INTERNATIONAL SPECIALIST FOR SOLE MACHINES
SPECIALIZZATI IN MACCHINARI PER SUOLIFICI

EUROMARCHE

ITALIA
ORIGINAL

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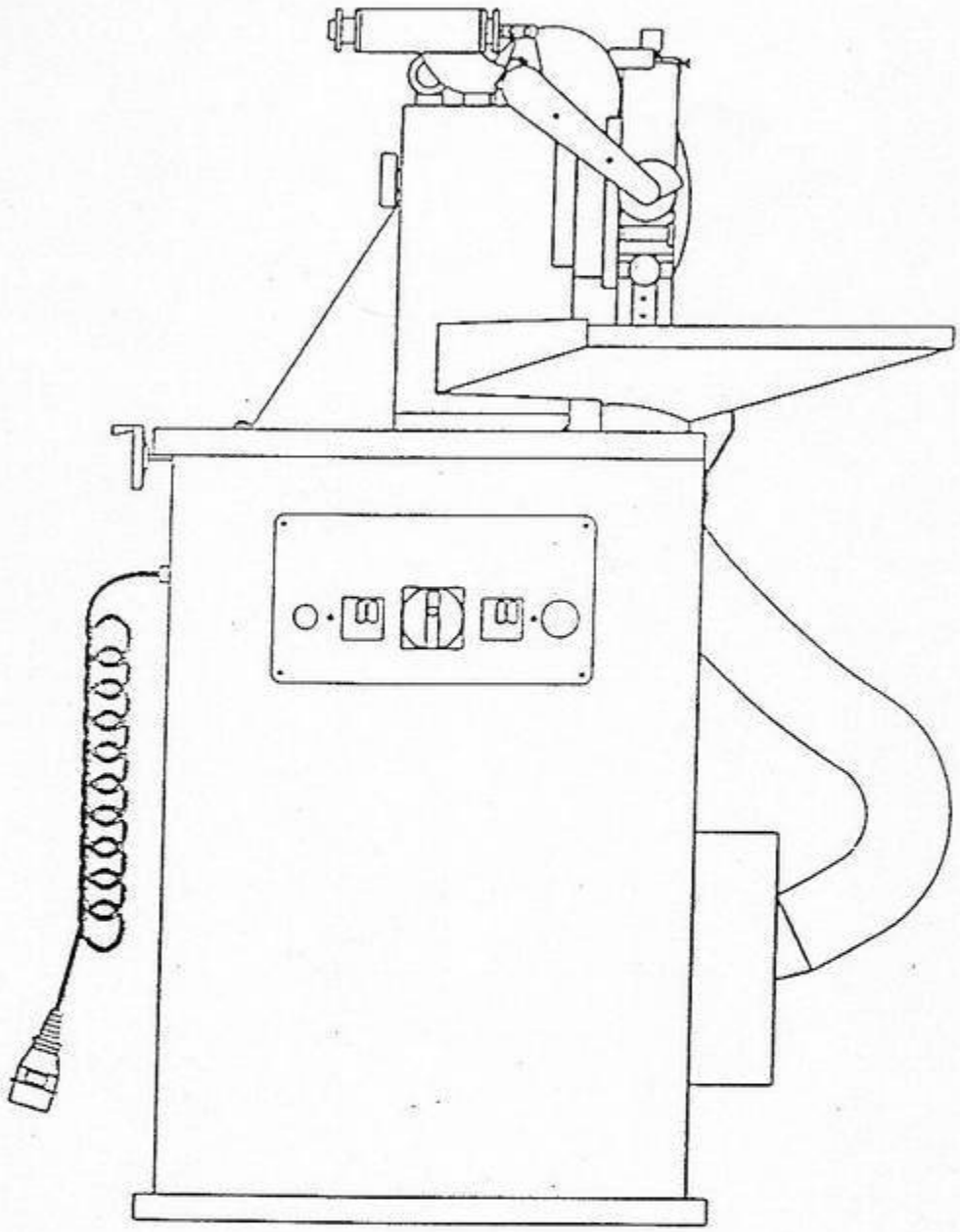
FRESATRICE PER SOTTOPIEDI , MOD. CGC Z11, NUOVA
INSOLE MILLING MACHINE , MOD. CGC Z11, NEW

CODE 006

INSTRUCTION HANDBOOK



COSTRUZIONE MACCHINE PER CALZATURE

Officina meccanica C.G.C. s.r.l.

VIA AGUZZAFAME 205 - 27029 VIGEVANO (PV) ITALIA
Tel. (0381) 40259 Fax (0381) 344801

MODEL: Z-11

SERIES: .....

SERIAL N°: .....

YEAR OF CONSTRUCTION: .....

WARNINGS

1) In paragraphs containing technical description, the location of various machine parts and accessories is always to be understood in relation to the control position.

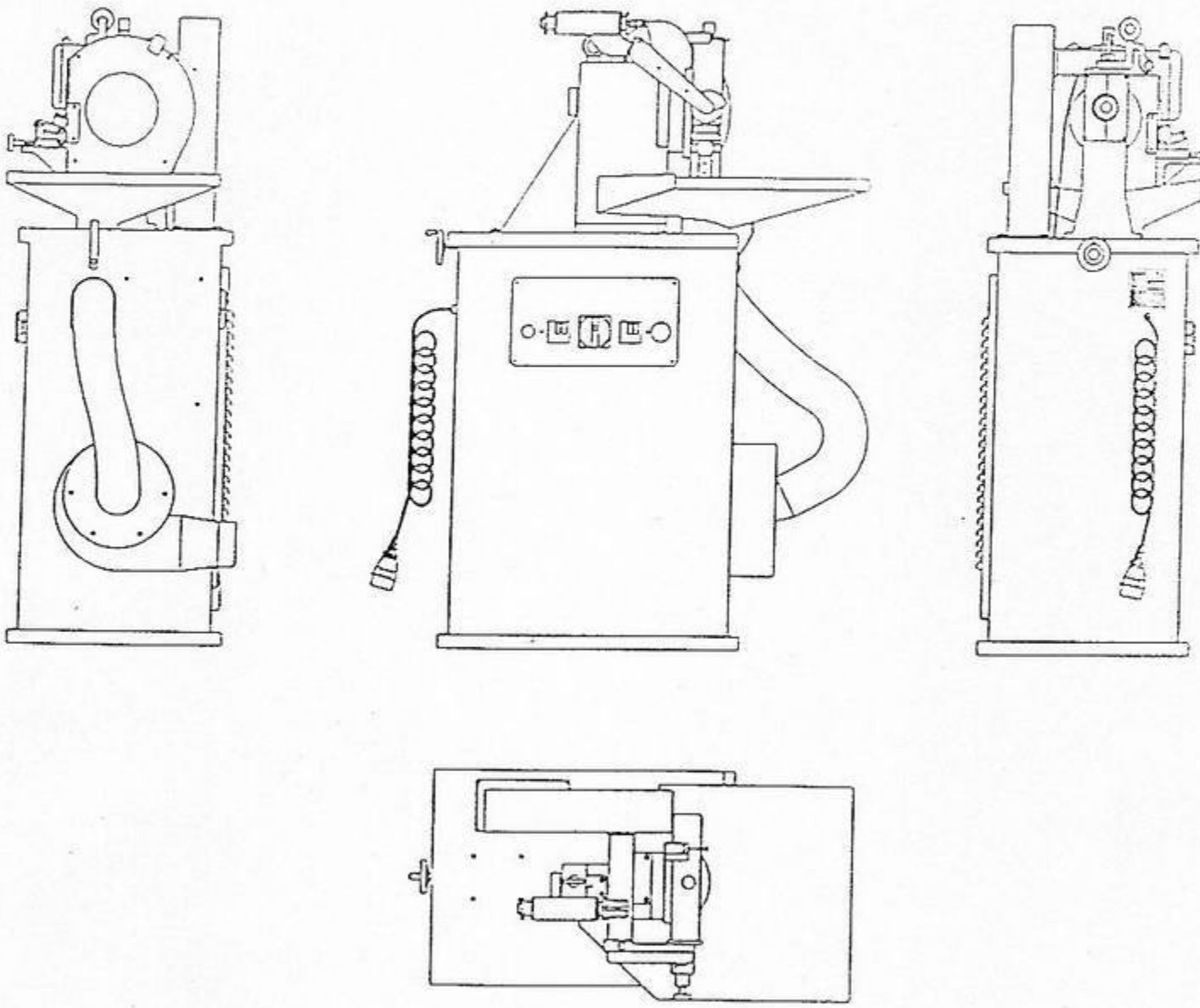
2) In paragraphs containing technical description, the appropriate technical term is used when referring to mechanical parts.

