

**TRONCATRICE A DISCO PER METALLI FERROSI
CUTTING-OFF MACHINE WITH CIRCULAR BLADE FOR FERROUS METALS
METALL-KREISSAEGE
TRONÇONNEUSE A DISQUE POUR METAUX FERREUX
CORTADORA DE DISCO PARA METALES FERROSOS**

**MANUALE DI ISTRUZIONI PER L'USO - INSTRUCTION MANUAL FOR OPERATION
BETRIEBSANLEITUNG - MANUEL D'INSTRUCTIONS POUR L'EMPLOI
MANUAL DE INSTRUCCIONES DE USO**

COSTRUTTORE:

MANUFACTURER :

ERBAUER:

MACC S.p.A. SCHIO (VI) - ITALY

CONSTRUCTEUR:

CONSTRUCTOR:

MODELLO:

MODEL :

NEW 350

MODELL:

MODELE:

MODELO:

MATRICOLA:

SERIAL NUMBER:

KENNNUMMER:

MATRICULE:

MATRICULA:

ANNO DI COSTRUZIONE:

YEAR OF CONSTRUCTION:

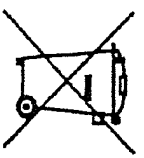
2010

BAUJAHR:

ANNEE DE CONSTRUCTION:

AÑO DE COSTRUCCION :

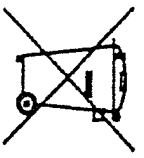
Magyarul



Felhasználás előtt elektromos és elektronikus készülékek hulladékként való elválogtatása (Használható az Európai Unió és egyéb európai országok eszelektív hulladékgyűjtési rendszereiben)

Ez a szimbólum a készülékek vagy a csomagoláson azt jelzi, hogy a terméket ne kezelje háztartási hulladékként. Kérjük, hogy az elektromos és elektronikai hulladék gyűjtésére kijelölt gyűjtőhelyen adja le. A felesleges vagy termékeknek helyes kezelésével segít megelőzni a környezeti és az emberi egészségre károsodást, mely bekövetkezhet, ha nem követi a hulladék kezelési helyes módját. Az anyagok újrahasznosítása segít a természeti erőforrások megőrzésében. A termék újrahasznosítása érdekében további információkat forduljon a helyi önkormányzat felé, ahol a hulladékgyűjtés szolgáltatásához vagy ahhoz az üzlethez, ahol a terméket megvásárolta.

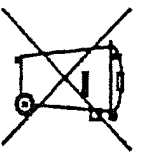
Česky



Nekládání a nepoužitým elektrickým a elektronickým zařízením (platná v Evropské unii a dalších evropských státech uplatňujících oddělený systém sběru)

Tento symbol umístěný na výrobku nebo jeho balení upozorňuje, že a výrobkem po ukončení jeho životnosti by nemělo být nakládáno jako s běžným odpadem z domácnosti. Mělo by být vyřazeno do speciálně určených sbíratek elektrických a elektronických výrobků a zařízení. Dodržování této instrukce zabrání nepříjemným dopadům na životní prostředí a zdraví lidí, které mohou způsobit neoprávněným vyřazením a výrobkem při jeho likvidaci. Recyklováním materiálu, z něhož je vyroben, pomůžete zachovat přírodní zdroje. Pro získání dalších informací o recyklování tohoto výrobku kontaktujte prosím místní úřady, místní firmu zabývající likvidací a sběr odpadů nebo prodejce, v níž jste výrobek zakoupili.

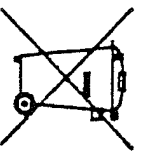
Slovensky



Likvidácia starých elektrických a elektronických zariadení (Platí v Európskej únii a ostatných európskych krajinách so zavedeným separovaným zberom)

Tento symbol na výrobku alebo obale znamená, že a výrobkom sa nemôže byť nakladané ako s domovým odpadom. Miesto (čo) je potrebné ho doviesť do určeného zberného miesta na recykliáciu elektrického zariadenia. Tým, že zariadenie správne zneškodíte, pomôžete zabrániť nepriaznivému negatívnemu vplyvu na životné prostredie a ľudské zdravie, ktoré by v opačnom prípade mohli pri nesprávnom nakladaní s týmto výrobkom. Recykliácia materiálov pomáha uchovávať prírodné zdroje. Pre získanie ďalších podrobných informácií o recykliácii tohoto výrobku kontaktujte prosím váš miestny alebo obecný úrad, miestnu službu pre zber domového odpadu alebo predajcu, kde ste výrobok zakúpili.

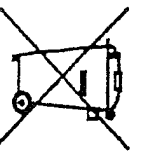
Türkçe



Eski Elektrikli & Elektronik Ekipmanların Atılması (Avrupa Birliği'nde ve AUA toplama sistemlerinde sahip diğer Avrupa ülkelerinde uygulanır)

Ürün veya ambalajı üzerindeki bu simbole, bu ürünü bir ev atığı olarak muamele görmemesi gerektiğini gösterir. Bunun yerine, elektrikli ve elektronik ekipmanların ayrı depolanmış için mevcut olan uygun toplama noktasına teslim etdirilmelidir. Bu ürünü doğru şekilde atılması sağlanarak, bu tür bir yanıtın mümkün olduğu kadar azaltılması sağlanabilir ve çevre ile insan sağlığına zararlı olabilecek etkilere bu nedenle azaltılabilir. Doğru şekilde atılması, doğal kaynakların korunmasına yardımcı oluruz. Malzemelerin ayrı depolanması, diğerleri seyrinde kullanılmaya yaradıkları, evsel atıkların geri dönüştürülmesine katkıda bulunabilir. İhtiyaç seyrinde kullanılmaya yaradıkları, evsel atıkların geri dönüştürülmesine katkıda bulunabilir. Bu türden geri dönüştürülme veya bu türden satın alınmış magazaya teması gerektirir.

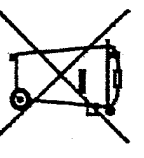
Slovenščina



Oddaja stare električne in elektronske opreme (veljavno v evropski uniji in ostalih evropskih državah s sistemom zbranje ločenih odpadkov)

Če so na izdelku ali na njegovih embalaži našli ta simbol, pomeni, da z izdelkom ne smete ravnati enako kot z drugimi gospodinjstskimi odpadki. Morate ga oddati na ustrezno zbirno mesto za recikliranje električne in elektronske opreme. S pravilno oddajo tega izdelka boste pomagali preprečiti negativne posledice na okolje in zdravje ljudi, do katerih bi prišlo v primeru neustreznega ravnanja ob oddatvi tega izdelka. Recikliranje materiala bo pripomoglo k ohranjanju naravnih virov. Podrobnejše informacije o recikliranju tega izdelka lahko dobite pri lokalni mešni upravi, službi oddajanja gospodinjstskih odpadkov ali v trgovini, kjer ste izdelka kupili. Odpadno električno in elektronsko opremo lahko oddate brezplačno tudi distributerju neposredno ob dobavi električne oz. elektronske opreme.

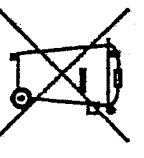
Русский



Утилизация электрического и электронного оборудования (применяется в странах Евросоюза и других европейских странах, где действует система раздельного сбора отходов)

Данный знак на устройстве или его упаковке означает, что данное устройство нельзя утилизировать вместе с прочими бытовыми отходами. Его следует сдать в соответствующий приемный пункт переработки электрического и электронного оборудования. Неправильная утилизация данного изделия может привести к потенциально негативному влиянию на окружающую среду и здоровье людей, поэтому для предотвращения подобных последствий необходимо выполнить специальные требования по утилизации этого изделия. Переработка данных материалов поможет сохранить природные ресурсы. Для получения более подробной информации о переработке этого изделия обратитесь в местные органы государственной службы сбора бытовых отходов или в магазин, где было приобретено изделие.

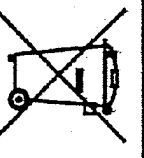
Slovní



Kyřování polatelných elektrických a elektronických zařízení (Evropská unie) je mulden Euroopan maiden kerättyjä jätteitä)

Symboli, joka on merkitty Tuotteen tai sen pakkauskesk, osoittaa, että tätä tuotetta ei saa käsitellä tavallisten jätteenä. Tuote on sen sijaan luovutettava eriytyneeseen sähkö- ja elektronikkajätteen keräilykeskään huolellisesti. Tärkeä on sen sijaan luovutettava eriytyneeseen sähkö- ja elektronikkajätteen keräilykeskään huolellisesti. Tällä tavalla vältetään mahdolliset haitalliset vaikutukset ympäristöön ja ihmisiin, jotka voivat aiheutua väärästä käytöstä. Materiaalien kierrätyksen avulla voidaan säästää luonnonvaroja. Tärkeämpää tietoa tämän tuotteen eriytyneeseen jätteeseen saa paikallisesta kunnantalonista.

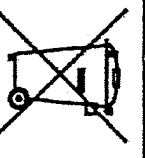
Dansk



Bortkælpelse af elektriske og elektroniske udstyr (gælder i EU og andre europæiske lande med egne indsamlingsystemer)

Hvis dette symbol findes på produktet eller på emballagen betyder det, at det pågældende produkt ikke må bortkælpes som almindeligt husholdningsaffald. Du skal i stedet afleveres det på et indsamlingssted, hvor elektriske og elektroniske udstyr kan blive genbragt. Når du bortkælder produktet korrekt, hjælper du med at forhindre de mulige negative påvirkninger af miljøet eller sundheden, der kan opstå. Hvis produktet bortkædles på en særlig måde, kan det hjælpe med at bevare naturressourcer. Yderligere oplysninger om genbrug af produktet fås på kommunen, på genbrugscenteret eller i den lokale hvor dit lokale produkt.

