CS4008 UNI

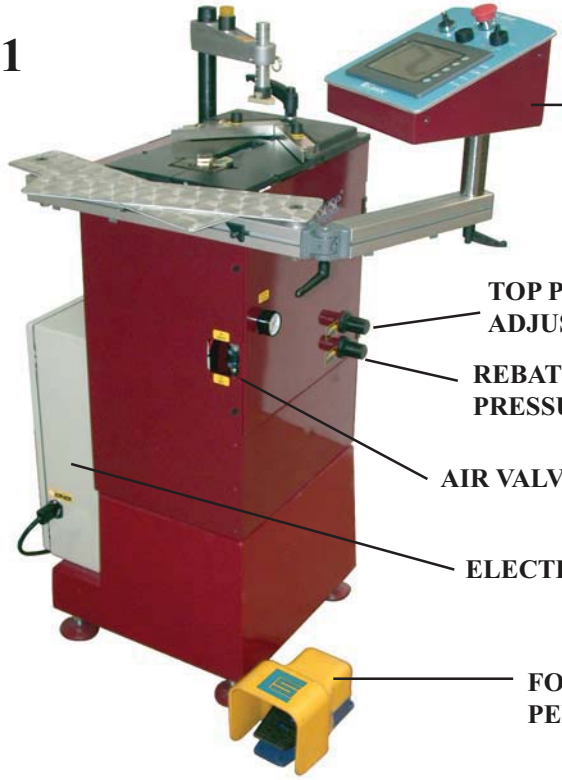
NUMERIC UNDERPINNER

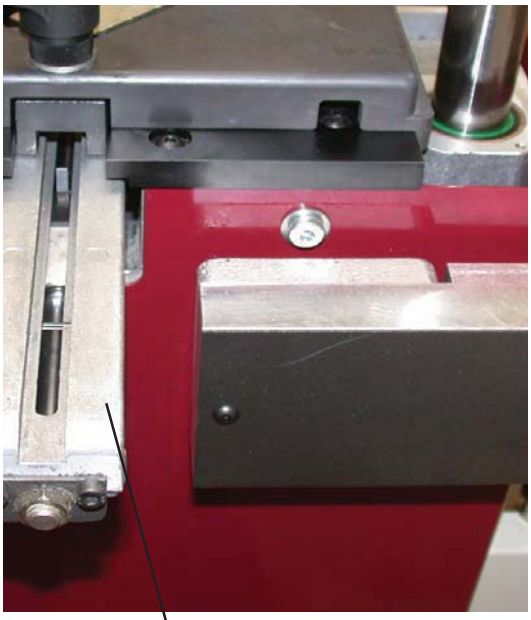
Technical and User Manual

Version 3 - 03 / 2011

Cassese / Communication

Fig 1

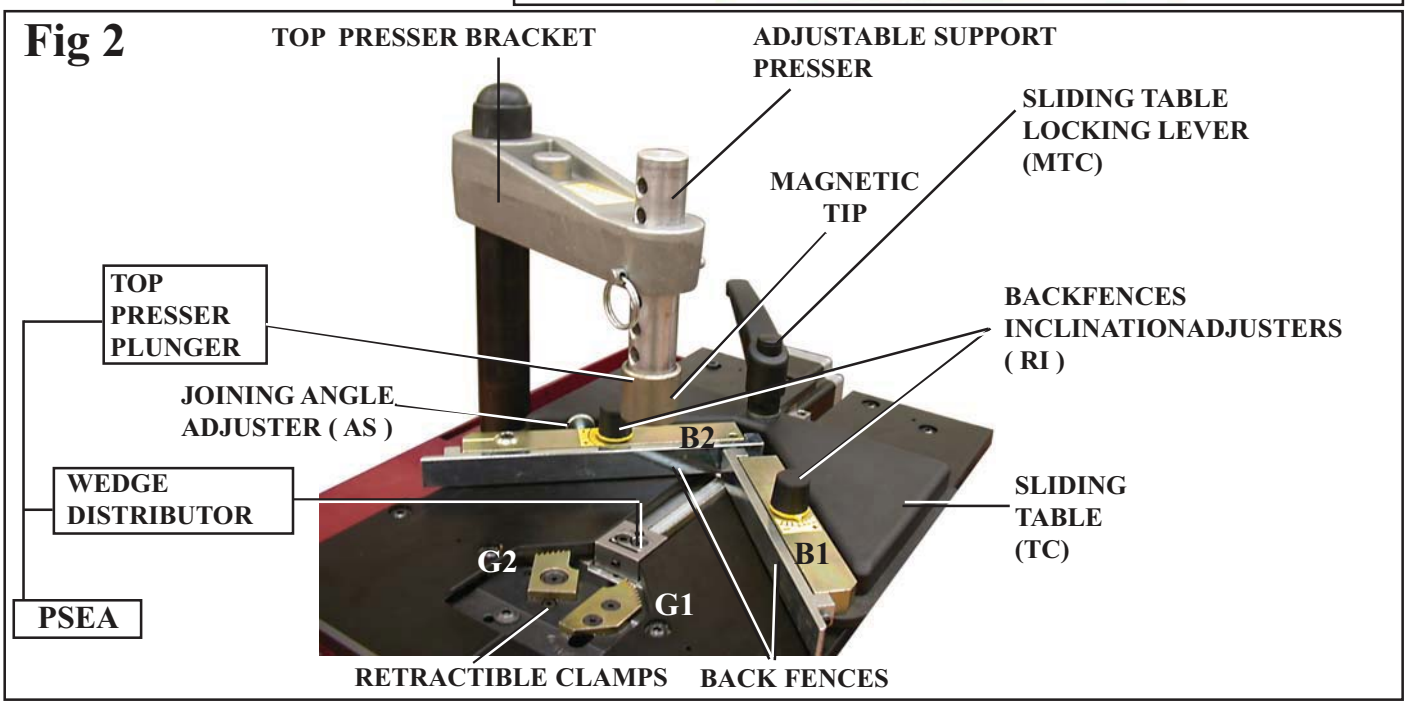




CS4008 UNI DESCRIPTIVE

Fig 3

Fig 2



CS4008 UNI INDEX

INTRODUCTION

You have just acquired a CS4008 UNI underpinning machine. We congratulate you on your excellent choice and thank you for your confidence. The CS4008 UNI benefits from Cassese® 's recognised expertise in picture-framing products. It enables joining of all sorts of wooden and plastic mouldings, in all shapes and sizes (Patent n°7522814). Joining is achieved with specially designed metal wedges ensuring perfect results.
IMPORTANT: Use Only Cassese® Masters™ wedges type «UNI»

ACCESSORIES

The CS4008 UNI is delivered with the following accessories, inside a cardboard box:
- 1 adjustable presser support/1 ball lock/1 magnetic triangle imprint base/
- 1 Black triangle (hardwood)/l White triangle (standard wood)/l magnetic rubber imprint base/1 Green rubber tip (30 mm hardwood)/l Yellow rubber tip (30 mm standard wood)/
- 1 set of spacer bars for small mouldings/3 Allen keys (2.5-3-5 mm).
- 1 wedge pusher tool/1 spare hammer/1 tube of grease
- 1 quick release female connector/1 US male nozzle/1 ribbed nozzle/2 trap door keys.
- 4 heads of wedges distribution (7 - 10 - 12- et 15 mm)

SPECIFICATIONS

Minimum moulding width: 3 mm/Maximum moulding width: 150 mm
Minimum moulding height: 5 mm/ Maximum moulding height: 112 mm
Minimum frame size: 85 x 85 mm
Maximum joining width from the heel of the moulding: 175 mm.
Size of the Cassese® Masters™ UNI wedges : - 5, 7, 10, 12 and 15 mm (softwood)
- 7, 10, 12 and 15 mm (hardwood)

3 types of wedges : Softwood, Hardwood and MDF
Weight of the CS4008 UNI: 150 kg
Overall dimensions: Width (without base) =52 cm, Depth=62 cm, Height=l18 cm
Power supply: Electricity: 220 v, single-phase, 50/60 Hz, Pw: 500w.
Pneumatic: compressed air 6-7 bars,
Consumption: 5 litres per cycle.

OPTIONS

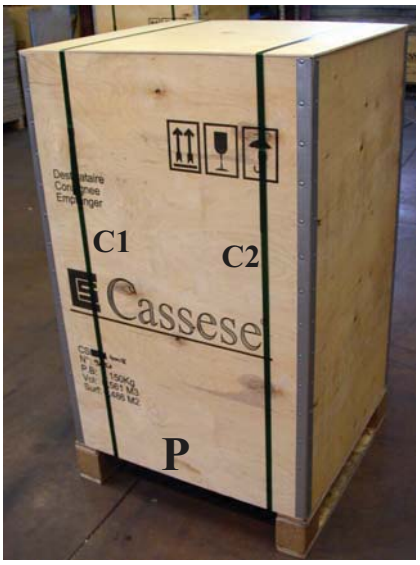
Head of distribution wedges 5 mm (Z22309)
Circular rotating table (ref. Z22662) Adjustable presser (ref. Z15381)
Barcode reader Z21476 (contact customer service).
File storage software for PC. Copies item files from the 4008 UNI to a PC and from a PC to the 4008 UNI.

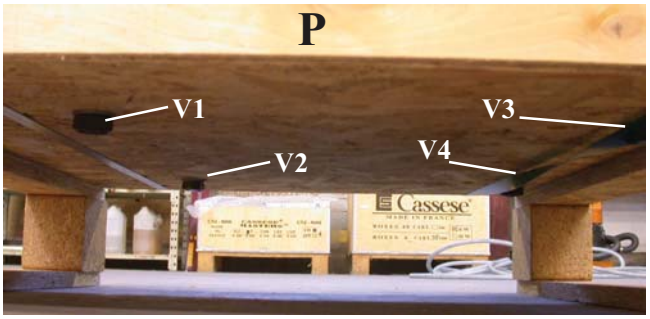
WARRANTY

The CS4008 UNI is guaranteed one year for parts and labour against manufacturing defects. Worn parts or those damaged as a result of non-compliance with instructions in the present manual are excluded from the guarantee.

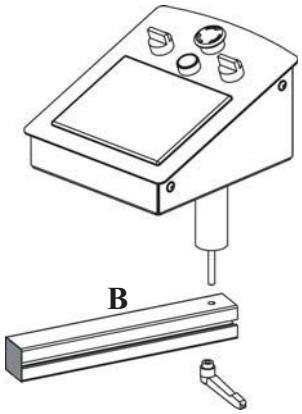
SETUP

1) INSTALLATION

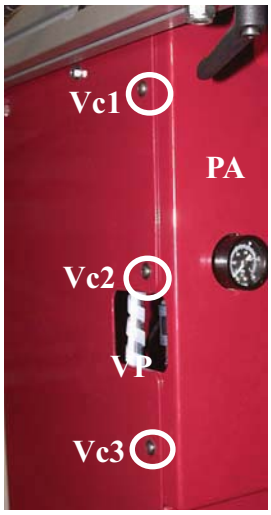




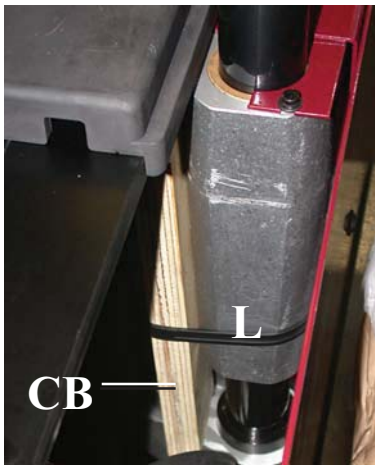
Remove the two bands CI and C2. To unpack the CS4008 UNI, slide the crate up over the top of the machine. The machine is attached to its transport pallet P by 4 screws underneath: VI, V2, V3 and V4. Remove them with a 24 mm flat wrench. Install the 4 feet (supplied) by screwing them firmly under the machine.



