Comall

Aluminium Machinery

Codice - Code - Kode

ZPX14393

AV SAVO

CE

OTT./08

MANUALE USO
CATALOGO RICAMBI
Punzonatrice

OPERATION MANUAL
SPARES CATALOGUE
Punching machine

MANUEL D'UTILISATION
CATALOGUE PIECES DE RECHANGE
Poinçonneuse

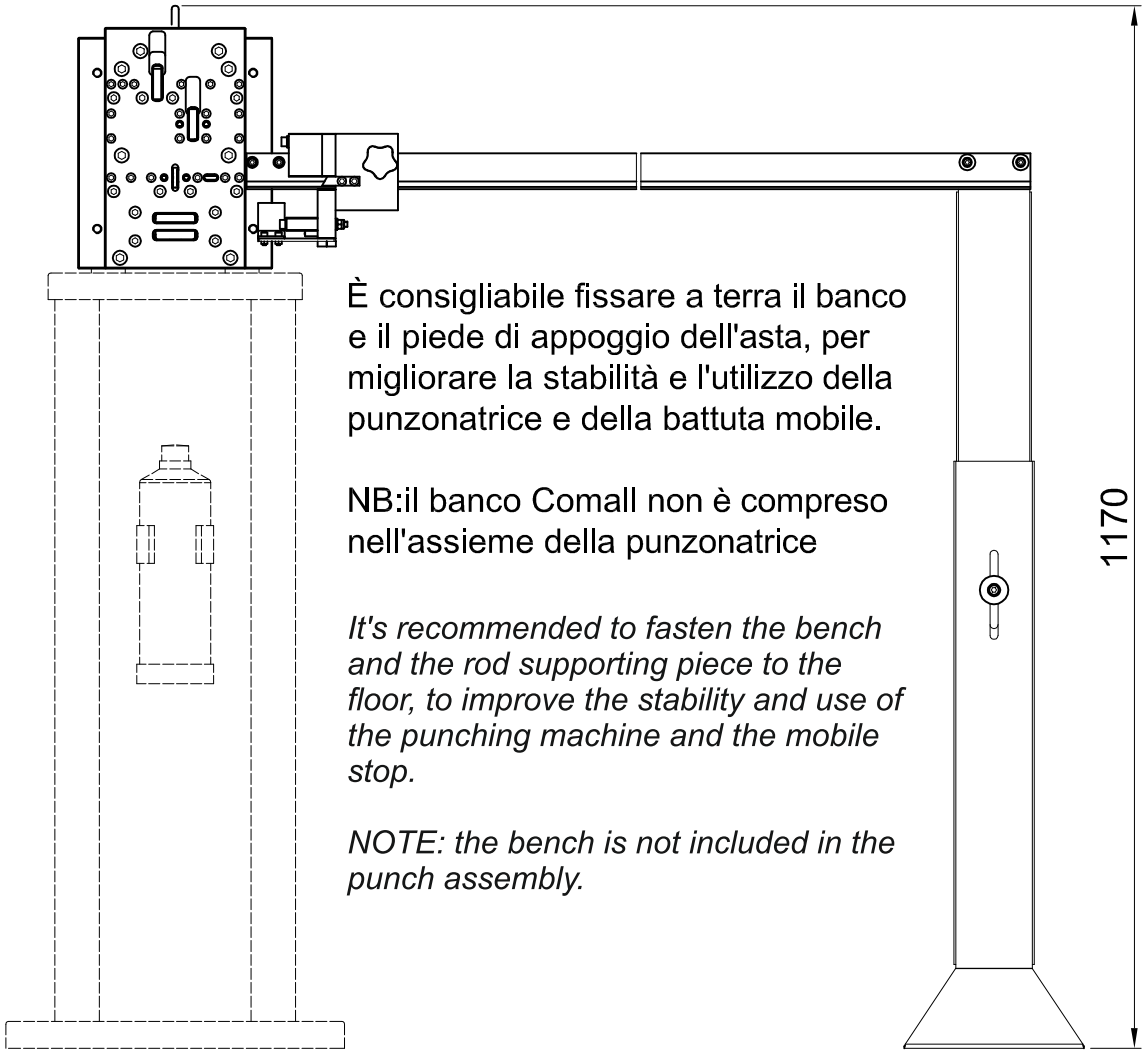
BEDIENUNGSANWEISUNG
ERSATZEILKATALOG
Stanzmaschinen

Doc. Cod. MUX10561

Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

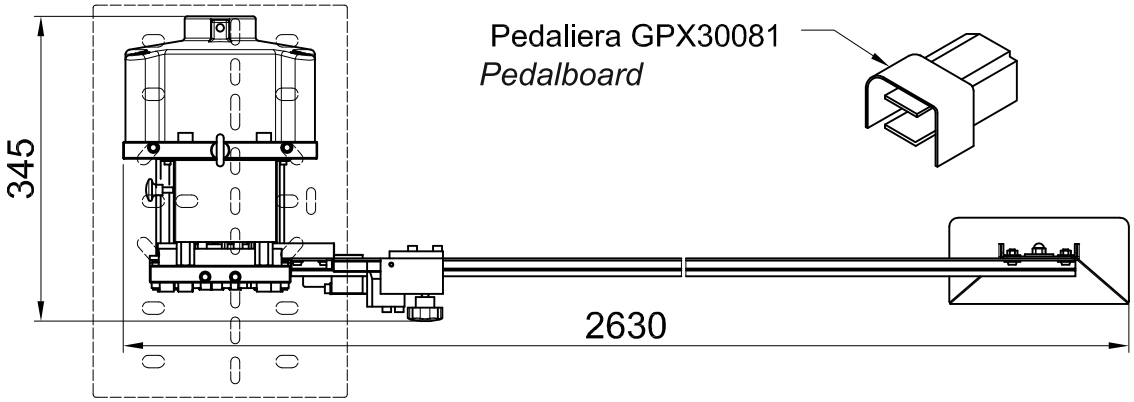


È consigliabile fissare a terra il banco e il piede di appoggio dell'asta, per migliorare la stabilità e l'utilizzo della punzonatrice e della battuta mobile.

NB:il banco Comall non è compreso nell'assieme della punzonatrice

It's recommended to fasten the bench and the rod supporting piece to the floor, to improve the stability and use of the punching machine and the mobile stop.

NOTE: the bench is not included in the punch assembly.



CARATTERISTICHE TECNICHE :			TECHNICAL DATA :		
Cilindro :	Ø200	mm.	Cylinder :	Ø200	mm.
Numero camere :	1		Number of chambers :	1	
Corsa cilindro :	20	mm.	Piston stroke :	20	mm.
Pressione di esercizio :	6	Bar	Working pressure :	6	Bar
Forza :	1740	Kg.	Power :	1740	Kg.
Consumo aria :	7.4	Nl per ciclo	Air consumption :	7.4	Nl per cycle
Dimensioni :	345x2615x1170h	mm.	Overall dimensions :	345x2615x1170h	mm.
Massa :	40	Kg.	Weight :	40	Kg.

