

NEOLT



HORIZONTAL ELECTRO FOAM TRIM PLUS

160 250 310



MANUALE D'USO
USER'S MANUAL
MANUEL D'UTILISATION
HANDBUCH
MANUAL DE USO

Horizontal
Electro foam trim plus
160/250/310



USER'S MANUAL

ENGLISH

Cod. NLT.QY-F-AF-MM-4-3S-GB

NEOLT

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VERSION: NLT-HEFTP-03-07/2004



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GENERAL INFORMATION**Data of the manual****1.1**Instruction manual.
Code of Manual**HORIZONTAL ELECTRO FOAM TRIM PLUS**
NLT.QY-F-AF-MM-4-3S-GB**Users****1.2**

Instruction manual.

- Transporter.
- Installer.
- User.
- Maintenance personnel.
- Demolition squad.



For further details on the users of this manual, see 2.2 *Qualifications of the personnel*.

Property of the information**1.3**

The information contained in this manual is reserved property. All rights are reserved.

This manual should be kept for future reference.

This manual cannot be reproduced or copied, as a whole or in parts, without prior written authorization of **NEOLT S.p.A.** These documents are provided only for the use of the customer whom the manual has been supplied to with the machine, and can be used only for the installation, use and maintenance of the machine the manual refers to.

NEOLT S.p.A. states that the information of this manual complies with the technical and safety requirements of the machine the manual refers to. The manufacturer cannot be held responsible for any direct or indirect damages to people, objects or animals due to the use of these documents or of the machine in conditions other than those authorized.

NEOLT S.p.A. reserves the right to change or improve, without notice, these documents and these machines, and also other machines marketed of the same model as the one this manual refers to but with a different serial number. The information of this manual particularly refers to the machine specified in 1.6 *Identification data of the machine*.

GENERAL INFORMATION

Conventions used**1.4****Conventional terms used****1.4.1**

Machine: indicates the machine specified in 1.6. *Identification data of the machine.*

Frame: bearing structure of the machine.

Stand : stand used to support the machine. It is used to keep the machine lifted from the ground and to balance off the work table.

Qualified personnel: people, who thanks to their knowledge and preparation and experience, as well as thanks to the knowledge of the relevant rules, safety requirements and service norms, are able to recognize and avoid any possible danger for the people, the material and the machine.

The descriptions of **direction, sense and position** (on the right of the machine, on the left of the machine) refer to the position of the operator in front of the machine. **Lower side** refers to the position of the operator in front of the command keyboard.

Conventional symbols used**1.4.2**

Text in italics: indicates the title of a chapter, a section, a sub-section, a paragraph, a table or an illustration of this manual, or another reference manual.

1 (generic number as an example): symbolic representation of a command device or signal.

A (generic letter as an example): symbolic representation of a part of the machine.



Notes contain important information, and are pointed out after the text they refer to.



The danger symbols indicate those procedures which, if not respected, could cause physical damages to the operator. The manufacturer cannot be held responsible for any damages to people due to non-compliance with these regulations.



The warning symbols indicate those procedures which, if not respected, could damage the machines or the devices connected to it. The manufacturer cannot be held responsible for any damages to objects due to the noncompliance with these regulations.

GENERAL INFORMATION**Identification data of the manufacturer****1.5**

Contact distributor for any maintenance intervention. Any unauthorized maintenance interventions make the warranty void.

neolt S.p.A.

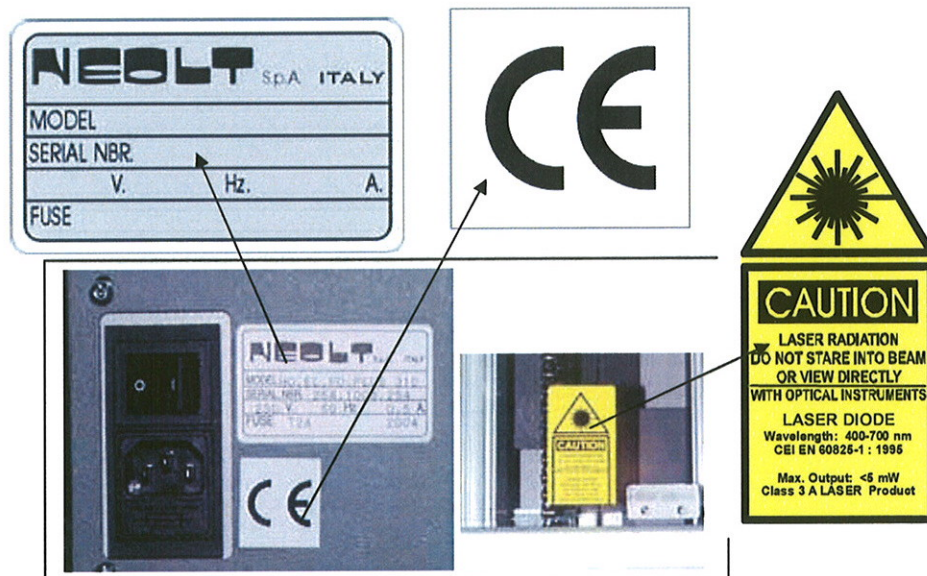
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Identification data of the machine**1.6**

Type	FIXED BLADE TRIMMER
Model	HO.EL.FO.plus XXX
Serial Number	
Year of Construction	

The machine has an identification label and EC mark on the right side of the machine, above the connection group. Whereas the laser label is on the Plexiglas above the keyboard.



GENERAL INFORMATION

EC conformity declaration**1.7**

Attachment A EC conformity declaration contains the reproduction of the EC conformity declaration of the machine.

Warranty**1.8**

NEOLT S.p.A. offers a one-year warranty on the machine.

The parts subject to normal wear out are not included in the warranty. The warranty is limited to the substitution or repair of the parts that should result damaged or defected.

The assessment of the defects and causes is carried out by NEOLT S.p.A.

The warranty is cancelled if the machine is used incorrectly, or in an improper or excessive way, if any non-original spare parts are used and for noncompliance with the standards of this manual.

In no case can the purchaser demand the resolution of the contract, claim for damages or the extension of the warranty.

The term "Original purchaser" refers to the person who first bought the product covered by this warranty for purposes other than reselling. The warranty is applicable and valid only for the original purchaser and only for the period (during the warranty period) in which the equipment is held by the original purchaser.

-
- ✓ NEOLT S.p.A. cannot be held responsible for any negative advertising or missed profits, due to malfunctioning, technical or mechanical, of the product being used or on display.
-

-
- ✓ The correct and safe operation of the machine is assured only if the machine is used in accordance with what is indicated in the manual and in the relevant documentation. NEOLT S.p.A. cannot be held responsible for any damages to people or things due to an incorrect use of the machine or modifications not authorized by the manufacturer.
-

Assistance**1.9**

NEOLT S.p.A. provides, upon request, assistance for the installation and the maintenance of the machine.

GENERAL INFORMATION**Use of the manual****1.10**

Carefully read the chapters *General information*, *Safety information*, *Characteristics of the machine* and *Operator interface*.



Please consult the relevant chapter for any transportation, installation, use, maintenance and demolition operation.

This manual and the enclosed documentation (**Attachment A** *EC conformity declaration*), must be kept for the entire technical life of the machine in order to consult it quickly when necessary.

If the machine is sold as second-hand, this manual and the enclosed documentation must be supplied along with the product.

Description of the machine**1.11****Correct use of the machine****1.11.1**

The machine must be used only to cut the media which it has been designed for (FOAM - SEMI-FOAM PVC).

The machine is made of physically independent and autonomous groups, therefore the proper use of the machine also refers to the correct functioning of only one part of it.

Use of the machine

The installation and the maintenance of the machine must be carried out by qualified personnel only.

The machine was designed to be used in an area with the following characteristics indicated in the section *PLACING OF THE MACHINE* 5.7 and in section *POWER DATA* 3.2.:

Incorrect use of the machine**1.11.2**

Any use other than that indicated in part 1.11.1 *Correct use of the machine* is to be considered incorrect, especially:

- Using the machine in ways which differ from those which it has been designed for, represents an anomalous condition and could therefore damage the structure of the machine.
- Using the machine without its protections and without the safety equipment it is provided with: particularly without the fixed protections that block access to the internal equipment.
- Not observing the procedures of this manual and especially maintenance and repair operations.
- Using the machine in an area at risk of fire or explosions if the machine itself does not have the proper fire equipment.
- Using the machine in areas containing explosive materials.
- Using the machine in an inflammable area.

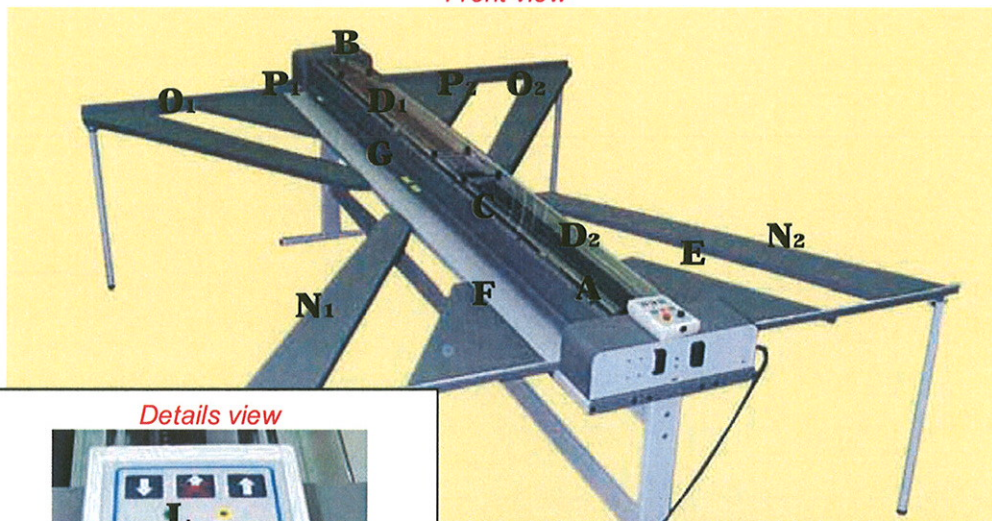
Structure of the machine

1.11.3

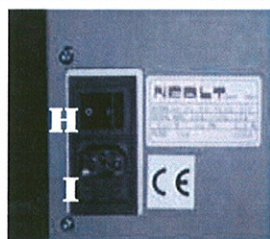
The machine includes the following parts:

A	Electronic board	L	Keyboard
B	Upper panel	M	Stop/Emergency switch
C	Sheet holder bar	N₁	Ext. low. Left section only 250/310.
D₁	Up. Plexiglas protection	N₂	Ext. low. Right section only 250/310.
D₂	Low. Plexiglas protection	O₁	Extension up. Left section only 310.
E	Low. Right feeding section	O₂	Extension up. Right section only 310.
F	Low. Left feeding section	P₁	Up. Right feeding section
G	Feeding table	P₂	up. Left feeding section
H	ON/OFF switch	Q	LASER switch
I	Power outlet	R	LASER label

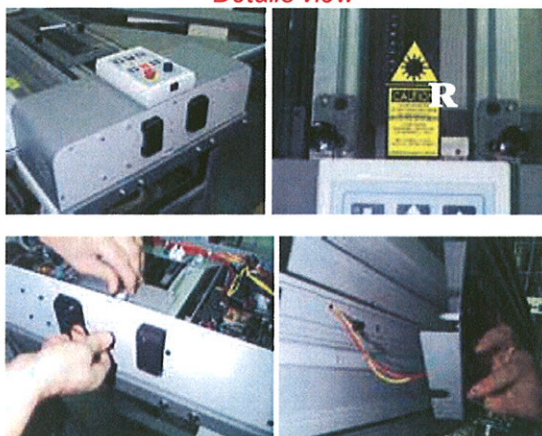
Front view



Details view



Details view



SAFETY INFORMATION**Safety criteria****2.1**

The machine has been designed and made in compliance with the essential safety criteria and regulations indicated below, and following amendments and integrations and the relating national regulations:

Low Voltage Directive	73/23/EC, 93/68/ EC
EMC Directive	89/336/ EC, 92/31/ EC, 93/68/ EC
Machine Directive	98/37/ EC, 98/79/ EC

(see *Attachment A in the user's manual, EC conformity certification*).