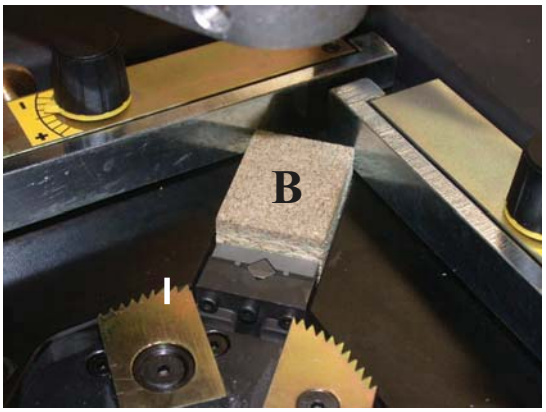
Install the screen unit on swivel arm B.



Remove the 3 screws in the plating Vcl, Vc2, Vc3 (near the pneumatic valve VP) with a 4 mm Allen key and open the machine access door PA.



Cut band L. While pushing down the presser arm (see fig. 2 p A) remove wooden block CB. Gently release the presser arm.

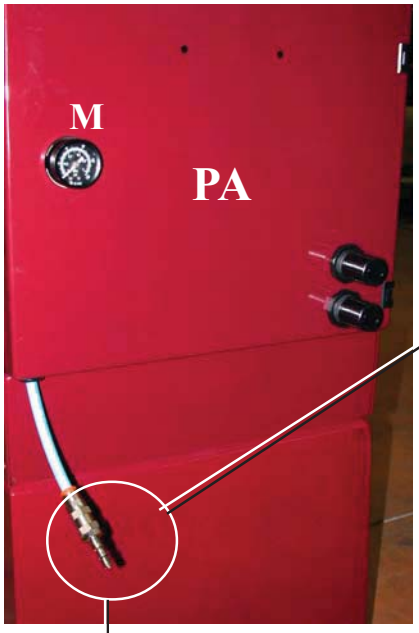


For safety reasons related to the transport of your CS4008 UNI, a wooden block has been placed between the distributor head and the sliding table.

Loosen the locking lever MTC of the sliding table and slide table Tc towards the back (see fig 2 p A).

Remove the wooden block.

2) CONNECTING TO COMPRESSED AIR



Connect the compressed air supply to the hose outside the machine, under access door PA

Open the AIR VALVE VP, the manometer M should show a **pressure reading of 6 bars.**

RACCORDS PNEUMATIQUE

STANDARD

Z 749
FEMALE QUICK RELEASE CONNECTOR

Z 556 **RIBBED NOZZLE**

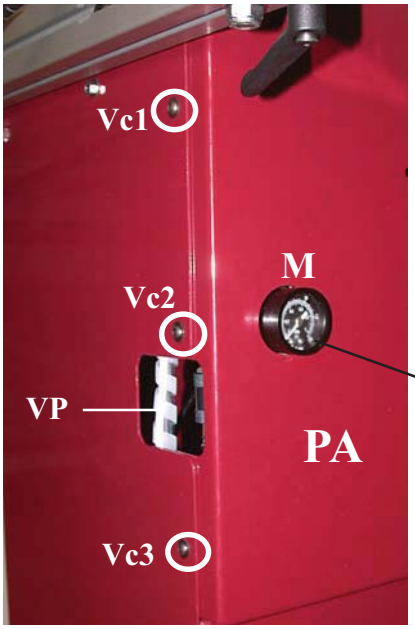
Z 675 **PRESSURE REDUCING CONNECTOR**

COMPRESSOR

USA

Z 701 **USA NOZZLE**

If the pressure indicated is not 6 bars:

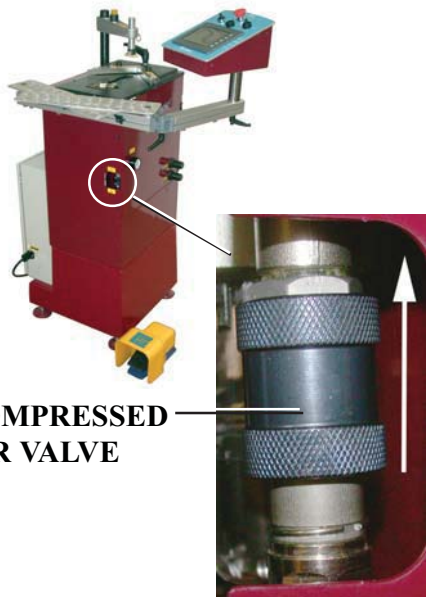


Check the pressure at the compressor, if pressure is correct at compressor then perfom following procedure:

Remove the 3 screws in the plating Vcl, Vc2, Vc3 (near the pneumatic valve VP) with a 4 mm Allen key and open the machine access door PA.

Pull up the pressure adjustment button RP and turn it (clockwise=more pressure) until the needle of manometer M reaches 6 bars.

3) START UP



COMPRESSED AIR VALVE

1) Connect the electrical plug of the CS4008 UNI to a grounded 220 V single-phase outlet.
2) Turn the compressed air valve to **ON.** The manometer should show 6 bars (see page 3).
3) Turn the **START/STOP** button. The touch sensitive screen should be displayed:

4) HOMESCREEN

Total number of staplings since the beginning of operation.

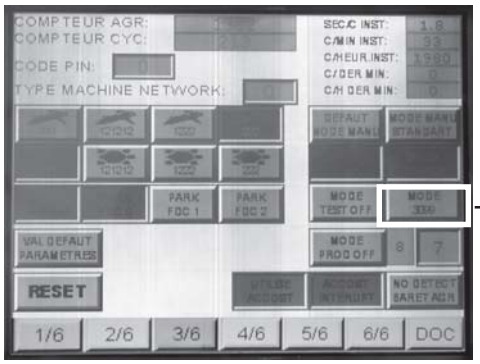
Program versions

Number of cycles completed since the beginning of operation.

F4

CHOICE OF LANGUAGE (Press the button that corresponds to your language)

5) DEFAULT SCREEN PARAMETERS



The default workscreen can be set in 486 or 3099 mode: Press F4 (PARAMETERS)/page 3/5 and specify the desired type of screen with the 486/3099 button.

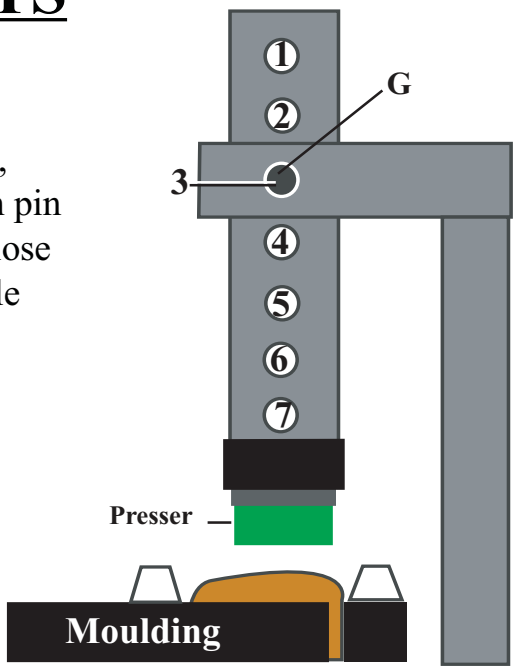
By pressing the pedal, on the touch sensitive screen, or during pre-clamping, the 486 or 3099 workscreen will be displayed.

ADJUSTMENTS

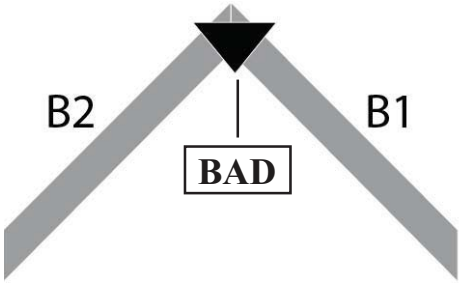
1) CHOICE OF PRESSER

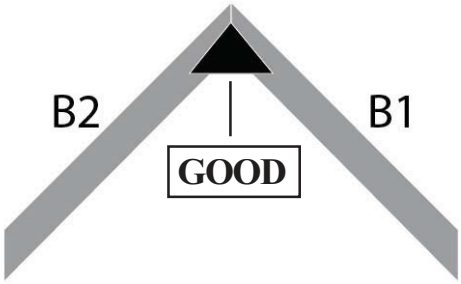
The presser is made up of an adjustable support and magnetic, interchangeable tips. It is mounted on the arm of the post with pin G and can be set at 7 different distances from the table. Pay close attention to the position of the triangle (the sides of the triangle should be parallel to stops Bl and B2: see fig 2 page A of the instruction manual)

BLACK PRESSER (TRIANGLE)	HARDWOOD
WHITE PRESSER (TRIANGLE)	SOFT WOOD
YELLOW RUBBER TIP	30 mm HARD WOOD
GREEN RUBBER TIP	30 mm SOFT WOOD



POSITIONING THE PRESSER
POSITIONING OF RUBBER PRESSERS/TRIANGLE

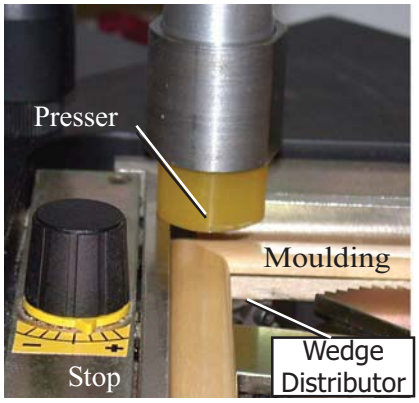




Pay attention to position well the triangle T : the sides of the triangle must be parallel to stops B1 and B2 .

7-position fitting for Rubber Pressers and Triangles. Supplied with 2 magnetic tips for each presser imprint.

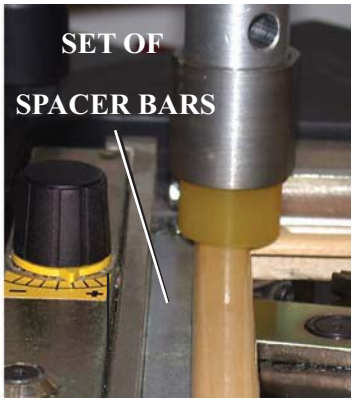
2) HOW TO USE THE SPACER BARS



BAD

When joining small mouldings, lower than the height of the stops, it is necessary to use the set of spacer bars supplied with the machine.

GOOD

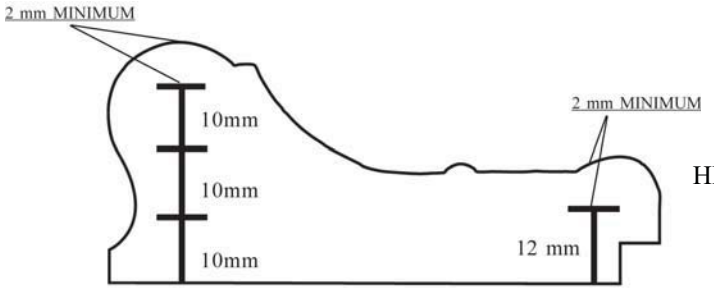


3) ADJUSTING THE SLIDING TABLE

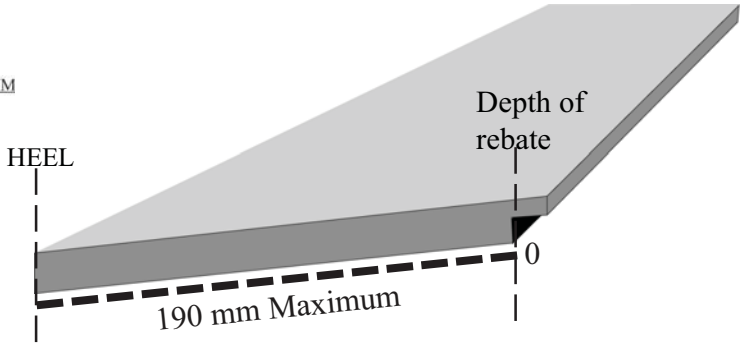
1) Turn the «pre-clamping» button to ON.
2) Place a moulding against stop Bl. If the moulding height is lower than the stops, you must insert the set of metal spacer bars provided with the accessories before placing the mouldings against them (see page 5).
3) Move sliding table TC (fig 2 p A) until clamp Gl (fig 2 p A) touches the moulding.
4) Turn the locking lever of sliding table TC (fig 2 p A).

