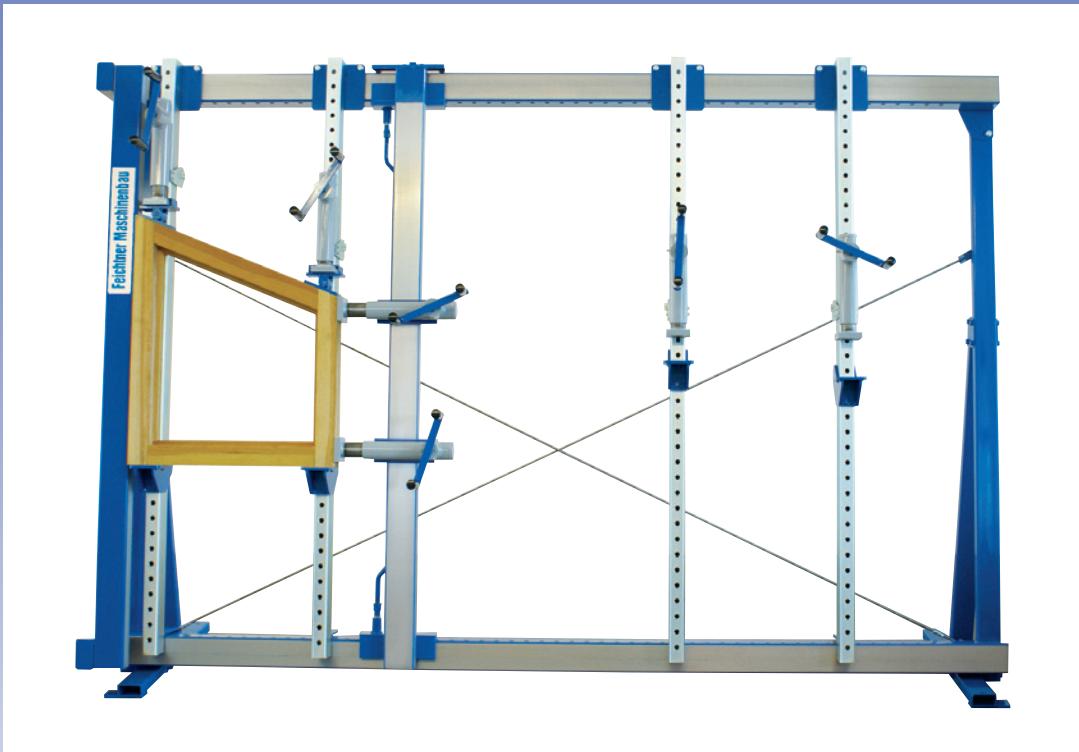


OPERATION MANUAL

UNIVERSAL GLUING PRESS
AND MOUNTING DEVICE

RPW 3000 plus



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Introduction

Dear Costumer!

With the purchase of this frame press you acquired a high quality product, to which we can congratulate you.

It shows us, that you appreciate quality and technical leadership.

By purchasing the Feichtner frame press you have the following advantages:

- Optimized pressure control**
- Angle accurate pressing of large-format parts**
- Very good price / performance ratio**
- Small space requirement**
- 3 press units in the basic equipment**
- Delivery of the press on request in assembled condition**

Read the following instructions carefully.

It will provide you a valuable help in the assembly and operation of the new frame press.

Please keep this manual for future reference.

We wish you much pleasure with your new frame press.

Josef Feichtner

FEICHTNER
Maschinenbau 

General information

Before starting and operating the new machine, please read this operation manual carefully and follow the instructions.

Disregarding this instructions may cause personal injury or property damage.

Operation of the machine is only permitted with devices and spare parts which are included in the scope of delivery or are listed in the spare and wear parts list.

Accessories must be matched to the basic unit (safety and operability). For more detailed information, please contact the manufacturer or his contractual partner.

For ease of understanding, the following symbols have been used:



This area represents a special danger to the operating personnel or maintenance personnel, if the operating instructions are not observed.



