



MAKSIWA®

CBC.TPM

Automatic Edgebander

INSTRUCTION MANUAL

Model: CBC.TPM
Series Version: 00
09/2023



Attention: Read this manual before using the machine.

Greetings,

Congratulations, you just purchased the CBC.TPM – Maksiwa Automatic Edgebander, which was developed with the Maksiwa's highest standards of technology and quality. Your Edgebender allows you to have the highest productivity in woodworking. Besides a great finish, the CBC.TPM ensures that your work pieces come always precise. It should be noted that to use this machine with maximum efficiency, you should read and understand the instructions in this manual. Visit our website to know about our launches and other product lines:

www.maksiwa.com

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1 SAFETY REGULATIONS

Read all instructions in this manual. Failure to follow all instructions listed below may result in personal injury and equipment damage. **WARNING:** When using electrical equipment, always follow the safety precautions to reduce risk of fire, electric shock and personal injury. The manufacturer declares that they are not liable for damages to person(s) or object(s) which may be caused by failure to comply with the safety regulations.

1.1 Workspace

- Keep the work surface clean. Disorganized surfaces and areas are an invitation, for accidents in the work place.
- Do not use the saw in hazardous environments. Do not use the machine in places that are damp, wet, exposed to rain, or in the presence of flammable liquids or gases. Keep your work area well lit.
- Visitors must be kept at a safe distance from the workspace. Take the appropriate precaution by using padlocks or following the appropriate lock-out-tag procedures.

1.2 Electrical Safety

- Ensure that your power supply is in accordance with the rating of the machine. A 10% increase or decrease in voltage will cause power loss and overheating. All Maksiwa equipment is factory tested. If this Machine does not operate properly, first check the power supply.
- **CAUTION: WHEN SERVICING OR REPAIRING THE MACHINE, ONLY USE OEM PARTS.**
- The plug used for the machine must be rated for the correct voltage/Amps and compatible with the electrical outlet. Never modify the plug.
- Do not use any adapter plugs. Using the correct plug (without modifications) with the correct outlet will reduce the risk of electrical shock.

1.3 Personal Safety

- Stay alert, pay attention at what you are doing and use common sense when operating the machine. Do not use the machine when you are tired or under the influence of drugs, alcohol, or medication. If distracted, while operating the machine, it may in result in serious personal injury.



ALWAYS USE PROPER PROTECTION WHEN OPERATING THIS EQUIPMENT.

- Always wear safety glasses, face protection, safety anti-slip shoes, and ear protection to reduce personal injury.
- Always wear safety glasses, face protection, safety anti-slip shoes, and ear protection to reduce personal injury.
- Do not wear loose clothing, gloves, chains, rings, bracelets or other accessories. It is also recommended to use hair protection.
- Do not over stretch to reach. Keep balanced and feet firmly planted at all times.
- Disconnect the machine from the power supply before servicing or performing repairs.
- Reduce the risk of unintended starts by making sure that the main power switch is turned off before plugging the cord into the outlet.
- Use recommended accessories. Refer to the instruction manual to check the recommended accessories. Improper use of the accessories may cause personal injury.
- Never stand on the machine. serious accidents can occur if the machine is tilted.
- Your safety is your responsibility. Serious risks are involved when working with machinery.
- Always focus on the job, do not operate machine when tired.
- Never use in dangerous environment such as in damp, wet location, or expose under the rain.
- Never leave machine running without attention.
- Never open the protection cover while the machine is still running.
- The machine operator must not be younger than the minimum age established by legislation and must also be fully qualified to work with this machine.
- Many accidents are caused by appropriate clothing and personal objects (i.e. bracelets, watches, necklaces etc.). Make sure that buttons are securely fastened.
- Do not wear ties and tie back long hair.
- Wear approved footwear and safety glasses for your eyes at all time.
- The machine and working area around it must always be kept clean, keep well lighted and ventilation.
- The use of safety devices is obligatory and must never be removed, modified or damaged. The manufacturer declines all responsibility if safety devices are modified in any way.
- In exceptional working conditions the safety devices provided with the machine may be insufficient. It is your responsibility to make and fit the necessary additional safety devices.
- All work on electrical components must be carried out by a qualified electrician.
- All maintenance work must be carried out with the machine switched off, padlocked, the compressed air tube disconnected from the fast Snap-on fitting.
- Use only cutting tools in good condition. In any case avoid using a hammer. Screws, nuts and bolts must be tightened with a proportional strength, neither too slack nor too tight. Use only the tools given just as they are without altering their strength.

1.4 Machine Safety

- Turn off the machine, unplug the power cord, and wait until the working process stops, before performing any maintenance or adjustments to the machine.
- Do not overload the Machine, it will perform the job better and safer if used as indicated.
- Do not force the machine by performing a job for which it was not intended for.
- Inspect the machine. Keep it in a clean and neat condition for optimal performance.
- Follow the instructions on lubricating and changing accessories.
- Check the alignment of moving parts and for any damaged parts, before continuing to use the machine. A part that is damaged should be carefully examined to determine, if it is functioning properly and if it will affect the machines.
- Do not use the machine if any the switches do not work properly.
- Never leave the machine running unattended.
- Turn off the main power switch when not in use to prevent any accidents.
- Protect the power supply circuit with at least a fuse or circuit breaker. Do not attempt to operate the machine at any voltage other than the designated voltage.
- Do not use abrasives. Excessive heat generated by abrasive particles will damage the components.
- Do not move the workpiece or open the cover until the initiated job has stopped.
- ATTENTION: Any powder created by sanding, cutting, grinding, drilling, and other activities contains chemicals that can cause cancer, birth and other reproductive harm. Some examples of these products are: in lead; crystal silica brick, cement and other masonry products; and arsenic and chromium from chemically treated wood.
- CAUTION: Do not connect the machine to the power outlet until this manual is read and understood Never perform operations hands-free. Think, "How can I avoid accidents?".
- Always wear safety goggles. Turn off the power and wait for the machine to stop and cool before starting to service or making adjustments.

2 INTRODUCTION

2.1 Scope and objective of the manual

This manual is for the operator and all staff who have the responsibility of using the machine correctly, keeping optimum safety conditions at work at all times.

The manual includes machine technical specifications, as well as the information required for its correct installation, start up, maintenance and troubleshooting. It is highly recommended to read it carefully, especially the sections related to warnings and using options, and to keep it at hand, preferably close to the machine, so it is always available for any query.

2.2 Presentation

These innovative machines represent an evolution from the renowned titanium series, transitioning into a more compact form factor. The CBC.TPM has been meticulously designed to cater to the requirements of small-scale production while seamlessly blending versatility and innovative technology to ensure a flawless edge-to-panel bonding process, resulting in impeccable finishes of the utmost quality.

To achieve this exceptional performance, the CBC.TPM is equipped with distinct functional groups, each dedicated to executing specific operations within the process, ensuring precision and efficiency at every step.

2.3 Reference regulations

The CBC.TPM Edgebander is designed and built in accordance with current regulations and legislation:

- European regulations: 2006/95 / CE, 2004/108 / CE, 2006/42 / CE
- 2006/95 / CE Low Tension Regulation
- 2004/108 / CE CEM Regulation
- 2006/42 / CE Machinery Regulation
- Harmonized regulations: EN 14121: 2007, EN 60204-1: 1999, EN 13849-1: 2008, EN 953: 1998, EN 1088: 1996 and EN 13850: 2007

2.4 General warnings

The correct use of the machine implies precise knowledge of this manual and all the risks derived from its misuse. Only authorized personnel must use the machine.

The correct operation of the machine is guaranteed for the functions and materials specified in this manual. MAKSIWA assumes no responsibility when the machine is used for purposes not indicated and not in accordance with the manual.

MAKSIWA is not responsible for the security, reliability and performance of the machine if the warnings and suggestions referred to in this manual are not respected, particularly with regard to assembly, handling, preventive maintenance and repair activities.

The electrical installation for the machine must be in accordance with USA Regulations and Harmonized Regulations detailed in section 1.3 of this manual. The manufacturer denies all kinds of responsibility in the event that the machine is not correctly connected to the equipotential ground installation and consequently the protection devices are not mounted behind the machine itself. Section 5.4 of this manual refers to the minimum requirements to be considered during the electrical installation of the machine.

For preventive maintenance and repair operations, use only original spare parts or those expressly authorized by MAKSIWA should be used.

3 TECHNICAL SPECIFICATIONS

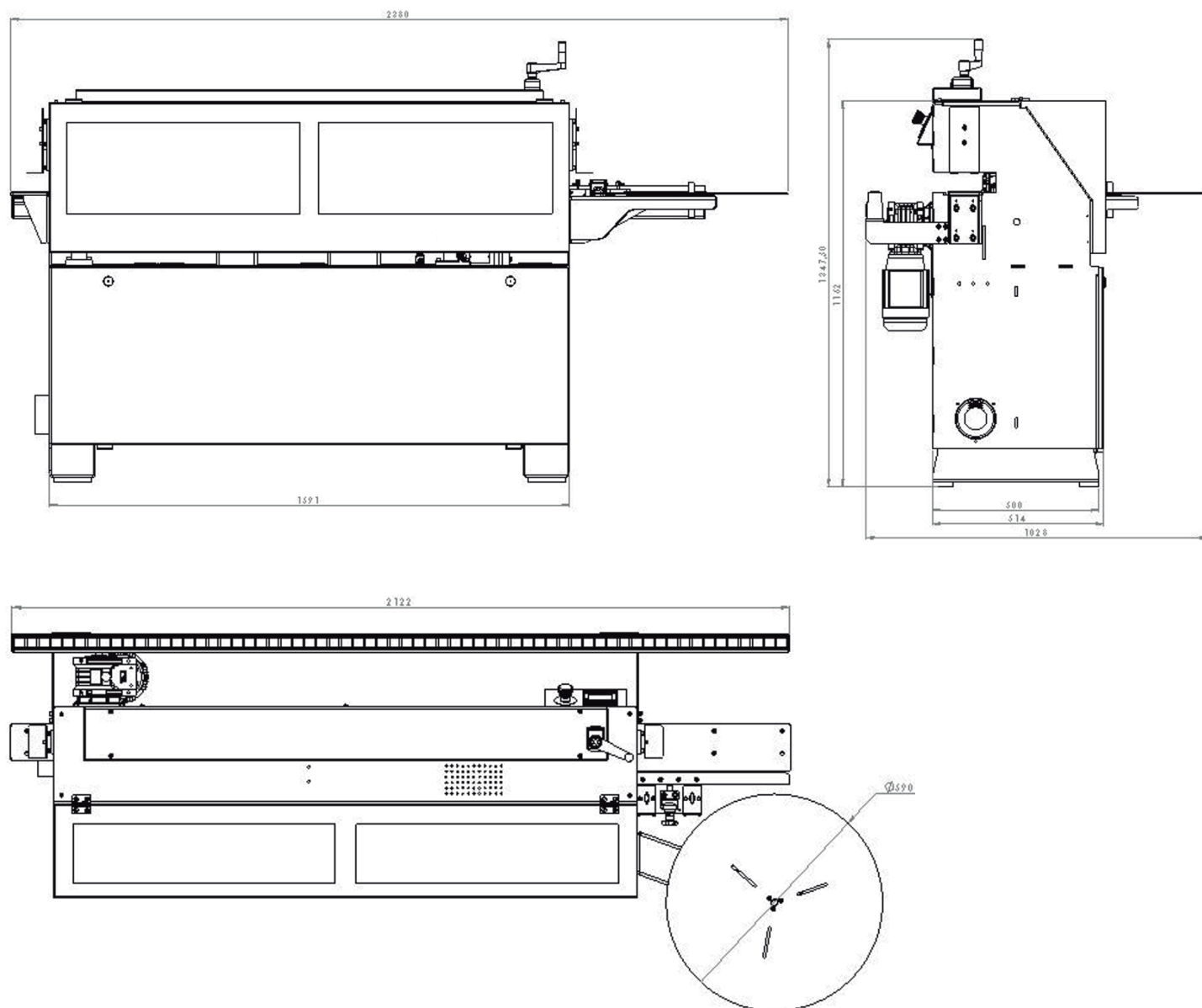
3.1 Power requirements

MODEL	VOLTAGE	PHASE	Total	Total
			kW	Amps
CBC.TPM	220V	Single phase	5.2	23.9

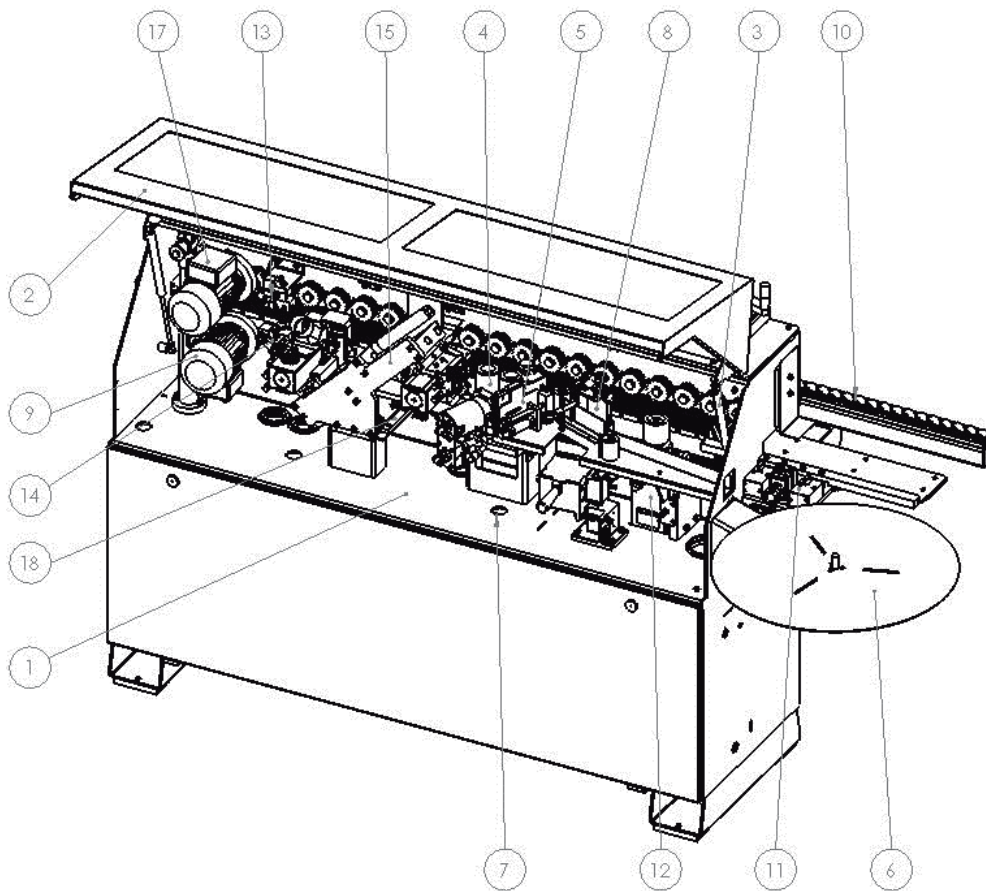
3.2 Technical details

	CBC.TPM
PANNEL THICKNESS (MIN/MAX, mm)	10 – 40
PANEL WIDTH (mm)	120
MINUMUM PANEL LENGTH	200
TAPE THICKNESS (MIN/MAX, mm)	0.4 – 2
DRAG CHAIN SPEED (m/min)	6.5
WORKING AIR PRESSURE (MPa)	0.6
DUST COLLECTOR POWER (m3/h)	1,700
MAXIMUM AIR CONSUMPTION (l/min)	200
NET WEIGHT (Kg)	500

3.3 Dimensions (Machine Layout)



3.4 Machine Configuration

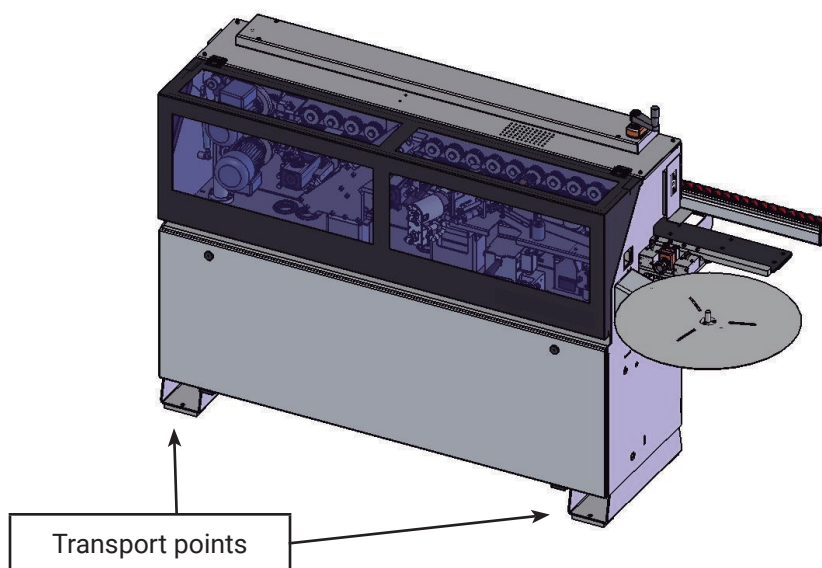


Working units list CBC.TPM - 10170207			
#	Qty.	Unit model	Reference
1	1	CBC.TPM MAIN FRAME	100332
2	1	Cabin door	1900300
3	2	gas spring 08 430 350 (Carrera 170)	5005303
4	1	Pressure rollers	700130
5	1	Tape Guide	500177
6	1	Coil Tray	1800050
7	1	Electric/pneumatic panel distribution	5005442
8	1	GLUE POT	600105
9	1	Lower buffing unit	1300039
10	1	Fixed apron	2000270
11	1	Adjustable infeed fence	200114
12	1	PRE-MILLING UNIT PF-1	400068
13	1	Glue scraper RR1 up	1200032
14	1	Glue scraper RR1 down	1200033
15	1	END/FLUSH TRIMMING UNIT T-4X	800076
16	1	5.2" screen assembly	5005584
17	1	Upper buffer unit	1100136
18	1	Handrail guide regulation X-4T	1100137

4 INSTALLATION AND START UP

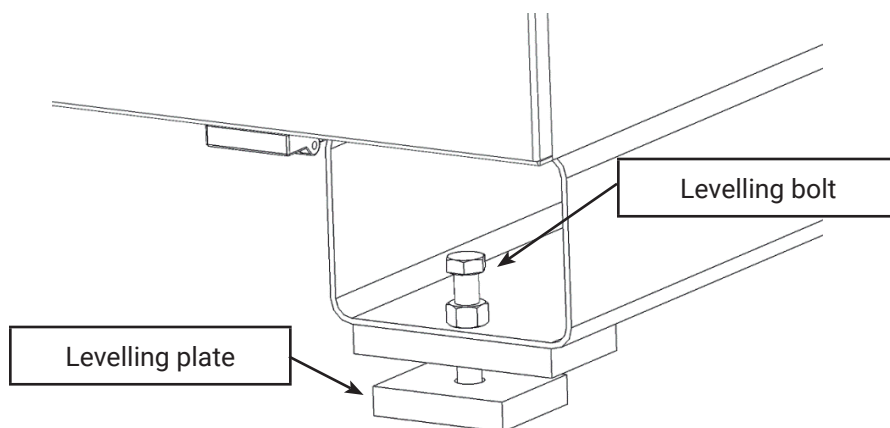
4.1 Transport

- Use adequate machinery for transport.
- Lift and transport the machine considering that the support points must be as close as possible to the transport bars.
- Be as cautious as possible when lifting and moving the machine to prevent eventual dangers provoked by unforeseen movements, which could cause damage to people or objects.



4.1.1 Level

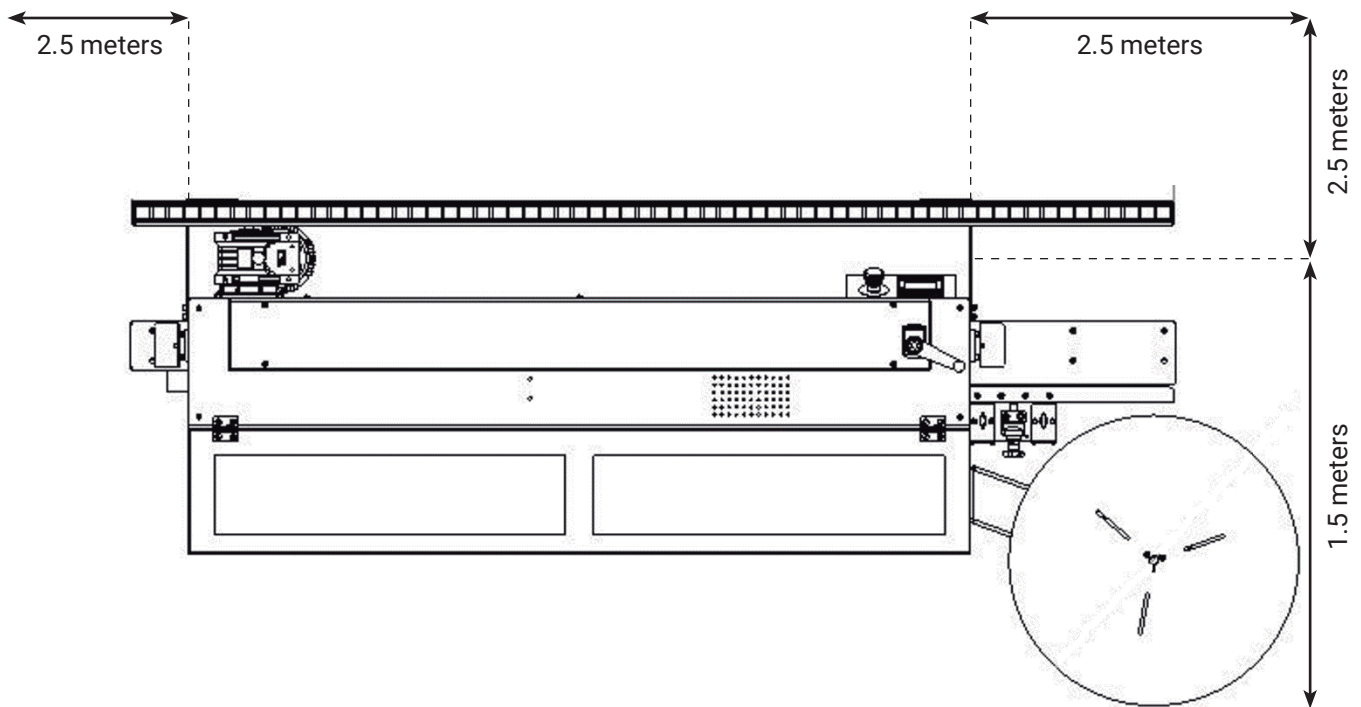
- Position the machine in a flat surface suitable to support the weight of the machine.
- Use the support plates for levelling the machine surface. Use the bolts supplied with the machine to jack and level. Check with a level on various parts of the machine.
- Perform the final leveling test by securing the panel in place and positioning the level on top of it.



4.2 Operators working area (safety position)

Place the machine in final position keeping in mind the following premises:

- A maximum of two operators are required to use the machine, one located at the entrance of the machine to introduce the raw panels and the other at the exit to collect the finished panels. Check safe working zones for the two operators are at the bottom of this page.
- The machine screen (HMI) is easily accessible to operators and is located outside any area that could be dangerous for them.
- There are no cables/hoses in the path of the machine workers that could cause any accident.
- Pay utmost attention to avoid objects that obstruct work in working zone.



4.3 Units release, Fixed apron and coil tray

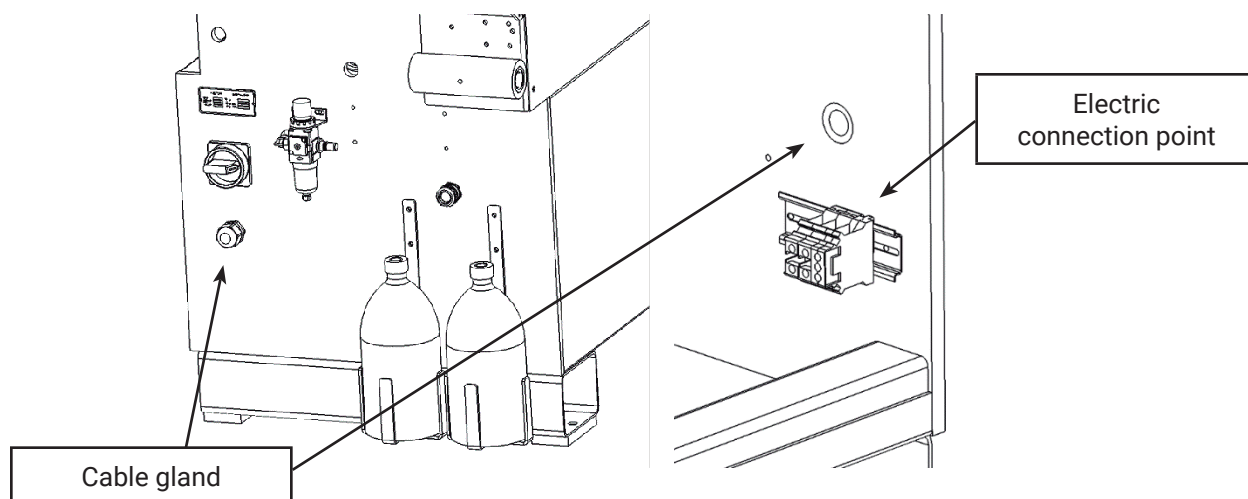
After positioning the machine, and before connecting compressed air and power supply, release all zip ties, or any other element mean for machine transport. Check the correct pneumatic and mechanical movement of the unit, ensuring that there is no damage after transport.

Proceed to install extensible aprons and coil tray. Refer to the manual of each unit for more information.

4.4 Electrical installation

Proceed with electrical installation after leveling the machine, coil tray and apron installation. Follow these guidelines:

- Installation must be in accordance with USA Regulations and Harmonized regulations.
- Availability of an equipotential ground installation.
- Availability of fuses or short-circuit and surge protection switches on each conductor wire excluding the ground wire.
- For CBC.TPM use a cable of 3 x 10 AWG (1 phase 120V + 1 phase 120V + ground = phase to phase 220V)
- Pass the cable gland to the interior of electric cabinet and connect it accordingly. Ensure that the cable will not interfere with the working zone causing any accident.



IMPORTANT: Before making the connection of the machine, check that the voltage among terminals **L0, N0** is **220V**, and Depending on your region, your electrical panel may have a high leg on one of the phases. Avoid using it, as doing so can cause irreparable damage to the machine's electronic converters and **VOID THE WARRANTY.**

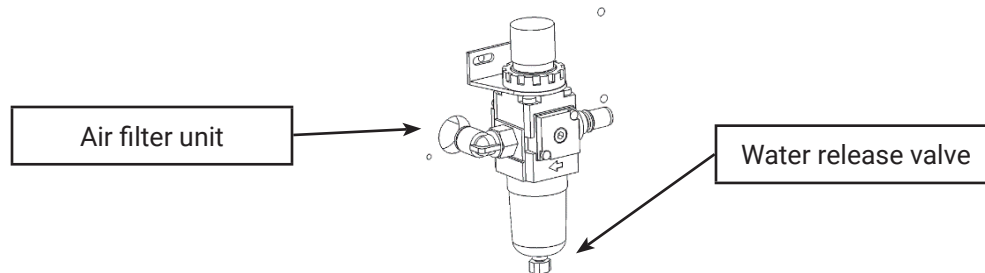
4.5 Pneumatic installation

For pneumatic connection:

Use a tube/hose with an internal diameter between 10 and 12mm and connect it to the air filter unit using with a minimum socket of 3/8" (make sure that this hose will not interfere with working zone causing any accident).

Set-up a minimum pressure of 0.6MPa and ensure a flow of 200 liters / minute. (7 SCFM @ 90 PSI)

Ensure a humidity free compressed air towards the machine and use the valve to release the water inside the filter periodically.



A poor pneumatic connection will cause incorrect movement of working units causing mechanical damage, and consequently **LOSS OF WARRANTY**.

4.6 Start and stop (first check-up)

Once the machine is in final position, connected correctly to the electricity and with pneumatic connection, now you can turn on the machine and check working units and safety systems:

- Ensure that the emergency button, cabin security and any other security system present in the machine is working.
- Check the correct height of pressure.
- Turn off all the units except the gluepot. When the glue pot reaches the programmed temperature, you can start the machine using the ON / OFF button (Start / Stop).
- Turn on all the units one by one and check the correct functioning of all according to your work.



NEVER USE THE EMERGENCY STOP TO STOP THE MACHINE UNDER ORDINARY WORKING CONDITIONS. USE IT ONLY IN EXCEPTIONAL EMERGENCIES.



MAKSIWA FORBIDS REMOVING OR MODIFYING THE MAGNETIC SAFETY DETECTORS, WHICH CAUSE THE MACHINE TO STOP WHEN THE CABIN DOOR IS OPEN. IT IS ALSO FORBIDDEN TO START THE MACHINE WHEN ANY OF THE CONNECTORS IS NOT OPERATIONAL OR DISABLED.

5 MAINTENANCE AND CLEANING



BEFORE STARTING PREVENTIVE MAINTENANCE, DISCONNECT THE MACHINE ELECTRICALLY AND PNEUMATICALLY. INSTRUCTED STAFF MUST PERFORM THIS PROCESS.

5.1 Daily preventive maintenance

Daily, before starting using the machine, perform the following operations:

- Check that there are no elements obstructing the correct movement of units and motors since any obstruction could damage the groups or cause personal injuries.
- Verify that pressures are correct.

Daily, after using the machine, perform the following operations:

- The working area should be cleaned using pressure air to remove chips and material residues that may settle over the working groups and jeopardize the machine's proper operation. Pay special attention to cleaning the drag chain pads. An inadequate cleaning will cause the remains of material in the pads and thus prevent the proper sliding of panels, also generating irregularities on the surface that lead to further pressure beam adjustment.
- Check the condition of cutters and tracers.

5.2 Weekly Maintenance

Perform the following operations once a week:

- Conduct all the daily maintenance detailed previously.
- Cleaning of the glue pot to leave it empty and remove any trace of glue.
- Check the safety level of the electrical installation.
- Check the status of tools (pre-milling, End/Flush trimmer cutters).
- Raise the pressure beam, clean the wheels, and drag chain pads with a specifying cleaning product.
- Lubricate the chain slightly with synthetic fluid grease.
- Draining the filter group to remove water and impurities.

6 SAFETY

6.1 General safety rules

- Only a trained operator can use the machine to ensure the correct use of the machine as well as its protection devices and accessories. Carefully read this manual to learn about safety devices usefulness, limitations, and potential dangers.
- Only a trained technician should connect the machine.
- Perform the machine adjustment and regulation according to this instruction manual.
- Conduct preventive maintenance processes as often as required.
- Before starting each job and before starting the machine verify that control and working devices are always free of chips from the previously edged material.
- Before performing any operation on the machine, make sure that there are no obstacles around the working.
- Do not place flammable substances near the machine since any spark could cause explosion or fire.
- The operator must always keep in mind the risks before approaching the most dangerous areas with his hands.
- Never remove the protections from the glue pot since they avoid any risk of burning for the operator.
- Always turn off the machine when not in use.
- Do not touch or manipulate areas that move without having switched off the machine and without making sure that there is no residual movement.

6.2 Personal Protection Equipment (PPE)

The following PPE will be required, depending on the work:

- Eye protection: during preparation work.
- Safety shoes.
- Dust protection mask when cleaning the machine.
- Protective gloves: when handling hot parts, glues or cutting tools.
- Acoustic protection.
- Working clothes: the operator should NOT wear loose clothing that could be an obstacle or snag. Do not wear either tie, bracelets, rings, etc.

6.3 Environmental and noise limits

The environmental and noise limits for safe operation are listed below:

Environmental and noise limits		
	MINIMUM	MAXIMUM
ENVIRONMENT	INDOOR USE ONLY	
WORKING TEMPERATURE	18° C	50° C
STORAGE TEMPERATURE	- 20° C	70° C
HUMIDITY	20% relative humidity without condensation	90% relative humidity without condensation
HEIGHT	Sea level	1.800 m
ISSUED FROM ALL MACHINE AREAS DURING USE IN A TYPICAL OPERATOR POSITION	70 dB	≥ 85 dB

6.4 Procedure in case of an accident of failure

In case of an emergency stop the machine with emergency button / buttons (red on a yellow background) located near the control panel. It has top priority over any other signal / status of the machine. Afterward, reset the machine as follows:

- Ensure that the hazardous situation has been resolved and that all operators are in optimal condition and in their designated safe areas before resuming work.
- Reset the emergency button by rotating it until it returns to its default position.
- Reset the machine using the display screen. For more details, see the “Touchscreen Operation Manual.”
- Use the emergency stop button properly and never to interrupt work replacing the start / stop function.
- The emergency stop interrupts all machine functions. Some groups, such as the glue pot, can be damaged as a result of downtime, which turns into serious trouble when working with PUR since it solidifies in the glue pot, becoming embedded and causing in most cases glue pot damage and replacement.



MAKSIWA IS NOT RESPONSIBLE FOR FAILURE CAUSED BY IMPROPER USE OF THE EMERGENCY STOP

7 COMMON ERRORS AND SOLUTIONS

Fault	Solutions
Machine won't start	Check if any alarm appears on the DISPLAY (for more details, read the annex "Touch screen operating manual"). Also, confirm all the exterior conditions (electricity, compressed air).
Chipping on board	The occurrence of chips may be due to the use of inadequate panel, which may even have nails inserted (for example, chipboard).
	Check the condition of cutters to verify that there are no broken blades. Proceed according to annex "Pre-milling unit Operating Manual" to conduct this operation.
Irregular edge feeding	First, check that air pressure at machine entrance is correct (0.6 MPa).
	Disconnect the machine electric and pneumatically and observe closely feeding tray and observe if the feeding system is working as it should. Check annex "Feeding user manual".
	Check that the edge roll is not caught at any stage, which prevents its natural movement (it could be the case of small strips of adhesive tape stuck at the bottom of the roll and hardly visible at first sight).
Board moves at end trim	First, carefully read the annex "Trimmer Operating Manual" and check that all pneumatic pressures are correct.
	Disconnect air pressure supply from the machine and manually check that the group performs all its movements smoothly.
	Clean the wheels and drag chain steps with a specific cleaning product.
Less radius / milling at trimmers	First, carefully read the annex "Trimmer operating manual" and check that all pneumatic pressures are correct.
	Check unit tracing: when feeding a panel, the unit must trace 1mm frontally and vertically.
Board unalignment	If it is evident that the board does not advance, maintaining parallelism and tracing throughout the process, check the correct pressure beam height along the condition of the chain pads and wheels. If necessary, clean the wheels and drag chain steps with a specific cleaning product.
	In small pieces, it is possible to tighten the pressure beam 0.5 mm more than the panel measurement. Tightening more than 1mm would mean forcing the drag chain motor to work. This causes overheating and excessive wear of the wheels and tires of the pressure beam.
	Check the tracing of the pressure rollers, for more details, read the appendix "Operation manual of the roller base".
	Verify that the pressure of the guillotine according to the appendix "Operating Manual of the Feeding Tray". In some cases, the pressure is increased to process high edge thicknesses and is not restored when the edge is changed again, causing vibrations.
Irregular gluing	First, carefully read the annex "Gluepot user manual".
	Check gluepot quantity and status.
	Verify gluepot tracing and pressure and notice that the board is not moved by any of the working groups, and the gluepot maintains uniform tracing along the path of a long board.
	Observe the condition of the gluing roller. Contact a trained technician to perform the maintenance, if necessary.
	Check that the board cutting is 90 degrees.

USER INTERFACE

Model: CBC.TPM Series HMI NB3.5Q
Series Version: 00
09/2023



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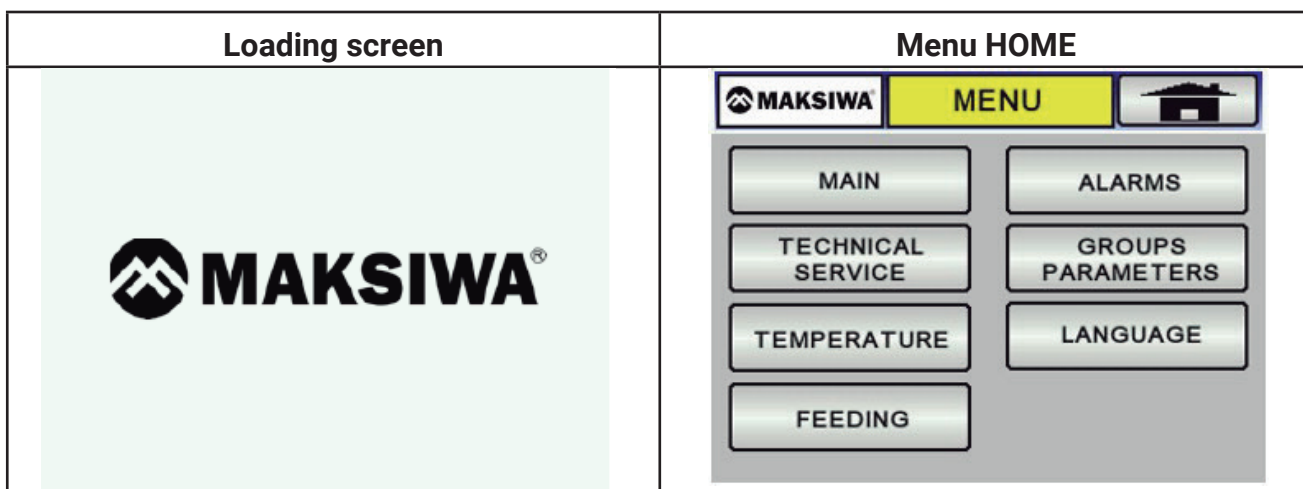
1 INTRODUCTION

The present manual is for the operators and all personnel in charge of the correct use of the machine, especially taking care of the security at the working place.

