

IMPORTANT

4.1. The transport should be done by qualified personnel only.

4.2. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).

4.3. Unless customer requests the contrary, the machine will be delivered with wooden packaging.

4.4. Movable parts on the machine should be fixed before carrying out the transport.

4.5. The machine size and weight measurements, given the technical specification sheet.

5. INSTALLATION OF THE MACHINE

5.1 Preparation

- 5.1.1 The machine size and weight measurements, given the technical specification sheet. The ground, where the machine will be placed, should be even, solid enough to bear the weight of the machine
- 5.1.2 The machine should be located approx. 50 cm away from the rear wall
- 5.1.3 You can provide the balance of the machine with adjustable counterforts (PICTURE 2 NO 72) in the bottom part.
- 5.1.4 Tie the table of machine given as standard accessory on the front surface of the chassis. Apply the definition below step by step for the assembly of the table.



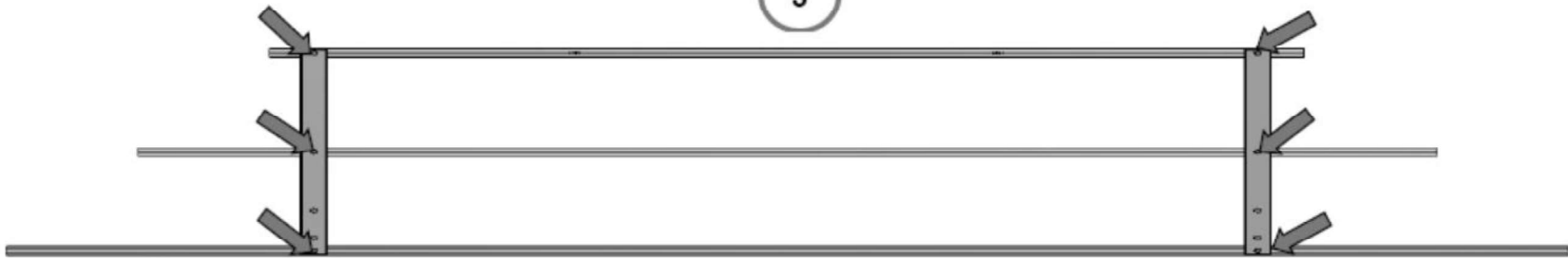
Disassembled View

2



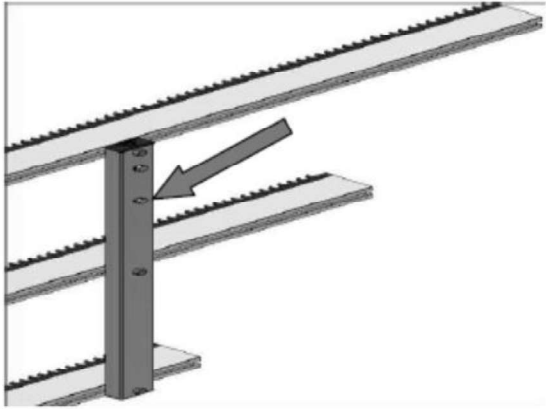
Table structure is stretched to position the leg connection profiles perpendicular to the table profiles.

3



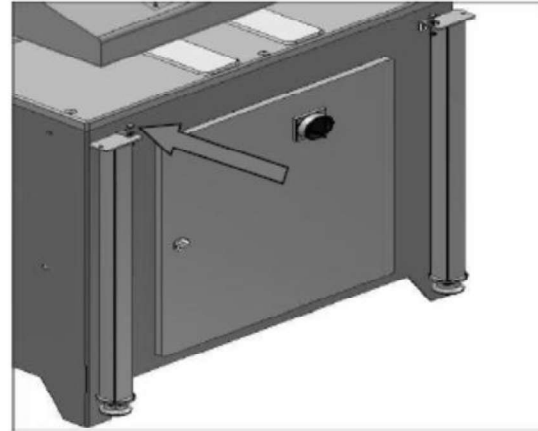
Profile fixing bolts are tightened with the help of 10mm wrench.

