habasit

OPERATING INSTRUCTIONS

Manually-operated die cutter flex and step flex AFZ-1200

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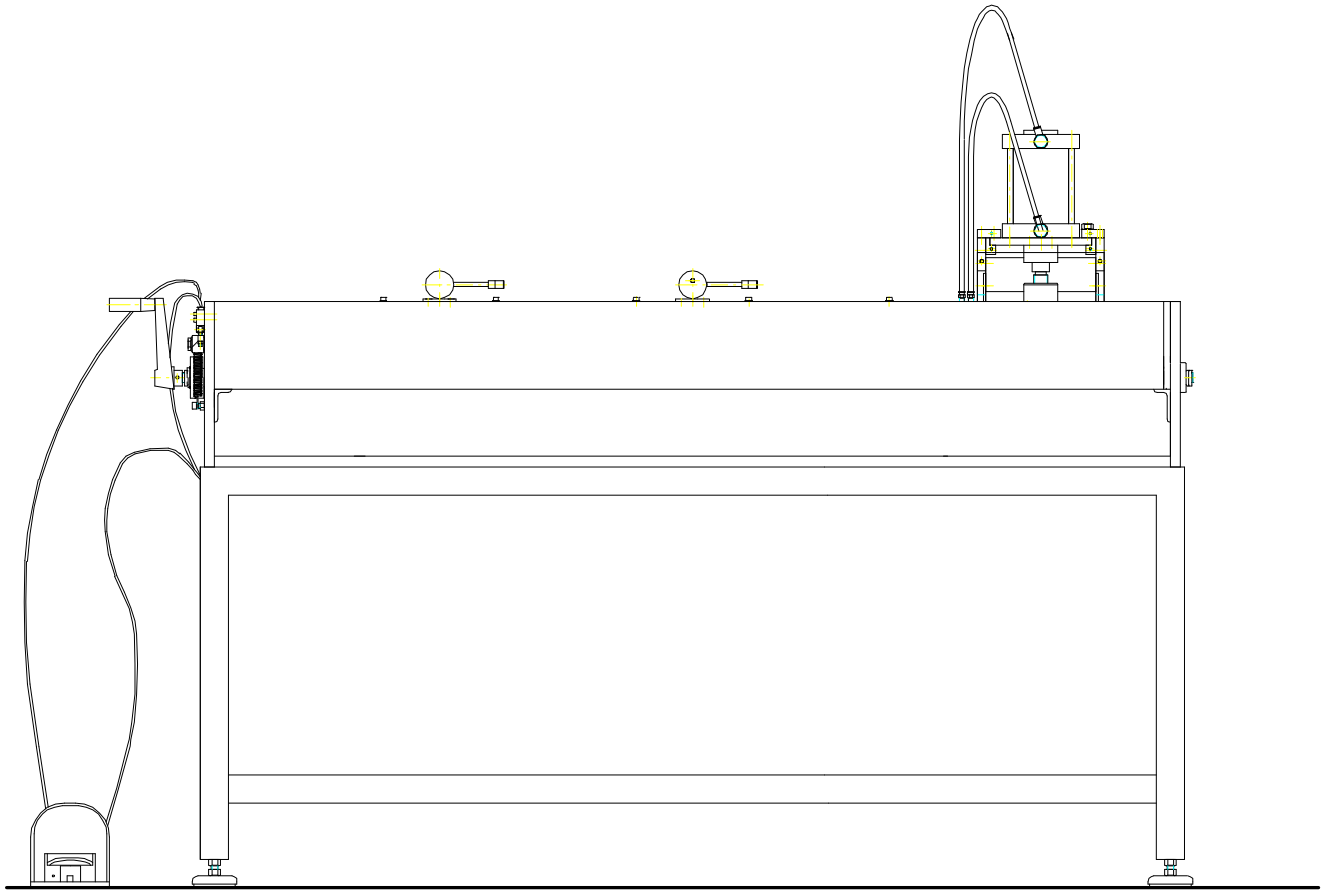


HABASIT ITALIANA S.P.A.
VIA MEUCCI, 8
I 31029 VITTORIO VENETO (TV)

MACHINE MODEL: AFZ-1200 AND AFZ-1200/P

DESCRIPTION: MANUALLY-OPERATED DIE CUTTER FLEX AND DOUBLE FLEX

MANUFACTURER:

HABASIT ITALIANA SPA

VIA MEUCCI,8

31029 VITTORIO VENETO/TV

INDEX

CHAP.1 INTRODUCTION

THIS MANUAL CONTAINS ALL THE TRANSPORTATION, ASSEMBLY, OPERATING AND MAINTENANCE INSTRUCTIONS NECESSARY TO OBTAIN THE BEST RESULTS FROM THE MACHINE AND TO EXTEND ITS WORKING LIFE.

WE ADVISE YOU TO READ THESE INSTRUCTIONS BEFORE STARTING UP THE MACHINE AND TO COMPLY WITH THEM FULLY.

HABASIT ITALIANA S.P.A. RESERVES THE RIGHT TO MAKE ANY CHANGES IT DEEMS NECESSARY IN ORDER TO IMPROVE THE FUNCTIONING OF THE MACHINE.

EEC REGULATIONS

THIS MANUAL HAS BEEN DRAWN UP IN COMPLIANCE WITH THE PROVISIONS OF EEC DIRECTIVES 89/392-91/368-93/44-93/68; AS INDICATED IN THE DESIGN DEFINITION OF A MACHINE, THE OPERATING INSTRUCTIONS FORM AN INTEGRAL PART THEREOF.

THIS MANUAL HAS BEEN COMPILED, ADOPTING THE CRITERIA REFERRED TO IN **EUROPEAN STANDARD EN -292** WITH PARTICULAR REFERENCE TO POINT 1.7.4-89/392 "OPERATING INSTRUCTIONS" (INSTRUCTIONS, GENERAL REQUIREMENTS AND TYPE OF INSTRUCTIONS).

THE INSTRUCTIONS CONTAINED IN THIS MANUAL ARE INTENDED FOR THE OPERATORS' USE.

LEGISLATIVE DECREE N°626/94-IMPLEMENTATION OF EEC DIRECTIVE 89/391 RELATING TO IMPROVED SAFETY AND HEALTH CONDITIONS FOR WORKERS AT THEIR PLACE OF WORK

ART.5

OBLIGATIONS ON THE PART OF WORKERS

POINT 2

2B) THEY SHALL USE MACHINERY, EQUIPMENT, TOOLS, DANGEROUS SUBSTANCES AND PREPARATIONS, MEANS OF TRANSPORT AND OPERATING EQUIPMENT, AS WELL AS SAFETY EQUIPMENT, IN A CORRECT MANNER;

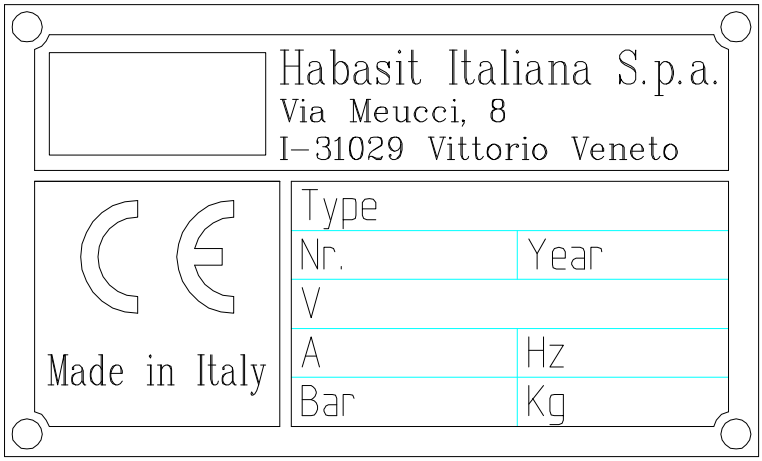
2C) THEY SHALL USE PROTECTIVE EQUIPMENT PROVIDED IN AN APPROPRIATE MANNER;

