

GARANTİ BELGESİ

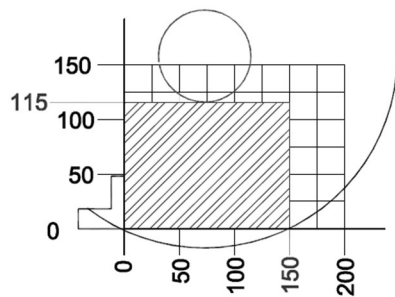
İMALATÇI FİRMA : YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş.
ADRES : TAŞDELEN MH. ATABEY CD. No 9 34788 ÇEKMEKÖY
İSTANBUL-TÜRKİYE
TELEFON : 0216.312.28.28 PBX
TELEFAX : 0216.484.42.88
İMZA-KAŞE :

ÜRÜNÜN CİNSİ : ALÜMİNYUM VE PVC KESME MAKİNESİ
MARKASI : YILMAZ
MODEL KODU : KD 350 / KD 400 M-D-P
BANDROL/SERİ NO :
TESLİM TARİHİ :
GARANTİ SÜRESİ : 2 YIL
AZAMI TAMİR SÜRESİ : 30 İŞ GÜNÜ

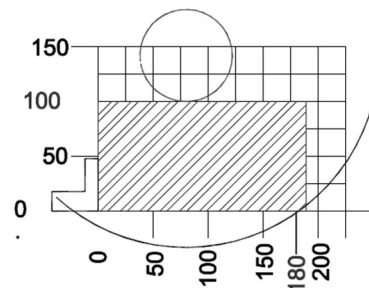
YETKİLİ SATICI FİRMA :
ADRES :

TELEFON :
TELEFAX :
İMZA-KAŞE :