3) All the operations described in this manual must be carried out with the motor off, and only after the electric system has been properly disconnected, i.e., after the supply cable has been unplugged from the mains socket.

INDEX

1 - DESCRIPTION OF THE MACHINE

The machine mod. Z-11, built by **Officina meccanica C.G.C.**, is a milling machine, suitable for processing men's and women's insoles.
The machine is equipped with two three-phase asynchronous motors which power the milling disc and the conveyor of the insoles which are to be processed.
The machine operations are commanded by the electric control panel located on the front of the main upright. The machine has a frontal work station, and is designed to work in manual mode.



1.1 Safety guards and safety measures

The manufacturer has provided and fitted the following safety guards:

1- External fixed guard for the milling disc and the cover secured by cheese-headed hexagonal-slot screws.

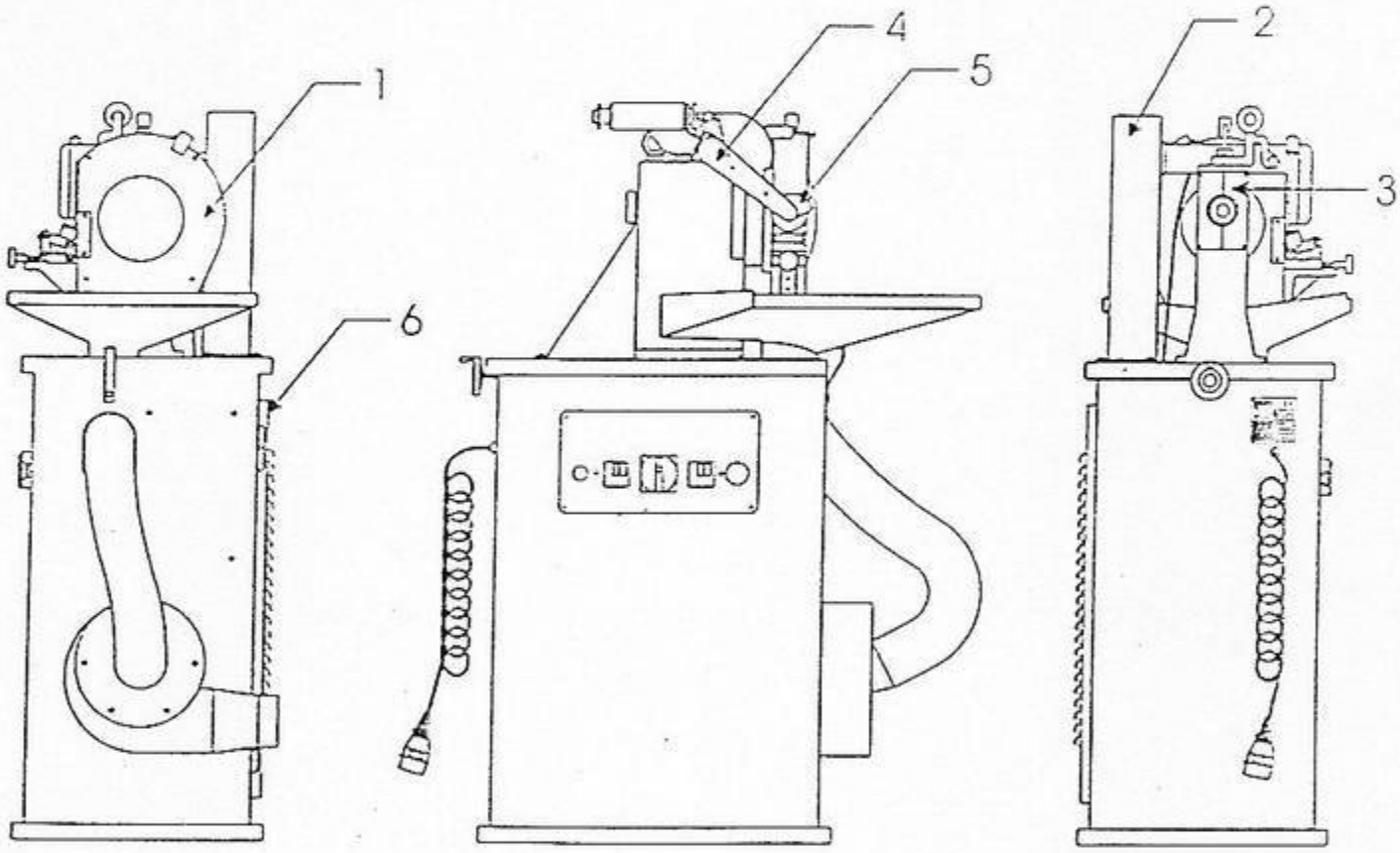
2- External fixed guard for the conveyor drive belt and the cover.

3- External fixed guards for the milling disc drive belt, secured by flathead hexagonal-slot screws.

4- External fixed guard for the gearing chain.

5- External fixed guard for the partial covering of the transport wheel.

6- External fixed guard, secured by a cheese-headed hexagonal-slot screw.



Warning:
The manufacturer has provided and fitted safety guards in order to ensure the safety of the operator while he is carrying out his duties.
When the machine is in operation, these protective guards must not be removed for any reason whatsoever.
Since it is not possible to mount devices in the area of the transport wheel to provide protection against eventual contact with the working area, the operator must pay full attention to what he is doing when operating the machine in the milling phase of the insole.

2. The Z-11: TECHNICAL DATA

FEATURES	TECHNICAL DATA
Width	930 mm
Depth	520 mm
Height	1400 mm
Weight	150 kg
Hourly production rate	5000 ÷ 6000 pairs / 8 hours
Control circuit	24 V
MOTOR FEATURES	**TECHNICAL DATA**
Electric cutter motor	Three-phase asyncronous
Power	1,5 HP ~ 1,3 KW
Speed of rotation	2900 rpm/min at 50 Hz
Protection rating	IP 55
Motor consumption	1,08 KW
Electric transport motor	Three-phase asyncronous
Power	1,25 HP
Rotation speed	1400 rpm at 50 Hz
Protection rating	IP 55
Motor consumption	0,18 KW

3 - CORRECT AND INCORRECT USE OF THE MACHINE

The machine mod. Z-11, built by Officina meccanica C.G.C., is designed to be used for the milling of men's and women's insoles.
If the machine is used for any purpose other than that for which it has been designed and built, such use is anomalous and, as well as putting the operator in serious danger, it is also liable to result in damage to the machine itself.

