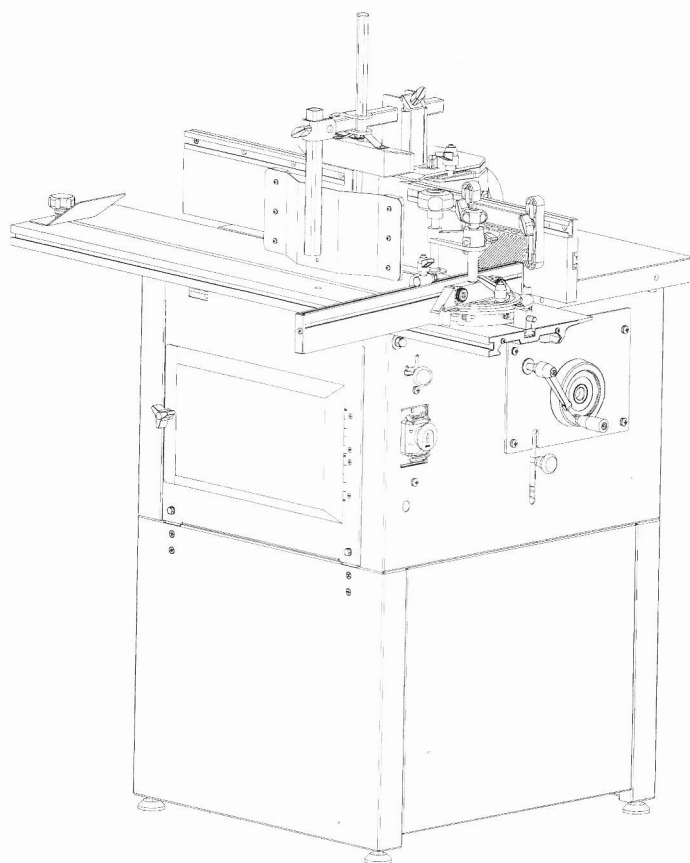




TOUPIE

(Modèle : MX5108)



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NOTICE D'UTILISATION / ASSEMBLY AND OPERATING INSTRUCTIONS

machine either with paraffin oil or any similar solvent, do not use petrol or similar solvents for this activity—they might cause reduced corrosion resistance of certain parts of the machine.

The working area size depends on the type of the machine, assumed working operations and size of material machined.

Do not forget about the space for location of a sufficiently effective exhausting system or connecting hoses for the central exhaustion.

Delivery form

The machine is delivered standard like prescribed here below:

- spindle ring-----18
- table ring -----2
- fence assembly-----1
- 22 mm A/F spanner-----1
- sliding table-----1

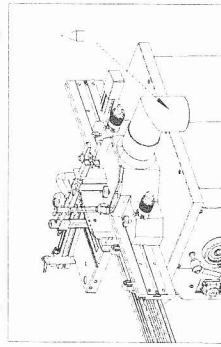
Working area

It is important to maintain free area of 0.8 m around the machine, which is required for the working place. If any long material is machined, it is necessary to have a sufficient room in front of the machine as well behind it in the places of material input and output.

Connection of the exhaustion system

Work on the machine only with the exhaustion system connected and running !

For the proper functioning of the machine, exhaustion equipment with minimum exhaustion capacity of 570 m³/hour and minimum speed of air in the pipes equal to 20m/s for dry particles and 790 m³/hour and minimum speed of air in the pipes equal to 28m/s for wet particles is necessary.



Switch on the machine drive and exhaustion system at the same time!

Use flexible exhausting hoses with diameters equal to 100 mm. The exhausting hose is connected to exhausting outlet whose location on machine is as follows:

For the moulding machine the exhausting hose is fitted onto the outlet from the moulding tool cover which also forms the exhausting connector (A). The hose diameter is 100 mm.

Connection to the mains

- Damaged power supply cables must be replaced by the competent specialist immediately. Operation with damaged cables is dangerous to life and is therefore forbidden!

- Before putting the machine into operation make sure that the voltage and frequency specified on the machine type plate comply with the values of the mains

to which it is connected.

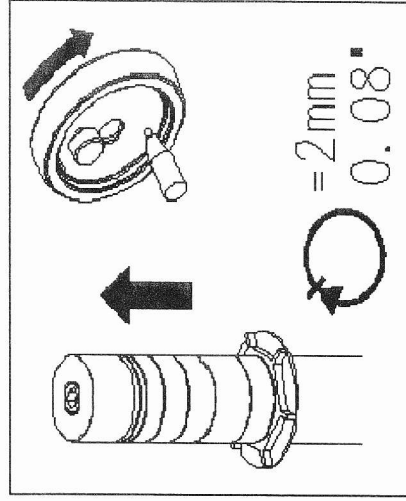
- Over voltage protection shall be provided by the end user.
- Before adjustment and replacement of tools and before any adjustment work, alterations and maintenance work, always turn off the switch and disconnect the plug from supply socket.
- This machine must be connected to the protection earth. Inspect and be sure that the socket is reliably earthed.