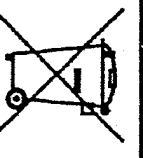
Português



Tratamento de Equipamentos Eléctricos e Electrónicos no final da sua vida útil (Aplicável na União Europeia e em países Europeus com sistemas de recolha selectiva de resíduos)

Este símbolo, colocado no produto ou na sua embalagem, indica que este não deve ser tratado como resíduo urbano indiferenciado. Deve ser colocado num ponto de recolha destinado a resíduos de equipamentos eléctricos e electrónicos. Assaguntando-se que este produto é correctamente depositado, irá prevenir potenciais consequências negativas para o ambiente bem como para a saúde, que de outra forma poderiam ocorrer pelo mau manuseamento destes produtos. A reciclagem dos materiais contribui para a sustentação dos recursos naturais. Para obter informações mais detalhadas sobre a reciclagem deste produto, por favor contacte o município onde reside, os serviços de recolha de resíduos ou a loja onde adquiriu o produto.

Ελληνικά



Αποκοπή Πάραου Ηλεκτρικού & Ηλεκτρονικού Εξοπλισμού/Γραμμής στην Ευρωπαϊκή Ένωση και άλλες Ευρωπαϊκές χώρες με ξεχωριστά συστήματα περισυλλογής)

Το σύμβολο αυτό ενόψει στο προϊόν ή στη συσκευασία του σημαίνει ότι το προϊόν δεν πρέπει να πεταχτεί μαζί με τα οικιακά απορρίμματα αλλά πρέπει να αποδοθεί σε ένα κατάλληλο σημείο συλλογής ηλεκτρικού και ηλεκτρονικού υλικού που αναγράφεται. Με το να βοηθήσετε ότι το προϊόν πεταχτεί σωστά, βοηθάτε στην πρόληψη πιθανών αρνητικών επιπτώσεων στο περιβάλλον και την υγεία. Η ανακύκλωση των υλικών θα βοηθήσει στην εξοικονόμηση φυσικών πόρων, θα απορροφήσει πληροφορίες σχετικά με την ανακύκλωση αυτού του προϊόντος, παρακάτω ετικετών που υπάρχουν με τις υπηρεσίες κομμάτι της του δήμου σας ή το κατάστημα όπου αγοράσατε το προϊόν.

1. INTRODUCTION

The "Operating instructions" are an integral part of the machine and should be consulted before, during and after the start up of the machine and whenever else required. The content of these instructions should always be carefully observed.

The observance of the above is the only way to achieve the two fundamental aims of this manual:

- Optimization of machine performance
- Prevent damage to the machine and injury to the operator

The index of the chapters and the index of the drawings, diagrams and tables is contained in chapter 3 and can be used to help the location of specific information.

CAUTION : BEFORE INSTALLING THE MACHINE, READ THE OPERATING INSTRUCTIONS CAREFULLY

2. INFORMATION ABOUT MAINTENANCE ASSISTANCE

2.1 GUARANTEE

- MACC S.p.A. products are guaranteed against material and manufacturing defects for a period of 12 months from the date of delivery or, if the machine is installed by MACC employees, from the date of machine start up.
- The buyer is only entitled to the replacement of parts which are acknowledged as faulty: carriage and packing are at the buyer's expense. In the event of the above, the following information should be supplied:
 1. Date and number of purchasing document
 2. Machine model
 3. Serial number
 4. Code of any relevant drawings
- Requests for compensation for the inactivity of the machine will not be accepted.
- The guarantee does not cover uses which are not in line with these operating instructions which are an integral part of the machine. Nor is maintenance covered if the instructions supplied are not observed.
- The guarantee will not cover machines which have undergone unauthorized modifications.
- Modification or tampering with the safety devices is strictly forbidden.

3. INDEX

3.1 INDEX OF CHAPTERS

Chap. 1	Introduction
Chap. 2	Information about maintenance assistance
Chap. 3	Index of chapters, drawings, diagrams and tables
Chap. 4	Description of the machine Description of the machine and its components Intended and unsuitable uses of the machine
Chap. 5	Main technical data
Chap. 6	Handling and transportation
Chap. 7	Installation
Chap. 8	Start up and operation Devices and their location Tools supplied Operation Special safety checks General safety rules Measures to prevent residual risks Safety, Guidance, Notice labels on the machine
Chap. 9	Maintenance and repairs General safety measures Routine checks and maintenance Description of routine maintenance
Chap. 10	Information regarding environmental noise
Chap. 11	Laying off - Demolition
Chap. 12	List of spare parts

3.2 INDEX OF DRAWINGS, DIAGRAMS AND TABLES

ENCL. TYPE	DESCRIPTION	ENCL No.	CHAP.
Table	Choice of circular blade	1	8.3
Drawings	Handling and transportation- Installation plan	1	6/7/8
Drawings	Electrical details	2	7
Diagram	Electrical installation	2	
Drawings	Motor-blade block	3	7/8.3/9
Drawings	Base block and vice	3	8.3/9.3
Drawing	Machine assembly	4	8.3

4. DESCRIPTION OF THE MACHINE

4.1 DESCRIPTION OF THE MACHINE AND ITS COMPONENTS

The NEW 350 cutting-off machine with circular blade for ferrous metals produced by MACC is made from a solid casting, carefully processed and provided with holes for fastening to a bench or pedestal. The upper surface, designed to allow the complete draining away of the cutting fluid, has been processed using precision machinery to allow the attachment of a sturdy vice with burr-proof jaws.

The bar-stop device allows the length required to be preset and a constant level of performance for repeated cuts.

The blade-holding head is firmly attached to a reduction unit in oil bath built onto the motor and to the base by means of a joint which provides 45° rotation both to the left and right and the cutting movement with manual feed.

The coolant pump is also securely attached to the motor block.

The main switch is located above the motor block. Another switch is used to select motor rotation speed and therefore cutting speed.

The control lever, fitted with an ergonomic hand-grip and blade activation button with safety release action, reduces fatigue during operation to a minimum.

The blade is protected by a guard which in its turn protects the operator from ejected shavings and coolant.

The machine is supplied with a set of service spanners.

4.2 INTENDED AND UNSUITABLE USES OF THE MACHINE

The NEW 350 cutting-off machine with circular blade has been designed and built to cut bars, structural steel and ferrous metal pipes in accordance with the instructions contained in this manual.

Therefore, the cutting of other materials is not permitted: if the above recommendations are not observed, the machine could be damaged and the health and safety of the operator put at risk.

Cutting is not permitted, if the bar has not been first locked in the vice.

5. MAIN TECHNICAL DATA

Under no circumstances should the following data be altered, this is in order to protect the correct functioning of the machine and to avoid creating safety risks for the operator.

MOTOR	three-phase
Motor Power	KW 2,5/3,3 - KW 1,8/2,4
Motor revolutions (two speeds)	1400-2800 rpm 700-1400 rpm
CIRCULAR BLADE (SAW)	Number of teeth and feed holes according to table
Maximum diameter and thickness	Diameter: 350 mm Thickness: 3
BLADE REVOLUTIONS per minute	40-80 rpm 20-40 rpm
CUTTING ANGLE	90° right - 45° left
PIECE LOCKING VICE: MAX OPENING	190 mm
COOLANT TANK CAPACITY	litres 3
MACHINE WEIGHT	210 kg - 2060 N

6. HANDLING AND TRANSPORTATION

For safe handling and transportation use a lift truck for movement indoors or a bridge crane; in this case, also using cables fastened to the sling positions indicated on the drawing 1 Encl. 1. Keep the machine in its normal position and avoid turning it upside down. If the machine is fastened to the pedestal, stability will be greatly reduced and therefore all the necessary measures should be taken to stop the machine from tipping over.

All handling and transportation operations should be carried out by trained staff.

7. MACHINE INSTALLATION

A. MACHINE CHECK AND CONTROL LEVER ASSEMBLY

The machine should be checked to make sure that it has not been damaged during transportation and handling.

Control lever assembly (draw.5-6 Encl.3) : Fit the supplied head lever 25, into position 24 and fasten it by means of the nut 50. To fit the handle, connect the electric cable terminals 220 to the microswitch 218 and place it in the left second half of the handle as shown in draw. 4 Encl.2. Complete the assembly using the screws 221 and then 219. Make sure that the cable is inserted into the lever slot 25, after having checked that there are no burrs or sharp edges in the slot.

B. FASTENING OF THE MACHINE

The machine will be able to operate in keeping with the technical parameters supplied by MACC if it is positioned correctly and fastened securely to the bench or the factory floor so that vibrations are minimal during operation . Consult drawing 2 NEW 350 Installation plan Encl.1.

C. ASSEMBLY OF CIRCULAR BLADE

For the assembly of the circular blade, remove the screw No. 36 (Draw. 5-6 Encl. 3), keeping the motor-blade block raised and rotate the mobile guard 31 backwards. Unscrew the screw 28 clockwise, withdraw the flange 29, insert the circular blade, making sure that the toothing faces the same direction as the arrow on the mobile guard. Then refit flange 29 and screw 28.

D. ELECTRICAL CONNECTION TO THE MAINS

Install a differential thermomagnetic switch with characteristics suited to the mains.

Make sure that the power supply voltage corresponds to the voltage on the motor plate. Connect the cable to the power supply line observing the colour codes of the individual wires, pay particular attention to the earth wire. Connect the machine, make sure that the rotation of the circular blade is in the direction shown by the arrow on the guard.

E. CUTTING COOLANT

For the cooling of the circular blade, fill the tank with emulsible oil obtained from a mixture of water and AGIP AQUAMET 700 EP oil with a percentage of 5-7%

8. MACHINE START UP AND OPERATION

8.1 DEVICES AND THEIR LOCATION

(The location of the devices described is shown on the NEW 350 installation plan Draw.2, Encl.1)

Code 203	CHANGEVER SWITCH
Code 218	START-STOP MICROSWITCH: situated inside the handle located at the end of the control lever and has safety release action.
Code 208	EMERGENCY BUTTON
Code 97	CUTTING ANGLE DEVICE: to check that cutting inclination is as required
Code 21	LOCKING VICE
Code 77	BAR-STOP
Code 25	CONTROL LEVER WITH HANDLE

8.2 TOOLS SUPPLIED

1	Allen wrench size 3
1	Allen wrench size 4
1	Allen wrench size 5
1	Allen wrench size 6
1	Allen wrench size 14

8.3 OPERATION

CHECKS TO CARRY OUT BEFORE EACH CUT

- A. Make sure that the circular blade is fastened securely by means of screw 28 (DRAW 5-6 ENCL 3)
- B. Check that the hand indicates the required cutting angle (vice scale)
- C. Make sure that the head and vice are locked by means of the lever 88 (DRAW 7-8 ENCL 3)
- D. With the motor off, lower the head and check that at the end of the stroke, the circular blade does not touch the counter-vice 75. If the circular blade does touch, adjust the screw 109 located at the centre of the head support 4 (DRAW 5-6 ENCL 3)
- E. Make sure that the piece to be cut is adequately secured in the vice.
- F. Make sure that the coolant is circulating in the machine.

