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General information

Name and address of manufacturer : NV WERKHUIZEN LANDUYT
Kolvestraat 44
B - 8000 BRUGGE
BELGIUM



The model has been examined by the following organisation :
L'INSTITUT NATIONAL DE RECHERCHE ET DE SECURITE I.N.R.S.
Avenue de Bourgogne - BP 27 - F54501 VANDOEUVRE CEDEX - FRANCE

Description of the machine :
Panelsaw Z3200-Z2500-Z1700

Date of construction of the machine : from 1993 on



Important instructions when ordering spare parts

Always mention the following items on your order :

- Type of machine
- Serial number from manual
- Part number and quantity
- Your reference and correct phone and fax number



Attention

Working with woodworking machines can be extremely dangerous if the safety instructions are not followed.

It is recommended you systematically use the safety equipment installed on the machine.

Safety and maintenance instructions



Woodworking with machinery is a pleasant job that will give you a lot of satisfaction. Nevertheless, working with a machine requires constant attention and care. Therefore, for your own safety, pay attention to the instructions summarised in this chapter.

- The machine can only be used safely if the operator strictly follows the operating and safety instructions.
- It is absolutely essential to read this manual before using the machine so you know how the machine works and what its limitations are.
- Always make sure that all safety devices are fitted to the machine and that the machine is connected to a dust extraction system.
Also provide sufficient space around the machine and good lighting in the workshop.
- When changing the tools or when doing a maintenance job, the machine must always be disconnected from its power supply.
- Knives and tools which are not correctly sharpened or are in bad condition not only diminish the quality of the work, but also increase the risk of accidents.
- Always wear suitable clothing. Loose or torn clothes are very dangerous.
- Keep children away from the machine and the workshop.
- To avoid damaging your hearing we recommend you wear ear protection when working with the machine.

Danger list



This list was based on parts 1 and 2 of EN 292 and annexe A of part 2.

Operating instructions



- The following recommendations for safe working procedures are given as an example, on top of all information characteristic of this machine.
- When working with the machine, safety equipment must be used.
- Nevertheless, the user must also follow the operating instructions to avoid accidents.

1. Training of machine users

It is absolutely essential that the panel saw user receives thorough training regarding operating and adjusting the machine.

In particular :

- a) the risks involved in working with the machine;
- b) the operating principles, the correct usage and adjustment of the machine;
- c) the correct choice of the tools for each operation;
- d) the safe handling of parts to be processed;
- e) the position of the hands in relation to the sawblade;
- f) storing the workpieces safely before and after sawing them.

2. Stability

In order to be able to use the machine safely, it is essential to place it stably on the ground or other stable surface.



3. Adjustment and installation

- a) Disconnect the machine from the power supply before every adjustment.
 - b) The recommendations of the manufacturer must be followed when adjusting and installing the tools.
 - c) The tools must be suited to the material being cut to assure safe and efficient sawing.
- The tools must be correctly sharpened and installed.

4. Handling of tools

In order to avoid severe cuts, safety measures must be taken when handling the sawblades.



Normal and prohibited use

The panel saw is designed for the following work and is equipped with protective devices for these processes only.

It is not designed to work materials such as ferrous or non-ferrous metals, work different from that stated below is prohibited.

- Ripping with the parallel saw fence with/without the sawblade tilted and the fence upright or in the low position.
- Right-angled or mitre cuts with the 90° fence mounted to the sliding table with tilted or vertical sawblade.
- Cross-cutting workpieces using the adjustable stop on the 90° fence.
- Cutting panels or solid wood on the sliding table.

Prohibited use

Following tasks are prohibited on the panel saw :

- submerged cuts by removing the riving knife and/or guard;
- all types of cuts without using the table saw fence, the 90° fence or sliding table;
- Cutting large workpieces that exceed the machine capacity without using aids such as roller supports.

Remaining risks

Main risks on the panel saw are :

- unintentional contact of the hand with the running sawblade;
- workpiece kickback
- tipping of the workpiece due to insufficient support.

Noise reduction

- The type and condition of the sawblade is important in keeping the noise level as low as possible.
- The material and the position of the safety devices are important in reducing the noise level.
- Using the correct speed of the sawblade for the type of material will reduce the noise level as well.
- The above does not negate the fact that extra safety equipment such as ear protection must be used.

Explanation of acoustic levels



The values given are the emission levels; these are not necessarily the levels at which the operator can work safely.

Although there is a link between the emission values and the exposition level, it cannot be used in a reliable way to determine if supplementary measures should be taken.

Noise information

- measurements : as per ISO norm 7960
- as per annexe D

Workpost under load	Level continuous acoustic pressure as per index A dB (A)	Level acoustic power dB (A) (MW)	Max. value account. pressure as per index C (instantaneous) dB
Saw	91	105 (26,3)	< 130

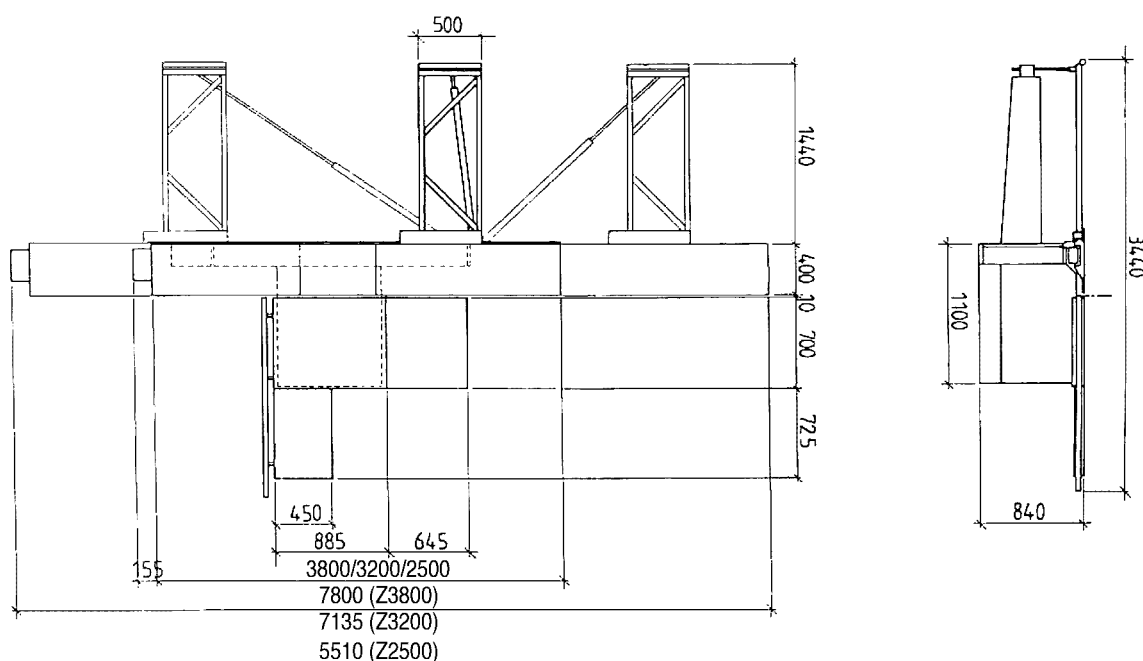
The dust emission examination was carried out by the following approved body :

Prüfinstitut für Holzstaubmessungen
Institut für Werkzeugmaschinen
Universität Stuttgart - Germany

Measurements as per DIN 33 893 (GS-HO-05)

Measurement values show that the TRK-value of 2 mg/m³ has not been exceeded.

Notification number and date : 08.03.1996/FPH-AZ : 029/95





Technical Data

Voltage	V	220 - 380 - 220 mono
Motors three phase	KW	4-5,5, Option 7,5
Saw diameter min.-max.	mm	300-400
Max. depth of cut (dia. 400 min)	mm	125
Max depth of cut at 45°	mm	100
Tilting of main saw		90° - 45°
Max. cut capacity on right side	mm	1380
Saw stroke	mm	3200-2500-1700
Saw arbor diameter	mm	30
RPM main sawblade		3000-4000-5000
Motor power scorer	KW	0,5
RPM sawblade scorer		7000
Scorer diameter	mm	120
Max depth of cut incisor	mm	4,5
Tilting of scorer		90° - 45°
Sliding table dimensions	mm	3200-2500-1700x400
Saw table dimensions	mm	1530x700
Diameter outlet	mm	120 - 60
Net weight	Kg	1150-1050-1000
Gross weight	Kg	1200-1100-1050
Packing dimensions (LxWxH) Z3200	mm	2270x1330x1020 + 3250x450x200
Packing dimensions (LxWxH) Z2500	mm	2270x1330x1020
Packing dimensions (LxWxH) Z1700	mm	2270x1330x1020

Transportation of the machine (fig.1+2)



You will receive the machine in a crate made of heavy duty particle board panels, which can be easily recycled.

After removing the sides and top panels of the crate, steel bars or rods can be placed in the 3 holes in the machine frame (1).

By using hoist equipment the machine can now be lifted with a small crane or forklift truck, but severe jolts must be avoided.

When the machine is placed on the ground, it is still possible to move it by removing the front cover plate and placing a hand pallet truck in the two openings in the front of the frame (2). The machine must be leveled in both directions to assure good sliding motion of the sliding table.

Two leveling bolts must be put in before the machine is placed on the floor : one bolt under the pivot of the telescopic arm and the second under the electrical switch panel.

These bolts have to be set with the bolt head upside down. The two big leveling bolts (2) can be reached by opening the machine access door. If possible, the machine must be placed on rubber plates which act as shock absorbers and reduce the noise level.

Electrical connection (fig.3+4)



The electrical connection must be carried out by a qualified electrician who is able to calculate exactly the required wire cross-section and capacity of the workshop fuses.

Check that the mains voltage of the machine corresponds with the voltage supply to your workshop.

Now open the electrical switch panel and introduce the cable. Connect the 3 phases to the terminals on the connection block marked L1, L2, L3. If there is a neutral conductor (blue) it must be connected to the terminal N.

Connect the earth wire (green-yellow) to the terminal marked with the earth symbol PE.

Attention :

- Check first if the saw spindle runs freely and if all safety devices are fitted before starting the machine.
- If the direction of rotation of the sawblade is not correct, the wires L1 and L2 must be exchanged (clockwise direction of the spindle is correct).
- For safety reasons this must only be done without the sawblade on the spindle !

Thermal overloads

The machine has overload protections on both saw and scoring motors. Should the motor be shut-off by one of these protectors, it is necessary to wait a few minutes until the overload has cooled down.

Mounting of the sliding table (fig.5)



The position of the sliding table relative to the machine is factory set and needs no further adjustments.

Simply put the table onto the frame with the two lateral adjustment bolts (1) in the two lugs placed at the side of the frame.

These lateral adjustment bolts (1) are also factory set and normally need no adjustment.

