



Wadkin Bursgreen Wall Saw



Models: 3216 & 4122
Types: Premium & Premium Plus
Compact Premium & Compact Premium Plus



Supplied by Advanced Machinery Services

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1 PREFACE

1.1 Information on Operating Instructions

This operating guide contains information on the use of BALA DPME and DPM KS panel sawing machines and all the information about working with these machines. This guide is the main reference for all persons appointed for the installation, use, service and maintenance of the panel saw.

This operating guide contains explanations and safety precautions for the transport, installation, operation, operation, use and maintenance of the vertical panel sawing machine.

1.2 Modifications

Modifications made by BALA should only be carried out on vertical panel saw machines. Any modification beyond this is prohibited.

1.3 Display Rules

In order to be able to understand the specific or important information in this user manual more quickly and easily, texts and pictures are marked with certain symbols, warning words and text marks.

1.3.1 Warning Notes



This information note draws attention to a danger that directly threatens the person, which, if not avoided, could lead to serious injury or death.

Here, it explains what the danger is, what consequences it can have for you, and what you need to do to prevent it.

- Protective prevention must be strictly observed.

1.3.2 Other Danger Warnings Indicating Special Hazard Sources



-Electric Shock

Warning against dangerous electrical voltage.



-Fire hazard

It warns against flammable substances and processes that may cause fire.



-Crush hazard

It warns against the risk of compression or crushing of the body parts.



- Harmful substances

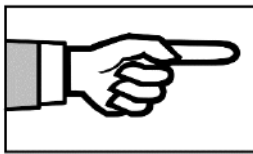
Indicates a hazard to health or to irritants.



-Laser Beam

Attention, laser beams can lead to blindness.

1.3.3 Other Pictograms and Notes



- Tooltip for application

This sign points to clues and explanations that may be useful when working with a panel saw and transfers points that need to be known in the process of cutting material.



-Emergency Stop Button

This sign indicates that the machine must be stopped and the emergency close button pressed for further control steps.

1.4 Limitation of Liability

All information, notes and explanations contained in these user manual are based on standards and safety directives applicable to vertical panel saw machines. The vertical panel saw machine itself and its accessories are at the latest technical level.

The manufacturer will not assume any liability for damages resulting from:

- non-compliance with user manual
- Unsuitable use
- Failure to use protective devices or equipment or improper use

- Misuse
- Interventions by non-trained personnel
- Modifications made by unauthorized person
- Not using original BALA spare parts

1.5 Customer Service

If you have any questions regarding the installation, operation and maintenance of the vertical panel saw, please refer to the operating manual first. If you need more help or assistance to solve the problem, contact your dealer's customer service. Likewise, if you need spare parts, or if you only need to carry out major repairs that must be done by a trained service technician, contact your dealer's customer service. Contact AMS Service department on 0844 844 9949 or servicing@advancedmachinery.co.uk.

1.6 Spare Parts

Incorrect or faulty spare parts can cause damage to the machine, malfunctions or complete machine breakdown, and can pose a safety hazard.

- Only use original Wadkijn Bursgreen spare parts included in the spare parts list.
- Modify parts subject to abrasion within the prescribed time.
- Replace standard parts only with equivalent parts.

2 SHIPPING AND ASSEMBLY

2.1 Safety Directives

2.1.1 General Safety Directives

- The vehicle must not be moved without fully loaded machinery, apparatus and accessories.
- During loading; breaking, tilting conditions must be taken into account and the specified safety instructions must be applied.
- Do not load the machine in the vehicle or on the forklift so as to disrupt the balance.
- Do not load the vehicle in such a way as to obstruct the view of the vehicle, disrupt the safety of driving the vehicle or forklift, cover registration plates, signs, brakes and turning lights and reflectors.
- Measures should be taken such as support, reinforcement necessary for the collapse or disintegration of the stack to damage yourself or others.
- Be extremely careful when loading materials that are difficult to load with the danger of slipping and rolling due to its shape.
- After the lorry loading is complete, even if there are very short distances, it should definitely not have personnel on the load.

- The material to be loaded can be loaded up to 30 cm below the neck of the case. Special loads should be obtained by contacting the Occupational Health and Safety Team.

- Be sure to check that the loaded product is safely loaded along with all accessories.

- The complete user manual should be read and understood well.

- The operator assigned to use Wadkin Bursgreen vertical panel sizing machines must be identified. and the use of non-informed personnel should not be allowed

- Only original parts or parts recommended by Advanced Machinery Services should be used on Wadkin Bursgreen vertical panel saw machines.

- The instructions given in the apparatus and accessories shipped with the machine apply.

- The transport personnel must obtain the necessary information during loading.

2.1.2 In Case of Accident

- Move away from the dangerous area immediately and get the safety of the accident area.

- inform your supervisor.

- Those who have an accident; first aid by authorised personnel.

- inform the Wadkin Bursgreen about the accident.

2.1.3 Protective Equipment

In transportation, installation, disassembly and disposal, there may be accidents that could lead to serious injury or death due to machine parts and package overturning, falling or breaking.

These studies should only be carried out by persons who have been trained for it and have personal protective equipment.

- Use protective goggles when necessary.

- Wear gloves with high tactile feel and non-slip.

- Wear safety boots.

- Wear suitable work clothing that does not wrap around any moving parts.

2.1.4 Transport

The vertical panel saw machines are bulky and heavy. Incorrect handling, improper handling, and incorrectly selected fasteners may cause injury and overturning of the machine during shipping. Selecting a transport mode suitable for weather conditions is another safety measure. The following instructions should be applied in order to minimize the negative.

- Transport vehicles with suitable safety devices must be selected. Care must be taken to ensure that the fixing devices in the vehicle are not missing. It is important to use inertia and devices that can accommodate centrifugal force.

- The vehicle must be able to take the machine weight; load safety and connection equipment must be tested and approved in accordance with the standards.

- When lifting tools are used, the permitted carrying capacity must not be exceeded.

- Hanging loads are never safe.
- The vehicle floor must be checked. (lubricity, rust formation, residues of liquid and sticky substances)

2.1.5 Installation

- Installation and assembly must be done by authorized dealers or Wadkin Bursgreen officials.
- Installation should be done in correct order, fixed at specified values against parts falling, tipping, loosening problems.
- Correct lifting devices and fasteners must be used to remove and hold the machine components during installation-assembly.

2.1.6 Dismantling of machine - change of location

- The Wadkin Bursgreen vertical panel saw machine needs to be disassembled in accordance with the method. Otherwise it may cause injury.
- No parts must be removed to disrupt the machine's stability without using the lifting tools to secure the machine.
- The securing bolts should be loosened after taking the necessary precautions.
- All machining tools must be removed from the machine and loose parts must be removed.

2.1.7 Electric

- Work to be done in the field of electricity; it should only be done by personnel with a certificate of professional competence.
- The vertical panel saw machine is removed from operation and all of the machine and all accessory systems must be disconnected from the mains supply via the electrical connection terminals when dismantling.
- Adjust all power lines that run the operating systems before the disassembly so as not to carry voltage.
- All disassembly and transport work must be carried out only after these closing and checking operations.

2.1.8 Compressed Air

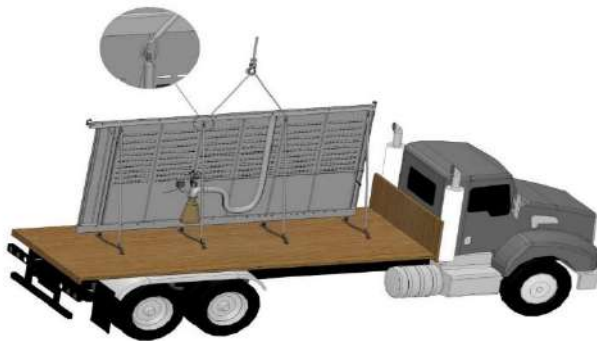
- This machine requires a compressed air installation; it should only be done by personnel with a certificate of professional competence.
- Empty the pressure of the entire compressed air system of the machine and check that the pressure remains unchanged.
- When the vertical panel saw machine is removed from operation and removed, all of the machine and all accessory systems in the machine's compressed air connection must be disconnected from the operating pressure-relief air network.
- All disassembly and transport work must be carried out only after discharge of the pneumatic system pressure.

2.1.9 Removal from Operation

- Saw frame; must be taken in the saw frame so that it no longer remains.
- The saw unit should not turn and should be fixed so that it does not come in and out.
- Cable chains resting on the profiles should be fixed so that they do not fall down.
- The open ends of the dust-absorbing pipes and hoses must be closed.

2.2 Transportation of Chassis

- Disconnect the vehicle's connections with the aid of appropriate apparatus, after the vehicle has stopped and the necessary safety precautions have been taken.
- Connect the hook rope at the top balance points of the machine. and lift the chassis with the help of a crane or forklift as shown below.
- Move the machine safely to the area to be used and ensure that it rests on its feet.
- All fastening elements and connections shall be made by authorized service personnel.

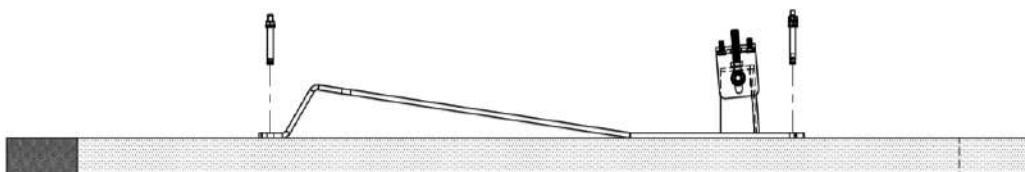
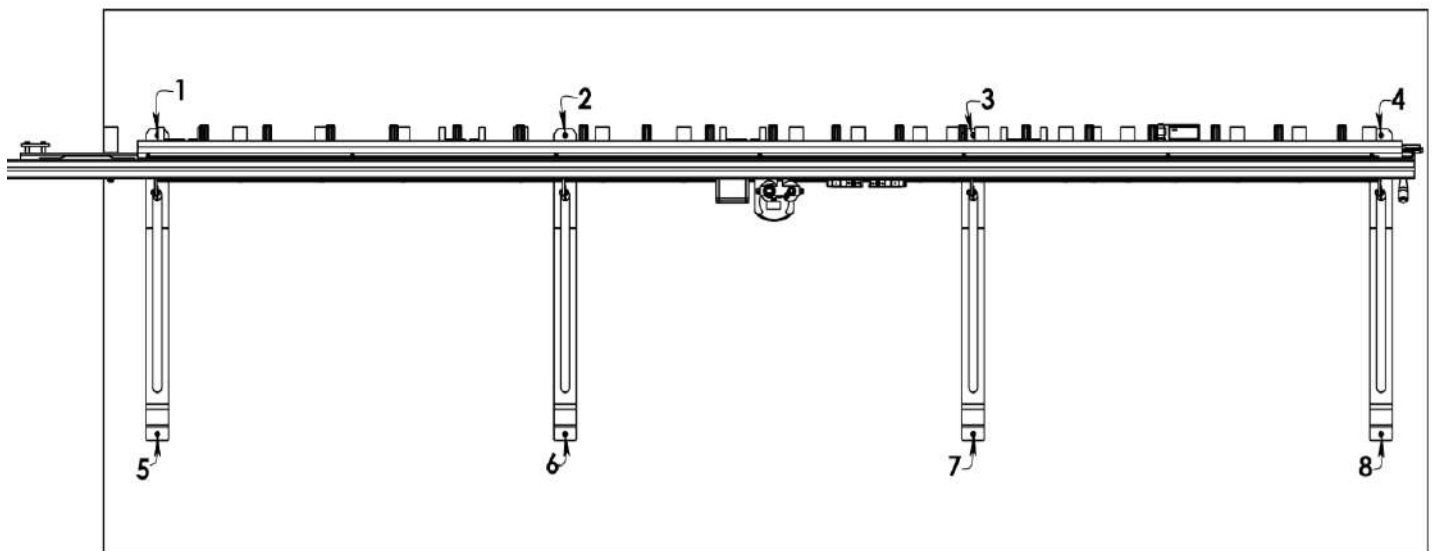
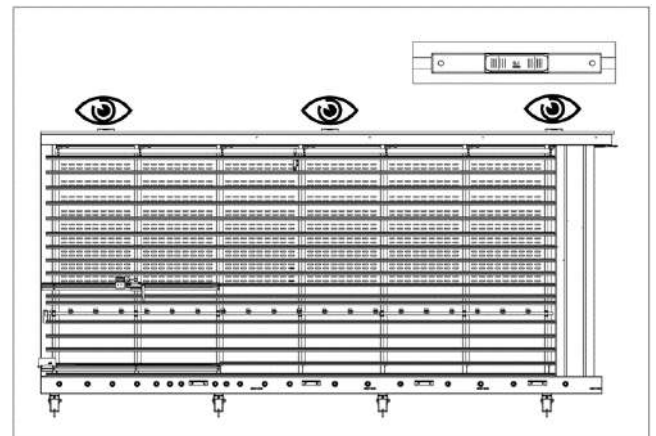
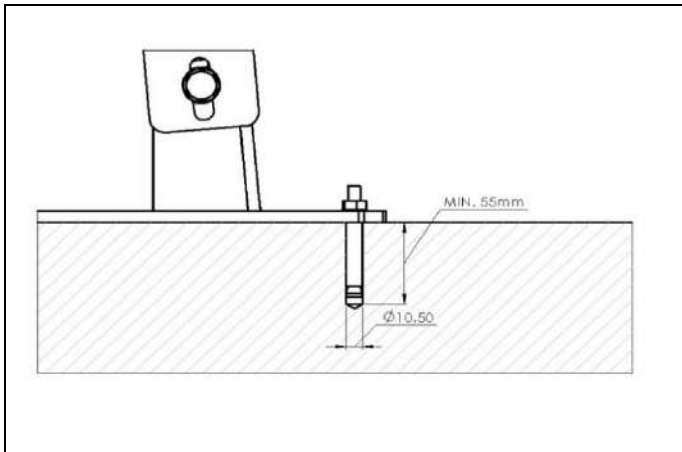


The Wadkin Bursgreen vertical panel sizing machine must be installed with a systematic, safe and accurate sequence. When the chassis is assembled, it should be carried out by the trained personnel in the following order after it is lowered according to the safety instructions given.

