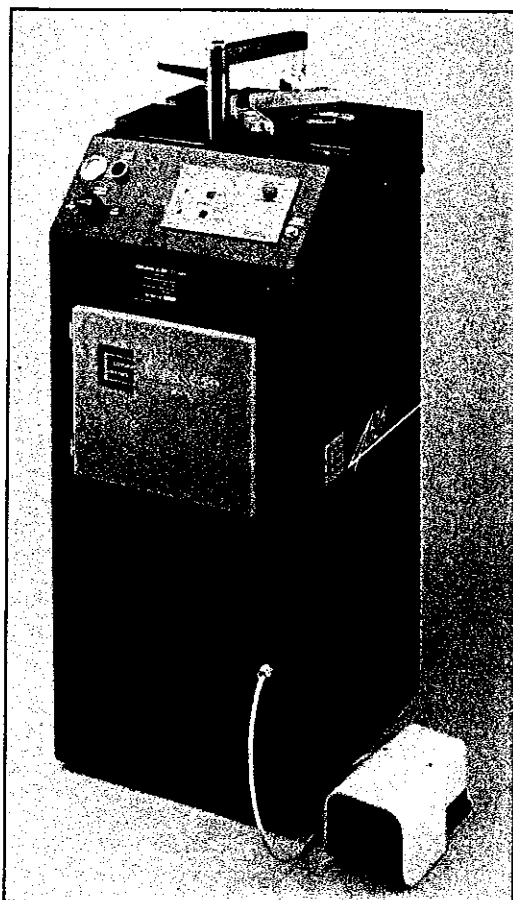


ECassese®
Quality for the world

CS 486



OPERATING & TECHNICAL MANUAL

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INTRODUCTION



I - INTRODUCTION

You have just purchased a CS 486. We thank you for your choice and for the confidence you have placed in our Company.

The CS 486 benefits from the experience of joiners which have made Cassese's reputation. It allows mouldings of any shape to be joined (Patent # 7522814)

The CS 486 is designed to allow the operator to move completely around the machine.

Joining is carried out by metal wedges specially designed for perfect clamping.

IMPORTANT: Do not use other cartridges except genuine Cassese ones (CS Registered Trademark)

II - ACCESSORIES (provided with the machine)

- 135° shims for eight-sided frames
- Spacer bars for small mouldings
- 1 triangle holder with : 1 black triangle (hardwoods), 1 white triangle (soft woods)
- 1 elastomer holder with, according to the shape of the mouldings: 1 green elastomer adaptor for hardwoods (with a height of 45 mm), 2 orange elastomer adaptors for soft woods (with heights of 45 & 30 mm).
- 1 spare hammer
- 1 tube of grease
- 1 quick coupling for compressed air
- 1 3 mm Allen wrench
- 1 tool for putting wedges back into the cartridge

III - SPECIFICATIONS

- Minimum moulding width: 5 mm; maximum: 130 mm
- Minimum moulding height: 7 mm; maximum: 90 mm
- Minimum frame dimensions: 85 mm X 85 mm X ***
- Size of wedges (in 275 packs): 5, 7, 10, 12 and 15 mm
- Two types of wedges : soft woods, hardwoods.
- Machine weight : approximately 80 kg.
- over-all dimensions : W 450 mm X L (without rotating table) 490 mm X H 1130 mm
- Power : 220/110 V single phase electric - Consumption: 100 watts.
- Pneumatic : 7 bars compressed air; consumption of 5 litres per cycle.
- air conditioning : Pressure reducing valve + Pressure gauge, connection via piping with an interior diameter of 8 mm.

IV - OPTIONS

- Independent rotating table with a diameter of 1300 mm, making it easy to manipulate frames with dimensions up to table diameter.
- furniture accessory for joining rabbetless mouldings and/or frames with small dimensions.
- Shims for six-sided, eight-sided etc frames.

V - GUARANTEE

The CS 486 is guaranteed for 1 year, parts and workmanship against any manufacturing defect. Worn parts and those damaged due to use contrary to that stated in these instructions are excluded from this guarantee.

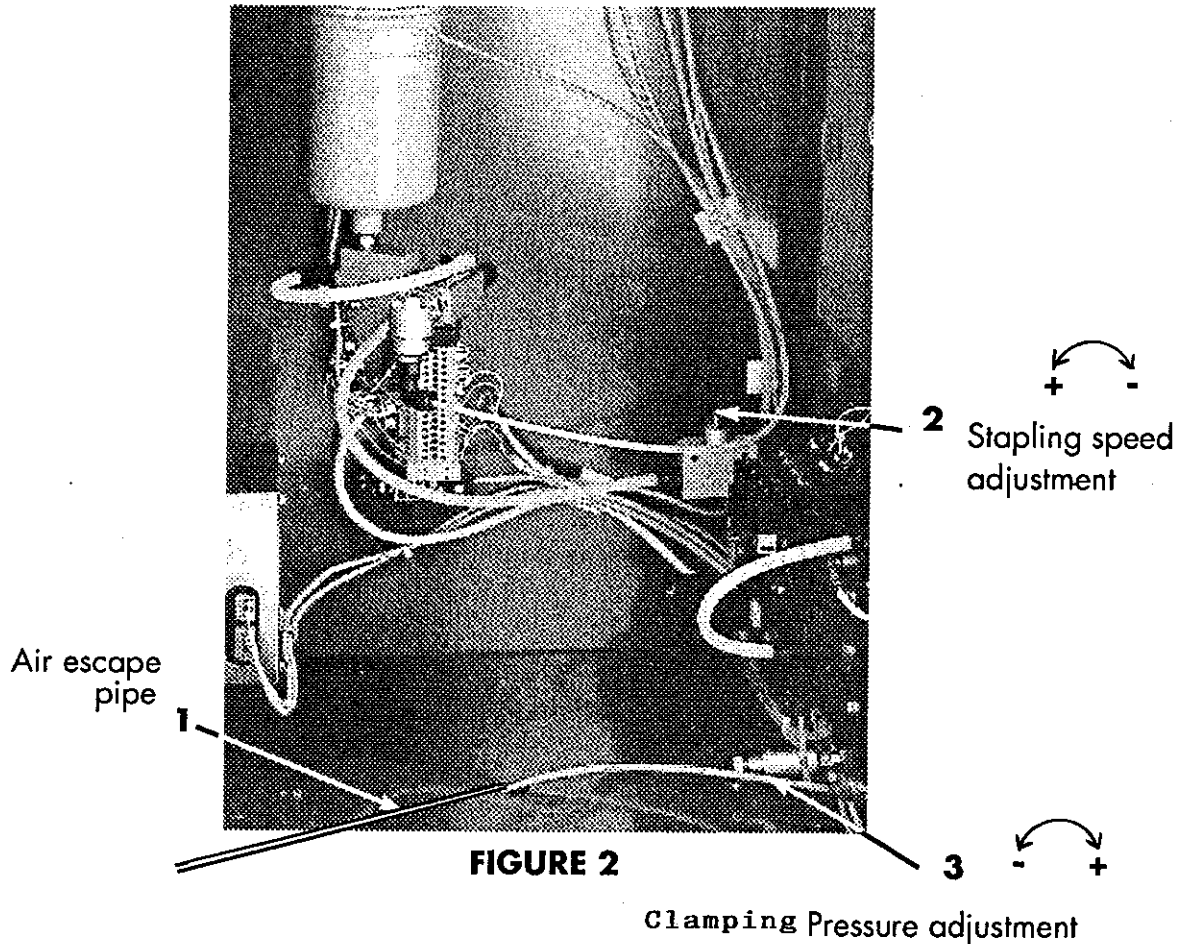
INTRODUCTION

INSTALLATION

I - REASSEMBLY

- 1 - Reassemble the four legs of the machine (which come with the accessories).
- 2 - Reassemble the X, W and B handles (Fig 1) by replacing the transport screws, without locking them.
- 3 - Place the tube of grease attached to the cylinder inside the machine.

NOTE: Throughout the explanations for setting up and adjustment given in these instructions, we are assuming that user is standing IN FRONT of the machine, on the keyboard side, as indicated in FIGURE 1.



IMPORTANT:

IN ORDER TO OBTAIN THE BEST RESULTS WITH YOUR ELECTRONIC CS 486, WE RECOMMEND THAT YOU CARRY OUT THE ADJUSTING AND PUTTING INTO SERVICE OPERATIONS FOR THE MACHINE IN THE ORDER INDICATED IN THESE INSTRUCTIONS.