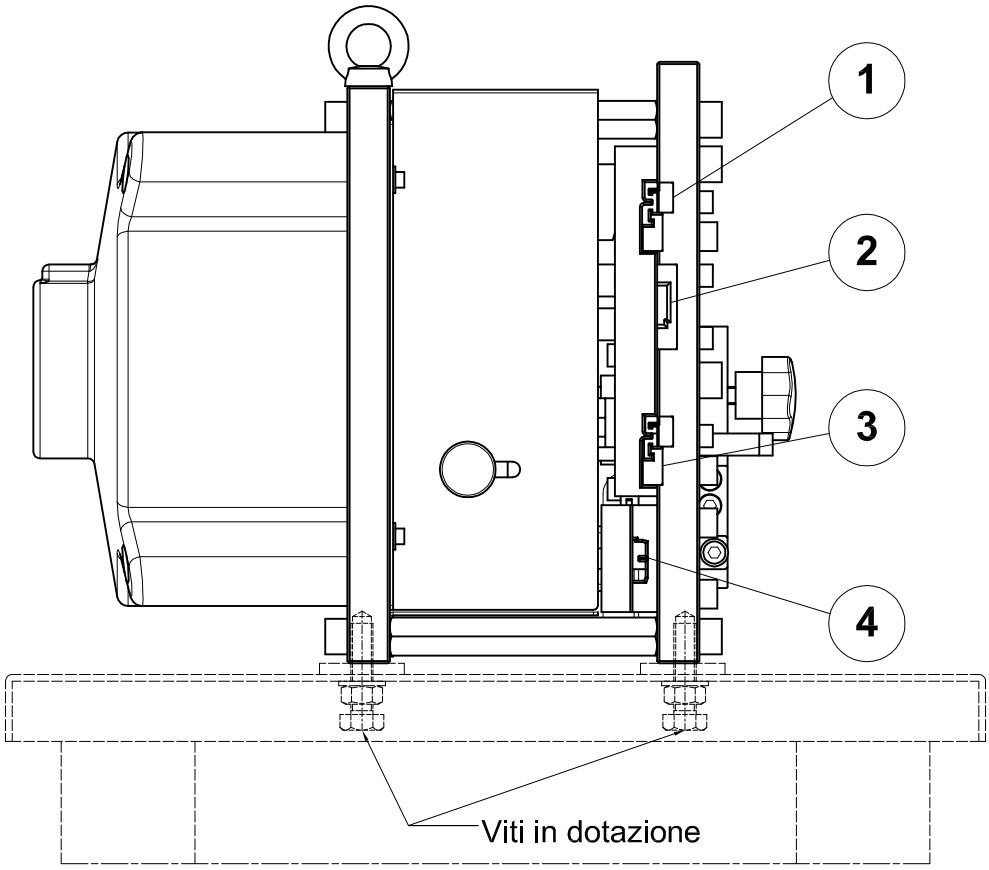
Comall
Aluminium Machinery

AV SAVIO

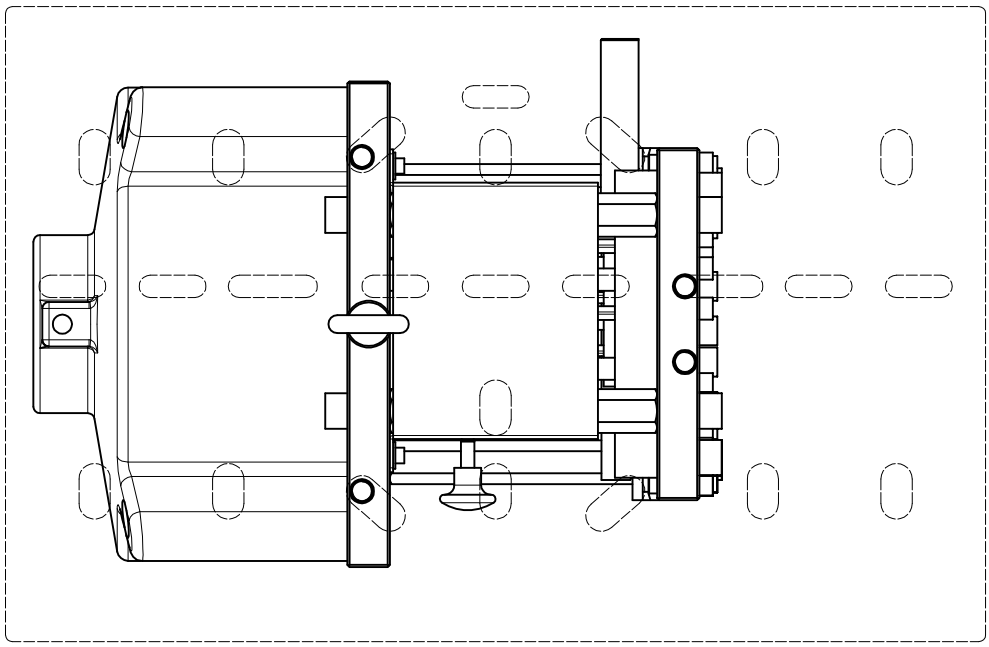
Codice - Code - Kode
ZPX14393

STAZIONI PUNZONATRICE E FISSAGGIO AL BANCO

PUNCHING MACHINE STAGES AND FASTENING TO THE BENCH



Supplied screws



NB:il banco Comall non è compreso nell'assieme della punzonatrice

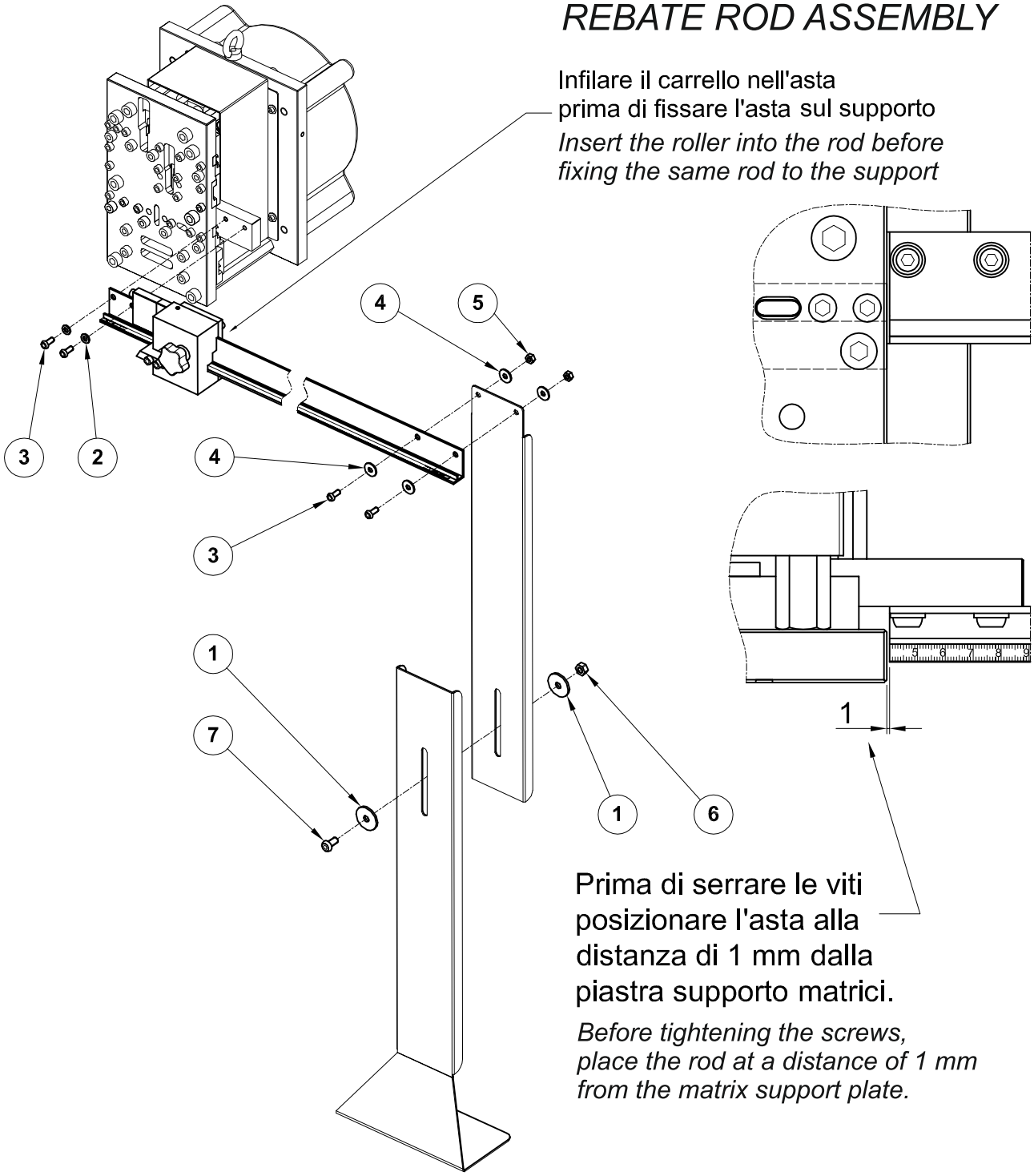
NOTE: the bench is not included in the punch assembly.

Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

ASSEMBLAGGIO ASTA DI BATTUTA
REBATE ROD ASSEMBLY

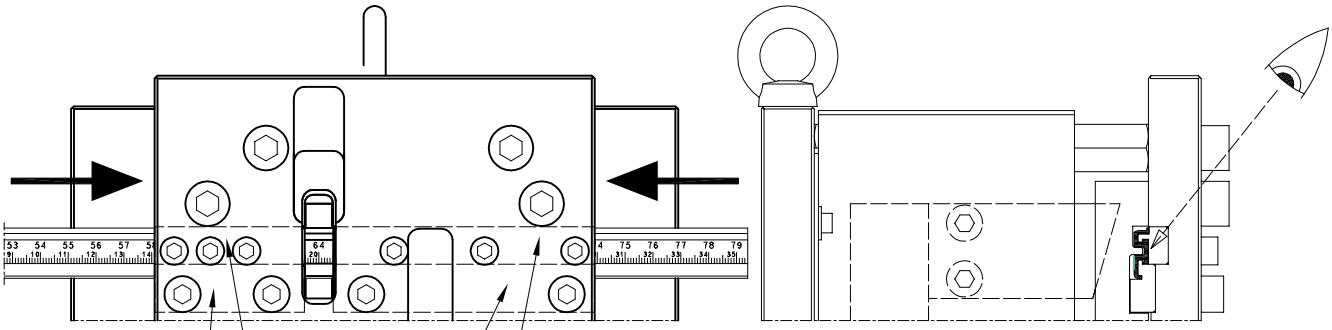


Rif.	Codice / Code	Descrizione / Description		Q.ta / Pcs.
7	MBX20807	Vite M8x16 zincata	Galvanized screw M8x16	1
6	MBX20769	Dado medio M8 zincato	Medium galvanized nut M8	1
5	MBX20768	Dado medio M6 zincato	Medium galvanized nut M6	2
4	MBX20766	Rosetta M6x18x1.5 R40 zincata	Galvanized rosette M6x18x1.5 R40	4
3	MBX20618	Vite M6x14 zincata	Galvanized screw M6x14	4
2	MBX20170	Rosetta M6 R40 zincata	Galvanized rosette M6 R40	2
1	MBX20147	Rosetta M8x32x2.5 R40 zincata	Galvanized rosette M8x32x2.5 R40	2

STAZIONE 1 *STAGE 1*

Taglio e asole a 10 mm di interasse su asta braccio sagomata dx e sx

Cutting and slots at 10 mm of distance between centres on RH / LH shaped arm rod



Matrice / *Matrix* MMX45347

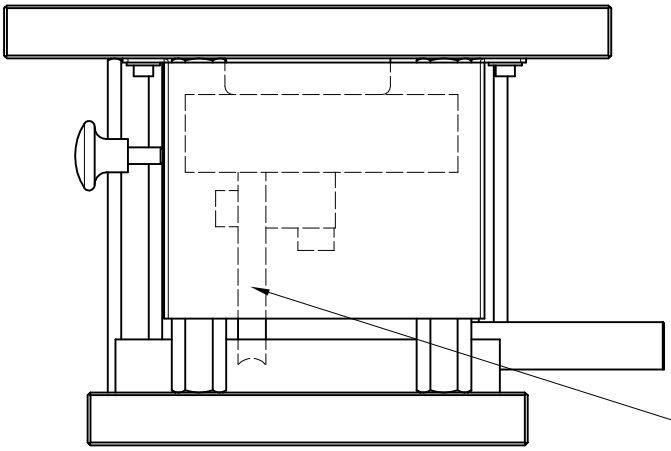
Matrice / *Matrix* MMX45345

Matrice / *Matrix* MMX45346

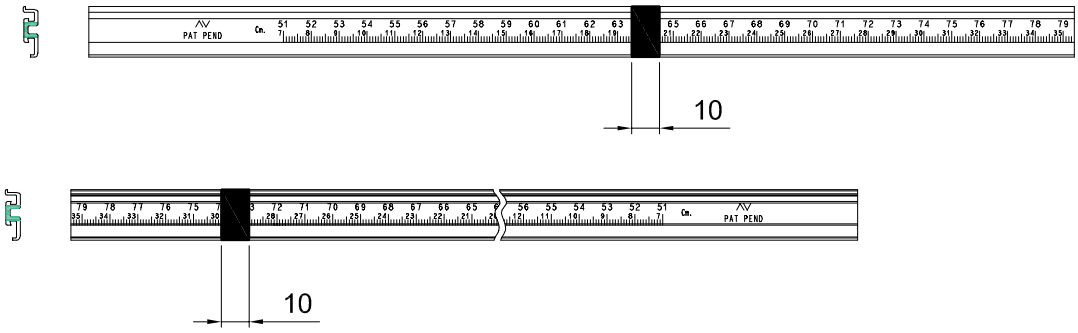
Matrice / *Matrix* MMX45344

- Introduzione dell'asta dx e sx.
- Riferimento visivo per taglio asta su tampografia.
- La lettura si esegue all'interno della finestra di taglio

- *RH/LH rod insertion*
- *Visual reference for cutting rod on tampography*
- *The reading is performed inside the cutting window*



