



# CS 4008 XL

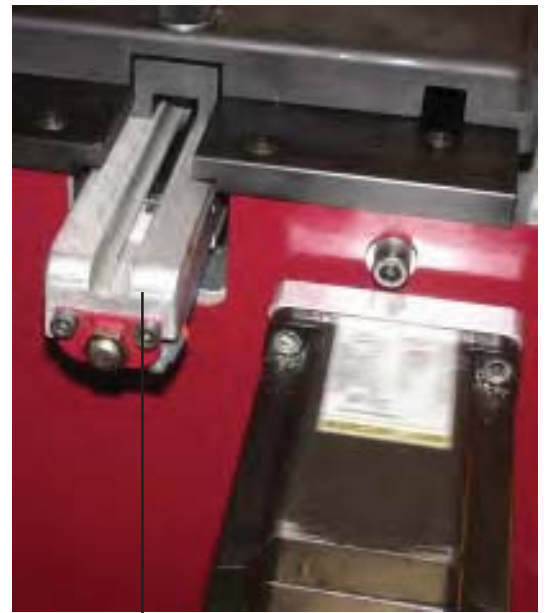
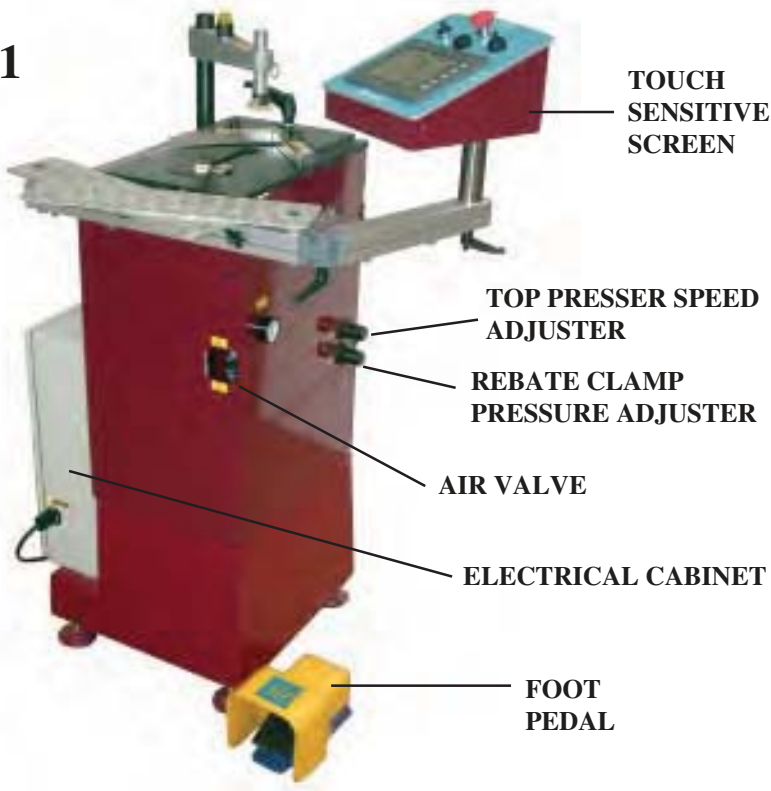
NUMERIC UNDERPINNER / ASSEMBLEUSE NUMERIQUE



