QINGDAO HONGSHENGHONG MACHINERY CO., LTD.

USER MANUAL

FOR

SEMI-AUTO WOOD PANEL SAW MACHINE

MODEL: MJ6226 / MJ6233 / MJ6238

QINGDAO HONGSHENGHONG MACHINERY CO., LTD.

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Specification

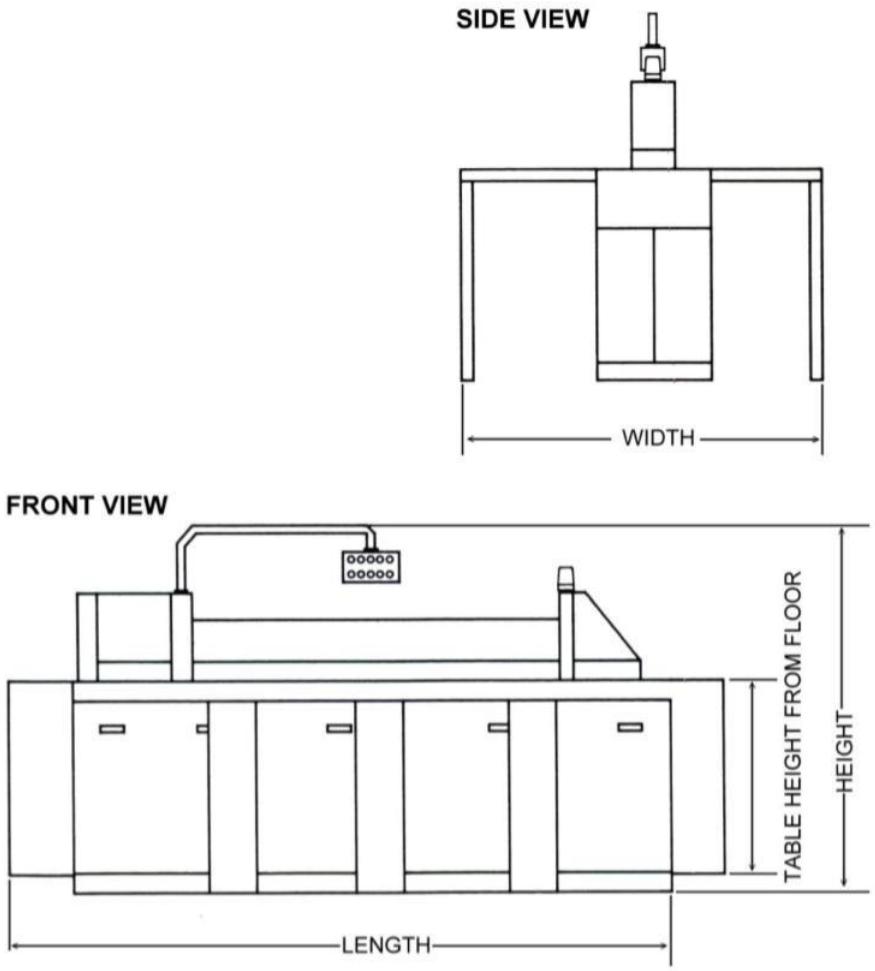
Maximum cutting length:	2600mm	Diameter of grooving saw spindle:	25.4mm
Maximum cutting thickness:	70mm	Cutting Speed	16-26-36m/min (3 step)
Rotate speed of main saw blade:	5600rpm	Total Power	8.6kw
Diameter of main saw blade:	355mm	Overall Size	5300x3550x1750mm
Diameter of main saw spindle:	30mm	Weight	3000kg
Rotate speed of grooving saw blade:	5600rpm	Accuracy	±0.25mm
Diameter of grooving saw blade:	160mm	Voltage	380V, 50Hz

STANDARD ACCESSORIES

1. Infeed and outfeed table ---3 sets each for in feed and out feed.
2. Main saw blade—diameter 355mm.
3. Scoring saw blade---diameter 160mm
4. Tool box with kits

INSTALLATION LAYOUT

MODEL	MJ-6226	MJ-6233	MJ-6238
LENGTH	5300MM	5600MM	6000MM
WIDTH	3550MM	3550MM	3550MM
HEIGHT	1750MM	1750MM	1750MM
TABLE HEIGHT	850MM	850MM	850MM



INSTALLATION NOTICE

Read and be familiar with the user manual before operating the machine.
Always keep the guards in place and in proper working condition.
Properly ground the machine to prevent electrical shock.
Remove all adjustment keys and tools on the machine before operation.
Cut the power supply when you need to change or adjust the saw blade to prevent additional start.
Keep working area clean.
Never leave the machine unattended while machine running. Turn off the machine and never leave until the machine completely stop.
Always ask professional electrician to perform the electric maintenance for the machine.
Make sure the main saw blade and scoring saw blade and correctly fitted according to the running direction. Tighten both blade securely.
Do not place hands understand the beam or the emergency stop line.
Do not open guards when machine is running.

