
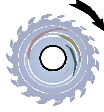
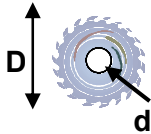
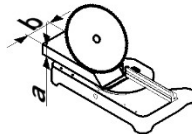
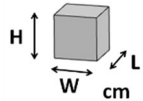








Luna Machinery

Aluminium Machinery & Accessories

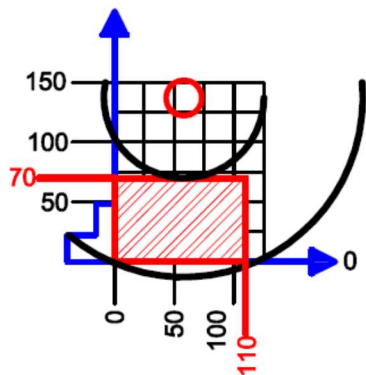
KY KD 310 - TECHNICAL FEATURES

							
KD 310	800 W 50 Hz 230 V AC N PE	3000 dev/dak. RPM	D = 300 mm d = 30 / 32 mm	--	W = 63 L = 52 H = 48	26 kg	29 kg
KY 310	800 W 50 Hz 230 V AC N PE	3000 dev/dak. RPM	D = 300 mm d = 30 / 32 mm	a : 50 mm b : 130 mm	W = 63 L = 52 H = 48	26 kg	29 kg

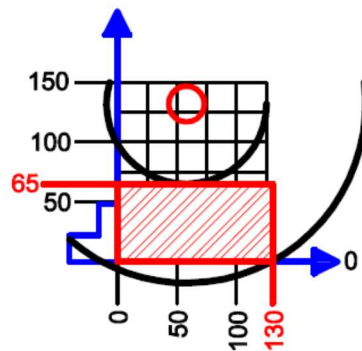
 YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş Taşdelen Mh. Atabey Cd. No 9 34788 Çekmeköy İSTANBUL-TÜRKİYE Tel: (0216) 312.28.28 (PBX) – FAX: (0216) 484.42.88 Web : www.yilmazmachine.com.tr e-mail: yilmaz@yilmazmachine.com.tr			
MODEL TYPE MODEL	KD 310	RATED CURRENT NOMINAL AKIM	3,4 A
SERIAL NO SERI NO		IDLING REV. DEVİR SAYISI	3000 RPM
PROD. DATE ÜRETİM TAR.		SAW DIAMETER TESTERE ÇAPı	Ø300 mm
TOTAL POWER TOPLAM GÜÇ	800 W		
RATED VOLTAGE NOMINAL GERİLİM	230V AC N PE	WEIGHT AĞIRLIK	29 KG.

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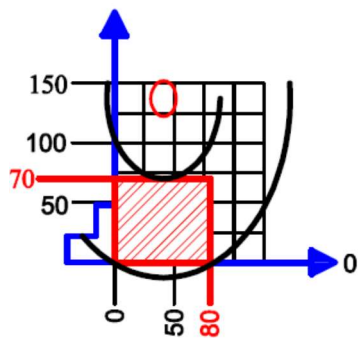
CUTTING DIAGRAM



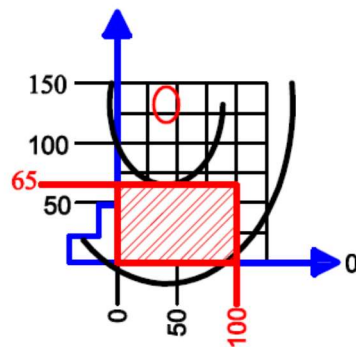
90° : 110 x 70 mm.



90° : 130 x 65 mm.

