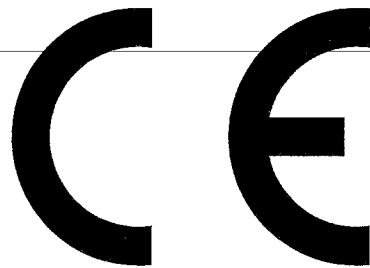


OPERATING INSTRUCTION

INDEX 125/150 LS

MODEL 480

**NC-CONTROLLED DRILLING, GLUING
AND DOWEL INSERTING MACHINE**



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VERSION 00-06

LIST OF CONTENTS

SAFETY INSTRUCTION **PAGE 3**

GENERAL **PAGE 4**

COMMISSIONING OF THE MACHINE **PAGE 5**

PHOTOS WITH DISCRIPTION **PAGE 7**

**ADJUSTMENT OF THE MACHINE
AND WORKING INSTRUCTION** **PAGE 13**

MAINTENANCE INSTRUCTION **PAGE 19**

TECHNICAL DATA **PAGE 20**

ACCESSORIES **PAGE 21**

DIAGRAMS

SAFETY INSTRUCTIONS

Before commissioning the machine please read and understand the following operating instructions. Only trained and authorized personnel should operate this equipment.

Take care of your hands

- do not put your hands near the tools (drill bits) while the machine is running.**
- do not place hands on moving parts.**
- wait until the machine comes to a standstill, before loading or unloading the workpiece into the machine.**

Do not remove electrical and mechanical safety equipments.

**Do not make adjustments while the machine is running.
Disconnect electrical current and pressure supply when doing adjustment or maintenance work.**

When looking for a defect or doing repairs

- ... only ask an authorized expert**
- ... place a warning notice on the machine**
- ... disconnect electrical current and pressure supply**

This machine throws a dowel projectiles and injects glue, which can cause injury. Don't look straight in the direction of the outlet of the inserting station and the glue nozzle.

Never put your fingers direct in front of the outlet of the glue nozzle and the dowel inserting unit.

Always wear eye protection when using the maschine.

Always turn the maschine off before doing any maintenance.

Observe other safety instructions for special equipment.

Do not use the machine, if your are not fully aware of all safety precautions.

GENERAL

SPECIFICATIONS FOR INTENDED USE

You can use the machine for:

- drilling dowel holes, glueing and inserting of dowels with a dowel diametre of Ø6mm - Ø12mm and a dowel length of 25mm - 60mm into particle board, MDF or solid wood.
- No other users are intended and may damage the machine or cause personal injury. Consult the manufacturer before attempting any other operation.

WORK POSITION

To use the machine, the operator must face the front of the machine in reach of the starting buttons and the control console, where the emergency switch is situated.

ENVIRONMENTAL CONDITIONS

Do not use the machine in an environment where there is danger of explosion.

Use the machine at a tempertature range from 5° to 50° Celsius. (41 to 122 F)

Make sure the working area around the machine is clear of debris and obstructions.

GUARANTEE

This machine is designed and built to the highest quality standards. It should provide years of precision use, provided it is used as intended and properly maintained.

In your own interest please carry out the usual inspection of the machine immediately upon delivery. Note any apparent transport damage on bill of lading. If damage has occurred, note the damage to the transport company as well as the dealer or agent from whom you purchased the machine.

~~The guarantee declaration includes only the change over of parts, not the mounting-time and travelling-time of the service technician and no expenses for consequential damages.~~

It is not included in the guarantee:

- * Transport damage (please inform immediately the transport-agent);
- * Damage to the machine caused by improper or inappropriate use
- * Consequential damages;
- * Damages to the working material;
- * Normal wear and tear of parts such as belts, pulleys, gears, bearings, fuses etc.

COMMISSIONING OF THE MACHINE

TRANSPORT AND SET-UP

The delivery of the machine is in an assembled condition. For transport the machine use a forklift or pallet jack under the frame of the machine.

(Machine weight is approximately 2204 lbs = 1000kg)

Clean the machine after unpacking, taking care to remove all surface protectants. Level the machine by using the four(4) leveling bolts (part 1) on the machine base.

ELECTRICAL CONNECTION

The electrical connection must be done by an authorized electrician. The voltage can be found on the serial number plate on the side of the machine. Connect the terminal connection according to the wiring diagram. Fuses for every should be 16 amp.

ATTENTION! Check the direction of rotation of the drillhead. The drill spindle has to turn right. (clockwise)

COMPRESSED-AIR-CONNECTION

The interior dimension of the air supply line should be at least 6 mm. Use only cleaned and unoled compressed air. A quickcoupling is on the maintenance unit (part 20) assembled. Connect the machine with the quickcoupling to the air supply.

The maintenance unit on the machine should be set for 6-8 bar operating range. The machine will not work properly with less than continuous air pressure at the recommended level.

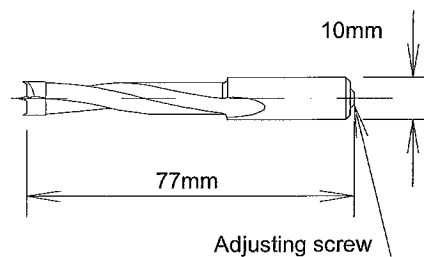
CONNECTION OF THE DUST EXTRACTION

The machine should be connected to a vacuum unit with an air speed of at least 20m/sec. The connection-opening (part 21) is on the lower backside of the machine. The connection diameter of the exhaust is 120mm.

INSTALLING TOOLING IN THE DRILLHEAD

You can use a tooling 77mm lengths (resp. 70mm depending at the order), with a shank diameter of 10mm. Depending of your used dowel diameter you can plug into the chuck the right drill bit. Therefore remove the yellow cover plate and plug in the drill bit. Clamp the drillbit on the flat side of the shaft with the threaded pin. Use only right turning drill bits.

Attention: If you don't use the spindle of the drillhead, put a yellow cover plate on the chuck, for to protect of damage and loosing the threaded pin.



ATTENTION! During maintenance and adjustment work disconnect the machine from the electric and pneumatic power supply.

FILLING OF THE GLUE AND WATER CONTAINER (6 bar glue pressure system)

Attention! Open the pressure container only in pressure-free condition.

You can switch on or off the air-supply direct on the glue container with a slide valve (part 29). Check the pressure-free condition on the pressure containers by lifting the red safety valve on the cover of the pressure container. When the air is completely escaped through the red safety-valve you can open the pressure containers.

Now you can fill in 5 kg of glue (1,5 gallon) and 5 liters of water (1,5 gallon) in the signed pressure container by using the funnel with the filter to protect the container from dirt. Take care, that the air connection at the glue and water containers are fixed well. Make sure when you hang the containers on the left side of the machine that the air and glue-hoses are not cracked.

CHECKING OF GLUE-VISCOSITY

Attention! Take care to use only glue of the correct viscosity 150 m.Pa.s. +/-10% or 28 to 35 DIN-s. Also inform your glue supplier that the glue will be used on dowel inserting machine. This is important that the glue will have the correct chemical components.