## Technical and User Manual Manuel Technique & d'Utilisation

Version 1 - 11 / 2008

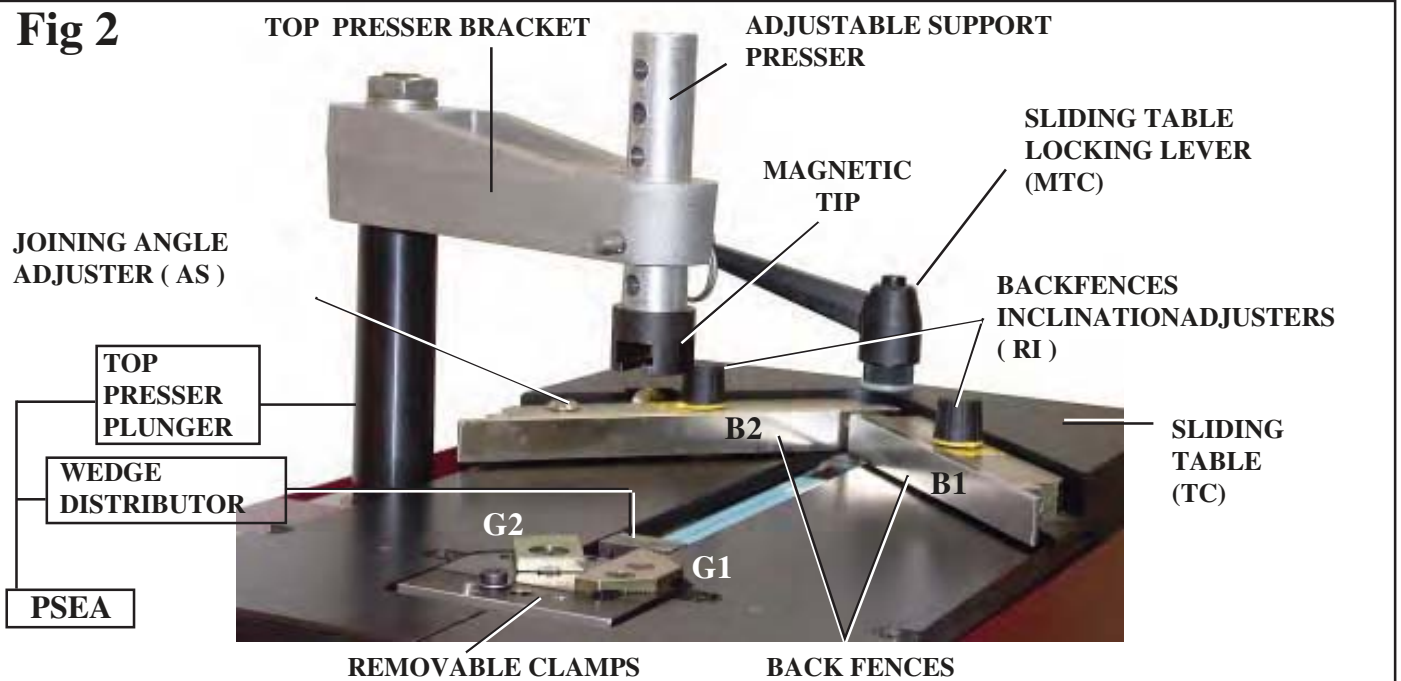
**Fig 1**



**CS 4008XL  
DESCRIPTIVE**



**Fig 2**



# CS4008XL INDEX

CS4008XL DESCRIPTIVE	A
INTRODUCTION	
ACCESSORIES	1
SPECIFICATIONS	1
OPTIONS	1
WARRANTY	1
SETUP	
1) INSTALLATION	2
2) CONNECTING TO COMPRESSED AIR	3
3) START UP	4
ADJUSTMENTS	
1) CHOICE OF PRESSER	5
2) HOW TO USE THE SPACER BARS	5
3) ADJUSTING THE SLIDING TABLE	6
4) SELECTING THE STAPLING POSITIONS	6
5) ADJUSTING ANGLES OF THE STOPS	6
6) ADJUSTING THE JOINING ANGLE	7
JOINING	
1) MEANS OF JOINING	7
2) LOADING WEDGES	7
3) JOINING IN MODE 486	8
a) SETTING COUNTER PARAMETERS	9
b) MEMORISING JOINING PARAMETERS	9
4) JOINING IN MODE 3099	10
a) MEMORISING JOINING PARAMETERS	11
b) JOINING A FRAME	11
5) ITEMS MODE	12
- MANAGING THE ITEMS DATABASE	12-13
NETWORK MODE	14
PARAMETERS	
6) PARAMETERS	15
7) SYSTEM PARAMETERS	16
PROGRAMME CHART	16
MAINTENANCE	
1) SCHEDULED MAINTENANCE	17
2) BLOCK H MAINTENANCE	17
3) REINITIALISING THE WEDGE MAINTENANCE ALARM	18
4) ADDITIONAL REQUIRED MAINTENANCE	18
5) UNBLOCKING THE HAMMER	19
6) EXTRACTING A WEDGE CAUGHT IN THE DISTRIBUTOR	19
TROUBLESHOOTING GUIDE	20-22

# **INTRODUCTION**

You have just acquired a CS 4008 XL underpinning machine. We congratulate you on your excellent choice and thank you for your confidence. The CS 4008 XL 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® CS wedge cartridges

## **ACCESSORIES**

The CS 4008 XL 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)/1 White triangle (standard wood)/1 magnetic rubber imprint base/1 Green rubber tip (30 mm hardwood)/1 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.

## **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 Cassese wedges in packages of 275: 5-7-10-12-15 mm. 3-4 mm available on request.

Two types of wedges: standard wood and hardwood.

Weight of the CS 4008 XL: 150 kg

Overall dimensions: Width (without base) =52 cm, Depth=62 cm, Height=118 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**

Circular rotating table (ref. Z3074) Adjustable presser (ref. Z3898)

Barcode reader Z21476 (contact customer service).

File storage software for PC. Copies item files from the 4008XL to a PC and from a PC to the 4008XL.

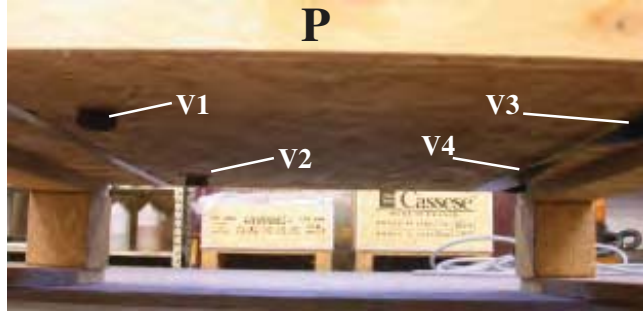
## **WARRANTY**

The CS 4008 XL 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.

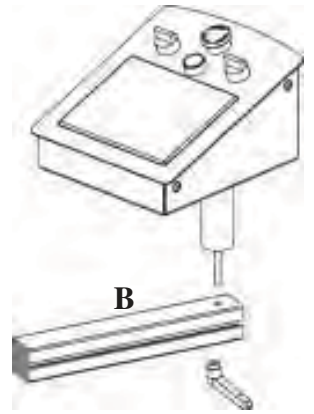


# SETUP

## 1 ) INSTALLATION



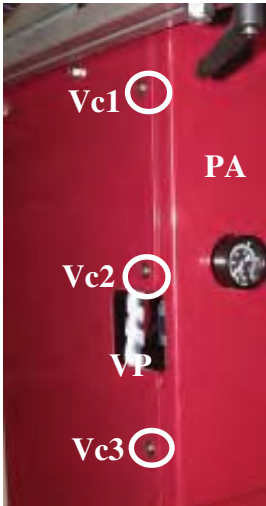
Remove the two bands C1 and C2. To unpack the CS4008XL, slide the crate up over the top of the machine. The machine is attached to its transport pallet P by 4 screws underneath: V1, V2, V3 and V4. Remove them with a 24 mm flat wrench. Install the 4 feet (supplied) by screwing them firmly under the machine.



Install the screen unit on swivel arm B.

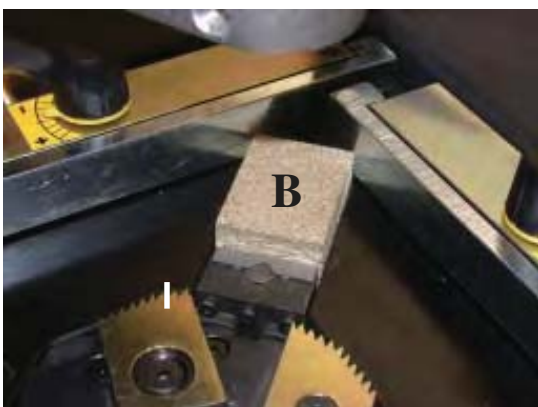
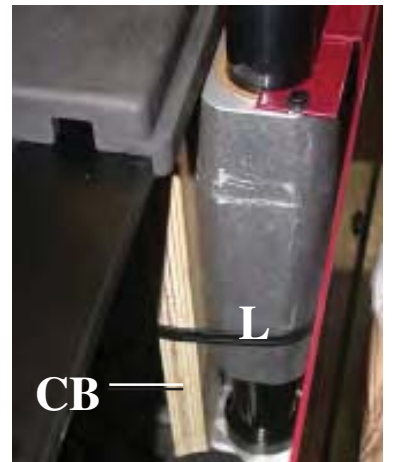


Remove the 4 fastening screws on the motor with a 4 mm Allen key. Use them to attach motor M to collar E.