4) SELECTING THE STAPLING POSITION

The CS4008 UNI is designed to join mouldings in 1 to 9 places with a maximum of 9 wedges for each position. This choice is based on the width of the moulding, its hardness and thickness.



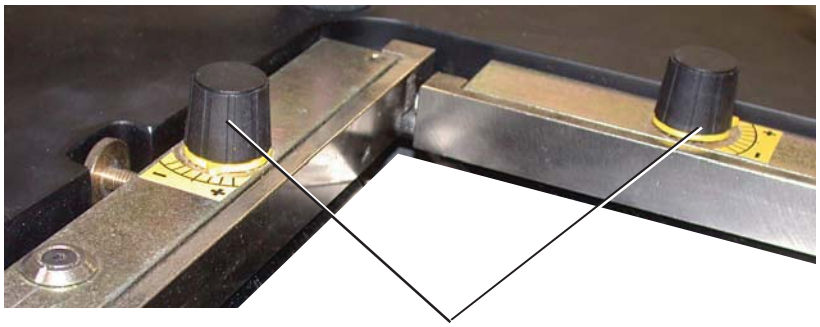
Generally, a clearance of 2 mm MINIMUM is required above the wedge. Wedges that are the same size can be stacked, in order to avoid changing size of wedge when joining frames of various thicknesses.



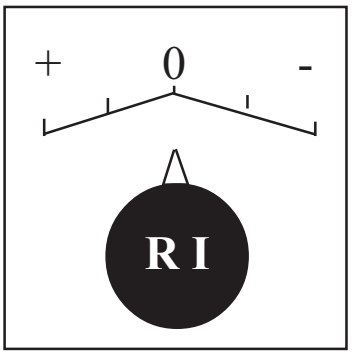
Measurement of the width is based on the diagonal cut from the depth of rebate to the heel. The profile width must not exceed 190 mm.

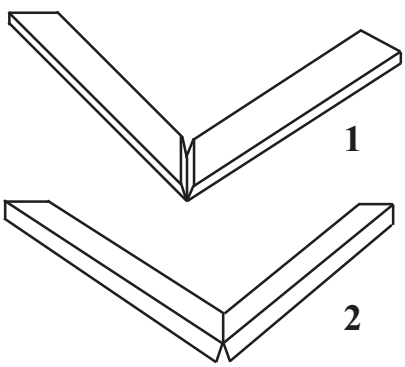
NB : IN EVERY CASE, STAPLING SHOULD BE PERFORMED AS CLOSE AS POSSIBLE TO THE THICKEST PART OF THE MOULDING.

5) ADJUSTING ANGLES OF THE STOPS



(RI) BUTTONS FOR ADJUSTING STOP ANGLES

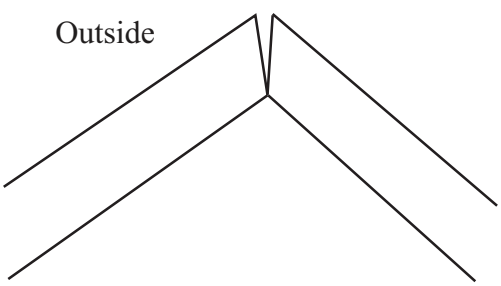


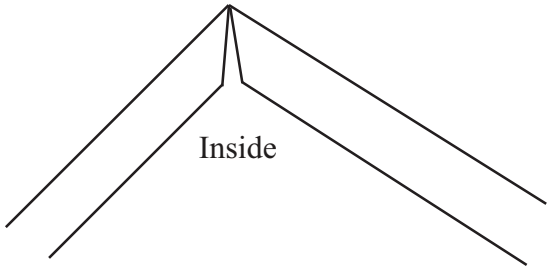


1) If the corner has an opening **on top,** turn the two adjustment buttons (RI) an identical value towards the MINUS sign (-) (Fig. 2 p A).
2) If the corner has an opening **underneath,** turn the same two adjustment buttons (RI) an identical value towards the PLUS sign (+) (Fig. 2 p A).

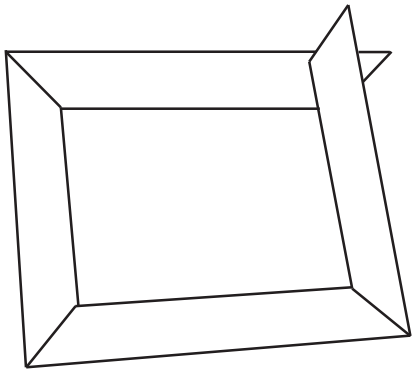
6) ADJUSTING THE JOINING ANGLE

If the corner is open towards the **outside;**
Tighten the adjustment screw AS (page A, fig. 2 & figure AS below) to correct the error and check the quality of the angle by clamping the corner against the stops again.





If the corner is open towards the **inside; Loosen** the angle adjustment screw AS (page A, fig. 2 & figure AS below) to correct the error and check the quality of the angle by clamping the mouldings against the stops again.



If you obtain this result, check your cutting angle. The angle is incorrect in this case because it is less than 45°. Have the angle of your cutting machine corrected.

IT IS IMPOSSIBLE TO MAKE A FRAME WITH ANGLES LESS THAN 90°

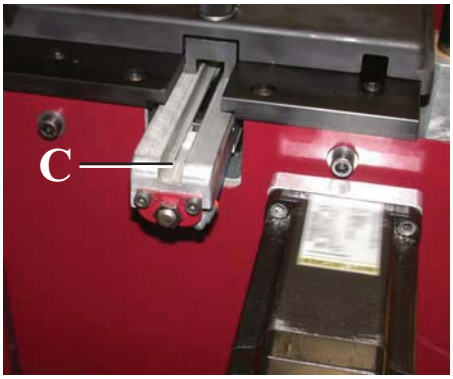
JOINING

1) MEANS OF JOINING

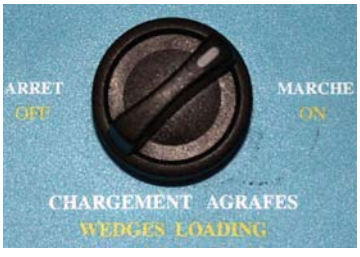
For greater reliability and productivity over time, use only Cassese (R) Masters (TM) wedges type «UNI» with your CS4008 UNI.

Joining is performed using metal wedges specially designed to ensure perfect corners. Five standard sizes are available: 5, 7, 10, 12 and 15 mm. On special order, 3 mm wedges are available for Slips (fillets).

2) LOADING WEDGES

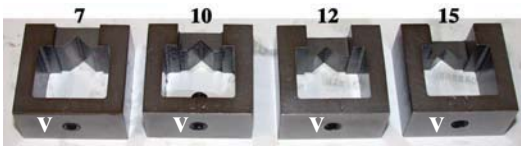


Turn the button WEDGES LOADING to the ON position. The wedge loading slot C retracts. Slide the wedge strip CS in, all the way to the distributor window. Turn the button WEDGES LOADING to the OFF position. The slot returns to its normal position.



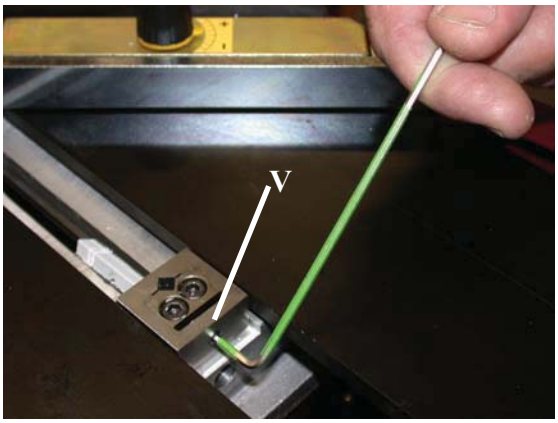
LOADING WEDGES

IMPORTANT: TURN THE MACHINE OFF AND DISCONNECT THE AIR INTAKE.

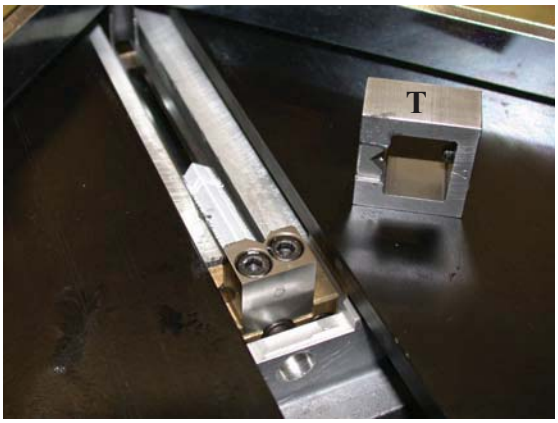


The **CS4008UNI** comes with 4 stapling heads, each corresponding to a specific staple, i.e., 7, 10, 12 and 15mm.

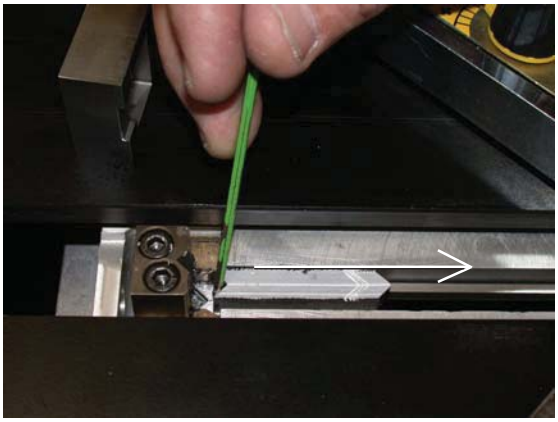
The following procedure is to be followed for installing/replacing the stapling head on the machine :



Using the 2.5 mm Allen wrench provided, unscrew the locking screw (V) of the stapling head and place on the machine.

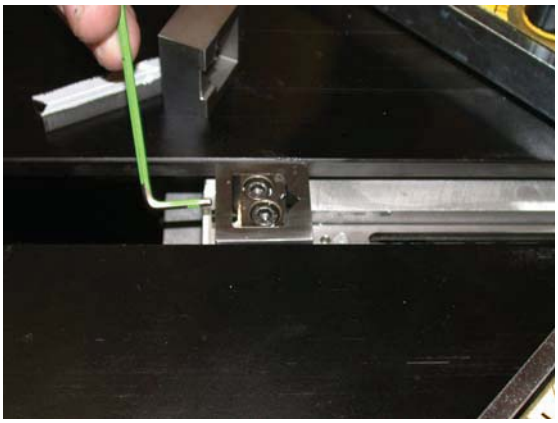


Detach the stapling head (T) by pulling it upwards.

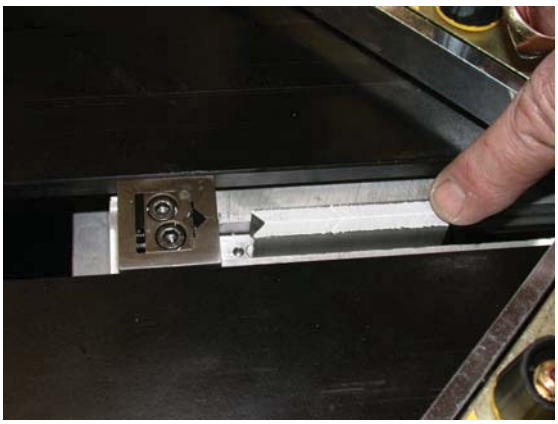


The staples in place are held magnetically. Push them back to free them.

