

METALMASTER

OPERATION MANUAL



HYDRAULIC NC GUILLOTINE

E21S CONTROLLER

Model
HG-2504C

Order Code S9335

Edition No : 001

Date of Issue : 03/2023

www.machineryhouse.com.au

MACHINE DETAILS

MACHINE	<input type="text" value="HYDRAULIC NC GUILLOTINE"/>
MODEL NO.	<input type="text"/>
SERIAL NO.	<input type="text"/>
DATE OF MANF.	<input type="text"/>

DISTRIBUTED BY

www.machineryhouse.com.auwww.machineryhouse.co.nz**Note:**

This manual is only for your reference. Owing to the continuous improvement of the Metalmaster machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before using this electric machine.

**NOTE:**

In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)

An example of a product specification plate. It features the Metalmaster logo at the top, followed by the text "PRODUCT SPECIFICATION". Below this, there are several rows of labels and input fields: "MODEL:", "CAPACITY:", "SER. NO:", "MFG DATE:", "WEIGHT:", "VOLTS:", and "MOTOR Kw:". At the bottom, it includes the website "www.machineryhouse.com.au" and "Made in China".

METALMASTER	
PRODUCT SPECIFICATION	
MODEL:	<input type="text"/>
CAPACITY:	<input type="text"/>
SER. NO:	<input type="text"/>
MFG DATE:	<input type="text"/>
WEIGHT:	<input type="text"/>
VOLTS:	<input type="text"/>
MOTOR Kw:	<input type="text"/>
www.machineryhouse.com.au	
Made in China	

Fig.1

C O N T E N T S:

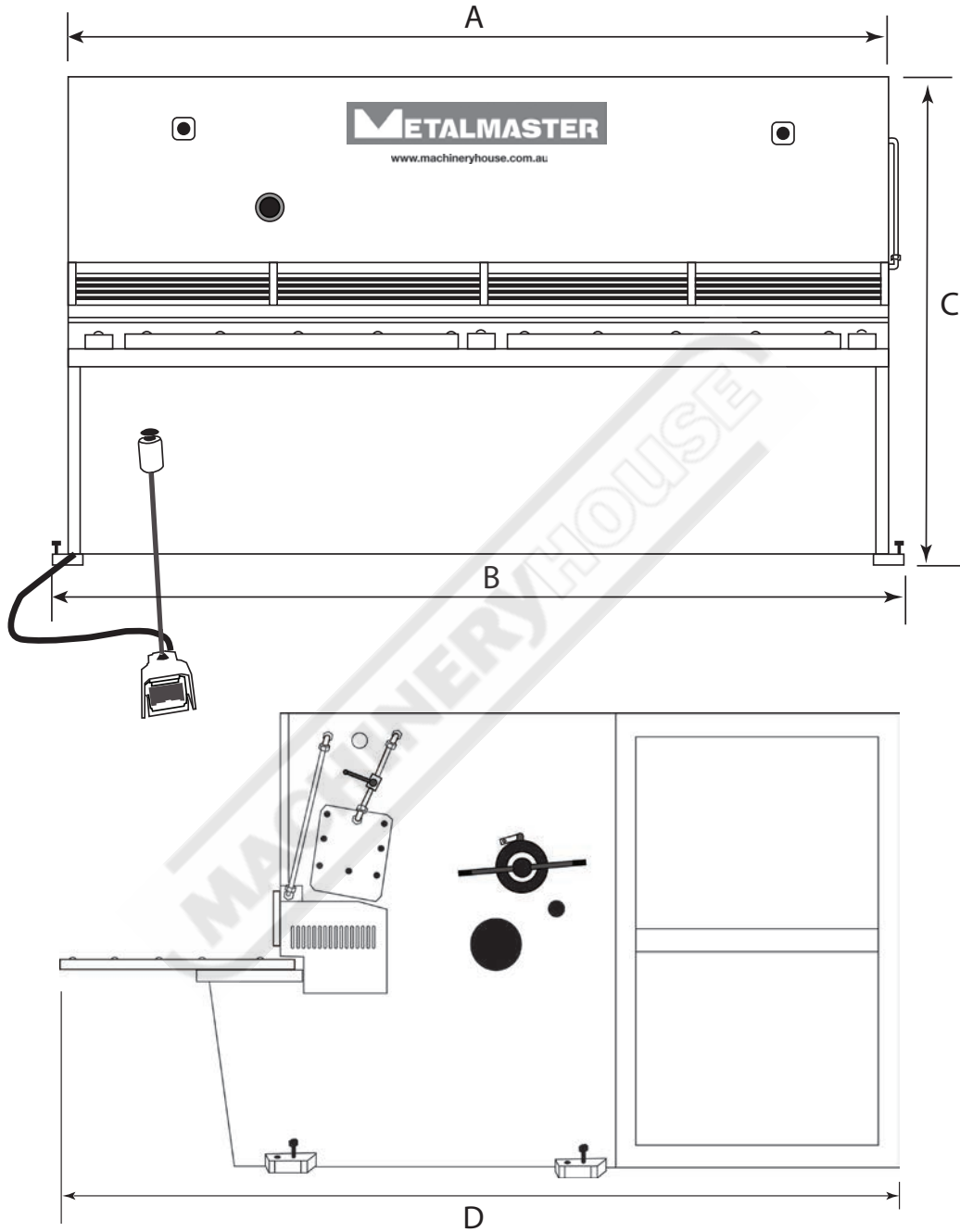
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1.1 SPECIFICATIONS:

Order Code	S9335
MACHINE TYPE	HG-2504C
Shearing Length (mm)	2500
Material Capacity Mild Steel (mm)	4
Material Capacity Stainless Steel (mm)	2.5
Shear Angle (degree)	1.5
Back Gauge Range (mm)	750
System Pressure	18
Oil Tank Volume	150
Floor Space Width (mm)	3300
Depth* (mm)	2930
Height (mm)	1700
* Includes allowance for rear safety fence	
Height of Work Table (mm)	780
Weight (kgs)	3150
Main Motor 3Ph 415V 50Hz (kW)	4
Back Gauge 3Ph 415V 50 Hz (kW)	0.55

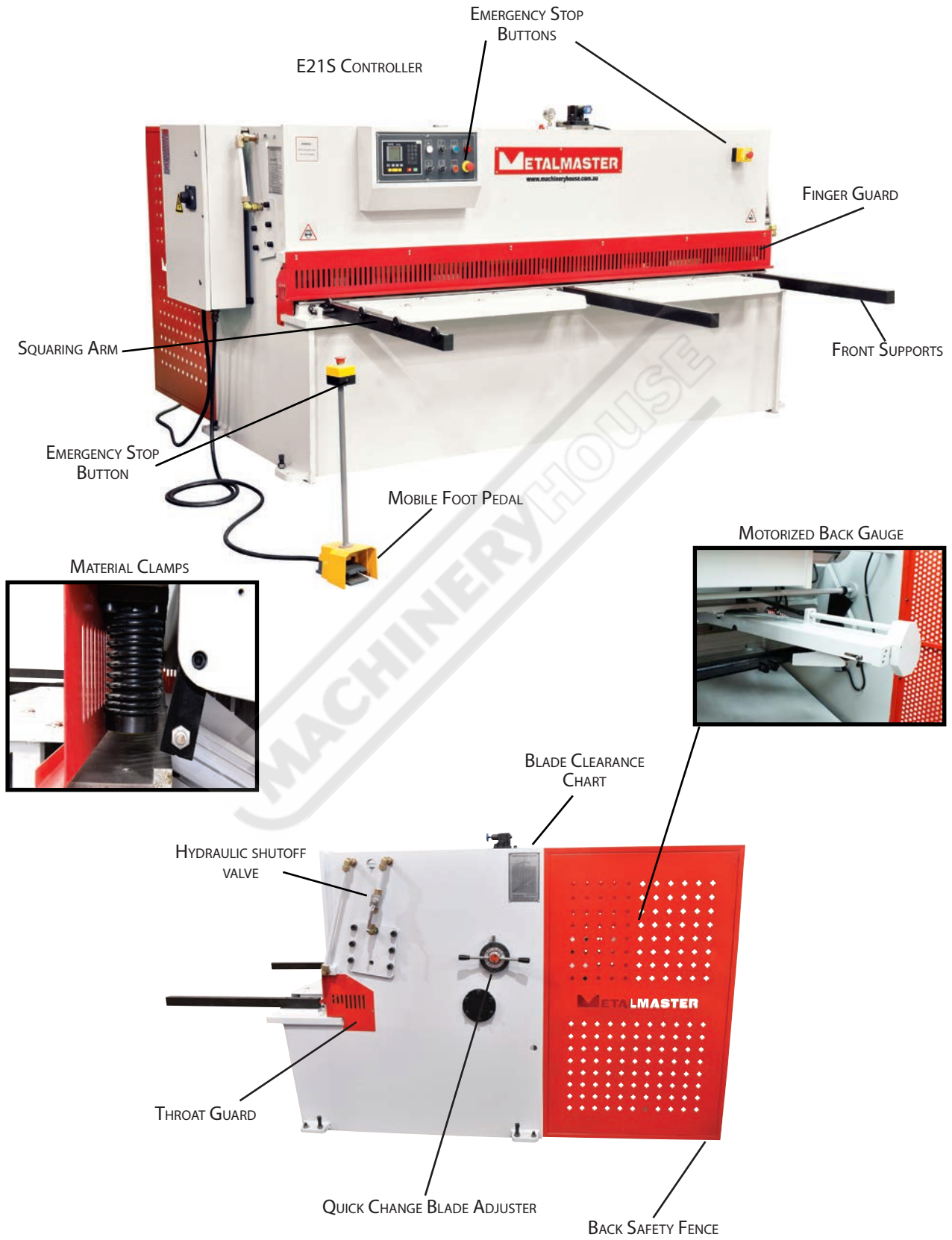
1.2. STANDARD EQUIPMENT:

Back-gauge assembly
Rear guarding
Foot switch and control panel
Front sheet supports
Toolset and Instruction manual

1.3. OVERALL DRAWINGS

mm	HG-2504C
A	3175
B	3300
C	1700
D	2930

1.4 IDENTIFICATION



2.1 GENERAL METALWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation



WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension, of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the workpiece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECTION THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL METALWORKING MACHINE SAFETY Cont.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT

- × Do not distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × Do not wear loose clothing, gloves, necktie's, rings, bracelets or other jewellery that can be come entangled in moving parts. Confine long hair.
- × Do not handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × Do not use rags or wear gloves near moving parts of machines.
- × Do not use compressed air to blow debris from machines or to clean dirt from clothes.
- × Do not force the machine. It will do the job safer and better at the rate for which it was designed.