2D) THEY SHALL INFORM THE EMPLOYER, MANAGER OR PERSON IN CHARGE IMMEDIATELY OF ANY FAULT IN THE EQUIPMENT OR DEVICES REFERRED TO UNDER LETTERS B) AND C), OR OF ANY OTHER HAZARDOUS CONDITIONS BROUGHT TO THEIR ATTENTION, TAKING DIRECT ACTION IN THE EVENT OF AN EMERGENCY, WITHIN THE SCOPE OF THEIR ASSIGNED DUTIES AND CAPABILITIES, TO ELIMINATE OR REDUCE THE SAID FAULT OR HAZARD AND SHALL NOTIFY THE WORKERS' SECURITY REPRESENTATIVE ACCORDINGLY;

2E) THEY MAY NOT REMOVE OR ALTER SAFETY, SIGNALLING OR CONTROL DEVICES UNLESS AUTHORISED TO DO SO;

2F) THEY MAY NOT CARRY OUT ANY OPERATION OR MANOEUVRE UPON THEIR OWN INITIATIVE WHICH THEY ARE NOT EXPRESSLY AUTHORISED TO PERFORM OR WHICH MIGHT PUT THEIR OWN SAFETY OR THAT OF THEIR FELLOW WORKERS AT RISK.

INDICATING PLATE



CHAP.2 HANDLING AND TRANSPORTATION

2.1 TRANSPORTATION AND INSTRUCTIONS REGARDING HANDLING

THE MACHINE IS DELIVERED IN A SINGLE UNIT, PACKED IN A WOODEN CRATE.

MACHINES TRANSPORTED BY SEA ARE ALSO PACKED IN SPECIAL HEAT RETRACTION SACKS WHICH PROTECT THE MATERIALS AGAINST CORROSIVE AGENTS.

THE MACHINE IS ANCHORED TO THE INTERNAL BASE OF THE CRATE WITH BOLTS. THE CRATE MUST BE HANDLED BY PERSONNEL TRAINED TO OPERATE FORK-LIFTS. SEE FIGURE 1.

UPON DELIVERY, OPEN THE CRATE AND CHECK THAT THE MACHINE HAS NOT BEEN DAMAGED DURING TRANSPORTATION; IF SO, INFORM THE SHIPPING AGENT WITHOUT DELAY.

IF THE MACHINE IS NOT GOING TO BE USED WITHIN A SHORT TIME OF ITS DELIVERY, THEN IT MUST BE STORED IN A DRY PLACE UNDER CONTROLLED TEMPERATURE AND ATMOSPHERE CONDITIONS, UNTIL IT IS PUT INTO OPERATION **THE MACHINE SHOULD NOT BE KEPT OUTSIDE**.

COMPONENTS LEFT IN STORAGE SHOULD BE EXAMINED REGULARLY TO ENSURE THAT THEY HAVE NOT DETERIORATED.

USE A FORK-LIFT OF APPROPRIATE CAPACITY TO MOVE THE MACHINE TO THE INSTALLATION SITE. SEE FIG.2.

FIGURE 1

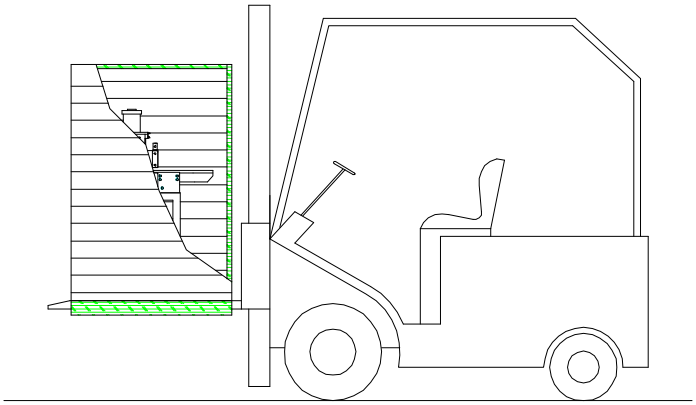
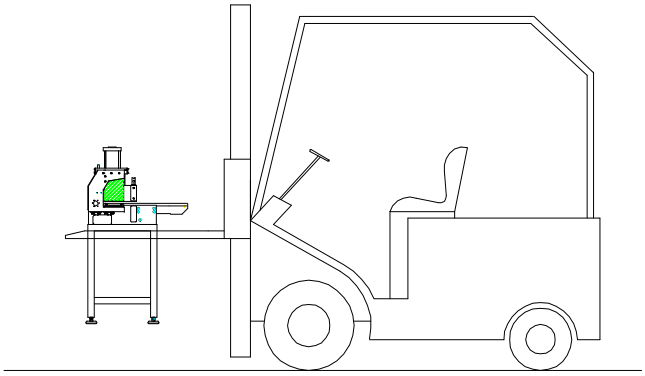


FIGURE 2



AFZ-1200

NET WEIGHT KG. 255 / LB. 561
WEIGHT WITH CRATE KG.435 / LB. 957
SIZE OF CRATE MM. 2210X1190XH 1810 / IN. 87"X46.8"X H 71.2"

AFZ-1200/P

NET WEIGHT KG.155 / LB. 342
WEIGHT WITH CRATE KG.285 / LB. 628
SIZE OF CRATE MM. 2070X1020XH 900 / IN. 82"X41"X H 36"

CHAP.3 STARTING UP THE MACHINE

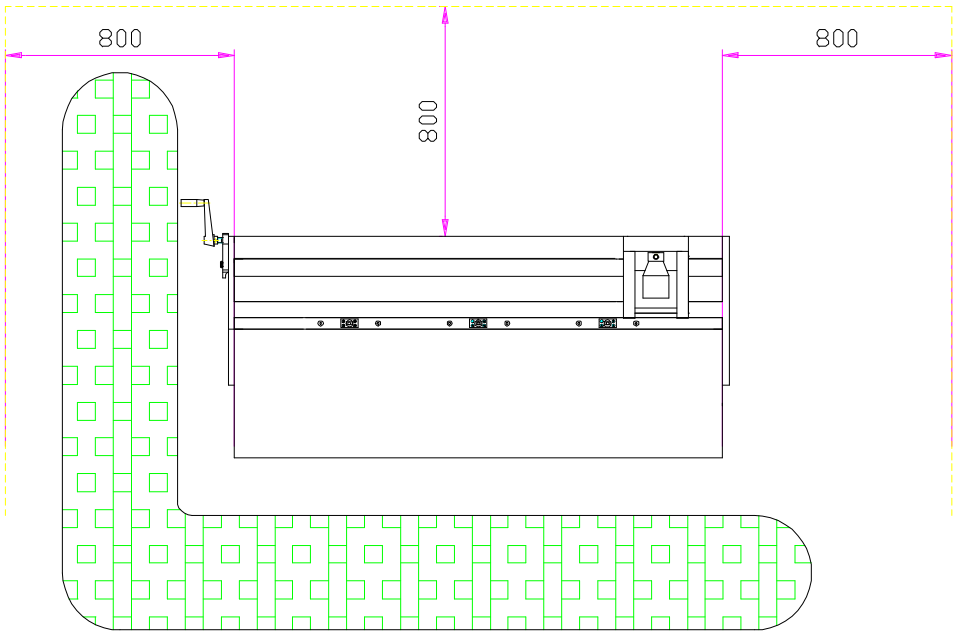
3.1 ANCHORING INSTRUCTIONS

3.1.1-THE MACHINE IS ALWAYS SUPPLIED IN PERFECT CONDITION, UNDERGOING A RIGOROUS INSPECTION ON OUR FACTORY PREMISES.