CUTTING OPERATION

- A. Before each cutting operation, if the cutting inclination is not as required, correct or change the inclination by placing the bench lever 88 in position A (DRAW 7-8 ENCL 3) and after correction, forcefully turn it to position B.
- B. Clamp the piece to be cut by means of the handwheel 11 (DRAW 7-8 ENCL 3), turn the main switch 212 and the speed switch 203 to the position required (we recommend No.1), take hold of the handle 26 located at the end of the head lever and press button 218. The blade will now start turning.
- C. Position the blade carefully on the piece to be cut. Then increase the pressure in order to accelerate the cutting operation without using excessive force. To make a series of cuts, position the bar-stop 77 at the size required. Fix it into position by using the knob 79 (DRAW 9 ENCL 4).
- D. To replace the circular blade carry out the same operations used to assemble the circular blade. (chapter 7c).
- E. For the choice of most suitable blade consult the table ENCL. 1.

We strongly discourage the use of blades with ruined or insufficiently sharp cutting edges

8.4 SPECIAL SAFETY CHECKS

- A. Before using the machine, check carefully that the safety devices are in good working order, that the mobile parts are not blocked, that no parts are damaged and that all the components are installed correctly and are functioning properly.
- B. Make sure, before operating the machine, that the screws of the guards and other protective devices are adequately secured, especially the screws on the circular blade guard and the rotation levers of the circular blade mobile guard.
- C. Check that the safety microswitches and the emergency button are functioning correctly. Test them during a loadless machine cycle.
- D. Make sure that the mobile guard does not leave uncovered an angle of more than 5° in order to prevent fingers from entering.
- E. Pay attention to environmental conditions. Do not expose the machine to rain; to not use it in damp environments, position the machine on a clean dry floor that has no oil or grease stains.
- F. Before using the machine, the operator should make sure that all tools and service spanners used for maintenance or adjustment have been removed.

8.5 GENERAL SAFETY RULES

- A. Wear appropriate clothing. The operator's clothing should not be loose or dangling nor should it have parts which could easily get caught. Sleeves should contain elastic.
Belts, rings or chains should not be worn. Long hair should be kept in a net.
- B. Avoid unstable operating positions. Find a safe and evenly balanced position to operate the machine.
- C. Keep the work area tidy, untidiness increases the risk of accidents.
- D. Do not use the power supply cable to disconnect the plug from the socket. Protect the cable from high temperatures, oil or sharp edges. For outdoor use, only use extension cables which are in line with current regulations.

8.6 MEASURES TO PREVENT RESIDUAL RISKS

- A. The removal of guards and tampering with the safety devices is strictly forbidden.
- B. Gloves should always be worn.
- C. Standard work clothing should be used and kept closed and should not have flapping parts.
- D. The machine should not be cleaned with liquids under pressure.
- E. In the event of fire, extinguishers should not be used unless they are the powder type. The electric power supply to the machine should always be disconnected in these circumstances.
- F. Do not insert foreign bodies into the motor cover and to not supply the machine with voltage by tampering with the safety microswitches or main switch.
- G. Take the necessary precautions to avoid the machine being started by other people during loading, adjustment, piece changing or cleaning.

Safety, Guidance, Notice labels on the machine



9. MAINTENANCE AND REPAIRS

9.1 GENERAL SAFETY MEASURES

- A. Lockable main switch. Open the padlock in the event of machine failure or replacement of the circular blade. The padlock key should be entrusted to a responsible person.
- B. Before carrying out any work on electrical equipment, remove the power supply plug from the control panel (disconnect voltage).
- C. Only use cables to supply power, which have a cross-section suited to the power of the machine.
- D. Opening key. The keys of the machine should be kept by authorized personnel. Do not leave the keys for doors which provide access to the hydraulic or electrical parts or keys to lockable switches in easy of reach of unauthorized personnel.
- E. Repairs should only be carried out by authorized personnel. Only spare parts made by the original manufacturer should be used, otherwise these could cause damage or injury.

9.2 ROUTINE CHECKS AND MAINTENANCE

FREQUENCY (working hours)	OPERATION
1000 hours	Replace the oil in the gear box with AGIP ACER 320 oil (0.2 litres) or equivalent.
1000	Lubrication of mobile parts in the piece locking vice (GREASE AGIP MU 2)
50	Cleaning of the coolant tank and filter check
if necessary	Check functioning of bench lever

9.3 DESCRIPTION OF ROUTINE MAINTENANCE

A. Replacement of gear box oil

Remove caps 95 and 22 (draw.5-6 Encl.3), let all the used oil flow out into a container which should have a label indicating the contents for the purposes of disposal. Replace cap 22. Feed 0.2 litres of oil (as specified above) into the oil feed hole located on the upper part of the gear box and then replace cap 95.

B. Lubrication of mobile parts of piece locking vice

Remove the vice 21 completely by turning hand wheel 11 (draw.7-8 Encl.3). Clean and grease the parts worked by the counter-vice 75, the vice 21 and the vice gib 101. Put a drop of oil in the oil feed hole 19 located behind the handwheel.

C. Cleaning of the coolant tank: Filter check.

Empty the coolant from the tank by means of the tap located on the rear part of the machine bench (after moving the liquid feed pipe away from this). Collect the coolant in a container for future disposal.

Remove screws 118 and the drilled plate 87 (draw.7-8 Encl.3). Clean out the shavings and the metallic powder, taking care not to scatter this over the machine especially around the motor and the box containing the electrical equipment. Refit the plate 87 and fasten it with screws 118, turn the tap off and reconnect the pipe. Check filter 55 and if necessary replace it. Fill the tank with the amount and liquid stated previously.

D Checking of bench lever functioning

Check regularly that the rotation release - locking lever is working properly. In the event of the lever not locking correctly, loosen grub screw 91 (draw.7-8 Encl.3), tighten nut 90 and fasten grub screw 91 again. Make sure that with the bench lever in position A, arm 4 which supports the blade-motor block can rotate freely.

10. INFORMATION REGARDING ENVIRONMENTAL NOISE

An environmental noise test carried out on the NEW 350 cutting-off machine with circular blade, identical to the machine to which these operation instructions refer, has given the following results:

ACOUSTIC RADIATION PRESSURE

- $L_{Aeq} = 82,6$ dB (A)
- $L_{peak} = 90,6$ dB (the maximum acceptable value is 140 dB)
- The level of background noise has no influence = 48.5-54,2 dB (A).

11. LAYING OFF AND DISMANTLING

11.1 LAYING OFF

If the machine is to be laid off or left idle for a long period, the following operations must be carried out:

- Disconnect the machine from the electricity mains.
- Empty oil from the gear box and cooling liquid from its tank
- Clean carefully the machine by getting rid of all traces of grease, especially on the worked parts that must be protected with anti-oxidants.
- Cover the machine with a sheet, preferably not plastic as it can cause rust due to the humidity condensation.
- Store the machine in a closed, dust-free place.

11.2 DISMANTLING

If the machine must be definitively dismantled, its components must be sub-divided for the purpose of a possible recycle of the materials and for the environment safety. The following table is given for your guidance:

Steel	Electrical Components	Light alloy	Cast iron	Bronze Copper	Plastic and rubber	Various
Flanges and pins	Motors winding	Gear boxes	Structural parts	Bushings	Seals	
Rollers	Push button and Control system (relais-transformer)				Electrical box	
Spring						





12. LIST OF SPARE PARTS

POS.	DESCRIPTION	CODE
1	Pedestal	004/71
2	Bench	001/06
3	O-Ring 134	068/04
4	Rotating arm	005/07
5	Roller arm pin	048/04
6	Snap ring D.25 DIN 471	
7	Nut M10 DIN 934	
8	Screw HH M10x55 DIN 931	
9	Roller arm	047/04
10	Roller	049/04
11	Vice handwheel	029/03
12	Hexagon socket grub with cone point M10X10 DIN 914	
13	Vice spring	021/31
14	Hexagon socket grub with cone point M8X10 DIN 914	
15	Vice bearing flange	020/31
16	Cage AxK 30 47	060/31
17	Fifth wheel AS 30 47	061/31
18	Stop bush	025/03
19	Oiler D.6	
20	Vice lever	007/31
21	Vice	008/03
22	Oil dram plug 3/8"	
23	Oil lever plug 3/8"	
24	Head	003/07
25	Head lever	024-A/07
26	Head lever handle	046/05
27	Disk	
28	Disk nut	030/06
29	Disk flange	020/07
30	Snap ring D.45 E	
31	Disk movable guard	012/07
32	HSHC screw M6x14 DIN 912	
33	Divider	026/07
34	Water pipe	
35	Disk guard	011/07
36	HSHC screw M6x16 DIN 912	
37	Movable blade cover rod	016/04
38	HSHC screw M8x20 DIN 912	
39	Fixed blade cover rod	016/06
40	Dowel M10x45 DIN 914	
41	Front motor flange	
42	Motor casing	
43	Key 5x5x35 DIN 6604	
44	Bearing 6205 2Z	020/19
45	Spring ring D.18 DIN6799	
46	Bearing 629	043/05
47	Snap ring D.9 E DIN 471	
48	Pump carrier	003/05
49	HSHC screw M4x12 DIN 912	
50	Hexagon lock nut M20 DIN 936	
51	Washer x M6 DIN 125/A	
52	HSHC screw M6x20 DIN 912	
53	AC Pump	041/05
54	Water pipe	
55	Filter FB 1	045/05
56	Fan guard	
57	Fan	
58	Rotor	
59	Stator	
60	HSFHC Screw M8X30 DIN 7991	
61	Wascher	
62	HSFHC Screw M6X20 DIN 7991	
63	Oil retainer 30-47-7	067/04