Through the programmable screen, you will have a detail Access to the function of all operative groups.

2 USING TOUCH SCREEN

The first screen that we will see on the display once we supply power to the machine will be an initial screen with the MAKSIWA logo. This screen will stay for a few seconds, and you will immediately jump to the HOME menu.

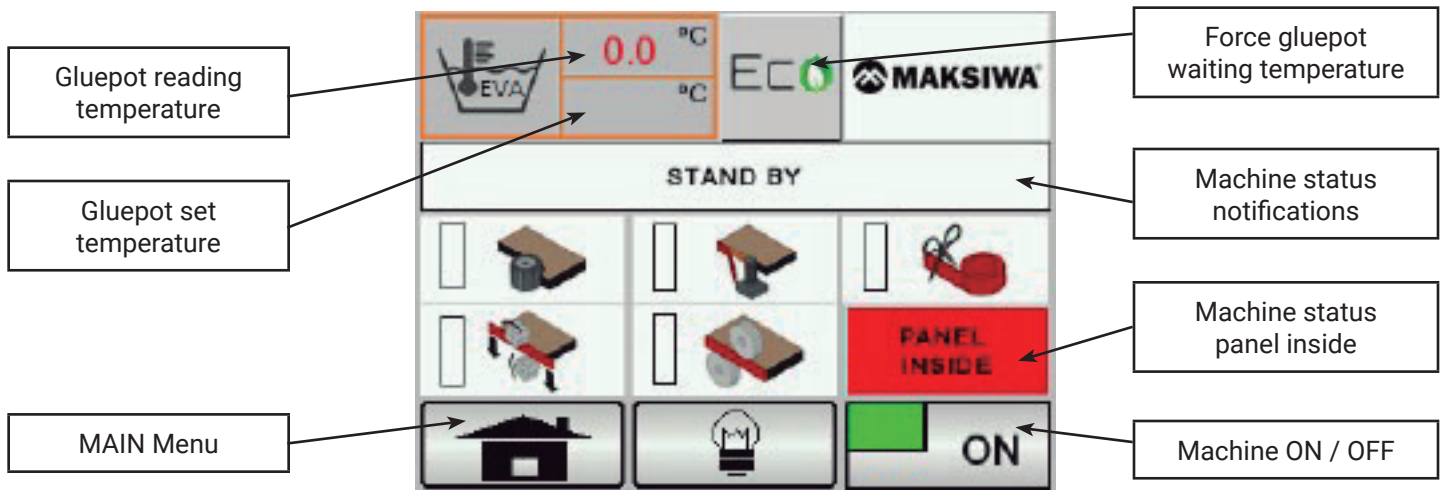


From the MAIN menu, you can access the following functions:

- **MAIN** – Main working menu.
- **TECHNICAL SERVICE** – Allows advanced machine adjustment.
- **TEMPERATURE** – Limited access to force waiting temperature (with password).
- **FEEDING** – Access feeding system ON/OFF and feeding time.
- **ALARMS** – Access to active alarms.
- **GROUPS PARAMETERS**– Access to unit settings.
- **LANGUAGE** – Allows changing HMI language.

3 MAIN

The MAIN menu summarizes basic information of the machine, shows the status of the machine, set temperature / actual gluepot temperature, status of all units, and allows access to the main ON / OFF button to start the groups.



3.1 Working units

Image	Description
	Pre-milling
	Gluepot
	Guillotine
	Trimmer
	Buffing
	Guillotine
	Units not present in machine

3.2 Machine status notifications

- **STANDBY** – Gluepot not selected from screen.
- **WAIT WORKING TEMPERATURE** – Gluepot heating to set temperature.
- **WORKING TEMPERATURE OK** – Correct work temperature. The machine is ready to work.
- **PRODUCTION** – Machine working.
- **TO WAITING TEMPERATURE**– Gluepot is cooling to waiting temperature.
- **INITIALIZING UNITS** – The machine takes 5 seconds to initialize all units after pressing “ON” button, meanwhile, it displays this message.
- **STOPPING UNITS** – The machine takes 5 seconds to stop all units after pressing “OFF” button pressed, meanwhile, it displays this message.
- **EMPTYING MACHINE** – After an alarm, the machine empties the panels into the machine.
- **WAITING EMPTYING MACHINE**– When there is an alarm, and with a panel inside the machine, screen displays this message.

4 TEMPERATURE

Limited access to force glue with password.

5 TECHNICAL SERVICE

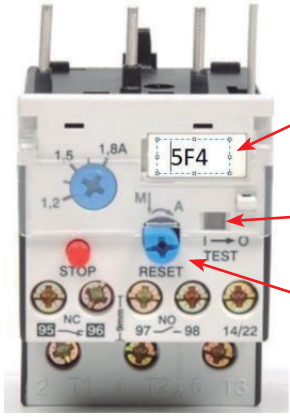
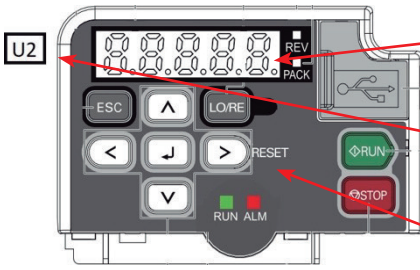
Advanced settings menu, only for qualified technicians.

6 ALARMS

ALARMS menu shows all active alarms. You can press the CLEAR ALARM button when the incident has been resolved.

6.1 Alarms list

Alarm	Possible causes	Solutions
MAXIMUM TEMPERATURE	Temperature sensor fault	Check the correct connection of the temperature Sensor.
	Solid state relay or PLC output fault	Possible electrical component failure. Contact the technical service.
EMERGENCY STOP	Emergency button pressed	Release the emergency stop button.
AIR PRESSURE	Low air pressure	Check that there is 0.6MPa (90PSI) in the general input.

LOW TEMPERATURE	Gluepot heating	The gluepot has not yet reached the minimum working temperature.
	Damaged heating elements	If after a long time, the gluepot does not reach the correct temperature, it is possible that some resistances heating elements are damaged.
SELECT MODEL	Fatal PLC error	Contact technical service to fix the error.
TOO CLOSE PANELS ERROR	Too close distance feeding panels	Panels fed very closely. In this case, you must empty the machine (remove all the panels inside).
CABINS OPEN	Cabins open	Check that the doors are closed and the door sensor is making proper contact. If the error persists, the failure may be due to a sensor malfunction.
THERMAL RELAY ALARM	Overload in a motor	 Locate the relay that caused the fault, write down the relay reference to report the fault to the authorized technical service, and press the blue button (RESET) and reset the alarm from the screen. You can disable the unit with faulty motor to continue working.
INVERTER ERROR	Low input voltage	 Locate the drive that caused the fault, write down the reference number to report the fault to the authorized technical service, and press the RESET button to be able to reset the fault from the screen.
	Faulty motor	
	Inverter damaged	

7 GROUP PARAMETERS

Only guillotine and feeding adjustment is possible without the authorization of an expert Maksiwa machinery technician.

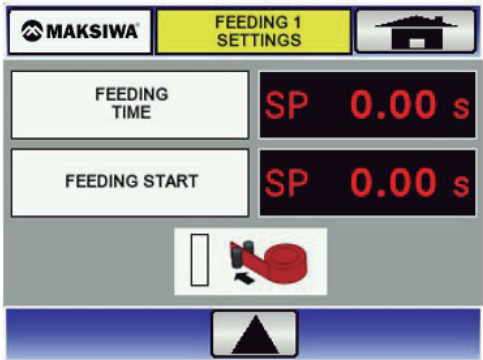


MAKSIWA declines all responsibility associated with any alteration of the parameters of the different unit by unauthorized personnel.

7.1 Guillotine

HOME menu GROUPS PARAMETERS ICON	
CUTTING TIME The time the guillotine remains active. CUTTING DELAY TIME Cutting time for the excess of the rear part.	

7.2 Feeding

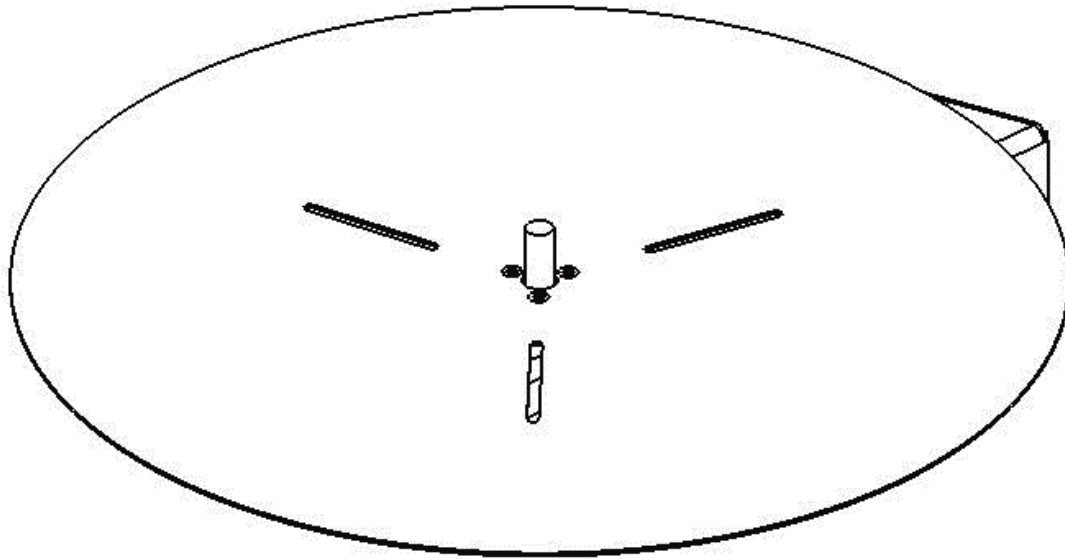
HOME menu GROUPS PARAMETERS ICON	
FEEDING TIME The time the feeding piston remains active. FEEDING START Feeding start time after limit switch trigger.	

8 LANGUAGES

It is possible to change the display language. To do this, just click on the language you want to work in.

COIL HOLDER

Model: CBC.TPM Series Coil holder
Series Version: 00
10/2023



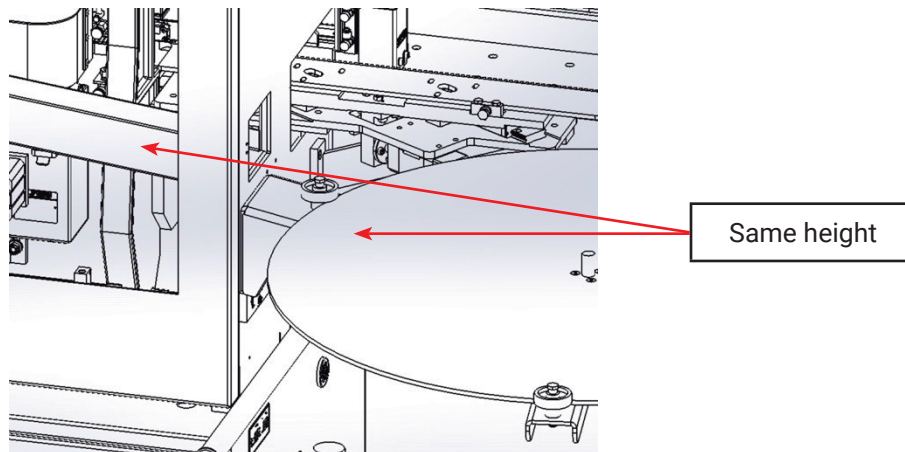
Index

1. Unit Scope and Description
2. Adjustment
3. Unit Composition

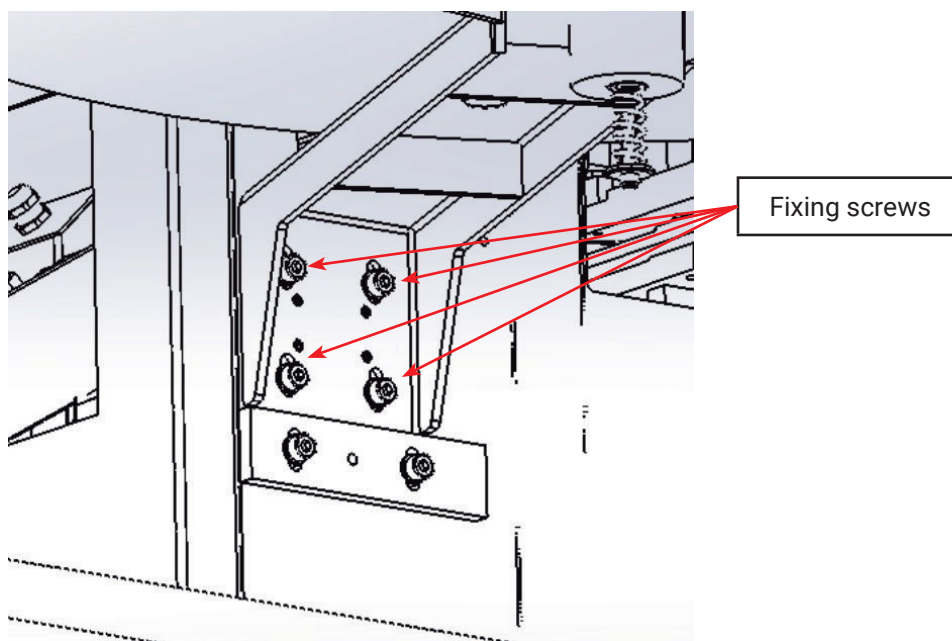
1 UNIT SCOPE AND DESCRIPTION

The coil holder supports the coil / edge while working. This unit attached at the entrance of the machine. For secure shipping, we disassemble this unit; please assemble following the adjustment instructions.

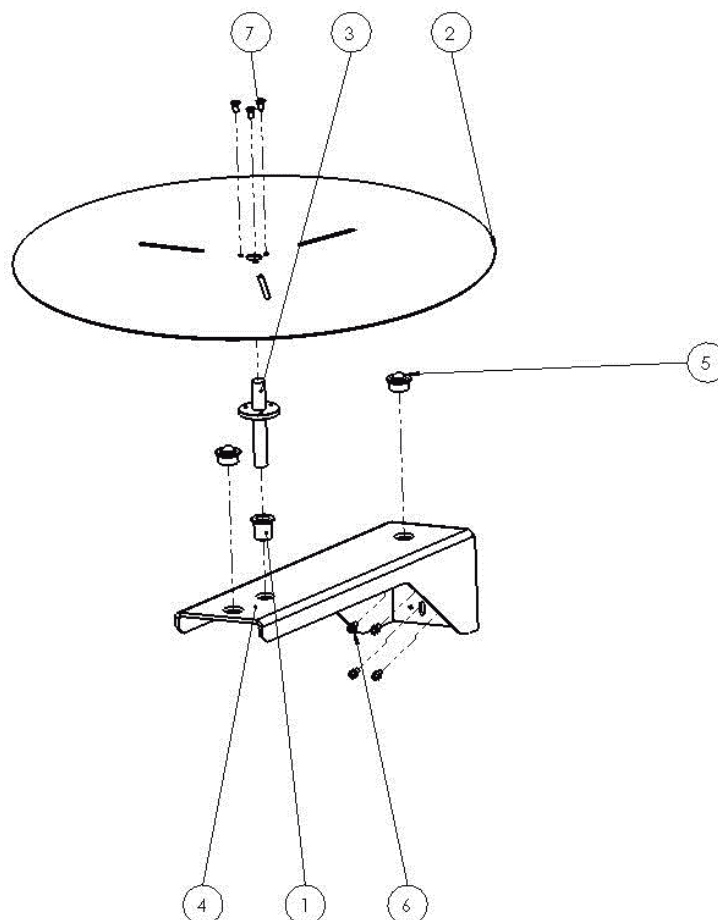
2 ADJUSTMENT



Before starting the machine, check that the coil holder disc is at the same level as the feeding tray. In case it is not at the same level, we must regulate the height of the holder as follows:



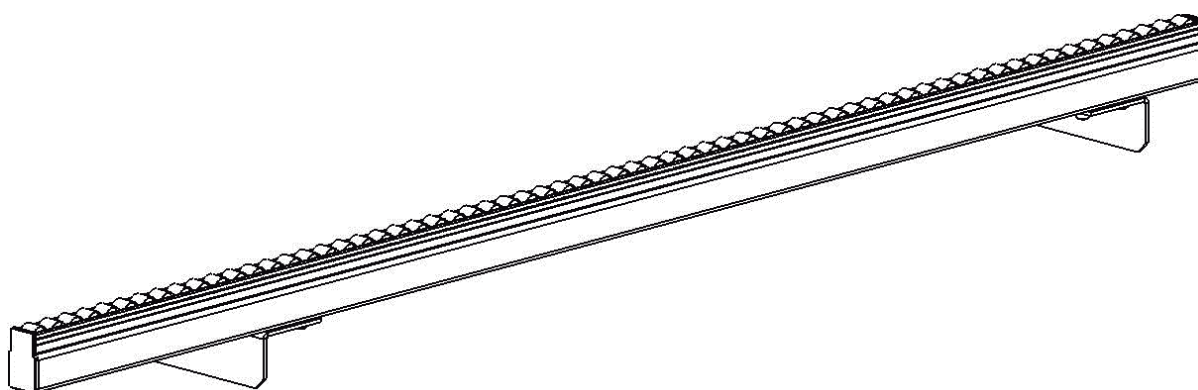
3 UNIT COMPOSITION



1800049 Coil Holder			
#	Qty.	Description	Reference
1	1	Selfoil Type B Bushing 16-22-25,28-3	102000229
2	1	D590 Disk	401006147
3	1	Coil tray shaft	404001187
4	1	shaft	407000346
5	2	Conveyor balls SPS 15 B	5002820
6	4	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
7	3	COUNTERSUNK SCREW DIN7991, M6 X12 THREAD:12mm	6320601202

SUPPORT APRON

Model: CBC.TPM Series Support Apron
Series Version: 00
06/2023



Index

1. Unit Scope and Description
2. Adjustment
3. Unit Composition

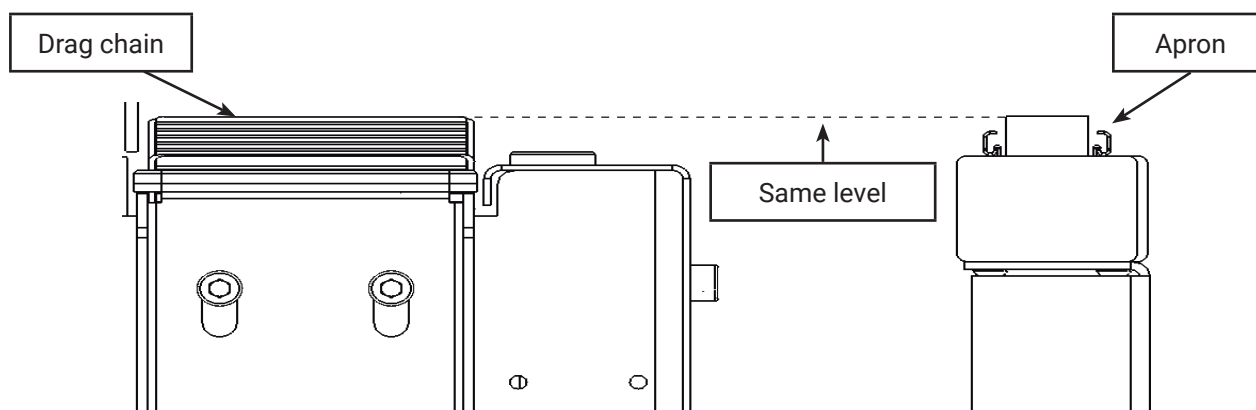
1 UNIT SCOPE AND DESCRIPTION

The function of the apron group is to help hold the panel correctly on the same level as the drag chain and slide it easily.

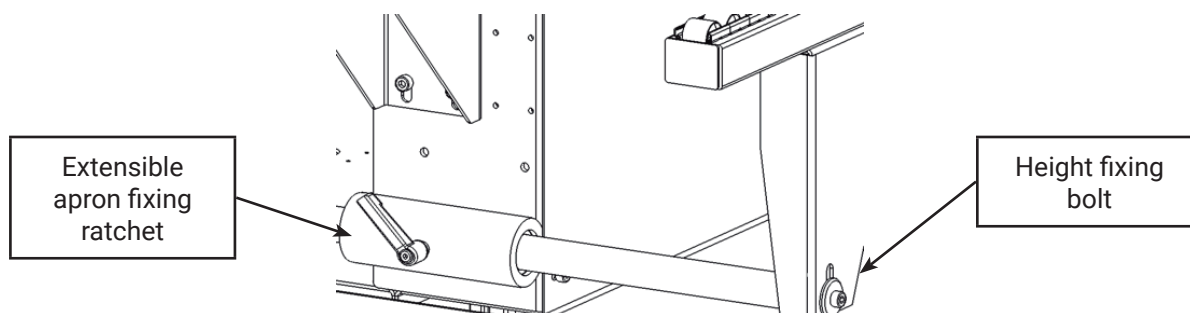
Due to the apron length and for easy transport, we supply this unit disassembled.

2 ADJUSTMENT

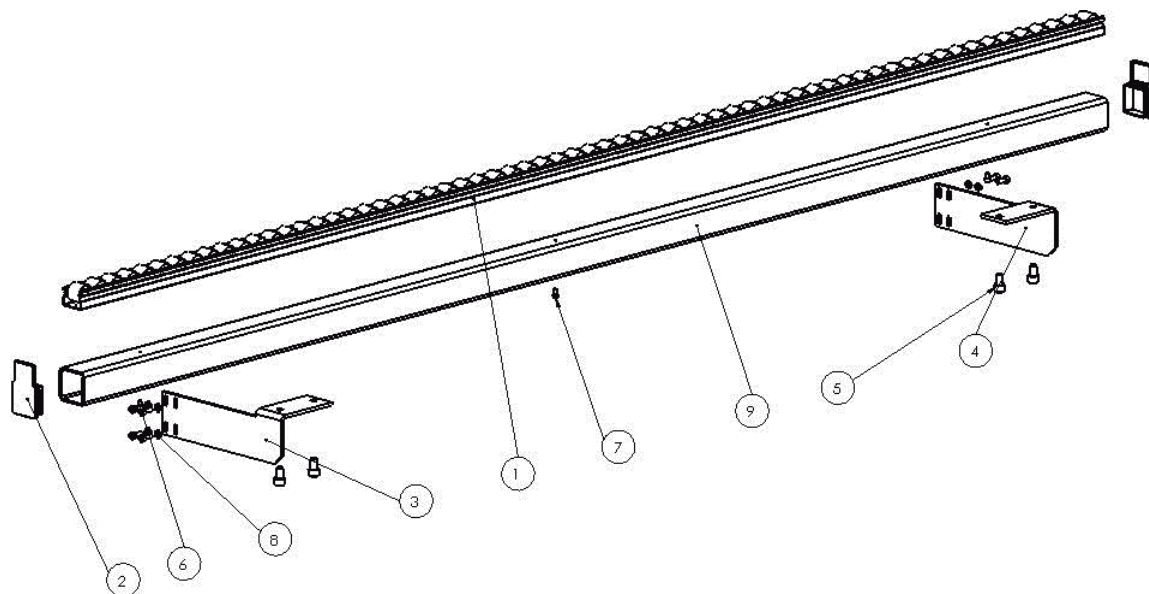
Before starting work, check that the apron is at the same height as the drag chain. On the contrary, the panel will enter tilted causing groups malfunction and obtaining an incorrect finish.



Adjust the height using height-fixing bolts on both sides of the apron arms. In addition, to adjust the apron extension, lose apron-fixing ratchet.



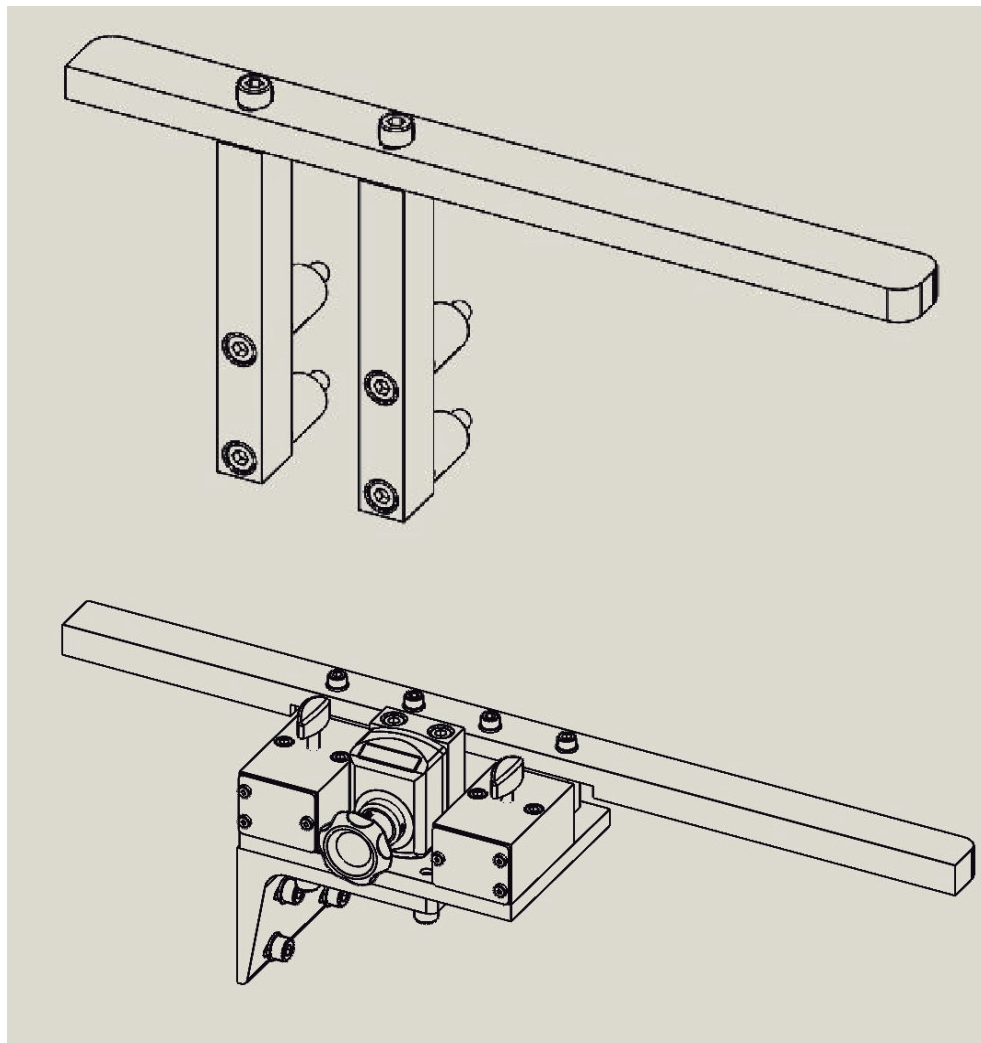
3 UNIT COMPOSITION



2000270 Fix apron			
#	Qty.	Description	Reference
1	1	Apron rail	5005421
2	2	Apron side cover	401006095
3	1	Fixed input support	401006286
4	1	Fixed output support	401006285
5	4	ALLEN SCREW DIN 912 M10 x 16 (16mm THREAD)	6311001601
6	8	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
7	3	ALLEN SCREW DIN 912 M5 x 8 (8mm THREAD)	6310500801
8	8	DIN 125 M6 WASHER	6610600001
9	1	Apron tube	405000717

INFEEDING FENCE

Model: CBC.TPM Series Infeeding Fence
Series Version: 00
06/2023



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1. Unit Scope and Description
2. Maintenance
3. Unit Composition

1 UNIT SCOPE AND DESCRIPTION

The infeeding fence guides the panel into the machine and ensures that it maintains a uniform and parallel path with the unit of the machine throughout the Edgebanding process.

In the case of the CBC.TPM Series, with mobile infeeding, you can adjust the depth of the unit easily, in this way, the pre-milling unit will remove only the thickness set.

2 MAINTENANCE



Before starting preventive maintenance, disconnect the machine electrically and pneumatically. Perform the maintenance, only if you have received proper training from a qualified technician.

- Clean the fence daily with a mild cleaning agent.
- Daily remove (vacuum) wood chips and edge trim that may gather near the fence.
- Periodically check that the panel enters the machine without drifting.

When placing a panel at the machine entrance make sure that the panel rests fully on the fence.

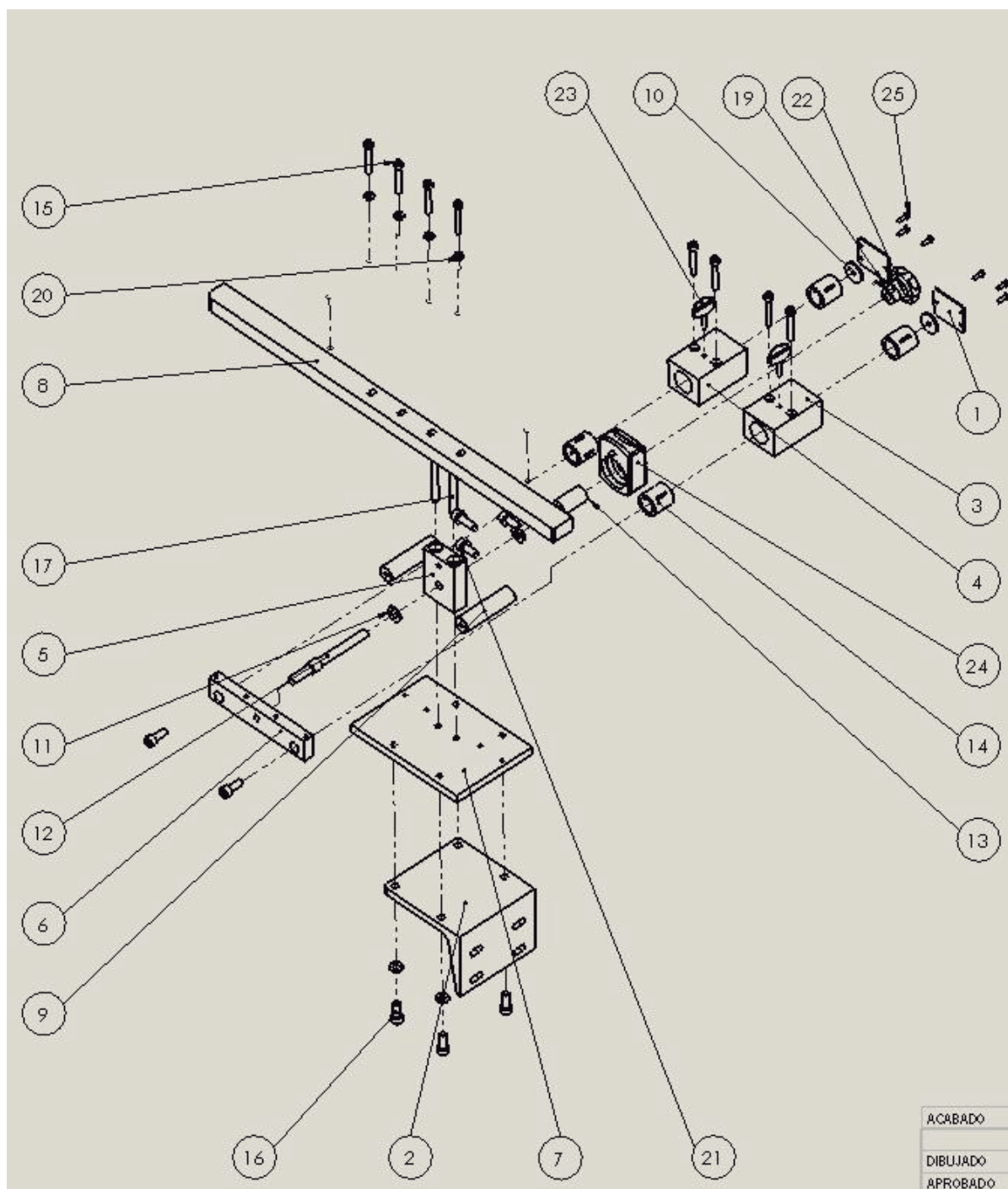
Whenever the panel advances through the machine going out of its way (separating from infeeding fence) this may indicate that there is a problem in the infeed fence.

Follow these steps to determine if fence alignment with the panel is correct:

- Deactivate all units, except for the gluepot, which you deactivate it manually with the cancellation lever.
- Clean chain pads and wheels.
- Make sure that the fence is 37mm away from the chain pad edge.
- Feed 3 long 300x500mm panels by their short side and stop the machine so that one panel stays at the beginning, another in the middle and the last one at the end of the machine; check that the pressure beam exerts a uniform pressure on the 3 panels.
- Feed a long panel. Make sure that this panel has a perfect cut, since if the panel suffers from “banana effect” you will not be able to determine if the infeed fence has a problem or not.
- Stop the long panel matching the end of the panel with the start of the infeed fence.
- If you notice a gap between the panel and the infeeding fence, it means that the fence is out of parallelism with the drag chain.

Only a trained technician should adjust the infeeding fence.

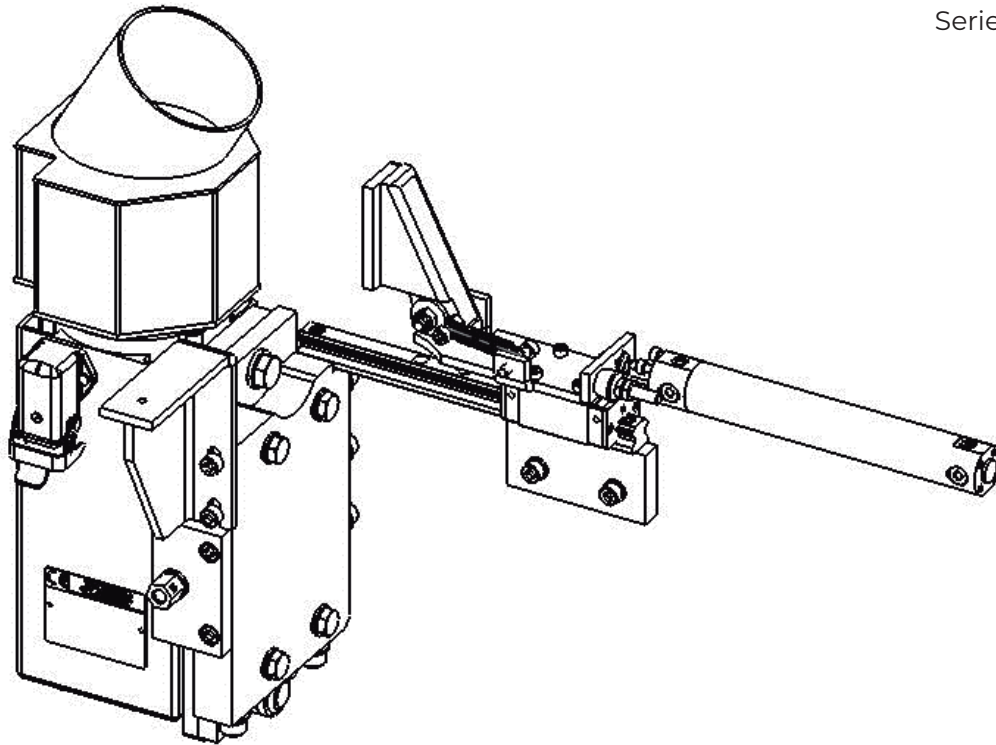
3 UNIT COMPOSITION



0200113 Infeeding fence			
#	Qty.	Description	Reference
1	2	GUIDE BLOCK PROTECTION	401000517
2	1	Angle Support	402000193
3	1	Guide Block	403000275
4	1	Guide Block	403000275
5	1	Siko Support for Entrance Regulating Device	403000281
6	1	Entrance Regulating Device	403002225
7	1	Adjustment Base Plate	403002226
8	1	Handrail for Entrance Regulating Device	403002914
9	2	Guide Column	404000180
10	2	Stop Washer	404000181
11	2	Brass Washer Ø20 x Ø10 x 1.5	404000182
12	1	Siko Shaft for Entrance Regulating Device	404000183
13	1	Siko Indicator Bushing	404000184
14	4	Linear Ball Bushing LBBR20	6172030011
15	8	ALLEN SCREW DIN 912 M6 x 40 (40mm THREAD)	6310604001
16	8	ALLEN SCREW DIN 912 M8 x 20 (20mm THREAD)	6310802001
17	2	ALLEN SCREW DIN 912 M8 x 70 (70mm THREAD)	6310807001
18	1	PAN HEAD SET SCREW DIN 913 M5 x 10	6330501001
19	1	PAN HEAD SET SCREW DIN 913 M6 x 6	6330600601
20	4	WASHER DIN 125 M6	6610600001
21	8	WASHER DIN 125 M8	6610800001
22	1	Handwheel knob 1132 D45	9250105901
23	2	Knob M6 x 25	9250476301
24	1	Positioner DA09	9350921051
25	6	DIN 7984 - M4 x 12 --- 9.9N	
26	2	ALLEN SCREW DIN 912 M8 x 25 (25mm THREAD)	6310802501

PREMILLING UNIT PF-1

Model: CBC.TPM Series PF-1 Pre-milling unit
Series Version: 00
10/2023



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1. Description And Aim Of The Unit
2. Work Description And Adjustment
 - 2.1 Screen Selection
 - 2.2..Work Description
 - 2.3..Electric Composition
 - 2.3.1 Electric Composition
 - 2.4..Unit Adjustment
 - 2.4.1 Depth And Tilt Adjustment
3. Maintenance
 - 3.1 General Maintenance
 - 3.2 Tool Change
 - 3.3 Inserts Change
4. Alarms
5. Errors And Solutions
6. Unit Composition
 - 6.1 Complete Unit
 - 6.2 Support Assembly
 - 6.3 Motor Assembly
 - 6.4 Rear Tracer Assembly

1 UNIT SCOPE AND DESCRIPTION

The job of the pre-milling unit is to remove all the irregularities that the panel may present in the profile. It is composed of a high-frequency motor, which avoids chipping at both lead and trail of panel.

