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Instruction Manual Decoiler AZ-DF





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Azimuth Manual Decoilers Instruction Manual

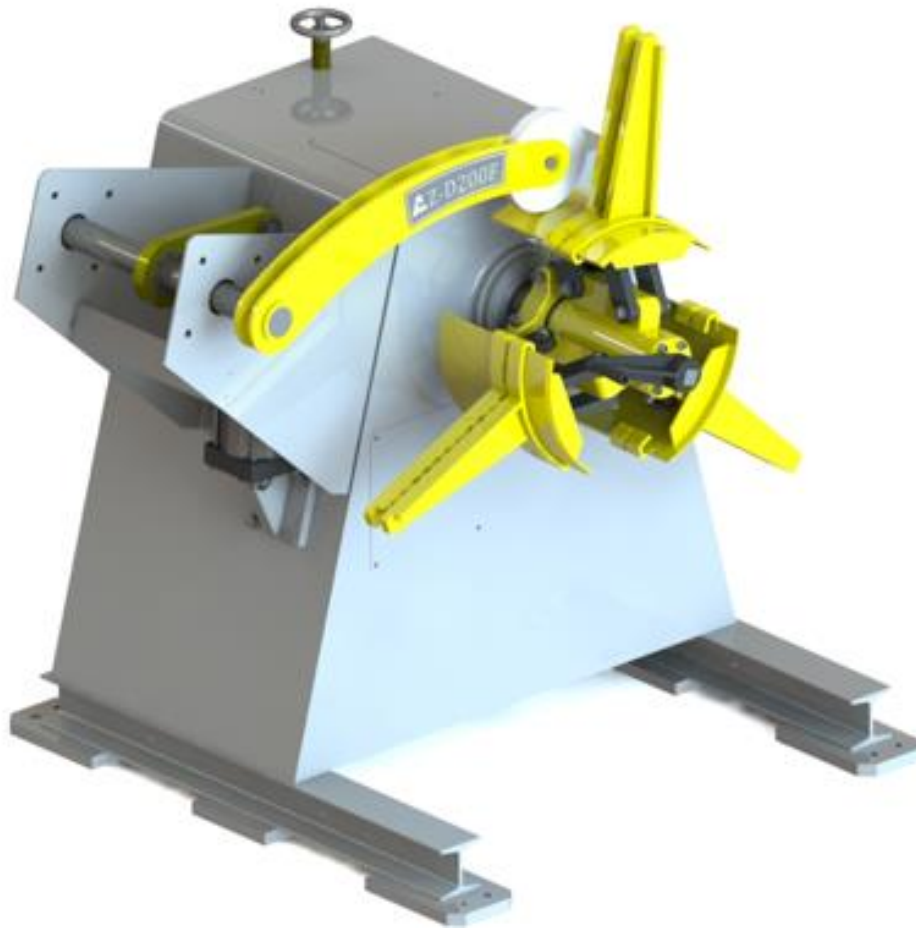




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1 WORD OF CAUTION

- ⚠ This machine is rated for 208V/60Hz and 480V/60Hz in star configuration. Make sure to properly connect the machine.
- ⚠ Before using the machine with material, make sure to perform a visual inspection and try to cycle it 5 times to verify that nothing has been damaged during transport (guarding system, etc.)
- ⚠ Never operate this machine until you've read & understood that this machine is dangerous. Placing your hands or any part of your body in this machine could lead to serious injuries or death.
- ⚠ Never operate this machine without the use of a guard or safety device that will always protect you from injuries.
- ⚠ Never work on this machine unless the power is turned off and locked.

***** Never put your hands in the machine unless the power is turned off and locked out ****



The following general conditions must be followed.

