

INSTRUCTION MANUAL

TRANSLATION OF THE ORIGINAL OPERATING INSTRUCTIONS

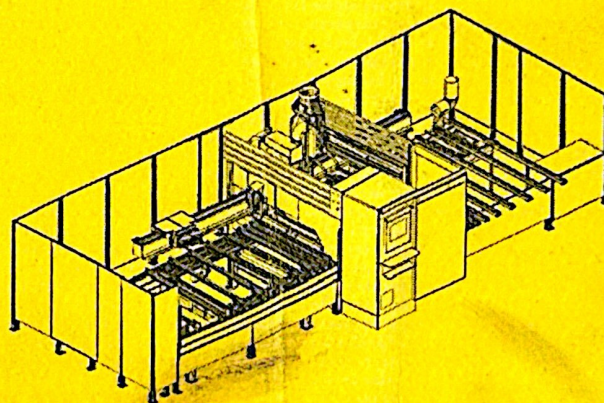
This manual must be kept for future reference and must always remain with the machine

TYPE
UNIFLEX HP

MODEL
UNIFLEX HP

FORA-FRESATRICE A CNNC BORING AND ROUTING MACHINE

**NUMERIC CONTROL BORING - ROUTING MACHINE FOR WORKING WITH WOOD
AND MATERIAL WITH SIMILAR PHYSICAL CHARACTERISTICS**



AA2/004529