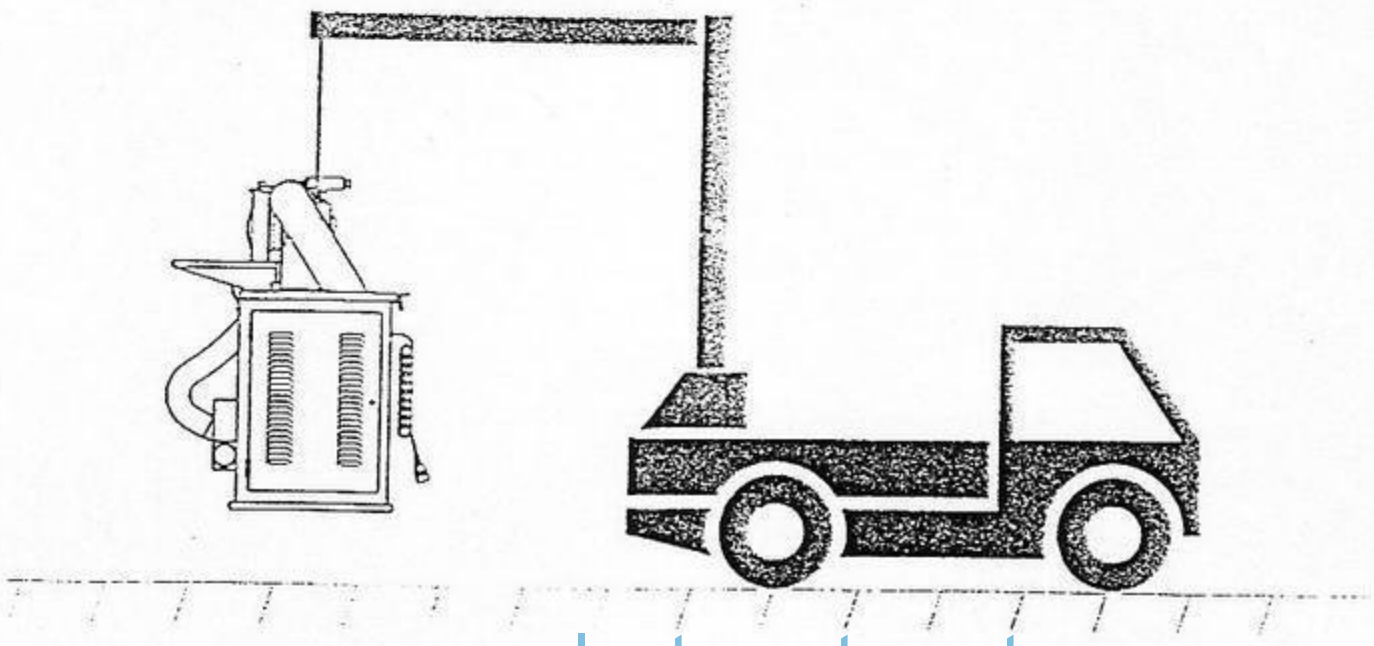
3.1 Contra-indications and dangers associated with incorrect use of the machine

- The control drives are set at the manufacturer's plant. The working cycle is tested several times before the machine is despatched to the user.

4 - HANDLING AND TRANSPORTATION OF THE MACHINE

Providing a support pallet is first secured to the machine base, the milling machine, mod. Z-11, can be moved by fork-lift truck. The machine must only be moved by an expert operator, assisted by a second machine handler who, on the ground, must ensure that there are no obstacles in the area across which the machine is to be moved.

Lifting cables (of adequate size) can be used for lifting and handling operations. These cables must be connected to the hook of a small crane, driven by an expert crane operator. A machine handler must check that the machine will not, during transportation, be impeded by obstacles which the crane operator is unable to see, due to the dimensions of the machine itself.



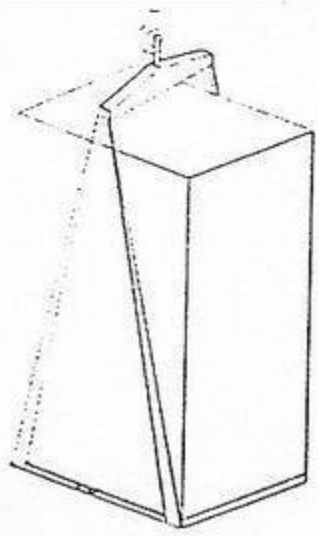
Warnings:

1) If the milling machine is shipped packed in a case or wooden crate, the packaged machine must be properly slung before being handled or moved.

2) In order to remove all risk of injury to staff during the movement of the suspended load, make sure that no one enters the area across which the crane or forklift truck is to travel.

3) It is advisable, especially if the machine is to be shipped by sea, in a case or crate, to place bags of hygroscopic salt in the case or crate; it is also advisable to protect the machine parts with protective anti-rust paint.

4) The machine must be secured to the support pallet. In order to do this, 4 threaded M10 holes have been bored into the machine base.

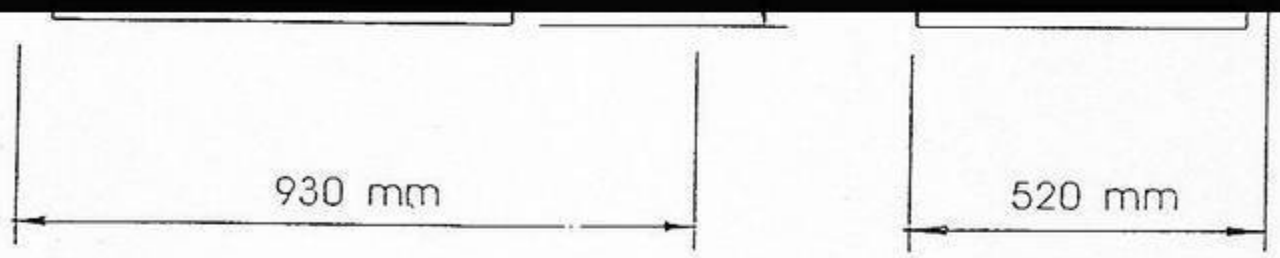


5 - INSTALLING THE MACHINE

Attention: the place where the machine is installed must - in order to reduce tothe minimum the possibility of fatigue and to allow the operator to work in conditions of maximum safety - be one which presents optimal heat and humidity conditions for the well-being of the operator.

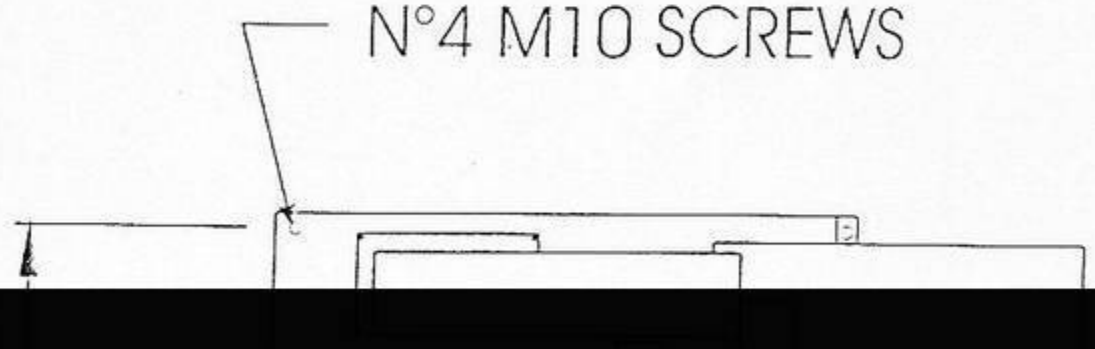
5.1 Machine dimensions

The dimensions of the machine mod. Z-11 are given in the diagram.