THE MACHINE SHOULD BE PLACED ON A STABLE FLOOR SURFACE. AS THE MACHINE IS NOT SUBJECTED TO EXCESSIVE VIBRATIONS, THERE IS NO NEED FOR SPECIAL FLOOR ANCHORING. SIMPLY ENSURE THAT THE MACHINE IS PERFECTLY LEVEL, REGULATING THE VIBRATION-PROOF FEET PROVIDED.

3.1.2- THE MACHINE MUST ALSO BE POSITIONED IN ACCORDANCE WITH THE GENERAL INSTALLATION LAYOUT, MAKING SURE THAT ITS POSITION IS CORRECT IN RELATION TO OTHER MACHINES PREVIOUSLY ASSEMBLED OR ALREADY INSTALLED. MAKE SURE THAT THE DISTANCE INDICATED IN FIG.3, NECESSARY TO PROVIDE ACCESS FOR THE OPERATION AND MAINTENANCE OF THE MACHINE, IS RESPECTED.

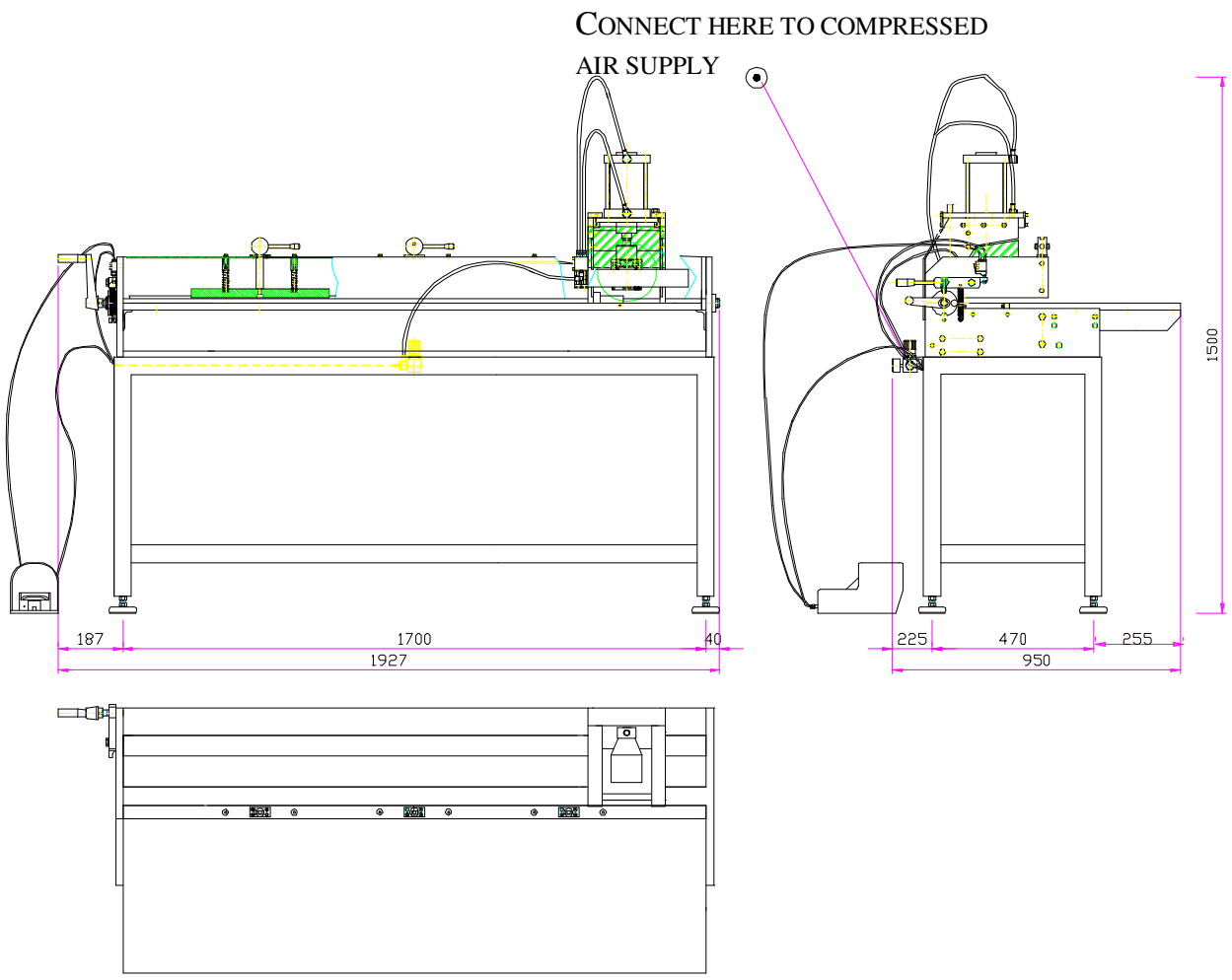
FIGURE 3 - OPERATOR'S ACCESS ZONE AND SPACE REQUIRED FOR OPERATION AND MAINTENANCE (IN MM.)



3.2 CONNECTING MACHINE TO ENERGY SOURCES

AS THIS MACHINE IS OPERATED MANUALLY, IT DOES NOT HAVE TO BE CONNECTED TO THE ELECTRIC MAINS SUPPLY. IT MUST HOWEVER BE CONNECTED TO A COMPRESSED AIR SUPPLY BY MEANS OF THE UNION FITTED ON THE PRESSURE REGULATOR UNIT. A COCK MUST ALSO BE FITTED BETWEEN THE AIR DUCTS AND THE REGULATOR (TO IMPROVE THE PERFORMANCE OF THE MACHINE, WE SUGGEST THAT A FILTERED, LUBRICATED COMPRESSED AIR SUPPLY BE USED). SEE FIG. 4. (MEASUREMENTS GIVEN IN MM.) AVOID USING TEMPORARY OR UNSUITABLE TUBING AS THIS IS SUBJECT TO EXCESSIVE WEAR. USE STANDARD TUBES OF APPROPRIATE SIZE. THE WORKING PRESSURE IS 6 BAR.

FIGURE 4 OVERALL DIMENSIONS AND LAYOUT



3.3 RECOMMENDED PREVENTIVE MEASURES

SAFETY STANDARDS

IN ORDER TO KEEP THE MACHINE IN PERFECT CONDITION AND TO ENSURE THAT THE OPERATOR IS ABLE TO WORK IN ABSOLUTE SAFETY, WE RECOMMEND THAT THE FOLLOWING INSTRUCTIONS BE COMPLIED WITH TO THE FULL:

3.3.1 MAKE SURE THAT THE INSTRUCTIONS CONTAINED IN THIS MANUAL ARE BROUGHT TO THE ATTENTION OF ALL THE OPERATORS CONCERNED.

3.3.2 MAKE SURE THAT THE MACHINE IS KEPT IN PERFECT WORKING ORDER AND ALWAYS USE THE PROTECTIVE DEVICES SUPPLIED WITH IT.

3.3.3 DO NOT ALTER OR REMOVE THE PROTECTIVE DEVICES/GUARDS UNLESS THE MACHINE IS NOT IN OPERATION AND HAS BEEN DISCONNECTED FROM THE PNEUMATIC SUPPLY.

3.3.4 ALWAYS DISCONNECT THE MACHINE FROM THE PNEUMATIC SUPPLY, BY CLOSING THE AIR COCK FITTED BETWEEN THE AIR DUCTS AND THE PRESSURE REGULATOR, BEFORE CARRYING OUT ANY MAINTENANCE, REGULATION, CLEANING OR LUBRICATION OPERATION ON MECHANICAL COMPONENTS.

