FOREWORD

Read this manual before operating any machinery

ORIGINAL INSTRUCTIONS
Before starting any operation it is compulsory to read this instruction manual. The guarantee that the machine will function and perform properly is strictly dependent upon the application of all the instructions contained in this manual.

Operator Qualification
The operators assigned to using this machine must be supplied with all of the necessary information and instruction and should be provided with adequate training regarding safety in pertaining to:

a) The conditions of use of the equipment;

b) Foreseeable abnormal situations, pursuant to Article 73 of Legislative Decree 81/08.

We guarantee the Machine's conformity to the specifications and technical instructions described in the Manual on the date of issuance and listed herein; On the other hand, the machine may also be subject to important technical changes in the future, without the manual being updated.

Therefore, see FERVI for information about modifications that could be implemented.

REV. 1 November 2013
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1 INTRODUCTION

This manual is delivered with the machine, and it must be regarded as an inseparable part of it. The manufacturer holds all ownership to material and intellectual property of this manual; any disclosure or copying, even partial, of this publication without prior written consent is forbidden.

The purpose of this manual is to provide the knowledge necessary for the use and maintenance of the Shear machine for sheet metal (Art. 0652/1000), and create a sense of responsibility and knowledge of the capabilities and limitations of the device entrusted to the operator.

As the machine is entrusted to experienced and skilled operators, the following machine must be perfectly known by the operator if you want it to be used safely and effectively. Operators must be properly trained and prepared, so make sure that this manual is read and consulted by the staff responsible for commissioning, operation and maintenance of the Shear machine for sheet metal. This is to make all operations the safest and most effective possible for those who carry out these tasks.

Therefore, it is imperative to strictly comply with the requirements in this manual, a necessary condition for safe and satisfactory operation of the machine.

Before starting operation, installation and usage of the Shear machine for sheet metal, authorised personnel must therefore:

- carefully read this technical document;
- know which protections and safety devices are available on the machines, their location and how they work.

The buyer is responsible for ensuring that users are properly trained, that they are aware of all the information and instructions in this document and that they are aware of the potential risks of operating the Shear machine for sheet metal.

*The manufacturer waives any and all responsibility for damage to people and/or things caused by non-observance of the instructions in this manual.*

The Shear machine for sheet metal has been designed and built with mechanical guards and safety devices designed to protect the operator/user from possible injury. It is strictly forbidden to modify or remove guards, safety devices and caution labels. If this must be done (for example, for cleaning or repair), make sure that no one can use the machine.

*Modifications to the machine carried out by the user must be considered their sole responsibility, therefore the manufacturer waives any and all responsibility for any damage caused to persons and/or property resulting from maintenance performed by unqualified personnel and in a manner unlike the operating procedures shown below.*
GRAPHIC REPRESENTATION OF SAFETY, OPERATIONAL AND RISK WARNINGS
The following boxes are designed to attract the attention of the reader/user for the proper and safe use of the machine:

Pay attention
This highlights behavioural rules to prevent damage to the machine and/or the occurrence of dangerous situations.

Residual Risks
This highlights the presence of dangers that cause residual risks to which the operator must pay attention in order to avoid injury or damage to property.

1.1 Preface
For safe and easy operation of the Shear machine for sheet metal, this manual must be read carefully in order to acquire the necessary knowledge. In other words, durability and performance are strictly dependent on how it is used.
Even if already familiar with the Shear machine for sheet metal, it is necessary to follow the instructions contained herein, in addition to the general precautions to be observed while working.
- Acquire full knowledge of the machine.
  Read this manual carefully to understand: operation, safety devices and all necessary precautions. All this is to allow safe use of the machine.
- Wear appropriate clothing for the job.
  The operator must wear appropriate clothing, so as to prevent the occurrence of unpleasant accidents.
- Maintain the machine with care.

Using the machine
The machine must only be used by qualified personnel trained to use the machine by authorised personnel.
2 SAFETY WARNINGS

2.1 General safety rules for machine tools

Risks associated with the use of the machine
Do NOT underestimate the risks related to the use of the machine and stay focused on the work you are carrying out.

Risks associated with the use of the machine
Despite the implementation of all safety devices for safe use of the equipment, it is necessary to take note of all the accident prevention requirements highlighted in various parts of this manual.

Risks associated with the use of the machine
Each and every person who is responsible for the use and maintenance of the device should first have read the instruction manual, particularly the chapter dealing with safety. It is recommended that the plant safety manager get written confirmation of the above.

Risks associated with the use of the machine
- During all work phases with the machine, you should proceed with great caution in order to avoid damage to persons, to property or to the machine itself.
- Please only use the machine for its envisaged uses.
- Don't tamper with the safety devices equipping the machine.

Risks associated with the use of the machine
Before starting any work on the machine, the operator must wear the appropriate personal protective equipment (PPE) such as gloves and eye protection.

1. Always check the efficiency and integrity of the machine.
2. Before using the machine, get used to ensuring that no remaining adjustment or maintenance wrenches have remained inserted.
3. Keep the workplace tidy and free from hindrances; disorder causes accidents.
4. Make sure that the work environment is forbidden to children, non-employees and animals.

5. Do not perform tasks on the machine other than those for which it was designed. Only use the machine in the manner in which it was intended, as described in this instruction manual.

6. Work without disturbances.

7. Work areas must be well lit.

8. Always wear eye protection and protective gloves while working. If dust is produced, use the appropriate masks.

9. Wear appropriate clothing. Loose clothing, dangling jewellery, long hair, etc., can get caught in the moving parts, causing irreparable injury.

