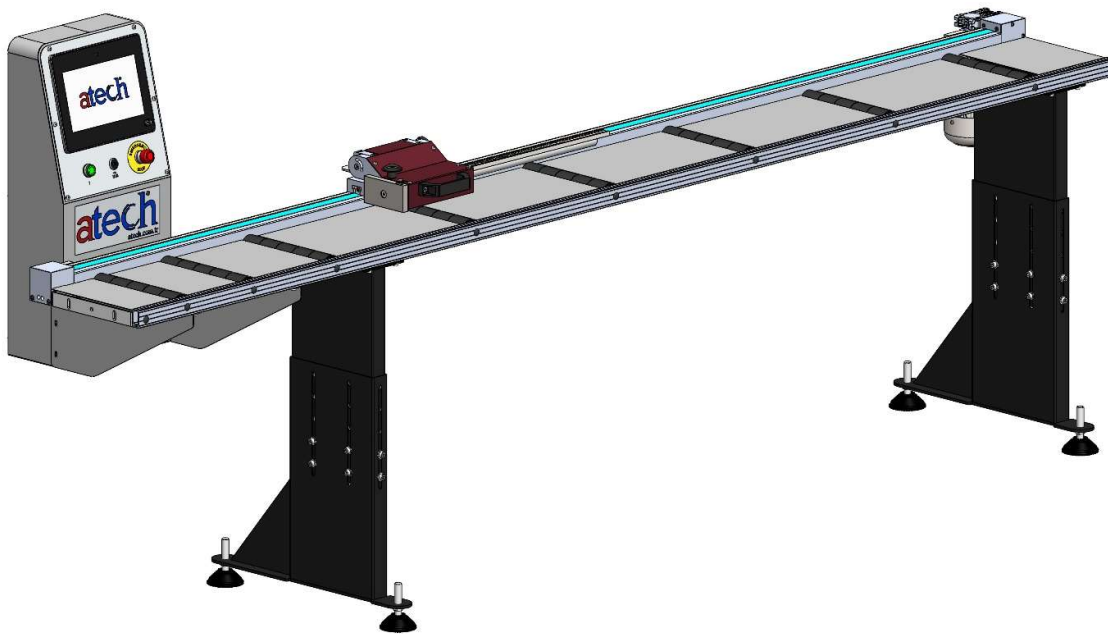




ATechMachinery.com



ASP – 3/6

**AUTOMATED STOP & POSITIONER
USER'S MANUAL**



CONTENTS

1. GENERAL INFORMATION

- 1.1. Introduction
- 1.2. Information About The Distributor

2. MACHINE'S DESCRIPTION AND PURPOSE OF USE

- 2.1. Machine's Description
- 2.2. Overall Dimensions
- 2.3. Parts List and Technical Drawings
- 2.4. Electric Power Scheme
- 2.5. Electric Circuit Schemes

3. SAFETY

- 3.1. Safety Information
- 3.2. Accident Prevention
- 3.3. General Safety Information
- 3.4. Safety Symbols And Meanings

4. TRANSPORT OF THE MACHINE

5. INSTALLATION OF THE MACHINE

- 5.1. Preparation

6. MACHINE SAFETY DATA

7. OPERATION

- 7.1. Panel Promotion and Program Entry
- 7.2. Automatic Cutting
 - 7.2.1. Recipe
 - 7.2.2. Cut List
- 7.3. Manual Cutting
- 7.4. Slicing
- 7.5. USB Recipe
- 7.6. Settings
 - 7.6.1. Technician Settings
- 7.7. Calibration
- 7.8. Input And Output Test

1. GENERAL INFORMATION

1.1. Introduction

The user's manual given by the manufacturer contains information about the machine parts. Each machine operator should read these instructions carefully, and the machine should be operated after fully understanding them.

Safe and efficient use of the machine for long term depends on understanding and following the instructions contained in this manual. The technical drawings and details contained in this manual constitute a guide for the operator.

1.2. Information About The Distributor

ATECH MACHINE, INC.

8539 Ziggy Lane, Gaithersburg, MD 20877 - USA

Ph. : +1-240-505-1967

e-mail : info@ATechMachinery.com

In case of any technical problem please contact your nearest ATECH dealer or ATECH head office through the above mentioned phone or e-mail address.

Technical labels with the model description of the machine are fixed onto the front side of each machine.

The machine's serial number and manufacturing year are stipulated on the technical label.