II - KEYBOARD

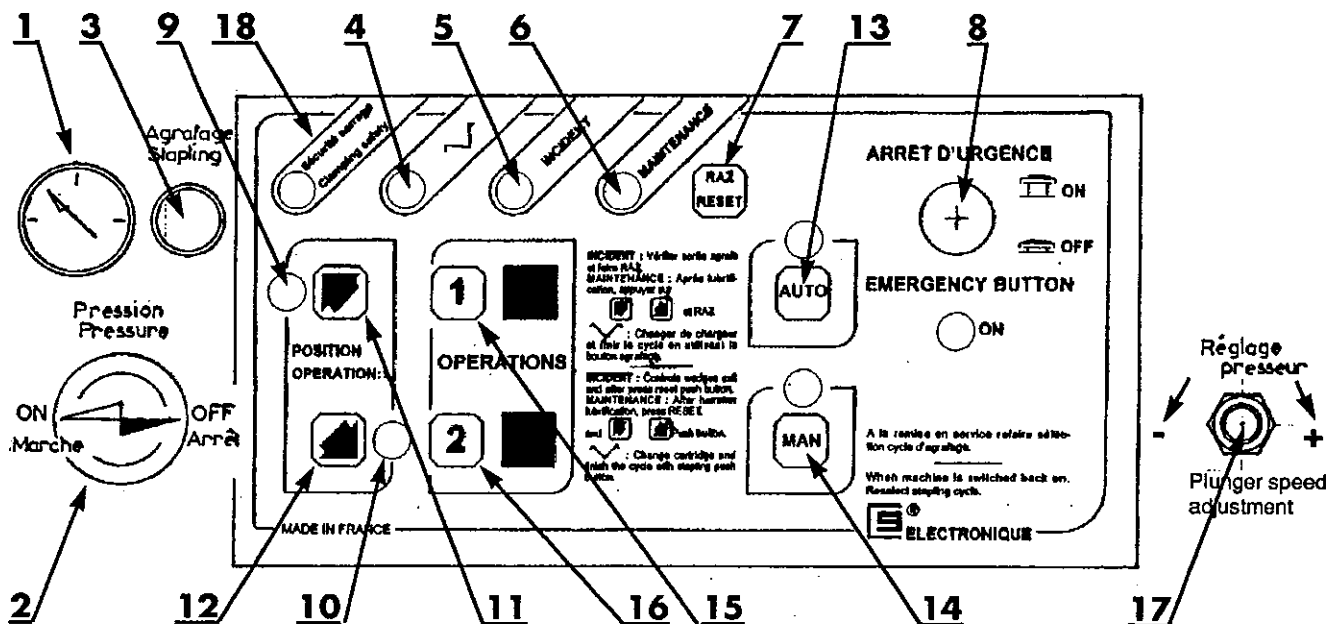


FIGURE 3

- 1: Pressure gauge
- 2: Air valve - ON/OFF
- 3: Stapling button (see "operation", page 8)
- 4: "NO WEDGE" indicator (see page 7)
- 5: "TROUBLE" indicator (see page 14)
- 6: MAINTENANCE indicator (see page 14)
- 7: RESET button (see page 14, I-C)
- 8: Emergency button and main switch
- 9 & 10: Stapling head position indicator
- 11: Button for positioning the wedge outside the frame
- 12: Button for positioning the wedge inside the frame
- 13: "Automatic cycle" button (see operation page 8)
- 14: "Manual cycle" button (see operation page 8)
- 15: Selector for the number of wedges in the first position (OPERATION 1)
- 16: Selector for the number of wedges in the second position (OPERATION 2)
- 17: Vertical plunger E (Fig 1) speed adjustment
- 18: Clamping safety (see page 15 or the following)

III - PLUGGING THE MACHINE IN

- a) Plug the CS 486 into a grounded 220 or 110 (depending on country) volt electrical socket.
- b) Connect the air pipe located inside the machine using the quick coupler provided for this.
- c) Plug in the air compressor.
- d) Attach the escape pipe after the compressed air pipe by crossing the metal barrier via the opening located on the side, in such a way that the air escapes outside the machine (FIG. 2).
- e) Check that the pressure on the pressure gauge indicates at least 6 bars (maxi 8).

ADJUSTMENTS

3

I - ADJUSTING THE SLIDING TABLE (FIG. 1)

- 1 - Lower the lever J located on the right side of the machine in order to advance the Q and P clamping shoes, and to release the vertical plunger.
- 2 - Be sure that the 2 K and K' buttons (backstop angle) are at zero. Place a moulding against backstop M (in the event that the height of the moulding is less than that of the backstop, the set of metal spacer bars supplied with the accessories must be slid against backstops M and N, and then the mouldings to be joined are placed against them).
- 4 - Move the sliding table until the clamping shoe just touches the moulding.
- 5 - Tighten the locking handle (B).

II - SELECTING THE STAPLING POSITION

The CS 486 is designed to join mouldings in 1 or 2 places, with 1, 2 or 3 wedges at each one of these places.

The choice is made as a function of the width of the moulding to be joined and of its thickness.

NOTE: IN ANY CASE, STAPLING MUST BE CARRIED OUT AS NEAR AS POSSIBLE TO THE MOULDINGS HIGHEST PART(S) (FIGURE 4)

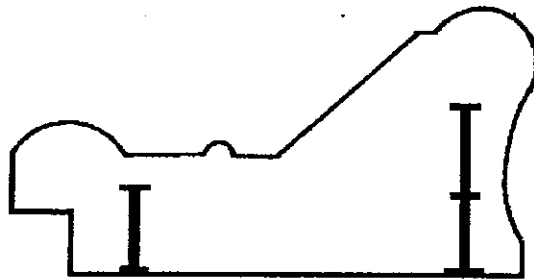


FIGURE 4

- 1 -
Unlock handles X & W.

a) First stapling position : outside part of the frame.

Slide bracket E to the left until the desired stapling position, then bring handle W towards the front and lock it.

b) Second stapling position : inside part of the frame.

Slide bracket E to the right until it reaches the stapling position desired, bring backstopped handle X to the rear and lock it.

- 2 - Erect the lever J.

ADJUSTMENTS

III - SELECTING THE NUMBER OF WEDGES AS A FUNCTION OF THE STAPLING POSITION

Selection is accomplished with the machine's keyboard.

A - FIRST DESIRED STAPLING POSITION : OUTSIDE THE FRAME (FIGURE 5)

Select the first position by pressing the arrow (Ref. 11), on the panel, indicator light 9 lights up, the position is selected.

B - CHOOSING THE NUMBER OF WEDGES IN THE FIRST POSITION : Press the OPERATION 1 button Ref. 15 and display the number of wedges desired: 1, 2 or 3.

C - CHOOSING THE NUMBER OF WEDGES IN THE SECOND POSITION : Choose the number of wedges in the second position by displaying the desired number (1, 2 or 3) on the keyboard by pressing the "OPERATION 2" button (Ref. 16)

IF THE FIRST STAPLING POSITION DESIRED IS THE ONE LOCATED INSIDE THE FRAME, select the Ref. 12 arrow first on the instrument panel, then continue as indicated above.

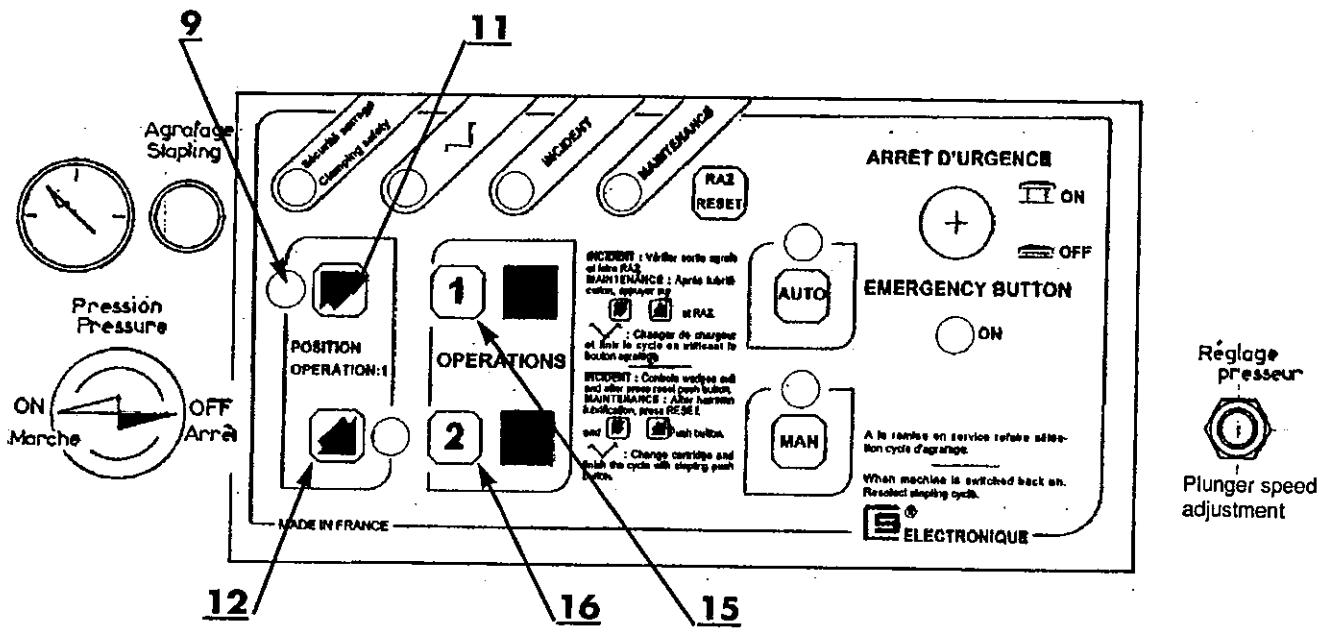


FIGURE 5

NOTE : IN THE EVENT THAT ONLY ONE STAPLING POSITION IS NECESSARY, SELECT THE NUMBER OF WEDGES WITH BUTTON 15, "OPERATION 1" ONLY.

ADJUSTMENTS

IV - CHOOSING WEDGES

Selecting wedge size (5, 7, 10, 12 or 15 mm) is accomplished as a function of the height of the mouldings to be joined.

Generally, a minimum margin of 2 mm is left above the wedge.

Example : moulding with a thickness of 12 mm: 10 mm wedge.

NOTE*: Wedges of the same size may be superimposed (FIG 6), in order to avoid having to change the staple loader if frames with different thicknesses are being joined.

*When joining hardwood if standard wedges do not work (bend, break or do not penetrate totally), use special hardwood wedges.

TIP : even on hardwood, try first standard (normal) wedges.

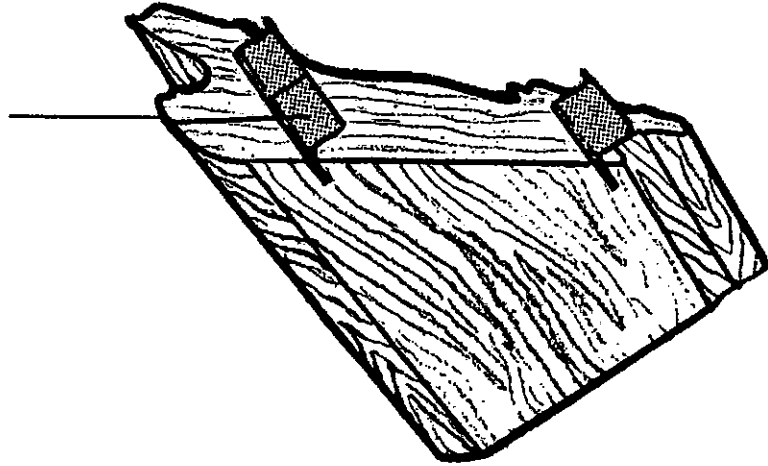


FIGURE 6

V - CHANGING THE CARTRIDGE (FIG 1 - REP. F)

- 1 - Pull the wedge thruster (FIGURE 1 - Rep F) to the back
- 2 - Remove the empty cartridge
- 3 - Insert the new cartridge completely into the window of the distributor.
- 4 - Release wire Rep. F. slowly

NOTE: When the cartridge is empty or if there is no cartridge, the Indicator Rep . 4 FIG 3 lights up.