BEFORE OPERATING ANY MACHINE, TAKE TIME TO READ AND UNDERSTAND ALL SAFETY SIGNS AND SYMBOLS. IF NOT UNDERSTOOD SEEK EXPLANATION FROM YOUR SUPERVISOR OR DISTRIBUTOR

2.1 GENERAL METALWORKING MACHINE SAFETY Cont.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery
- Being struck by material ejected from the machinery
- Contact or entanglement with the machinery
- Contact or entanglement with any material in motion

Health Hazards (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust
- Heat, noise, and vibration
- Ionizing or non-ionizing radiation (X-ray, lasers, etc.)
- Biological contamination and waste
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip)

Other Hazards

- Slips and falls from and around machinery during maintenance
- Unstable equipment that is not secured against falling over
- Safe access to/from machines (access, egress)
- Fire or explosion
- Pressure injection injuries from the release of fluids and gases under high pressure
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components
- Environment in which the machine is used (in a machine shop, or in a work site)

WARNING

MACHINES ARE SAFEGUARDED TO PROTECT THE OPERATOR FROM INJURY OR DEATH WITH THE PLACEMENT OF GUARDS. MACHINES MUST NOT BE OPERATED WITH THE GUARDS REMOVED OR DAMAGED.

2.2 SAFETY PROCEDURES FOR GUILLOTINES

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual



Safety glasses must be worn at all times in work areas.



Long and loose hair must be contained.



Rings and jewelry must not be worn.



Sturdy footwear must be worn at all times in work areas.



Close fitting/protective clothing must be worn.



Gloves must not be worn when using this machine.

SAFETY CHECKS BEFORE OPERATING

- Ensure fixed guards are in place to prevent hands or other parts of the body from entering area's of high risk.
- Guards or safety devices must never be removed or adjusted, except by an authorized person for maintenance purposes.
- Working parts should be well lubricated and free of rust and dirt.
- The area around the machine must be adequately lit and kept free of materials, which might cause slips or trips.
- Be aware of other personnel in the immediate vicinity and ensure the area is clear before using equipment.
- Familiarize yourself with and check all machine operations and controls.
- Ensure cutting table is clear of scrap and tools.
- Faulty equipment must not be used. Immediately report suspect machinery.

SAFETY CHECKS WHEN OPERATING

- Do not attempt to cut material beyond the capacity of the machine.
- Never attempt to cut rod, strap or wire with this machine.
- Use correct lifting procedures when handling large sheets of material.
- Take extreme care during the initial feeding of the workpiece into the machine.
- The workpiece should always be held sufficiently far back from the edge being fed into the guillotine.
- Ensure fingers and limbs are clear before operating the guillotine.
- Hold material firmly to prevent inaccurate cutting due to creep.
- When cutting ensure feet are positioned to avoid contact with the foot operated lever.

SAFETY CHECKS AFTER OPERATION

- Remove all off cuts and place them in either the storage rack or waste bin.
- Leave the work area in a safe, clean and tidy state.

POTENTIAL HAZARDS

- Cuts from the sharp edges and burrs on the sheets before and after cutting.
- Parts of the body being caught in crush and pinch points.
- Injuries caused when handling metal sheets.

2.3 LIFTING INSTRUCTIONS

On the day that the machine arrives, make sure that a crane with sufficient capacity is available to unload the machine from the vehicle. Make sure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

To handle the Guillotine, use only the two sling lifting points located on the top of the end plates. (Fig. 2.3) The slings should be positioned so the machine is level when lifted.

When using slings please take note of the sling angle and the loads that apply

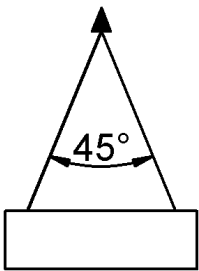


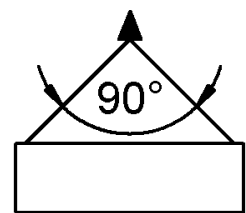
FIG 2.1.

When the slings are at a 45° angle then each sling will carry the equivalent of 50% of load weight. (Fig.2.1).

When the slings are at a 90° angle then each sling will carry the equivalent of 75% of the load weight on each sling. (Fig 2.2)

NOTE! METALMASTER RECOMMEND NOT TO EXCEED 90° ANGLE

FIG 2.2



LIFTING POINTS

When lifting the machine only use the lifting points on the machine. (Fig. 2.3) and sling as per diagram below. (Fig. 2.4) Ensure that when lifting, the machine does not tip over.

Check that the lifting slings do not interfere with the hydraulic pipes or electrical conduits. Certified lifting slings only should be used.

Failure to follow these instructions could cause damage to the machine

LIFTING POINT

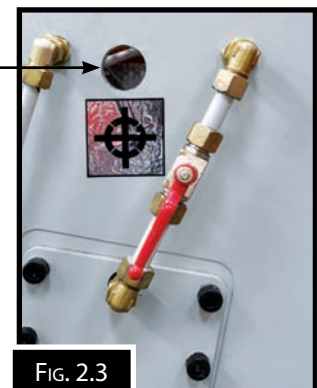


FIG. 2.3

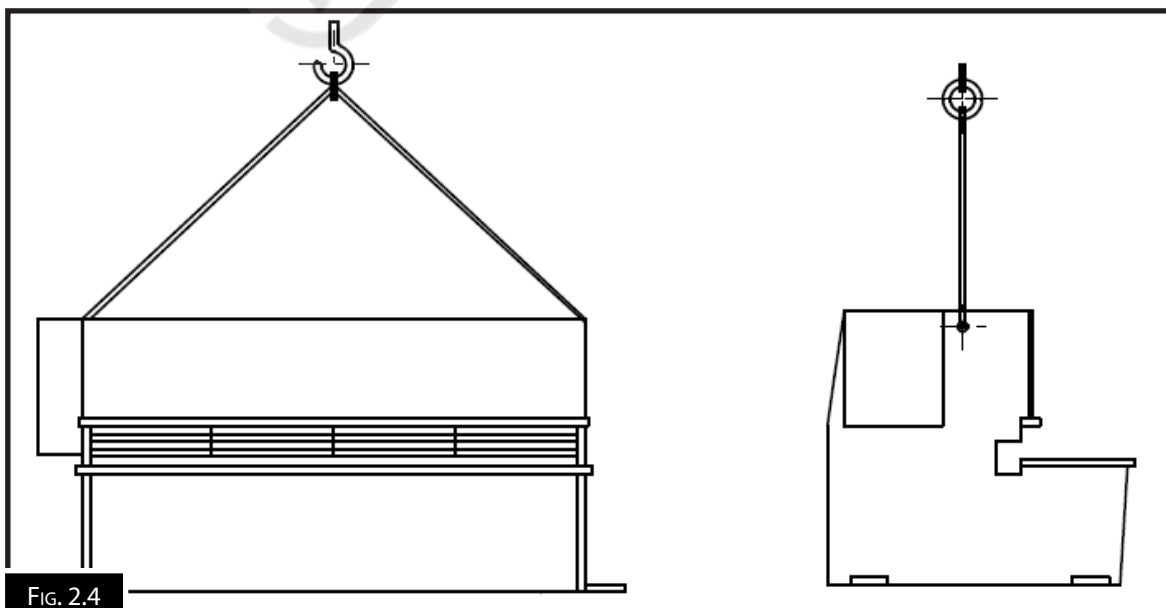


FIG. 2.4

3. SETUP

3.1 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust prevented products.

It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

3.2 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

OPTIONS FOR MOUNTING

The machine is best mounted on a concrete slab.

Masonry anchors with bolts are the best way to anchor machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. (Fig. 3.1)

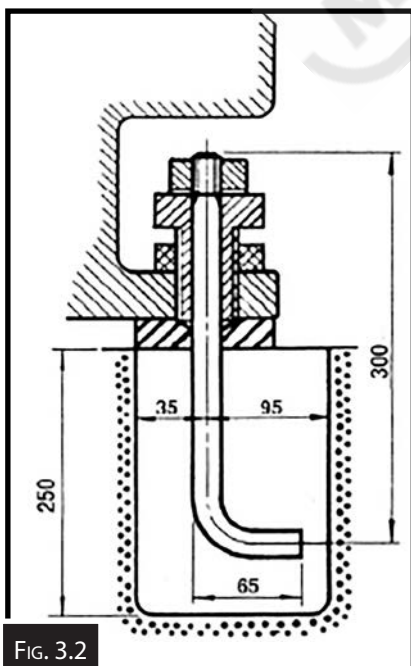


FIG. 3.2

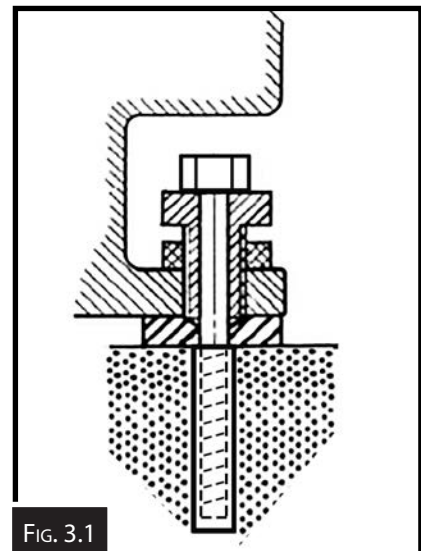


FIG. 3.1

In some case a suitable foundation may not be available and a new one may need to be prepared.

