



THE PROMAC AIR POWERED CROPPER

USE AND MAINTENANCE MANUAL



**PROMAC
GROUP**

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1.0 MANUAL

1.1 AIM OF THIS MANUAL.

With this manual we aim to provide you with the necessary instructions for safe use and maintenance of the machine. **Before proceeding with use or maintenance operations, you must therefore carefully read all sections of this manual.**

It is forbid to reproduce, transmit or transcribe this use and maintenance manual, or to memorize it in an archive, or to translate it into other languages, in any form or with any means whatsoever, without the written permission of **WINDOW MACHINERY SALES LTD T/A PROMAC**.

WINDOW MACHINERY SALES LTD T/A PROMAC declines all and any liability and/or indirect damage or injury to persons and/or things caused by technical errors and omissions or by use of this manual. **WINDOW MACHINERY SALES LTD T/A PROMAC** also reserves the right to modify the contents and presentation of this manual without warning, with the aim of offering a better product.

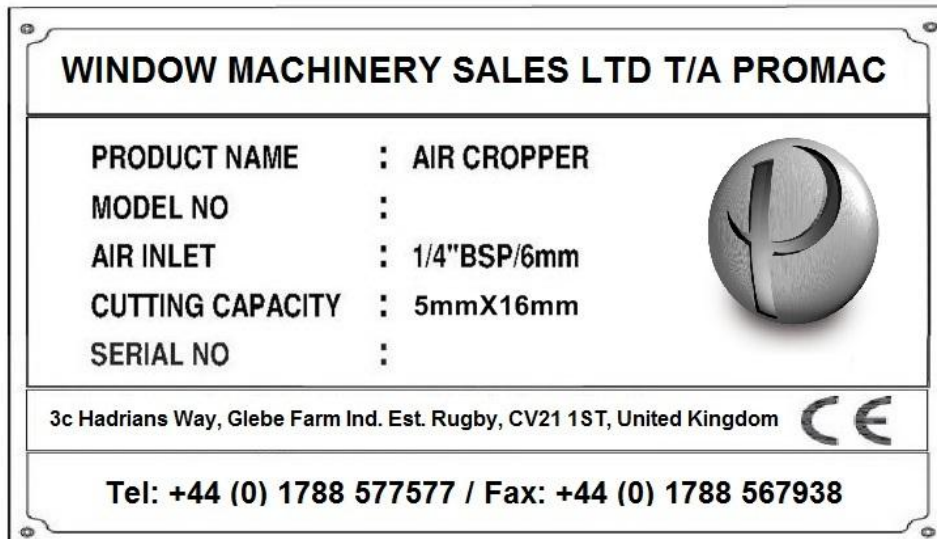
Safety Regulation

- **KNOW YOUR MACHINE.**
For your own safety, read the owner's manual carefully. Learn its application and limitations as well as specific potential hazards pertinent to this machine.
- **KEEP GUARDS IN PLACE AND IN WORKING ORDER.**
- **REMOVE ADJUSTING KEYS AND WRENCHES.**
For habit of checking to see that keys and adjusting wrenches are remove from the machine before turning it on.
- **KEEP WORK AREA CLEAN.**
Cluttered areas and benches invite accidents.
- **DO NOT USE IN DANGEROUS ENVIRONMENTS.**
Do not use power tools in damp or we locations, or expose them to rain.
Keeps work area well illuminated.
- **KEEP CHILDREN AWAY.**
All visitors should be kept at a safe distance from work area.
- **MAKE WORKSHOP CHILDPROOF.**
With padlocks, master switches, or by removing starter keys.
- **DO NOT FORCE THE MACHINE.**
It will do the job better and be safer at the rate for which it was designed.
- **USE THE RIGHT TOOLS.**
Do not force the machine or attachments to do a job for which they were not designed.
- **WEAR PROPER APPAREL.**
Avoid loose clothing, gloves, neckties, rings, bracelets, or jewelry, which could be caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- **SECURE WORK.**
Use clamps or a vice to hold work when practical. It is safer than using your hand and frees both hands to operate the machine.

- **DO NOT OVERREACH.**
- **MAINTAIN MACHINE IN TOP CONDITION.**
Keep machine clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- **DISCONNECT MACHINE FROM POWER SOURCE.**
Before servicing and when changing accessories, or when mounting and remounting motor.
- **USE RECOMMENDED ACCESSORIES.**
Consult the owner's manual for recommended accessories.
- **NEVER LEAVE MACHINE RUNNING UNATTENDED. TURN POWER OFF.**
Protective guards and shields must be in place at all times unless that specific part requires servicing.