64	Bearing 3205	065/04
65	Snap ring D.52 I DIN 472	
66	Worm screw spacer	018/07
67	Worm screw	020/04
68	Self-locking ring-nut M20x1	
69	Bearing 6302	044/03
70	Helical gear	015/07
71	Self-locking ring-nut M35x1,5	
72	HSFHC screw M10x16 DIN 7991	
73	Washer	067/31
74	Countervice right jaw	016/19
75	Countervice	003/19
76	Nut M16 DIN 936	
77	Bar stop	004/05
78	Bar stopping rod	031/05
79	Handwheel D.40 M8x25	077/25
80	Water pipe	
81		
82		
83	Bench tap	042/05
84		
85		
86		
87	Crucible	021/21
88	Bench lever	002/06
89	Belleville washer 50x25,4x2 DIN2093	
90	Selflocking ring nut 32x1.5	
91	Dowel M8x10 DIN 916	
92	Key 6x6x40 DIN 6604	
93	Disk shaft	019/07
94	Oil retainer 50/65x8	
95	Oil filling cap 3/8"	
96	Left vice jaw	032/03
97	Cutting angle device	
98	Left countervice jaw	015/19
99	Dowel M8x25 DIN 914	
100	Nut M8 DIN 934	
101	Vice gib	031/03
102	Fast clamping vice screw	033/03
103	Support plate of low voltage control	048/21
104		
105		
106		
107		
108	Nut M12 DIN 936	
109	HH screw M12x30 DIN 933	
110	Dowel M8x10 DIN 914	
111	Head gear	024/19
112		
113		
114	Countervice pin	022/07
115	Rotating plate	007/19
116	Head pin	057/07
117	Oiler D.6	
118	HSCH screw M6x60 DIN 912	
119	HSCH screw M8x20 DIN 912	
120	Washer	
121	HSHC screw M10x20 DIN 912	
122	Rear motor flange	
123	Washer	
124	Couter-vice fastening bracket	031/19
125	Release lever M8x20	025/21
126	Sphere D. 30 FM 10	082/14
127	Positioning pin	022/21
128	Nut M10 DIN 936	
129		
130	HH screw M12x80 DIN 933	

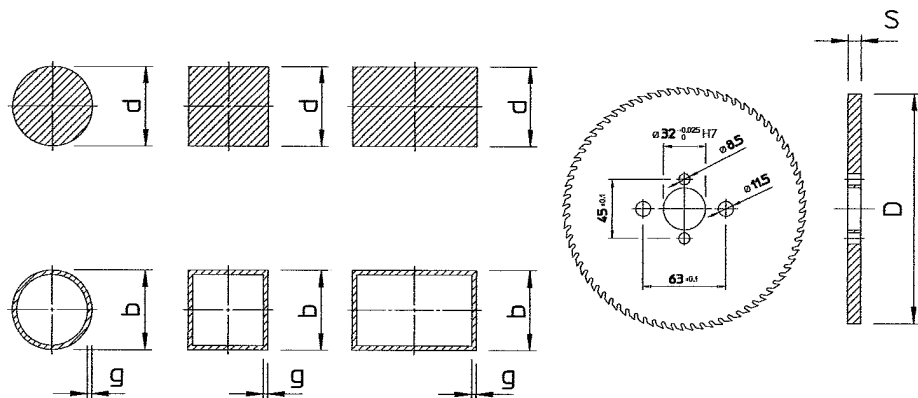
131		
132	Washer D.6 DIN 125/A	
133	Stake D.9x18	
134	Hexagon nut medium M10 DIN934	043/31
135	Eye tie rod M10x50	
136	Hexagon nut medium M12 DIN934	035/38
137	Eye tie rod M12x50	030/07
138	Return spring	
139	HH screw M10x25 DIN 931	
140	Washer D.10 DIN 125/A	
141	Fixed antifraze bracket	039/03
142	HSHC screw M8x20 DIN 912	
143	Movable antifraze bracket	028/05
144	Washer D.8 DIN 125/A	
145	HSFHC Screw M6X16 DIN 7991	
		066/90
200	Box	067/90
199	Cover box	069/90
201	Plate	
202		
		011/90
203	Changeover switch	
204	RH screw M4x14 7981	
205	HSHC screw M4x6 DIN 912	
206		
207		085/90
208	Emergency button	
209		032/90
210	Remote controlled switch	053/90
211	Thermal relay	
212		
213	Earth connection bar	
214	RH screw M4x14 DIN 7981	
215		
216		042/90
217	Transformer 20 VA	028/90
218	Micro switch of handle	
219	HSFHC screw M4x8 DIN 7991	
220	Electrical cable 2x1	
221	RH screw M2,9x13 DIN 7981	
222	Button	

CAPACITA' DI TAGLIO - CUTTING CAPACITY - NEW 350

CAPACITA' DI TAGLIO - CUTTING CAPACITY - CAPACITE DE COUPE SCHNITTKAPAZITAET - CAPACIDAD DE CORTE				
90°	60	110	100 x 100	155 x 80
45°	55	90	85 x 85	90 x 85

SCELTA DEL DISCO - BLADE SELECTION

Diametro - Diameter Diametre - Durchmesser	200	225	250	275	300	315	350
Spessore - Thickness Epaisseur - Dicke	1.8	1.8	2	2.5	2.5	2.5	3
b=10-80 g<2	t	3	3	3	3	3	3
	z	200	230	250	280	300	320
b=10-80 g=2-4 d=10-18	t	5	5	5	5	5	5
	z	130	140	160	170	190	200
b=20-80 g=4-10 d=18-30	t	8	8	8	8	8	8
	z	80	90	100	110	120	120
d=30-40	t	10	10	10	10	10	10
	z	60	70	80	90	90	100
d>40	t	/	/	/	12	12	12
	z	/	/	/	70	80	80



Si garantisce il funzionamento ottimale della vite-corona utilizzando dischi con fori di trascinamento.

Best performance of worm screw worm wheel gearing is guaranteed when circular saw blades with drawing-holes are used.

Nous garantissons le bon fonctionnement de la vis et couronne seulement si l'on emploie des fraise-scies avec trous d'entraînement.

Die verwendung von Sägeblättern mit Mitnehmerlochern sichern den guten Betrieb der Schnecke und des Scheckenkranzes.

b= diametro esterno/altezza (tubi) - outside diameter/height (pipe)
diamètre extérieur/hauteur

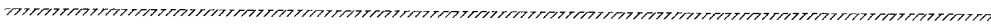
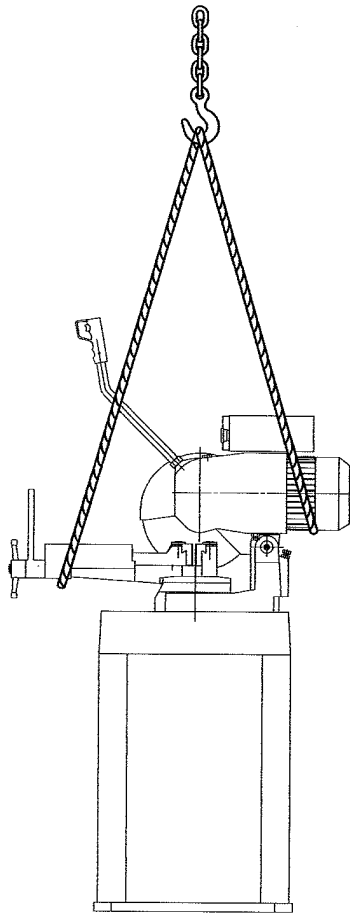
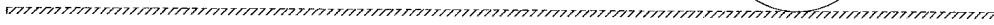
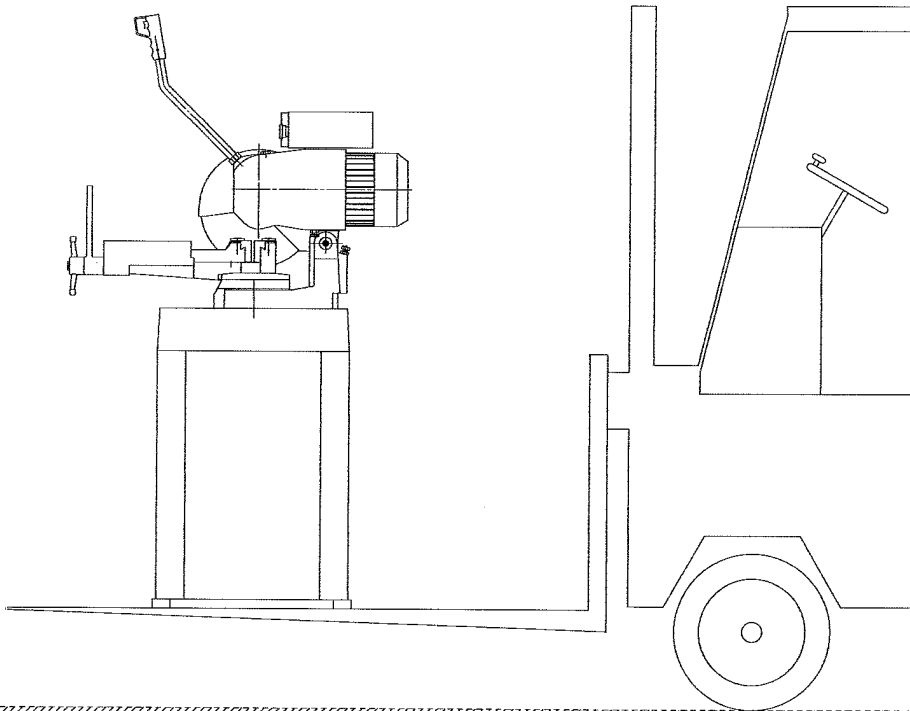
d= diametro/altezza (pieni) - diameter/height (solid)
diamètre/hauteur (plein) - durchmesser/hohe (voll)