10. Replace worn and/or damaged parts, check that the guards and protection devices work properly before operating. If necessary, have the machine checked by the service support personnel. Use only original spare parts.

11. Do not use the machine in areas with a risk of fire and/or explosion.

12. It is recommended that users of this publication, for maintenance and repair, have a basic knowledge of mechanical principles and of repair technique procedures.

13. The person responsible for company safety is to make sure that the staff responsible for using the machine have read and understood this manual in its entirety.

14. The company safety manager is responsible for monitoring the company's risk status according to Legislative Decree no. 81/08.

2.2 Technical support

For any problems or concerns, please contact, without hesitation the Customer Service Department of your dealer, who has competent and specialized staff, specific equipment and spare parts.

2.3 Other provisions

IT IS FORBIDDEN TO TAMPER WITH SAFETY DEVICES

The first thing to do when starting work is to check for the presence and integrity of the protections and the operation of the safety devices.

If any defect is encountered do not use the machine!

Even more so, it is strictly forbidden to modify or remove guards, safety devices, labels and indication signs.
2.4 Safety pictograms

Figure 1 - Safety pictograms

ATTENZIONE! WARNING!
LEGGERE LE ISTRUZIONI PRIMA DI UTILIZZARE LA MACCHINA.
READ THE INSTRUCTION MANUAL BEFORE OPERATING.
NON AVVICINARE PARTI DEL CORPO AL PUNTO DI TAGLIO AL
MOMENTO DELL’OPERAZIONE.
DON’T PLACE ANY PART OF THE BODY NEAR THE CUTTING AREA.
POSIZIONARE LA MACCHINA SU UNA SUPERFICIE STABILE
PLACE THE MACHINE ON A RIGID SURFACE.
NON UTILIZZARE INDUMENTI INGOMBRANTI DURANTE
L’UTILIZZO DELLA MACCHINA
DON’T WEAR HAMPER CLOTHES WHEN USING THE MACHINE.
3 RECEIPT AND UNPACKING

Upon receipt of the machine, carefully examine if the outer packaging is in good condition. Remove the cover to inspect if any part has been damaged during shipping or if there are missing parts. In the event that any of the above situations occurs, notify the transporter and the supplier directly. Some parts and accessories are packaged unassembled in bulky packaging. Carefully check the parts and accessories in separate packaging. Then assemble the parts on the machine according to the drawings.

4 TECHNICAL SPECIFICATIONS

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
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<tbody>
<tr>
<td>Size</td>
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</tr>
<tr>
<td>Cutting capacity</td>
<td>1000 mm</td>
</tr>
<tr>
<td>Max thickness of cut</td>
<td>0.8 mm</td>
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<tr>
<td>Weight</td>
<td>430 kg</td>
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</tbody>
</table>
5 INSTALLATION

Be sure to install the shear machine on a solid, level surface. The work area should be well lit to prevent any incorrect operation or to prevent damage.
Attach the machine to the ground with anchoring bolts to prevent vibrations, place a spirit level on the surface of the table to level the machine in all directions. Place a few layers of metal between the ground and the machine to adjust the levelling. Then tighten all bolts after adjusting them.

⚠️ Using the machine

- The blades are sharp. During the operation be very careful. Keep hands away from the blade.
- Wear safety or protective glasses. Always wear protective gloves. Keep the work area clean and avoid slippages and jerking.
- Never remove safety devices and maintain tolerance to the minimum relative to the space required for the supply of material.
- Never use the machine to cut bars or material beyond its capacity.
- Never attempt to cut any type of material less than 25 mm in width for the entire length of the machine.

⚠️ Use of PPE

In any case, ALWAYS use appropriate personal protective equipment such as:

- crush resistant gloves;
- accident prevention shoes;
- overalls or aprons;
- safety goggles;
- Hearing protection devices

Figure 2 - Personal protective equipment.
6 OPERATING INSTRUCTIONS

6.1 Adjusting rear cutting
Pre-adjust the cutting capacity, loosen the adjustment knobs, move the slide, move the bar forward or backward in direction depending on the extent required. Tighten the locking and make fine adjustments using the small wheel. Tighten the screws to secure the bars in place.

6.2 Adjusting blade tolerance
To adjust the tolerance of the blade, loosen the front screws and the table locking screws, also loosen the table bolts on both sides. Use a 0.002" plate and adjust the table locking screws. Then loosen all the screws.

6.3 Adjusting the platform
If the platform is buckled after use, it is possible to adjust it using the adjusting bolt, check the alignment of the mounting bolt. Re-tighten all the bolts. To adjust the blade up or down, move the pin downwards on the pedal and loosen the nut. Adjust the play up or down. Reassemble the pieces.
Loosening the locking screws may cause a malfunction of the blade during use. Check and make sure they are properly against the shims, but be careful not to press excessively.

6.4 Sharpening the blade
The upper blade has two cutting edges that are sharpened with two bevelled edges. Turn it over to expose the new cutting edge when the other is blunt. It can be sharpened with a grinding wheel on both sides.
The lower blade has a cutting edge with two edges and a bevelled face. It can be re-sharpened using a grinder on the large side of the blade, the side that has 1 bevel.
7 EXPLODED VIEW AND SPARE PARTS
<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Quantity</th>
<th>Part No.</th>
<th>Description</th>
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