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Operation and maintenance WINTER Doppelsäumer DOUBLECUTMAX 450

The most important information

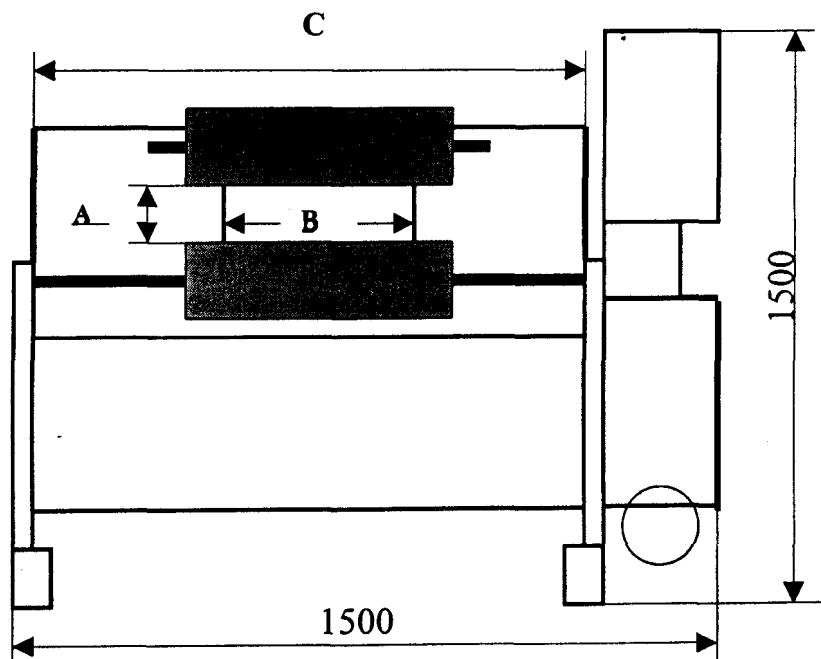
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1. Model OB-II – technical data