g= spessore del tubo - pipe thickness
epaisseur du tube - rohrdicke

t= passo dentatura - tooth pitch
pas denture - entfernung verzahnung

z= numero di denti - number of teeth
numero de dents - zahnnummer

MOVIMENTAZIONE TRASPORTO
HANDLING AND TRANSPORTATION



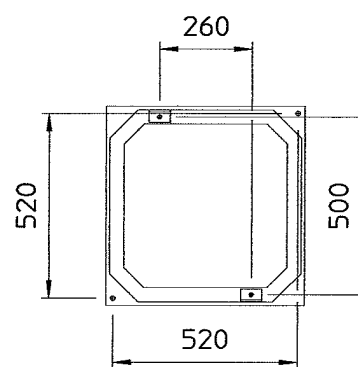
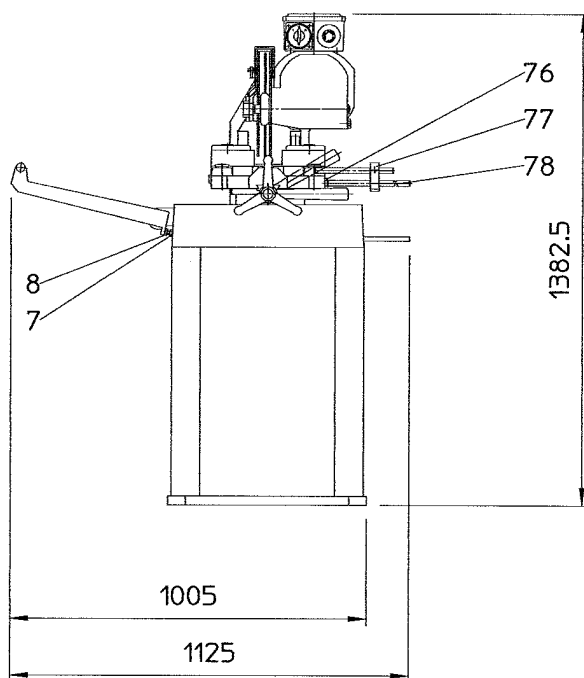
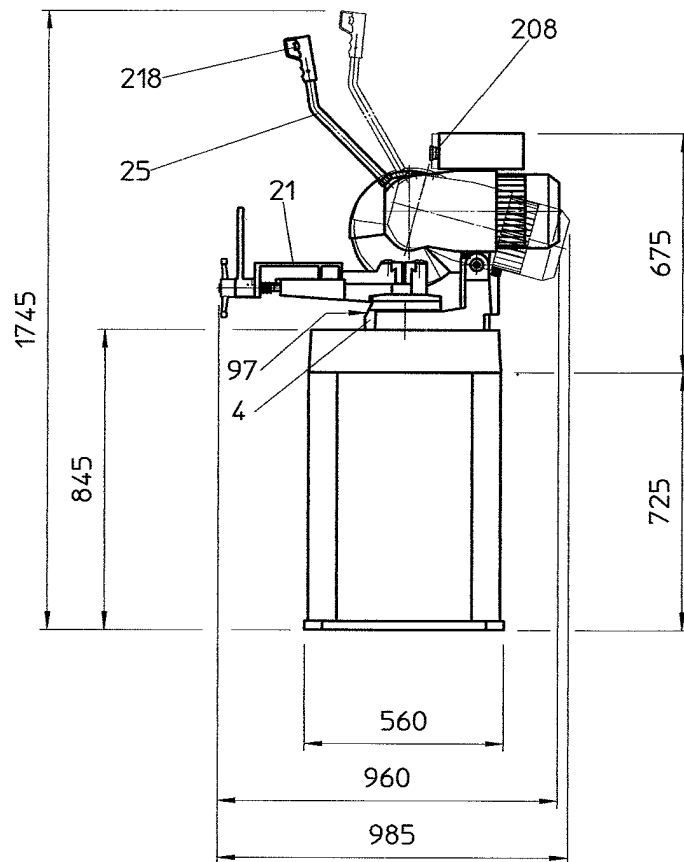
DIMENSIONE D'INGOMBRO E INSTALLAZIONE