4



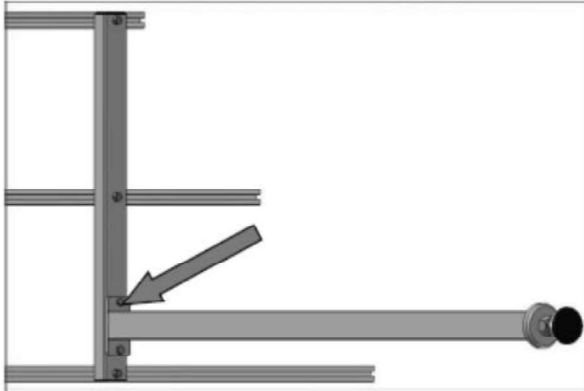
Take out the two M6 bolts shown at the figure

5



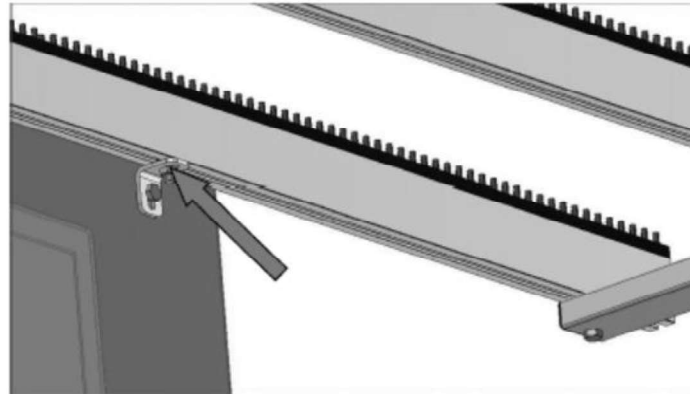
Take out the two M6 bolts and nuts shown at the figure where the two legs have been connected for transportation purposes.

6



Connect the two legs to their shown places with the help of the bolts which are taken out for transportation purposes.

7



At the last step, fix the the table structure to the chassis of the machine with the nuts taken out for transportation purposes to the slot bolts in the profile slot.

5.2 Connecting to Power Source

5.2.1 The Electrical connection must be made by a licensed electrician

5.2.2 The power outlet socket on the machine should be available.

5.2.3 Plug the machine to a grounded socket.

5.2.4 Main voltage of the machine is optional as 230 V 50 Hz or 400 V 50 Hz.



5.2.5 Check the power source voltage. It has to be in accordance with the values stipulated on the machine's type label

5.2.6 After electrical connection is made, machine must be operated in idle running and it must be controlled whether rotation directions of cutting tools are correct or not and if the rotation direction is wrong, appropriate connection must be made

6. MACHINE SAFETY INFORMATION

6.1 Lifting, installation, electric maintenance of the machine should be carried out by qualified personnel only.

6.2 Routine maintenance and scheduled maintenance should be carried out by qualified personnel after unplugging the machine and disconnecting the air supply first.

6.3 Ensure that the machine has been cleaned, tested and maintain before starting to operate.

6.4 Check the safety devices, power cable and moving parts regularly. Don't operate the machine before having replaced defective safety devices or faulty parts.

6.5 Never replace the milling cutters before unplugging first.



6.6 Keep foreign materials away from the working area of the machine, keep away from the machine's moving parts

6.7 Do not work on the machine by removing the protective parts



The safety data have been defined above. In order to prevent physical damage or damage to the equipment, please read the safety information carefully and keep the manual always in an easy accessible place.

7. OPERATION

7.1 Preparation

7.1.1 Degrease and dry the machine table. Especially ensure that the holding grips and handles are clean and dry



7.1.2 Clean all surfaces of the machine from chip and foreign particles. Use eye glasses for protection.

7.1.3 Control whether cutting tools (FIGURE 6 NO: 63) are inserted safely to their places.

7.1.4 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them.

7.1.5 Cutting tool must process on the part after machine is operated and cycled.

7.2 Operation

7.2.1 Switch the system start switch to “1”

7.2.2 Select the necessary operation through the position selection button (FIGURE 3 NO.10).

7.2.3 Put the boiled profile on the plate and justify it properly on the switches (PICTURE 4 NO.58) on set-square (PICTURE 4 NO.26). Clamp will automatically fix the profile.

