



Temelsan[®]

MAKASHP CUTTING MACHINE USER MANUAL



Congratulation to your new TEMELSAN Cutting Machine MAKASHP

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BASIC INFORMATIONS

This manual user guide is prepared to be useful in order to get familiar with the machine and the functions of the machine. By the help of this manual guide, the operator becomes a capable to use the machine in an optimal way in order to operationalize safely, ergonomically and properly.

This manual user guide allows the operators not to take risk, minimize the idle and repair time. It also helps to increase lifetime of the machine.

This manual user guide should be kept in a proper place and be accessible easily when needed. The local regulations included safety and environmental requirements must be followed in addition to the statements based on this manual user guide.

In case of an issue, complaint, request, demand on spare parts etc. please note the following information along with the below message

Concerning following Object:

Machine Model: TEMELSAN MAKASHP

Mfg. year: 2018

Serial Number: _____

APPROPRIATE USE

The machine is designed to cut the all dimensions of steel and band saw blades.

In the event of using the machine rather than described in which case the machine would be out of warranty situation of Temelsan.

WARRANTY AND LIABILITY

In the event of involving a personal injury or physical damages are not covered by the warranty if the following events occur as below.

- Using the machine for a purpose rather than intended
- Technically, improper installation, start-up operation or maintenance of the machine
- In the act of using the machine while any of safety equipment is a broken or protective device inappropriately running.
- Making constructional changes on running parameters.
- Insufficient control of abrasion parts
- Inappropriate repairs
- The catastrophic failures due to the action of foreign objects / Bodies and excessive force applied

SAFETY

Below safety requirements must be applied without skipping anything and priority case to carry out.

QUALIFIED PERSONNEL

Certain tasks must be carried out on the machine by a professional qualified personnel. Not third parties neither the children should be near the machine working area.

PLANNING AND SET-UP

Planning, transportation, installation, programming, start-up, maintenance, repairs and other works must be done by qualified personnel. Authorized technician must check it also.

The following matters must be noted:

- Technical data and details concerning the permissible use of the machine and its accessories.
- General and specific local preparation and safety measures.
- Personal usage and the use of general safety equipment must be related the norms.
- Especially listed on this manual guide but specifically not listed in the operating instructions that has been explicitly forbidden. Such as a handicapped to use the machine is such cases it is necessary to contact the manufacturing company.

OPERATIONS

Dangers hidden in disregards of safety regulations.

SAFETY DEVICES

The machine is equipped with the safety devices corresponding to current state of the art. In the matter of safety equipment, the machine may not be disabled, removed, dismantled, damaged. It applies in particular to:

- Finger protection glass

AREAS OF USAGE

The Cutting machine of Temelsan MAKASHP is used for any kind of steel bands and band saw blades or bi-metal or carbide tipped band saw blades.

The cutting capacity for Band Saw Blades is from minimum 6x0.65mm up to a maximum 100 x1.60mm. The machine is capable to cut all kinds of band saw blades which are called carbon, wood, bi-metal, CT Work on the pressured air supply is only to be done by professional mechanic.

The machine need to be assembled on the desk.

The machine can be set-up by the customer's own staff if officially approved by Temelsan.

Please read the following sections thoroughly and carefully before the initial start-up and ensure that you clearly understand it.

MAINTENANCE

In order to insure a safe operation on the machine and prevent accidents, the job listed in the section "Servicing" must be carried out regularly. If the owner of machine is not in a position to do that also must be arranged by an authorized service agent.

ISSUES

The machine must be cut off from air supply at once in case of any problem occurs during the operation and then locked for not being restarted accidentally by an unauthorized person.

The machine must be cut off from air supply in this case.

- Unusual sounds, vibrations, smells

**WARNING!**

Only suitably qualified personnel must service the machine!

ATTENTION!

Note the following at emergent cases (fire, explosions, breakage):

- Switch off the compressed air supply

SAFETY MEASURED RELATED WITH THE MACHINE**WEAR PROTECTIVE GLASSES!**

Welding beads produced during welding work could damage your eyes.

**WEAR GLOVES!**

The sharp edges of the blades can cause hand injuries.

REQUIREMENTS OF WORKING PLACE

- Flat and smooth desk
- Required big enough area around the machine
- Environmental conditions
- The client is obliged to local air distributor notified technical requirements

PRESS-AIR REQUIREMENTS

The machine needs dry and clean air pressure, which needs 6-8 bars. The reservoir capacity of the air compressor should be at least 150 liters.