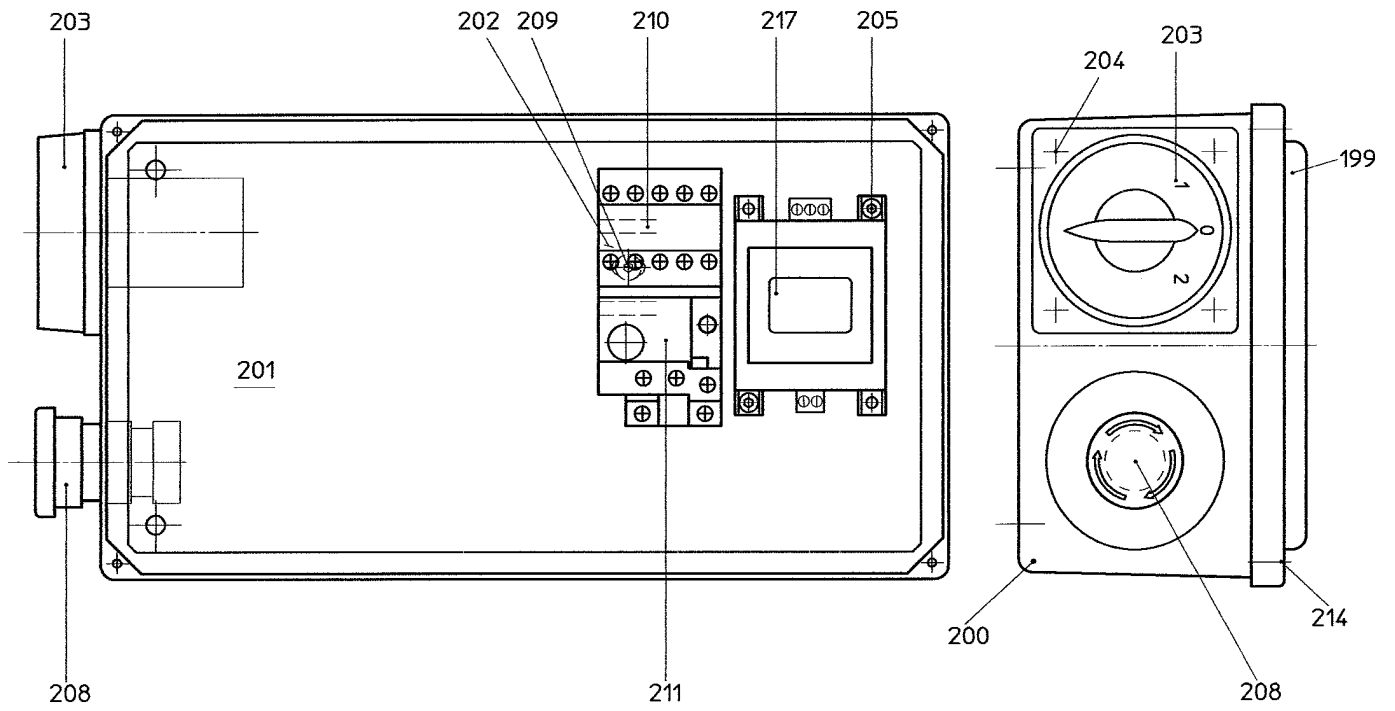
Overall dimensions and installation

Dimensions hors-tout et installation

Aussenabmessungen und installation

Dimensiones maximas extremas e instalacion





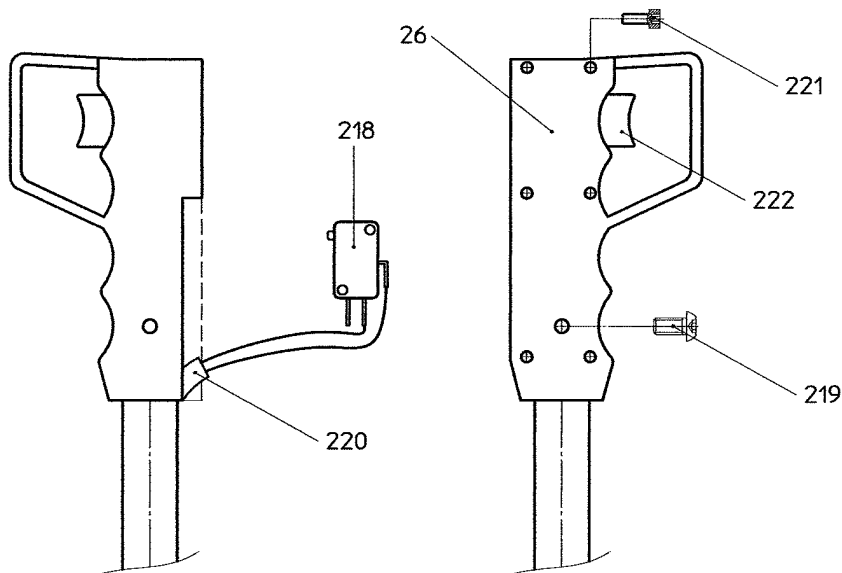
Cassetta Impianto elettrico

Electric Box

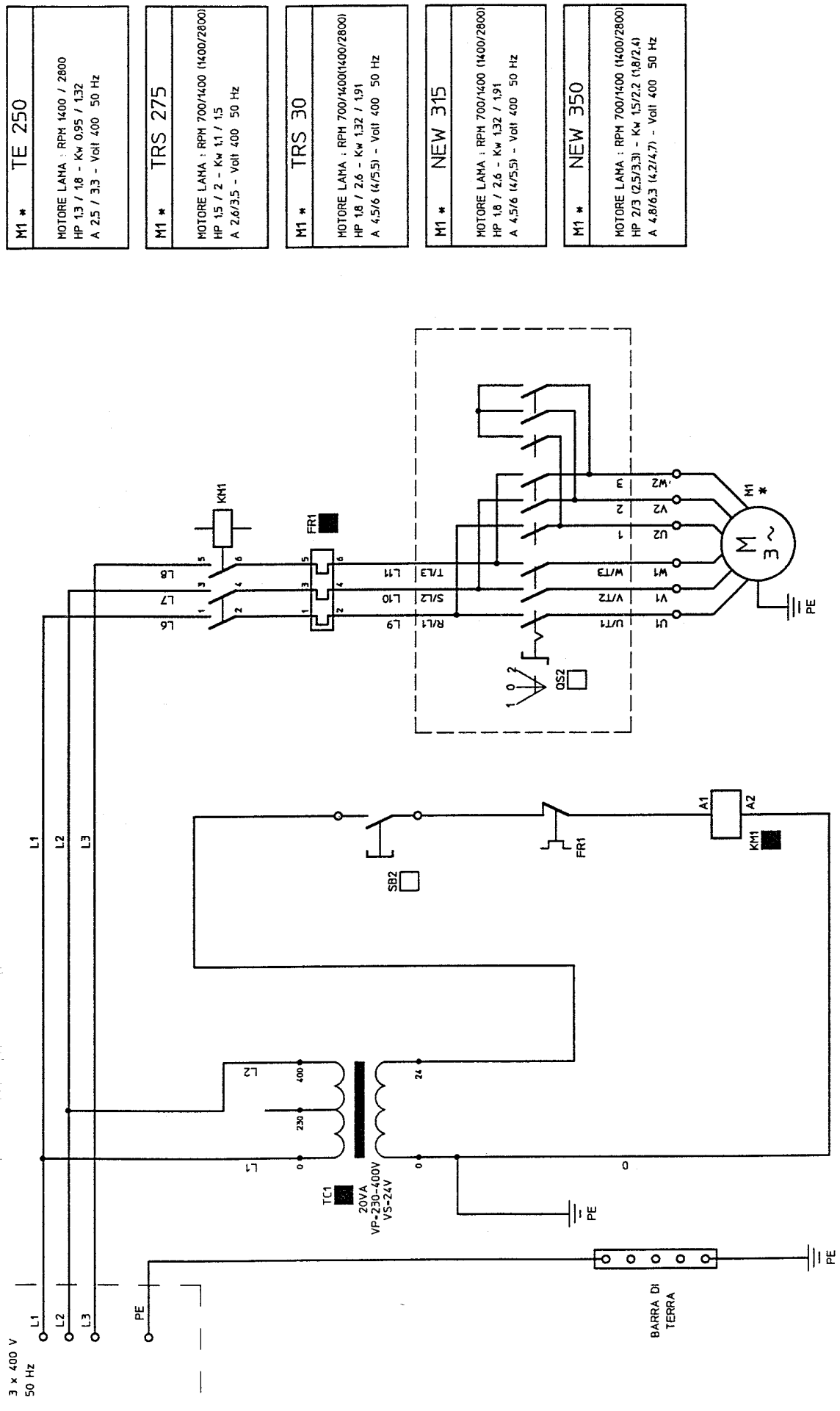
Boîte Electrique

Schaltkasten

Caja Eléctrica



0 1 2 3 4 5 6 7 8 9



M1 *	TE 250
MOTORE LAMA : RPM 1400 / 2800 HP 1.3 / 1.8 - Kw 0.95 / 1.32 A 2.5 / 3.3 - Volt 400 50 Hz	

M1 *	TRS 275
MOTORE LAMA : RPM 700/1400 (1400/2800) HP 1.5 / 2 - Kw 1.1 / 1.5 A 2.6/3.5 - Volt 400 50 Hz	

M1 *	TRS 30
MOTORE LAMA : RPM 700/1400(1400/2800) HP 1.8 / 2.6 - Kw 1.32 / 1.91 A 4.5/6 (4/5.5) - Volt 400 50 Hz	

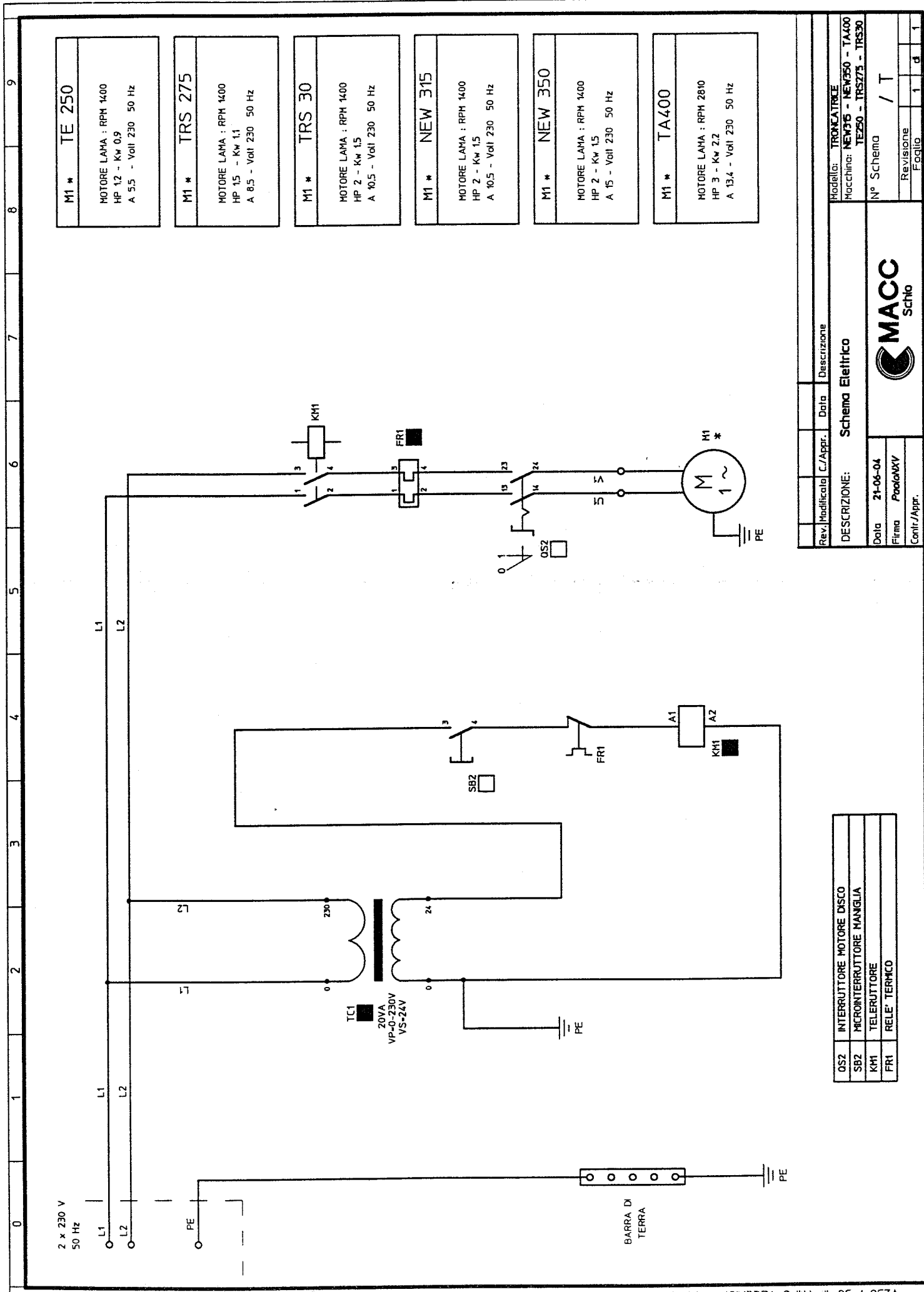
M1 *	NEW 315
MOTORE LAMA : RPM 700/1400 (1400/2800) HP 1.8 / 2.6 - Kw 1.32 / 1.91 A 4.5/6 (4/5.5) - Volt 400 50 Hz	

M1 *	NEW 350
MOTORE LAMA : RPM 700/1400 (1400/2800) HP 2/3 (2.5/3.3) - Kw 1.5/2.2 (1.8/2.4) A 4.8/6.3 (4.2/4.7) - Volt 400 50 Hz	

OS2	COMMITATORE MOTORE DISCO
SB2	MICROINTERRUTTORE MANGLIA
KM1	TELETRUTTORE
FR1	RELE' TERMICO

Rev./Modificata	C./Appr.	Data	Descrizione
			Schema Elettrico
Modello: TRONATRICE			
Macchina: NEW 315 - NEW 350			
TE 250 - TRS 275 - TRS 30			
N° Schema			/ T
Firma			Revisione
Data 21-06-04			
PopoloMXY			