Thanks to the accurate analysis carried out by the manufacturer, most of the risks depending on the conditions of use of the machine, both foreseeable and reasonably foreseeable, have been eliminated.

The complete documentation including all the safety measures adopted are in the technical booklet of the machine, which is deposited at the manufacturer's premises.

The manufacturer recommends strictly complying with the instructions, procedures and recommendations of this manual and with the laws in force on the safety in the work place. This also refers to the use of the protection equipment foreseen, both those integrated in the machine and personal.



NEOLT S.p.A. cannot be held responsible for any damages to people, animals or objects due to noncompliance with the safety standards and recommendations of these documents.

Safety laws and decrees

List of personal protection equipment and safety equipment

Decree 462/01 section I general information

Regulation for the quick procedure for reporting installations and protection devices against atmospheric discharges, ground connections for electric devices and dangerous electric equipment.

Decree 2 May 2001

Criteria for the identification and use of Personal Protection Equipment (PPE).

Notice 3/2001 - Art. 2, section 4 of Law Decree n. 359/99

Information on the procedure for the periodic controls of certain work equipment.

Law 626/94 Safety and Health of workers.

Law 475/ 92 (updated on January 2, 1997) PPE

Decree 303/56 (updated on March 18, 1996) General regulations on work hygiene.

SAFETY INFORMATION**Technical specifications of LASER module (optional)****2.1.1**

Laser classification CEI,76-2

Standard CEI EN 60825-1 laser class **3 A**.

Emission <5 mW

Safety

Class **3 A**, lasers, in a wave length interval between 400 and 700 nm. do not require particular safety locks or keys for their operation. The opening of the beam through a line generation lens is < 40°. Refer to detail view page 1.6 particular **R**.

**Qualifications of the personnel****2.2**

Technical life of the machine	Qualification of the operator in charge
Transportation	Qualified transportation
Installation	Qualified personnel
Use	Qualified personnel
Ordinary maintenance	Qualified personnel
Extraordinary maintenance	Technicians appointed by NEOLT S.p.A.
Demolition	Qualified personnel

SAFETY INFORMATION**Responsibility****2.3**

✓ NEOLT S.p.A. cannot be held responsible for any damages to people, animals or objects due to noncompliance with the safety standards and recommendations of these documents.

💣 Tampering with the protections and the safety devices is dangerous for the people using the machine and for those exposed to.

✓ NEOLT S.p.A. cannot be held responsible for any damages to people, animals or objects due to tampering with the protections.

Protection**2.3.1**

The machine is provided with the following protections.

Inter-locked moving protections:

- Double magnetic microswitch lower Plexiglas protection.

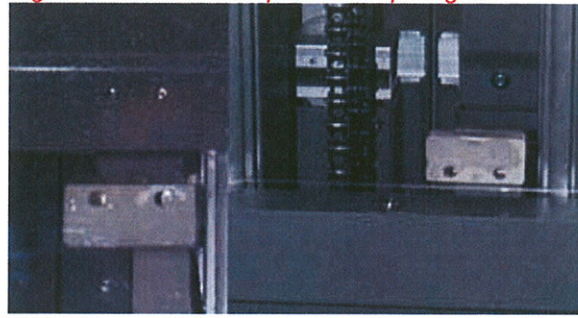
Fixed protections:

- Lower electronic panel cover.
- Upper gear cover panel.
- Upper Plexiglas protection.

SAFETY INFORMATION**Active safety devices****2.3.2**

- The machine has a Stop/Emergency button on the keyboard.
- Inter-locked protections (Plexiglas for model 160, lower Plexiglas for models 250-310).
- Two magnetic Microswitch for protection Plexiglas model 160
- Two magnetic Microswitch for lower protection Plexiglas model 250-310
- Indirect safety operation – Equipotential protection circuit.
- Optical sensor indicating media to cut.
- Two carriage end of stroke sensors.

Fig. 2.1 Microswitch protection plexiglas



Dangerous areas and residual risks**2.4**

All the areas around the machine in which people are at risk of injuries or health problems are considered dangerous.



Pay close attention to hands when the sheet holder bar is being lowered.

During certain intervention procedures on the machine, which are pointed out each time in this manual, residual risks for the operator may arise. Residual risks can be avoided by carefully complying with the procedures of this manual and using the personal protection equipment indicated in *Chapter 2.1 Safety Criteria*.

Fig. 2.2 Sheet holder bar



SAFETY INFORMATION

- Position the power cable so that it is not stepped on or ruined.
- Maintenance and service operations must be carried out only by the technicians authorized by the manufacturer
- Pay attention to the danger signs on the trimmer.
- Avoid, during operations, direct exposure on the LASER source positioned under the lower cover panel, between the two shifting bars of the carriage.
- Attention: any interventions carried out on the LASER different from those specified can cause exposure to dangerous levels of radiations

Fig. 2.3 Danger label



✓ NEOLT S.p.A. cannot be held responsible for any damages to people, animals or objects due to noncompliance with the relevant standards or incorrect use of the prescribed personal protection equipment (PPE). *Chapter 2.1 safety criteria.*

SAFETY INFORMATION**Noise****2.5**

Information on noise produced by a machine identical to the one indicated in this manual, measured according to the indications of the "Machine Directive" (98/37/EC and following amendments).

Average level of continuous pondered equivalent acoustic pressure, around the machine at one meter's distance:

- While the machine is operating: lower than 60 db.

Information on noise hazard**2.5.1**

The levels of acoustic emission indicated are not necessarily safe for the workers. The levels of exposure of the worker are obviously linked to the emission levels of the machine, however other factors affect the levels of exposure of the workers: duration of the exposure, characteristics of the area and the presence of other machines. The levels of emission of the machine, however, allow the users to assess the danger related to acoustic emissions.



A continuous use of the machine and of other machinery present in the area of installation could lead to a high level of personal daily exposure to noise.

When daily personal exposure is equal to or higher than 85 dB (A) the use of PPE is recommended (protective caps, protective ear plugs, ...).

When daily personal exposure is equal to or higher than 90 dB (A) the use of PPE is obligatory (protective caps, protective ear plugs, ...).

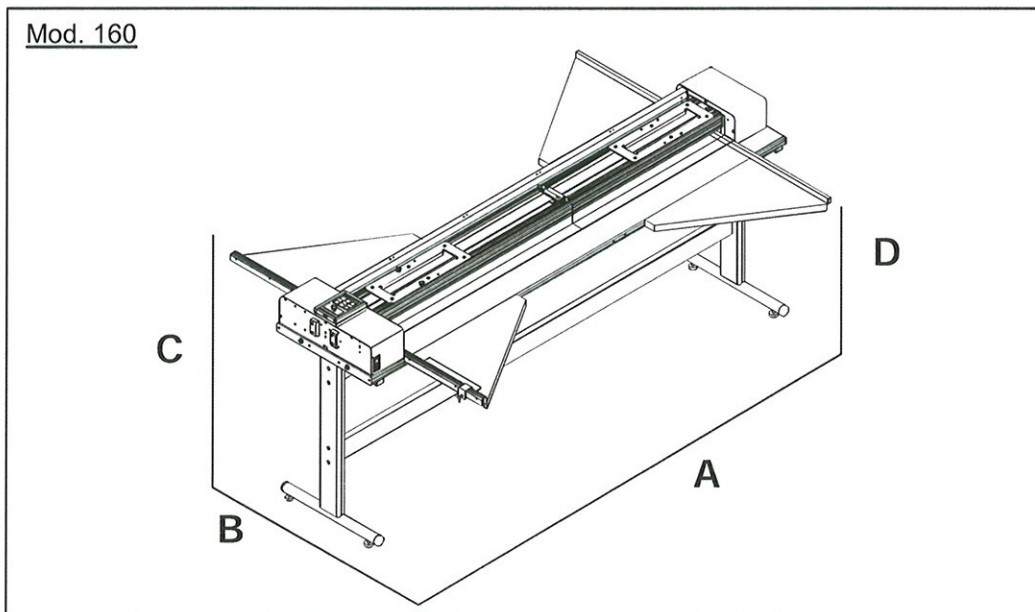
For further information on the protection measures, in Italy refer to the regulation UNI EN458 of 1995 and EN457