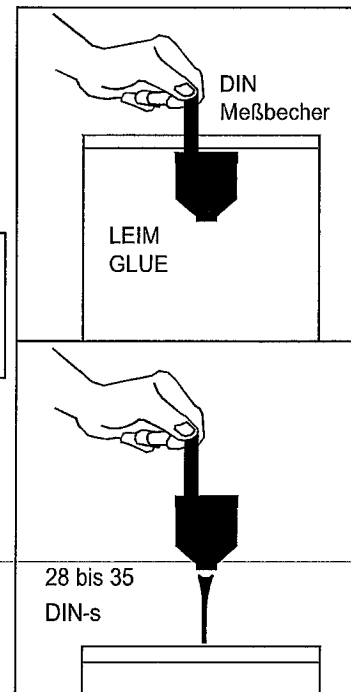
Long storage will cause setting of glue solids. Check viscosity always before refilling the glue. Put the supplied measuring-funnel (100 cm³) completely into the glue-pot and by lifting the measuring funnel check the time it takes for the viscosity gauge to empty. The measured time is called DIN-seconds. (DIN-s)

FILLING OF THE GLUE AND WATER CONTAINER (30 bar high pressure system)

High pressure systems are special accessories and are available in 2 versions.

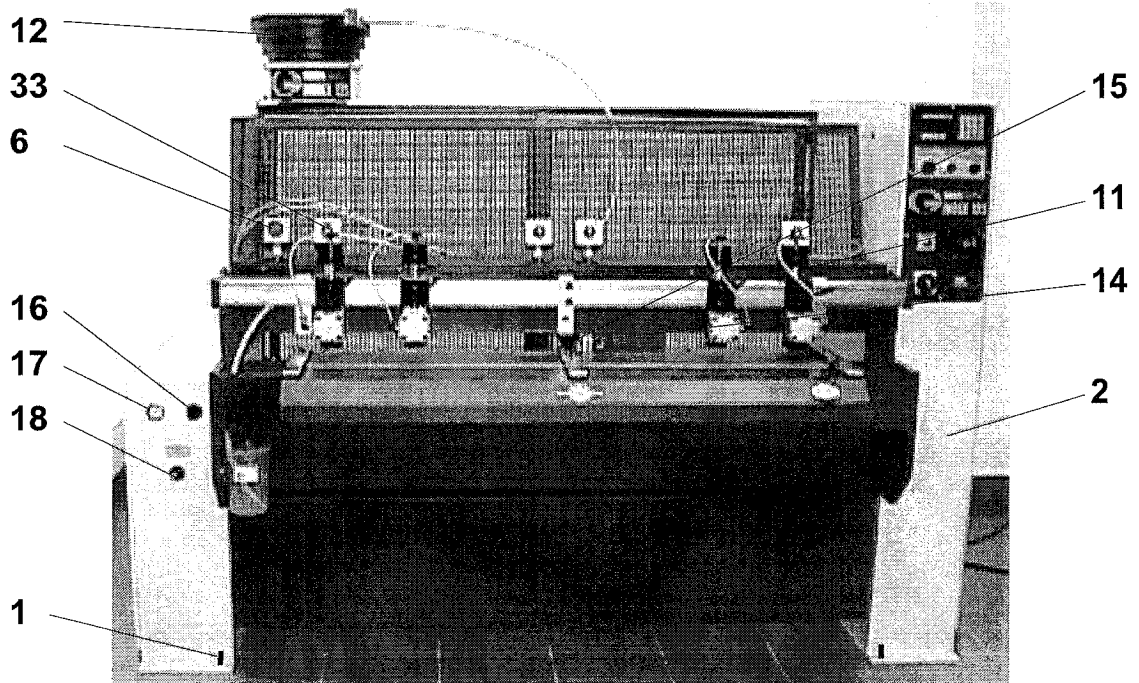
1. The integrated high pressure pump is taking the glue and the water out of the same pressure containers as used by the 6 bar glue pressure system. In this case the glue pump is mounted on the left side of the machine. The pump is working at a conversion from 5:1. and can supply a volume of 29cm³ per double-stroke. On the left frontside of the machine all necessary installations can be carried out. Glue water selector switch, pressure regulator for the high pressure glue pump (2-6 bar). (adjusted pressure multiplied by 5 gives the working pressure) The filling of the glue and water container are carried out as by standard 6 bar pressure system.
2. The external high pressure pump is working at a conversion from 5:1 and can supply a volume of 110 cm³ per double stroke. This pump is mounted on a separate stand and take the glue out of a 30 kg (9 Gallon) plastic glue pot. The pressure regulator on the pump should be set between 2 - 6 bar. (Installed pressure multiplied by 5 gives the actual glue pressure.) A water container for 5 liter (1,5 Gallon) water is used instead of the glue container for cleaning of the glue pumps.

Attention: With the high pressure system you can use a glue with a viscosity of max. 1500 m.Pa.s.