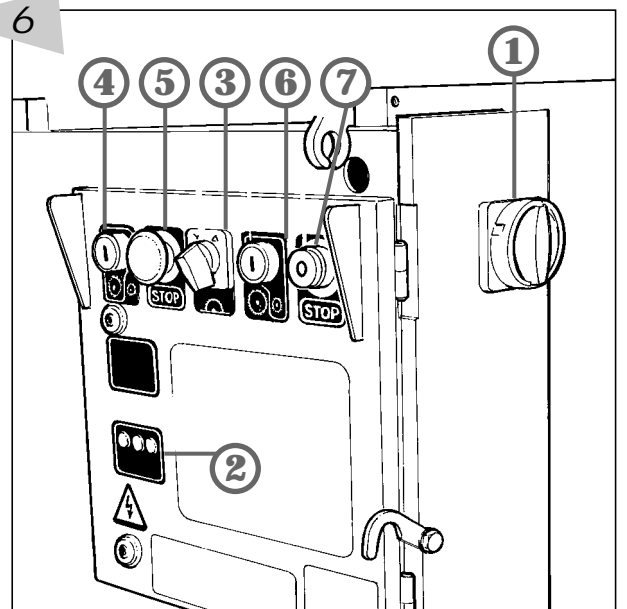
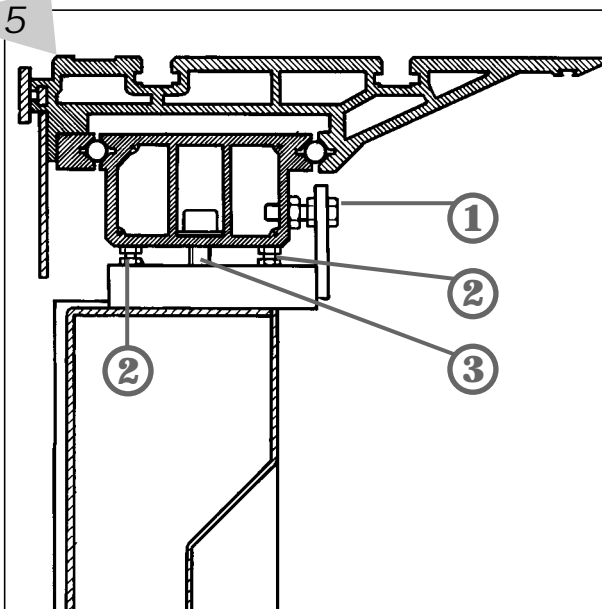
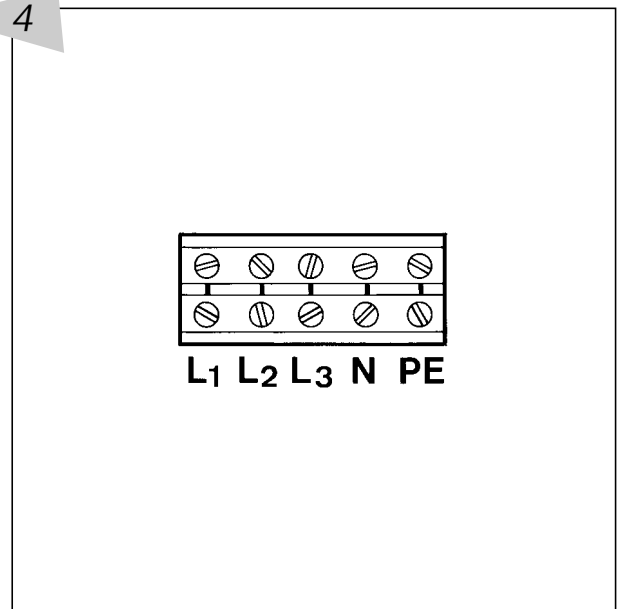
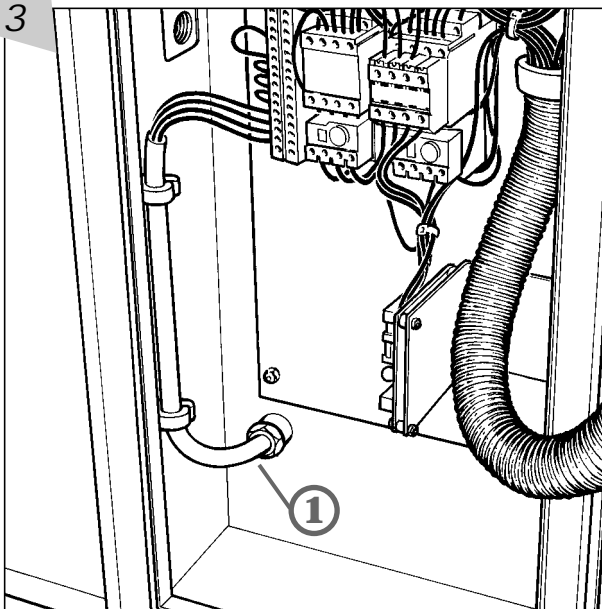
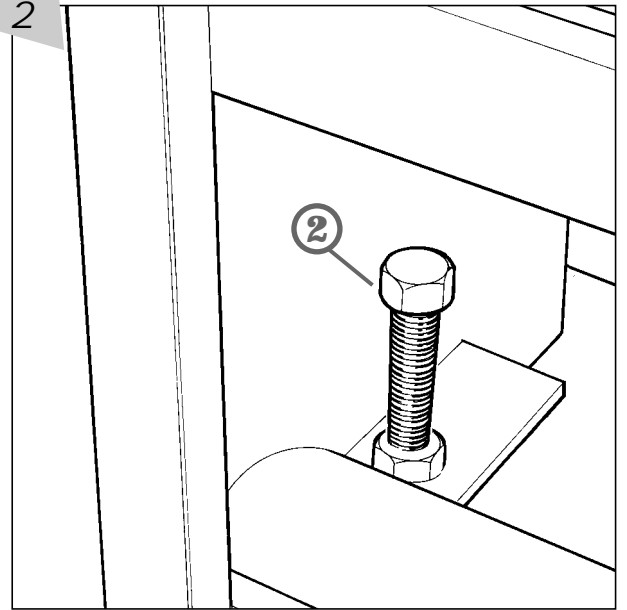
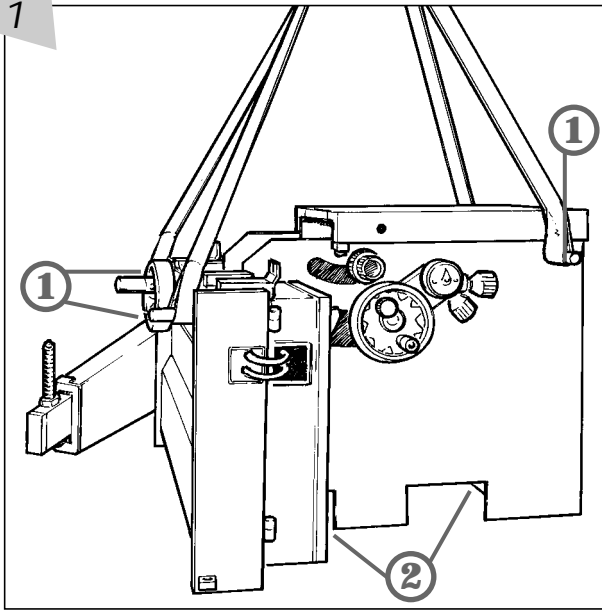
Now place the 4 big Allen bolts (3) into the lower section of the sliding table. Ensure the table from flipping over when sliding away the upper section of the sliding table.

These 4 bolts need to be well tightened.

The 8 small adjustment bolts (2) are height setting bolts set at factory. To ensure a clean and neat cut the sliding table has to be set 100 % parallel to the sawblade.

To correct the parallelism between sliding table and sawblade, unlock the 4 big Allen bolts (3) and adjust with one of the two parallel adjustment bolts (1).

After adjustment tighten the 4 big Allen bolts.



Starting up the machine (fig.6)



Turn the main switch (1) to “1” and ensure that the star-delta switch (3) is put in position “star”.

To start the main saw motor push the start button (4). After about 8 seconds put the star-delta switch (3) in position “delta”.

This time delay is needed to let the motor gain its full speed before switching over to “delta”.

When you forget to switch over from “star” to “delta”, the motor will reach its full speed but will have no power, and will be damaged. The scorer motor is started by pushing the start button (6); this is only possible with the main saw motor running.

By pushing the stop button (7) the scorer motor is stopped, when the emergency stop button (5) is pushed both motors are stopped.

The main saw motor is equipped with an automatic brake which slows down the motor within 10 seconds as soon as the machine is shut off.

Warning :

When the machine access door is open, it is impossible to start up the machine.

The RPM indicator lights at the front of the main switch panel show the speed of the saw spindle as soon as the machine is switched on with the main switch (1).

All fuses can be found inside the electrical switch panel and each time this panel is opened the machine has to be disconnected from its power supply.



Changing main sawblade and scorer sawblade (fig.7+8)

Warning : Before changing sawblades always turn off the main switch.
Handle sawblades with care, to avoid serious cuts and injuries.

Push the sliding table to the rear and open the saw cover. Raise the main sawblade to its highest position and put the key(3) into the saw arbor nut.
Put the locking pin (2) in the opening of the sawtable and turn the arbor with the key (3) until the locking pin (2) engages in the hole in the saw arbor pulley.
Now unlock the nut. Before fitting the new sawblade ensure the blade and flanges are clean. This prevents wobbling of the sawblade.
Never forget, after the saw arbor nut has been tightened, to remove the locking pin from the pulley before starting up the motor.

Attention :

Only sawblade diameters from 250 to 400 mm are allowed on the machine.
The use of HSS sawblades is strictly forbidden on all panelsaws; only use carbide-tipped sawblades.

The scorer sawblade is changed as follows : turn the scorer blade to the left and put the key (1) onto the flatened arbor. Loosen the bolt with the Allen key (2) and put the scorer blade on. After changing the blade tighten the bolt.

Warning :

All main sawblades which are used on the panel saw must have two additional holes in the sawblade body, to prevent the sawblade from loosening when the rotation of the saw arbor is stopped by the brake on the motor.
The two little bolts in the fixed saw arbor flange prevent the saw from coming off and may under no circumstance be removed.
The dimensions of these holes can be seen in fig.9.



Use and adjustment of the riving knife (fig.10)

The machine is equipped with two riving knives for the use of sawblades from 250 to 300 mm and 350 to 400 mm.
The riving knife has to be adjusted in such a way that over its entire length the gap between sawblade and riving knife does not exceed min.3 mm and max.8 mm.
The riving knife can be adjusted in both vertical and horizontal direction.
The height setting has to be adjusted in such a way that the highest point of the riving knife never exceeds more than 3 mm above the highest placed sawblade tooth.
After height adjustment always lock the central bolt (3). The 3 little adjustment screws (2) are used for the exact setting of the riving knife in line with the sawblade.
For slotting or grooving the riving knife has to be adjusted in such a way that the upper part of the riving knife is never set lower than the highest sawtooth in use.
Never remove this riving knife. Kickbacks are severe and very dangerous.

Lower sawblade cover (fig.10 bis)



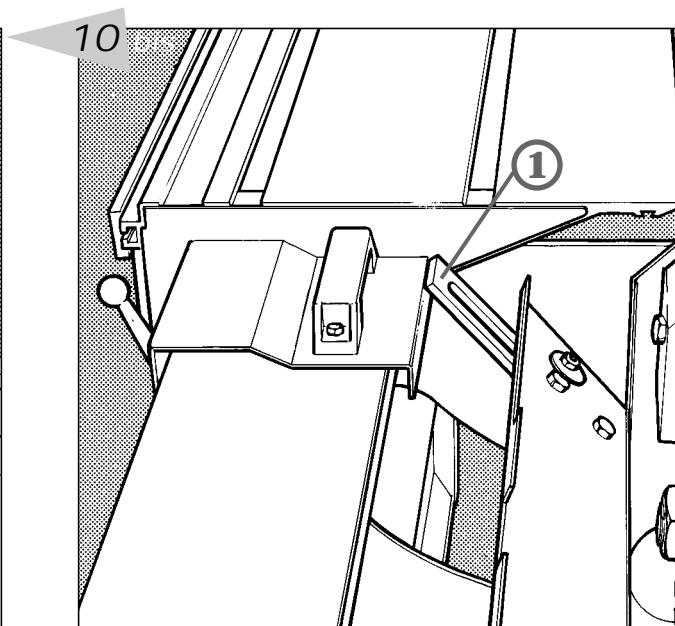
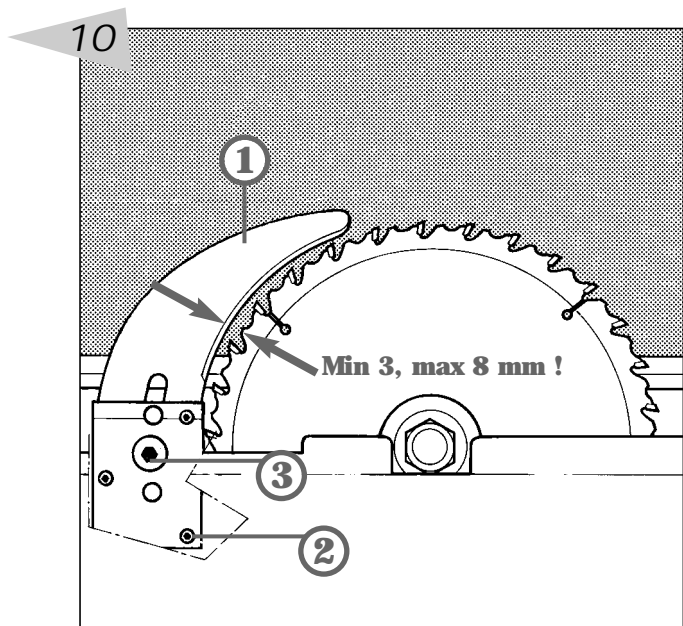
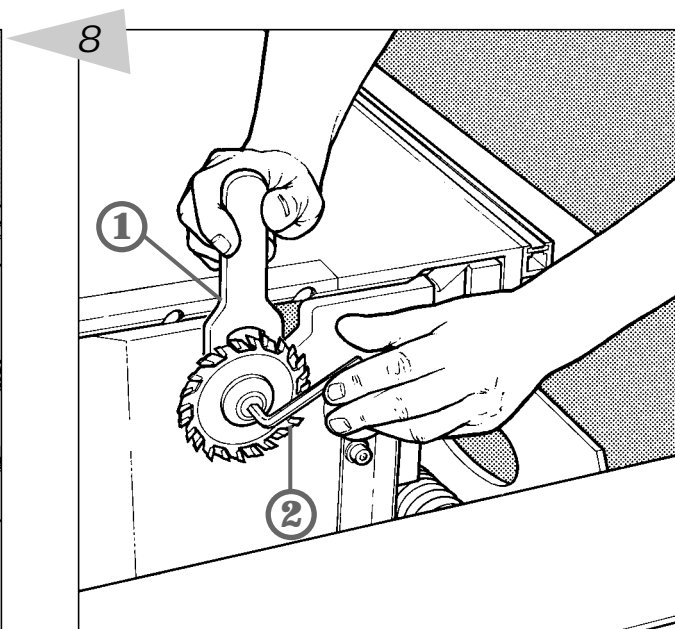
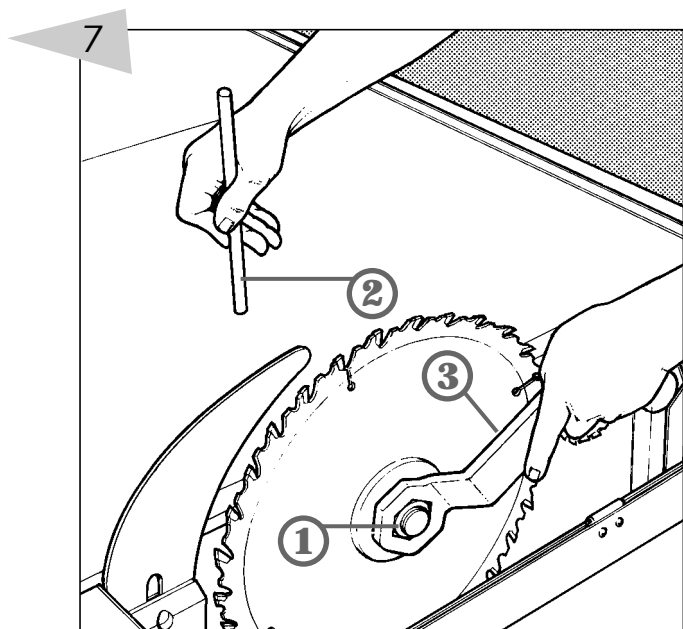
The lower sawblade cover has an extra safety device which will protect the user during sawblade changing.