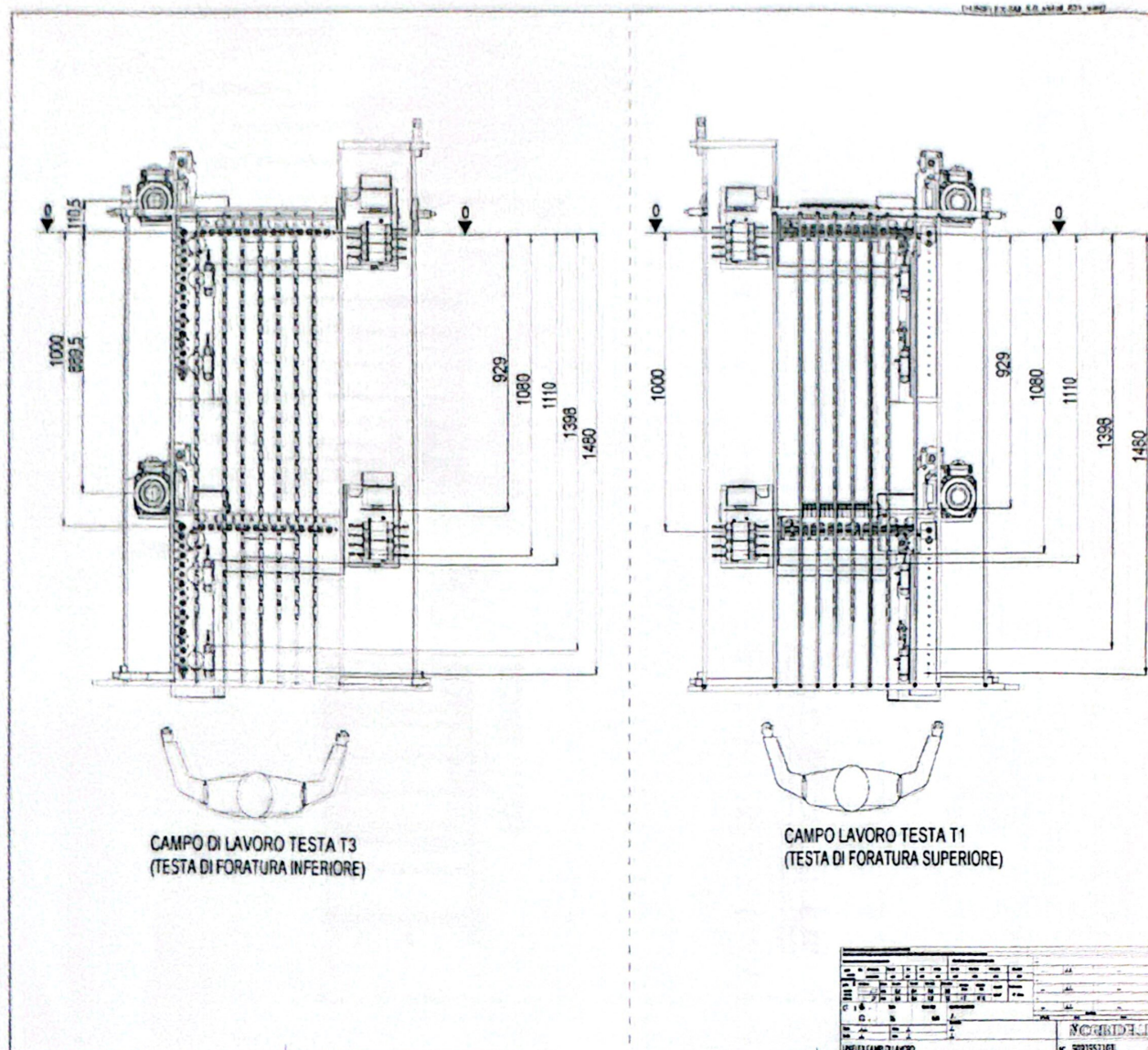
Rel. 6.5 / 20-04-2016

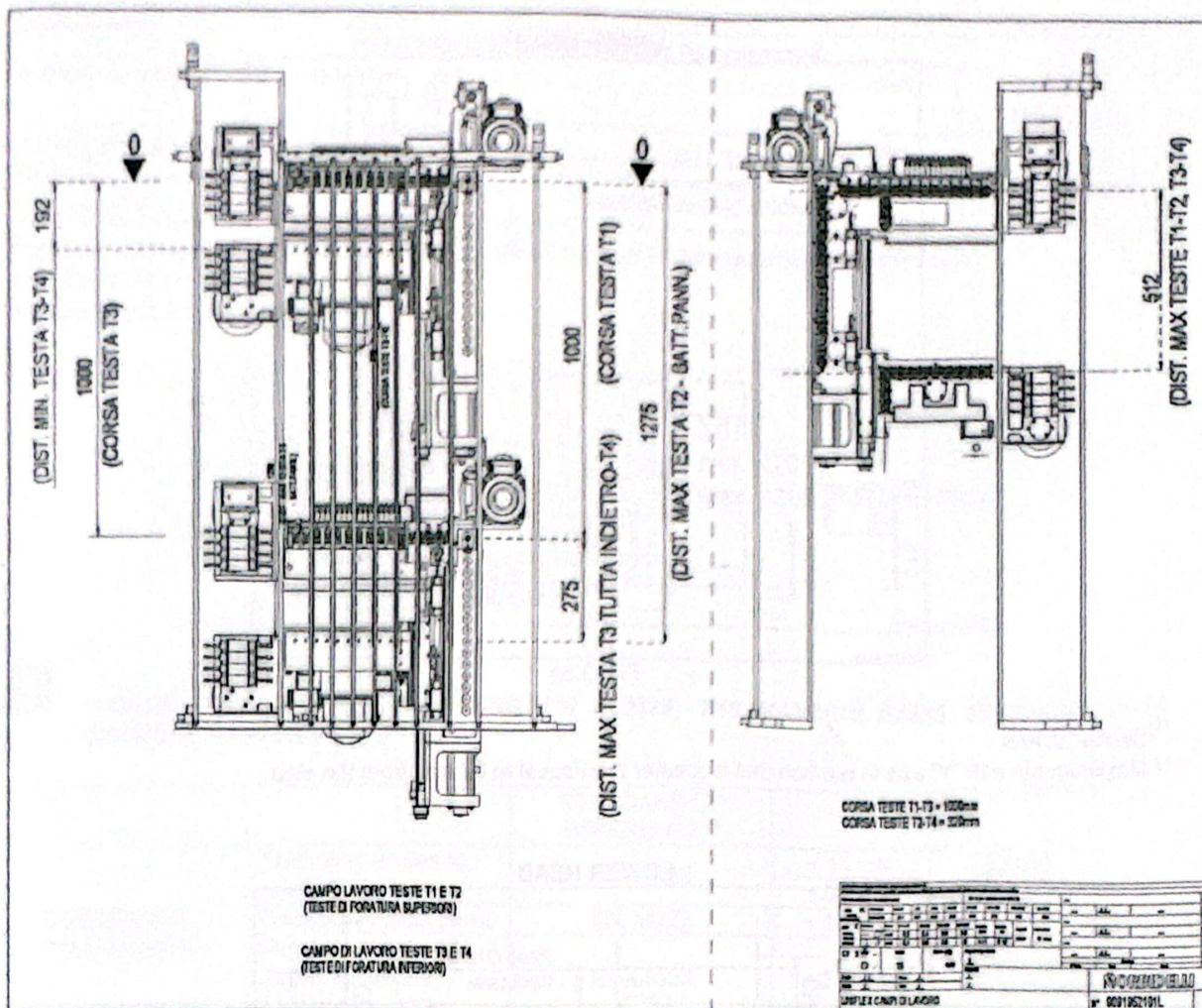
EN

6.3 Machine data

GENERAL TECHNICAL DATA		
Height working table	mm	950
Stroke of "X" - "Y" axes. Refer to section "Work range dimensions"		
Stroke of "Z" axes. Refer to section "Z" Axis Stroke"		
Programmable speed in "X" direction ("X" - "Y" axis)	m/min	120
Programmable speed in "Y" direction ("U" - "V" axis)	m/min	35