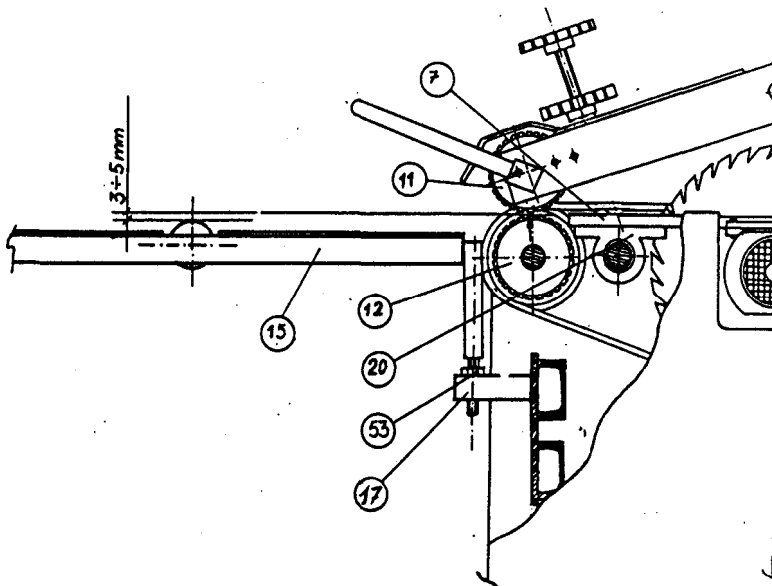
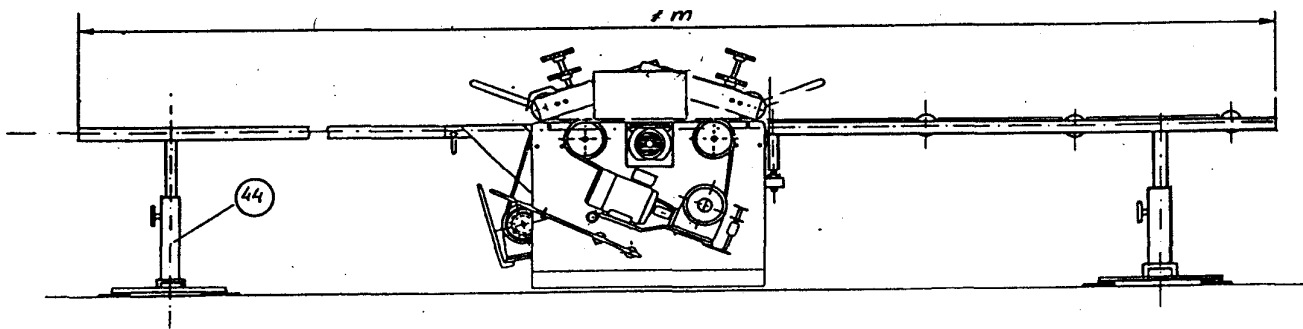
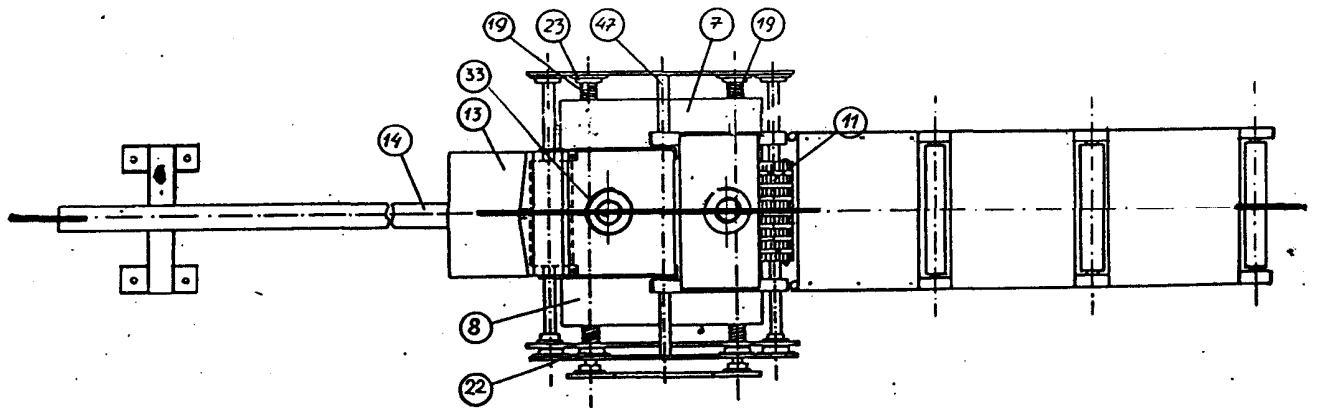
| Technical data of OB-II: | | |
|---------------------------------|---|-----------------------------|
| 1. | Width to be edged | 70 – 430 mm |
| 2. | Thickness to be edged | 15 – 80 mm |
| 3. | Diameter of saw blades | 400 mm |
| 4. | Speed of changing the distance between the blades | 10 mm / sec. |
| 5. | Propulsion of saw blades | 2 x 4,7 kW / 2800 r.p.m. |
| 6. | Propulsion of feed | 1,1 kW / 1400 r.p.m. |
| 7. | Propulsion of adjusting the width of edging | 1,1 kW / 1400 r.p.m. |
| 8. | Total power installed | 11,6 kW / 380 V / 50 Hz |
| 9. | Speed of feed – 6 degrees | 7, 10, 13, 14, 20, 26 m/min |
| 10. | Overall dimensions (without the tables) | 1,60 x 1,50 x H 1,50 m |
| 11. | Length of: | |
| | - receiving table | 2,30 m |
| | - feeding rail | 3,15 m |
| | - total length of unit | 7,00 m |
| 12. | Total weight | 1 350 kg |