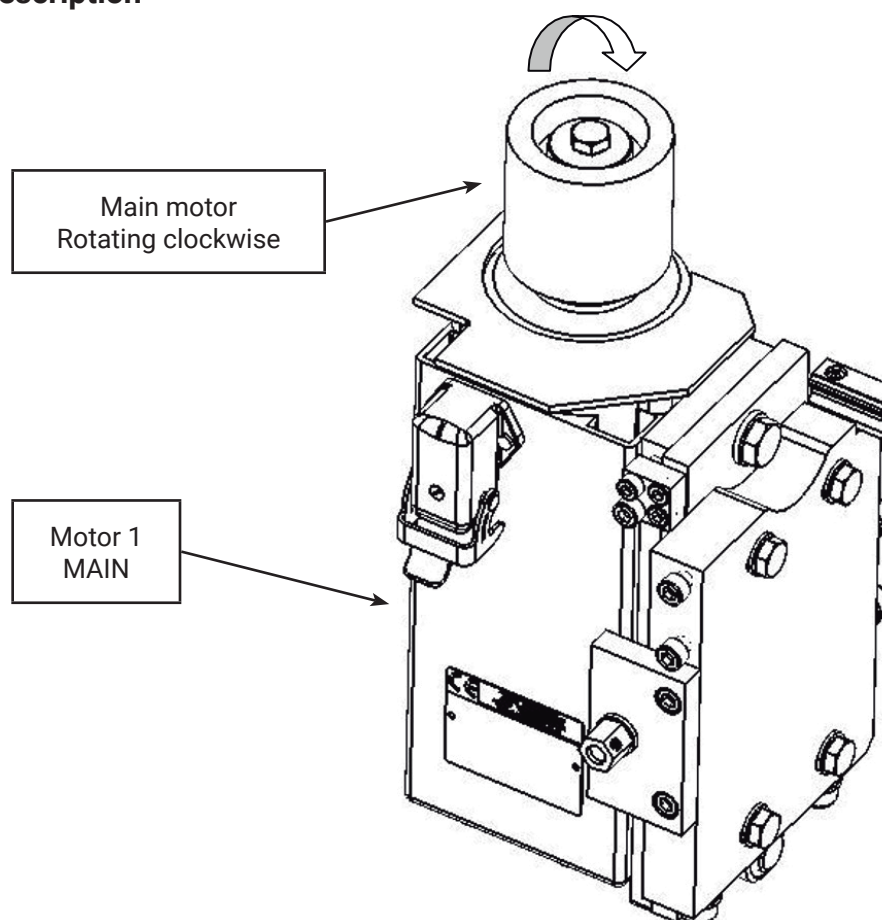
	Frequency (Hz)	Speed (rpm)	Main motor (kW)
PF-2	150	9000	0.75

2 WORK DESCRIPTION AND ADJUSTMENT

2.1 Screen selection

ON	OFF
	

2.2 Work description



2.3 Electric composition

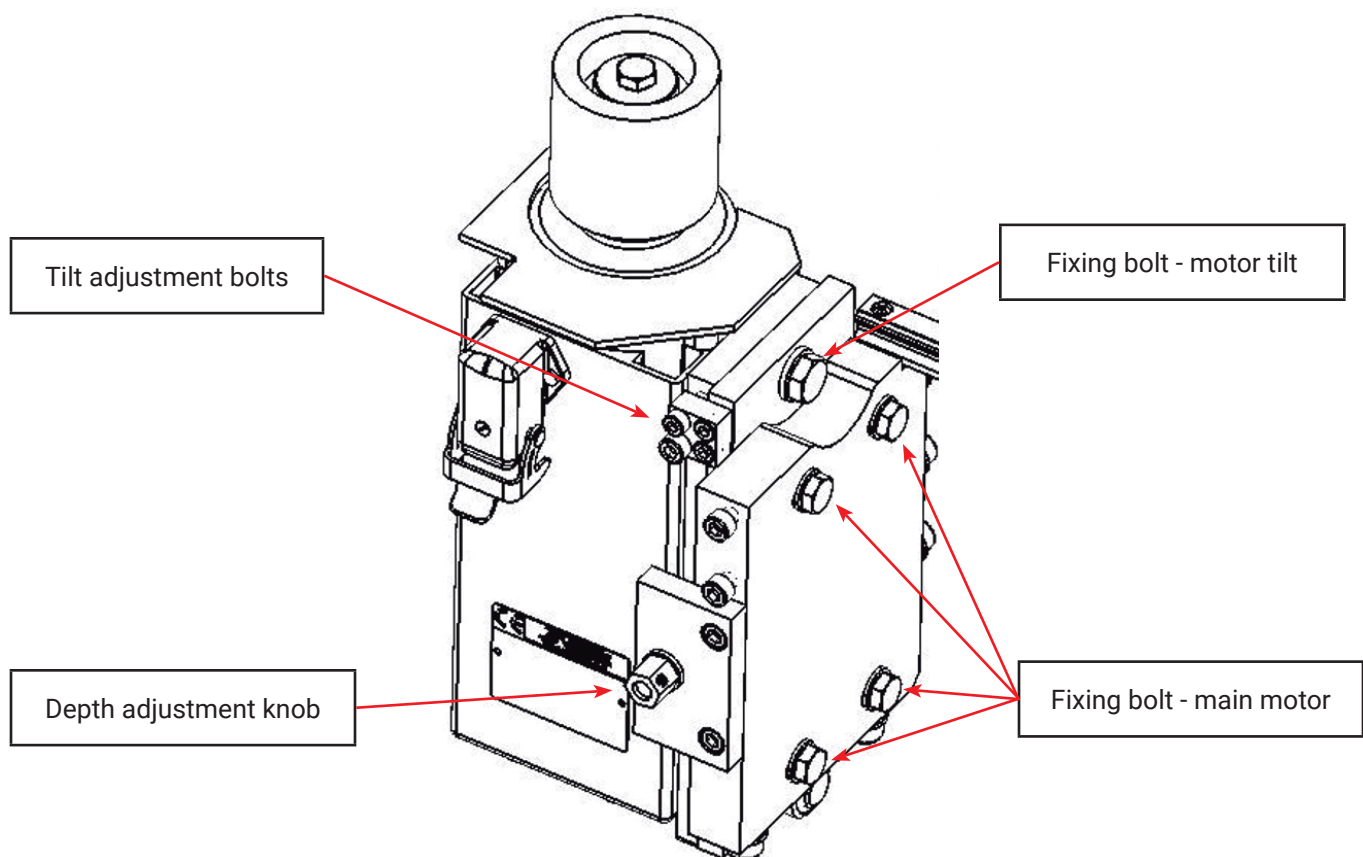
This configuration detailed below might change. Please check the update electric and pneumatic diagram to confirm the correct sensors, electric and pneumatic components.

	Motor	Inverter
Main motor	6M1	U4
Output motor	6M2	

2.4 Unit Adjustment

*The adjustments described below are meant for trained technicians.

2.4 .1 Depth and tilt adjustment



- Adjust the motor depth losing the unit fixing bolts and acting accordingly on the depth adjustment knob.
- Adjust the motor tilt the unit losing motor tilt fixing bolt and acting accordingly on the tilt adjust bolts.

3 MAINTENANCE

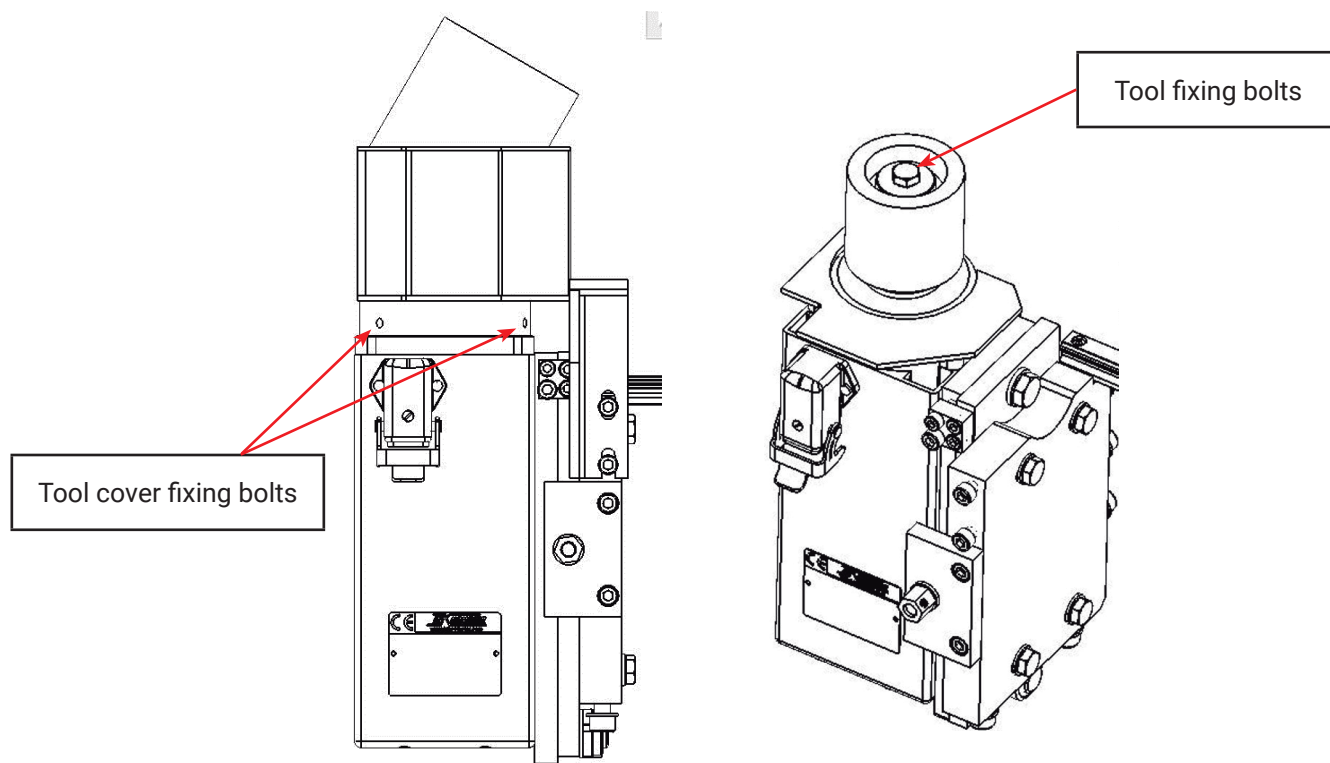
Before starting the Maintenance, turn off the machine (disconnect completely electrically) and disconnect compressed air.
Only trained personnel can perform these operations.

3.1 General maintenance

- Daily remove (vacuum) dust that may be near the unit.
- Grease the linear guides. Perform this operation every 3 months.
- Check manually daily, without pneumatic pressure, that the motor moves correctly, without any obstruction.

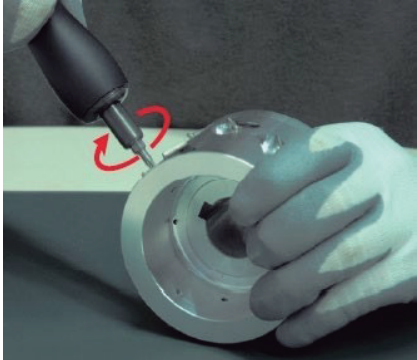
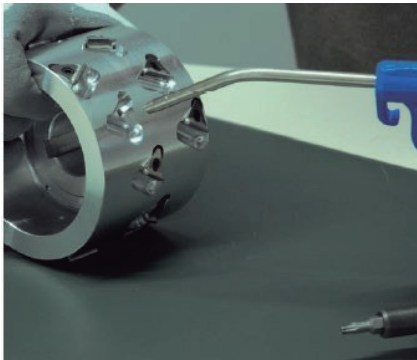
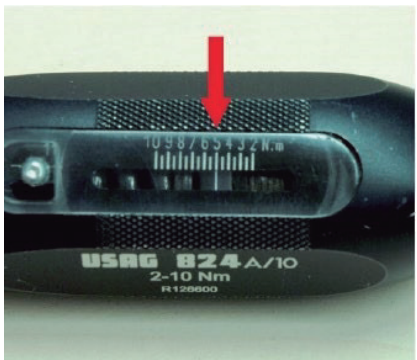
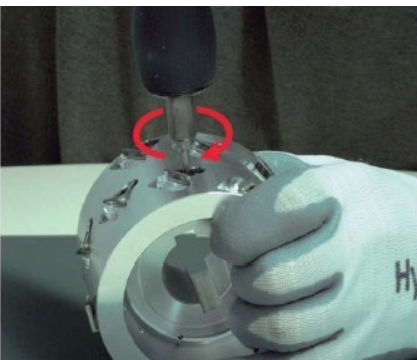
3.2 Tool change

- Remove the tool cover by taking out the fixing bolts.

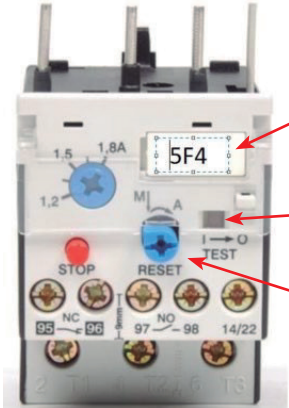
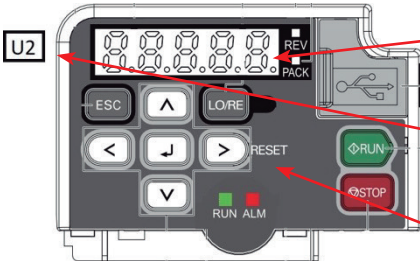


- Lock the motor shaft rotation from bottom side with an Allen key of 6mm.
- Keep in mind that the shaft has Reverse thread due to its rotation.
- Use a 13mm spanner (or socket) to lose the tool fixing bolts.
- Now you should be able to remove the tools and replace.

3.3 Inserts change

1	Clean the cutter block to remove any residue of glue or dust.	
2		Loosen and remove the screws on the blades you want to replace using a Trox 15 wrench. The screws may be too tight from use, never force or damage the screws and contact service.
3		Carefully clean the surface of the blade insert with compressed air.
4		Set the torque wrench to 5N·m.
5		Insert the blade ensuring the correct position and secure the screw with the torque wrench.

4 ALARMS

Alarm	Possible cause	Solution
Thermic relay	Thermal relay alarm due to a motor malfunction	 Motor reference TEST box, Relay status: Yellow: Alarm. Green: OK. RESET Button Locate the relay that caused the fault, write down the relay reference to report the fault to the authorized technical service, and press the blue button (RESET) and reset the alarm from the screen. You can disable the unit with faulty motor to continue working.
	Low input voltage	
Inverter	Motor failure	
	Inverter fault	
	Worn tools	 Inverter display Inverter reference RESET Button Locate the drive that caused the fault, write down the reference number to report the fault to the authorized technical service, and press the RESET button to be able to reset the fault from the screen.

5 ERRORS AND SOLUTIONS

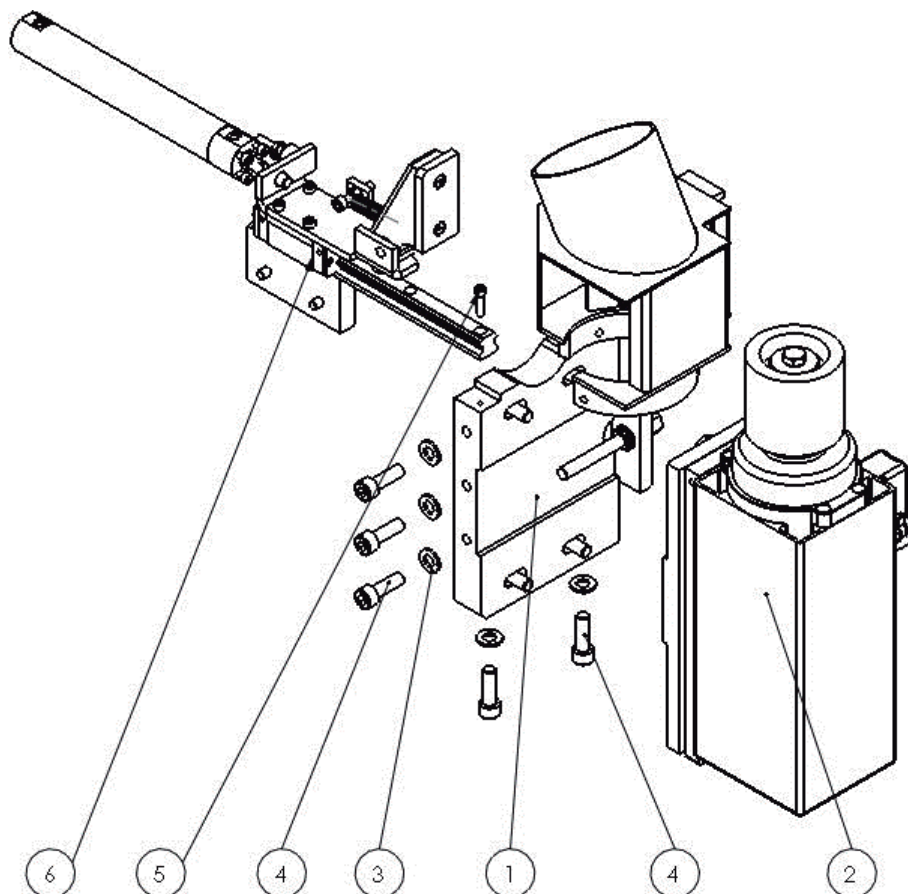
Before making any adjustments to improve the finish, check the following:

- Correct height of the pressure beam: Check that the pressure beam grips well the panel, and it does not move in its path.
- Correct guiding of the drag chain with a long panel (+ 1.50m): Check with a long panel that it follows its path with infeeding fence. If the board separates at the front, or back, it may result in an incorrect finish.
- Free movement: Remove the pneumatic pressure of the machine and check the motor of the first pre-milling. It must move freely.
- Continuous pressure: Reconnect the pressure and check that it maintains at 0.6MPa (90 PSI) during operation.

	Possible causes	Solutions
Pre-milling in angle (different from 90°)	Incorrect apron height	If the apron is not on the same level as the drag chain, it may affect the finishing of the pre-milling unit. To do this, check the correct height by consulting the attached manual.
	Motor tilted	Contact an authorized technician to verify and solve the fault.
Uneven finish	Linear bearing not clean	Without pneumatic pressure, check that the second motor moves freely. If necessary, clean and grease the linear bearings.
	Banana effect in panel cut	Check (especially on long panels) that cutting the board does not release the surface tension, causing a deflection called the banana effect. To fix it, you can double trim the panel.
	Unaligned infeeding fence	Check with a long panel that, when fed into the machine, it is does not separate from infeeding fence. If so, consult the manual attached to the infeeding fence to solve the fault.
Chipping on top/bottom	Worn tools	Check, and if necessary, replace the cutting tools.

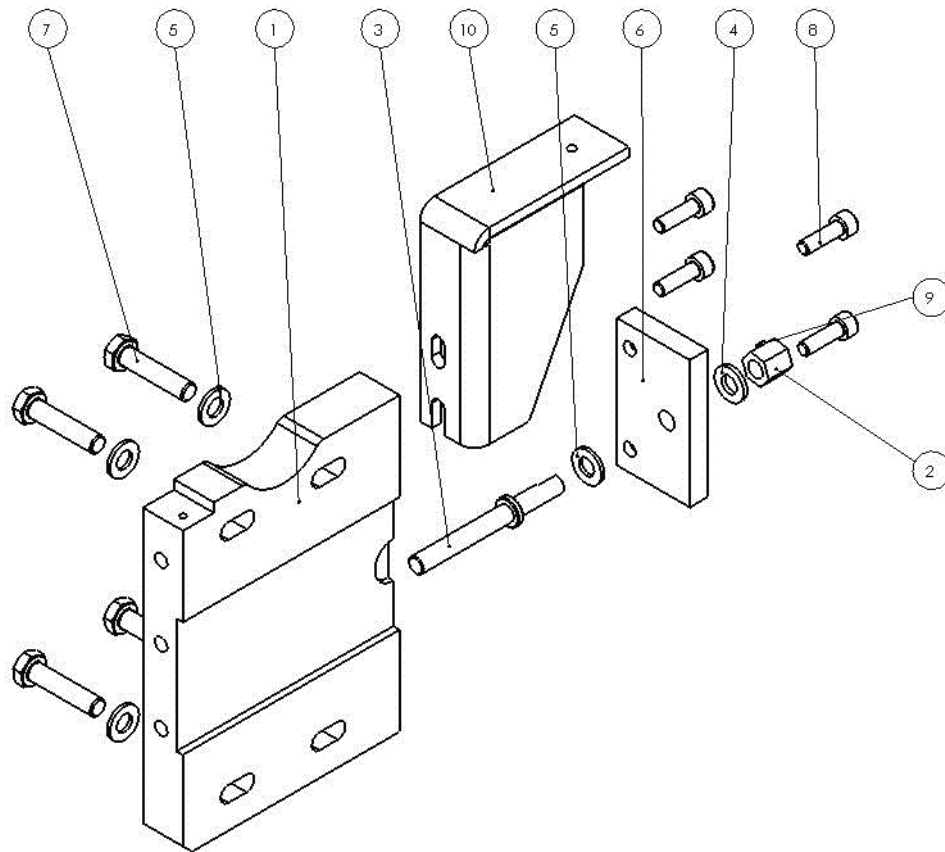
6 UNIT COMPOSITION

6.1 Complete unit (0400068)



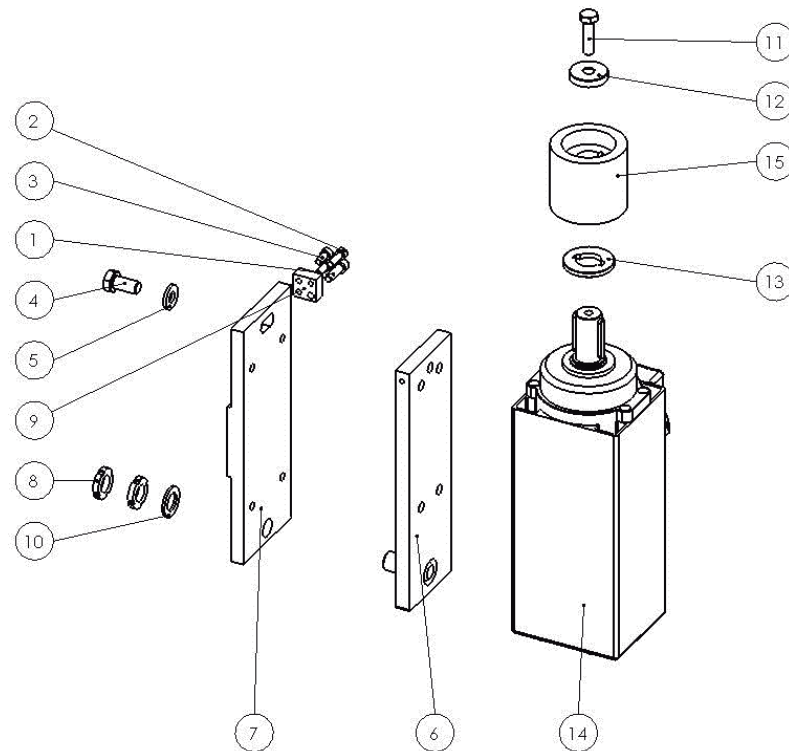
Pre-milling PF-1 0400068			
#	Qty.	Description	Reference
1	1	Support set	5005407
2	1	Cutting set	5005410
3	5	DIN 125 M8 WASHER	6610800001
4	5	ALLEN SCREW DIN 912 M8 x 25 (25mm THREAD)	6310802501
5	1	ALLEN SCREW DIN 912 M4 x 16 (16mm THREAD)	6310401601
6	1	Anti-splinter trigger assembly	5005411
7	1	Suction box PF-1	5005441

6.2 Support assembly



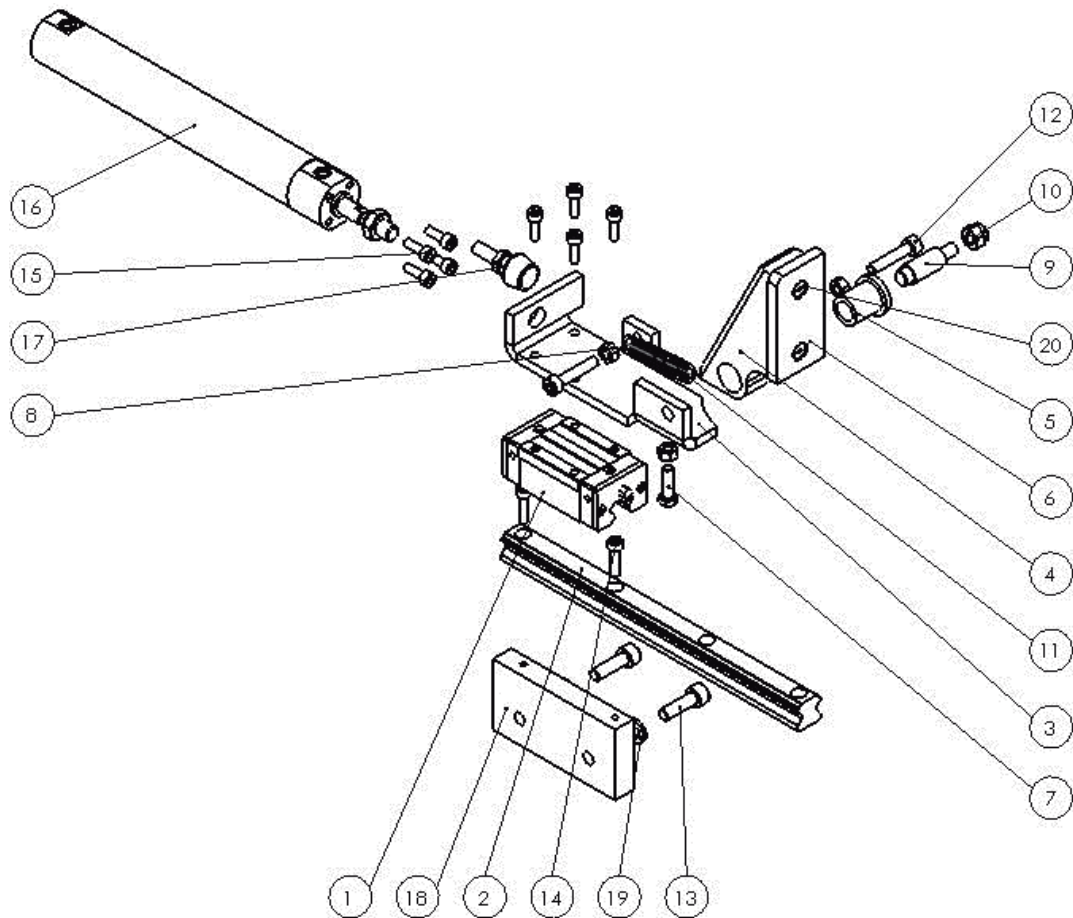
Support assembly 5005407			
#	Qty.	Description	Reference
1	1	Group support	403002908
2	1	Hex knob	404000583
3	1	Horizontal adjustment axis	404001397
4	1	Brass Washer M8	6610800201
5	5	DIN 125 M8 WASHER	6610800001
6	1	Regulation plate	403002911
7	4	DIN933 HEXAGON SCREW, M8 X 35	6360803501
8	4	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
9	1	FLAT HEAD PRISONER DIN913 M4 X 5	6330400501
10	1	Tray support	401006413
11	1	Group support	403002908
12	1	Hex knob	404000583
13	1	Horizontal adjustment shaft	404001397

6.3 Motor assembly



Motor assembly 5005410			
#	Qty.	Description	Reference
1	1	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
2	1	ALLEN SCREW DIN 912 M5 x 16 (16mm THREAD)	6310501601
3	2	ALLEN SCREW DIN 912 M5 x 12 (12mm THREAD)	6310501201
4	1	DIN933 HEXAGON SCREW, M10 X 20	6361002001
5	1	Washer DIN 6902 - A 9.3	
6	1	Motor plate welding set	5005408
7	1	Guide base	403002909
8	2	KM2 Nut	6151020001
9	1	Motor regulation stop	403000261
10	1	Brass washer 25x15x2	404000195
11	1	Screw with hexagonal head ISO 8676 - M8 x 30	
12	1	Cutter washer	404000144
13	1	Lower bushing	404000165
14	1	Tecknomotor 1.1 Kw motor 41470305	5801501211
15	1	Diamond cutters 60x65xd20 Left	55_9310600661

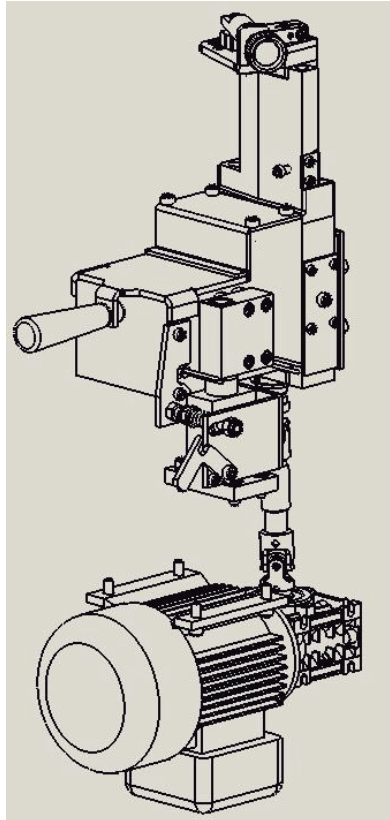
6.4 Rear tracer assembly



Rear tracer assembly 5005411			
#	Qty.	Description	Reference
1	1	HGH15CAZ0H	102000136
2	1	HGR15R194C Guide	102000705
3	1	Trigger support plate	401006368
4	1	Anti-splinter trigger	403002913
5	1	Bushing B101520-203	6221015201
6	1	Anti-splinter plate	409000624
7	1	DIN933 HEXAGON SCREW, M5 X 16	6360501601
8	3	DIN934 HEXAGONAL NUT, M5	6410500001
9	1	Trigger rocker axis	404001873
10	1	SELF LOCKING NUT DIN982, M6	6420600001
11	1	E03600581750S	

GLUEPOT

Model: CBC.TPM Series Gluepot M2 Quick Change
Series Version: 00
06/2023



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1. Unit Scope and Description
2. Screen Selection And Activation
 - 2.1 Screen Selection
 - 2.2 Manual Activation
3. Operation And Adjustment
 - 3.1 Work Description
 - 3.2 Unit Description And Adjustment Points
4. Maintenance
 - 4.1 General Maintenance
 - 4.2 Changing Heating Elements
5. Alarms
6. Troubleshooting
7. Unit Composition
 - 7.1 Complete Gluepot
 - 7.1.1 Deposit Assembly
 - 7.2 Tracing Base
 - 7.3 Glue Roller Housing Assembly

1 UNIT SCOPE AND DESCRIPTION

The gluepot is a glue applicator unit for MAKSIWA automatic edge banders. It works with EVA glue. It has a capacity of 1.2 Kg and a power of 3 KW. It consists of:

- Deposit for melting the glue.
- Four heating elements to melt glue quickly.
- Mechanism that allows the emptying of the gluepot.
- Software that manages and reports on the operations for changing the glue.
- Different mechanical and electrical safety elements.
- Advance roller-housing assembly, capable of applying the glue on different thickness.
- Easy glue quantity adjustment.

2 SCREEN SELECTION AND ACTIVATION

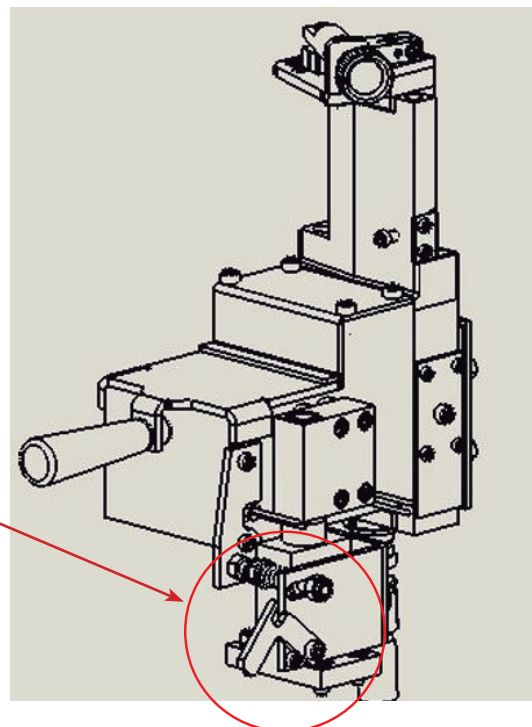
2.1 Screen selection

ON	OFF
	

2.2 Manual activation

Ensure that the unit is in working position (unit lever engaged):

Unit lever engaged



3 OPERATION AND ADJUSTMENT

3.1 Work description

- It takes around 12 minute to reach the working temperature with EVA glue (this time may vary depending on the ambient temperature and the type of glue).
- HMI screen displays accurate temperature of gluepot and glue roller, even it is possible to adjust a different temperature, depending on glue manufacturer specifications.
- When starting the machine, the glue goes up the endless roller, and when a work piece passes, it distributes the glue evenly along the entire side of the board.
- With the correct setting of the amount of glue, no additional adjustment is necessary to work with different board thicknesses. Only change the glue quantity when working with different kind of panels (for example, MDF panel requires less glue than chipboard).