Maintenance work must be carried out at certain intervals in these areas.



Note or information on individual components of the machine which make the use easier or more understandable.

Intended usage

The universal gluing press "RPW 3000 plus" is used for gluing applications in the wood processing industry.

Thanks to its easy handling and versatile extras, this press is extremely economical and time-saving to use.

The Feichtner ** UNIVERSAL GLUING PRESS "RPW 3000 plus" ** may only be used for gluing wood and wood joints.

Observe the instructions given in this operating manual. Use of this device for other than its intended is unsafe.

The manufacturer does not assume any liability for resulting personal injury and/or material damage from improper use.

It is recommended to consult a person who already has experience with such a machine when assembling and setting up the machine.



Only original accessories or spare parts ensure perfect functioning of the machine.
No liability is assumed for damage resulting from the use of external components.



The device should only be operated, maintained and repaired by persons who are familiar with the intended use and the dangers of the device!

Failure to observe the operating and maintenance instructions described by the manufacturer in these operating manual excludes any liability on the part of the manufacturer in the event of a defect.

Safety instructions



4.1 General safety instructions:

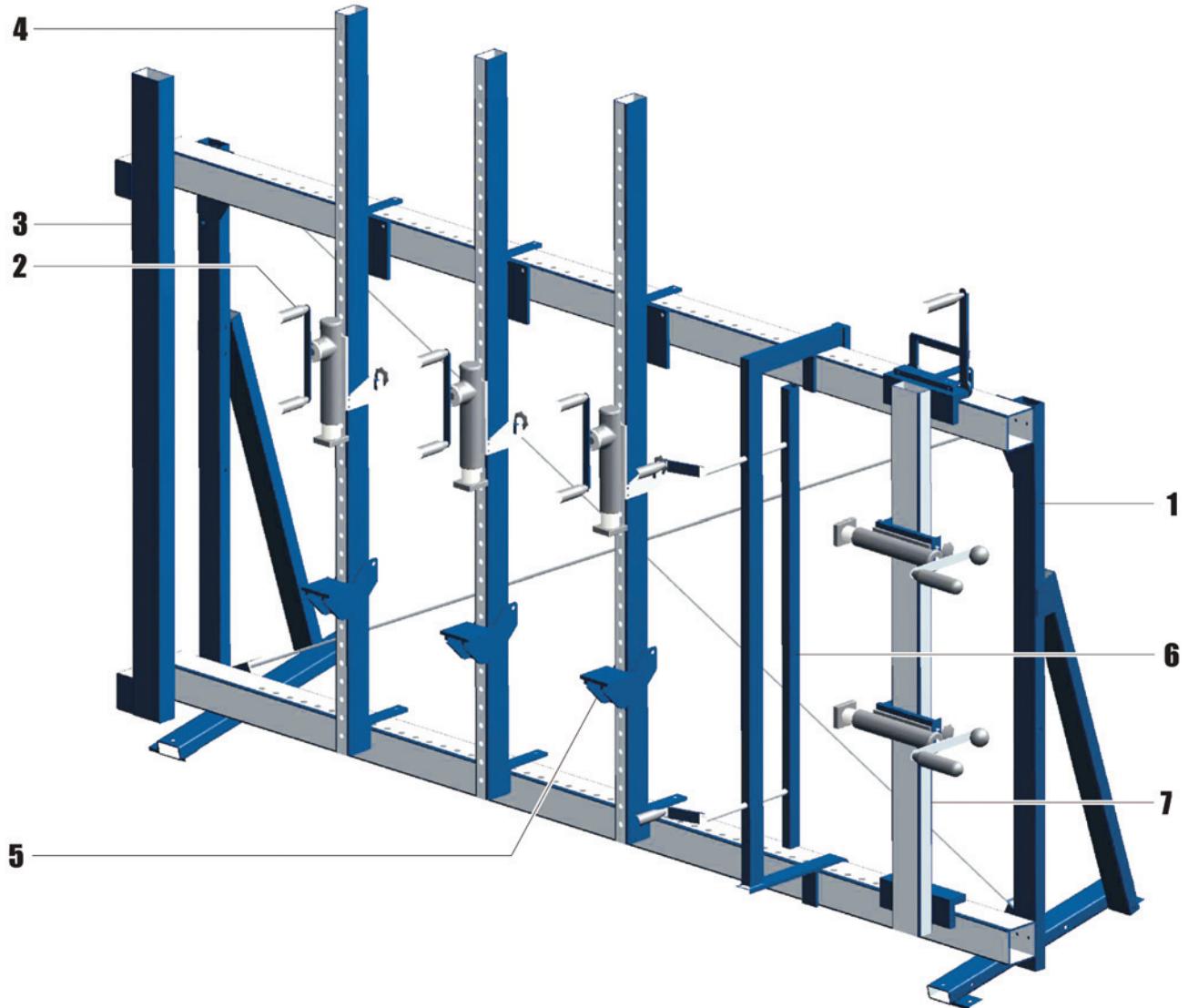
Any person charged with setting up, operation, maintenance and repair must have read and understood the operating instructions and, in particular, the chapter on safety.