KESME DİYAGRAMI – CUTTING DIAGRAM – ДИАГРАММА ВЫПИЛИВАНИЯ

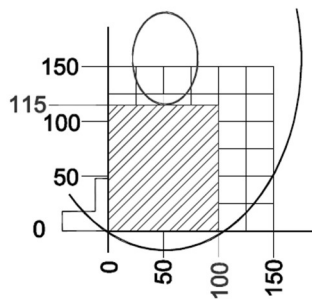


90° : 150 x 115 mm

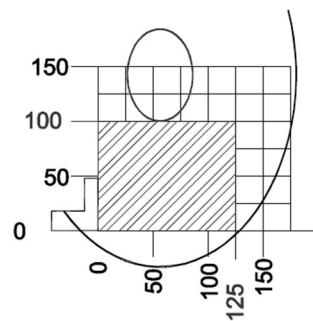


90° : 180 x 100 mm

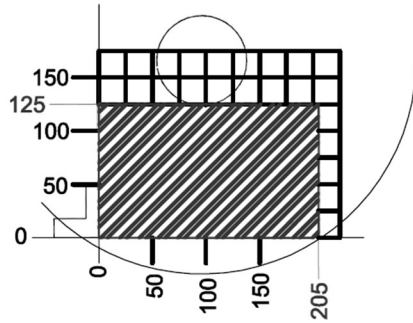
KD 350 M/D/P



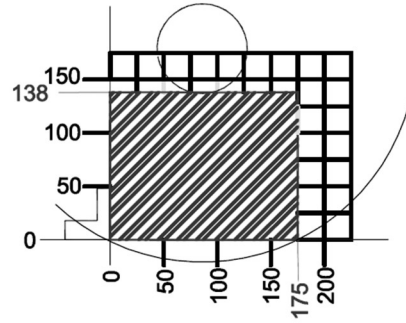
45° : 100 x 115 mm



45° : 125 x 100 mm

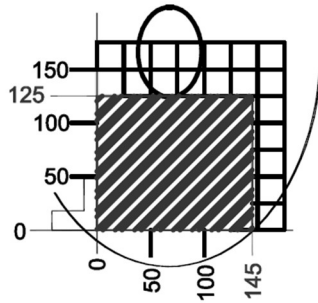


90° : 205 x 125 mm

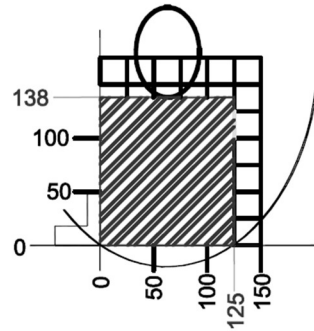


90° : 175 x 138 mm

KD 400 M/D/P

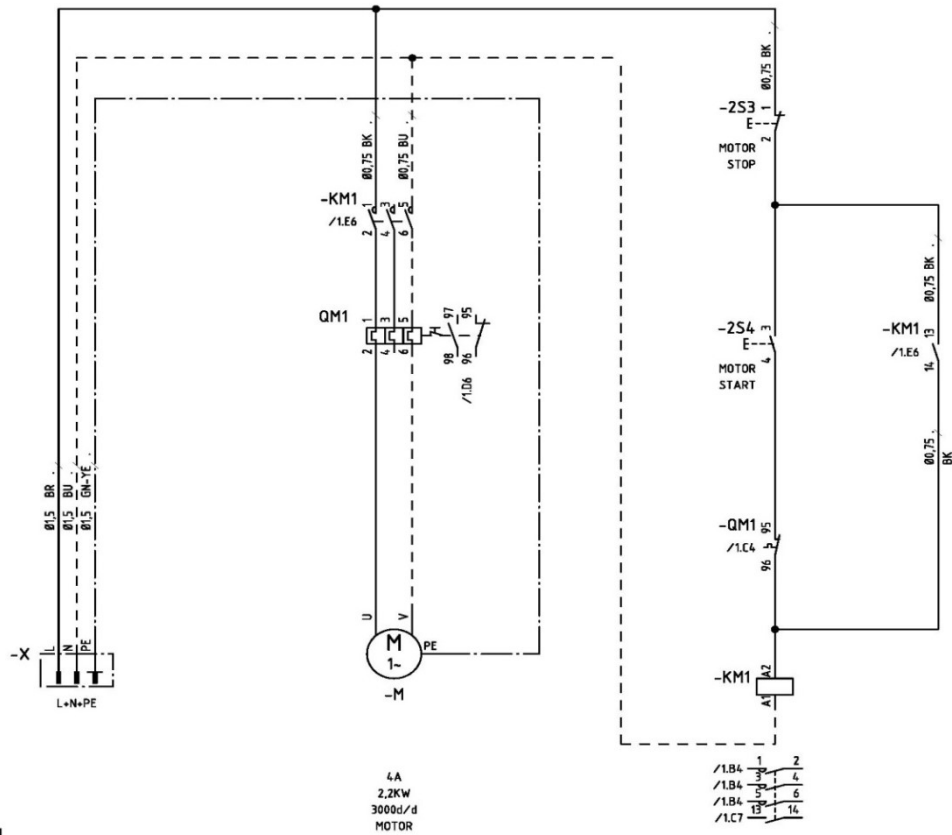


