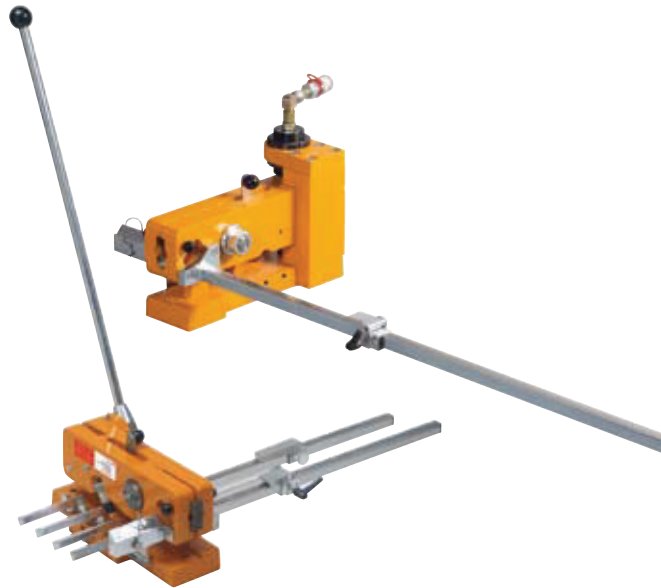


Operating instructions Section shears 2671

Contents

1. Introduction
2. Safety requirements
 - 2.1 General safety requirements
 - 2.2 Additional safety requirements
3. Handling of the equipment
 - 3.1 Intended use
 - 3.2 Predictable misuse / Improper handling
 - 3.3 Residual risks
4. Commissioning
 - 4.1 Assembly
 - 4.2 Hydraulic connection
5. Code of practice
 - 5.1 Mode of operation: Cutting
 - 5.2 Mounting of punching tools
 - 5.3 Mode of operation: Perforating
6. Maintenance / cleaning
7. Troubleshooting and service



Section shears 2671-0100-01-00 + 2671-0200-01-00

Drawing: Section shears for cutting and punching of section rails

1. Introduction

Thanks for your decision to purchase the Section shears 2671. The installation manual will provide a detailed description on how to operate this equipment safely.

Please treat this document with care and make sure that it is read, understood and followed by all operating personnel.

2 Safety requirements

2.1 General Safety requirements

Machinery with moving parts always bears the risk of bodily injury and requires specific caution and carefulness. To minimize the risk, please read this manual carefully before operating this equipment.

- this equipment may only be operated in faultless condition
- variations have to be reported to the supervisor immediately
- the work environment has to be tidy
- the work place has to be well illuminated
- large, heavy work pieces have to be secured against falling
- potentially leaking oil (leak) has to be cleaned up immediately
- operating personnel is required to wear proper safety apparel (gloves, antislip work shoes, close-fitting apparel, ear protection, safety glasses)
- work at the machine is prohibited if concentration could be affected (e.g. through drugs or alcohol)
- keep away children

The equipment is not designed and intended for any other work than described in this manual. In the case of misapplication, we will not be reliable for any resulting damages.

2.2 Additional safety requirements for the handling of the Section shears 2671

- Set-up and commissioning of this equipment must only be performed by qualified personnel that has read and understood this manual.
- Before connecting to a hydraulic pump, make sure that the hose is without pressure and the pump is switched off.
- For commissioning, cleaning, maintenance, change of parts, and tool changes, make sure that the equipment is without pressure (pump switched off)
- The maximum pressure of 450 bar must not be exceeded.
- Hydraulic hoses must not be bent. Be aware of tripping hazards.
- Safety mechanisms must not be removed or deactivated.
- The equipment must be switched off / made pressure-less if it is not used.

For damages, provoked by improper installation or non-compliance of the safety requirements, häwa GmbH & Co.KG can not be made liable.

Operating instructions Section shears 2671

3 Handling of the equipment

The Section shears are state-of-the-art and in accordance with the relevant safety regulations at time of placing on the market, and with regards to its intended application.

The Section shears 2671 hold an EC-certificate of conformance (see attachment), and are therefore in conformance with the machinery directive 2006/42/EC.

We reserve technical modifications as part of further developments of the machine.

3.1 Intended use

The section shears 2671 have been developed for cutting and punching of section rails of steel sheet, copper and aluminum. Depending on the design, it is powered by a hand lever or pneumatically.

The use of the section shears must follow along with the guidelines of this manual.

Each and every inappropriate usage are considered unauthorized handling and therefore outside of the manufacturer's limit of liability.