It is recommended to the machine user to provide in-house operating instructions, prepared by a person with professional skills and qualifications to train particular operators. The participation of the instruction and training has to be confirmed by all participants in a written protocol.

Safety instructions to the machine user and/or operators:

- Any operation, that affects the safety of the equipment, must be omitted.
- The operator must ensure that no unauthorized persons work with or on the machine.
- The operator is obliged to check safety-relevant parts, f. e. protective devices before setting up and in case of defects to have them repaired before start up the machine.
- The operator has to take care that a holding-down device is used for surface gluing so that the workpiece cannot fall out of the frame due to the pressing pressure.
- When moving the press arm, hold the pad shoe, so that it cannot fall downwards.
- The rack-and-pinion gears may only be operated by means of pure muscular force and without the aid of any other tools. A violation of the regulations will result in a damage to the gluing press (bent profiled pipe, broken rack-and-pinion gears) which is excluded from the guarantee.
- It is important to ensure, whether there is any other person in the working area or danger area.

Device view/ Main controls



- 1) Base frame
- 2) Rack-and-pinion gear vertical
- 3) 90°-stop device
- 4) Press arm
- 5) Height adjustable pad shoe
- 6) Holding down clamp (Accessory)
- 7) Side pressure arm including 2 rack-and-pinion gears (Accessory)

Set up/Operation

Installation:

Place the press in an accessible place with flat ground.
The frame is then anchored to the ground.

Before starting work:

Always check that all the controls on the press are in order. Check that the rack-and-pinion gears and the hydraulic cylinders are free from dirt.

Remove possible glue residues from the stop angle and the pads to ensure a clean gluing.

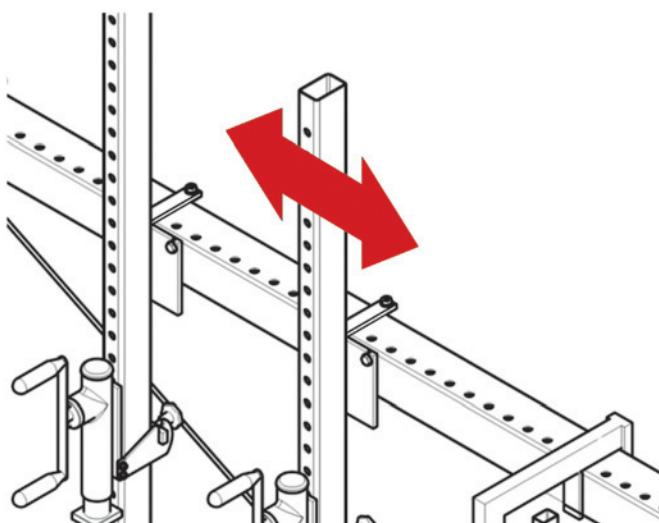


Before starting work, check that all pressing devices are properly attached to the frame and that they are locked in the row of holes.