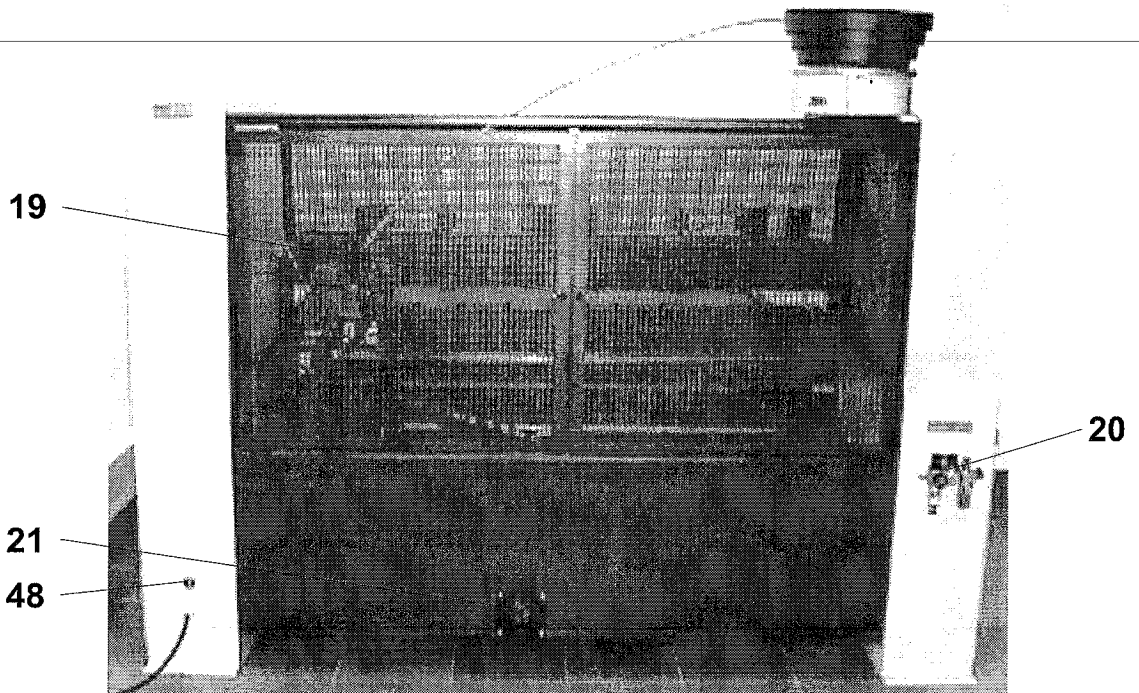


PHOTOS

Pic.1 Frontview

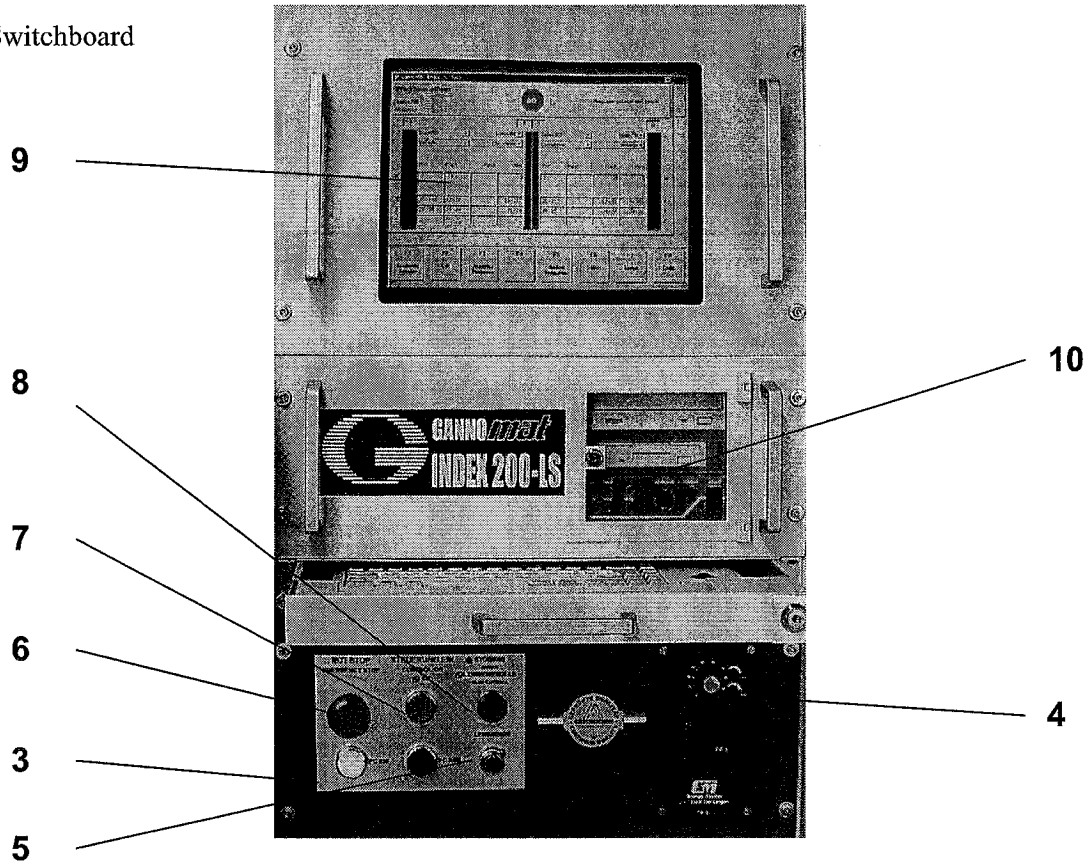


Pic.2 Backview

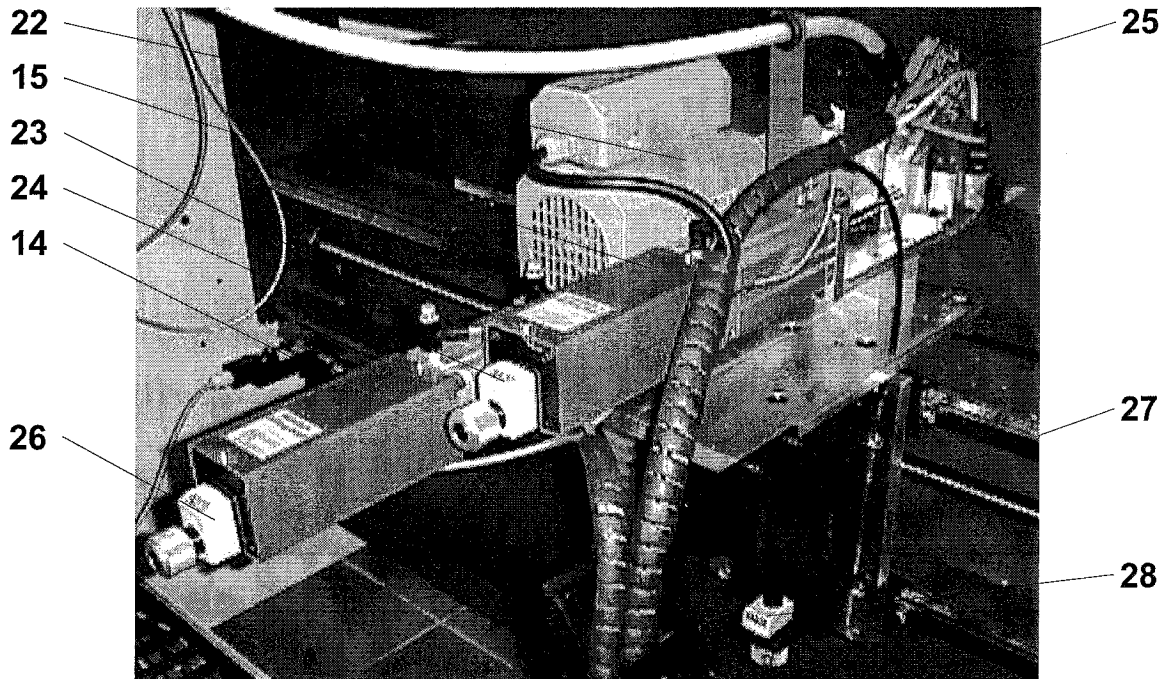


PHOTOS

Pic.3 Switchboard

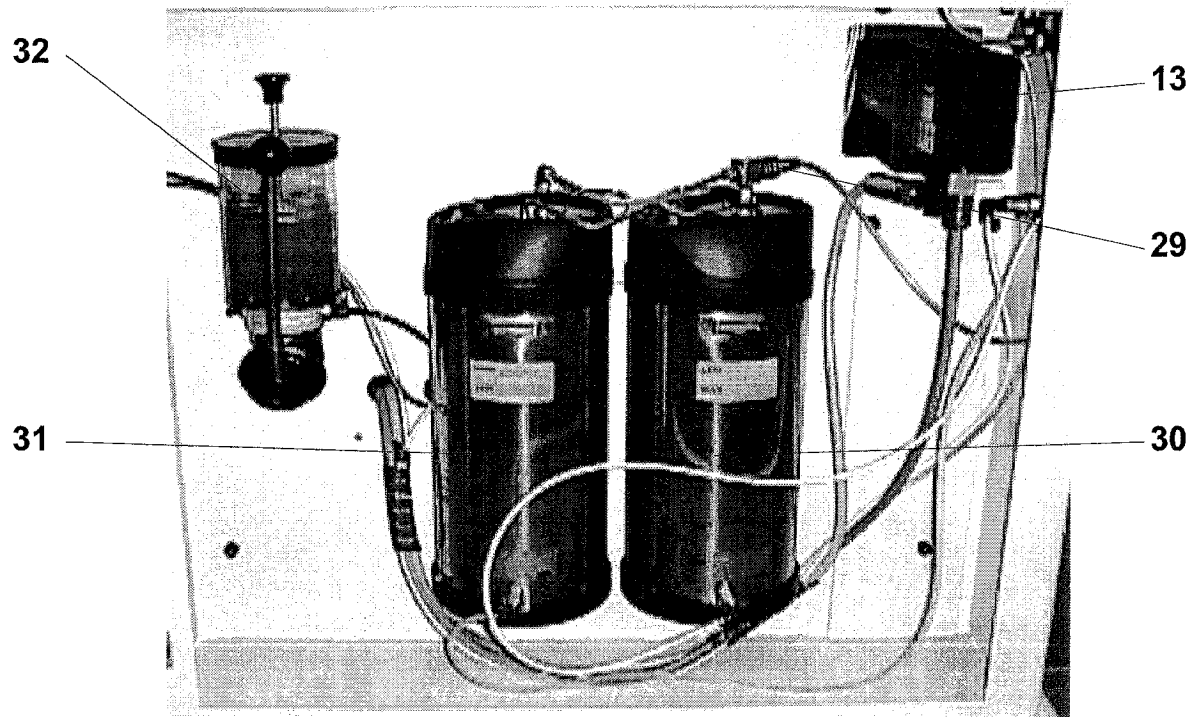


Pic.4 Workingunit

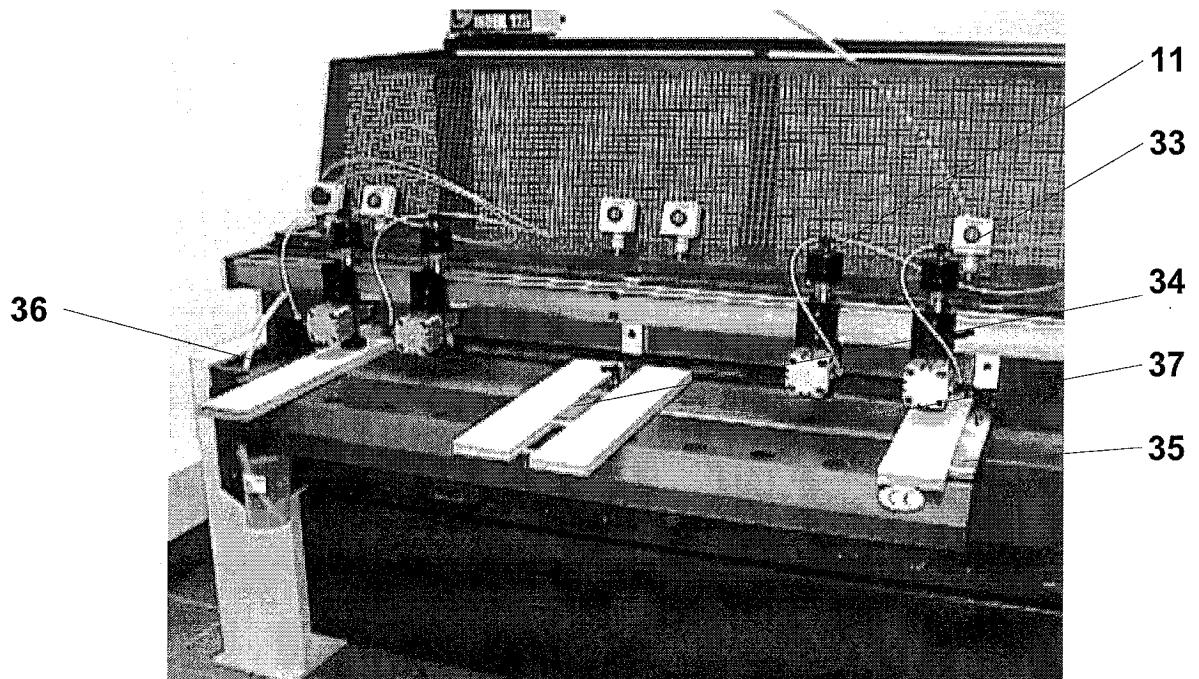


PHOTOS

Pic.5 Glue / watercontainer

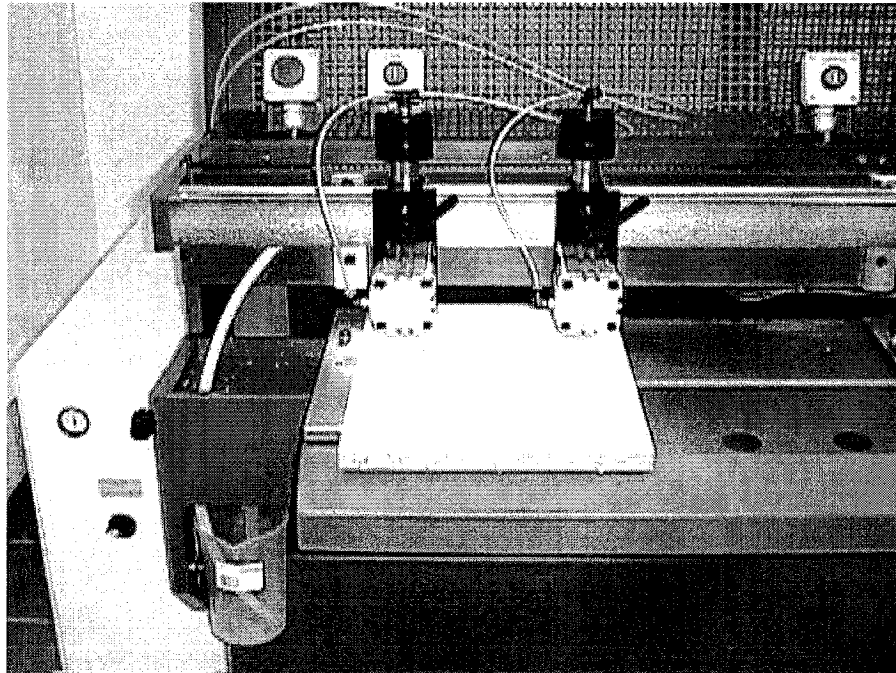


Pic.6 Workingsupport

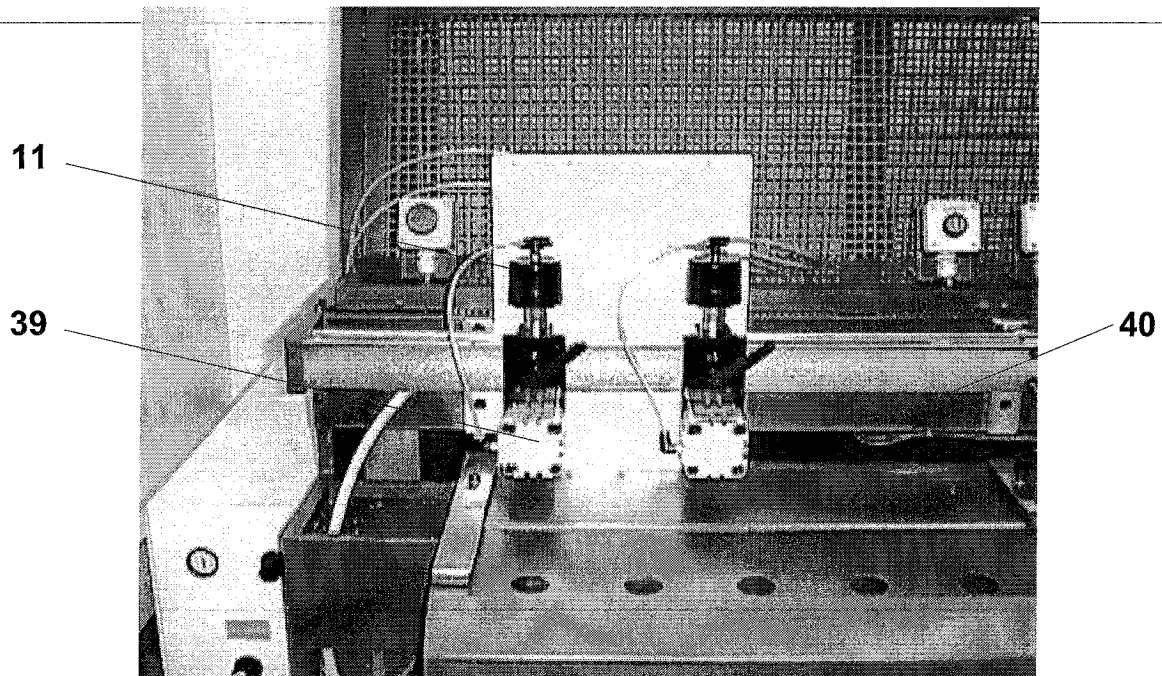


PHOTOS

Pic.7 Faceside drilling, glueing and inserting

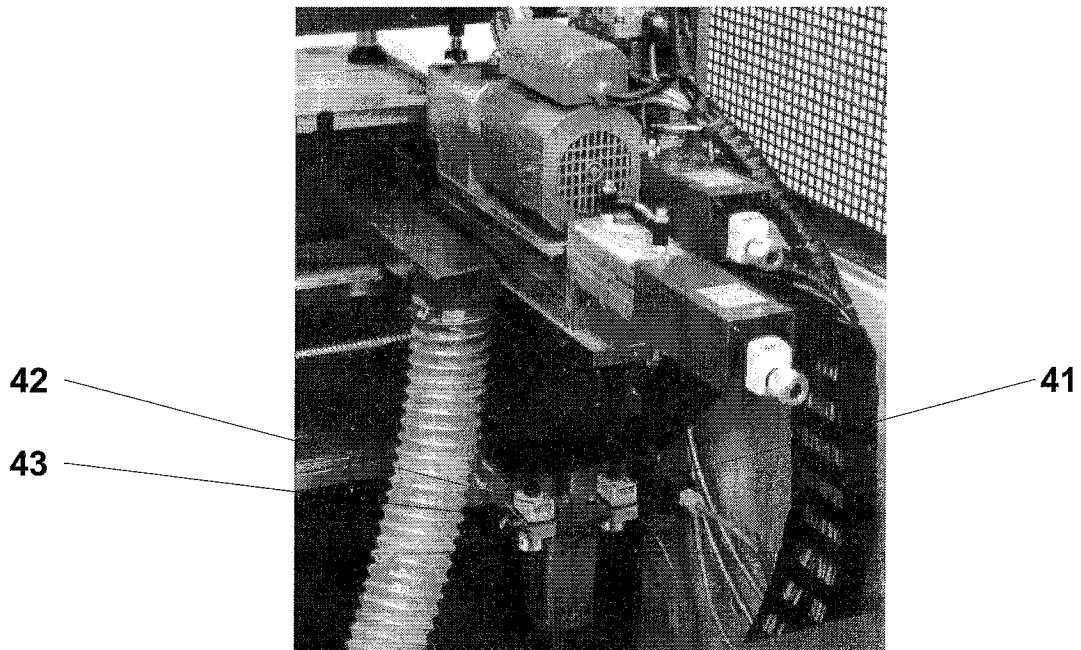
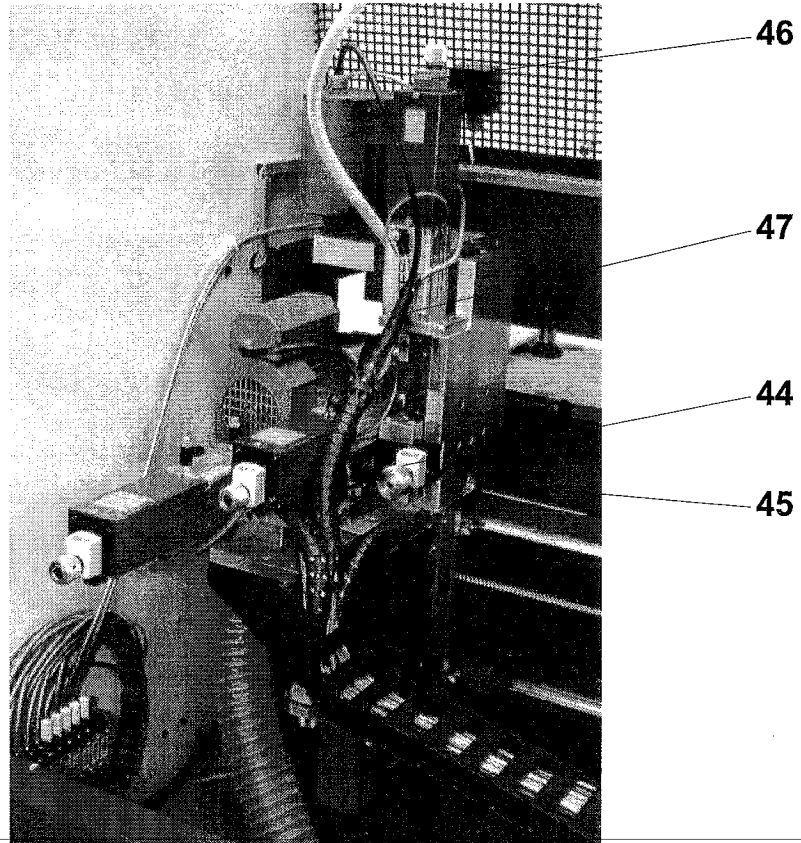


Pic.8 Flatside drilling



PHOTOS

Pic.9 Vertical drilling from the top resp. peumatical height adjustment for 2 levels Z - axis



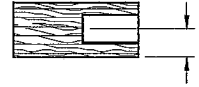
DISCRIPTION OF THE PHOTOS

1	Adjusting screw	25	Dowel selection unit
2	Elektric switchbox	26	Digital counter drilling depth
3	PC ON and OFF switch	27	Clamping lever position adjustment