Insert the stapling head corresponding to the staple size chosen.



Attach the new stapling head with the 2.5 mm Allen wrench.



Insert a bar of staples in the staple distribution groove, A second bar of staples can be inserted after it. The staple loading operation is complete.

3) JOINING IN 486 MODE

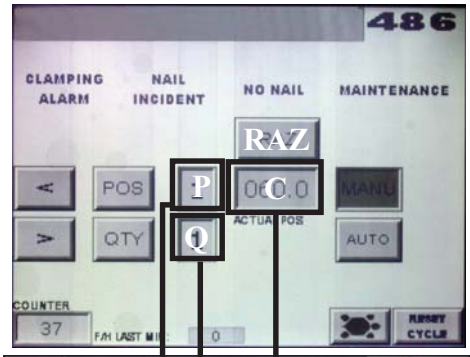
The 486 workscreen is displayed by pressing Fl. If this screen has been set as the default workscreen, it will automatically be displayed by pressing on the homescreen. A flashing message indicates the machine must be placed in the pre-clamping position.

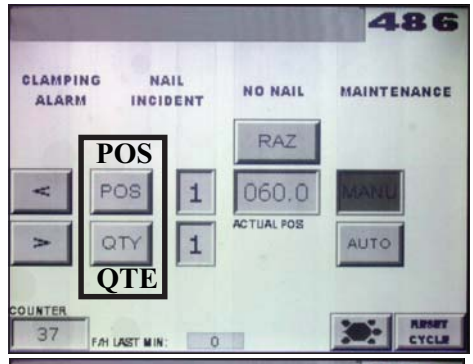
Turn the button **PRE-CLAMPING towards ON.** Reset at 0, if necessary, all the position fields **POS** and quantity fields **QTY** using the **CLEAR** button (RAZ).

The post/stapling joining **(P/SEA** see **fig.** 2 p A) is initialised and moves to position 1, near the clamps. Place the profile against stop Bl and adjust the Sliding Table (see page 6). At this point, the stapling positions and quantity of wedges for each point will have been defined. By pressing the buttons < (back) and > (forward) you can visually change the position of the **P/SEA** unit. Field C provides the position of the **P/SEA** joining in mm, the 0 position being near the clamps. Movement follows the cutting angle. You can move directly to a given dimension by pressing field C of position dimension. A numeric keypad is displayed. Enter the desired position, from 0 to 190. Press **ENTER** to confirm the dimension.

By pressing several times on **POS,** you can move to positions 2, 3, and so on, up to a maximum of 9. After position 9=back to position 1. You can go directly to a given position by pressing the position number field P. A numeric keypad is displayed. Enter the desired position n°, from 1 to 9. Press **ENTER** to confirm.

By pressing several times on **QTY,** you can specify the quantity of wedges for the position: 1, 2, 3, and so on, up to a maximum of 9. After 9=back to 0. You can specify directly the quantity of wedges for a position by pressing the wedge quantity field Q. A numeric keypad is displayed. Enter the desired quantity from 0 to 9. The selection buttons Manu/Auto define the way the frame is assembled.

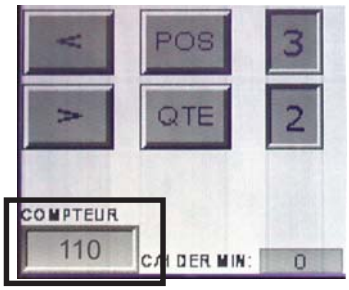




MANU=Press Pedal (clamping) + Press Stapling Button.
NB: we advise you to use this two-step method for the first frames in order to check the accuracy of the settings.

AUTO= Press Pedal (Clamping/Stapling in a single operation).

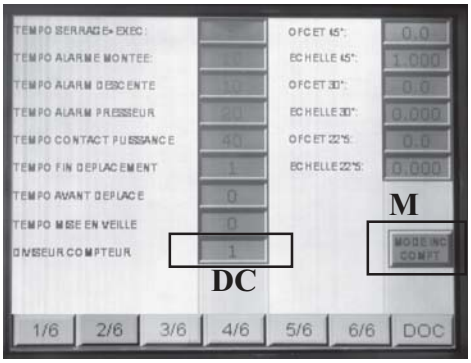
The **COUNTER field indicates the number of cycles completed.** By pressing this field, a numeric keyboard is displayed, enabling you to attribute a value: the counter can be Incremental or Decremental, see below:

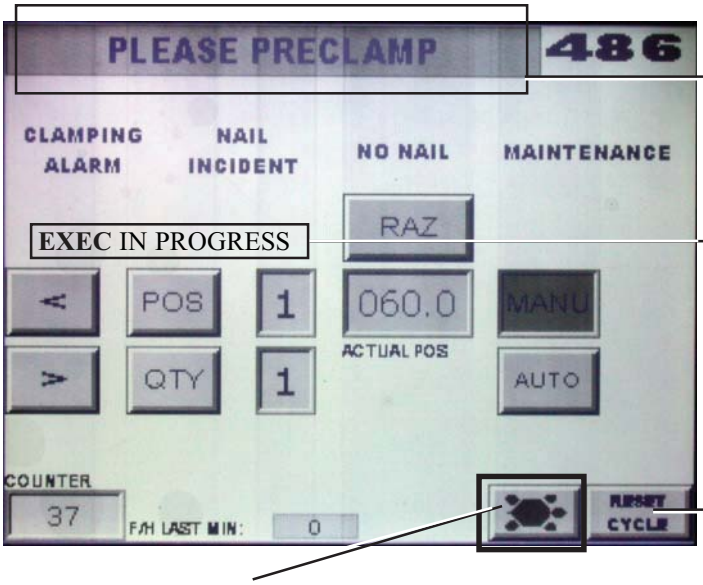


a) SETTING COUNTER PARAMETERS

Press F4 (the **parameters** screen is displayed), then the button at the bottom of screen 2/6. Specify using the button **M:**

Mode INC COUNT (counts the stapling cycles by addition) or
Mode DEC COUNT (counts the stapling cycles by subtraction)
Enter the unit of division in the field COUNTER DIVISION (DC):
1 = counts the number of assembled corners.
4 = counts the number of assembled frames (etc..)





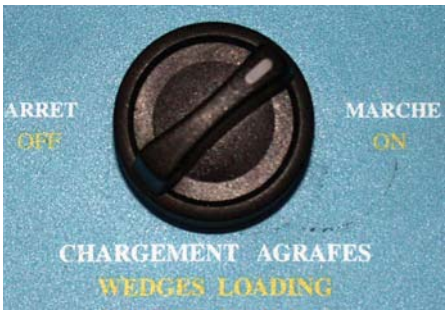
A text message indicates the state of the machine when there is a problem.

When a cycle is in progress, the message «cycle in progress» appears on the screen and all the buttons are blocked.
The display of positions and quantities change as the stapling cycle progresses.

When an incident occurs, the **RESET** button interrupts the current cycle. Perform re-clamping again.

The **TORTOISE/HARE** button is used to set the stapling mode. The stapling mode is defined in **Parameters** 3/6 (see page xx). The standard default mode is **TORTOISE.** Parameterise the **TORTOISE/HARE** button to obtain a different stapling system for each mode, combining the first pressing (l=slow) and boosted pressing (2=rapid). For example: TORTOISE=l 11 for fragile mouldings and HARE=222 for more sturdy mouldings.

When the machine is out of wedges, it completely retracts the wedge loading slot and displays a message inviting you to insert a new strip of UNI wedges. Insert a new one, pushing it until it reaches the distributor window. Press the Stapling button to continue. The machine continues the stapling cycle where it left off.



B) MEMORISING JOINING PARAMETERS

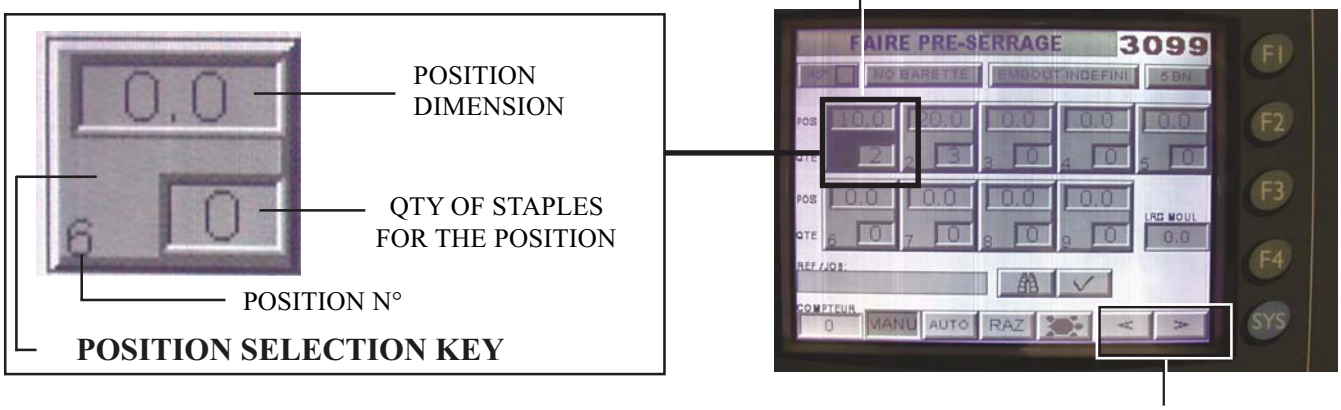
See **3099 Mode (page** 10). The joining parameters in 486 Mode can be found on the 3099 Mode screen.
Follow the memorisation procedure on this screen.
Or switch to **Items Mode** using F3 and press the button FROM EXEC.
The parameters previously displayed on the 486 screen can be found on the Items screen (see item memorisation page 11)

4) JOINING IN 3099 MODE

After turning the machine on, press F2: the 3099 screen is displayed. A message invites you to perform pre-clamping. To clear all of the positions and quantities press «CLEAR» (RAZ): the post/SE stapling unit is initialised and moves to the default position, near the clamps.

Important: the 0 position is near the clamps, the unit moves along the cutting angle.

Parameters of the points position and the quantity of wedges for each position are set in the following manner: Each stapling point is numbered from 1 to 9 and includes the distance from point 0 (clamps) and the quantity of wedges inserted.



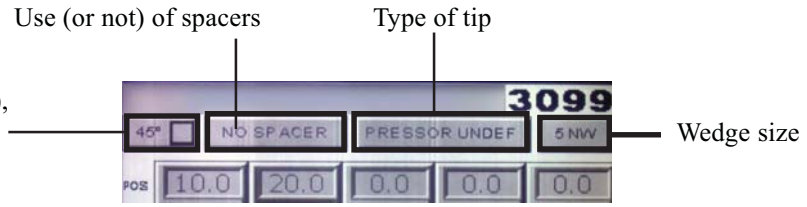
There are 2 methods for entering the **POSITION** parameters: **either** using the arrows < (back) and > (forward) which visually move the **P/SEA to the desired position, or** entering values via the numeric keyboard, which is displayed after pressing on the upper field (be careful to confirm each value by pressing ENTER)
The quantity of wedges (from 0 to 9) is entered, after pressing the lower field, via the numeric keyboard.
Proceed the same way for the subsequent positions.
By pressing on the display of a position dimension, the P/SEA unit moves directly to that dimension.