Air Supply Check

Main Air Supply minimum 6 maximum 8 Bar

The compressor should be adjusted as starting to fill the air by 6 Bar and stop to fill by 8 Bar if Cutting Pressure does not reach the enough capacity, the main air pressure is too low never adjust the main Air pressure over 8 Bar. Factory adjustment is 9,5 Bar The Tube size for Air Pressure supply is minimum 12x10 mm.

FIRST INSTALLATION AND ADJUSTMENTS

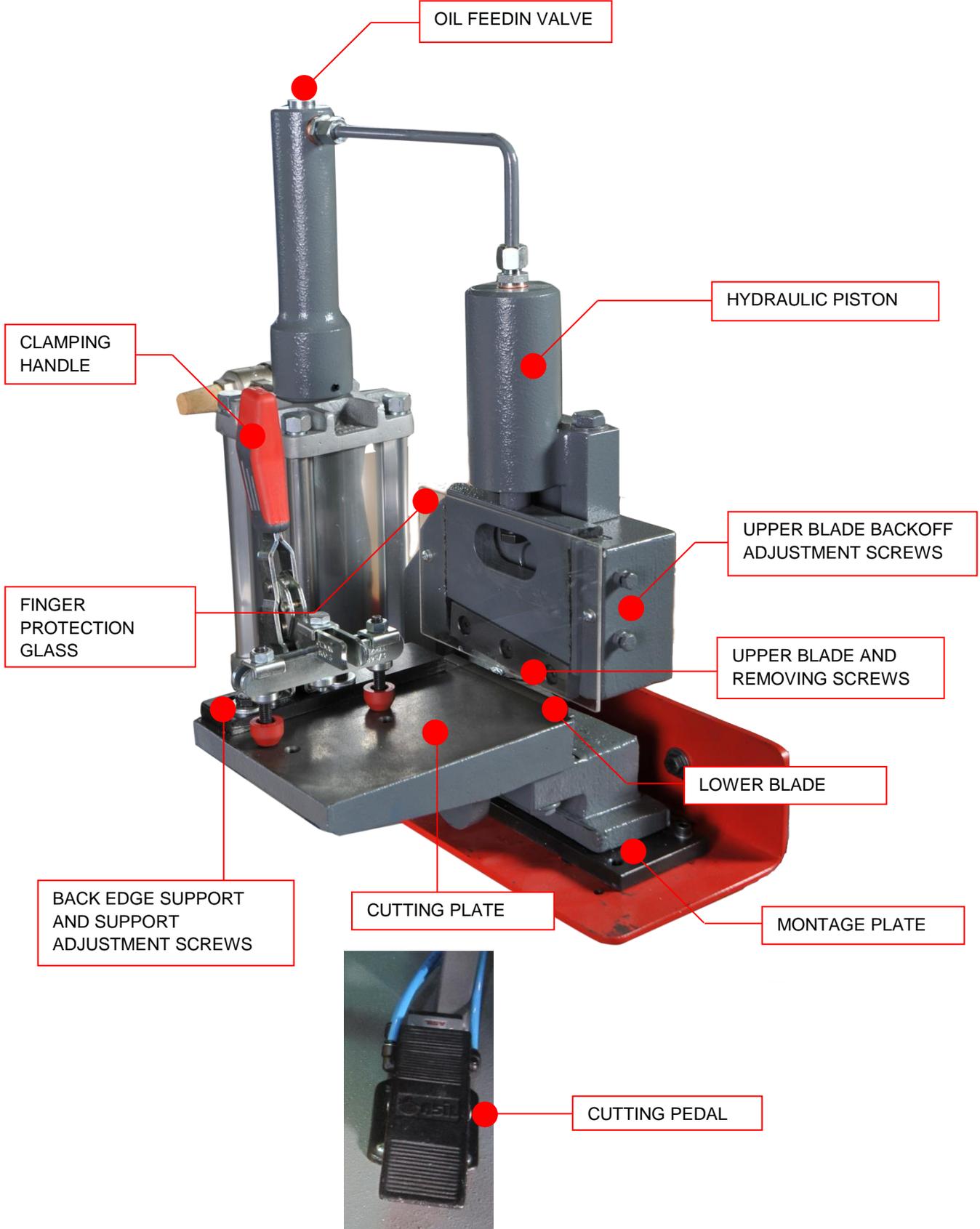
Authorized professionals, who must read this user guide, must do first installation and adjustments. In case of questions, is an immediately contact with manufacturer/supplier required.