3.2 Unit description and adjustment points

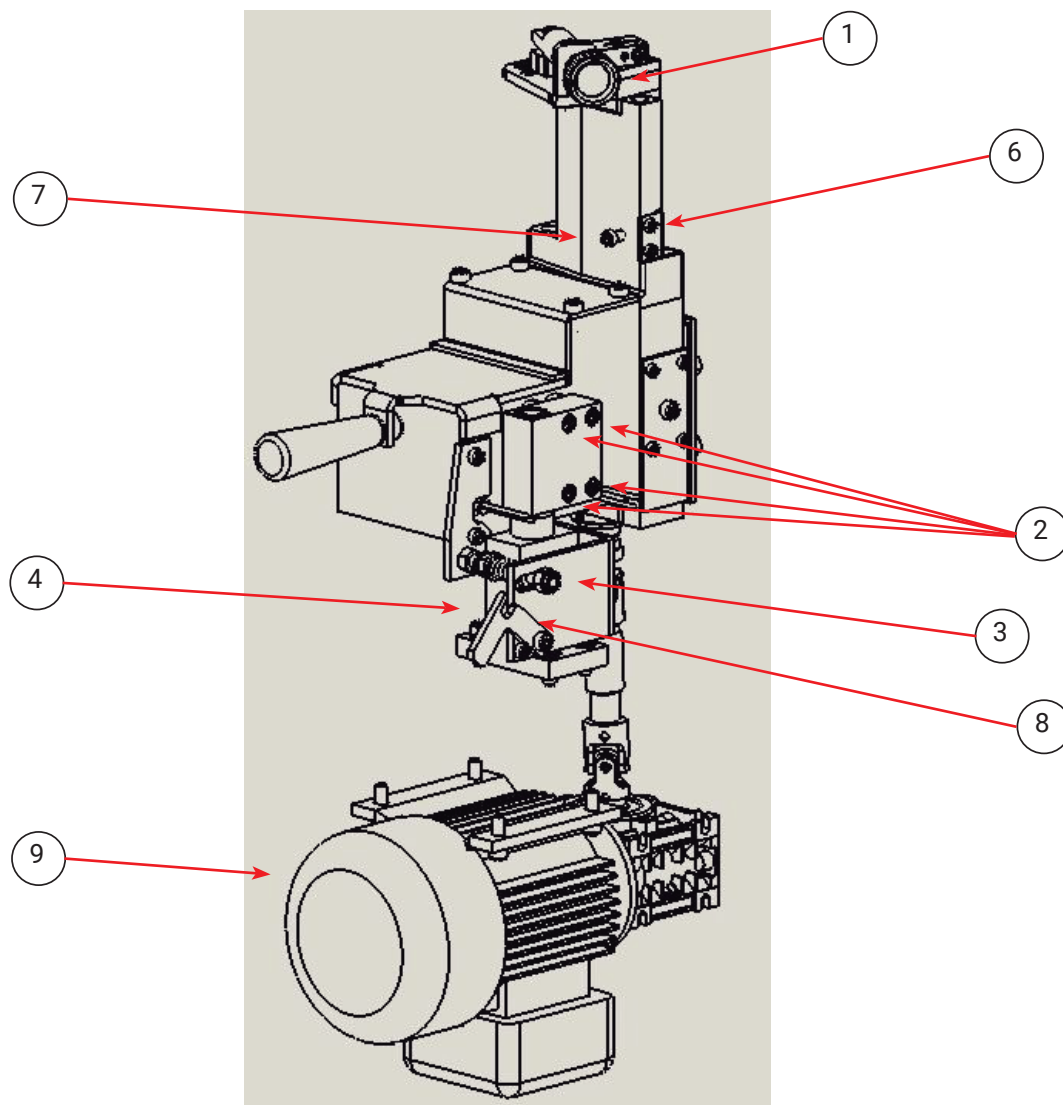
Safety warning



A trained technician with special tools adjusts this unit. For this reason, MAKSIWA does not recommend handling without the support of an authorized technician.
The gluepot unit works at 200 degrees (EVA glue). Use all necessary precautions handling the gluepot to avoid any kind of injury (gloves).
Do not adjust the unit while the machine is running to avoid enrollment with the chain. For proper handling.



Before making any adjustments, try to solve the problem with the appropriate preventive/corrective actions, and follow these steps detailed in the section on common errors and failures.



#	Element	Function
1	Glue regulator knob	Turning clockwise reduces the glue quantity and counterclockwise increases.
2	Unit fixing bolts*	Fixing the unit to the base and fixing the angle of the roller.
	Roller inclination*	
3	Self-locking nut: tracing	Tracing the unit (1mm set).
4	Self-locking nut: tension	Increase or reduce the tension of tracing.
6	Roller tracing plate*	Tracing plate with bolt to make a gap of 0.05 mm between roller and panel.
7	Roller tracing plate bolt*	
8	Gluepot deactivation lever	Retreats the gluepot.
9	Motor + gearbox	To move the glue roller

4 MAINTENANCE



Before starting the Maintenance, turn off the machine (disconnect completely electrically) and disconnect compressed air. Only trained personnel can perform these operations.

4.1 General maintenance

- Clean the gluepot daily with compressed air, with glue at low temperature, and avoiding dirt from entering the unit.
- Check that the glue return hole is not blocked, and the excess glue is correctly returning to the gluepot.
- To remove burnt glue, use silicone or wooden spatulas to avoid damaging the Teflon coating.

4.2 Changing heating elements

Proceed as follows:

- To replace the heating element, turn off the machine completely; remove the air and feeding tray.
- Disconnect the 6-pin quick connector that powers the heating elements and disconnect the 4-pin quick connector from the temperature sensor.
- Remove the gluepot and place it on a workbench.
- Disconnect the heating elements from the quick connector, remove them from their housing and replace them with the new ones.

5 ALARMS

Alarm	Possible cause	Solutions
Maximum temperature	Temperature sensor fault	Verify correct reading on temperature display. If asterisks appear instead of current temperature, it is due to sensor failure. Check if it is well connected.
	Solid state relay fails	In this case, a qualified technician must replace said item

6 TROUBLESHOOTING

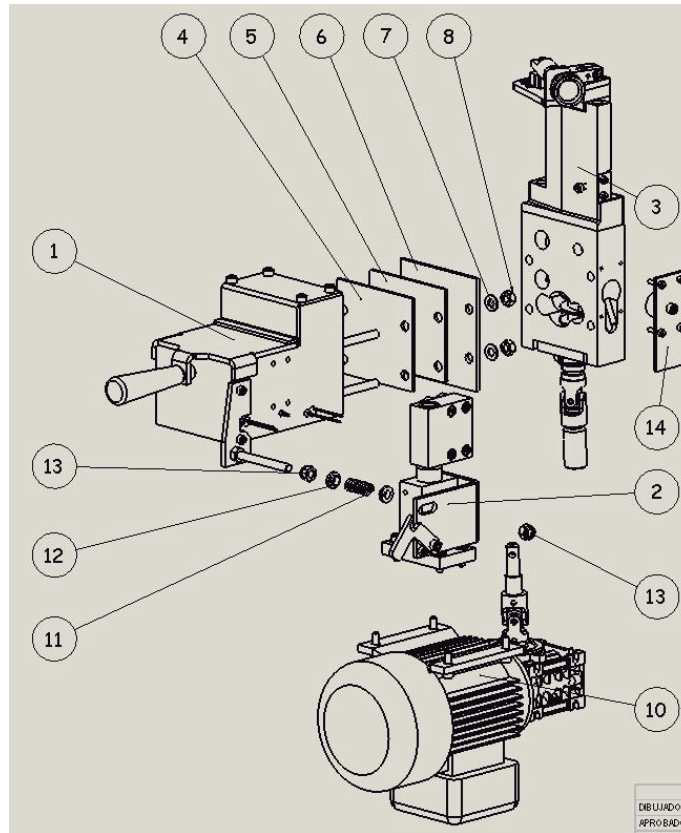
Before making any adjustments to improve the finish, do the following:

- Correct height of the pressure beam: Check that the pressure beam grips the panel well, and it does not move in its path.
- Correct guiding of the drag chain with a long board (+ 1.50m): Check with a long panel that it follows its path with the infedding fence. If the board separates at the front, or back, it may result in an incorrect finish.

Error	Possible cause	Solutions
Glueing only half of the panel	Panel cutting	Verify if the panel is at 90°.
	Glue roller tilted	Follow the instructions described in this manual on how to adjust the unit inclination and consult a trained MAKSIWA technician
Uneven glueing	Not enough tracing	Increase the tracing
	Fault in glue roller housing assembly	Contact the technical service.

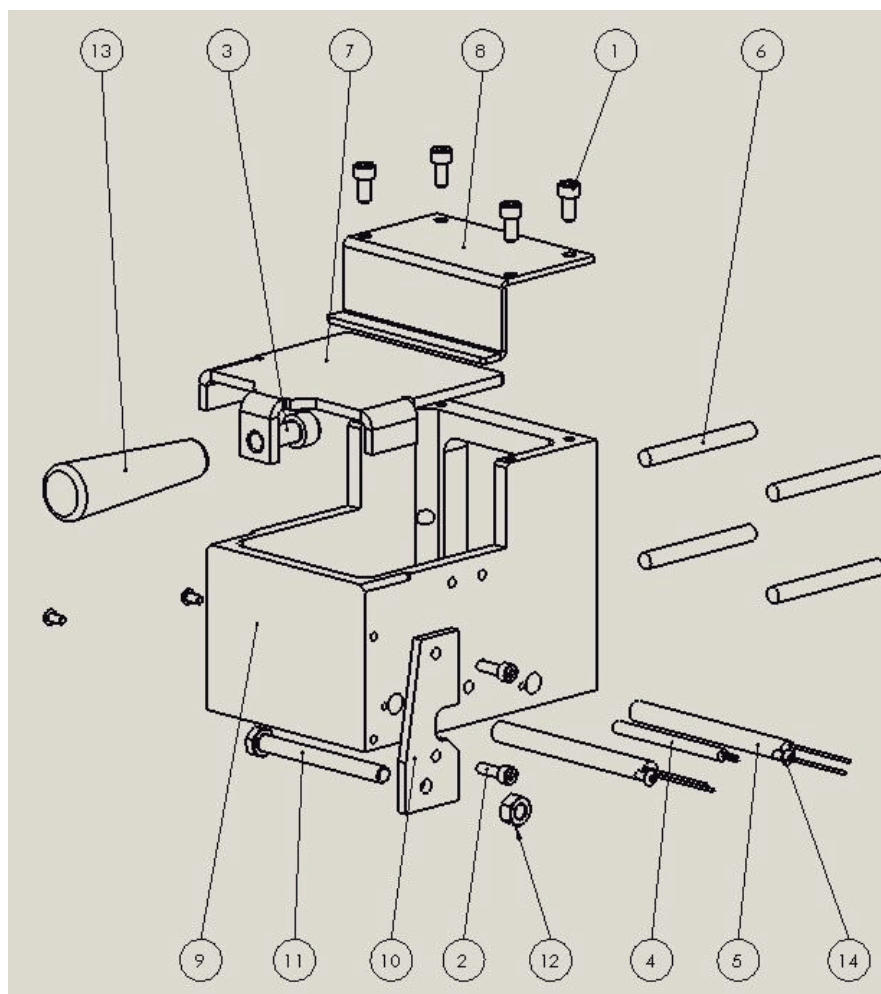
7 UNIT COMPOSITION

7.1 Complete gluepot



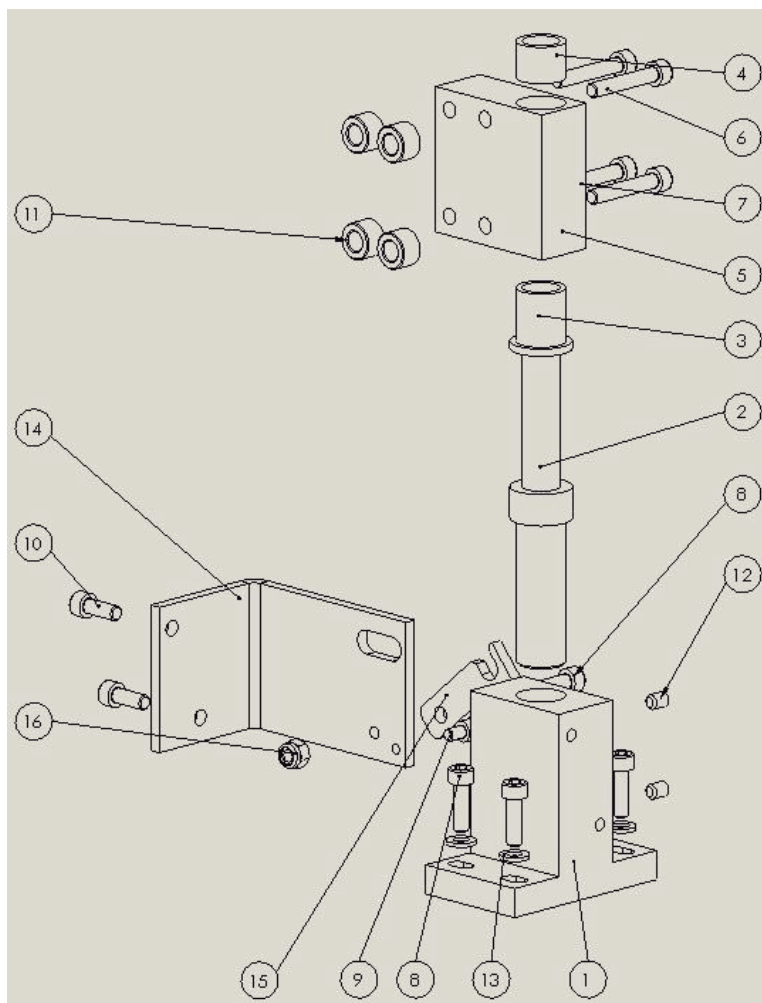
Complete gluepot assembly 0600103			
#	Qty.	Description	Reference
1	1	Gluepot body	5005340
2	1	gluepot Support	5005567
3	1	ADJUSTABLE SHAFT NOZZLE ASSEMBLY	5003737
4	1	Heating element 1000542 400w	3535125011
5	1	Front heating insulating plate	409000122
6	1	Heating element cover	401000772
7	4	DIN 125 M8 WASHER	6610800001
8	4	DIN934 HEXAGONAL NUT, M8	6410800001
9	1	N/A	5000246
10	1	Motor assembly	5005338
11	1	Vertical tracer spring	500854
12	2	Dock spring accommodation	404000934
13	2	SELF LOCKING NUT DIN982, M8	6420800001
14	1	Plug set 60	5000172

7.1.1 Deposit assembly



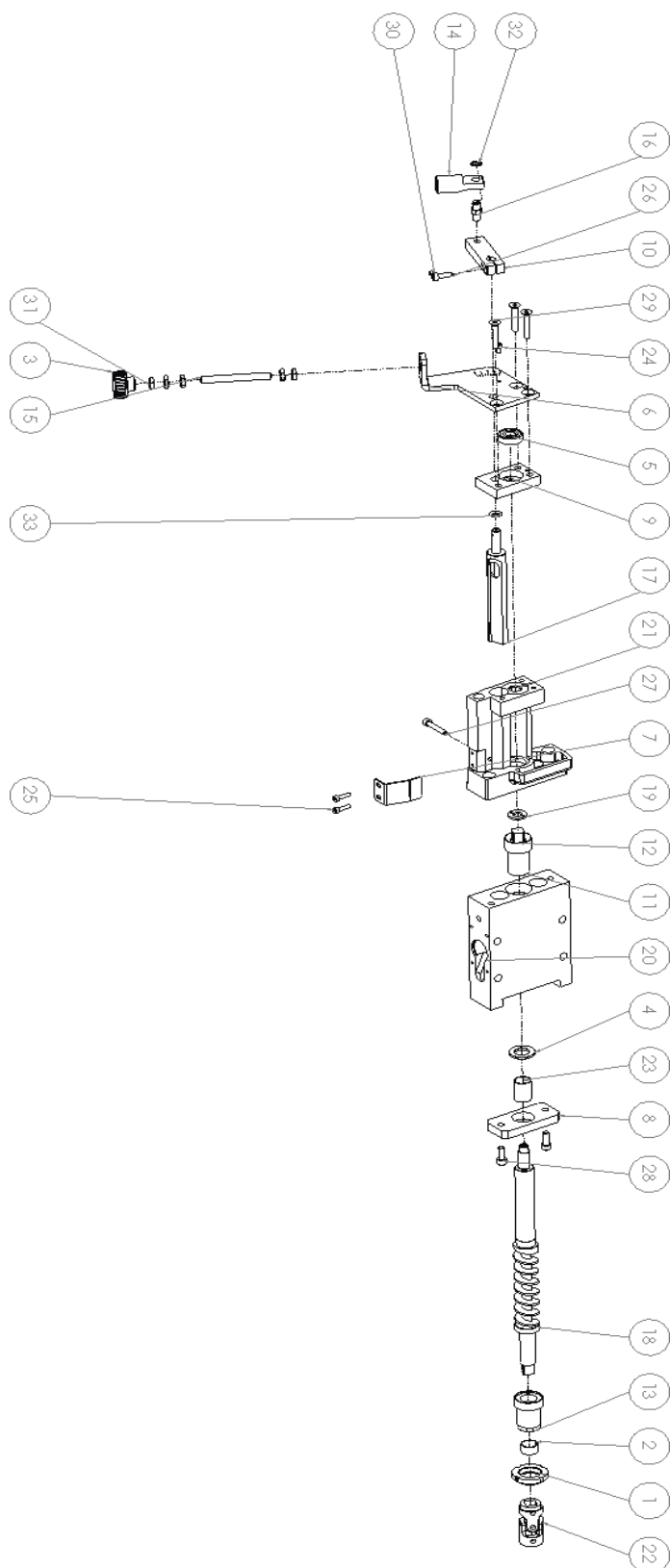
Deposit assembly 5003540			
#	Qty.	Description	Reference
1	4	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
2	2	ALLEN SCREW DIN 912 M5 x 16 (16mm THREAD)	6310501601
3	1	ALLEN SCREW DIN 912 M10 x 25 (25mm THREAD)	6311002501
4	1	Temperature sensor type J no. 25 D6x70	3482280001
5	2	Heating element D.10 x 100 315W	3542101001
6	4	Threaded rod M8x70	404000514
7	1	Gluepot lid	401006270
8	1	Fixed tank cover	401006271
9	1	Gluepot tank	408000246
10	1	Tracer bolt support	401006268
11	1	DIN933 HEXAGON SCREW, M8 X 80	6360808001

7.2 Tracing base



Tracing base CBC.TPM gluepot 5005567			
#	Qty.	Description	Reference
1	1	Tilting bar bench support	409000620
2	1	M1 pivoting shaft	404000172
3	1	Porosoil bushing 15x20x25 B	6221520151
4	1	Porosoil bushing 15x20x15 A	6211520151
5	1	Gluepot pivoting support	409000053
6	3	ALLEN SCREW DIN 912 M6 x 35 (24mm THREAD)	6310603501
7	1	ALLEN SCREW DIN 912 M6 x 35 (35mm THREAD)	6310603501
8	5	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
9	1	ALLEN SCREW DIN 912 M5 x 8 (8mm THREAD)	6310500801

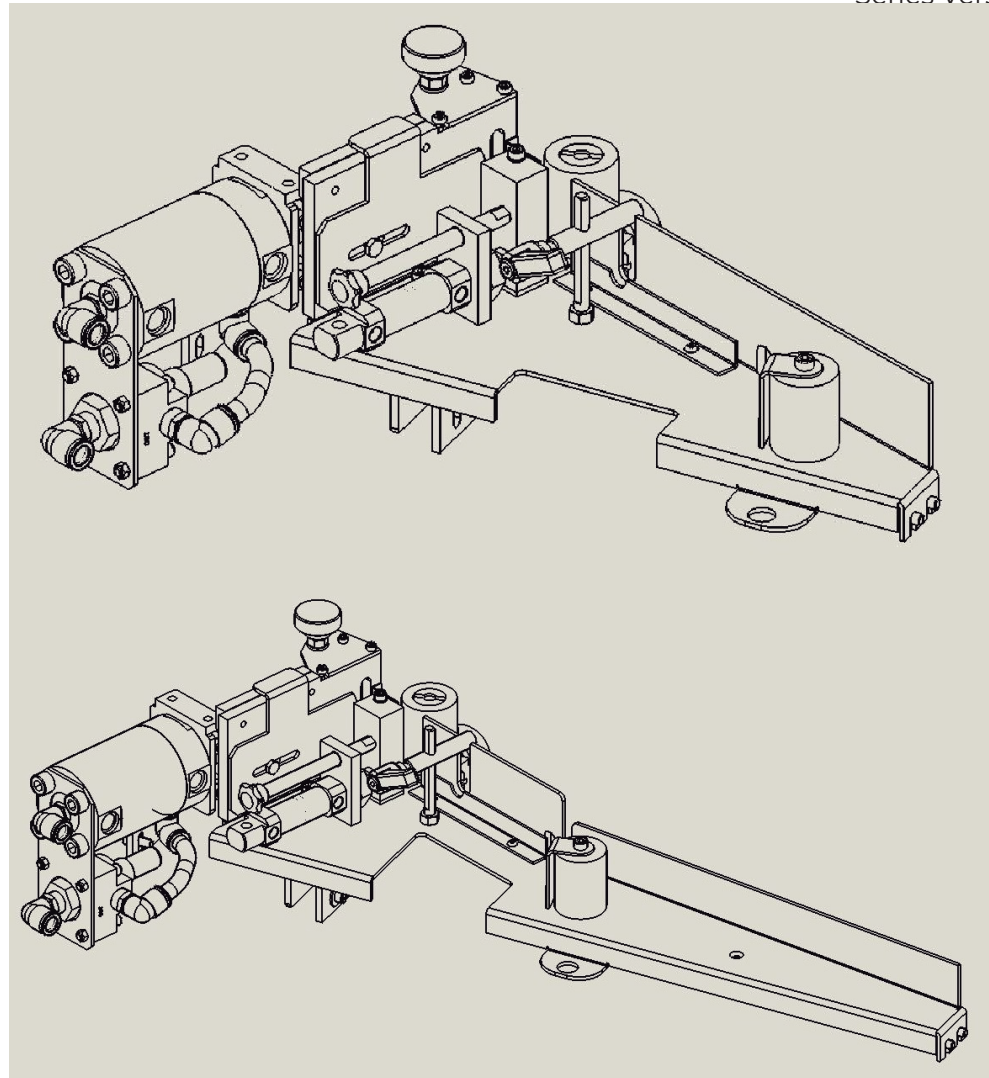
7.3 Glue roller housing assembly



Glue roller housing assembly 5003737			
#	Qty.	Description	Reference
1	1	Locking nut KMAT5 M25x1.5	102000173
2	1	MB1610DU	102000174
3	1	Knob ELESA+GANter BT.32 B-M8	102000175
4	1	Disk AXIAL GS81102 Machined	102000178
5	1	Bearing 6000-2RS ENC 330°C	102000278
6	1	Support plate - knob	401004795
7	1	Inner adjustment tracer	401005524
8	1	Threaded plate	403001569
9	1	Roller housing top cover	403002255
10	1	Opening lever	403002256
11	1	Slider	404000427
12	1	Housing gasket	404000721
13	1	Bottom guide gasket	404001168
14	1	Union nut	404001298
15	1	Threaded shaft M8 x 75	404001299
16	1	Adjustment pivot	404001300
17	1	Glue dosification gate	404001467
18	1	Glue roller	404001468
19	1	Glue roller washer	404001715
20	1	Roller housing (adjustable)	409000344
21	1	Top side roller housing	5003336
22	1	Universal joint	5412221201
23	1	Friction gasket MB1625DU	6240162501
24	1	Allen bolt DIN 912 M4 x 8 (Thread 8mm)	6310400801
25	2	Allen bolt DIN 912 M4 x 16 (Thread 16mm)	6310401601
26	1	Allen bolt DIN 912 M5 x 16 (Thread 16mm)	6310501601
27	1	Allen bolt DIN 912 M5 x 30 (Thread 22mm)	6310503001
28	2	Allen bolt DIN 912 M6 x 16 (Thread 16mm)	6310601601
29	3	Bolt DIN7991 M6 X 35 Thread:28.7mm	6320603501
30	1	Grub screw DIN914 M5 X 6	6330500621
31	5	Hex bolt DIN936, M8	6410800021
32	1	Seeger ring Ext. DIN471 8 X 0.8	6630800001
33	1	O-ring 8x2.65-A-ISO 3601-1	

FEEDING TRAY

Model: CBC.TPM Series Feeding Tray
Series Version: 00
10/2023



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1. Unit Scope and Description
2. Tape Position And Height Adjustment
3. Group Parametres
 - 3.1 Guillotine
 - 3.2 Feeding
4. Troubleshooting
5. Unit Composition
 - 5.1 Complete Unit Assembly
 - 5.2 Feeding Shaft Assembly

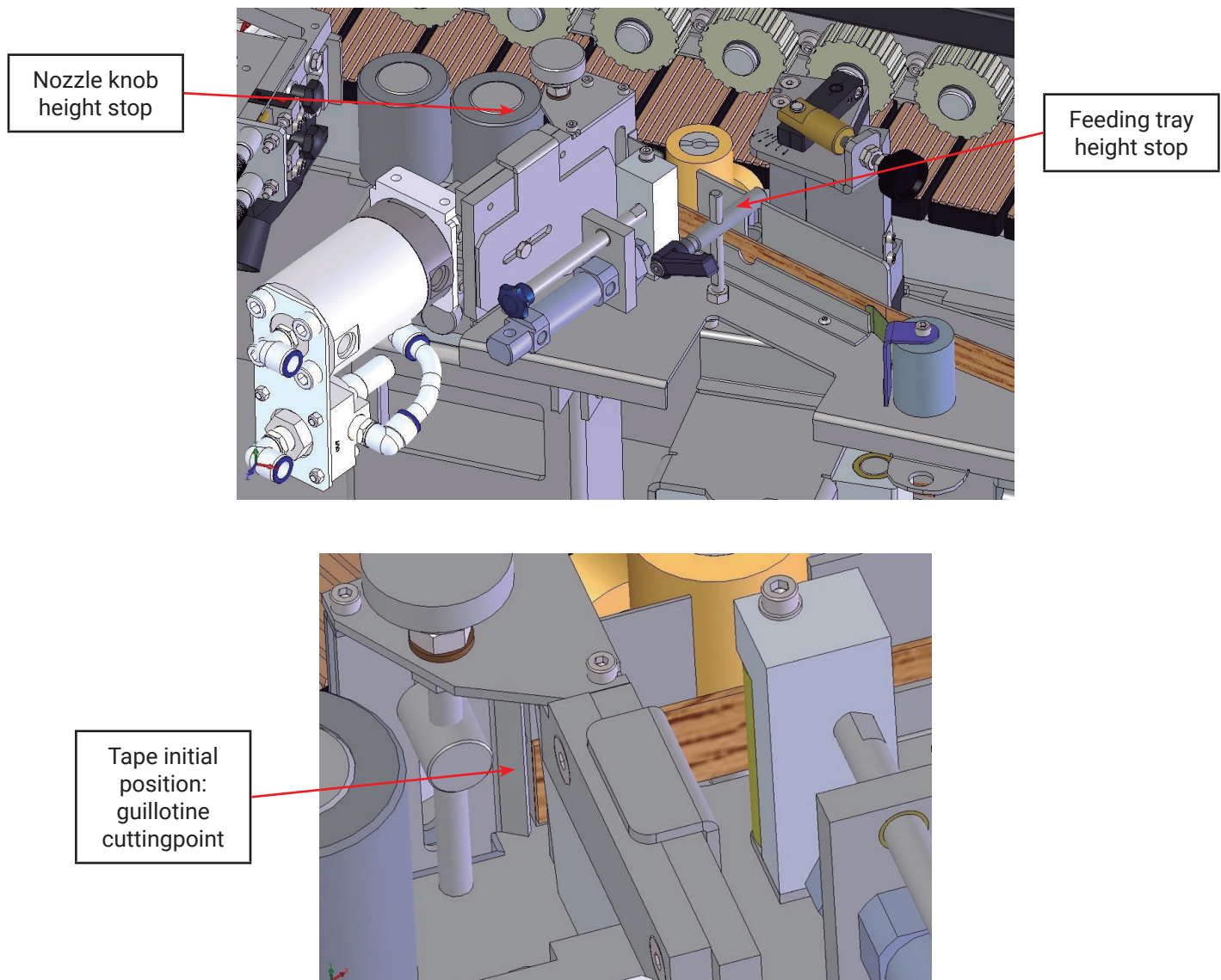
1 UNIT SCOPE AND DESCRIPTION

The feeding tray feeds the tape until middle of the first roller, so on front side of panel leaves an overhang of 5 mm and on rear side of panel cuts the edge tape leaving again 5 mm for the end trimming to work on it.

2 TAPE POSITION AND HEIGHT ADJUSTMENT

When feeding the tape for first time, make for following adjustment:

- Adjust correct height on nozzle knob.
- Adjust correct height on feeding tray stop.
- Position tape on guillotine cutting point.



3 GROUP PARAMETRES



MAKSIWA declines all responsibility associated with any alteration of the parameters of units by unauthorized personnel.

3.1 Guillotine

HOME menu GROUPS PARAMETERS ICON	
CUTTING TIME The time the guillotine remains active. CUTTING DELAY TIME Cutting time for the excess of the rear part.	

3.2 Feeding

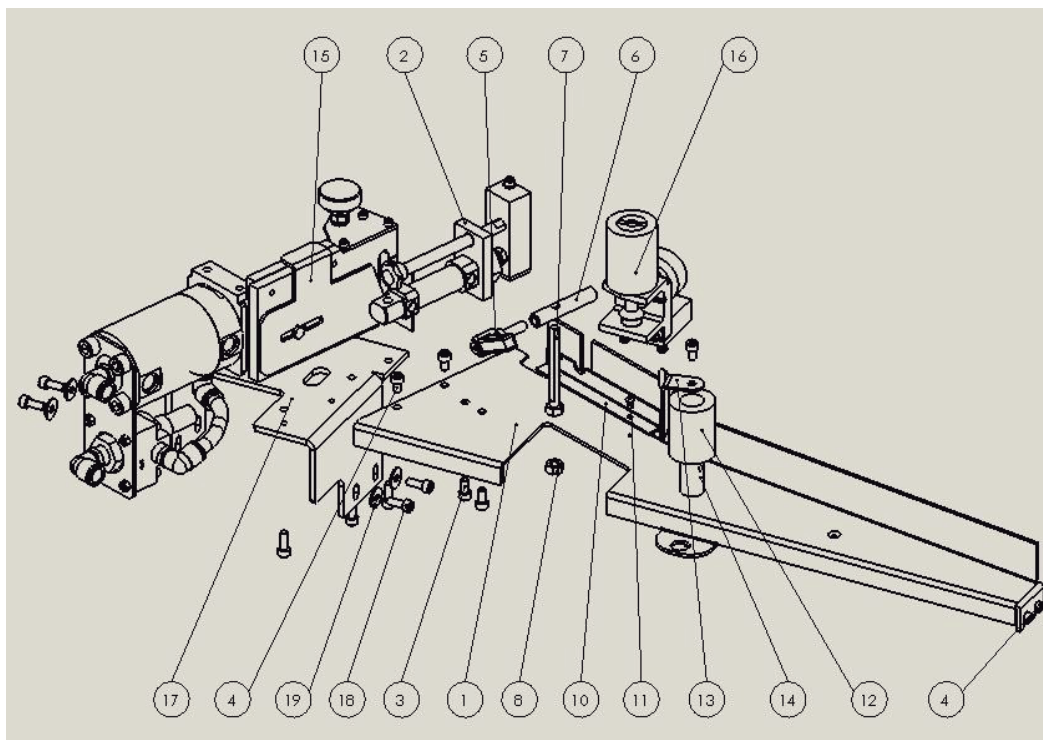
HOME menu GROUPS PARAMETERS ICON	
FEEDING TIME The time the feeding piston remains active. FEEDING START Feeding start time after limit switch trigger.	

4 TROUBLESHOOTING

Error	Possible cause	Solution
Guillotine not cutting	Guillotine status	Replace the guillotine cutter
	Mechanical obstruction	Disconnect pneumatic pressure, clean the area with compressed air and move by hand to ensure free movement.
	Not enough pressure	Check the pressure in the MR4 pressure gauge, and if necessary, raise it a little.
Edge not feeding	Feeding shaft mechanical obstruction	Check that the feeding shaft turns freely. If necessary, disassemble it for proper cleaning.
	Mechanical obstruction	Check that the piston goes in and out correctly.
	Loose feeding shaft	Check that the feed shaft is properly tightened, and the rubber roller does not rotate freely. Remember it is reverse thread.
	High pressure	If the feed shaft pressure is too high, the machine will not feed properly. The correct pressure is determined in the attached pneumatic diagram.

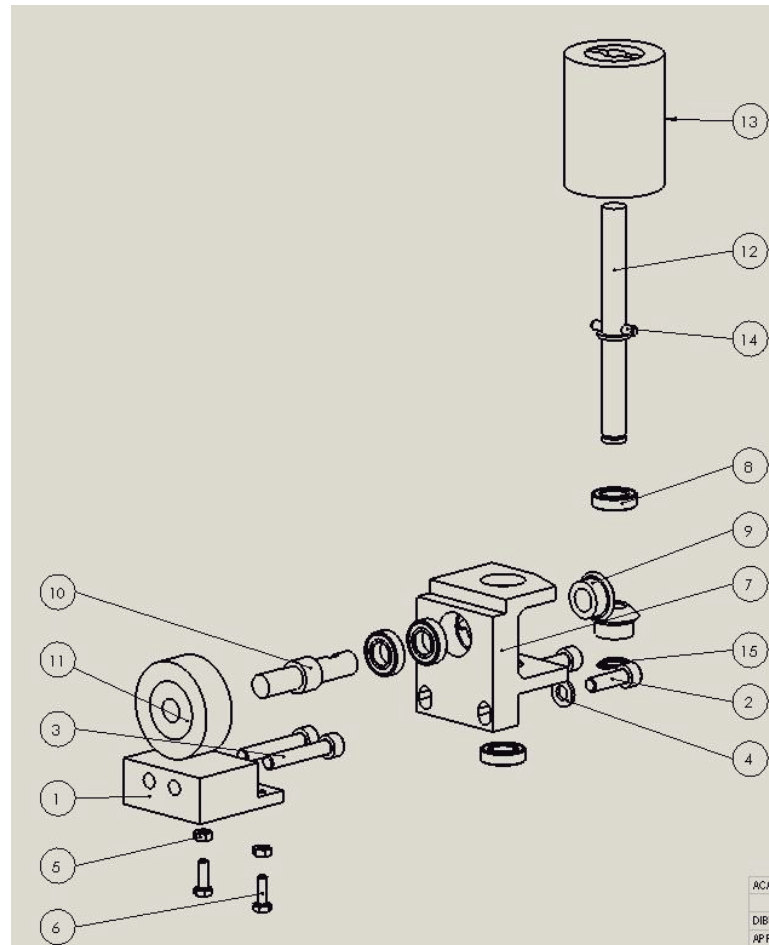
5 UNIT COMPOSITION

5.1 Complete unit assembly



Feeding tray 0500175			
#	Qty.	Description	Reference
1	1	Feeding tray	401006412
2	1	Feeder guided cylinder assembly	5005057
3	2	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
4	5	ALLEN SCREW DIN 912 M6 x 10 (10mm THREAD)	6310601001
5	1	Handle M8x25	9206430841
6	1	Strip stopper	404000497
7	1	Strip level guide	404000498
8	3	DIN934 HEXAGONAL NUT, M8	6410800001
9	2	DIN 125 M6 WASHER	6610600001
10	1	Strip guide plate	401006227
11	2	DOUBLE HEAD SCREW, DIN7380 M4 X 8	6340400801
12	1	Roller	404000499
13	1	strapping set	5000725
14	1	guide shaft	404000500
15	1	Cutter cylinder assembly (3MM)	5004082
16	1	Tracer feeder assembly	5005317
17	1	Top plate cutter clamping roller base	401006250
18	7	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
19	4	LARGE WASHER DIN9021, M6	6610600011

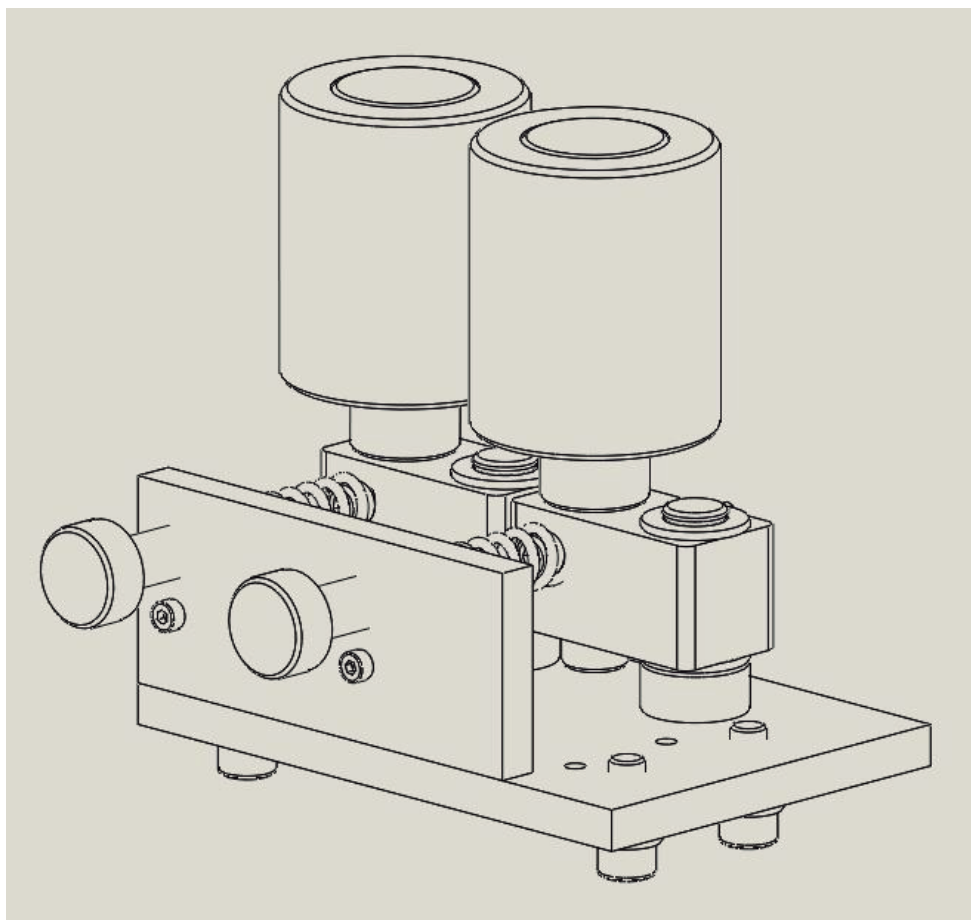
5.2 Feeding shaft assembly



Feeding shaft 5005317			
#	Qty.	Description	Reference
1	1	Tracer bracket support	403002872
2	2	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
3	2	ALLEN SCREW DIN 912 M6 x 35 (24mm THREAD)	6310603501
4	2	DIN 125 M6 WASHER	6610600001
5	2	DIN934 HEXAGONAL NUT, M4	6410400001
6	2	DIN933 HEXAGON SCREW, M4 X 12	6360401201
7	1	Tracer-feeding bracket	409000618
8	4	6800ZZ	
9	2	Conic sprocket di10	
10	1	horizontal gear shaft	404001849
11	1	Panel tracing roller	5005315
12	1	vertical gear shaft	404001850
13	1	Feed Roller	5005316
14	1	PARALLEL PIN DIN6325, 4 X 20 - A - St	6520402001
15	1	Ext. Seeger Ring DIN471 10 X 1	6631000001

PRESSURE ROLLERS

Model: CBC.TPM Series Side Pressure Rollers
Series Version: 00
10/2023



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1. Unit Scope and Description
2. Unit Adjustment And Maintenance
 - 2.1 Pressure Adjustment
 - 2.2 Pressure Rollers Cleaning
3. Unit Composition
 - 3.1 Main Assembly
 - 3.2 Base Support

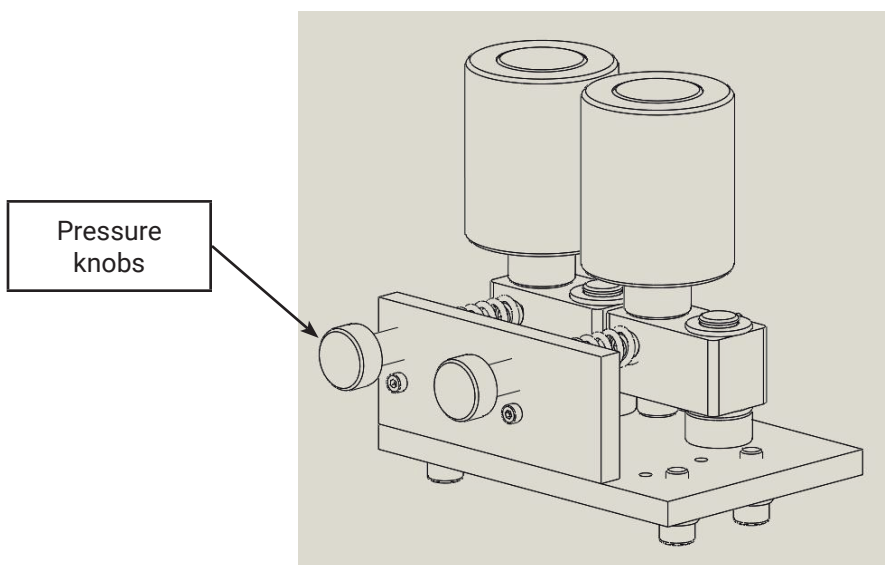
1 UNIT SCOPE AND DESCRIPTION

The roller base functions to apply pressure to the edge, ensuring proper adhesion to the panel.

