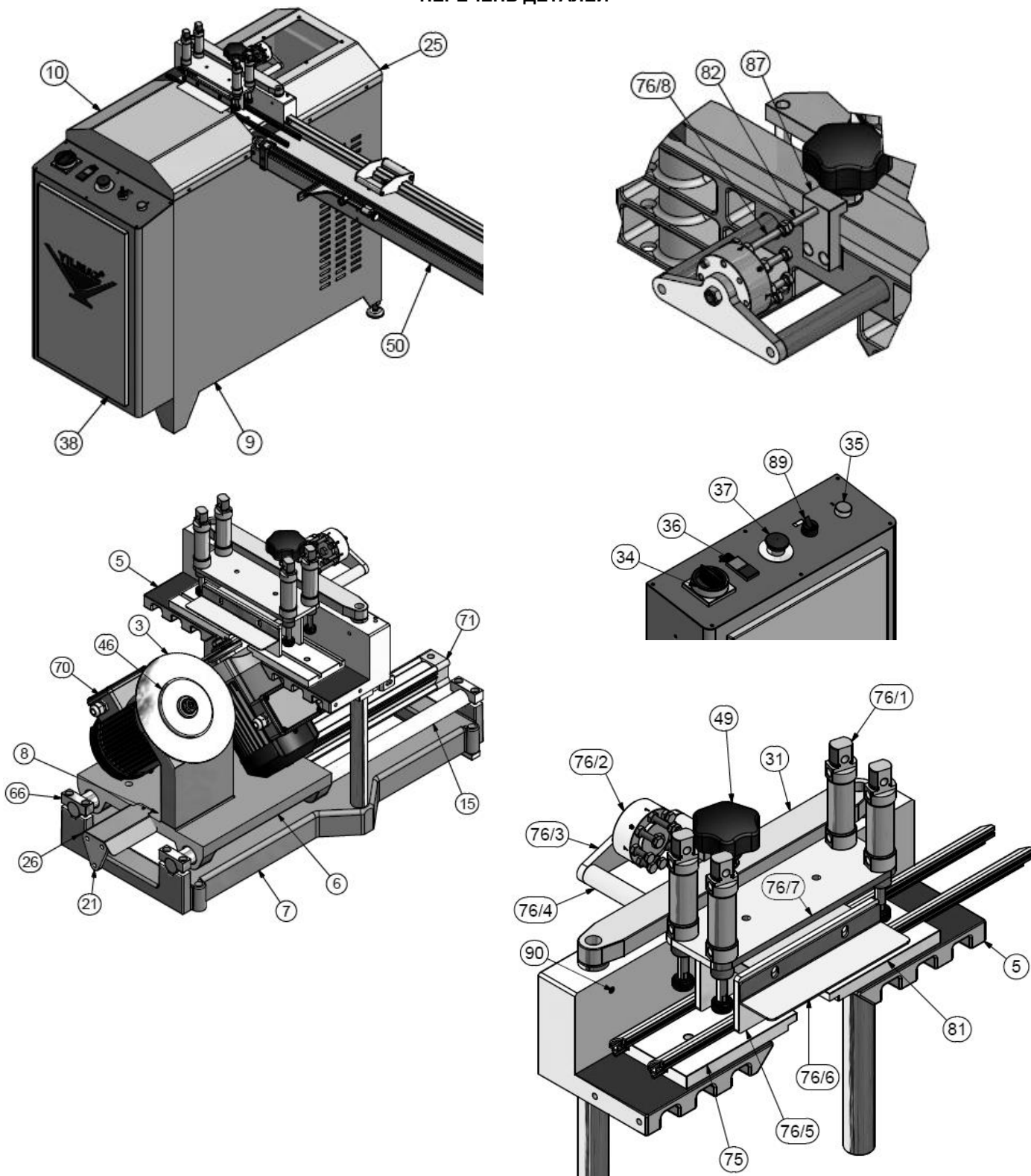




# Yılmaz SK 412 автоматический штапикорез

## ПЕРЕЧЕНЬ ДЕТАЛЕЙ


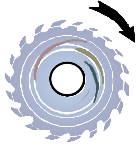
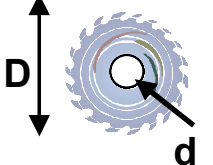

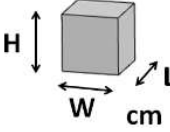






№	КОД / артикул	КОЛИЧЕСТВО	№	КОД / артикул	КОЛИЧЕСТВО
3	1SK010000-0001	1	76	2TU012210-1016	1
5	2TU012510-0392	1	76/1	1PN020000-0191	1
6	2TU012510-0308	1	76/2	2TU011110-1135	1
8	2TU012510-0311	2	76/3	2TU011441-0720	1
9	1SA010000-0051	1	76/4	2TU014010-0198	1
10	1SA030000-0091	1	76/5	2TU011441-0709	2
15	2TU014010-0093	2	76/6	2TU011441-0719	1
21	2TU011441-0289	1	81	2TU012310-0103	1
25	1SA030000-0090	1	87	2TU012210-1047	1
26	1SA050000-0152	1			
31	2TU012210-0906	1			
38	1SA020000-0026	1			
46	1SK010000-0008	1			
49	1PL020000-0008	1			
50	3UA010030-0097	1			
66	2TU011210-0643:	4			
70	3UA730030-0008	2			
71	1PN020000-0122	1			