2. MACHINE'S DESCRIPTION AND TECHNICAL FEATURES

2.1. Machine's Description

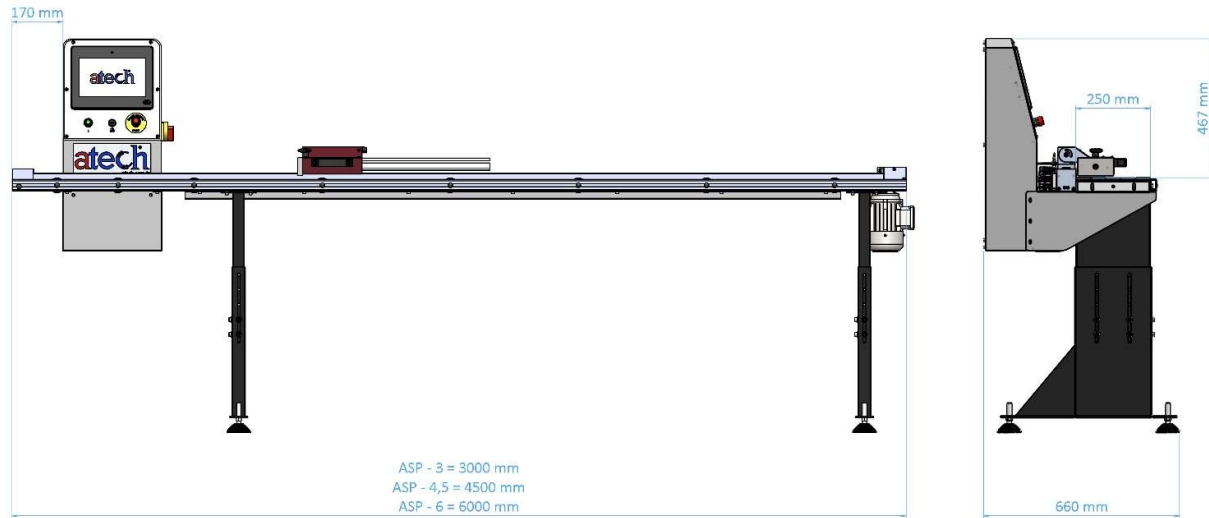
It is a computerized drive conveyor that helps to cut long profiles to length on saws.

- WORKS WITH MACHINES OF ANY BRAND
- PLC Windows CE Operation System
- Memory: up to 1,200 cut lists memory for use with optimization system. Up to 5,000 cut lists memory if no optimization system is used.
- It is a PLC controlled conveyor. It helps to cut the window glazing beads to the desired dimensions precisely on saws.
- Manual or automatic operation
- 10" touch screen
- Manual or computer recipe creation
- Possibility to change the cutting list on the screen
- Parts are ordered and cut according to the data sent from the measuring bar
- Production in special dimensions according to demand

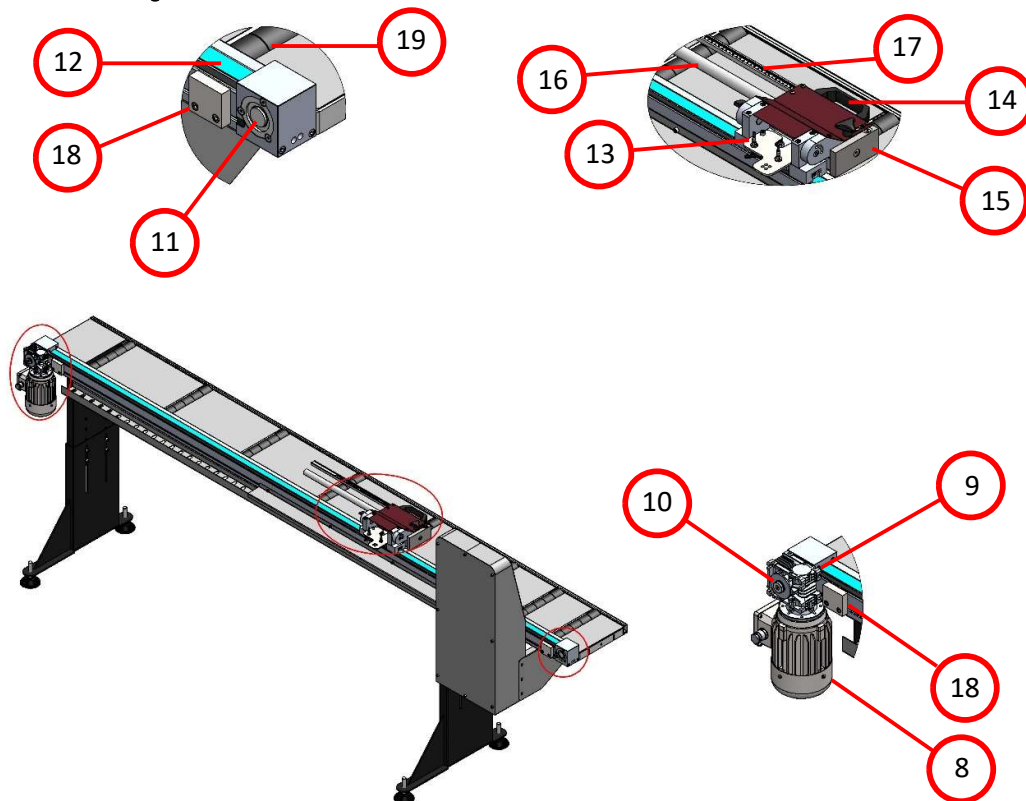
Please mention the below mentioned data in all your correspondence regarding the machine with the manufacturer and/or your ATECH dealer.