The 3099 enables you to specify:

ANGLE / SPACER BAR / TIP / SIZE

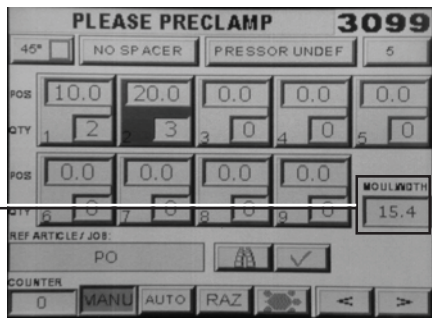
By pressing these buttons, you can specify:

Angle: 45° (squares, rectangles), 30° (hexagons), 25° (octagons)

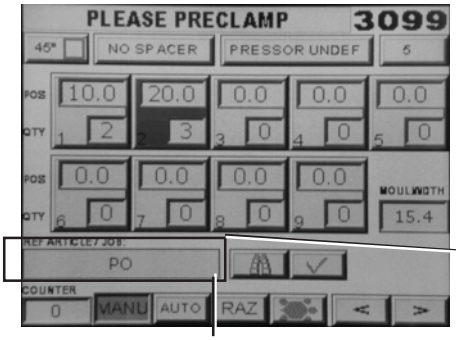


These elements do not affect the machine cycle. They are an optional visual aid for the operator.

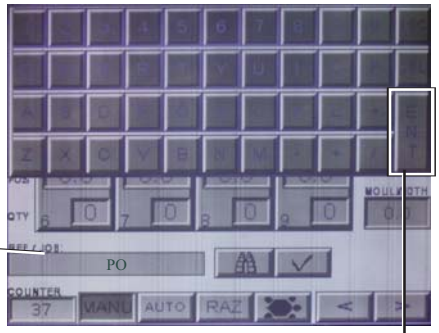
By pressing on the field marked **MOULDING WIDTH,** you can indicate this dimension . Entering the moulding width is optional. It is a visual indication for the operator, just like the tip, size, spacer bars and angle. NB: When the machine is out of wedges and the moulding width has been entered, the post will retract to the moulding width. If the moulding width has not been entered, or if it is less than the position dimensions, the machine will move to the furthest position
and will ask you (via a message) to reload (see procedure page 7) Press the staple button to continue.



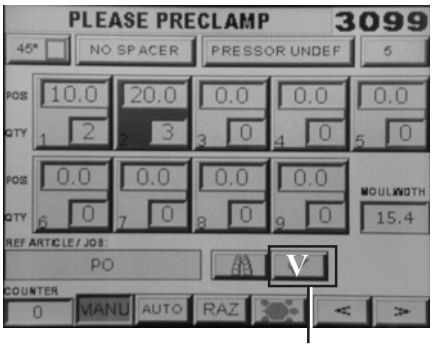
A) MEMORISING JOINING PARAMETERS



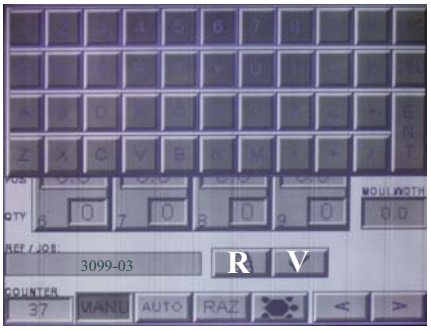
After pressing **REF/JOB** the machine will ask you to enter an item name using the numeric keyboard.



Once the item name has been entered, confirm by pressing **ENT** on the numeric keyboard.



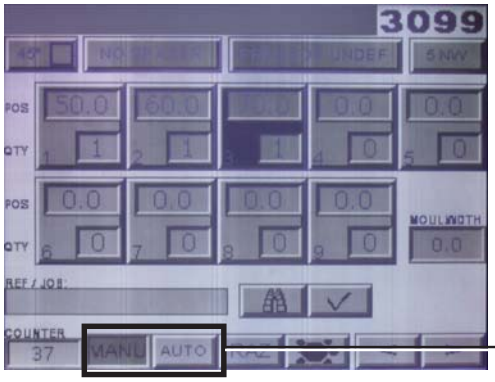
The joining parameters of the profile must be saved with the validation key V.



The **SEARCH (R)** key can be used to call up a [known item (in this case 3099-03) from the 3099 screen.
Enter the exact name of the item. Confirm by pressing ENT. I Then press **SEARCH.**
After pressing **VERS EXEC,** the machine executes the item. It is possible to create an item directly via the 3099 execution screen.
Enter the various parameters of the moulding (positions and wedge quantities). Then enter a name in **REF/JOB** and validate it by pressing V.
If the item already exists, a confirmation screen will be displayed.

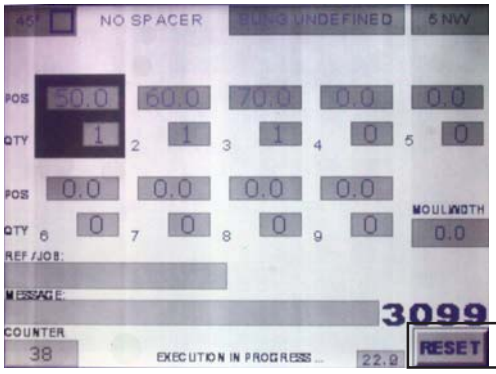
B) JOINING A FRAME

Once the parameters have been entered in the machine, two modes (AUTO and MANU) can be used to assemble the frame. They define how the stapling cycle will be launched:



MANU=Press Pedal (clamping) + Press Staple Button.
NB: we advise you to use this two-step method for the first frames in order to check the accuracy of the settings.

AUTO= Press Pedal (Clamping/Stapling in a single operation).



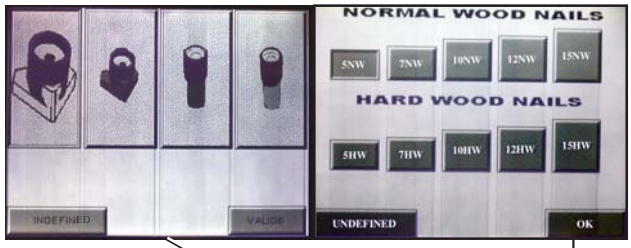
When the stapling cycle has been launched, the machine will display an execution screen indicating each position as it is completed.

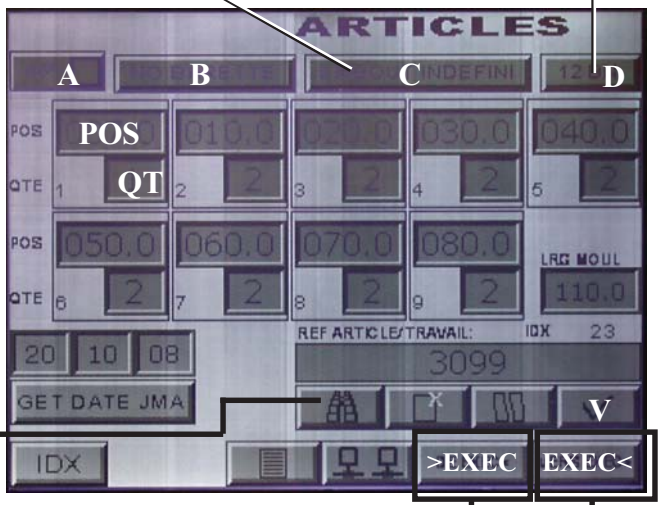
You can stop the cycle in progress using the RESET button without turning off the machine.

5) ITEMS MODE

Press F3 to access the ITEMS screen. An item consists in the following parameters:
- **Item name:** up to 16 alphanumeric characters. Press on the field **REF ITEMS** and enter the desired name via the numeric keyboard. Then press **ENT** followed by **V.**
-**1 to 9 stapling positions:** depending on the cutting angle and for a maximum width of 190 mm. Enter the position after pressing on **POS.**
1 to 9 wedges per position: enter the number of wedges after pressing on each **QTY** field.
Moulding width: from 0 to 190 mm maximum from the depth of the rebate.
Creation date: Press DATE DMY or modify each field of the date displayed.
Joining angle: scroll down the different angles by pressing button **A**
Use (or not) of spacer bars: select the desired option by pressing **B**
Type of tip: Choose one of 4 tips, then press **C**
Wedge size: Choose the size after pressing button D
All these values can be changed at a later date, by pressing the corresponding button (or display). Modifications only affect the item and not execution in progress.

The CS4008 UNI can record up to 3,000 items.





To Create a new item, press **NEW.** All the parameters are cleared. The date is reinitialised. Enter your parameters; enter the item name and validate (V). If an item with the same name already exists, a warning will be displayed. Confirm replacement of the existing item or cancel and continue the procedure with a different name.

SEARCH **NEW** **DELETE** **VALIDATE**

By pressing >EXEC, you can transfer the «T parameters of the item file to the execution screen (486 or 3099 depending on parameterisation of your preferences).

By pressing EXEC<, you can transfer the execution parameters of the job in progress to the item file.

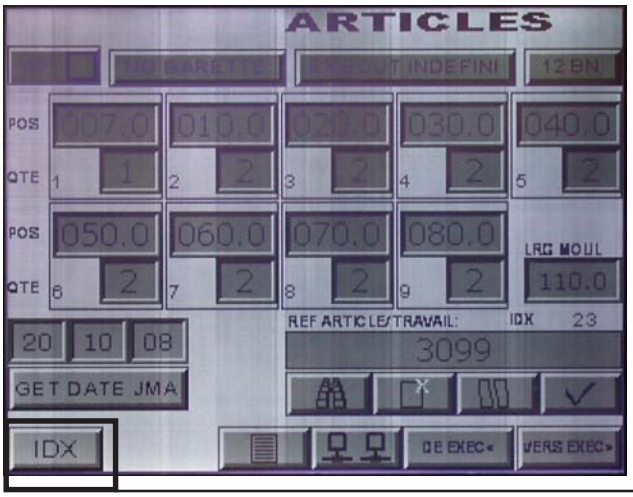
MANAGING THE ITEMS DATABASE

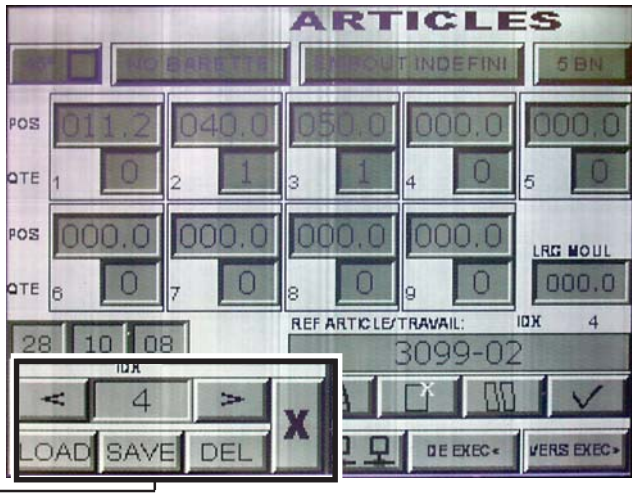
To SEARCH for a saved item, press on the name of the item. A numeric keyboard is displayed. Enter the name and confirm. Then press SEARCH. If the item exists, its parameters will be displayed. Otherwise, the message INEXISTENT ITEM will be displayed.

To DELETE an item from the machine's memory, press DELETE

To MODIFY an item, change the desired parameters and confirm. A confirmation screen will appear. Confirm or return to the item file.

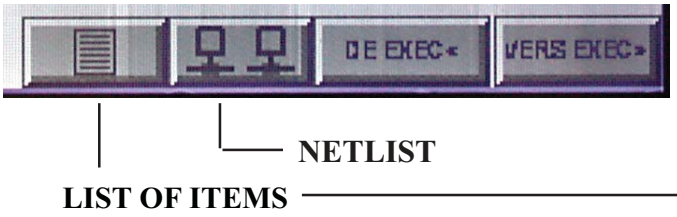
To COPY: call up the desired item (enter its name and then press SEARCH). Modify the name, then confirm by pressing V

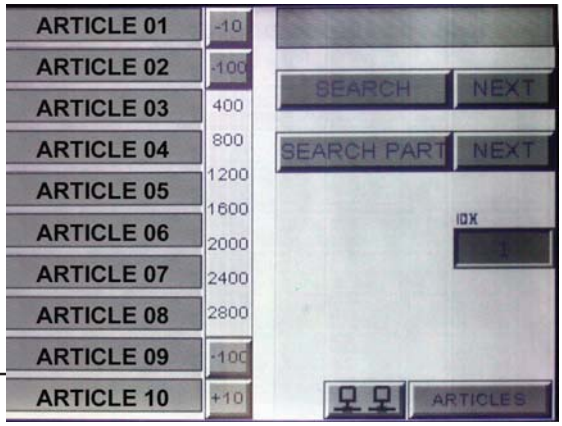




If you press IDX, a new screen will be displayed, enabling you to scroll down the list of items saved in the machine.