Calculate the dimensions of the finished wooden board or the finished frame so that you can adjust the press arms, support shoes and hydraulic cylinders accordingly.

Adjust the press arms in such a way (horizontally move) that a uniform distance and thus a uniform pressing pressure is produced.

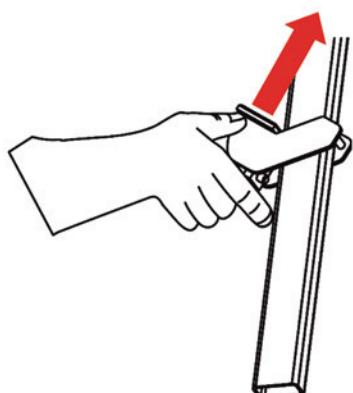


Set up / Operation

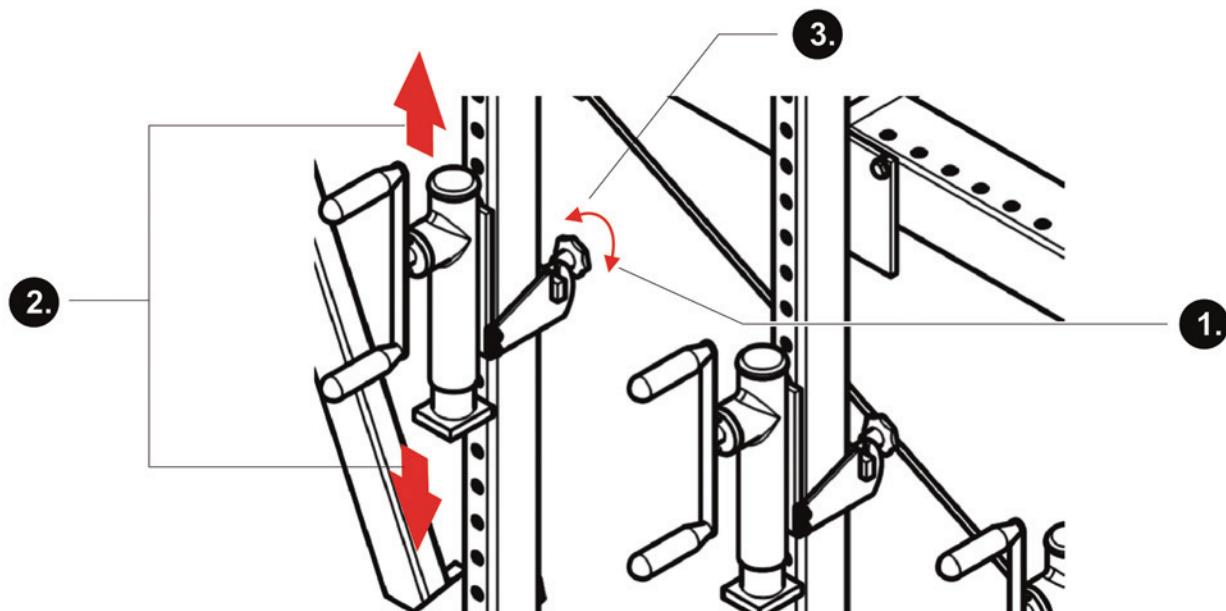
Make sure that the rack-and-pinion gears are fully retracted in order to provide enough clearance for the pressing operation.

Pad shoes and rack-and-pinion gears can be adjusted downwards or upwards as required.

Make sure that the star-stud bolts are tightened again to the angle gears and that the support shoes engage properly.



Pull up the pad shoe to release the locking pin.
The pad shoe can now be moved freely.
Then release the pad shoe just before the desired position and push it until the bolt snaps back into place.



When gluing frames, ensure that the press shoes are located at the corner points of the frame so as to avoid deflection and possible damage to the workpiece.

