

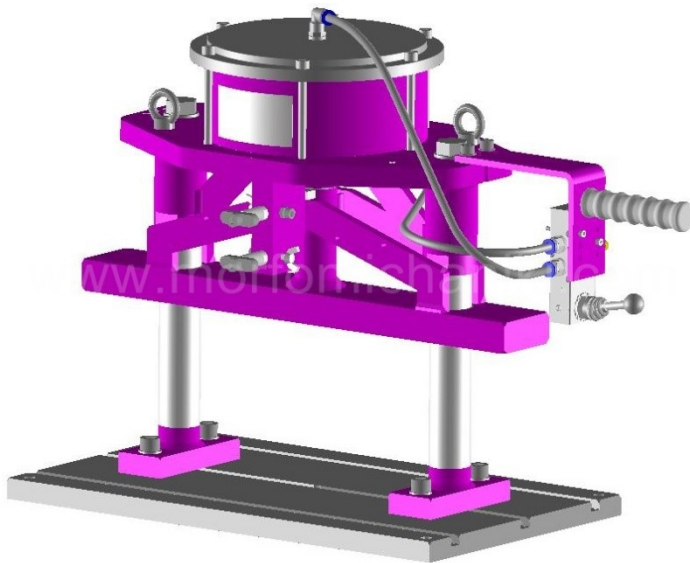


MORFOMICHANIKI LTD

AIR PRESS MACHINE

USER'S MANUAL

Version 2.2012



Designed and manufactured by Morfomichaniki



Translation
Μετάφραση
перевод
ترجمة
Traducción

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Editor: Loizos LOIZOU

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1. GENERAL

1.1 Description

MORFOMICHAНИKI air press machine is a registered industrial design (R) and generally is used for cuts ([punching](#)) on aluminum profiles and for other industrial purposes. The installed tools are customer's choice. Visit our web site for details about tools referring to the tool number that is located on each tool.

Please read carefully this manual and all labels on the machine before use. There is a big danger for amputation, other injuries or damages on the machine and the tools in case you do not follow the safety instructions.



1.2 Pressing force

At 6 bar 2 ton, at 9 bar 3 ton (1N=0.102Kg, 1ton=1000Kg)

1.3 Weight

Machine: 66Kg (without cutting tools)

Table: 16Kg

Wooden box: 19Kg (1030mm x 520mm x 620mm)

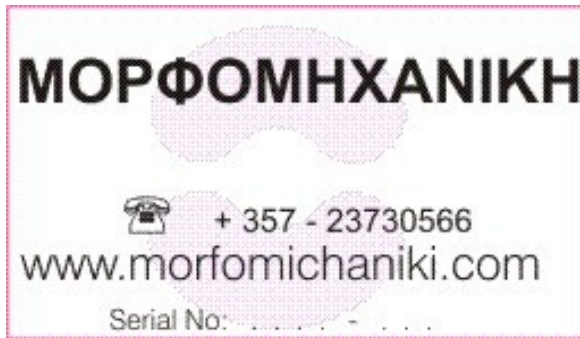
Cutting tools: 3Kg average (use this number only for rough calculation of a package weight).

1.4 Size

Machine: 500mm x 300mm x 470mm

Table: 480mm x 480mm x 900mm

1.5 Machine identity



The identity of the machine is determined by the Serial No. and it is shown on the front label of the machine.

Morfomichaniki keeps full data for each machine referring to the Serial No.

2. SAFETY

2.1 Label on the machine



2.2 Label TA12 in the shop near the air press machine

SAFETY RULES FOR PRESSES

1. PRESS MACHINES ARE BEING USED ONLY BY THE AUTHORISED PERSONS THAT ARE SHOWN ON THE TABLE "AUTHORISED MACHINE'S USERS"
2. VISITORS ARE PROHIBITED TO BE NEAR THE PRESSES
3. WORKING ON A PRESS IS BEING DONE BY ONE WORKER. NEVER TWO TOGETHER
4. PREFER AIR PRESSURE AROUND 7-8 bar AND NEVER MORE THAN 10 bar
5. REMOVE CUTTED PIECES WITHOUT PUTTING HANDS IN THE TOOLS
6. SPRAY THE CUTTING TOOLS WITH REQUIRED FLUIDS
7. COVER THE PRESS AFTER EACH USE, WITH ITS COVER
8. DO NOT CHANGE THE HAND VALVE WITH A FOOT VALVE
9. IN CASE OF PROBLEMS CONTACT THE MANUFACTURER
10. THERE IS A BIG DANGER OF AMPUTATION, INJURIES OR DAMAGES ON THE MACHINE AND THE TOOLS IN CASE YOU DO NOT FOLLOW THE SAFETY RULES