The foundation should be concrete approximately 200mm thick with pockets left clear for the hold down bolts.. The hold down bolts can be "L" shape as per the example in Fig. 3.2

3.3 BASE FOUNDATION AND SECURING POINTS

To optimize the performance of the machine it is important that the foundation for the machine is stable and level. It is best if the machine does not straddle two concrete slabs, but instead is mounted on a single slab. The machine must be leveled and firmly stationed on the floor where it is to be used. The floor load, must be suitable for the weight of the machine. If there is no slab suitable to hold the machine then a solid concrete base must be prepared according to the Foundation Diagram below.

The sizes for the bolt holes position are listed as A-B in the chart below. Check the sizes with the distributor.

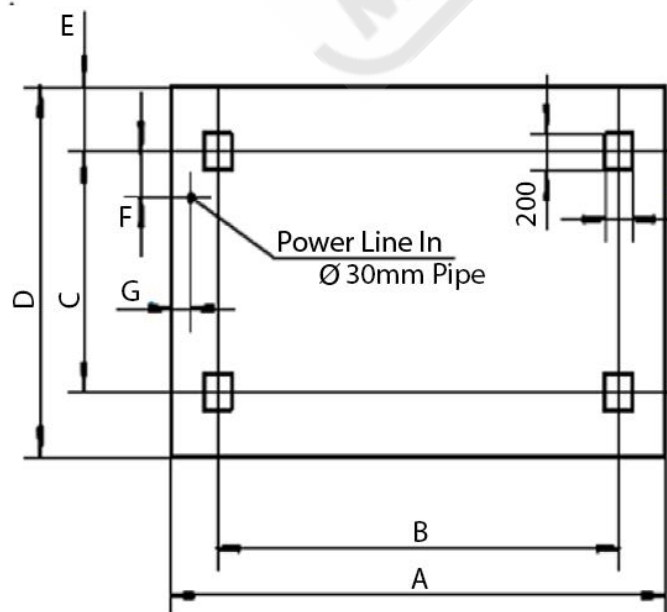
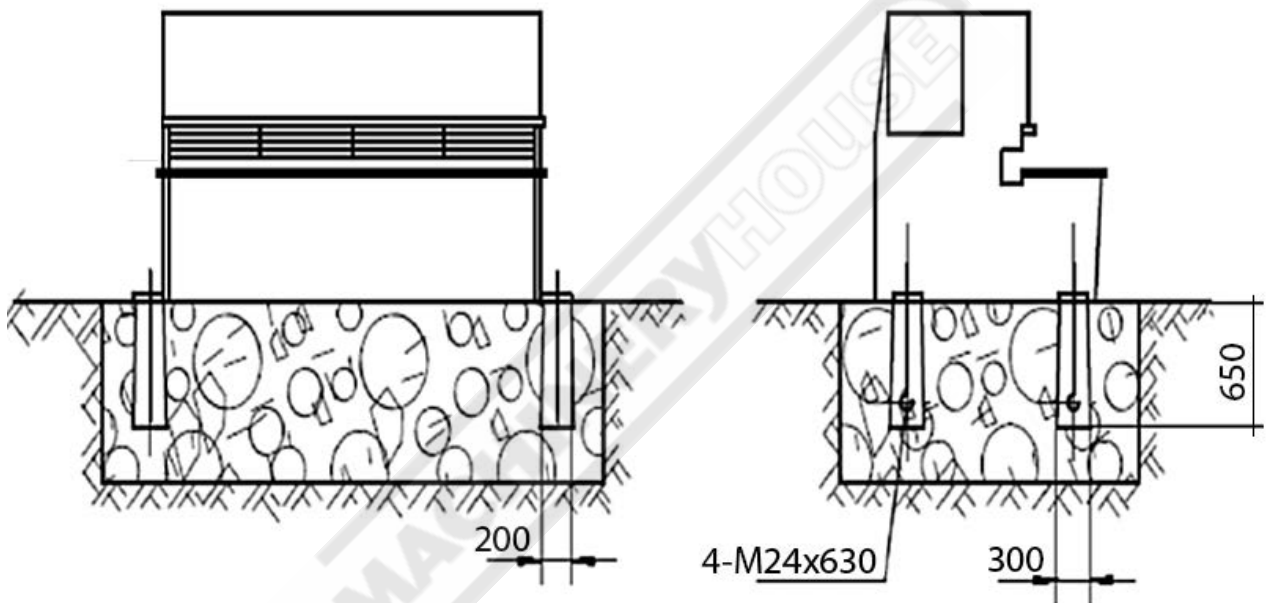


Table of Measurement

Model	A	B	C	D	E	F	G
HG-2504C	3500	2885	1000	1200	60	250	100

3.4 ELECTRICAL INSTALLATION

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 415V. To minimize the risk of electrocution, fire, or equipment damage, these machines should be hard wired with installation work and electrical wiring done by a qualified electrician.

NOTE : THE USE OF AN EXTENSION CORD IS NOT RECOMMENDED AS IT MAY DECREASE THE LIFE OF ELECTRICAL COMPONENTS ON YOUR MACHINE.

ELECTRICAL REQUIREMENTS

Nominal Voltage.....415V
Cycle.....50 Hz
Phase.....Three Phase
Power Supply Circuit.....20 Amps

(Full load current rating is available on the specification plate on the motor.)

3.5 FULL-LOAD CURRENT RATING

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine can be found on the specification plate on the machine.

It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.

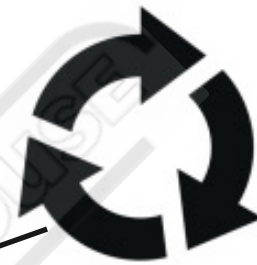


3.6 CHECKING THE POWER SUPPLY

METALMASTER machines are supplied wired ready to run. Check the specification plate on the machine to confirm that the voltage is compatible with the local power supply.

The machine must be connected to the power by a qualified and licensed electrician. Warranty may be voided if it is found that the connection was not carried out by a qualified electrician.

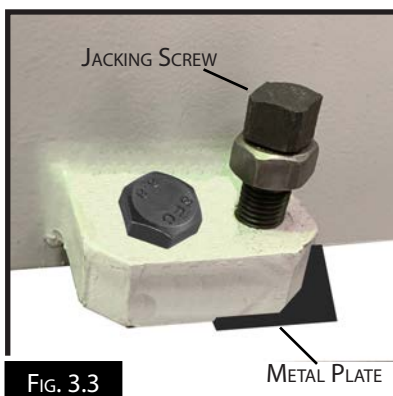
Check the rotation of the motor. If the direction does not match the diagram below, isolate the machine and change the wiring



3.7 MACHINE LEVELING

To set your machine up so that it operates to optimum performance, apply the following procedure. After the guillotine has been anchored to a concrete slab floor, it then needs to be leveled. The leveling is performed using the screws on each pad.(Fig. 3.3). Loosen the hold down bolts and place a level on the surface of the working table. Tolerances: 1000:0.30mm, for both longitudinal and transverse.

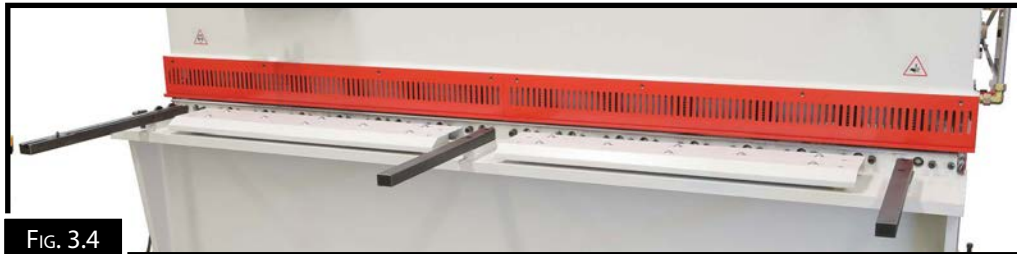
Metal plates need to be placed under each jacking screw to distribute the load. Once level then tighten the hold down bolts.



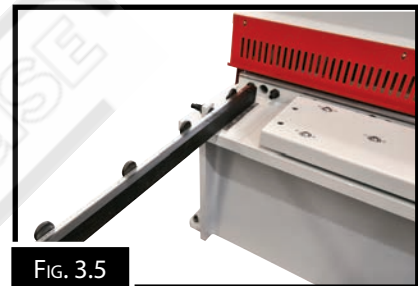
THE MACHINE MUST NOT REST ON SUPPORTS OTHER THAN THOSE DEFINED IN FIG. 3.3

3.8 ATTACHING THE ACCESSORIES.

- ❑ Bolt the support arms onto the feed table. Ensure they are level and square to the table. (Fig 3.4)



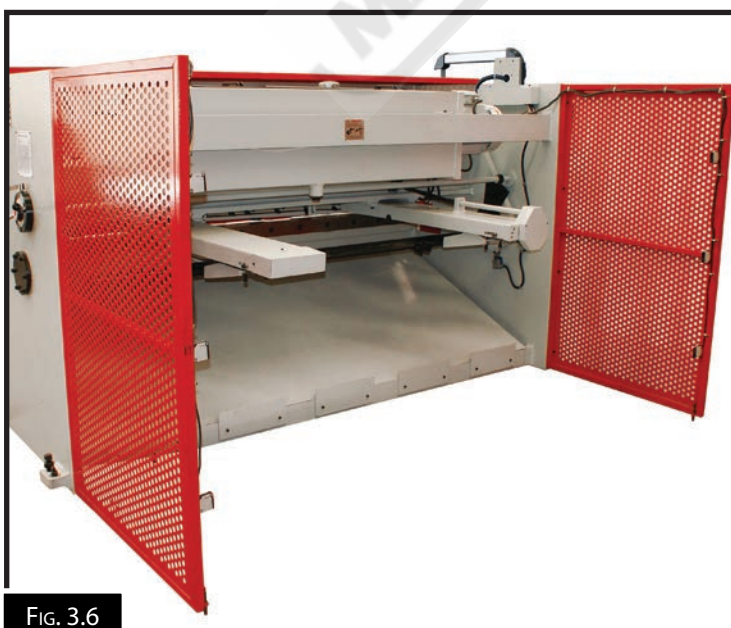
- ❑ Place the squaring stops Fig 3.5 into position on the table top, securing into place with the bolts supplied. Check that the square stops are square to the blade. Adjust by loosening the bolts and moving by the amount allowed by the clearance of the holes.



