

PNEUMATIC FOLD CLOSER

Model with auto stop



USER MANUAL

Introduction

The closer can be used with most types of folding machines type M82 VM 84 and others of the same design. The design of the closer is such that the air supply affects only the closer's speed. The result is not affected by a lower quantity of air. It is affected only by the mechanical adjustment of the air pressure.

Patented closing procedure that results in a minimum of damage to painted surfaces.

This user manual is provided together with the fold closer.

Information

Manufacturer: Lima Besparingssskog
SE-780 64 Lima, Sweden
Tel: Int + 46 (0)280 32040
Fax: Int + 46 (0)280 32107

Original spare parts to be ordered from the manufacturer

Technical data

Length	420 mm	(16.54 in.)
Width	200 mm	(7.87 in.)
Height	200 mm	(7.87 in.)
Weight	10 kg	(22 lbs)
Compressed air supply	Max. pressure	8 bar (118 psi)
	Min. pressure	5 bar (75 psi)
Air consumption	min 350 litres/minute (12.4 cu.ft./minute)	
Folding speed	5 – 8 m/min (16.4 – 26.2 ft/min) (Depending upon the capacity of the compressor)	
Hose		
Minimum diameter:	10 mm	(0.40 in.)
Maximum length	30 m	(90.5 ft)
Noise level:	<60 dB(A)	

Starting up

- Carry out manual folding of the plates over an initial distance of approximately 400 mm (16 in.) as shown in Figure 1.
- Always place the machine on a level surface. Connect the air supply as shown in Figure 2.

Note that the machine always goes to the starting position when the air supply is connected. This can cause a risk of being crushed.

- Place the machine over the folder with the air connection from the fold direction. Lift the lever to tension the folder wheels (Figure 2).
- Check that the machine is properly mounted on the fold as shown in Figure 1.
- Start the machine by using the Start and Stop switch as shown in Figure 2.
- Check the fold and, if necessary, adjust the folding pressure using the control valve for this purpose (Figure 2). Turn clockwise to increase the pressure. The basic setting is approximately 5 bar (75 psi). Increase as required.
- When folding has been completed stop the machine using the Start and Stop switch.
- Lower the level to release the folder wheels (Figure 2).

Lubrication and maintenance

- The machine requires an effective air filter and water separator to function properly.
- The machine requires regular lubrication after 300 m².
- Check all bolted fasteners for tightness and parts for wear ***at regular intervals***.
- Clean the machine thoroughly after use.

Starting the fold closer with auto stop.

The fold closer with fold sensor is placed as shown in the auto stop figure, right-hand view.

Perform manual folding of the sheets for a starting distance of around 400 mm according to Figure 1.

Always place the machine on a flat surface.

Connect the compressed air as shown in Figure 2.

Note that the machine always assumes the start position when the air supply is connected. Beware of the risk of crushing.

Check that the fold sensor runs freely at each fold closure. The autostop will not operate if the fold sensor jams.

Place the machine over the fold with the air connection from the fold direction. Raise the lever to tension the fold wheel (Figure 2).

Check that the machine is correctly positioned on the fold according to Figure 1.

When starting set the switch to ON (start) as shown in Figure 2. Activate the machine by pressing the fold closer's start button as shown in the right hand view of the autostop figure.

Check the fold and, if required, adjust the fold pressure using the regulating valve for fold pressure (Figure 2). Turning to the right increases the pressure (basic setting 5 bar). Increase as required.

The fold closer stops automatically at the end of the fold. Note that it does not stop automatically if there is an obstacle. Discontinue folding if there is an obstacle etc by setting the switch to OFF (stop). See Figure 2.

Move the lever down to release the fold wheel (Figure 2).

Operation and maintenance

- The machine requires an effective filter and water separator for problem-free operation.
- The machine must be lubricated after approximately 300 m².
- Check all bolted fasteners and wear parts.
- Clean the machine thoroughly after use.

CAUTION

Note that the machine always goes to the starting position when the air supply is connected. This can cause a risk of being crushed.

- Disconnect the air supply if the machine locks while folding as a consequence of a fault.
- Check the fold and the air pressure and connect the machine so that it returns to the starting position.
- Contact the manufacturer in the event of any major problems.