7.2.4 The machine will carry out the cleaning operation and stop.

NOTE: Press emergency button at the moment of potential danger RESİM 3 NO.11)



The milling cutters have to be started freely, without touching the profile. They have to start to rotate first before making the milling operation.

8. MAINTENANCE, SERVICE AND REPAIR

8.1 Maintenance

8.1.1 Cut the electric and pneumatic power connections of the machine.

8.1.2 Clean all surfaces of the machine from burs, chips and foreign substances. If the machine will not be used for a long time, lubricate undyed parts with oil that prevents rusting.

8.1.3 When cleaning the machine, do not use materials that may damage the dye.

8.1.4 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them..

8.1.5 Before using cutting tool, operate the machine out of gear and control whether it is inserted correctly, it is without flexure and it is inserted appropriately. Do not use cutting tools that are damaged or lost its functionality.

8.1.6 If the sawteeth are blunted, change immediately with a new / sharpened saw.

8.1.7 Sharpen with proper sharpening machines by taking the angular value of the saw into consideration.,

8.2 Changing the cutting tool



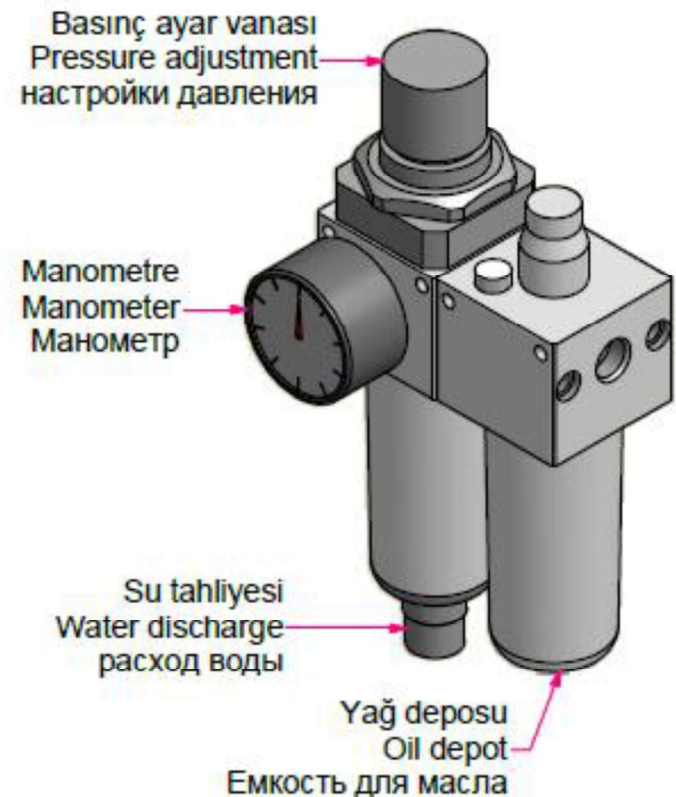
- 8.2.1 Use protective gloves when replacing Saw
- 8.2.2 Cut the electric connection of the machine.
- 8.2.3 Open the upper protection cover. (FIGURE 2-NO: 45)
- 8.2.4 Push the blade-changing button (FIGURE 6 NO: 44). Bearing tightening the saw group will go up (FIGURE 6 NO: 87/3). Take the idle tightening bearing and take out the saw group. Mount the saw group, prepared according to the profile to be processed, on the shaft. Push the blade-changing button again and mount the tightening bearing that you took off.

IMPORTANT

WHEN REPLACING THE MILLING CUTTER GROUP, ENSURE THE CUTTERS ROTATE IN THE CORRECT DIRECTION

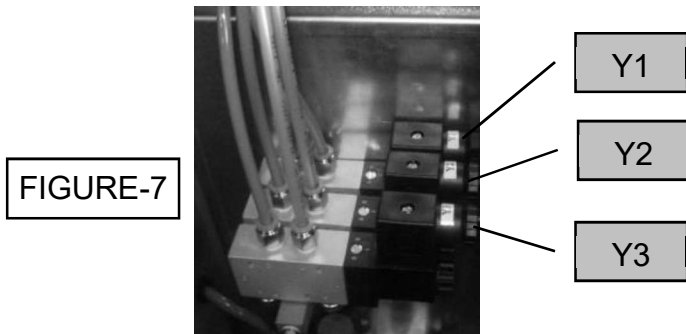
8.3 Adjust the air pressure (pneumatic systems)