5.2 Surface supporting the machine

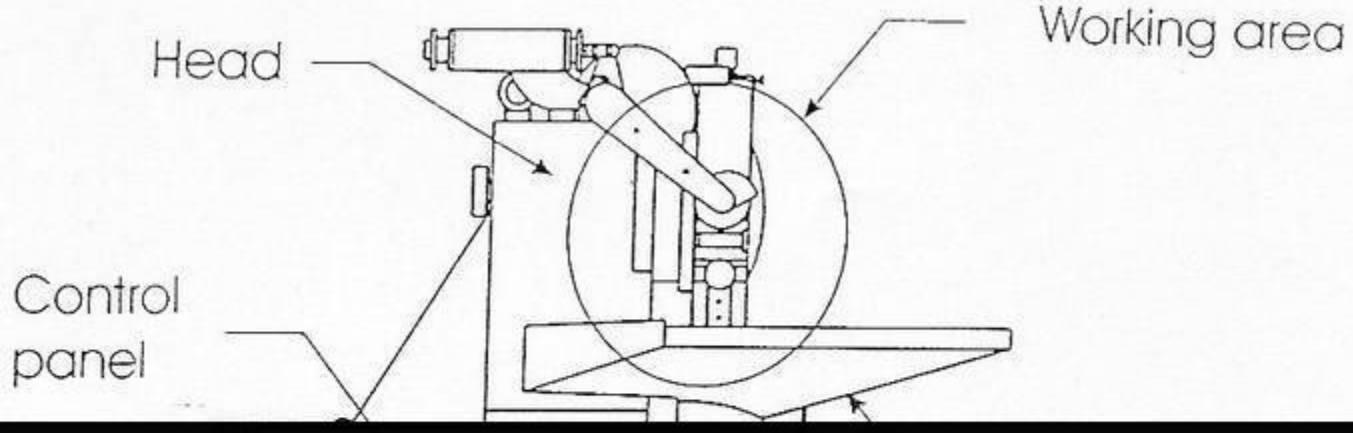
The machine does not need to be anchored to the floor.



Warning:

1) In order to ensure correct working, use the four M10 adjustment screws (for levelling the machine) located on the base of the upright to obtain perfect adhesion to the floor.

5.3 Front-on view of the Z-11: main machine references



5.4 Clearances to respect

In order to ensure that the machine can be used correctly, and to facilitate maintenance operations on the machine, it should be installed in a position in which the minimum clearance distances, shown in the diagram, are respected:

6 - MACHINE ASSEMBLY AND PREPARATION FOR USE

6.1 Assembling the accessories

The machine is fully assembled at the manufacturer's plant. The user is not required to assemble any particular auxiliary group.

6.2 Preventive checks

Upon receipt of the machine, it is advisable :

- to check that all the parts comprising the machine have, indeed, been sent to the user's plant

1) Always wear protective gloves and use a dry cloth to clean the machine.

2) The operations described above must only be carried out after the electric system has been properly disconnected, i.e., after the supply cable has been unplugged from the mains socket.

6.3 Connecting the machine with the external energy supply

6.3.1 Connecting up the electrical energy supply

The machine comes with a 4-metre electrical supply cable and plug.
The connection of the machine must only be done by an expert operator.
The frequency and supply voltages for which the machine is intended, are indicated on the special plate located on the left side of the machine upright.

Warnings:

1) It is advisable to use safety switches (magneto-thermal switches) to protect the user's mains against possible overloading.

2) If the machine supply voltage and the mains voltage are not the same, it will be necessary to change the terminal connections of the transformer and of the motor.

IMPORTANT: to carry out this operation, disconnect the electric system, removing the supply plug from the mains socket.

6.4 Checks, adjustments and settings

6.4.1 Checking the direction of motor rotation

The correct direction of rotation is shown on the two stickers on the upper part of the external fixed guard (see Fig. A).

To carry out this check, proceed as follows:

1) Turn the MAIN SWITCH to position 1; (see par. 7.1)
2) Press the buttons which activate the transport and the milling: the machine is now live and the electric motors starts up and causes the milling disc and the transport wheel to rotate (see par. 7.1).

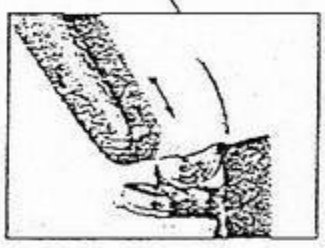
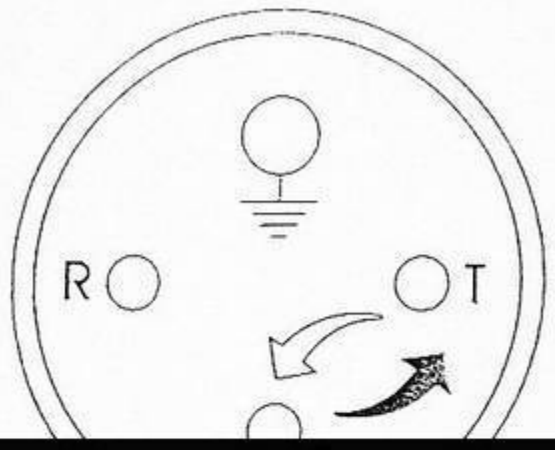


FIG. A

If the disc is not rotating in the correct direction, two phase wires in the electric plug of the main supply cable will have to be reversed.



6.4.2 Motor belt tension of the milling disc

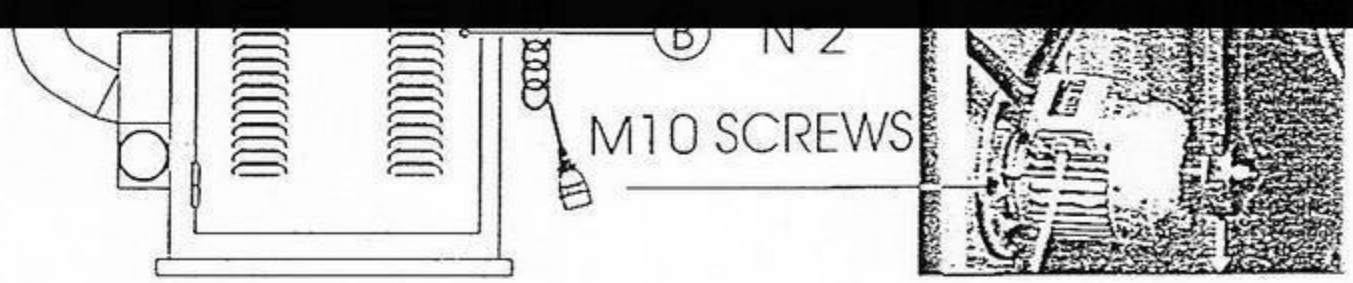
Adjusting the tension of the motor belt.

Attention: the tension of the motor belt should be checked at least once every six months.

The belt which, through two pulleys, drives the milling disc is a flat belt type LA250. This adjustment must be carried out in order to achieve the correct working tension.

The adjustment should be carried out as described below:

- turn the MAIN SWITCH TO POSITION 0;



Warning:
If, for any reason, the belt breaks or has to be replaced, specially trained personnel must be called.

6.4.3 Adjusting the spring tension

This adjustment operation enables you to subject the insole to more or less pressure from the transport wheel.

Having turned off, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the ring nut (A);
- loosen the ring nut (B) to reduce spring tension; continue loosening the ring nut until the required tension is achieved;
- tighten the blocking ring nut (A).

6.4.4 Adjusting the height of the transport wheel

This adjustment enables you to achieve the ideal height for transport action of the insole which is to be processed.

Having switched off the machine, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the blocking ring nut (C);
- loosen the ring nut (D) to reduce the space between the transport wheel and the dragging wheel;
- having completed the adjustment, tighten the ring nut (C).