Remove the 3 screws in the plating Vc1, 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 the presser arm (see fig. 2 p A) remove wooden block CB. Gently release the presser arm.

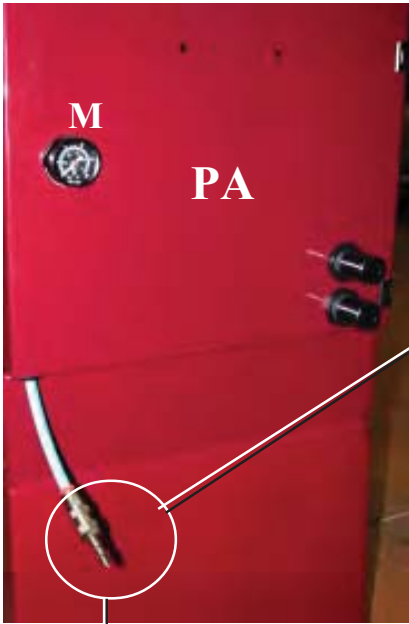


For safety reasons related to the transport of your CS4008 XL, a wooden block has been placed between the distributor head and the sliding table.

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.

### PNEUMATIC CONNECTIONS



**STANDARD**



**Z 749**

**FEMALE QUICK RELEASE CONNECTOR**



**Z 556**

**RIBBED NOZZLE**

**Z 675 PRESSURE REDUCING CONNECTOR**



**USA**

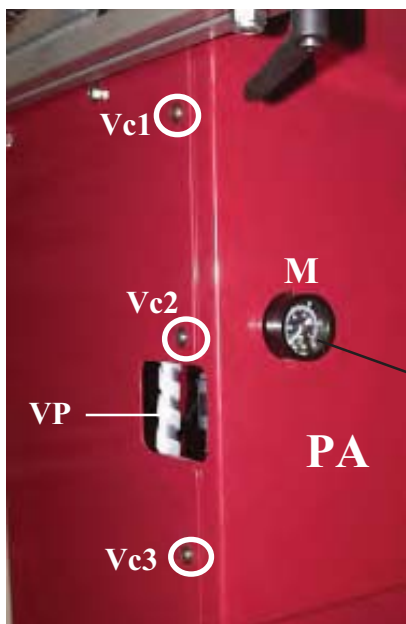


**Z 701**

**USA NOZZLE**

**COMPRESSOR**

If the pressure indicated is not 6 bars:



Remove the 3 screws in the plating Vc1, 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 CS4008XL 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.

**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.

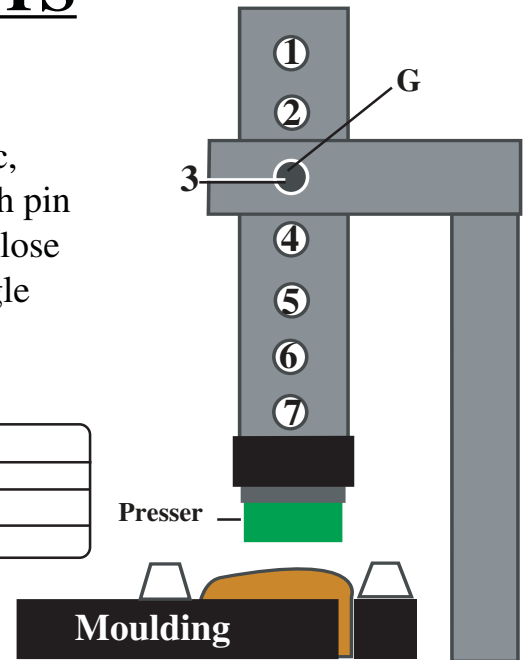


# ADJUSTMENTS

## 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 B1 and B2: see fig 2 page A of the instruction manual)

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



## POSITIONING THE PRESSER

### POSITIONING OF RUBBER PRESSERS/TRIANGLE

#### MAXIMUM MOULDING HEIGHT FOR THE 7 POSITIONS :



Position	Triangle	Rubber 30 mm
1	13 mm	20 mm
2	27 mm	35 mm
3	42 mm	49 mm
4	57 mm	63 mm
5	71 mm	73 mm
6	85 mm	92 mm
7	100 mm	170 mm

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**

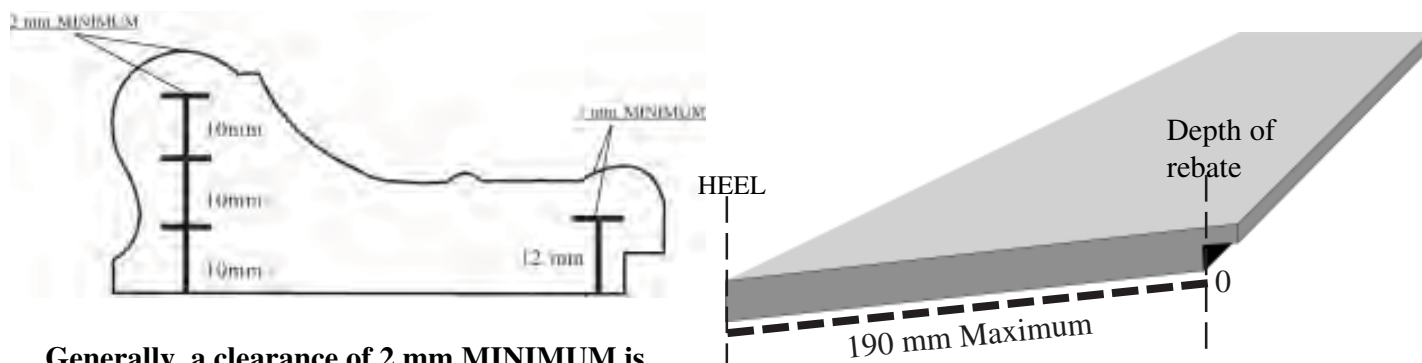


### 3 ) ADJUSTING THE SLIDING TABLE

- 1) Turn the «pre-clamping» button to ON.
- 2) Place a moulding against stop B1. 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 G1 (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 CS4008XL 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.

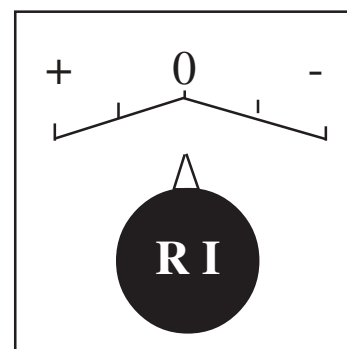


Generally, a clearance of 2 mm MINIMUM is required above the wedge. Wedges that are the same size can be stacked, in order to avoid changing wedge cartridges when joining frames of various thicknesses.