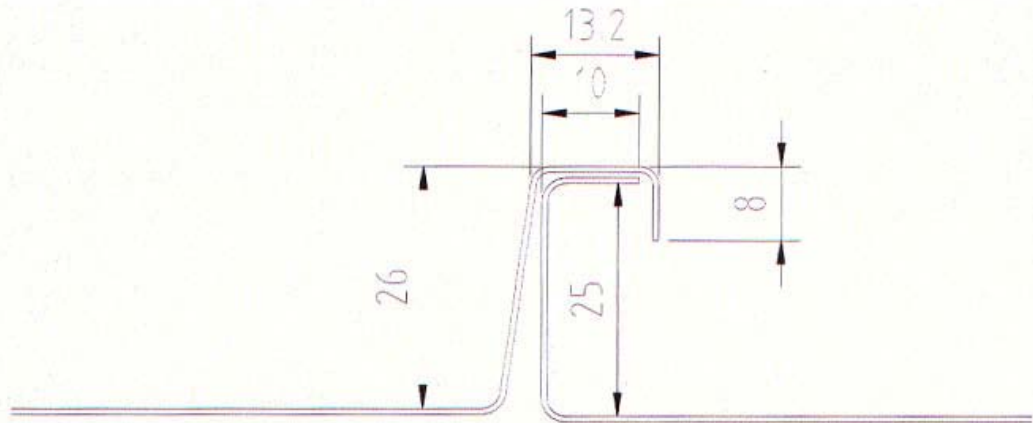
ALWAYS DISCONNECT THE AIR SUPPLY before adjusting the machine. There is a risk of being crushed by clamps and guides under the machine.

- Always place the machine on a level surface with the folder wheels facing the surface when connecting.
- Use the machine only if it is in a safe and serviceable condition.
- All protective devices must be in place.

ALWAYS DISCONNECT THE AIR SUPPLY before carrying out repairs or service on the machine.

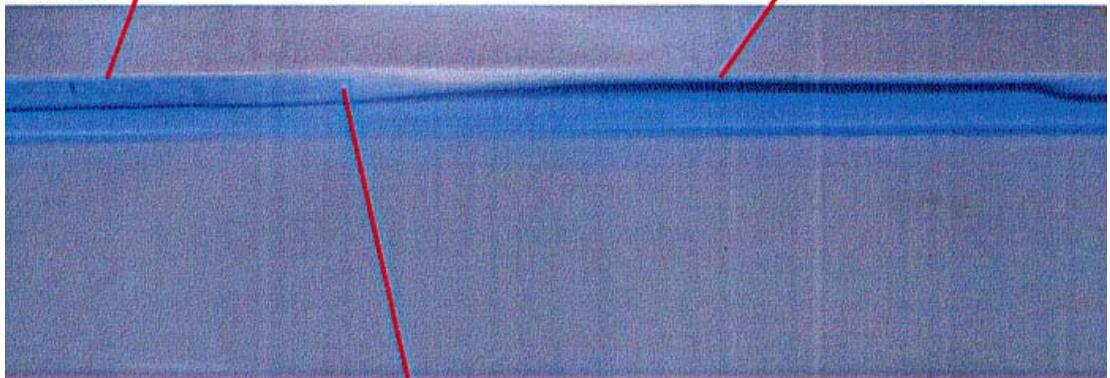
Figure 1

Recommended fold dimensions with the machine in its basic setting.