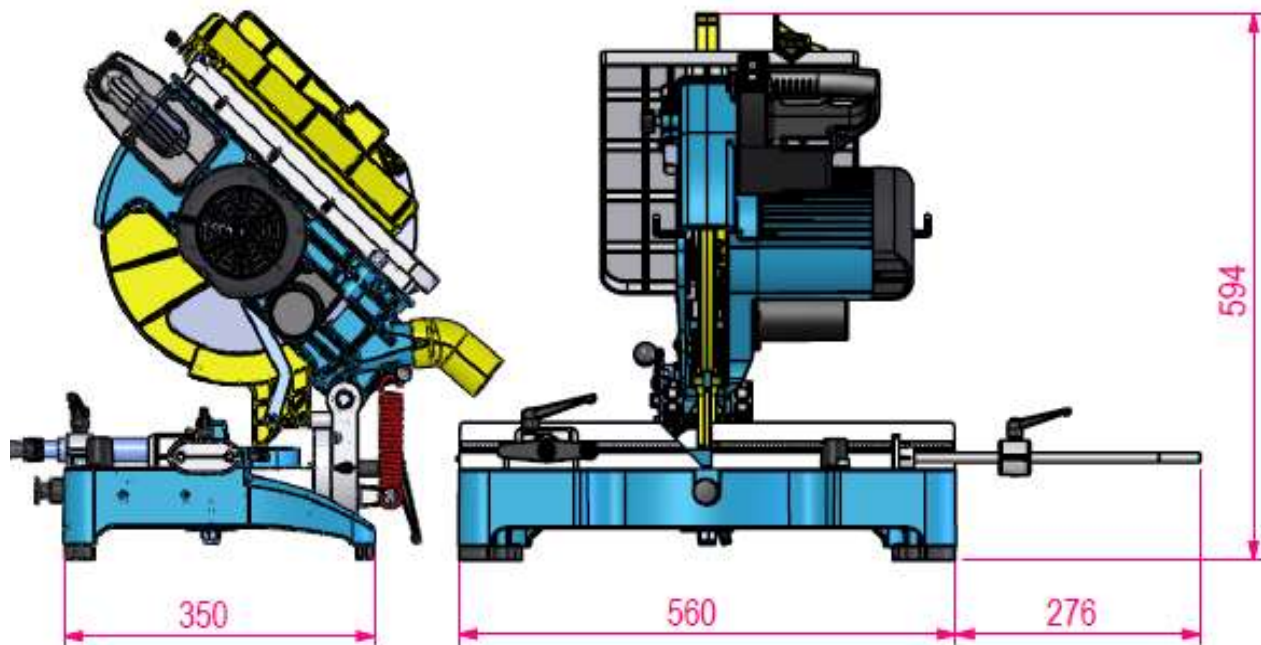


45° : 80 x 70 mm.