CHARACTERISTICS OF THE MACHINE**Technical specifications****3.1**

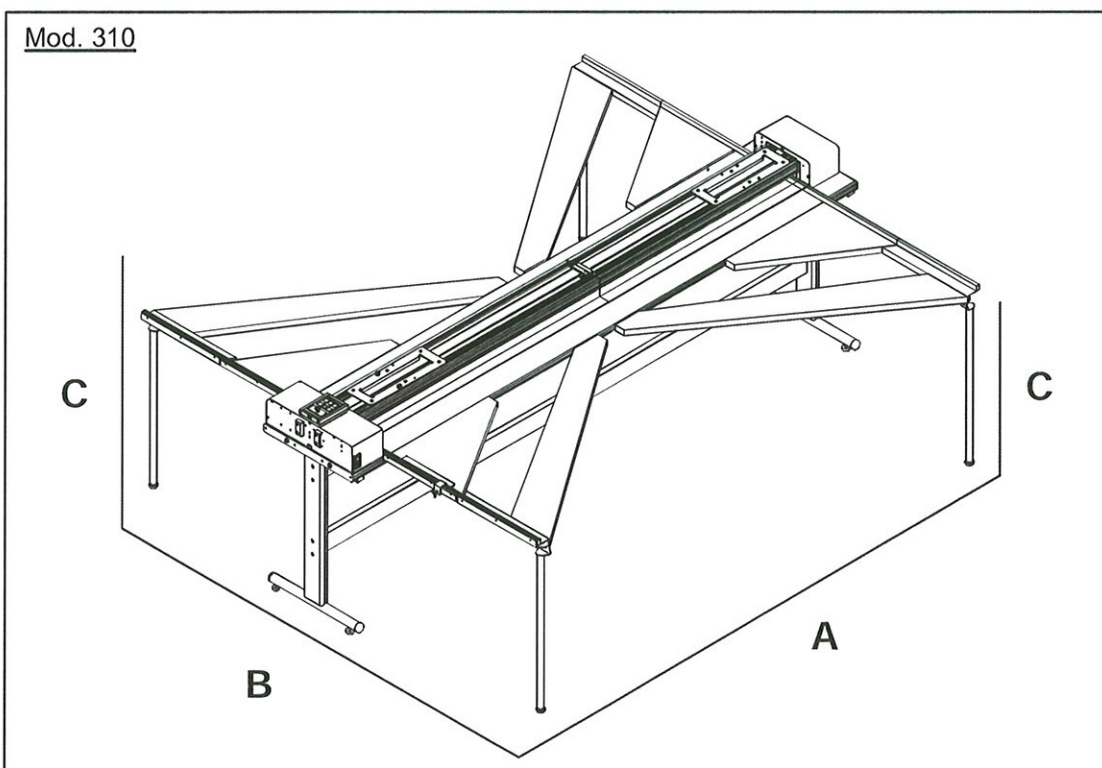
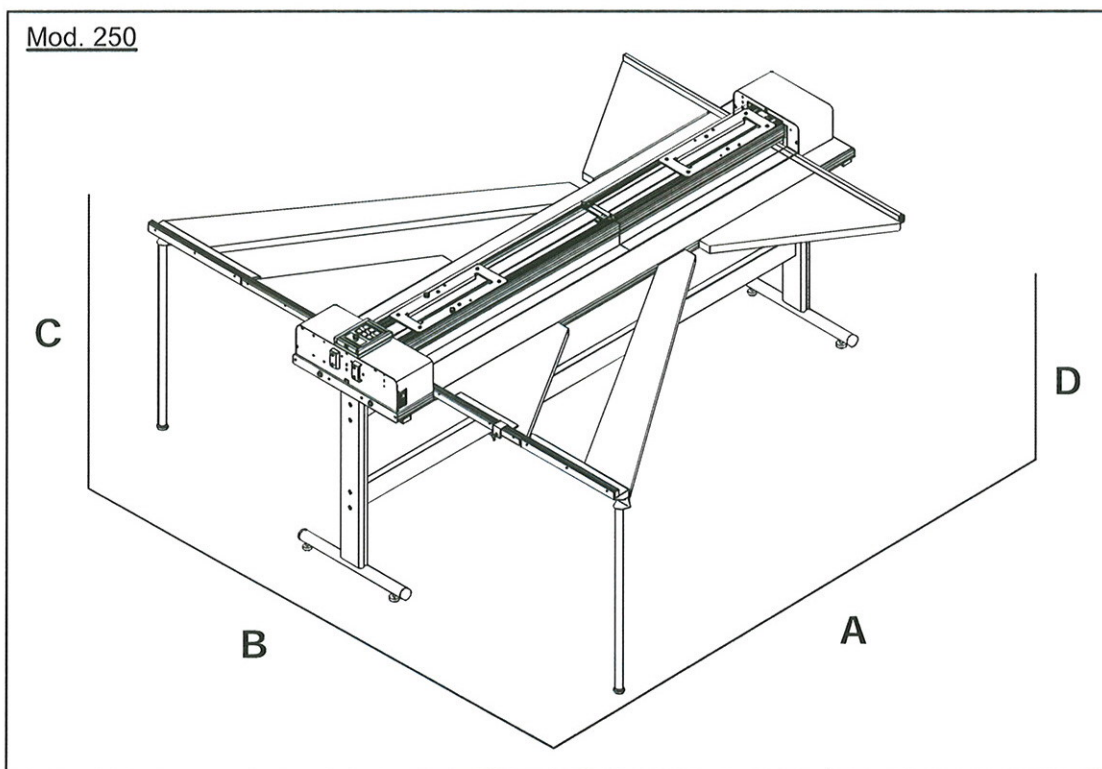
Model		1 60	250	3 10
Max. length of cut (inches)		63	98,5	122
A	Length (inches)	84,6	120	143,7
B	Width (inches)	60,6	101,6	v
C	Height with stand (inches)	45,3	45,3	45,3
D	Height work table (inches)	35,4	35,4	35,4
Weight of machine (Lbs.)		198,4	286,6	330,7
Weight of stand (Lbs)		26,5	33	44
Allowed media		See list in <i>Chapter machine performances 3.3</i>		
Cutting speed		From 0 to 0,65 feet/sec		

HORIZONTAL ELECTRO FOAM TRIM PLUS: electric trimmer with fixed blade cutting head made of tempered steel, assembled on a double sliding bar to cut media like FOAM and FOREX®. Control pushbutton panel. Adjustment using the carriage speed potentiometer according to the type of media to trim. Metal parts painted with epoxy powders, gray RAL 7035. Four cutting heads for four cutting thickness 5-10-20-30 mm for the different types of material. Including, reference brackets, stand, electric sheet holder to block the media to cut with open and close controls on keyboard, side extensions and laser tracer.

Mod. 160



CHARACTERISTICS OF THE MACHINE



CHARACTERISTICS OF THE MACHINE**Power supply data****3.2**

- Voltage and single-phase frequency: 230V/240V – 50Hz/60Hz – (110V/ 50-60Hz).
- Absorption: max. 1.4A – (max. 2.5A).

**Responsibility**

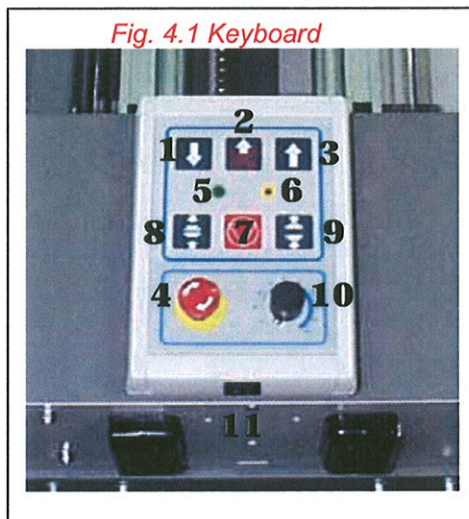
NEOLT S.p.A. cannot be held responsible for problems, defects that should take place due to non-compliance with the power supply values supplied.





Machine performances**3.3**






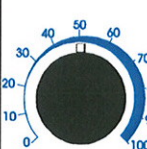
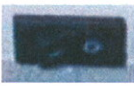
<i>Material</i>	Horizontal Electro FOAM Trim plus
	Max. cutting thickness 1,2 inches
Corex	X
Cork	X
Foamboard	X
Hardboard	X
Magnetic Vinyl	X
Mountboard	X
Polystyrene	X
Gatofoam	X
Foamex	X
Forex®	(MAX 0,4 inches)

Description of commands**4.1**

The keyboard has easy-to-use command and programming keys.
Switch on the machine and follow the sequence below to use the operating keys.



Key	Description
1 	Cut Key Press this key to start the cutting key. When the carriage is moving the green led of the key lights up
2 	"Special" Key Press this key only when the "Special Blade" blade holder is being used. The operation of the key depends on the closing of the sheet holder and on the engagement of the microswitch indicating the presence of the media to cut.
3 	Carriage Up Key Press this key to bring the blade holder carriage up. The green led of the key lights up
4 	Stop/Emergency Key When this key is pressed all the operations of the machine. Rotate key from left to right to unlock.

Key	Description
5 	Green led The led switches on when the machine is powered, it flashes during the sheet holder's open and close movements.
6 	Yellow led The led switches on and flashes when a wrong command is given. The led flashes when the command is not reset. The led lights up as the sheet holder is being closed when it is in position.
7 	Reset or stop key Use this key to cancel the operation when a wrong command is given or to stop an operation underway.
8 	Sheet holder close key Press this key to start closing the sheet holder, when the key is released the sheet holder stops. The sheet holder is in position when the yellow led lights up. If the sheet holder is not in position the cut cannot be performed.
9 	Sheet holder open key Press this key to start opening the sheet holder. This key offers two possibilities. Press once to automatically open up to end of stroke, press again to stop the sheet holder's travel. BY keeping it pressed for more then three seconds when the key is released the sheet holder stops.
10 	Potentiometer speed control knob Adjust the potentiometer to control the up and down carriage speed. This allows the operator to obtain a more effective and precise cut, especially for harder media.
11 	LASER tracer system ON/OFF switch When this switch is pressed a light beam is activated to indicate the position of the cut.

INSTALLATION

Qualifications of the operator**5.1**

The transportation, installation and connecting operations of the machine must be carried out by qualified personnel only, transporters and electricians.

Transportation**5.2****Transportation conditions****5.2.1**

The trimmer is shipped with a carton packaging 1 to protect the panels on the top ends and a box 2 which holds everything. (*Fig. 5.1*) *Transportation conditions*. The box contains the standard side extensions, the lower stand, the stand for model 160, or the wall assembly components for models 250-310, the tool bag needed to complete the few installation operations of the machine and the user's manual.

The size of the packaging and its total weight (packaging and trimmer) are as follows

Model	160	250	310
Dimensions (inches)	92,5Lx26,8Px16,9H	128Lx24,8Px28H	149,6Lx24,8Px28H
Weight (gross – Lbs.)	264,5	374,8	485



The hoisting, transportation and handling operations of the machine or its parts must be exclusively carried out by competent personnel, properly trained for the task.



It is absolutely forbidden to pass or stop under hanging loads.

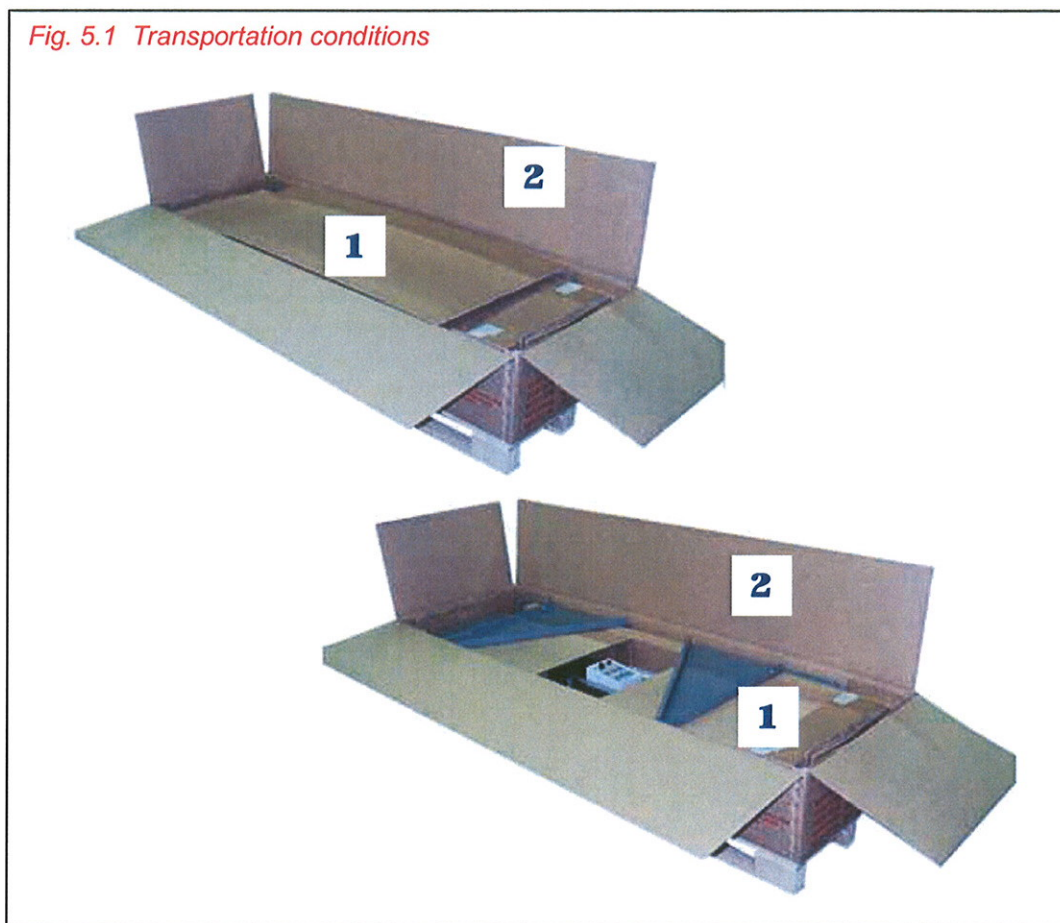


The machine hoisting, transportation and handling means must be adequate for the weight of the machine and the size of the elements to lift, transport and handle and must comply with the laws in force in the area of installation.