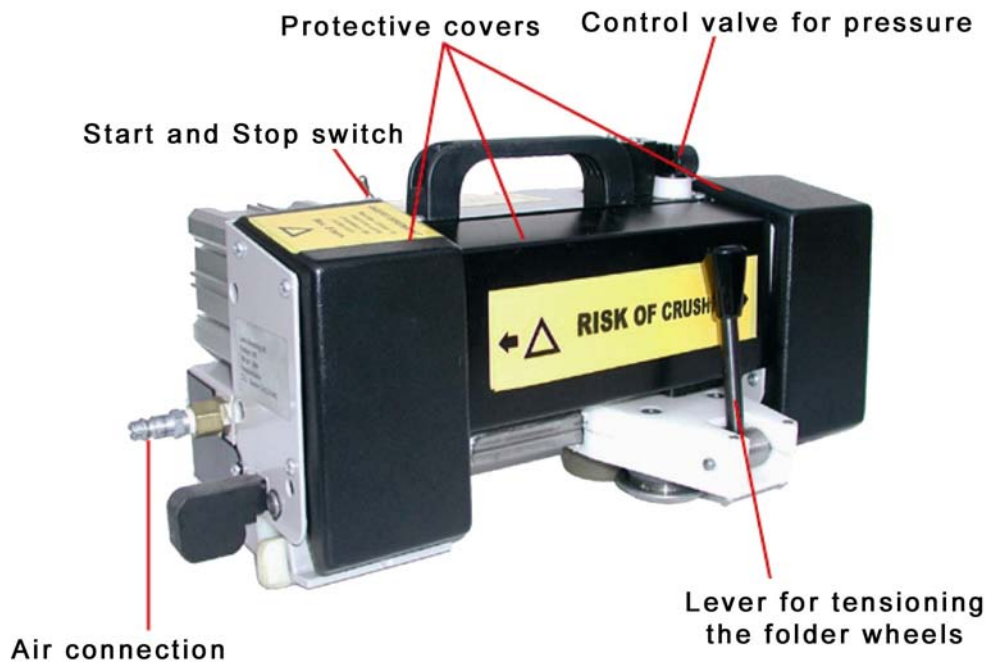
Starting distance: approximately 150 mm (6 in.) to be folded manually as shown.

Locking the fold approximately 250 mm (10 in).

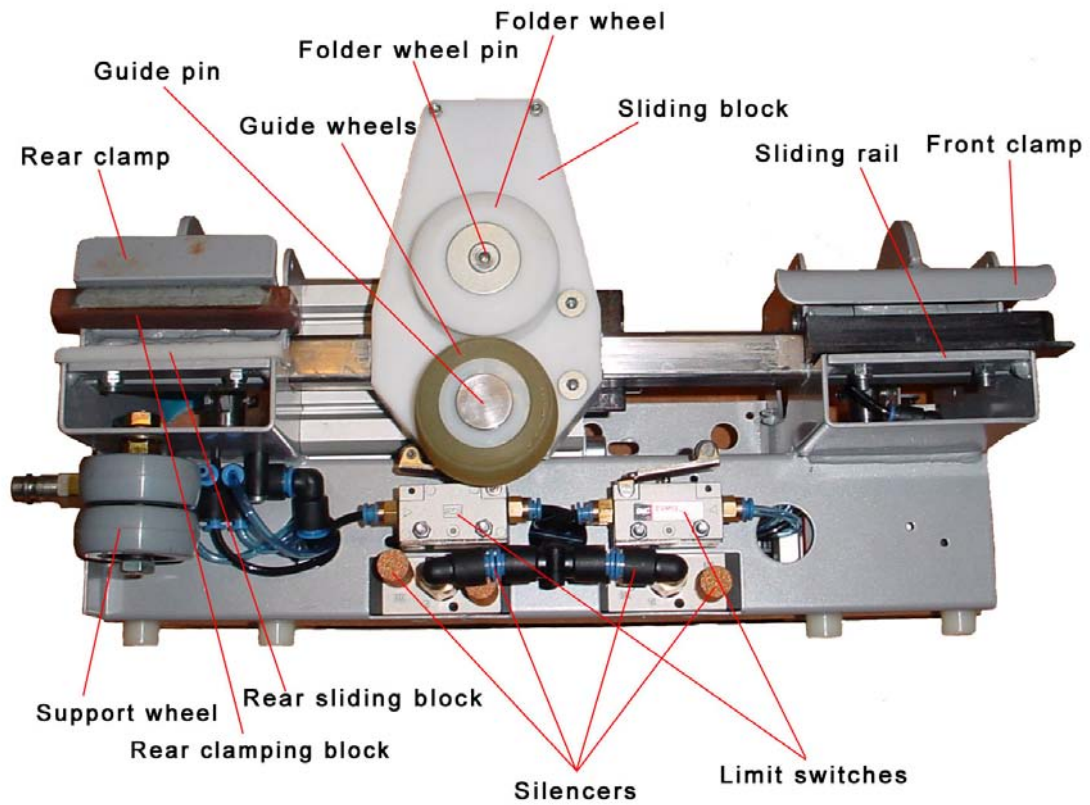


Position of the folder wheels when mounting the folding machine.