3.2 Predictable misuse / improper handling

With every modification of the machine and with predictable misuse or improper handling of the Section shears the EC-certificate of conformance ceases to exist and with that the operating license.

Predictable misuse / improper handling:

- Outdoor use
- Use with removed protective gear
- Unsecured use
- Use with blunt tooling
- Incorrectly executed repairs
- Non-intended use

3.3 Residual risks

Not all risk could be avoided structurally without confinement of its intended use. The residual risks of the Section shears have been analyzed with a risk assessment.

Possible residual risks that cannot be avoided structurally could be:

- Bruises through tilting over equipment during the installation
- Bruises through falling of large, heavy work pieces
- Bruises or cutting of limbs through disregard of this operating manual
- Bursting of a hydraulic hose
- Slipping on oil through hydraulic leak
- Unintended operation / turning-on of equipment
- Cutting injuries through tools or sharp sheet metal
- Pinching of fingers during the pumping (only with hand pump design)

Residual risks can be avoided by doing the following:

- Vigilant working
- Paying attention to all notes on the equipment and in this manual
- Following the general safety stipulations / regulations

Operating instructions Section shears 2671

4. Commissioning

For transportation purposes the length stop is packaged separately and needs to be installed before commissioning of the tool.
The screw have to be tightened securely.

4.1 Assembly

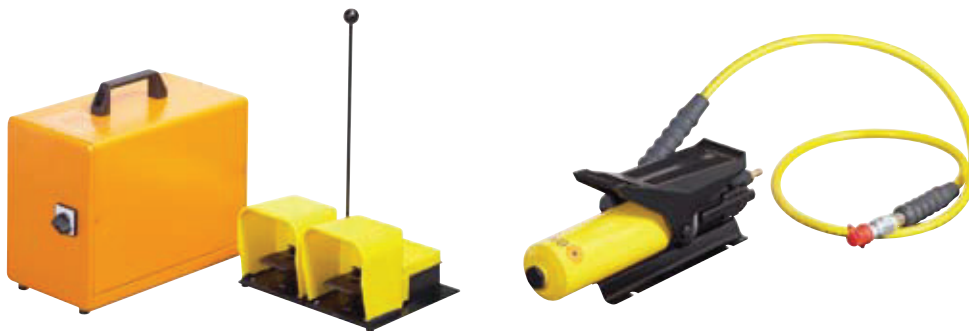
Screw section shears on solid base (table or bench) (pay attention to correct height for fatigue-proof operation).

When mounting section shears make sure that scraps can fall down (provide a drilled hole).

4.2 Hydraulicconnection

Connect hydraulic pump to section shears by means of quick release coupling.

Attention: You must not operate the quick release coupling under load.

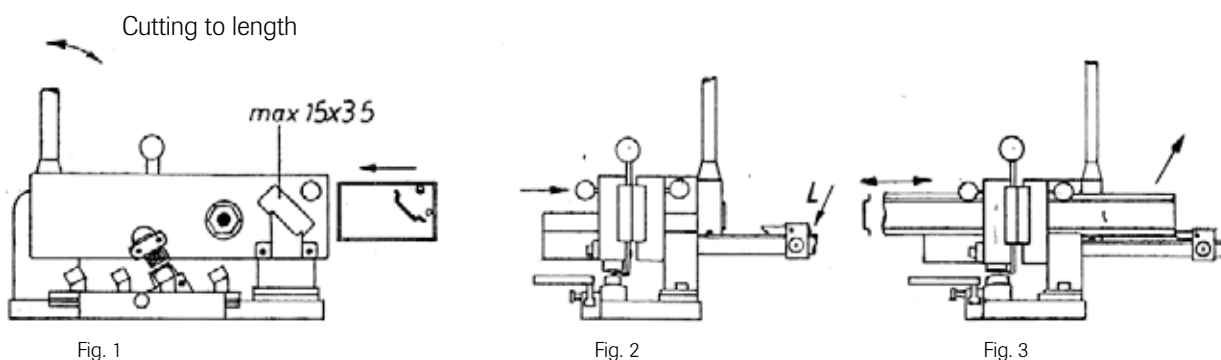


5. Code of practice

Attention: To avoid an overload, do not simultaneously cut and punch.