Press **LIST OF ITEMS** and a screen will display the items in the machine's memory, by lists of 10 names.



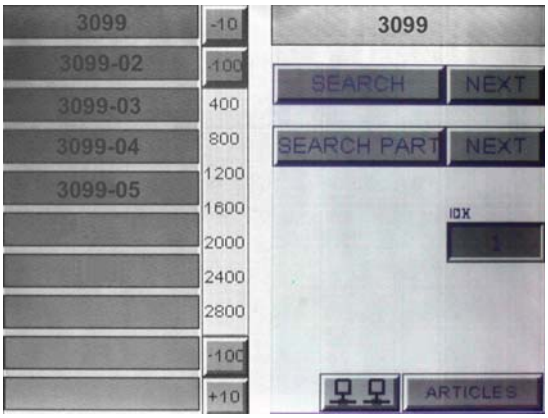


You can move up and down the index from the page of 10 items displayed by pressing +10 (10 items lower), +100 (100 items lower),-10 (10 items higher),-100 (100 higher).
You can also enter the value of the index displayed directly by pressing **IDX.** You can even go to a predefined value 400/800/1200/1600/2000/2400/2800 using the scroll bar.

NOTE: A newly created item will appear in the first available empty slot. A deleted item frees up a slot. Therefore, items do not necessarily appear in the order they were created.

To search for an item in the machine's memory using the list, enter its name after pressing **ITEM NAME** and confirm using the ENT button on the numeric keyboard. Then press SEARCH to call up the item among the 3,000 files in the database.

Press on one of the 10 names in the list to call up the file of the selected item. Then press **>EXEC** to execute it.



You can search for any item using part of the name.

Example: 3099 and 3099-02 are two different items.
Using the **PARTIAL** button, you can search for all items starting with 3099.

NETWORK MODE

This system only functions if the machine is connected to a PC/SERVER that dispatches jobs to a network of machines.

The system is based on the following principle:
The PC/Server records a list of orders and organises a list of Jobs according to various priorities.
The server proposes, depending on the type of machine (saw/joiner) and a job database, a queue of 10 jobs.
A job is defined by:

- Its NAME
- Its joining Parameters (when appropriate).
- The Quantity requested.
- Its Status:

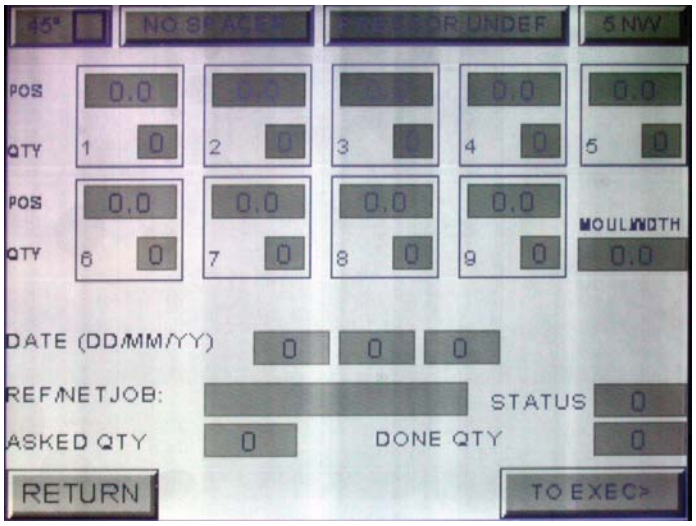
FREE (waiting)/MACHINE REQUEST (GET)/REQUEST ACKNOWLEDGED (ACK)/COMPLETED (DONE).

- The quantity already completed. The machine requests a list of Jobs in the queue. The PC/SERVER sends back a list of 10 Jobs from the list of orders, according to different parameters and priorities.

The operator selects GET-Request for Job. 1 to 10 Jobs can be requested by a single machine.
The PC/SERVER sends back the list of 10 Jobs, with the response ACK if the request is accepted. It could be refused, for example, if the order has been cancelled or another machine has already taken the job. The machine executes the entire job or part of it.
The operator enters the quantity completed and then makes a DONE request. DONE can only be executed if the job has been requested and acknowledged. Several jobs may be DONE at the time of the machine request.
The PC/SERVER records the job, even if it is partially completed, deallocates the Jobs Done and creates a new list with the next 10 Jobs in the queue, and so on.

NETLIST

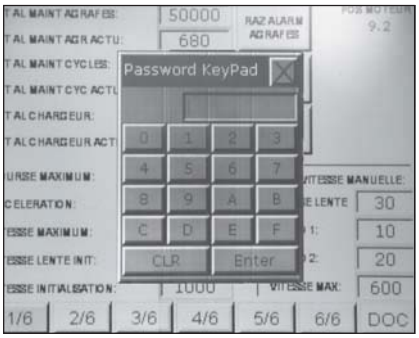
LIST OF ITEMS



Starting from the item file, press NETLIST
Press UPDATE to update the list.
Make a GET/ACK or DONE request.
Press UPDATE to update the list.
Execute the job and then press UPDATE to update the list.
You can use the execution parameters in the NETLIST.
To visualise the parameters of a job, press on the job name.
Then press >EXEC. The machine is adjusted according to the Job parameters in NETLIST.
Otherwise, you can execute the Job using your own parameters, or those of an item in the machine's memory. You can still use DONE.

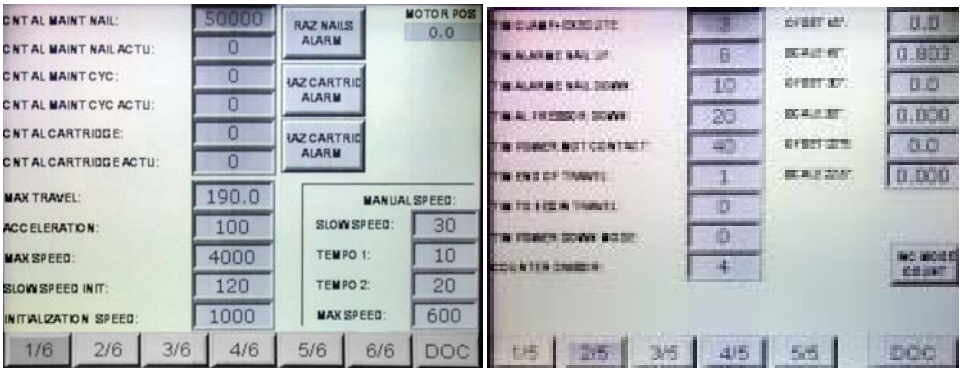
THESE NETWORK FUNCTIONS ARE DESTINED TO EVOLVE -SEE EVOLUTION OF «Cassese Barcode»

6) PARAMETERS



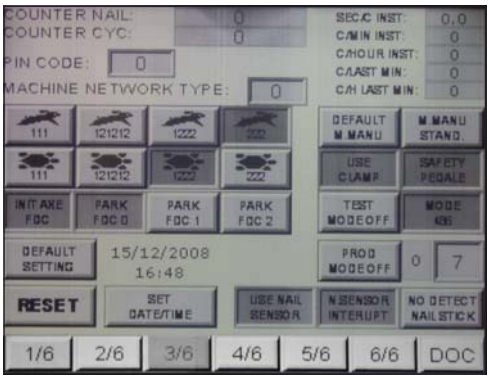
Pressing F4 provides access to the PARAMETERS. Access to various parameters of the CS4008 UNI is organised in a hierarchical manner according to user level. A password is requested when a user tries to modify a given option (parameter pages). The user level remains active while the machine is turned on.

Level 1-code 5000-User Level 1: RESET ALARMS, SET TIME, INTERACTIVE MODIFICATIONS OF FILES AND/OR MODIFICATIONS.
Level 2-code 9059-User Level 2: OFFSET/RATIO/SPEED/TEMPO...
Level 3-code 0721- User Level 3: management of the ITEM DATABASE (parameters page 5)
Level 4-code XXXX- Total access for CASSESE customer service (modification of cycle/wedge stats, direct read/write in the Database)



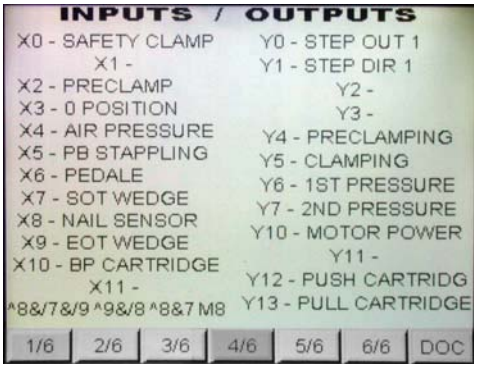
Pages 1, 2 and 3 concern various machine parameters.

Do not modify without authorisation from CASSESE Customer Service

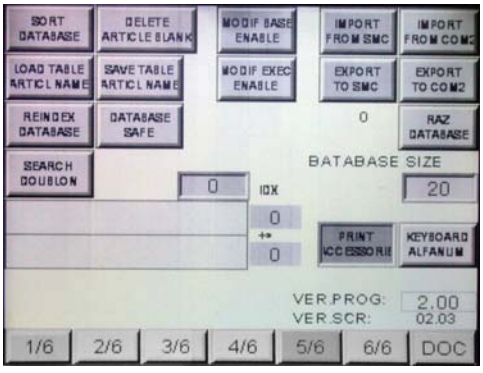


In page 2 are the options to configure the execution counter:
-mode inc count: to select increasing or deacreasing counter.
-counter divisor: to be set at 1 for corner counting, at 4 for frame counting
Page 3 enables you to define operational preferences of the machine.
The main options are:
-3099/486 MODE preference
-Manuel/Auto default mode when the machine is turned on.
-Stapling mode 111,1212, 122 (first pressing and boosted pressing).
The stapling mode will define the use of first pressing (gentler) and second pressing (more powerful).

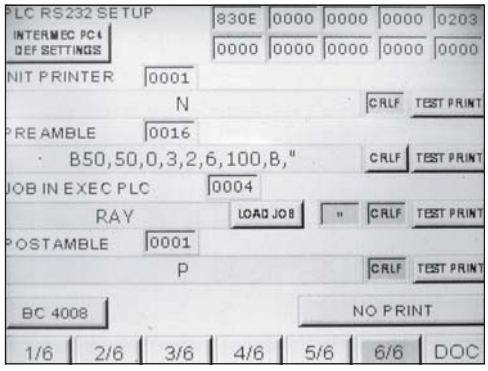
1111 : the machine only uses the first pressing (soft mouldings).
1212 : the machine, for each wedge, will use normal an great pressure: it gives a progressiv increase of pressure on top of the moulding, can be usefull for some soft mouldings
1222 : the machine, for the first wedge, will use normal an great pressure so the bung moves down gently, then for stacked wedges will run directly with great pressure so it goes faster and helps penetration of the wedge
222 : only the main pressure (saves time with very hard would).



Page 4 enables visualisation of Input/ Output. This page is functional, even during continuous operation of the machine.



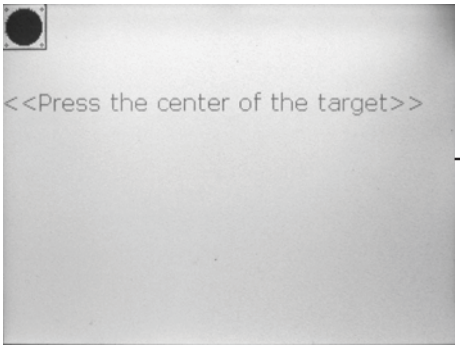
Page 5 is used to manage the items database.
Use only at the request of CASSESE Customer Service.