Never clean or remove chips while the machine is running. Do not remove or alter warning labels and replace any that become obscured.

Name Plate



Warning Plate (Pictures/Photos)

This machine has warning symbols attached on it as shown below to ensure proper and safe operation.

These symbols are used on the machine to indicate points or instances of specific danger to operating personnel.

Make sure to memorize these symbols and bring them to the attention of others as and when necessary.

Do not remove safety symbols from the machine.



.2 TERMINOLOGY.

From this point onwards, in this manual the following terms will be used with their definitions as here provided:

Machine: the artefact supplied by **WINDOW MACHINERY SALES LTD T/A PROMAC** and commercially denominated:
THE PROMAC AIR POWERED CROPPER.

Vendor: the company **WINDOW MACHINERY SALES LTD T/A PROMAC** with commercial office at: 3c Hadrians Way, Glebe Farm Ind. Est. Rugby CV21 1ST, United Kingdom Tel. +44 (0) 1788 577577 / Fax +44 (0) 1788567938

CAUTION !

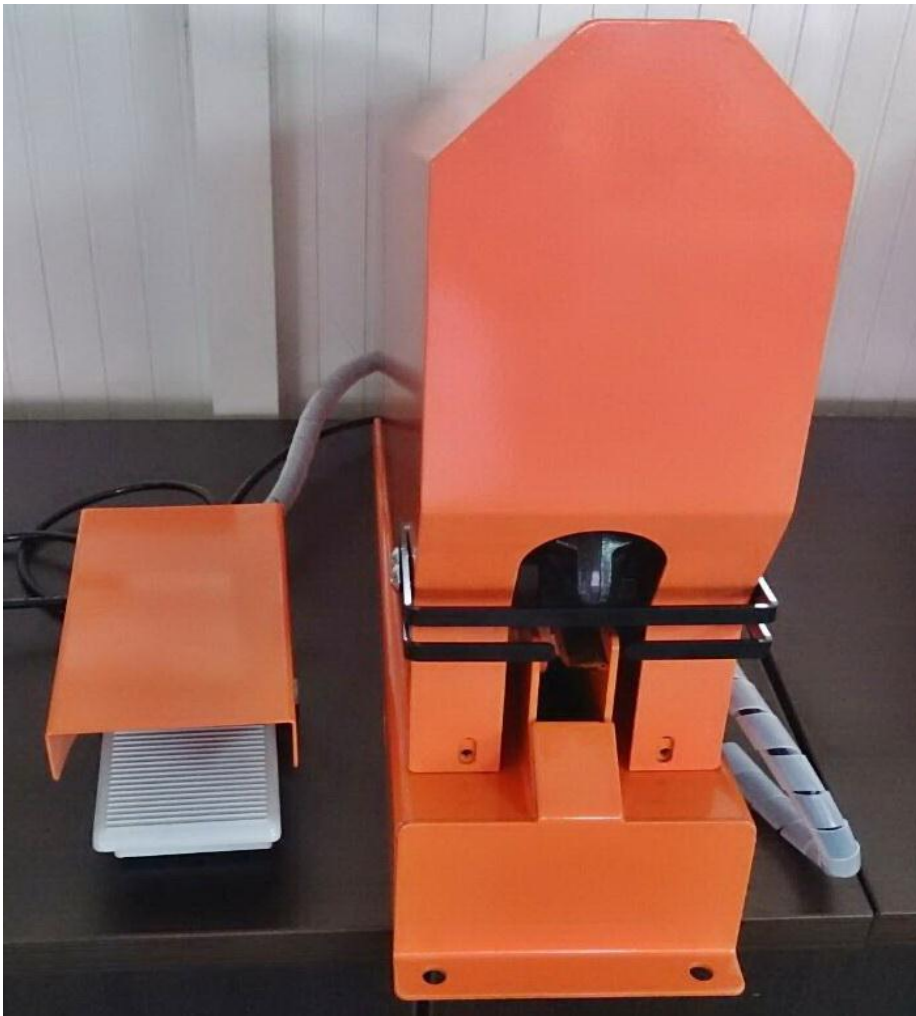
Anyone using this machine or making it available for use explicitly and irrevocably acknowledges that the manufacturer of the same cannot be attributed with any kind of liability (either civil, penal or any other whatsoever) in case of accidents occurring in the presence of (and not necessarily “as a consequence of”) breach of one or more of the provisions of this manual.