- 8.3.1 Pull up pressure adjustment valve. Set adjustment valve to the desired value on manometer by turning it clockwise or counter clockwise. Then lock the valve by pressing it down.
- 8.3.2 Set the air pressure between 6 and 8 BAR. If air pressure drops below the stated values, accessories operating with pneumatic power do not work.
- 8.3.3 Conditioner unit accumulates the water in the air in the collection container so that it won't damage pneumatic components. At the end of the working day, empty the accumulated water by opening water discharge valve under the collection container
- 8.3.4 In order to put oil to the oil tank, remove the reservoir by turning. Oils recommended by the manufacturer are; ; TELLUS C10 / BP ENERGOL HLP 10 / MOBIL DTE LIGHT / PETROL OFİSİ SPINDURA 10.



9. TROUBLESHOOTING GUIDE

Here are some recommendations for solving urgent problems. If the trouble cannot be solved, or if you have a problem other than those described hereunder, please contact our technical service or your nearest dealer.



Y1	Provide clamps movement
Y2	Provide scratching cutters movement .
Y3	Provide engine movement

9.1. If stop warning seen on the display



Press ok button the screen below appears



Run prog.using up / down arrow buttons, point out run / stop and press Menu / OK button.



Using up / down arrow buttons point out yes command pressing Menu / OK Button your system passes the run mode.

9.2. Error notices on display

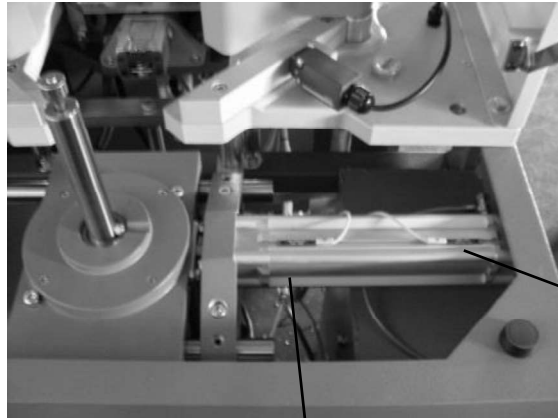
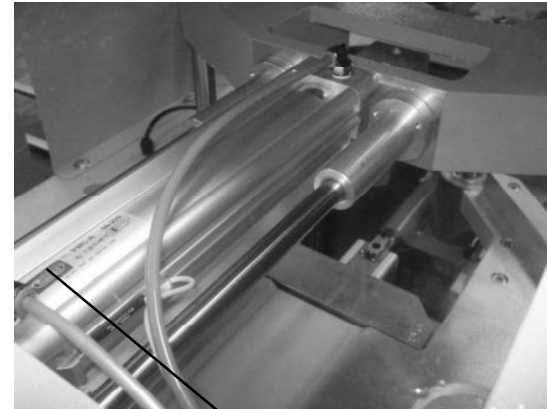


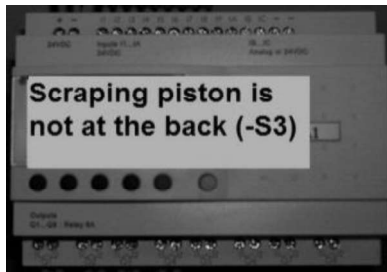
FIGURE-9

Motor Piston Ahead Sensor S7

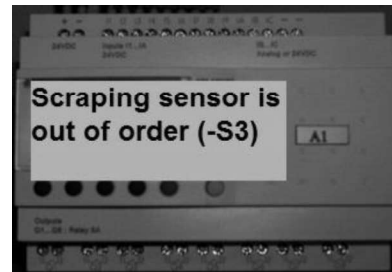
Motor Piston at back Sensor S4



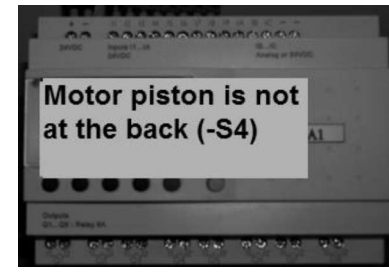
Top Tearing Piston Sensor (-S3)