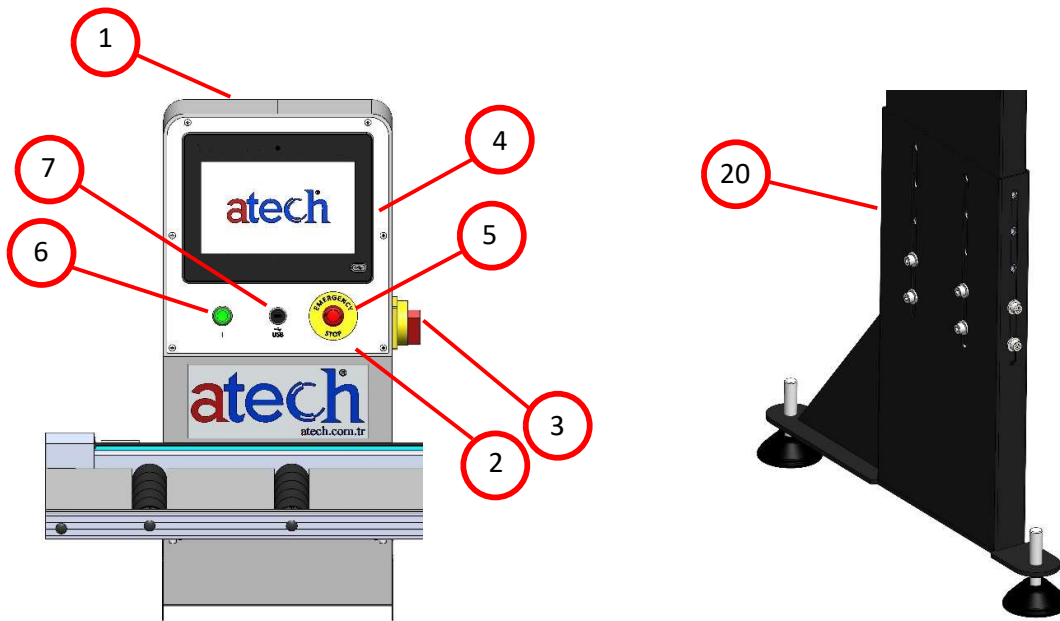
- Machine model
- Machine's serial number
- Voltage and frequency
- Name of dealer where machine was purchased
- Date of purchase
- Description of the machine fault
- Average operational period a day

2.2. Overall Dimensions



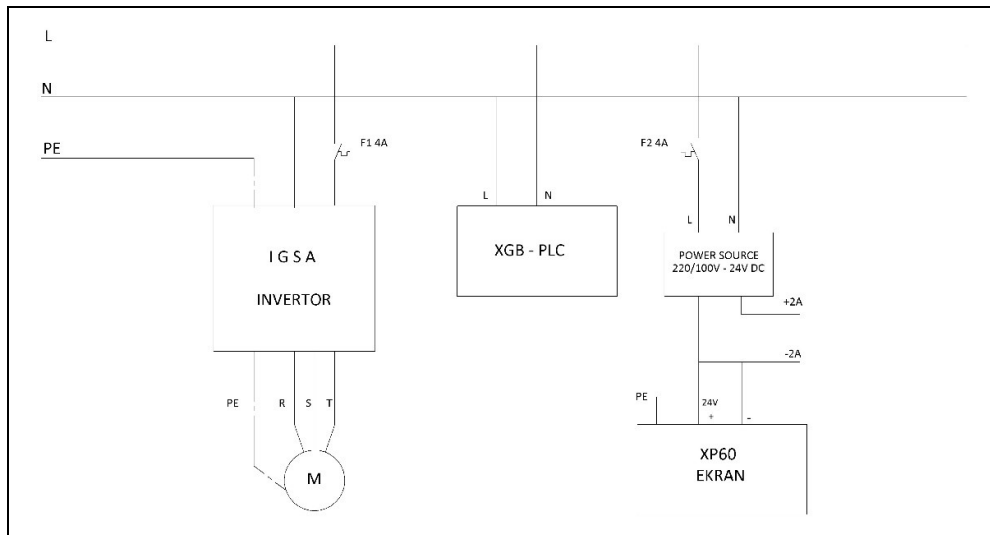
2.3. Parts List ve Technical Drawings



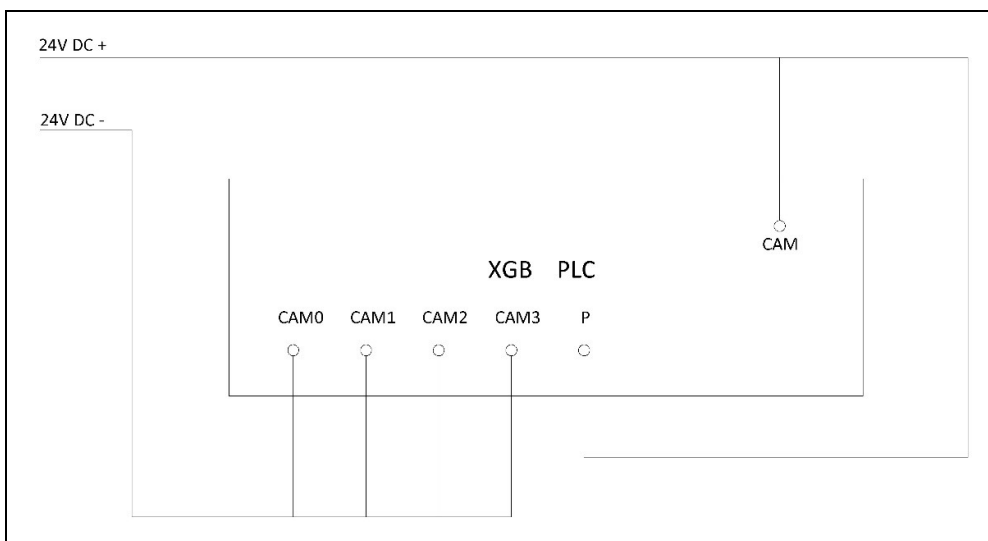
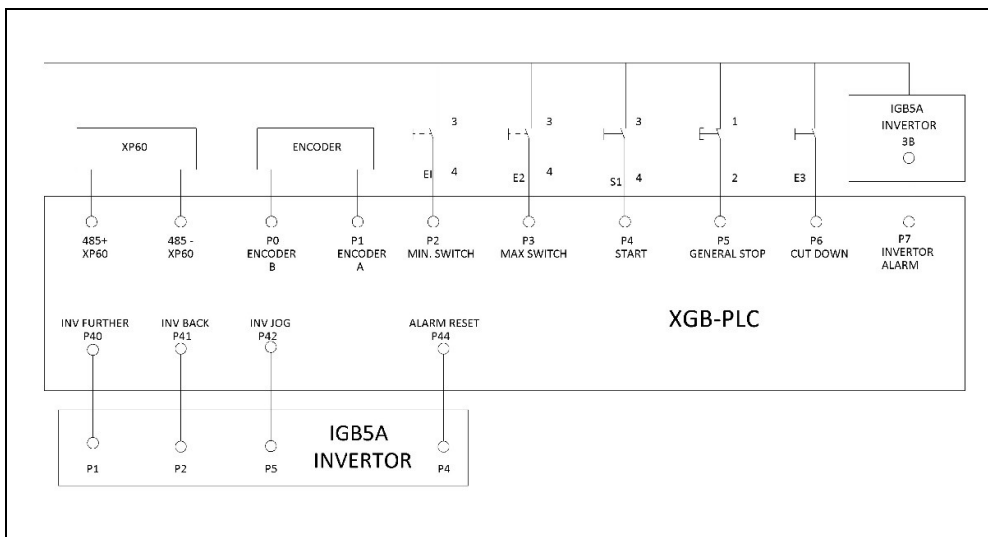