Should anyone using this machine or making it available for use fail to acknowledge the validity of this manual, and give immediate written notification thereto by registered mail to the manufacturer of the same. In the absence of such formal notification, the previous arbitration clause must be deemed explicitly irrevocably accepted by simply switching on and using the machine.

2.0 MACHINE IDENTIFICATION.

2.1 MACHINE

Check that the machine delivered to you corresponds to the illustrations below

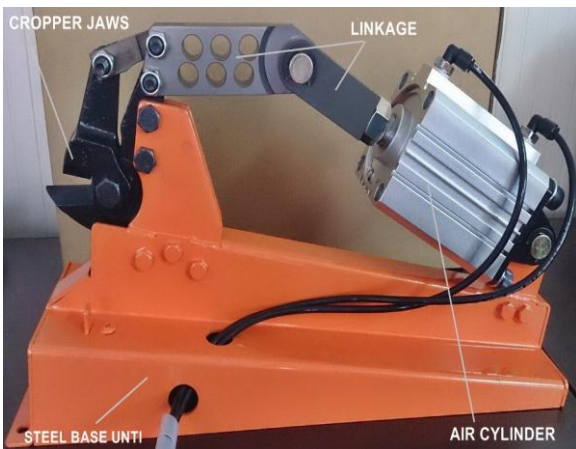


2.2 GENERAL DISCRIPTION OF THE MACHINE.

The machine addressed in this manual has been designed specifically for the use of cropping to length window and door gear components used in certain types of UPVC, ALUMINIUM, TIMBER, windows and doors.

The machine is composed of the Following Parts:

STEEL BASE UNIT, CROPPER JAWS, AIR CYLINDER, FOOT SWITCH, AIR CYLINDER to CROPPER JAWS LINKAGE, COVERING LID and GUARD BARS.



2.3 OPERATING PRINCIPLE.

The operating principle involves the following :

- 1. The material to be cropped (cut off) is placed into the cropper jaws at the Desired cut off point.**
- 2. Ensuring that the jaws are clear of all but the work piece.
The foot switch is then depressed.**
- 3. This activates the air cylinder, which in turn through the cylinder to jaw Linkage closes the cropper jaws thus cropping off the material as required.**
- 4. The foot switch is released allowing the jaws to open and the air cylinder to return to the start position ready for the next cropping.**

2.4 TECHNICAL DATA.

OVERALL HEIGHT	40 cm
OVERALL WIDTH	14 cm
OVERALL LENGTH	51 cm
WEIGHT	16 Kg
WORKING AIR PRESSURE (MAX)	6.2 bar (90 psi)
AIR INLET	1/4" BSP/6mm
CUTTING CAPACITY	5mm x 16mm IN MILD STEEL

3.0 INSTALLATION AND STARTING

3.1 POSITIONING.

The surface upon which the machine is to be installed must be flat, stable and of sufficient strength to support the weight of the machine and material to be cropped. The work area must be well lit. Clear from unsecured objects and obstructions.

CAUTION !

The machine must be firmly secured to the work surface. This should be done thru the four existing 8mm dia clearance holes in the base of the machine, using M8 nuts and bolts or coach bolts etc.

3.2 CONNECTION.

“ The machine has no ELECTRICAL CONNECTIONS.”

The air connection is thru one single inlet into the foot switch via a 6mm dia push fitting.

The maximum operating air pressure is 6.2bar (90psi)

The feed air line must be fitted with a cut off valve to enable safe machine adjustments, maintenance, and cleaning etc,

It is also recommended that the feed air line be fitted with the following for protection of the the machine system.

AIR PRESSURE REGULATOR.

AIR FILTER.

AIR LUBRICATOR.

3.3 STARTING.

Eye protection, Safety footwear, must be worn at all times by person operating the machine

The work area should be free of any obstructions.

Check that the covering lid, guard bars, are in position and secured.

Check that the jaws are free from damage and obstructions.

Turn on the air supply to the machine and check that the air pressure dose not exceed 6.2bar (90psi)

The machine is now ready for use.

See section 2.3 of this manual OPREATING PRINCIPLE.

At the end of production use. The air supply to the machine should be turned off at the air cut off valve and the work area left in a clean and tidy condition.

THE MACHINE MUST ONLY BE OPERATED BY AN AUTHORIZED COMPETENT PERSON.