TA12 19-3-2010

2.3 Label TA22 in the shop near the air press machine

AUTHORISED MACHINE'S USERS

Put in the box the name of author and the date of authorization

Machine Worker	1	2	3	4	5	6	7	8	9	10	11	12	13

TA22 20-6-2010

***BASIC for the safety of the staff is that the one hand keeps the profile and the other is pushing the handle of the air valve

***This machine is not designed to be used by people with a physical sensory or mental impairment or people without knowledge or experience, unless they are supervised or given prior instructions concerning the use of the appliance by someone responsible for their safety. Children must be supervised to ensure that they do not play with appliance.

3. LOADING

3.1 Transportation package loading Box hanged on two belts 3m each.



Forklift also can be used



3.2 Air press loading

Unscrew the cover of the wooden box and take out the table first.



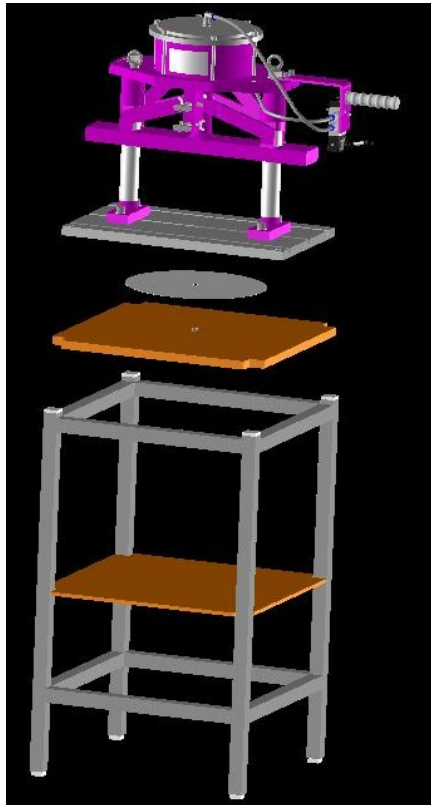
Unscrew the machine from the box and then hang the machine on the two hangers.



4. ASSEMBLY

4.1 Positioning the air press machine on the table

Never touch tools when you move the machine. Touching the tools could cause an injury or moving of the tools. Focus at the sign on thick wood "This side down"



The machine should be able to rotate on the table and axis of the rotation should be the pin in the center of the wood.
Note that the table should be ordered as accessory.

4.2 Pressured air connections

Use auto coupling [RECTUS TYPE 26](#) to connect to the machine. In case you want to use other system than RECTUS it must be similar to RECTUS TYPE 26 ([auto coupling](#)). If you do not use auto coupling it will not be able to assembly tools on the machine and also it will not be able to run all the maintenance actions.



Air pressure must be from 6 to 8.5bar. NEVER use higher air pressure than 10 bars.

When air is connected to the machine, the machine it is up (open).

All air parts' connections on the machine are ¼ BSP.

4.3 Tool assembly

This chapter is only for people authorized by Morfomichaniki. Authorization is given only for one tool number and it is not valid for other tool numbers.

Refer to the specific tool instructions to assembly it on the machine.

Technical Tip 1: Blow air with air-pistol in order to move the press a little up or a little down.



Click on the photo to watch the video

Technical Tip 2: When the press is down and you have just installed a tool and you want to put air into the machine, keep the valve handle down. After the air is in the machine move the handle slowly-slowly up. During this upward movement you will feel if the assembled tool is correctly centered. In case that the male is touching the female the tool is not correctly centered.