Part No	Part Name	QTY	Part No	Part Name	QTY
1	Electric Panel	1	11	Front Bearing Shaft	1
2	Control Panel	1	12	5M Timing Belt	1
3	Main Switch	1	13	Inductive Sensor	2
4	10" PLC Touch Screen	1	14	Profile Support Body	1
5	Emergency Stop Button	1	15	Profile Support Plate	1
6	Action Button	1	16	Profile Support Adjustment Shaft	1
7	USB Port	1	17	Profile Support Ruler	1
8	0,25 kW AC Motor	1	18	Inductive Sensor Limit Plate	2
9	Reducer	1	19	Roller	45
10	Reducer Shaft	1	20	Conveyor Foot	2

2.4. Electric Power Scheme



2.5. Electric Circuit Schemes



3. SAFETY

3.4. Safety Information

The symbols shown hereunder are necessary to be read with special attention.

Not reading or observing of them may cause damage to the equipment or personal injury.

IMPORTANT

The **IMPORTANT** symbol above is one telling to apply special care and to be careful at carrying out the specified operation.

CAUTION!

The **CAUTION!** Symbol above warns you against specific dangers and requires to read the text. Not observing may cause damage to the equipment.



The above symbol DANGER WARNING, warns you against specific dangers and you have definitely to read them. Negligence may cause damage to the equipment and bodily injury. Read the user's manual carefully before using the machine or carrying out maintenance works.



3.5. Accident Preception



- 3.5.1.** Our machines are manufactured in accordance with EN 60204–1 and EN 292–2 CE safety directives, which cover national and international safety directives.
- 3.5.2.** It is the task of the employer to warn his staff against risks, to train them on prevention of accident, to provide for necessary safety equipment and devices for the operator's safety.
- 3.5.3.** Before starting to work with the machine, the operator should check the features of the machine, learn all details of the machine's operation.
- 3.5.4.** Machine should be operated only by staff members, who have read and understood the contents of this manual.
- 3.5.5.** All directives, recommendations and general safety rules contained in this manual have to be observed fully. The machine cannot be operated in any way for purposes other than those described herein. Otherwise, the manufacturer shall not be deemed responsible for any damages or injuries. And such circumstances would lead to the termination of the warranty.

3.6. General Safety Information



- 3.6.1.** The power cable should be led in such a way that nobody can step on it or nothing can be placed on it. Special care be taken regarding the inlet and outlet sockets.
- 3.6.2.** If the power cable should be damaged during operation, don't touch and unplug it. Never use damaged power cables.
- 3.6.3.** Don't overload machines for drilling and cutting. Your machine will operate more safely with power supply in accordance CE with the stipulated values.
- 3.6.4.** Don't place your hands between parts in motion.
- 3.6.5.** Use protective eye glasses and ear plugs. Don't wear oversized clothes and jewels. These can be caught by moving.
- 3.6.6.** Keep your working place always clean, dry and tidy for accident prevention and safe operation.
- 3.6.7.** Use correct illumination for the safety of the operator. (ISO 8995-89 Standard The Lighting of Indoor Work System)
- 3.6.8.** Don't leave anything on the machine.
- 3.6.9.** Don't use any materials other than those recommended by the manufacturer for cutting operations on the machine.
- 3.6.10.** Ensure that the work piece is clamped appropriately by the machine's clamp or vice.
- 3.6.11.** Ensure safe working position, always keep your balance.
- 3.6.12.** Keep your machine always clean for safe operation. Follow the instructions at maintenance and replacement of accessories. Check the plug and cable regularly. If damaged, let it be replaced by a qualified electrician. Keep handles and grips free of any oil and grease.
- 3.6.13.** Unplug first, before conducting maintenance works.
- 3.6.14.** Ensure that any keys or adjustment tools have been removed before operating the machine.
- 3.6.15.** If you are required to operate the machine outside, use only appropriate extension cables.
- 3.6.16.** Repairs should be carried out by qualified technicians only. Otherwise, accidents may occur.
- 3.6.17.** Before starting a new operation, check the appropriate function of protective devices and tools, ensure that they work properly. All conditions have to be fulfilled in order to ensure proper operation of your machine. Damaged protective parts and equipment have to be replaced or repaired properly (by the manufacturer or dealer).
- 3.6.18.** Don't use machines with improperly functioning buttons and switches.
- 3.6.19.** Don't keep flammable, combustible liquids and materials next to the machine and electric connections

3.7. Safety Symbols And Meanings

	Electric warnings.		Use protective goggles.
---	--------------------	---	-------------------------

	Read operating instructions carefully before using or maintaining the machine.		Use protective earmuffs.
---	--	---	--------------------------

4. TRANSPORT OF THE MACHINE

IMPORTANT

* The transport should be done by qualified personnel only.