If this happens when a cycle is in progress, the mouldings remain clamped, so to keep them fix and to be able to superimpose the next wedges as intended.

The new cartridge must thus be set in place as indicated above, and then press the "STAPLING" button to finish the cycle.

The Rep. 4 indicator doesn't go out until the stapling button 3 is pressed (FIG 3).

OPERATION

I - POSITIONING THE PLUNGER

Check that the travel between the top of the moulding and the rubber endpiece of the plunger is not greater than 50 mm (FIGURE 7)

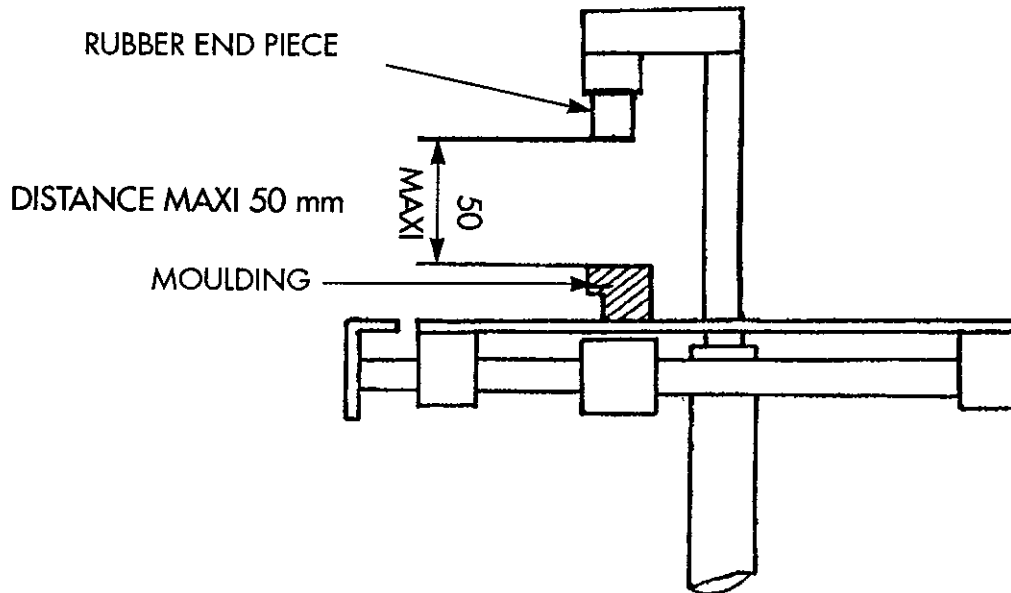


FIGURE 7

If this distance is bigger than 50 mm, use a longer rubber endpiece (see INTRODUCTION PAGE 1)

II - JOINING THE FRAME

Joining in manual position (MAN)

- 1 - Place the moulding against backstop M and slide it over to backstop N.
- 2 - While continuing to hold the first moulding, position the second moulding against backstop N and slide it until it touches the first.
 - a) While holding the mouldings, press the pedal in order to clamp the two mouldings and keep it pressed until the following step.
 - b) Press the stapling button once (FIG 3 - Rep. 3)

The cycle takes place automatically until the moulding is released.

Joining in automatic position (AUTO)

Only press the pedal, this single press triggers the cycle until the moulding is released.

VARIOUS ADJUSTMENTS

I - ADJUSTING THE JOINING ANGLE (FIGURES 8 A & 8 B)

If the angle opens to the outside, (FIG 8A), tighten the adjusting screw (FIG 9 - Ref. L) to correct the error and check the adjustment by clamping the mouldings (MAN position, press the pedal)

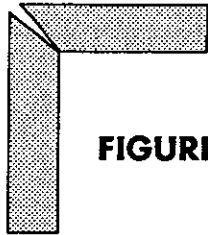


FIGURE 8 A

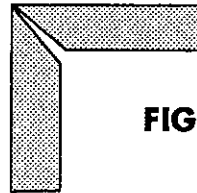


FIGURE 8 B

If the angle opens to the inside (FIG 8B), unscrew the angle adjusting screw (Ref. L - FIG 9) in such a way as to correct the error.

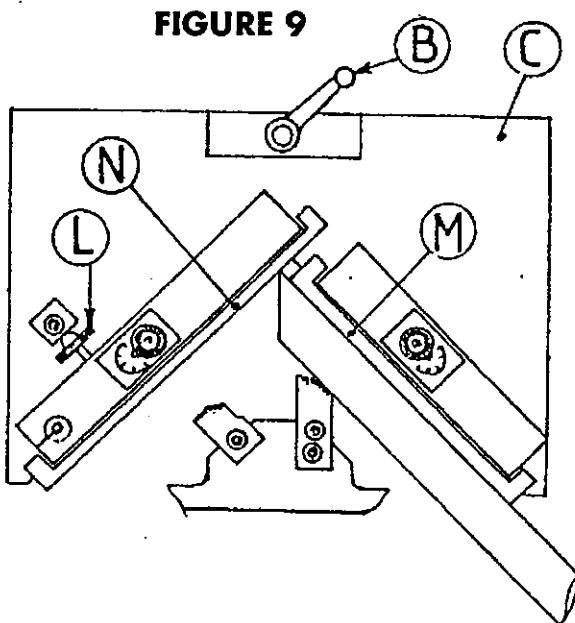
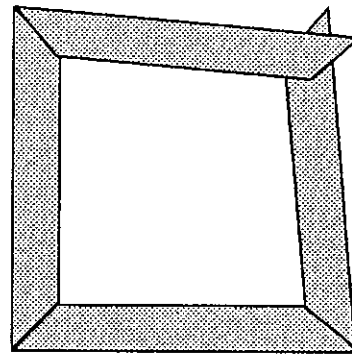


FIGURE 9



If this result is obtained, check your cutting angle which, in this case is incorrect because it is less than 45°*

* Continue with the adjustment of the angle of your cutting machine (it is impossible to join for less than 90°)

II - OFFSETTING OF MOULDINGS : ADJUSTING THE CLAMPING SHOES

When the mouldings are clamped, and if they are offset, use the pressure adjustment button located inside the machine (FIG 2 - Ref. 3)

In the event that the mouldings are to be glued, do this before making the adjustment. Correct clamping can be checked by looking at the depth of the mark left in the mouldings by the clamping shoes (approximately 0 to 0.4 mm, according to the wood's hardness).

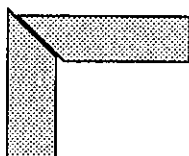
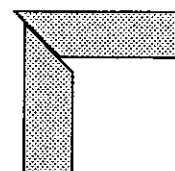


FIGURE 10



DECREASE CLAMPING PRESSURE
BY BUTTON 3 (FIG 2)

INCREASE CLAMPING PRESSURE
BY BUTTON 3 (FIG 2)

III - JOINING ANGLE OPENING UPWARDS OR DOWNWARDS : ADJUSTING THE BACKSTOP ANGLE

- If the joining angle opens upwards (FIG 11 A), turn the 2 K & K' adjusting buttons (FIG 1) equal ly towards the MINUS (-)
- If the joining angle opens downwards (FIG 11 B), turn the 2 K & K' adjusting buttons equal ly towards the PLUS (+)

opening upwards

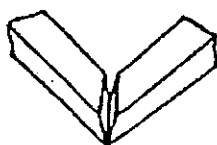
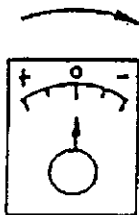


FIG 11 A



opening downwards

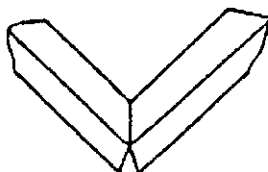
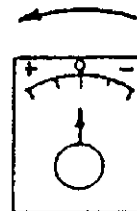


FIG 11 B



IV - CHANGING THE CARTRIDGE DURING A CYCLE

In the event that the cartridge is empty, the "NO WEDGE" indicator light (KEYBOARD Rep. 4) lights up. If this happens while a cycle is in progress, the mouldings remain clamped and the machine stops. If this happens while stapling the inside position, the machine comes automatically to the outside position so to help the user and to make the change of cartridge quicker.

Change the cartridge (see page 7), and press the "stapling" button (FIG 3 Rep. 3) to complete the cycle.

V - ADJUSTING THE START-OF-TRAVEL SWITCH

If, despite the fact that the vertical plunger's speed has been reduced by turnbutton 17 (FIG 3)) the plunger comes down too quickly, loosen the start-of-travel backstop towards the left, being careful to maintain a margin of approximately 4 mm of travel (FIGURE 12).