4	Hopperfeed regulator	28	Digital counter position adjustment
5	Glue amount regulator	29	Slide valve
6	Emergency stop	30	Glue container
7	Control on switch	31	Water container
8	Glue control lamp / Error indicator lamp	32	Lubrication unit
9	15“ VGA display	33	Start button
10	Industrial PC, HDD, FDD, CD ROM	34	Central stop
11	Vertical clamping cylinder	35	Stop right
12	Hopper feed	36	Stop left
13	Brushless servo motor	37	Working support
14	Drilling unit	38	On /Off switch hopper feed
15	Glueing and inserting unit	39	Horizontal clamping cylinder
16	Glue / water pressure regulator	40	Support for flatside drilling
17	Pressure gauge	41	Digital counter down position
18	Selector switch glue / water	42	Digital counter up position
19	Safety switch	43	Brass clamp screw
20	Maintenance unit	44	Digital counter position vertical unit
21	Exhaust tube connection	45	Brass clamp screw
22	Drilling motor	46	Digital counter drilling depth vertical unit
23	Feed speed regulator	47	Feed speed regulator
24	Digital counter inserting depth	48	Board RS 232

ADJUSTMENT OF THE MACHINE AND WORKING INSTRUCTION

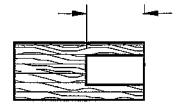
ADJUSTMENT OF THE HEIGHT POSITION OF THE DRILLING AND INSERTING UNIT (manual adjustment)

For to adjust the position of the drilling and inserting unit you have to open the safety gate at the backside of the machine. The safety switch (part19) at the gate gives a signal to the control and the machine cannot work. The height position can be adjusted with the digital counter (part28) at the lower backside of the drilling and inserting unit from 5mm till 40mm. For to adjust the position you have first to open the clamping lever (part27) above the digital counter and then you can adjust the position with the digital counter. Then rethighten the unit with the clamping lever.