- ❑ Re tighten the screws.

- ❑ Unpack and attach the rear fence to the back of the machine. Ensure that the sensors have been connected and set up. (Fig.3.6)

- ❑ Unpack the mobile foot control and plug the into the socket provided on the machine. (Fig.3.7)



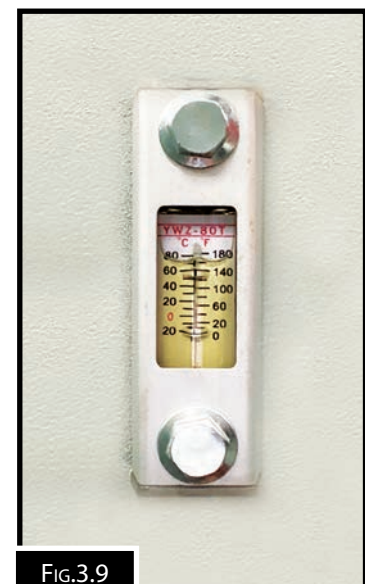
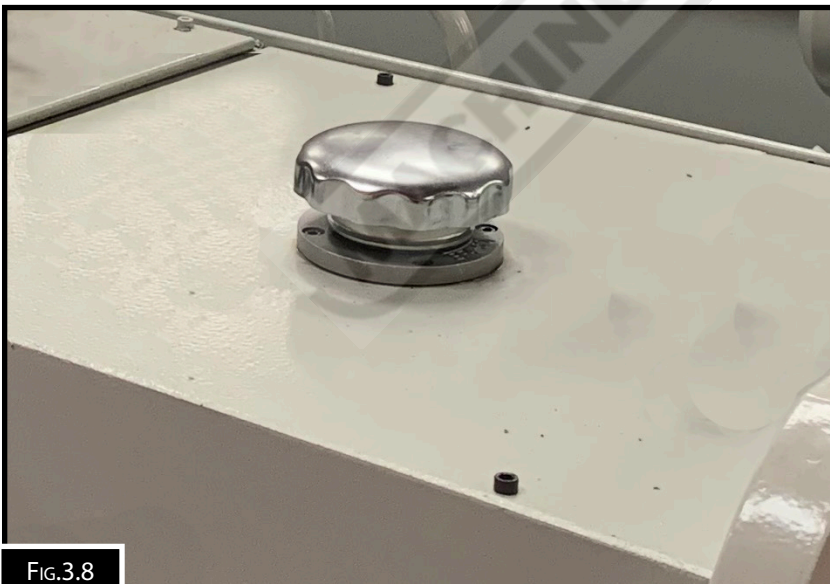
3.9 FILL THE HYDRAULIC OIL TANK.

The hydraulic unit is located at the rear of the machine. Take care when accessing the hydraulic oil tank.

When filling the tank with oil, make sure that the top of the tank is clean and free from dust and dirt.

To fill the oil tank:

- Remove the top cover or covers of the hydraulic oil tank, or if a oil pump is available then remove the filler cap.
- Using a pump add the oil into the tank. Metalmaster recommend Shell Tellus Oil 46 or an equivalent.
- Pour or pump the recommended hydraulic oil into the hydraulic oil tank to the specified level of the oil gauge. The specified level is near the middle mark of the oil gauge when the ram is at the maximum opening limit.
- Always maintain this oil level to ensure that the machine operates to its optimum performance.



4. COMMISSIONING

4.1. PREPARATION OF THE MACHINE.

- Remove all wrapping and packing grease from the machine.
- Check the machine for loose bolts. Tighten as required.
- Inspect for oil leakage or loose fittings. Similarly check the main rams between the frames.
- Clean the blades and tighten the securing bolts as required. Examine the cutting edges of both blades for damage.
- Inform your service provider of any damage or faults with the machine.

4.2 CONTROLS

The purpose of this control overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, and the machine controls and what they do. It also helps the operator to understand if they are discussed later in this manual.

MAIN ISOLATING SWITCH

The main isolating switch is found on the side of the electrical box. This switch cuts the power supply from the power source to the machine. (Fig.3.10)

⚠ WARNING IF ELECTRICAL MAINTENANCE IS CARRIED OUT THEN THE POWER MUST BE DISCONNECTED FROM THE SOURCE BY REMOVING THE FUSES AT THE POWER SUPPLY BOARD.



FIG.3.10

EMERGENCY STOP BUTTONS

The electrical and hydraulic circuits of your machine are designed to allow operation with maximum safety. The following precautions are available on the machine for enhanced safety.

There are five Emergency stop buttons (engaging type) on the machine. Two are found on the front of the machine, one on the foot switch control unit, one on the main control pendant, and one on the back of the electrical cabinet. Once the button has been pressed to reset the emergency stop, the red button must be rotated to reset the stop. (Fig.3.11)



FIG.3.11

4.2 CONTROLS Cont.

Main Controls

The main machine operating controls are located on the pendant.



1	Power On Indicator Light	5	Shadow Line Light ON/OFF
2	Lockout Key Lock to the pump	6	Continuous or Single Cut
3	Illuminated Pump Start Button	7	Rear Guard Sensor Light
4	Hydraulic Pump Stop	8	Emergency Stop

Foot pedal control

Emergency stop button (engaging type) is available on the foot switch control unit.

The foot pedal when pressed activates the shearing beam and must be held in the depressed position until the machine has completed its cut. Releasing the foot pedal during the shearing operation will return the machine to the top of its stroke when controller is set to single cut.



4.3 OMRON E3Z - SAFETY SENSORS OPERATION & ALIGNMENT

The safety circuit consists of a reset switch and two rear side fences, each having 3 sensors. Your machine has a RED warning light on the pendant and a message "Machine Not Ready on the E21S controller. When the main power is switched on the safety circuit must be reset before the hydraulic pump can be started.

A: Basic Control - Light on



B: E21S Control Display



A: Basic Control - Light on : indicates the safety circuit has not been reset.

B: E21S Control Display: "Mach not Ready" indicates the hydraulic pump has not been started.

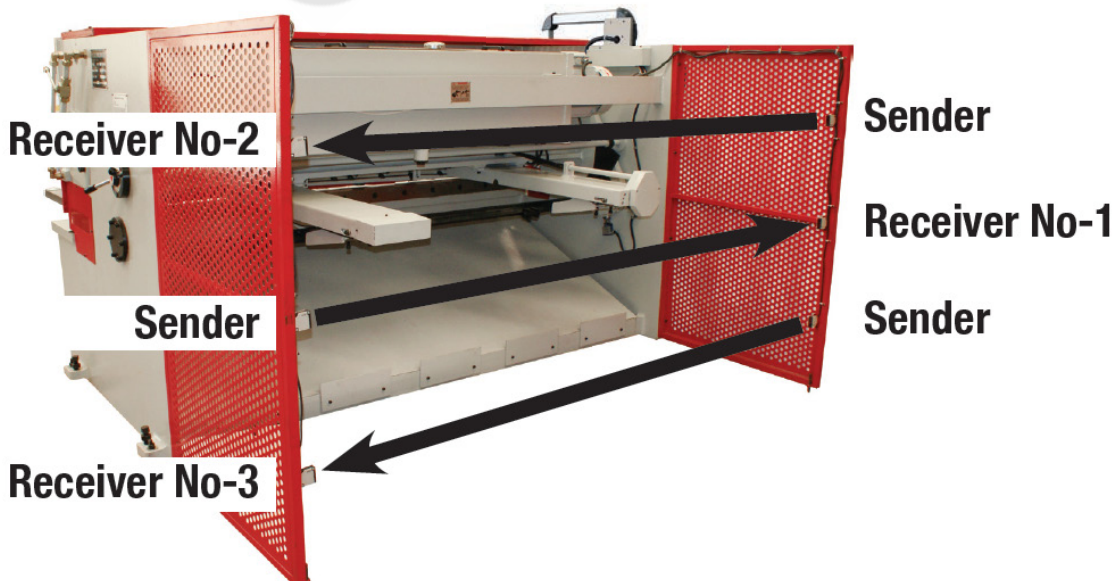
RESET BUTTON

The green reset button is found on the rear of electrical box

The rear sensors must be aligned before this reset switch can be pressed.