ASSEMBLY AND USING THE MACHINE

1. Montage the machine on place that your technical personnel decide
2. Connect the pressured air supply hose
3. Fix the Pedal on floor (recommended)

OPERATION STEPS

- 1- Pull up the “**CLAMPING HANDLE**”
- 2- Push the band saw on place and be sure that back edge of band saw is touching the “**SUPPORT PLATE**”
- 3- Pull down the “**CLAMPING HANDLE**” when you reach the dimension that you want to cut
- 4- Push the “**PEDAL**” to cut the band saw
- 5- Pull up the “**CLAMPING HANDLE**”
- 6- Operation is over

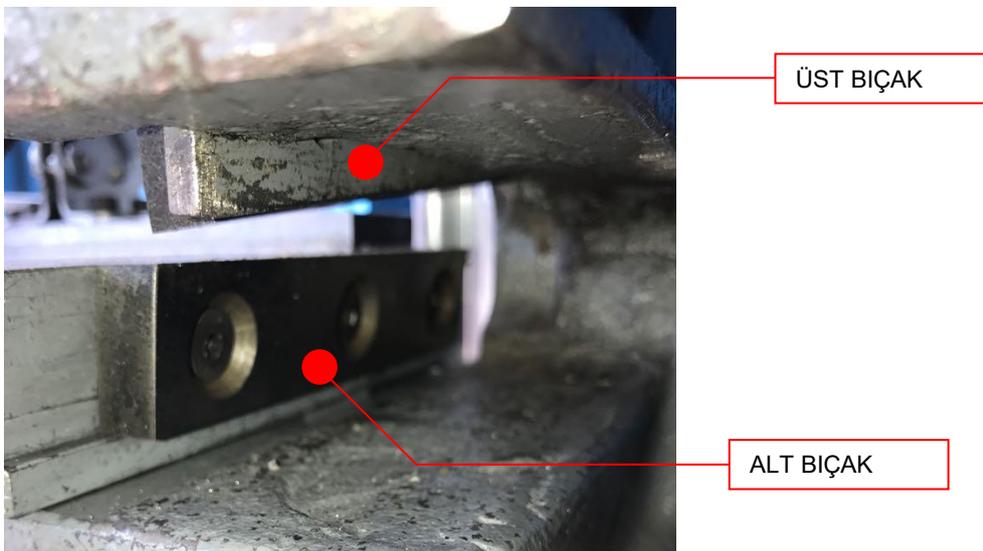
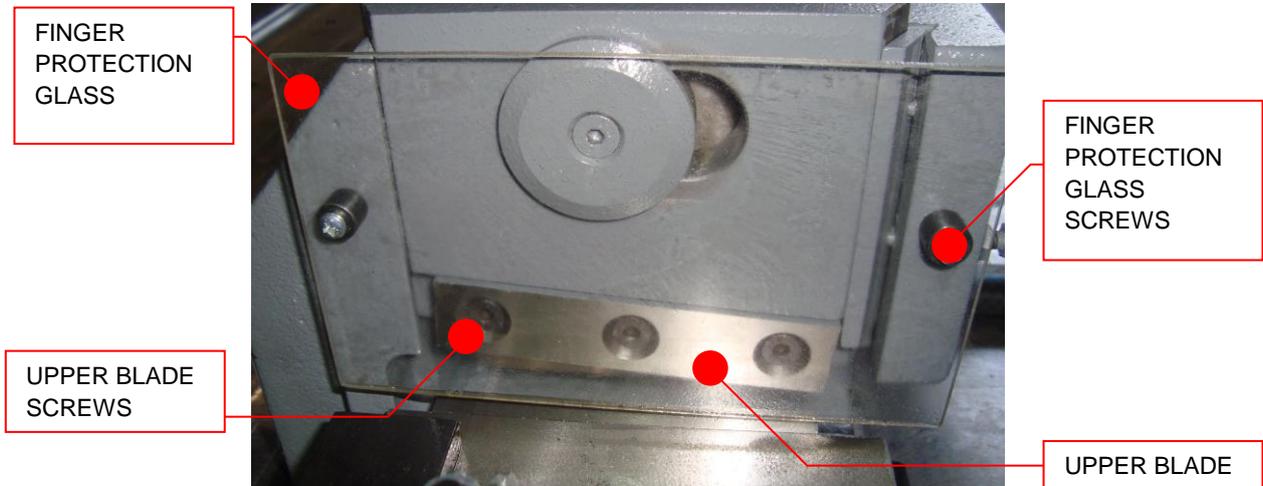
EQUIPMENTS

SERVICE THE CUTTER

The machine has parts that have to be serviced frequently. Please follow the steps when you do service by your own personnel.