Programmable speed in "Z" direction ("A" - "B"-axis)	m/min	30
Overall weight with electrical equipment. Refer to layout plan (section on Overall Dimensions)		
Sound power according to standards ISO / EN : See chap. "Noisiness level"		

6.3.1 Working field dimensions





0.3.1.1 "Z" Axis Stroke

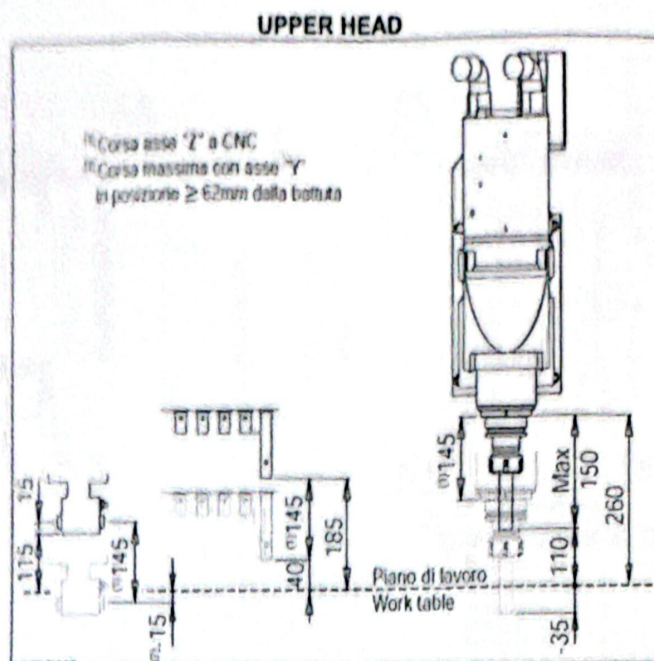


Fig. 3.5a

⁽¹⁾ Stroke "Z" axis

⁽²⁾ Maximum run with "Y" axis in position that is greater than/equal to 62 mm from the stop