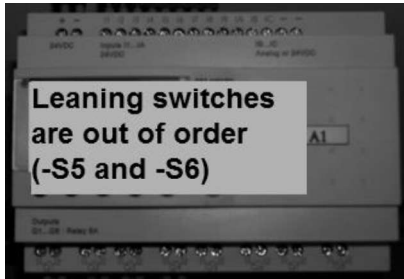
Scraping piston is not at the back (-S3) ;
Insufficient air pressure or Y2 valve may remain affixed



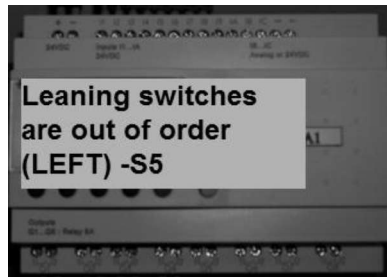
Scraping sensor is out of order (-S3) ;
Change S3 tearing piston sensor



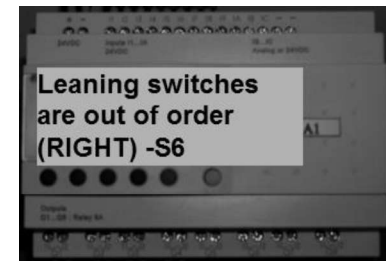
Motor piston not at the back (-S4) ;
Insufficient air pressure or Y3 valve may remain affixed



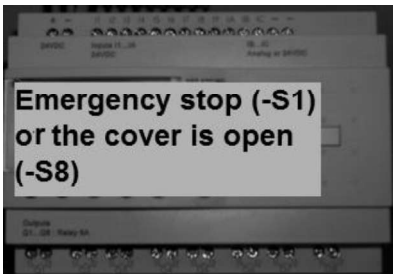
Leaning switches are out of order (-S5 and -S6) ; Change switches



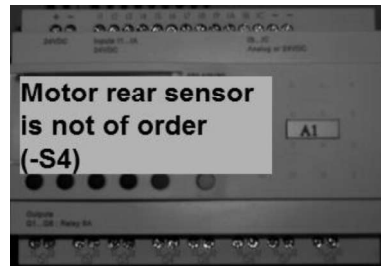
Leaning switches are out of order (LEFT) (-S5) ; Change left set square switch



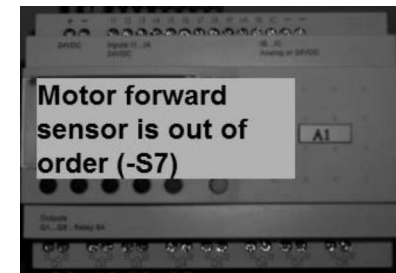
Leaning switches are out of order (LEFT) (-S6) ; Change right set square



**Emergency stop (-S1) or the cover is open(-S8)
Change emergency button whether pushed or top cover whether opened**



Motor rear sensor is out of order (-S4) ; Change the sensor



Motor forward sensor is out of order (-S7); Change the sensor

10. WARRANTY CONDITIONS

YILMAZ Machine Industry and Trade Limited Company, guarantees that all machines have been tested and conform to the international standards.

The guarantee is valid 24 months from despatch date and does not cover the electrical parts of the machine.