It consists of two rollers with same diameter that presses evenly on all the surface of the edge against the panel, achieving a perfect adhesion, at the same cooling down the glue and preparing it for next units to work on.

2 UNIT ADJUSTMENT AND MAINTENANCE

2.1 Pressure adjustment



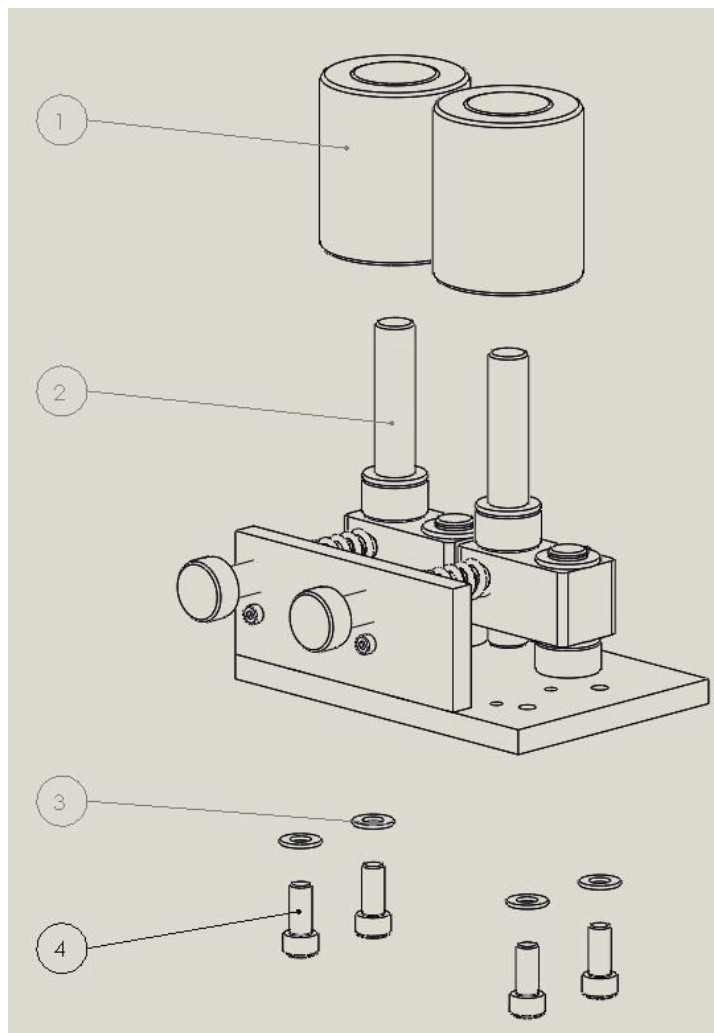
Use pressure knobs, move clockwise to reduce the pressure and counterclockwise to increase the pressure of the rollers on panel.

2.2 Pressure rollers cleaning

For cleaning the rollers, do not use any rigid element that could damage them. To remove glue residue, use a cloth with thinner or a cleaning product.

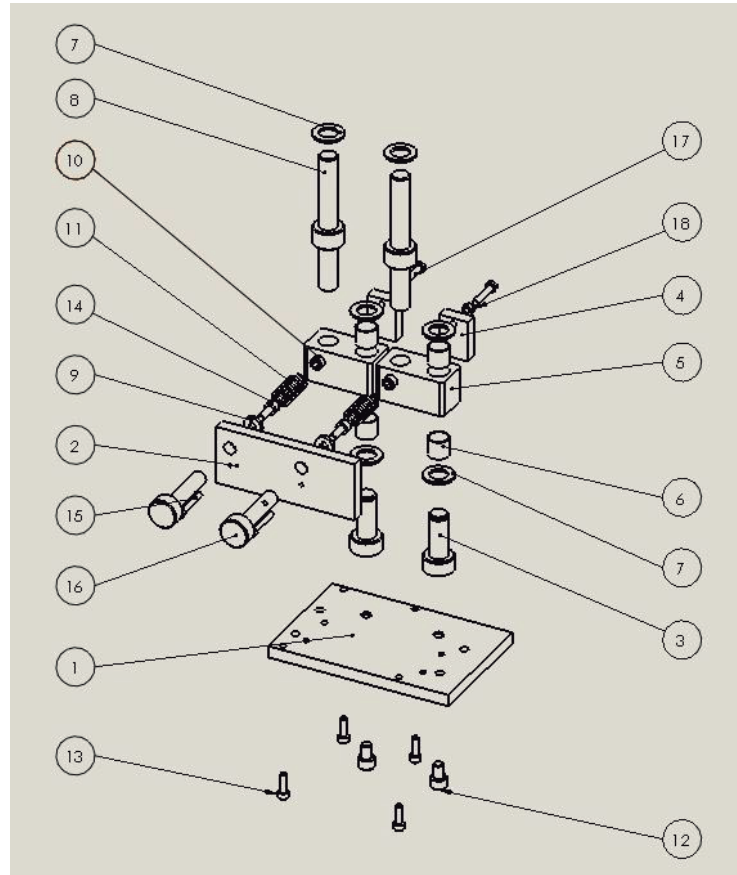
3 UNIT COMPOSITION

3.1 Main assembly



Side Pressure Rollers 0700130			
#	Qty.	Description	Reference
1	2	Straight roller assembly	5000393
2	1	Pressure Set	5005332
3	4	DIN 125 M8 WASHER	6610800001
4	1	ALLEN SCREW DIN 912 M8 x 20 (20mm THREAD)	6310802001

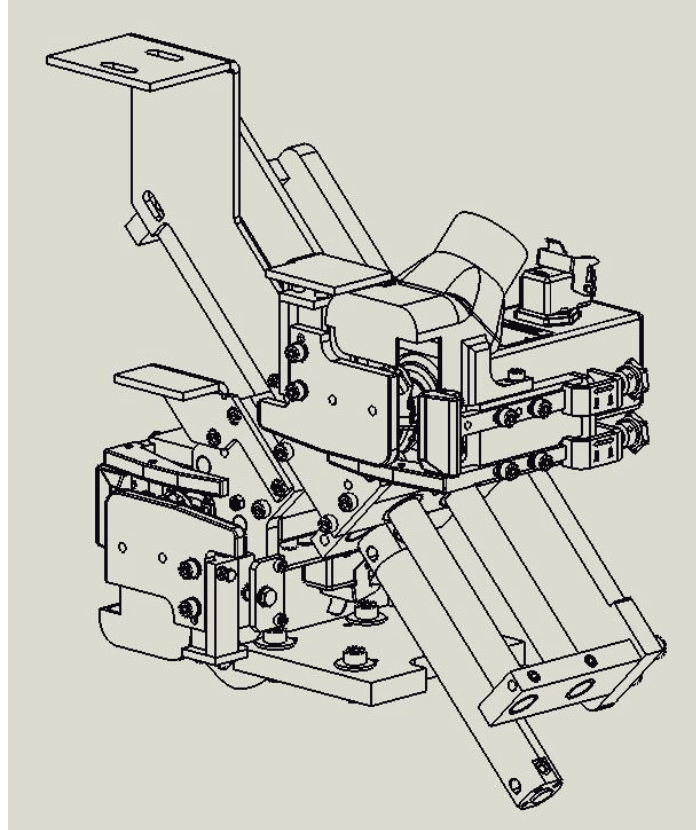
3.2 Base Support



Side Pressure Rollers 5005332			
#	Qty.	Description	Reference
1	1	Roller base plate	409000619
2	1	Front roller base	403002878
3	2	Pivoting shaft	404001851
4	2	Roller pressure stop	403000503
5	2	tilting block	403002325
6	4	PAP1515 P10	6240151501
7	6	Friction washer	404000361
8	2	Guide Roller Shaft	404001852
9	2	Washer 15x3	404000367
10	2	Allen screw M6x40 - DIN 912	allenM6x8
11	2	Spring pressure	9294031501
12	2	ALLEN SCREW DIN 912 M8 x 12 (12mm THREAD)	6310801201
13	4	ALLEN SCREW DIN 912 M5 x 16 (16mm THREAD)	6310501601
14	2	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
15	2	ALLEN SCREW DIN 912 M4 x 30 (20mm THREAD)	6310403001
16	2	Radius Tensioner	404000379
17	2	DIN933 HEXAGON SCREW, M5 X 25	6360502501
18	2	DIN934 HEXAGONAL NUT, M5	6410500001

TRIMMING UNIT TX-4

Model: CBC.TPM Series Trimming Unit TX-4
Series Version: 00
10/2023



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- 1. Introduction
 - 1.1 Description And Objective Of The Unit
 - 1.2 Screen Selection And Manul Activation
- 2. Work Description And Adjustment
 - 2.1 Work Description
 - 2.2 Bottom And Front Working Sequence
 - 2.3 Top And Rear Trimmer Working Sequence
 - 2.4 Work Limits - Minimum Distance Between Panels
 - 2.4.2 Unit Adjustment Points
- 3. Alarms
- 4. Troubleshooting
- 5. Unit Composition
 - 5.1 Complete Unit Composition
 - 5.2 Column Support
 - 5.3 End Trimming/Trimming Block Assembly
 - 5.4 Horizontal Tracing Assembly
 - 5.5 Vertical Tracing Assembly

1 INTRODUCTION

1.1 Description and objective of the unit

The patented unit TX-4, performs the following functions:

- Top and bottom trimming (flat and radius up to 2 mm).
- End trimming with vertical rounding.

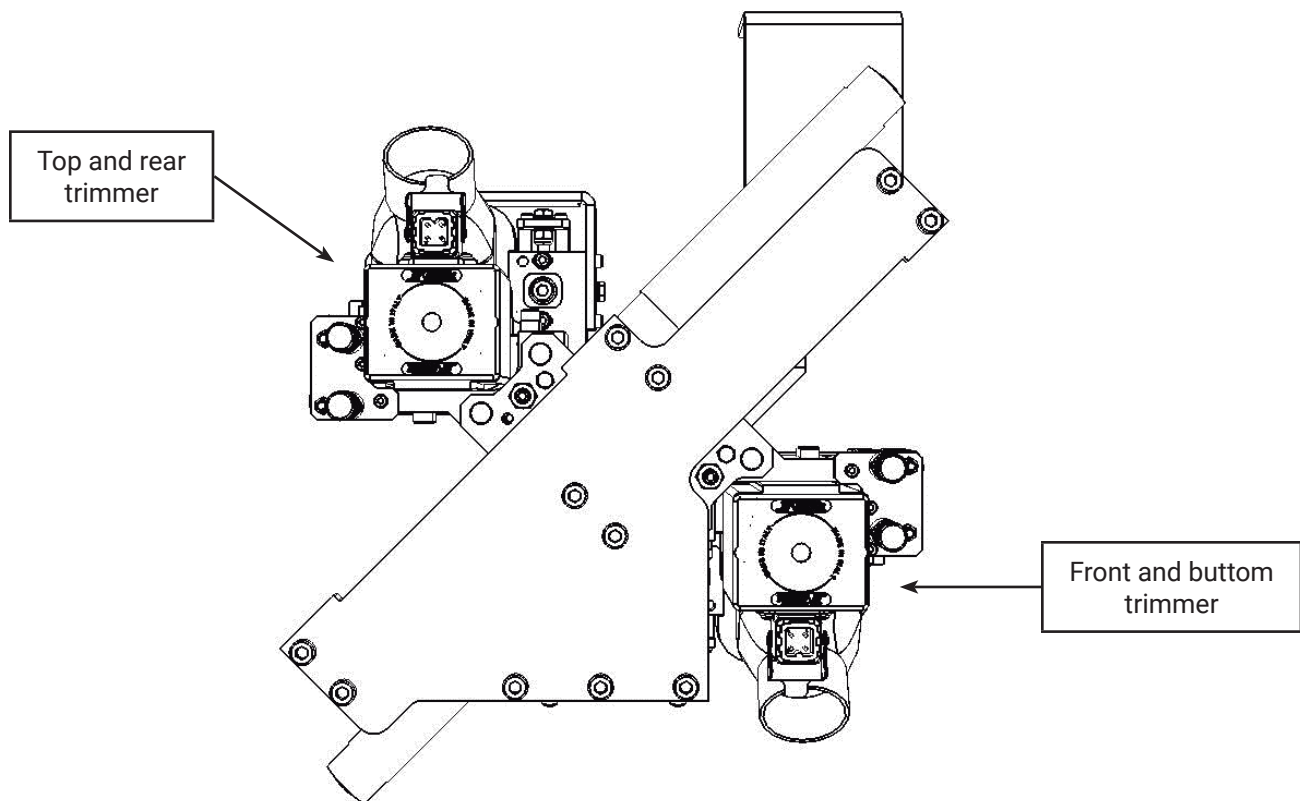
This means, that the unit combines work of end trimming unit and top/bottom trimming unit.

1.2 Screen selection and manual activation

ON	OFF
	

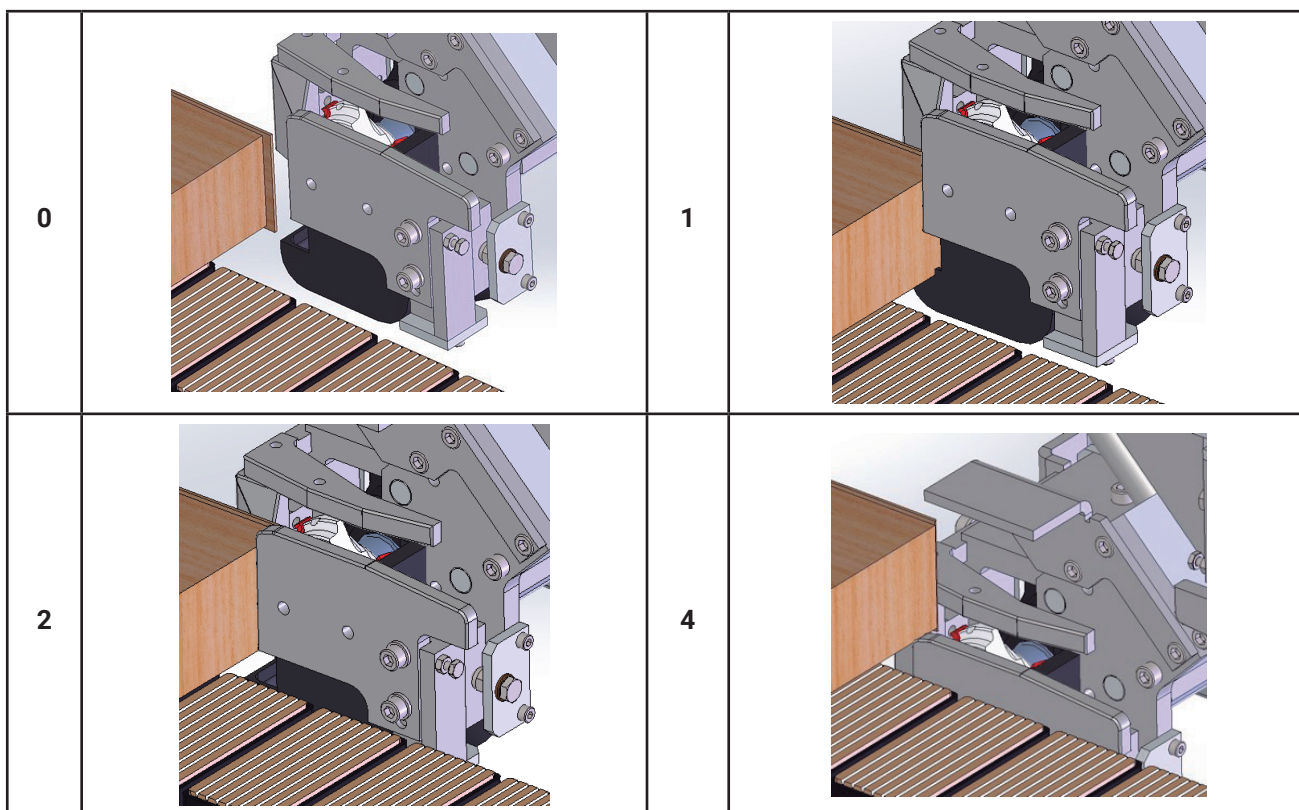
2 WORK DESCRIPTION AND ADJUSTMENT

2.1 Work description

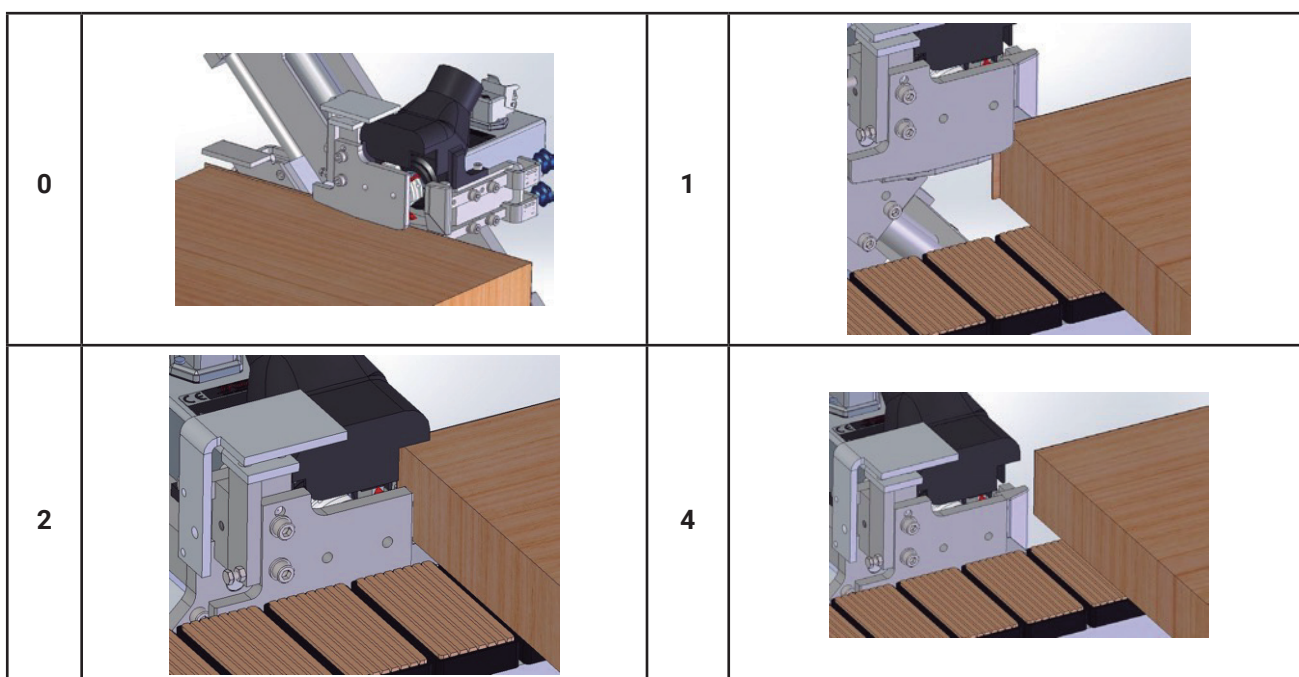


When selecting and feeding a panel, both units go up and wait for next panel.

2.2 Bottom And Front Working Sequence



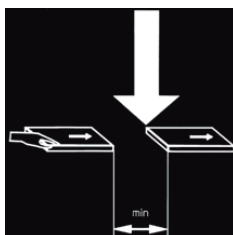
2.3 Top and rear trimmer working sequence



2.4 Work Limits - Minimum distance between panels

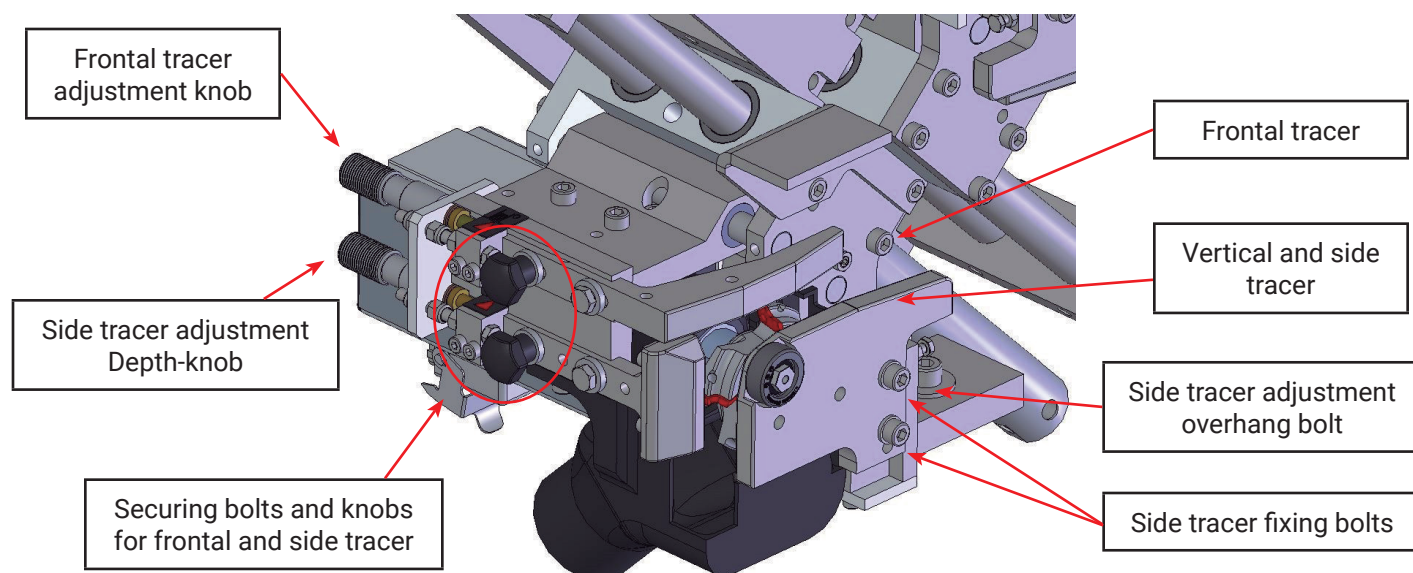


The following sticker indicates the minimum distance between panels when feeding. This safety distance allows the unit to position for the next panel.

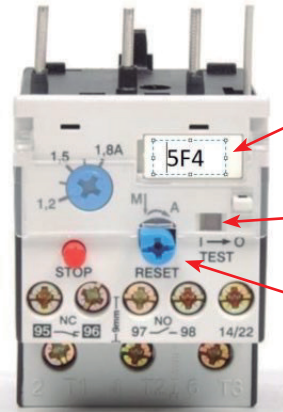
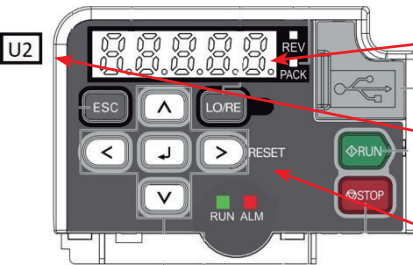


Use the reference sticker and feed the panel when the rear side of the previous panel passes through the minimum distance panels sticker.

2.4.1 Unit adjustment points



3 ALARMS

Alarm	Possible causes	Solutions
Thermal alarm	Thermal relay alarm due to a motor malfunction	 Locate the relay that caused the fault, write down the relay reference to report the fault to the authorized technical service, and press the blue button (RESET) and reset the alarm from the screen. You can disable the unit with faulty motor to continue working.
Inverter	Low input voltage Engine failure Variator failure	 Locate the drive that caused the fault, write down the reference number to report the fault to the authorized technical service, and press the RESET button to be able to reset the fault from the screen.

4 TROUBLESHOOTING

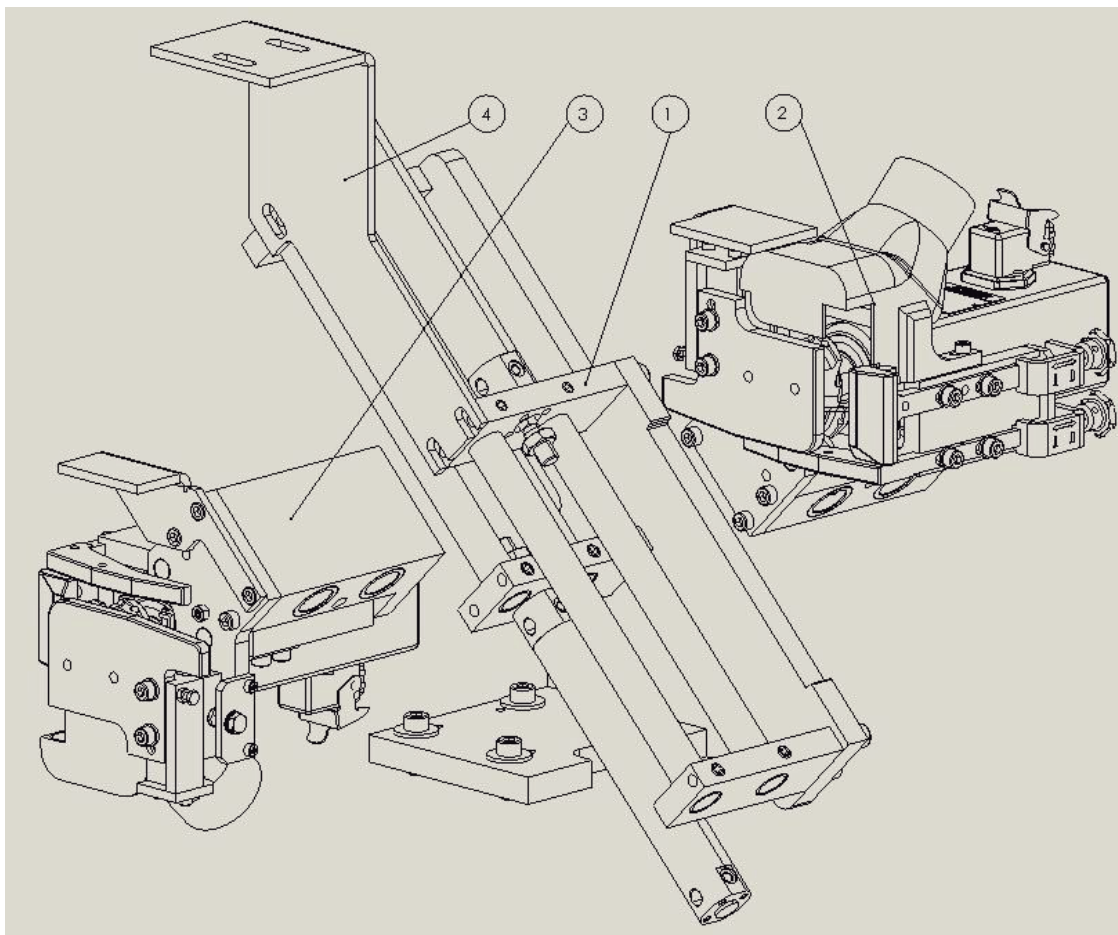
Before making any adjustments to improve the finish, follow the next steps:

- Correct height of the pressure beam: Check that the pressure beam holds the panel properly and that the panel does not move in its path.
- Correct guidance of the chain with a long panel (+1.50m): Check with a long panel that it follows its trajectory with the infeeding fence. If the panel separates at the front or at the rear, this may result in an incorrect finish.
- Cleaning of the tracers: Check that the tracers have no traces of glue or other elements that attribute to false tracing.
- Free movement: Remove the pneumatic pressure to the machine and manually check that the unit moves freely in and out, up and down.
- Continuous pressure: Reconnect the pressure and check that it remains at 0.6MPa.

Error	Possible cause	Solutions
The panel moves	Wrong pressure	Check whether the tamper exerts sufficient pressure. Also clean the chain pads and tamper wheels.
	Incorrect pneumatic pressure	Check the pneumatic diagram to determine the correct pressures.
Does not cut on time	Failure in screen times	Contact an authorized technician to remedy the fault.
Irregular cut	Excessive cutter/ feeder overrun	Adjust the feeder / cutter times so that the overrun does not exceed 10mm.

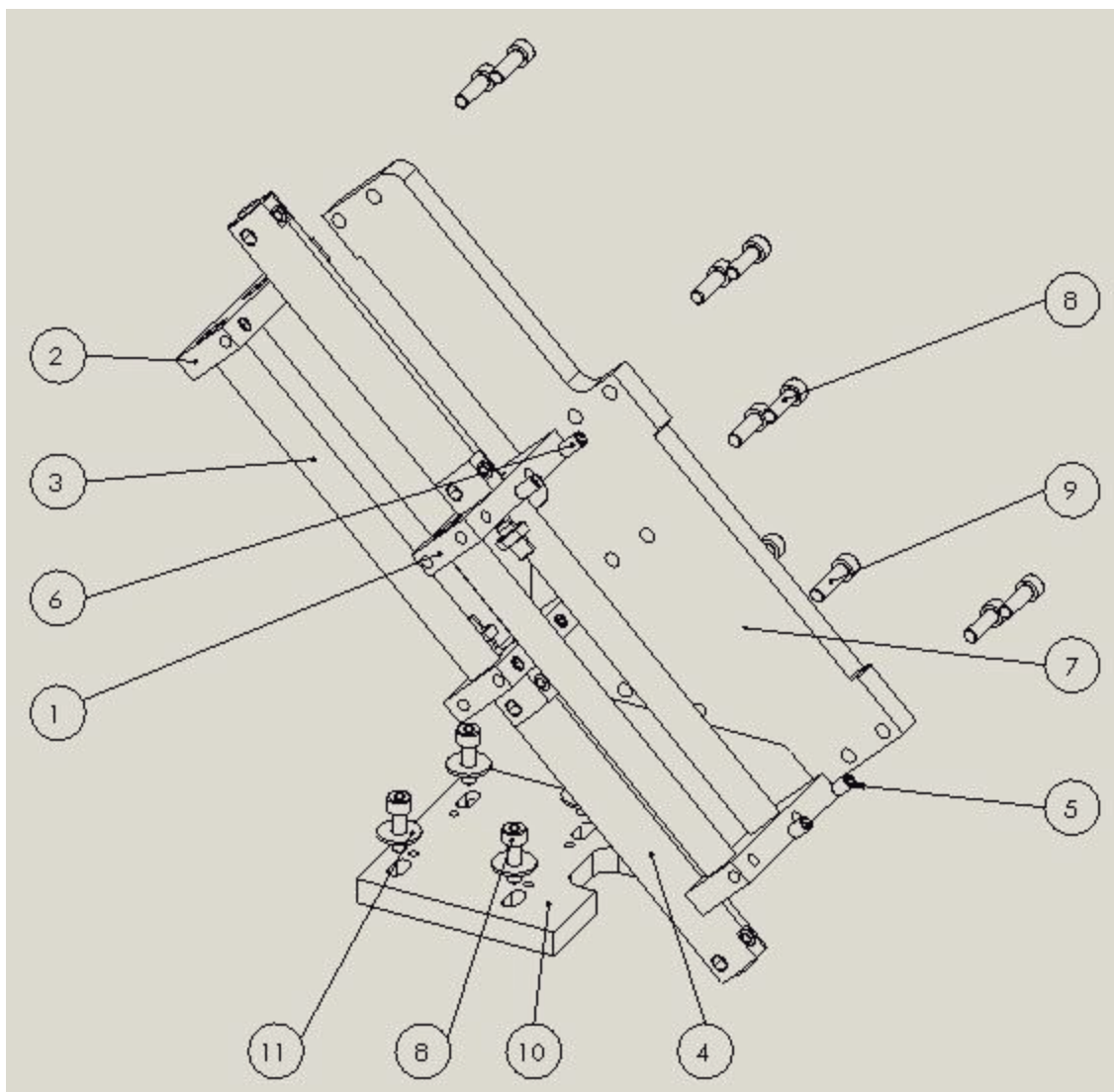
5 UNIT COMPOSITION

5.1 Complete unit composition (0800075)



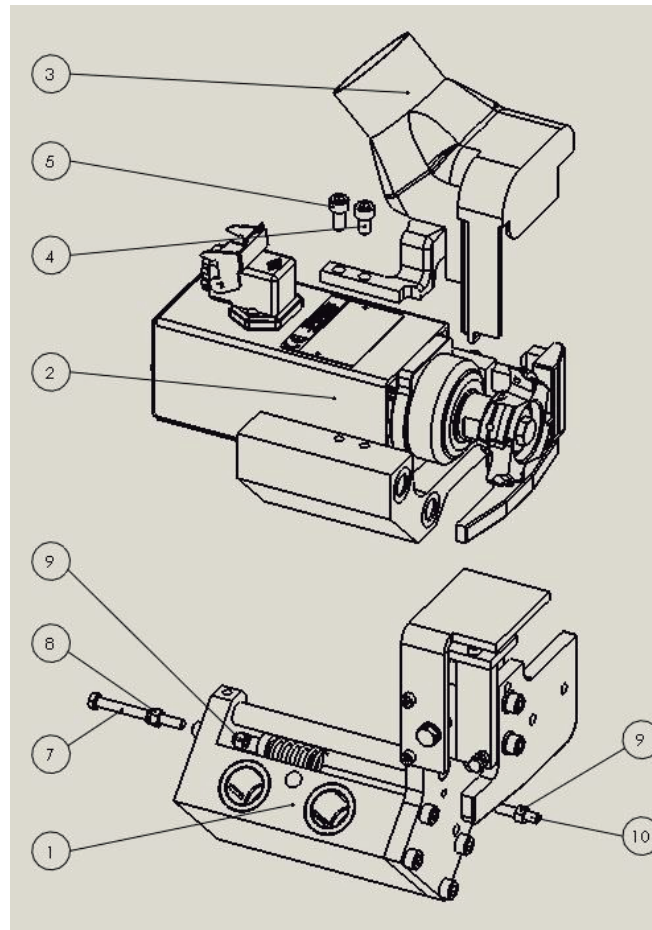
Trimming set TX-4 0800075			
#	Qty.	Description	Reference
1	1	COLUMN SUPPORT	5005427
2	1	End trim/Trimming block assembly	5005430
3	1	End trim/Trimming block assembly	5005430
4	1	Hold-down fixing support	401006426
5	1	COLUMN SUPPORT	5005427