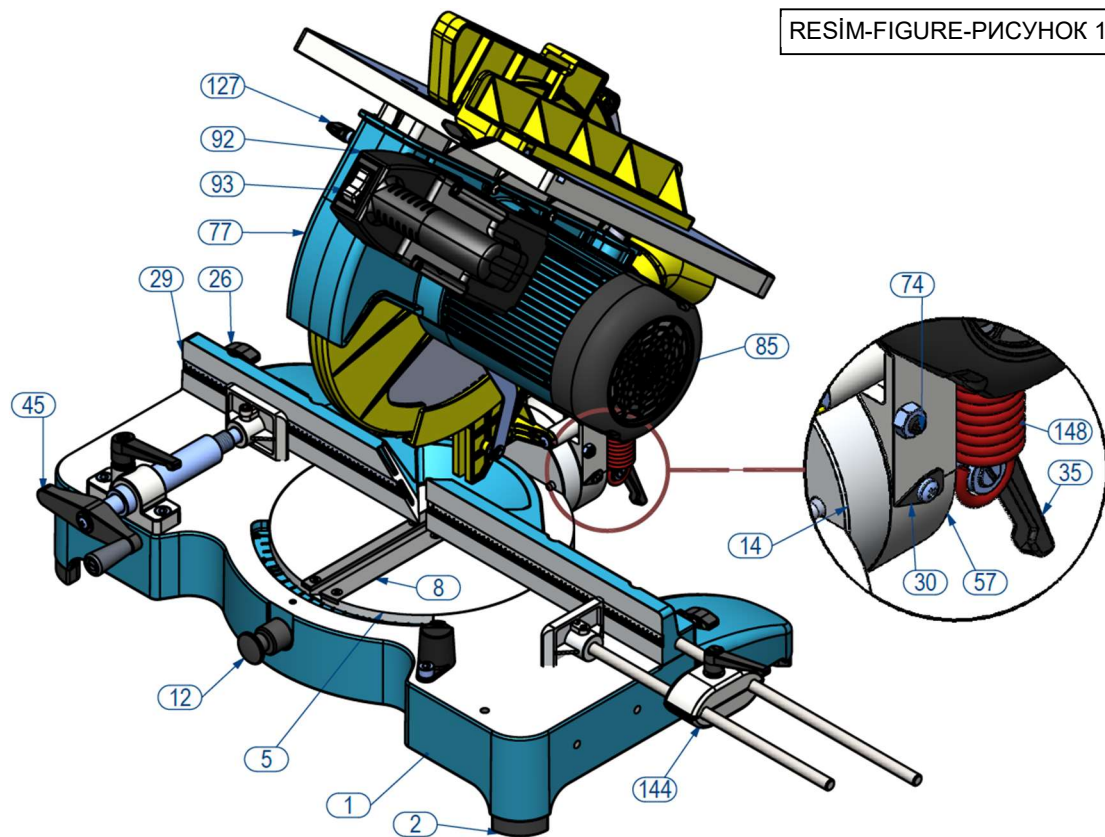


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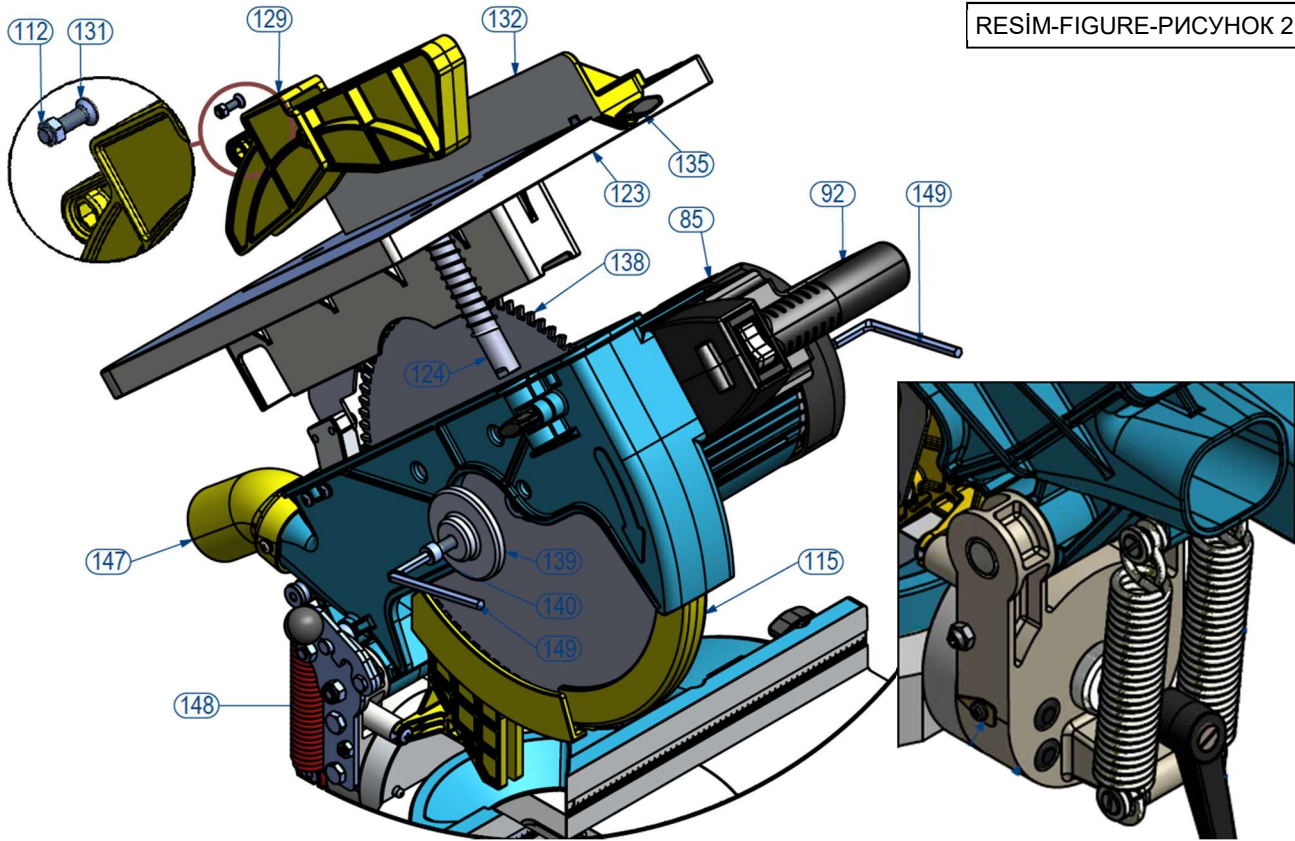
DIMENSIONS