ADJUSTMENT OF THE BORING DEPTH

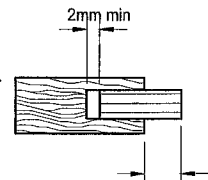
For to adjust the drilling depth you have to open the safety gate at the backside of the machine. The safety switch (part19) at the gate gives a signal to the control and the machine cannot work. The boring depth can be adjusted with the digital counter (part26) at the drilling unit.



Remember: You have to use a 77mm long drill bit. Only then fits the real drilling depth to the indicated drilling depth at the digital counter.

ADJUSTMENT OF THE DOWEL INSERTING DEPTH

For to adjust the inserting depth you have to open the safety gate at the backside of the machine. The safety switch (part19) at the gate gives a signal to the control and the machine cannot work. The inserting depth can be adjusted with the digital counter (part24) at the inserting unit.



ADJUSTMENT OF THE DRILLING SPEED

The regulators for the forward and backward speed of the drilling cylinder are situated direct at the drilling cylinder. These throttle valves (part23) are screwed in at the exits of the drilling cylinder. The ideal speed is already set at the factory but for different working conditions you can adjust the drilling speed.

ADJUSTMENT OF THE CLAMPING CYLINDER

For safety purposes, the vertical clamp cylinders (part 11) have a maximum stroke of 10mm. After determining workpiece thickness, set the pressure pads of the clamp cylinders to a maximum 3-5mm above the workpiece surface. Tighten the clamping lever on the clamping cylinder holder. The horizontal clamp cylinders (part39) are fixed at the same clamp cylinder holder as the vertical clamp cylinders. The horizontal clamp cylinders have a stroke of 15mm. The max. workpiece thickness for flatside drilling is 20mm.

HOPPER FEED

With the on/off switch (part38) you can switch on the hopper feed. If the hopper feed is switched on and the machine isn't used for a while, the hopper feed switches off after 1 minute. If you start again the machine, the hopper feed starts automatically.

ADJUSTMENT OF THE INSERTING UNIT

Function:

The dowels are coming from the hopper feed through the dowel supply till the dowel stop cylinder. When you insert a dowel, the dowel selection cylinder clamps the dowels which are coming from the hopper feed. The dowel stop cylinder release, one dowel falls down into the guide sleeve and is ready to insert. Meanwhile the dowel stop cylinder moves out and the dowel selection cylinder release. Now is the inserting unit is ready to select a new dowel.

Take care, that the dowel feed tube is always completely filled. Use always dowels with the best possible quality, for the keep the machine free of errors.

You can use dowels with a length of 25 - 60mm.

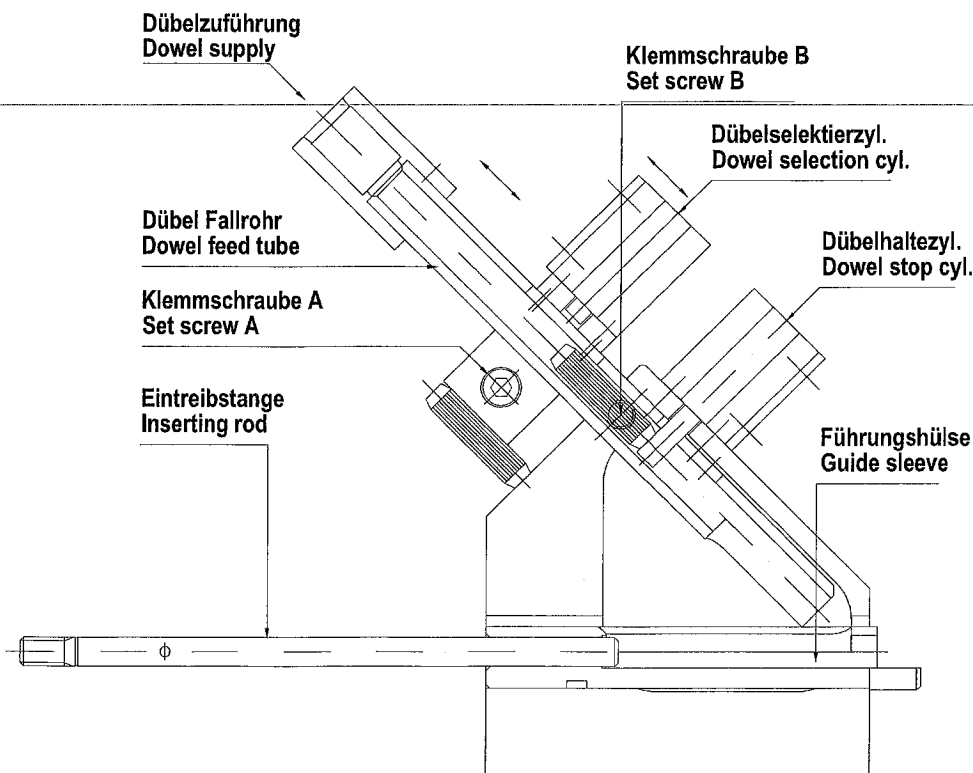
Adjustment of the inserting unit for a dowel length of 25 - 45mm:

Release the set screw A and put a 25 - 45mm long dowel to the holder of the dowel selection cylinder, as shown down at the drawing. Clamp the holder again, that the end of the dowel and the holder is at the same level.

Adjustment of the inserting unit for a dowel length of 45 - 60mm:

Adjust the dowel selection cylinder to a length of 45mm like the description above. If you release the set screw B, you can move the complete feed tube 15mm to the back. Put a 45 - 60mm long dowel to the holder of the dowel selection cylinder, as shown down at the drawing. Clamp the feed tube again, that the end of the dowel and the holder is at the same level.

If you have a too long dowel into the feed tube, the dowel cannot fall out of the inserting unit and blocks the system. At the software instruction point 5 system functions / dowel ejection you can read, how you can eject a too long dowel.



GLUE AMOUNT REGULATOR

With the glue amount regulator (Part5) you can adjust the glue amount infinitely.

GLUE/WATER SELECTOR SWITCH

By this selector switch (Part18) you can choose between GLUE or WATER. When you move the switch to stop position the glue- and water-container will be blocked.

USE OF THE PROGRAMS

You can work with the machine with the programs

- Cleaning**
- Drilling**
- Drilling-Glueing**
- Glueing-Inserting**
- Drilling-Glueing-Inserting**

Cleaning:

The program "CLEANING" is used for washing the glue lines and the nozzle. For perfect maintenance we recommend to wash every day. To carry out the washing mode look at the programming instruction how to operate. At the machine you have to switch the selector switch "GLUE/WATER" to position "WATER" and push the starting button till clear water will escape out of the nozzle. To set the machine back for standard use switch selector switch "GLUE/WATER" to position "GLUE", and push the starting button till clear glue will escape out of the nozzle.