Punzone / *Punch* MPX45396

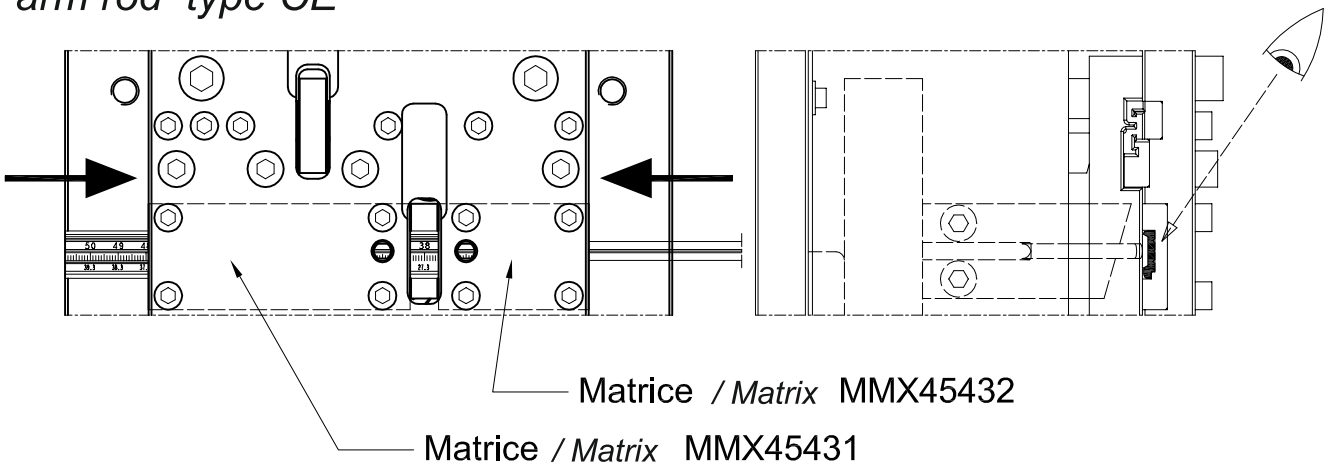


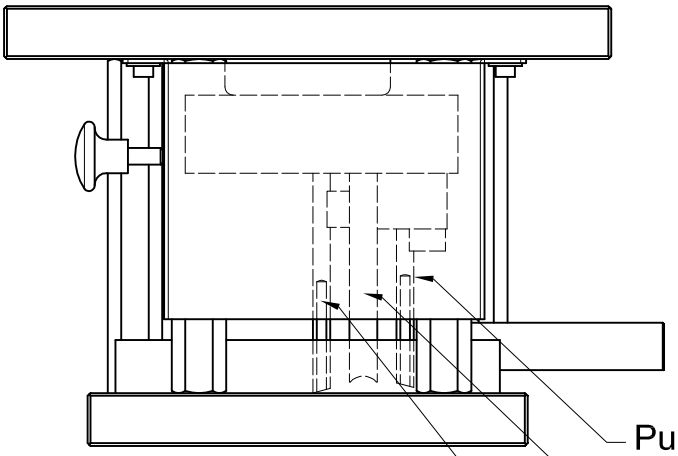
Codice - Code - Kode
ZPX14393

STAZIONE 2 *STAGE 2*

Taglio e asole a 10 mm di interasse su asta braccio tipo CE dx e sx

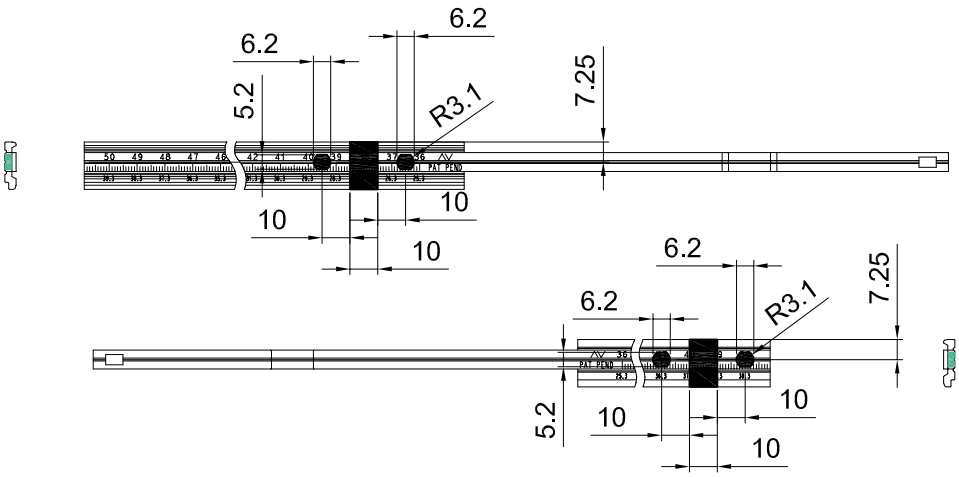
Cutting and slots at 10 mm of distance between centres on RH / LH arm rod type CE





- Introduzione dell'asta dx e sx.
- Riferimento visivo per taglio asta su tampografia.
- La lettura si esegue all'interno della finestra di taglio

- *RH/LH rod insertion*
- *Visual reference for cutting rod on tampography*
- *The reading is performed inside the cutting window*



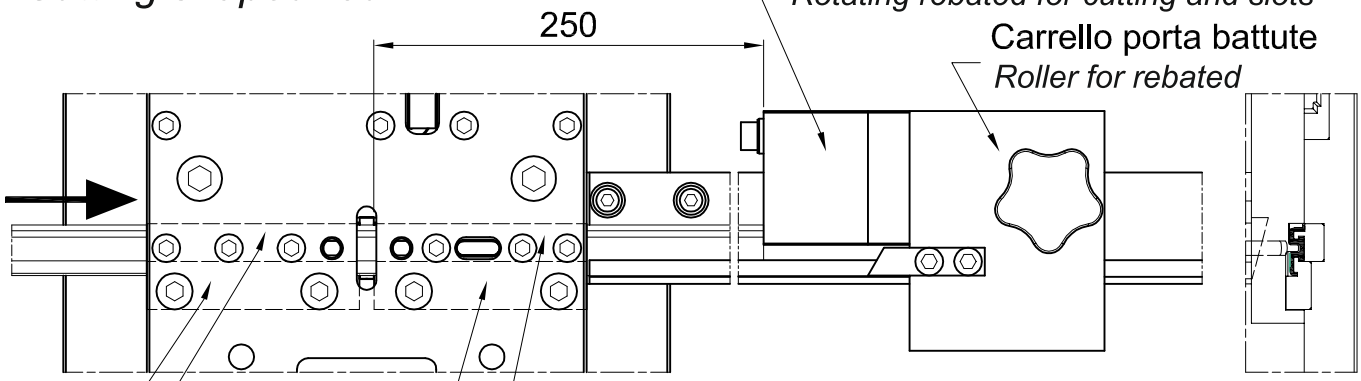
Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

STAZIONE 3 *STAGE 3*

Taglio asta sagomata
Cutting shaped rod



Matrice / *Matrix* MMX45434

Matrice / *Matrix* MMX45351

Matrice / *Matrix* MMX45433

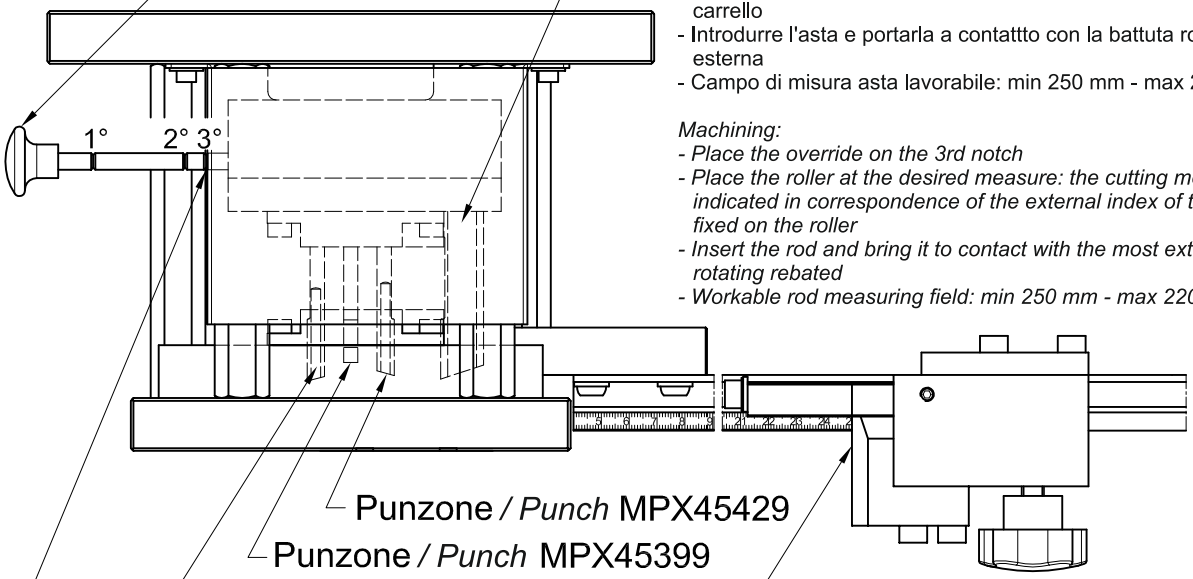
Matrice / *Matrix* MMX45350

Punzone / *Punch* MPX45402

Per eseguire la lavorazione:
- Posizionare l'esclusore sulla 3° tacca
- Posizionare il carrello alla misura desiderata: la misura di taglio si legge in corrispondenza dell'indice esterno del piattino fissato sul carrello
- Introdurre l'asta e portarla a contattto con la battuta rotante più esterna
- Campo di misura asta lavorabile: min 250 mm - max 2200 mm