During this period:

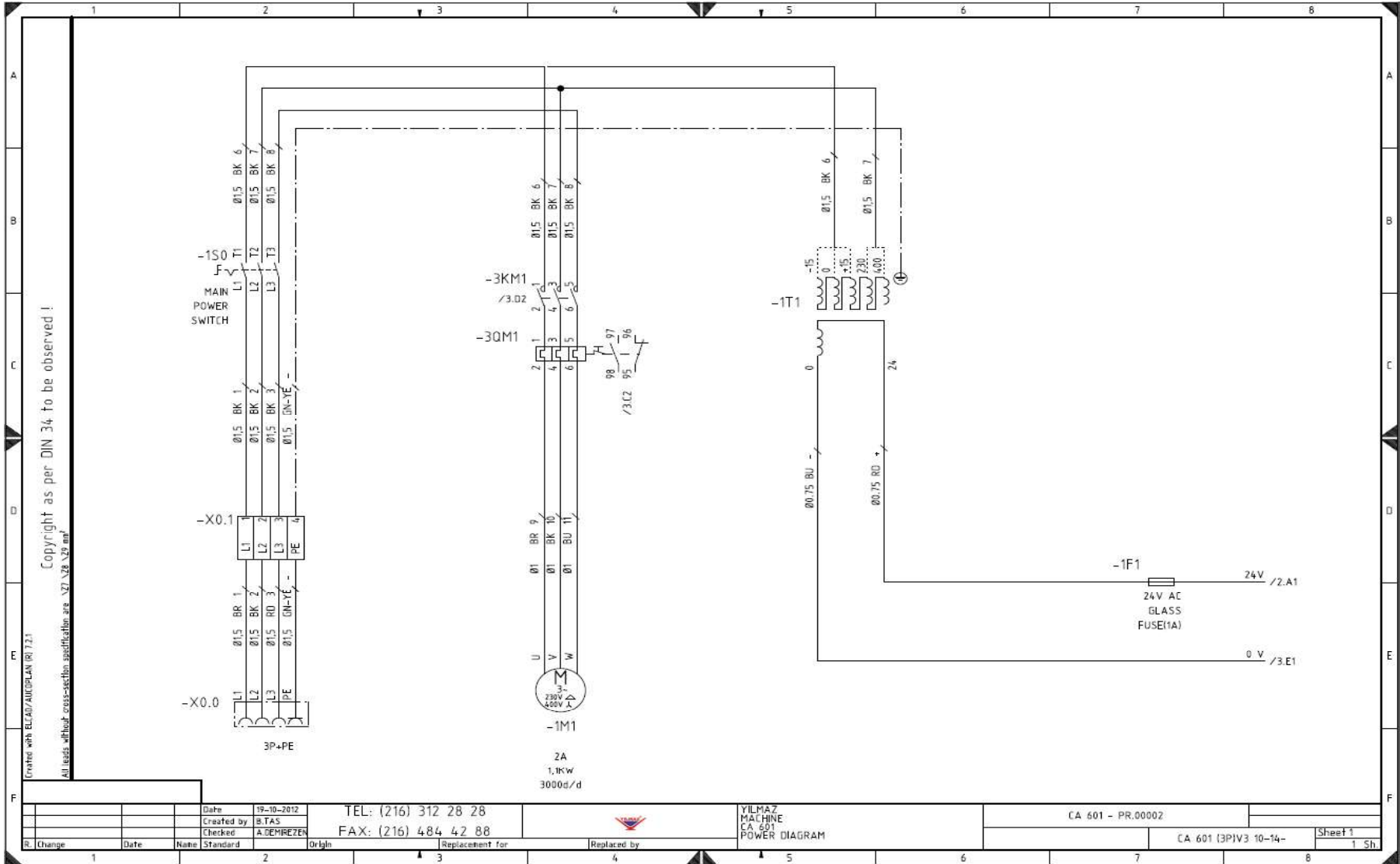
- Any repair and replacement effected at our workshop is completely free of charge (only transport costs are at customer's charge).
- For repair and replacement effected by our technician at the customer's site, we will invoice only the travel and lodging costs for our technician.