Protect the machine from external atmospherics, see paragraph *Characteristics of the machine* in 5.7.1.

Fig. 5.1 Transportation conditions



Assessment of damages during transportation

5.2.2

Check the conditions of the machine by visually inspecting it, after having removed it from the shipping box. Any defects on the visible parts of the machine indicate crashes during transportation, which could also affect the normal operation of the machine.

Especially assess the conditions of these parts:

- *Stop/Emergency Key* and keyboard.
- Potentiometer carriage speed adjustment.
- Keyboard.
- Carriage Plexiglas protection for model 160.
- Carriage Plexiglas protection, upper and lower for models 250-310.
- Side extensions and guides for side extensions.

Make sure the screws and nuts of the covering panels are tight.

Assembly**5.3****Assembly of stand****5.3.1**

- Open the packaging box **2** which contains all parts (**Fig. 5.1**).
- Remove carton protections **1** (**Fig. 5.1**). Remove all free parts that may hinder the machine placing operations.



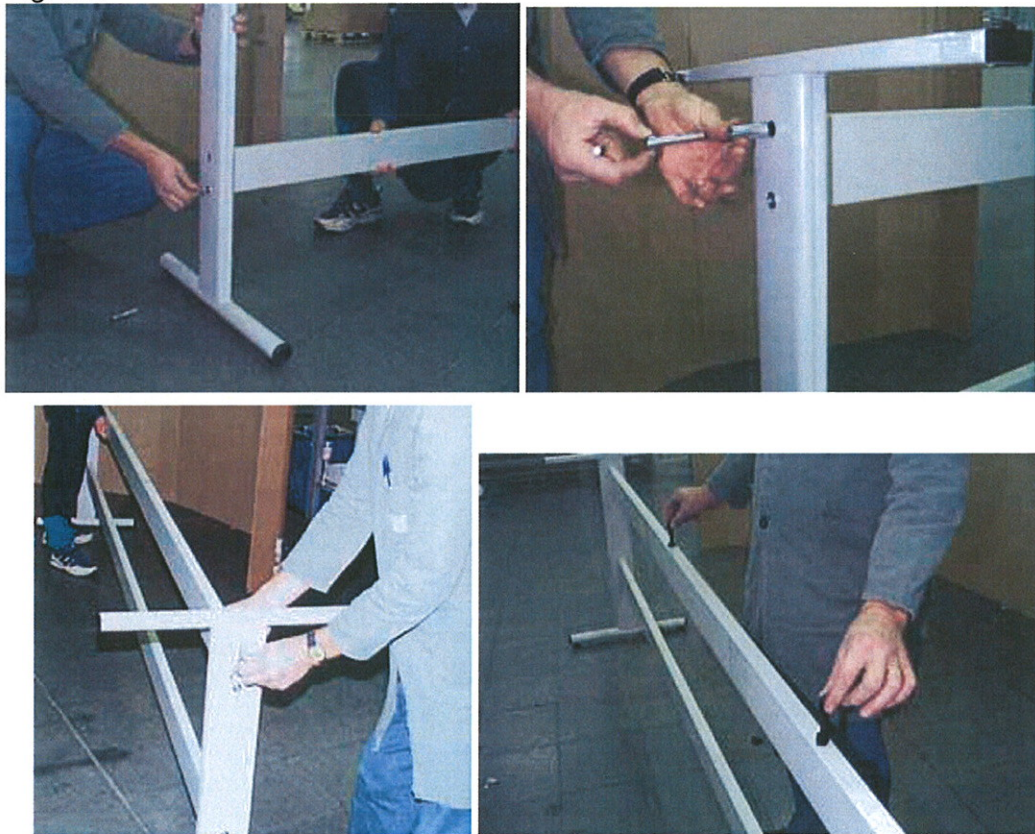
This operation must be carried out by at least two people.



Attention the shoulder has holes with different diameters, the side with the holes of a bigger diameter must face outwards.

- Assemble the stand by first screwing on the lower cross-bar to the shoulder using the screws and bushes supplied. (**Fig. 5.2**).

Fig. 5.2



INSTALLATION

- Screw the upper cross bar (**fig. 5.2**) to the shoulders as for the lower one, using the supplied screws and bushes. (**fig. 5.2**).



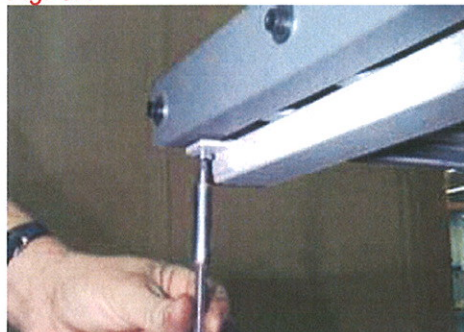
Attention when assembling the upper cross bar, make sure the holes for the adjustment pins of the work table are facing upward (**fig. 5.2**). For calibration see paragraph *Adjustment of cutting table* 5.4.

- Put the two table adjustment pins in the holes of the upper cross bar. (**Fig. 5.2**).



This operation must be carried out by at least four people.

- Remove the trimmer from the carton packaging and place it on the table that has just been assembled, fix the trimmer to the table, with the four cross screws supplied. (**Fig. 5.3 Fig. 5.4**).

Fig. 5.3**Fig. 5.4**

Assembly of side extensions mod.160

5.3.2

There are four side extensions for model 160, two in the upper and two in the lower part (the **lower side** being the position of the operator with the command keyboard in front).

- Remove the four extensions from the box (there are two extensions with millimetric scale guide, which will be assembled on the lower side. And two extensions without millimetric scale that shall be positioned on the upper side.

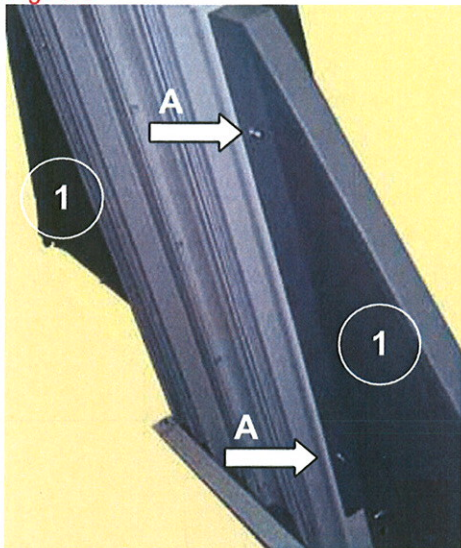
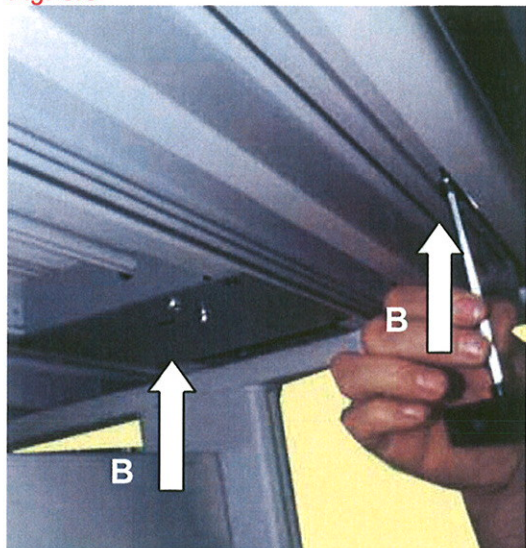
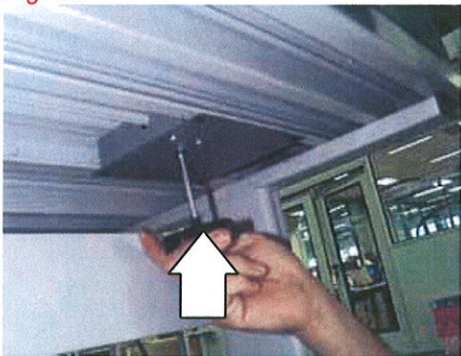


At least two people must carry out this operation



Start the assembly of the extensions from any side. As reference we shall start from the left of the keyboard.

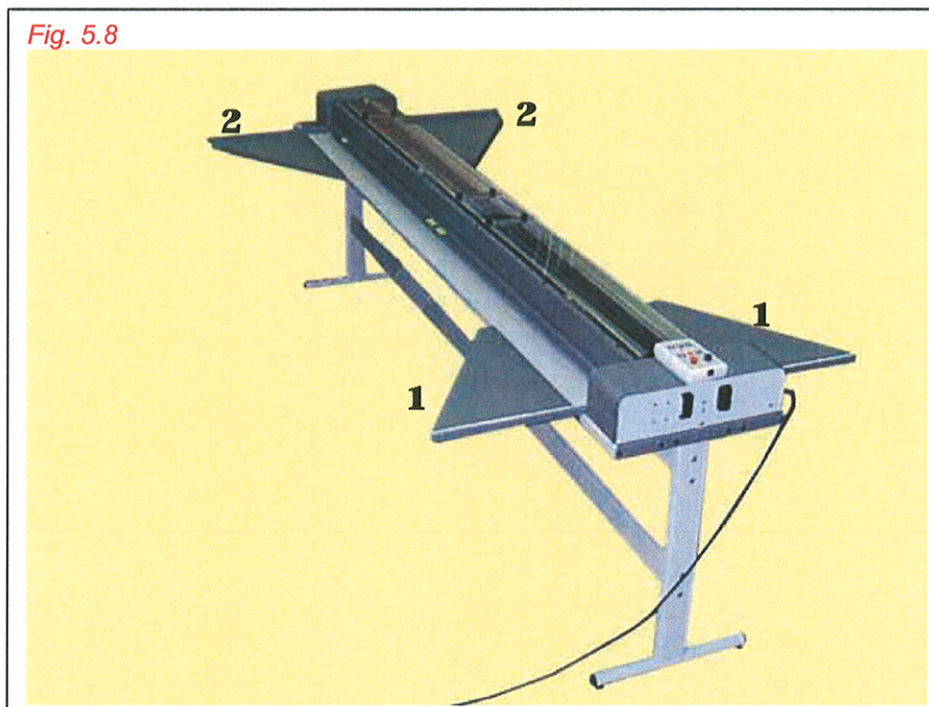
- Position the extensions with millimetric scale **1**, on the lower side of the machine, fixing them to the side of the machine work table, with the supplied screws **A** (*Fig. 5.5*).
- Screw the guide on both parts, fixing it with the screws **B** to the work table (*Fig. 5.6*). Attention: one of the screws must be put into a hole in the protection panel of the sheet indicator optical sensor (*Fig. 5.7*).

Fig. 5.5*Fig. 5.6**Fig. 5.7*

INSTALLATION

- Position the extensions with the guide without millimetric scale **2**, on the upper side of the machine (**Fig. 5.8**), fixing them to the side of the work table of the machine, with the supplied screws **A** (**Fig. 5.5**).
- Fix the guide on both sides, by tightening the screws B to the work table (**Fig. 5.6**).

Fig. 5.8

**Assembly of side extensions mod. 250****5.3.3**

There are six side extensions for model 250, two in the upper and four in the lower part (the **lower side** being the position of the operator with the command keyboard in front).

- Remove the six extensions from the box (there are four extensions with millimetric scale guide, which will be assembled on the lower side. And two extensions without millimetric scale that shall be positioned on the upper side).



At least two people must carry out this operation.



Start the assembly of the extensions from any side. As reference we shall start from the left of the keyboard.