LIFTING AND INSTALLATION OF THE MACHINE BODY

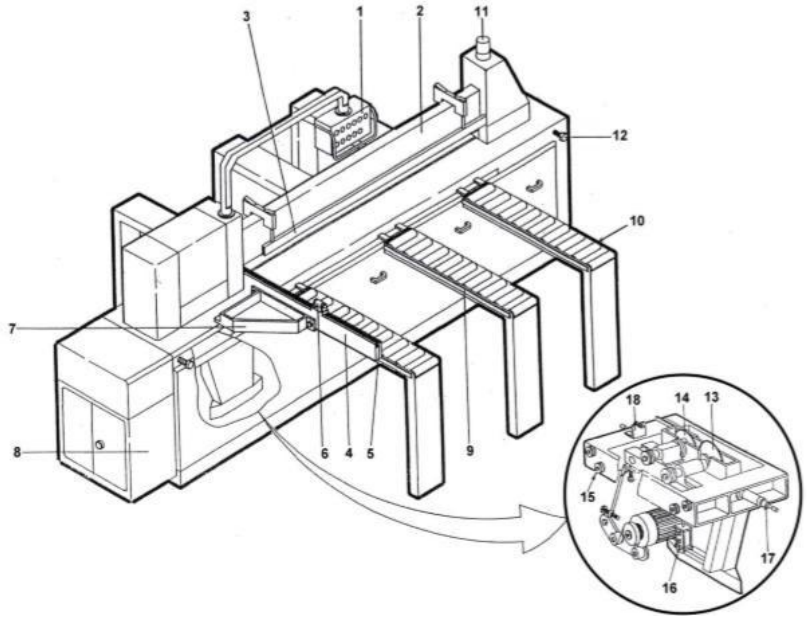
The machine should be lifted by a fork lift. Pay attention to the machine balance while lifting.
The machine weight of each models are as follows:

MJ-6226	Net Weight 3000kg
MJ-6233	Net Weight 3200kg
MJ-6238	Net Weight 3400kg

The machine should be installed on a solid and flat ground.
Leave enough space around the machine for easily loading materials.
The machine legs equipped with some levelling screws, adjust the screws and make the machine on a flat ground.

PARTS OF THE MACHINE

1. Control panel
2. Wood clamp beam
3. Emergency stop shaft
4. Rip fence
5. Rule gauge
6. Width adjust Stopper
7. Tool tray
8. Electrical control box
9. Infeed roller conveyor table
10. Outfeed conveyor table
11. Overload warning lamp
12. Lifting bolt
13. Main sawblade
14. Scoring sawblade
15. Feed wheel
16. Sawblade raising cylinder
17. Shock absorber
18. Optical fiber sensor



DESCRIPTION OF CONTROL PANEL FUNCTIONS

Saw Up	The saw blade goes up
Saw Down	The saw blade goes down
Beam Up	The pressure beam goes up for loading material
Beam Down	The pressure beam goes down for pressing material
Saw Carriage forward	Saw carriage go forward
Saw Carriage Backward	Saw carriage go backward
Saw Blade Run	Saw blade start running
Saw Blade Stop	Saw blade stop
Manual Mode	To set the machine movement manually

Position	To show to current position of the saw blade
Overload Indicator	If overload cutting happens while machine cutting, this light will on and alarm the operator, machine will stop
Emergency Stop	When this button is pressed, all machine movement will stop.(Note: please check if the saw blade has returned to its original position when this button is pressed)
Power Indication	Press this button to start or off the machine

POWER SUPPLY WIRING

Before connecting the machine with outside power source, make sure that the voltage of your power source complies with the machine voltage. The standard voltage of the machine is 3 phase 380V, 50Hz.