Drilling:

At the program „DRILLING“ the machine drills only holes into the preprogramed positions. To carry out the drilling mode look at the programming instruction how to operate.

Drilling-Glueing:

At the program „DRILLING-GLUEING“ the machine drills holes into the preprogramed positions and inserts glue according to the glue amount what you have selected. The glue is inserted by 6 bar pressure-system what will guarantee straight and clear glue-shot. If you have to less glue into the glue container the glue control lamp (part8) begins to flash. To carry out the drilling-glueing mode look at the programming instruction how to operate.

Glueing-Inserting:

At the program „GLUEING-INSERTING“ the machine inserts glue according to the glue amount what you have selected into predrilled holes and inserts a dowel into this hole. Take care, that the position of the predrilled holes fits to the programed positions for the glueing-inserting operation. To carry out the glueing -inserting mode look at the programming instruction how to operate.

Drilling-Glueing-Inserting:

At the program „DRILLING-GLUEING-INSERTING“ the machine drills holes into the preprogrammed position and inserts glue according to the glue amount what you have selected into predrilled holes and inserts a dowel into this hole. To carry out the drilling-glueing -inserting mode look at the programming instruction how to operate.

STARTING OF THE DRILLING, GLUEING AND INSERTING PROCESS

You can use 4 working areas at the machine. (pic.6) For every working area (stopping edge) you have a separate starting button. Till a workpiece width of 300mm you can put 4 workpieces at the machine and till a workpiece width of 600mm you can put 2 workpieces at the machine. The max. working width is 1250mm. If you want to machine a workpiece which is larger than 600mm you have to disassemble the center stop. (part34)

The machine must be connected to the electric and pneumatic power supply and the main switch (part3) has to be switched on. Condition to start the machine is, that you have send first a program to that working area you want to use.

Activate the start of the drilling or drilling, glueing and inserting process with that starting button (part33) which fits to the working area you want to use. After the start button is pushed the automatic operating starts. This means that the clamping cylinders are activated, the drilling, glueing and inserting process starts. When this process is finished, the clamping cylinders release.

The **EMERGENCY SWITCH** (part6) stops any machine function and the drill head and the inserting station automatically goes to the rest position. To restart the machine the emergency switch must be turned counter clockwise as marked on the switch. Also the **CONTROL ON** button (part7) has to be pushed again for to reactivate the control of the machine.

If you push the emergency button the loaded programs at the working memory (RAM) of the control are canceled. This means, that you have to reload the wished programs too.

The **SAFETY SWITCH** (part19) at the safety gate at the backside of the machine has the same effect as the emergency switch. The safety gate must be closed to operate this machine. Don't remove this safety equipment.

If you push the **CONTROL ON** (part7) button during the machine is working the machine stops and the activated clamping cylinders release. For to restart, activate again the starting button. The loaded program starts again from the beginning.

FACE SIDE MACHINEING: (pic. 7)

For to drill, glue and insert dowels into the face side of a workpiece, you have to put the workpiece regular at the supporting table (part37) and against a side stop. (part34,35,36) When you start the working process the vertical clamping cylinders (part11) are clamping the workpiece.

FLAT SIDE MACHINEING: (with the horizontal drilling unit (optional)) (pic. 8)

For to drill into the flat side of a workpiece, you have to put the workpiece from the top between the clamping cylinders and support for flat side drilling (part40) at the supporting table and against the side stops for flatside drilling. When you start the working process the horizontal clamping cylinders (part39) are clamping the workpiece.

For information: The vertical and the horizontal clamping cylinders are moveing out always together.

ADJUSTMENT OF THE HEIGHT POSITION OF THE DRILLING AND INSERTING UNIT Z - axis pneumatic adjustment for 2 levels (optional) (Pic. 9)

For to adjust the position of the drilling and inserting unit you have to open the safety gate at the backside of the machine. The safety switch (part19) at the gate gives a signal to the control and the machine cannot work. The upper resp. lower height position can be adjusted separately, with the digital counters at the lower backside of the drilling and inserting unit from 5mm till 40mm. First you have to loose the brass clamp screw (part 43) at the lateral side of the digital counters. With the left digital counter (part 41) you can adjust the lower and with the right digital counter (part42) you can adjust the upper position. If the drilling and inserting unit is at the lower position, you can adjust the upper position height. If the drilling and inserting unit is at the upper position, you can adjust the lower position height. Then retighten the brass clamp screws (part43). You can switch the lower resp. upper position at the keyboard at the front of the machine independent of the program with a switch.

ADJUSTMENT OF THE HEIGHT POSITION OF THE DRILLING AND INSERTING UNIT Z - axis motorized adjustment (optional) (Pic. 9)

With this solution you can adjust the position height with the control board (keyboard and display) from 5 - 40mm with the motorized Z-axis. You can adjust the position height at the front of the machine with the keyboard and the display depending from the order solution, program dependent or program independent. How to adjust the position height, you can find at the software instruction.

LUBRICATION HINT: Take care, that the threaded spindle of the Z-axis adjustment will be lubricated every 100 operating hours with graphite grease at the lubrication nipple.

GLUE INSERTING CONTROL G.I.C. (optional)

This system checks electronically, if glue leaves really the glue nozzle or not. Supposition, that this system works is, that it is switched on (software instruction) and in the used program glueing is programmed. If no glue leaves the glue nozzle at some reasons (maybe the glue container is empty or the glue nozzle is dirty), you have to work after the following mode of operation.

- The drilling and inserting unit comes to a standstill, the CONTROL ON button and the GLUE CONTROL LAMP / ERROR INDICATOR LAMP begins to flashing.
- Push the CONTROL ON button ⇒ The workpiece will be ready drilled, but no glue will be injected and no dowel will be inserted. - The unit will move to the middle of the left working field and the clamping cylinders are open.
- Remove the workpiece - , push the CONTROL ON button again. ⇒ The dowel, who is already at the brass guide will thrown out. After that the unit will move to the most left position. (cleaning position)
- Repair the error through cleaning of the glue nozzle or refilling glue. If you push the starting button for working field 1, you can activate the glue nozzle for cleaning as long as you push the starting button (like cleaning mode)
- Push the CONTROL ON button again. ⇒ The machine is again ready for working and the CONTROL ON button and the GLUE CONTROL LAMP / ERROR INDICATOR LAMP finish to flash.

DRILLING WITH THE VERTICAL DRILLING UNIT FROM THE TOP (optional) (pic.9)**ADJUSTMENT OF THE POSITION**

For to adjust the position of the drilling and inserting unit you have to open the safety gate at the backside of the machine. The safty switch (part19) at the gate gives a signal to the control and the machine cannot work. The position can be adjusted with the digital counter (part44) at the backside of the drilling unit from 5mm till 40mm. For to adjust the position you have first to open the brass clamping screw (part45) at the lateral side of the digital counter an then you can adjust the position with the digital counter. Then rethighten the unit with the brass clamping screw.

ADJUSTMENT OF THE DRILLING DEPTH

For to adjust the drilling depth you have to open the safety gate at the backside of the machine. The safty switch (part19) at the gate gives a signal to the control and the machine cannot work. The drilling depth can be adjusted with the digital counter (part46) at the drilling unit.