To open the lower cover the upper part of the sliding table has to be slid to the back.

Now the two locks can be opened at both sides of the cover and the safety lever can be pulled up.

Only now can the sawblade cover be opened and this safety device prevents the table from being pushed to the front, which would result in injuries to the operator's hands.

After closing the lower cover push down the safety lever (1).





Height setting of main sawblade and scorer sawblade (fig.11)

Main sawblade height setting is done by turning the handwheel (1). After the sawblade is set at the desired cutting depth the handwheel has to be locked with the locking knob (2).

One turn of this handwheel equals 5 mm of height setting.

The height setting of the scorer sawblade is done by turning the knob (4), and locked by turning the wheelnut (3). One turn of this height setting knob equals 3 mm.

The maximum cutting depth using a main sawblade diameter of 400 mm is 125 mm and for the scorer 4,5 mm using a sawblade diameter of 100 mm.



Tilting of the sawunit (fig.12)

By turning the handwheel (2) the whole sawunit can be tilted and set at any angle between 90° and 45°. After setting, lock the sawunit in this position using the locking knob (1).

The angle can be read at the large scale (3).

Both 45° and 90° positive stops are factory set and need no adjustment. After setting the sawunit at the desired cutting angle the cutting depth of the scorer must be set again.



Lateral adjustment of the scoring blade (fig.13+14)

Each time the main sawblade is replaced by a new one, or even a newly sharpened sawblade, the scorer has to be adjusted to match the main sawblade teeth width. It is very important that this is done in the correct way to ensure a clean cut, free of splintering.

The use of two piece scoring saws is best because they can easily be adjusted using spacer rings.

The lateral movement of the scorer sawblade is achieved by turning the knob (fig. 11,5) and the locked using the knob (fig. 11,6).

After the lateral adjustment is done the scale (fig. 11,7) has to be set at "0".

Figures 13 and 14 show the different possibilities :

- 1) Without the use of a scorer saw
- 2) Correct setting of the scorer saw but too deep
- 3) Too much to the right side
- 4) Correct setting of the scorer saw.



Operating the sliding table (fig.15+16)

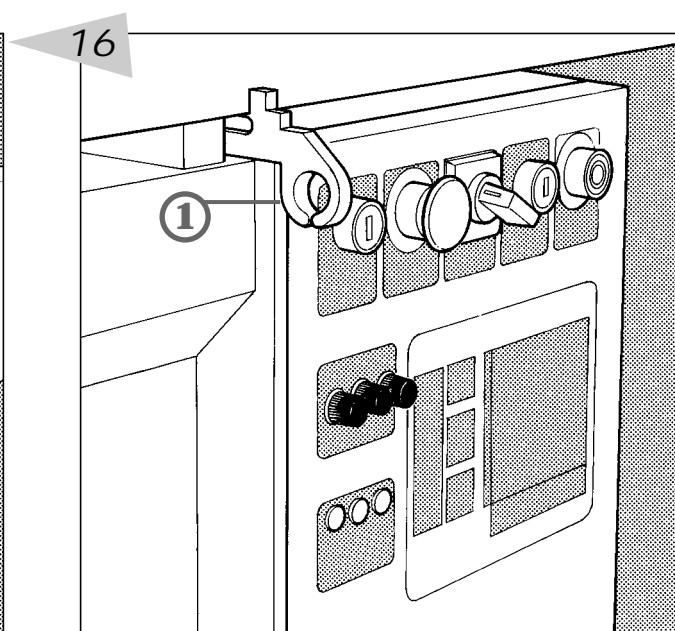
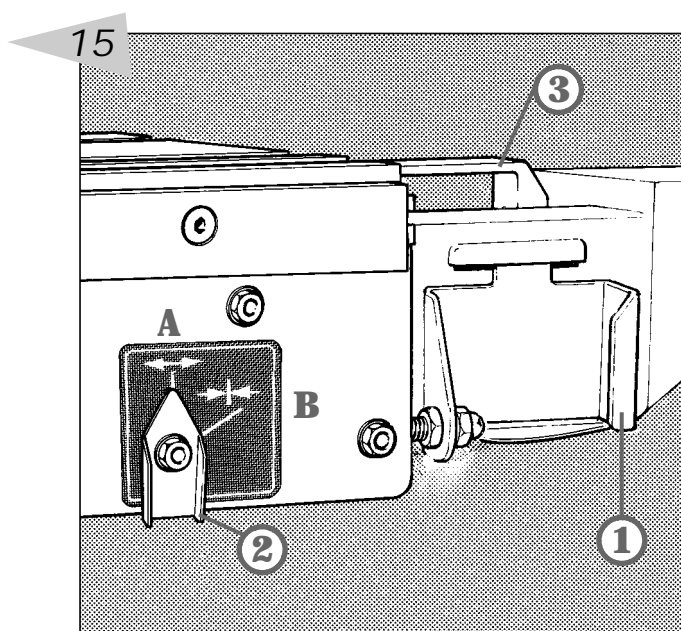
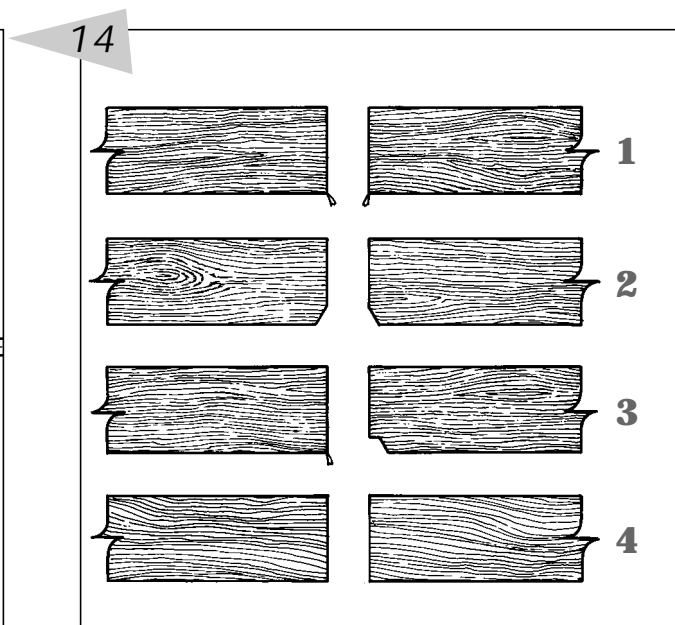
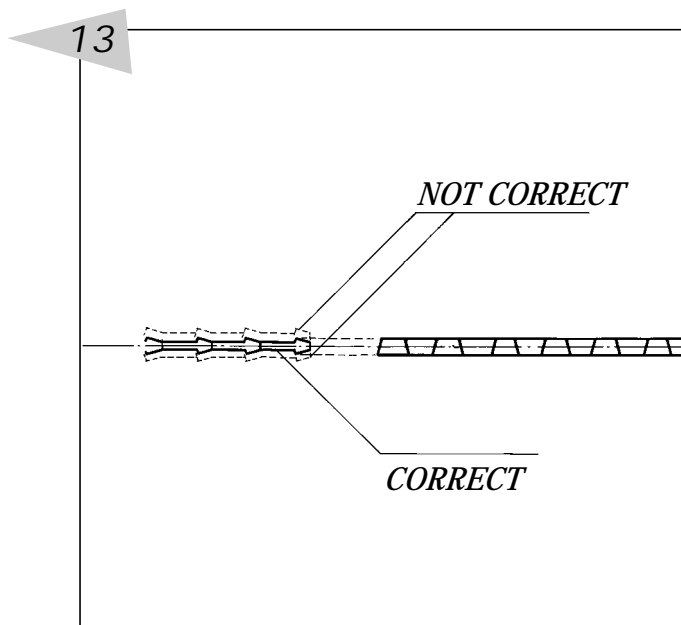
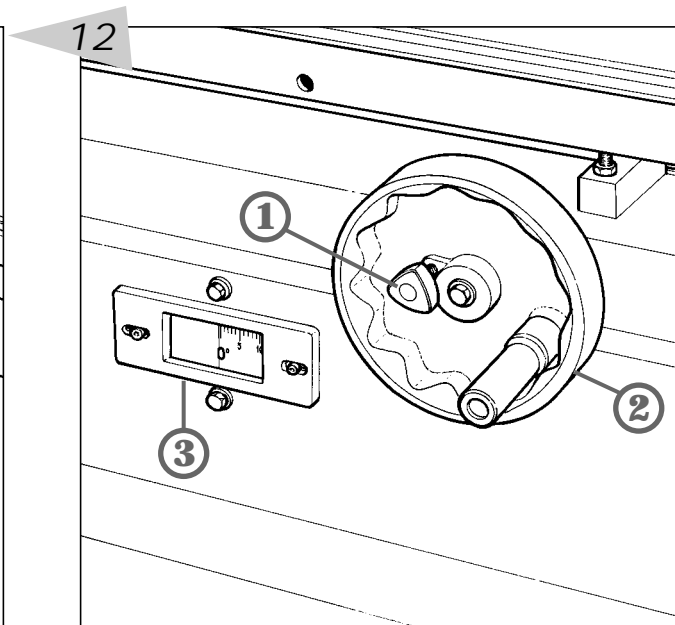
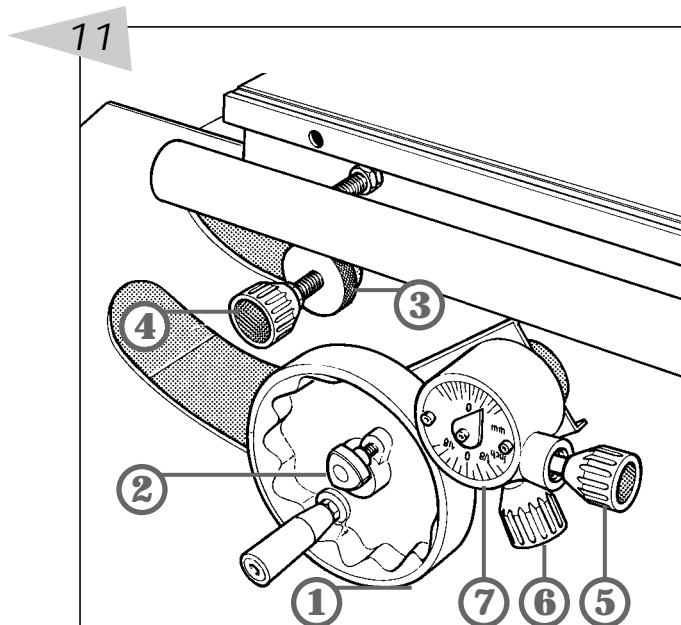
When loading panels and when cutting using the parallel fence the sliding table should be locked. There are two different systems to achieve this. The first system is used when loading the panel onto the sliding table to prevent the table from sliding away from the operator.

To lock the table in the front position put the arrow (2) on "B". When the sliding table is pulled to the front it will automatically be locked in this position.

Unlock the table : pull handle (3) and put arrow (2) on "A".

The second system is for cutting with the parallel fence. Simply pull the bolt (fig.16,1) and engage it in one of the tree slots along the side of the sliding table.

The movement of the sliding table is halted by 4 rubber buffers at both ends of the sliding table. If over a long period of time many short movements of the sliding table are made by e.g. cross-cutting solid wood, then it is possible that the ball carrier between the upper and lower part of the sliding table will move. This means it will be no longer correctly positioned to allow the sliding table to slide through its full course.





The operator will feel resistance in the sliding table motion and the full stroke will not be achieved. This effect can be corrected simply by pushing the table with a few short, light pushes against the buffer stop at the end, until the position of the ball carrier is adjusted and the table can be moved again along its full stroke.



Maintenance and lubrication of the sliding table

It is highly recommended to clean the sliding table once a week, and to remove all sawdust and chips which gradually slow down the sliding table. From both sides of the sliding table blow out the dust which has accumulated between the two sections and on the ball carrier.

This can be done more easily and efficiently when the upper part of the sliding table is slid to the rear, and must then be repeated with the upper part at the front end.

After all dust has been blown out, a thin oil with a teflon base or plain diesel oil should be sprayed onto the steel V-liner strips on both the upper and lower part of the sliding table. Never use a thick oil or grease ! This maintenance job will only take 10 minutes of your time, and will ensure the machine gives full satisfaction.



Mounting of the cross-cut table (fig.17)

The cross-cut table can be slid from the back to the center of the sliding table via the flat bar on the side of the sliding table.

The 2 brackets (2) should be positioned to allow the cross-cut table to be easily moved along the sliding table. The table must be locked in position using handle (1).

Please note that the machine is constructed so that the cross-cut table can be moved to the middle of the sliding table only.

The telescopic arm support is too short to allow the cross-cut table to be set at the front of the sliding table. Both telescopic arm and cross-cut table are factory set and need no adjustment.



Mounting of the 90° cross-cut fence (fig.18)

The cross-cut table has 4 precision holes allowing the fence to be put in 2 positions : at the back and front of the cross-cut table. Simply put the fence onto the cross-cut table and lock it in position using the two serrated nuts (1).

The 90° right angle of the fence is factory set. Should the 90° angle need to be adjusted, then the two bolts (2) must be loosened; then by turning the little bolt (1), the angle can be opened or closed towards the sawblade. After adjustment the bolts (2) have to be retightened.