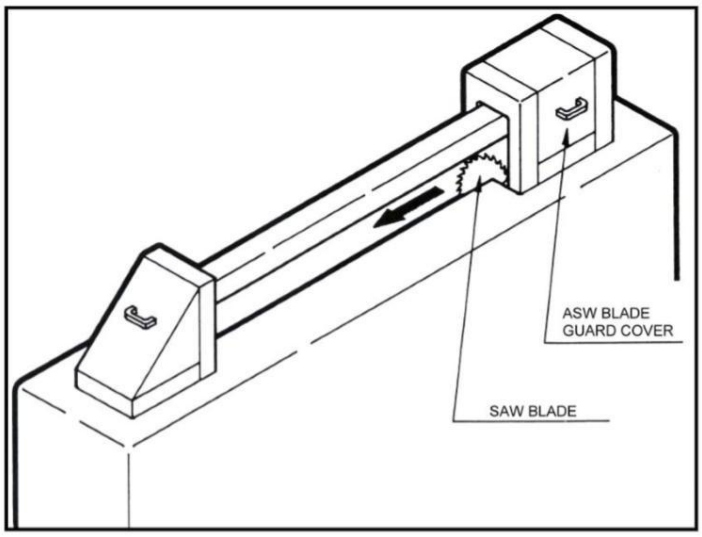
Connect the power source wire to the right connection point which inside the electric box.

The machine must be properly grounded to prevent electric shock.

Follow the following instructions to check if the wires are connected correctly:

(1) Turn on the power indication button to start the machine.

(2) Press Saw Blade Run button to check its turning direction. If both saw blades move in opposite direction, then means the wires are connected correctly. If not, change any two of the three phase wire to the connection point in control box, then check again.

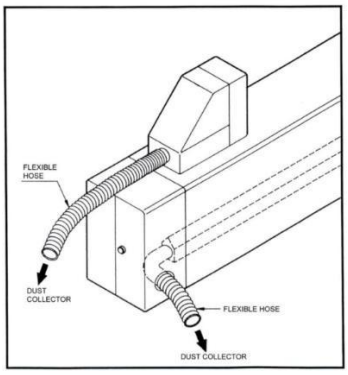


CONNECTION OF DUST COLLECTOR

There are 100mm diameter dust hood outlets provided at both sides of the machine, to be connected with dust collecting tube.

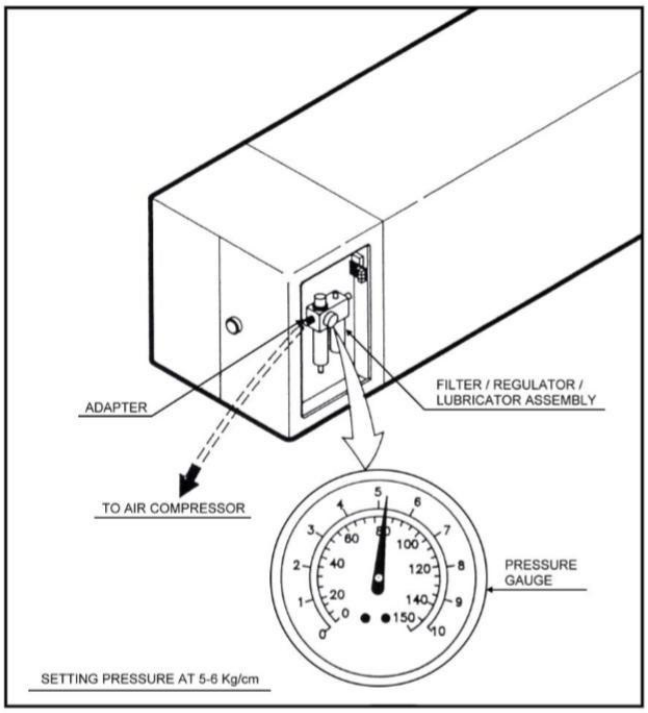
Connect them to the dust collector.

Make sure the dust collector is operating before cutting procedure.



CONNECTION WITH AIR

The machine should be connected with air compressor. The normal pressure of the machine is 5-6kg/cm2.