Machining:
- *Place the override on the 3rd notch*
- *Place the roller at the desired measure: the cutting measure is indicated in correspondence of the external index of the plate fixed on the roller*
- *Insert the rod and bring it to contact with the most external rotating rebated*
- *Workable rod measuring field: min 250 mm - max 2200 mm*

Esclusore / *Override*



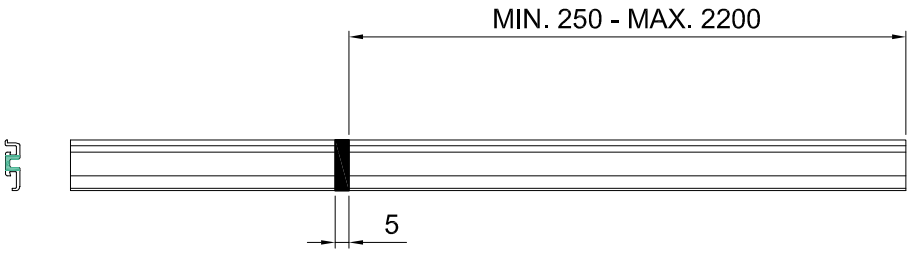
Punzone / *Punch* MPX45429

Punzone / *Punch* MPX45399

Punzone / *Punch* MPX45428

Tacca di riferimento
Reference notch

Lato lettura scala millimetrata
Es. : 250 mm.
Reading side for millimeter range
Ex: 250 mm



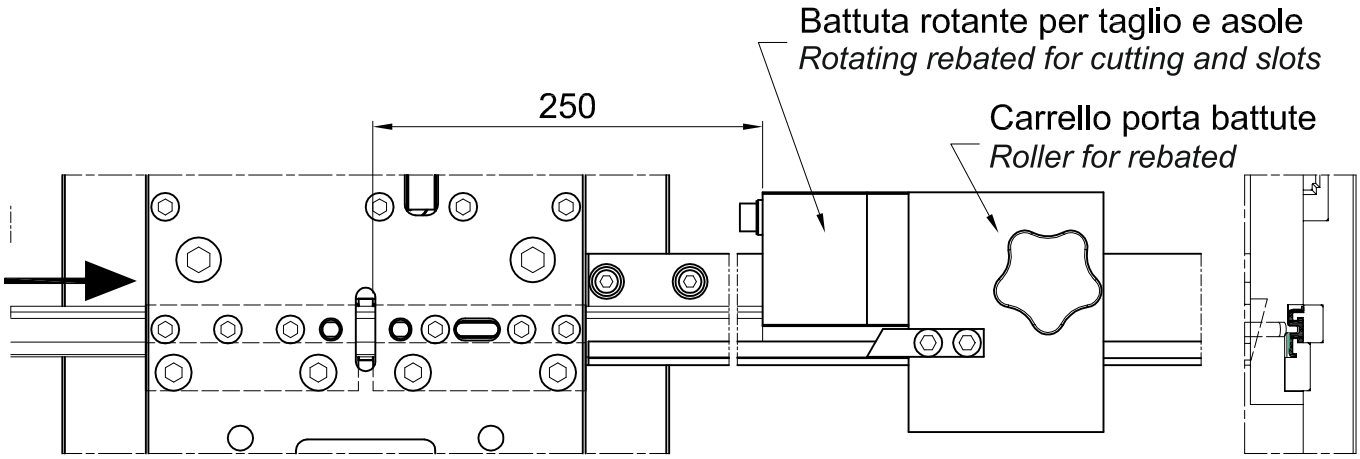
Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

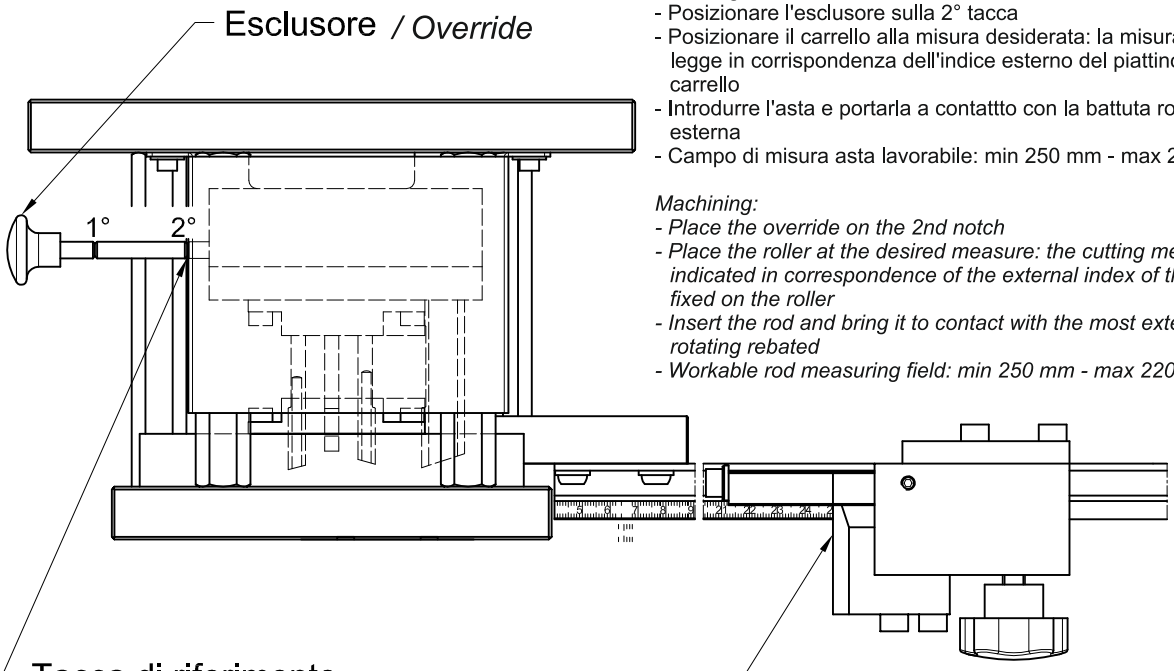
STAZIONE 3 *STAGE 3*

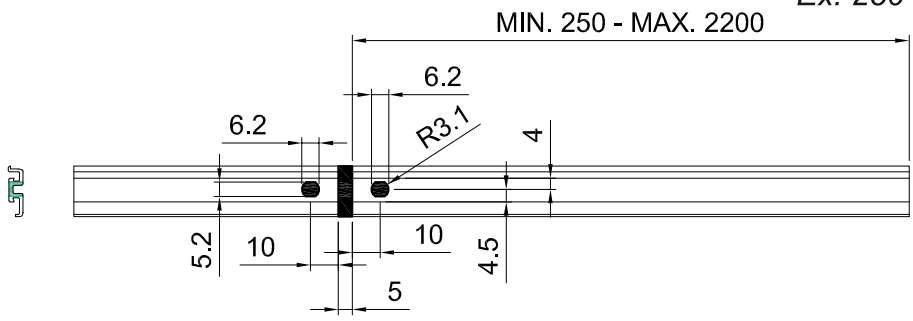
Taglio e asole a 10 mm di interasse su asta sagomata
Cutting and slots at 10 mm of distance between centres on shaped rod