The guarantee does not cover damages caused by:

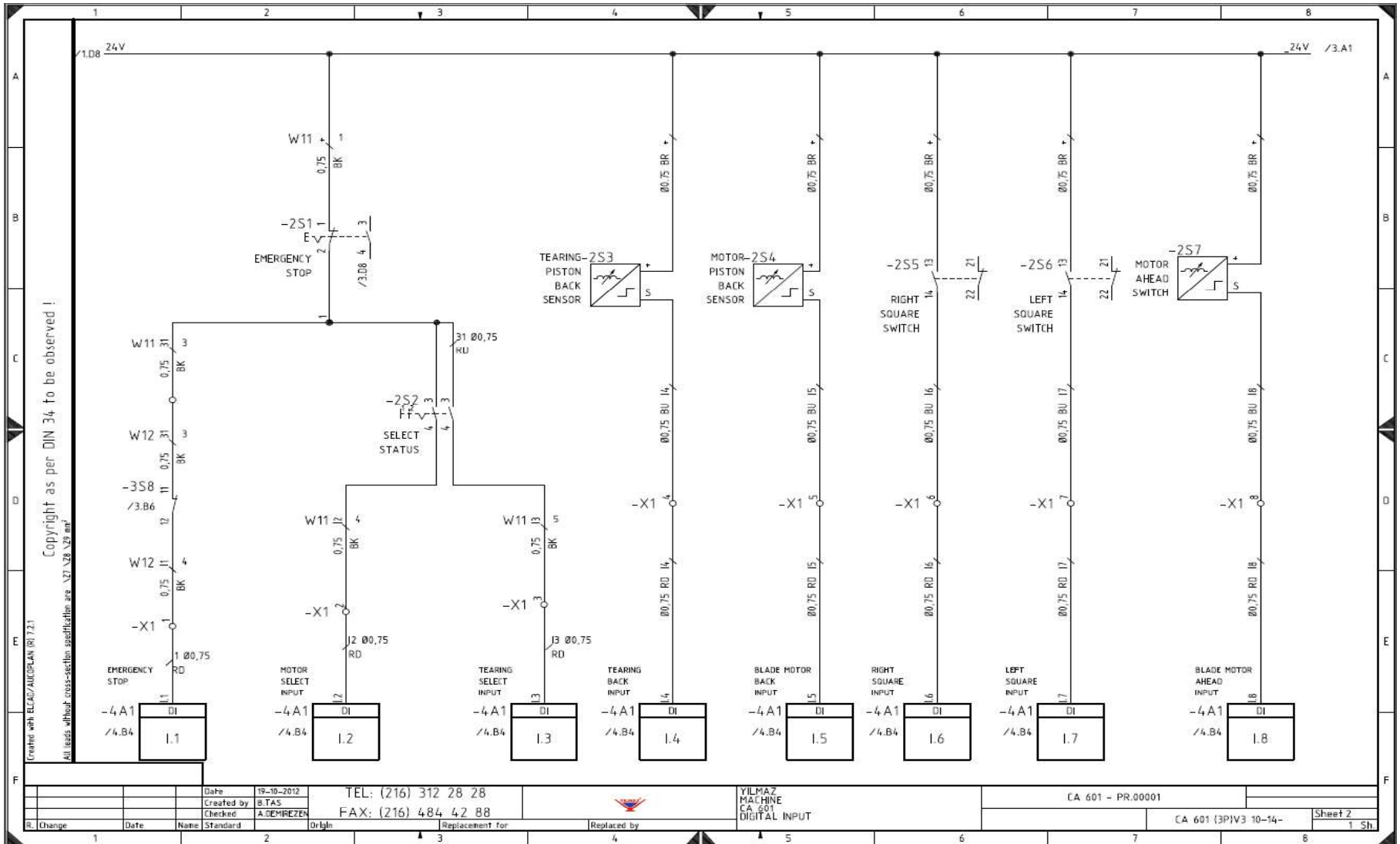
- not respect of the rules indicated in the manual instruction book
- not correct voltage
- improper use or use not in accordance with what the Machine has been designed for
- use of non original tooling
- programming errors
- lack of cleaning and of ordinary maintenance by the customer
- transport or displacement (even inside the workshop)
- natural events (lightings, fires, floods)

The warranty does not cover, in any case, damages caused by the malfunction of the Machine