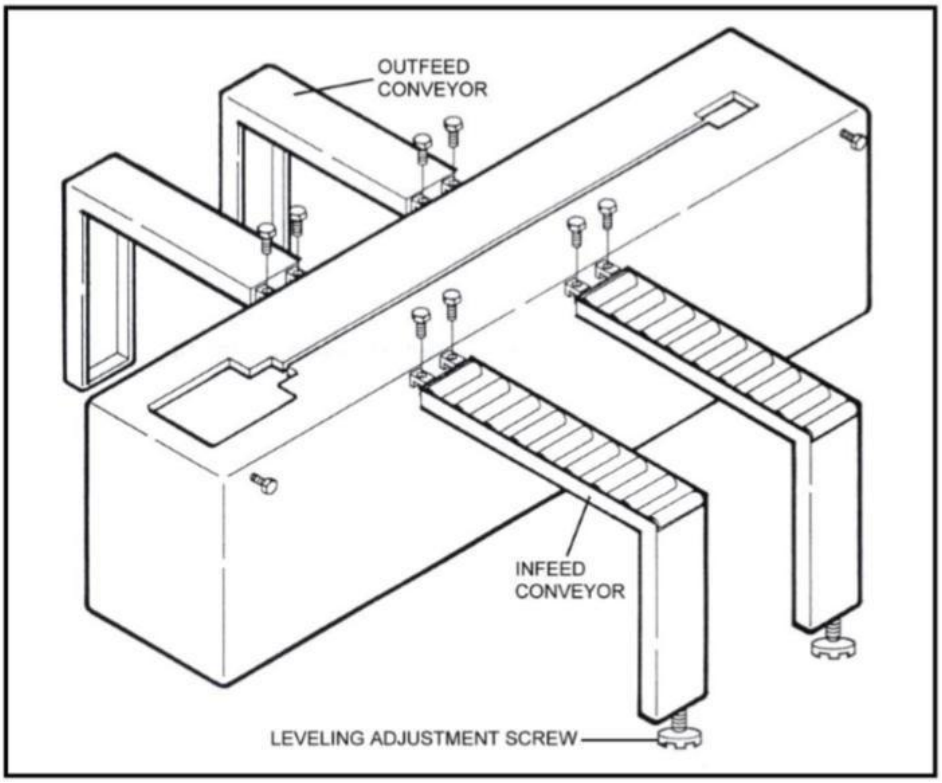


INSTALL INFEED AND OUTFEED TABLE

There are 3 sets of infeed table and 3 sets of outfeed table of the machine. The infeed table is roller type, the outfeed table is a flat type.

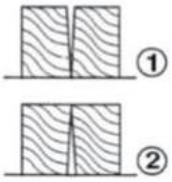
Once the machine is installed at the working site, install the infeed and outfeed table on the machine.

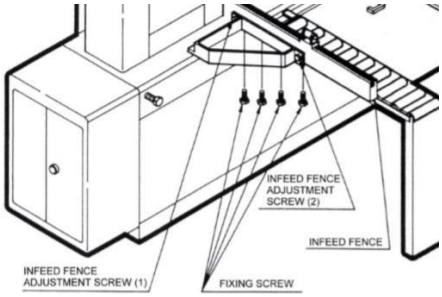
After the table finished installation, make the levelling adjustment. To do this, put a straight ruler on the machine table, and adjust the levelling through the screws under the table.



ADJUSTMENT OF THE INFEED FENCE

(1) Try to cut stacked panels, hold the piece edge by edge, and check if there is any gap between the edge, if so, adjust the infeed fence.
(2) Loosen the screws that tighten on infeed fence, they are at the bottom of the infeed fence.
(3) If the gap is on the top as shown on the picture, adjust the screw 1.
(4) If the gap is on the button, then adjust screw 2.
(5) After adjustment, tighten the screws in the button of infeed fence.



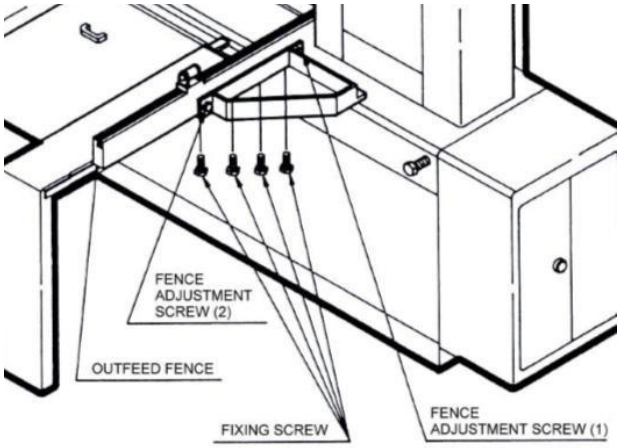


OUTFEED FENCE ADJUSTMENT

(1) Adjust the outfeed fence after the infeed fence is adjusted.
(2) Hold a trimmed wood plate against the infeed fence and outfeed fence. Use

infeed fence as a reference, then adjust the outfeed fence.