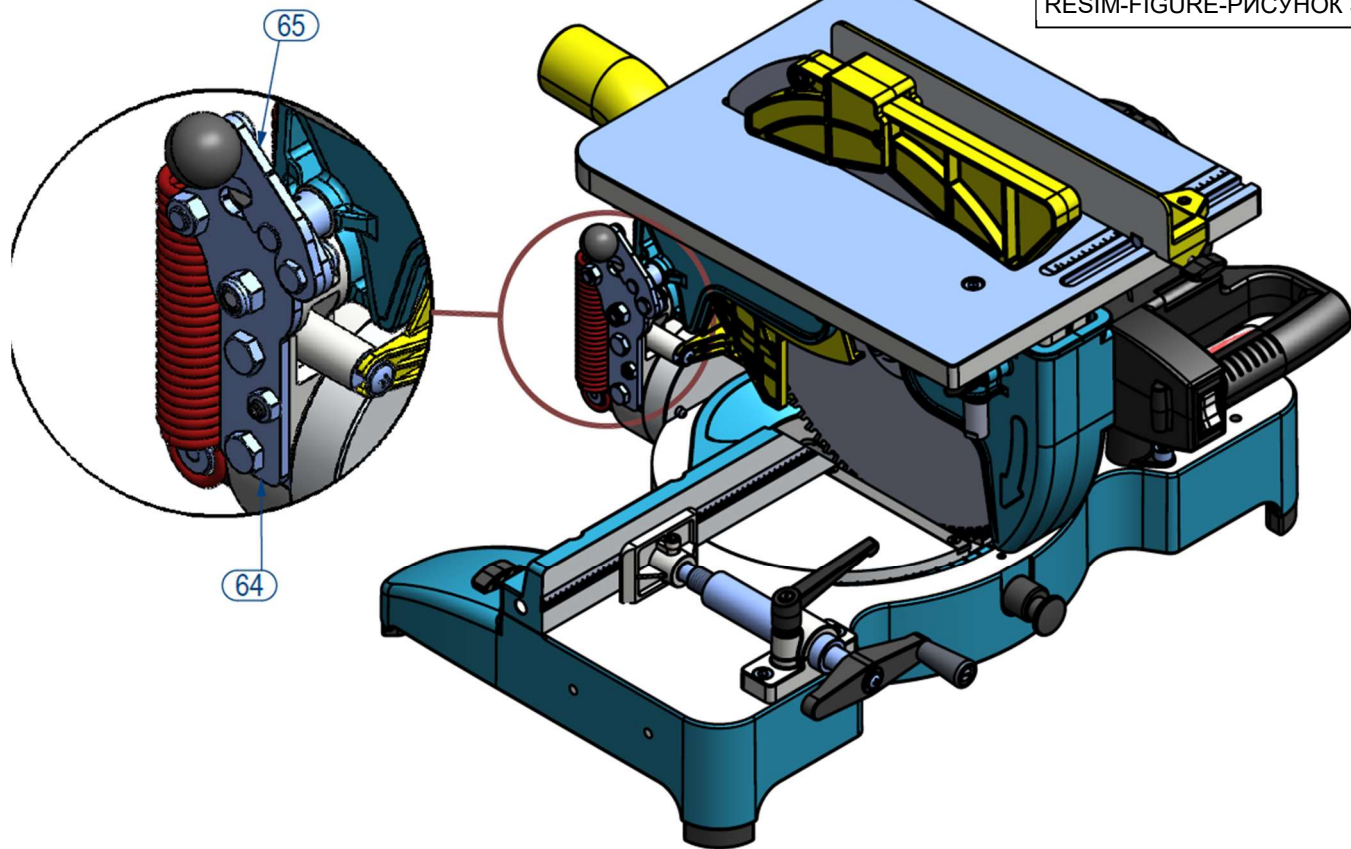
PART LIST



RESİM-FIGURE-ПИСУНОК 2

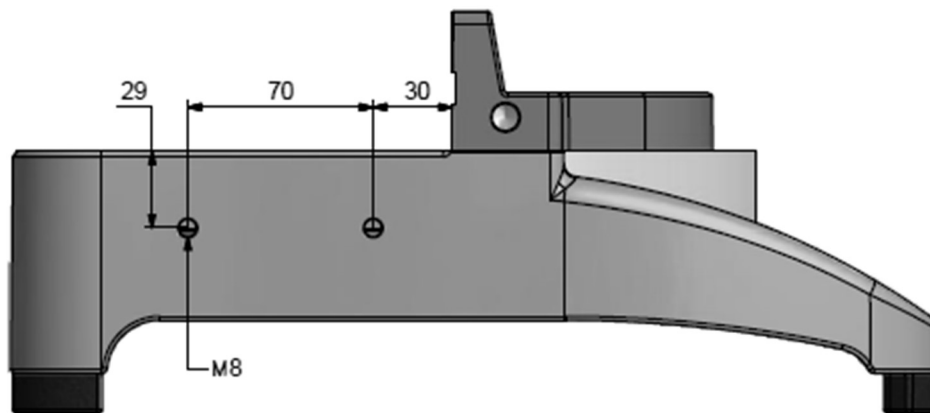


РЕСІМ-FIGURE-РИСУНОК 3



NO номер	СТОК КОДУ / CODE ПОРЯДОК КОД	ADET / QTY КОЛИЧЕСТВО	NO номер	СТОК КОДУ / CODE ПОРЯДОК КОД	ADET / QTY КОЛИЧЕСТВО
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2	1PL030000-0024	4	129	1PL010000-0049	1
5	3UA250030-0009	1	132	3UA770030-0013	1
8	1PL010000-0011	1	135	2TU011110-0146	1
12	3UA030030-0001	1	138	1SK010000-0002	1
14	2TU012610-0020	1	139	2TU011710-0004	1
26	2TU011110-0145	4	140	1SC021000-0027	1
29	2TU012610-0079 (KD 310)	1	144	3UA250030-0002	1
29	2TU012610-0087 (KY 310)	1	147	1PL010000-0057	1
30	2TU011441-1542 (KY 310)	1	148	1YY021000-0004	2
35	3UA040030-0013 (KY 310)	1	149	2TU011210-0177	2
45	3UA090030-0004	1			
57	2TU012610-0019	1			
64	3UA770030-0020	1			
77	3UB030030-0001	1			
85	3UB030030-0002	1			
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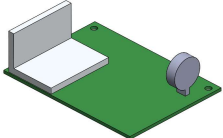
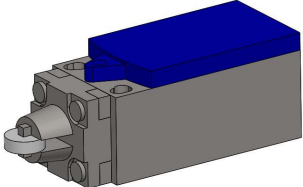
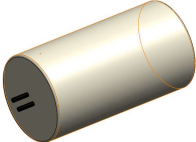
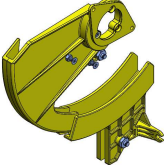
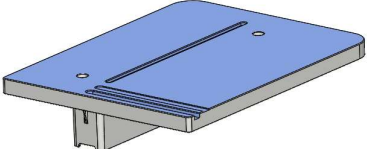
HOLE DIMENSIONS FOR CONVEYOR CENNECTION