* Minimal timber length to be edged: 1,20 m

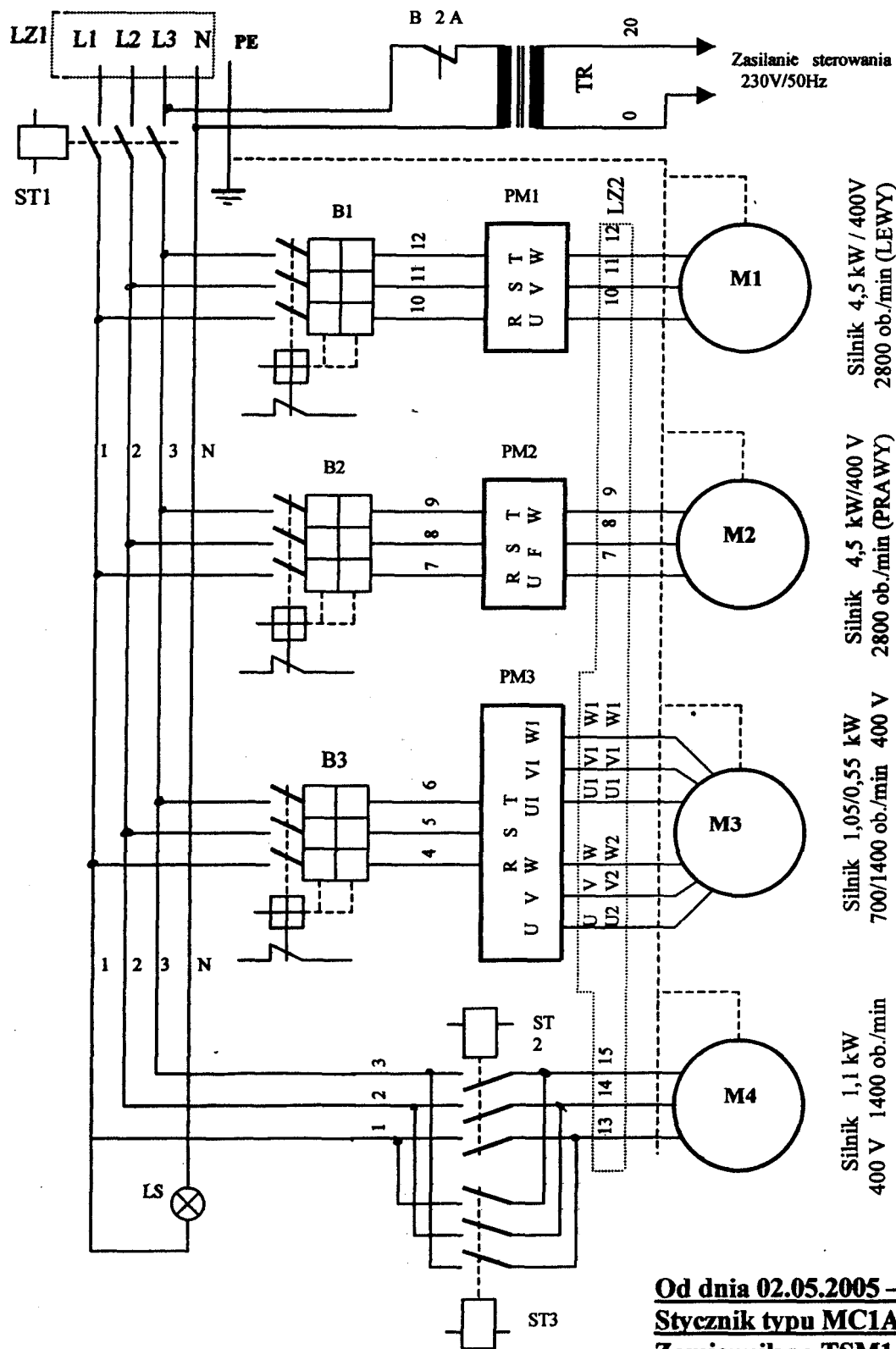


A = 20 – 80 mm
B = 70 – 430 mm
C = 900 mm

2. Adjusting the whole unit (OB-II and OB-IIM)



3. Electric circuits of OB-II



M1 – motor 4,5kW/400V/2800 r.p.m. (LEFT)

M2 – motor 4,5kW/400V/2800 r.p.m. (RIGHT)

M3 – motor 1,05/0,55kW /400V/ 700/1400 r.p.m.

M4 – motor 1,1kW/400V/1400 r.p.m.

Power supply of control (*zasilanie sterowania*): 230V/50Hz

4. The most important hints

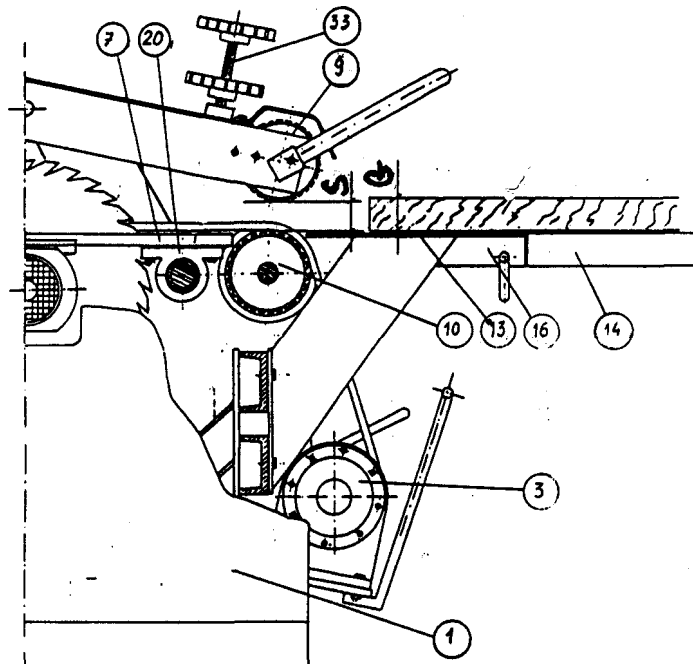
IMPORTANT!:

Self-turning off of the machine means that some of the engines is overheated. Check immediately which propulsion unit caused the overheating. The causes can be among others the blunt saw blades, too high edging feeds used, the propulsion block.

IMPORTANT!:

Do not correct the cutting symmetry during the edging!!! (that may block the saw blades propulsion)

Adjusting the rollers:



$$S = G - (8 \text{ to } 12 \text{ mm})$$

S – slit between the rollers
G – board thickness

The slit between the rollers should be smaller 8 to 12 mm than the board thickness to be edged.