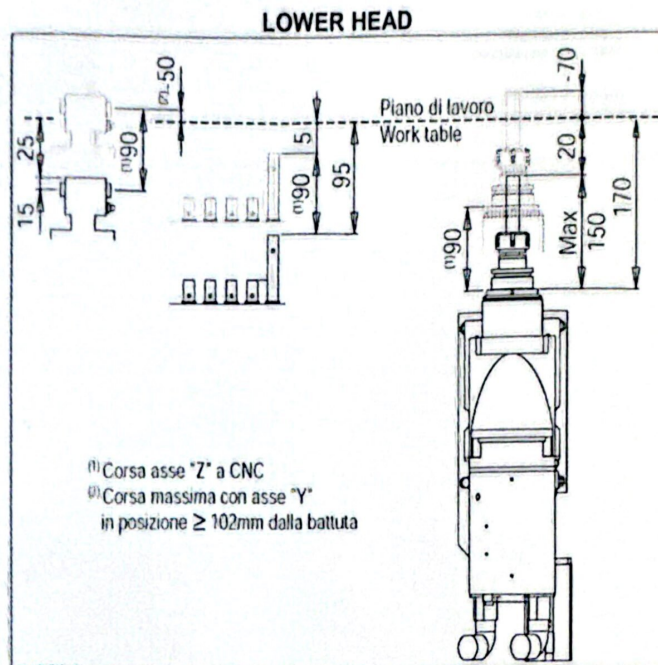


Fig. 3.5b

⁽¹⁾ Stroke "Z" axis

⁽²⁾ Maximum run with "Y" axis in position that is greater than/equal to 102mm from the stop

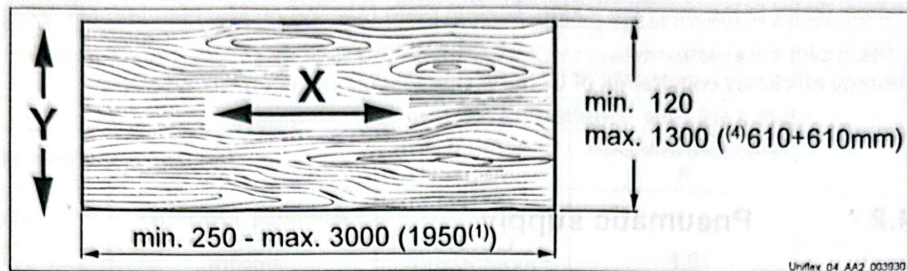
6.3.2 Dimensions of piece to be machined

Dimensions of piece that can be processed		
Minimum / maximum width panel (X)	mm	250/3000 (250/1950 ⁽¹⁾)
Minimum / maximum depth panel (Y)	mm	120 / 1300
Minimum / maximum thickness panels	mm	10/80 ⁽²⁾ - 60 ⁽³⁾
Maximum panels weight	Kg	100

⁽¹⁾ Without needing to take the piece back for handling, referred to the machining a standard side

⁽²⁾ Individual panel

⁽³⁾ overlapping panels (30+30)



(4) NOTE: WITH THE PRELOAD FUNCTION ACTIVE, THE MAXIMUM PANEL DEPTH IN "Y" IS REDUCED TO 610mm

		STANDARD OF REFERENCE**	VALUES	
DIMENSIONAL TOLERANCES	Thickness related to nominal	EN 14323	< 15 mm	> 15 mm
			± 0,2 mm	± 0,3 mm
	Thickness inside panel	EN 14323	± 0,3 mm	
	Planarity (balanced panels thickness >15mm)	EN 14323	< 2 mm/m	

**The latest version of the standards of reference must be taken into account



IT'S FORBIDDEN TO WORK PANELS WITH FEATURES THAT ARE NOT INCLUDED IN THE INDICATED DIMENSIONS

THE MACHINE CAN MACHINE SQUARE OR RECTANGULAR PANELS WHOSE LONG SIDE MUST BE CONSISTENT WITH THE DIRECTION "X" OF THE MACHINING COORDINATES. SQUARE.