6.4.5 Adjusting the transport action speed

This adjustment enables you to increase or reduce the transport speed.

Having turned on the machine, proceed as follows:

- turn the MAIN SWITCH TO POSITION 1;
- turn the handwheel (A) towards higher values (see plate) to increase the transport action speed;
- turn the handwheel (A) towards lower values (see plate) to reduce the transport action speed.

6.4.6 Adjusting the milling angle

This adjustment enables you to increase or reduce the insole milling angle.

Having switched off the machine, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the two hexagonal-head screws (A);
- set the required milling angle using the scale on the plate (B);
- once you have achieved the required saddle angle, tighten the socket-head screws (A).

6.4.7 Adjusting the milling distance

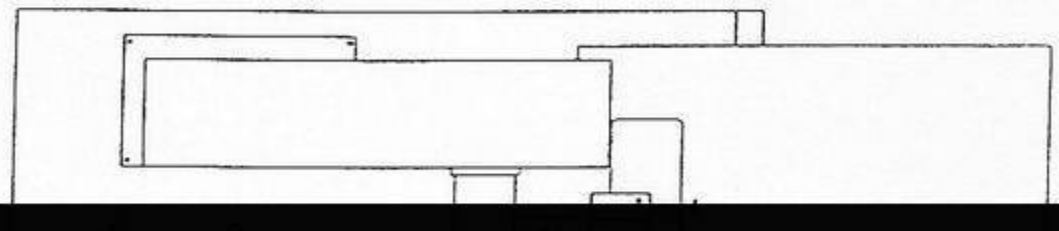
This adjustment is carried out in order to obtain a greater or lesser degree of the milling on the insole.

Having switched off the machine, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the socket-head fixing screw (C);
- turn the pawl (D) in an anti-clockwise direction to reduce the milling distance;
- turn the pawl (D) in a clockwise direction to increase the milling distance;
- having achieved the required milling distance, tighten the socket-head screw (C).

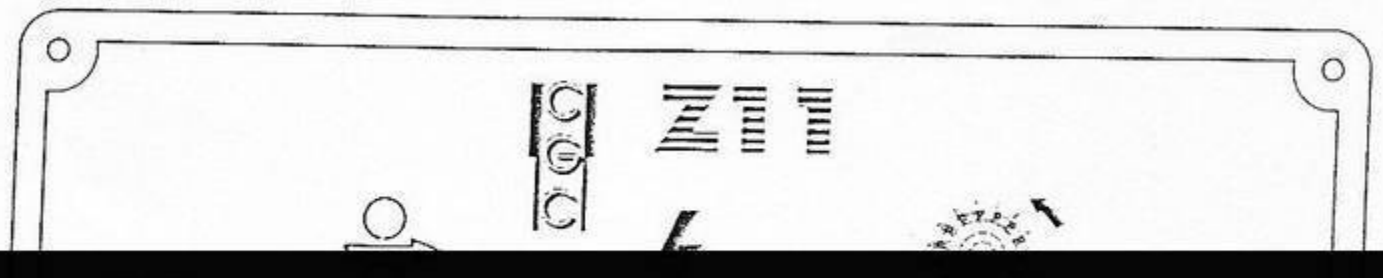
7 - PUTTING THE MACHINE INTO OPERATION

The machine's control and work station is located opposite the user.
To ensure its good working and long life, the machine mod. Z-11, should only be used by specially-trained operators.



7.1 Electrical control panel

The electrical control panel is located in the work station, on the front of the machine upright i. It is secured by screws.



In panel 1 are the following controls:

1) START BUTTON (NOT IN EXTRA-CEE VERSION)

2) REDUCER MOTOR SERVOMOTOR
When the button 1 is pressed, the reducer motor begins to rotate

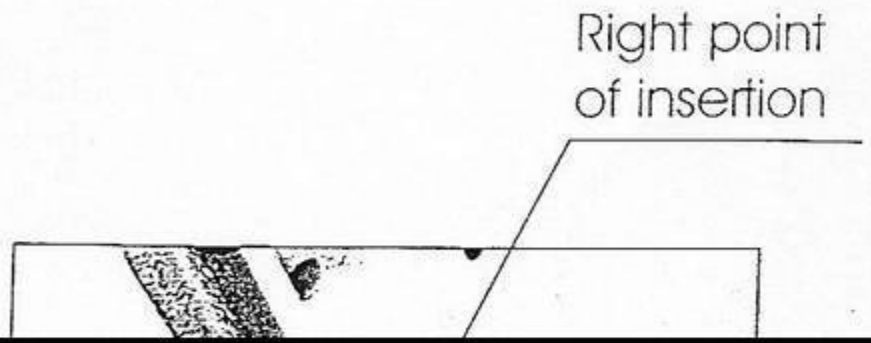
3) MAIN SWITCH (2-position switch)
when the switch is turned to position 1, the electric system of the machine is fed.

4) MILLING MOTOR SERVOMOTOR
When the button 1 is pressed, the cutter motor begins to rotate.

5) EMERGENCY BUTTON WITH SAFETY DEVICE - RED PUSH BUTTON
When the red push button is pressed the electric supply is cut off and the motor stops
(NOT IN EXTRA-CEE VERSION)

7.2 Positioning the material for processing

The material which is to be processed is placed between the dragging wheel and the transport wheel as shown in the picture:



8 - USING MACHINE MOD. Z-11

8.1 Description of the working cycle: actions and consequences

The working cycle is as follows:

1) Turn the MAIN SWITCH (located on the control panel on the front of the machine upright) to position 1. The machine is now live.

2) Turn the two servo-motors (located on the control panel on the front of the machine upright) to position 1 to set the motors running.

3) Press the START button to set the motors running.

DOCUMENT... ...NTO ELETTRICO

TECHNIC... ...CTRIC PLANT

PRIMA PAGINA

descrizione impianto : FRESATRICE

Nr. Rev. : 01

Tot. Fogli 4

Foglio Nr. 1

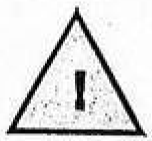
COMMITTENTE
CLIENTE
COMMESSA N.
MATRICOLA
SOFTWARE

'' COMMITTE...

via Agua...

DOCUMENTAZIONE TECNICA - IMPIANT [redacted]

PRECAUZIONI ED AVVERT [redacted]



- Prima dell'installazione [redacted] uzioni ed avvertenze di sicurezza riportate sul manuale d'uso e tutt [redacted]
- L'allacciamento e l'avvi [redacted] zzato.
- L'impianto comporta te [redacted] pericolosità. In caso di mancata osservanza delle istruzio [redacted] nni alla persona, anche fatali ,ed alle proprietà.
- Ogni intervento di ripara [redacted] solo da personale specializzato, e solo dopo che sia messo al co [redacted] enuti nel manuale riguardanti il funzionamento e la man [redacted]
- La manomissione e la m [redacted] nell'impianto, oltre a far decadere qualsiasi tipo di garanzia [redacted] danni alla persona, anche fatali, ed alle proprietà.
- Le apparecchiature e i co [redacted] stesse caratteristiche, facendo riferimento alla lista parti, fornita as [redacted]
- La presenza di apparecch [redacted] cciamento di rete alla macchina, di interruttori automatici di [redacted] stesso eroga durante il suo normale funzionamento.
- Tenere la presente docu [redacted] re una copia il personale addetto.
- L'equipaggiamento elett [redacted] i di funzionamento specificate, secondo EN 60204 - 1 (4.4 - 4.4. [redacted]

- Vietare ai bambini e a [redacted]
- L'uso dell'impianto e q [redacted] ndicato nello schema elettrico.
- Modifiche non autorizz [redacted] nsigliati dal fabbricante dell'impianto stesso potrebbe causare [redacted] à decadere qualsiasi tipo di responsabilità e garanz [redacted]

" COMMITTENTE " [redacted]

C.[redacted]

via Aguzzafa [redacted]

AVVERTENZE E PRECAUZIONI

descrizione Impianto : FRESATRICE	Tot. fogli
Nr. Rev. : 01	Foglio Nr.