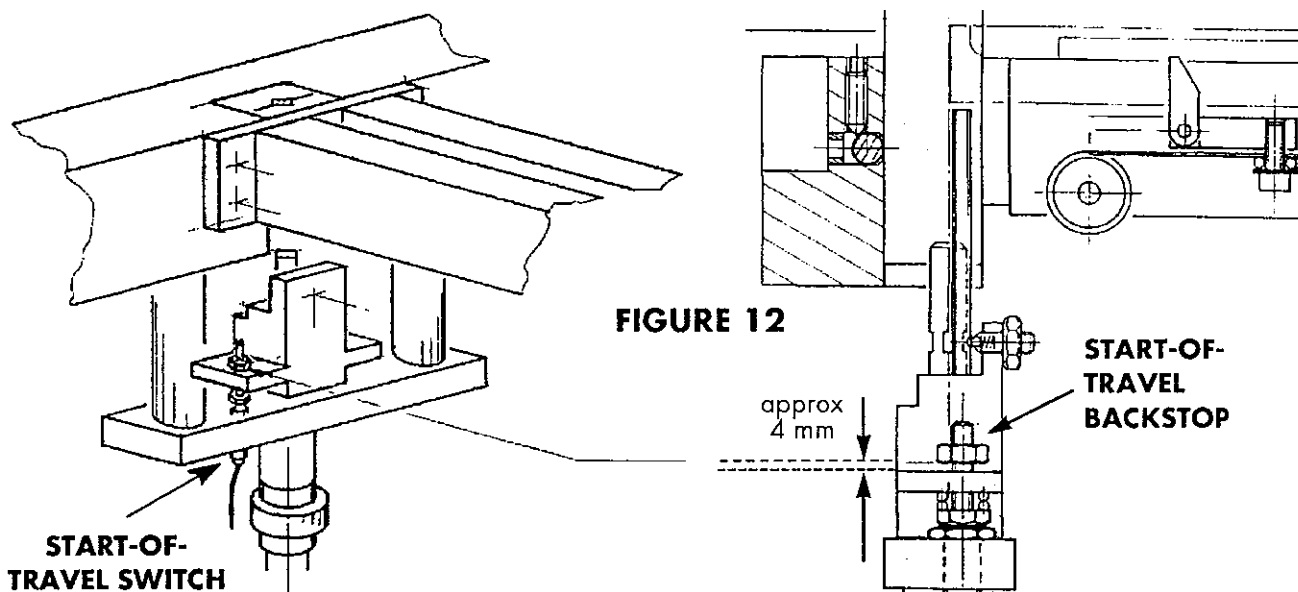


FIGURE 12

VI - REMOVING THE SLIDING TABLE

To remove the sliding table (to clean for example), unscrew the locking lever (Rep. B - FIGURE 13) and remove the table by taking it with the two backstop angle buttons (Rep. K - FIGURE 13).

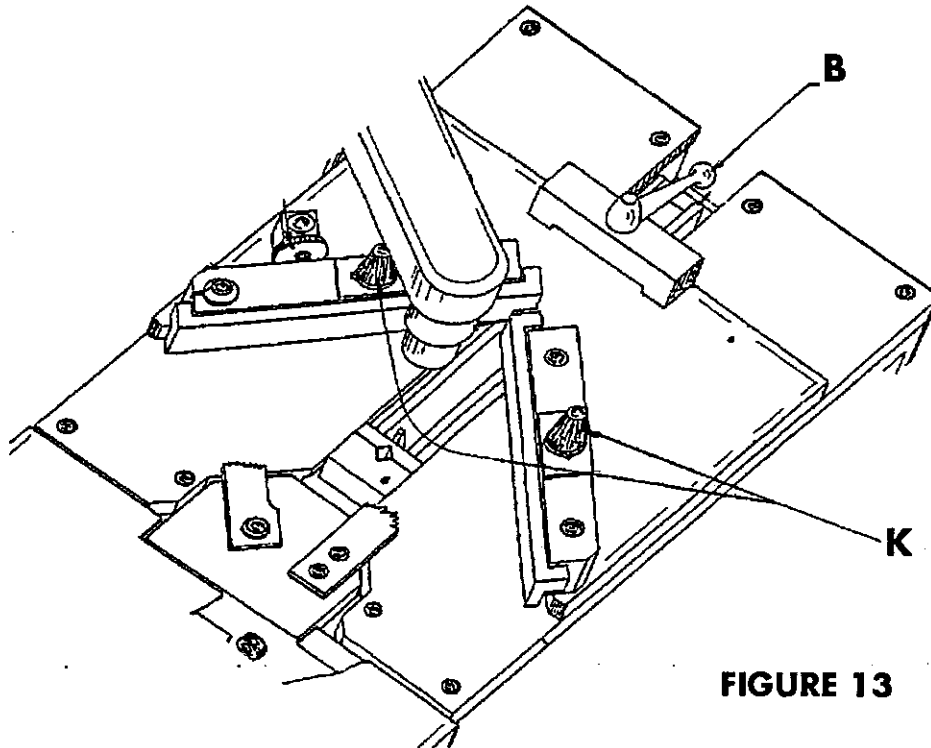


FIGURE 13

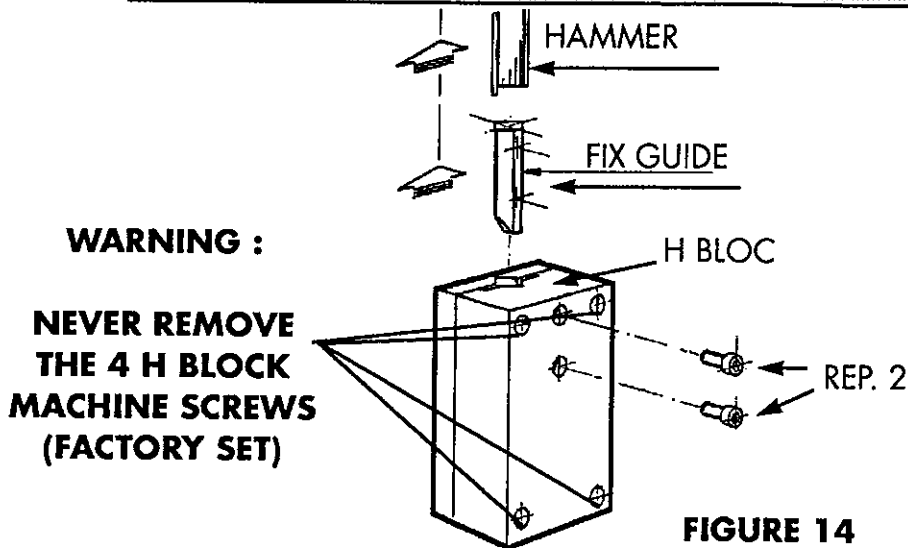
SERVICING

I - CHANGING THE HAMMER (FIGURE 14)

The hammer is the part which pushes the wedges through the block H.

IT IS RECOMMENDED TO CHANGE THE HAMMER AT LEAST ONCE A YEAR

BEFORE ANY SERVICING, UNPLUG THE MACHINE FROM THE MAINS AND CLOSE THE AIR VALVE



PROCEDURE :

- 1 - Remove the current cartridge,
- 2 - With the 3 mm Allen wrench, unscrew the retaining screw on the front of the H block (see FIG 1) and remove the block H.
- 3 - **A : THE HAMMER IS BROKEN** : it is still inside the H block; in this case:
 - a) Using a 2.5 mm Allen wrench, unscrew the 2 central holding screws (REP 2 FIG 14) of the fix guide,
 - b) Take it completely out, then extract the broken hammer,
 - c) Put the fix guide back in place,
 - d) Retighten the two screws (Ref. 2)
 - e) Replace the block in its housing in the right direction, i.e ; window placed next to the cartridge side,
 - f) Lock the H block retaining screw using the Allen wrench
 - g) Insert the new hammer (hole towards the bottom) into the H block until it does not stick out any more.
 - h) Plug the machine back in and insert an angle or two pieces of moulding in order to simulate a stapling
 - i) Do the first stapling empty, without cartridge but by pulling the wire-Ref. F-Fig 2 : the hammer will automatically take its place in the mechanism.
 - j) Put the cartridge back in place.

B : THE HAMMER IS NOT BROKEN BUT YOU WANT TO CHANGE IT

- a) Proceed as in Procedure 1 & 2,
- b) Using a pair of pliers, remove the hammer from its frame by pulling it vertically,
- c) Repeat steps from A/e until the end.

II - MAINTAINING THE “WEDGE DISTRIBUTION” (= H BLOC) PART

Periodically pull the H block out of the machine and, without taking it completely out, clean it (blow on it) (Fig. 15)

Lubricate the hammer a little before putting it back.

III - UPKEEP AND LUBRICATING

If the plunger (FIG 1 - Rep. E) does not slide very well horizontally, lubricate the horizontal axes inside the machine (use a motor oil (20/40 SAE).

In the event that glue is used, lightly spray some silicon oil (aerosol can) on plates Y & Z; this will make eventual cleaning of glue specks easier after drying.

To clean the glue rests from machine's table scrape the glue WHEN DRY.

IV - MAINTENANCE INDICATOR LIGHT

Every 50,000 staplings, the “MAINTENANCE” indicator lights up.
See the procedure to be followed on page 14 -I.

After testing, press the three RESET Rep. 7, Ref. 11, and Rep. 12 buttons simultaneously in order to reset the machines electronic memory to zero.

If the “MAINTENANCE” light blinks, this signals that there is a problem with the stapling pressure (see page 14)

V - REMOVING A WEDGE JAMMED IN THE “H” BLOCK

For safety reasons, the machine stops (“TROUBLE” light is lit)

Try to remove the cartridge, and in case it resists, use the G* tool in order to place the wedge engaged in the H block back into the cartridge.

Before using the machine again, check the setting by referring to operating malfunctions, Page 18.

Turn the CS 486 back on by pressing RESET.

* NOTE: Never insert the G tool more than 6 mm into the block.

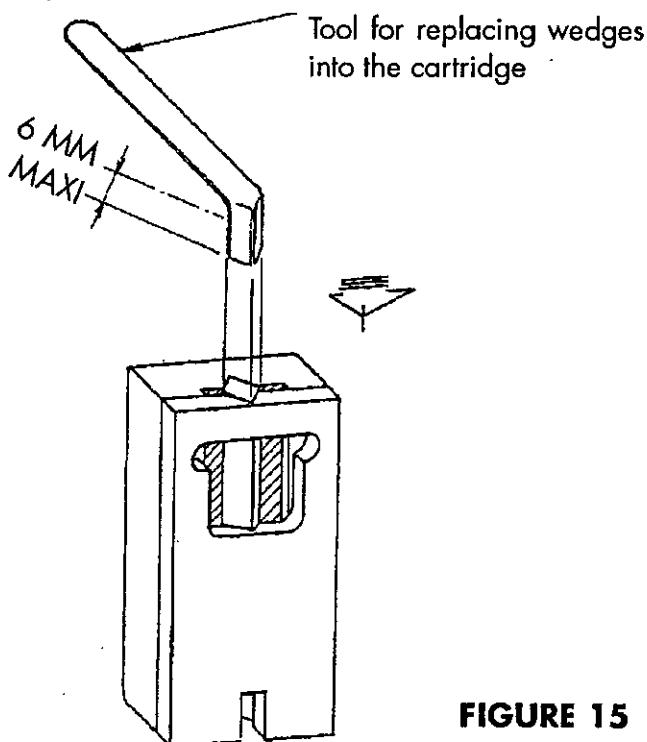


FIGURE 15

KEYBOARD ANNUNCIATOR BOARD

I - MAINTENANCE INDICATOR (REP. 6 - FIG 3)

When the machine is idle, the red indicator light located on the start-of-travel switch (FIG 12) is out if the start-of-travel backstop setting is correct (part 09 E, see parts list).