4.0 MAINTENANCE.

SAFETY NOTE

Under no circumstances must any of the following be carried out **WITHOUT TURNING OFF THE AIR SUPPLY AT THE AIR SUPPLY CUT OFF VALVE.**
CLEANING, INSPECTION, MAINTENANCE, THE REMOVAL OF ANY COMPONENT PART OF THE MACHINE.

The machine should be cleaned at the end of each work period.

4.1 DAILY CHECKS. BEFORE STARTING PRODUCTION.

Drain air filter.
Check oil level in air lubricator.
Check cropper jaws for damage ie wear chipping etc.
Check air supply pressure 6.2bar (90psi) max

4.2 PERIODIC CHECKS. FREQUENCY IS DEPENDENT UPON USAGE

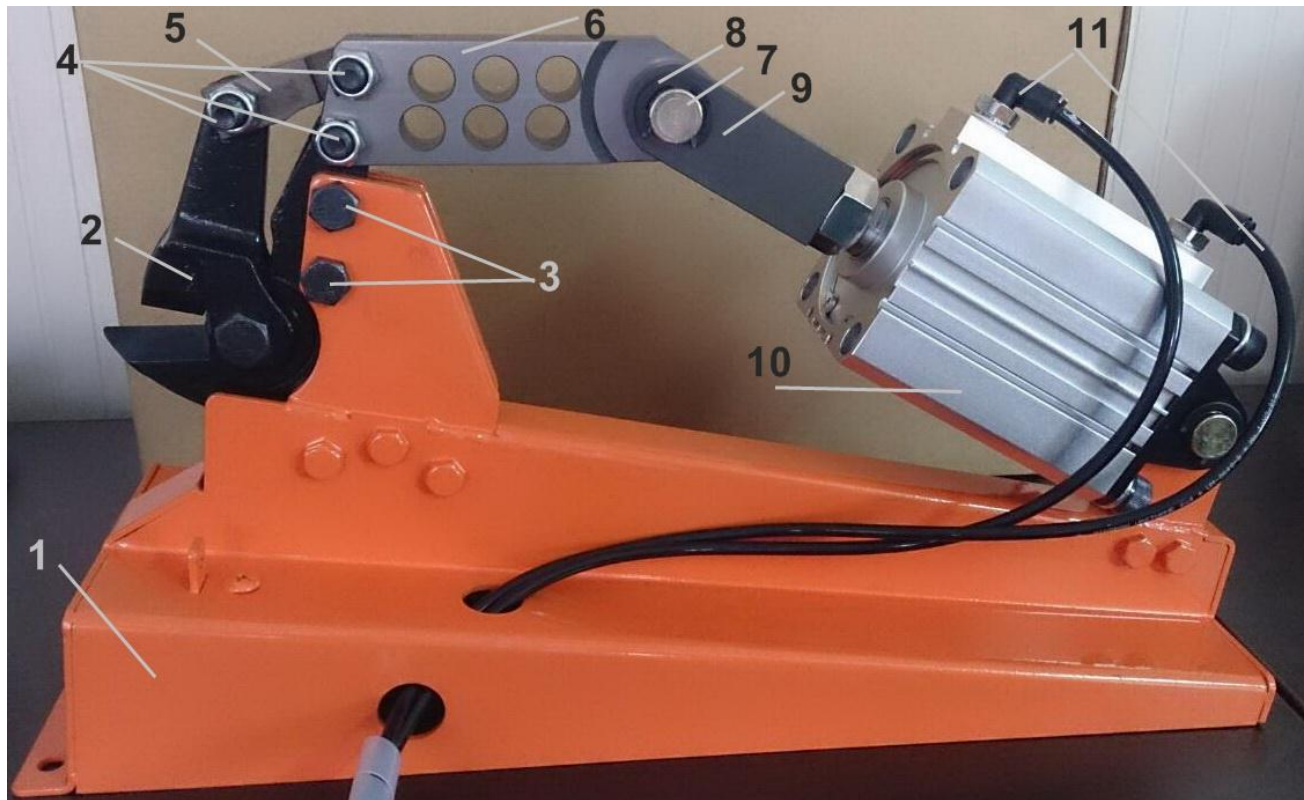
Check air connections for leaks.
Check air pipes for wear.
Check foot switch return spring for tension return
Remove cover lid and check all hinge pins, fixing bolts, linkage components for wear.
Lubricate all moving parts.
Replace all worn parts.

NOTE !

All inspections and maintenance should be carried out by competent maintenance persons.