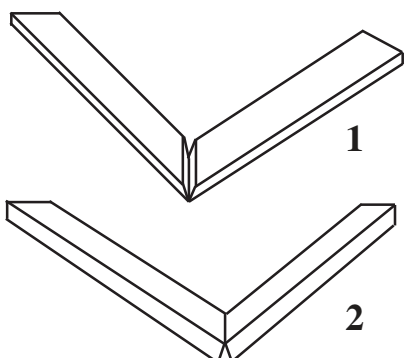
Measurement of the width is based on the diagonal cut from the depth of rebate to the heel. The profile width must not exceed 190 mm.

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



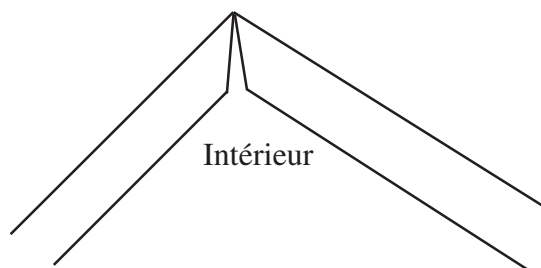
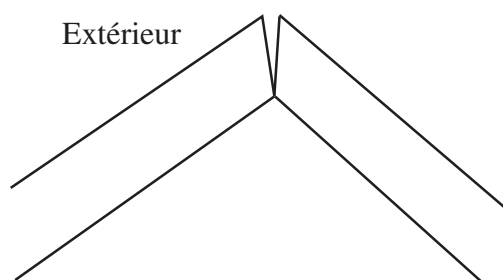
1) If the corner has an opening **on top**, turn the two adjustment buttons (RI) an identical value towards the MINUS sign (-) (Fig. 2 p A).

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).

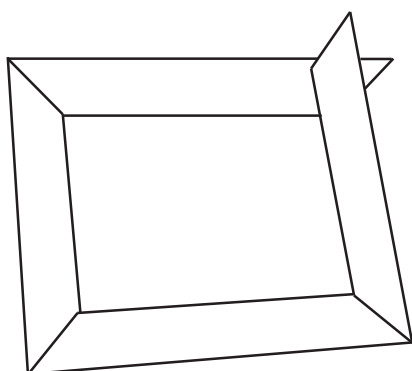
## 6) ADJUSTING THE JOINING ANGLE

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 wedge cartridges with your CS 4008 XL



Joining is performed using metal wedges specially designed to ensure perfect corners. Five standard sizes are available: 5, 7, 10, 12 and 15 mm, packaged in cartridges of 275 units for hardwoods or soft woods. On special order, cartridges of 3 and 4 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 loader 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.



### 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.

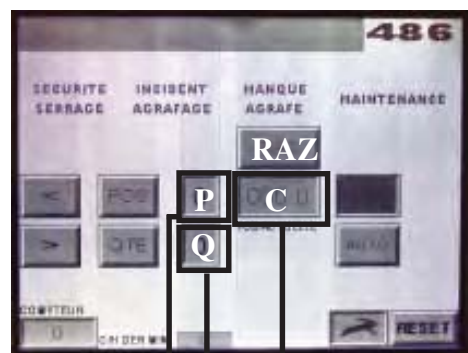


Turn the button **PRE-CLAMPING** towards **ON**. Reset at 0, if necessary, all the position fields **POS** and quantity fields **QTY** using the **CLEAR** button (**RAZ**).

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 B1 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 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).**



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 2/5. Specify using the button **M**:

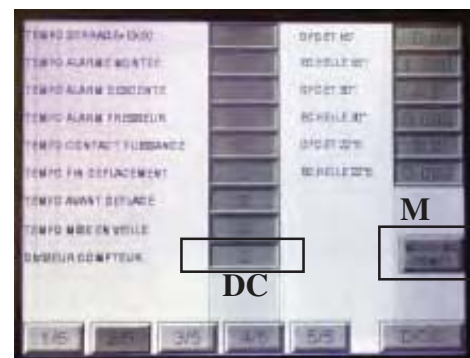
**Mode INC COUNT** (counts the stapling cycles by addition) or

**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 displays 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 3/5** (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 (1=slow) and boosted pressing (2=rapid). For example: TORTOISE=1 11 for fragile mouldings and HARE=222 for more sturdy mouldings.

When the machine is out of wedges, it completely retracts the cartridge loading slot and displays a message inviting you to insert a new cartridge CS. Remove the empty cartridge. Insert the 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)

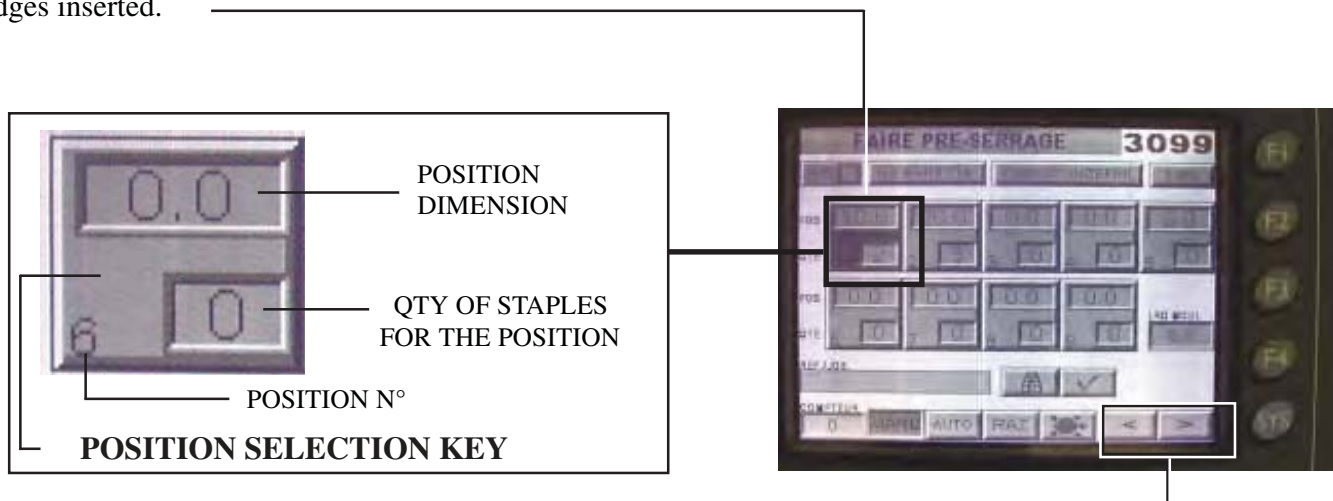


## 4) JOINING IN 3099 MODE

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 position points 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.