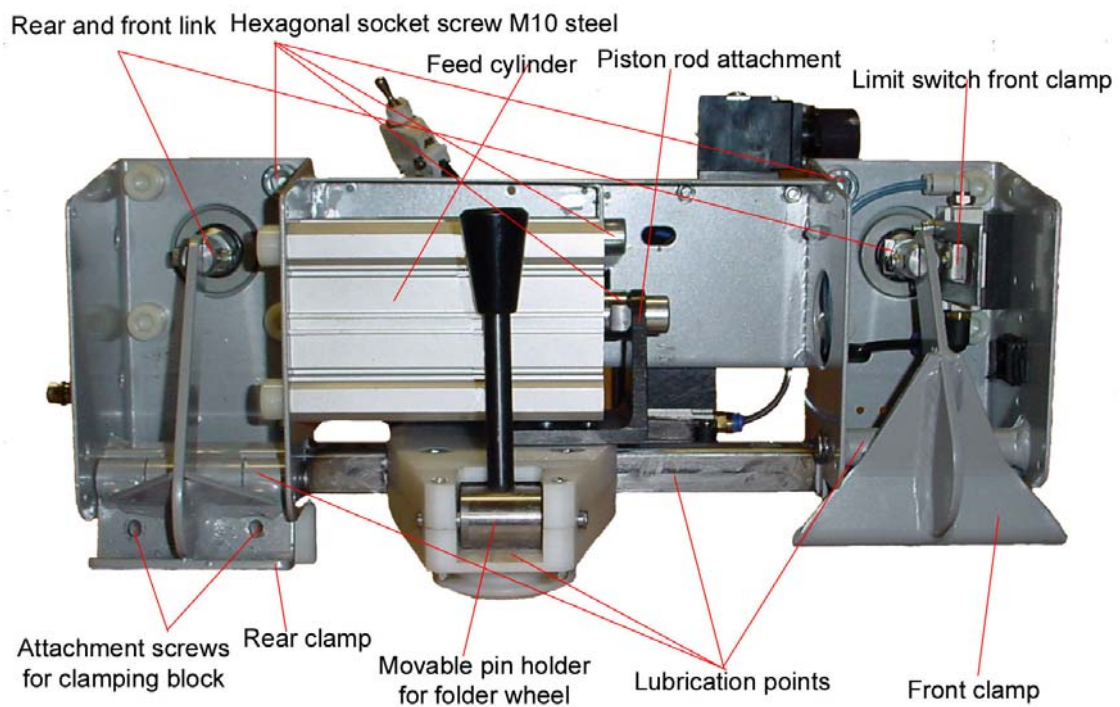
Figure 2. Fold closer



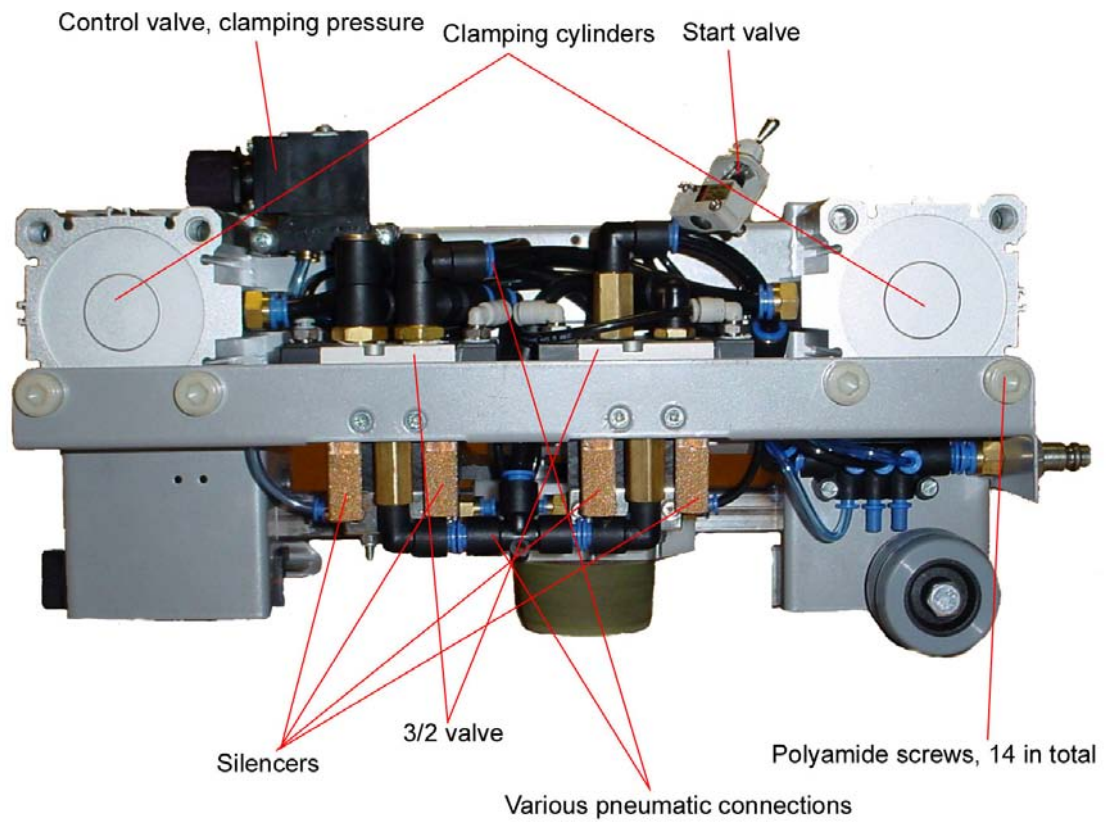
Underside of fold closer



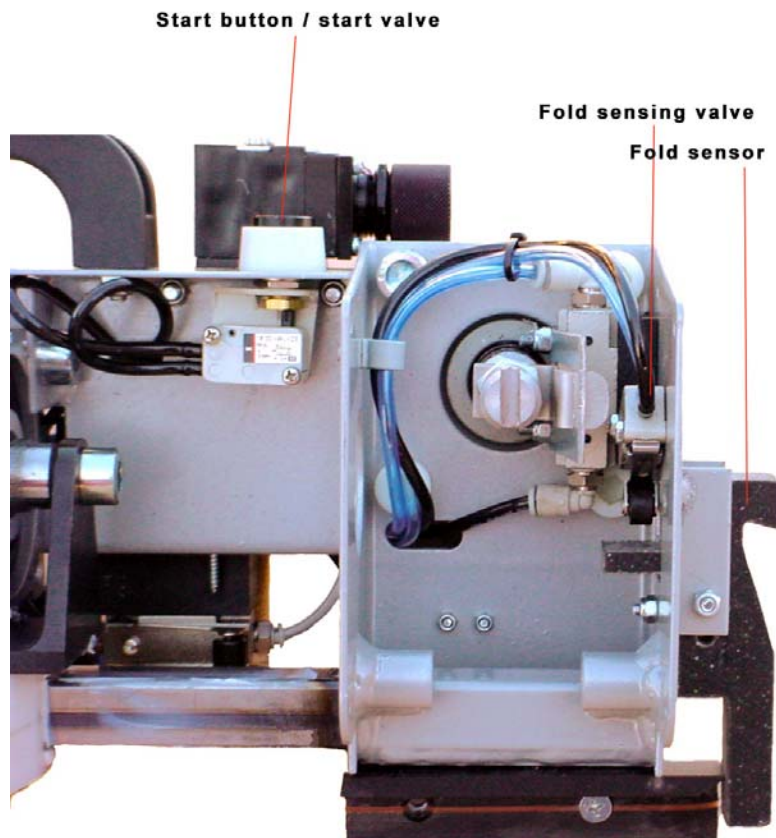
Fold closer - Right-hand view



Fold closer - Lef-hand view



**Fold closer with autostop
Right-hand view**



Left-hand view

Valves for autostop (two)