4.3 SPARE PARTS LIST.

ITEM	DESCRIPTION	QTY
1	Steel base unit.	1
2	Cropper jaw assembly.	1
3	Fixing nut and bolt.	2
4	Fixing nut and bolt.	3
5	Jaw link.	1
6	Cylinder to Jaw link.	1
7	Hinge pin.	1
8	E retainer.	2
9	Clevis.	1
10	Air cylinder.	1
11	Air pipes.	2
12	Foot switch.	1



5.0 SUPPLIES GUARANTEE

5.1 GUARANTEE

The supplier's guarantee has a duration of 6 months from the date of sale or delivery (or even from the effective installation of the machine, but only if done by technicians directly assigned and/or authorized thereto by the supplier).

The guarantee provides for the free replacement of all components that might break or be subject to abnormal wear due to an ascertained defect of design, supplies, construction, assembly or installation that can be ascribed to the manufacturer.

Request for assistance under guarantee must be made directly to the supplier. Any defects of design, supplies, construction, assembly or installation that can be ascribed to the manufacturer must be notified without fail by means of registered mail with returned receipt note, send to head office of WINDOW MACHINERY SALES LTD T/A PROMAC no longer than the seventh day immediately following their discovery.

Any such defects of design, supplies, construction, assembly or installation that can be ascribed to the manufacturer must be notified by fax to the head office of WINDOW MACHINERY SALES LTD T/A PROMAC within 24 hours of their discovery, so as to prevent any further damage and/or accidents.

Failure to comply with the instructions given in the previous two points will exonerate the manufacturer and supplier from the consequences of possible greater liability for damages and/or accidents consequent to late or omitted notification.

For all matters not expressly indicated, the provisions of law as envisaged by Directive 85/374/eec "Liability for Defective Products".

CAUTION !

The manufacturer's/supplier's guarantee WILL UNDER NO CIRCUMSTANCES INCLUDE:

- replacement of the machine following action taken to faults;
- any kind of reimbursement for working time of personnel not directly assigned and/or authorized by the manufacturer to carry out any operations and/or repairs;
- any kind of reimbursement for expendables and/or hire of any equipment and/or purchase of equipment to carry out any operations and/or repairs with personnel not directly assigned and/or authorized by the manufacturer/supplier;
- any kind of reimbursement for damaged or destroyed goods;
- damage caused by unsuitability of the environment in which the machine operates;
- damage caused by phenomena not involved in normal machine operation (atmospheric electrical discharges, voltage fluctuations, fire, floods, etc);
- any kind of reimbursement for possible loss of earnings (direct or indirect) and/or for any expenses (direct or indirect) and/or for any penalties (direct or indirect) and/or damage (direct or indirect) of commercial nature and/or involving prestige due to possible standstill of the machine and/or of other machines and/or production lines in any way operating together with our machine and/or consequent to possible damage to/or destruction of goods;
- malicious damage caused by anyone whatsoever, either intentionally or unintentionally, and also damage derived from demonstrations, insurrection, riots and/or similar occurrences, even if occurring in the sphere of reunions convened legally (for example:

5.1 GUARANTEE (continued)

trade union meetings at the workplace) and/or authorized by public authorities (for example: trade union demonstrations);
damage deriving from natural events such as lightning, floods, earthquakes, etc.

CAUTION !

The manufacturer's /supplier's guarantee **WILL BE COMPLETELY INVALIDATED:**

- In case of failure to respect any provision, instruction, recommendation, warning or prohibition communicated by the manufacturer and/or by the manufacturer's commercial network in any form whatsoever (verbal, written, by telephone, by fax, on paper, electronic, magnetic, optical, audiovisual, etc. supports); in particular, in case of failure to respect any instruction (for use and for purpose other than use) given in this manual;
- In case of improper or unreasonable use of the machine, even if not envisaged and/or expressly prohibited by the manufacturer/supplier;
- If the machine is modified in anyway whatsoever , even slightly;
- If the machine is modified, without the manufacturer's/supplier's written approval, following possible rulings made by local authorities for control and/or prevention, even if such medications are compulsory;
- If components of the machine are replaced with components not supplied by the manufacturer/supplier, regardless of their technical characteristics;
- If the machine is repaired by personnel other than personnel directly assigned and/or authorized by the manufacturer/supplier;
- If the machine is moved and/or installed by personnel other than directly assigned and/or authorized in writing by the manufacturer/supplier;
- If damage to the machine is caused by carelessness and/or negligence;
- If the machine has not been correctly purchased from and/or correctly paid for to the manufacturer/supplier in accordance with all agreed contractual conditions; in particular, any failure or delay to make payments will invalidate the manufacturer's/supplier's guarantee for the entire period of failure or delay to make payment; the period in which failure or delay to make payment may have occurred cannot be recovered even when all sums due have been fully paid; that is to say, the manufacturer's/supplier's guarantee will always expire after 6 months after the date of installation of the machine by personnel directly assigned thereto and/or by the manufacturer/supplier;
- If a valid invoice demonstrating correct purchase cannot be exhibited.