Calibration of the scale on the cross-cut fence (fig.19+20)

Each time a new sawblade is put onto the machine the scales have to be calibrated.

Put the first repetition stop (1) at a certain measure and cut off a sample.

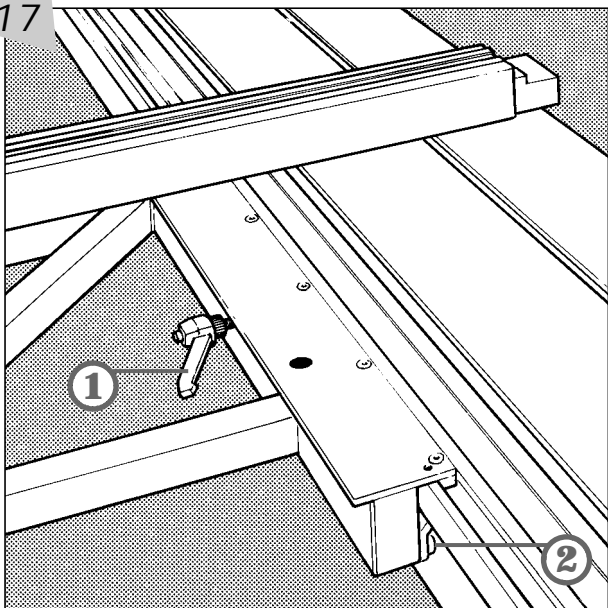
Measure the exact length of the sample, unlock the screw which holds the scale and move the scale until the exact length corresponds with the index on the repetition stop.

Now the scale on the telescopic part of the fence (fig.20,2) has to be adjusted to the first scale.

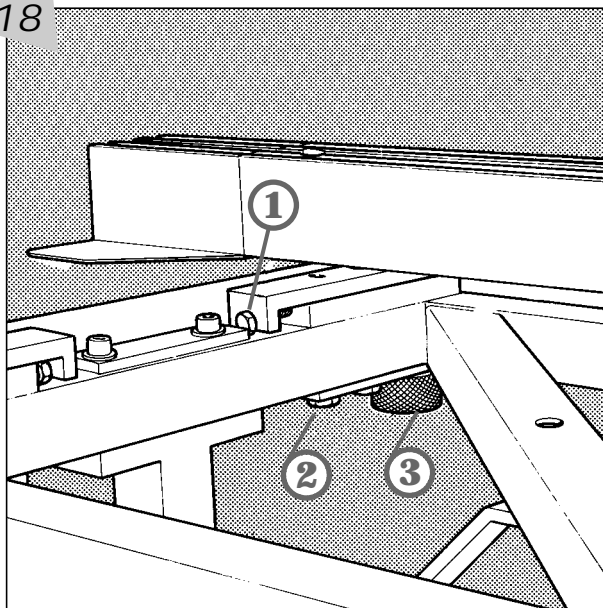
When using the telescopic extension, the second repetition stop (3) has to be set at 1925 mm to make the different scales correspond with one another. The best way to check if all scales correspond is to make several test cuts on the different scales.

When, after some time, the wooden protection cap at the front on the cross-cut fence is cut away, a new one has to be made according diagram fig.21.

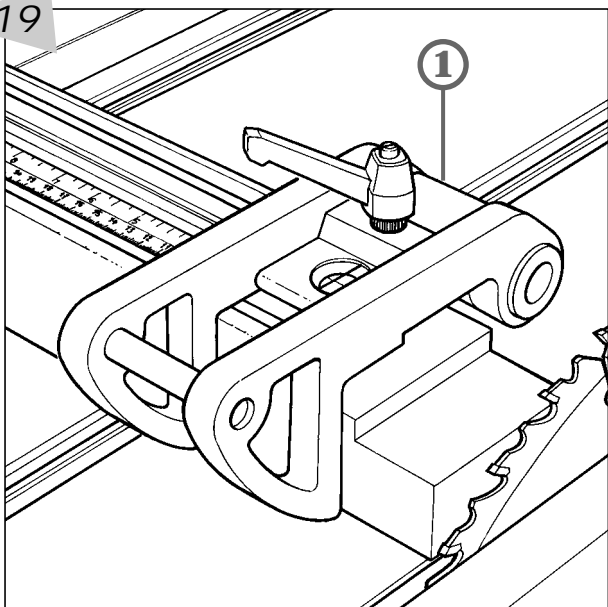
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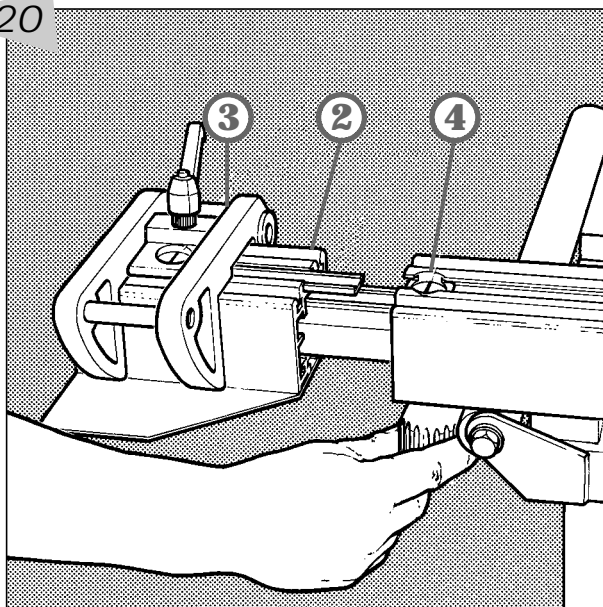
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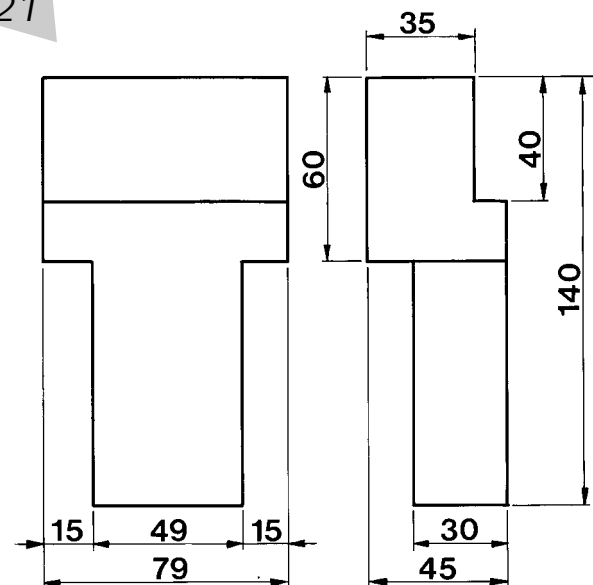
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20



21





Mitre fence (fig.22)

The flat T-nut which holds the vertical rod of the wood clamp is factory set and has to stay in its position to make the angle scale correspond.

To set the required angle : unlock the rod (1) and the auto-release handle (2). To slide the fence (5) towards the sawblade, unlock the two handles (3). Reading the angle set is done at the back of the aluminum bracket (4).



Use of the parallel fence (fig.23)

When the serrated knob (3) is unlocked and the handle (1) is lifted up, the complete parallel fence can be moved.

To lock the fence in position push the handle (1) down.

The micrometric adjustment is achieved by locking the knob (3), by holding the handle (1) in the upright position and by turning the serrated knob (2).

After the adjustment push handle (1) down to lock the fence in place. When cutting small workpieces with the sawunit inclined at 45°, the fence should be used in the low position.

Simply unlock the eccentric clamping handle (4), slide off the fence and slide it back on in the low position.

Lock the fence with the eccentric clamping handle (4).

When cutting solid wood using the parallel fence, to avoid the wood getting stuck between the fence and the riving knife (resulting in a highly dangerous kickback) it is recommended to reposition the fence so that its end protrudes just past the end of the riving knife.



Calibration of the scale on the parallel fence (fig.24)

Each time a new sawblade is fitted the parallel fence scale has to be calibrated to the new sawblade.

By cutting a sample and measuring its exact length, the scale can be adjusted so that the exact measure corresponds with the front side of the fence.

After the screw (1) has been loosened the scale can be adjusted. To avoid the fence contacting the sawblade while it is revolving, the stop ring (2) has to be adjusted.

Slide the fence to about 10 mm from the sawblade.

Now slide the stopring (2) across the round guide bar (3) until it comes up against the casting of the fence. Tighten the lock screw on the stop ring.

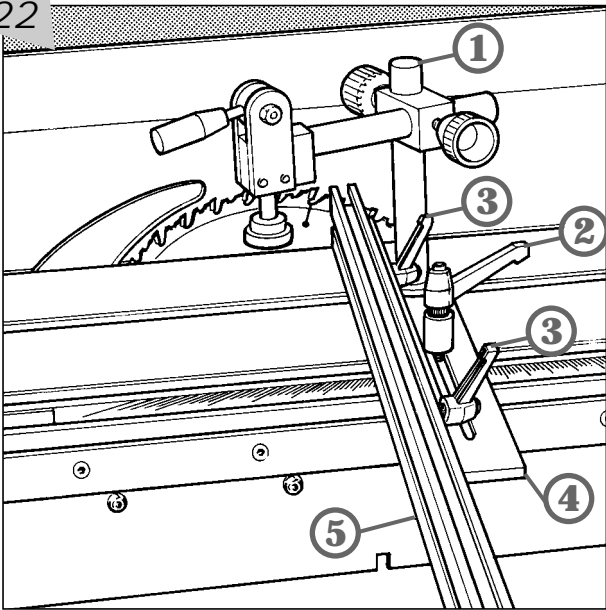


Mounting of the roller support (fig.25)

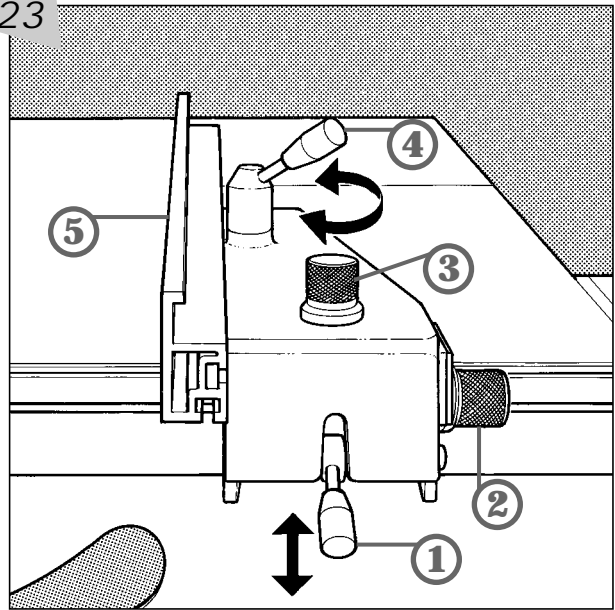
Put the hinge plate (1) of the roller support onto the frame using the bolts (2). The roller has to be adjusted to the height of the saw table using the lower stopring.

The whole support can be lowered and can be swung aside after opening the knob (4). If the roller support has to be taken off, simply lift it off its hinges.

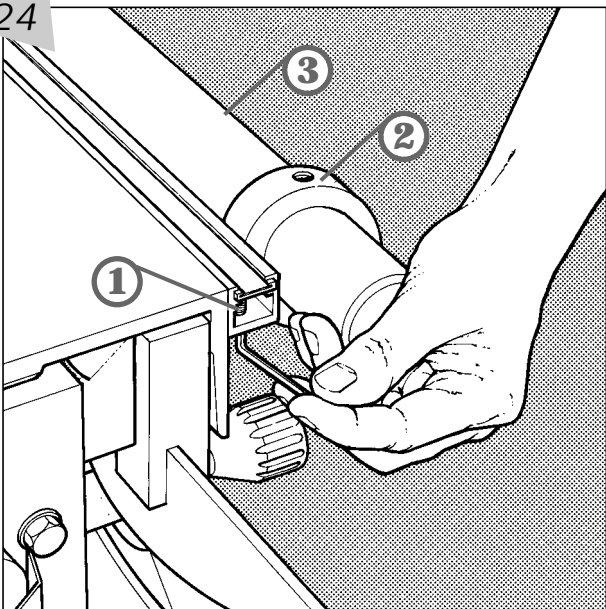
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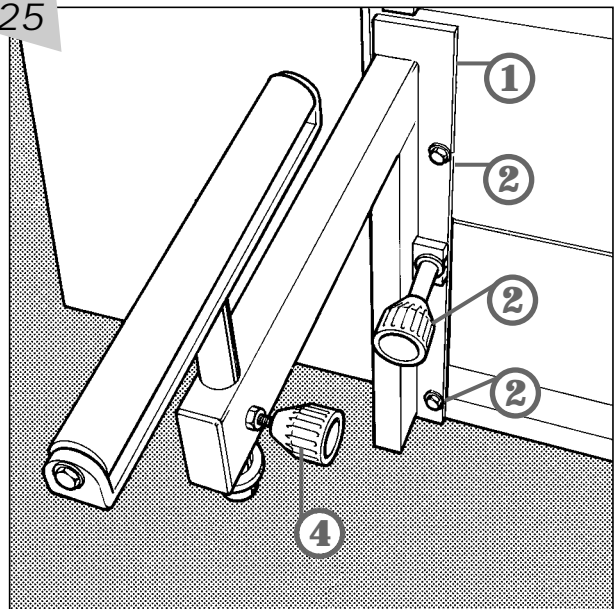
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25





Overhead sawguard (fig.26+27)

For safety and health reasons it is highly recommended to connect the machine and the saw guard to a dust extractor system.