45° : 145 x 125 mm

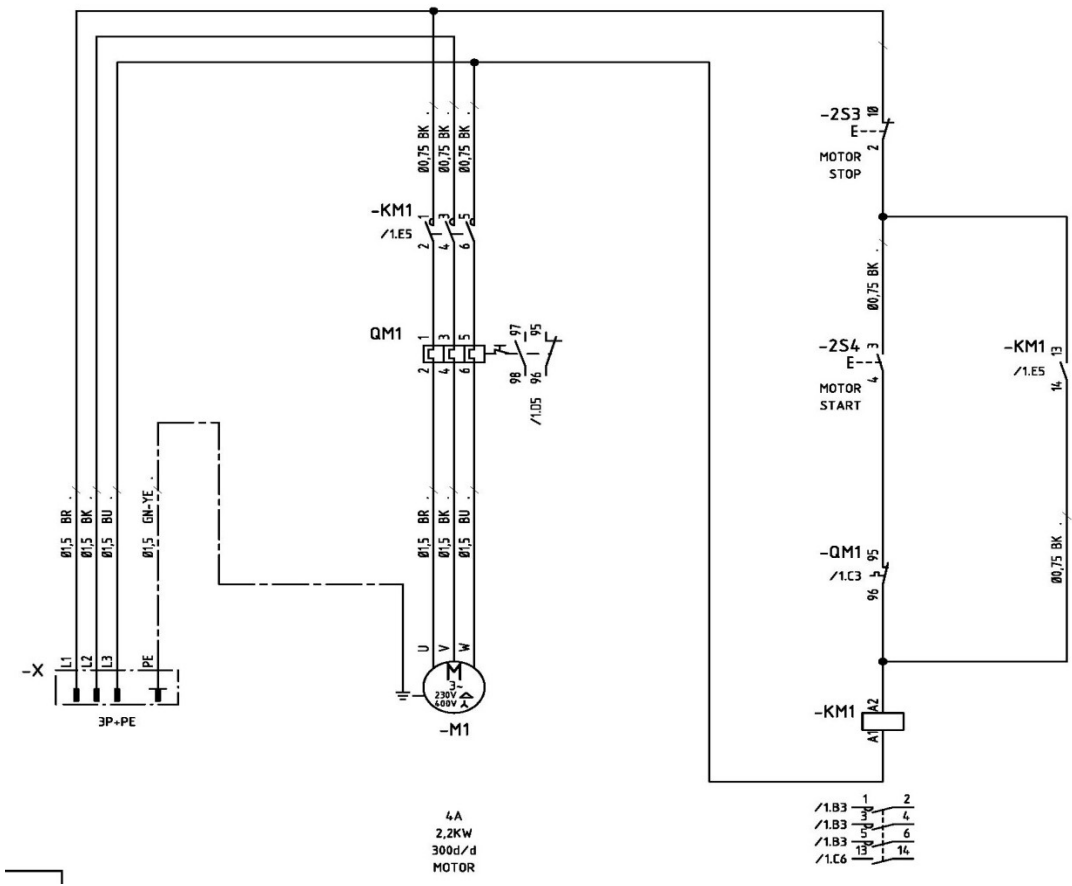


45° : 125 x 138 mm

ELEKTRİK ŞEMASI - WIRING DIAGRAM - ДИАГРАММА ЭЛЕКТРОПРОВОДКИ

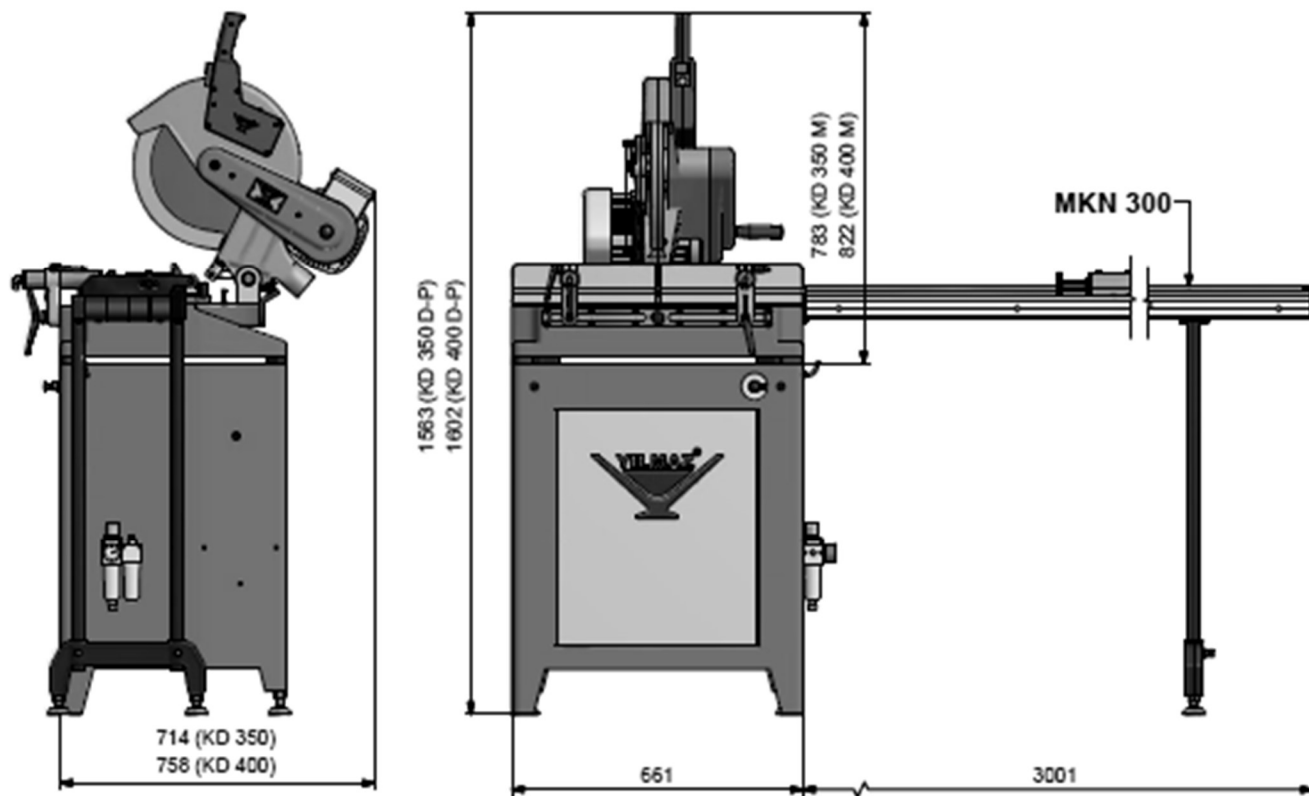


230V 1P



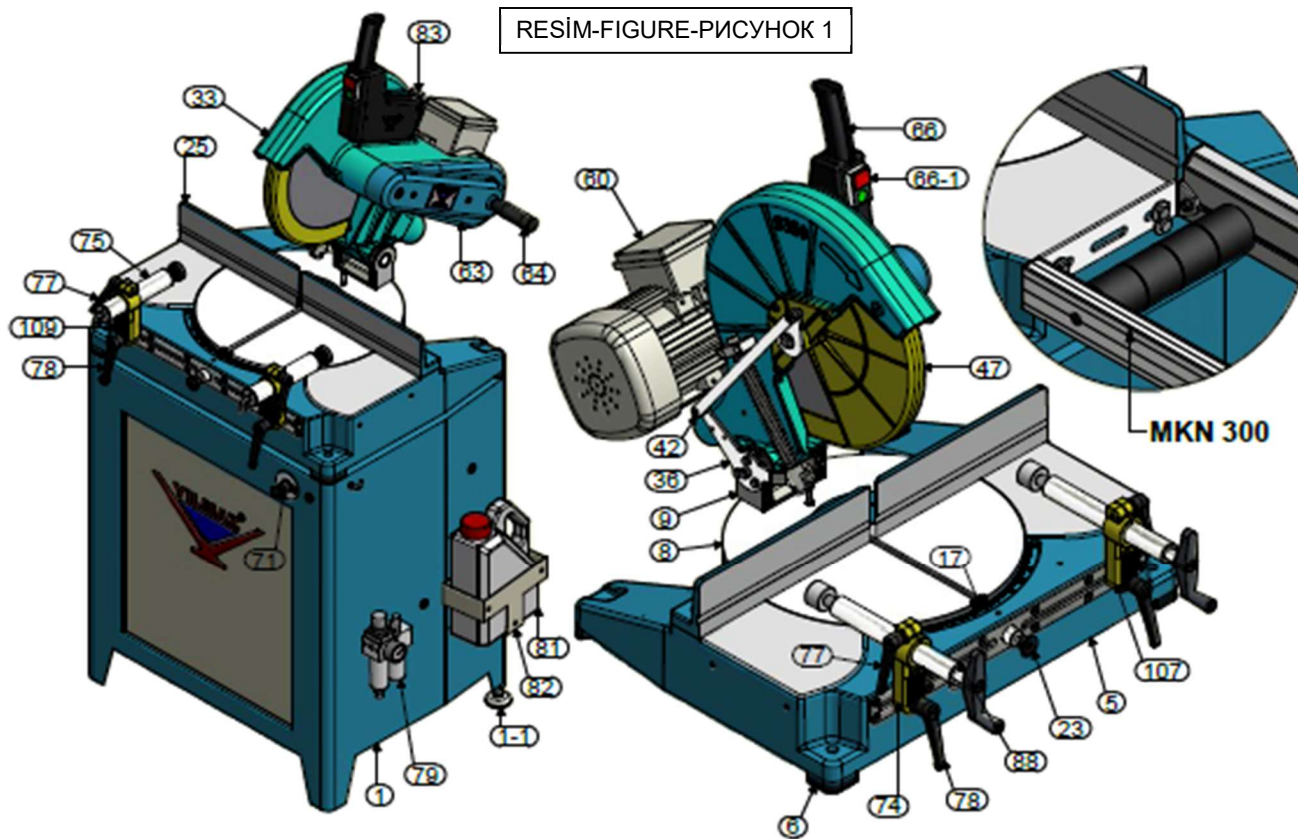
400V 3P

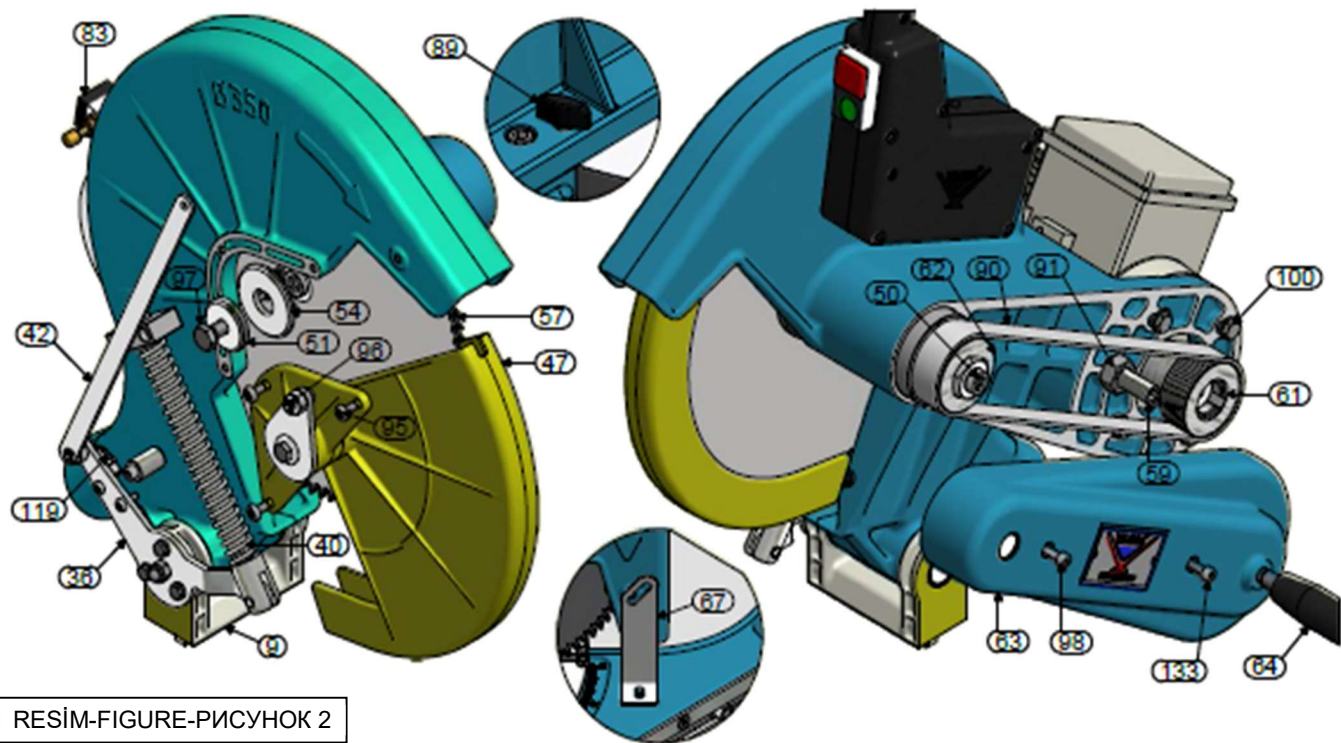
BOYUTLAR – DIMENSIONS – РАЗМЕРЫ



PARÇA LİSTESİ - PART LIST - ПЕРЕЧЕНЬ ДЕТАЛЕЙ

RESİM-FIGURE-РИСУНОК 1



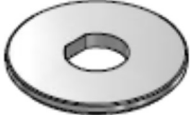

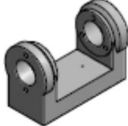
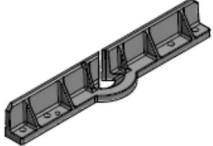