5. Recommended speeds of feed

| Speed of feed* m/min | Timber thickness mm | Kind of wood |
|-------------------------|------------------------|-----------------------|
| 26 | 20 to 35 | All kinds of wood |
| 20 | 30 to 50 | Soft coniferous wood |
| 14 | 35 to 50 | Hard broadleaved wood |
| 13 | 40 to 70 | Soft coniferous wood |
| 10 | 40 to 70 | Hard broadleaved wood |
| 7 | 60 to 80 | All kinds of wood |

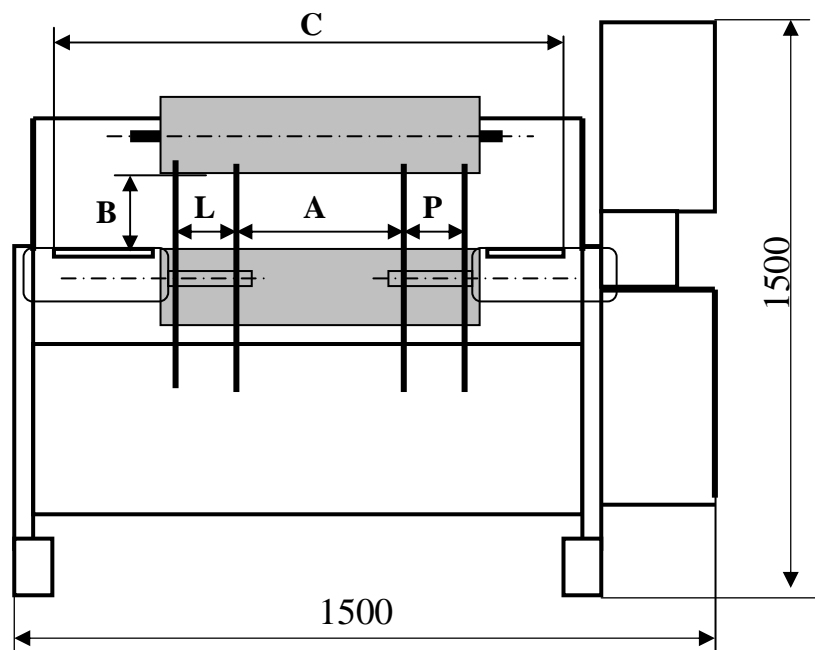
* Provided that the saw blades are correctly sharpened!!!

6. Maintenance of the OB-II and OB-IIM

- 1. Every 8 hours – clean the power screws and the screws of leading the tables (19). Also oil them with very thin oil or with diesel.**
- 2. Every 1 month – oil the power feed chain**
- 3. Every 3 months – oil the power chain of the tables**
- 4. Every 2 years – change the oil in the gears of the power feed and tables. They are filled with the Hipol Oil 15F.**
Also keep a right oil level.
Oil in the gear: 0,6 L
5. Look after the cleanliness of the rollers, especially in the winter season when the dirty rollers may become icy.

7. Model OB-IIM – technical data

| Technical data of OB-IIM: | | |
|---------------------------|---|-----------------------------|
| 1. | Overall width to be edged | 60 – 430 mm |
| 2. | Thickness to be edged | 15 – 80 mm |
| 3. | Blades with diameter of 400mm, hole 80, 18 teeth | 4 pcs. |
| 4. | Speed of changing the distance between the blades | 10 mm / sec. |
| 5. | Propulsion of saw blades | 2 x 5,2 kW |
| 6. | Propulsion of feed | 1,1 kW |
| 7. | Propulsion of adjusting the width of edging | 1,1 kW |
| 8. | Propulsion of lifting the rollers (to order) | 0,2 kW |
| 9. | Total power installed | 12,8 kW / 400 V |
| 10. | Speed of feed – 6 degrees | 7, 10, 13, 14, 20, 26 m/min |
| 11. | Overall dimensions (without the tables) | 1,60 x 1,50 x H 1,50 m |
| 12. | Length of: | |
| | - receiving table | 2,30 m |
| | - feeding rail | 3,15 m |
| | - total length of unit | 7,00 m |
| 13. | Total weight | 1 400 kg |