(3) Loose the screws at the bottom of outfeed fence, then adjust the screw 1 and 2. After adjustment, tighten the screws at the bottom.



REPLACING THE MAIN SAW BLADE

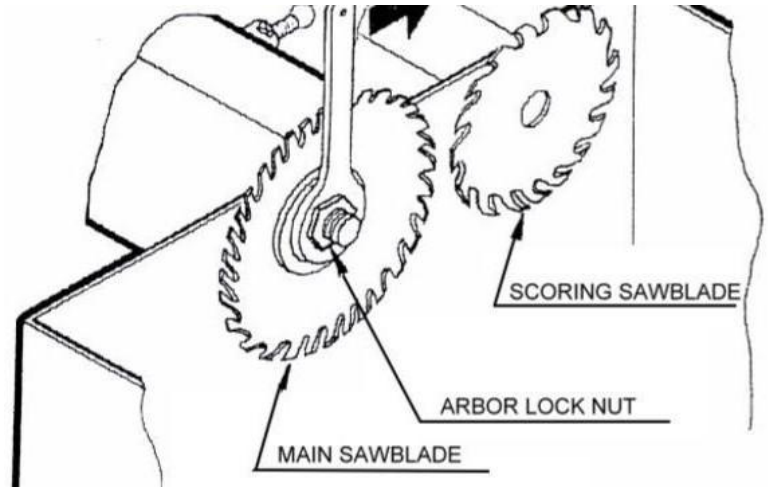
(1) Make the saw blade up to the highest position

(2) Use a spanner to hold the saw blade lock nut, rotate the spanner to loose the nut (same direction as the saw blade teeth)

(3) Take out the saw blade and clean the clamp.

(4) Install the new saw blade, rotate the spanner in the opposite direction as saw blade teeth to tighten the saw blade.

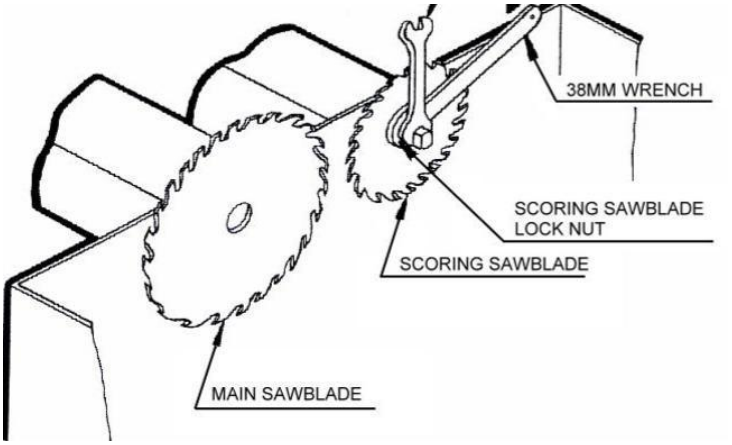
(5) Once the saw blade is changed, make it reach to the lowest position. If saw blade is not lowered entirely, all control will be locked.



REPLACING THE SCORING SAW BLADE

(SAME METHOD AS MAIN SAW BLADE)

(1) Make the saw blade up to the highest position
(2) Use a spanner to hold the saw blade lock nut, rotate the spanner to loose the nut (same direction as the saw blade teeth)
(3) Take out the saw blade and clean the clamp.
(4) Install the new saw blade, rotate the spanner in the opposite direction as saw blade teeth to tighten the saw blade.



HOW TO CHOOSE DIFFERENT SAW BLADE ACCORDING TO DIFFERENT MATERIAL

The saw blade can be divided into alternating type and teeth type. Both of them are suitable for cutting 30mm thickness single/double side laminating chipboard, MDF, plywood. But of the panel is hard or too much glue, that will be influence on the cutting effect, for example, edge become black, edge breakage, machine loud noise or machine cutting difficulty. It means the saw blade is not sharp, should sharpening the saw blade or change a new saw blade.
For panel thickness less than 30mm, better use teeth type saw blade.