СПИСОК ЗАПАСНЫХ ЧАСТЕЙ			
№	РИСУНОК	КОД / артикул	НАИМЕНОВАНИЕ ДЕТАЛИ
1		1EL090000-0003	КНОПКА START XB7-NA31
2		1EL090000-0001	КНОПКА АВАРИЙНОЙ ОСТАНОВКИ XB4-BS8442
3		1EL050000-0027	РЕЛЕ питания RT 424024 24V DC 2 C/0 8-10A
4		1EL040000-0405	КОНТАКТОР ASL09-30-10-81 (24V DC 50-60)

5		1EL090000-0016	XB4-BW73731B5 ÇİFTLİ BUTON (24V AC/DC LED) DOUBLE BUTTON КНОПКА ДУЭТ
6		1EL090000-0033	КНОПКА вкл/выкл с зачитным кожухом ZBA 710
7		1EL200000-0037	ДАТЧИК RZT6-03ZUS-KWO NO (1025522)

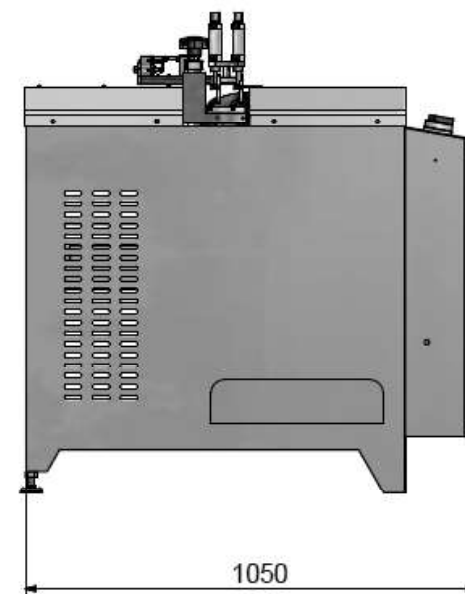
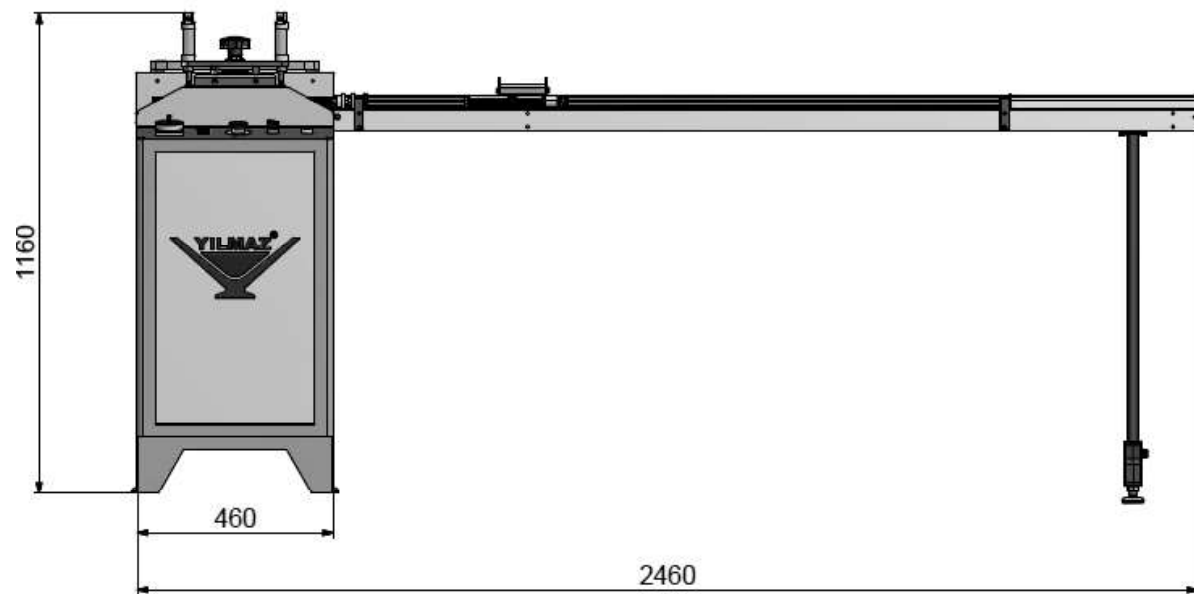
## ТЕХНИЧЕСКИЕ ОСОБЕННОСТИ

									
<b>CK 412</b>	1200 W x 2 50 Hz 400 V AC 3 P PE	800 W x 2 50 Hz 230 V AC P N PE	3000 D/dak. RPM	$D_1 = 110 \text{ mm}$ $D_2 = 200 \text{ mm}$ $d = 30-32 \text{ mm}$	6/8 Bar	35 Lt. / dak. Lt/min	$W = 54$ $L = 113$ $H = 124$	134 kg	168 kg

 <p><b>YILMAZ MAKİNE SANAYİ VE TİCARET A.Ş</b> Turgut Özal Bulvarı No:173 Tasdelen 34788 Çekmeköy İSTANBUL-TÜRKİYE Tel: +90 (216) 312 28 28 (Pbx) Fax: +90 (216) 484 42 88 web : www.yilmazmachine.com.tr e-mail: yilmaz@yilmazmachine.com.tr</p> 			
MODEL TYPE MODEL	CK 412	RATED CURRENT NOMINAL AKIM	5,1 A
SERIAL NO SERI NO		SAW DIAMETER TESTERE ÇAPI	Ø200xØ30/32mm
PROD.DATE ÜRETİM TAR.		AIR CONSUMP. HAVA TÜKETİMİ	35 Lt / min
TOTAL POWER TOPLAM GÜÇ	2440 W	AIR PRESSURE HAVA BASINCI	6-8 BAR
RATED VOLTAGE NOMİNAL GERİLİM	400V AC 3P PE	WEIGHT AĞIRLIK	134 KG.