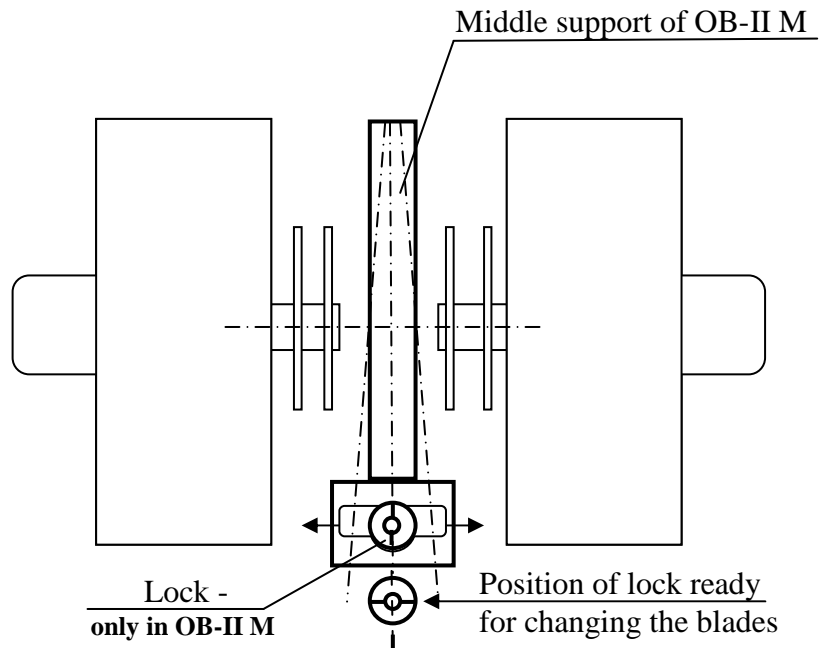
- A > 60 ⇔ 230 mm - width to be edged, electric changeable one
 B > 15 ⇔ 80 mm - height to be edged
 C > 950 mm - horizontal clearance
 L > 10 ⇔ 100 mm - settings changable on distance pieces
 P > 10 ⇔ 100 mm - settings changable on distance pieces

Minimal length of timber to be edged is 1,20 m.

8. Changing the saw blades in OB-II and OB-IIM

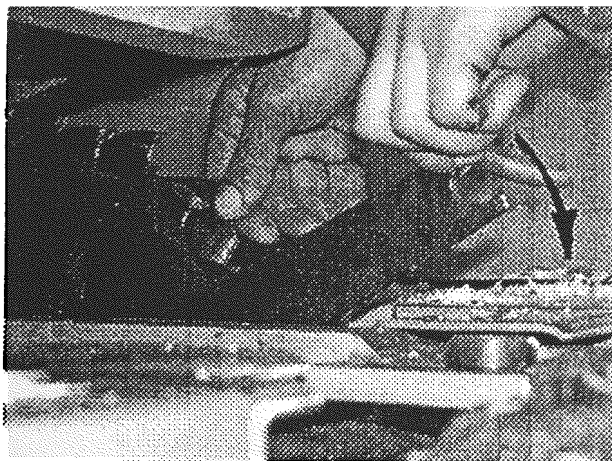
Before changing the saw blades, at first **part the tables maximally** and then **lift the front upper roller**. Parting the tables after lifting the rollers is impossible. Then perform the following actions:

- 1. Unlock the lock** (a key for turning the lock is a standard equipment) **and then move the middle support:**
 - to the right, if you change the left saw blades
 - to the left, if you change the right saw blades



- 2. The machine is equipped with the special wrench. Use only this wrench for unscrewing the nut M30 fastening the blades.**

The axle (pivot) of the blades of the left side has a right thread and the right axle – a left thread. Make both unscrewing and screwing by brisk turning the blades unit together with the putted-on wrench toward the screw casing when **screwing** or toward the upper crosspiece when **unscrewing** (see the pictures below).



Screwing



Unscrewing

3. **Changing a blade** – see the picture below.



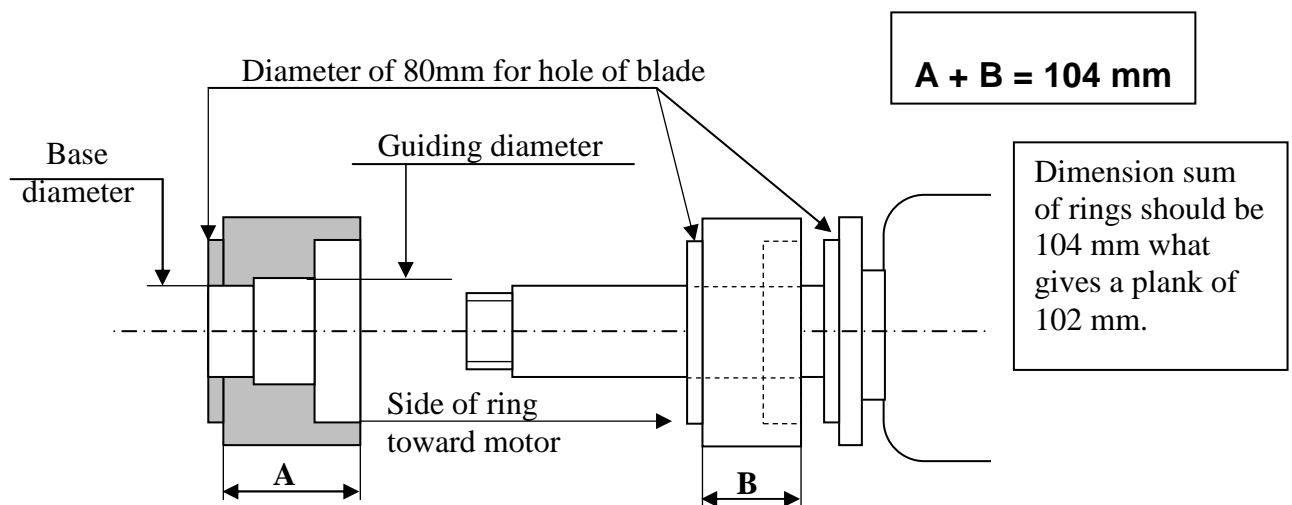
LOOK OUT !!! COLLISION !