5.2 Column Support (5005427)



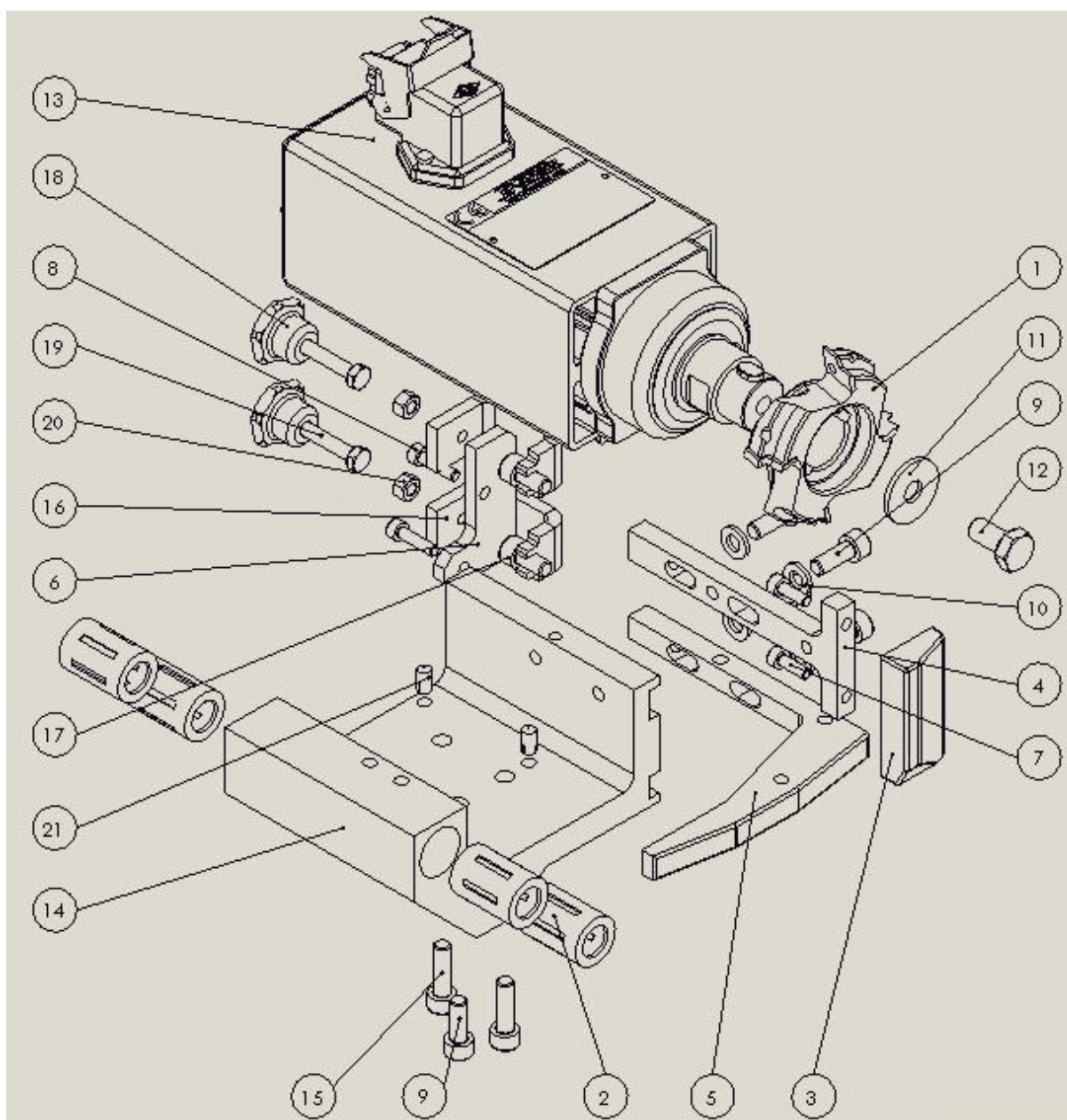
Trimming Support column 5005427			
#	Qty.	Description	Reference
1	2	End bar support	403002918
2	2	Central bar support	403002919
3	4	Support bar	404001842
4	2	CDG1BN25_130Z_0_1_0_	
5	6	FLAT HEAD GRUB SCREW DIN913 M8 X 12	6330801201
6	2	FLAT HEAD GRUB SCREW DIN913 M8 X 16	6330801601
7	1	Bar support front plate	403002920
8	12	ALLEN SCREW DIN 912 M8 x 25 (25mm THREAD)	6310802501
9	3	ALLEN SCREW DIN 912 M8 x 30 (30mm THREAD)	6310803001
10	1	Group support base	403002921

5.3 End trimming/trimming block assembly (5005430)



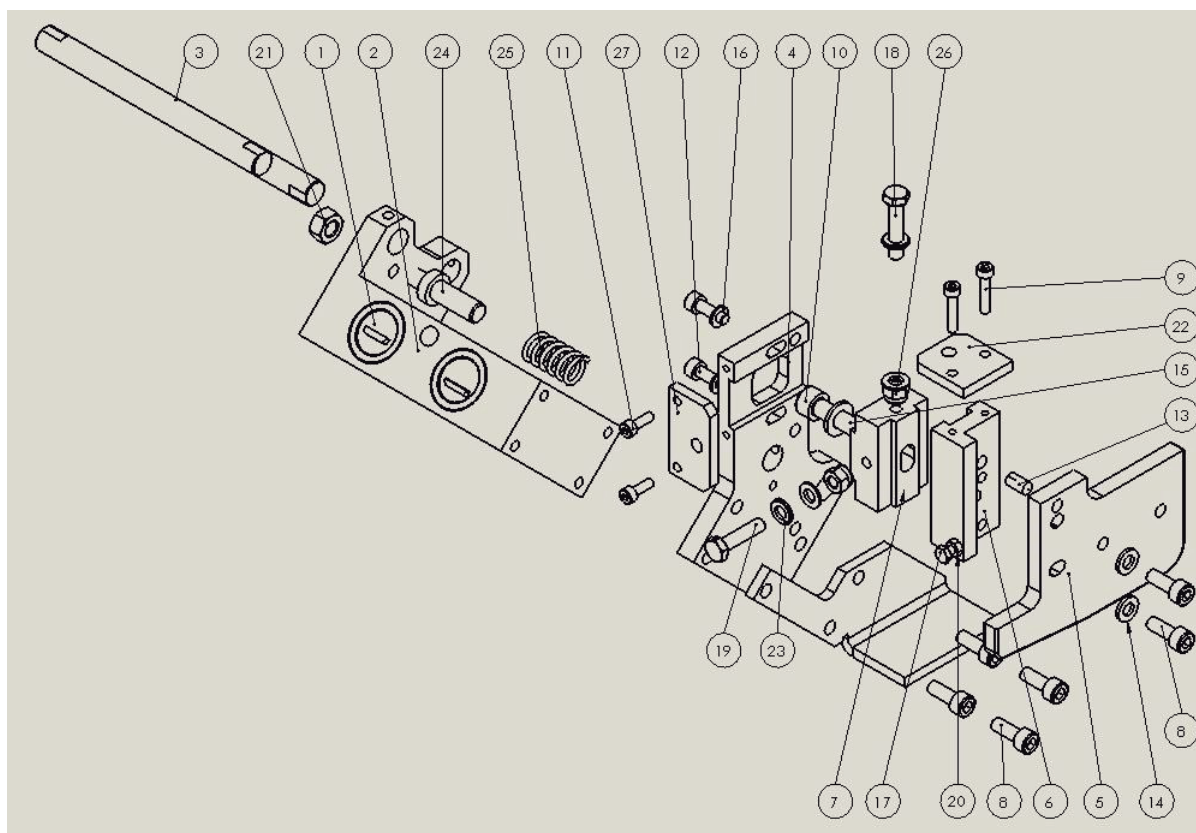
Trimming block assembly 5005430			
#	Qty.	Description	Reference
1	1	End-cutting/trimming vertical tracer block	5005429
2	1	Horizontal tracer block end trimming/trimming	5005428
3	1	VF-1 aspiration	408000251
4	1	ALLEN SCREW DIN 912 M6 x 10 (10mm THREAD)	6310601001
5	1	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
6	1	ALLEN SCREW DIN 912 M5 x 12 (12mm THREAD)	6310501201
7	1	DIN933 HEXAGON SCREW, M5 X 50	6360505001
8	1	SELF LOCKING NUT DIN982, M5	6420500001
9	2	DIN934 HEXAGONAL NUT, M5	6410500001
10	1	FLAT HEAD PRISONER DIN913 M5 X 25	6330502501

5.4 Horizontal tracing assembly (5005428)



Horizontal tracing assembly 5005428			
#	Qty.	Description	Reference
1	1	JC-2 cutter block	17483
2	4	KH12PP Linear Bearing	102000028
3	1	End trimming tracer	403002922
4	1	End trimming tracer support	407000352
5	1	Trimming Front tracer	407000355
6	1	Handrail Tracers adjustment	401006397
7	2	ALLEN SCREW DIN 912 M4 x 12 (12mm THREAD)	6310401201
8	2	ALLEN SCREW DIN 912 M4 x 16 (16mm THREAD)	6310401601
9	3	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
10	4	DIN 125 M6 WASHER	6610600001
11	1	LARGE WASHER DIN9021, M8	6610800011
12	1	DIN933 HEXAGON SCREW, M8 X 16	6360801601
13	1	Teknomotor JC-2 motor	5800550721
14	1	Motor/tracer support block	408000250
15	4	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
16	2	Positioner carpenter stop	401006410
17	2	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
18	2	Elesa vh 153-25	102000275
19	2	DIN933 HEXAGON SCREW, M5 X 35	6360503501
20	2	DIN934 HEXAGONAL NUT, M5	6410500001

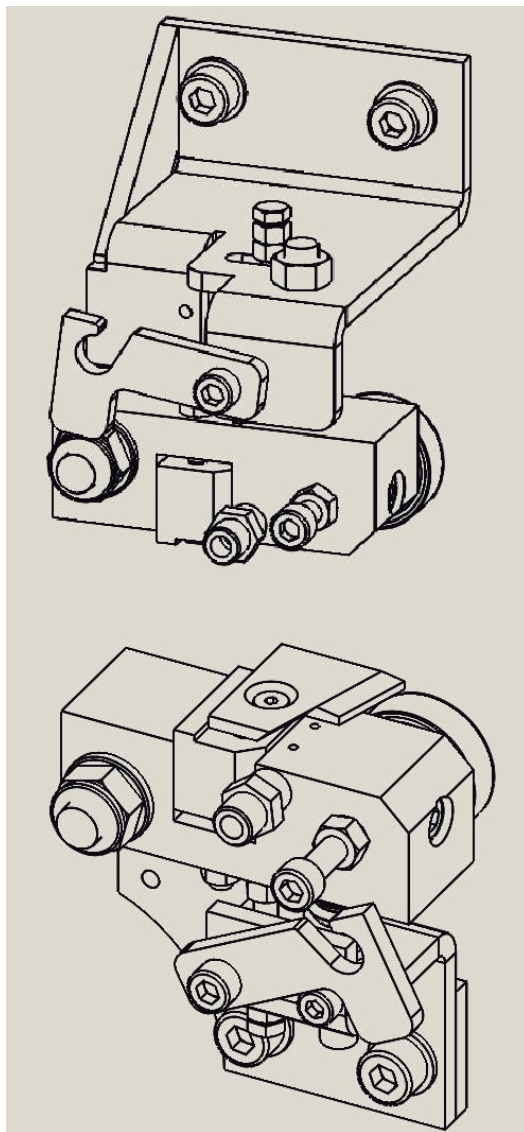
5.5 Vertical tracing assembly (5005429)



Vertical tracing assembly 5005429			
#	Qty.	Description	Reference
1	4	Linear ball bushing KH2030	6172030001
2	1	Sliding/tracing block	409000625
3	2	Linear Guide Ina w12 h6 L:133	404001875
4	1	Vertical tracer support	407000354
5	1	Vertical tracer trigger	407000348
6	1	Horizontal/perpendicular adjustment of vertical tracer	403002862
7	1	Vertical tracer adjustment block	403002861
8	6	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
9	2	ALLEN SCREW DIN 912 M4 x 20 (20mm THREAD)	6310402001
10	1	ALLEN SCREW DIN 912 M8 x 30 (30mm THREAD)	6310803001
11	2	ALLEN SCREW DIN 912 M4 x 12 (12mm THREAD)	6310401201
12	2	ALLEN SCREW DIN 912 M5 x 16 (16mm THREAD)	6310501601
13	1	Knurled PIN DIN1472 6 x 12	6570601201
14	2	DIN 125 M6 WASHER	6610600001
15	1	DIN 125 M8 WASHER	6610800001
16	2	DIN 125 M5 WASHER	6610500001
17	1	DIN933 HEXAGON SCREW, M4 X 16	6360401601
18	1	DIN933 HEXAGON SCREW, M6 X 30	6360603001
19	1	DIN933 HEXAGON SCREW, M6 X 25	6360602501
20	1	DIN934 HEXAGONAL NUT, M4	6410400001
21	1	DIN934 HEXAGONAL NUT, M8	6410800001
22	1	Vertical adjustment handrail	403002866
23	4	M6 brass washer	6610600201
24	1	Horizontal tracer regulator	404001860
25	1	Spring pressure	9294031501
26	2	SELF LOCKING NUT DIN982, M6	6420600001
27	1	Horizontal adjustment handrail	403002865
28	1	Rear car top stop	401006311

GLUE SCRAPPER

Model: CBC.TPM Series Glue Scrapper RR-1
Series Version: 00
10/2023



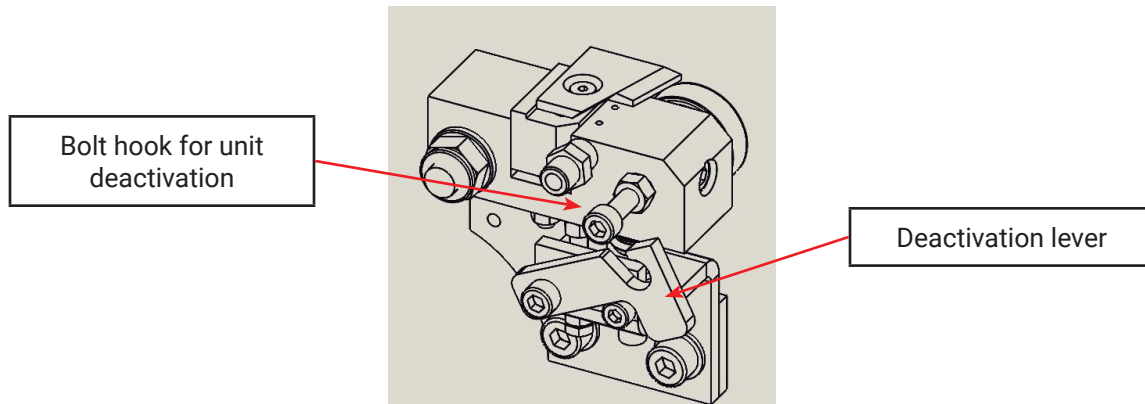
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1. Unit Scope and Description
2. Operation And Adjustment
3. Maintenance
 - 3.1 General Maintenance
 - 3.2 Tool Change
4. Troubleshooting
5. Unit Composition
 - 5.1 Top Glue Scrapper
 - 5.2 Bottom Glue Scrapper

1 UNIT SCOPE AND DESCRIPTION

The glue scraper is used to remove excess of glue that may have remained in the gluing process and leave a better finish. It consists of a vertical tracer that acts on the panel and a blade that attacks the edge to eliminate excess of glue.

2 OPERATION AND ADJUSTMENT



To activate the unit, you must remove the deactivation lever from the bolt hook. To deactivate the unit again, lift the group slightly, and insert the deactivation lever.

3 MAINTENANCE



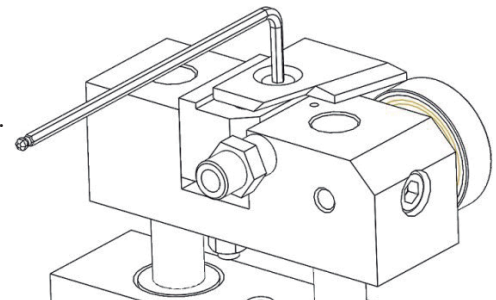
Before starting the Maintenance, turn off the machine (disconnect completely electrically) and disconnect compressed air. Only trained personnel can perform these operations.

3.1 General maintenance

- Clean the tracer of the unit daily with a mild cleaning agent.
- Clean the blades daily with a mild cleaning agent.
- Remove (vacuum) any chip debris and edge excess that may be near the unit.

3.2 Tool change

- Use a 3mm Allen key to remove the screw holding the blade.
- Clean the blade holder and before installing the new blade.

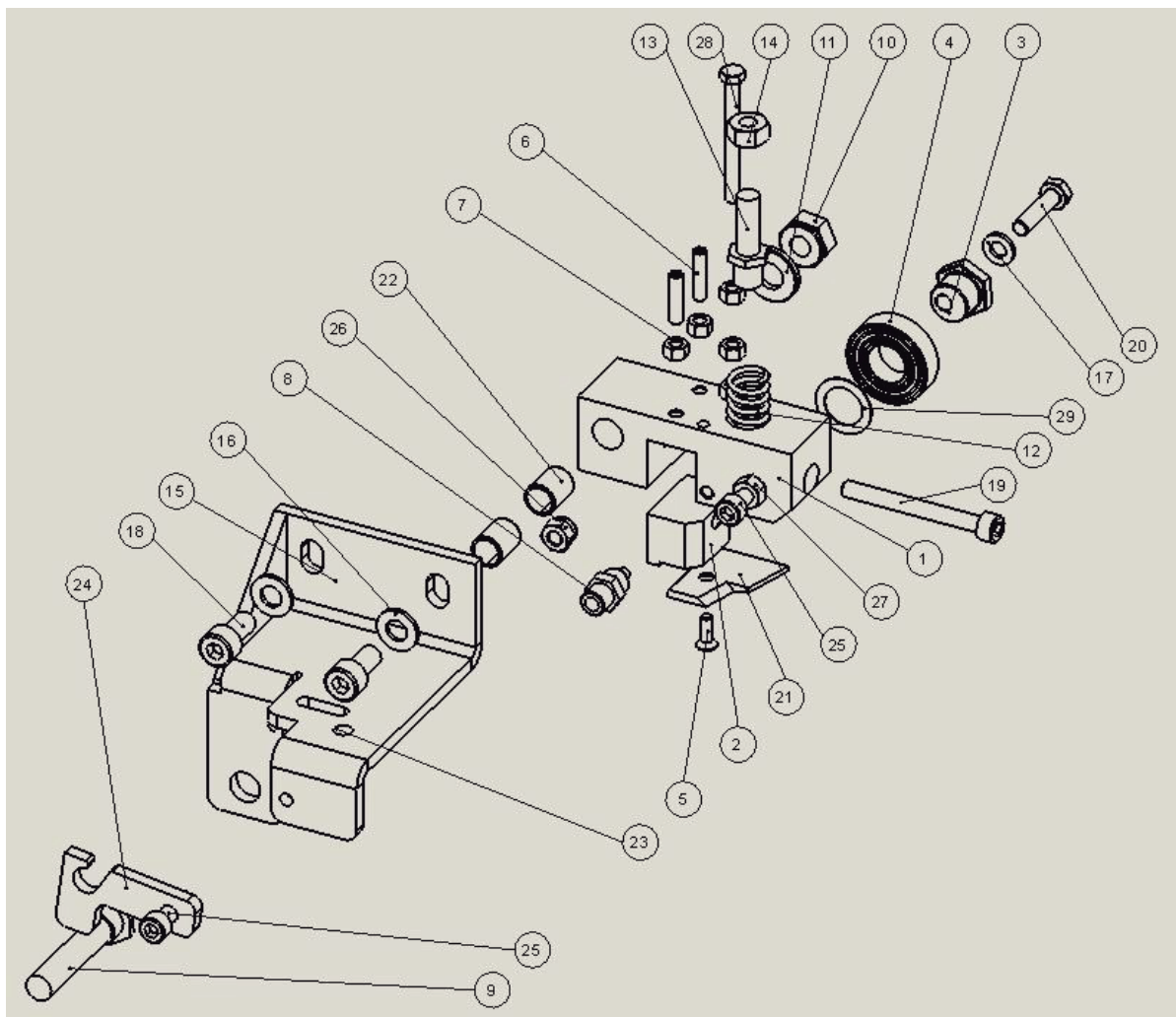


4 TROUBLESHOOTING

Fault	Possible cause	Solutions
Overhang	Blade is not clean	Clean the blade with a mild thinner.
	Incorrect unit tracing	Check if the unit is tracing 1mm.
	Blade damaged	Change the blade.
Panel with scratches	Irregular panel	Check with a freshly cut new panel to determine if the fault is coming from the board or the unit.
	Unit unaligned	Adjust the unit with the support of a trained technician.

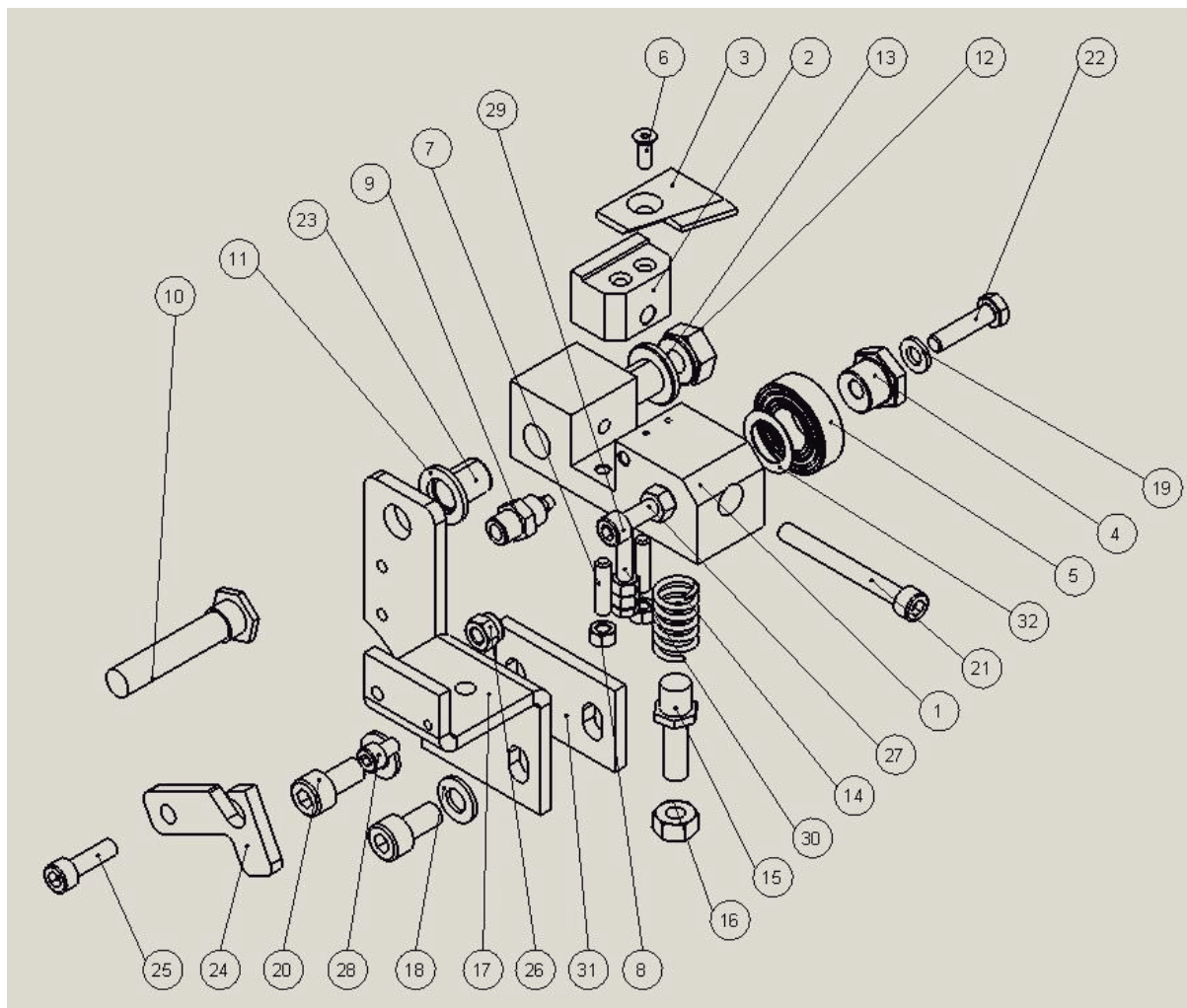
5 UNIT COMPOSITION

5.1 Top glue scrapper (1200032)



Top glue scrapper RR-1 1200032			
#	Qty.	Description	Reference
1	1	Top main body	403002887
2	1	Blade support	403000136
3	1	Eccentric bearing 6002	404000075
4	1	Bearing 6002-2ZR	5000057
5	1	COUNTERSUNK SCREW DIN7991, M4 X 12THREAD:12mm	6320401202
6	2	FLAT HEAD PRISONER DIN913 M5 X 20	6330502001
7	5	DIN934 HEXAGONAL NUT, M5	6410500001
8	1	Straight fitting	
9	1	Scraper tracer shaft	404001862
10	1	DIN 985 M10 self-locking nut	
11	1	M10 Washer	6611000101
12	1	Spring pressure	9294031501
13	1	Spring adjustment	404000357
14	1	DIN 934 - M8 Nut	6410800001
15	1	Reinforced top bracket	5005512
16	2	DIN 125 M8 WASHER	6610800001
17	1	DIN 125 M6 WASHER	6610600001
18	2	ALLEN SCREW DIN 912 M8 x 16 (16mm THREAD)	6310801601
19	1	ALLEN SCREW DIN 912 M6 x 55 (24mm THREAD)	6310605501
20	1	DIN933 HEXAGON SCREW, M6 X 25	6360602501
21	1	Glue scraper blade	409000033
22	2	1015du	102000582
23	1	Spacer washer	404000355
24	1	Locking plate RR-1	401006367
25	2	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
26	1	SELF LOCKING NUT DIN982, M6	6420600001
27	1	Hexagon Nut ISO 4033 - M6 - W - N	
28	1	DIN933 HEXAGON SCREW, M5 X 50	6360505001
29	1	Tracer spacer washer	404001889

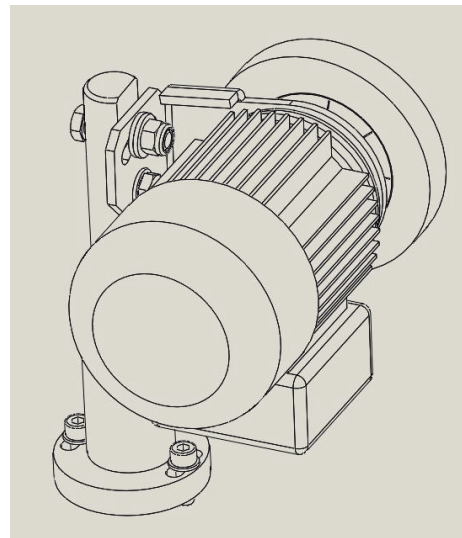
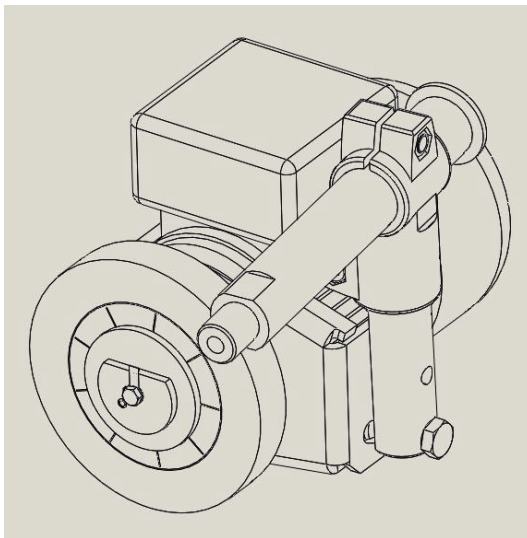
5.2 Bottom glue scrapper 1200033



Bottom glue scrapper RR-1 1200033			
#	Qty.	Description	Reference
1	1	Main body top	403002887
2	1	Blade support	403000136
3	1	Blade Symmetry	409000030
4	1	Eccentric bearing 6002	404000075
5	1	Bearing 6002-2ZR	5000057
6	1	DIN7991 COUNTERSUNK SCREW, M4 X 12	6320401202
7	2	FLAT HEAD PRISONER DIN913 M5 X 20	6330502001
8	5	DIN934 HEXAGONAL NUT, M5	6410500001
9	1	Straight fitting	
10	1	Scraper copier shaft	404001862
11	1	spacer washer	404000355
12	1	DIN 985 M10 self-locking nut	M10
13	1	M10 Washer	6611000101
14	1	Spring pressure	9294031501
15	1	Spring adjustment	404000357
16	1	DIN 934 - M8 Nut	6410800001
17	1	RR-1 Bottom Bracket	401006522
18	2	DIN 125 M8 WASHER	6610800001
19	1	DIN 125 M6 WASHER	6610600001
20	2	ALLEN SCREW DIN 912 M8 x 16 (16mm THREAD)	6310801601
21	1	ALLEN SCREW DIN 912 M6 x 55 (24mm THREAD)	6310605501
22	1	DIN933 HEXAGON SCREW, M6 X 25	6360602501
23	2	1015du	102000582
24	1	Locking plate RR-1	401006367
25	1	ALLEN SCREW DIN 912 M6 x 20 (20mm THREAD)	6310602001
26	1	SELF LOCKING NUT DIN982, M6	6420600001
27	1	Hexagon Nut ISO 4033 - M6 - W - N	
28	1	ALLEN SCREW DIN 912 M5 x 8 (8mm THREAD)	6310500801
29	1	ALLEN SCREW DIN 912 M6 x 25 (25mm THREAD)	6310602501
30	1	DIN933 HEXAGON SCREW, M5 X 40	6360504001
31	1	bottom bracket spacer	401006525
32	1	Copier spacer washer	404001889

BUFFING UNIT PC-3

Model: CBC.TPM Series Buffing Unit PC-3
Series Version: 00
10/2023



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1. Unit Scope and Description
2. Screen Selection And Unit Activation
3. Operation And Adjustment
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 - 3.3 Electric Composition
 - 3.4 Unit Adjustment
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 - 4.1 Change Polishing Clothes
5. Alarms
6. Troubleshooting
7. Unit Composition
 - 7.1 Top Buffing Unit
 - 7.2 Bottom Buffing Unit
 - 7.3 Buffing Disk Assembly

1 UNIT SCOPE AND DESCRIPTION

The function of the group is to polish sharp edges and smooth the finish, also clean the remains of glue that have remained on the panel. It consists of two motors of 0.11 kW of power. It is possible to install a huge variety of polishing cloths.

2 SCREEN SELECTION AND UNIT ACTIVATION

ON	OFF
	

3 OPERATION AND ADJUSTMENT

3.1 Work description

- The group oversees cleaning, polishing and smoothing the work of the trimmers, radius scraper and glue scraper.
- In the case of 0.4mm edge, after machining the group with a trimmer or the glue scraper, the group smooths the sharp edge.
- In the case of working with the cleaning agent, helps to remove the remains of glue.

3.2 Unit work position

- Approximately 3° tilt vertically.
- Approximately 3° tilt horizontally.
- No oscillation
- Rotation in the direction of the panel.

3.3 Electric composition



This configuration detailed below might change. Please check the update electric diagram to confirm the correct electric components.

	Motor	Thermal relay	Inverter
Top motor	2M1	2F1	U3
Bottom motor	2M2	2F2	

3.4 Unit adjustment

Security warning

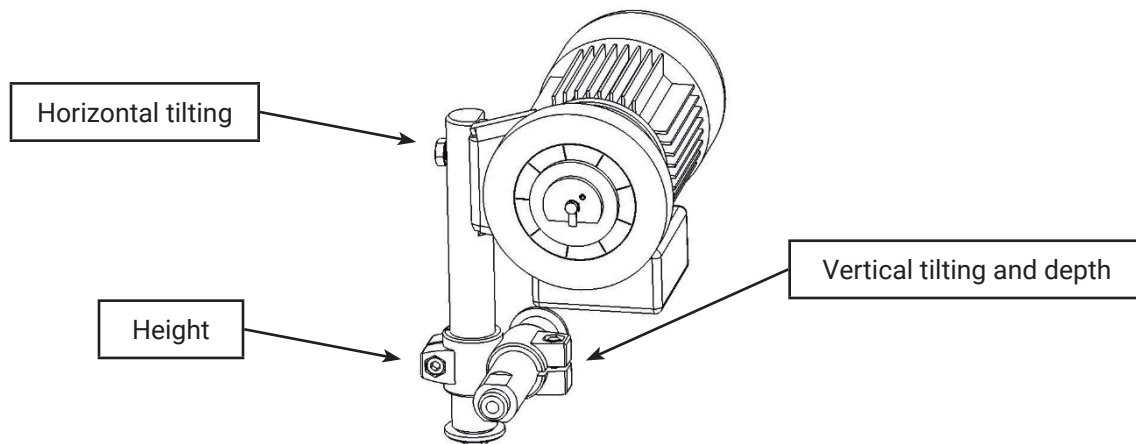


A trained technician with special tools adjusts this unit. For this reason, MAKSIWA does not recommend handling without the support of an authorized technician. The pre-milling unit has cutting blades that can cause serious damage under improper use of the unit. Do not adjust the unit while the machine is running to avoid enrollment with the chain. For proper handling, disconnection of the unit is essential.



Before making any adjustments, try to solve the problem with the appropriate preventive/corrective actions, and follow these steps detailed in the section on common errors and failures.

Move forward or backward, loosening the horizontal fixing nut, to move it vertically, loosen the vertical movement-fixing nut and manipulate the motor vertically to the necessary height. To rotate the motor position, loosen the rotation-locking nut (3).



4 MAINTENANCE

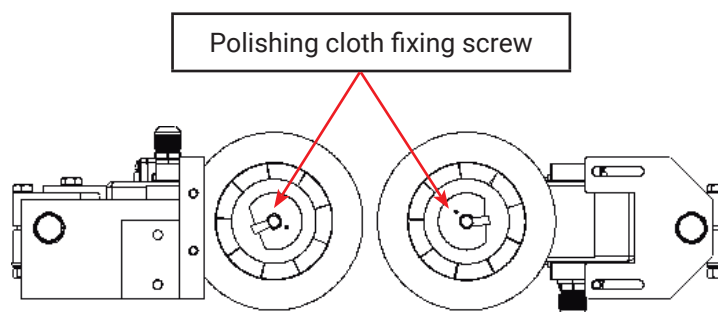
Before starting the Maintenance, turn off the machine (disconnect completely electrically) and disconnect compressed air. Only trained personnel can perform these operations.

General maintenance

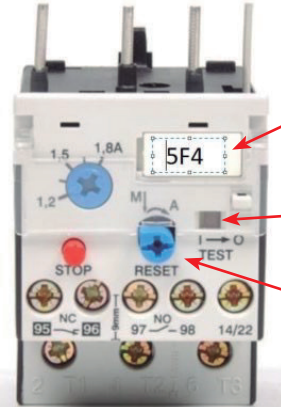
- Clean polishing cloths daily.
- Clean (vacuum) everyday chips and strings of PVC and glue from trimmers and scrappers.
- Check manually everyday if the motor is moving freely.

4.1 Change polishing clothes

To replace the polishing cloth, loosen the fixing screw of the polishing cloth, leaving it free to be replaced. To block the rotation of the motor, insert the key from behind and at the same time loosen the screw.