- Check the machine and make sure that there is no damage when taking delivery of your machine. Please ask your dealer for replacement of shipping damage within 7 days starting the date of purchase, replacement requests are invalid after 7 days.
- Please check whether the accessories are missing while delivery of your machine. If there are any missing parts, please ask your dealer for the provision of the parts in question within 7 days from the date of purchase. Request you make after 7 days will not be considered.
- Make sure your machine is grounded and there are no voltage fluctuations on power supply.
- Failures caused by use of improper power connections are not covered by warranty of your machine. Repair of such failures will bring you financial burden.
- Do not try to attach external parts to each other's slots or their own slot the wrong way. Do all connections while the machine is off, do not try to attach or detach any parts while the machine is running.
- Do not interfere with software on the machine. Any modification to the software can be done only if Azimuth approves the request. Otherwise, it will cause your machine to be out of warranty.
- Make sure all connections to the machine are correctly made.
- Machine work surface must be flat, non-slip and solid.
- If our machine works with another machine than Azimuth ones, the manufacturer is not liable for any damage or work loss due to shock, moving around or vibrations in the event of overload of the other machine.
- Loading capacity of the machine must not be exceeded. Work overload will damage the machine and all components rotating.
- Make sure the machine is working as shown by the technical service during installation.
- Only use our machines for sheet materials, our machines are designed for uncoiling, feeding and cutting sheet metals. They are not suitable for round or rectangle profiled materials.



2 INSTALLATION

This section covers the mechanical set-up of the decoiler AZ-DF. Please make sure to fully understand these instructions before attempting to make mechanical adjustments to the machine.

2.1 Decoiler alignment and leveling

All components of the line such as decoiler, straightener, feeder, die and press should be exactly parallel to each other. Precision lasers are used to meet this requirement during installation. If the feed line is not properly aligned, the sheet material may slide to the sides and get damaged or stick inside the die and damage the equipment. The distance between the decoiler and the feeder should be around 10 to 13 feet. Creating the proper loop for the material will help the automatic sequence and material stress.

To level the decoiler correctly, use the screws located on the feet of the machine. Make sure to secure the equipment with anchors afterward. Azimuth installation staff are providing support for this manner.

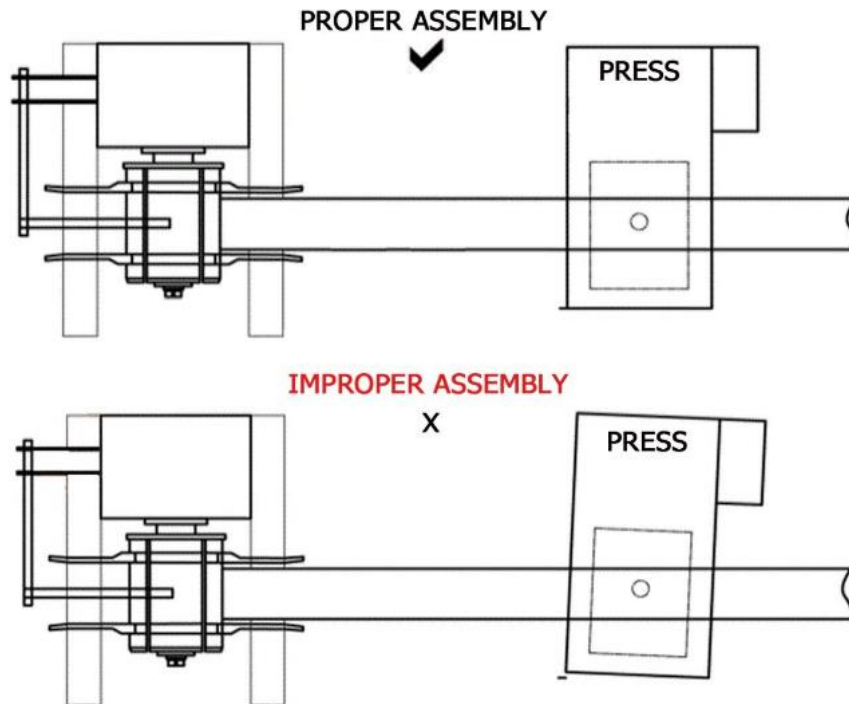


Figure 1 : Feedline alignment



2.2 Installation of the Coil

To make sure everything is ready for the installation of the coil, lift the pressure arm to keep it out of the way and follow the sequence below.