REAR FENCES WITH SENSORS MOUNTED

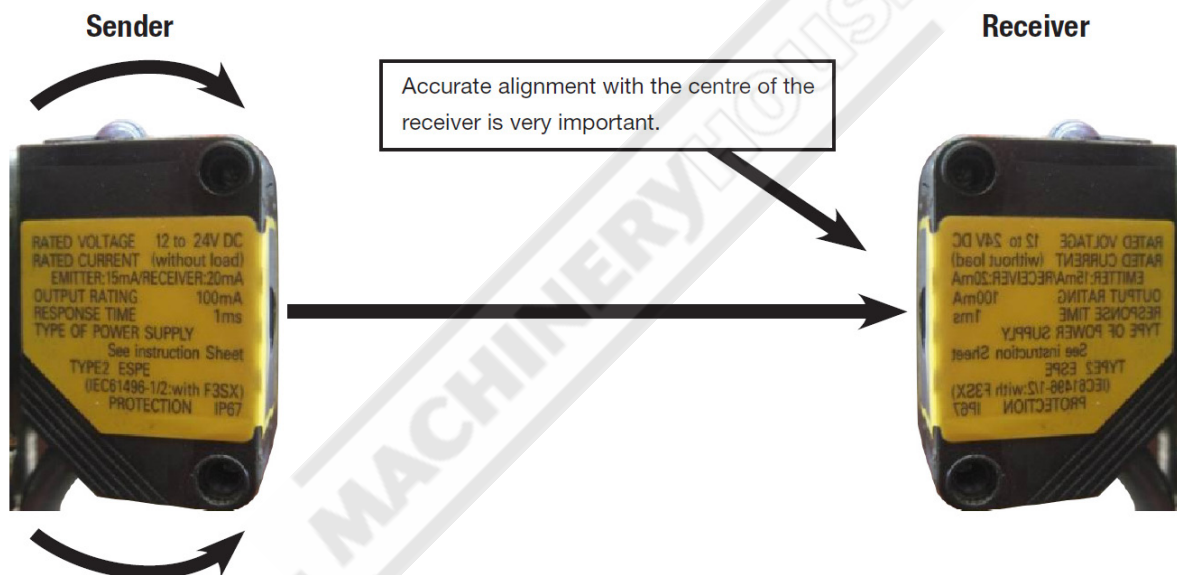


MACHINE SETUP

First ensure that the machine is level and all four leveling jacking bolts are correctly adjusted. Ensure the rear fences are tight and the stabilizing bolt is on the ground to stop the fence moving around.

ALIGNMENT

The sensors are sensitive to alignment so try to align as accurately as possible. If the sender is only slightly aligned with the receiver, any vibration when cutting will stop the pump and the safety circuit will have to be reset again. Alignment could involve loosening the sensor mounting screws or bending the mounting brackets to get the best alignment.



IDENTIFYING SENSORS

SENDERS

Each sender has a red light on top of the unit and a red light on the front. These two lights will be on all the time while the machine has power.



RECEIVER

Each receiver has two lights on top of the unit. These lights indicate if the receiver has power and if it has been aligned correctly with the sender.

No lights on**No Power****Green light on****Power on & not aligned****Green & Orange lights on****Power on & aligned****ALIGNMENT ORDER**

The receivers are wired in series and must be aligned in the correct order. As each receiver is aligned correctly it will send power to the next receiver.

No-1 receiver (middle) A green light on indicates it has power. When it is correctly aligned with the sender a orange & green light will be on and it will send power to No-2 receiver.

No-2 receiver (top) A green light on indicates it has power. When correctly aligned with the sender a orange & green light will be on and it will send power to the No-3 receiver.

No-3 receiver (bottom) will have a green light on and when it is correctly aligned with the sender the orange & green light will be on and it will send power to the reset button.

Successful alignment When all 3 receivers are aligned correctly with their corresponding senders, they should all have orange and green lights on top.

5. OPERATION

The Metalmaster Guillotine is designed to perform specific operations that are described in this manual. Many of these operations can be dangerous or deadly if performed incorrectly. The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If you are experiencing difficulties performing any operation, stop using the machine! If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced operator. **Above all, your safety should come first!**

5.1 STARTING THE MACHINE FOR THE FIRST TIME.

1. Turn the main isolation switch ON and wait for the controller unit to load up.(Fig.5.1)
2. Press the RESET button on the Electrical cabinet. (Fig.5.2)
3. Turn the pump lockout key lock "ON"
4. Press the pump start button. (Fig.5.3)
5. Press the green program start button on the controller (Fig.5.3)

**FIG. 5.1****FIG. 5.3****FIG. 5.2**

5.2 PERFORM PRE-OPERATIONAL SAFETY CHECK PRIOR TO OPERATING

When the main power is switched on the safety circuit must be reset before the hydraulic pump can be started. This will be displayed only by a RED warning light (A), on the pendant control. The E21S Controller will not display any notification

A: Basic Control - Light on



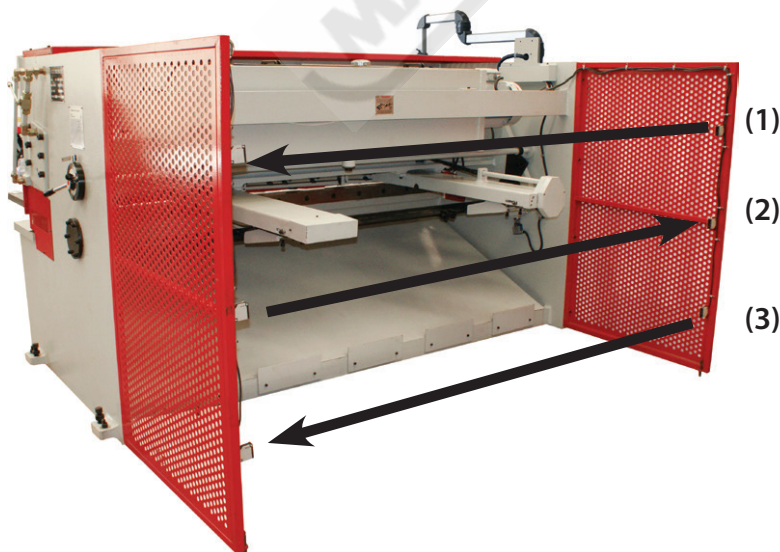
E21S Control Display



1. REAR SAFETY GUARD CHECK, PLEASE FOLLOW THESE STEPS

1. Start machine as per instruction procedures in "5.1 Starting the Machine For The First Time"
2. Go to the back of the machine, stand outside the rear safety gate & obstruct sensor (1)
3. Ensure the machine has stopped and is disabled
4. Check on the control pendant that the Warning light (A) is illuminated
5. Press the green reset button rear of electrical box refer image (D)
6. Repeat steps 1 to 5 for each of the other sensors (2) & (3)

C: Rear Guarding Sensors



D: Guard Reset Button



5.3 TESTING THE EMERGENCY STOPS.

The Metalmaster Guillotines are fitted with four emergency stop buttons. One is on the mobile foot pedal and one is on the pendant control panel. The other two emergency stop buttons are on the front of the guillotine. They should be tested one at a time to ensure they are all working correctly.

To test the emergency stops:

1. Make sure that all the emergency buttons have been reset
2. Start the machine and then press the emergency stop on the pendant. The machine's hydraulic pump should stop and the power should be cut off. (Fig.5.5)
3. Try to restart the hydraulic pump by pressing the green pump start button. If the pump will not start then the emergency stop is working correctly.
4. Reset the emergency button by twisting the top red section until the red section pops up.
5. Press the green pump start button again. The pump should now start. The emergency stop is working correctly.
6. Repeat steps 1-5 for each of the other emergency stop buttons. (Fig.5.6)



FIG. 5.5



FIG. 5.6



NOTE: BEFORE STARTING THE OPERATION OF THE MACHINE, CHECK THAT THERE ARE NO PERSONS AND OBSTACLES AROUND THE MACHINE. PAY PARTICULAR ATTENTION TO THE REAR OF THE MACHINE.

NEVER PLACE HAND TOOLS AND PARTS BETWEEN THE BLADES

5.4 E21S GUILLOTINE CALIBRATION: X AXIS

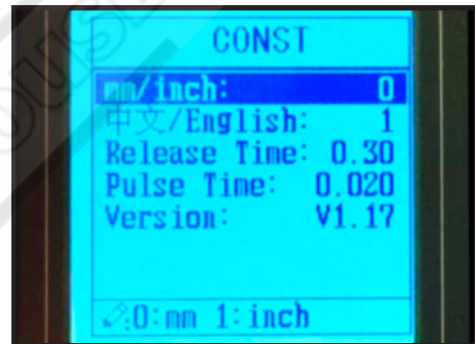
The Metalmaster Guillotine is calibrated before the machine leaves the factory and should not need any further adjustments. However should the machine at any time need to be calibrated, the following is the procedure.

NOTE: BEFORE PROCEEDING TO CALIBRATE THE X AXIS, PLEASE ENSURE THE BACK GAUGE IS PARALLEL TO THE CUTTING BLADE. REFER PAGE 36 FOR BACK GAUGE PARALLEL ADJUSTMENT

1. Use a rule and manually move back gauge until it measures 100mm between the back gauge and the edge of the bottom blade.

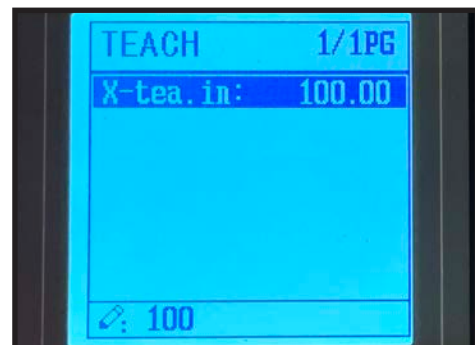


2. Press P until "CONST" page is located.



3. Type password (1212) and press enter to locate Teach screen.

4. In the teach screen, highlight X, and type 100 and then press enter.



5. Press P twice to exit and return to the "Single" page..

6. Check X = 100mm on the "Single" page.

NOTE: THE MANUAL BACK GAUGE ADJUSTER SHOULD NOT BE MOVED WHEN THE POWER TO THE MACHINE HAS BEEN CUT. THIS MOVEMENT WILL CAUSE THE X" AXIS TO BE OUT OF CALIBRATION. IF THIS HAPPENS THEN THE PROCEDURE ABOVE WILL NEED TO BE DONE AGAIN.



5.5 ESTUN E21S GUILLOTINE CONTROLLER OPERATION

SINGLE: Common page that is used by anyone who wants to re-write a job.



X - (X Back gauge actual position)

XP - (X Program Position) - Back gauge distance from the blade

DX - (Distance of Back Gauge Retraction) - Amount the back gauge will retract when cutting

PP - (Program Pieces) - Number of pieces to be cut

DLY - (Delay Retraction) - Time delay in seconds for the back gauge to retract when cutting

CP - (Completed Pieces) - Amount of pieces that have been completed

TMR - (Timer) - Set timer to ensure material cuts all the way through - Approx. 1 sec = 600mm

Operation: With XP highlighted, type 100 and press the enter button. Continue the same process until all parameters have been entered and then press green program start button. The controller will now find X position. Once it has found position you can start cutting material.