3.3.5 KEEP WELL AWAY FROM MOVING PARTS IF DRESSED IN LOOSE-FITTING CLOTHES.

3.3.6 TAKE GREAT CARE, WHEN LOADING OR UNLOADING THE MACHINE, TO SELECT THE RIGHT ATTACHMENT POINT FOR STEEL CABLES OR COTTON BELTS IN ORDER TO AVOID DAMAGING EITHER THE MACHINE OR HARNESSING EQUIPMENT. WHEN USING THIS TYPE OF EQUIPMENT, MAKE SURE THAT IT DOES NOT COME INTO CONTACT WITH THE CUTTING ELEMENTS OF THE MACHINE AND THEREBY CAUSE EXCESSIVE WEAR.

CHAP. 4 DESCRIPTION OF MACHINE, REPAIRS, ACCESSORIES AND/OR SAFETY EQUIPMENT

4.1 DESCRIPTION OF MACHINE

THE MANUALLY-OPERATED DIE CUTTER **-AFZ-1200** IS EQUIPPED WITH:

N° 1 DIE-CUTTING HEAD.

THE MACHINE CAN USE THE FOLLOWING DIE-CUTTING HEADS:

10/80, 20/80 OR 10/120 FOR FLEXPROOF

10/50, 20/50 FOR DOUBLE FLEXPROOF

A HIGH DEGREE OF MACHINING PRECISION IS GUARANTEED BY THE FINE QUALITY COMPONENTS MAKING UP THE AFZ-1200 MODEL.

THE MAIN COMPONENTS MAKING UP THE AFZ-1200 ARE AS FOLLOWS (SEE FIGURE 5):

1) BASE STRUCTURE IN STEEL TUBING

2) DIE-CUTTING CARRIAGE SLIDING ON HARDENED, GROUND PRISMATIC SLIDEWAYS

3) DIE-CUTTING CARRIAGE CONTROLLED MANUALLY BY RECIRCULATING BALL BEARING SCREWS

4) DIE-CUTTING CARRIAGE STARTING POINT DISPLACEMENT SELECTOR

5) DIE-CUTTING HEAD

6) OPERATION OF DIE-CUTTING HEAD CAN BE DISPLACED TO ALLOW FLEXPROOF DOUBLE CUTTING TO BE PERFORMED AS HEAD IS MOVED

7) DIE-CUTTING HEAD EQUIPPED WITH STARTING PEDAL AND VALVE

8) HANDLES TO SECURE BELT TO WORK-TOP

9) PROTECTIVE DEVICES/GUARDS

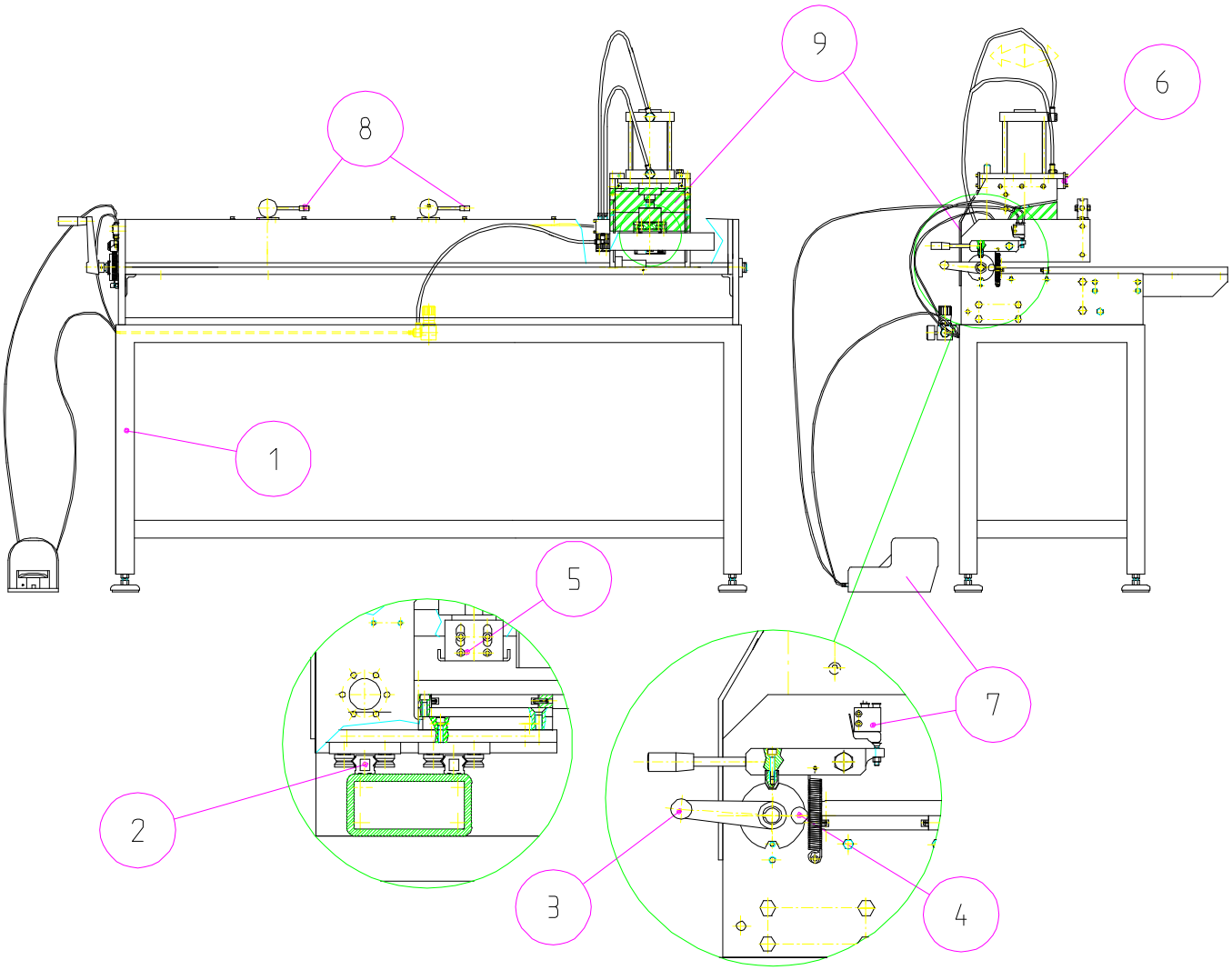
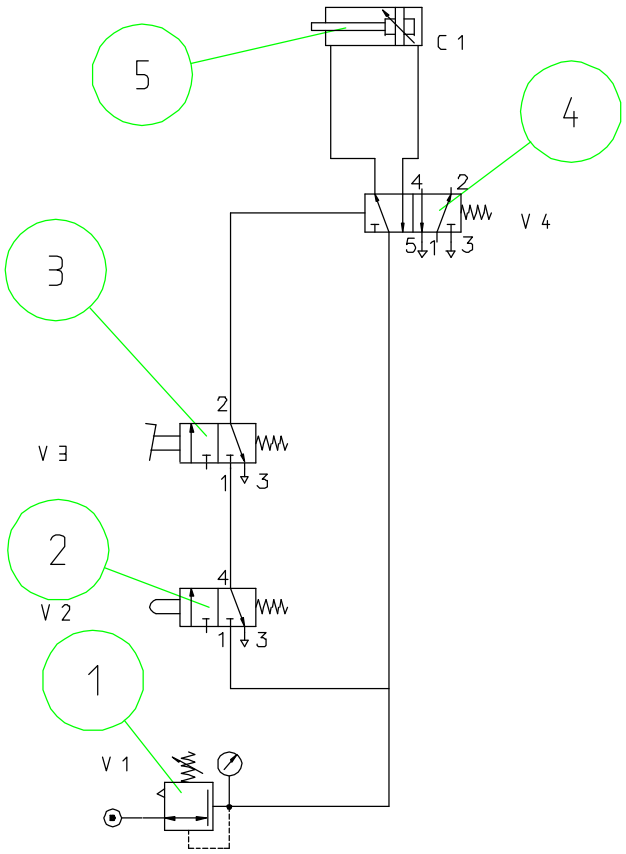