INSTALLATION

- Position the extensions with millimetric scale **1**, on the lower side of the machine, fixing them to the side of the machine work table, with the supplied screws **A** (Fig. 5.9).
- Screw the guide on both parts and the extension **3** (Fig. 5.12), fixing it with the screws **B** to the work table and the extension **1** (Fig. 5.10). Attention: one of the screws must be put into a hole in the protection panel of the sheet indicator optical sensor (Fig. 5.11).

Fig. 5.9

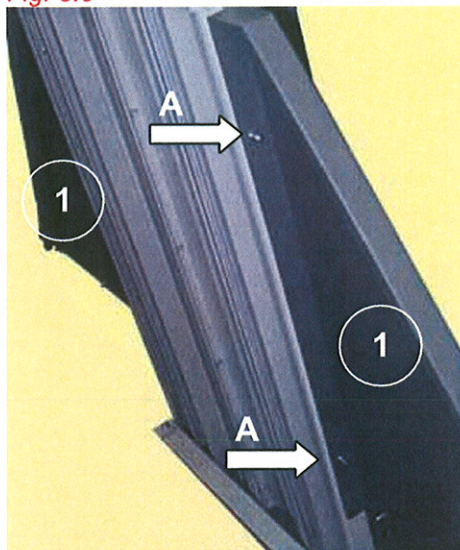


Fig. 5.10

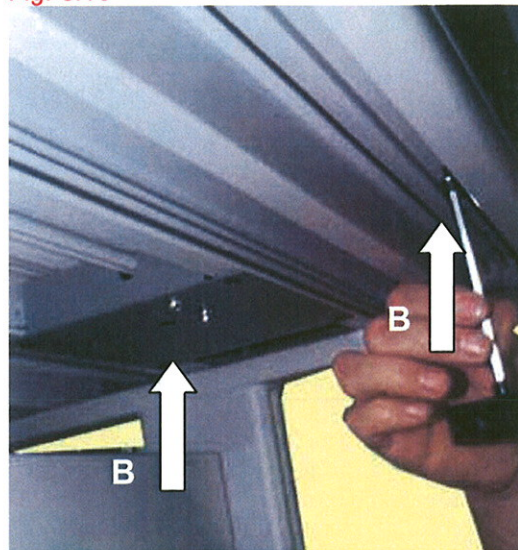


Fig. 5.11

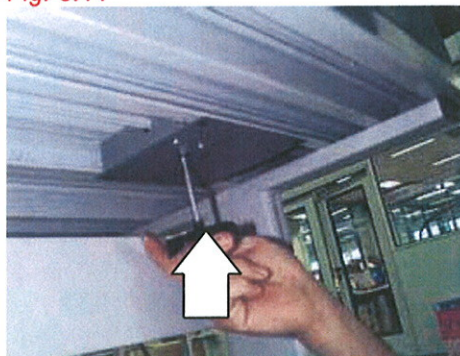
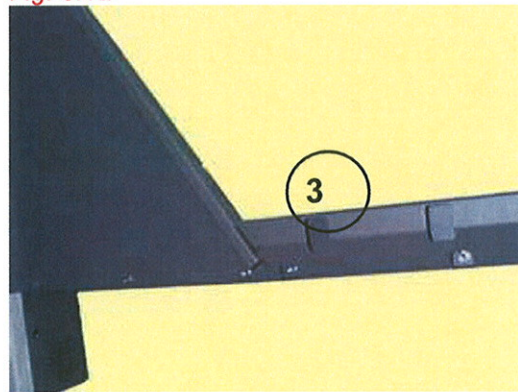


Fig. 5.12



INSTALLATION

- Use the supplied screws to fix the extension **4**, on the right and left, to the work table (**Fig. 5.13**). Put the extension on the guide stand extension **3** positioned previously with the two supplied screws (**Fig. 5.14**).

Fig. 5.13

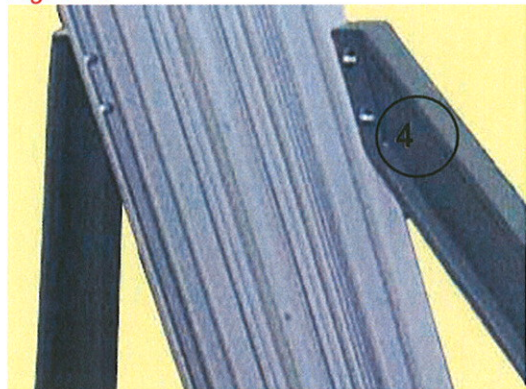
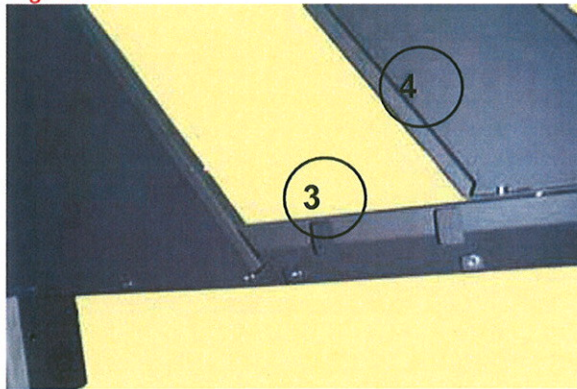


Fig. 5.14

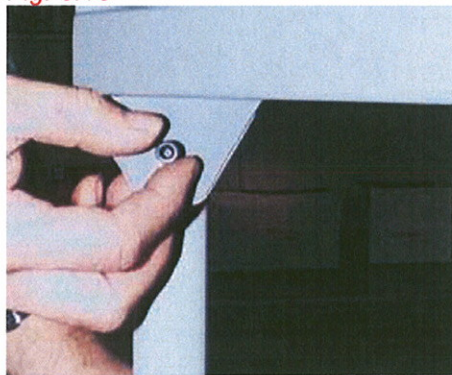


- Then fix the supporting legs to the side extensions (**Fig. 5.15**).
- Screw the foot to the extension with the supplied screws (**Fig. 5.16**).

Fig. 5.15

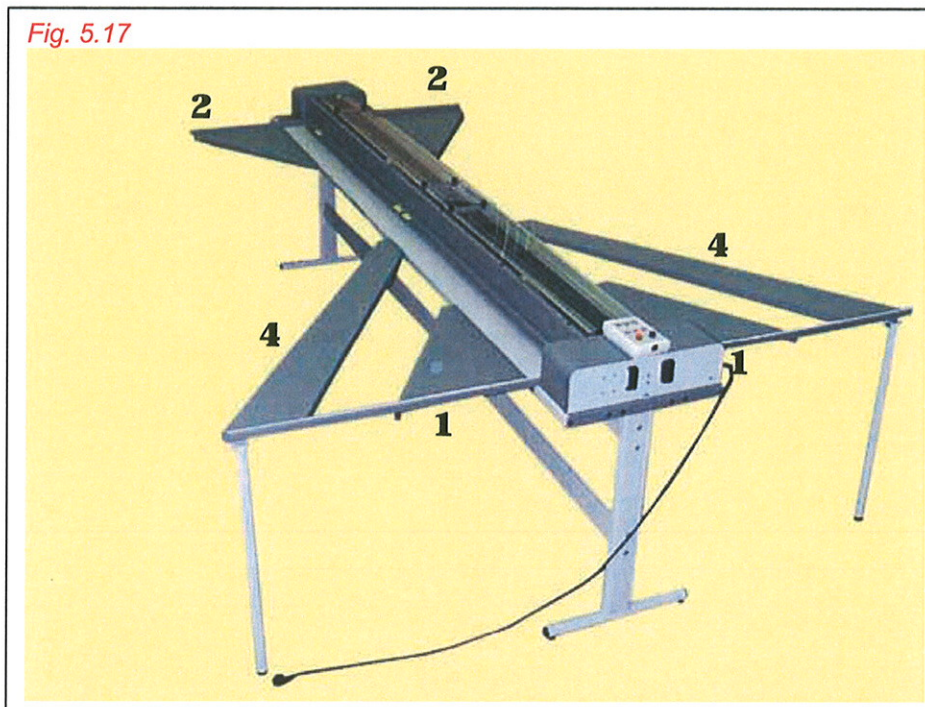


Fig. 5.16



INSTALLATION

- Position the extensions with the guide without millimetric scale **2**, on the upper side of the machine (**Fig. 5.17**), fixing them to the side of the work table of the machine, with the supplied screws **A** (**Fig. 5.9**).
- Fix the guide on both sides, by tightening the screws B to the work table (**Fig. 5.10**).

Fig. 5.17**Assembly of side extensions mod.310****5.3.4**

There are eight side extensions for model 310, four in the upper and four in the lower part (the **lower side** being the position of the operator with the command keyboard in front).

- Remove the eight extensions from the box (there are four extensions with millimetric scale guide, which will be assembled on the lower side. And four extensions without millimetric scale that shall be positioned on the upper side).



At least two people must carry out this operation.



Start the assembly of the extensions from any side. As reference we shall start from the left of the keyboard.

- Position the extensions with millimetric scale **1**, on the lower side of the machine, fixing them to the side of the machine work table, with the supplied screws **A** (Fig. 5.18).
- Screw the guide on both parts and the extension **3** (Fig. 5.21), fixing it with the screws **B** to the work table and the extension **1** (Fig. 5.19). Attention: one of the screws must be put into a hole in the protection panel of the sheet indicator optical sensor (Fig. 5.20).

Fig. 5.18

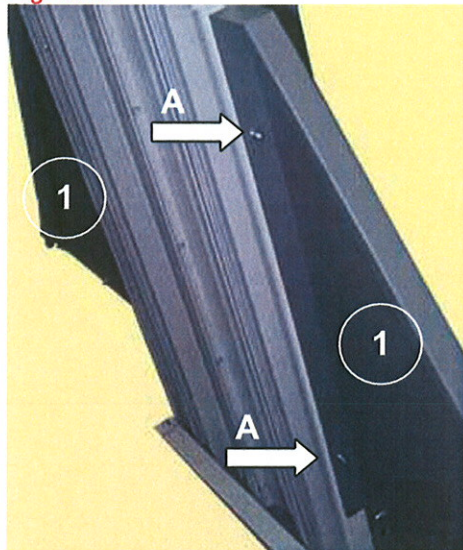


Fig. 5.19

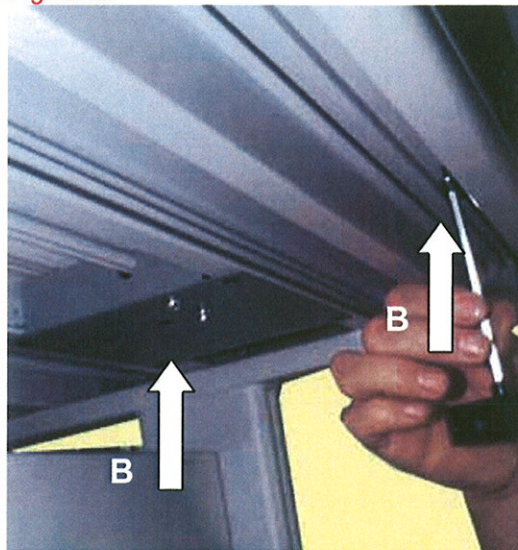


Fig. 5.20

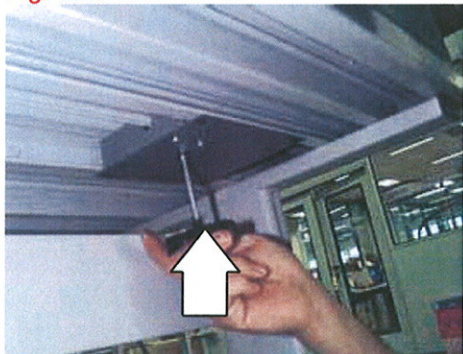
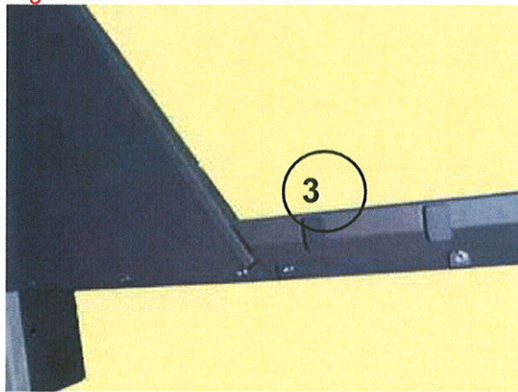


Fig. 5.21



- Use the supplied screws to fix the extension **4**, on the right and left, to the work table (**Fig. 5.22**). Put the extension on the guide stand extension **3** positioned previously with the two supplied screws (**Fig. 5.23**).