Set up/Operation

Clamping and gluing process:

If pad shoes, press arms and angle gears have been positioned, the actual working process can be started.

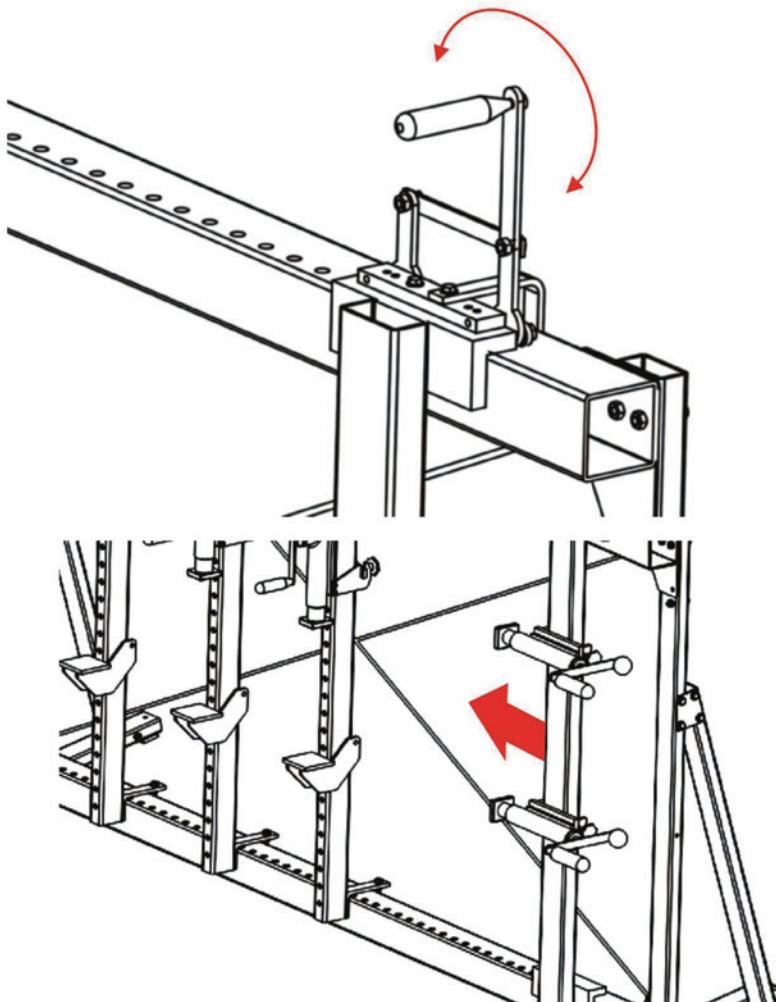
Fill the press with the glued pieces of wood, so that they stick to the 90°-stop.

Place the side pressure unit (accessory) in position. This is done by actuating the lever which raises the side pressure unit. This can then be freely moved now horizontally.

After the side pressure unit has been brought into the desired position, the lever must be actuated again so that the side pressure unit is lowered again and engages in the row of holes.



Ensure that the side pressure unit snaps securely into the row of holes so that the resulting side load (forces) can be transferred in an optimal way.



Use of the holding down clamp:

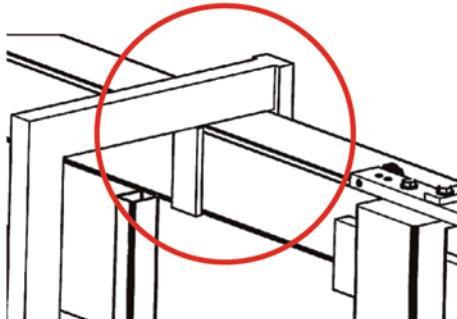
Use a holding down clamp for surface gluing so that the workpiece does not bend forward during pressing and the surface becomes flat.

The holding down clamp is simply to be mounted at the upper and lower longitudinal pipes from above.