1. Install the back coil keepers on each blade for the proper material width (see figure 2.2.1). If you are always using the same material width, the back coil keepers act as reference for the strip alignment with the press. Therefore, you can always keep them in the same position. Make sure they are clamped correctly at the bottom before putting a new coil;
2. Reduce the mandrel diameter with the handle;
3. Lift the coil with a sling to the height of the mandrel;
4. Insert the coil on the mandrel and stop it on the back coil keepers;
5. Expand the mandrel while maintaining the weight of the coil with the lifting equipment; Expanding the mandrel with the weight of the coil on it can damage the adjustment screw;
6. Add the last three coil keepers (see figure 2.2.2);
7. Clamp the pressure arm and secure everything in place.

***** NEVER UNSTRAPED THE COIL BEFORE PUTTING THE PRESSURE ARM. THIS MAY LEAD THE COIL UNFOLDING AND OPERATORS GETTING HURT *****

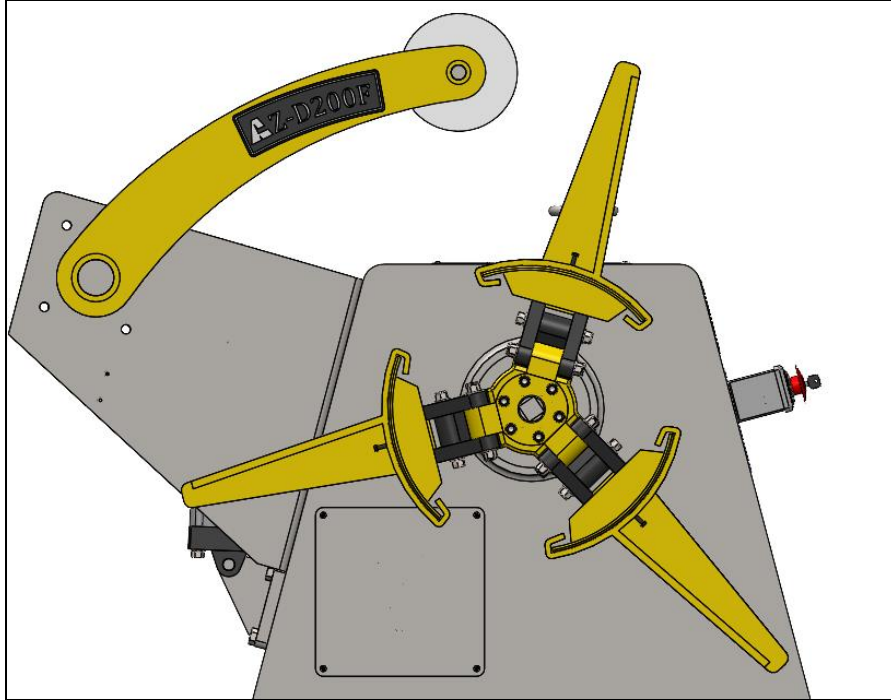


Figure 2 : Installation of the pals on the mandrel

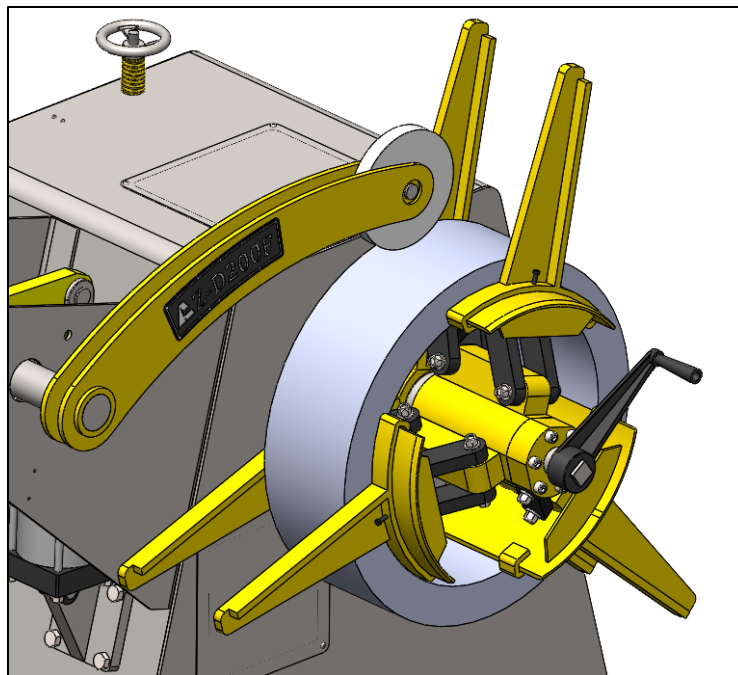


Figure 3 : Coil installation and pressure arm



2.3 Adjusting the Manual Brake

Light tension on the brake needs to be applied only when the decoiler tends to continue spinning even if the motor is stopped. when the coil is pulled forward. Simply rotate the handle clockwise to add tension. See Figure 3 below for more details.