- 1- The frame should be lowered with the help of the necessary fixtures, which have been previously cleaned and planned.
- 2- The feet are adjusted so that all the feet of the chassis are pressed.
- 3- Open the holes from the points where the holes in the feet are located.
- 4- The machine feet are secured in place with the help of the steel dowels that come with the machine.

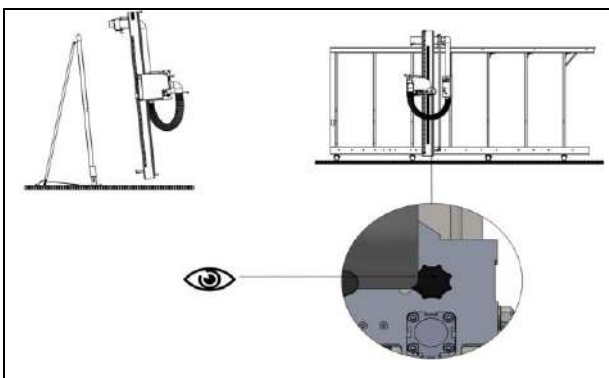
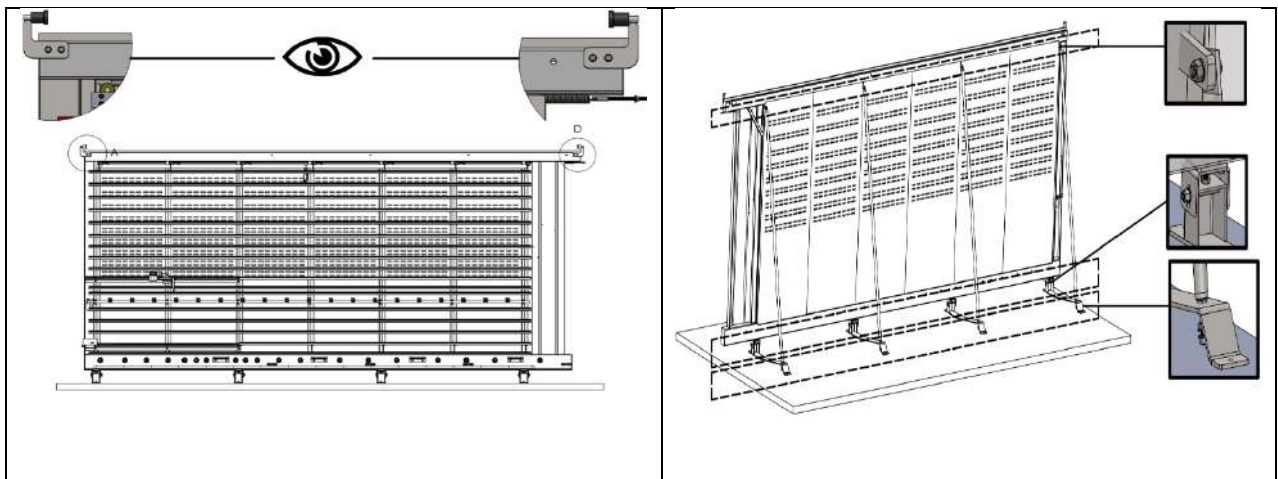
5- A spirit level is placed at various points of the machine as shown, the machine is roughly leveled by adjusting the foot heights by looking at the water level.

6- Accurate scaling of the machine is only possible by controlling the vertical and horizontal cuts made in the machine.



2.3 Transportation of Gantry

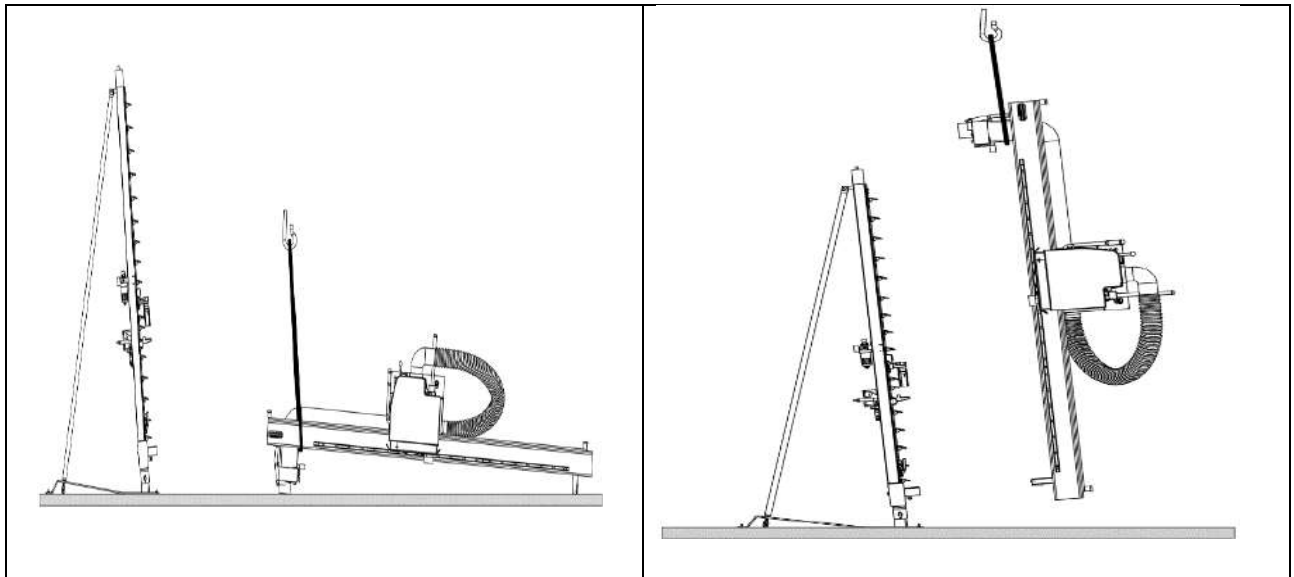
- Disconnect the gantry from the vehicle.
 - You must use a forklift or a tool that can do the same to transport the gantry.
 - While carrying the gantry part of the machine; make sure that the cutting head is at the center of the weight as shown below.
 - When handling the gantry, do not damage any hoses or cables on it.
 - Do not damage the saw when handling the gantry.
- 1- Check that the tabs on the frame look like they are. (The tearing of the packaging during transport may not be intermittent and may be reversed for space-saving purposes.)
 - 2- Check the connection points on the chassis as shown on the scheme.
 - 3- On the gantry; there is a saw unit retainer as shown. During lifting, the cutting unit must not be moved so that it does not fall or cause injury.



The Wadkin Bursgreen vertical panel sizing machine must be installed with a systematic, safe and accurate sequence. Once the gantry has been installed in accordance with the safety instructions given during installation, it should be done by the trained personnel in the following order.

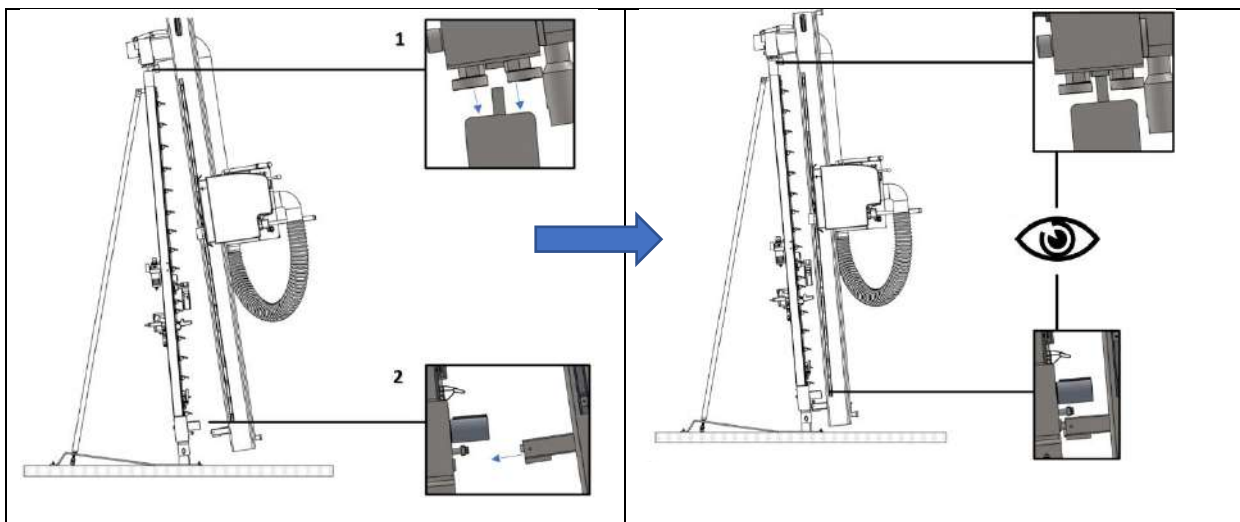
1- The gantry is connected with a rope in accordance with the safety instructions from the point indicated.

2- Gantry is pulled up with the help of a rope, forklift or crane and brought to a vertical position. At this time, the balance of the gantry must be provided.

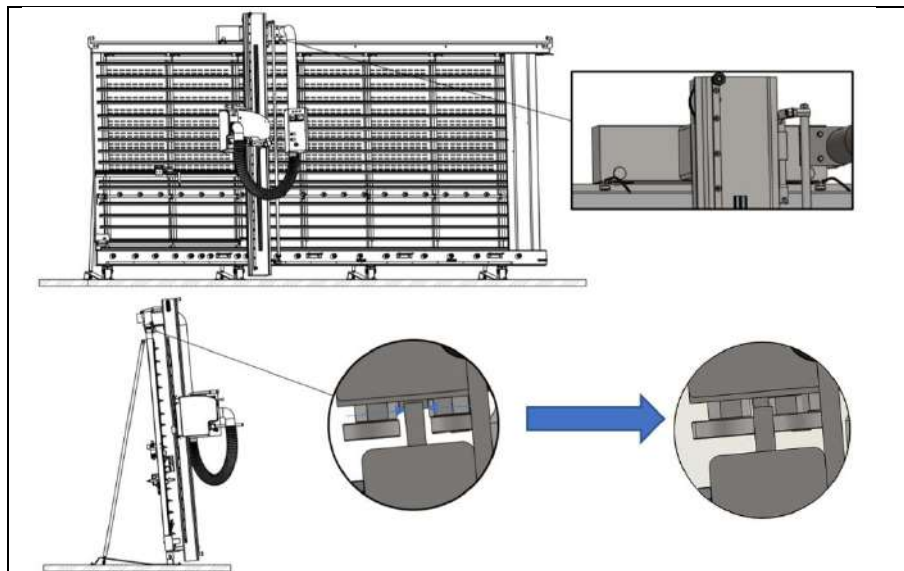


3- Once the bearings on the gantry are balanced so that they are slightly inclined, then place on the top of the frame.

4- The rope is carefully released downwards to ensure that the bottom bearing is seated on the bottom railing.



5-The upper bearings should be tangential to the upper rake as shown. The key must be turned clockwise and reversed as shown. After setting the bearings, they should be tightened clockwise.



3.USAGE

3.1 Main Safety Directives

In this chapter; safety instructions are included under the headings such as moving, setting up, changing the position of the vertical panel saw machine.

3.1.1 Proper Use

Vertical panel saw machines are only intended to perform cutting operations in the following materials.

Material	Maximum Thickness
Wooden board materials, i.e.: Plywood, MDF,	60 mm
Solid wood	50 mm
Duroplast	10-30 mm
Foam thermoplastic	60 mm
Aluminium	20 mm
Drywall	60 mm

proper use includes the below:

- The operating instructions, especially the safety instructions in the operating instructions, must comply with the service, control and maintenance requirements as specified by the manufacturer.
- Workplace safety, occupational medicine, dust and noise safety regulations and directive must be respected wherever the machine is located.

-Only authorized personnel are allowed to use this machine. Vertical panel saw machines must only be used, equipped and inspected by persons who know the machine and have knowledge of the existing hazards.

-The panel saw machine and accessories must be kept in a state of technical safety and operational safety. Cleaning and replacement of defective parts with original spare parts immediately. Unauthorized modification or alteration to the machine or accessories is prohibited.