- 4.4.1. The machine should be transported by lifting with proper equipment (not touching the ground during the transport).
- 4.4.2. The machine is delivered wrapped in nylon and packet in carton box, unless other form of packing is agreed upon with the customer.
- 4.4.3. For the weight and overall dimensions of the machine see Technical Features.
- 4.4.4. Keep the carton box packing of the machine for future use.

5. INSTALLATION OF YOUR MACHINE

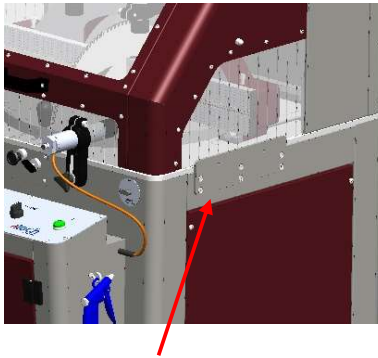
The ground, where the machine will be placed, should be even, solid enough to bear the weight of the machine.

5.4. Preparation

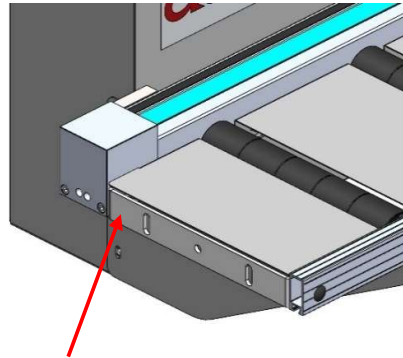
IMPORTANT

Remove the bolts and stopper connections first, which are used to fix the moving parts, before making the electric connection and starting the machine.

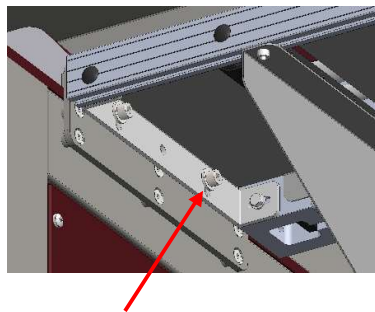
- 5.4.1. To connect the conveyor to the desired machine, mount the conveyor-machine connection plate to the corresponding place on the machine with M8 bolt.



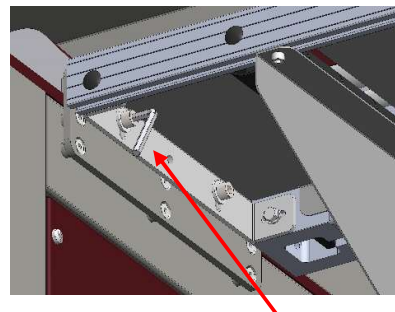
Conveyor Connection Sheet Metal



Saw Connection Sheet Metal

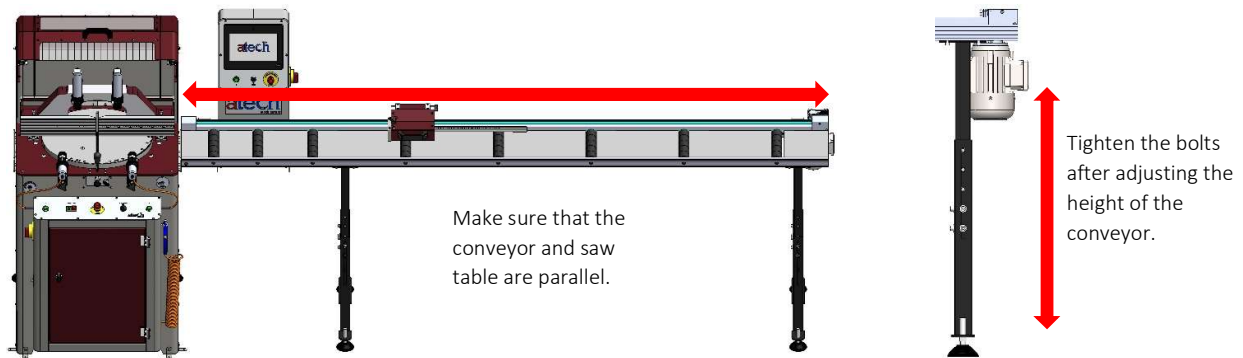


The bolt connections on the sheet metal have to be on top of each other

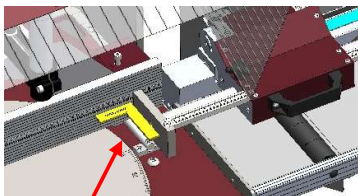


Complete the assembly with M8 washer and bolt.

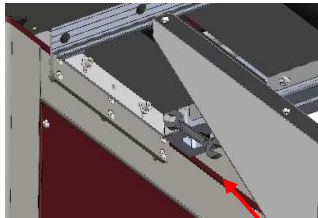
- 5.4.2. Use the bolts to adjust the height of the conveyor.