Example: This job will cut 100mm. There is no retraction and no delay. There are 4 pieces to cut and 0 pieces have been completed so far. The blade will travel approximately 1200mm

PROG: Program management page



This page gives access to all the saved programs, there are 40 programs and ability to save 25 steps for each program.

Operation: Press the **P** (program button) until Program management page has been located. Enter **1** and press enter, this will take you straight to the Product Information Page for program **No-1**.

PROG: Product Information Page

This page lets you enter parameters for the pieces to be cut.

ST - (Steps) - How many different length pieces to be cut in 1 program

PP - (Programmed Pieces) - Number of pieces to be cut

CP - (Completed Pieces) - Amount of pieces that have been completed

DLY - (Delay Retraction) - Time delay in seconds for the back gauge to retract when cutting

TMR - (Timer) - Set timer to ensure material cuts all the way through - Approx. 1 sec = 600mm



Operation: With ST highlighted type 2 and press the enter key, this will save parameter and PP will then be highlighted. Continue until all desired parameters have been entered.

Example: This program has 2 different length pieces to be cut and is repeated 5 times. 4 pieces have been cut, the back gauge has a 1 second delay and the blade has a cut width of three seconds.

PROG: Individual Cut Information Page

This page lets you enter information for each individual cut.

X - (X Back Gauge - actual position)

XP - (X Program Position) - 100mm back gauge distance from the blade

DX - (Distance of Back Gauge Retraction) - 5mm back gauge retraction

RP - (Repeat) - This cut will be repeated 2 times



Operation: With X highlighted, type 100 and press the enter button. Continue the same process until all desired parameters have been entered. Once all cuts have been completed press **arrow across and enter parameters for step 2.**

Example: Program 1 has 2 steps and step 1 will be repeated before program moves to step 2.

5.6 SETTING THE BLADE GAP

Setting the blade gap correctly will prolong the life of the blades and most likely, the guillotine itself. Too tight and excessive forces will be needed to shear the metal, and not tight enough the metal may jam in the gap. To adjust the blade gap for the material thickness and type, first check the chart on the side of the machine (Fig 5.7) for the recommended settings.

GAP ADJUSTMENT TABLE

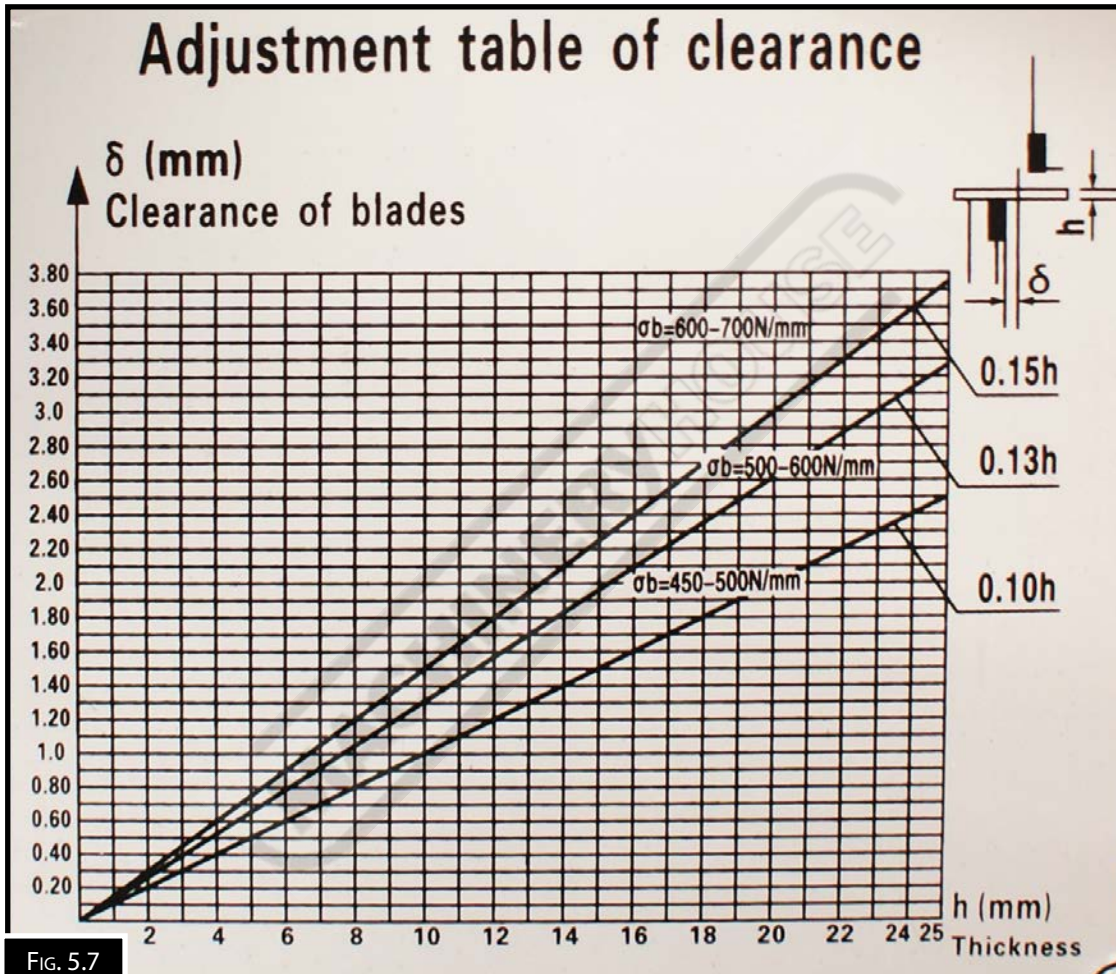


FIG. 5.7

Once the chart has been checked then adjust the blade clearance.

To Adjust The Gap:

1. Loosen the clamp at the top of the hand-wheel.
2. Turn the hand wheel (Fig 5.8) to the correct graduated setting.
3. Tighten the clamp on top of the hand wheel.

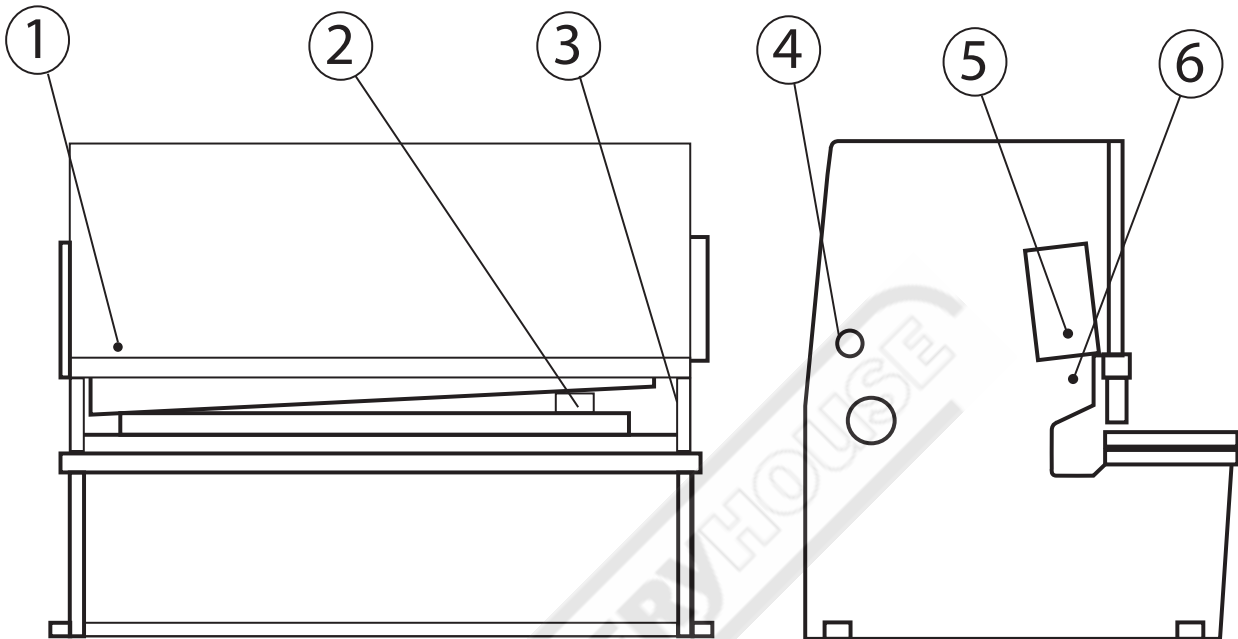


FIG. 5.8

6. MAINTENANCE AND INSPECTION**6.1 TYPE AND FREQUENCY OF INSPECTIONS**

Inspection	Period	Responsibility
Lubrication of all grease points	Daily	Operator
Lubrication of slide-ways	Weekly	Operator
All Guards that protect against physical damage	Daily	Operator
Machine fixing bolts against loosening	Weekly	Operator
Oil leakage in cylinders	Weekly	Operator
Hydraulic Oil Change and filter	1000hrs	Maintenance
Oil leakage in pipes, hoses and hydraulic elements	Weekly	Operator
Hydraulic fluid level	Weekly	Operator
Cylinder connections bolts against loosening	Weekly	Operator
Safety & limit switches against loosening, damage	Weekly	Operator
Terminal connections of the electrical installation	Annually	Electrician
Back Gauge drive Belt Tension	Weekly	Operator

6.2 LUBRICATION POINTS



Lubricants.

- Cylinder and main pivot points - grease.
- Back-stop: shafts, screws, nuts - grease.
- Shear beam slides - grease.
- Hydraulic oil #46.

6.3 CHANGING THE HYDRAULIC OIL

All precautions must be taken to keep the hydraulic system clean at all times. When changing oil, make sure that the top of the oil tank is clean and free from dust and dirt.