RESİM-FIGURE-РИСУНОК 2

NO номер	СТОК КОДУ / CODE ПОРЯДОК КОД	АДЕТ / QTY КОЛИЧЕСТВО	NO номер	СТОК КОДУ / CODE ПОРЯДОК КОД	АДЕТ / QTY КОЛИЧЕСТВО
1	1SA010000-0060	1	57	1SK010000-0003 (KD 350)	1
5	2TU012610-0094	1	57	1SK010000-0004 (KD 400)	1
6	1PL030000-0017	2	59	2TU011110-1018	1
8	2TU011610-0009	1	60	1EL070001-0002 (230 V)	1
9	2TU012610-0102	1	60	1EL070001-0001 (400 V)	1
17	2TU011441-0043	1	61	2TU012110-0029	1
23	3UA030030-0003	1	62	2TU012110-0030	1
25	2TU012610-0100	1	63	2TU012610-0097 (KD 350)	1
33	2TU012710-0007 (KD 350)	1	63	2TU012610-0099 (KD 400)	1
33	2TU012710-0008 (KD 400)	1	64	1PL010000-0076	1
36	2TU011441-0905 (KD 350)	1	66	1PL010000-0042	1
36	2TU011441-0906 (KD 400)	1	66-1	1EL010000-0080	1
40	1YY011000-0023 (KD 350)	1	67	2TU011441-0305	1
40	1YY011000-0025 (KD 400)	1	71	1PN010000-0087	1
42	2TU011210-0073 (KD 350)	1	74	2TU012610-0010	1
42	2TU011210-0100 (KD 400)	1	75	3UA060030-0013	2
47	2TU012610-0096 (KD 350)	1	77	3UA040030-0007	2
47	2TU012610-0098 (KD 400)	1	78	3UA040030-0002	2
50	2TU011110-0135	1	79	3UA110030-0020	1
51	2TU011110-0857	1	83	1PN010000-0012	1
54	2TU011441-0651	1	86	4UN300030-0001	1

87	2TU012610-0009	2		
88	3UA090030-0008	2		
89	2TU011110-0145	1		
90	1SR070000-0007 (KD 350)	1		
90	1SR070000-0006 (KD 400)	1		
91	1SC071000-0005	1		
95	1SC041000-0014	3		
96	1SC131000-0006	2		
97	1SC011000-0002	1		
98	1SC0210000-0050	5		
100	1SC011000-0036	4		
107	2TU012610-0053	1		
107	2TU012610-0010	1		
119	1PN010000-0157	1		

YEDEK PARA LİSTESİ / SPARE PART LIST / СПИСОК ЗАПАСНЫХ ЧАСТЕЙ

PARA NO PART NO НОМЕР	RESİM PICTURE РИСУНОК	STOK KODU / CODE ПОРЯДОК КОД	PARA ADI – PART NAME НАИМЕНОВАНИЕ ДЕТАЛИ
54		2TU011441-0651	DIŞ KAPLİN COUPLIN
		2TU011710-0006	TESTERE KAPLİNİ SAW COUPLIN
9		3UA320030-0002	ATAL CLEVIS
25		2TU012610-0100	GÖNYE SETSQUARE
47		3UA320030-0014 (KD 350) 3UA410030-0014 (KD 400)	TESTERE MUHAFAZASI SAW GUARD

74		2TU012610-0009 / 0053 (KD 350-400 M/D) 2TU012610-0010 / 0054 (KD 350-400 P/PS)	MENGENE YATAĐI CLAMP MOUNTING BRACKET
75		3UA060030-0013 (KD 350-400 P/PS)	PNÖMATİK MENGENE PNEUMATIC CLAMP
88		3UA090030-0008 (KD 350-400 M/D)	MEKANİK MENGENE MECHANIC CLAMP
77		3UA040030-0007	M8x32 PİPO M8x32 HANDLE
78		3UA040030-0002	M10*50 PİPO M12*60 HANDLE
43		1SK010000-0003 (KD 350) 1SK010000-0004 (KD 400)	Ø 350 / 400 TESTERE BIÇAĐI Ø 350 / 400 SAW BLADE

83		1PN010000-0012 (KD 350-400 PS)	SPRAYER SU PÜSKÜRTME VALF WATER SPRAY VALVE
		1SR010000-0005	6204 RULMAN 6204 BEARING
90		1SR070000-0007 (KD 350) 1SR070000-0006 (KD 400)	MOTOR KAYIŞI MOTOR BELT
75-1		1PL010000-0033	MENGENE PABUCU CLAMP FEET
66		1PL010000-0042	KOL HANDLE

66-1		1EL090000-0017	ŞALTER SWITCH
60		1EL070001-0002 (230V-1P 50 Hz) 1EL070001-0017 (240V-1P 50 Hz) 1EL070001-0019 (220V-1P 60 Hz) 1EL070001-0001 (400V-415V 3P 50 Hz) (440V-3P 60 Hz)	MOTOR MOTOR
79		3UA110030-0020	ŞARTLANDIRICI LUBRICATOR
119		1PN0140000-0157	AZ 431 MP VALF AZ 431 MP VALVE

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 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, combusive liquids and materials next to the machine and electric connections.

3. MACHINE'S DESCRIPTION

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

- Cutting at angles of 15° - $22,5^{\circ}$ - 30° - 45° - 90°
- KD 350-400 M : Portable with manual clamps, cutting is manual.
- KD 350-400 D : Stationary with manual clamps, cutting is manual.
- KD 350-400 P : Stationary with pneumatic clamps, cutting is manual.
- Machine has been designed in accordance with the CE Safety Directives.