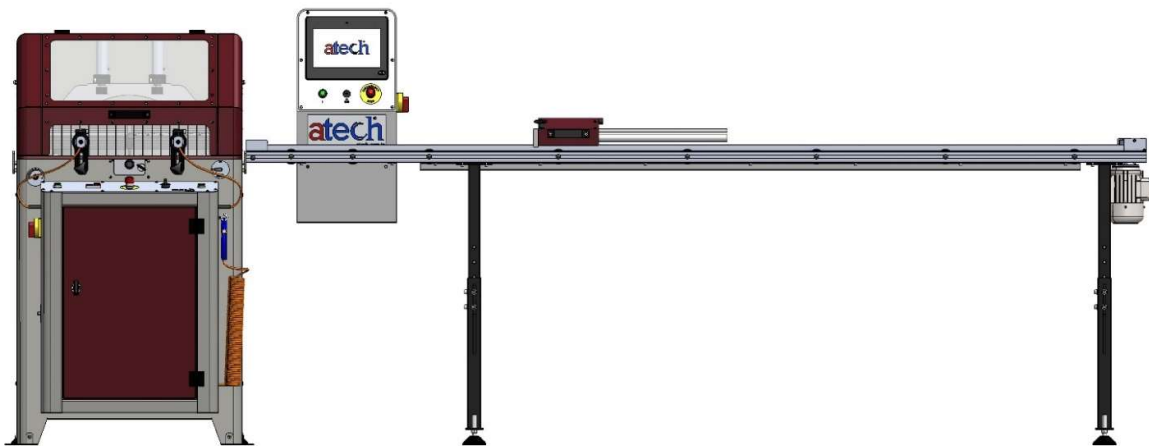
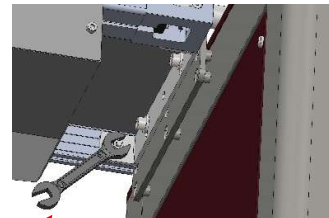
5.4.3. After the height adjustment of the conveyor, it is necessary to adjust the steepness of the conveyor support with the machine miter.



Check the perpendicularity between the miter and the support using a set-square. If the system is not in the desired tolerance, make the steepness adjustment from the machine connection plate of the conveyor.



With 10 wrenches, loosen the bolt and nut that connect the machine connection sheet metal to the conveyor and adjust the steepness. After the steepness is achieved, tighten the bolt and nut.



5.1.4. Connect the connecting cable socket with a plug conforming to the CE, UL standards.

5.1.5. Check your input energy before energizing the machine.

6. MACHINE SAFETY DATA

6.4.1. Lifting, installation, electric maintenance of the machine should be carried out by qualified personnel only.

6.4.2. Routine maintenance and scheduled maintenance should be carried out by qualified personnel after unplugging the machine first.

6.4.3. Ensure that the machine has been cleaned, tested and maintained before starting to operate it.

6.4.4. Check the safety devices, power cable and moving parts regularly. Don't operate the machine before having replaced defective safety devices or faulty parts.

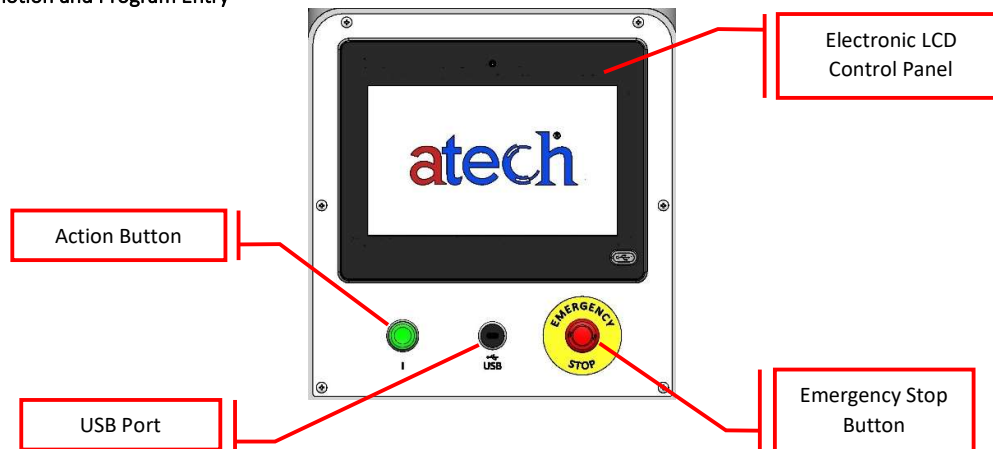
6.4.5. Keep foreign materials away from the working area of the machine, keep away from the machine's moving parts.

IMPORTANT

The safety data have been defined above. In order to prevent physical damage or damage to the equipment, please read the safety information carefully and keep the manual always in an easy accessible place.

7. OPERATION

7.4. Panel Promotion and Program Entry



ASP PLC Controlled Conveyors Use of electronic positioning device;



OFF

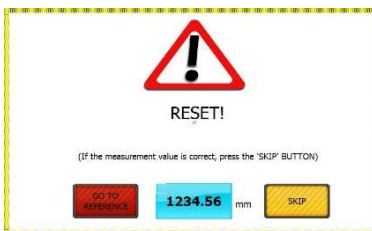


ON

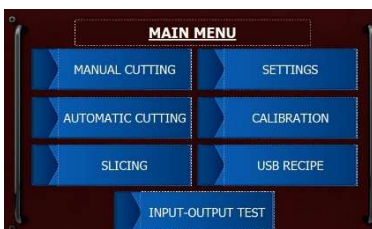
- Set Main Switch to "1". Electronic positioning device with touch screen. Tap the appropriate language option on the screen to pass the introduction page (ATECH).