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MODEL TYPE MODEL	CK 412	RATED CURRENT NOMINAL AKIM	9,2 A
SERIAL NO SERI NO		SAW DIAMETER TESTERE ÇAPI	Ø200 x Ø30/32mm
PROD.DATE ÜRETİM TAR.		AIR CONSUMP. HAVA TÜKETİMİ	35 Lt / min
TOTAL POWER TOPLAM GÜÇ	1600 W	AIR PRESSURE HAVA BASINCI	6-8 BAR
RATED VOLTAGE NOMİNAL GERİLİM	230V AC P N PE	WEIGHT AĞIRLIK	134 KG.

## РАЗМЕРЫ



## 7. OPERATION

### 7.1 Preparation

7.1.1 Clean the glazing bead mould channels from any burr and foreign materials. Ensure especially that the glazing bead moulds are clean.



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

7.1.3 The CK 412 Automatic Glazing Bead Saw has been designed for cutting of aluminum and PVC glazing beads at 45° angle for making 90° corner joining..

7.1.4 Control whether cutting tools 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 (PICTURE 4 NO.76/7) the work piece properly.**

7.1.8 Up-Down adjustment of glazing bead mould can be performed by adjustment part on the machine. (PICTURE 4 NO.49) First loosen the set square fixing set screws (PICTURE 4 NO.5). Make the adjustment by turning the knob up/down. Then again tighten the set screws and nut.

### 7.2 Operation

7.2.1 Switch the system start switch to “1” (PICTURE 6 NO.34)

7.2.2 Place bar profile to be cut as shown in PICTURE 7.

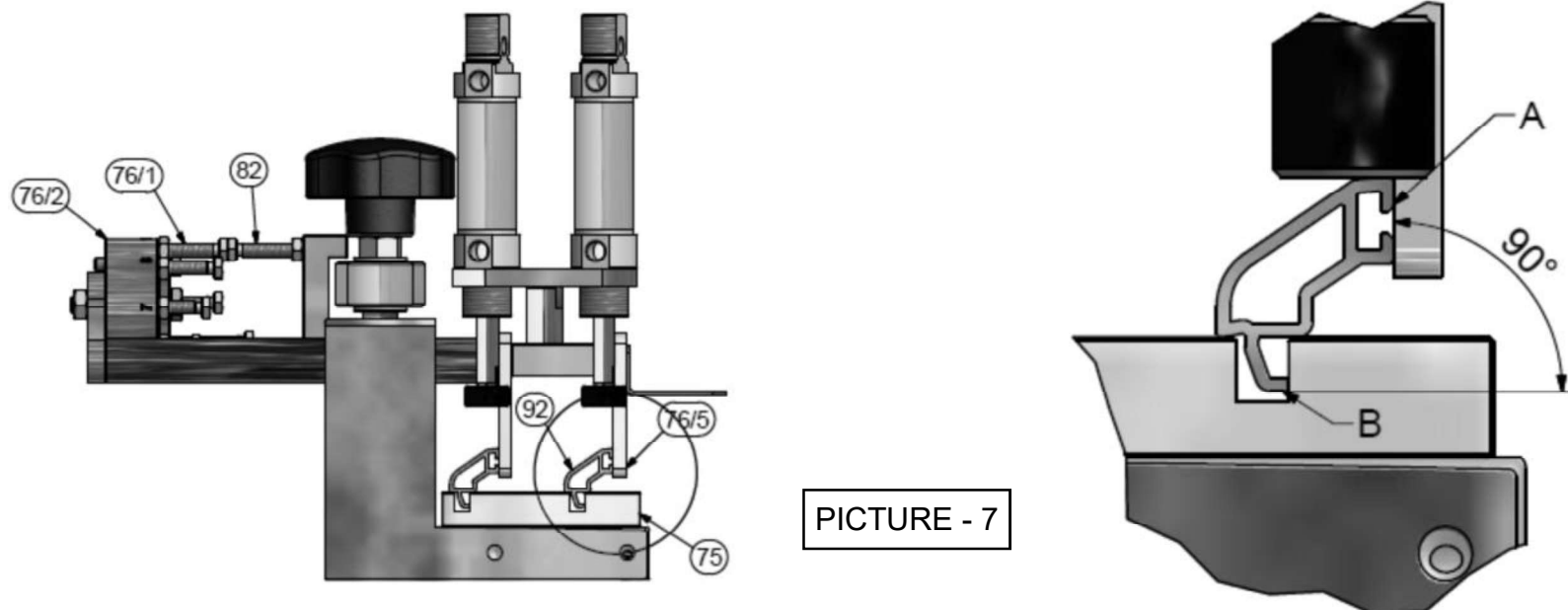
7.2.3 Align supporting plate (PICTURE 7 NO. 76/5) on the gasket side of bar profile by moving forth and back

7.2.4 Clench the profile by rotating the clamp handle

**NOTE: In order to have a correct measurement and cut, imaginary lines passing through A and B should be perpendicular to each other as shown in PICTURE 7**

7.2.5 After aligning the profile with the plate, place the bolt, which is on the scaled measurement section (PICTURE 7 NO: 76) on to the bolt, which is provided with a preset value on setsquare (PICTURE 7, NO. 82). Then, squeeze the nuts by using a wrench and tighten the mold.