Direction of rotation

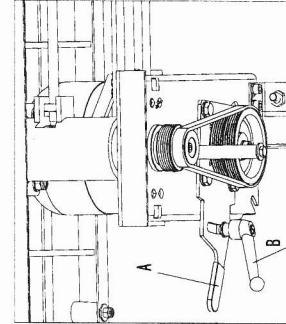
If you are standing on the side of the machine and viewing from upper of the table, the moulder spindle rotates anticlockwise if you look down.

Operation and adjustment of the machine

Set the height of the moulding spindle by means of the hand wheel located on the rear right side of the stand and secure it with the arresting screw. Select the suitable filler of the table (table filler) according to the tool used.

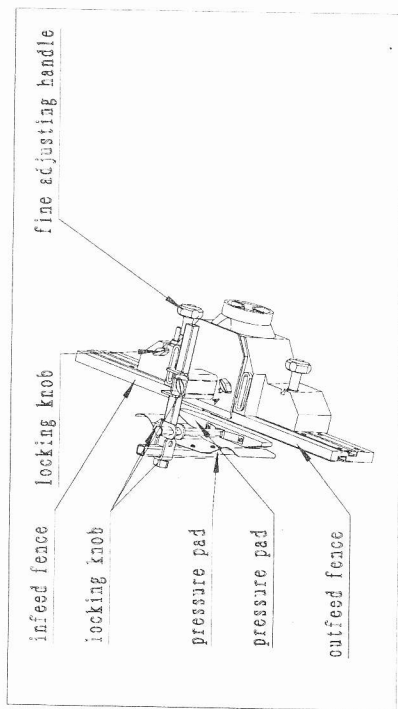


Speed change



The machine may be operated at 6,500 RPM (lower pulleys) or 4,500 RPM (upper pulleys). To change the spindle speed, loosen the lock handle (A) and pivot the motor assembly toward the spindle. Reposition the belt to the desired speed and tension the knob(B).

Lengthwise moulding

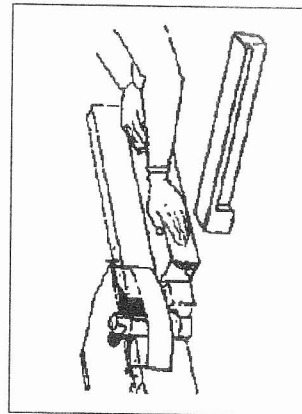


Tool: use suitable tools with a defined thickness of the chip for manual feeding.
 Working cycle: while test moulding is being performed, start working with a workpiece with sufficient length, width and height. It is necessary to prevent blocking of the machine, or to use a security kick-back adapted to the workpiece dimensions. In order to prevent kickback it is necessary to use back and/or front end stops fixed to the fence, table or fixed to and extension table.
 Never set the rulers while the machine is being operated!
 While working, perform the lateral adjustment of the fence plates, keep the opening for the tool to be reduced to a minimum, lock the fence plates and adjust the fine adjusting handle to set the required chip (wood removal) and lock the station by the locking knob.
 Keep the pressure pads in contact with the table and the fence plates firmly and evenly along the guide ruler.
 The cutting speed shall exceed 40 m s^{-1} in order to lessen the risk of kickback but shall not exceed 70 m s^{-1} in order to lessen the risk of tool damage.
 Adequate general or localised lighting shall be provided.

Moulding of workpieces with small cross-section

Tool : Choose the tool suitable for manual feeding.

Working cycle: Adjust the moulding machine and put both halves of the ruler close to the tool. Machine the material only by means of a pusher! Choose the size of the pusher so that the hand may be put on it comfortably.



Protective aids

For work on the machine eye protection are prescribed. It is advisable to use appropriate ear protection and commended working shoes. Working overall coats are not allowed to use.

Handlings NOT allowed

On the machine, it is **NOT** allowed to:

- perform any alteration of the machine safety items without the manufacturer's permission
- perform any manipulation inconsistent with safety instructions in this handbook
- touch the tool or its close surrounding places and other moving parts
- machine any materials other than wood or those based on wood
- overload the machine while machining large semi-finished products
- remove chips from the place near the tools by hand or with any object while the machine is being operated
- use other tools than those delivered or recommended by the machine manufacturer

Using the Fence as a Guide

Shaping with the fence is the safest and most satisfactory method of working. This method should always be used when work permits. Almost all-straight work can be used with the fence.

1. For most work, where a portion of the edge of the work is not touched by the cutter, both the front and rear fences are in a straight line, as shown in figure 8.