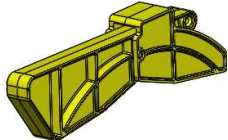
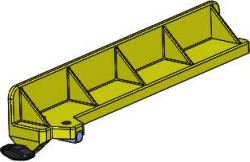

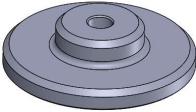



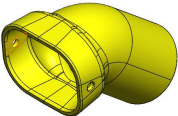
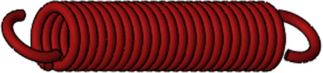
PARÇA NO PART NO НОМЕР	RESİM FIGURE РИСУНОК	STOK KODU / CODE ПОРЯДОК КОД
5		3UA250030-0009
8		1PL010000-0011
12		3UA030030-0001
14		2TU012610-0020
26		2TU011110-0145

29		<p>2TU012610-0079 (KD 310) 2TU012610-0087 (KY 310)</p>
35		<p>3UA040030-0013 (KY 310)</p>
45		<p>3UA090030-0004</p>
57		<p>2TU012610-0019</p>
64		<p>3UA770030-0020</p>
77		<p>3UB030030-0001</p>

85		3UB030030-0002
92		1PL010000-0107
93		1EL010000-0011
		1EL020000-0022 (KD/KY 310B)
		1EL040000-0500 (KD/KY 310B)

		1EL190000-0400 (KD/KY 310B)
		1EL020000-0012 (KD/KY 310B)
		1EL180000-0001
115		1PL010000-0048
123		2TU012610-0081

129		1PL010000-0049
132		3UA770030-0013
138		1SK010000-0002
139		2TU011710-0004
144		3UA250030-0002

147		1PL010000-0057
148		1YY021000-0004

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 - 1.2. Service Information
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- 3. Machine's Description**
- 4. Transport of the Machine**
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 - 5.1. Preparation
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- 8. Maintenance, Service and Repair**
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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 / sales@lunamac.com.au













Web www.yilmazmachine.com.tr / www.lunamac.com.au

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 Do not leave any things on the machine.
- 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

Portable mitre cutting machines designed for straight and angle cutting of PVC and Aluminium profiles.

- Positive locating pin lock at 0-15°- 22, 5°- 30°- 45°- 60° - 75° intermediate angles set with a table lock.
- Cutting on upper table.
- The cutting head can be tilted 45° on the left-hand side.(KY 310)
- Machine has been designed in accordance with the CE Safety Directives.

<u>STANDARD ACCESSORIES</u>	<u>OPTIONAL ACCESSORIES</u>
Profile support	MKN 150 / 300 Conveyor
Clamp	MS Machine stand
User manual	300 mm Saw blade
Service wrench (6 mm)	

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. The power connection plug of the machine is located on the rear side of the machine.
- 5.1.3 Profile fitting (FIGURE 1 NO.144) are delivered disassembled. Assemble profile fitting parts on the square as it is seen in the figure.
- 5.1.4 Springs (FIGURE 2 NO.148) are delivered disassembled. Assemble springs as it is seen in the figure.
- 5.1.5 Remove the springs are not using the machine for a long period of time.
- 5.1.6 Demount the piece of packaging on the table (FIGURE 1 NO.1).

5.2 Connecting to Power Source

- 5.2.1 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 Mains voltage of the machine is optional as 230 V 50 Hz.



5.2.5 Check the supply voltage. **The source voltage must be in accordance with the data on the machine's 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'S 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 first.
- 6.3 Ensure that the machine has been cleaned, tested and maintained before starting to operate it.
- 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 cutting tools 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

IMPORTANT

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 This machine can process on products manufactured from rigid plastic and aluminum materials that don't include iron alloy.
- 7.1.4 Control whether cutting tools (FIGURE 2 NO.138) are inserted safely to their places.
- 7.1.5 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them.
- 7.1.6 Cutting tool must process on the part after machine is operated and cycled.
- 7.1.7 **Do not process the profile before clamping the work piece properly.**

7.2 Operation

- 7.2.1 Place PVC or aluminum profile that you are going to process on to the table (FIGURE 1 NO.1). Fix it with clamp (FIGURE 1 NO.45) on the table.
- 7.2.1 Start the motor by pressing the Start button on the grip. (FIGURE 1 NO.92)
- 7.2.2 Carry out the cutting operation by pressing down the cutting head holding the grip until the profile is cut off.
- 7.2.3 After cutting off the material, bring the cutting grip to its original position, press the Stop button. The saw blade will come to a full stop after continuing its idle rotation for a while.