**NOTE: By using the scales on the measurement (PICTURE 7 NO 76/2), height of the bolt can be adjusted (PICTURE 7 NO. 76), and 8 different bar profiles are able to be cut at single mold.**



7.2.6 Adjust the cutting length of the bead using the measuring tape and bead support plate.(PICTURE 7)

7.2.7 Start the electrical motor by pressing the motor start button. (PICTURE 6 NO.36)

7.2.8 Begin the cutting operation by pressing the cutting start button (PICTURE 6 NO.35). The machine automatically performs cutting operation and returns back to its starting position. Stop the electrical motor by pressing the motor stop button. (PICTURE 6 NO 36)



**NOTE: Remove the pressure on the cutting buttons in a possible hazard, or press the emergency stop button.**

7.2.9 Switch the system start switch to “1” (PICTURE 6 NO.34)

### **7.3 Use of the KA 200 easy measuring apparatus**

7.3.1 With the KA 200 Easy Measuring apparatus (PICTURE 8) it is possible to apply two different distance measurements serially.

7.3.2 Press the measurement adjustment part against the upper inner section of the frame, which you want to take the reference measurement from

7.3.3 Press the part Support 1 against the lower inner section of the frame, where you want to take the reference measurement from, by loosening and moving the tightening handle. Tighten the handle again to fix the position.

7.3.4 You may repeat the above described operation for the part Support 2 as well to use it for the second reference measurement.



## 8. MAINTENANCE, SERVICE AND REPAIR

### 8.1 Maintenance

- 8.1.1 Cut the electric and pneumatic power connections of the machine.
- 8.1.2 Clean all surfaces of the machine from burs, chips and foreign substances. If the machine will not be used for a long time, lubricate undyed parts with oil that prevents rusting.
- 8.1.3 When cleaning the machine, do not use materials that may damage the dye.
- 8.1.4 Control cutting tools against corrosion, distortion and fractions. If cutting tools are damaged, change them..
- 8.1.5 Before using cutting tool, operate the machine out of gear and control whether it is inserted correctly, it is without flexure and it is inserted appropriately. Do not use cutting tools that are damaged or lost its functionality.
- 8.1.6 If the sawteeth are blunted, change immediately with a new / sharpened saw.
- 8.1.7 Sharpen with proper sharpening machines by taking the angular value of the saw into consideration.

## 8.2 Changing the cutting tool

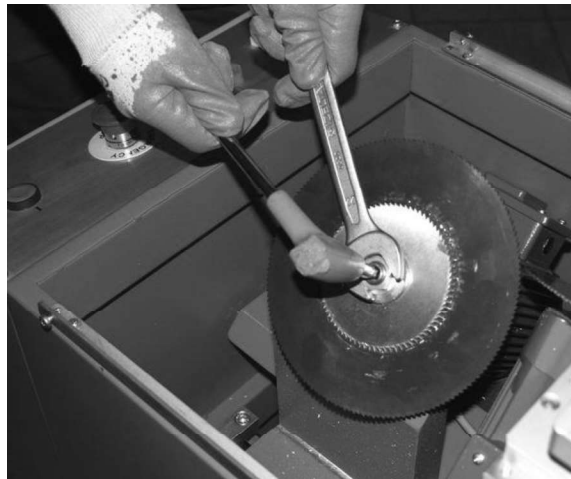


8.2.1 Use protective gloves when replacing Saw

8.2.2 Cut the electric connection of the machine.

8.2.3 Open the upper protection covers.

8.2.4 Take out the nuts by using 8mm allen wrench and 22 mm. wrench as shown at the photo



PICTURE-9

8.2.5 Remove the connection parts of cutting set in the right order.

8.2.6 Remove the saw carefully

8.2.7 Mount the saw by being sure that the rotation direction onto the axle is true.

**NOTE: Ensure that the saw blades rotate in correct direction (the correct direction has been marked on the machine's upper cover)**

8.2.8 Replace all removed parts in the same order.

8.2.9 **The saw selection should be made proper to EN 847-1 Standard.**

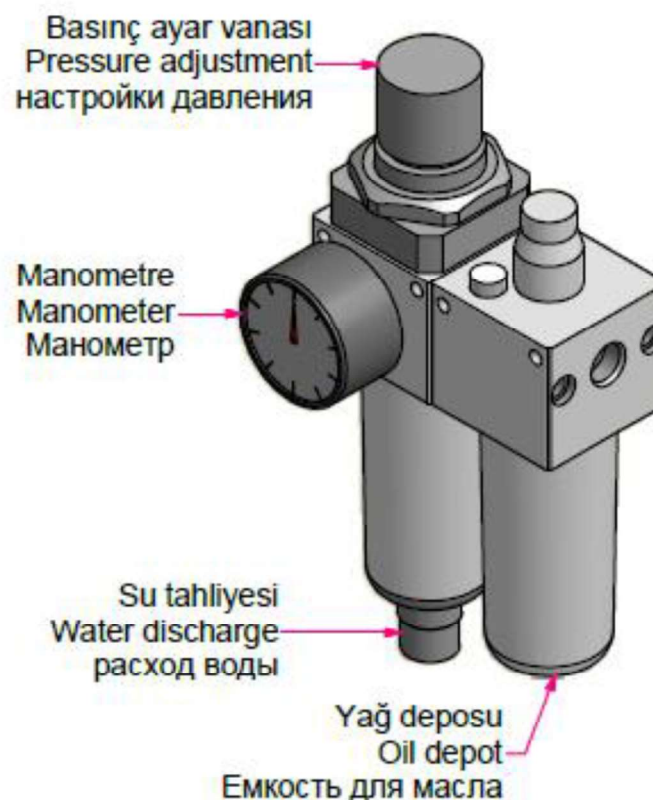
### 8.3 Adjust the air pressure (pneumatic systems)

8.3.1 Pull up pressure adjustment valve. Set adjustment valve to the desired value on manometer by turning it clockwise or counter clockwise. Then lock the valve by pressing it down.