Both outlets on the machine (dia.120 mm) and on the saw guard (dia.60 mm) need to be connected, and the dust extractor should be powerful enough to obtain an airflow of at least 20 m/sec., measured at the outlet on the machine.

The guard has to be adjusted in such a way that both main and scoring sawblade are covered, and should be adjusted in height so that the workpiece can slide under the guard.

Height setting is achieved with the handle (1).

Relative to the sawblade diameter in use the guard has to be limited in height using the diameter indicator (2).

To adjust the guard to the diameter of the sawblade push the guard down to the table and then set the indicator (2) according to the diameter of the saw in use.

The narrow saw guard (A) is for cuts at 90°. All other cuts are made with the wide extension saw guard (B). To change the extension or sideplate, unlock handle (fig.27,4) and remove the side plate. Keep the plexiglass window (1) clean to ensure good visibility and optimal safety. When damaged replace this part as soon as possible (partnr. Z326).



RPM indicator lights (fig.28)

After the machine has been switched on by the main switch, the indicator lights at the front electrical panel show the speed of the saw arbor. When changing speed always take care that the indicator detector (1) is placed in the correct position, to avoid the belt rubbing against the detector, leading to a premature wear of the belt.

This can be felt and seen.

The machine has 3 RPMs : 3000 - 4000 - 5000.



Belt tension and speed changing (fig.29+30)

Main sawbelt :

Always choose the speed accordingly the sawblade diameter and never exceed the maximum allowed cutting speed for carbide tipped sawblades of 100 m/sec.

This is a very important safety rule.

To loosen the belt, pull and turn handle (1) to the left. When the belt has been changed or put in another groove of the pulleys and the indicator detector (2) has been checked for its correct position, the belt has to be tensioned. Pull and turn the handle (1) to the right and engage it into the serrated span sector. (3)

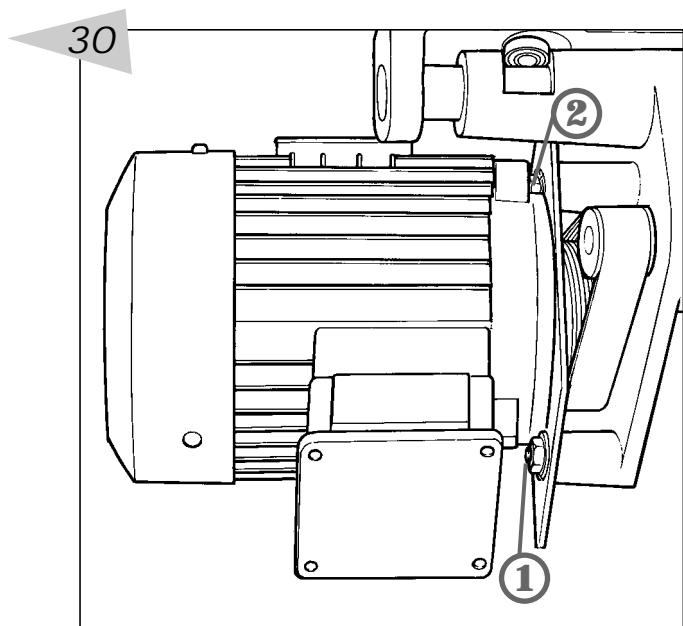
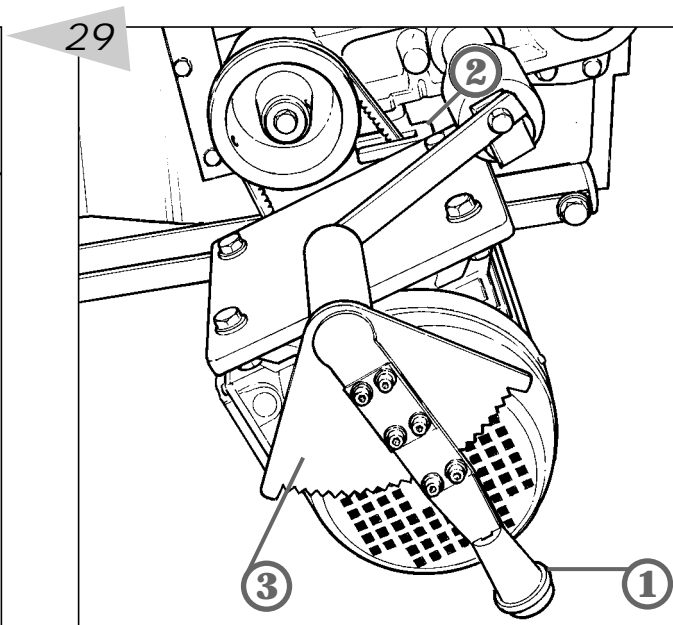
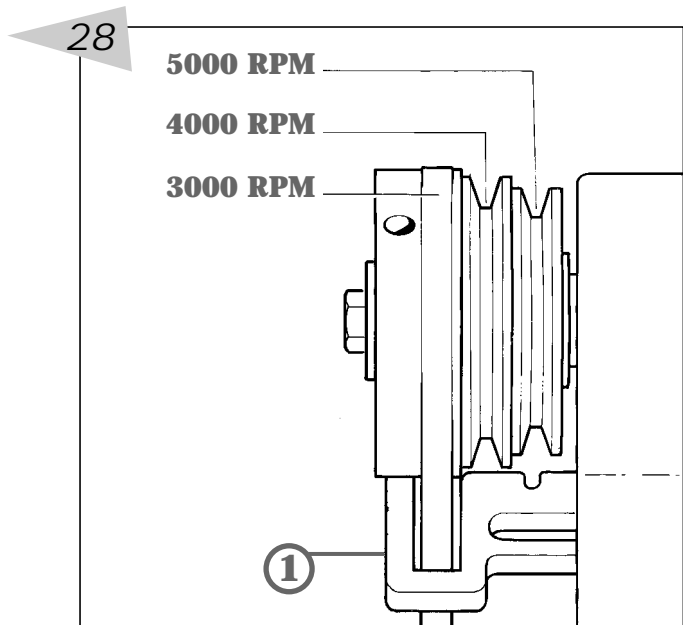
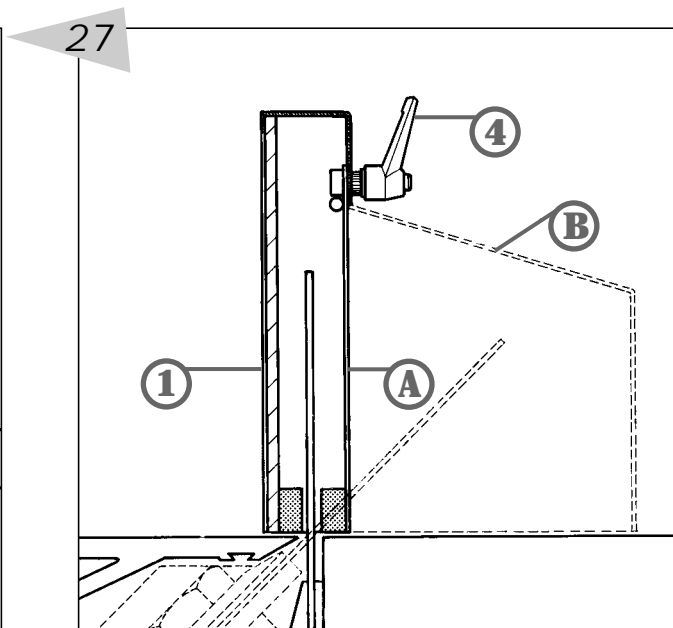
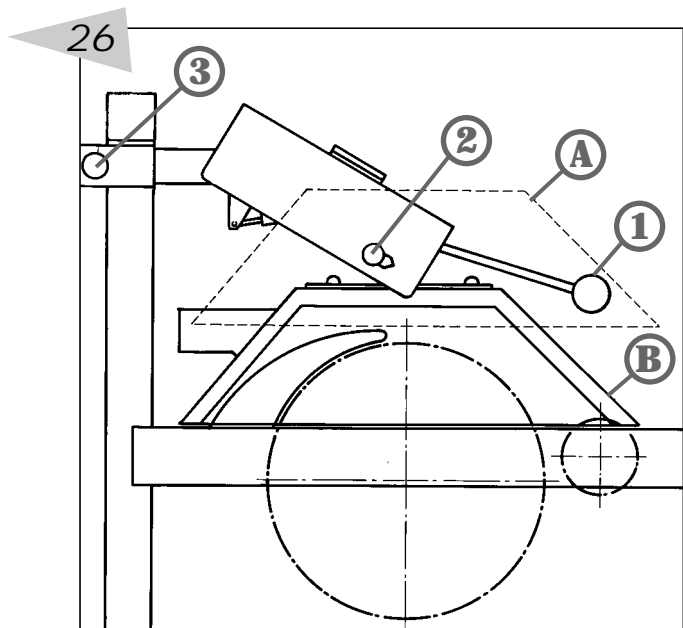
Make sure the belt is not overtensioned, because this leads to damage of the saw arbor and belt.

Check regularly the condition of the belt and, if necessary, replace it (partnr. N8207 : XPA 800 Quadpower).

Scoring sawbelt :

To tension the scoring sawbelt loosen the two nuts (1-2) which hold the motor, push the motor down, tighten the two nuts while holding the motor down.

To change the belt remove the motor completely. When the belt is replaced, but before tensioning it, ensure that it is correctly seated into the grooves of both pulleys.





Maintenance of the machine

The interior and exterior of the machine have to be cleaned regularly to avoid an accumulation of dust and woodchips.

Any deposition of resin on the sliding table and other surfaces has to be removed.

Never smoke while cleaning the machine, and especially when using petrol, kerosene or other inflammable products. This could lead to an explosion and serious burns for the operator.

All moving parts have to be kept clean and have to be lubricated with a little very thin oil, diesel or penetrating oil.

All bearings in the machine are double sealed and need no lubrication. The use of a dust extraction system will most certainly extend the life of your machine.

The lifetime of the motors can be extended by blowing out sawdust from the cooling fan and motor itself.

In particular the sliding table needs care and attention : see chapter "operating the sliding table".



Problems : causes and solutions

1. The machine does not start when the start button is activated :

- access door is still open : close the door correctly
- main fuse is switched off : power cut, power shortage or motor overload
- star-delta switch in wrong position : put switch on "star"
- main switch off : put switch on "1"

2. Reduction of speed when working :

- belt tension not correct : tension the belt
- motor overload due to incorrect feed rate : reduce the feed rate
- blunt tools : sharpen tools

3. Vibration of the sawblade or arbor :

- unbalanced tool : replace or have the tool balanced
- worn or damaged belt : replace the belt

4. Thermal overload does not re-arm automatically after shut-off and cooling down period :

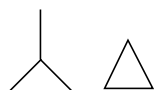
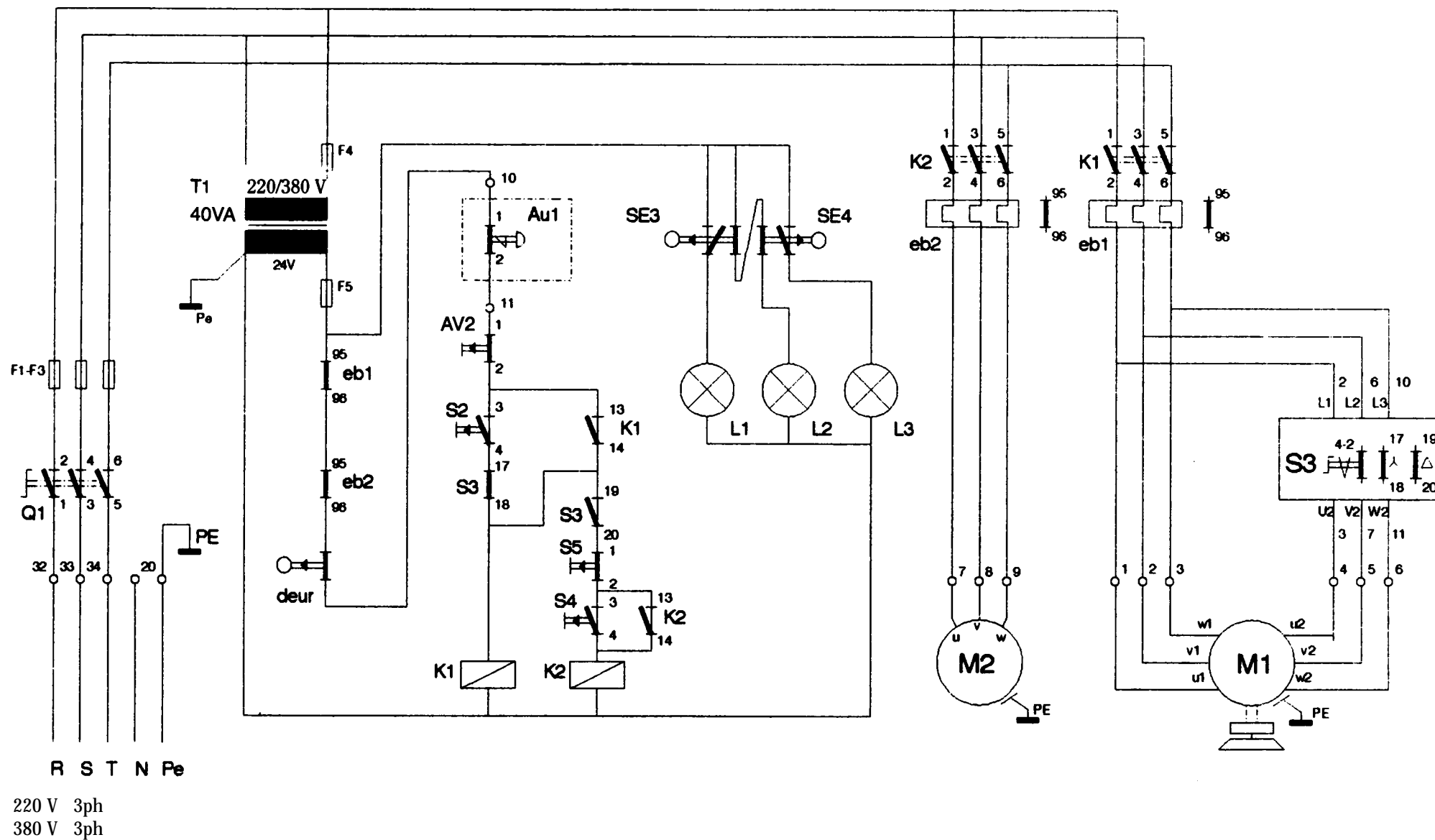
- overload is not set on automatic reset or the overload is faulty