3.1.2 Operator's Liability

The panel sawing machine will be used in the industry. For this reason, it is obliged to comply with the legal provisions and directives of the machine's own security, accident prevention and environmental protection. Operator should keep informed about the most current clauses in this area.

Operator is responsible for training of personnel.

- Any one who is assigned to work with the machine must read and understand this operating manual before starting work.

- Make sure that these persons also read and understand the operating instructions for the operations to be performed with the panel saw machine.

- Through trainings; be sure to read and understand the operating instructions for the operations to be performed with the panel saw.

- Through trainings; draw the attention of these people to special hazards that may suddenly occur while working with panel saws and materials

- Please confirm in writing to those who participated in the training that these instructions and training were received.

-Regularly check safety and accident prevention regulations, whether safety devices are used, whether safety regulations are adhered to, and whether personal protective equipment is being used.

- The fact that the panel sawing machine is in perfect condition in terms of technical and hygienic must ensure that the safety mechanisms are fully fitted and operational.

- Regularly check that the security symbols and labels attached to the machine are legible and clean.

3.1.3 Staff Quality

Use / Service Personnel

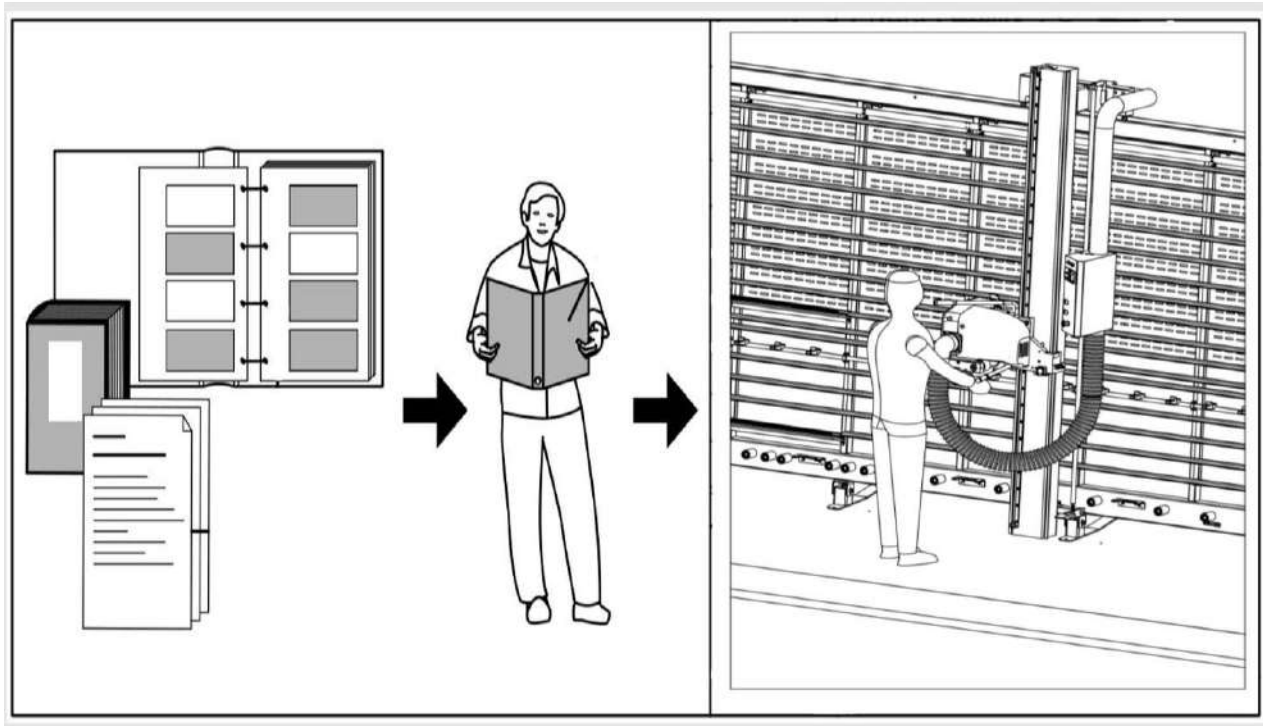
The vertical panel saw must only be operated, equipped, controlled and inspected by persons trained in the use and service of the machine, who have the necessary authority.

- Persons must have proved that he has read and understood all of the operating manual, in particular the safety directives.

- The operating instructions and trainings issued by the owner of the machine (operator) must be taken into account and understood.

- Personal protective work equipment must be identified, always in use, and kept in good condition for quality and hygiene.

- First aid equipment and information on measures to be taken in case of fire / accident.



MAINTENANCE PERSONNEL

The panel saw must be repaired by service technicians who have been trained. These persons should in principle know all the information required. For this, repair personnel must have a special training on maintenance / repair by the machine manufacturer or dealer and have appropriate equipment. These persons are the members of Advanced Machinery Services or the dealer of Wadkin Bursgreen.

3.1.4 Operator/ Auxiliary Working Area

The panel sawing machine is designed to be equipped and usable by a single person. You can use the helpers to load the machine and pick up the cut pieces.

-As an operator; during the machining, lightly stand in front of the saw unit on the left or in front of the control panel in front of the control box. At this point, the control and other operating elements are clearly visible and easily accessible. The entire periphery of the saw blade will be in front of you.

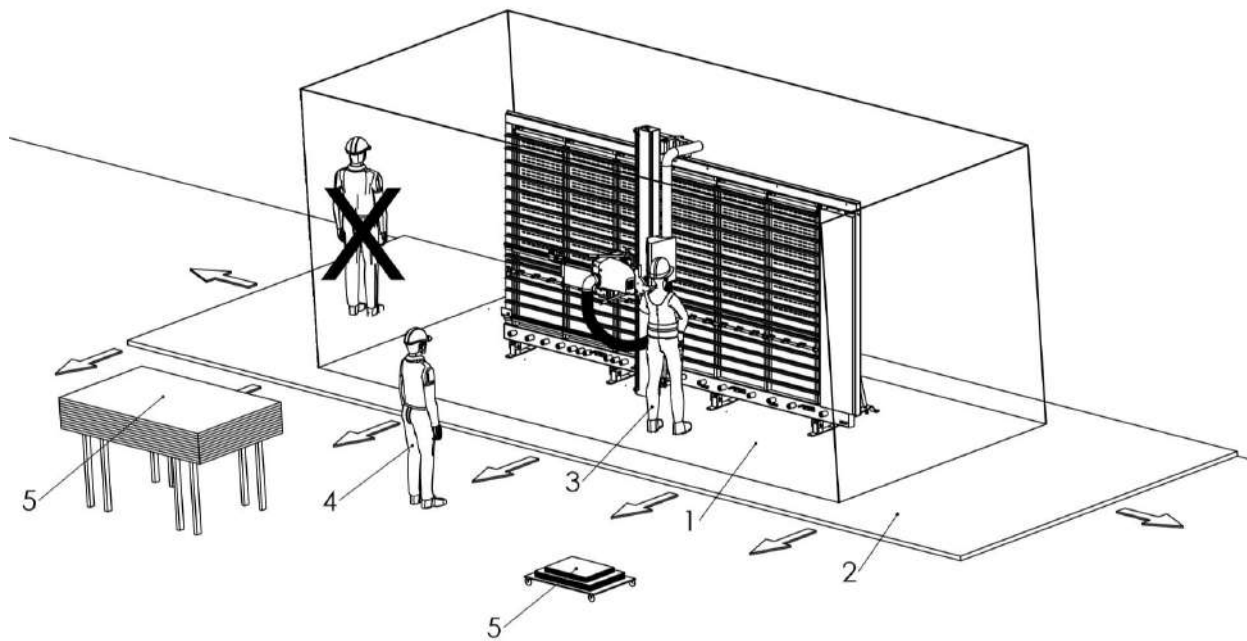
-Arrange the work area appropriately so that there is always enough free space (2) for the machine's use and that the use staff / assistants can move without being exposed to any danger.

- Make sure that you will not be injured by the machine towards other machine parts, work pieces or transport devices.

-As an operator you know the planned business process. The assistant operator must always provide clear instructions. Ex. If assistants assigned to fix work pieces need to work exceptionally in their operation, you must ensure that they never enter danger due to the work of the machine or that they do not enter their hands near the cutting unit.

- The assistants (4) must exit the machine's working area after placing or receiving the cutting material. They must stop in a place where they will not prevent the machine from being commanded.

- Use sheet handling equipment when transporting heavy plates to or from the machine. Always keep outside the working area of the panel saw (5) when you are not using these devices.
- Ensure that the departure and arrival areas used for the transport of the plates are always open and in good condition.



3.1.5 Pattern of Behavior in Case of Emergency

It is important to act on threats that are directly threatening or likely to come into play in the following way:

- Stop the machine immediately with emergency stop button
- Then move in the following way, depending on whether it is malfunctioning or damaging.
- Take an aspiration so that the machine will not reopen until the fault is cleared.
- Act according to the general alarm and recovery guidelines known in the event of major damage

3.1.6 Modifications / Changes Made by Unauthorized Persons

Changes, additions or modifications to the panel saw machine are prohibited by unauthorized persons. This includes repair work, such as alignment of metal parts, welding of components. If such work needs to be done, it is necessary to contact the manufacturer of the machine beforehand.

3.1.7 Death Hazard Caused by Inoperative Security Devices

Safety mechanisms ensure that the machine is operated with maximum security. For this reason, these devices should never be disabled. However, there is a safe operation when the safety devices are mounted and in operation.

- Never disable security mechanisms.
- Do not remove any coating on the machine.
- Do not solve any anchors on the machine and do not make any changes that could ruin the machine's statue.

- Before starting to work, be absolutely sure that all safety devices are installed and operational.

3.1.8 Saw Unit

- requirements for cutting insert

The main saw blades should have the following measurements.

Diameter	min 240mm, max. 250mm
Hole diameter	30 mm
Side diameter	TKO 42 mm, 2xO7 mm, diametrically
Maximum thickness	3,5mm

- Use only sharpened saw blades and milling tools. The cutting edge geometry and the cutting edge material must match the material to be cut.

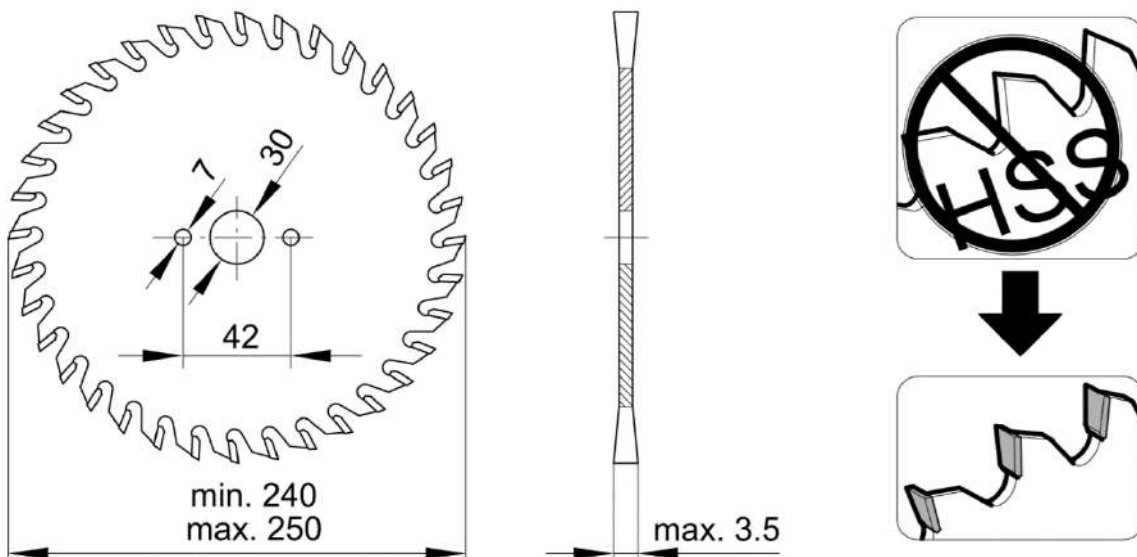
- Never use cracked or deformed saw blades

- The use of HSS type saw blades is prohibited.

- When working with processing tools, you may be injured by sharp edges. Use appropriate fittings and transport arrangements.

- The grooving blades used must be compatible with the machine

- The instructions for accessory systems include more safety directives for the described teams.