8.3.2 Set the air pressure between 6 and 8 BAR. If air pressure drops below the stated values, accessories operating with pneumatic power do not work.

8.3.3 Conditioner unit accumulates the water in the air in the collection container so that it won't damage pneumatic components. At the end of the working day, empty the accumulated water by opening water discharge valve under the collection container

8.3.4 In order to put oil to the oil tank, remove the reservoir by turning. Oils recommended by the manufacturer are; ; TELLUS C10 / BP ENERGOL HLP 10 / MOBIL DTE LIGHT / PETROL OFİSİ SPINDURA 10.



## 9. NOISY EMISSION VALUES

<b>Material</b>	PVC (Glass bead profile	<b>LwA</b>	80 dB (Measured Value)
<b>Lenght</b>	2000 mm.	<b>LpA</b>	93 dB (Average Sound Pressure Value
<b>Width</b>	22 mm.	<b>K</b>	2 dB (Uncertainty in the Measurements)
<b>Height</b>	20 mm.		

The values given for the noise are the emission level and it does not show that it is in the safe working level. A connection between emission and exposure levels is available, however it is not used confidently for the determination whether these more advanced precautions are necessary or not. The factors that affect the real level of exposure, affecting the working power, are residence time, features of working place, in other words other noise resources, actions on other side and the number of the machines. Furthermore, the exposure level given permission can change from country to country. This informing, however, provides the machine user to evaluate the hazard and risks well.

<b>Machine Characteristic Information</b>		<b>Saw Characteristic Information</b>	
<b>Testere Dönüş Hızı</b>	3000 dev / dak	<b>Saw Size</b>	200 mm
<b>Motor Gücü</b>	1.2 Kw x 2	<b>Saw Thickness</b>	2.2 mm
<b>Nominal Gerilim</b>	400 V	<b>Saw Shaft Thickness</b>	1.8 mm
		<b>Saw Progress Speed</b>	7.4 m / min.

## 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.

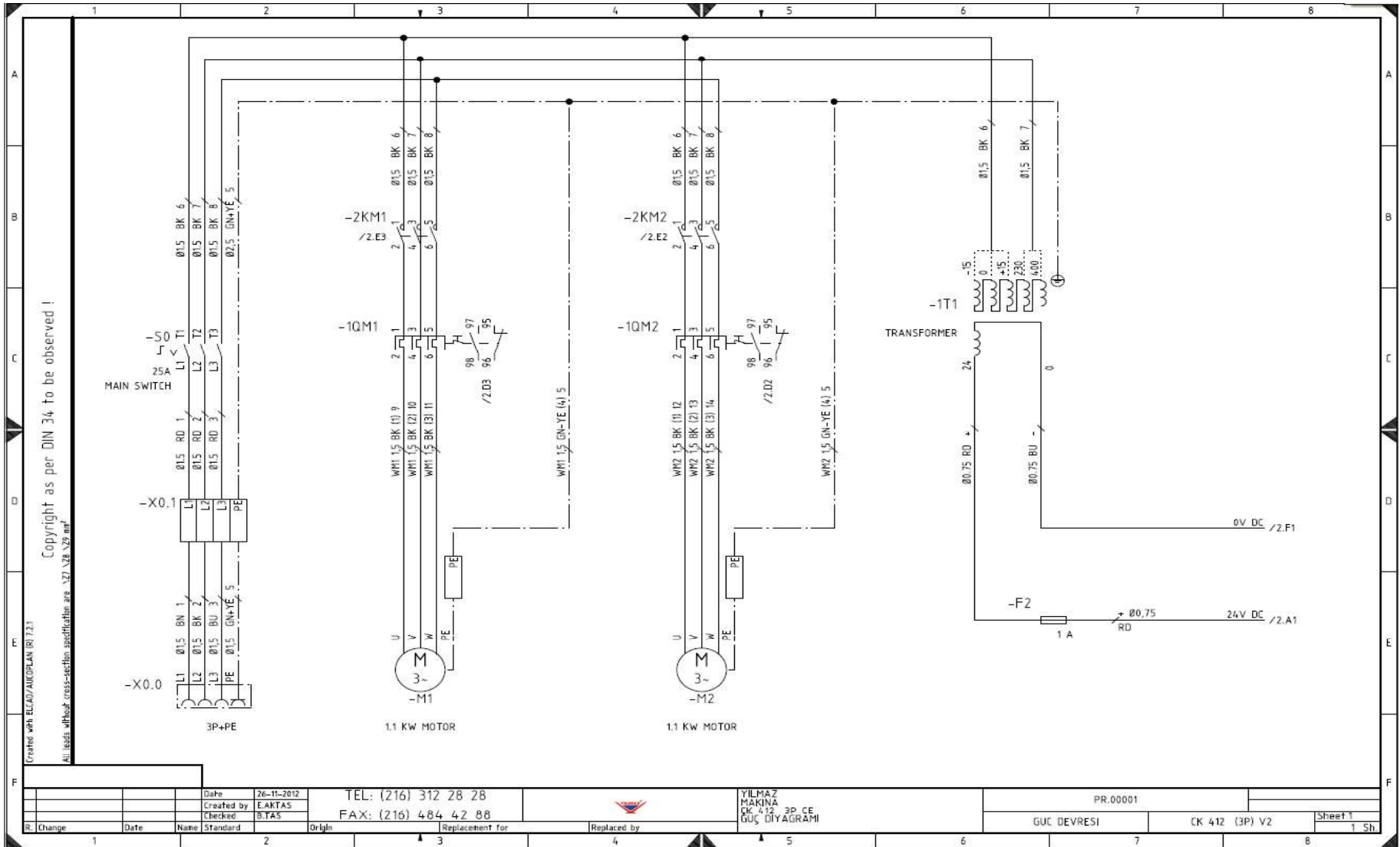
During this period:

- 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.