ADJUST THE SCORING SAW BLADE

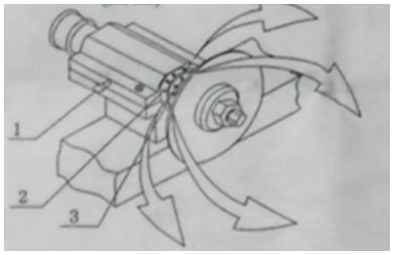
The scoring saw blade can be adjusted up/down, left/right. If the cutting is not straight or have burrs on edge, it means the scoring saw blade position is wrong.

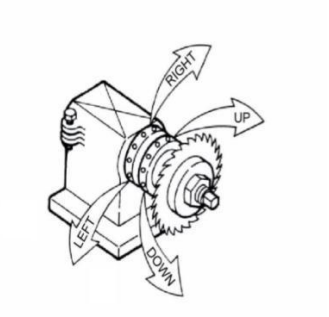
1. RIGHT / LEFT ADJUSTMENT FOR THE SCORING SAW BLADE

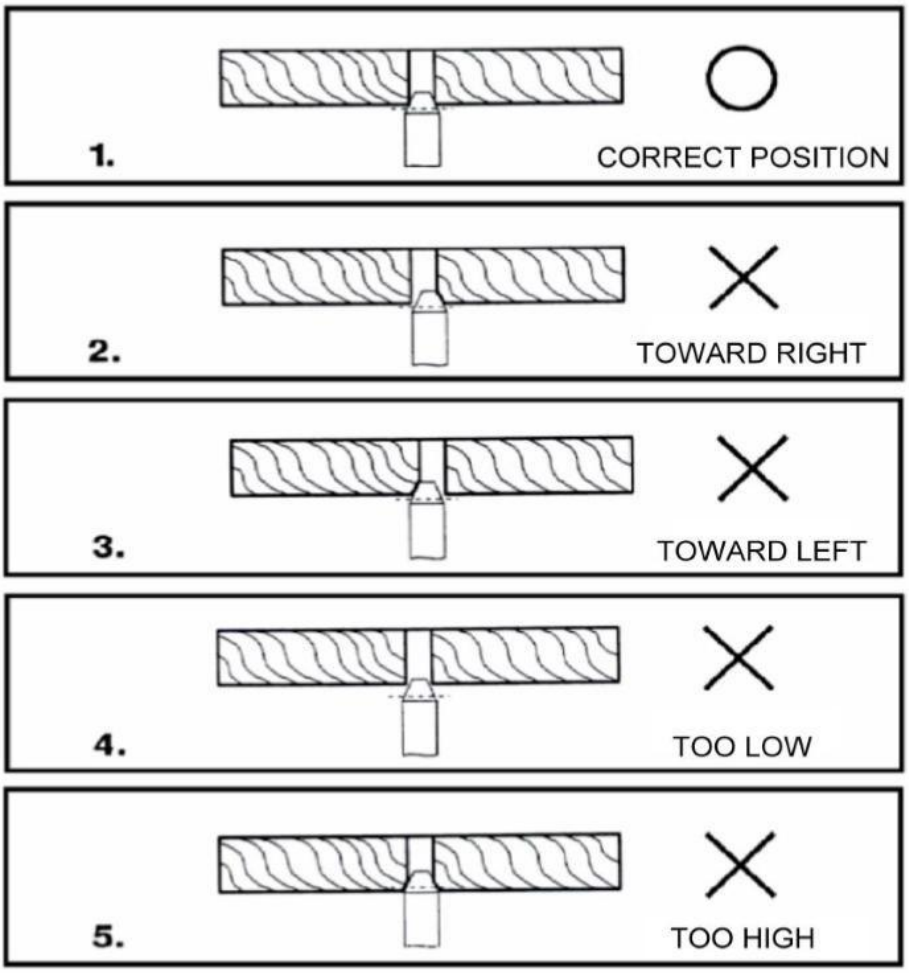
If only one edge has burr and the other edge has not, that should adjust the left / right of scoring saw blade. First loose screw 1, then use spanner to adjust screw 2, rotate anticlockwise, then the scoring saw blade will move to right side, if rotate screw 2 in opposite direction, the scoring saw blade will move to left side. After both scoring saw blade and main saw blade are in the same line, tighten screw 1.