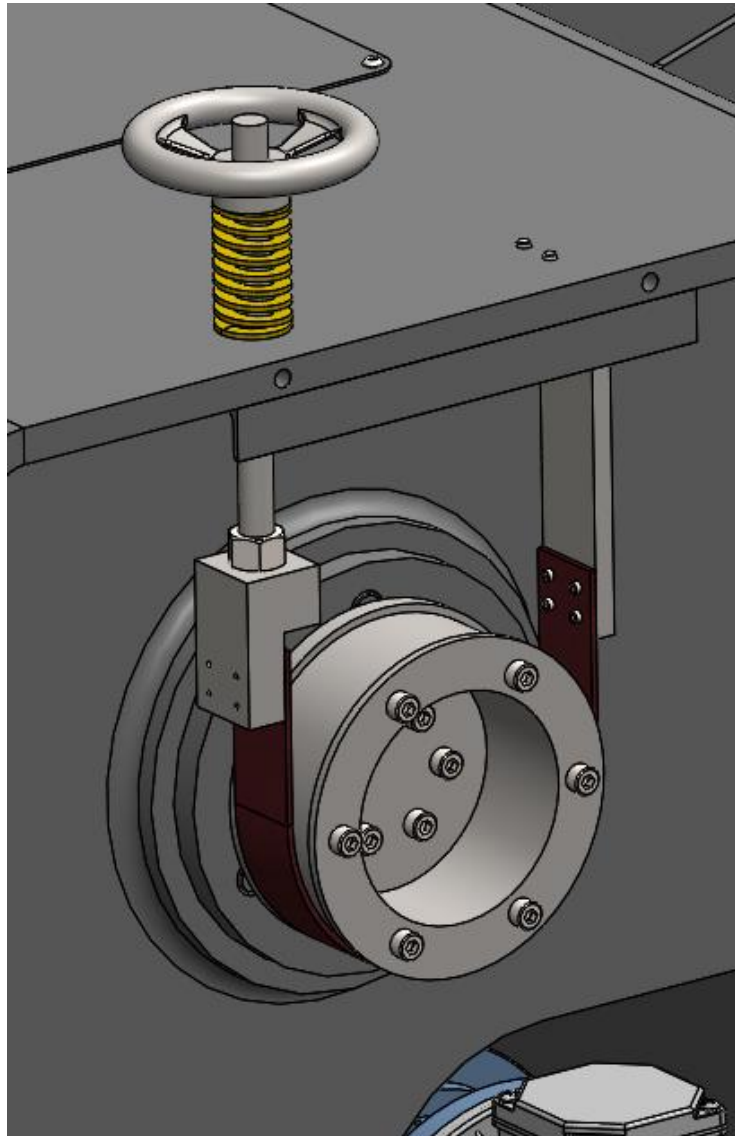


Figure 4 : Decoiler brake



3 MAINTENANCE

3.1 Machine Routine Maintenance Needs

- The condition in the air system (dryer/lubricator), daily oil checks should be made and the water must be emptied. Verify if there is a leak and if the pressure is normal.
- Electrical components and machine functionality (loop sensor, e-stop, valves, oil pressure, brake and all switches) should be checked daily to ensure the proper functionality of the system.
- Before working with the machine, operators must check all the working parts, should do the checks against the possibility of loosening and dismantling due to the vibrations occurring during feeding. Uncommon sounds are a good sign of malfunction.
- Lubricate guidance rollers and screw shafts regularly.
- Periodically lubricate all the bearings and gears according to the maintenance chart.
- Periodically lubricate the expansion mandrel and pressure arm cylinder according to the maintenance chart.
- Lubricate and check the tension of the mandrel chain. Chains should be moving forward and backward equivalent to the width of a link.
- General maintenance and checks on the machine are mainly focused on abrasion and moving parts. Verify the following parts according to the maintenance chart. For further details, go to Appendix I.
 - Gearbox sprocket: AZ-D200F(H)-3003-00.
 - Shaft bearing: AZ-D200F(H)-1007-00
 - Mandrel chain: AZ-D200F(H)-0001-00.
 - Mandrel sprocket: AZ-D200F(H)-2003-00.
 - Mandrel shaft locknut: AZ-D200F(H)-2006-00.
 - Brake: AZ-D200F(H)-6007-00.