DOCUMENTAZIONE TECNICA - IMPIA

DATI TECNICI

POTENZA INSTALLATA (kW)
TENSIONE DI ALIMENTAZIONE (V
FREQUENZA (Hz)
N.ro FASI
CONNESSIONE AL CONDUTTORE
SEZIONE CAVI DI ALIMENTAZION
ASSORBIMENTO (A)
INTERRUTTORE CONSIGLIATO DA INSTA
DEI CAVI DI ALIMENTAZIONE :
POTERE D'INTERRUZIONE
CORRENTE NOMINALE
SENSIBILITA'

…AZIONI

…O DI INTERVENTO INGIUSTIFICATO
…NTERRUTTORE DIFFERENZIALE SOSTITUIRE
…SSO CON UNO DI TIPO B O DI SENSIBILITA'
…ORE (0.3A)

CIRCUITO	COLORE
TERRA	…LO-VERDE
NEUTRO	…O
POTENZA C.A.	
POTENZA C.C.	
ILLUMINAZIONE	
SERVIZI	
AUSILIARI C.A.	
AUSILIARI C.C.	
ALIMENTAZIONE C.N.C.	

" COMMITTENTE

C.

via Aguzza

DATI TECNICI

descrizione Impianto : FRESATRICE

Nr. Rev. : 01

Tot. Fogli 4

Foglio Nr.

8 - USING MACHINE MOD. Z-11

8.1 Description of the working cycle: actions and consequences

The working cycle is as follows:

1) Turn the MAIN SWITCH (located on the control panel on the front of the machine upright) to position 1. The machine is now live.

2) Turn the two servo-motors (located on the control panel on the front of the machine upright) to position 1 to set the motors running.

3) Press the START button to set the motors running.

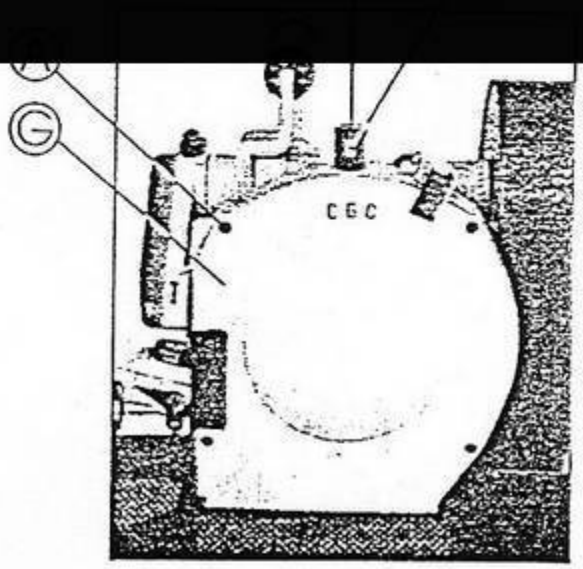
9 - REPLACEMENT OPERATIONS

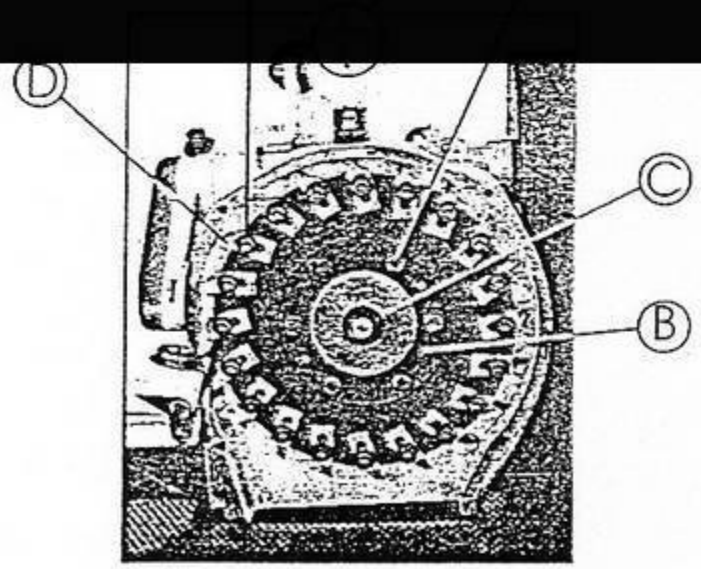
9.1 Replacing the knives

The knives should be replaced whenever they appear worn.

Proceed as follows to replace the knives:

- turn the MAIN SWITCH TO POSITION 0;
- slide off the external fixed protective cover (G) first loosening the four cylindrical-head hexagonal-slot screws (A);
- loosen the hexagonal-head screws (H) on the disc (B);
- slide the disc (B) off the flange (C);



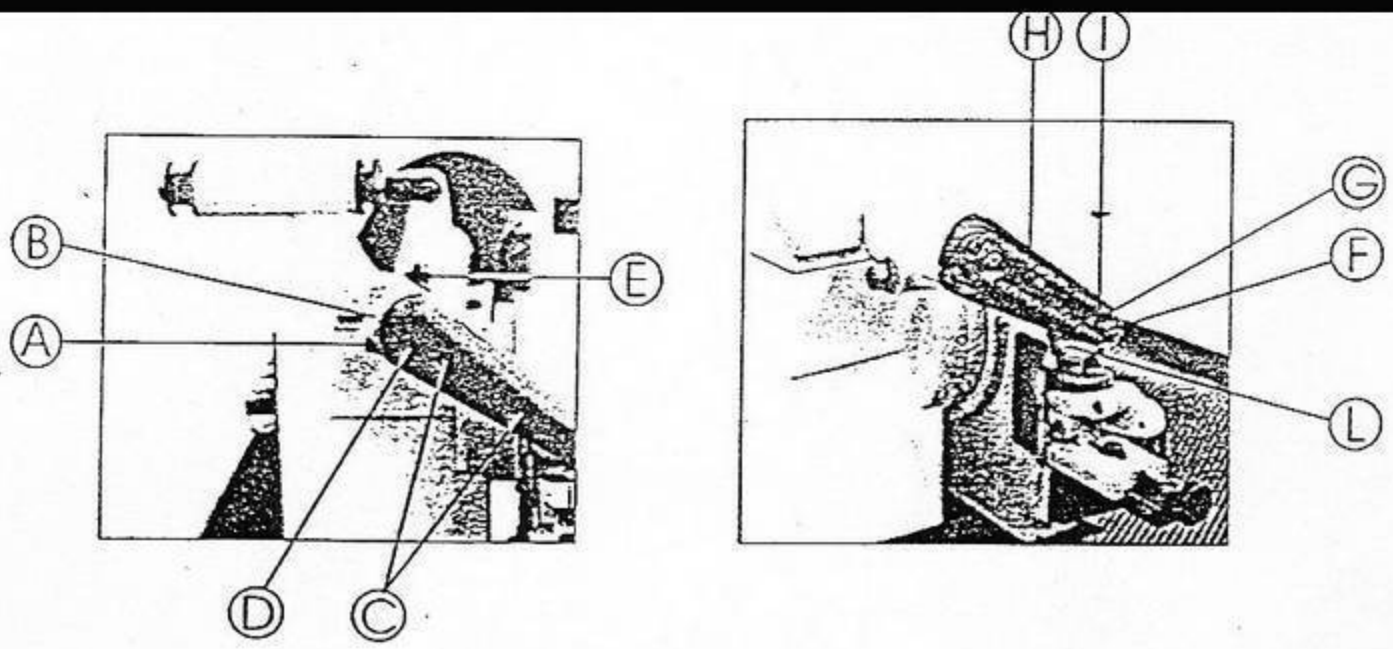


9.2 Replacing the transport wheel

This wheel should be replaced whenever it appears worn.