CAUTION !

For the guarantee to be valid, the pre printed form on the next page must be completely filled in and sent no later than thirty days after the date of installation of the machine. The form must not be photocopied or otherwise reproduced, but must consist solely in the next page of this manual.
The next page, with the pre printed form, must therefore be physically removed from the manual.

5.1 GUARANTEE (continued)

The form must be sent solely by registered mail in a sealed envelope.

A copy of the guarantee activation form may be sent in advance by fax, but the original copy must always also be sent by registered mail.

All data that you communicate to us will be rigorously subject to applicable legislation on privacy protection and will not be communicated to a third party, unless as strictly necessary for the execution of our guarantee in your favour.

CAUTION !

The guarantee is not to be confused with either routine or special maintenance, which is entirely at your expense.

For components purchased by the manufacturer from the supplier , the sole guarantee for the buyer shall be those granted by these suppliers.

The manufacturer/supplier will not be liable for operations covered by the guarantee nor for the reimbursement of direct or indirect damages of any nature or for any reason whatsoever deriving from failure to activate and/or regulate operating parameters of the machine.

The machine must never be used outdoors.

5.2 GUARANTEE ACTIVATION FORM

For the guarantee offered by the supplier to be valid, it is *essential* that this guarantee form:
Is fully completed in block letters or other legible script;
Is sent only by registered mail in a sealed envelope to the following address: WINDOW MACHINERY SALES LTD T/A PROMAC, 3c Hadrians Way, Glebe Farm Ind. Est. Rugby CV21 1ST, United Kingdom.
This guarantee form can be sent in advance by fax to **+44 (0) 1788 567938**

To ensure that we have received this form correctly (by mail or fax), please call us on **+44 (0) 1788 577577**.
Receipt by us of a copy of this form by fax does not exonerate you from your obligation to send the original of the guarantee form by registered mail in a sealed envelope.

Sender data:

Company using machine.....
Street and number.....
Postcode and town.....
Telephone number complete with area code.....
Fax number complete with area code.....

Machine data:

Commercial name of model.....
Serial number.....
Purchase or installation date.....

Data on use of machine:

Number of operators:.....Use:.....
.....
.....

Make, model, serial number, characteristics of machines located before machine:.....
.....
.....
.....

Make, model, serial number, characteristics of machines located after machine:.....
.....
.....
.....

Date of transmission of this guarantee form:.....
Rubber stamp, signature and role of sender:.....

CAUTION !

Anyone using this machine or making it available for use explicitly and irrevocably acknowledges that the manufacturer/supplier of the same cannot be attributed with any kind of liability (either civil, penal or of any other nature whatsoever) in case of accidents occurring in the presence of (and not necessarily "as a consequence of") breach of one or more (without exclusion) of the provisions contained in the manual.

6.0 DECLARATION OF CE CONFORMITY



EC DECLARATION OF CONFORMITY

Applicant : WINDOW MACHINERY SALES LTD T/A PROMAC
Address of Applicant : 3c Hadrians Way, Glebe Farm Ind. Est. Rugby CV21 1ST,
United Kingdom
Product Name : PROMAC AIR POWERED CROPPER
Directive : Machinery Directive 2006/42/EC

The TCF is archived by WINDOW MACHINERY SALES LTD T/A PROMAC with commercial office at: 3c Hadrians Way, Glebe Farm Ind. Est. Rugby CV21 1ST, United Kingdom

Tel: +44 (0) 1788 577577 / Fax: +44 (0) 1788 567938

For the most specific risks of this machine, safety and compliance with the essential requirements of the Directive has been based on elements of:

- EN ISO 12100:2010 / Safety of machinery — General principles for design — Risk assessment and risk reduction
- EN ISO 4414:2010 / Pneumatic fluid power - General rules and safety requirements for systems and their components (ISO 4414:2010)

Date : 19-05-2015

Signature :  BOB HOPPER

Qualification : MANAGER

Place : RUGBY UNITED KINGDOM

CE