Technical Tip 3: Most tools can be checked by eye if they are correctly centered.

Technical Tip 4: For tightening screws the torque must be 46Nm for M8 (In case screws are supplied by Morfomichaniki or in other case they should conform to DIN 912/quality 12.9). Practically you can have the same torque by using long (180mm) “ALEN key 6mm” and tighten until the key bends.

5. MAINTENANCE

5.1 Lubrication

Wurth (Cut & Cool Cutting Oil)	Brunox	WD40	KENT WHITE GREASE III
			
Cutting fluid	Cutting fluid and short time preservation		Long time preservasion
Every 10 cuts on the used tool	Every Week		On brand new machine and Every 3 months and for transportation
On the cutting parts of the used tool	On all parts of all the tools		On all parts of all the tools

We expect you to give us information about other lubricants you use in order to evaluate them.

5.2 Cleaning

Clean the machine using pressured air. Use glasses to protect your eyes.



In case you have to use hands take out the air before cleaning.

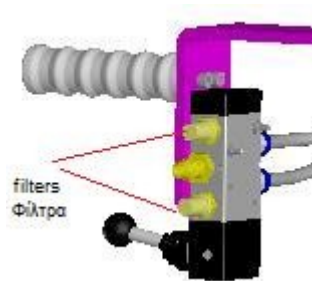
Cover the machine after finishing production.



5.3 Pressured air

Keep air dry

Change the air filters-silencers on valves in case the machine moves very slowly.



The installation of air tubes diameter 8mm is shown in the total icon of the machine in the front page of this manual.

5.4 Damaged or failing tools

Contact MORFOMICANIKI if there is anything that makes you feel that any tool is not working properly. Contact also MORFOMICANIKI when one of the following appears:

1. Broken tool
2. Not clean cut
3. The profile cannot be positioned easily
4. The profile cannot be removed easily
5. The tool has moved
6. The surface of profile is being scratched

It is better if you contact Morfomichaniki as soon as possible, because usually the problem becomes bigger gradually and the biggest damage for the tool is the breakage.

6. SERVICE

6.1 Authorized service points

1. Morfomichaniki Ltd.

68 Nikis street

5288 Paralimni

Cyprus

Tel: +357-23730566

Fax: +357-23730577

Email: louis@morfomichaniki.com

Website: www.morfomichaniki.com

6.2 Service request

Refer to press machine and tool number in order to determine a tool.

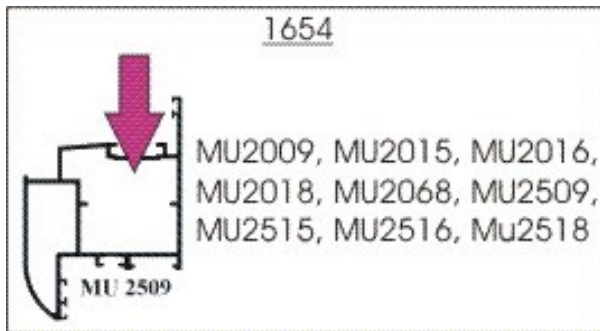
Clean the machine with air before you transport it to the service point.

Bring, at the service point, profiles with different colors in order to test the repaired tools.

7. OPERATION

7.1 Applications

Follow the label's instructions placed on the machine for each tool application. Each label shows the number of the tool, the number of the profile, the direction of the profile, the motion and the position of the cutting tool and the numbers of other suitable profiles.



For more information visit MORFOMICANIKI'S website.