A - MAINTENANCE INDICATOR LIT STEADY = 50000 wedges completed.

Cut the power, lubricate the hammer without removing it via the interior of the machine (lightly oil the visible parts with your finger)

Lubricate the two horizontal axes (Part #. 3002, page 18), using motor oil (example SAE 20/50)

Turn it back on.

Reset the staplings counter to zero by pressing three buttons Rep. 7, 11 & 12 (KEYBOARD) **SIMULTANEOUSLY**

The MAINTENANCE indicator should go out.

B - THE MAINTENANCE INDICATOR IS BLINKING SLOWLY (1 blink/second)

The start-of-travel backstop is not set properly (see adjustment P 10)

A staple is engaged in the H block output

- Replace it into the cartridge using the G tool (FIG 15).

C - MAINTENANCE INDICATOR IS BLINKING RAPIDLY (4 blinks/second)

Power trouble on the stapling cylinder. Replace the wedge engaged in the H block using the tool, as before.

Do not use the machine, and contact your salesman.

AFTER THE PROBLEM HAS BEEN TAKEN CARE OF, RESTART THE MACHINE BY PRESSING RESET (KEYBOARD Rep. 7)

II - TROUBLE LIGHT (REP. 5 - FIG 3)

A - "TROUBLE" INDICATOR LIT STEADY

a) The distance between the adaptor and the moulding was not respected (50 mm maxi); use a longer rubber endpiece.

b) The plunger lowering speed is too slow, increase the lowering speed using the adjusting turnbutton (Ref. 17 KEYBOARD)

In these two cases, a wedge may be engaged in the H block output, it must therefore be replaced in the cartridge using the G tool.

c) A wedge is jammed in the H block, proceed as if changing the hammer (see page 13).

d) The end-of-travel switch is improperly set, contact your salesman.

B - "INCIDENT" LIGHT BLINKING SLOWLY (1 blink/second)

The start-of-travel switch is damaged ; this is the result of reduced stapling pressure. Contact your salesman.

C - "INCIDENT" INDICATOR BLINKING RAPIDLY (4 blinks/second)

The end-of-travel switch is damaged; the machine no longer staples.

Contact your salesman.



III - CLAMPING SAFETY INDICATOR (REP. 18 - FIG 3)

INDICATOR LIT DURING A STAPLING CYCLE

Indicates :

that the distance between the clamping and the mouldings is too great to get a perfect clamping (may be due to incorrect tightening of handle B (Fig. 1). Repeat the adjustment (P. 5 - 1) and tighten the handle well.

Or :

The clamping pressure is too great
Lower the clamping pressure (P.3 Fig.2).

IV - POSITION INDICATORS (REF. 9 - REF. 10 - FIG 3)

BLINKING INDICATOR

Either :

The handle (W or X, FIG 1) corresponding to the blinking indicator is incorrectly tightened or improperly positioned.
Position the handle again and tighten it well.

Or :

The backstop position switch (Part 06 A, see parts list) is defective.
Contact your salesman.