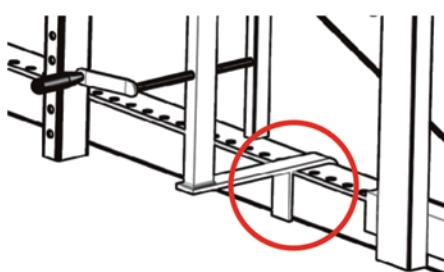
Now move the holding down clamp to the desired position. Then crank the hold-down profile in the direction of the wood panel until the workpiece is evenly against the press arms.



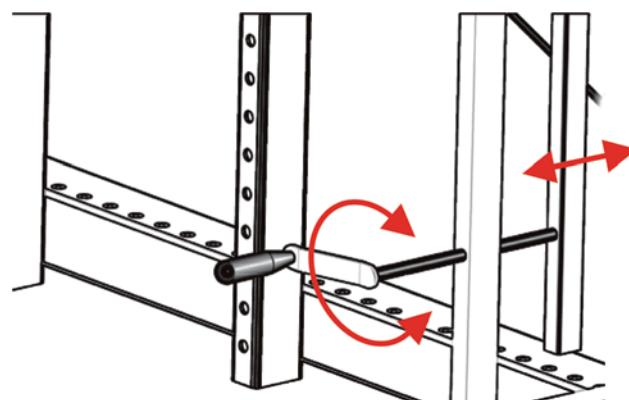
The clamping device serves only to prevent a deflection of the workpiece, and not as an additional pressing device.



Place the clamping device on the top



Mount the clamping device
on the lower position



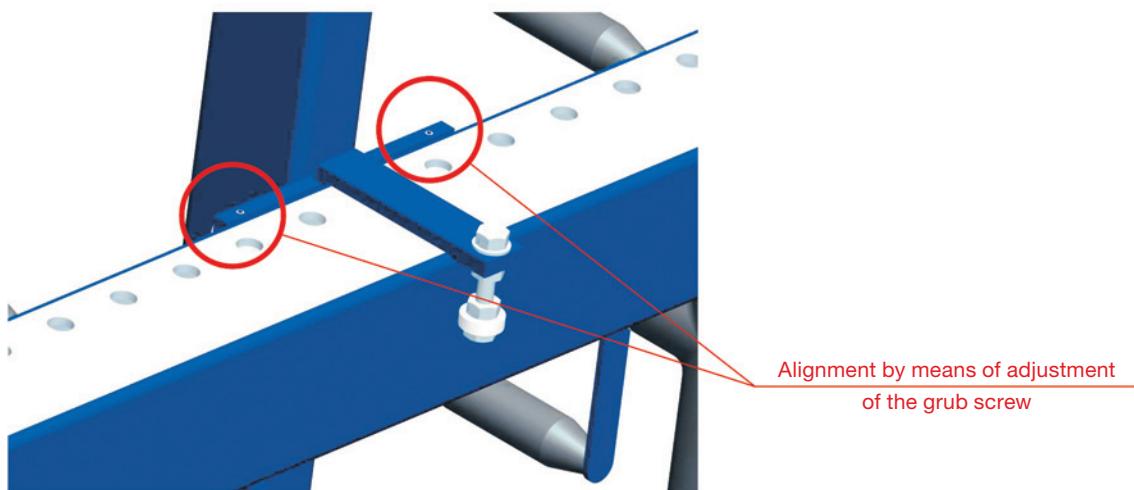
Place the clamping device on the work piece by means
of a crank