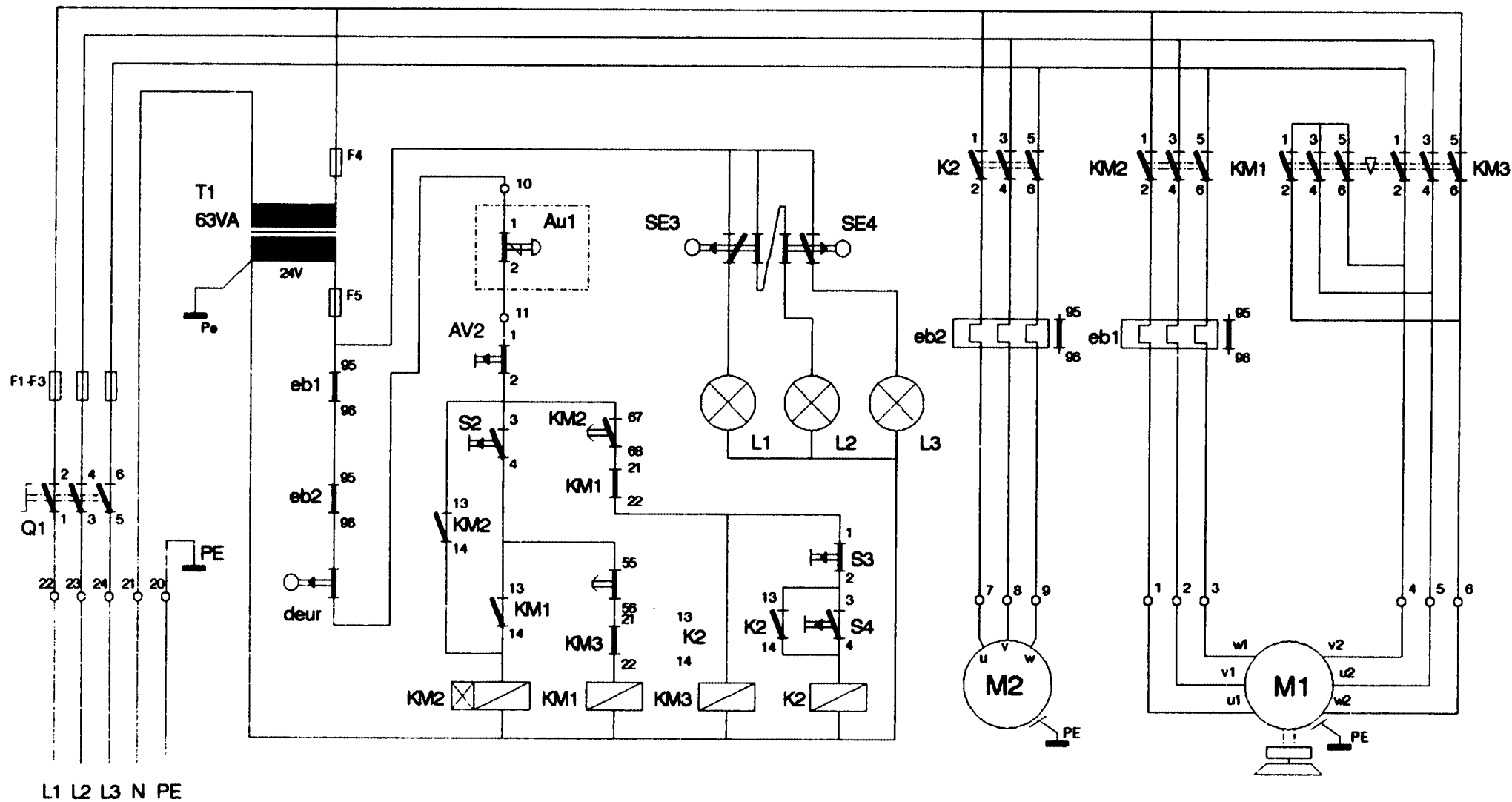
If you cannot solve the problem yourself or you do not find your problem in this list, please contact your Robland dealer.

Electrical components spares list



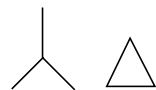
				Order n°	
Q1	Main switch			N 8443	
F1-2-3	Fuse 10x38 mm	4-5,5KW 380V = 16A		N 8537	
		4KW 220 3ph = 16A		N 8537	
		7,5KW 380V = 25A		N 8542	
		5,5KW 220 3ph = 25A		N 8542	
		7,5KW 220 3ph = 40A		-	
F4	Fuse primary	10x38 mm 1A		N 8454	
F5	Fuse secondary	10x38 mm 2A		N 8553	
F	Fuse holder Legrand			N 8534	
T1	Transformator	220-380-24V 30VA	manual start	N 8470	
		63VA	auto star-delta	N 8563	
eb1	Thermal overload	7-11A 380V 4KW	manual start	N 8491	
	main sawmotor	4-6A 380V 4KW	auto star-delta	N 8474	
		9-13A 380V 5,5KW	manual start	N 8476	
		5-8A 380V 5,5KW	auto star-delta	N 8475	
		12-18A 380V 7,5KW	manual start	N 8477	
		7-11A 380V 7,5KW	auto star-delta	N 8491	
		12-18A 220V 3ph 4KW	manual start	N 8477	
		7-11A 220V 3ph 4KW	auto star-delta	N 8491	
		17-34A 220V 3ph 5,5KW	manual start	N 8487	
		9-13A 220V 3ph 5,5KW	auto star-delta	N 8476	
		24-34A 220V 3ph 7,5KW	manual start	N 8435	
		12-18A 220V 3ph 7,5KW	auto star-delta	N 8477	
eb2	Thermal overload	1,4-2A 380V 0,55KW		N 8469	
	Scoring motor	2,8-4,4A 220V 3ph 0,55KW		N 8489	
SE1	Micro Switch			N 8506	
AU1	Emergency stop			N 8502	
AU2	Emergency stop			N 8502	
				<u>CE 24V</u>	<u>Normal</u>
K1	Magnetic relay	4KW 380V SK11	manual start	N 8457	N 8467
	Main sawmotor	4KW 380V SK-R11CX	auto star-delta	N 8557	N 8555
		5,5KW 380V SK11	manual start	N 8457	N 8467
		5,5KW 380V SK-R11CX	auto star-delta	N 8557	N 8555
		7,5KW 380V SK21	manual start	N 8461	N 8580
		7,5KW 380V SK21	auto star-delta	3x N 8461	3x N 8580
		4KW 220V 3ph SK21	manual start	N 8461	N 8465
		4KW 220V 3ph SK21	auto star-delta	3x N 8461	3x N 8465
		5,5KW 220V 3ph SK21	manual start	N 8461	N 8465
		5,5KW 220V 3ph SK21	auto star-delta	3x N 8461	3x N 8465
		7,5KW 220V 3ph SK25	manual start	N 8566	-
		7,5KW 220V 3ph SK25	auto star-delta	3x N 8461	-
K2	Magnetic relay	0,55KW 380V SK10		N 8459	N 8462
	scoring motor	0,55KW 220V 3ph SK10		N 8459	N 8460
S5	Stop button scoring motor			N 8480	N 8480
S4	Start button scoring motor			N 8500	N 8500
S3	Star-delta switch			N 8447	N 8447
S2	Start button main motor			N 8500	N 8500
SE3-4	Micro switch RPM indication			N 8506	
L1-L2-L3	RPM indication lights 24V			N 8439	
				<u>Brake</u>	<u>Normal</u>
M1	Main sawmotor	4KW 380/660V		M 353	M 352
		5,5KW 380/660V		M 358	M 356
		7,5KW 380/660V		M 386	M 393
		4KW 220/380V		M 351	M 350
		5,5KW 220/380V		M 359	M 354
		7,5KW 220/380V		M 384	M 394
M2	Scoring motor	0,55KW 220/380V		M 1470	

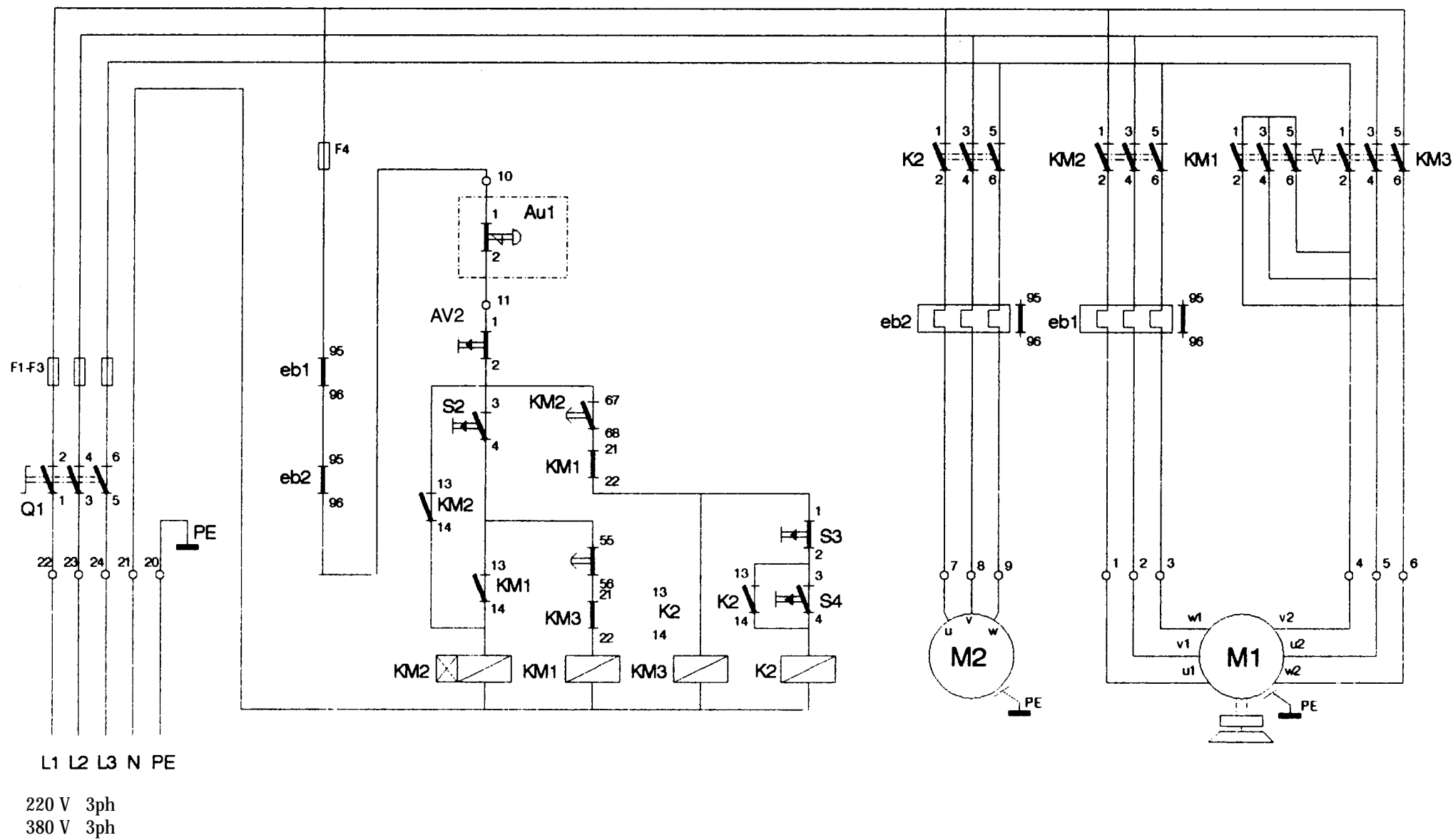
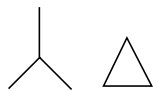