The drilling depht applies to the axis of the horizontal drilling unit. This means, if you adjust the drilling depht at 0mm, the vertical drilling unit drills exactly to the centre axis of the horizontal drilling hole.

Remember: You have to use a 77mm long drill bit. Only then fits the real drilling depth to the indicated drilling depth at the digital counter.

ADJUSTMENT OF THE DRILLING SPEED

The regulators for the forward and backward speed of the drilling cylinder are situated direct at the drilling cylinder. These throttle valves (part47) are screwed in at the exits of the drilling cylinder. The ideal speed is already set at the factory but for different working conditions you can adjust the drilling speed.

How to program the vertical drilling unit, you can find at the software instruction.

MAINTENANCE INSTRUCTION

CONTROL OF THE MAINTENANCE UNIT

The maintenance unit performs important functions which are essential to the operation of the machine.

Air pressure must be adjusted to 6-8 bar/85-112 PSI.

The maintenance unit (part20) consists of a regulator, a pressure gauge, a water separator vessel which filters out the condensed water trapped in compressed air and an oiler. Too much water and/or dirt in the compressed air can hinder the function of the machine. The water vessel must be regularly checked and emptied through opening of the drain screw when necessary. The oiler supplies the pneumaticsystem with a thin oil film. The oiler on the maintenance unit is already adjusted for the right oil amount and is marked on that position. Take care, that always much enough oil is present in the oilglass of the maintenance unit. Use common hydraulic oil for the oiler.

GREASE RECOMMENDATION

The drillhead must be lubricated at the nipples **only** with **OMV RENOLIT UNITEMP 2** grease every 500 operating hours therewith the machine work accurate.

The guide bearings of the drilling and inserting unit have to lubricate every 100 operating hours with bearing grease at the lubrication nipples.

LUBRICATION HINT for the motorized Z-axis:

Take care, that the threaded spindle of the Z-axis will be lubricated every 100 operating hours with graphit grease „Molycote BR 2 Plus“ at the lubrication nipple of the spindle.

LUBRICATOR UNIT

The lubricator unit (part32) is used for the lubrication of the drive spindle of the axis. You should lubricate the drive shaft every 100 operating hours. The lubricator unit is situated on the left side of the machine. For to lubricate the spindle pull the lever once down. The lubricator unit is filled with bearing grease. For to refill the grease container lift the cover and put the grease in.

CLEANING

Regulary cleaning is a requirement therewith the machine works without any problems.

GLUE AND WATER CONTAINER

Set the pressure regulator (part16) at the left side of the machine at 4 to 6 bar for the glue and the water container. By refilling of glue or water in the container make sure to use the funnel with the filter to protect the containers from dirt and clean approx. every six months glue and water container completely.

If your delivered glue amount is not correct please check glue viscosity, check, that the glue and water lines are not cracked, clean the whole system with water by using program "**CLEANING**" (Programing instruction) and check, that no dirt or hard glue particles are in the glue or water container.

DOWEL SELECTION OF THE MACHINE

Make sure that the hopper feed (part12), the dowel channel and the dowel selection unit (part25) are always clean of dirt to guarantee trouble-free operation.

THE GLUE NOZZLE

Make sure that the glue nozzle and dowel guide at the front of the inserting unit are always clean and free of glue particles to guarantee precise glue-shots and trouble-free function.

ELECTRONICAL CONTROL-UNIT

The IPC control-unit (Industrial Personal Computer) will check and coordinate all functions of the machine. The LED's on the electronical control-unit will inform you about all inputs and outputs which are activated and has the feature of a self-diagnostic-system. (input/output).

TECHNICAL DATA

Drilling motor power rating:	0,75 KW
Rotation per minute of the drilling spindle:	8000 U/min
Noise:	< 85 dB
Working length of the NC axis:	1250mm
max. speed of the NC axis:	75m/mim
Working heigh	900mm
Position height	5-40mm
Drilling depht	max. 50mm
Dowel length ouside the panel	5-15mm
Clampinghigh max. workpiece-thickness	80mm
Dowel-diameter	6,8,10,12mm
Dowel lengh	25 -60mm
Toolshankdiameter	10mm
Weight	1000 kg (2204 lbs) net
Place demand	2,50 m x 1,30 m x 1,70 m
Pressure-consumption per workcycle	ca. 1,2 l
Pressure-connection	6-8 bar/85-112 PSI

Producer:

GANNER Maschinenproduktion - GmbH.

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ACCESSORIES

NC-CONTROLLED DRILLING, GLUING AND DOWEL INSERTING MACHINE GANNOMAT "INDEX 125"

complete in standard equipment with:

- Boring/Inserting aggregate travel on profile bearing guides with
1 pcs. Single spindle boring unit, motor 0,75 KW, spindle speed 8000 R.P.M. and
1 pcs. Blowing-, Gluing- and Dowel Inserting unit
for dowel Ø 8 mm, dowel length 25-60 mm
- Central lubrication
- X-Axis NC-controlled, with working width 1250 mm, travel speed 75 m/min
- Z-Axis manual setting by digital counter, position from working table 5-40 mm
- Y-Axis manual setting by digital counter, boring depth from 0-50 mm, outstanding dowel length 5-15 mm
- Closed gluing system with 6 bar glue pressure
- Setting of glue amount by potentiometer through electronic control
- Selector switch GLUE/WATER for easy rinsing of the entire system
- 1 pcs. stainless steel pot for 5 kg glue (1 ½ gallons) and 1 pcs. stainless steel pot for 5 litres water (1 ½ gallons)
- Glue container control light for indicating low volume of glue in the glue pot
- Stopping system consists of:
1 pcs. right-hand stop, 1 pcs. left-hand stop and 1 pcs. center stop (all removable)
4 pcs. starting buttons for individual working of 1-4 workpieces
- 4 pcs. pneumatic clamping cylinder for workpiece thickness max. 80 mm
- 1 pcs. exhaust device, Ø 80 mm
- Control by IBM compatible industrial PC
- Programming by menu-based-software, boring patterns are free programmable by ABSOLUTE-, RELATIVE- or PITCH PROGRAMMING, automatic mirror-image programming and working process optimization.
Variable programming of right-hand and left-hand work zones.
Clear text on-screen identification of programme errors.
- Electrical requirements 400 V/3 ph/50 c.p.s., (2,75 kW, 12 A)

Order.-No.

0480-0000

ACCESSORIES:

- | | | |
|---|--|------------|
| 1 | Modification-kit for the 1 pc. dowel inserting unit
for dowel Ø 6 mm or 10 mm or 12 mm (on choice) | 0480-2000 |
| 1 | Fixture for the face drilling of small work pieces, vertically clamped | 0480-0820 |
| 1 | Single spindle top boring unit for face drilling
0,75 KW, 5.000 U/min (e.g. Häfele Minifix) | 0480-0830 |
| 1 | Mitre stop 45 ° | 0480-0860 |
| 1 | Electronic inductive glue insert control system G.I.C.
for 1 pc. glue nozzle | 0480-0880 |
| 1 | Upcharge for machine with special voltage (e.g. 220 V/3 ph/60 c.p.s.) | 0480-0170 |
| 1 | Graphic supported programming system for external PC for WIN 3.11 or WIN 95
for data transfer by serial link including software | |
| 1 | Internal floppy disc drive FDD 1,44 MB | |
| 1 | NE 2.000 compatible network card including software | |
| 1 | Bar code reader for automatic loading of programme numbers | on request |