Preventive Maintenance

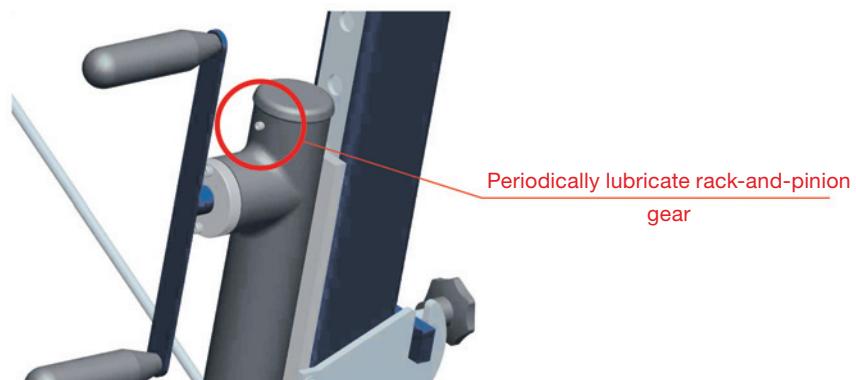


With the Feichtner frame press you have acquired an extremely low maintenance – almost maintenance free device. However, in order to guarantee an optimal performance sequence and to extend the service life of the machine, the following maintenance instructions should be observed.

- 1) Allow glue residues to harden and then scrape them off.
- 2) Clean or remove dust from the surface of the upper profile, the rollers and the hydraulic cylinders occasionally.
- 3) The gauge screws are used to adjust the press arms and can be adjusted by means of an Allen key.



- 4) Occasionally the fastening screws on the frame and on the press arms should be inspected and, if necessary, retightened.
- 5) Regularly lubricate the rack-and-pinion gears on the press arms and on the side pressure device.



Technical Data Sheet

Mounting dimensions (HxW):	1600 x 2900 mm
For frames:	1600 x 2600 mm
Basic equipment:	3 press units with adjustable angle drives 150 mm distance, 3 tons of pressure, 90°-stop Operation manual incl. EU-declaration of conformity
Special accessories:	Side pressure unit with 2 angular gears Holding down clamp device Landing gear (chassis) Pad shoes – long version Swiveling pressure shoes for angle gluing

Machine supplied completely assembled – Accessories on request at the factory or the responsible contractual partner.

Warranty conditions

Warranty claims according to our general terms and conditions:

- The supplier gives a guarantee for his machines of 2 years. However, this only applies to visible design errors and material defects. The supplier shall only be liable for defects of the delivery in such a way that he has to remedy any defective parts of his product free of charge or to deliver it at his own discretion.
 - The warranty period begins on the day of delivery.
 - The defects must be reported to the supplier immediately in writing and the parts concerned must be sent to him on request. Regarding liability for faulty design or defective design; for material defects, the supplier is only liable to the extent that he should have been aware of the defect in the case of application of professional diligence.
 - The supplier is not liable for damages that have arisen for the following reasons:
 - Faulty assembly or setup by the customer or third parties
 - Unsuitable or improper use
 - Normal wear
 - Faulty or careless handling of the machine
 - Excessive use
- The supplier is not obliged to remedy defects, if the customer has not fulfilled his payment obligation.
- Further claims by the customer, in particular a claim for compensation for damages, which are not caused by the equipment itself, do not exist.

Handling of spare parts deliveries during guarantee period:

The customer himself sends the defective part back to us free of charge. The workshop manager assesses the damage and checks whether there is a guarantee claim according to the above mentioned terms and conditions. The spare part is also sent free to the customer when the warranty is granted.

EU-declaration of conformity

The manufacturer

Feichtner Maschinenbau

**Gramsham 2
D-84550 Feichten an der Alz**



declares that the machine described in the enclosed operating manual:

Type: Universal gluing press and mounting device
“RPW 3000 plus”

Brand: Feichtner

Serial number: _____

Manufacture year: _____

complies with the guidelines of Directives 2006/42 / EC (for machinery).

Applied harmonized standards, in particular:

DIN EN ISO 12100-1

DIN EN ISO 12100-2

Gramsham, _____

Signature/Stamp



**Gramsham 2
D-84550 Feichten/Alz**

**Phone +49 8623-7035 · Fax +49 8623-7036
info@feichtner-maschinenbau.de
www.feichtner-maschinenbau.de**