ATTENTION!
Using the blades with the "side blades/knives" and with a diameter below 400mm is forbidden!!!

LOOK OUT !!! COLLISION !

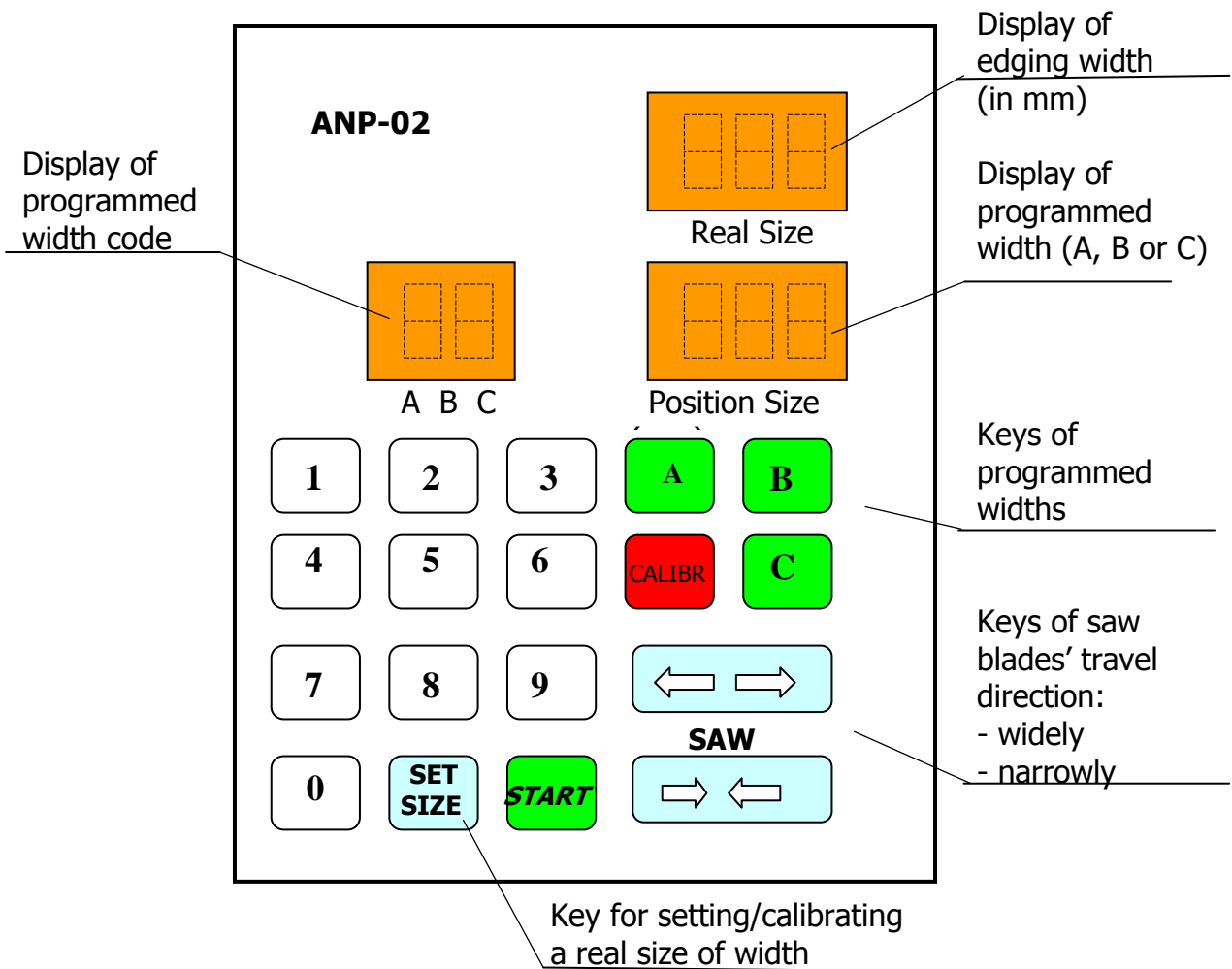
Change the blades only with the leather gloves on the hands and with the use of the wrench being in the equipment of the machine.