5.1 Mode of operation: Cutting

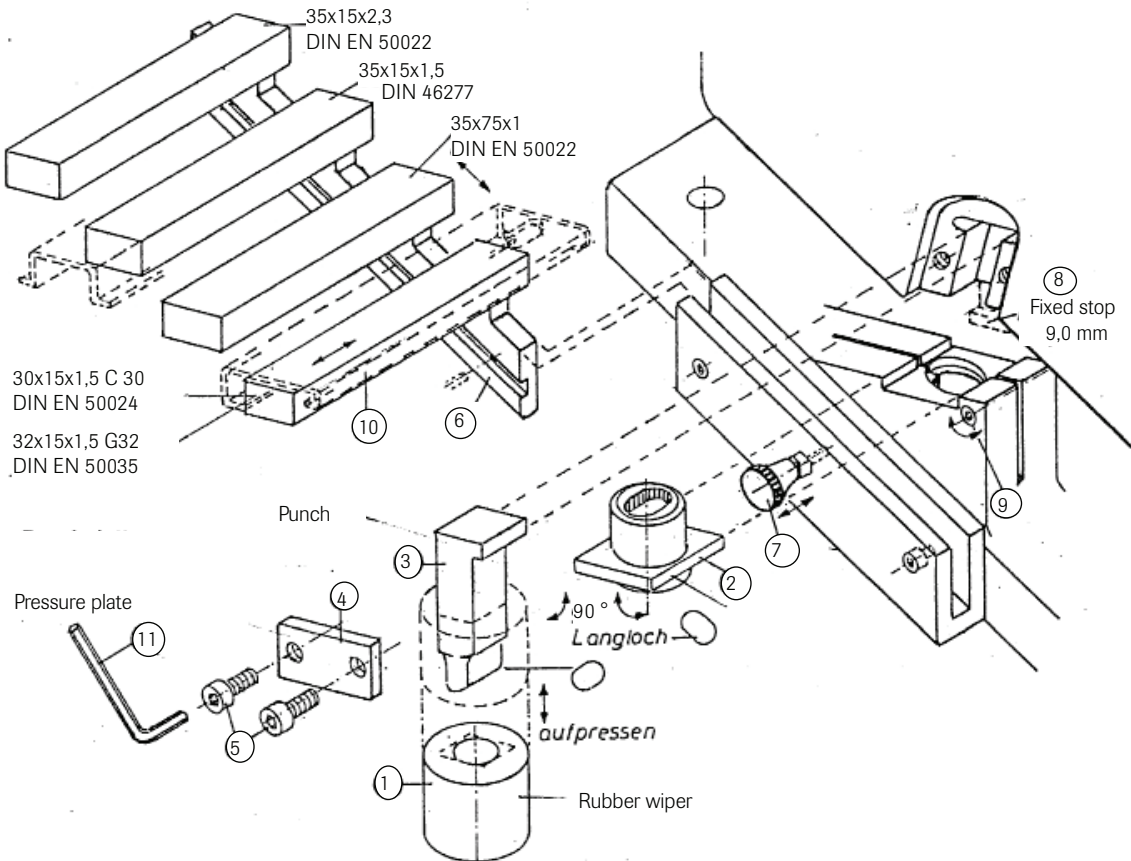
- Insert suitable shears plates from front in section shears (fig. 1)
- Snap in locking pins (fig. 2)
- Adjust length stop to required length (measuring scale at the right side of the stop) (fig. 2)
- Insert rail in the section shears through the guide from the left side until it stops (fig. 3)
- Operate hand lever or hydraulic pump for cutting
- Remove rail and scraps from the shears (fig. 3)



5.2 Mounting of punching tools

Press rubber wiper (1) with round hole onto punch (3). Insert and clamp (9) die (2). Insert punch (3) into support and secure it with pressure plate (4+5).

When punching oblong holes, please check if die is mounted in a vertical or horizontal position.



5.3 Mode of operation: perforating

Install punch tool. Position suitable rail guide (6) and secure it (7). Insert rail to the fixed (8) or adjustable stop (optional accessory). Operate hand lever or hydraulic pump for perforating. Remove perforated rail (10).

6. Maintenance / Cleaning

- At regular intervals the unit should be cleaned and lubricated at the grease nipples
- Before each use, the unit should undergo an optical evaluation, incl. the hydraulic hose and the drive system
- Oily rags and hydraulic oil have to be treated as hazardous waste

7. Troubleshooting and service

If you experience a break-down of the equipment please contact your local sales office or the manufacturer. Here you will receive help and hints to do smaller repair work yourself. If a complex repair is necessary, this must be performed by our factory-service, as häwa will not assume any liability for improper repairs and resulting consequential damages.

Service Hotline:

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