-Riving Knife

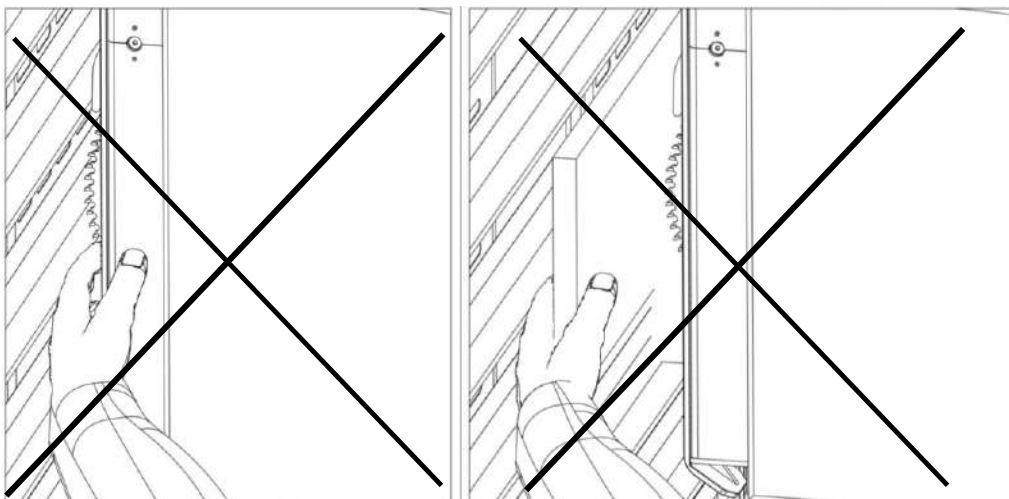
- The riving knife must always be used on the vertical panel saw machines. In sections the riving knife can be reversed per cut. The riving knife must never be fixed while retracted.
- The suction hood must be removed for placement, adjustment and control of the riving knife. It is forbidden to operate the machine in this case. Before starting this work, stop the machine and press the emergency stop button.

-OPERATION OF CUTTING UNIT

- Always hold the control unit when shifting the cutting unit.
- Bring the saw unit to the beginning of the cut while outside the material.
- start to size the material after the saw blade has reached the full rotation speed.

3.1.9 Dust Sucking

- Panel saw machine; must be connected to a suction system installed by the operator in accordance with the applicable directives in the geographical region where the machine is operated. The suction systems of the operator can be fixed-set or portable dust removers.
- The dust suction system should start working when the saw motor is running at the latest and the saw motor should be operated to discharge the suction lines for a certain period of time after closing.
- The pipes and hoses of the dust extraction system must be connected to the grounded construction parts of the machine as conductors for the dissolution of static electricity.
- The panel sizing machine must always be operated with a suction hood that is undamaged and properly installed. Damaged suction hoods should be replaced immediately.
- Damaged or compressed suction hoods will not provide adequate protection against the saw blade and will reduce suction. As a result, heavy injuries and heavy dust concentrations in the air can occur.
- The suction hood should never be tightened. The hood must always be able to take the required take off action.
- Never put your hand in front of the suction hood. The processing tool can cause severe injury by coming out of the tool space in the suction hood.
- Never put your hand behind the cut material. During entry and / or cutting, the saw blade leaves behind the cut material and enters the gap in the support wall. There is a danger of severe injury in this area.



3.1.10 Cutting Material

- Requirements for cutting material

- Only materials suitable for the capacity of the machine should be processed.

Observe the maximum cutting widths, maximum plate thicknesses and maximum work piece weights depending on the support being installed.

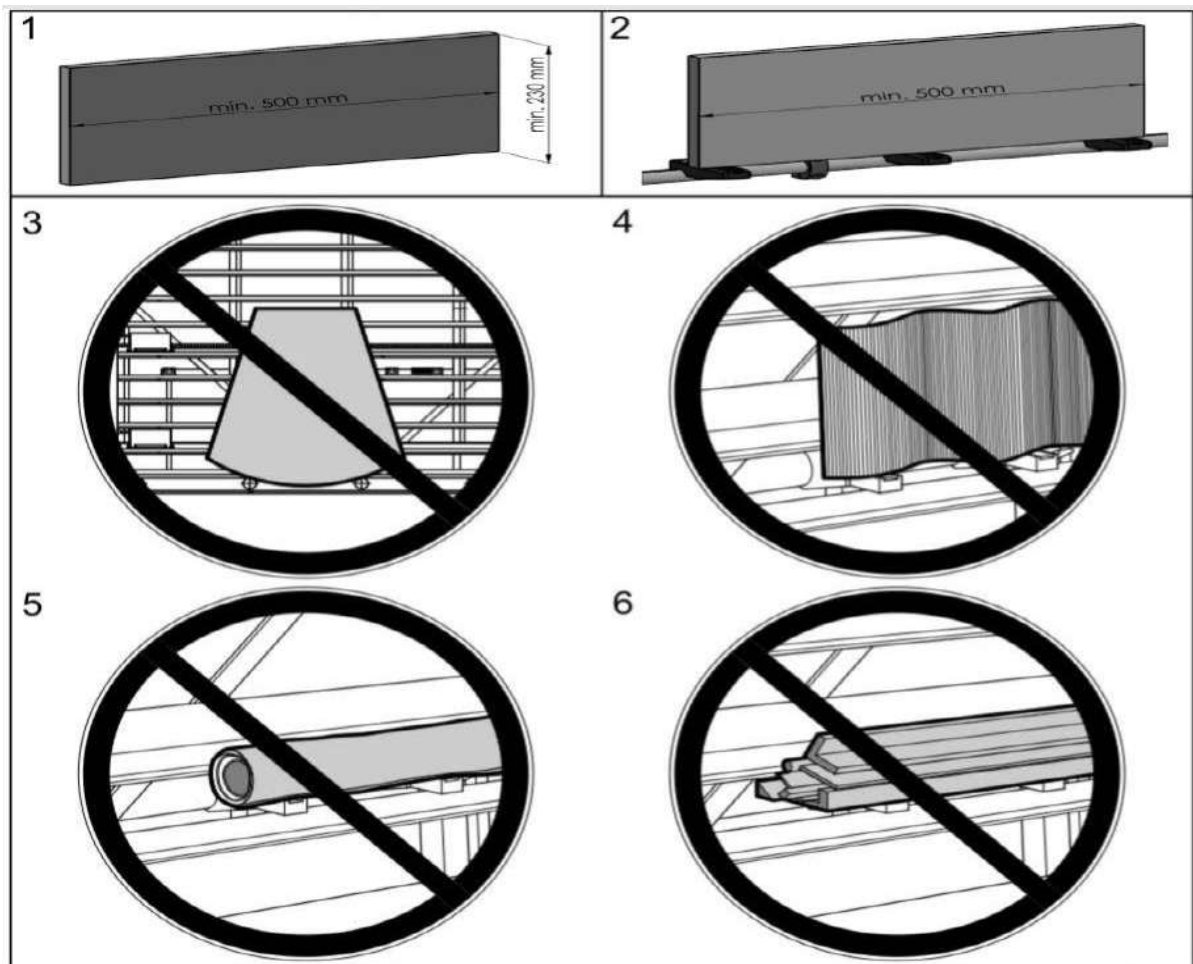
- The following minimum work piece measurements must not be exceeded.

Horizontal cutting and vertical cutting (1)

X=500 mm Y=230 mm

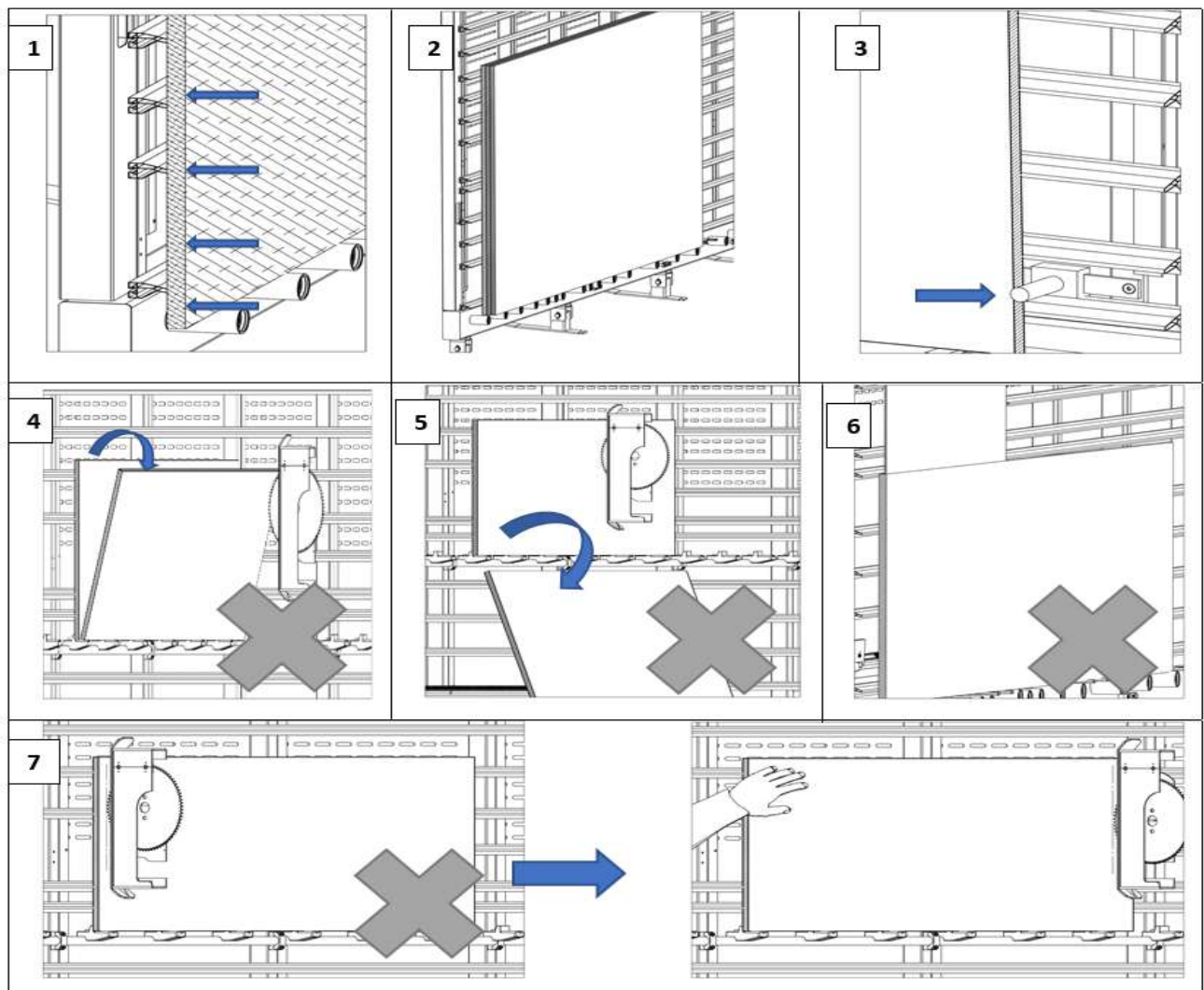
Work pieces with the following characteristics must never be machined in a vertical panel saw machine.

- Amorphous materials
- Soft materials
- Unstable materials
- Round materials



- Positioning work pieces on the machine

- The cutting material must be placed on the support wall in a wiping manner along its entire surface (1).
- Place only equal-sized plates on the machine during package cuts (2).
- Use medium stoppers for horizontal machining of smaller work pieces and / or machining of horizontal stoppers on support rollers of work pieces (3).
- For horizontal or vertical cutting, place the work pieces on the plate support in such a way as to stabilize, not slip, or tilt forward or downward. The work pieces must be able to withstand the forces coming from the saw blade and the spring suction hood (4-5).
- Make sure that there is no cutting material on the medium support before turning it off (5).
- Never stack plates of different format or thickness on top of each other (6).
- The cutting position of the work pieces should be determined in such a way as to allow the parts to be held or manually secured with a sufficient axial distance to the saw blade. Sufficient distance is the distance that you will not touch the saw blade in improper situations such as your hand slip. Assign an assistant if necessary (7)



3.1.11 Usage Wizard Error Notification

When a malfunction occurs on the machine, you must first determine the type of malfunction.

Depending on the type of malfunction, these can be cleared by the machine user.

E.g. Defects in electrical or pneumatic systems must not be removed by the operator.

- Do not open electrical or pneumatic control bodies
- Do not turn on the power switch or motor protection switch after it has been triggered.
- Do not change insured fuses.
- Do not activate electrical appliances in the control cabinets.

Such defects should only be rectified by the dealer or Wadkin Bursgreen service technicians.

3.1.12 Residual Risks

The panel saw is manufactured in accordance with the applicable standards and accepted safety regulations. The machine is suitable for the latest technical level.

Nevertheless, there may be a risk of damage to the machine or other persons or to the health of the users and / or third parties during the use of the machine.

Electric shock

Contact with voltage conducting parts may lead directly to death or serious injury. Defective electrical components or damaged insulation can carry voltage.

Danger of injury from splinters coming from tools or cutting material

When a processing tool is broken or the cutting material is being processed, splinters and particles may be ejected from the tool or the material. These can lead to injuries.

- Use protective equipment during handling: Protective work clothing, safety goggles and protective gloves.

Danger of injury from moving machine parts

The movements of the saw gantry and sawing unit can trap, drag, and injure people's clothing or similar objects.

Likewise, people or bodily limbs can be jammed or crushed between machine parts or between machine and work pieces.

- Use personal protective work equipment while working on the machine.
- Never enter the dangerous zone of moving machine parts or insert your hand.

Danger of injury from processing tools

Sharply sharpened machining tools can cause serious disruption or separation of the body parts during installation / removal of the machine or when placed in the machine.

- Do not bring your hand close to the tool when the saw is stationary or running.
- Use personal protective work equipment while working on processing tools.