1- CHANGING THE BLADE

- Cut off air supply!
- Remove the two screws of Finger Protection Glass
- Take off the protection glass
- Unscrew the three screws of Upper Blade
- Take off the upper blade
- Do same operation for lower blade
- Make grinding on blades and replace it back

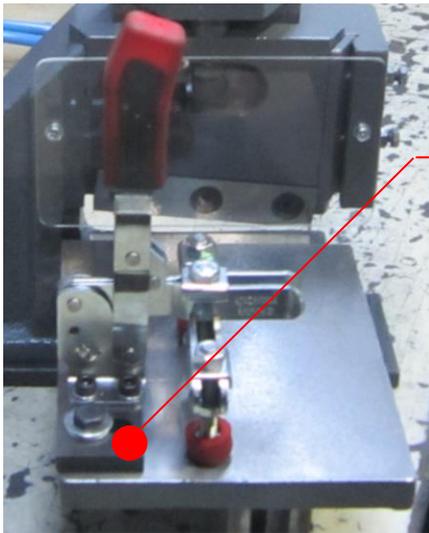


2- ADJUSTMENT OF UPPER BLADE BACK OFF

- In case of blade is not back off easily unscrew a little those screws (Upper Blade BackOff Adjustment Screws) to make it more smooth to slide back off easily.
- In case blade is back off so fast in this case you can't make proper cut. Screw those two screws to make it proper to slide back off

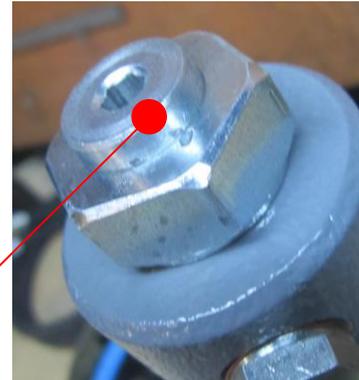
3- ADJUSTMENT OF SUPPORT PLATE

- Use the allen key to unscrew two of screws
- Press the Pedal to close the blade
- Use the mitre to make the support plate to be 90° with Blade face
- Screw it too hard the Support plate do not lose position.



SUPPORT PLATE

OIL CAP



4- OIL FEEDING

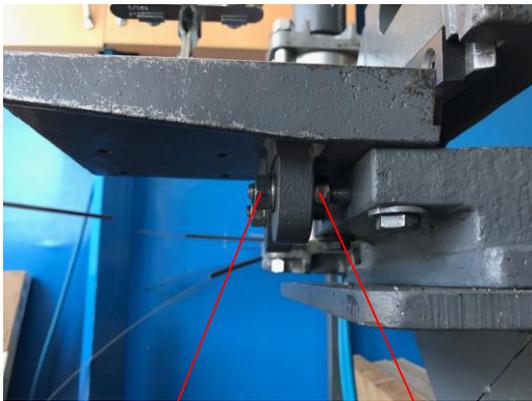
Important to know: if you not see any leaking of oil around the machine you don't need to touch or service the oil level.

- Remove the cap with allen key
- Use the special nipple tool and oil feeder (Nr46 Hidraulic oil)

5- ADJUSTMENT OF CUTTING PLATE

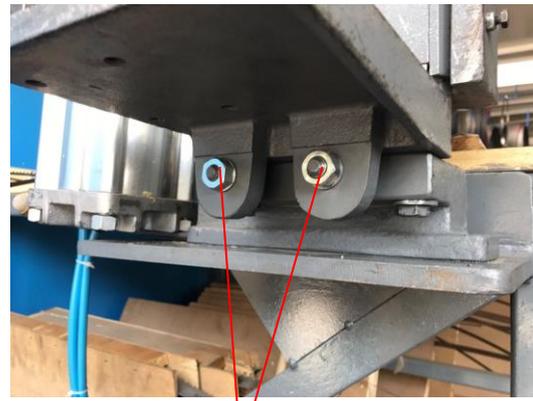
Cutting plate should be checked and adjusted frequently or on each operation of blades.

- Use the keys to unscrew those nuts
- Make cutting plate on exactly position
- Screw first nut nr 1 then block it with nut nr 2
- Try to cut paper to check the proper position of cutting plate
- In case of cutting is not same on each place of cutting table try to find exactly adjustment and screw the nuts.



NUT NR 1

NUT NR 2



CUTTING PLATE
ADJUSTMENT NUTS