<u>STANDARD ACCESSORIES</u>	<u>OPTIONAL ACCESSORIES</u>
User manual	MKN 300 Conveyor
Service wrench (8 mm)	MS Machine stand (KD 350-400 M)
Service wrench (17 mm)	Cooling system (KD 350-400 P)
350 mm Saw blade (KD 350)	
400 mm Saw blade (KD 400)	

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 You can provide the balance of the machine with adjustable counterforts (FIGURE 1 NO 1-1) in the bottom part.
- 5.1.4 Clamps (FIGURE 1 NO.75 / 88) are sent as demounted. Mount the clamps as shown on the figure on the table. (FIGURE 1 NO.5)
- 5.1.5 Conditioner unit (FIGURE 1 NO.79) are sent as demounted. Mount the clamps as shown on the figure on the chassis. (FIGURE 1 NO.1)
- 5.1.6 Plastic handle (FIGURE 1 NO.64) should be sent as demounted. Mount the plastic handle as shown on the figure. (FIGURE 2 NO.63)
- 5.1.7 Make the MKN 300 conveyor (FIGURE 1 NO.86-optional) connection as in the FIGURE. The length of MKN 300 conveyor is 3 meters.
- 5.1.8 Remove the carriage safety part (FIGURE 2 NO.68). While removing the carriage safety part, head group that the saw is connected is pushed to the rear side with the power of spring swiftly. This might cause severe damage on machine. In order to prevent this situation, apply pressure on the arm that is enough to cover the power of the spring.

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 or 400 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.

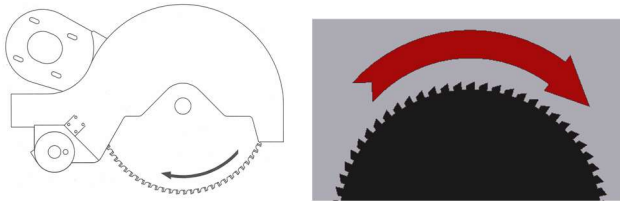
7.1.3 This machine can process on products manufactured from rigid plastic and aluminum materials that don't include iron alloy.

7.1.4 Control whether cutting tools (FIGURE 2 NO.57) 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.

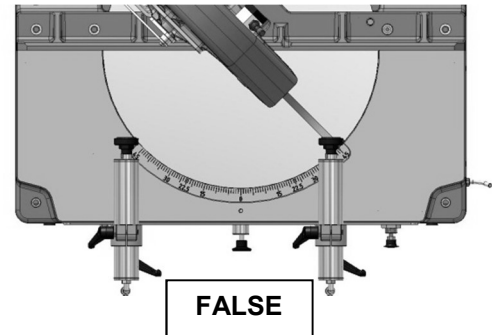
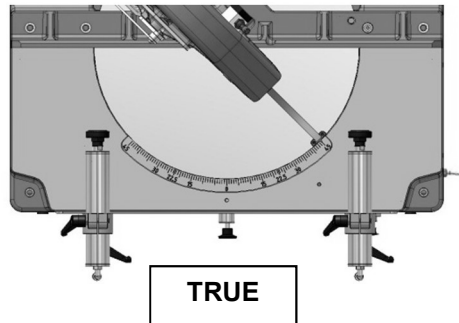
7.1.7 Absolutely control the direction of rotation of the saw.



7.1.8 Do not process the profile before clamping the work piece properly.



7.1.9 While making cutting on the machine, be careful about clamps' being out of the cutting area of the saw.



7.2 Operation

- 7.2.1 Place PVC or aluminum profile that you are going to process on to the table (FIGURE 1 NO.5). Fix it with clamps (FIGURE 1 NO.75 / 88) on the table.
- 7.2.2 KD 350-400 M/D: The clamping is manual. KD 350-400 P: Clamping is pneumatically. You can adjust forward-backward, up-down position of the clamps with special clamping parts (FIGURE 1 NO.77/78). Control of pneumatic clamp is made with the button (FIGURE 1 NO.71) on the chassis (FIGURE 1 NO.1).
- 7.2.3 Control the firmness of the special clamping screw (FIGURE 2 NO.89) on set square (FIGURE 1 NO.25)
- 7.2.4 Operate the motor by pressing the start button (FIGURE 1 NO.66-1) on arm (FIGURE 1 NO.66)
- 7.2.5 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.
- 7.2.6 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.
- 7.2.7 Remove the part by opening the clamps.



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.

7.3 Angular cutting

- 7.3.1 Loosen the special clamping screw (FIGURE 2 NO.89) on set square (FIGURE 1 NO.25)
- 7.3.2 Pull the spring shaft (FIGURE 1 NO.23) from spring slot. At the same time, get the head (FIGURE 1 NO.33) at the level you want with the aid of plastic arm (FIGURE 1 NO.64) with your other hand. You can read the angle values with the aid of level reader (FIGURE 1 NO.17) on the plate (FIGURE 1 NO.33).
- 7.3.3 15- 22.5- 30 and 45 degrees can be set with the aid of spring (FIGURE 1 NO.23) and other sub degrees can be set with the aid of special clamping screw (FIGURE 2 NO.89) on the set square (FIGURE 1 NO.25). The spring will not be fixed to the slot in the sub-levels. Tighten the special clamping screw after you turn the head at the level you want.
- 7.3.4 Carry out the cutting operation after.

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 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.

8.2 Changing the cutting tool

- 8.2.1 Cut the electric connection of the machine.
- 8.2.2 Dismantle the blade guard group (FIGURE 2 NO.47) in the stipulated order.
- 8.2.3 Remove the segment (FIGURE 2 NO.96) on the protection sheet bar (FIGURE 2 NO.42). Set the end of the protection sheet bar to off-position by removing it from the pin.
- 8.2.4 Remove the saw protection connection screws (FIGURE 2 NO.95) with the aid of philips screwdriver. Remove the saw protection Group which is set to off-position.
- 8.2.5 Remove the M10 bolt (FIGURE 2 NO.97) from its place with the aid of 17 mm switch. While removing the bolt, hold from the other end of the saw shaft (FIGURE 2 NO.50) with 8 mm Allen switch.
- 8.2.6 Remove the string (FIGURE 2 NO.51) and saw coupling (FIGURE 2 NO.54) respectively.
- 8.2.7 Take out the saw blade (FIGURE 2 NO.57) carefully.
- 8.2.8 Install the new saw blade onto the shaft ensuring the correct rotation direction.
- 8.2.9 Install the guard group parts applying the reverse order as described above.
- 8.2.10 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.
- 8.2.11 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.

8.2.12 During saw blade change operations, use protective gloves



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

8.2.14 **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.**

8.3 Changing the belt

8.3.1 Cut the electric connection of the machine.

8.3.2 Also, remove M5 imbus screw (FIGURE 2 NO.98) with the aid of Allen switch by turning the plastic arm (FIGURE 2 NO.64) manually. After removing the connections, remove the balancing wheel protection (FIGURE 2 NO.63) from its place.

8.3.3 Loosen the motor connection bolts (FIGURE 2 NO.100) with the aid of 13 mm switch.

8.3.4 Hold the belt tension part (FIGURE 2 NO. 59) from its part, which has a nozzle, to the switch with the aid of 12 mm switch. Loosen the M16 nut (FIGURE 2 NO.91) which is located on the belt tension part with the aid of 24 mm switch.