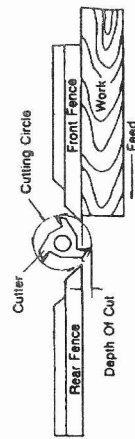


Fig. 8

2. When the shaping operation removes the entire edge of the work (i.e. jointing or making a full bead), the shaped edge will not be supported by the rear fence when both fences are in line as shown in Figure 9. In this case, the workpiece should be advanced to the position shown in figure 9 and stopped.

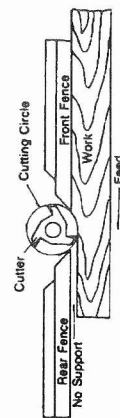


Fig. 9

3. The front fence should be advanced to contact the work as

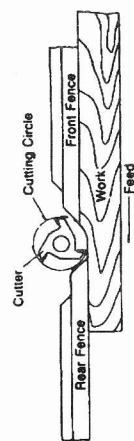


Fig. 10

shown in figure 10. The

rear fence will then be in line with the cutting circle.

Shaping with Collars

Follow these rules when shaping with collars for safest operation and best results:

1. Collars must be smooth and free from all gum or other substances.
2. The edge of the work must be smooth. Any irregularity in the surface, which rides against the collar, will be duplicated on the shaped surface.

3. A portion of the work's edge must remain untouched by the cutter so that the collar will have sufficient bearing surface. See figure 11 for an example of insufficient bearing surface.

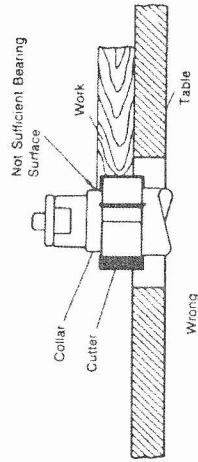


Fig. 11

4. Figure 12 illustrates sufficient bearing surface.

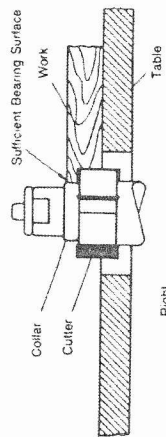


Fig. 12

5. Under no circumstances should a small workpiece be shaped against the collars as shown in Figure 13.

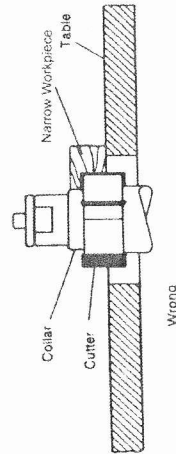


Fig. 13

Collar Positioning

Collars may be positioned above, below, or between two cutters:

1. When using the collar below the cutter, figure 14, the progress of the cut can be observed at all times. A disadvantage of this method is any accidental lifting of the work will gouge the wood and ruin the workpiece.

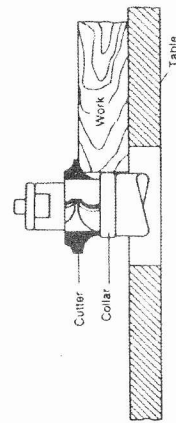


Fig. 14

2. Using the collar above the cutter, figure 15, offers the advantage of the cut not being affected by slight variations in the stock's thickness. However, the cut is not visible during the operation. Another advantage is accidental lifting of the work piece will not gouge the work piece. Simply correct the mistake by repeating the operation.

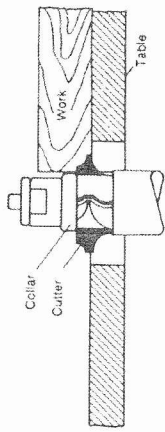


Fig. 15

3. The collar between cutters method, shown in figure 16, has both the advantages and disadvantages of the first two methods. This method is used primarily where both edges of the work are to be shaped. The machine can not be used for tenoning!

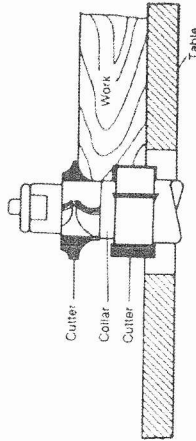
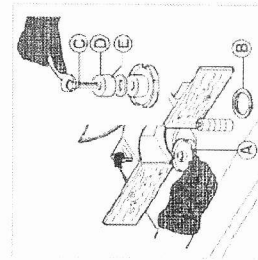


Fig. 16

Tools

Replacement of moulding tools

Only use moulding tools that are designed for manual feeding and may be clamped firmly and safely. Only tools conforming to EN847-1:2005 and marked MAN shall be used.



Before mounting tool (A) make sure that spacing rings (E) are clean and not damaged. Make sure that the fastening method is proper. The moulding tool is fixed and clamped by bolt (nut) (C), through spindle ring (D) and spacing rings (E) on the moulding spindle! Adjust the hole in the table according to the diameter of moulding tool (A) by table rings (B).

When installing the moulding tools, the cover of guard needs to be opened. Loose the two locking knobs (F) to open the cover. After installation, close the cover and lock it through the locking knobs.

Warning: Always close the cover of guard and lock it securely after tools installed.