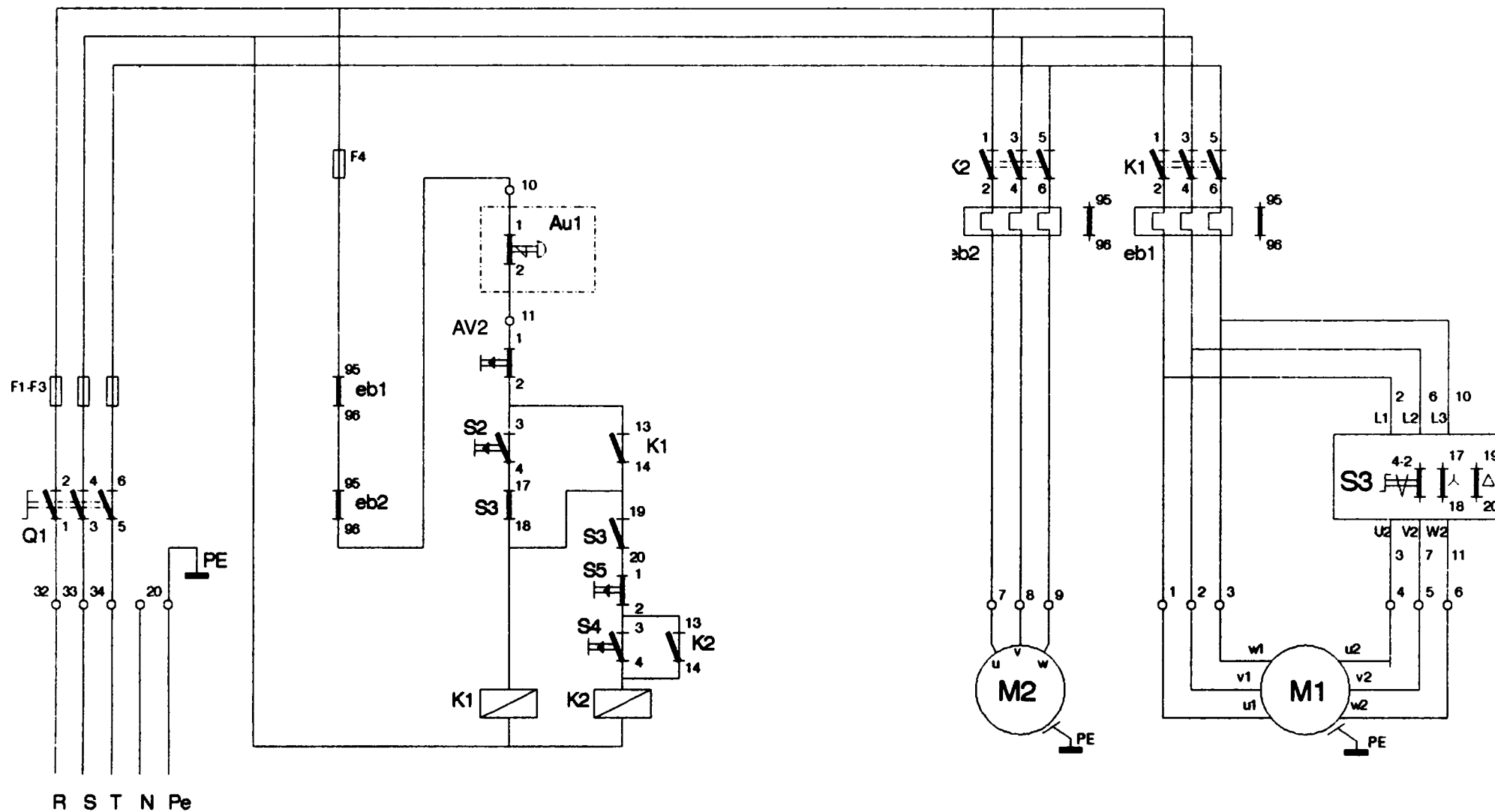


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CE AUTO

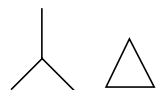



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AUTO


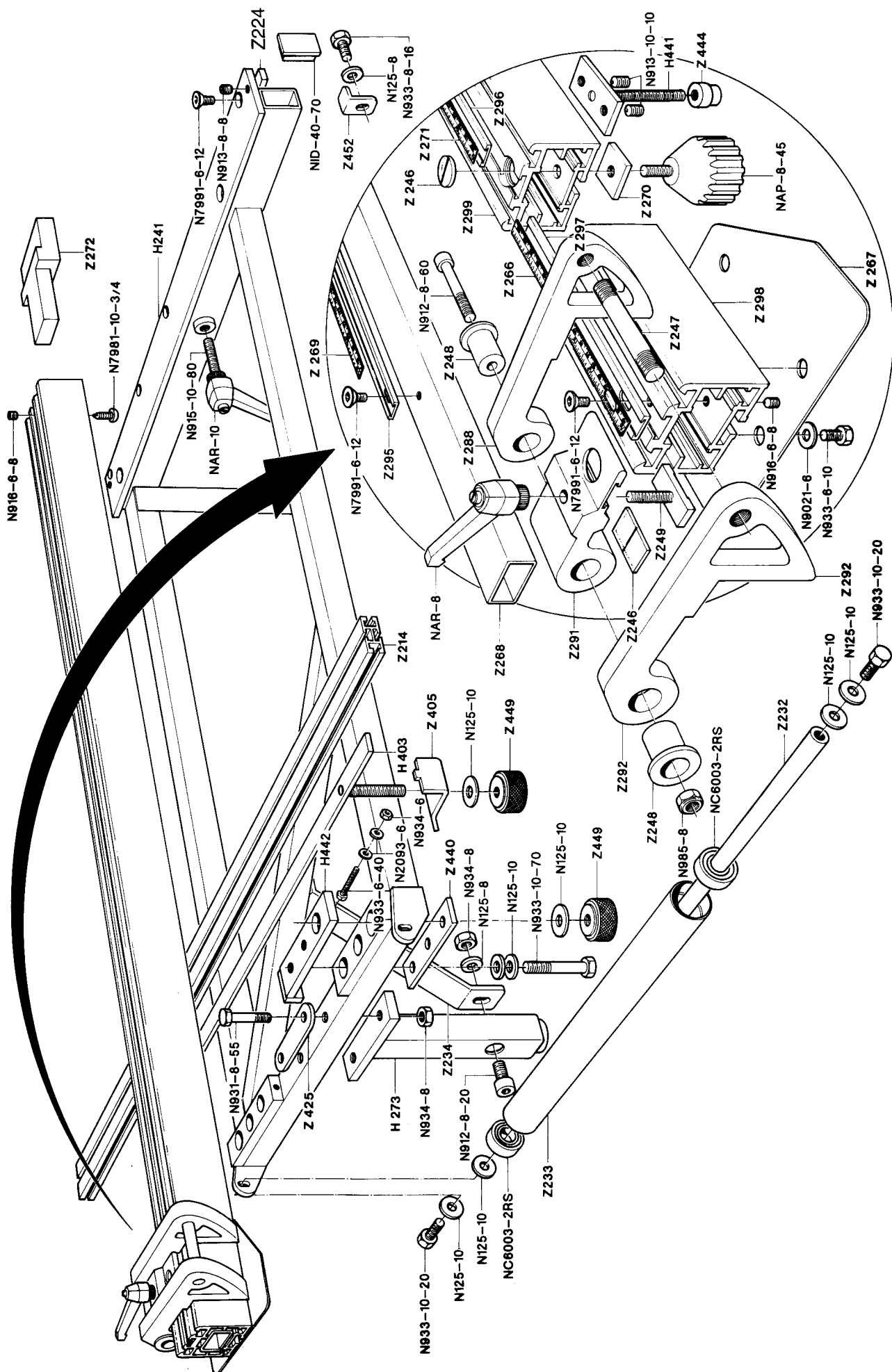



















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MANUAL

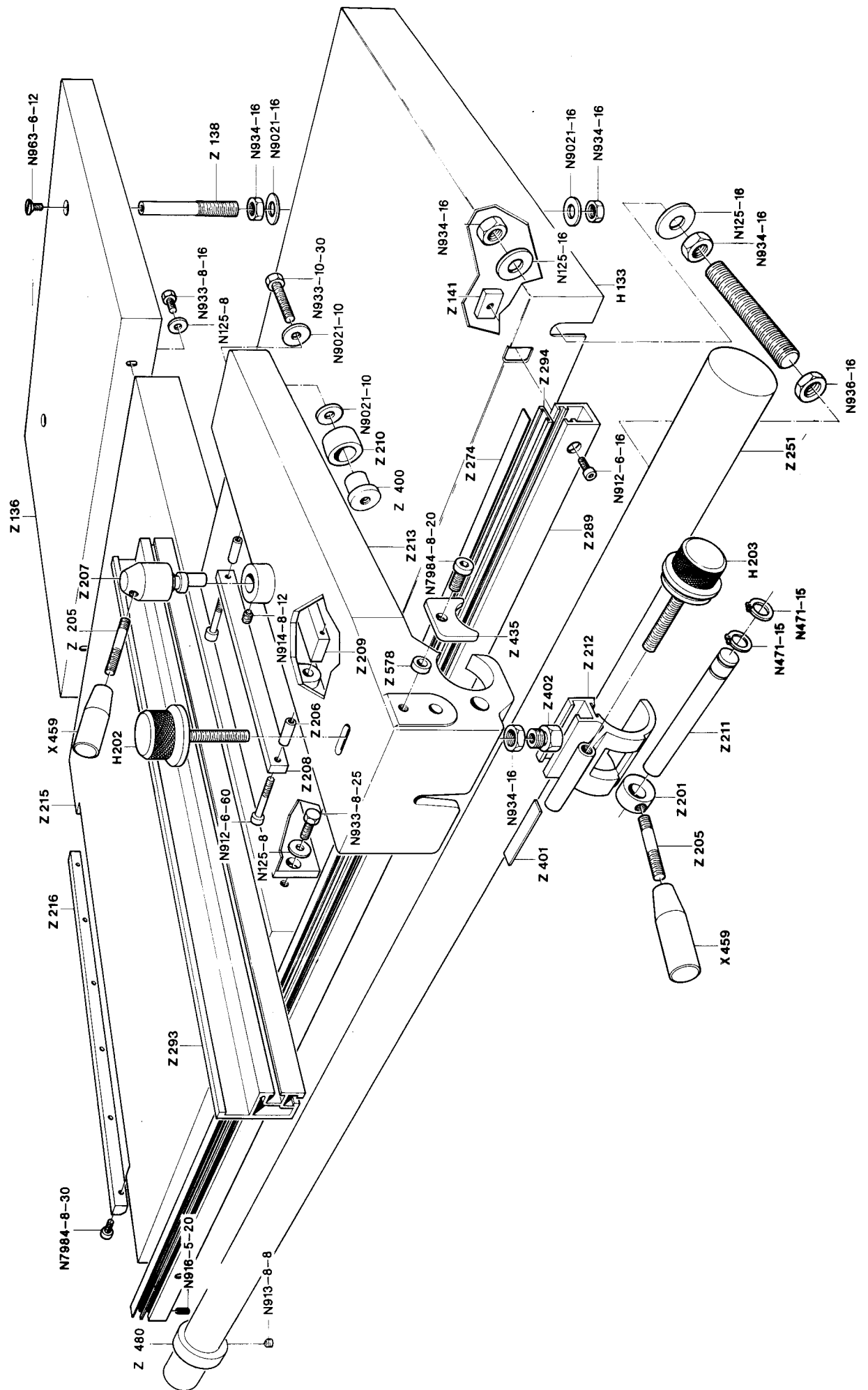


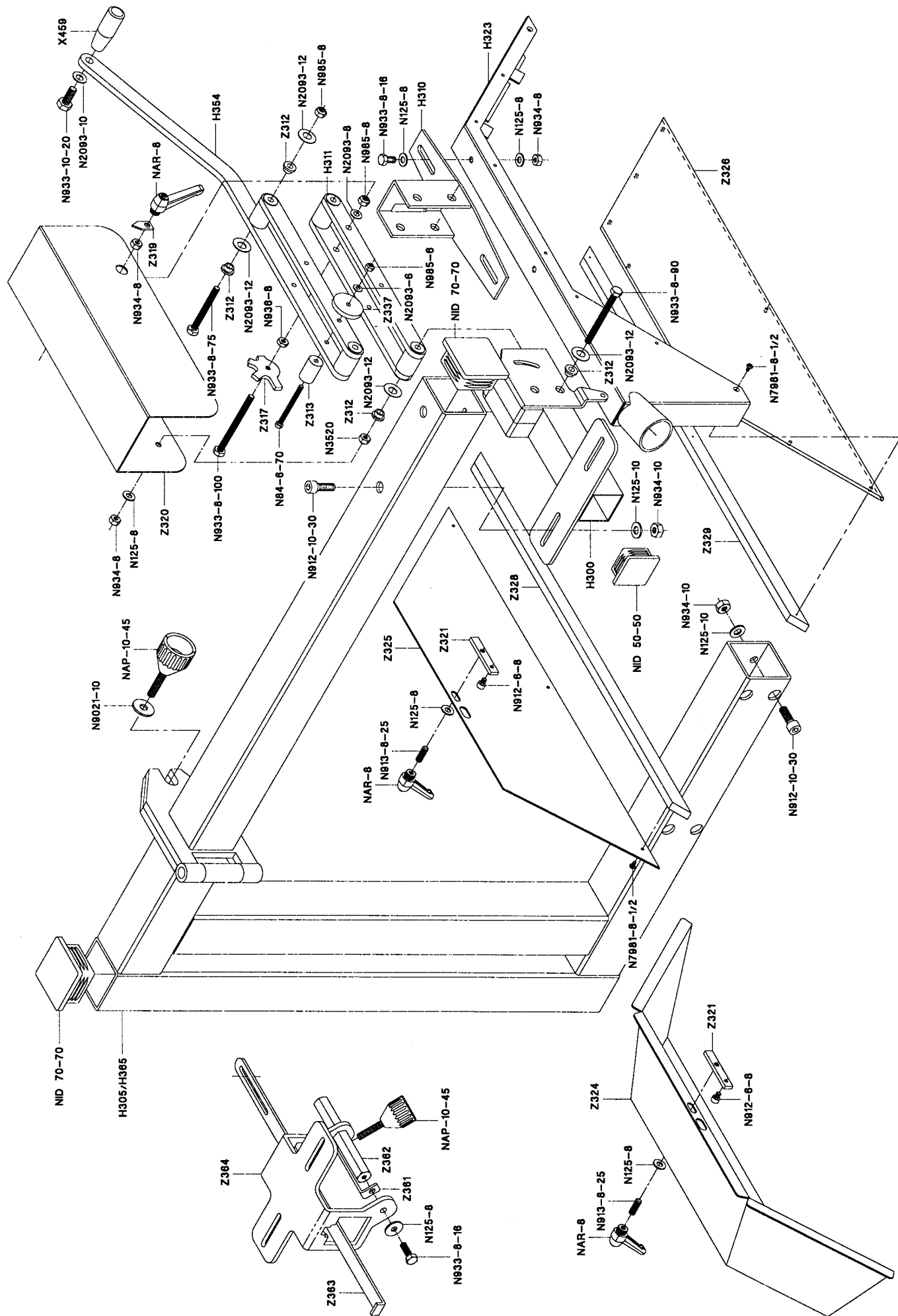


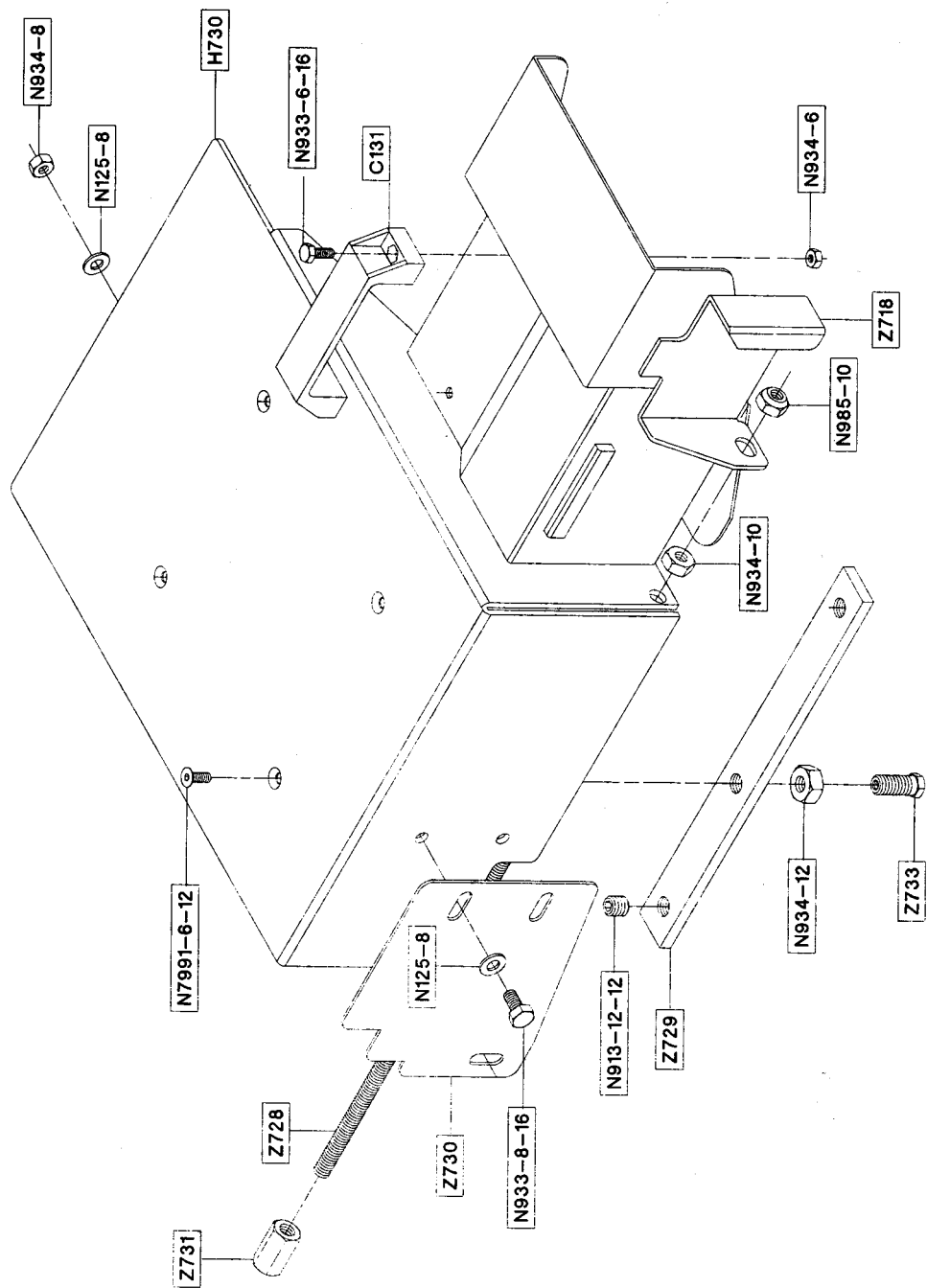


NR	VOLT	RPM	KW	
M381	230/0mno	3000	2.2	
M382	230/400	3000	4	
M383	230/400	3000	4	
M384	230/400	3000	4	
M385	400/700	3000	4	
M386	400/700	3000	4	
M387	400/700	3000	4	
M388	400/700	3000	5.5	
M389	400/700	3000	5.5	
M390	230/400	3000	5.5	
M391	230/400	3000	5.5	
M392	230/400	3000	7.5	
M393	230/400	3000	7.5	
M394	230/400	3000	7.5	
M395	400/700	3000	7.5	
M396	400/700	3000	7.5	





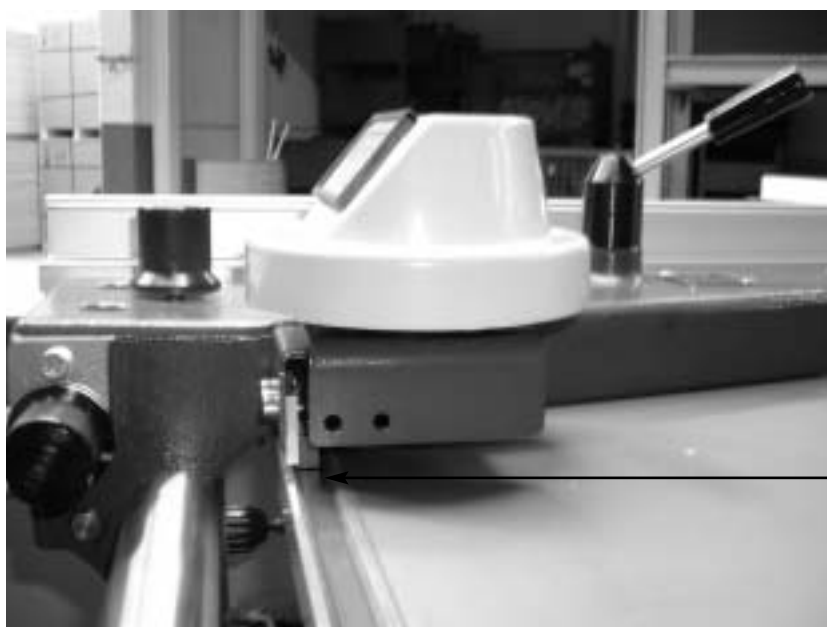




Mounting instructions for panel saw Z serie

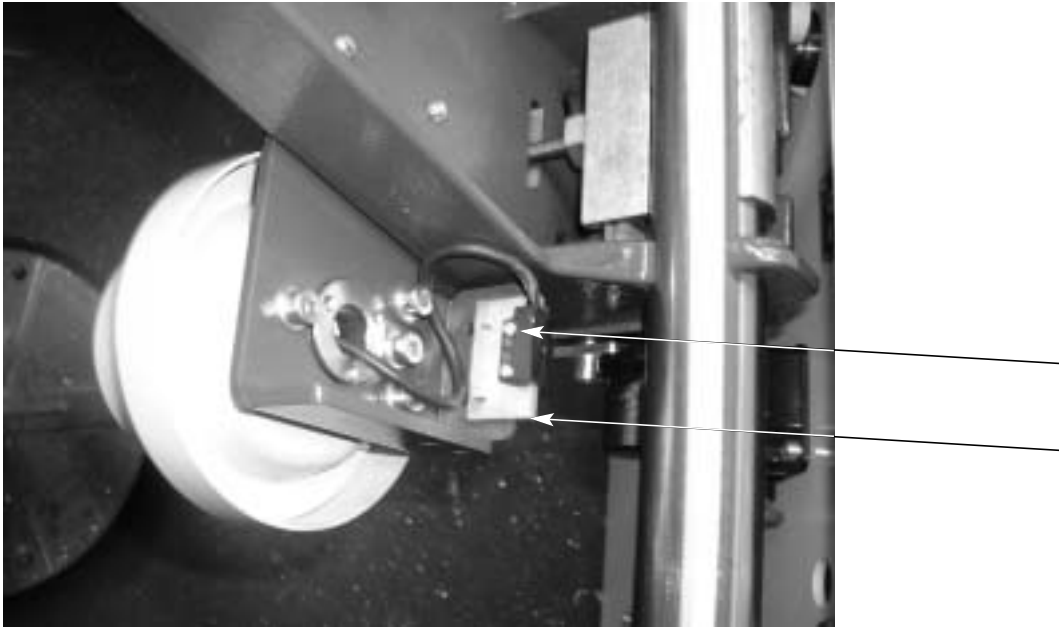


Put the digital read-out onto the parallel fence support block using the 2 holes already drilled. On older machines these 2 holes need to be drilled.
Now put the alu profile holding the magnetic strip onto the saw table at 1 mm below the table's front edge.



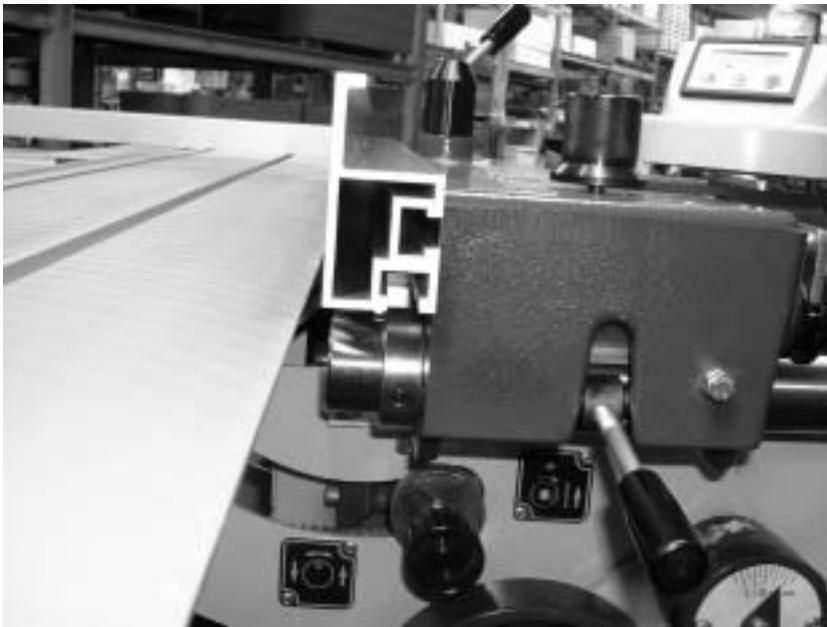
Make sure the sensor is put in the middle of the magnetic strip, and the distance between strip and sensor is set at 0,5 to 1 mm maximum.
Make sure the sensor stays at 0,5 to 1 mm over the entire length of the magnetic strip.

Option A5216: Retro-fit digital read-out for parallel fence



Adjusting the sensor is easy and simple: flip the parallel fence block over and loosen the bolts for the different brackets.

After adjustment is done, make sure all bolts are well tightened.



The calibration of the read-out is easy and simple: slide the alu saw fence up against the saw blade so that the teeth just touch the fence, and now push simultaneous both buttons F and SET, now the read-out is set at 0.