FIGURE 5

4.2 POWER SUPPLY SYSTEMS

PNEUMATIC DIAGRAM



1) PRESSURE REGULATOR UNIT
2) VALVE 1
3) PEDAL
4) VALVE 2
5) CYLINDER

4.3 SPARE PARTS

FIG. 7 MECHANICAL SPARE PARTS

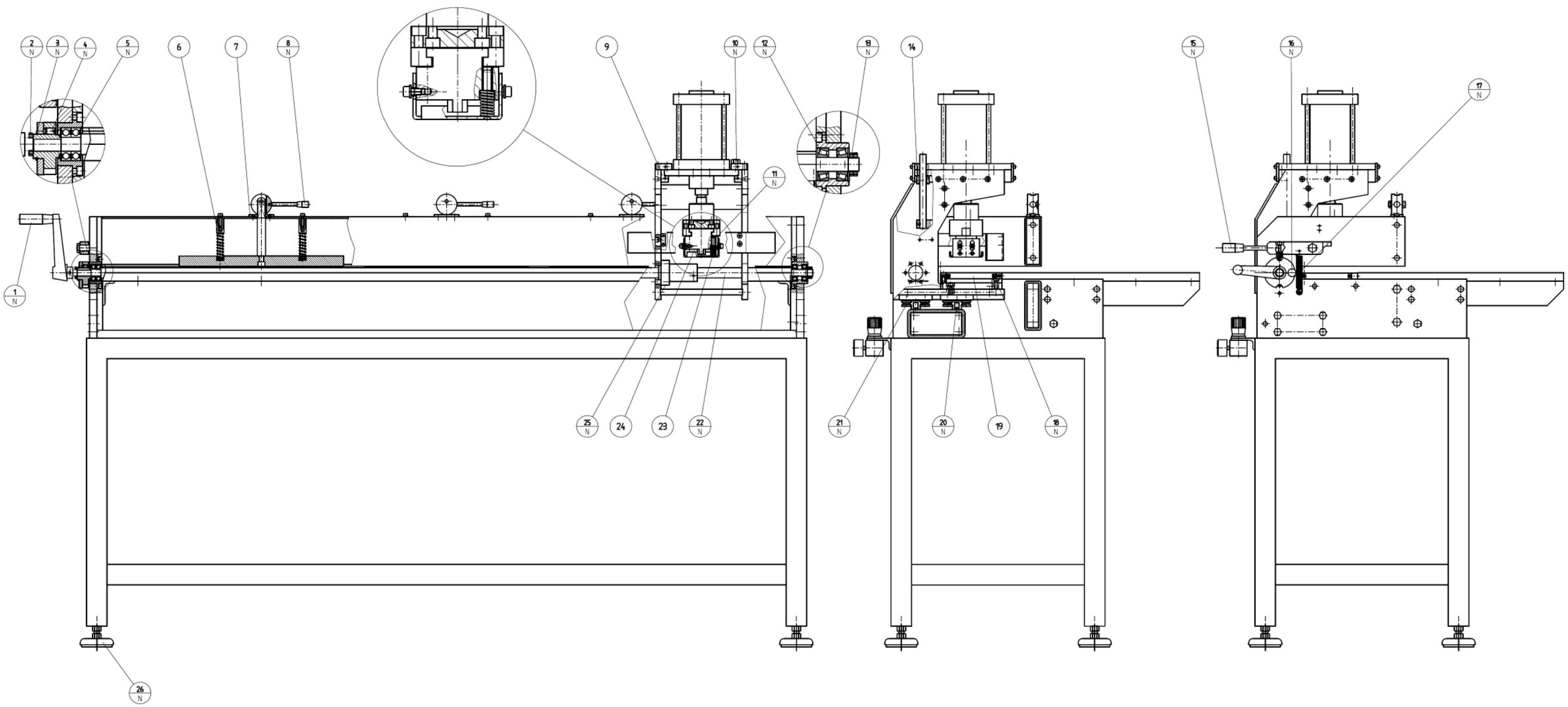
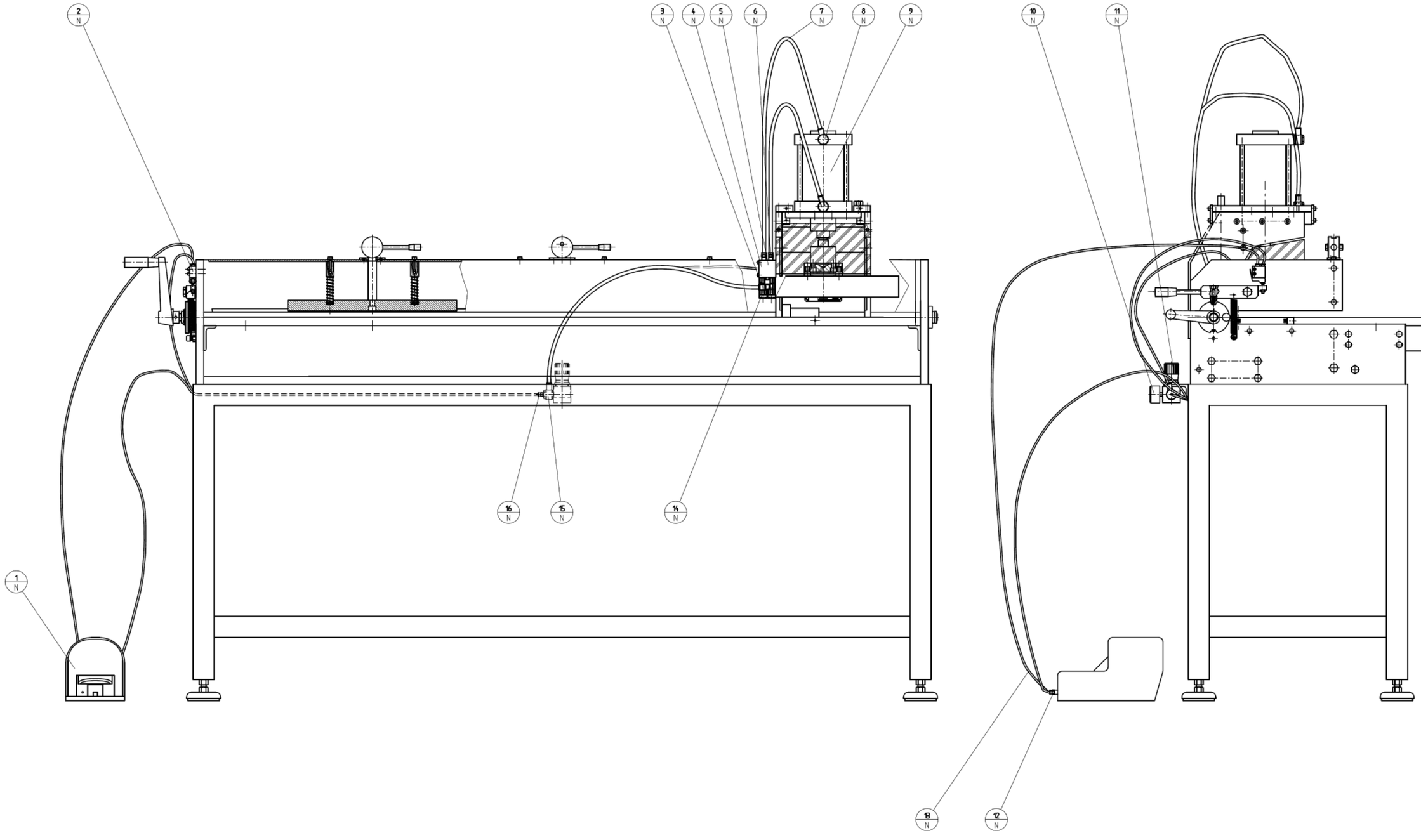


FIG. 8 PNEUMATIC SPARE PARTS



4.4) REPAIRS

THE MACHINE IS ENCLOSED BY FIXED GUARDS WHICH PREVENT ACCESS TO HAZARDOUS AREAS. SEE FIG.5 NO. 9

ACCIDENT PREVENTION

THE GUARDS ILLUSTRATED IN FIG. 5 NO. 9 MUST NOT, UNDER ANY CIRCUMSTANCES, BE REMOVED.