To replace the transport wheel, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the fixing nut (A);
- lift the transport arm (B);
- tighten the fixing nut (A) fully;
- loosen the two socket-head screws (C);
- remove the cover (D);
- loosen the nut (E);
- turn the transport arm (B) gently in an anti-clockwise direction in order to reduce the chain tension (G);



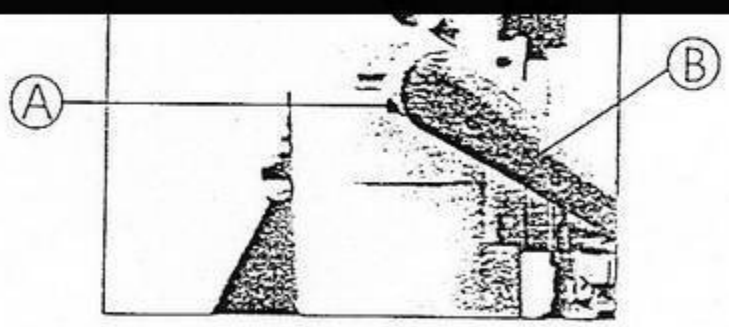
9.3 Replacing the chain and the gears

The chain and the gears should be replaced whenever they appear worn or are not functioning efficiently.
To replace the chain and the gears follow the procedure described in paragraph 9.2.

9.4 Replacing the dragging wheel

The dragging wheel should be replaced whenever it appears worn or if a different type of dragging wheel is needed.

To replace the dragging wheel, proceed as follows:

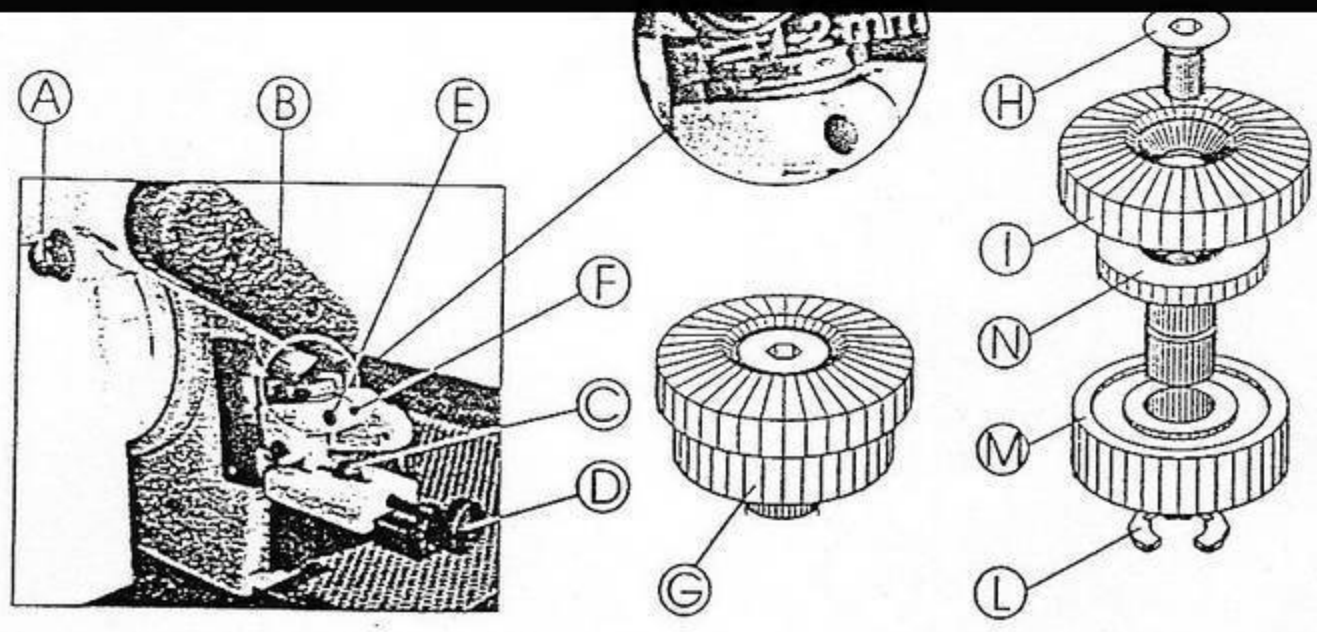


9.5 Replacing the dragging wheel holder and the bearing

The dragging wheel holder and the bearing should be replaced whenever either of these parts appears worn.

To replace the dragging wheel holder and the bearing, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- loosen the nut (A);
- lift the transport arm (B);
- screw in the nut (A) again;
- loosen the hexagonal-head screw (C);
- turn the pawl (D) in a clockwise direction to push the saddle backwards;
- unscrew the cheese-headed hexagonal slot screw (E);



9.6 Replacing the slide

The slide should be replaced whenever it appears worn.

To replace the slide, proceed as follows:

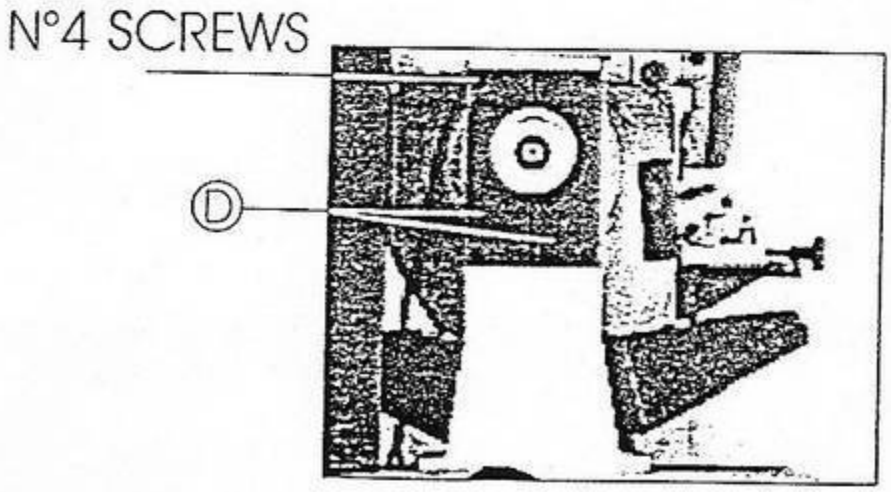
- turn the MAIN SWITCH TO POSITION 0;
- unscrew the socket-head screw (A);
- move the saddle away from the cutter by turning the pawl (B), now slide out the saddle (D);
- loosen the two socket-head slide (D) fixing screws (C);
- pull the slide (D) out of its housing and replace it;
- screw in the two socket-head slide fixing screws (C);
- position the saddle on the special slide;

9.7 Replacing the flat belt

The flat belt should be replaced whenever it appears worn.