7.2.4 Remove the part by opening the clamp.



Don't operate the saw while it touches the work piece. The saw must be operated only when the head is in the top position.

On the bottom plate during the cutting process, the remaining portion of the saw above is completely closed.

7.3 Angular cutting

7.3.1 Press the saw blade down inside the slot of the turning table.

7.3.2 Pull the snap pin from its hole. (FIGURE 1 NO.12)

7.3.3 Adjust the desired cutting angle by turning the handle to the left or right, and release the snap.

7.3.4 It is possible to make a straight or slanted cut on this machine. 0-15 - 22.5 - 30 – 45 degrees can be adjusted with the help of a safety catch (FIGURE 1 NO. 12), and the other interim degrees with the help of a special clamping screw (FIGURE 1 NO. 24). The safety catch is not seated in the slot in interim degrees. Tighten the clamping screw after turning the turntable to a special degree you desire.

7.3.5 Carry out the cutting operation after.

7.4 Angular cutting (KY 310)

7.4.1 Loosen the pipe. (FIGURE 1 NO.35)

7.4.2 Tilt the head to left-hand side.

- 7.4.3 Adjust the desired angle according to the degree table. (FIGURE 1 NO.30) and fix the head by tightening the pipe.
- 7.3.6 Carry out the cutting operation after.

IMPORTANT

Angle cutting is done, make sure that cutting unit is fixed

Tilted cutting is possible only with the head at 90°.

Make the 90° and 45° (tilted) precise adjustment via the M6 nut (FIGURE 1 NO.74) on the rear fork.

8. MAINTENANCE, SERVICE AND REPAIR

8.1 Maintenance

- 8.1.1 Cut the electric and pneumatic (if any) power connections of the machine.
- 8.1.2 Clean all surfaces of the machine from burrs, 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.

8.2 Changing the cutting tool

8.2.1 Cut the electric connection of the machine.

8.2.2 Remove the upper casing part. (FIGURE 2 NO.129)

8.2.3 Group of top table (FIGURE 2 NO.123), pull tightening (FIGURE 1 NO.127) loosening and remove it.

8.2.4 Unscrew the M8 screw (FIGURE 2 NO.140) with a hexagonal key. (FIGURE 2 NO.149)

8.2.5 Remove the part (FIGURE 2 NO.139) in this order.

8.2.6 Take out the saw blade (FIGURE 2 NO.138) carefully.

8.2.7 Install the new saw blade onto the shaft ensuring the correct rotation direction.

8.2.8 Install the guard group parts applying the reverse order as described above.

8.2.9 It is necessary to sharpen / replace the saw blade in certain intervals depending on the cutting material. If the cut material leaves burr after the cutting operation or if the saw blade is strained, it needs to be sharpened / replaced.

8.2.10 When replacing the saw blade, use the part of the blade washer which is appropriate for the blade shaft diameter. The outer diameter of the blade washer is 30 and 32 mm.

8.2.11 During saw blade change operations, use protective gloves



8.2.12 **Saw must be selected according to standart DIN EN 847-1**



8.2.13 **A saw blade rotating in reverse direction, causes danger both for the operator and the equipment. The teeth of the saw blade would be damaged and even broken.**

9. WARRANTY CONDITIONS

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

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
- electrical component faults
- lack of cleaning and of ordinary maintenance by the customer
- transport or displacement (even inside the workshop)
- natural events (lightnings, fires, floods)
- Phase failure or overvoltage, failures due to faulty electrical installation
- The problems caused by the absence of grounding in the electrical installation

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