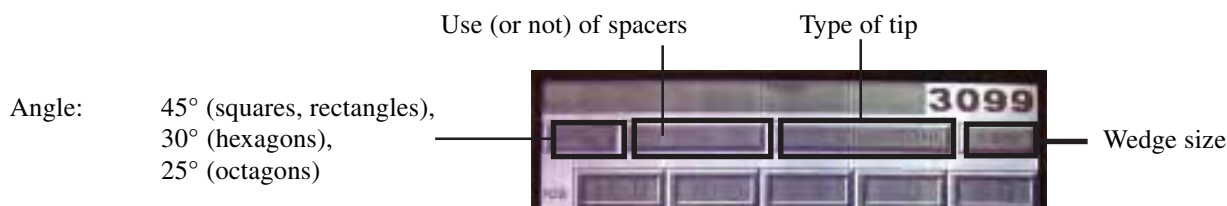
There are 2 methods for entering the **POSITION** parameters: **either** using the arrows < (back) and > (forward) which visually move the **P/SEA to the desired position**, **or** entering values via the numeric keyboard, which is displayed after pressing on the upper field (be careful to confirm each 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:

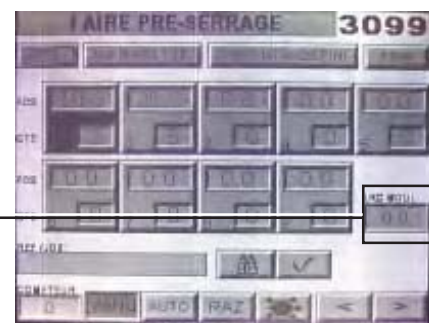
**ANGLE / SPACER BAR / TIP / SIZE**

By pressing these buttons, you can specify:

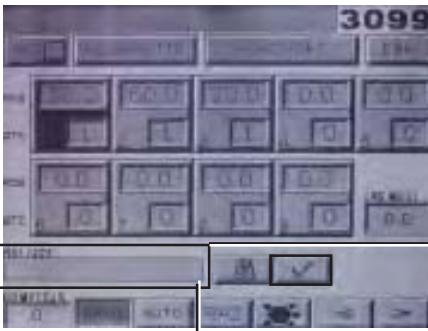


These elements do not affect the machine cycle. They are an optional visual aid for the operator.

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 8) Press the staple button to continue.



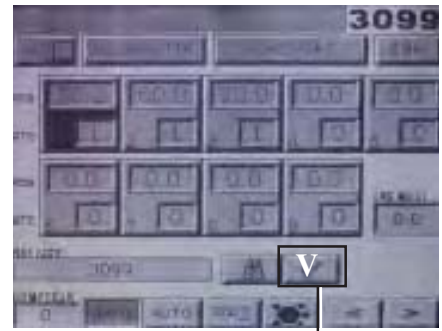
## A) MEMORISING JOINING PARAMETERS



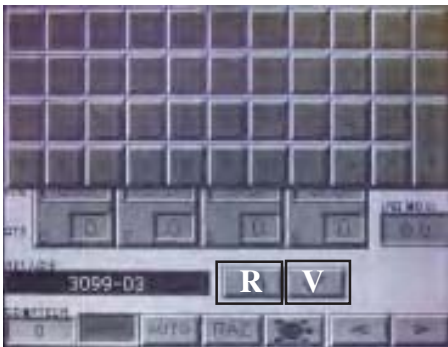
After pressing **REF/JOB** the machine will ask you to enter an item name using the numeric keyboard.



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.

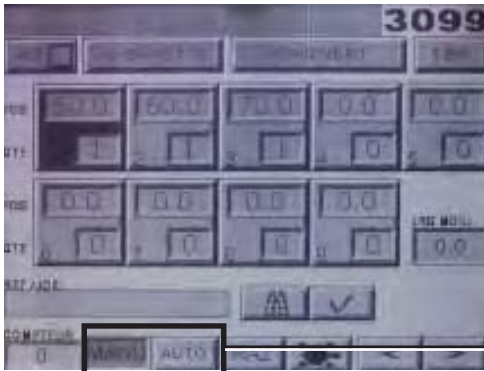
Enter the exact name of the item. Confirm by pressing **ENT**. I Then press **SEARCH**.

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

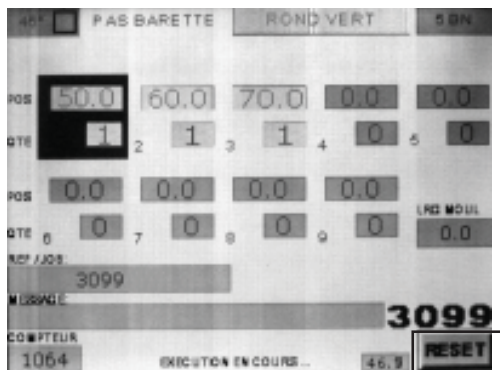
Once the parameters have been entered in the machine, two modes (**AUTO** and **MANU**) can be used to assemble the frame. They define how the stapling cycle will be launched:



**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**

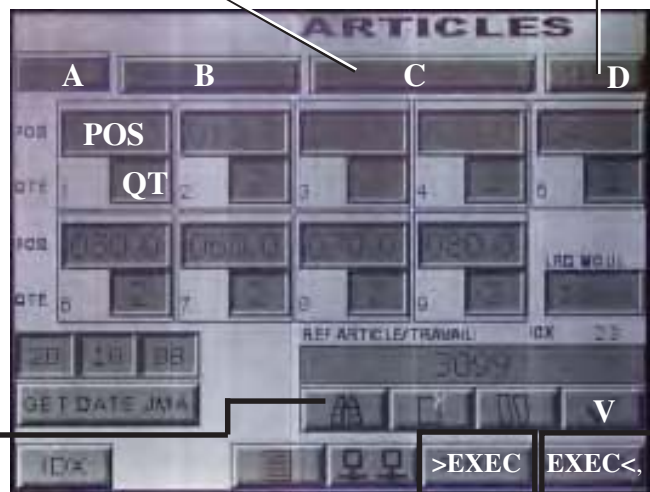
**Wedge size:** Choose the size after pressing button **D**

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 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.