Fig. 5.22

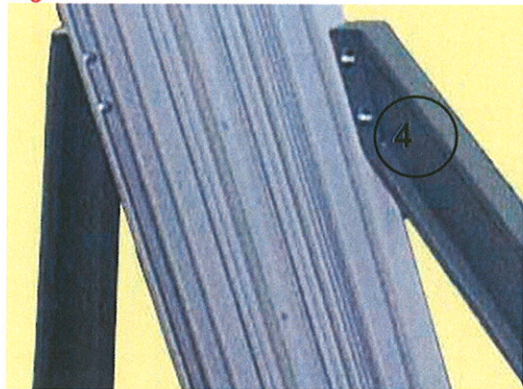
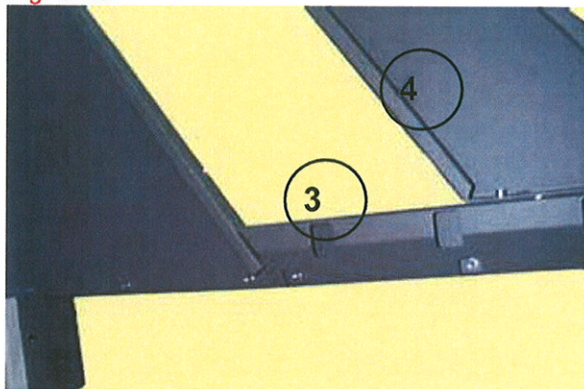


Fig. 5.23

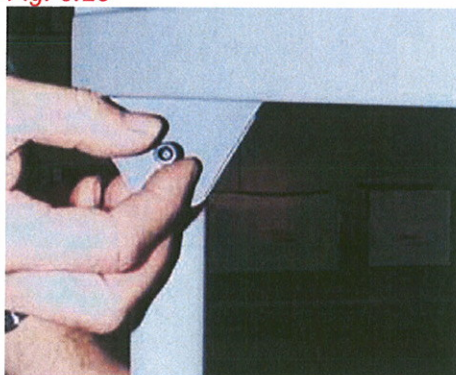


- Then fix the supporting legs to the side extensions (**Fig. 5.24**).
- Screw the foot to the extension with the supplied screws (**Fig. 5.25**).

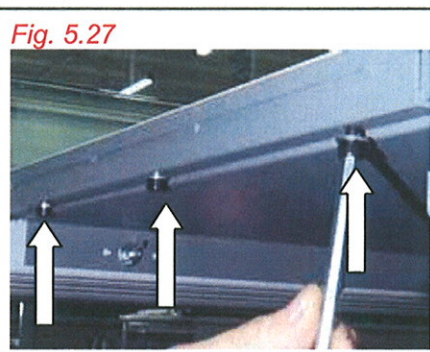
Fig. 5.24



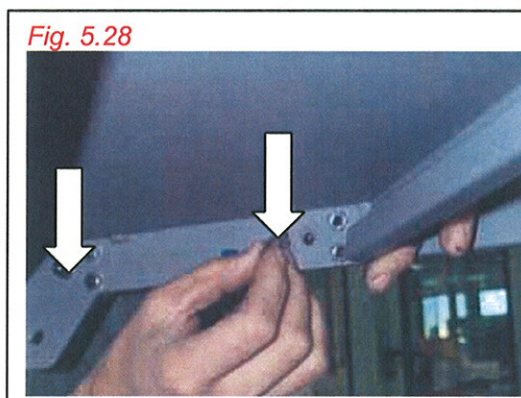
Fig. 5.25



- Position the extension with the guide without millimetric scale **2**, on the upper part of the machine (**Fig. 5.31**), fixing them to the side of the work table, using the supplied screws **A** (**Fig. 5.18**).
- Fix the guide on both sides, fixing it with the screws **B** to the work table (**Fig. 5.19**).
- Position the further extension of the upper extension **5**, in section 2, (**Fig. 5.26**), fixing it using the three supplied screws (**Fig. 5.27**).

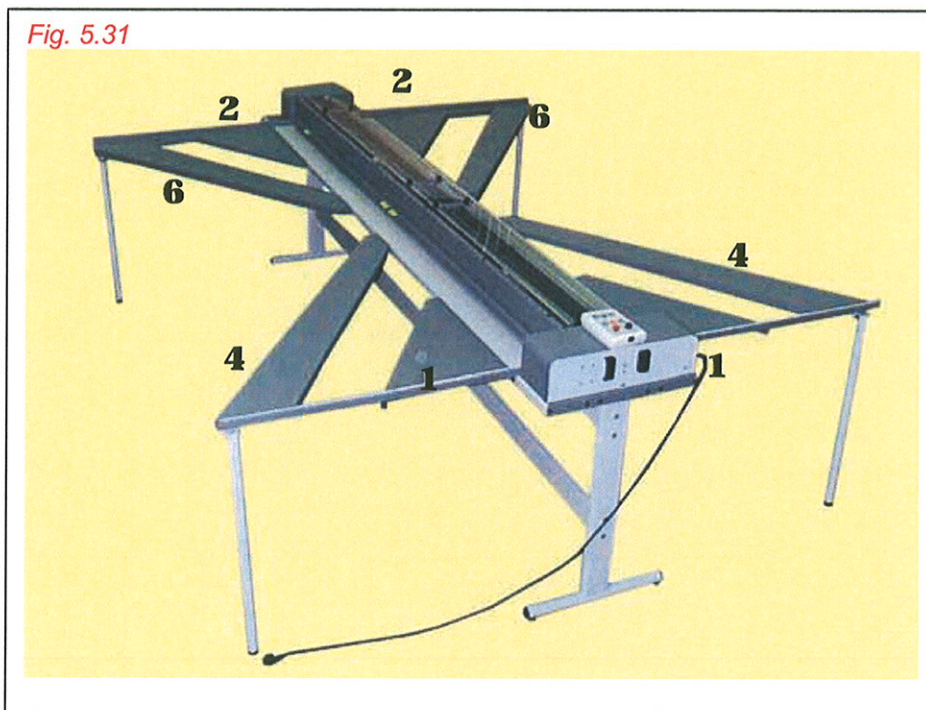


- Fix the extension using the supplied screws **6**, both on the right and left, to the work table (**Fig. 5.31**). Put the further extension on the guide extension **5** assembled previously using the two supplied screws. (**Fig. 5.28**).



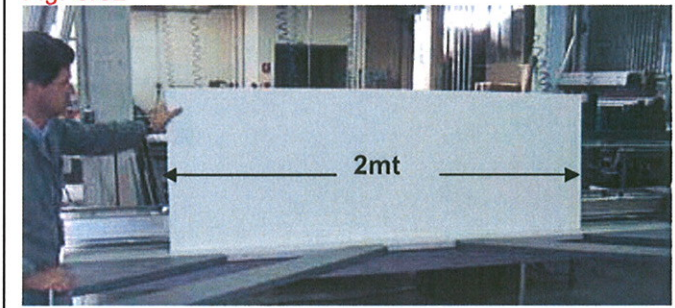
- The fix the supporting legs to the side extensions (**Fig. 5.29**).
- Screw on the leg to the extensions with the supplied screws (**Fig. 5.30**).



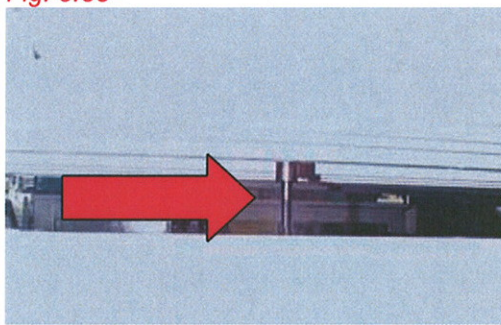
Fig. 5.31

Adjustment of cutting table**5.4**

- Connect the trimmer and trim a foam sheet about 2 Mt. long.

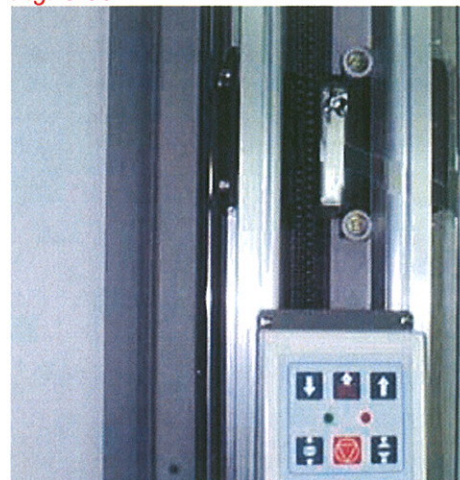
Fig. 5.32

- Position the trimmed foam profile on the table (*Fig. 5.32*).
- Follow this procedure to verify the parallelism between the table and the foam sheet:
- Adjust the rods placed under the table, (*Fig. 5.33*) until you reach the desired parallelism.
- Position the reference bracket on the millimetric guide stand (*Fig. 5.34*)

Fig. 5.33*Fig. 5.34*

Assembly of blade holder carriage**5.5**

- Press the *Up Key* to place the carriage (**Fig. 5.35**) in a central position right above the keyboard.
- Remove the protection Plexiglas (**Fig. 5.37**) using the screws (**Fig. 5.36**).

Fig. 5.35*Fig. 5.36**Fig. 5.37*



Wear protection gloves while assembling the blades because they are very sharp.

- Assemble the blade (**Fig. 5.38**) on the desired carriage (2 types supplied 20-30 mm plus 2 special of 5-10 mm.).

Fig. 5.38



To cut material with thickness between 5 and 10 mm, use the "Special" blade-holder. See procedure *Assembly of "Special" blade holder carriage 5.5.1.*

- Put carriage in proper seat, be careful to position the blade in the cutting slot (**Fig. 5.39**) of the table and tighten the two supplied screws (**Fig. 5.40**).