2. UP / DOWN ADJUSTMENT FOR THE SCORING SAW BLADE

If both edges has burr, it means the scoring saw blade position too low, then we should make it higher. If both edges is not straight (bevel), it means the scoring saw blade position too high, then we should make it lower. First loose screw 1, then use spanner to adjust screw 3, rotate clockwise, then the scoring saw blade will go up, if rotate screw 3 in opposite direction, the scoring saw blade will go down. After adjusting to the right position, tighten screw 1.







V BELT TENSION ADJUSTMENT

(1) MAIN SAW BLADE DRIVING BELT TENSION ADJUSTMENT

Loosen screw 2 on scoring saw blade, then adjust screw 1 (anti-clockwise to tighten the belt, clockwise to loosen the belt), after adjustment, tighten screw 1.

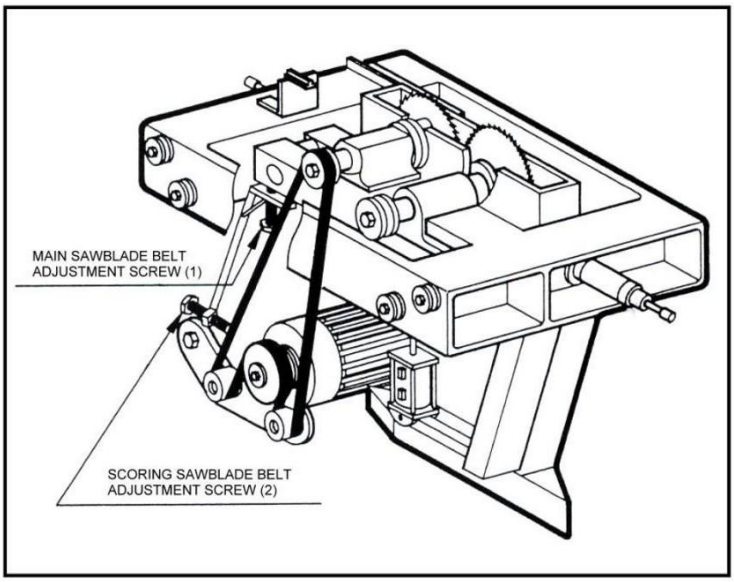
(2) SCORING SAW BLADE DRIVING BELT TENSION ADJUSTMENT

Adjust screw 2 (anti-clockwise to tighten the belt, clockwise to loosen the belt), after adjustment, tighten screw 2.