M1 * TE 250
 MOTORE LAMA : RPM 1400
 HP 1,2 - Kw 0,9
 A 5,5 - Volti 230 50 Hz

M1 * TRS 275
 MOTORE LAMA : RPM 1400
 HP 1,5 - Kw 1,1
 A 8,5 - Volti 230 50 Hz

M1 * TRS 30
 MOTORE LAMA : RPM 1400
 HP 2 - Kw 1,5
 A 10,5 - Volti 230 50 Hz

M1 * NEW 315
 MOTORE LAMA : RPM 1400
 HP 2 - Kw 1,5
 A 10,5 - Volti 230 50 Hz

M1 * NEW 350
 MOTORE LAMA : RPM 1400
 HP 2 - Kw 1,5
 A 15 - Volti 230 50 Hz

M1 * TA400
 MOTORE LAMA : RPM 2810
 HP 3 - Kw 2,2
 A 13,4 - Volti 230 50 Hz

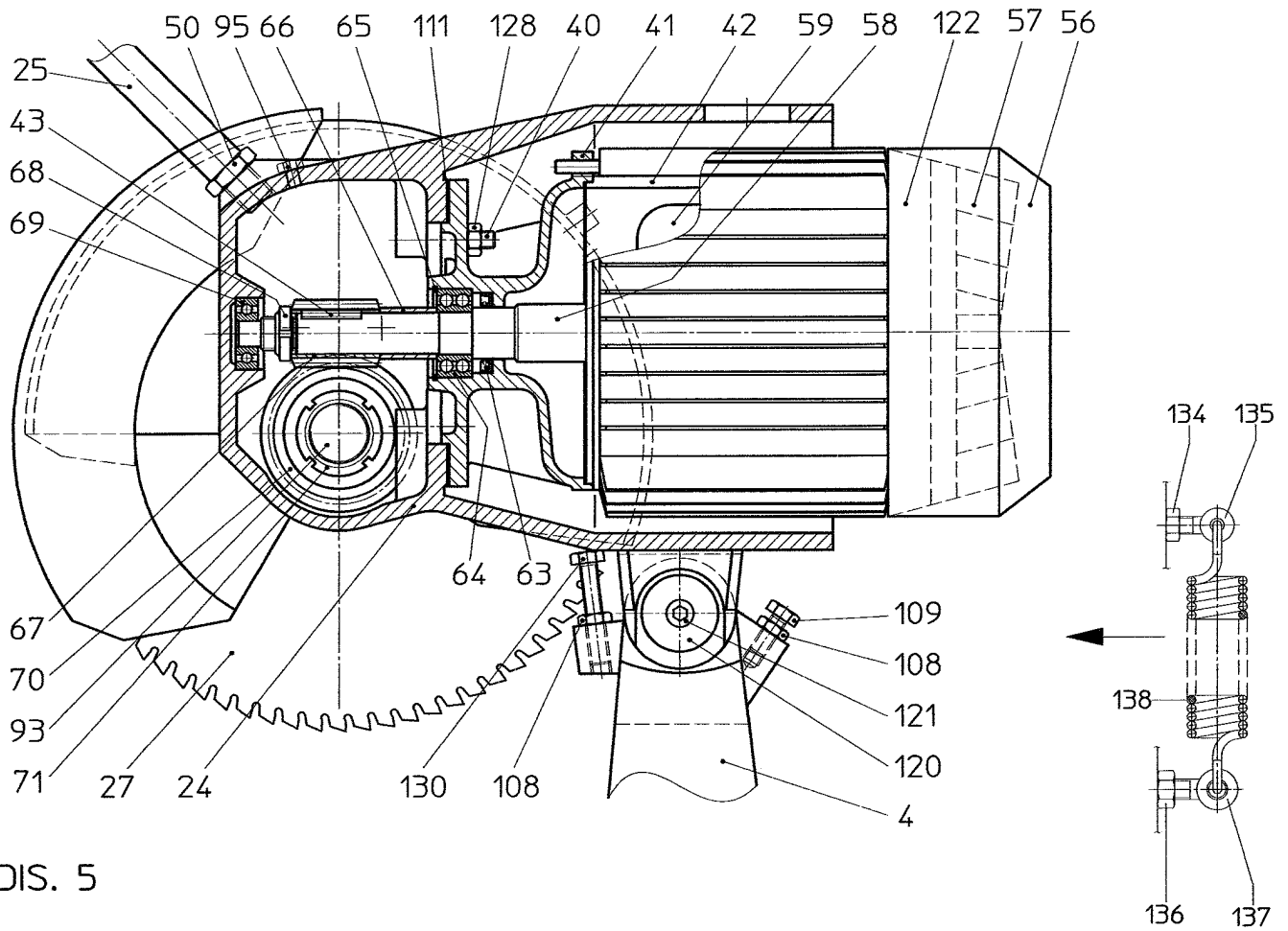
Rev. / Modificata / C. / Appr.	Data	Descrizione
		Schema Elettrico
Modello: TRONCATRICE		
Macchina: NEW315 - NEW350 - TA400		
TE250 - TRS275 - TRS30		
N° Schema / T		
Revisione	1	d
Foglio	1	1

OS2	INTERRUTTORE MOTORE DISCO
SB2	MICROINTERRUTTORE MANGIA
KM1	TELERUTTORE
FR1	RELE' TERMICO

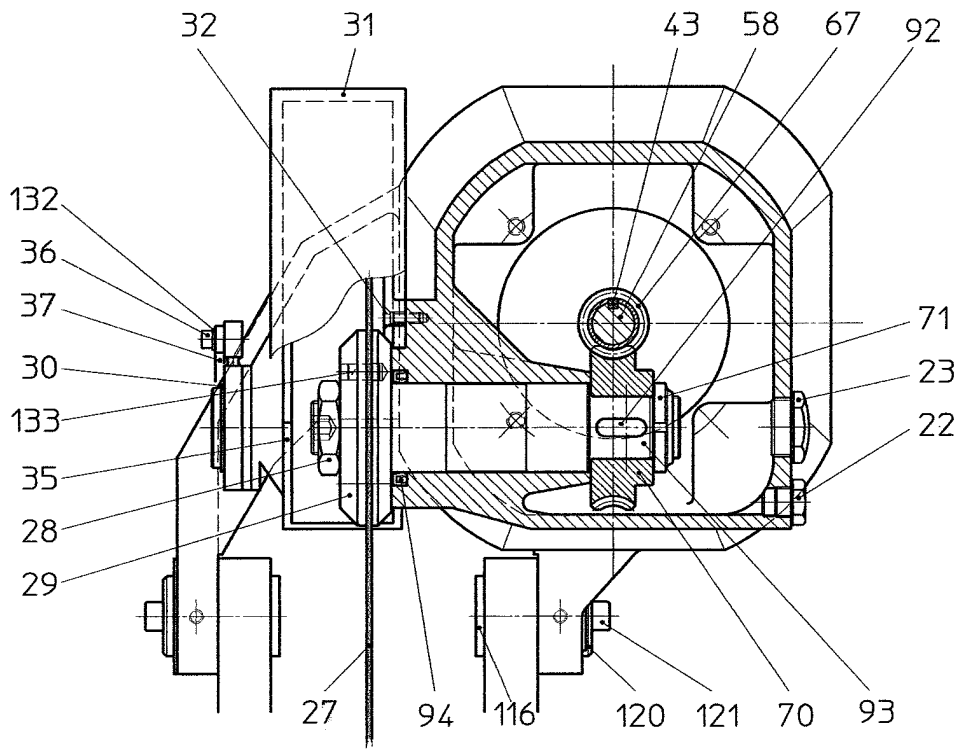


2 x 230 V
 50 Hz

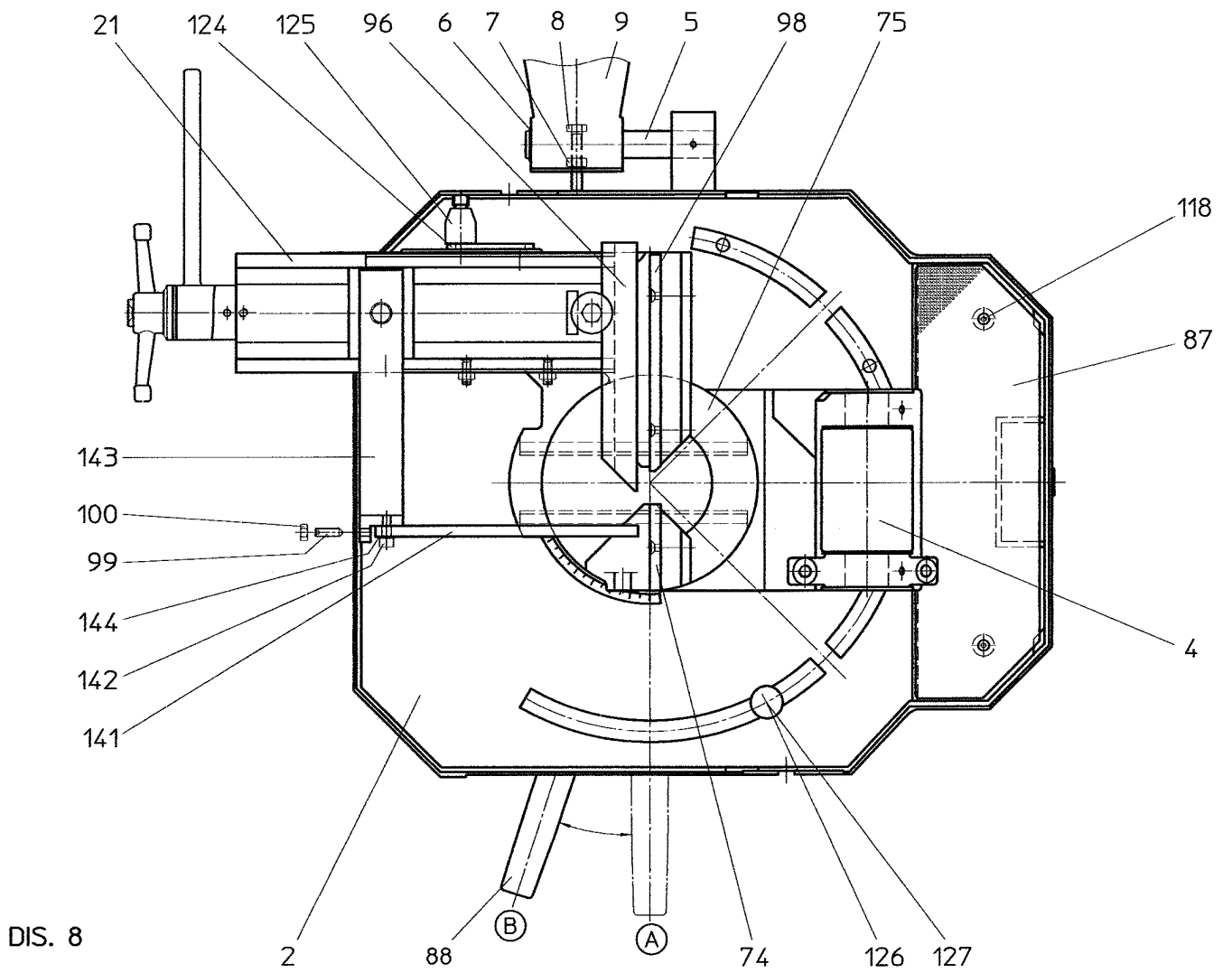
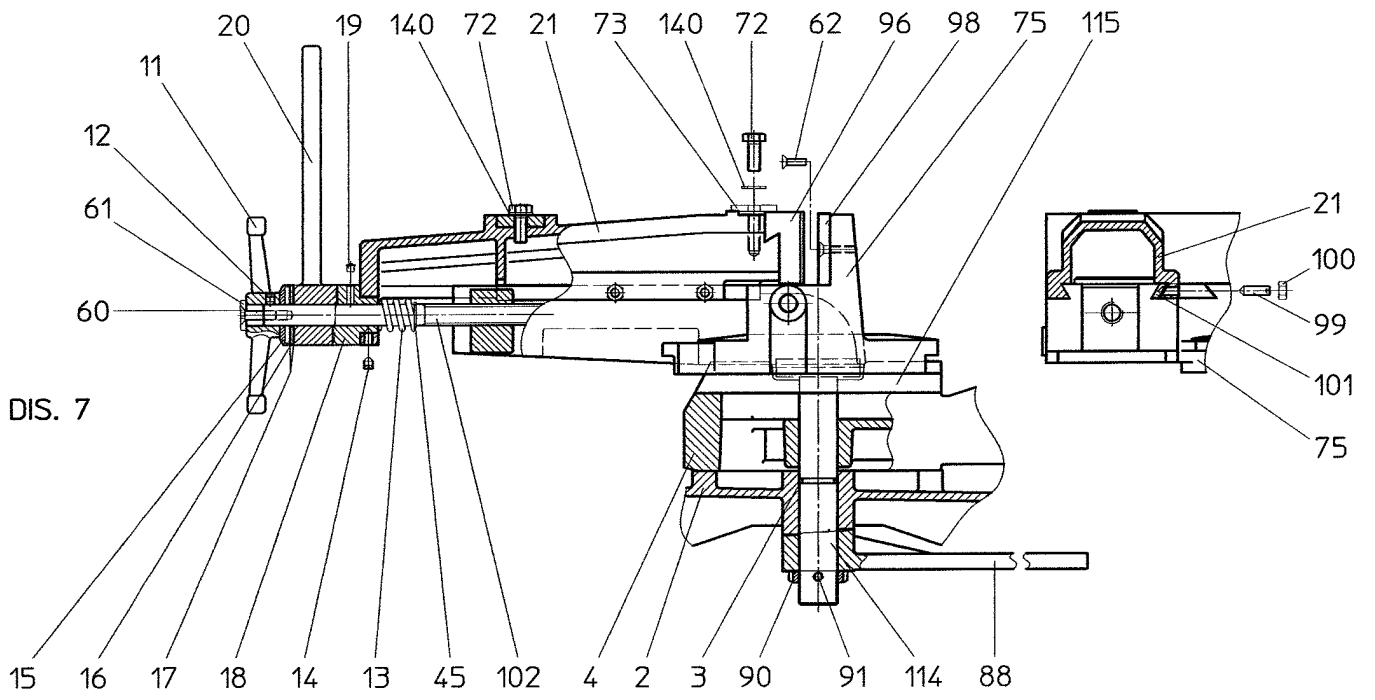
BARRA DI
 TERRA