MACHINING OPERATIONS ON PARTICULAR PROFILES MUST BE ASSESSED AT THE CONTRACT STAGE

THE MACHINE WITH MANUAL LOADING CAN WORK TWO OVERLAPPED PIECES: THE TOTAL OF THE THICKNESS HAS NOT TO BE HIGHER THAN 60mm

6.4 Energy sources

6.4.1 Electricity

ELECTRIC TECHNICAL SPECIFICATIONS		
Motor power of 12 / 18 spindles drilling head		
Electrospindle power and/or optionals machining units: see specific chap.		
Infeed roller conveyor motor power ⁽¹⁾ (OPT)	kW (Hp)	1.1 (1.5)
Standard power supply	V / Hz	400 / 50-60
Electric connecting cables = 3 Phases + Neutral + Earth		
Rated current in Amps: Refer to the machine's Identification plate (section on Machine Identification)		

⁽¹⁾ Technical data: see motor data plate

Excluded from energy efficiency constraints of Commission Regulation (EC) No. 640/2009

6.4.2 Pneumatic supply

TECHNICAL SPECIFICATIONS compressed air supply and extraction		
Compressed air supply minimum pressure	Bar	7
Working pressure	Bar	6,5
Medium consumption of compressed air	NI/min	1100
Istantaneous max. consumption of the compressed air	NI/min	1640

6.8 Table of noise levels

Working conditions: Drilling (in compliance with EN 848-3)*					
Quantity measured description		Reference standards	Associated uncertainty K	Drilling	
Lop : level of sound pressure at operator stations - dB (A) and peak level [dB(C)]	Operator position	EN ISO 11202:2010	4.0	VSA	LAV
	Infeed			72	75 [95]
	Outfeed			-	-
Lw : level of sound pressure issued : dB(A) _{1 pW} [mW(A)]		EN ISO 3746:2010	4.0	91 [1]	94 [2]
The maximum value of the instantaneous acoustic pressure, C-weighted , is less than 130dB(C)					
VSA No machining without dust extractor equipment			LAV Machining with dust extractor equipment		
* Reference should be made to the test report for the analysis of operating conditions used differently from the standards prescribed above.					

Working conditions: Routing (in compliance with EN 848-3)*					
Quantity measured description		Reference standards	Associated uncertainty K	Routing	
Lop : level of sound pressure at operator stations - dB (A) and peak level [db(C)]	Operator position	EN ISO 11202:2010	4.0	VSA	LAV
	Infeed			73	81 [97]
	Outfeed			-	-
Lw : level of sound pressure issued : dB(A) _{re 1 pW} [mW(A)]		EN ISO 3746:2010	4.0	90 [1]	97 [6]
The maximum value of the instantaneous acoustic pressure, C-weighted , is less than 130dB(C)					
VSA No machining without dust extractor equipment			LAV Machining with dust extractor equipment		
* Reference should be made to the test report for the analysis of operating conditions used differently from the standards prescribed above.					

Declared dual-number noise emission values, in accordance with ISO 4871



NOTE:

The noise values are emission levels and not necessarily safe working levels.

While there is a correlation between emission levels and exposure levels, this is not a reliable parameter for determining whether further precautions should be taken.

The factors which influence the real exposure of the operator include the duration of exposure, environmental features, other sources of emission, e.g. number of machines and other adjacent machining operations.

The exposure level regulations may vary from country to country.

This information should however make it possible for the machine user to make a better assessment of the hazards and risks involved.



EAR DEFENDERS: use when the material being machined or the machining conditions raise the noise level above 80db.

Certain factors that positively affect machine noise level are:

- correct choice of tool
- correct selection of speed
- maintenance of tools and machine

(sp. 170mm)