- Perform machine position calibration if you are not sure of the position of the moving head before starting cutting. Press "GO TO REFERENCE" button. If you are sure of the position, click "SKIP" button to go to the main page.



- The main page is the screen page with operation selections and related settings. Operation is started by touching the desired operation button. Press on the name of the page you are on to return to the main page from other pages. Clicking on the main menu name, you can return to the language selection page.



7.5. Automatic Cutting



When you want to perform automatic cutting, you can make the measurements you have prepared before by selecting from the "CUT LIST" or with the new cutting values you will create from "RECIPE".

You can access the desired values by pressing the direction buttons next to the cutting list sequence number display to go to the measurement values existing in the "CUT LIST". When you reach the desired value, you can send it to the measure by pressing the "I" action button on the control panel. After the support body reaches the desired size, perform the cutting operation instructions of the machine used for cutting.

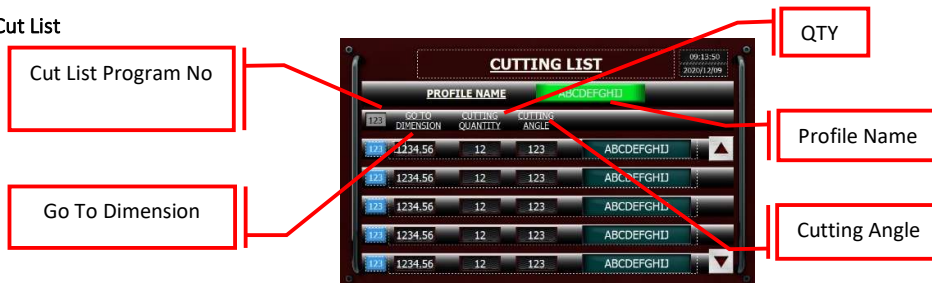
NOTE: If the value written in the quantity section is completed, the machine will automatically switch to the next memory recipe and wait for you to press the "I" action button.

7.5.1. Recipe



When you click on the recipe button, you can create a new recipe or you can access the values you have prepared before and make changes the values. Use the direction keys located on the side of the screen to access the existing values. To create a new recipe, fill in the relevant fields. To start cutting, press the page name and switch to the "AUTOMATIC CUTTING" page and continue the next steps as stated above. (7.2. Automatic Cutting))

7.5.2. Cut List



This is the section where the collective display of the recipes created. In this section, relevant values are entered and saved in the cut list. To start cutting, press the page name to switch to the "AUTOMATIC CUTTING" page and continue the next steps as stated above. (7.2. Automatic Cutting)

7.6. Manual Cutting



When you want to cut with "MANUAL CUTTING", write the desired workpiece size in the "GO TO DIMENSION" section. Press the "I" button after the cutting size is adjusted. After the support body reaches the desired size, perform the cutting operation instructions of the machine used for cutting.

7.7. Slicing



With the slicing operation, automatic cutting is made in the desired size, equal lengths and desired number of profiles. In order to process the workpiece to be sliced, create a new recipe or call the relevant program from the cut list.

While working in slicing, the length of the profile to be processed is entered into the system. After entering the cutting dimension and quantity (you can also enter the cutting angle for processing record information) press the "I" action button. After pressing the button, the support system goes to the length of the profile. Then start the cutting process in accordance with the instructions for use of the machine that will be processed. The system gives information when the process of each profile is completed until the amount of product requested for cutting is completed. When you press the "I" action button again, the support group moves to its first position. After placing the new profile, you can continue cutting where you left off. When the piece is completed, the system will automatically move on to the next process in the cut list.

NOTE: In order to precisely adjust the desired size in slicing, it is necessary to know the thickness of the saw well and enter the settings section.

7.8. USB Recipe



- Creating files on the PC
 - Open the Debug folder.
 - Enter the cutting optimization program.
 - Enter the profile information to be processed in the "CREATE PROFILE" section and save it.
 - Go to Recipe section and enter the cutting dimensions.
 - Press the "ADD" button, then "MAKE PLC RECIPE" button, and save the data. In addition, you can create different cutting recipes for the same profile in this section.
 - Save the recorded recipe information from the "PLC_recibe" file in the optimization folder in the documents folder into the "XP_recipe" folder in the USB.
- Transfer files to the ASP Control Panel
 - Plug the USB into the USB port on the control panel.
 - Press the "Dir_USB" button.
 - Enter the "XP_recipe" file and select the profile to be saved.
 - Select which recipe will be saved by clicking on "Selection".
 - After selecting the recipe to be recorded, select the operation unit to be registered. (*Automatic Cutting or Slicing*)
 - Click "Upload Data to PLC" button to complete the upload process.

7.9. Settings



In the settings section, as seen in the image above, the thickness of the saw used is entered into the system. There is also a technician settings section to be used by the authorized personnel in case of unexpected problems.

7.9.1. Technician Settings



CAUTION!

The machine is made ready for use by the manufacturer. In case of a malfunction in reference values, the authorized personnel will enter this page and make necessary arrangements.