8.3.5 Get the belt tension part (FIGURE 2 NO.59) to off-position by turning it with the aid of a switch, have the belt (FIGURE 1 NO.90) got loosen by pushing the motor (FIGURE 1 NO.60) forward.

8.3.6 Change the new belt with the previous one. Be careful when fixing the belt to the channels of balancing wheel (FIGURE 2 NO.61/62) of the channels of the belt.

8.3.7 After having fixed the new belt to its place, set the tightness of the belt by holding the belt tension part (FIGURE 2 NO.59) with the aid of 12 mm switch. After adjusting it to the proper tightness, tighten M16 nut FIGURE 2 NO.91) with your free hand while still holding the part.

8.3.8 Tighten the motor connection bolts. (FIGURE 2 NO.100)

8.3.9 Fix the removed parts by following the reverse sequence that you removed them before.

8.4 Angular and run out adjustment control of saw blade and set square

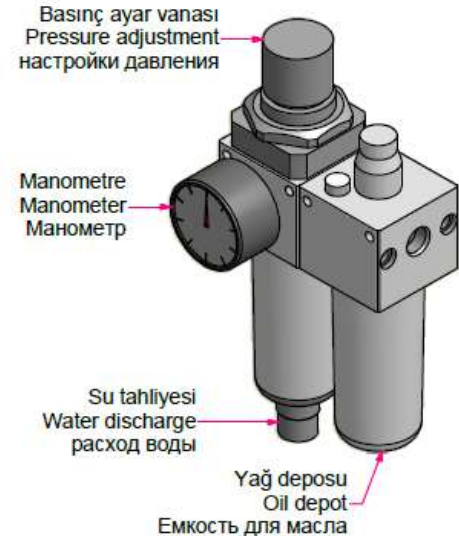
8.4.1 Cut the electric connection of the machine.

8.4.2 Control the run out of the saw blade with eyes. If possible use a dial gage.

8.4.3 If there is any problem in the inclined cut, control the saw's 90 degrees orthogonal to the set square with the aid of the set-square. If it is not proper, loosen the stay bolt at the top which tightens the spring (FIGURE 1 NO.23) Have the pin located to its place by turning the spring in way that it can provide it to be proper by setting it to the 90 degrees. Tighten the screw at the top again which fastens the spring.

8.5 Adjust the air pressure (pneumatic systems)

- 8.5.1 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.
- 8.5.2 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.
- 8.5.3 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.
- 8.5.4 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.

TROUBLE	CAUSES	REMEDY
Low surface quality (at aluminum and similar materials) : Rough surface, Large chip, Not homogenous surface, Saw blade traces visible	Not cooling the saw blade surfaces	Lubricating the saw blade cutting surfaces, Using of cooling liquid
	Using of damaged or blunt saw blade	Check the saw blade teeth. Replace if necessary.
	Saw blade moves to quick	The cutting speed is too high for the material. Decrease the cutting speed.
Motor does not work (Start button is pressed, not working)	No power supply to the machine.	Check the electric cable connections. Check the electric power sockets.
Motor is working but the pneumatic clamp pistons do not work.	The air supply connections are missing, or the air pressure is too low.	Check the air compressor connections. Adjust the air pressure between 6-8 Bar on the conditioner.
The saw blade rotates in reverse direction.	The electric connection, the power cable or the connection at the panel is wrong.	Let the electric connections carry out by a qualified electrician.

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:

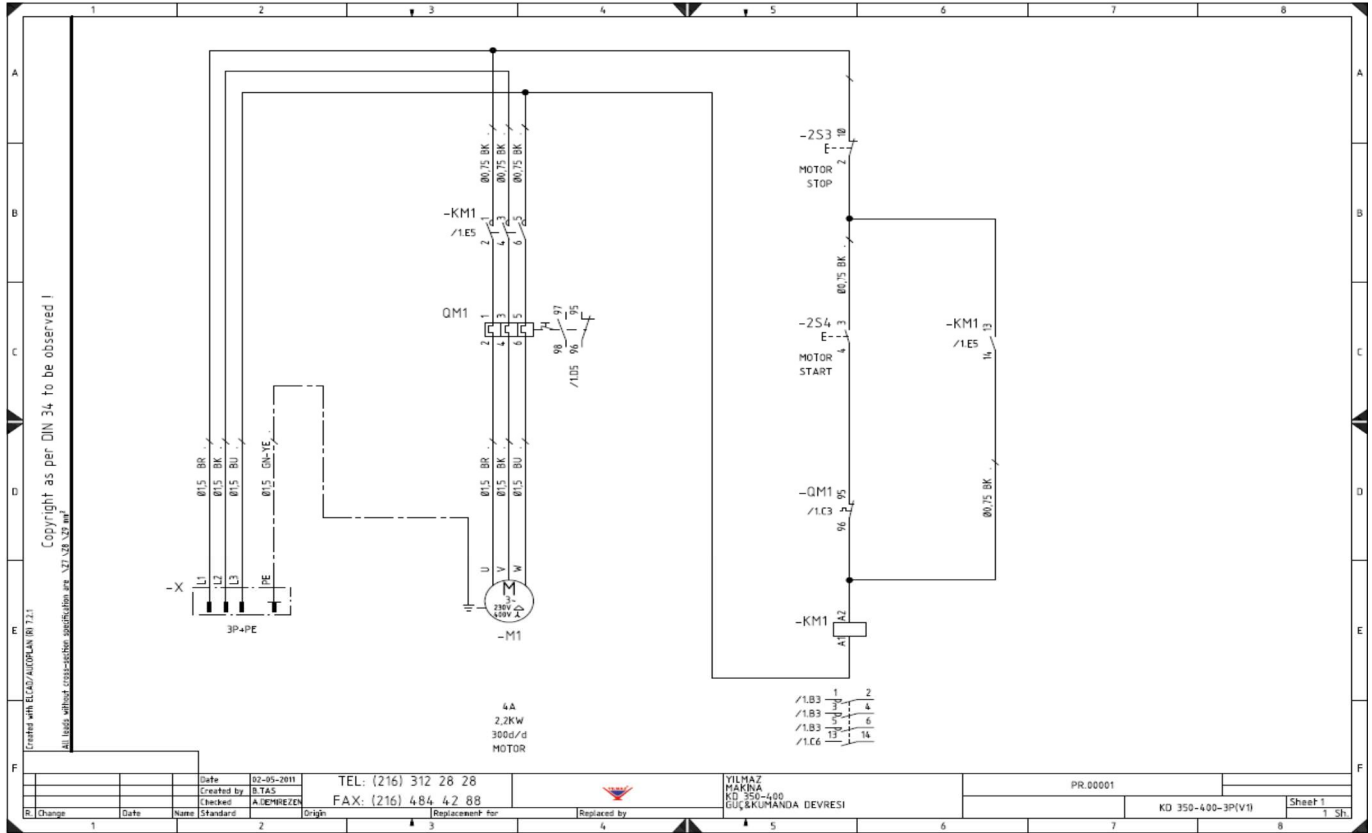
- Any repair and replacement effected at our workshop is completely free of charge (only transport costs are at customer's charge).
- For repair and replacement effected by our technician at the customer's site, we will invoice only the travel and lodging costs for our technician.