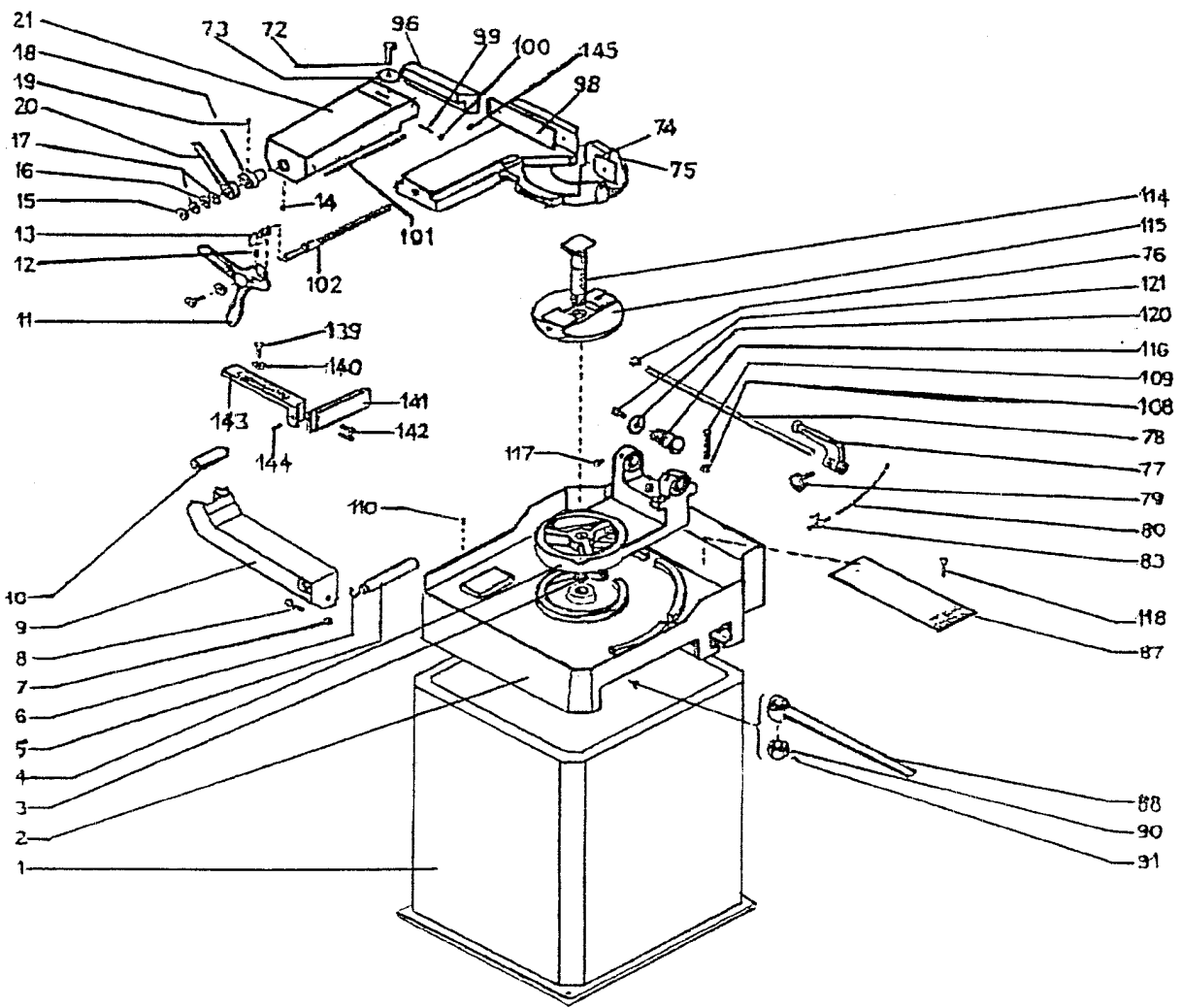
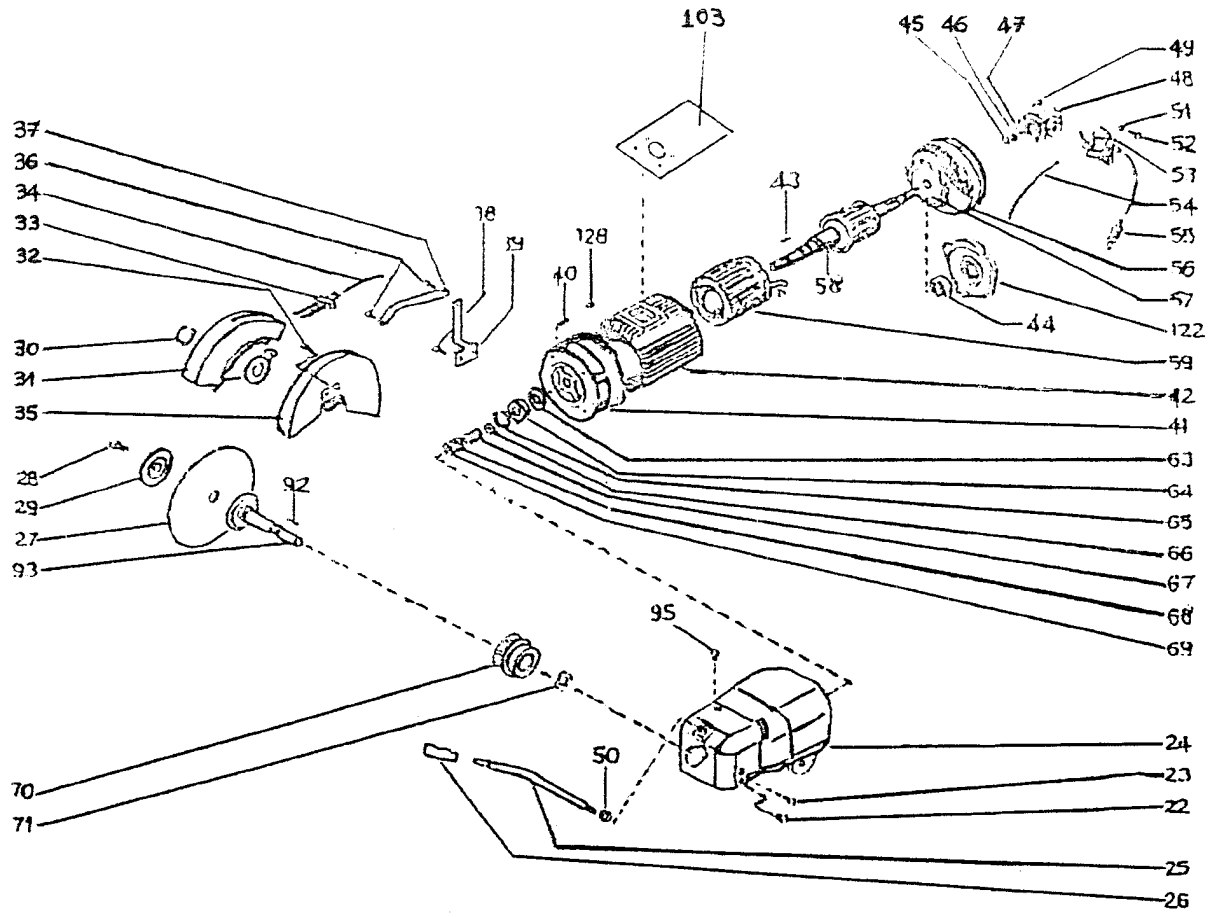


DIS. 5



DIS. 6





Dis. / Draw. 9