Per eseguire la lavorazione:
- Posizionare l'esclusore sulla 2° tacca
- Posizionare il carrello alla misura desiderata: la misura di taglio si legge in corrispondenza dell'indice esterno del piattino fissato sul carrello
- Introdurre l'asta e portarla a contattto con la battuta rotante più esterna
- Campo di misura asta lavorabile: min 250 mm - max 2200 mm

Machining:
- *Place the override on the 2nd notch*
- *Place the roller at the desired measure: the cutting measure is indicated in correspondence of the external index of the plate fixed on the roller*
- *Insert the rod and bring it to contact with the most external rotating rebated*
- *Workable rod measuring field: min 250 mm - max 2200 mm*





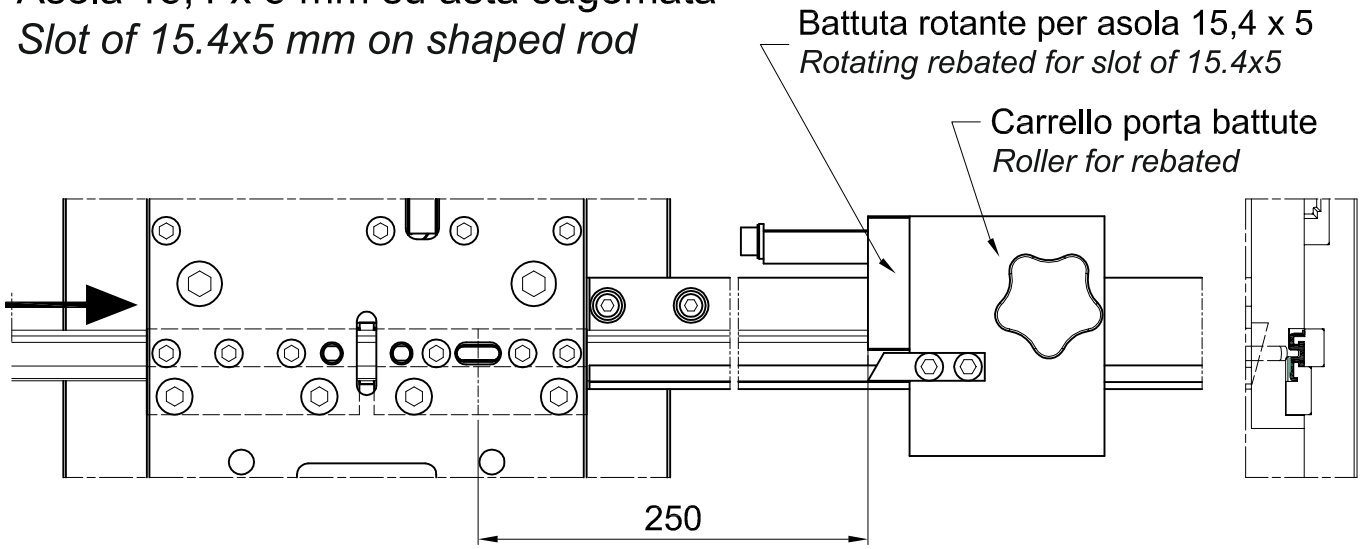
Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

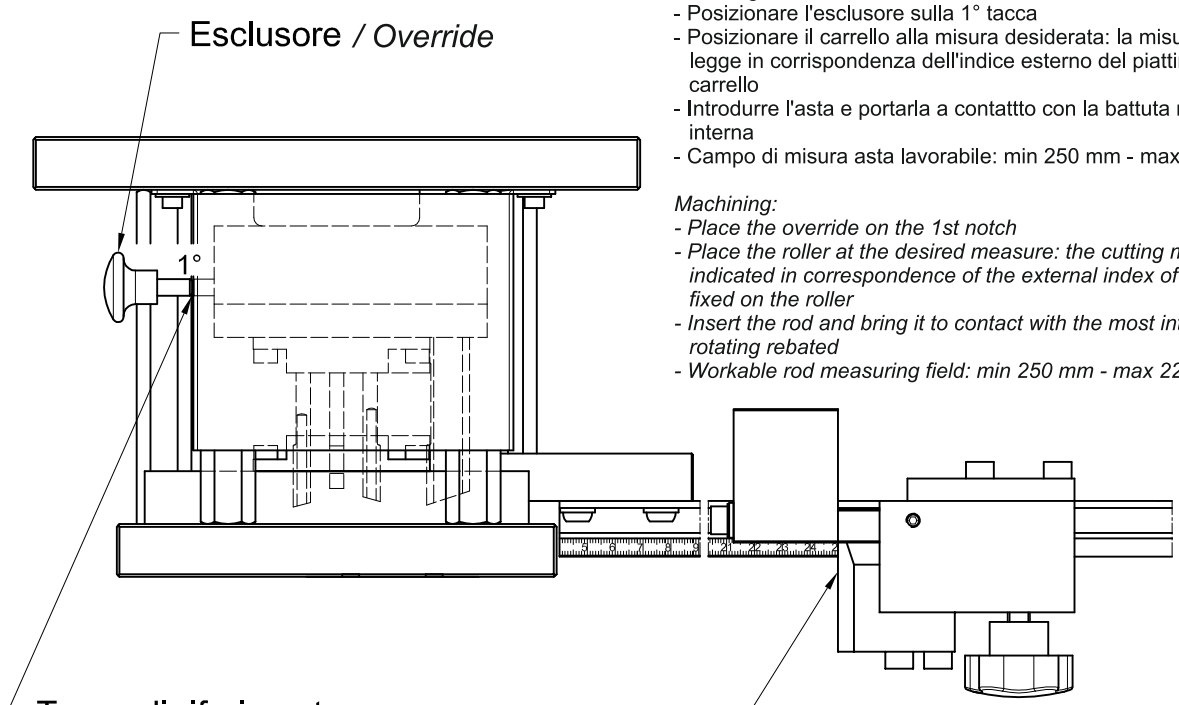
STAZIONE 3 *STAGE 3*

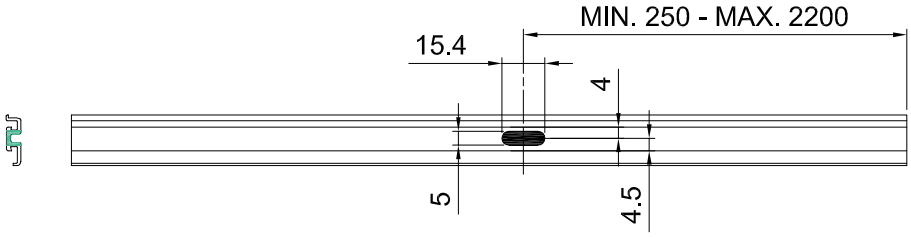
Asola 15,4 x 5 mm su asta sagomata
Slot of 15.4x5 mm on shaped rod