The guarantee does not cover damages caused by:

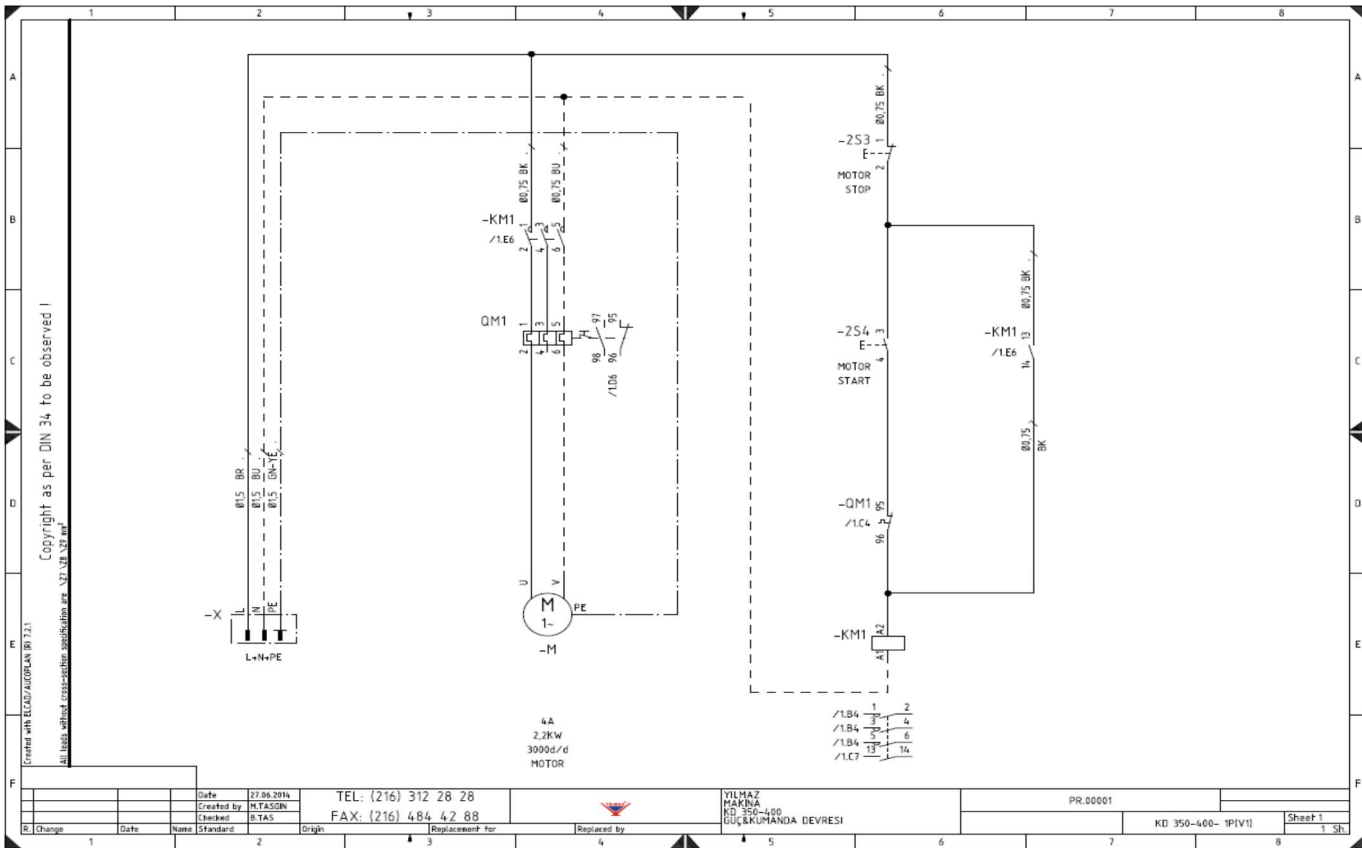
- not respect of the rules indicated in the manual instruction book
- not correct voltage
- improper use or use not in accordance with what the Machine has been designed for
- use of non original tooling
- programming errors
- lack of cleaning and of ordinary maintenance by the customer
- transport or 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