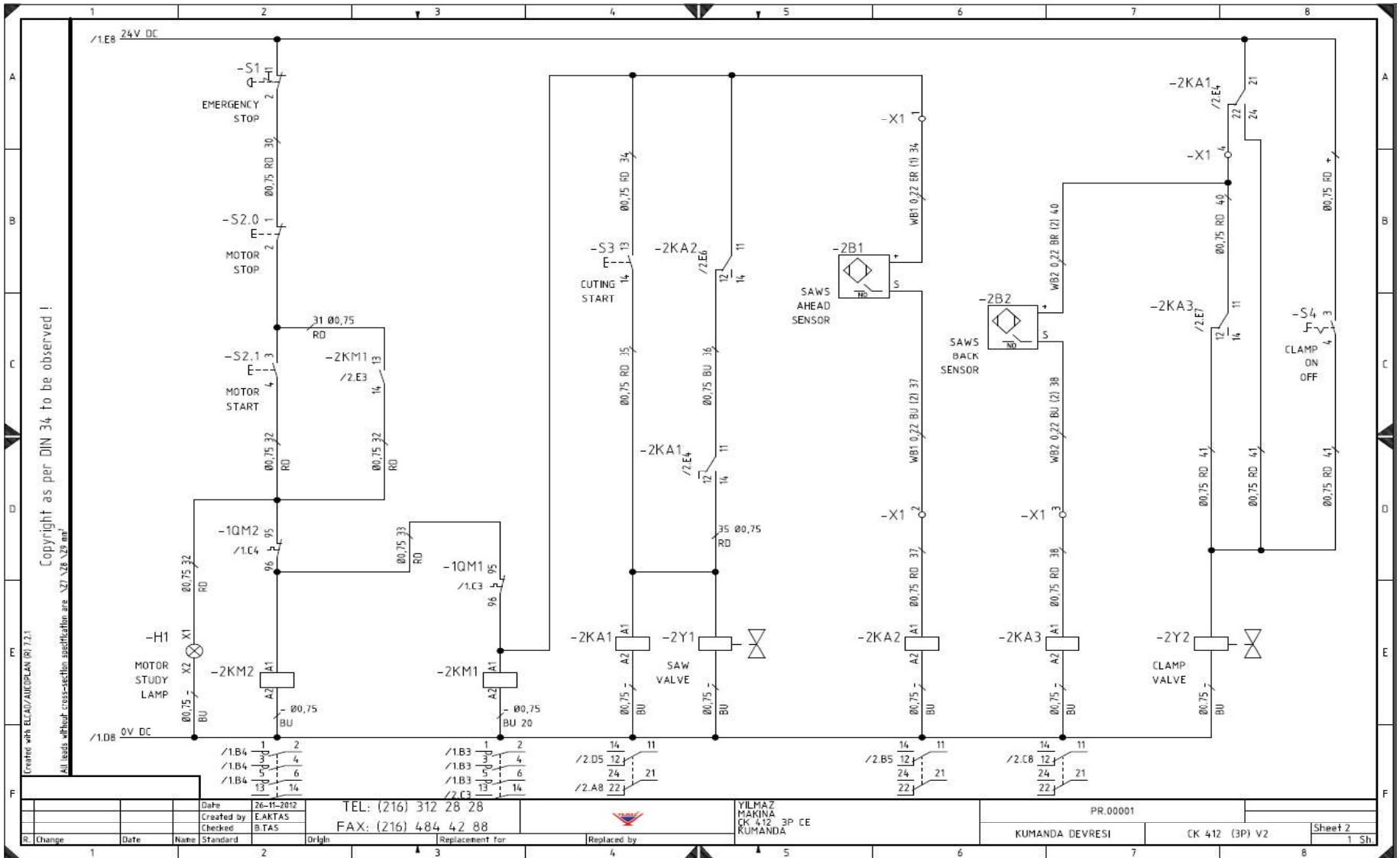
The guarantee does not cover damages caused by:

- 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)