5 ALARMS

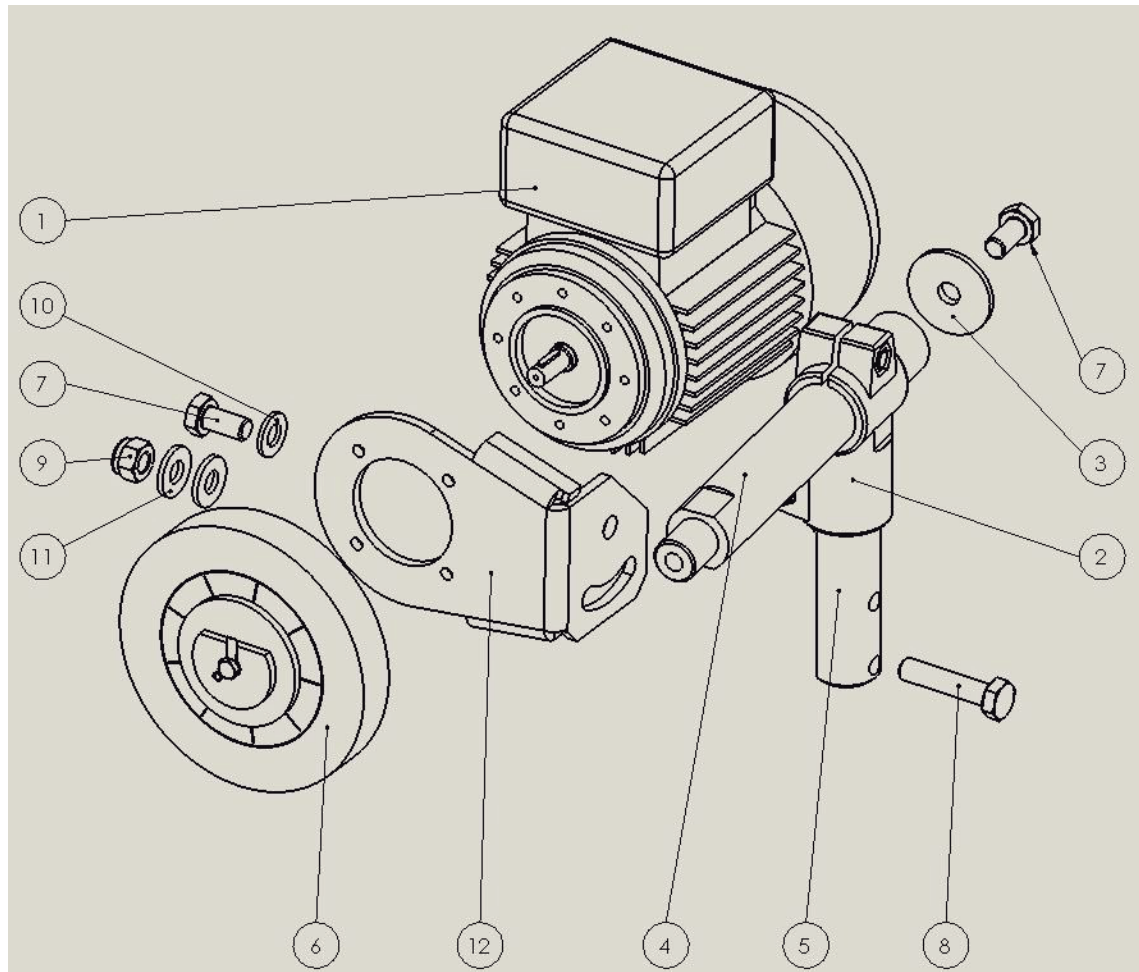
Alarm	Possible cause	Solution
Thermic relay	Thermal relay alarm due to a motor malfunction	 Locate the relay that caused the fault, write down the relay reference to report the fault to the authorized technical service, and press the blue button (RESET) and reset the alarm from the screen. You can disable the unit with faulty motor to continue working.

6 TROUBLESHOOTING

Fault	Possible cause	Solutions
Motor blocked /thermal relay alarm	Glue/edge strings from glue scrapper	Remove the excess of PVC/glue from motor.
Finish not clean	Dirty clothes	Change polishing clothes
Watermarks on panel	Too much pressure on panel	Reduce unit height to reduce pressure on panel.

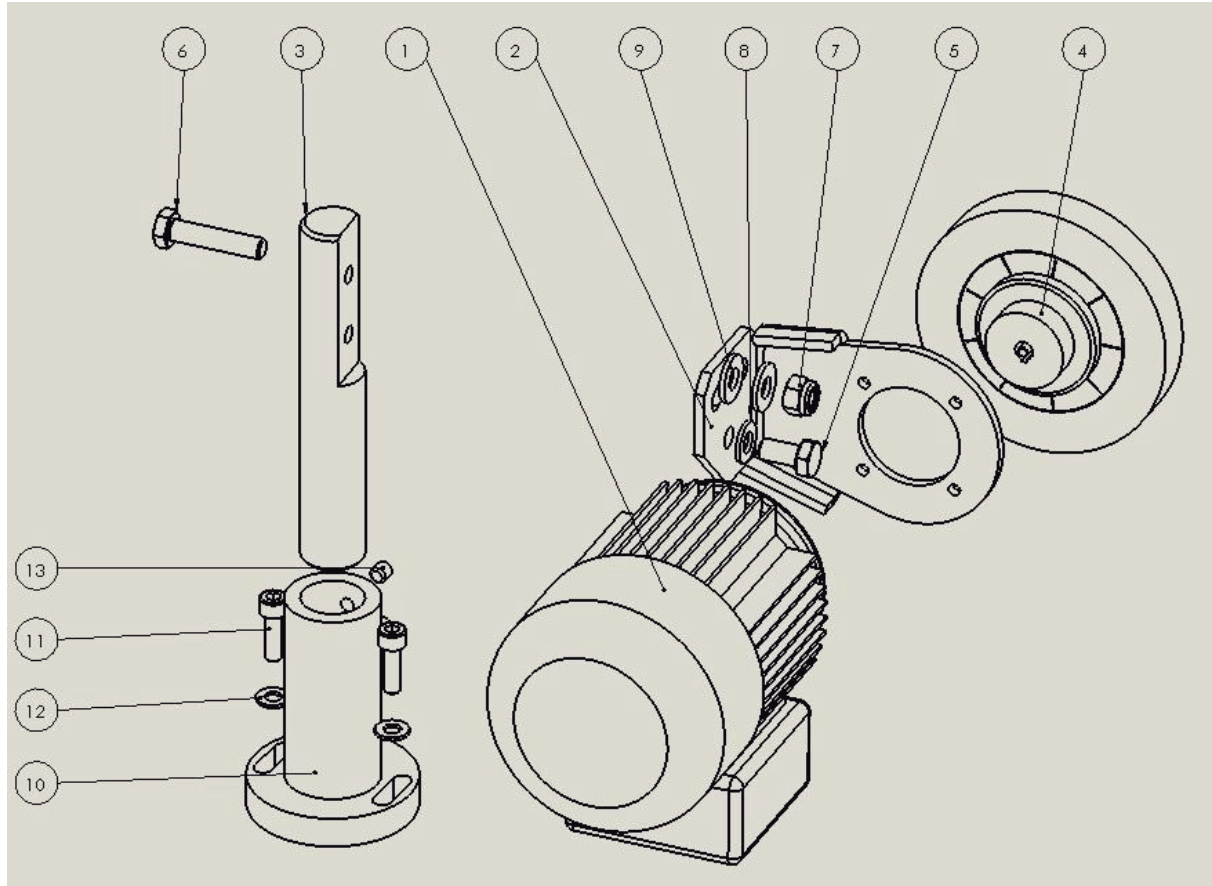
7 UNIT COMPOSITION

7.1 Top buffing unit (1300042)



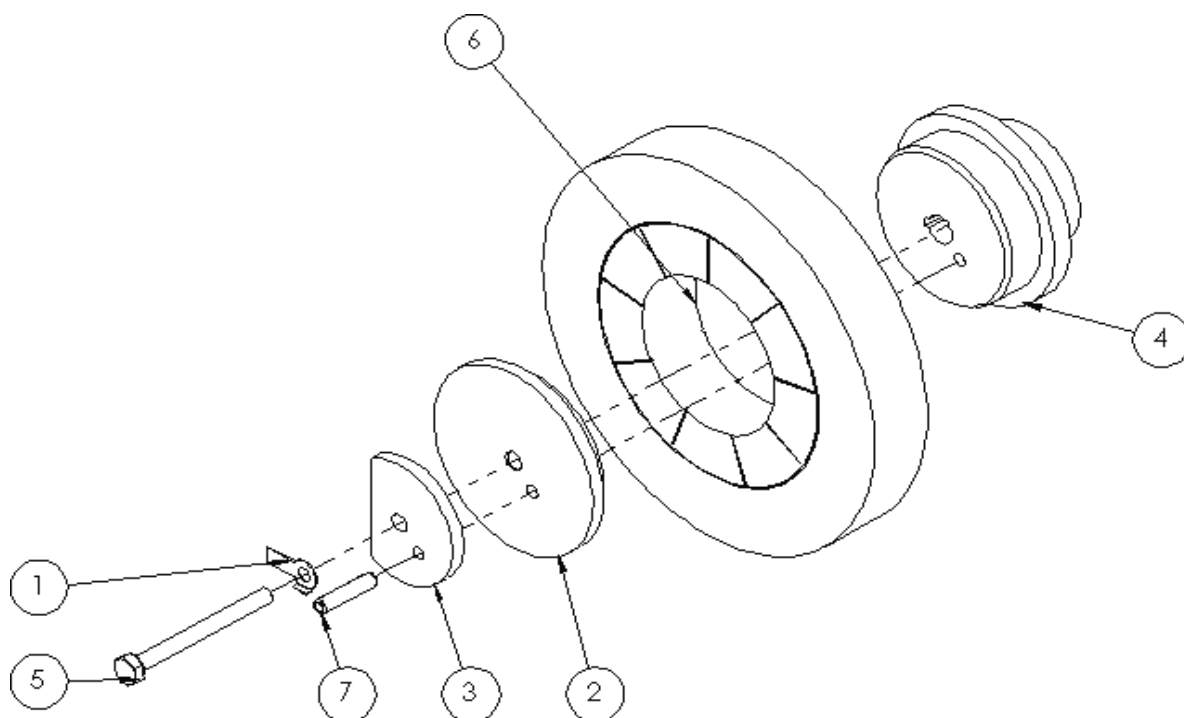
Top buffing unit 1300042			
#	Qty.	Description	Reference
1	1	Transtecno TS5624B14 - 0.09 kW - 1320rpm	100000013
2	1	T-angle connector clamp GN 192-B30-B30-40-2-SW	102000568
3	1	Extendable apron washer	404000377
4	1	Top fixed bar	404001372
5	1	Tilting column (upper)	404001697
6	1	polishing set	5002132
7	2	DIN933 HEXAGON SCREW, M10 X 20	6361002001
8	1	DIN933 HEXAGON SCREW, M10 X 45	6361004501
9	1	SELF LOCKING NUT DIN982, M10	6421000001
10	1	DIN 125 M10 WASHER	6611000001
11	2	Conical Washer DIN 6796-10	6691000001
12	1	Top motor support flange	401006526

7.2 Bottom buffing unit (1300039)



Bottom buffing unit 1300039			
#	Qty.	Description	Reference
1	1	Transtecno TS5624B14 - 0.09 kW - 1320rpm	100000013
2	1	Motor support flange	401004789
3	1	Tilting column	404001465
4	1	Buffing disc set	5002132
5	1	DIN933 HEXAGON SCREW, M10 X 20	6361002001
6	1	DIN933 HEXAGON SCREW, M10 X 45	6361004501
7	1	SELF LOCKING NUT DIN982, M10	6421000001
8	1	DIN 125 M10 WASHER	6611000001
9	2	Conical washer DIN 6796-10	6691000001
10	1	Bottom buffing support	404001879
11	2	ALLEN SCREW DIN 912 M8 x 25 (25mm THREAD)	6310802501
12	2	DIN 125 M8 WASHER	6610800001
13	2	FLAT HEAD PRISONER DIN913 M8 X 8	6330800801

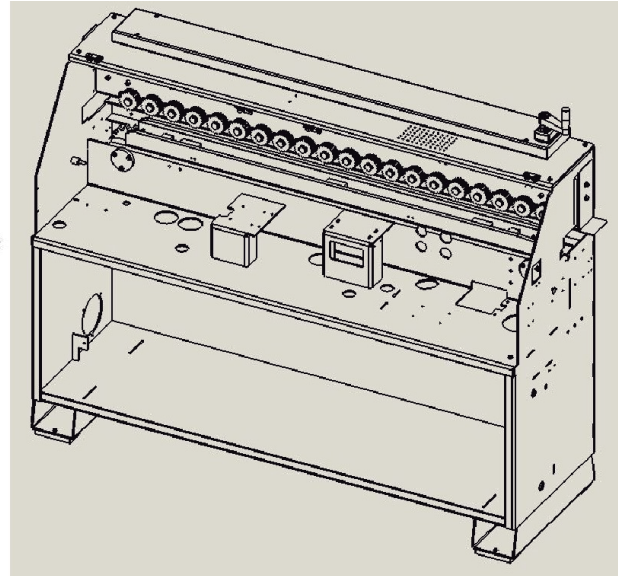
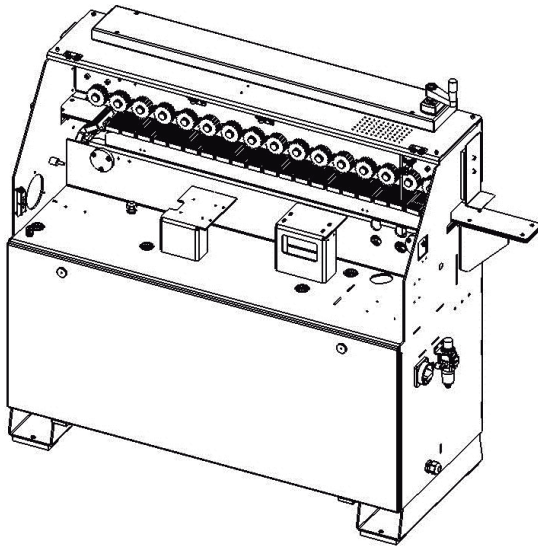
7.3 Buffing disk assembly



5002132 Buffing disc set			
#	Qty.	Description	Reference
1	1	Fixing washer D463 M4	102000176
2	1	Bolt fixing plate	404000754
3	1	Out gasket	404000971
4	1	Disk positioner	404000997
5	1	Hex bolt DIN933, M4 X50	6360405001
6	1	Buffing disk	9331251911
7	1	Elastic pin DIN 1481 D4 x 20	

BENCH FRAME

Model: CBC.TPM Series Bench Frame
Series Version: 00
09/2023

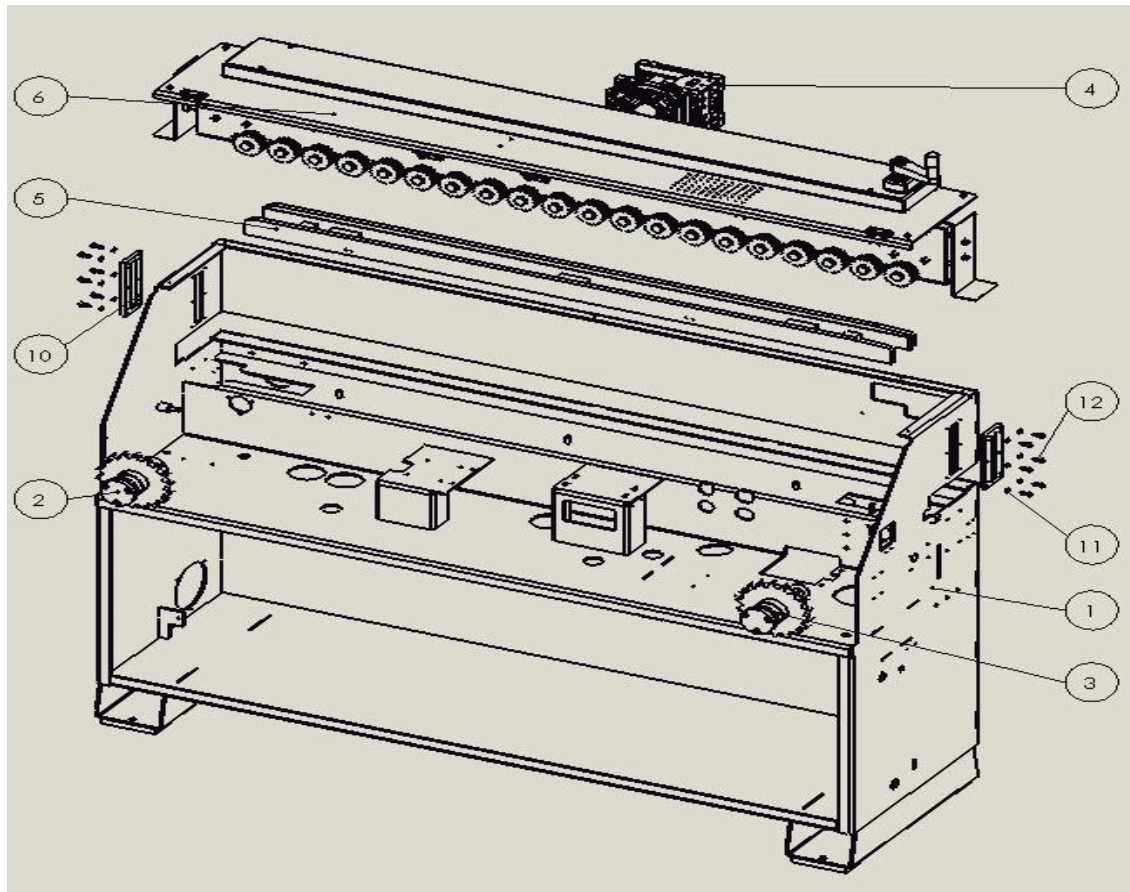


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 - 1.2 Detailed Benchframe
 - 1.3 Cabin
 - 1.4 Pressure Beam Composition
 - 1.5 Drag Chain Motor
 - 1.6 Driven Motor Sprocket
 - 1.7 Main Sprocket
 - 1.10 Pressure Wheel Assembly
 - 1.11 Drag Chain Step Assembly
 - 1.12 Drag Chain Support Nylon

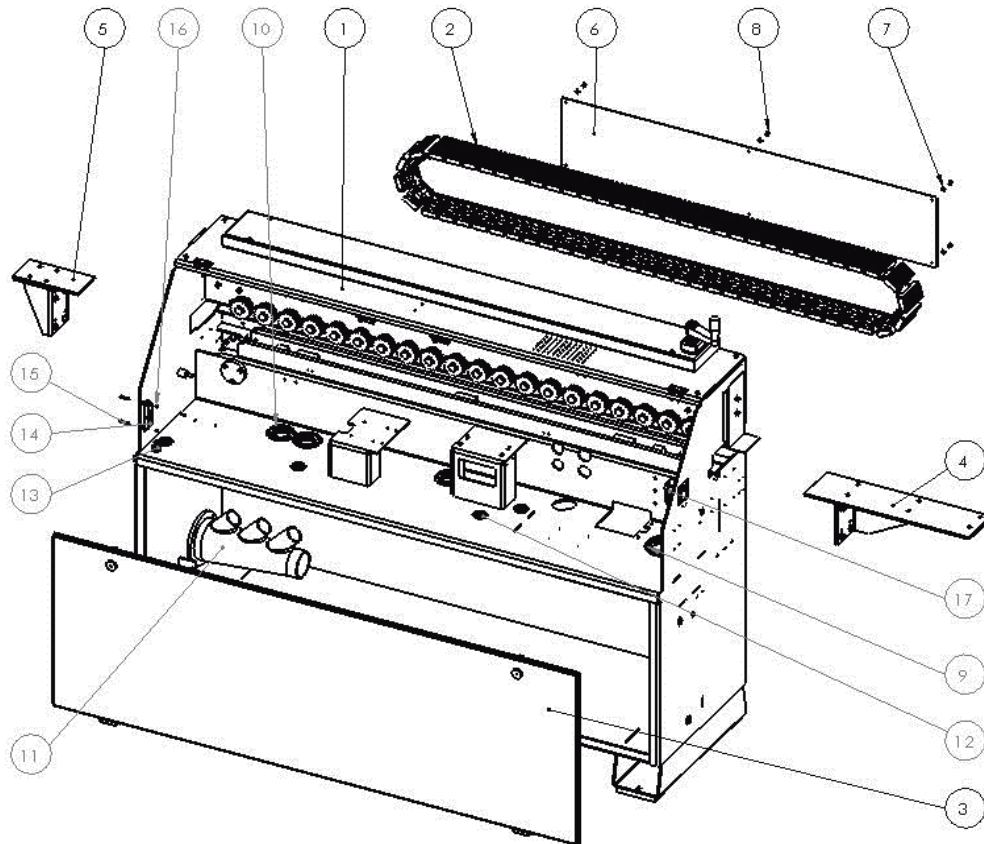
1 UNIT COMPOSITION

1.1 General bench frame



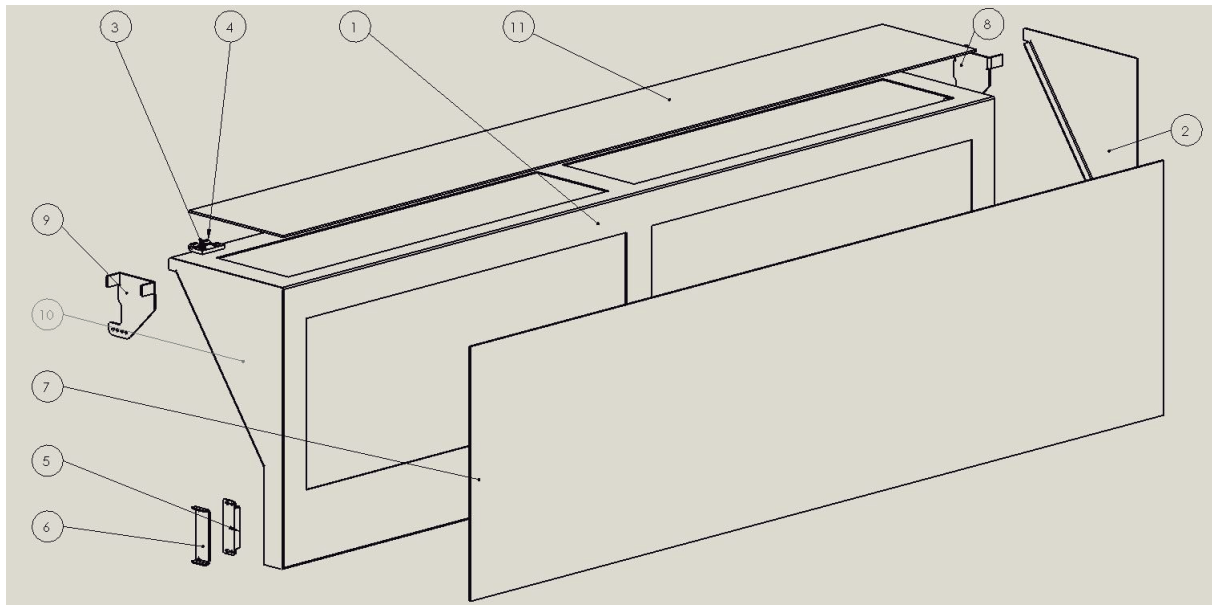
General bench frame – 5005566			
#	Qty.	Description	Reference
1	1	Main bench	5005563
2	1	Main sprocket assembly	5005297
3	1	Driven sprocket assembly	5005295
4	1	Transtecno drag gear motor	5005420
5	1	Chain guide fence	403002916
6	1	Pressure beam set	5005416
7	3	DIN 125 M10 WASHER	6611000001
8	3	ALLEN SCREW DIN 912 M10 x 25 (25mm THREAD)	6311002501
9	1	ALLEN SCREW DIN 912 M8 x 30 (30mm THREAD)	6310803001
10	2	Side foot guide	403002945
11	12	DIN 125 M6 WASHER	6610600001
12	12	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601

1.2 Detailed bench frame



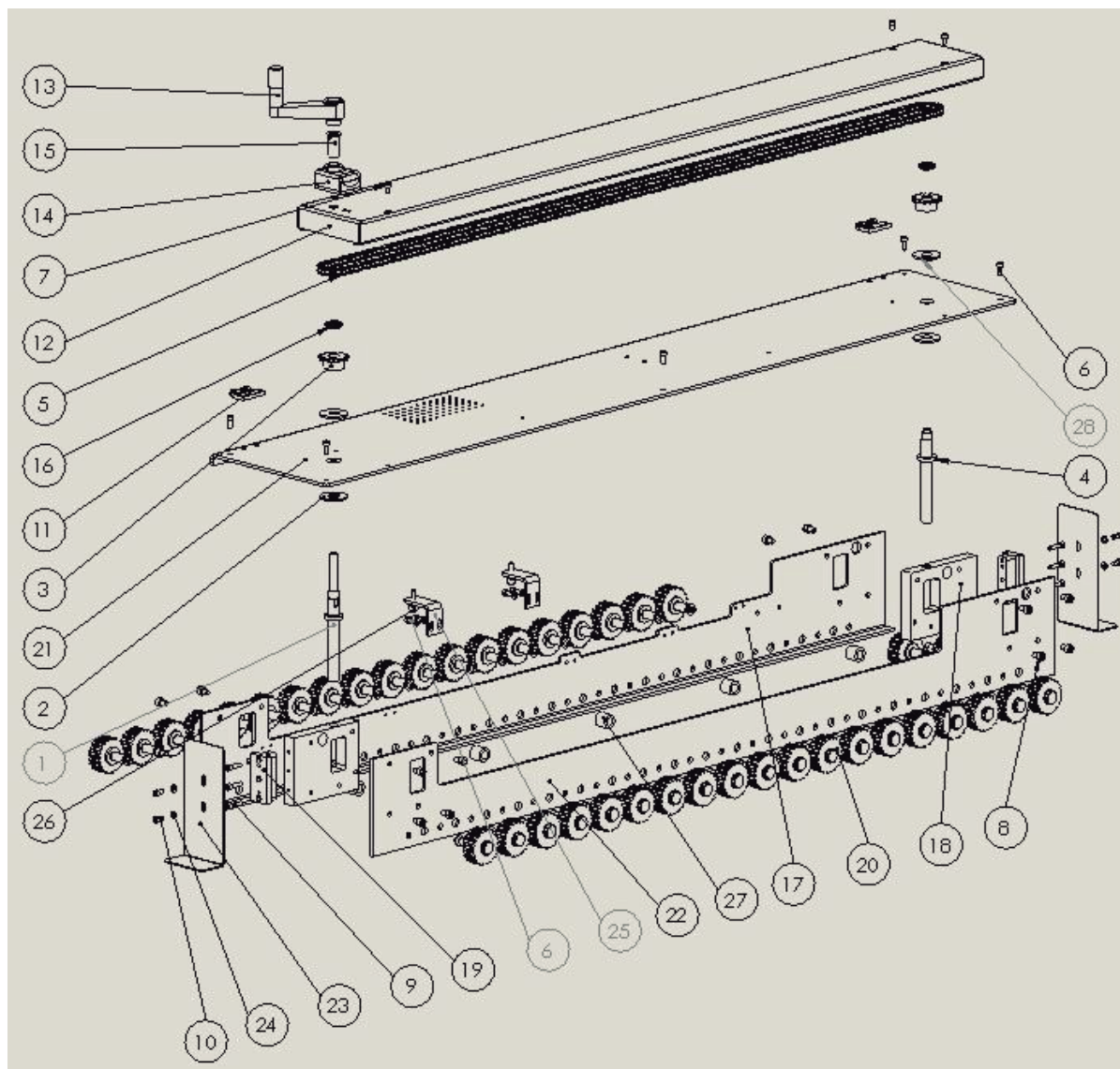
Detailed Bench Frame - 0100332			
#	Qty.	Description	Reference
1	1	BENCH PREASSEMBLY	5005566
2	1	Chain set 120 steps	5005414
3	1	Electric cabin door	5005417
4	1	Input bracket	5005413
5	1	Output bracket	5005346
6	1	Back cover	401006379
7	6	DIN 125 M6 WASHER	6610600001
8	6	DOUBLE HEAD SCREW, DIN7380 M6 X 10	6340601001
9	1	Profiler suction bench cover	102000243
10	3	Suction bench cover	102000239
11	1	CBC.TPM central vacuum	102000735
12	4	HYPFA1016753D63922	
13	1	PG9	100000046
14	1	Cabin safety sensor SRBD40AN5 (sensor)	100000015
15	2	ALLEN SCREW DIN 912 M4 x 25 (25mm THREAD)	6310402501
16	6	DIN934 HEXAGONAL NUT, M4	6410400001
17	1	Fitting PG29DN29	100000056

1.3 Cabin (1900300)



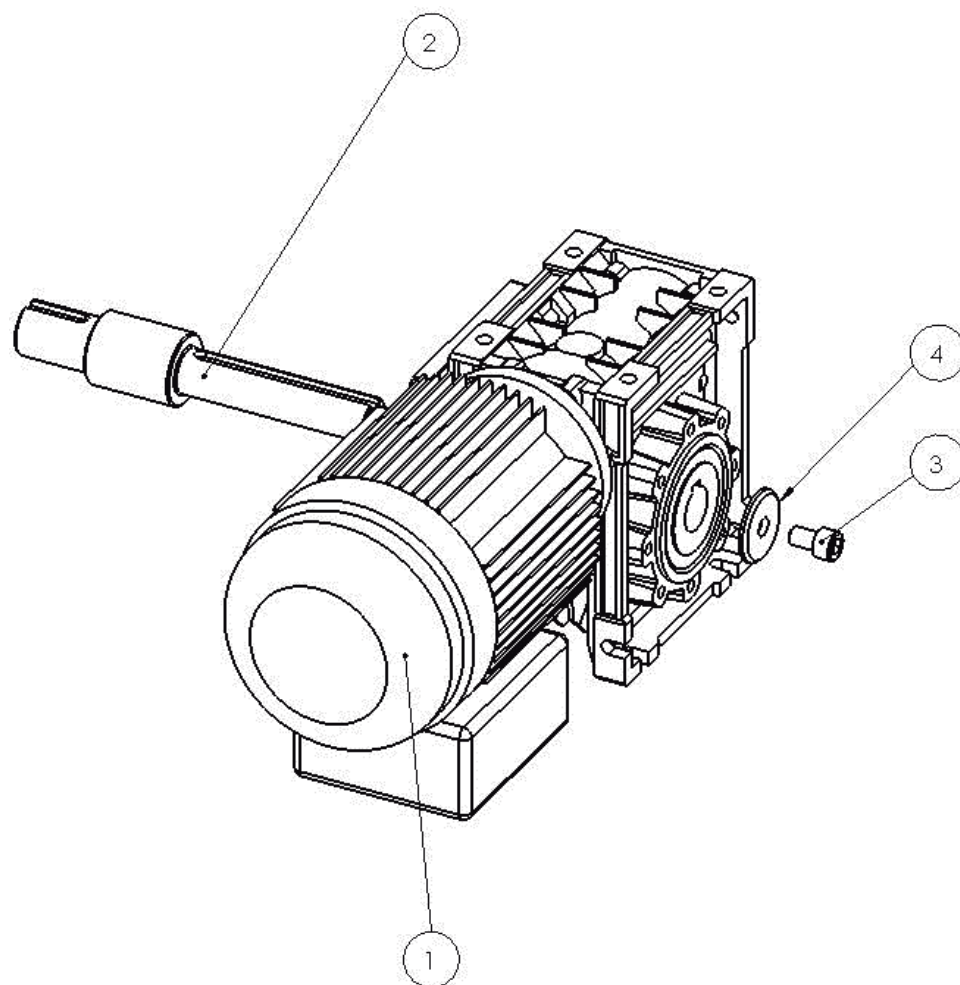
Cabin - 1900300			
#	Qty.	Description	Reference
1	1	Cabin door	401006383
2	1	Cab door side	401006398
3	4	COUNTERSUNK SCREW DIN7991, M6 X 20 THREAD:20mm	6320602002
4	2	CFM.50 SH-6-MD	102000682
5	1	SMB01F cabin door safe sensor switch	100000014
6	1	Lateral micro support	401004724
7	1	Cabin methacrylate	102000707
8	1	Ear 01	401006215
9	1	Ear 02	401006605
10	1	Symmetrical cabin door side	401006399
11	1	Cabin top methacrylate	102000711

1.4 Pressure beam composition



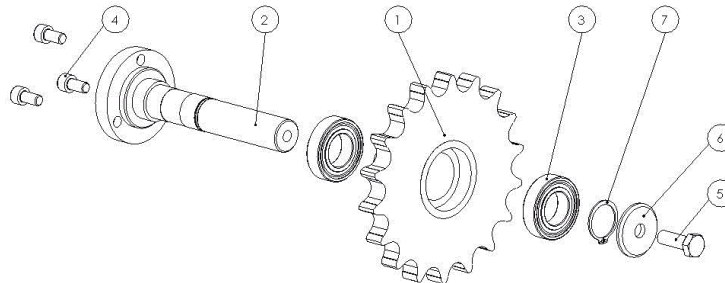
Pressure Beam Composition - 5005416			
#	Qty.	Description	Reference
1	1	Pressure beam input adjustment shaft	404001840
2	2	Brass washer M20	404000214
3	2	Sprocket 3/8" Z15	404001557
4	1	Pressure beam output adjustment shaft	404001838
5	2	Pressure beam chain	5005415
6	9	ALLEN SCREW DIN 912 M6 x 16 (16mm THREAD)	6310601601
7	4	ALLEN SCREW DIN 912 M6 x 10 (10mm THREAD)	6310601001
8	16	ALLEN SCREW DIN 912 M8 x 12 (12mm THREAD)	6310801201
9	6	ALLEN SCREW DIN 912 M6 x 25 (25mm THREAD)	6310602501
10	4	ALLEN SCREW DIN 912 M6 x 12 (12mm THREAD)	6310601201
11	2	CFM.50 SH-6-MD	102000682
12	1	Pressure beam Chain cover	401006381
13	1	Pusher lifting handle	9201001201
14	1	DA09 Positioner	9350921051
15	1	Siko stepper cap	404001492
16	2	KMAT-3 self-locking nut	102000695
17	1	Front plate stepper	401006375
18	2	Handrail end pressure beam	403002880
19	2	Side slider pressure beam	409000621
20	40	wheel assembly	5005364
21	1	Cab roof pressure beam	401006374
22	1	Back plate stepper	401006376
23	2	Pressure beam input/output square bracket	401006282
24	8	DIN 125 M6 WASHER	6610600001
25	2	X-4T stopper square	401006314
26	2	Clamping bolt GN 708.1-M6-35-A-ST (0)	
27	5	Spacer distance bushing	404001886
28	2	Brass stand-off cap	404001871

1.5 Drag chain motor



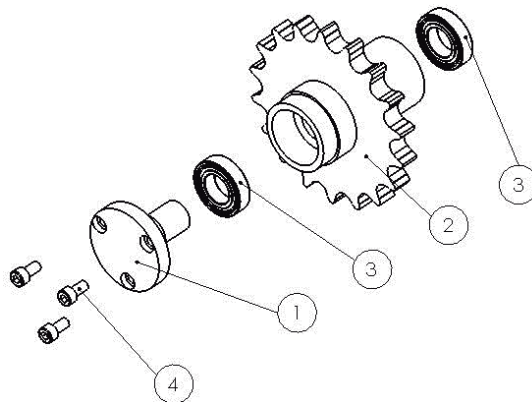
Drag chain motor - 5225297			
#	Qty.	Description	Reference
1	1	Single-phase gear motor 0.25Kw i:100 14rpm	5005362
2	1	gearbox shaft	404000016
3	1	ALLEN SCREW DIN 912 M10 x 16 (THREAD16mm)	6311001601
4	1	Washer Ø40x4xØ10.5	404000253

1.6 Driven motor sprocket



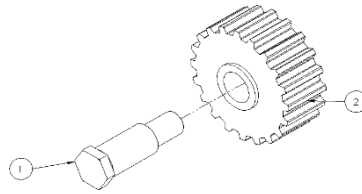
Drive sprocket drag chain - 5225295			
#	Qty.	Description	Reference
1	1	driven sprocket	404000247
2	1	driven sprocket shaft	404001836
3	2	6005-2RS	6116005301
4	3	ALLEN SCREW DIN 912 M8 x 16 (16mm THREAD)	6310801601
5	1	DIN933 HEXAGON SCREW, M10 X 30	6361003001
6	1	Washer Ø40x4xØ10.5	404000253
7	1	Ext. Seeger Ring DIN471 26 X 1.2	6632600001

1.7 Main sprocket



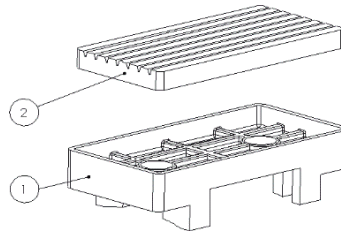
Main sprocket drag chain - 5225297			
#	Qty.	Description	Reference
1	1	driving sprocket shaft	404001837
2	1	Driving sprocket	404001835
3	2	6005-2RS	6116005301
4	3	ALLEN SCREW DIN 912 M8 x 16 (16mm THREAD)	6310801601

1.8 Pressure Wheel assembly



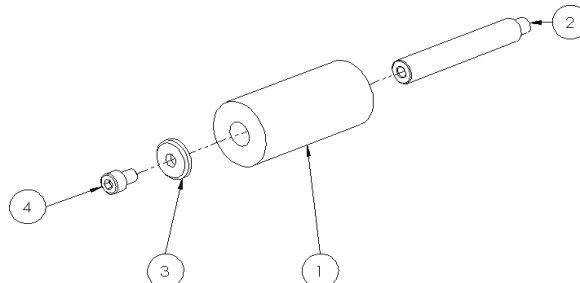
Pressure beam Wheel assembly - 5003400			
#	Qty.	Description	Reference
1	1	Pressure beam Wheel shaft	404001360
2	1	Pressure beam wheel	8880060601