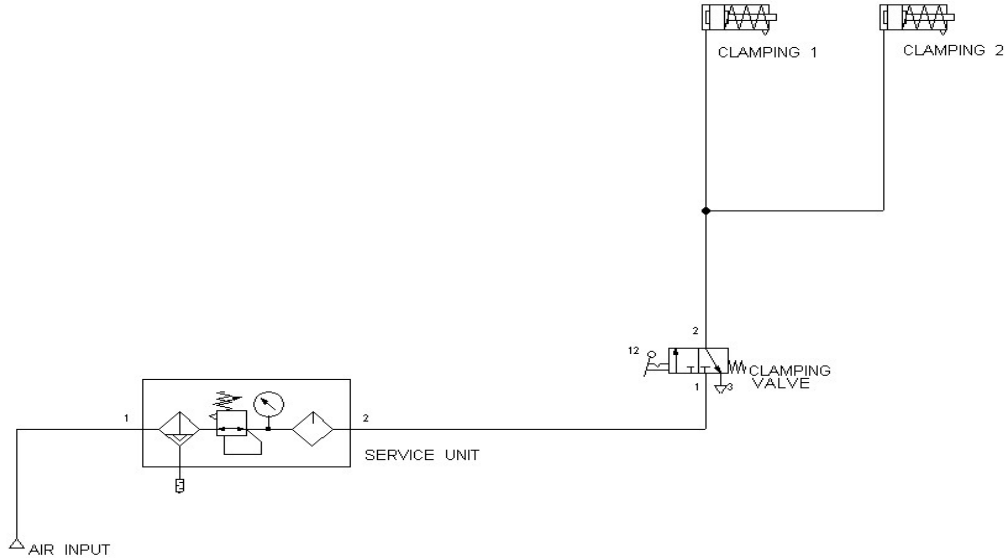


3 PHASE ELECTRICAL DIAGRAM SHEET 1



1 PHASE ELECTRICAL DIAGRAM SHEET 1

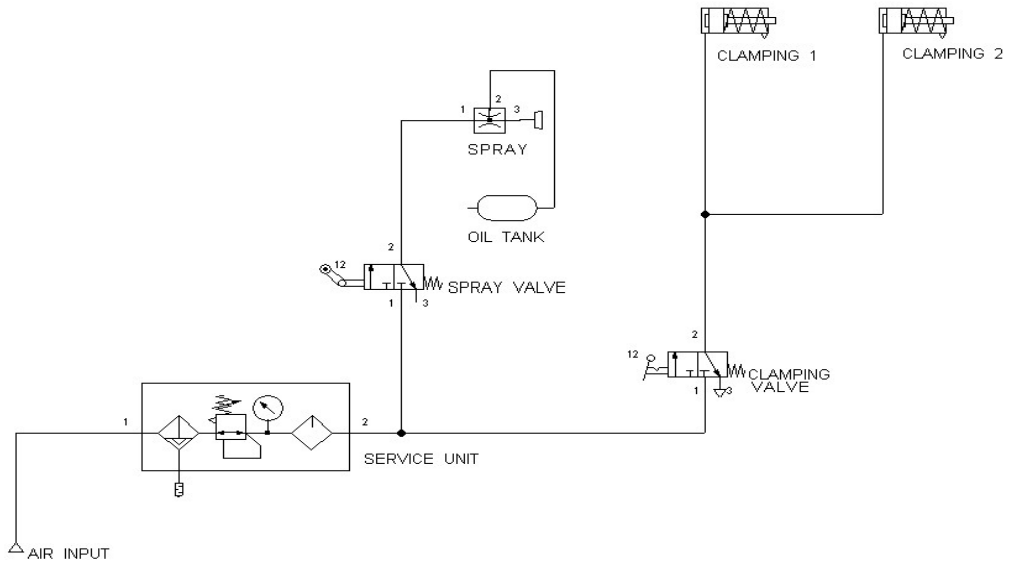
Pos	Designation	Part number	Type	Component Description	Packing unit	Unit of quantity	Price per PCS	Price EUR	Comment
1	AIR INPUT								
2	SERVICE UNIT								FRC-1/8-D-MINI
3	CLAMPING								241-084
4	CLAMPING 1								550-253
5	CLAMPING 2								550-253
6	YILMAZ MAKINA - PNEUMATIC DIAGRAM								



Aenderung	Datum	Name	Datum	Name	Benennung:	Zeichnungs-Nr.	Anlage	Blatt Nr.	SHEET: 1
a			gez.	28-06-2005	B.TAS	YILMAZ MAKINA - PNEUMATIC DIAGRAM ID 390 - 400 PS	Ort	von	
b					1			Blatt	
c			gepr.		E.AKTAS			Blatt	

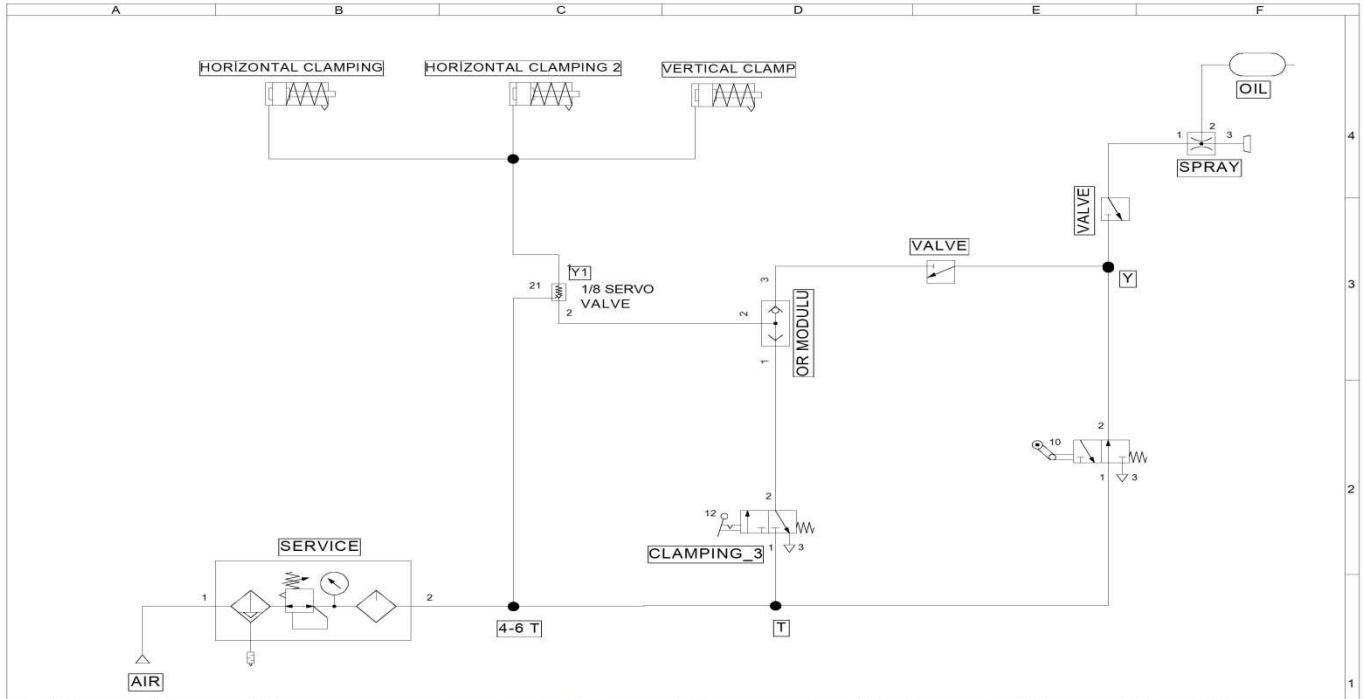
PNEUMATIC DIAGRAM SHEET 1

Pos	Designation	Part number	Type	Component Description	Packing unit	Unit of quantity	Price per PCS	Price EUR	Comment
1	AIR INPUT								
2	SERVICE UNIT								FRC-1/8-D-MINI
3	CLAMPING								241-084
4	CLAMPING 1								550-253
5	CLAMPING 2								550-253
6	YILMAZ MAKINA - PNEUMATIC DIAGRAM								
7	OIL TANK								
8	SPRAY								
9	SPRAY VALVE								



Aenderung	Datum	Name	Datum	Name	Benennung:	Zeichnungs-Nr.	Anlage	Blatt Nr.	SHEET: 1
			gez.	28-06-2005	S.TAS	1			
			gepr.		E.AKTAS		Ort	von	Blatt

PNEUMATIC DIAGRAM COOLING SYSTEM SHEET 1



created	Date	Name	Index	Revision no.	Number	Date	Name
	02-05-2011	OMER BATAL					
Seen	ALI DEMIREZEN		Doc. type:		Type:		
Release	Material:		Part number:		Page no.:		
Designation					KD 350-400 PS (CE)		

PNEUMATIC DIAGRAM CE SHEET 1