To replace the flat belt, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- unscrew the socket-head screw (B) to open the rear protective cover (A);
- loosen the two M10 cheese-headed hexagonal-slot screws which secure the milling disc motor;
- extract the belt (C) from the motor pulley;
- unscrew the four socket-head screws located on the two sections of the cover (D) which protects the belt;
- remove the two sections of the protective cover (D);
- slide the belt out through this opening and replace it;

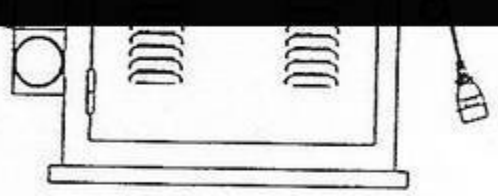


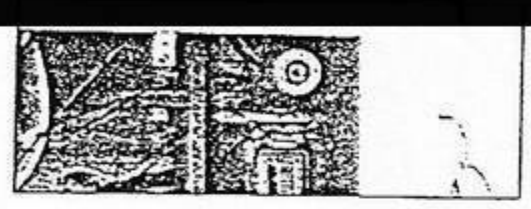
9.8 Replacing the V-belt

The V-belt should be replaced whenever it appears worn.

To replace the V-belt, proceed as follows:

- turn the MAIN SWITCH TO POSITION 0;
- turn the handwheel (A) towards the lower values (see plate) to increase the transport speed;
- loosen the five socket-head screws (B);
- slide off the protective cover (C);
- loosen the socket-head screw (E) to open the rear cover (D);
- grip the belt (F) on both sides and pull it upwards so as to detach it from the pulley;
- position the belt and pull it upwards to attach it to the pulley;





WARNING: all replacement operations must be carried out by qualified staff.

10 - ACCESSORY DEVICES

10.1 Sharpener, mod. Z, patented

The Z sharpener is used to sharpen the knives whenever they appear worn, with no need for disassembling the disc and the knives.

10.1.1 Technical features of the sharpener, mod. Z

FEATURES	TECHNICAL DATA
[illegible]	[illegible]
[illegible]	[illegible]
[illegible]	[illegible]

Operation	Machine part	Frequency
Visual check	electrical connections	weekly
Check	correct working of the servomotors	each time you start working
Check	correct working of the emergency button	each time you start working

11.2 Operations to be carried out only by the manufacturer's specially-trained personnel

The maintenance operations listed below require specialist knowledge and must, therefore, only be carried out by personnel specially trained by the manufacturer.

The user must never, for any reason whatsoever, do the following:

- replace or repair any of the mechanical drive parts;
- replace electrical parts;
- open the electrical control panel or carry out operations on the wiring;
- replace the belt;
- replace the knives and the disc;
- replace the transport wheel;

connected up.

3) **Fault**
Strange noises can be heard while the machine is running
Remedy
Check to see whether the bearings need replacing
Cause
Faulty or worn bearings

11.4 Parts subject to wear and replacement

Quantity	Machine part	Life expectancy (in years)
20	knives	6 months
1	dragging wheel	1
1	slide	1
1	transport wheel	4 - 6 months
1	bearing	2 - 4
2	bearing	2 - 4
1	chain	1
2	gears	1

11.5 Parts supplied with the machine mod. Z-11

Quantity	Machine part
4	10x20 M socket-head screw with nut
1	380 V 16A 4P Ilme mobile plug
1	3 socket-head wrench
1	4 socket-head wrench
1	5 socket-head wrench
1	6 socket-head wrench
1	8 socket-head wrench
1	17-19 flat wrench
1	10-13 flat wrench
1	centesimal comparator

12 - DISMANTLING THE MACHINE Z-11

Should it be necessary, for any reason, to put the machine out of service and dismantle it, always observe the following rules (designed to protect public health and the environment):

- remove from the machine even the smallest traces of oil and grease; lubricants must not be disposed of in the environment. They should, rather, be reclaimed or treated by a company which specialises in the disposal of these products;

- sheaths, flexible tubes and plastic (or non-metallic) components must be dismantled and disposed of separately;

- provided they are in good condition, electrical components (switches, transformers etc.) must be taken apart and reused, otherwise, if possible, they must be reconditioned and recycled;

- the machine frame and all the metallic parts of the machine must be taken apart and sorted according to material type. The various parts can then be demolished and melted down so that the material from which the machine was built can be recycled.

13 - *MAIN INSTRUCTIONS AND WARNINGS*

1) The manufacturer has provided and fitted safety guards in order to ensure the safety of the operator while he is carrying out his duties.
When the machine is in operation, these protective guards must not be removed for any reason whatsoever.

2) In order to stop the work cycle instantaneously at any time, press the red EMERGENCY button, located on the panel board on the front of the machine upright. This button cuts off the power supply to the motor and activates the pounding disc blocking device.
To restore normal working conditions, turn the red button in an anti-clockwise direction; the blocking device of the button will be released and it will return to its rest position.

3) Since it is not possible to mount devices in the area of the transport wheel to provide protection against eventual contact with the working area, the operator must pay full attention to what he is doing when operating the machine in the milling phase.

4) The user is strictly forbidden to replace the original drive pulley with one which has a bigger diameter. The original drive pulley is of the correct size to grant optimal working of the machine and to reach a working speed which enables the operator to work in maximum safety.

5) The place where the machine is installed must - in order to reduce to the minimum the possibility of fatigue and to allow the operator to work in conditions of maximum safety - be one which presents optimal heat and humidity conditions for the well-being of the operator.

6) If the machine is placed on a pallet and shipped packed in a case or wooden crate, the packaged machine must be properly slung before being handled or moved.

7) In order to remove all risk of injury to staff during the movement of the suspended load, make sure that no one enters the area across which the crane or forklift truck is to travel.

8) It is advisable, especially if the machine is to be shipped by sea, in a case or crate, to place bags of hygroscopic salt in the crate/case; it is also advisable to protect the machine parts with protective anti-rust paint.

9) If a small crane is used to lift or move the machine, in order to ensure maximum safety, the diameter of the lifting ropes must be sufficient to carry the weight of the machine + the weight of the case or crate.

10) If the machine supply voltage and the mains voltage are not the same, it will be necessary to change the connections to the terminal board of the two motors.

11) Adjustments and replacement operations must be carried out only after the machine has been stopped (MAIN SWITCH TURNED TO POSITION 0) and, if necessary, after the electrical supply cable plug has been removed from the mains socket

14 - GENERAL INFORMATION

A single copy of this instruction manual is supplied with the machine at the moment of purchase.
Any additional copies required must be ordered and purchased separately from the manufacturer.

This manual is intended to be consulted by the machine user or by machine maintenance personnel, or by the technician to whom these functions (including installation of the machine) are assigned.
The instructions contained in this manual must be read and followed carefully. Before starting up the machine, make sure that the indications given on the plates located on the machine have been respected.

In order to use this machine, staff must be specially trained and have acquired sufficient experience operating machines of this type. Always respect the indications contained in the user's manual as well as any specific regulations in force in the country in which the machine is to be installed.

The user's manual constitutes an integral part of the machine and has a function as crucial as that of any mechanical, electrical component, etc. It must be kept, (in good condition and available for consultation at any time), as part of the equipment of the machine. As this manual reflects the configuration of the machine at the time of its sale, it can no longer be considered valid or applicable if the machine is subsequently updated or improved.

Reserving the right, without warning, to update both this machine and this catalogue, the manufacturer is willing to consider remarks and suggestions for improvement of the machine, without however, being under any obligation to update machines or manuals already produced.
Spare parts can be ordered from the manufacturer by quoting the machine identification references given in the coupon.

The manufacturer will accept no responsibility for the consequences of failure to observe any of these precautionary procedures.

SPARE PART ORDER FORM (Facsimile to be photocopied, filled in and sent to the manufacturer)

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* Machine type .....

* Machine serial n°.....

* Part code n° .....

* Description.....

* Quantity required.....

* Machine connected to.....Frequency.....

* Catalogue edition (code n°).....