1.9 Drag chain step assembly



Drag chain step assembly - 300000001			
#	Qty.	Description	Reference
1	1	Drag chain step	1000088
2	1	Rubber pad	1000089

1.10 Drag chain Support nylon

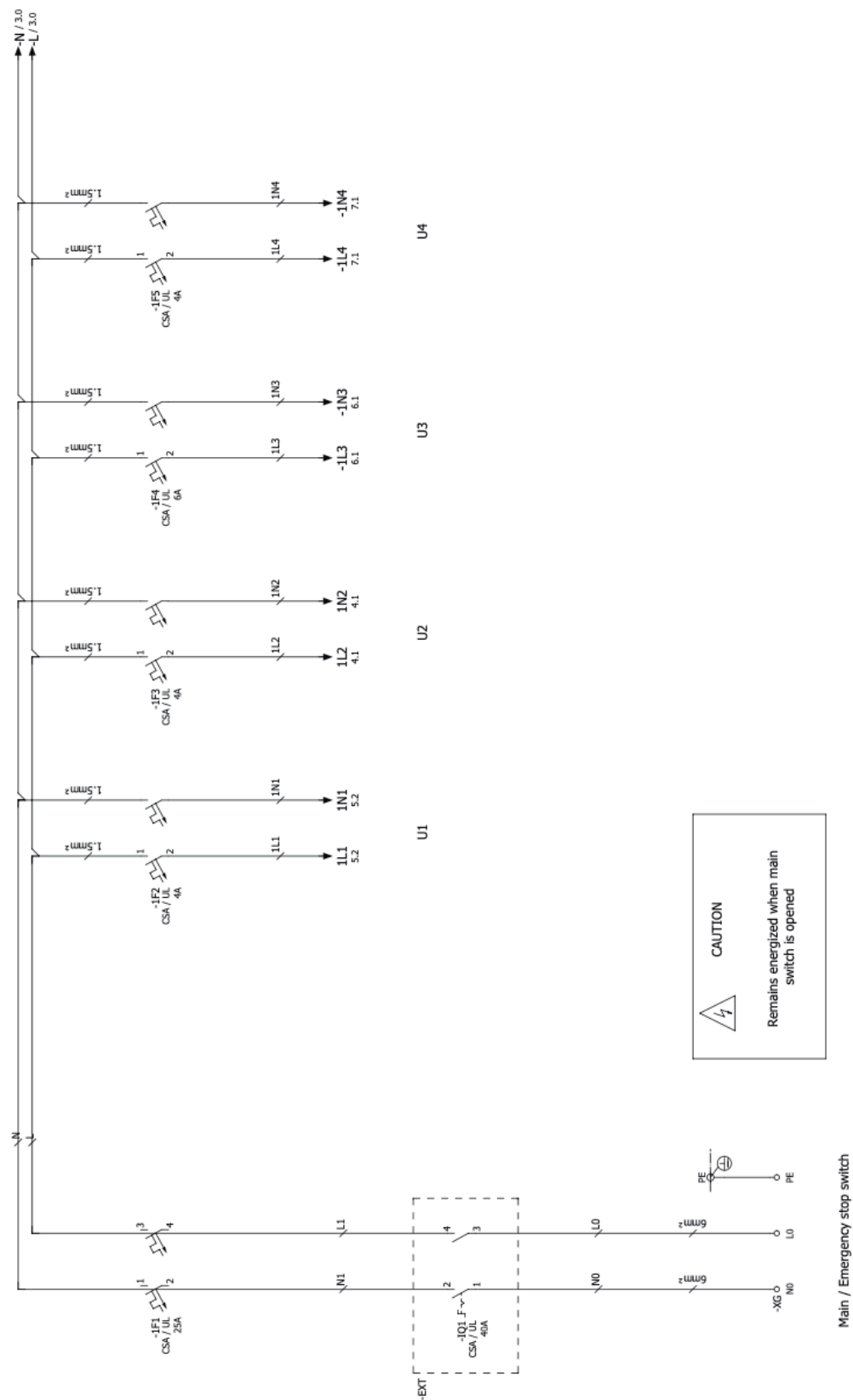


Nylon support chain - 5000429			
#	Qty.	Description	Reference
1	1	Drag chain Support roller	404000249
2	1	Roller shaft	404000250
3	1	Washer Ø25xØ8x4	404000252
4	1	ALLEN SCREW DIN 912 M8 x 12 (12mm THREAD)	6310801201

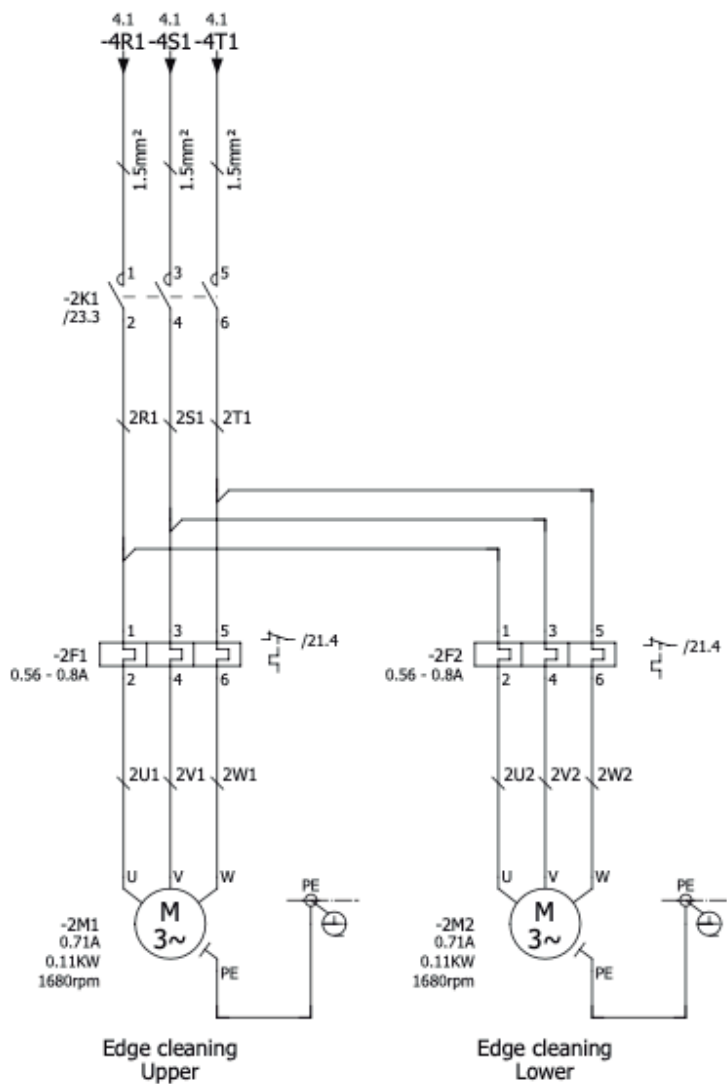
[illegible]

ELECTRICAL DIAGRAM

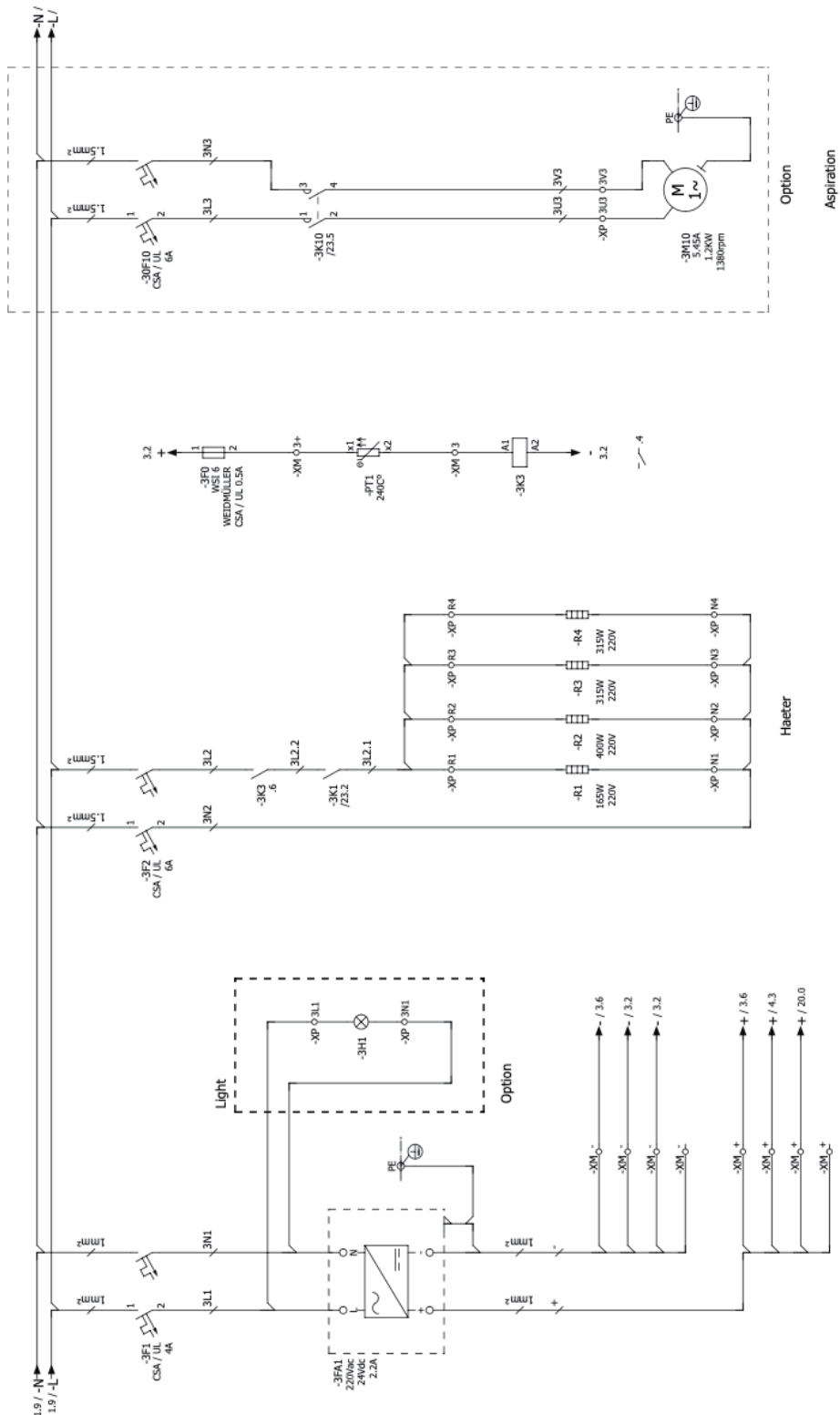
Power 1



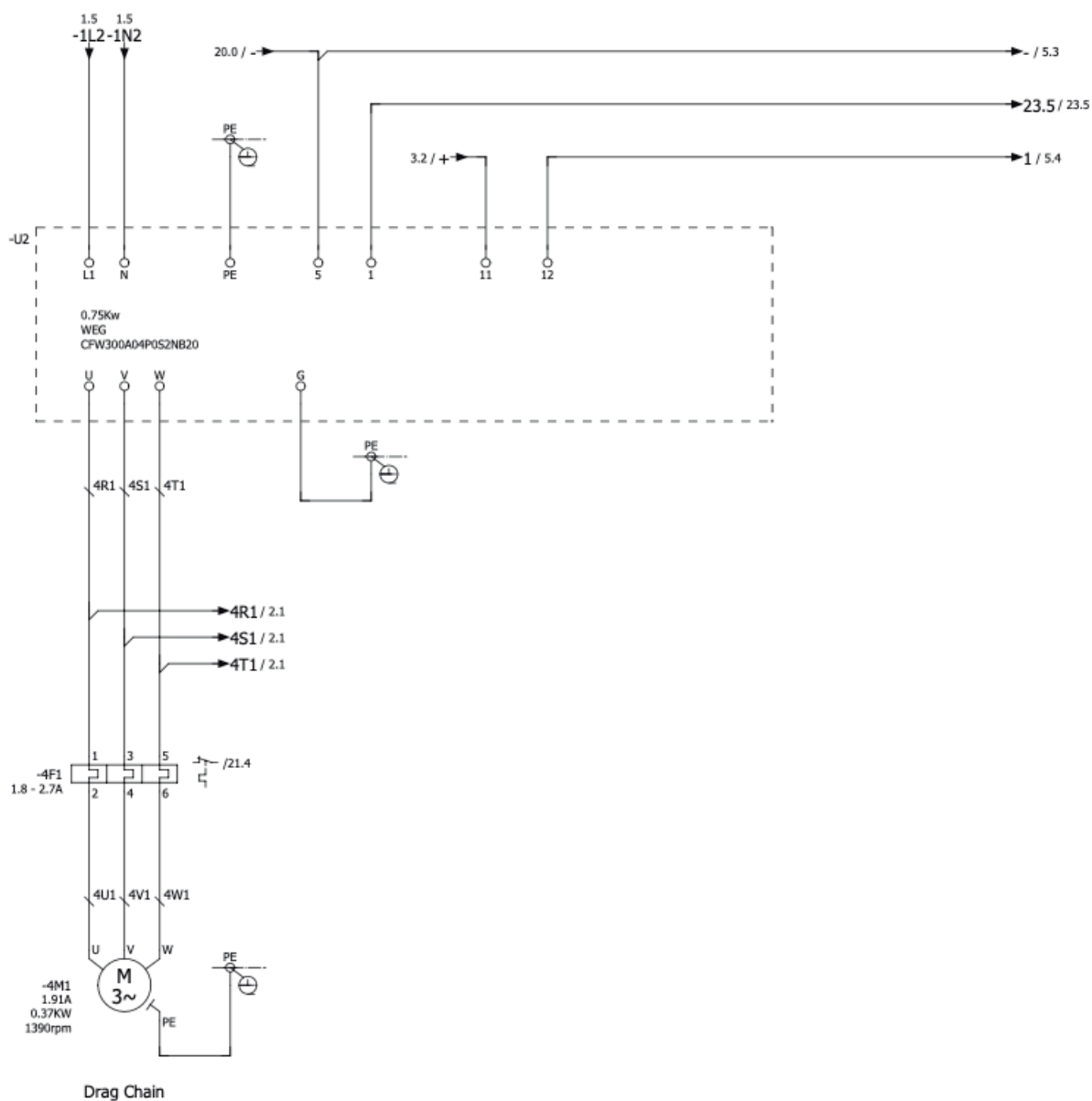
Power 2



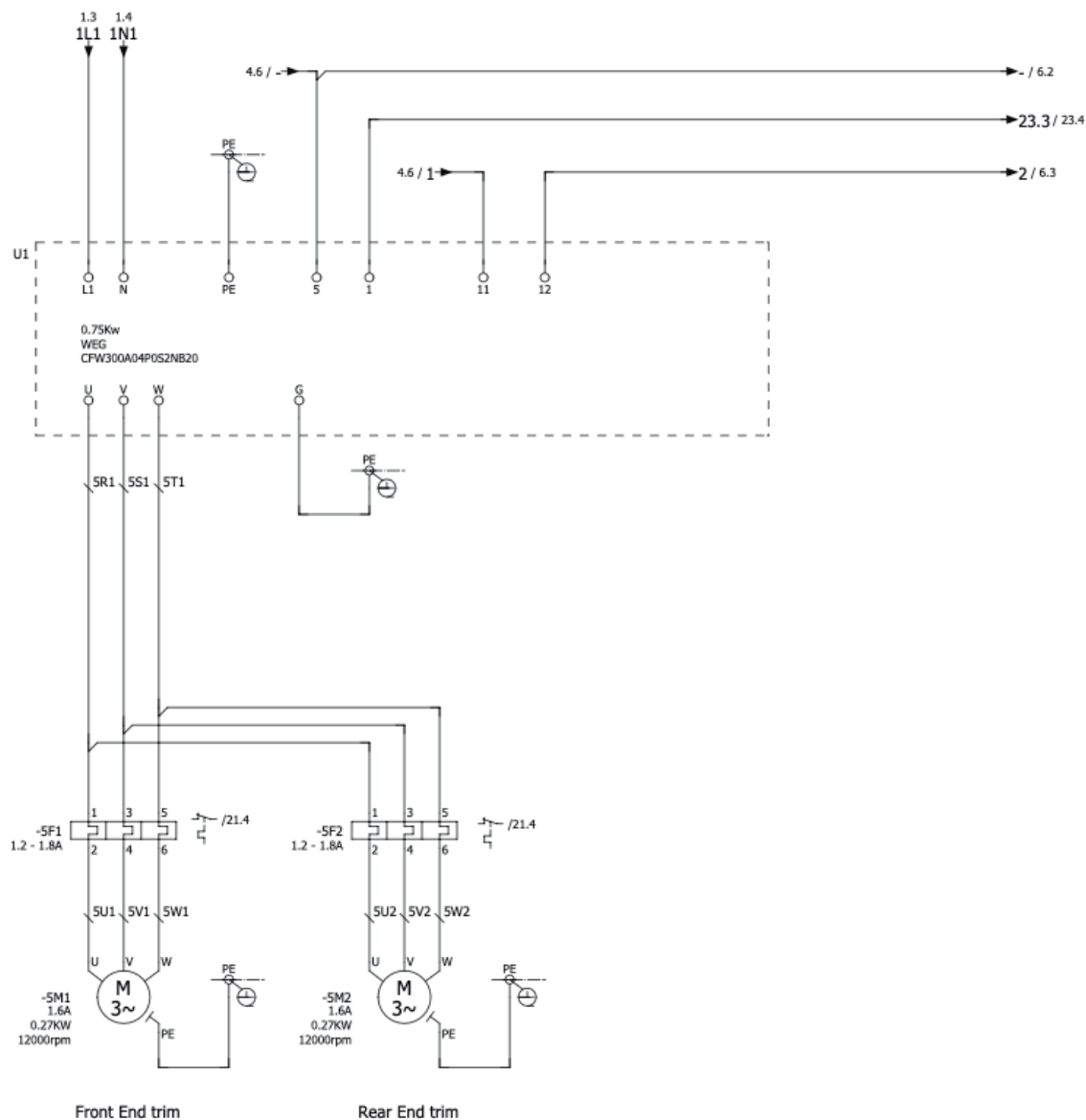
Power 3



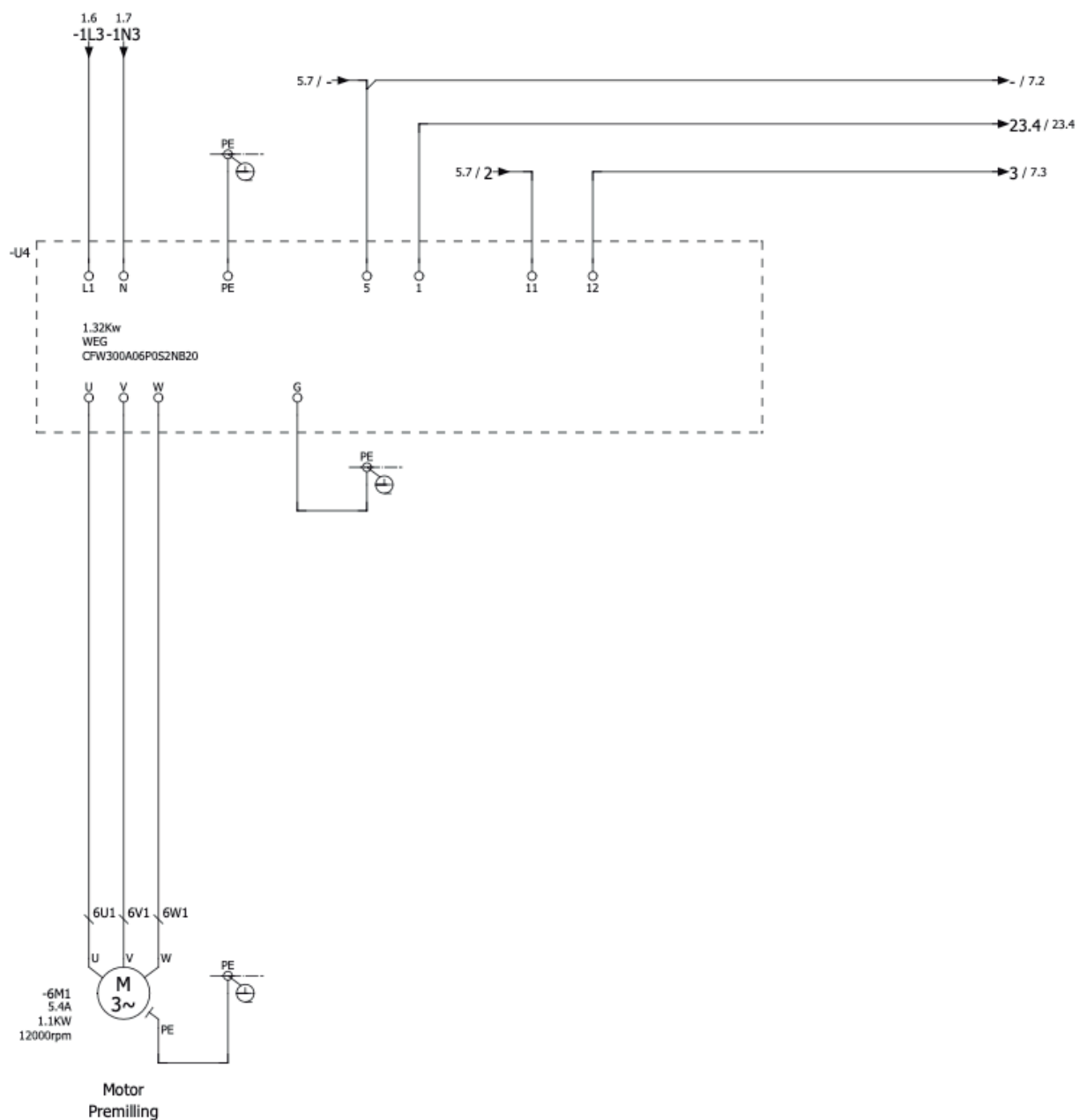
Power 4



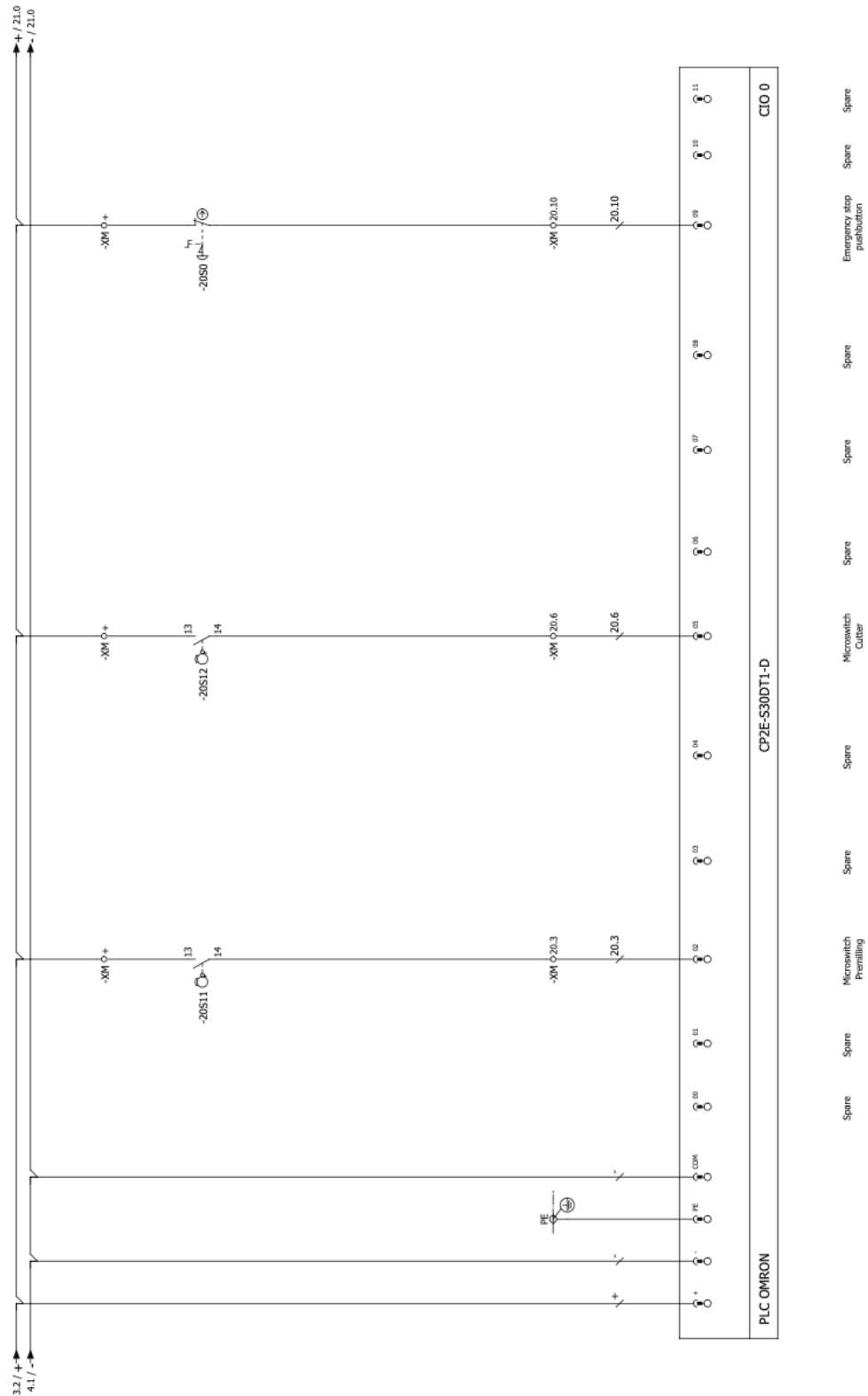
Power 5



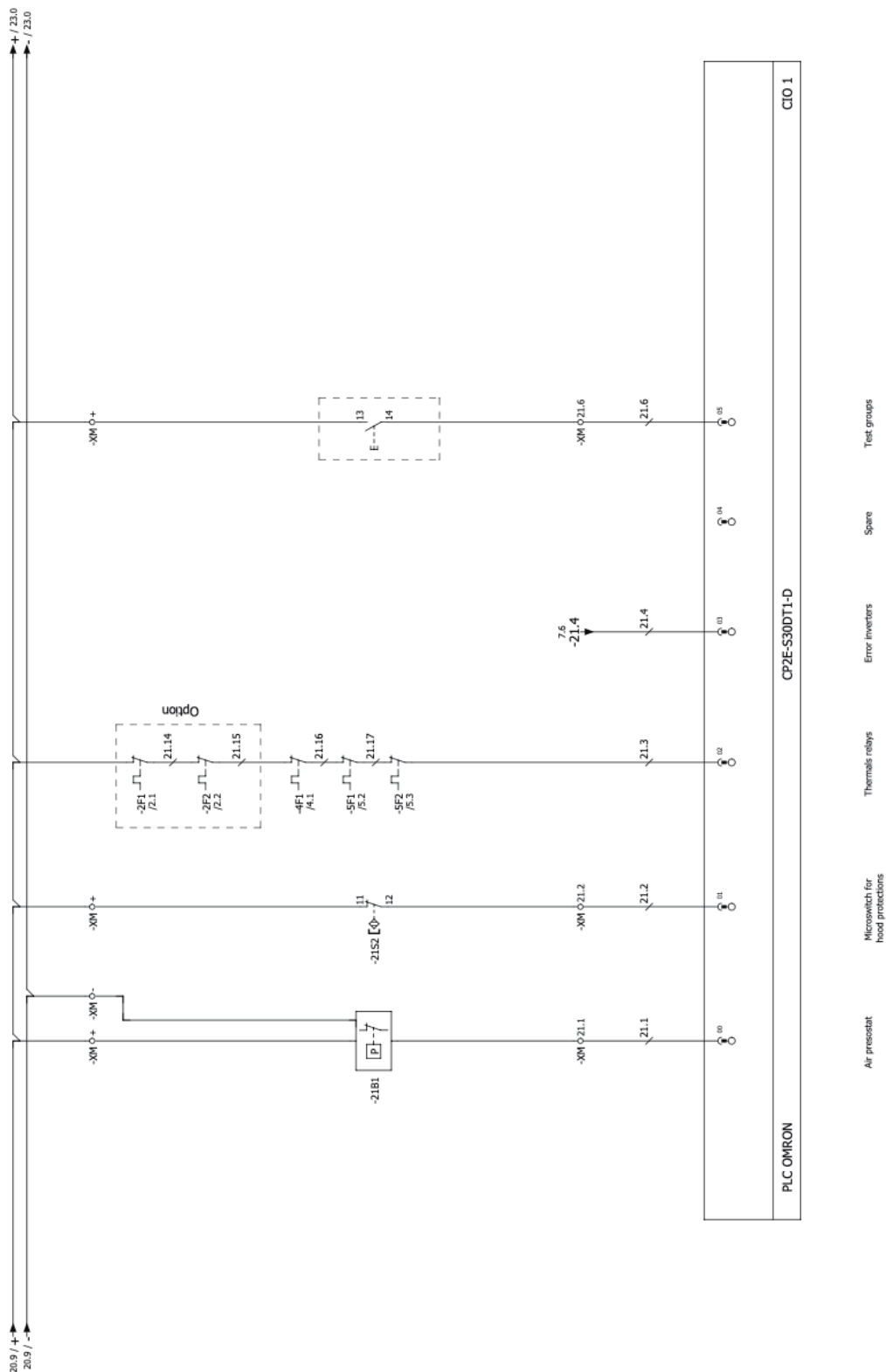
Power 6



PLC Inputs CIO 0

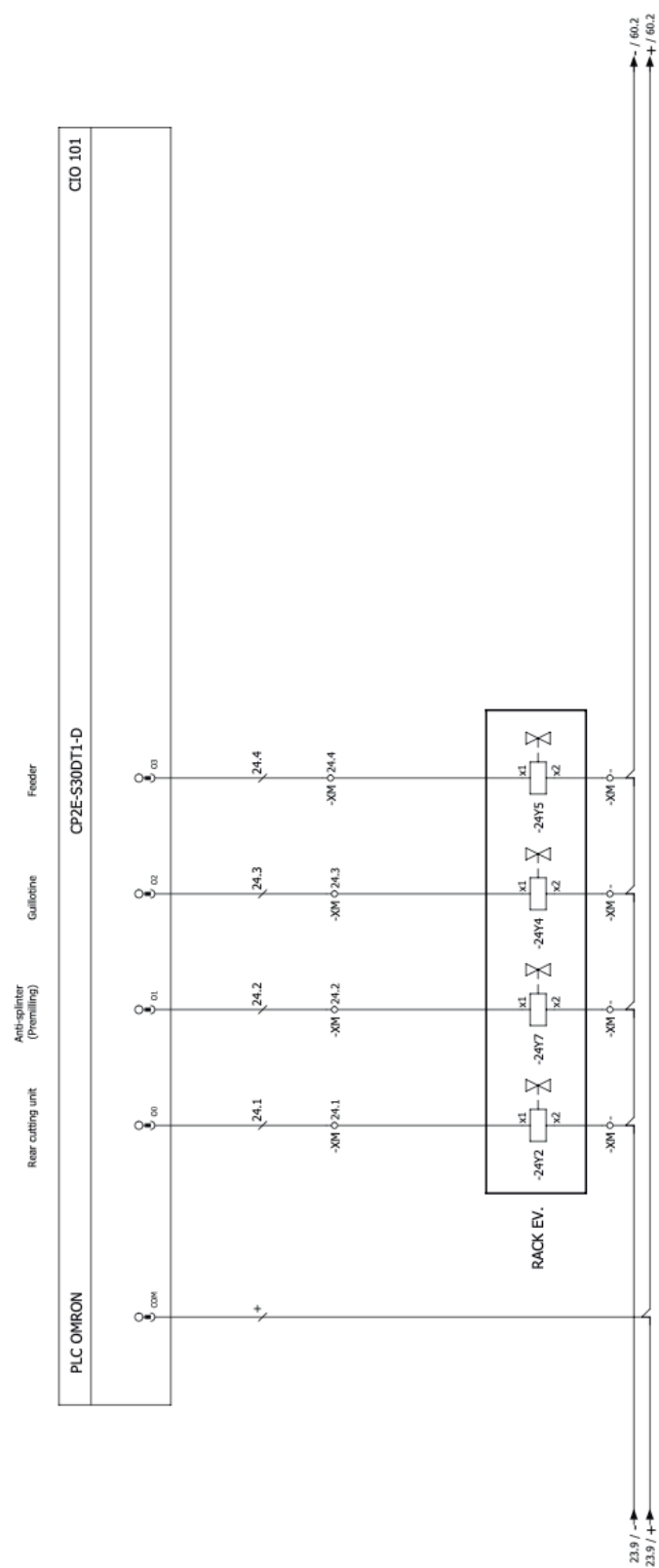


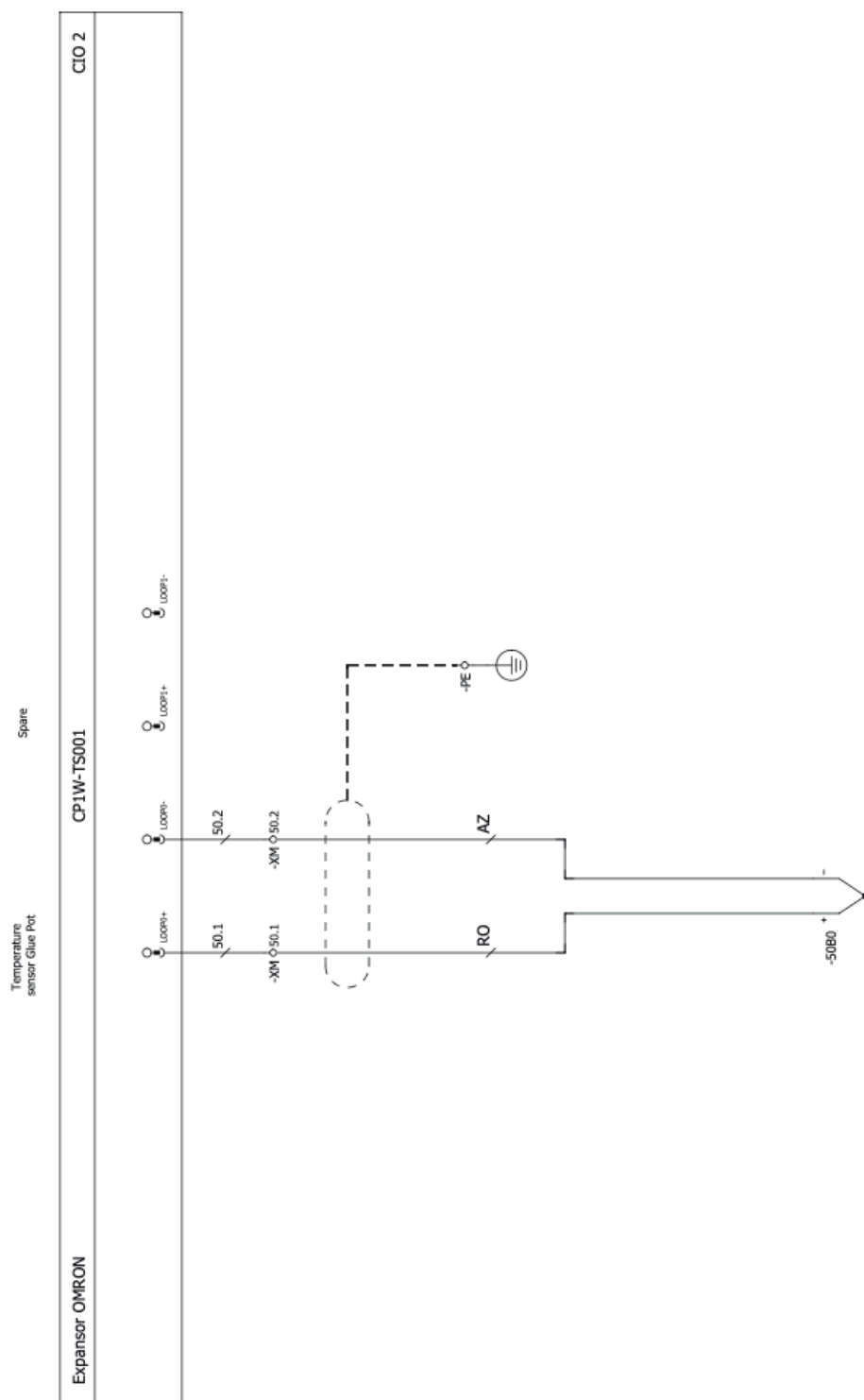
PLC Inputs CIO 1



[illegible]

PLC Inputs CIO 101





Connection Screen