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

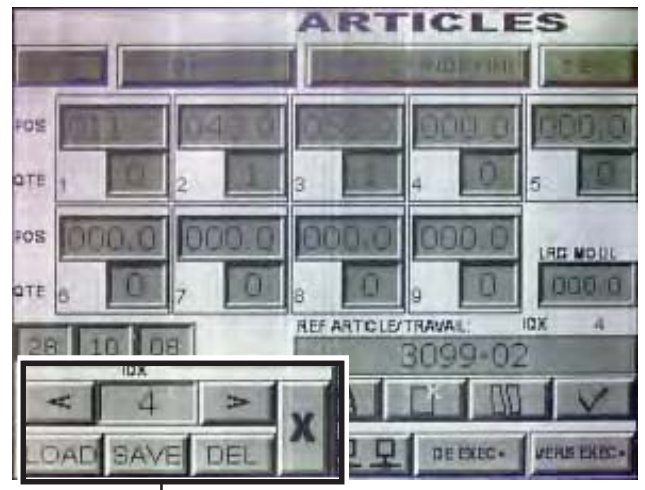
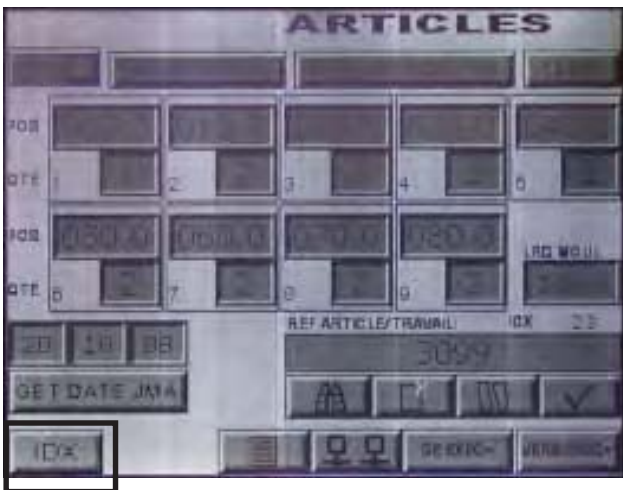
**To SEARCH** for a saved item, press on the name of the item. A numeric keyboard is displayed. Enter the name and confirm. Then press **SEARCH**. If the item exists, its parameters will be displayed. Otherwise, the message **INEXISTENT ITEM** will be displayed.

**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**



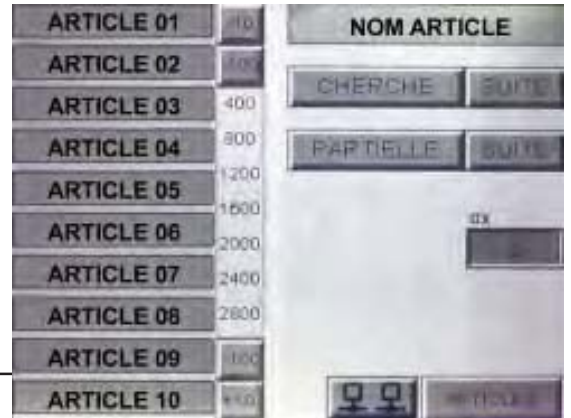


If you press **IDX**, a new screen will be displayed, enabling you to scroll down the list of items saved in the machine.

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



**LIST OF ITEMS** —————  
**NETLIST**



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.

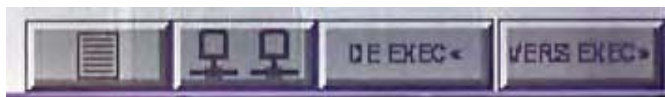
The operator selects GET-Request for Job. 1 to 10 Jobs can be requested by a single machine.

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.

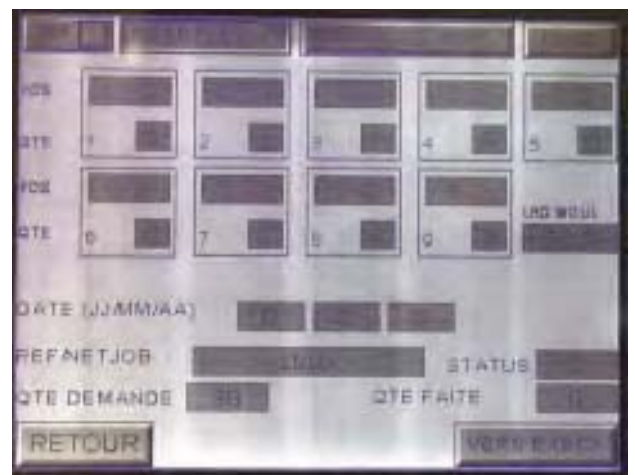
The PC/SERVER records the job, even if it is partially completed, deallocates the Jobs Done and creates a new list with the next 10 Jobs in the queue, and so on.

The machines are connected via a network cable (e.g. Ethernet CAT5) to a PC server.



**LIST OF ITEMS**

**NETLIST**



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 CS4008XL 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**

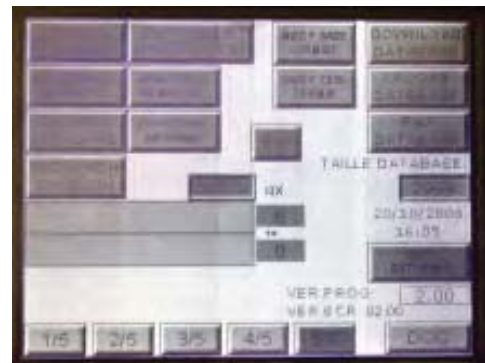


Page 3 enables you to define operational preferences of the machine. The main options are: -3099/486 MODE preference -INC/DEC counter cycle -Manuel/Auto default mode when the machine is turned on. -Stapling mode 111,1212, 122 (first pressing and boosted pressing). The stapling mode will define the use of first pressing (gentler) and second pressing (more powerful).

- 1111** : the machine only uses the first pressing (soft mouldings).
- 1212** : the machine presses each wedge a second time at each stapling.
- 1222** : the machine uses a first and second pressing, then, for stacking only, the second pressing (saves time).
- 222** : only the main pressure (saves time with very hard would).