4.5) RANGE OF APPLICATIONS FOR WHICH THE MACHINE IS DESIGNED

USE IN ACCORDANCE WITH REGULATIONS

YOUR MACHINE HAS BEEN CONSTRUCTED FOR FLEXPROOF CUTTING AND DOUBLE FLEXPROOF CUTTING OPERATIONS WITH THE USE OF A CUTTING BLADE. THE MACHINE MUST NOT BE USED BY MORE THAN ONE OPERATOR AT A TIME, AND MUST BE OPERATED IN THE POSITION ILLUSTRATED IN FIG. ....
THE ONLY TYPO OF MATERIAL WHICH SHOULD BE TREATED ARE HABASIT BELTS.

NO OTHER USE IS PERMITTED.
THE MANUFACTURER SHALL NOT BE HELD LIABLE FOR ANY DAMAGE OR INJURY CAUSED BY IMPROPER USE.

THE MACHINE MUST BE USED, SERVICED AND REPAIRED EXCLUSIVELY BY STAFF WHO ARE FAMILIAR WITH IT OR BY TECHNICIANS WITH EXPERIENCE OF THIS TYPE OF MACHINE WHO HAVE BEEN WARNED OF THE POSSIBLE RISKS INVOLVED. ANY ARBITRARY MODIFICATION TO THE MACHINE WILL AUTOMATICALLY EXONERATE THE MANUFACTURER FROM ANY LIABILITY FOR RESULTING DAMAGE.

THE MACHINE CAN BE USED WITH ACCESSORIES AND ORIGINAL TOOLS.
INFORMATION ON RISKS WHICH CANNOT BE AVOIDED

INFORMATION ON RISKS WHICH CANNOT BE AVOIDED

THE MACHINE HAS BEEN DESIGNED TO MINIMISE ANY RISK TO THE OPERATOR DURING PRODUCTION OR TO SERVICING STAFF PERFORMING ROUTINE AND SPECIAL MAINTENANCE OPERATIONS. AS THE MACHINE IS OPERATED MANUALLY AND IS EXTREMELY STRAIGHT-FORWARD TO USE, THERE DO NOT APPEAR TO BE ANY RESIDUAL RISKS.

CHAP. 5 OPERATING THE MACHINE

REFERENCE NUMBERS GIVEN IN THIS CHAPTER REFER TO THE DRAWING IN FIG. 9

5.1 APPLICATION

THE MANUALLY-OPERATED DIE CUTTERS IN THE AFZ-1200 SERIES HAVE BEEN SPECIFICALLY DESIGNED TO MAKE ZIGZAG CUTS IN HABASIT BELTS MEASURING UP TO 1250 MM./49.2" IN WIDTH, USING THE FLEXPROOF AND DOUBLE FLEXPROOF SYSTEM.

5.2 OPERATING METHODS

THE MACHINE OPERATES ACCORDING TO A CUTTING SEQUENCE. ONE PUNCHING STROKE MAKES TWO CUTS AND SUBSEQUENT CUTS ARE THEN LINED UP WITH THOSE PREVIOUSLY MADE TO FORM A CONTINUOUS ZIGZAG LINE. TO OBTAIN AN UNINTERRUPTED CUT, THE INDIVIDUAL CUTS ARE MADE TO OVERLAP BY APPROXIMATELY 1/2MM./0.02", BY OPERATION OF THE CUTTING BLADES WHICH ARE APPROXIMATELY 1MM./0.04" LONGER THAN ONE SIDE OF THE TRIANGLE MAKING UP THE ZIGZAG LINE. TO ENSURE THAT THE CUT IS COMPLETED AT THE EDGES OF THE BELT, CHECK THAT THE CENTRAL LINE ON THE PUNCH HEAD **(1)** PROTRUDES 3MM./0.12" FROM THE EDGE OF THE BELT AS THE FIRST AND LAST CUTS ARE MADE; IN ANY EVENT, PROVIDED THE OPERATOR MOVES THE PUNCH CARRIAGE **(2)** UP AGAINST THE STOP **(3)** DURING THE STARTING PHASE AND THEN STARTS CUTTING THE BELT FROM THIS POSITION, THE PROBLEM DESCRIBED ABOVE SHOULD NOT OCCUR.

5.3 FLEXPROOF CUTTING WITH 10/50 DIE-CUTTING HEAD

WITH THIS TYPE OF CUTTING PROCESS, THE BELT SHOULD MEASURE THE SAME AS THE STRETCH LENGTH REQUIRED PLUS 100MM. **FOR EXAMPLE:** IF YOU WANT A BELT WITH A STRETCH LENGTH OF 1000MMTHEN IT MUST BE CUT AT A LENGTH OF 1100MM.

MOVE THE BELT UP AGAINST THE SIDE SQUARE **(4)** AND THEN MOVE THE BELT FORWARD UP TO THE REFERENCE MARK ALREADY MADE 25MM. FROM THE EXTERIOR OF THE NYLON BLOCK GUIDEWAY **(11).** AT THIS POINT, ROTATE THE THREE LEVERS **(8),** STARTING WITH THAT NEAREST THE SIDE SQUARE **(4).**IN THIS WAY, THE CLAMPING BARS **(7)** WILL LOWER, PRESSING THE BELT DOWN ONTO THE WORK-TOP. RAISE THE KNOB **(13)** AND SLIDE THE CUTTING UNIT INTO POSITION **(0)**, BRING THE PUNCH CARRIAGE **(2)** UP AGAINST THE STOP **(3)** ON THE SIDE WHERE THE CARRIAGE CRANK IS FITTED. TURN THE CRANK **(10)** UNTIL IT REACHES THE FIRST NOTCH BETWEEN THE INDEX MARK ON THE LEVER **(17)** AND THE REFERENCE

MARKING ON THE SELECTOR **(16)**. AT THIS POINT, THE MACHINE IS READY TO START CUTTING THE BELT; PRESS DOWN ON THE PEDAL **(15)** AND ACTIVATE THE AIR VALVE **(14)** BY MEANS OF THE LEVER **(17).** SUBSEQUENT CUTS ARE MADE BY TURNING THE LEVER **(10)** A SINGLE TURN AND REPEATING THE OPERATION DESCRIBED ABOVE ALONG THE ENTIRE WIDTH OF THE BELT. MOVE THE PUNCH CARRIAGE **(2)** BACK AGAINST THE STOP **(3)** ON THE SIDE WHERE THE CARRIAGE CRANK IS FITTED.

TO CUT THE BELT ON THE OPPOSITE SIDE, TURN THE BELT OVER AND LINE IT UP WITH THE SIDE SQUARE **(4)** AS DESCRIBED ABOVE AND UP TO THE REFERENCE MARK **(11)**.TURN THE SELECTOR **(16)** A HALF-TURN UNTIL IT REACHES THE NOTCH BETWEEN THE LEVER INDEX **(17)** AND THE REFERENCE MARK DISPLACED 180° FROM THE POSITION USED FOR THE FIRST CUT. PROCEED WITH CUTTING OPERATION AS DESCRIBED ABOVE.