**S
R
V
I
C
I
N
G**

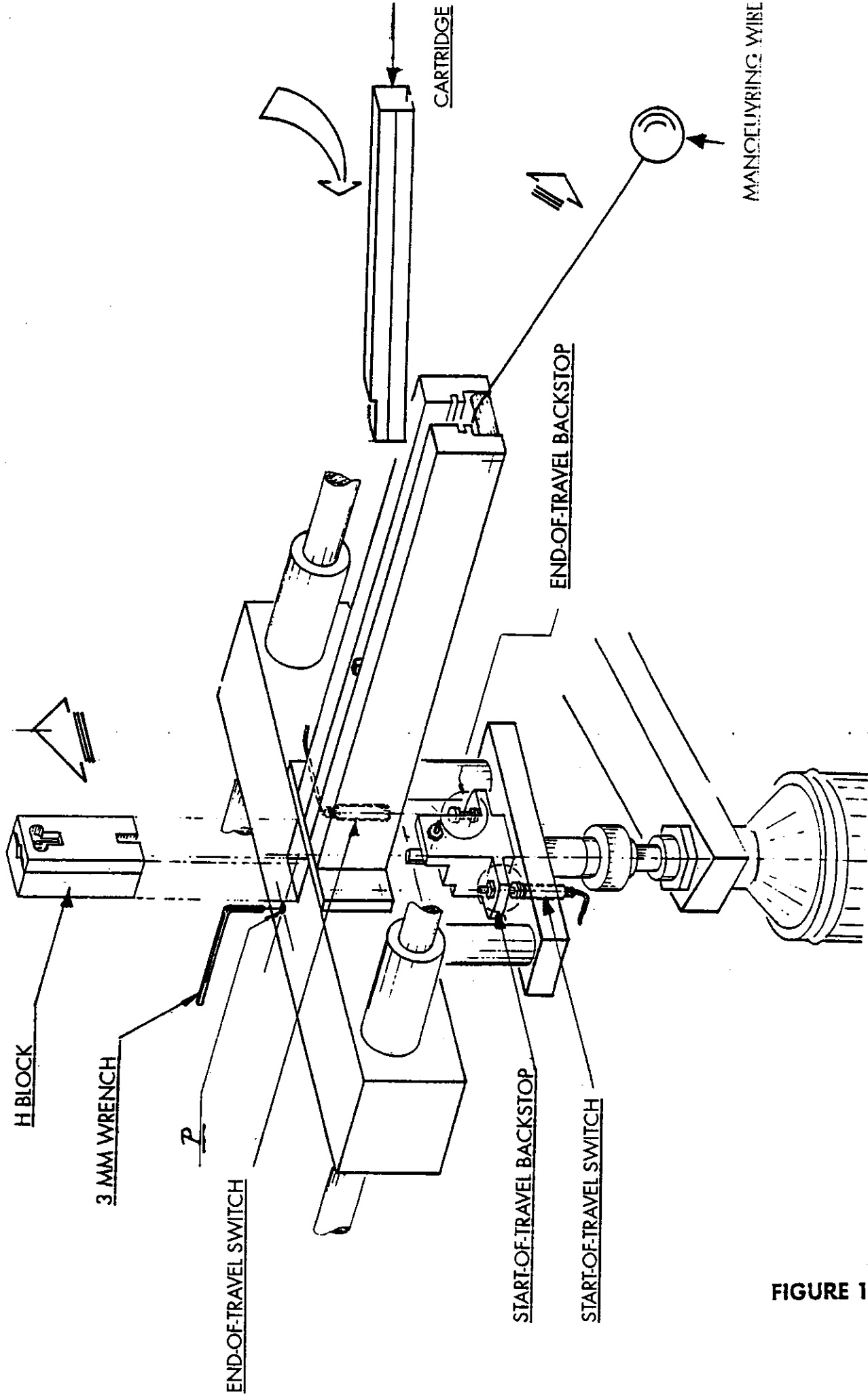


FIGURE 16

TROUBLE SHOOTING

PROBLEM	POSSIBLE CAUSES	CORRECTION	PAGES TO REED
NO STAPLE PENETRATES THE MOULDING	C 1 : The loader is empty C 2 : The loader is not properly positioned C 3 : The staple distributor is clogged C 4 : The staple spring is broken or not extended C 5 : The hammer is broken C 6 : Damaged start-of-travel transducer	R 1 : Use a new loader R 2 : Correctly position the loader R 3 : Clean it R 4 : Check the spring and replace it if necessary R 5 : Change the hammer R 6 : Contact your distributor	7 - V 10 - IV 13-II 12-I-A 14-II-C
THE STAPLE DOES NOT COMPLETELY PENETRATE THE MOULDING	C 7 : Feed pressure less than 6 bars C 8 : Hammer is damaged C 9 : 50 mm distance not respected C 10 : Plunger lowering speed too slow C 11 : A flexible plunger is being used on hardwood C 12 : Damaged end-of-travel transducer	R 7 : Increase the pressure on the gauge pressure to 6 bars R 8 : Change the hammer R 9 : Use the right adaptor R 10 : Screw the S button R 11 : Change the adaptor or triangle R 12 : Contact your distributor	- 12-I-A 8-I 14-D 1 - II
THE STAPLE BREAKS	C13 : Hardwood	R13: Change the adaptor or triangle	1 - II
IN AUTO MODE : THE CLAMPING SHOES DO NOT REMAIN IN CLAMPING POSITION IN MANUAL MODE : STAPLING IS NOT TRIGGERED	C 14 : No selection for operation 1 C 15 : Improper setting for the sliding table, KEYBOARD Rep. 18 indicator lit (FIG 3) C 16 : Clamping pressure too great in relation to the hardness of the wood, KEYBOARD Ref. 18 indicator lit C 17 : No staples. Rep. 3 indicator lit	R 14 : Select stapling again R 15 : Readjust the sliding table R 16 : Adjust the clamping pressure R 17 : Change the loader	5-III 5-I Fig 2 7 - V
INSUFFICIENT CLAMPING ON THE 2 MOULDINGS	C 18 : Insufficient clamping pressure	R 18 : Adjust clamping pressure	Fig 2
INSUFFICIENT CLAMPING ON THE LEFT MOULDING AND NORMAL CLAMPING ON THE RIGHT	C 19 : Incorrect clamping shoe setting	R 19 : Readjust the angle	9-I
INCORRECT JOINING ANGLE OPENING TO THE INSIDE OR TO THE OUTSIDE: - OPENING ABOVE OR BELOW THE JOINT - THE MOULDINGS ARE MARKED BY THE VERTICAL PLUNGER	C 20 : Incorrect joining angle setting C 21 : Incorrect setting for M & N backstops C 22 : Hardwood plunger being used on soft wood	R 20 : Readjust the angle R 21 : Readjust these backstops before continuing to join R 22 : Change the plunger by adapting to the type of wood	9-I 10-III 1-II
ANGLE IS OFFSET THE BACKSTOPS MOVE AFTER A CERTAIN NUMBER OF STAPLES	C 23: The mouldings are incorrectly positioned C 24 : Indexing is too quick or insufficient clamping with lever B	R 23 : Set the clamping shoe pressure R 24 : Adjust the output reducers located on the indexing cylinder inside the machine	9-II 10-VI
THE TROUBLE INDICATOR IS LIT; THE MACHINE NO LONGER OPERATES	C 25 : Maximum distance between the moulding and the pin has not been respected C 26 : Insufficient pressure on the pressure gauge C 27 : Insufficient pin lowering speed C 28 : A foreign body is preventing the hammer from completing rising	R 25 : Check the pin position (50 mm max.) R 26 : Check the pressure (7 bars minimum) R 27 : Adjust (Keyboard Ref. S) R 28 : Check around the hammer frame	8-I - 2 14-D
IF, AFTER "TROUBLE", THE STAPLE IS NOT ENGAGED IN THE MOULDING, THIS INDICATES THAT IT HAS REMAINED IN THE H BLOCK. IT MUST BE PUSHED AGAIN INTO THE LOADER USING THE G TOOL (FIG 15 PAGE 13). THE TOOL MUST NEVER BE INSERTED MORE THAN 6 MM INTO THE H BLOCK.			
PIN LOWERS TOO QUICKLY	C 29 : Improper setting for the lowering speed C 30 : Start-of-travel transducer setting has been disturbed	R 29 : Readjust the lowering speed setting using the button FIGURE 1 R 30 : Readjust the start-of-travel transducer	4 10-V
THE "POWER" INDICATOR NO LONGER LIGHTS	C 31 : The fuse located under the power cord output plate has fused	R 31 : Change the fuse	-
THE BACK OF THE FRAME IS STAINED	C 32 : Too much grease on the hammer	R 32 : Clean the H block	13-II
THE HAMMER IS STUCK IN THE H BLOCK	C 33 : Jammed staples	R 33 : Remove the H block	13-V
IF THE SUGGESTED CORRECTIONS DO NOT SOLVE THE PROBLEM, CONTACT YOUR SALESMAN'S SERVICE DEPARTMENT			

Qty	CODE	DESIGNATION	Qty	CODE	DESIGNATION
2	4860012	Spacer	4	4863120	Base footing
1	4860014	Stapling catch	1	4863121	Bottom metal sheet
1	4860015	Metal column	1	4866563N/B	Top presser triangle
1	4860016	Left holder frame	1	4868080	Sliding clamping shoe
1	4860017	Right holder frame	1	4868081	Adjusting gib
1	4860018	Holder support spacer	1	4868083	Pivoting clamping shoe
1	4860019	Press plunger	1	Z3177	Clamping cylinder
1	4860020	toe	1	Z3188	Clamping cylinder frame
1	4860021	Return spring	1	Z3195	Clamping shoe frame
1	4860024	Electric rail	2	Z3197	Metal column
1	4860808	Hammer	1	Z3198	Door automaton
1	4863011	Holder frame plate	1	06820032C	Sliding clamping shoe spring
1	4863018	Cylinder frame	2	03610012C	Backstop spring
1	4863021	Pliers	1	06607032T	Short preclamping spring MS747
1	4863022	Clamp	1	06607044T	Long preclamping spring MS 332
1	4863023	Rear bar	1	06008011C	Limit switch spring
1	4863026	Front bar	1	07509025C	Spring
1	4863032	Pivoting clamping shoe spring	1	06D	Cap for nut M10
2	4863035	Pivoting clamping shoe washer	1	22D	Pusher With ball
1	4863036	Clamping shoe axis	4	30D	Door Hinge
1	4863037	Clamping shoe lever	2	31D	Washer
1	4863038	Clamping shoe thrust bearing	4	32D	Adjustable foot
1	4863043	Frame	1	37D	Seale 0 - 500 mm
1	4863044	Shell	1	08E	End of travel switch
1	4863045	Lever holder	1	09E	Start of travel switch
1	4863046	Lever	1	11E	Preclamping transducer
1	4863047	Rod	1	Z6552	Power supply
1	4863049	Backstop holder plate	4	30E	1KW resistance
1	4863050	Right backstop holder	1	32E	Electrical power cover
1	4863051	Right backstop	1	35E	Electrical pedal
1	4863052	Left backstop holder	1	45E	Attachement
1	4863053	Left backstop	1	53E	Cable holder No9
1	4863054	Backstop spacer	1	55E	Cable attachement
1	4863055	Washer	1	157E	Cable holder screw No9
4	4863056	Locking screw	17	121E	Electric connector
1	4863058	Screw backstop	2	122E	End lock
2	4863059	Cam	2	123E	Selectable connector
2	4863060	Porter	1	124E	Comb
2	4863061	Adaptor spring	2	12M	M6x30 indexable lever
1	4863063	Backstop guide plate	1	49M	Savoy handle
1	4863064	Adjusting gib	2	11P	Straight connection Ø 4 - Ø 1/8
1	4863071	Keyboard strap	3	21P	Elbow Ø 4 - Ø 1/8
1	4863081	Power box	4	27P	Elbow Ø 8 - Ø 1/4
1	4863085	Indexing backstop guiding rod	1	31P	1/8 sleeve
1	4863089	Door	2	35P	Mamelon Ø 1/4
1	Z6253	Keyboard	1	37P	1/4" 1/8" reducing nipple
1	4863093	Clamping safety switch holder	1	51P	Elbow 1/4 M-F
1	4863094	Indexing cylinder frame	1	62P	T connection Ø 8
1	4863095	Indexing cylinder clamp	1	96P	Female Y Ø 4
1	4863097	Clamping shoe adjustment screw	1	106P	Reduction M 8 F 4
2	4863114	"MITEM" button spacer	1	115P	Air exhaust Ø 1/4
2	4863115	Stop label	1	117P	Air exhaust Ø 1/8
1	4863116	Door latch	1	124P	Ball valve Ø 1/4