Risk of injury from explosive pneumatic parts

Pressurised air coming out of defective pneumatic parts or exploding pneumatic parts can lead to injuries.

- If there is a fault in the damaged pneumatic line or in the pneumatic system, the compressed air should be immediately disconnected and repaired by an authorised persons only.
- The work to be carried out in the pneumatic system should only be carried out by authorised specialists.
- Use personal protective work equipment.

Health hazard caused by dust and noise

- The working panel saw produces noises and harmful dusts or other substances can form when certain materials are being processed. These effects can lead to hearing impairment or respiratory distress.
- Use personal protective equipment while the machine is running.
- Learn about the emission values involved when processing sheet materials.
- Use adequate respiratory protection in addition to personal protective equipment when handling hazardous materials.

The risk of occupational illnesses and injuries occurring as a result of work with materials and work pieces can be greatly reduced by us the following.

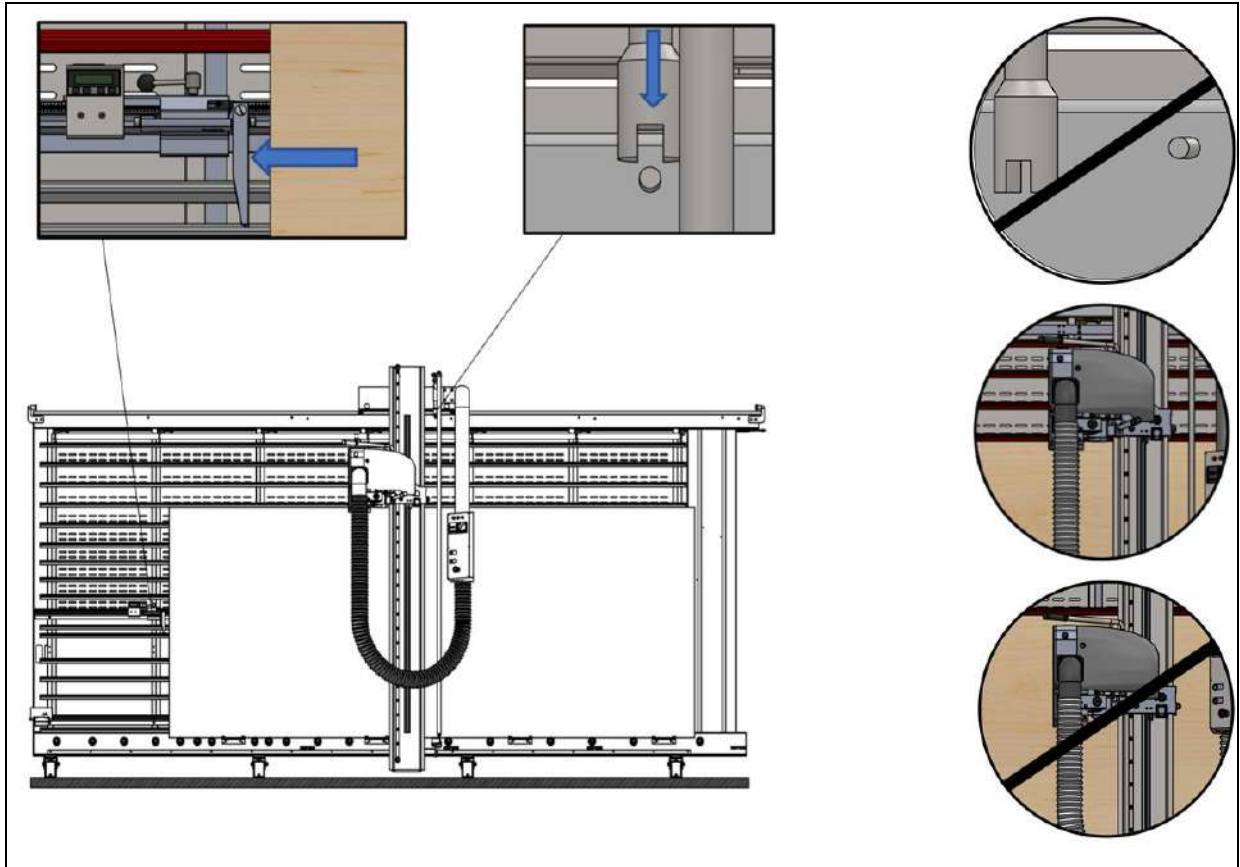
- Lifting and transport equipment for work pieces
- Aids for storage of materials
- Good lighting and ventilation of the workplace
- Proper arrangement of the workplace
- Emergency tools, devices and instructions

3.2 General Use Instructions

The Wadkin Bursgreen vertical panel saw machine is manufactured by specialists in the field of manufacturing, taking all safety precautions into consideration. The safety instructions specified during transportation, assembly and installation must be fully applied before use. The specified mechanical and electrical systems must be inspected and made available.

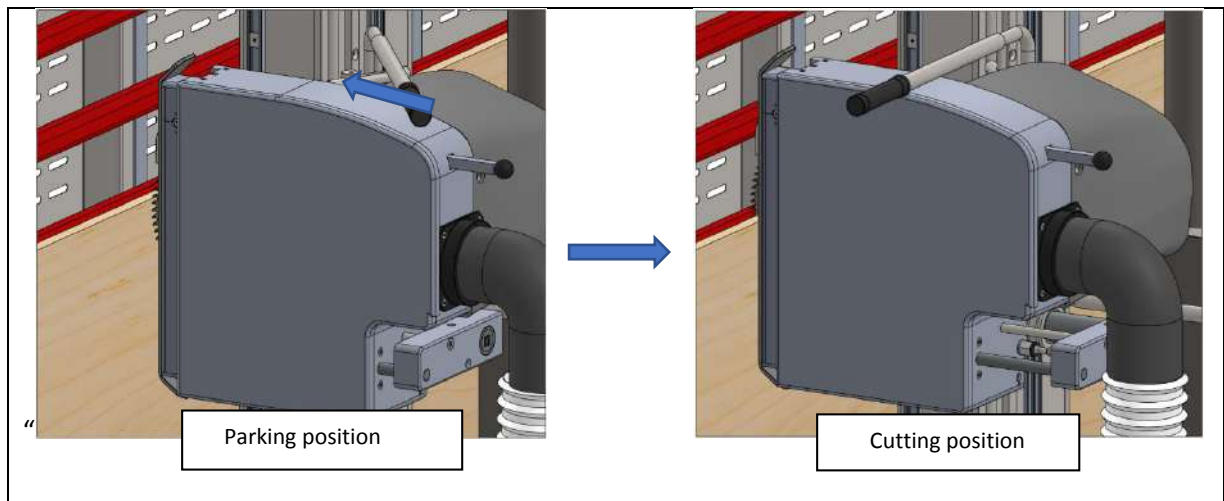
3.2.1 Vertical Cutting Operation

- 1- The material is securely placed on the machine. (see Positioning work pieces on the machine)
- 2- The ruler on the frame is set to the desired measure.
- 3- The gantry is secured to one of the desired lock points.
- 4- the material rest on the stopper which stayed on the ruler.

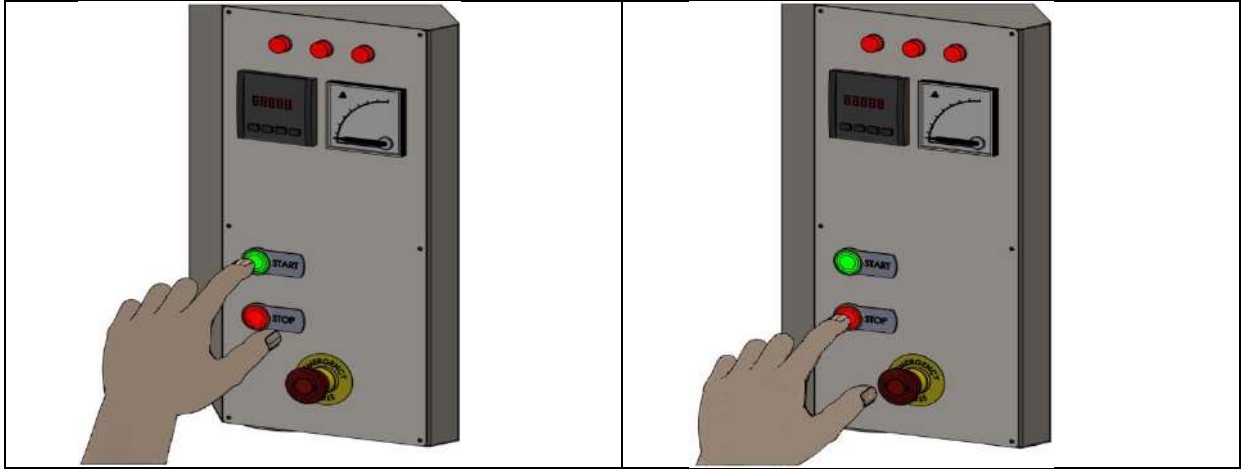


5- The saw unit is run and lifted to the top of the material on the gantry

6- The saw unit is taken to the vertical cutting position with the help of its arms.



7- The cutting operation is completed by lowering the saw to the lowest point at constant speed. Saw unit stopped with stop button.

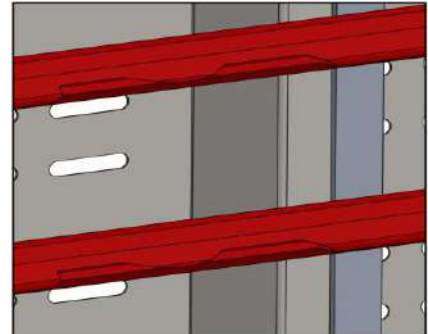


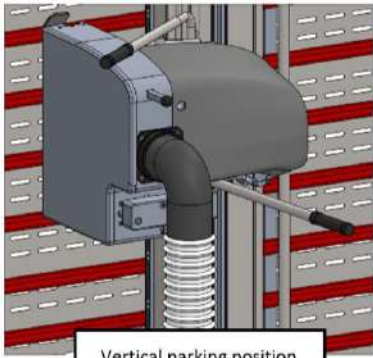
3.2.2 Vertical-Horizontal Position Change

You can change your machine's vertical horizontal cutting position as shown in the pictures. Please do not use before reading this warning. Your machine can change position easily with the help of arms. Your machine is in the cutting position during sizing. When the cut is over, the upper arm will come to the stop position when you pull it towards yourself. When you want to change the cutting position, you can pull it back towards you while the upper arm is in the stop position and replace the saw unit with the lower arm in the horizontal position. Do not leave your machine in the cutting position when the cuts are over. Move to stop position.

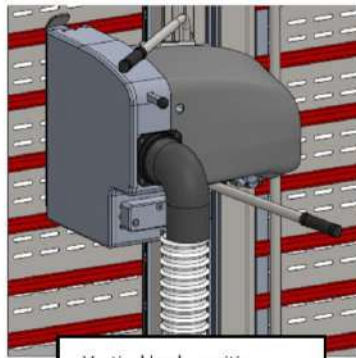
To switch between the meters, move your machine to the park position.

Otherwise, the wickets of your machine will be damaged as shown in the picture.

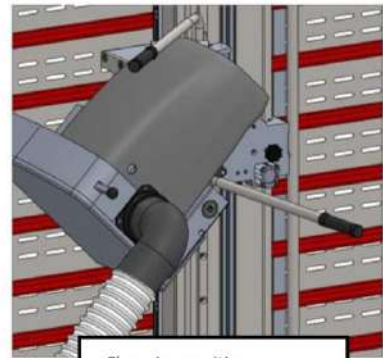




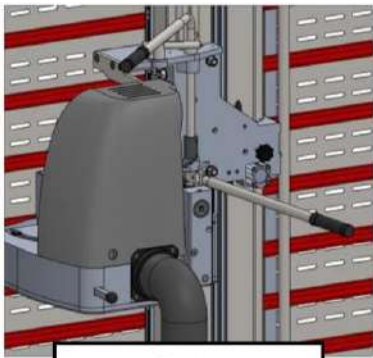
Vertical parking position



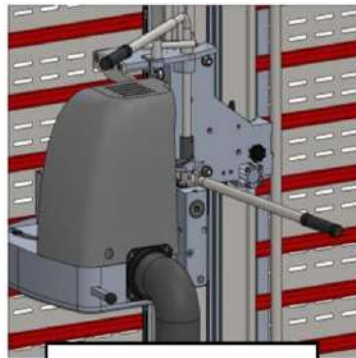
Vertical back position



Changing position



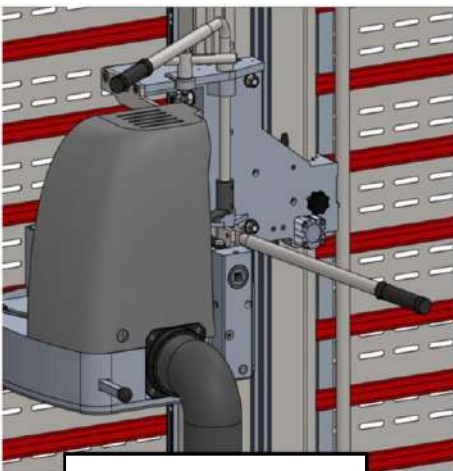
Horizontal back position



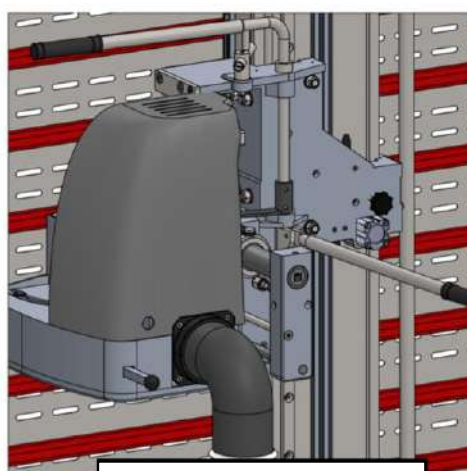
Horizontal parking position

3.2.3 Horizontal Cutting Operation

- 1- The material is securely placed on the machine.
- 2- The saw unit is taken to the horizontal cutting position.