5.4 FLEXPROOF CUTTING WITH 10/80 DIE-CUTTING HEAD

WITH THIS TYPE OF CUTTING PROCESS, THE BELT SHOULD MEASURE THE SAME AS THE STRETCH LENGTH REQUIRED PLUS 100 MM. **FOR EXAMPLE:** IF YOU WANT A BELT WITH A STRETCH LENGTH OF 1000MM. THEN IT MUST BE CUT AT A LENGTH OF.1100 MM.

MOVE THE BELT UP AGAINST THE SIDE SQUARE **(4)** AND THEN MOVE THE BELT FORWARD UP TO THE REFERENCE MARK ALREADY MADE 25 MM. FROM THE EXTERIOR OF THE NYLON BLOCK GUIDEWAY **(11).** AT THIS POINT, ROTATE THE THREE LEVERS **(8),** STARTING WITH THAT NEAREST THE SIDE SQUARE **(4).**IN THIS WAY, THE CLAMPING BARS **(7)** WILL LOWER, PRESSING THE BELT DOWN ONTO THE WORK-TOP. RAISE THE KNOB **(13)** AND SLIDE THE CUTTING UNIT INTO POSITION **(0)**, BRING THE PUNCH CARRIAGE **(2**) UP AGAINST THE STOP **(3)** ON THE SIDE WHERE THE CARRIAGE CRANK IS FITTED. TURN THE CRANK **(10)** UNTIL IT REACHES THE FIRST NOTCH BETWEEN THE INDEX MARK ON THE LEVER **(17)** AND THE REFERENCE MARKING ON THE SELECTOR **(16)**. AT THIS POINT, THE MACHINE IS READY TO START CUTTING THE BELT; PRESS DOWN ON THE PEDAL **(15)** AND ACTIVATE THE AIR VALVE **(14)** BY MEANS OF THE LEVER **(17).** SUBSEQUENT CUTS ARE MADE BY TURNING THE LEVER **(10)** A SINGLE TURN AND REPEATING THE OPERATION DESCRIBED ABOVE ALONG THE ENTIRE WIDTH OF THE BELT. MOVE THE PUNCH CARRIAGE **(2)** BACK AGAINST THE STOP **(3)** ON THE SIDE WHERE THE CARRIAGE CRANK IS FITTED.

TO CUT THE BELT ON THE OPPOSITE SIDE, TURN THE BELT OVER AND LINE IT UP WITH THE SIDE SQUARE **(4)** AS DESCRIBED ABOVE AND UP TO THE REFERENCE MARK **(11)**.TURN THE SELECTOR **(16)** A HALF-TURN UNTIL IT REACHES THE NOTCH BETWEEN THE LEVER INDEX **(17)** AND THE REFERENCE MARK DISPLACED 180° FROM THE POSITION USED FOR THE FIRST CUT. PROCEED WITH CUTTING OPERATION AS DESCRIBED ABOVE.

5.5 DOUBLE FLEXPROOF CUTTING WITH 20/50 DIE-CUTTING HEAD

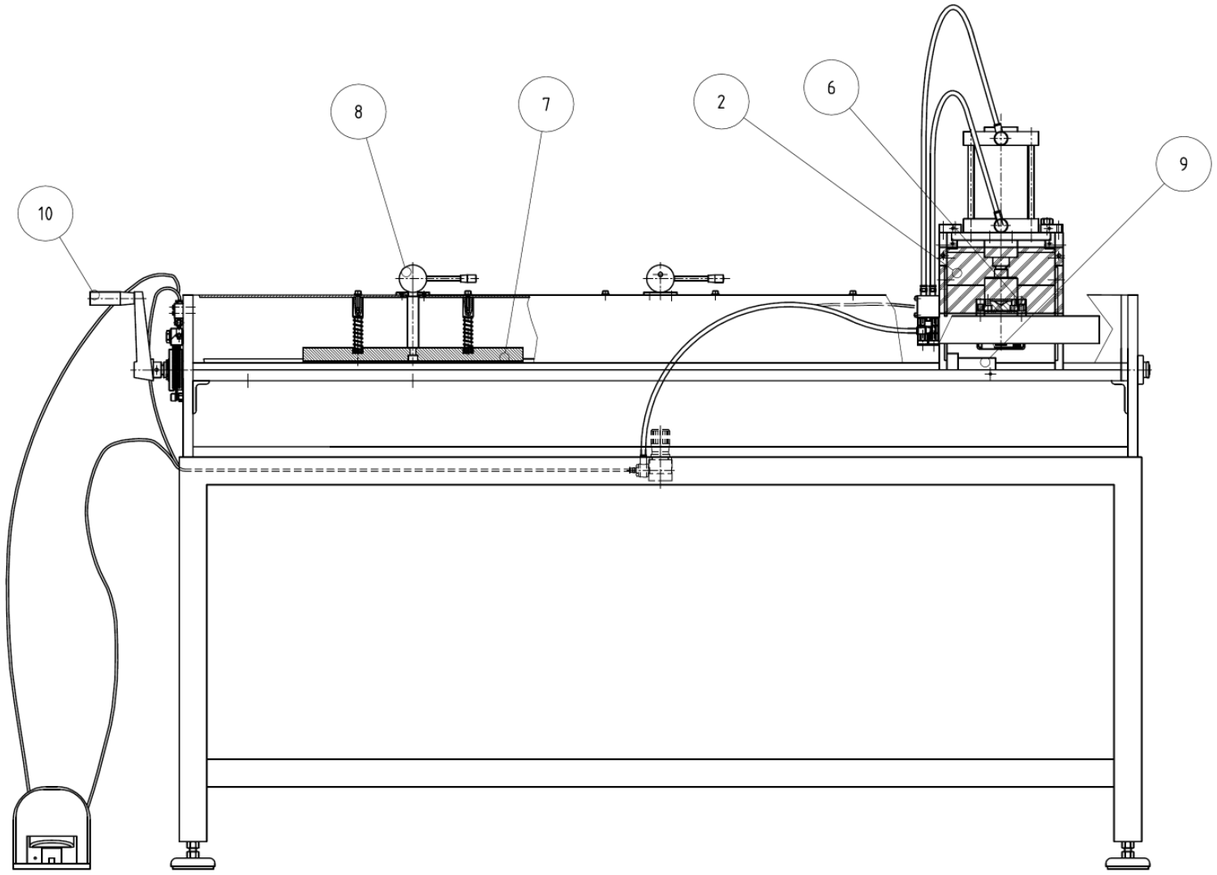
THIS TYPE OF PROCESS CAN ONLY BE CARRIED OUT ON TWO-PLY BELTS , SEPARATED AT EITHER END.

WITH THIS TYPE OF CUTTING PROCESS, THE BELT SHOULD MEASURE THE SAME AS THE STRETCH LENGTH REQUIRED PLUS 100MM.. **FOR EXAMPLE:** IF YOU WANT A BELT WITH A STRETCH LENGTH OF 1000MM." THEN IT MUST BE CUT AT A LENGTH OF 1100MM.