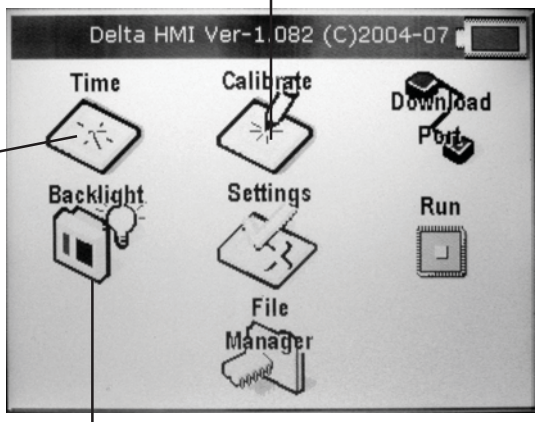
Page 6 is used for the parameterization of the printer.

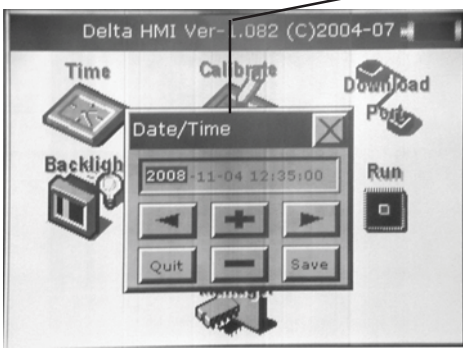
7) SYSTEM PARAMETERS

After pressing down on the SYS button, you can access the systems parameters. Some require a password. Authorised adjustments for a basic user are:

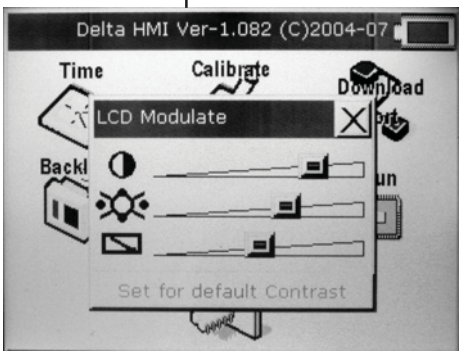


CALIBRATE: To calibrate the touchpad, follow the .instructions on the screen. Press the centre of the black circle.



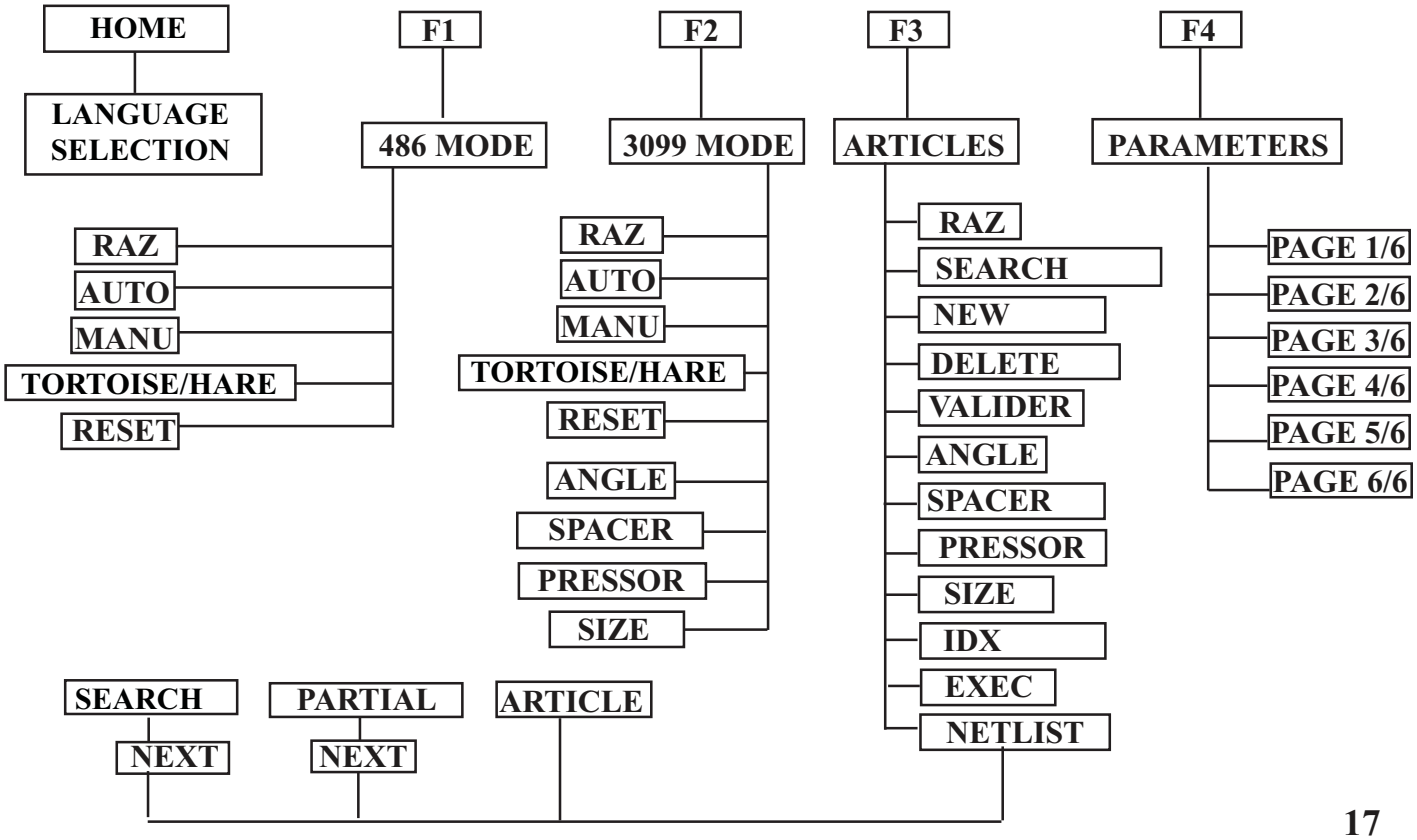


TIME:
Select Year-Month-Day-Hour-Minutes-Seconds with the left/right arrows and change the values with the + or - buttons. Save the settings with the **Save** button or use **Quit** to exit without saving changes.



BACKLIGHT: Adjusts luminosity, contrast and brightness of the screen.

CS4008 UNI PROGRAM CHART



MAINTENANCE

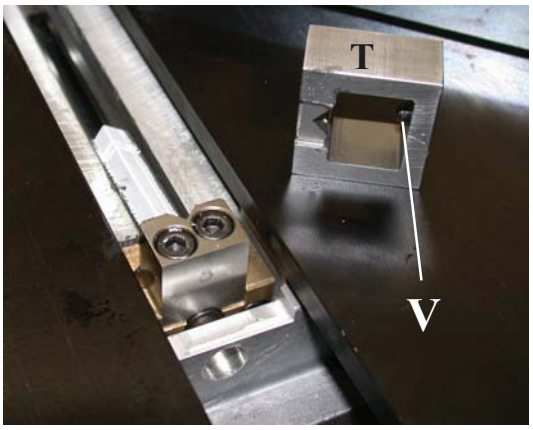
Important :

Before any work concerning the mechanical parts of the machine or its electrical cabinet, make sure to turn off both the power and compressed air supplies.

1. SCHEDULED MAINTENANCE :

In order to preserve your Cassese® machine and all its qualities, we recommend periodic preventive maintenance. This is why your Cassese® machine will display an alarm message, after every 50000 wedges, asking you to perform maintenance on the wedge distributor. The message «nails maintenance» means it's time to clean the wedge distributor. Follow the maintenance procedure described in the chapter entitled « Block H Maintenance ». Then reinitialise the alarm as explained in «reinitialising the nails maintenance alarm».

2. Distribution unit maintenance



To clean the distribution unit or merely to unjam the machine, we recommend following this procedure:

- Use the 2.5 mm Allen wrench that comes with the machine.
- With the 2.5 mm Allen wrench, unscrew the screw V from the stapling head (T) in place, then pull upward to remove it from its housing.
- Remove the staples from the distribution groove.
- Clean using a clean cloth.
- Replace the stapling head and tighten the distributor's locking screw using the 2.5 mm Allen wrench.

3. REINITIALISING THE WEDGE MAINTENANCE ALARM:

After performing maintenance on the wedge distributor block, press F4 in order to access the parameter pages of the machine. In page 1 press the button RESET NAILS ALARM. The machine will request an access code, type 5000 and confirm by pressing ENTER to reinitialise the alarm message.

4. ADDITIONAL REQUIRED MAINTENANCE:

We recommend keeping the machine clean. Check the ventilation filter of the electrical cabinet as well as the general state of the cabinet. If it is dirty, use a vacuum cleaner on the inside of the cabinet. Do not use compressed air. There is a filter on the ventilator outlet. Remove and inspect it. Eventually clean it with water. Dry it completely before installing it back in the machine to avoid any contact with water.

To clean the CS4008 UNI (table or body) do not use water based solutions, prefer WD40 or silicone sprays, which can be used to clean grime and glue residues. Do not douse the machine ! Spray the product on a soft cloth and use it to clean the machine. Do not use solvents. The two tables of the machine are made of a composite material. The advantage is this material does not suffer from corrosion and wood adhesive does not stick to it.
To clean the table, avoid sharp tools that could damage the surface. This can make the table porous and make glue stick more easily.
The mechanical unit used to move the stapling position forward and back does not require any special maintenance. Only the vertical column that supports the post must be lubricated (use 15W40 motor oil). Place a few drops of oil at the base of the column and do some stapling to help the oil penetrate the shaft. Lubricate this area at least once a year and more often during intensive use.

Like any machine that includes mechanical and electrical parts, it is strictly forbidden to expose it to water. The machine should be used and stored in a temperate room, away from humidity, cold, or excessively high temperatures. Using unsuitable or other brands of wedges instead of Cassese® genuine Masters™ «UNI» wedges may cancel the warranty. Without special authorisation, any dismantling of the machine (other than the procedures in this manual) by an unqualified person also cancels the effect of the warranty.

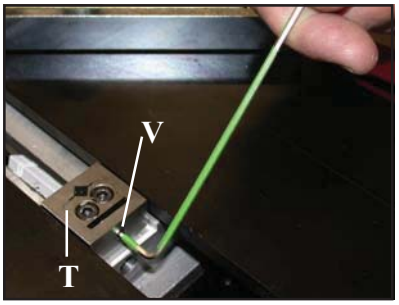
The following parts are considered as consumables and their wear is not covered by the warranty. Their life cycle depends directly on the proper use of the machine:

Z22003	hammer
Z1783	yellow elastomer 30 mm
Z1791	green elastomer 30 mm
Z1813	white triangle
Z1814	black triangle

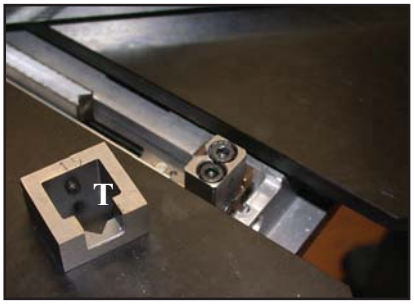
We recommend having your Cassese® equipment serviced once a year by your Cassese® distributor. This interval can be shortened in cases of intensive use. The cost of this service is not covered by the warranty. It is normal maintenance procedure.