SCHEDULE OF SPARE PARTS FOR CS 486

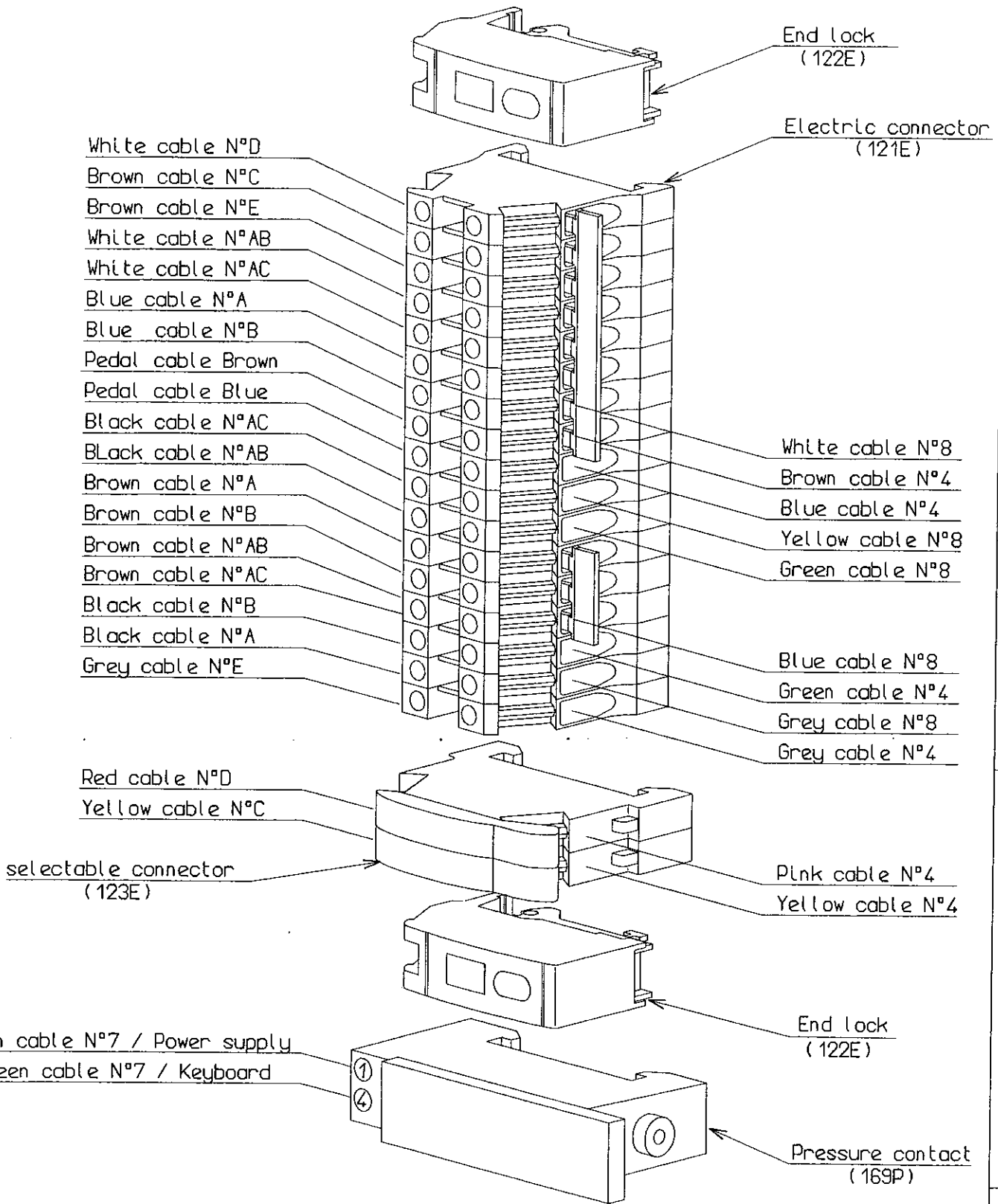


Zone Industrielle 77390 VERNEUIL L'ETANG

8

Qty	CODE	DESIGNATION	Qty	CODE	DESIGNATION
2	126P	Output reducer Ø 4 - Ø 1/8"	1	486SE6561	Triangle support + screw
1	128P	Output reducer Ø 8	1	486SETCOU	Sliding table assy
1	136P	Q/R air connector M.1/4	1	486SEBUTE	Wedge position stop assy
1	141P	Q/R air connector M.1/4 (US)	1	Z3498	Fixed stop assy
1	143P	Q/R air connector M.1/4 (JAPAN)	1	Z3499	Adjustable stop assy
1	151P	Circuit selector Ø 1/4	1	Z3490	Angled screw assy
1	156P	Output reducer MAR1	1	Z3516	Interface + electrovalve assy
1	165P	Pressure gauge + strap M.1/8			
1	169P	Single contact			
1	176P	Cylinder			
1	305P	Air circuit			
1	341P	Connector			
1	Z3661	Cable of pedal			
1	Z3666	Air tube 6 x 8 white			
1	Z3665	Air tube 2,7 x 4 white			
1	Z3738	Air tube 5 x 8 Blue			
1	Z3804	Cable			
1	Z3805	Cable			
1	Z3806	Cable			
1	Z3807	Cable			
1	Z3808	Cable			
2	Z3809	Cable			
1	486SESUPC	Cartridge support assy			
1	486SE3017	Wedge pusher spring assy			
1	486SEDESC	Hammer holder ball screw assy			
1	486SE13	Hammer support assy			
1	Z3143	Hammer stops assy			
1	Z3146	Adjustement nut assy			
2	Z3376	Clamp bearing assy			
1	486SEBARR	Stapling bars assy			
1	SE3072	Spacer bars assy			
1	486SE2728	Set of mach plates assy			
1	486SESELECT	Electrovalve assy			
1	486SE21A	Switch + cap assy			
2	486SE17A	Mitem button assy			
1	486SE32A	Stapling button assy			
1	486SECOND	Air regulator assy			
1	243E	Programme controller assy			
2	Z3176	Output reducer assy			
1	486SEVANNE	Air supply valve assy			
1	486SEFIL	Wire with ball assy			
1	Z3491	Sliding tables handle assy			
1	Z3492	Sliding tables stop assy			
1	Z3493	Wedge position cylinder assy			
1	Z3494	Wedge presence switch assy			
1	Z3384	Sleeve assy			
1	Z3495	Transfer cylinder stops assy			
1	486SEAGRA	Wedge distributor with square guide			
1	486SEPLAQ	Wedge distributor without square guide			

D C B A



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Mat. :	Trait. :	Qté. :	Ra <input checked="" type="checkbox"/>	TOLERANCES GENERALES : 1S02768-mK	Débit / Modèle :
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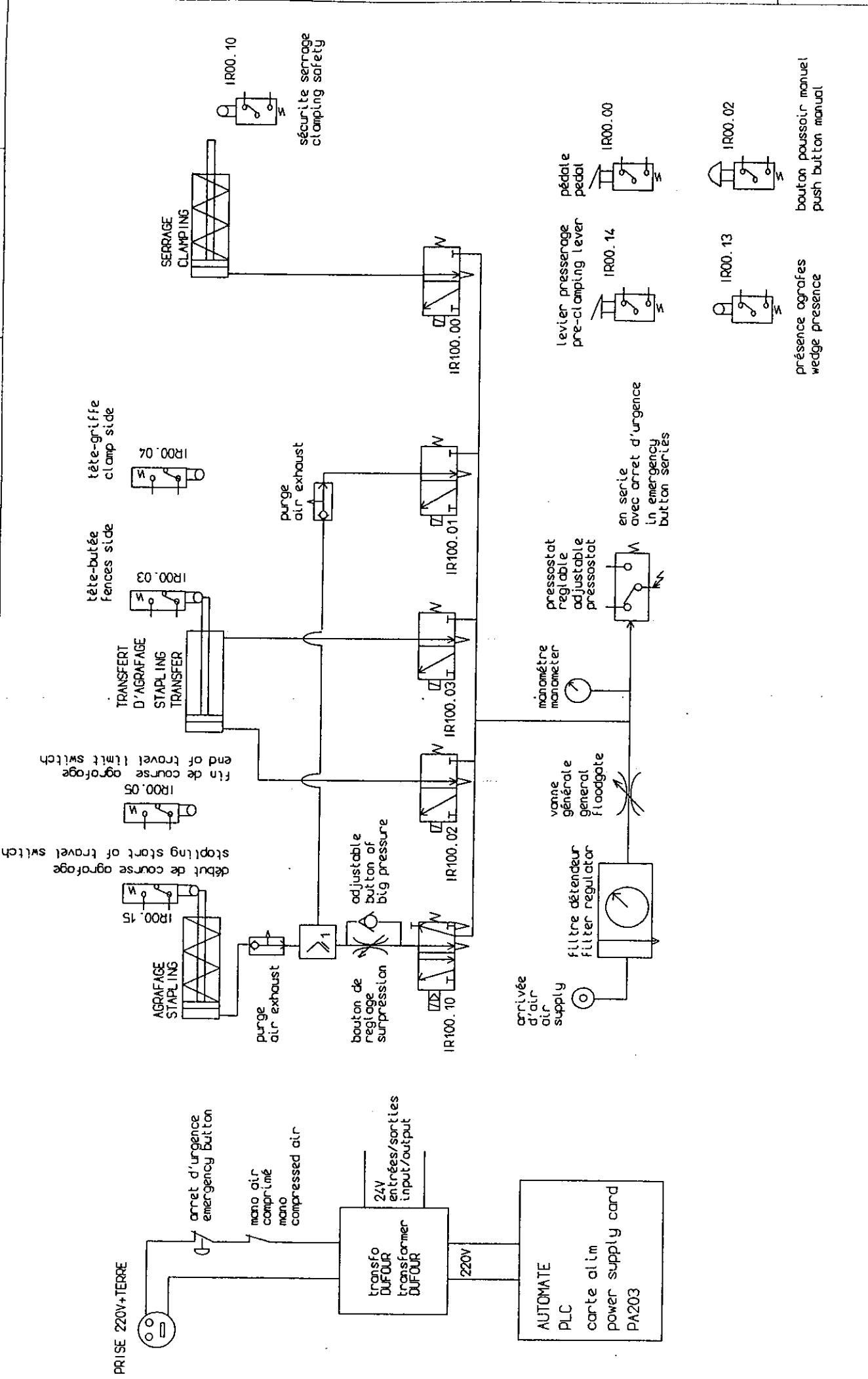


CS 486
 BRANCHEMENT DU BORNIER

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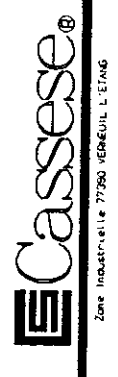
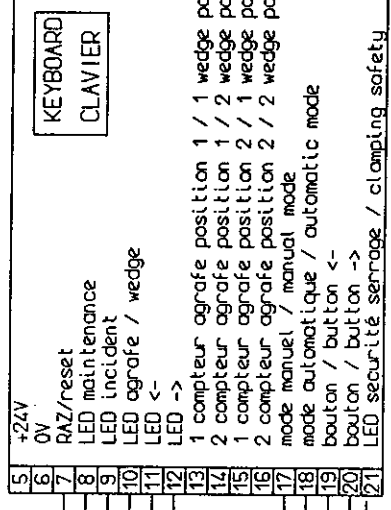
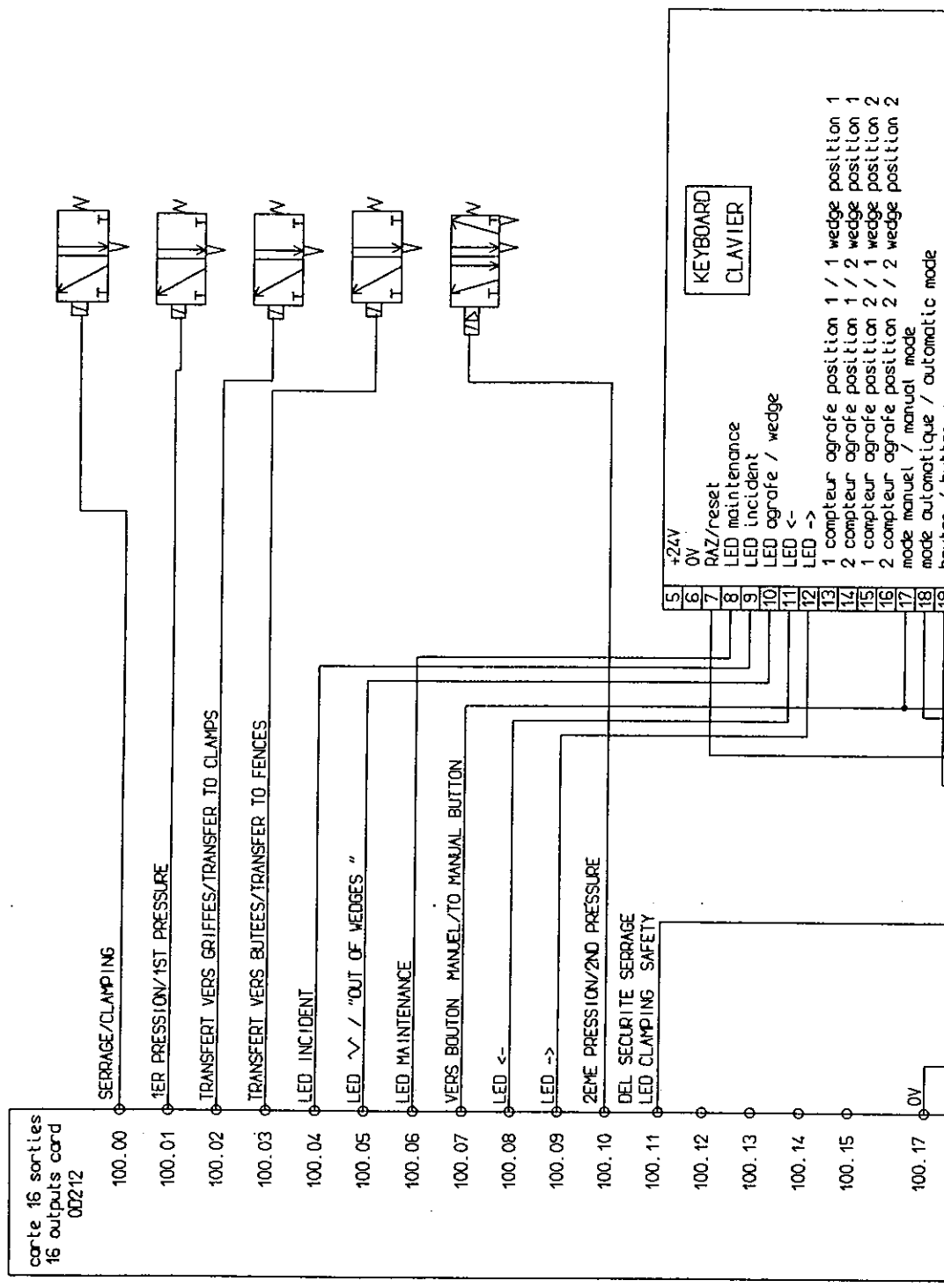
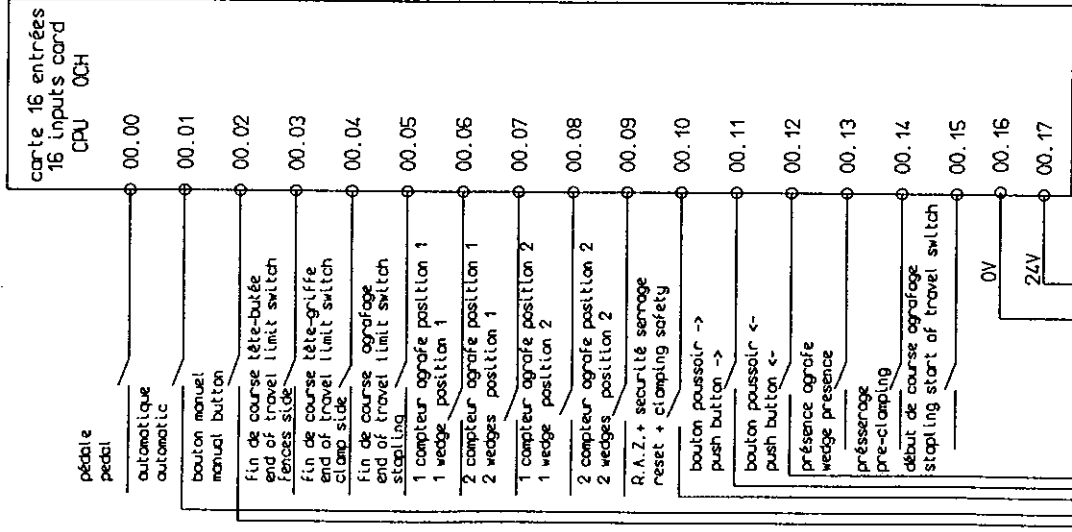
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CS 486
 SCHEMA PNEUMATIQUE