Now slide the fence a couple of mm's to the right, thus preventing the fence making contact with the saw blade, and slide the stop ring up against the parallel fence support and lock the bolt. It is recommended that each time a new saw blade is put onto the machine to calibrate again.



The little table extension as supplied, makes it possible as before to cut upto 1380 mm.
It will also act as a protection for the magnetic tape.





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EG Konformitätserklärung

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Conformity

Déclaration de Conformité
CE

89/392/CEE

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machine

erklären dass die
Bauart der Maschine

herewith declare that the
construction of the
machine

certifions par la présente
que la fabrication de la
machine

ROBLAND Z 3800 - Z3200 - Z2500
Art. nr - Stock Nr - Nr° Article

voldoet aan de volgende
richtlijnen

folgende Bestimmungen
entspricht

complies with the following
relevant regulations

est conforme aux
dispositions suivantes

EG MACHINERICHTLIJNEN • EG MASCHINERICHTLINIE
EC MACHINERY DIRECTIVE • DIRECTIVES CE RELATIVES AUX MACHINES

Het type-onderzoek werd
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Die Baumusterprüfung
wurde von folgender Stelle
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Type examination was
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Le modèle a été examiné
par l'organisme suivant

L'INSTITUT NATIONAL DE RECHERCHE ET DE SECURITE I.N.R.S.
Avenue de Bourgogne - BP 27 - F 54501 VANDOEUVRE CEDEX FRANCE

Nummer van het
type-onderzoek

Nummer der EG
Baumusterprüf-
bescheinigung

EC Type Examination
Certificate Number

Numéro du Certificat
d'Essai CE accordé au
modèle

0070 012A 5406 03 01

Z-series



Instruction manual



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machines

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