Per eseguire la lavorazione:
- Posizionare l'esclusore sulla 1° tacca
- Posizionare il carrello alla misura desiderata: la misura di taglio si legge in corrispondenza dell'indice esterno del piattino fissato sul carrello
- Introdurre l'asta e portarla a contattto con la battuta rotante più interna
- Campo di misura asta lavorabile: min 250 mm - max 2200 mm

Machining:
- *Place the override on the 1st notch*
- *Place the roller at the desired measure: the cutting measure is indicated in correspondence of the external index of the plate fixed on the roller*
- *Insert the rod and bring it to contact with the most internal rotating rebated*
- *Workable rod measuring field: min 250 mm - max 2200 mm*





Comall
Aluminium Machinery

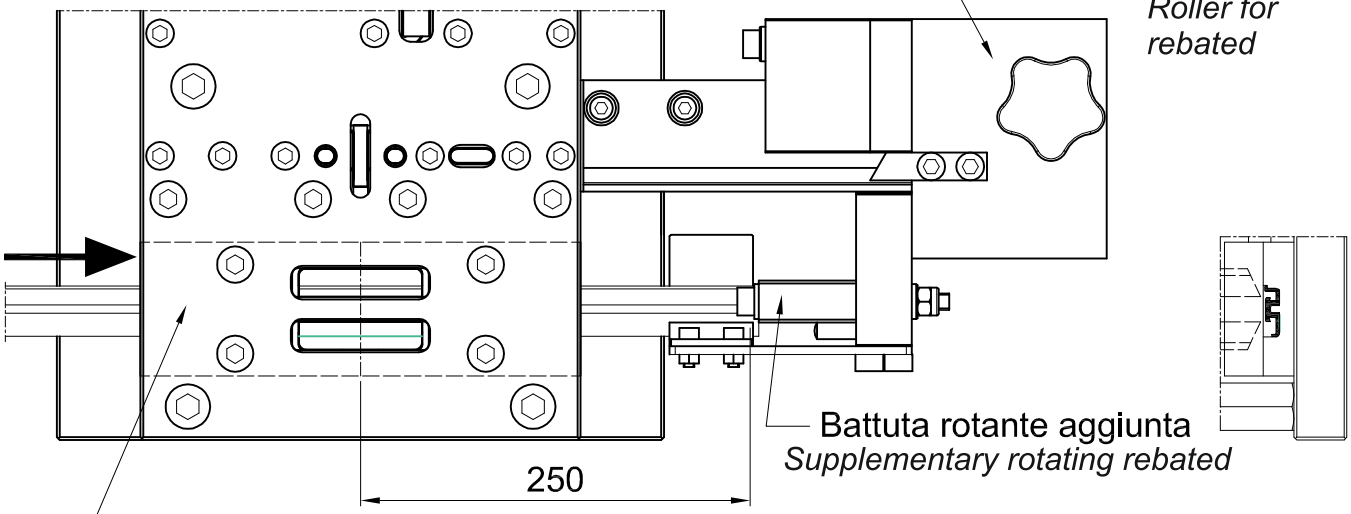
AV SAVIO

Codice - Code - Kode
ZPX14393

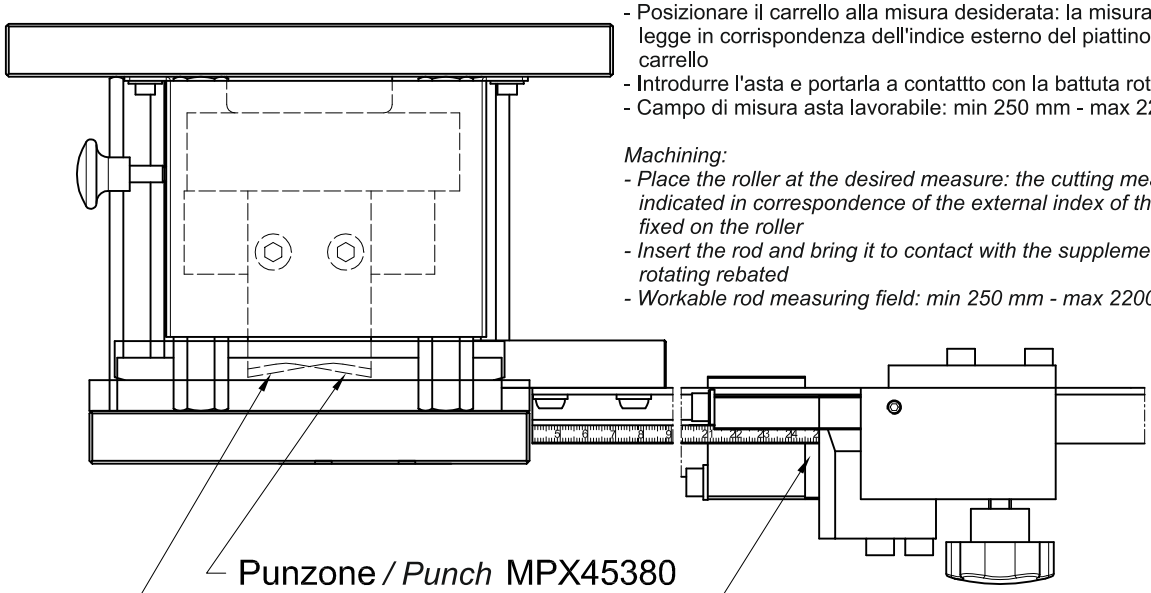
STAZIONE 4 KIT OPTIONAL : / *STAGE 4 OPTIONAL KIT:*

Asportazioni laterali contemporanee 44,2 x 3,8/5,2 mm

Contemporary lateral removals of 44.2x3.8/5.2 mm



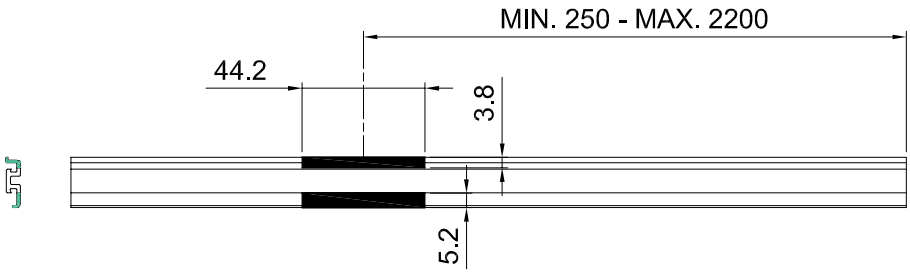
Matrice / *Matrix* MMX45230



Per eseguire la lavorazione:
- Posizionare il carrello alla misura desiderata: la misura di taglio si legge in corrispondenza dell'indice esterno del piattino fissato sul carrello
- Introdurre l'asta e portarla a contattto con la battuta rotante aggiunta
- Campo di misura asta lavorabile: min 250 mm - max 2200 mm

Machining:
- *Place the roller at the desired measure: the cutting measure is indicated in correspondence of the external index of the plate fixed on the roller*
- *Insert the rod and bring it to contact with the supplementary rotating rebated*
- *Workable rod measuring field: min 250 mm - max 2200 mm*

Lato lettura scala millimetrata
Es. : 250 mm.
Reading side for millimeter range
Ex: 250 mm