 - Pressure arm bearing: AZ-D200F(H)-2004-00



Table 1 Routine maintenance needs

Parts	Daily	Weekly	Monthly	Biannual
Conditioning oil control	✓			
Guidance rollers		✓		
Lubrication of bearings		✓		
Lubrification of expansion mandrel		✓		
Lubrification & tension of chains			✓	
General maintenance and checks of the machine				✓
Oil tank and hose control		✓		✓

3.2 Machine Troubleshooting Instructions

For any requests regarding troubleshooting or issues with the machine, contact the following authorized personal.

For mechanical requirements:

- 450-632-8080 x 204

For electrical or programming requirements:

- 450-632-8080 x 205



5 OPERATING THE DECOILER

This section explains how to operate the decoiler. Please make sure to understand these instructions before attempting to operate the machine

5.1 Using the Operator Station

The operator Station allows the user to start and stop the decoiler and operate its safeties.

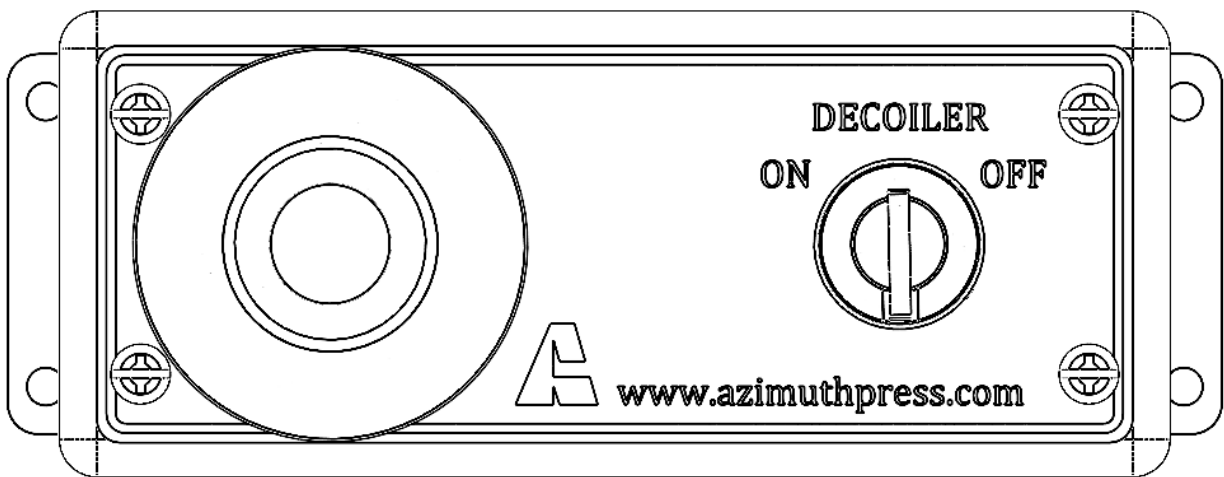


Figure 5 : Operator Station

The key selector switches between on and off to activate the pressure arm.

The Emergency Stop button immediately stops the decoiler and should only be used to stop the decoiler when there is an emergency. **Using it unnecessarily or frequently while the decoiler is running can cause premature wear on the motor drive and may cause problems with the sequence of the machine.**

When activated, the Emergency Stop button cuts the power to the motor, causing the decoiler to rapidly decelerate to a full stop.



APPENDIX APPENDIX I: AZ-D200F OVERALL DRAWING