To change the hydraulic oil:

1. DISCONNECT THE MACHINE FROM THE POWER SUPPLY
2. After removing the dust and dirt from the top of the tank, remove the socket head cap screws that secure the tank top cover and remove the cover or covers. (Fig 6.1)
3. Using an appropriate pump, drain out the old oil completely. Be sure nothing is left.
4. Unscrew the filter and replace with a new filter
5. With a clean cloth wipe the bottom of the tank to ensure that all contaminants have been removed.
6. Using a pump, add the new oil into the tank.
7. Oil level must be filled until the oil reaches the centre of the oil sight glass.
8. Always keep the oil at the specified level.

NOTE: OIL MUST BE CHANGED AFTER THE FIRST 200 WORKING HOURS OF USE, AND THEN AFTER EVERY 1000 WORKING HOURS (SEE: LUBRICATION FREQUENCY).



FIG. 6.1

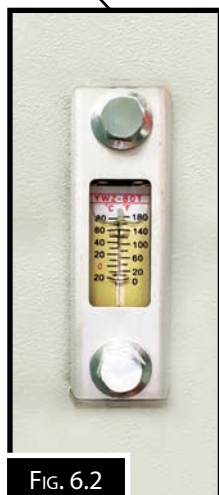


FIG. 6.2

SIGHT GLASS



FIG. 6.3

FILLER CAP

6.4 CHANGING THE FILTER

When dirt, dust, and other foreign matter are deposited in large amounts in the hydraulic circuit, the hydraulic pump may produce abnormal noise and decrease in discharge capacity, causing the cutting speed to slow or the top blade to vibrate. These conditions are attributable to the plugging of the filter in the hydraulic oil tank. When changing the Hydraulic oil always replace the filter.

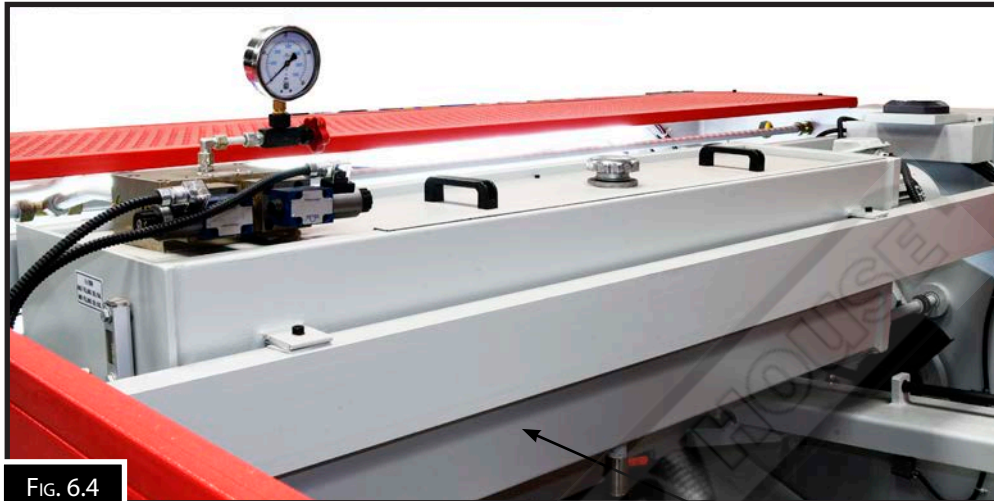


FIG. 6.4



FIG. 6.5

To Change The Filter

1. DISCONNECT THE MACHINE FROM THE POWER SUPPLY.
2. With a clean cloth, remove any dust or debris from the top of the tank to insure that nothing accidentally enters into the tank.
3. Remove the socket head cap screws that hold down the cover and remove the cover from the oil tank. (Fig.6.4)
4. Remove all the oil from the oil tank and wipe the inside of the tank clean with a cloth to remove any contaminants left in the bottom of the tank..
5. Unscrew the old filter from its place inside the oil tank (Fig.6.5)
6. Screw the new filter into its place in the tank and replace the cover and refill the tank with clean new oil.

NOTE: THE SUCTION FILTER ELEMENT MUST BE CLEANED AFTER THE FIRST 200 HOURS OF USE, AND THEN AFTER EVERY 1000 WORKING HOURS. REPLACE IF DAMAGED OR UN-SERVICEABLE.

6.5. BLADE PARALLEL ADJUSTMENT.

The following information applies when fitting new or sharpened blades.

This is a two man job where one will need to check the blade clearance with a feeler gauge (Fig 6.6) from the rear of the machine while the other adjusts the blade holder setting.

- The clearance must be checked across the full length of the blades.
- Use a feeler gauge, to test the clearance.
- According to the test adjust the clearance.

NOTE: BEFORE DEPRESSING THE FOOT PEDAL CHECK THAT THE BLADES WILL PASS AND WILL NOT TOUCH. IF THE BLADES TOUCH, DAMAGE MAY BE CAUSED TO THE CUTTING EDGE.

To Check The Clearance At Set Intervals On The Blade.

1. Set the selector control on the control box to normal operation function.
2. Depress the foot pedal and move the blade to the maximum down stroke position then shut off the ball valve (Fig 6.7) to hold the stroke in the down position.
3. DISCONNECT THE MACHINE FROM THE POWER SUPPLY.
4. Release the ball valve slowly to allow the upward movement of the top blade to check the clearance at set intersection intervals of the blades.
5. Once the clearances are equal and the blades parallel, tighten all fasteners and locknut's and release the ball valve fully.
6. RE-CONNECT THE POWER SUPPLY and cycle the machine a few times.
7. Take a test cut to ensure that the cut is clean and without burrs.
8. This operation may be required to be repeated until the clearance is parallel.



NOTE: THE BLADES ARE VERY SHARP AND CAN CUT VERY EASILY. USE THICK LEATHER GLOVES WHEN HANDLING THE BLADES AND ALWAYS USE A HELPING HAND WHEN INSTALLING NEW OR RESHARPENED BLADES.

6.6 MAINTAINING THE BACK GAUGE

A well maintained machine optimise's the performance and longevity of the machine. This is no more important than with the back gauge drive mechanism. Failures in this area can do a lot of damage. The main area that needs to be checked is the belt drive that ensures the back gauge travels in and out equally on each side. For this reason the belt adjustment must be correctly adjusted and maintained. (Fig 6.8)

To adjust the belt:

1. DISCONNECT THE MACHINE FROM THE POWER SUPPLY



FIG. 6.8

2. Loosen the socket head screw and adjust the belt (Fig.6.9)

NOTE: BEFORE ANY FINAL TENSIONING IS TO BE APPLIED MAKE SURE THAT THE TIMING BELT TEETH ARE FULLY SEATED IN THE TOOTH GROOVES ON BOTH TIMING BELT PULLEYS. CHECK TO MAKE SURE THAT THE TIMING BELT TEETH STAY SEATED IN THE TOOTH GROOVES BY ROTATING THE DRIVE SYSTEM BY HAND.

3. The tension on the belt should be the amount of deflection when the belt is pressed between the pulleys. The deflection should be approximately 1.2mm for every 100mm of span length.

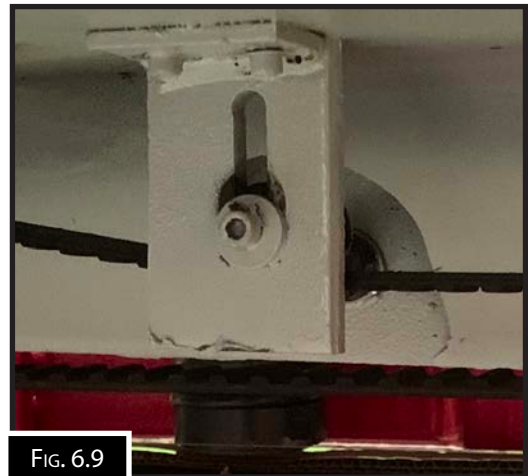


FIG. 6.9

6.7 BACK GAUGE PARALLEL ADJUSTMENT.

From time to time the back gauge may become out of parallel. This can happen when the machine is only used on one side of the machine. For this reason it is best to vary the position along the blades where the material is cut. If the back gauge does become out of parallel, then follow the procedure below. There are five adjusting screws on each arm.

The centre screw is adjusted to set the distance from the blade.(Fig.6.10)

The four adjusting screws are to set the tilt on the back gauge.

NOTE: THE BACK GAUGE SHOULD BE TILTED BACK AT THE TOP TO ENSURE THE MATERIAL IS CLEARED WHEN THE SWING ARM SWINGS DOWN



FIG. 6.10

To adjust the back gauge:

1. Adjust the back gauge to a gap of 20mm
2. With a small strip of steel take a cut at each end of the blade and one in the centre.
3. Measure each piece to determine if the back gauge is parallel. If adjustment is required.
4. DISCONNECT THE MACHINE FROM THE POWER SUPPLY
5. Select the arm that needs to be moved in towards the blade. Loosen the 4 lock nuts on the jacking screws and adjust the 4 set screws so that the back gauge tilts back at the top approximately 1-2 degrees. (Fig.6.11)
6. Loosen the centre lock screw on the arm that needs to be moved in towards the blade and adjust the centre screw as required. (Fig.6.12)
7. When adjusted correctly tighten all the lock screws.
8. Re connect the power and take a test cut. If the back gauge is not parallel then repeat steps 2-7 again.