4. **Changing the distance rings between the blades** should be carried out very carefully and precisely to not cause any damage of the shaft surface.



Clean and oil carefully the shaft and rings' holes with every change of the blades!!!

9. ANP-02 ELECTRONIC DEVICE FOR SETTING THE PLANKS' WIDTHS



Setting a real size of width:

(this operation is necessary always after changing the circular saw blades)

1. Edge a board with any width and then measure its real width, for example 124 mm.
2. Keep the key "SET SIZE" pressed as long as the three horizontal lines (- - -) appears on the top display "Real Size"
3. Enter 124 and press "START". The "SAV" inscription should be shown and after a moment the saved size (124) should appear on the top display "Real Size".

Saving the three width sizes A, B, C:

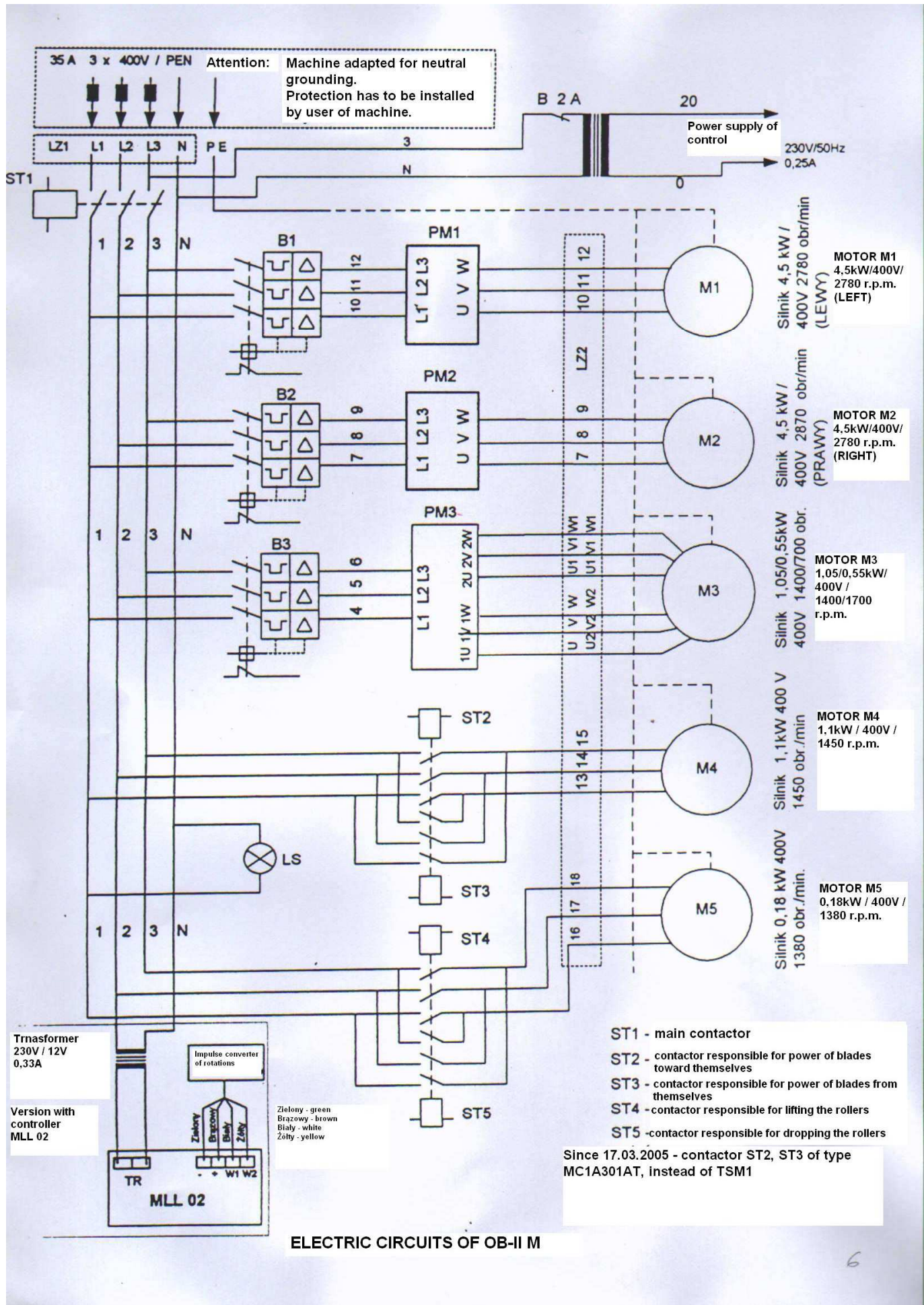
1. Press some of the keys A, B or C, for example A and keep it pressed for a few seconds until the A letter starts to flash on the left display "A B C".
2. Use the keys "0... 9" to enter a required width (press the keys relatively quickly) and then press "START".