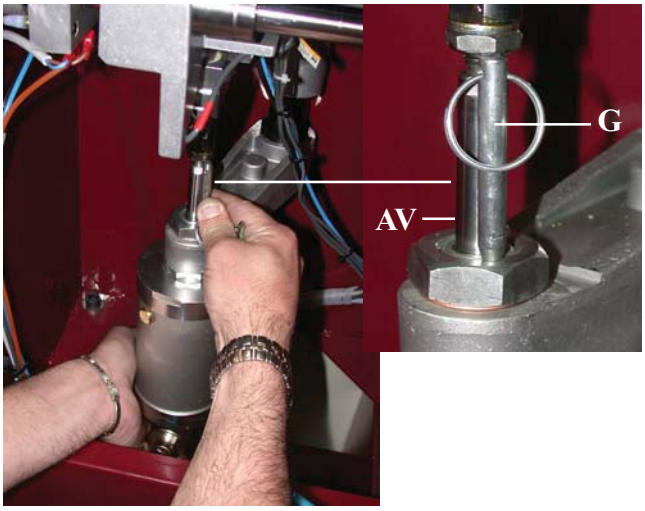
5. Replacement of the hammer

Before to perform any maintenance on mechanical or electrical parts, to ensure your safety, unplug the machine from air pressure and electrical supply

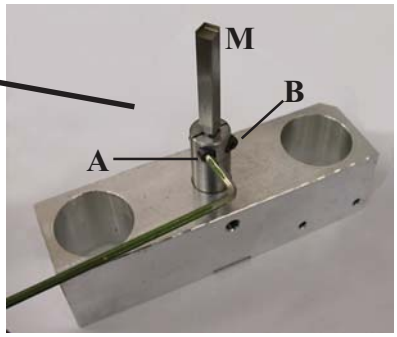


Unlock the V screw of the wedge's distribution block T (see fig 2 p.A) with the Allen de 2.5mm that is supplied with the machine. Pulling the head up, remove it from the machine

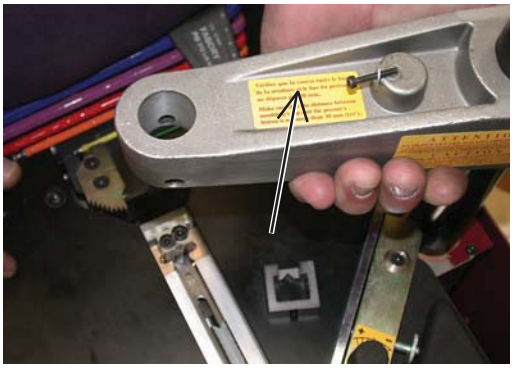




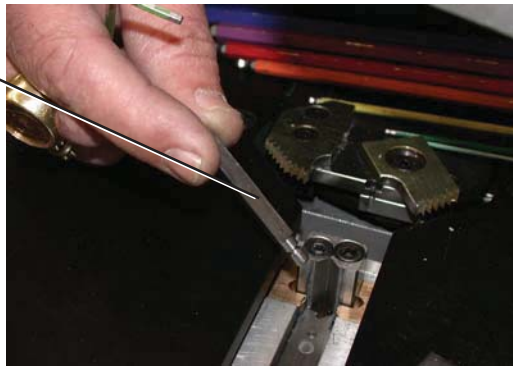
Open the access door of the mechanic, install the pin G of the bung support against the axe of the piston AV as shown in upper picture.



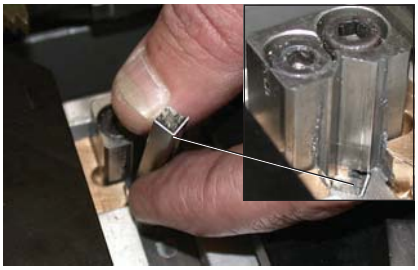
Inside the machine, using the 2.5mm Allen key, remove the two screws A and B holding the hammer.



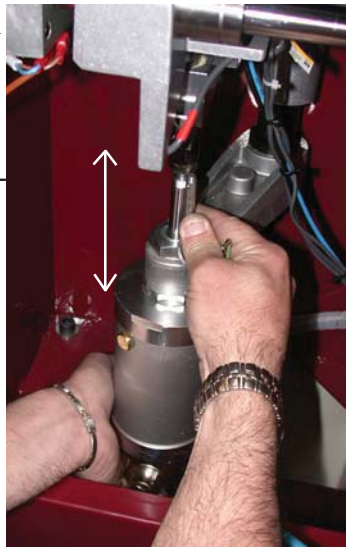
Lift up the pressor arm to be able to catch the hammer and take it out of the machine.



Apply some grease on the new hammer and insert it back inside the machine as indicated in attached picture. Remove excess of grease.



Inside the machine, tighten back the screws A and B with the Allen key of 2.5mm.
Check the hammer installation, it must be able to slide with no hard point then remove the pin G.
Install back the needed distribution head and lock it using the Allen key of 2.5mm.

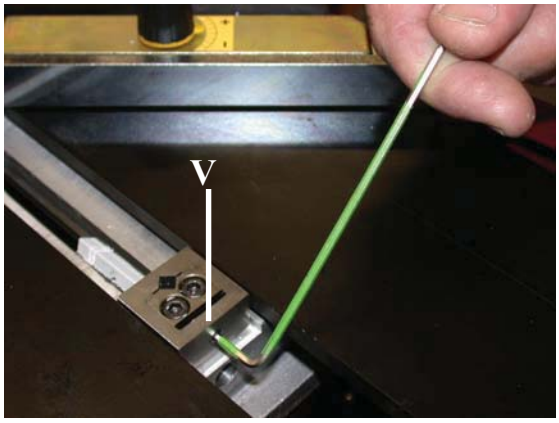


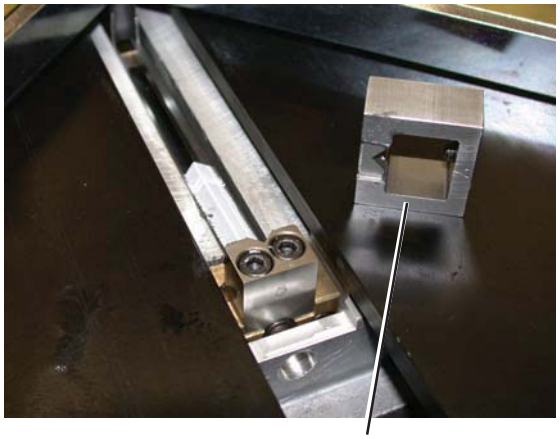
If, once block H has been unlocked, it is still impossible to pull it up, this is because the hammer is still locked in position by screw Z1394.

There is no need to dismantle the blocking screw. A simple operation will enable you to unblock the hammer. To do this, place your hands flat on the aluminium post that houses the presser. Press firmly down, several times if needed. A snapping sound indicates that the screw has unlocked the hammer. You can remove the distributor block and perform the maintenance procedure described in «**B**lock H maintenance».

6. <u>Extracting a wedge caught in the distributor:</u>

During the joining process, it is possible for a wedge to enter the distributor and not be pushed into the moulding (for example if the pedal is suddenly released or pressure is too low). In this case, the top of the wedge remains visible at the distributor exit and the cartridge cannot be removed. The message «Alarm Nail Up» or «Ãlarm Nail down » can appear on the screen.





- Using the 2.5 mm Allen wrench provided, unscrew the locking screw (V) of the <u>stapling head</u>.
- Remove the head T and eventual jammed wedges.
- Install back the head in the machine and lock the screw V.

TROUBLESHOOTING GUIDE:

You will find bellow the answers to frequent questions or troubled experimented by the users of the CS4008 UNI machine.

Nothing lights up, the screen is off when the emergency button is released.

> Check, for example by connecting another appliance, that the electrical outlet on which is plugged the machine is not defective.

> Open the machine door and check that the circuit breaker is in the «I» position. If it is off (button turned downwards), try to turn it back on. If it switches off again, contact your distributor to diagnose the problem. For information, the internal plug in the electrical cabinet is for connecting a barcode reader. Connecting a more powerful appliance can cause the machine to shut off. If this is the case, unplug the appliance before reinitialising the circuit breaker. DO NOT connect an appliance other than the barcode reader to this outlet.

The machine displays the message «alarm air pressure» and will not staple.

> Adjust the air pressure of the compressor or the machine.

The machine displays the message «nails maintenance».

> Refer to the section «scheduled maintenance».

The machine displays the message «pedal and pre-clamp».

> The pre-clamping button is still in the «ON» position during an attempt at joining by pressing the pedal. Turn it to «OFF» before pushing the pedal.

When I push the pedal, the machine blocks the mouldings with the clamps, but then releases them and does not shoot the wedge. The message «safety clamping» is displayed.

> The table has moved back (handle not tightened enough) and proper clamping of the mouldings is not possible. Repeat the pre-clamping procedure.

> The pre-clamping procedure was not performed correctly. Try again, following the instructions in chapter 6**.**

The machine appears to be inserting the wedges normally, but the «reload nails» message is displayed.

> The wedge channel is empty. Reload wedges and try joining again

> The hammer is broken. Perform the procedure described in «replacement of the hammer».

When you have dismantled the distributor, check the hammer to see if it is not damaged.

The machine appears to be inserting the wedges normally, but the wedges are not completely inserted.

> The hammer is broken. Perform the procedure described in «replacement of the hammer».

> The moulding is too low or too narrow. Therefore, the vertical presser cannot block it correctly against the stops. Use the «set of spacer bars» to join the moulding (see page 5).

> Air pressure is too low. Adjust the air pressure of the compressor or the machine.

> The moulding is not properly clamped to the table during the stapling process. Check the stapling position for stability of the upper presser and that the moulding is properly braced against the table. If you are using the machine near a table supporting the frame, make sure the mouldings remain level. If this is not the case, adjust the furniture or the machine so they are the same height (the machine has adjustable feet).

> The pedal was released too quickly. Try stapling again, keeping the pedal down until the cycle is completely finished.

The machine blocks, with the vertical presser against the moulding, then releases the pressure and displays the messages «alarm nail up».

> Air pressure is too low. Adjust the air pressure of the compressor or the machine. DO NOT exceed 8 bars.

> The wood is too hard. You can increase pressure, but DO NOT exceed 8 bars. Use «hardwood» wedges.

> Try to use lower the hammer is damaged or decrease the number of wedges at the blocking position (if stacking).

> The hammer is twisted or blocked. Perform the procedure described in «replacement of the hammer». When you have dismantled the distributor, check the hammer to see if it is split or twisted.

> The distance between the presser and moulding is too great. Adjust the height of the presser support with the pin. It should be less than 5 centimetres.

> The downward movement of the presser is too slow. Use the speed regulator located on the side of the machine to increase it.

> The hammer is jammed, perform the procedure described in «replacement of the hammer» to unblock the hammer.

The machine blocks, with the vertical presser against the moulding, then releases the pressure and displays the message «alarm nail down».

> The pedal was released too quickly. Try stapling again, keeping the pedal down until the cycle is completely finished

The machine blocks and displays the message «start of travel nail».

The sensor that informs the machine the hammer is in the downstroke position sends information that the hammer has not returned down. Perform the procedure described in «replacement of the hammer» to unblock the hammer.

The wedge breaks in the wood.

The wood is too hard. Use special «hardwood» wedges.

The backs are stained.

The distributor is full of grease. Perform the procedure described in «replacement of the hammer» and remove any excess grease. Do some stapling in scrap mouldings to purge any excess. Then wipe off the top of distribution block.

Handling the mouldings is difficult.

The horizontal presser (clamps) is too tight against the mouldings. Repeat the pre-clamping procedure described in chapter 3 page 6.

The corners are crooked.

Make sure to place the first moulding against stop B1. See figure 2 page A for more details. Make sure that clamping pressure is sufficient. Use the «clamp pressure» regulator to adjust it.

The message «corrupted database» is displayed.

Press F4, then select page 5. Press «re-index database». The machine will request a code. Enter 0721, then confirm by pressing ENT. Re-indexing starts. This operation can take several minutes as the database can hold up to 3,000 items.

If none of these suggestions produces the desired result, please contact your local Cassese® distributor. You can also contact us directly at www.cassese.com

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