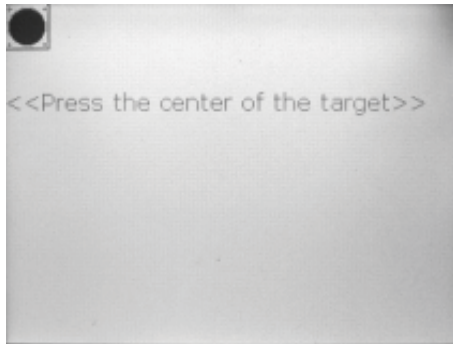
Page 4 enables visualisation of Input/Output. This page is functional, even during continuous operation of the machine.



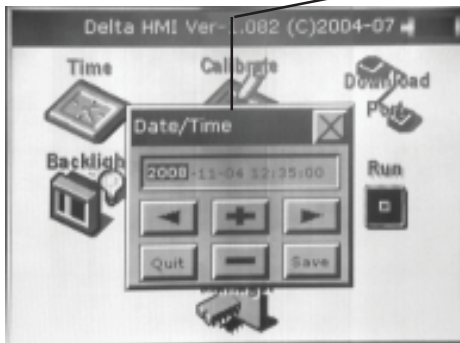
Page 5 is used to manage the items database. **Use only at the request of CASSESE Customer Service.**

## 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:

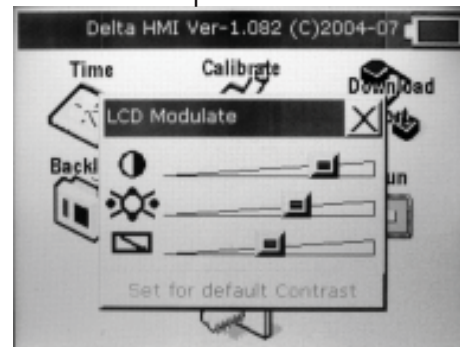


**CALIBRATE:** To calibrate the touchpad, follow the instructions on the screen. Press the centre of the black circle.



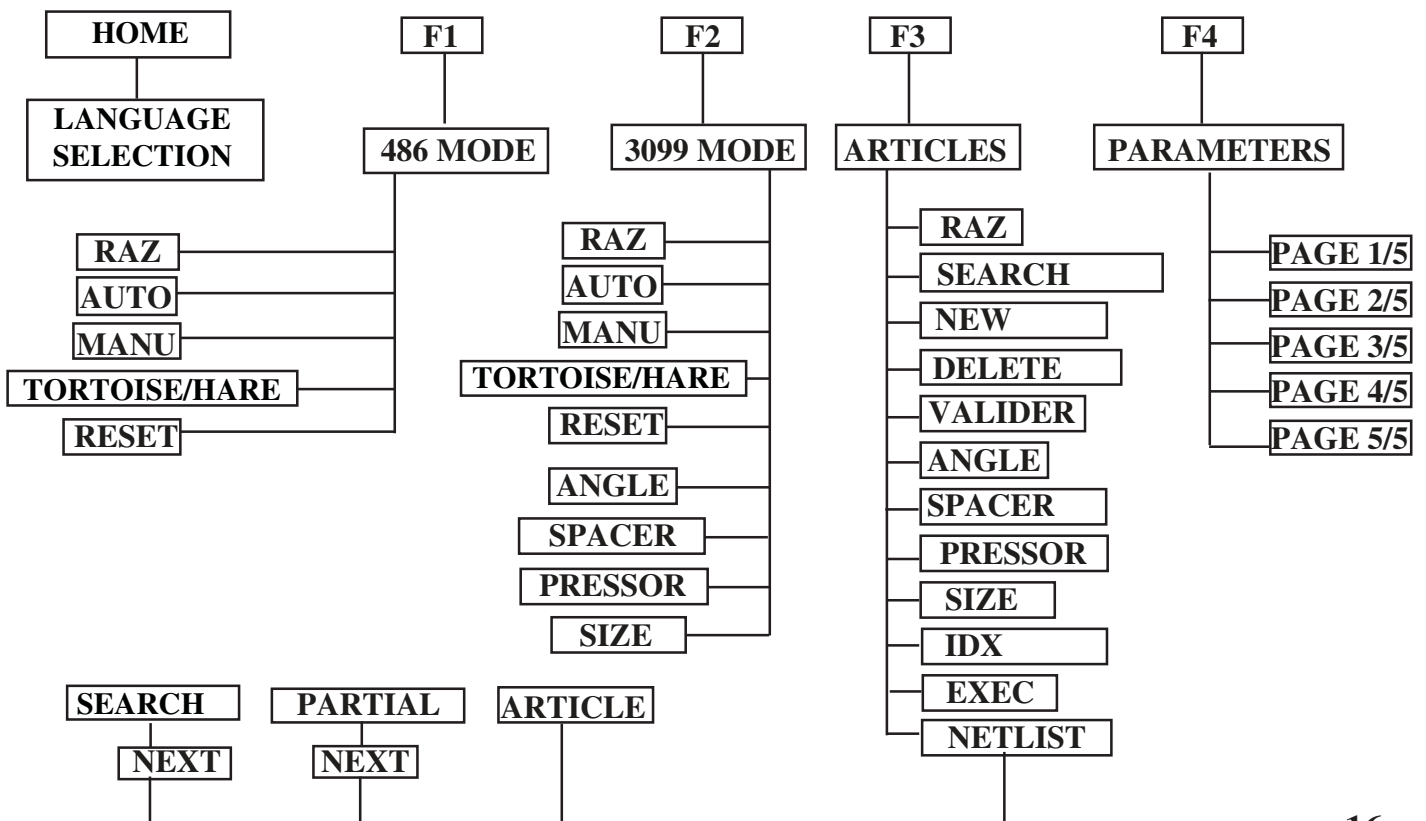
**TIME:**

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.

## CS 4008XL 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 block H. 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. BLOCK H MAINTENANCE :**

In order to clean block H or simply unblock the machine, we recommend the following procedure:

-Take the tube of grease, the 2.5 Allen key supplied with the machine.

-Using the 2,5 mm Allen key, loosen screw V to unblock block H.

-Pull up block H and remove it from its housing. If block H is jammed, follow the procedure for «unlocking the hammer».

- Once the block has been removed from the machine, use the 2.5 mm Allen key to loosen the six screws that hold it together and separate the three sections: the fixed guide G, plate P and back plate CP.