7.10. Calibration



If the cut profile size is different with the "ACTIVE MEASURE" value displayed on the screen, the dimension of the cut profile can be entered in the "CALIBRATION MEASURE" on the calibration page and click the "CALIBRATE" button to calibrate the measurement. Another solution is to click on the main menu button on the main page and after selecting the language, click the "GO TO REFERENCE" button to correct the machine size.

In order to make full use of the conveyor capacity, a two-position support system is used. It is possible to cut to the minimum extent when the support forward and to the maximum extent when the support back. When the support position is changed (when taken back while forward or when forward while back), go to the calibration page and click the button of the taken position and click the "CALIBRATE" button. The system will be calibrated in approximately 2 seconds. For example; When it is necessary to take it back while the gauge is ahead, the system calibration is performed by entering the calibration page, clicking the support back button once and then clicking the calibrate button.

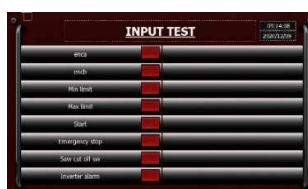


Support Forward



Support Back

7.11. Input And Output Test



CAUTION!

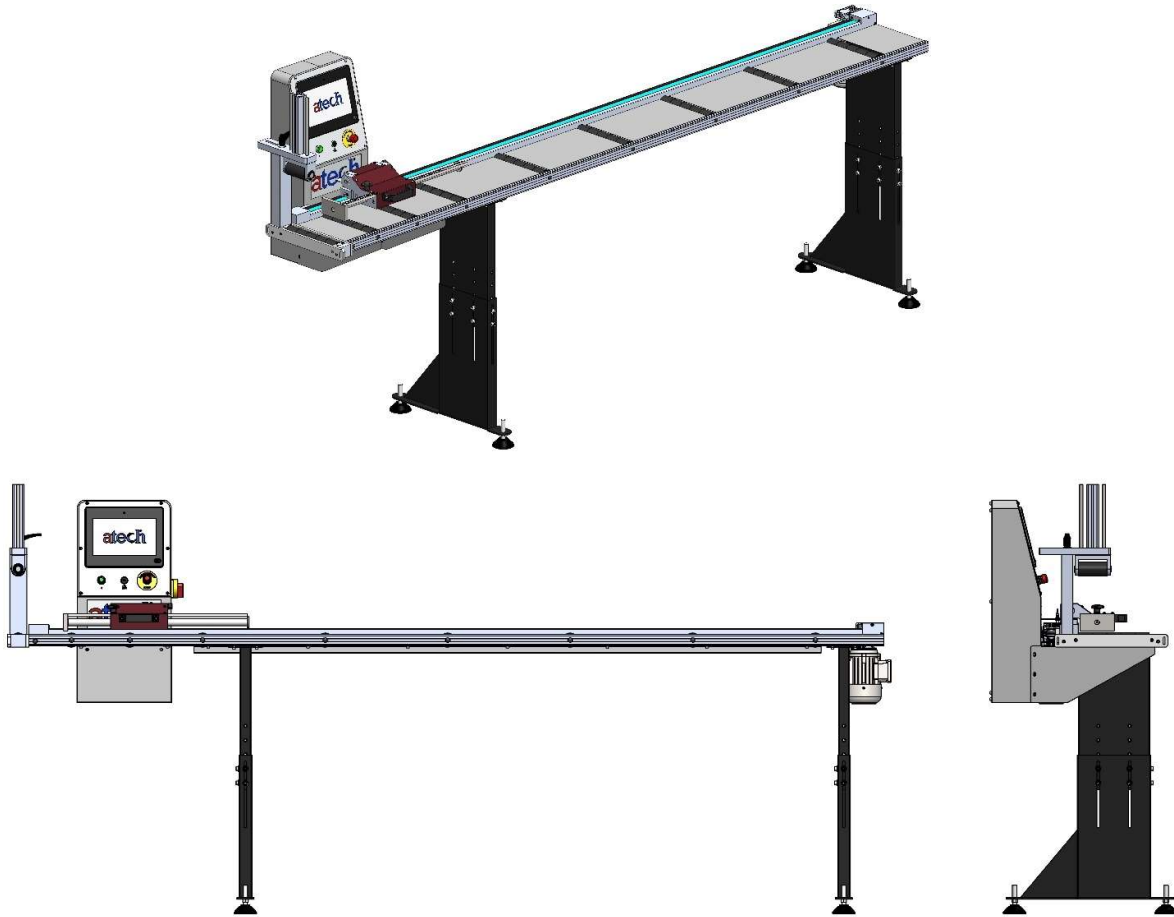
It will be used by authorized personnel or trained personnel for the necessary operations. Do not enter this section unless it is necessary for cutting operations or settings.

8. MAINTENANCE SERVICE AND REPAIR

- 8.4.1. Unplug the machine.
- 8.4.2. Remove all burr, chip and foreign materials from the machine surfaces. Use gloves to protect your hands from the sharp edges of the blade.
- 8.4.3. Don't use materials for cleaning the machine, which could damage its paint.

9. ROLLER CLAMP SYSTEM AS OPTION

9.1. Usage Instruction



Roller clamp system can be used in slicing and automatic cutting processes. The instructions specified in the operation to be processed are followed and sent to the support group position. After the profile is placed, the clamp button on the conveyor panel is pressed. The cutting process begins as specified in the instruction of the operation. The cutting process should continue until the support plate comes to the roller clamp.

NOTE: Adjust the inlet pressure of the roller clamp pneumatic cylinder from the pressure regulating valve depending on the profile dimension and weight used for the efficient operation of the system.

9.2. Pneumatic Scheme