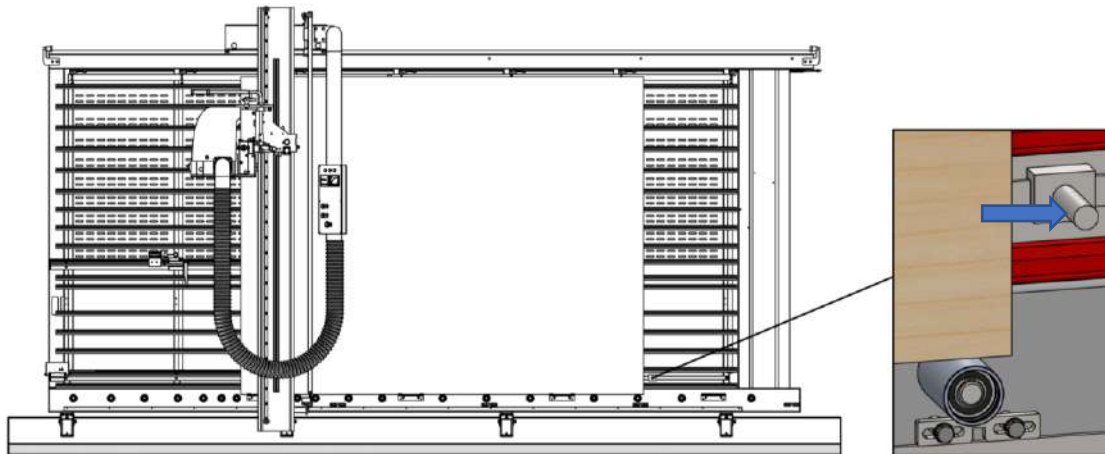


Parking position



Cutting position

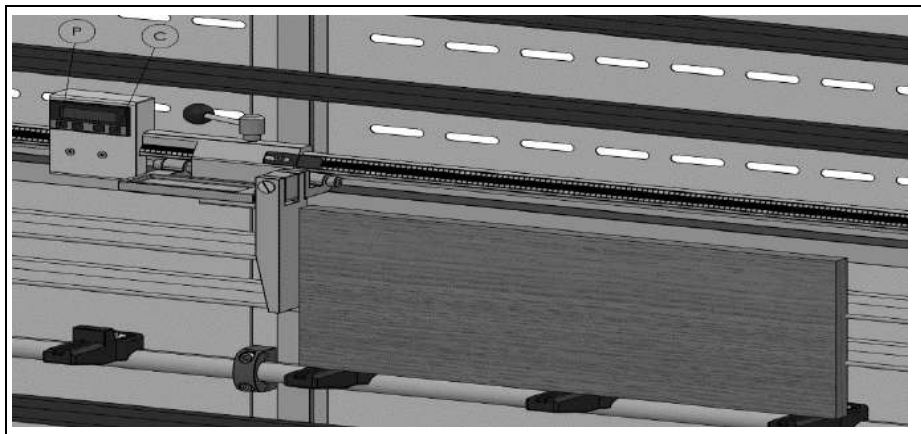
3- The plate is placed in the horizontal cutting stand.



4.DIGITAL MEASUREMENT SYSTEM

This product is used as an accessory for Wadkin Bursgreen vertical panel saw machine. It should not be forgotten that the use of the product may bring some dangers. You can prevent or reduce these hazards by following certain safety guidelines. The measurement strip contains magnetically recorded information. Severe external magnetic fields can cause this information to be destroyed and the measurement lane becoming unusable. Keep any strong magnetic field away from the magnetic stripe.

1. Aluminum stopper is set to manual position 0 mm.
2. Press "P" and "C" keys at the same time on the digital meter for reset the digital.
3. The digital display is positioned and secured with the aluminum stem as 200 mm.
4. Vertical cutting is done on the basis of the part and the piece size is measured accurately.
5. The denier "part size" is brought to -200 mm position and reset again. (eg: Measured piece size is 200.5mm, restraint is reset to 0,5mm position and reset)



5.SCORING SAW UNIT

This product is used as an accessory for Wadkin Bursgreen vertical panel sizing machine. It should not be forgotten that the product may bring some hazards with its use. You can reduce or prevent these hazards by following the safety instructions.

5.1 Tooling Assembly

The scoring blades must have the following characteristics.

Nominal diameter	80 mm
Minimum diameter	75 mm
Hole diameter	20 mm
Maximum width	3,6 mm

Only use sharp scoring blade suitable for the material. The cutting edge geometry of the saw leaves and the cutting edge material must be determined according to the material.

The use of HSS type saw blades is prohibited.

Saw blades that are cracked or deformed should not be used.

Maximum attention must be given to operations performed with processing tools. There is a risk of injury from very sharp edges. Appropriate fittings and handling arrangements should be used.

5.2 Processing of Cutting Material

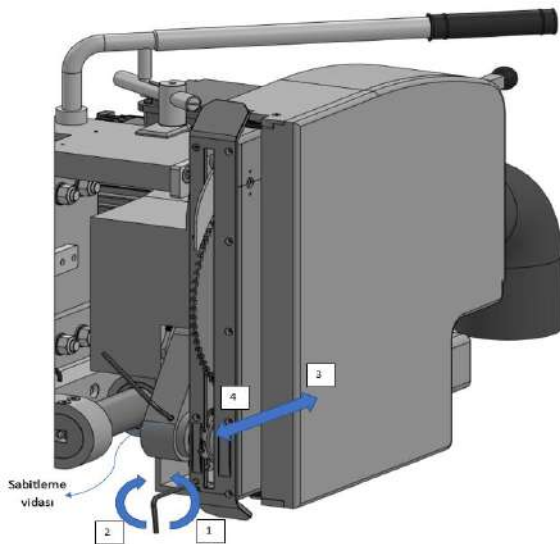
Never work without protective devices and never make any changes that could put safety on the machine

The scoring saw blade unit can only be pushed into the working position in the effective process. After the end of the cutting, the unit should be returned to the waiting position.

Settings for scoring saw blade centering and depth of draw should only be performed while the machine is stationary and the Emergency Off button is pressed.

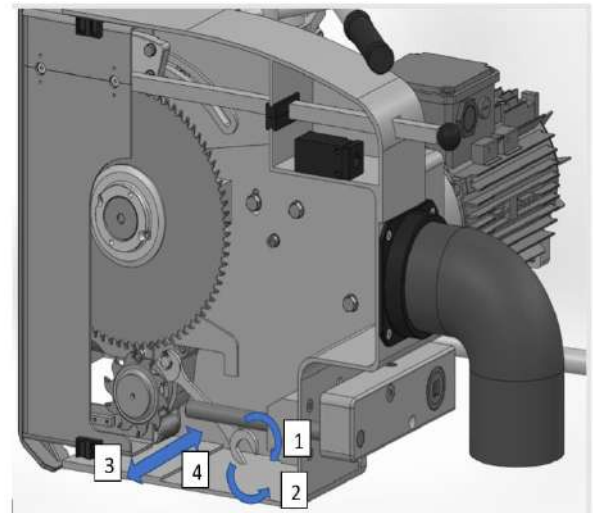
5.3 Settings of Scoring Blade

1. The fixing screw shown is loosened by turning 2 turns.
2. For right and left adjustment of the blade; the indicated screw moves 0.1 mm when turned.
3. The screw shown for the depth adjustment of the blade moves 1 mm when rotated 1 turn.



when the key rotate the direction 1, blade move the direction 3

when the key rotate the direction 2, blade move the direction 4



when the key rotate the direction 1, blade move the direction 3

when the key rotate the direction 2, blade move the direction 4

6 MAINTENANCE

6.1 Safety Instructions

Failure to perform maintenance or proper servicing may result in hazardous conditions on machine parts or tools.

- Follow the maintenance intervals specified in the maintenance chart.
- In all maintenance work, take an aspiration so that the machine and its accessories are not inadvertently operated. Switch off the circuit breaker and the pneumatic opening valve.
- Solvent should never be used in machine cleaning.

6.2 Daily Maintenance

Check the list below for daily maintenance.

Control Point	Method	Resolution
1. Gantry movement	Move the gantry	Gantry should move freely.* check lubrication
2. Visual Blade control	Turn the blade slowly with your hand and check the teeth.	It should not be broken or crushed. If this is the case, change the knife.

3. Machine cleaning	Clean with air and dry cloth	The machine should be cleaned every day after work.
4. Lubrication condition	Lubricate the rails.	Use fine oil with a sponge or cloth. Keep it away from dust after it has been greased.
5. Sound, vibration and heat of bearings	Listen to the sound of the blade and look at the motion of the cutting block during the process	There should be no abnormal sound and vibration. There should not be abnormal heat in the bearings. And the motordan sounds are not abnormal.
6. Dust hose	Make sure that the dust hose is not filled and that it does not accumulate at any point.	The powder hose must be open and there should be no sawdust in it.
7. Bolts, hose connections	Check all bolts before operating the machine	All the points must be secure

6.3 Weekly Maintenance

Check the list below for weekly maintenance.

Control Point	Method	Resolution
1. Main bar	The main bar should be lubricated for comfortable movement of the shaft. Lubricate every 15 days	The cutting head should be able to move smoothly to horizontal and vertical positions.

6.4 Monthly Maintenance

Check the list below for monthly maintenance.

Control Point	Method	Resolution
1. Upper rail surface tolerance	Measure thickness and straightness	It must be straight
2. Right angle tolerance of cutting blade	Measure by cutting the panel	Maximum tolerance 0.2 mm per 1 meter
3. Tolerance of Gantry	Measure by cutting the panel	Maximum tolerance 0.2 mm per 1 meter
4. Level of rails	Put a long piece on the bottom rollers	The cylinders must be at the same level.
5. Electric cables and pneumatic hoses	Check carefully	they should not open, cut or cracked. connection point should be tight

6.5 Yearly Maintenance

Check the list below for annual maintenance.

Control Point	Method	Resolution
1. Overall level of the machine	<p>Check the main parts. Check the machine's feet</p>	<p>The machine must be stationary. It should print all its feet. There should be no feet on the air. Be sure to safely fix it to the place feet.</p>
2. Motor insulation	<p>Measure with the measuring instruments.</p> <p>IMPORTANT: The insulation test must be carried out by a qualified technician in order to avoid damage.</p>	<p>The value should be more than 2 mega ohms.</p>
3. Material support profiles	<p>be renewed if damaged</p>	<p>Material support profiles are highly modifiable.</p>

7 WARRANTY CONDITIONS

Advanced Machinery Services guarantees that all machines are tested before shipment and manufactured in accordance with international standards. The warranty period of the machine is 12 months from the date of shipment.