Fig. 5.39

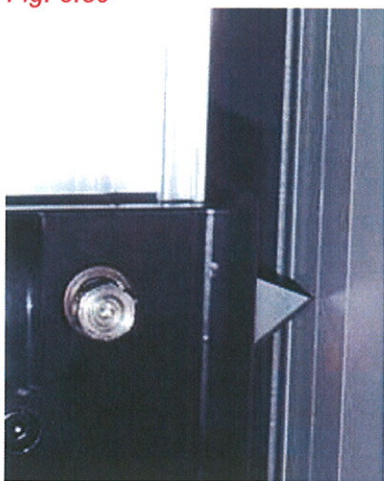
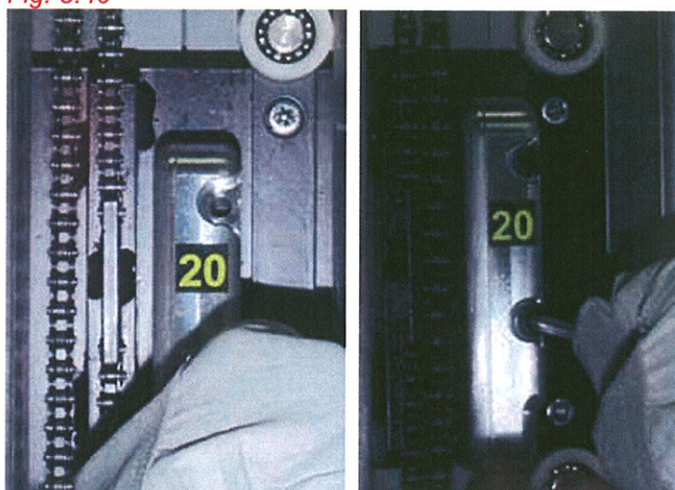


Fig. 5.40



- Reassemble the protection Plexiglas (**Fig. 5.37**) using the screws (**Fig. 5.36**).
- Connect the trimmer to a grounded outlet and not use any type of adaptor between the plug of the trimmer (**Fig. 5.41**) and the power outlet.
- Set the ON/OFF switch to ON. (**Fig. 5.42**).

Fig. 5.41

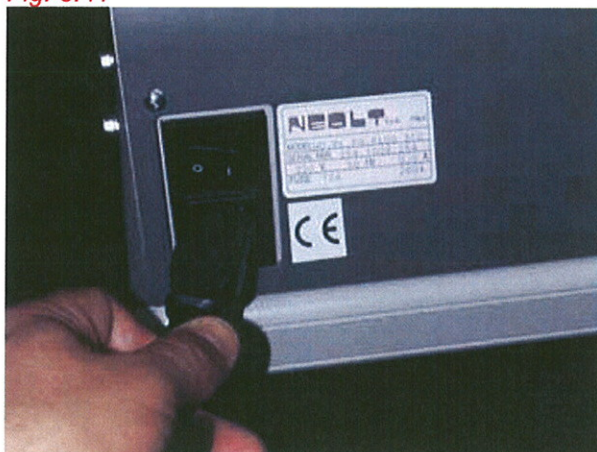
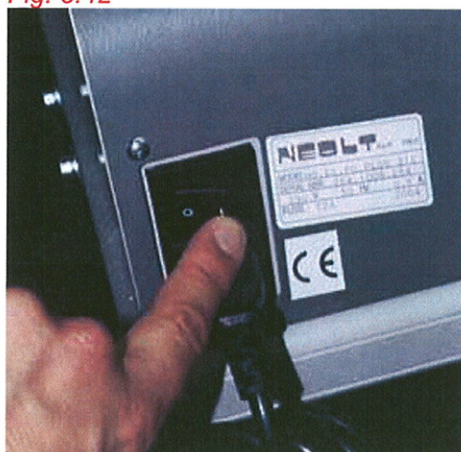


Fig. 5.42



No other adjustments are necessary because the machine is factory tested.

Assembly of "Special" blade holder carriage**5.5.1**

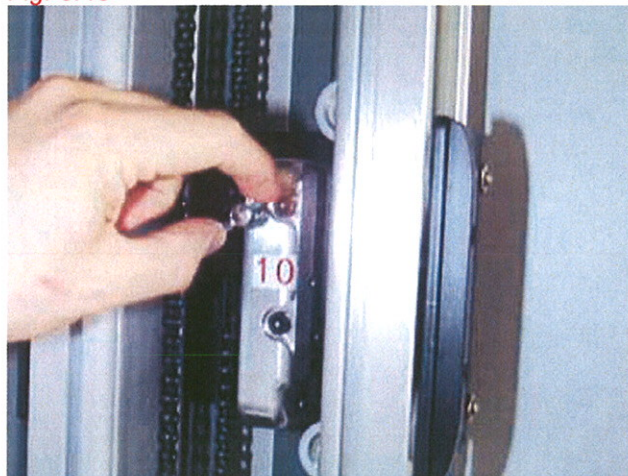
The installation and blade change modalities are the same of those indicated in the section *Assembly of blade holder carriage 5.5*.



Use only special blades on this type of blade holder.

The special blade-holder can work on the pressure of the blade through an adjustment screw (**Fig. 5.43**). See paragraph "*USE OF Special BLADE-HOLDER CARRIAGE 6.1.4*" for the correct use of the blade holder.

Fig. 5.43



Storage**5.6**

The indications contained in this section must be followed during the periods of temporary storage of the machine which could take place in the following situations:

- When the machine is not installed immediately after it is delivered.
- When the machine is disconnected and stored while waiting for it to be relocated.

For as much as possible the machine must be stored so that unauthorized personnel cannot access it. It must be protected against the possible damages due to dust, humidity, heat, cold, sun rays or other substances that could corrode or attack it.

The storage area must not be near dangerous areas.

Characteristics**5.6.1**

- Temperature interval: from -5°C to +55°C, maximum temperature for short periods.
- Humidity interval: from 30 % to 95% without condensate. Ideal humidity ~55%.
- Proper natural and/or artificial illumination.
- Proper protection from atmospherics.
- Adequate space to carry out the hoisting and transportation operations in a safe and easy way.
- Horizontal surface with a capacity higher than the mass of the machine.
- Adequate space to carry out ordinary maintenance and technical operations.

INSTALLATION

Placing of the machine**5.7**

Characteristics of the area the machine is placed in**5.7.1***Power supply*

The area where the machine is installed must be equipped with the power supply connections described in 3.2 *Power supply data*.

Space requirements

For the normal use of the machine and the loading and unloading operations, it is important to have an area directly proportional to the size of the media to cut.

Protection from atmospherics

The machine must be placed in a suitably protected room, away from atmospherics.

Floor requirements

Prepare the stable horizontal surface of the machine keeping in mind the mass of the machine itself. Also take into account all extra accessories.



Optimal stability and using conditions can be obtained with a maximum planarity error of \pm ... mm/m. Furthermore the machine must be balanced off by using back wheels. Furthermore the maximum inclination of the floor must not exceed 10° inclination.

Illumination

A good illumination is necessary to safely use and carry out maintenance operations (approximately 200 - 600 lux), according to standard UNI10380:1994.

Atmospheric characteristics of the area

- Temperature range: from 18°C to 35°C.
- Humidity range: from 30 % to 95% without condensate. Ideal humidity ~55%, with maximum temperature 40°C.

General characteristics of use

- The machine must not be used near explosive atmospheres
- The machine must not be used with acids, corrosive agents, salt, etc.
- The machine must not be used with ionizing and non-ionizing radiations (X-rays, microwaves, ultraviolet rays).

INSTALLATION

Electric wiring**5.7.2**



Verify that the electric distribution line is adequate for the power of the machine.



Electric hazards. Connect machine to a ground outlet before carrying out any other connection to the mains.

- Position the power cable so it is not stepped on and ruined.
- Do not put the power cable where it can be damaged.
- Maintenance and service operations must be performed only by the technical service authorized by the producer.
- Disconnect the electric line that powers the machine.
- If the disconnection device is the power cable, the power outlet must be easy to access and right by the machine.
- Power the line that powers the machines.

The electric power system of the machine must include:

- Protection against over-currents, through devices with intervention current, sized taking into account the maximum absorption of the machine.
- An intervention device for isolation defects (differential) with label data sized properly for the type of the machine.
- An external equipotential protection circuit (ground connections) adequate and complaint with the laws in force in the country of installation of the machine.

Testing**5.7.3**

Before using the machine continuously check the general operation of the machine by doing some trial cuttings.



If there are vibrations or unusual noise, immediately switch off the machine and contact the **NEOLT** technical assistance center, see *Identification data of manufacturer 1.5*.

Qualifications of the operator

6.1

The machine must be used by qualified personnel only

Place of work

6.1.1

Position of the operator: during the start up and cutting operations in front of the machine with control panel in the center. During maintenance operations the position depends on the specific operation that needs to be carried out.

Switching the machine on

6.1.2

The main switch is located on the right side of the electronic panel. When the main switch is set to ON the trimmer is ready for the cutting operations.

Feeding the media to cut

6.1.3

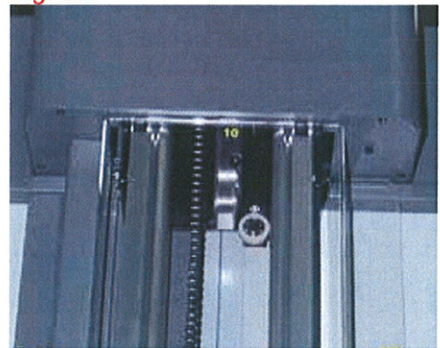
Follow the steps below to begin the process:

- Bring carriage up using the *Carriage Up Key* (**Fig. 6.1 - 6.2**).

Fig. 6.1



Fig. 6.2

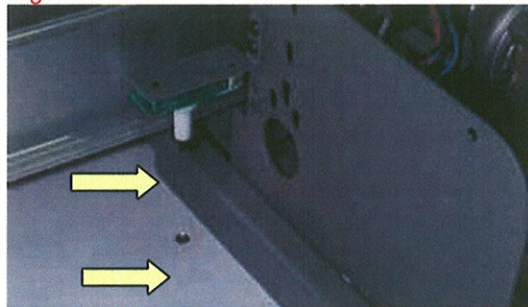
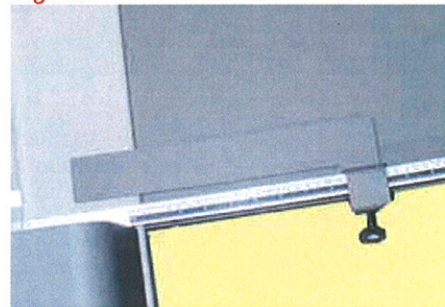


The cut is made vertically from top to bottom (not vice versa) and only with the Cut Key.



Before starting any cutting operations we suggest making sure the carriage is right for the thickness of the panel to cut. This will prevent low or high cuts.

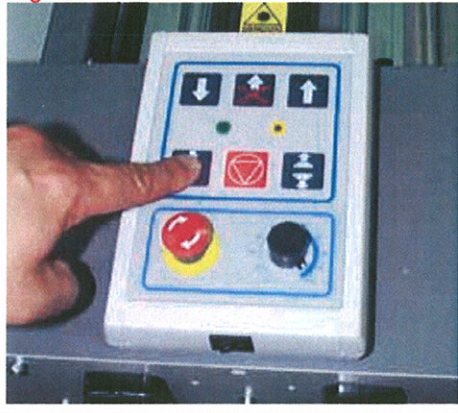
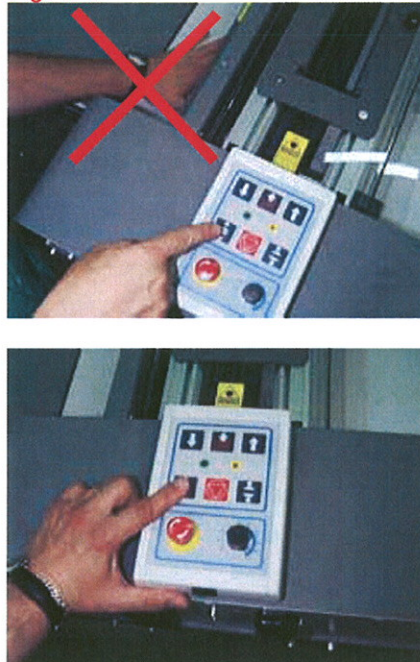
- Position the panel on the left extension and make sure the optical sensor is covered (*Fig. 6.3*). Use the reference brackets to select (*Fig. 6.4*) the desired cutting sizes.