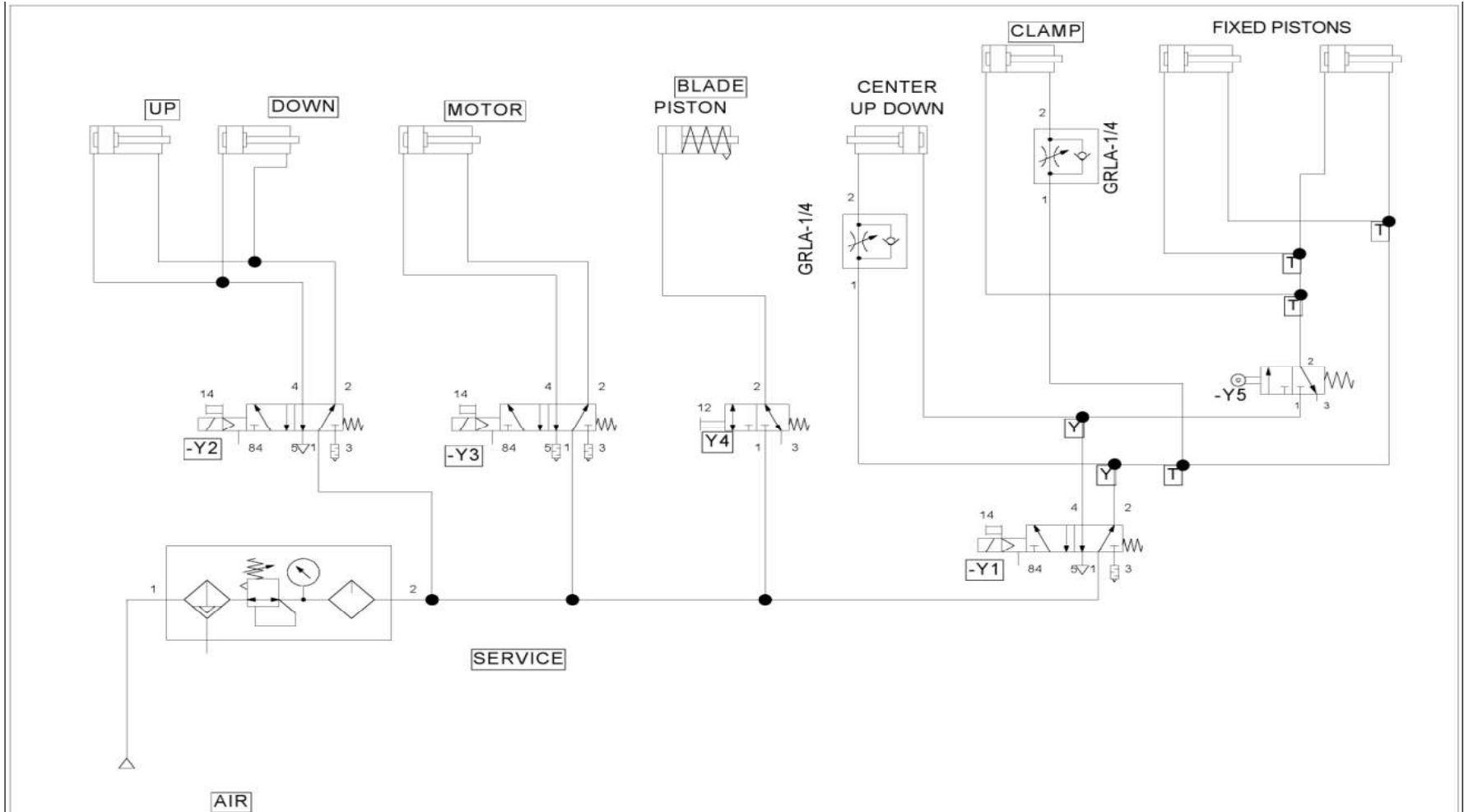
ELECTRIC&PNEUMATIC DIAGRAM



3 PHASE ELECTRICAL DIAGRAM SHEET 1



3 PHASE ELECTRICAL DIAGRAM SHEET 2



Aenderung	Datum	Name	Datum	Name	Benennung:	Zeichnungs-Nr.	Anlage	Blatt Nr. von	SHEET: 1 19.12.2012
a			gez.	O.BATAL	YILMAZ MAKINA - PNEUMATIC DIAGRAM CA 601 YENI V4	1	Ort		
b			gepr.	A.DEMIR					
c									
d									

PNEUMATIC DIAGRAM SHEET 1