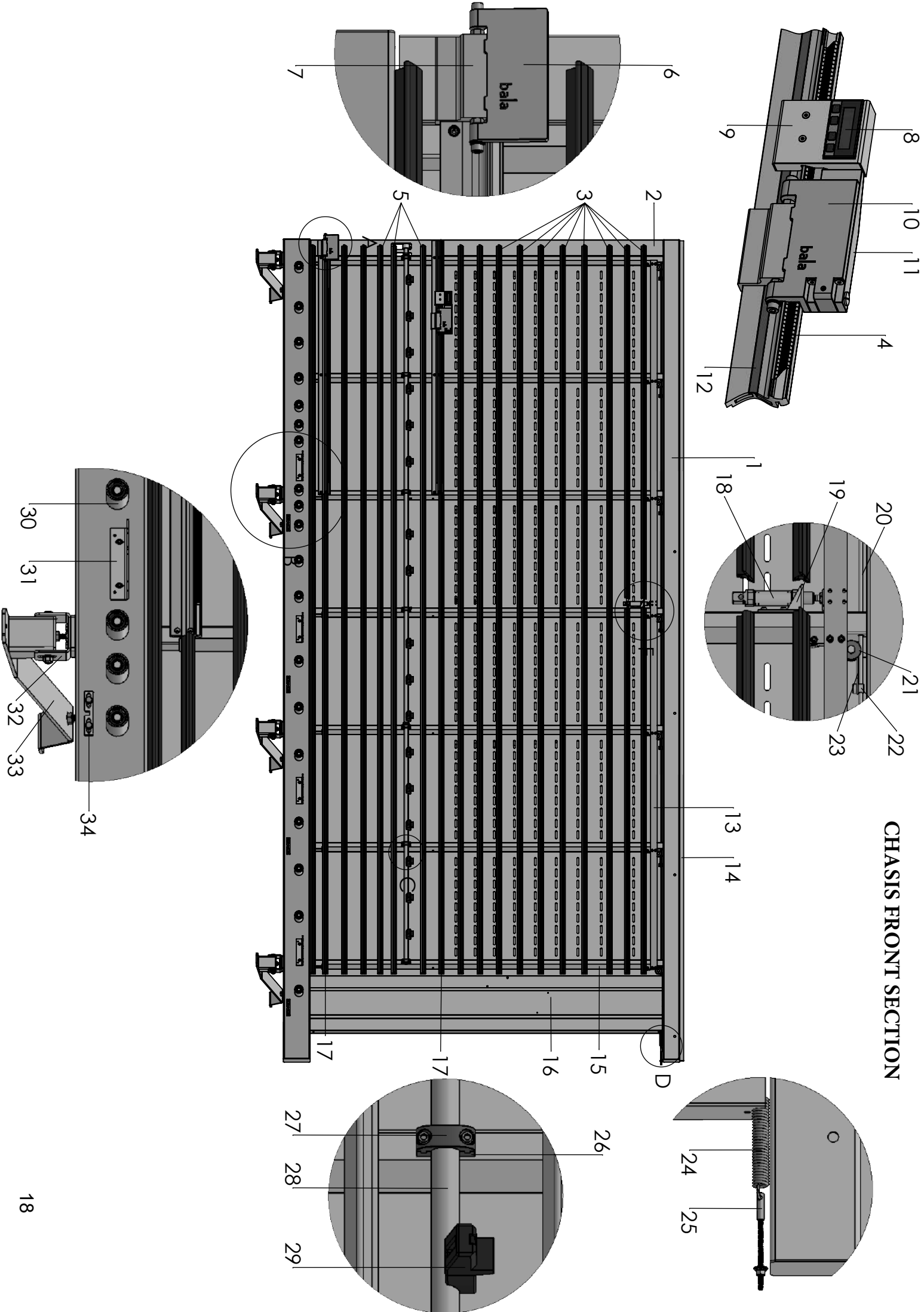
Warranty Covering Damages in the Following Situations

- In the event that any malfunction or defective part of the machine is replaced on site by our technical will be covered by our 12 months warranty conditions.

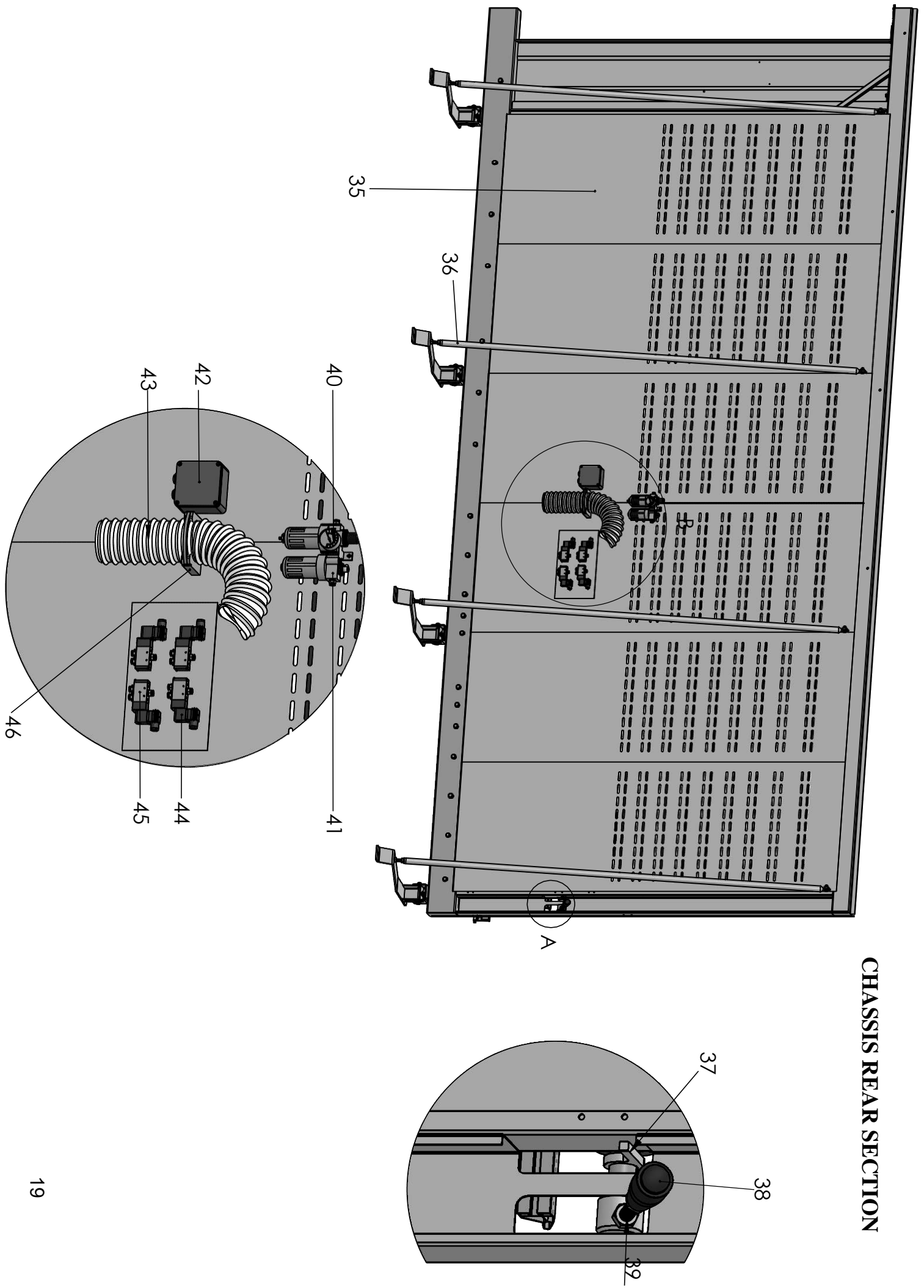
Warranty Does Not Cover Damages That Occur in the Following Situations

- Failure to comply with the rules set out in the instructions for use
- Improper use and improper use of the machine for design purposes.
- Routine maintenance of the machine (cleaning, oiling of the rails, etc.) is not done by the user or is incomplete
- Failures due to the electrical installation of the user in the electrical panels and materials of the machines
- Use of machining tools that are of poor quality and not suitable for machining may result in defects.
- Damages that may occur in the machine during relocation in the workshop or during the relocation of the machine to another facility.
- Natural Disasters (Fire, flood, earthquake etc.)
- Damage that may occur as a result of the machine being operated in a problematic manner.

CHASSIS FRONT SECTION



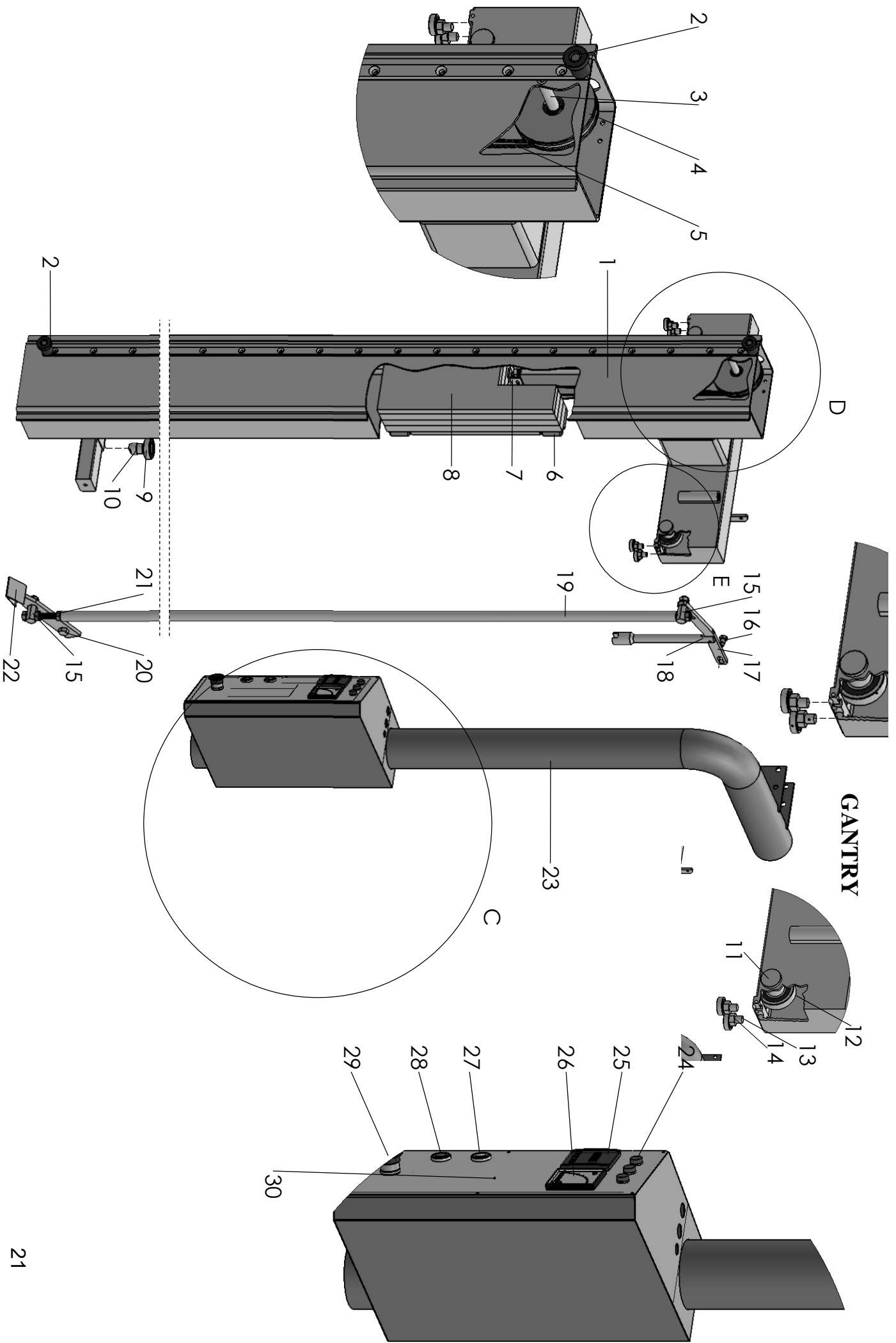
CHASSIS REAR SECTION



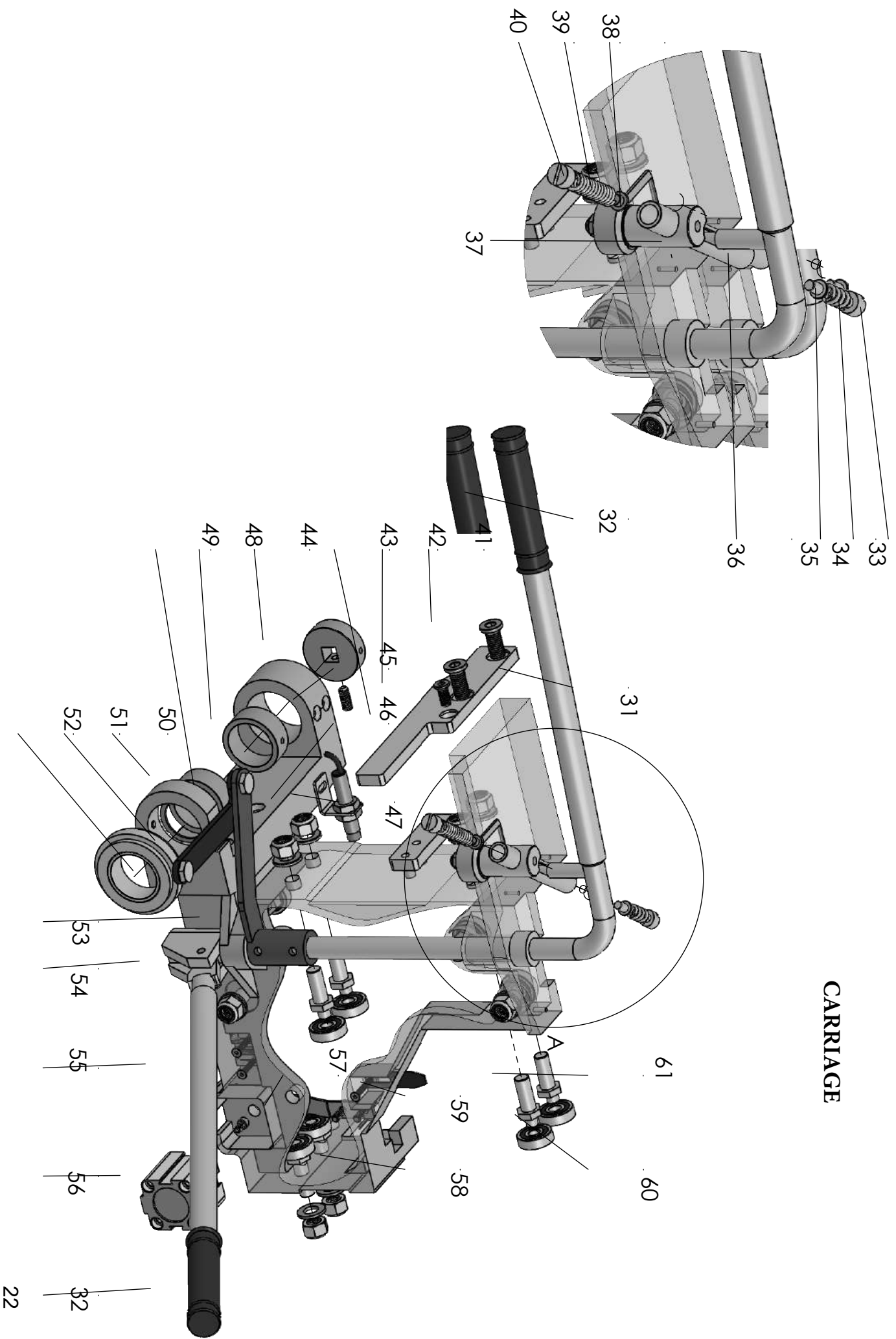
CHASSIPART LIST

Part no.	Part name
1	Chassis
2	Side sheet
3	Plastic profile
4	Meter
5	Plastic profile
6	Measurement part
7	Measurement part
8	Digital display
9	Measurement part
10	Measurement part
11	Display part
12	Magnetic band
13	Aluminum upper profile
14	Upper rail
15	Movable aluminum profile
16	Side sheet
17	Plastic profile
18	Pneumatic cylinder
19	Connection sheet
20	Upper spindle shaft
21	Upper roller
22	Rope
23	Spool pin part
24	Recoil spring
25	Recoil spring part
26	Clamp part
27	Clamp part
28	Shelf tube
29	Shelf plastic
30	Metal roller