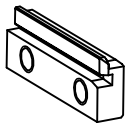
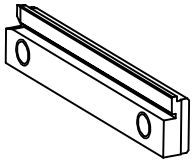
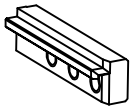
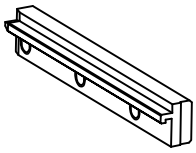
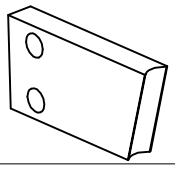
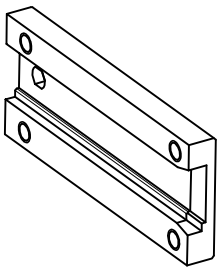
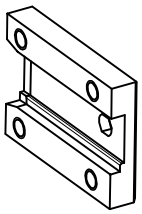
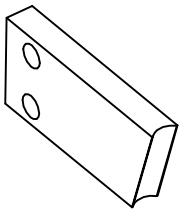
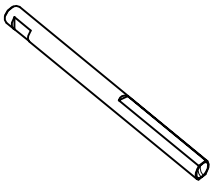


Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

PEZZI DI RICAMBIO *SPARE PARTS*

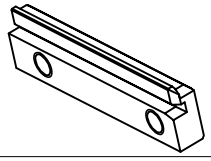
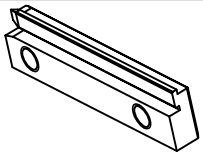
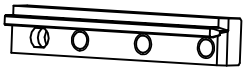
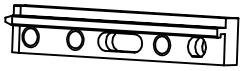
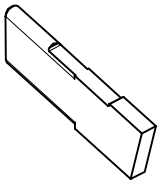
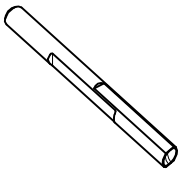
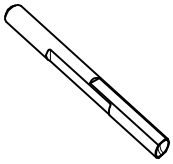
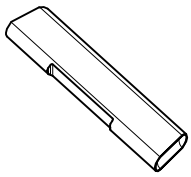
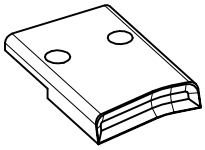
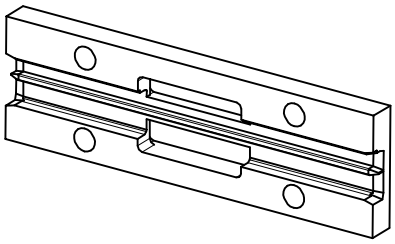
COD. *CODE*	DESCRIZIONE / *DESCRIPTION*	DISEGNO / *DRAWING*	STAZIONE *STAGE*
MMX45344	MATRICE INFERIORE ANTERIORE *FRONT LOWER MATRIX*		N° 1
MMX45345	MATRICE INFERIORE POSTERIORE *REAR LOWER MATRIX*		N° 1
MMX45346	MATRICE SUPERIORE ANTERIORE *FRONT UPPER MATRIX*		N° 1
MMX45347	MATRICE SUPERIORE POSTERIORE *REAR UPPER MATRIX*		N° 1
MPX45396	PUNZONE TAGLIO ASTA L = 68.8 *CUTTING ROD PUNCH L = 68.8*		N° 1
MMX45431	MATRICE ANTERIORE *FRONT MATRIX*		N° 2
MMX45432	MATRICE POSTERIORE *REAR MATRIX*		N° 2
MPX45397	PUNZONE TAGLIO ASTA L = 75 *CUTTING ROD PUNCH L = 75*		N° 2
MPX45427	PUNZONE ASOLA 6.2X5.2 *SLOT PUNCH 6.2 x 5.2*		N° 2

Comall
Aluminium Machinery

AV SAVIO

Codice - Code - Kode
ZPX14393

PEZZI DI RICAMBIO *SPARE PARTS*

COD. *CODE*	DESCRIZIONE / *DESCRIPTION*	DISEGNO / *DRAWING*	STAZIONE *STAGE*
MMX45350	MATRICE INFERIORE ANTERIORE *FRONT LOWER MATRIX*		N° 3
MMX45351	MATRICE INFERIORE POSTERIORE *REAR LOWER MATRIX*		N° 3
MMX45433	MATRICE SUPERIORE ANTERIORE *FRONT UPPER MATRIX*		N° 3
MMX45434	MATRICE SUPERIORE POSTERIORE *REAR UPPER MATRIX*		N° 3
MPX45399	PUNZONE TAGLIO ASTA *CUTTING ROD PUNCH*		N° 3
MPX45428	PUNZONE ASOLA 6.2X5.2 ANTERIORE L = 72.7 *FRONT SLOT 6.2 x 5.2 PUNCH L = 72.7*		N° 3
MPX45429	PUNZONE ASOLA 6.2X5.2 POSTERIORE L = 70.7 *REAR SLOT 6.2 x 5.2 PUNCH L = 70.7*		N° 3
MPX45402	PUNZONE ASOLA 15.4X5 *SLOT PUNCH 15.4 x 5*		N° 3
MPX45380	PUNZONE RASUTURA LATERALE *LATERAL SHAVING PUNCH*		N° 4
MMX45230	MATRICE RASATURE LATERALI *LATERAL SHAVING MATRIX*		N° 4

IMPORTANTE:
Il presente manuale d'uso – catalogo ricambi deve essere conservato unitamente alla punzonatrice.
Non si accettano ordini di ricambi se non identificati da: numero codice e numero matricola.
Consultare i riferimenti indicati nell'elenco particolari di ricambio.

Onde evitare errori nelle lavorazioni delle forature dove ci sono fermi registrabili, si richiede di eseguire una lavorazione per controllare l'esatta posizione dei fermi con l'accessorio che viene utilizzato.

"La Comall International non risponde per eventuali modifiche che l'estrusore apporta sui profilati delle serie esistenti, o per la introduzione di nuovi profilati nelle serie stesse"

IMPORTANT:
This operation manual – spares catalogue must be kept handy with machine.
Orders for spares will be accepted only if complete with: code number part number: check item ref. on chart (Spares list)

In order to avoid possible drilling errors where a template with adjustable clamping screws is being used, we recommend to operate once so as to check a possible run–out.

Comall International is not responsable for changes in profiles series made by

IMPORTANT:
Conserver le présent manuel d'utilisation – catalogue pièces de rechange avec la poinçonneuse.

Les commandés de pièces de rechange doivent mentionner: numéro de code–numéro de matricule (voir les références indiquées dans le tableau "liste des pièces de rechange") sinon elles ne seront pas acceptes.

Afin d'éviter toute erreur en phase de production en cas d'utilisation de butées réglables il est recommandé d'effectuer un usinage d'essai pour contrôler la position exacte des butées en effectuant un montage d'essai avec l'accessoire utilise.

Comall International ne répond pas des modifications qui pourraient être apportées sur les profiles des séries existantes ou pour l'introduction de nouveaux profiles dans les séries mêmes.

ACHTUNG:
Die vorliegende Bedienungsanweisung sowie der Ersatztellkatalog muessen zuasammer mit der Stanze aufbewahrt werden.
Es werden keineriel Ersaqtzteil – Bestellungen angenommen, wenn sie nicht von folgenden Daten begleitet werden: Codenummer und Matrikelnummer.
Bitte beachten sie dle Hinweise der Ersatzteil – Liste.

Um Fehler bel den Bohrarbeiten zu vermelden, empfiehit es sich ein Versuchsstueck zu fertigen, indem geprueft wird,ob die einstellbaren Spannzeugen richtlg angebracht worden sind.

Die Comall International uebernimmt keine Haftung fuer eventuelle Aenderungen, die Extrusionsfirma bei den Profilen der bisher bestehenden Serien hervorruft, oder fuer die Einfuehhrung von neuen profilen in dieselben Serien.

Comall
Aluminium Machinery
Via Salimbene Da Parma 4/C 42020 REGGIO EMILIA – ITALIA – Tel. 0522 549111 – Fax 0522 549115
E–mail: infocomall@comall.it – http: //www.comall.it