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CS 486
SCHEMA ELECTRIQUE

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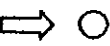


Wiring diagram. CPU11 / OD212 pour CS 486

INPUT - OCH				
	Cable N°1	Cable N°2	Cable N°4	Cable N°8
0			Blue Pedal	
1	Grey Auto			
2	Black Manual button			
3				Yellow position signal at fences
4				Green position signal at clamp
5			Green end of travel switch	
6	Blue 1 Operation I			
7	Grey 2 operation I			
8	Green 1 Operation II			
9	White 2 operation II			
10	Pink Reset		Pink Reset	
11	Yellow Push button ->			
12	Purple Push button <-			
13			Yellow Wedges presency	
14			Grey Pre clamping	
15				Grey Start of travel switch
COM-				Brown Electrodist common
				Blue start and end of travel switch
COM+	Red			Bridge to DC OUTPUT

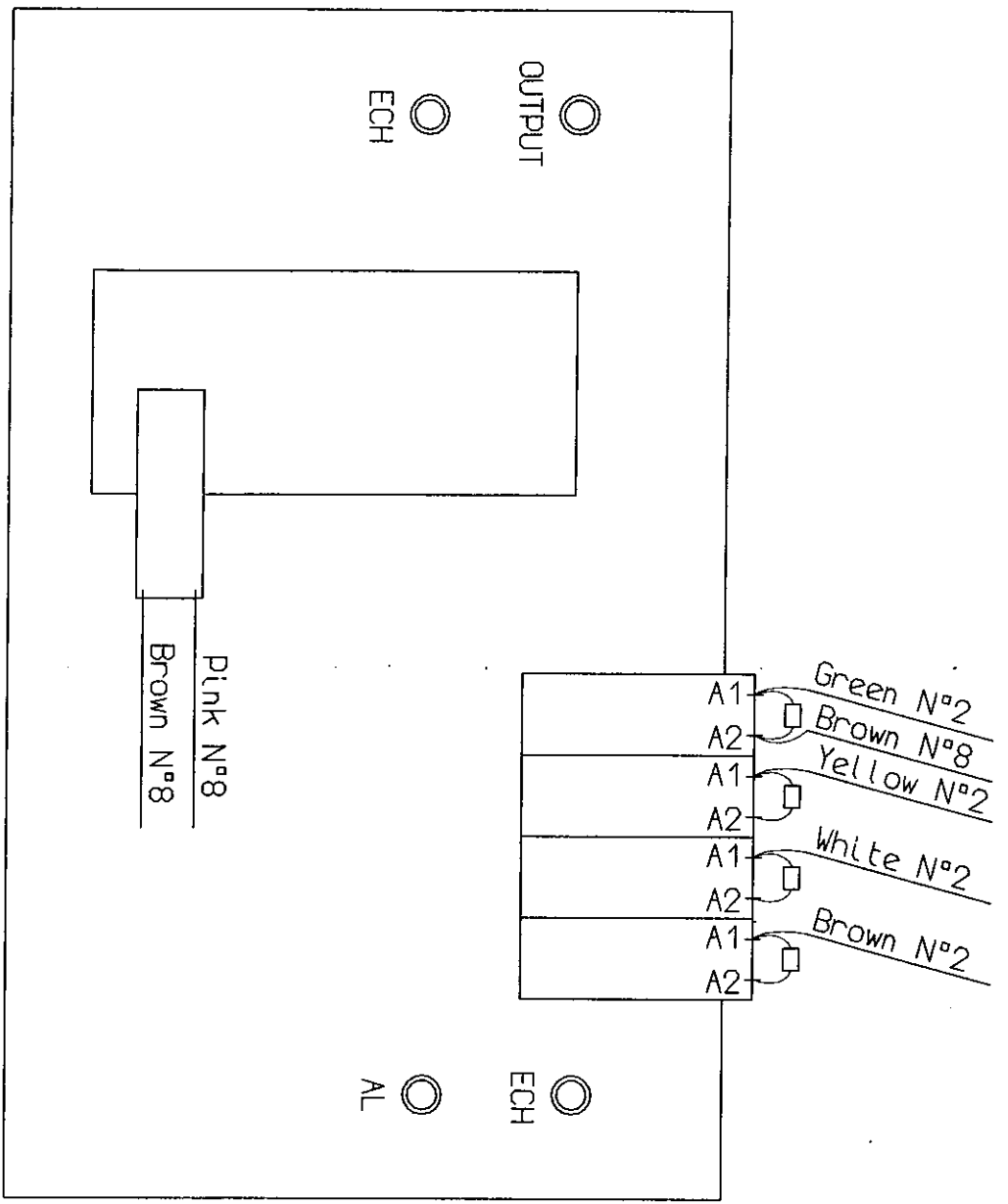
OUTPUT - OD212				
	Cable N°1	Cable N°2	Cable N°4	Cable N°8
0		Brown Clamping		
1		White 1 stapling pressure		
2		Yellow To the clamps		
3		Green To the fences		
4	White/Yellow Incident			
5	Brown/Green light LED			
6	Grey/Pink Maintenance			
7	Grey/Brown Manual bouton			
8	Yellow/Brown LED <-			
9	Red/Blue LED ->			
10				Pink Stapling big pressure
11	White/Green Clamping safety			
DC				Bridge to DC INPUT
COM	Grey/White		Brown Pedal	White Transfer stop

LISTE DES ENTREES / SORTIES
INPUT / OUTPUT LIST

CS486

N°	ENTREES / INPUT	SORTIE / OUTPUT
0	Pédale / Pedal	Serrage / Clamping
1	Mode automatique / automatic mode	Pression agrafage / Stapling pressure
2	Bouton manuel / Manual button	Transfert vers les griffes / Transfer to the clamps
3	Signal tête-butées / position signal (fences side)	Transfert vers les butées / Transfer to the fences
4	Signal tête-griffe / position signal (clamp side)	Incident (LED)
5	Capteur fin de course / end of travel limit switch	Light (LED)  / "out of wedges" light
6	1 Opération I	Maintenance (LED)
7	2 Opération I	Bouton manuel / Manual bouton
8	1 Opération II	Voyant agrafage-griffe / Light (LED) stapling clamp 
9	2 Opération II	Voyant agrafage-butées / Light (LED) stapling fences 
10	R.A.Z ou sécurité serrage / Reset or Clamping safety	Suppression agrafage / Stapling big pressure
11	Commande de déplacement vers les griffes / Move to the clamps Bouton poussoir / Push button 	Sécurité serrage / Clamping safety (LED)
12	Commande de déplacement vers les griffes / Move to the fences Bouton poussoir / Push button 	
13	Présence agrafes / Wedges presence	
14	Préserrage / Pre-clamping	
15	Capteur début course / Start Switch	

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 Zone Industrielle 77300 VENEUIL L'ETANG

CS 486
 BRANCHEMENT DU CIRCUIT

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 Ft: A4
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