Fig. 6.3*Fig. 6.4*

- Lower the sheet holder bar using the relevant key (*Fig. 6.5*).



Pay attention to position of hands (*Fig. 6.6*).

Fig. 6.5*Fig. 6.6*

Keep key pressed to close the sheet holder until the yellow led lights up.
If the yellow led does not light up, the cut cannot be performed.

USE

- Before performing the cut, adjust the speed of the carriage (**Fig. 6.7**). We suggest keeping very low speeds to cut very hard and rigid material.
- Press the *Cut Key* to perform the cut (**Fig. 6.8**) and lift the sheet holder bar pressing the key (**Fig. 6.9**). Press the key once to open the sheet holder in automatic modality, press the key for more than three seconds to block it when the key is released.

Fig. 6.7



Fig. 6.8



Fig. 6.9



- Remove both the original part and the cut part from the table.
- Follow the above mentioned procedure to perform a new cut.



As the carriage is moving up, it is not necessary for the carriage to reach the upper end of stroke, just oppress the *Stop Key* when the height of the panel to cut has been reached. The press the *Cut Key* to perform the key.



We highly recommend not leaning against or putting any object on the feeding table.

To cut a panel with limitations on the panel itself, use the laser tracer to line the panel cutting line with the machine cutting line.

Follow this procedure to use the laser tracer:

- Switch on the LASER pressing the ON/OFF switch in front of the keyboard. **Attention** the Plexiglas protection must be in position when the LASER is on
- Follow the above-mentioned procedure to feed the panel to trim
- Line up the cutting limits with the laser light
- Block the panel with the sheet holder bar and cut the panel following the procedure described previously.

Use of the "Special" blade holder carriage

6.1.4

Follow this procedure, to cut "soft" materials:

- Remove the Plexiglas shield.
- Rotate the adjustment screw **clockwise** (**Fig. 6.11**) up to the end of stroke, so that the blade penetrates in the relevant slot of the feeding table (**Fig. 6.10**).
- Re-assemble the Plexiglas shield.
- Adjust the speed of the carriage and press the **Cut Key** to cut the media.

Fig. 6.10

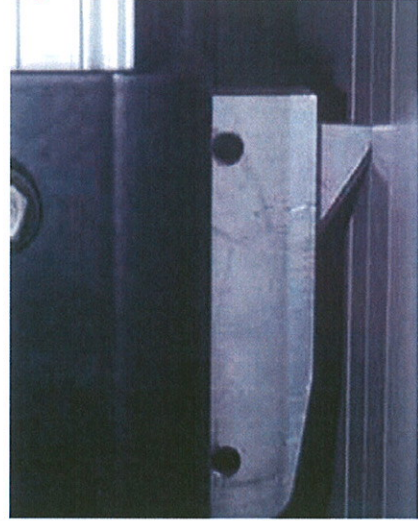
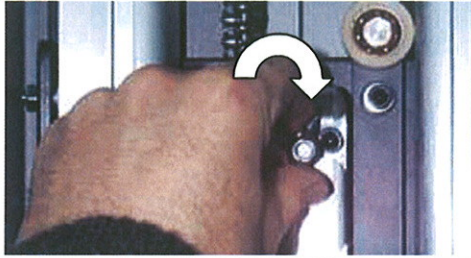


Fig. 6.31



Follow this procedure, to cut "hard" materials (PVC SEMI-FOAM):

- Remove the Plexiglas shield.
- Rotate the adjustment screw **counter-clockwise** (**Fig. 6.12**) until the blade reaches the position indicated in the illustration (**Fig. 6.13**) – about **0,5 mm** from the feeding table
- Re-assemble the Plexiglas shield
- Adjust the speed and press the **Cut Key** to perform the first phase of the cut.
- Press the "Special" Key (**Fig. 6.14**) to perform the second phase of the cut and finally cut the media.

Fig. 6.12

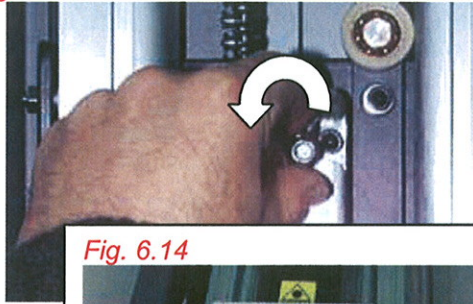


Fig. 6.13

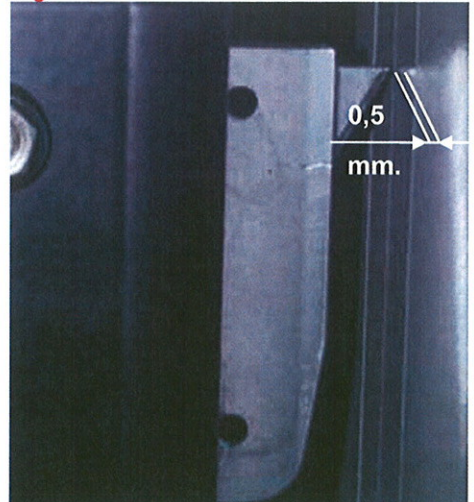


Fig. 6.14



Characteristics of the media to cut**6.1.5**

This trimmer was designed to cut "FOAM" and SEMI-FOAM PVC.



We recommend not trying to cut materials different from those which the machine has been designed for. They could seriously damage the machine.

Ordinary maintenance**7.1**

Risk of electric shocks and untimely movements during maintenance. Isolate the machine from power supply sources by unplugging the power cable.


Ordinary maintenance includes all those periodical and preventive operations that allow the machine to be used safely.

Qualifications of the operator**7.1.1**

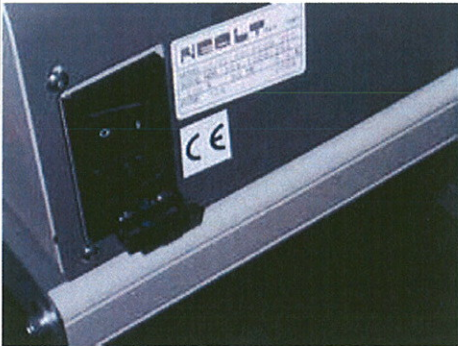
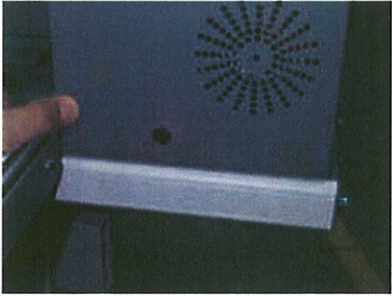
Ordinary maintenance of the machine must be carried out by qualified personnel only.

Procedures**7.1.2**

Please carry out the periodic operations listed in the table below.

Operation to be carried out	Frequency of execution	Procedure	Precautions
General dusting.	At user's discretion.	<ul style="list-style-type: none"> Clean the entire machine with a damp cloth. 	Do not use aggressive products.
Cleaning the scrap material.	If there is a lot of scrap material.	<ul style="list-style-type: none"> Remove the Plexiglas fastening screws. Remove the Plexiglas. Eliminate the scrap material with an aspirator and/or compressed air. 	<p>Wear a pair of protection gloves.</p> <p>Isolate the machine, disconnect power cable from power outlet and bring power cable near operator performing the intervention, so that he can always verify in every moment the real disconnection of the machine.</p>
Blade replacement.	If the cut is not regular.	See procedure <i>Assembly blade-holder carriage 5.5</i>	Wear a pair of protection gloves.

MAINTENANCE

<i>Operation to be carried out</i>	<i>Frequency of execution</i>	<i>Procedure</i>	<i>Precautions</i>
Testing the safety micro-switch.	At user's discretion.	Remove the Plexiglas shield of the carriage, press the <i>Cut Key</i> and verify that the motor doesn't start.	After the test, remove the carriage Plexiglas shield.
Grease the chain.	If there are noises and/or the carriage doesn't run smoothly.	<ul style="list-style-type: none"> Remove the carriage Plexiglas shield. Remove the Plexiglas. Grease the chain with a drop of oil. 	After carrying out the operation, reassemble the carriage Plexiglas shield.
Replacement of fuse of the power board.	If the fuse is burned.	<ul style="list-style-type: none"> Open the door near the power connector. Remove the burned fuse. Replace it with a new one (T 2A). 	Isolate the machine, disconnect power cable from power outlet and bring power cable near operator performing the intervention, so that he can always verify in every moment the real disconnection of the machine.
Motor block protection	Safety device for direct motor protection	<ul style="list-style-type: none"> Verify the led on the left side of the electronic board protection panel.  <ul style="list-style-type: none"> If the led is red switch off the machine. Try to understand why the motor protection tripped. After about 15" re-start the machine after eliminating the problem 	Isolate the machine, disconnect power cable from power outlet and bring power cable near operator performing the intervention, so that he can always verify in every moment the real disconnection of the machine.

Extraordinary maintenance

7.2

Directly contact NEOLT S.p.A for any extraordinary maintenance operation non contained in this manual.

DEMOLITION

Qualifications of the operator**8.1**

The machine can be demolished by qualified personnel only.

Deactivation of the machine**8.2**

Once the machine has reached the end of its technical and operating life, it must be deactivated. The machine must be deactivated and put in the condition of not being used for the purposes which it had originally been designed for. However, it must allow the reuse of the raw materials which it was built with.



NEOLT S.p.A. cannot be held responsible for damages to people or animals due to the reutilization of single parts of the machine for purposes or in situations different from those which it has been designed for.

Procedure**8.2.1**

- Disconnect the power cable.
- In case the machine has to be moved, refer to *5.2 Transportation*.



The machine is made of non biodegradable materials. It must therefore be brought to an authorized center for its disposal.

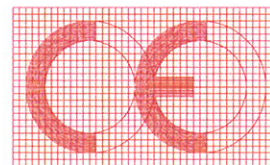
If for any reason the machine has to be put out of order, please comply with the following rules for the protection of the environment.

Aluminium, Iron, Plastic, general electric material and electronic boards must be removed and disposed of separately, by qualified personnel.

List of ATTACHMENTS

9.1

Attachment A *EC conformity declaration*



Hereby:

NEOLT S.p.A.
Via Galileo Galilei, 8
24036 Ponte S. Pietro
BERGAMO -ITALY-

d e c l a r e s

that the machine complies with the main safety requirements and the rules of the EC directives, it furthermore complies with the concepts and the construction style of **NEOLT S.p.A.**
If any modifications that have not been authorized by **NEOLT S.p.A.** are made on the machine this certification is automatically cancelled.

- | | |
|---------------------------|---|
| • Name of machine: | Fixed blade trimmer |
| • Type of machine: | horizontal electro
foam trim plus
160/250/310 |
| • Serial number: | see identification label |

- | | | |
|--|---|--|
| • Compliance EC directive: | EMC directive | 89/336/CEE, 92/31/CEE,
93/68/CEE, 93/97/CEE |
| | Low voltage directive | 73/23/CEE, 93/68/CEE |
| | Machine directive | 98/37/CE, 98/79/CE |
| • Applied harmonized standards: | EN 60950:1992+A1:1993+A2:1993+A3:1995
EN 55014
EN 60204-1/1997
EN 292-1/1991 - EN 999
EN 292-2/1992
EN 292-2/A1/1995
EN 61000-3-3
EN 61000-3-2 | |

Date and signature of manufacturer:

January 2004

Eng. P. CACCIA

Position of signer:

Technical Manager