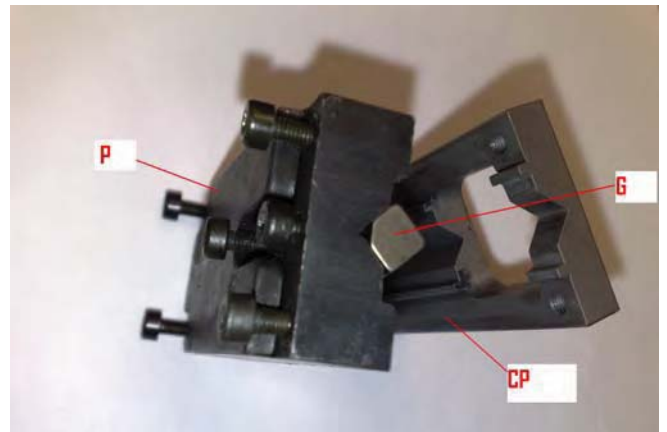
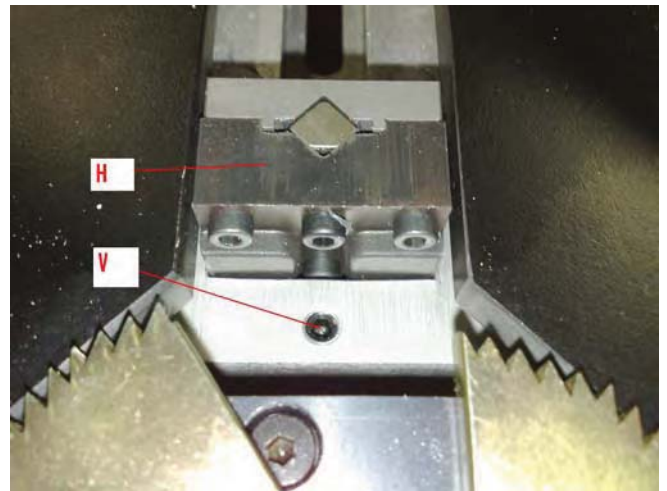
-Clean each part with a clean cloth. Inspect each one. Make sure there are no burrs. In the event of internal damage, a fine file can be used to eliminate any blisters inside the black part (plate P).

**IMPORTANT:** do not «eat away at the part» or reduce its dimensions otherwise, the machine will jam. The only solution at that point would consist in replacing the distributor block (order reference: Z817).

-Reassemble the three components of the block: the fixed guide G, plate P and back plate CP. Insert a knob of grease in the distributor block as shown in the illustration opposite.

-Replace the block in the machine, with the window facing upwards, towards the cartridge side. Make sure it has been inserted completely. It should be flush.

-Tighten the blocking screw with the 2,5 mm Allen key.





### 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 (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 that 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. The use of unsuitable consumables cancels the effect of 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:



- Z506 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. Unblocking the hammer:

The hammer (reference Z506) is a sort of long wedge (around five centimetres) located in the distribution block under the cartridge loader. A cylinder pushes it up so that it forces the wedge into the wood.

The hammer can become twisted or jammed if the machine is used incorrectly (use of unsuitable consumables, excessively hard wood, inappropriate stapling position...). It has a hole (in the lower part) in which the tip of a special screw is placed (reference Z1394). Indeed, this screw has a spring tip that normally retracts and releases the hammer if it is jammed in block H, so that it can be removed.



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 «Block H maintenance».



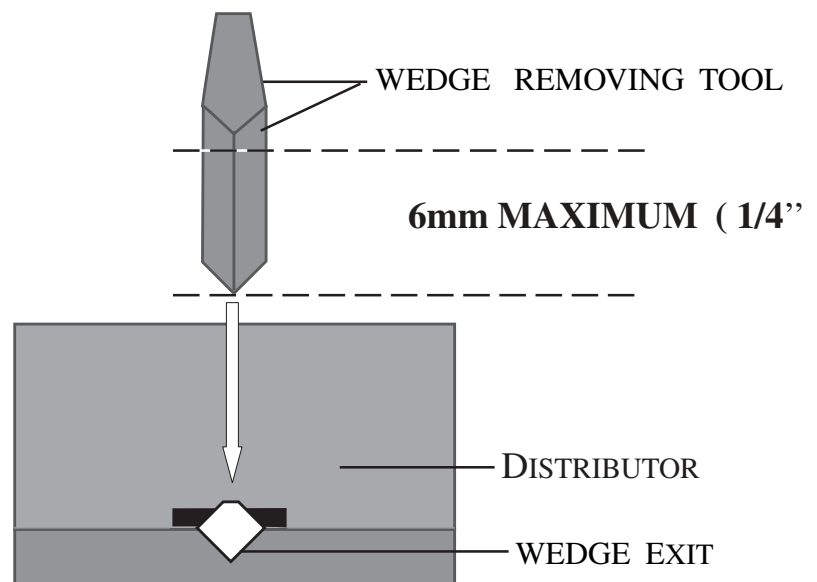
## 6. Extracting a wedge caught in the distributor:

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 «Alarm Nail down» can appear on the screen.

Use the wedge pusher tool provided with the machine accessories. Proceed as follows:

- 1- Disconnect the air supply.
- 2- Insert the wedge pusher tool and move the wedge down. Do not push the tool more than 6 mm into the distributor.
- 3- Try to remove the cartridge.

If inserting the wedge pusher tool is impossible, this means that the hammer and the wedge are both stuck in an upwards position. Apply the procedure described in «Block H maintenance».



## **TROUBLESHOOTING GUIDE:**

You will find below the answers to frequent questions or troubled experimented by the users of the CS4008 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 cartridge is empty, replace it and try joining again.
- > The wedge distributor is dirty and the wedges are blocked. Perform the procedure described in «maintenance of block H».
- > The hammer is broken. Perform the procedure described in «block H maintenance». When you have dismantled the distributor, check the hammer to see if it is split or twisted.

***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 «block H maintenance». When you have dismantled the distributor, check the hammer to see if it is split or twisted.

> 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 wedges or decrease the number of wedges at the blocking position (if stacking).

> The hammer is twisted or blocked. Perform the procedure described in «block H maintenance». 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 «maintenance of block H» 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 «maintenance of block H» 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 «maintenance of block H» and remove any excess grease. Do some stapling in scrap mouldings to purge any excess. Then wipe off the top of block H.

***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](http://www.cassese.com)*