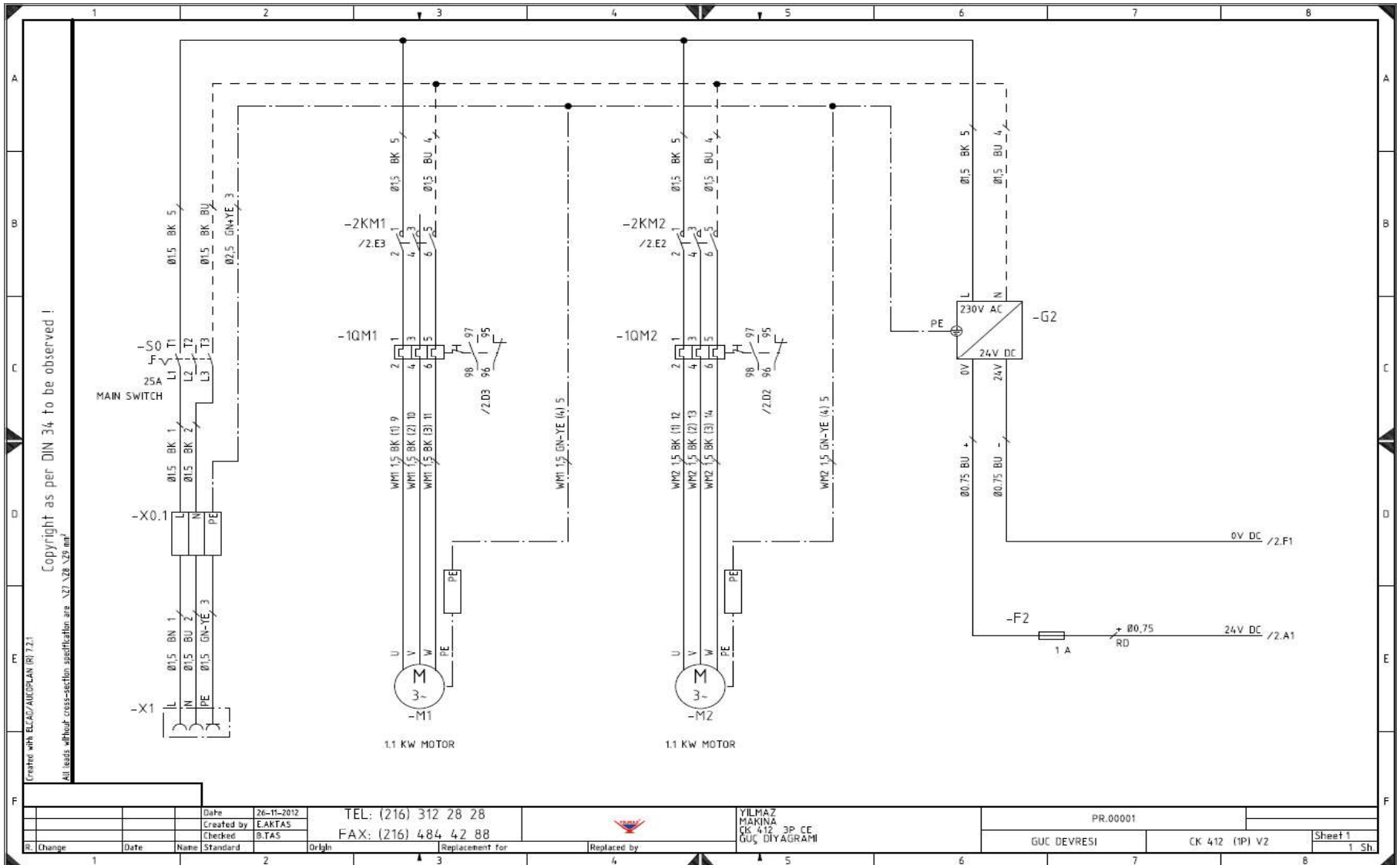
The warranty does not cover, in any case, damages caused by the malfunction of the Machine



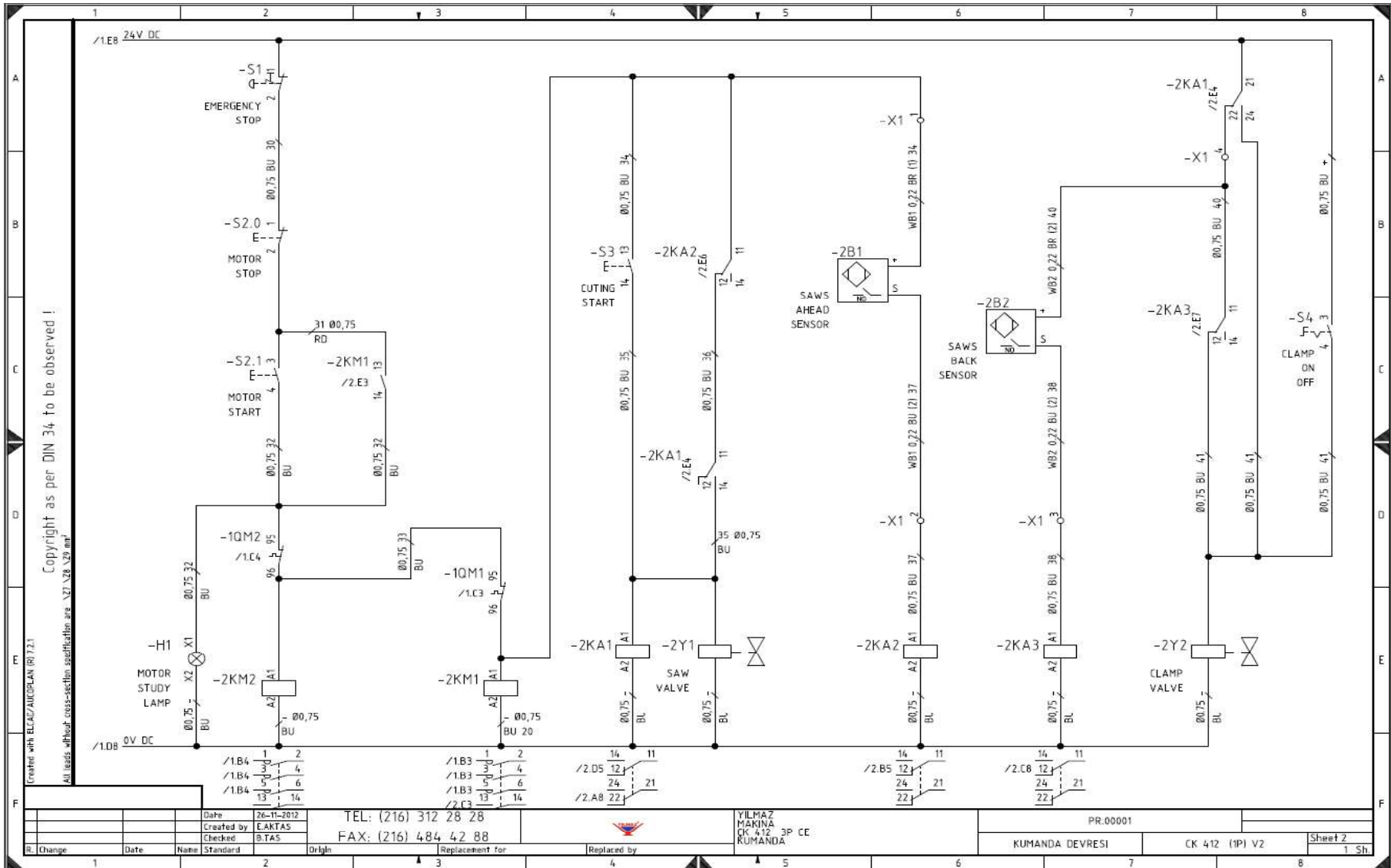
### CK 412 3 PHASE ELECTRICAL DIAGRAM SHEET 1