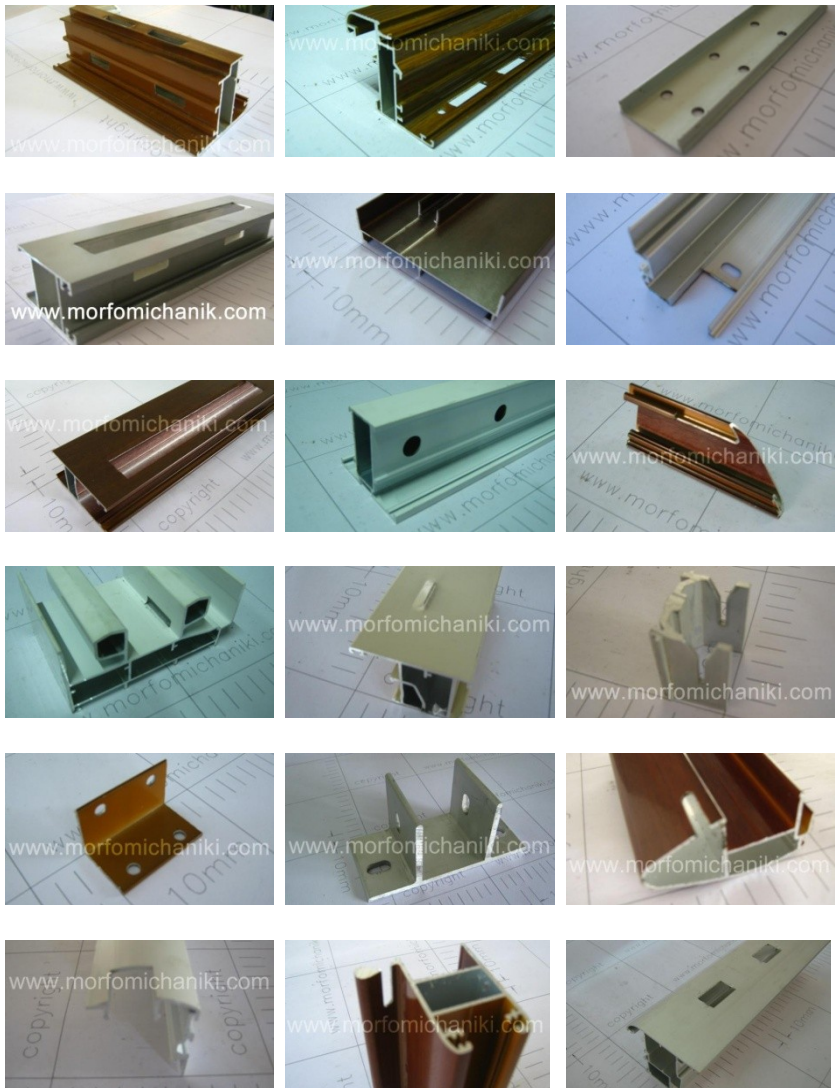
7.2 Profile handling

Use a stand for long profiles



Only one profile is possible to be punched per stroke.

7.3 Sample cuts



We can provide tools for any [kinds of punching](#) .

8. LIMITED GUARANTEE

8.1 Conditions (totally 5 conditions)

1. Guarantee for 1 year only.
2. Guarantee by prior sending to Morfomichaniki or to the authorized dealer the profile where the problem has occurred. This profile must be sent on customers cost.
3. There is no guarantee for tools that were modified by not authorized person.
4. There is no guarantee for tools or for the machine that are affected by tools modified by not authorized person.
5. The user must read this manual before using the machine and sign in the following table.

User	Name	Signature
1		
2		
3		
4		
5		
6		

9. ORDERS

9.1 By Catalogue

Ask for the catalogue of tools for the series of profiles you are working or find the catalogue in Morfomichaniki's website.

9.2 By Customer's requirements

We can develop new tools according to customer's requirements.

In order to make our offer for these we need some or all of the following information:

1. The number of the profile, the series and the manufacturer-extruder of the profile.
2. The number of the part that will be fitted in the cut and the manufacturer of the part.
3. The description (title) for the job (cut) on the profile.
4. A photo would help us to be faster.
5. Sometimes a hand sketch is enough as technical information. You can then make a photo of this sketch or scan it in order to send it to Morfomichaniki.
6. Sample profile with cut. On the profile should have written the number of the profile and the series.
7. Additional pieces of profile, length 50-55cm each for test on the punching tool. The quantity of these pieces should be available for 5-6 tests according to the length of the cut.

8. The part for assembling in the cut.
9. All the profile pieces should be prepared on saw machine in the same way as these would be used in the production.
10. In case you created your own profiles please provide us also with there PDF drawing file at the beginning of our communication. After a first step study of your profiles you will be asked to provide us with the DXF file of some drawings.