(3) BELT SPECIFICATION

Main saw spindle: V belt A1150 3pcs

Scoring saw spindle: flat belt 1700*20*2.0mm 1pcs

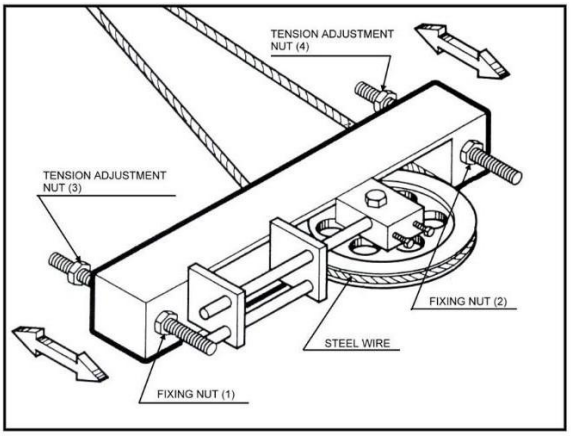


STEEL WIRE TENTION ADJUSTMENT

(1) Loosen the fixing nut 1 and 2

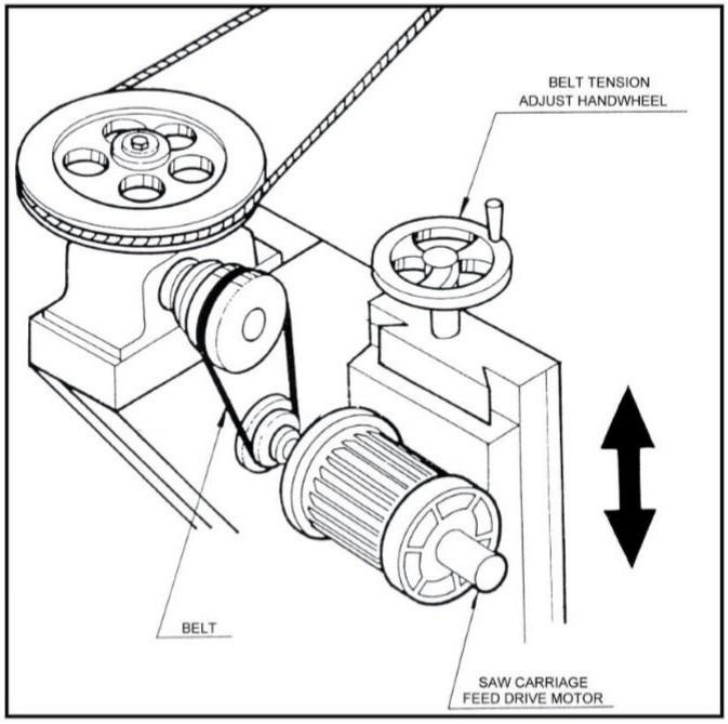
(2) Adjust the wire tension by turning the adjustment nuts 3 and 4

(3) Tighten fixing nut 1 and 2 after the wire tension is properly.



SAW CARRIAGE FEEDING SPEED ADJUSTMENT

The saw carriage is hang on the ground guide rail, transmission is control by the steel wire moving.
There are 3 steps of the speed, fast speed 36m/min, middle speed 26m/min, low speed 16m/min. Change the speed through changing the belt tension, there is a small handwheel to adjust the belt tension



SAW CARRIAGE RUNNING DISTANCE ADJUSTMENT

The running distance of saw carriage is control by time relay. The saw carriage running time is depend on the panel length and feeding speed (feeding speed is adjusted by the belt tension as above picture).

TROUBLE SHOOTING GUIDE

TROUBLE	PROBLEM CAUSE	SOLUTION
Overload warning	1. motor over load 2. lack of power phase or abnormal voltage 3. poor contact of motor wires 4. relay damage	1.(a) adjust the thermal pin to correct value (b) reduce the thickness of cutting (c) reduce the feeding speed of saw carriage 2. test the voltage 3. tighten the wires 4. replace the relay
Pressure beam can not raise or height is not enough	1. air pressure not enough 2. dust deposited between the beam gear and rack 3. poor lubrication 4. Solenoid valve	1. Properly set the air pressure 2. Clean the pressure beam bracket, and lubricate it with grease 3. Remove dust and lubricate
Saw blade goes up but saw carriage not move	1. Upper limit sensor broken 2. The distance between limit sensor and sensing steel is too big 3. Steel wire too loose 4. Dust in the saw carriage wheel	1. Replace limit sensor 2. Adjust the distance between limit sensor and sensing steel to 4-6mm 3. Tighten the steel wire 4. Clean the dust on the guide rail of saw carriage
After cutting the saw carriage not return	1. Down limit sensor broken 2. the distance between limit sensor and sensing steel is too big 3. AC contactor is broken	1. Replace the limit sensor 2. Adjust the distance between limit sensor and sensing steel to 4-6mm 3. Replace the AC contactor
The cutting edge become dark	1. The saw blade teeth not sharp 2. The saw blade teeth is not properly	1. Sharpening the saw blade or change a new one 2. Use correct saw blade according to the material
Saw blade not go up or	1. Air pressure not	1. Check if the pressure

height not enough	enough 2. Solenoid valve broke	on pressure gauge is normal 2. Replace Solenoid valve
During operating, the saw blade stop running,	Check if the emergency stop button is on	Adjust the emergency stop button

OPERATION PROCEDURES

1. Connect the power wires, air correctly
2. Open the power supply, power supply light on.
3. Use manual mode, to test the saw blade adjustment, saw carriage movement
4. Make sure the saw carriage is in its original position
5. Fix the fence position according to the panel size to be cut
6. Load the panel on worktable, firmly against the fence
7. Press AUTO START mode, machine start cutting panels.

DAILY MAINTENANCE

1. Check the filter bowl on the filter / lubrication unit, and release the water inside the bowl. The lubricator bowl should be kept at proper quantity of oil.
2. Clean the pressure beam guide rail and lubricate it.
3. Clean the saw carriage
4. Check the driving belt tension and adjust it if necessary
5. Remove the dust and chips inside the dust collector
6. Clean the guide rod and lubricate it.