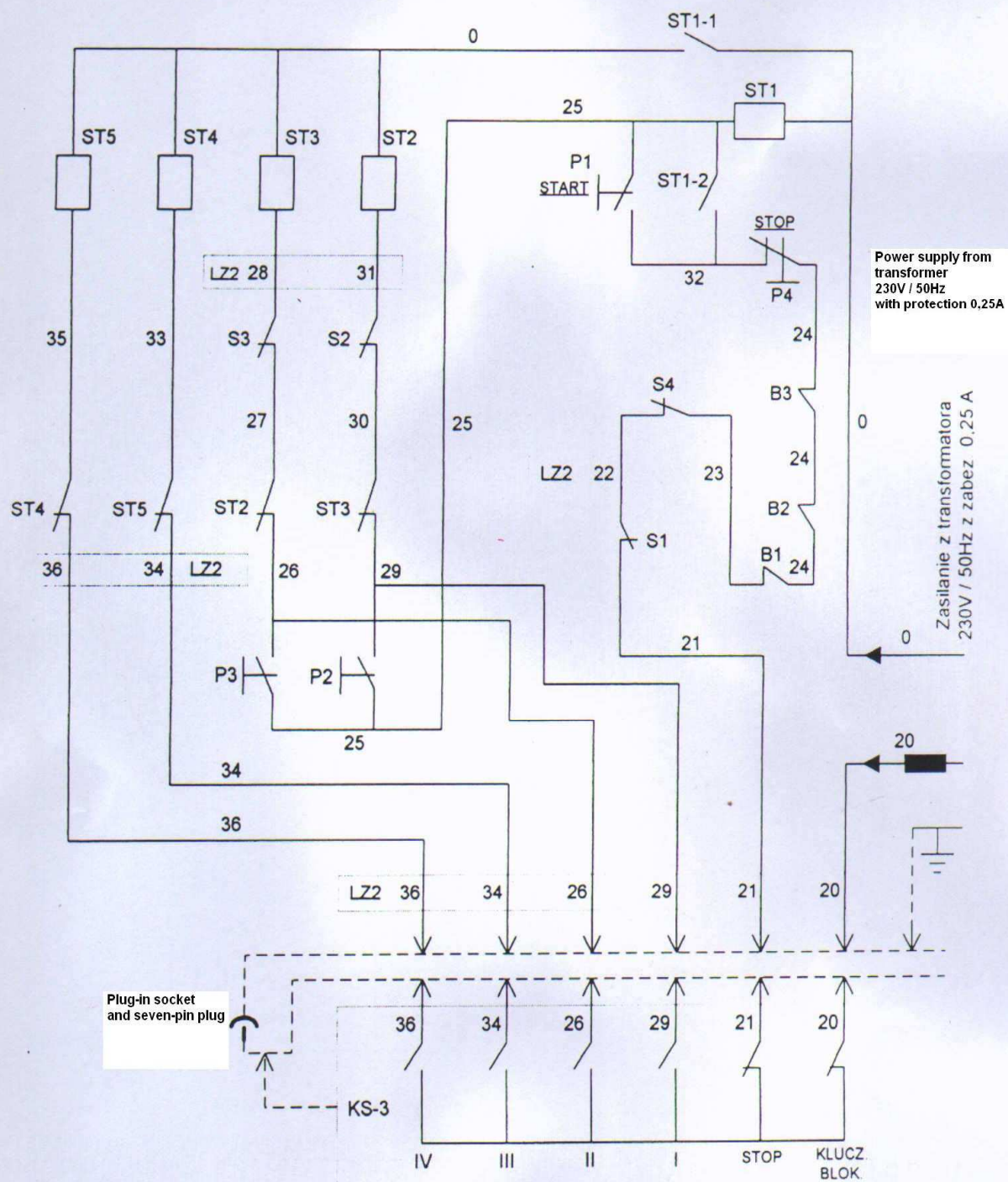
Edging the boards with a programmed width (A, B or C):

1. Press the programmed width (A, B or C) and then press "START"

Edging the boards with an individual entered width:

1. Use the keys "0...9" to enter a required width and then press "START"





ST2 + P2 + II KS-3 - moving one blade closer to the other one
 ST3 + P3 + I KS-3 - moving one blade away from the other one
 ST4 + III KS-3 - lifting the rollers
 ST5 + IV KS-3 - lowering the rollers
 S1 - limit switch of casings of saw blades
 S2 - limit switch of moving one blade away from the other one
 S3 - limit switch of moving one blade closer to the other one
 S4 - limit switch of control box opening
 ST1-1, ST1-2 - support contacts of main contactor ST1

CONTROL CIRCUITS OF OB-II M