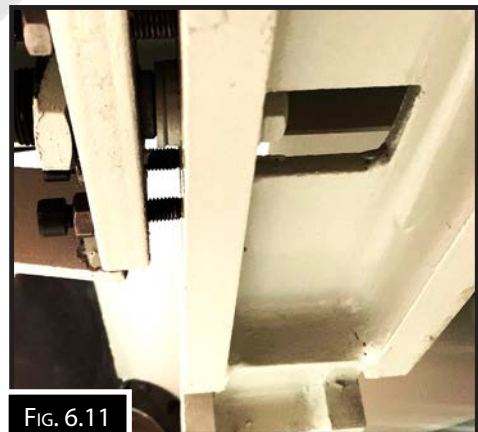


FIG. 6.11

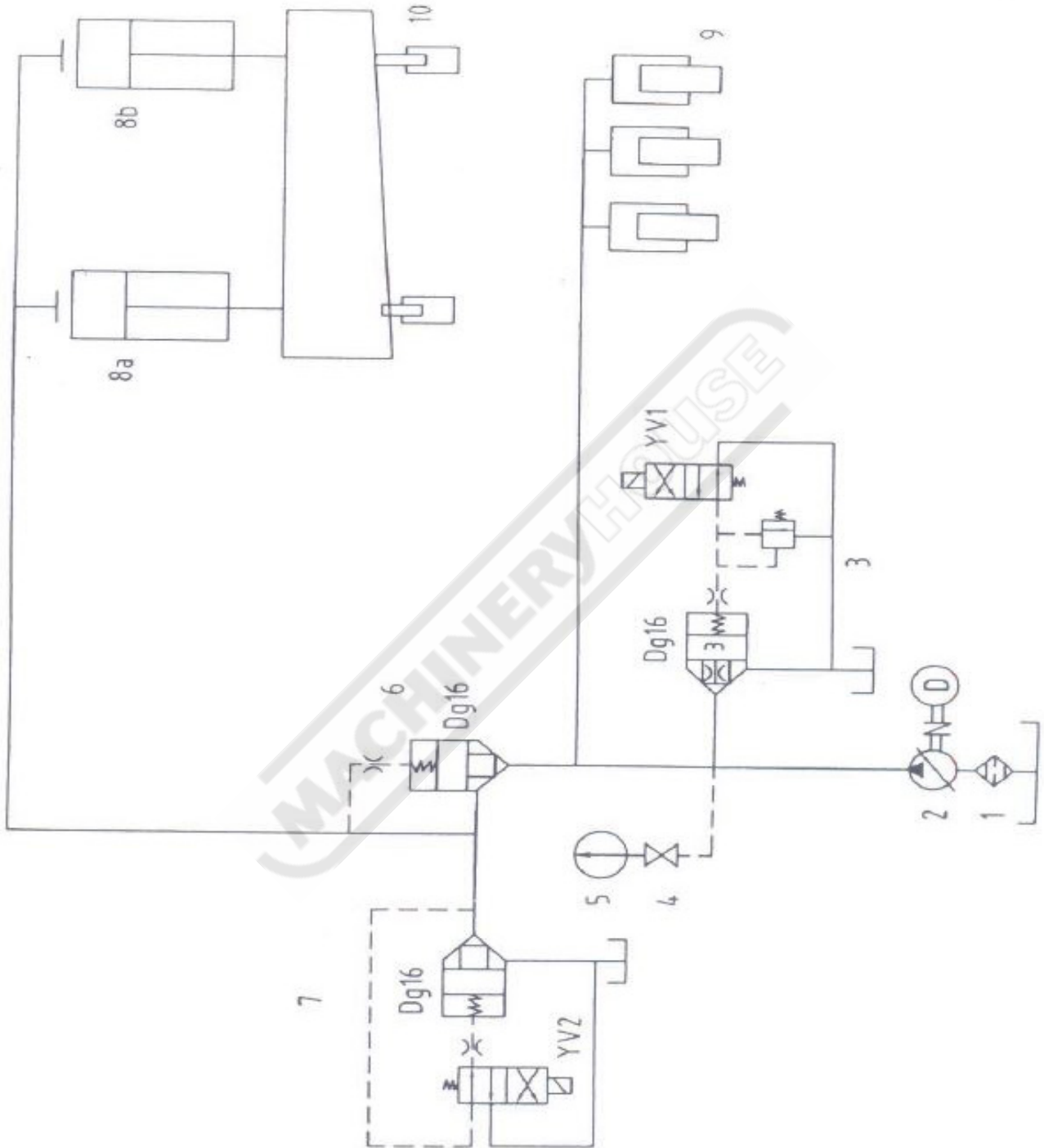


FIG. 6.12

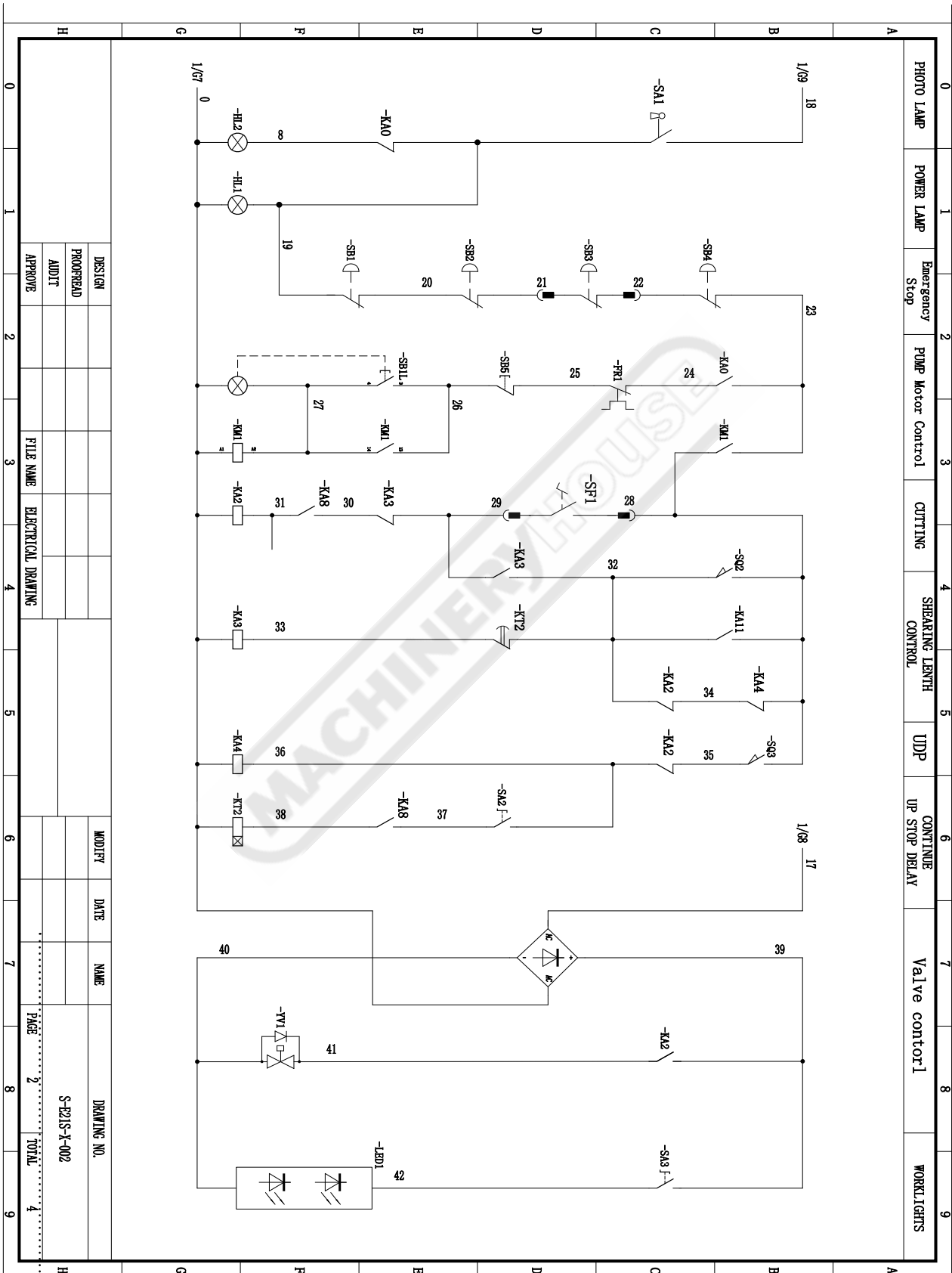
6.8 TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSES	ACTION
Machine shudder on the down stroke.	<ul style="list-style-type: none"> • Incorrect relief valve setting 	<ul style="list-style-type: none"> • Re-adjust relief valve. Adjust the relief valve by unlocking the hexagon head grub screw on the side of the body of the valve. Turn in a clockwise direction closing the valve while cycling the machine.
Machine will not cut.	<ul style="list-style-type: none"> • Low system oil pressure • Check the blades for excessive clearance or damage to the cutting edges 	<ul style="list-style-type: none"> • Check the system pressure. (See page 4) • Check the oil level (See page 17). • Check the blade gap (See page 29). • Reset or regrind the blades as required
Machine will not stop in the neutral position.	<ul style="list-style-type: none"> • Check limit switch /relay • Check directional control valve 	<ul style="list-style-type: none"> • Replace if necessary. • Remove valve, check and replace if necessary
Clamping does not work	<ul style="list-style-type: none"> • No clamping pressure 	<ul style="list-style-type: none"> • Check the system pressure. (See page 4) • Check electrical circuit
Oil leaking from cylinder	<ul style="list-style-type: none"> • Gland seal is damaged 	<ul style="list-style-type: none"> • Change seal
Oil leaking from fittings	<ul style="list-style-type: none"> • Fittings are loose 	<ul style="list-style-type: none"> • Tighten fittings
Back Gauge length does not match Controller	<ul style="list-style-type: none"> • Back Gauge out of calibration • Back Gauge drive belt faulty 	<ul style="list-style-type: none"> • Calibrate back gauge (refer page • Check the tension of the back gauge drive belt (See page 35)
Machine will not start	<ul style="list-style-type: none"> • Rear guarding sensors out of alignment • Emergency stop buttons not released. • Electrical overload protection tripped • Pump lockout key lock switched off 	<ul style="list-style-type: none"> • Align rear sensors (See page 20) • Check emergency stop buttons (See page 25) • Reset overload trip switch • Switch pump key lock "ON"

A. HYDRAULIC CIRCUIT FOR HG-2504E, HG-2506E, HG-3206E, HG-4006E



WIRING DIAGRAM FOR HG-SERIES GUILLOTINES (PAGE 2)



WIRING DIAGRAM FOR HG-SERIES GUILLOTINES (PAGE 4)