MOVE THE BELT UP AGAINST THE SIDE SQUARE **(4)** AND THEN MOVE THE BELT FORWARD UP TO THE REFERENCE MARK ALREADY MADE 25MM. FROM THE EXTERIOR OF THE NYLON BLOCK GUIDEWAY **(11).** AT THIS POINT, ROTATE THE THREE LEVERS **(8),** STARTING WITH THAT NEAREST THE SIDE SQUARE **(4).**IN THIS WAY, THE CLAMPING BARS **(7)** WILL LOWER, PRESSING THE BELT DOWN ONTO THE WORK-TOP. RAISE THE KNOB **(13)** AND SLIDE THE CUTTING UNIT INTO POSITION **(1)**, BRING THE PUNCH CARRIAGE **(2**) UP AGAINST THE STOP **(3)** ON THE SIDE WHERE THE CARRIAGE CRANK IS FITTED. TURN THE CRANK **(10)** UNTIL IT REACHES THE FIRST NOTCH BETWEEN THE INDEX MARK ON THE LEVER **(17)** AND THE REFERENCE MARKING ON THE SELECTOR **(16)**. AT THIS POINT, THE MACHINE IS READY TO START CUTTING THE BELT; PRESS DOWN ON THE PEDAL **(15)** AND ACTIVATE THE AIR VALVE **(14)** BY MEANS OF THE LEVER **(17).** SUBSEQUENT CUTS ARE MADE BY TURNING THE LEVER **(10)** TWO TURNS AND REPEATING THE OPERATION DESCRIBED ABOVE ALONG THE ENTIRE WIDTH OF THE BELT. LIFT THE KNOB **(13)** AGAIN AND SLIDE THE CUTTING UNIT INTO POSITION **(2)** . NOW PERFORM THE CUTTING OPERATION IN REVERSE, LIFTING THE TOP EDGE OF THE BELT AND RESTING IT ON THE SUPPORT **(12)** MOUNTED ON THE PUNCH CARRIAGE.

TO CUT THE BELT ON THE OPPOSITE SIDE, TURN THE BELT OVER AND LINE IT UP WITH THE SIDE SQUARE **(4)** AS DESCRIBED ABOVE AND UP TO THE REFERENCE MARK **(11)**.TURN THE CRANK **(10)** A SINGLE TURN UNTIL IT REACHES THE NOTCH BETWEEN THE LEVER INDEX **(17)** AND THE REFERENCE MARK DISPLACED 360° FROM THE POSITION USED FOR THE FIRST CUT. LIFT THE KNOB **(13)** AND SLIDE THE CUTTING UNIT BACK INTO POSITION **(1).** PROCEED WITH CUTTING OPERATION AS DESCRIBED ABOVE.

FIGURE 9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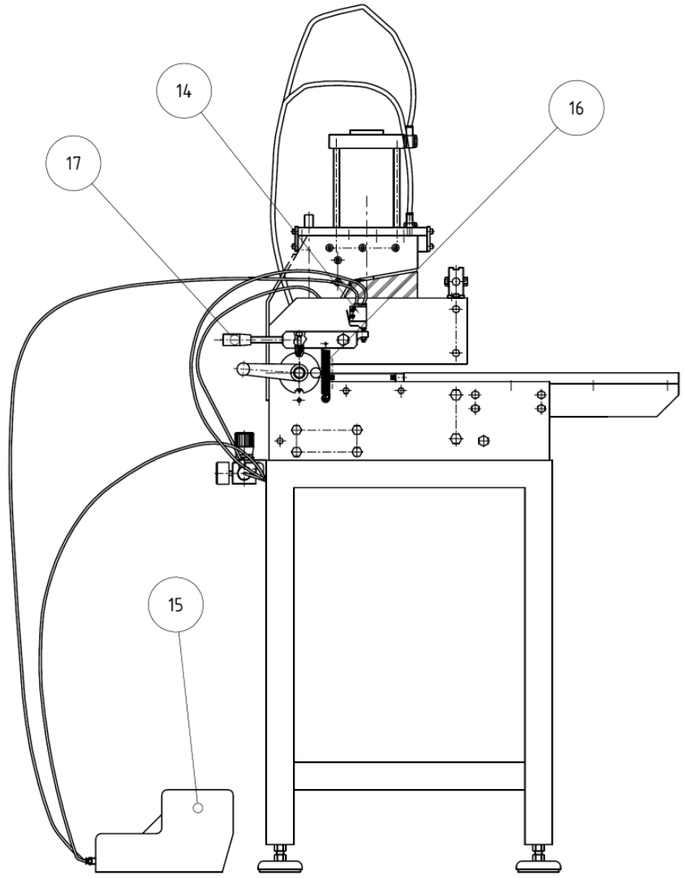
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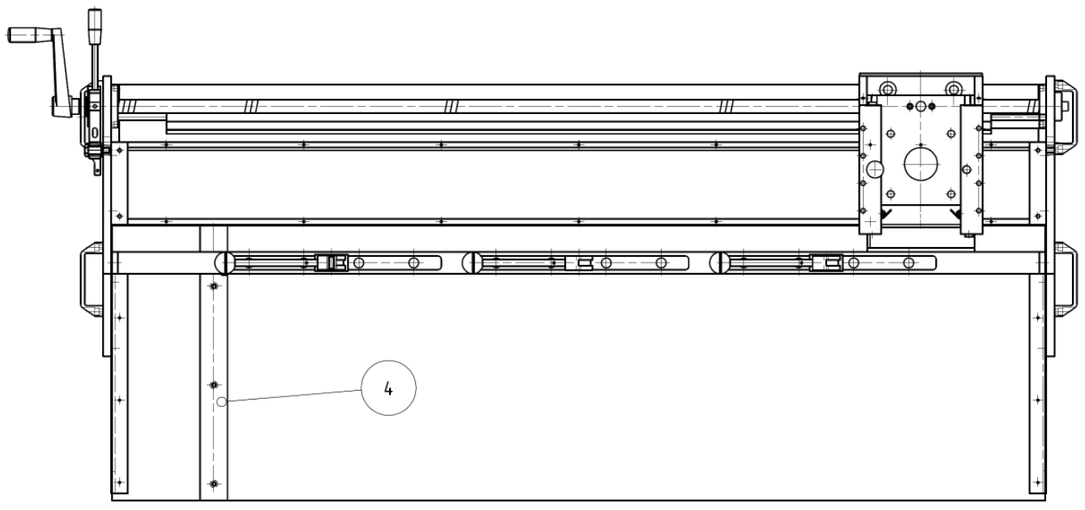
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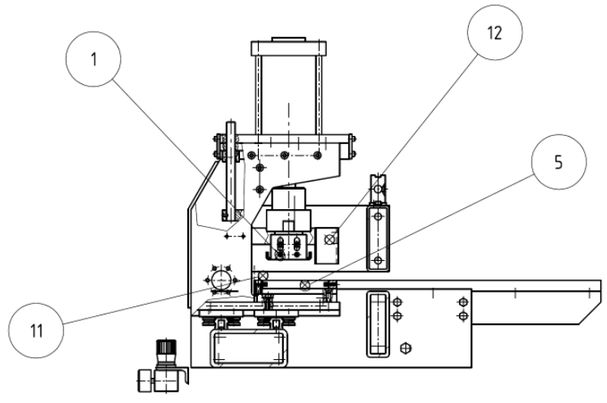
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Product liability, application considerations

THE PROPER SELECTION AND APPLICATION OF HABASIT PRODUCTS, INCLUDING THE RELATED AREA OF PRODUCT SAFETY, IS THE RESPONSIBILITY OF THE CUSTOMER.

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BECAUSE CONDITIONS OF USE ARE OUTSIDE OF HABASIT'S AND ITS AFFILIATED COMPANIES CONTROL, WE CANNOT ASSUME ANY LIABILITY CONCERNING THE SUITABILITY AND PROCESS ABILITY OF THE PRODUCTS MENTIONED HEREIN. THIS ALSO APPLIES TO PROCESS RESULTS / OUTPUT / MANUFACTURING GOODS AS WELL AS TO POSSIBLE DEFECTS, DAMAGES, CONSEQUENTIAL DAMAGES, AND FURTHER-REACHING CONSEQUENCES.