Part no.	Part name
31	Bottom Metal support
32	Bottom feet part
33	Feet part
34	Bottom lock part
35	Back side sheet
36	Feet tube
37	Shelf tube part
38	Handle
39	Connection
40	Display
41	Air conditioner
42	Junction Box
43	Dust hose
44	Valve bobbin
45	Pneumatic valve
46	Dust hose clamp



CARRIAGE

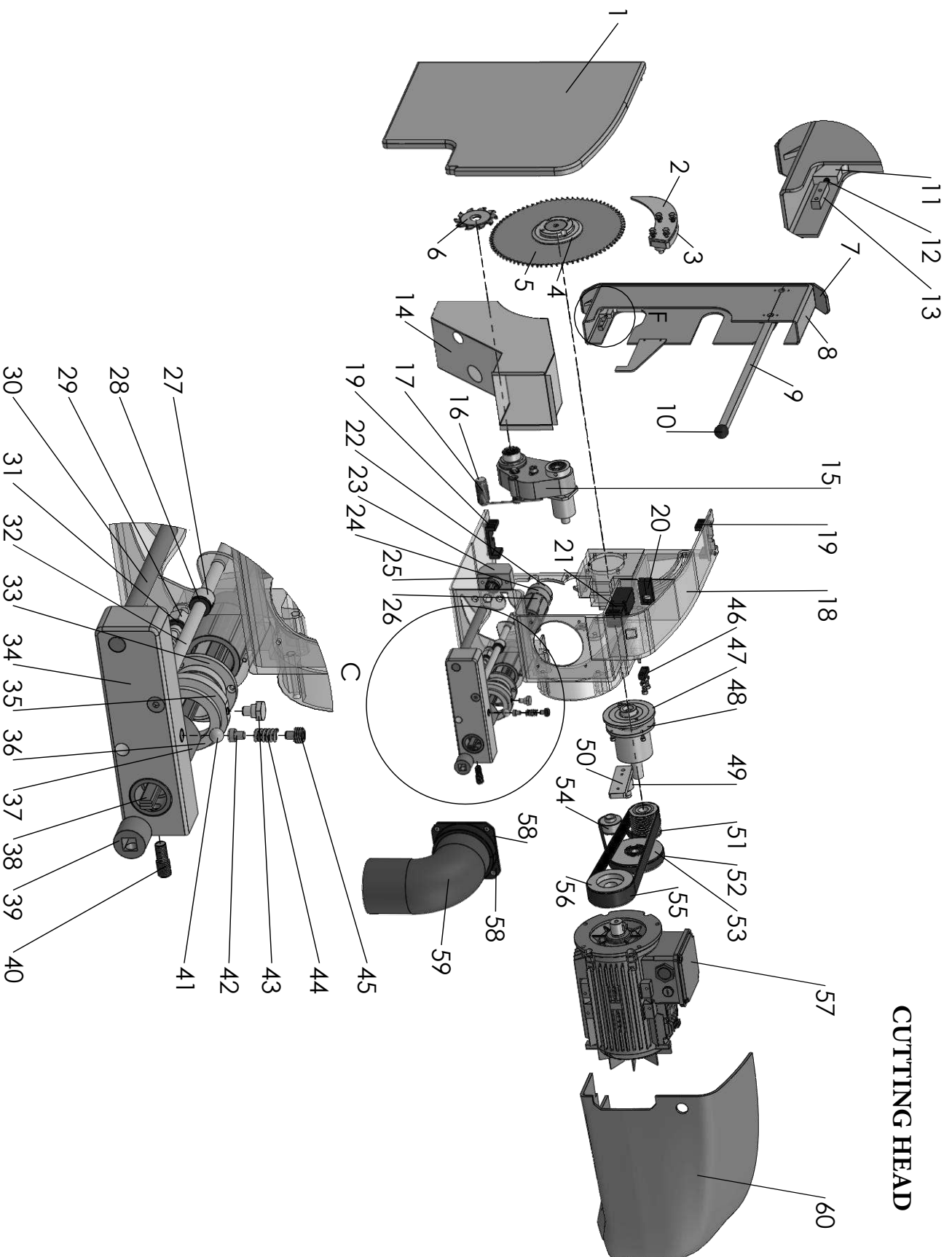


GANTRY AND CARRIAGE SPARE PART LIST

Part No.	Part name.
1	Carriage
2	Stop plastic
3	Pulley shaft
4	Steel rope pulley
5	Steel rope
6	Weight plastic
7	Rope connection sheet
8	Counterweight
9	Bearing
10	Bottom bearing part
11	Upper bearing part
12	Upper bearing
13	Upper eccentric part
14	Bearing
15	Upper lock connection part
16	Bolt
17	Lock part
18	Upper lock pin
19	lock tube
20	Bolt
21	Connector
22	Vertical lock part
23	Dust hose
24	Signal Lamp
25	Digital display
26	Ampere meter
27	Start button
28	Stop button
29	Emergency stop button
30	Control panel sheet

Part No.	Part name
31	Moving bar
32	Handle
33	Spring part
34	Spring (small)
35	Spring part
36	Moving bar part
37	Moving bar part
38	Plastic spring part
39	Spring (large)
40	Spring part
41	Bolt
42	Bolt
43	Motor sheet bar
44	Main bar connection
45	Stay bolt
46	Sensor connection part
47	Sensor
48	Bronze bushing part
49	Bolt
50	Bronze bushing part
51	Moving bar part
52	Bolt
53	Moving bar part
54	Lower handle connection
55	Lower handle
56	Pneumatic cylinder
57	Brake sheet
58	Carriage
59	Indicator
60	Bearing
61	Bearing connection part

CUTTING HEAD

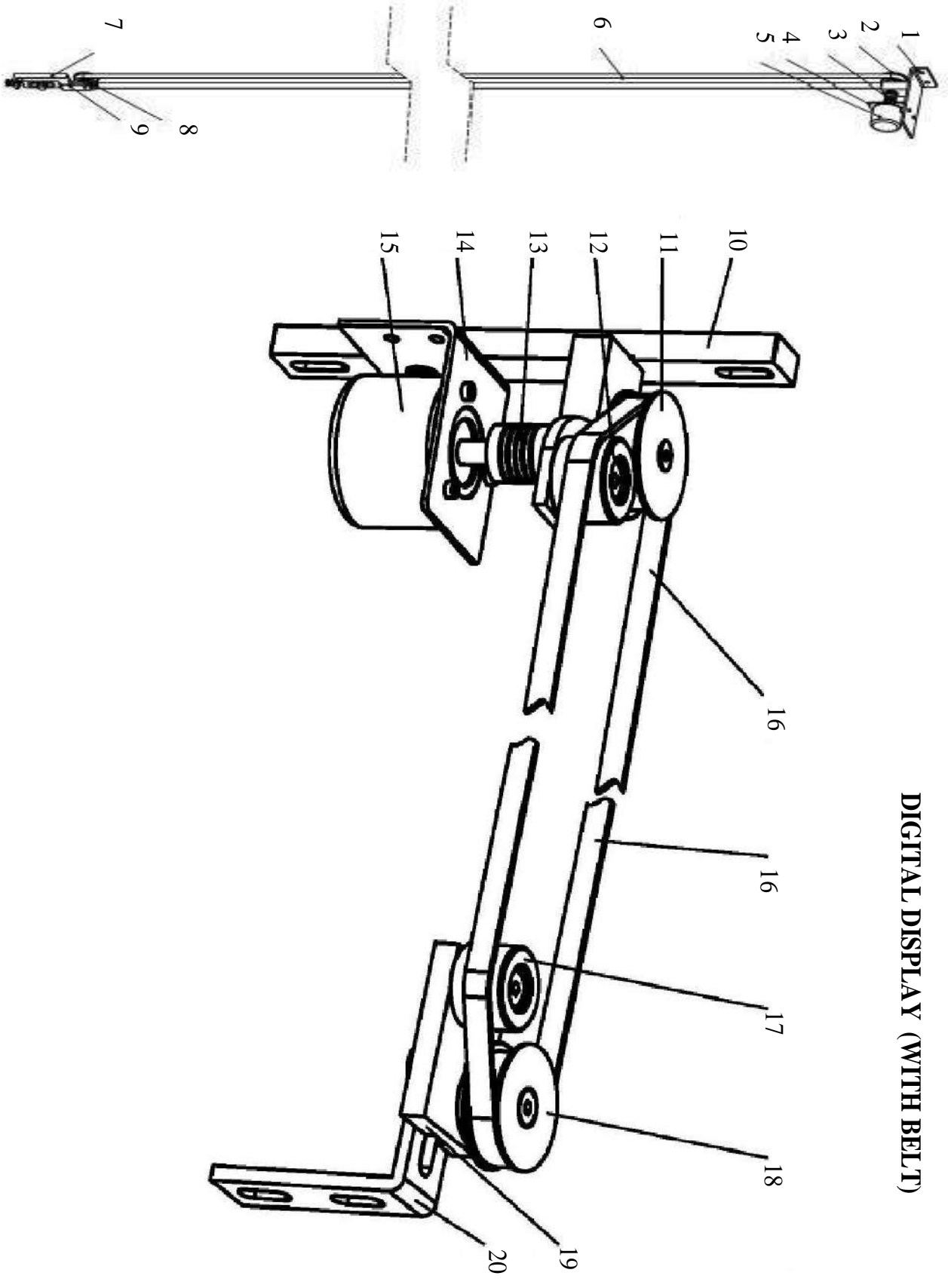


CUTTING HEAD SPARE PART LIST

Part No.	Part name
1	Blade door
2	Knife
3	Knife part
4	Cutting blade pulley
5	Cutting blade
6	Scoring blade
7	blade guard case plastic
8	blade guard case
9	Aluminum stick
10	Guard knob
11	Guard depth part
12	Guard depth part
13	Guard depth part
14	Hood
15	Scoring unit
16	Scoring spring part
17	Scoring spring
18	Casting
19	Guard bushing part
20	Plastic part
21	Switch
22	Bronze bushing part
23	Bearing bushing part
24	Bronze bushing part
25	Bearing
26	Bearing
27	Ring
28	Rug
29	Pin
30	Shaft

Part No.	Part name
31	Rug
32	Shaft
33	Handle part
34	Aluminum block
35	Handle part
36	Handle part
37	Main bar
38	Shaft spring
39	Block part
40	Stay bolt
41	Bearing
42	Block part
43	Bolt
44	Spring
45	Stay bolt
46	Motor small plastic
47	Main blade Shaft
48	Main blade shaft gland
49	Tension pulley part
50	Tension pulley
51	Main blade shaft pulley
52	Tension Belt
53	Tension pulley
54	Scoring pulley
55	Motor belt
56	Motor pulley
57	Motor
58	Plastic flange
59	Elbow
60	Motor cover

DIGITAL DISPLAY (WITH BELT)



DIGITAL DISPLAY (WITH BELT) SPARE PART LIST

Part No.	Part name
1	Encoder connection part
2	balance wheel
3	Coupling
4	Encoder connection part
5	Encoder
6	Belt
7	Tension pulley connection part
8	Tension pulley
9	Tension pulley connection part
10	Connection part
11	Pulley
12	Pulley
13	Coupling
14	Encoder connection part
15	Encoder
16	Belt
17	Pulley
18	Pulley
19	Connection part
20	Connection part

Agent or relevant supplier



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Version: 2021-22

Advanced Machinery Services Ltd.