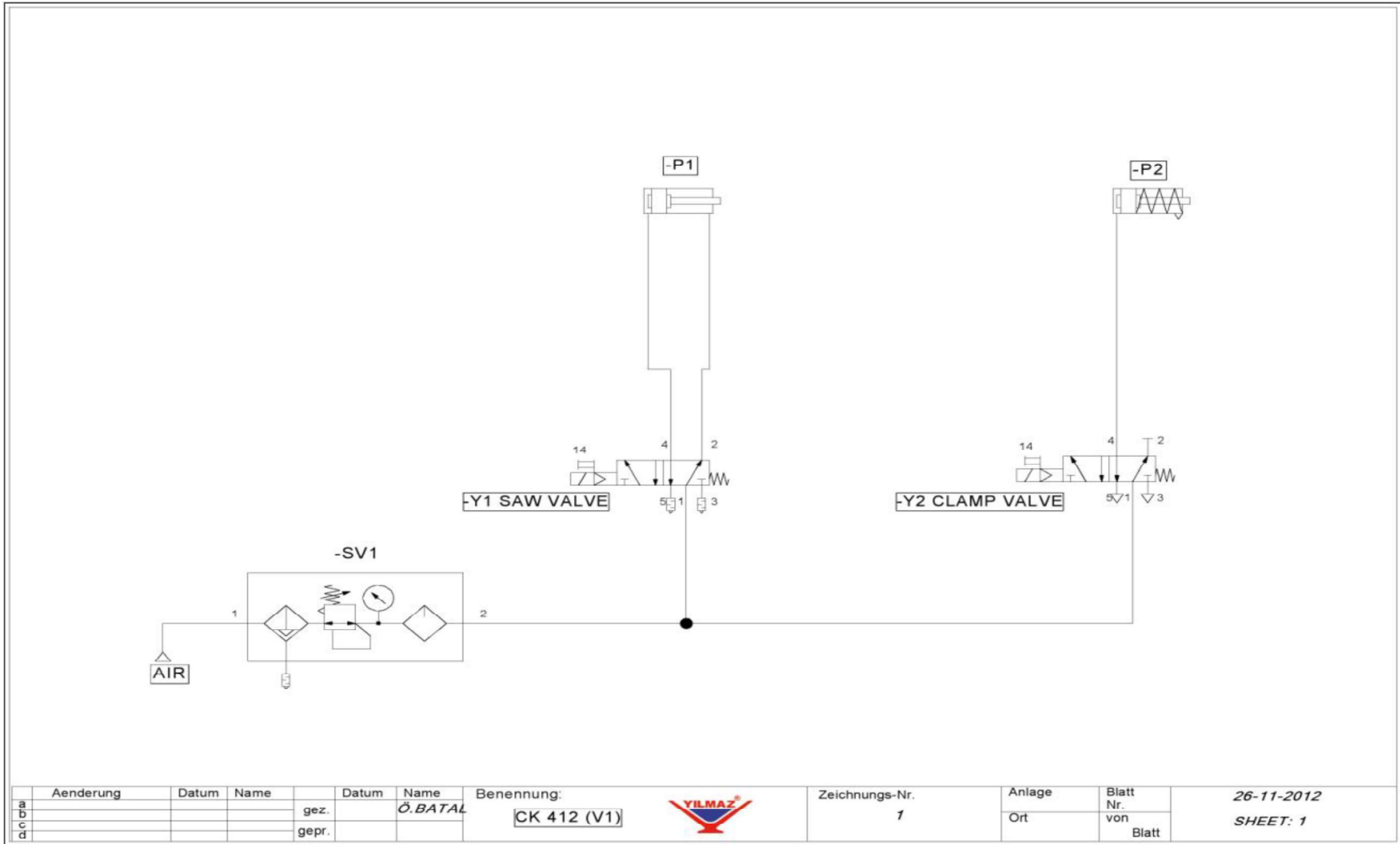
## CK 412 3 PHASE ELECTRICAL DIAGRAM SHEET 2



### CK 412 1 PHASE ELECTRICAL DIAGRAM SHEET 1



### CK 412 1 PHASE ELECTRICAL DIAGRAM SHEET 2



CK 412 PNEUMATIC DIAGRAM SHEET 1