

TELMEC SrL

SL13.11
SCORING MACHINE
MAINTENANCE AND
USER'S MANUAL

rev. 1.0

serial number : M

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code : 0900-1311EN10

INSTALLATION AND START-UP

ENVIRONMENT AND NECESSARY CONNECTIONS

The SL13.11 is a NC machine able to work with high precision. It is therefore reasonable to install it in a constant temperature environment. In fact, frequent temperature changes affect the precision of the CN machine. All the common rules valid for every CN machine are still in force for the SL13.11.

Power Supply

The SL13.11 has the following standard characteristics:

- * 380 Volts - 3 phases + GND
- * 50/60 Hz
- * 3 Kw

Whenever a different supply voltage is required, a transformer will be installed inside the machine. The connection to the power line must be made with a cable with the suitable indicated power characteristics.



The cable must be carried inside the machine through a hole located on the left side of the lower cabinet. The cable must always be connected to the terminal block located on the left side of the front panel. The terminal blocks are marked with **L1-L2-L3-GND**.

The customer must provide to protect the machine by a differential safety switch against short circuits.

Compressed Air

The required characteristics are the following:

- * pressure: 6 bars
- * capacity : 170 lit/min.
- * filtering : 40 microns

The connection must be done with a 1/8" connector located on the left side of the lower cabinet. The pneumatic system schematic is enclosed.

Exhausting System

The SL13.11 requires a suitable exhausting system for a proper functioning. The characteristics must be the following:

- * suction : 2000 mm/H₂O
- * capacity : 150 m³/h

On the back side of the lower cabinet a pipe fitting for the vacuum tube is located.



Never operate the machine without the exhauster or with an exhauster with lower characteristics. This may cause severe and permanent damages to the machine and compromise its correct functioning.

	MIN Limits	Max Limits	
Blade Diameter	98,00	100,00	mm
PCB Size	200,00	650,00	mm
Edge-Pin Distance	1,00	12,00	mm
Edge-Clamp Distance	1,00	12,00	mm
PCB Thickness	0,80	3,20	mm
Core	0,20	1,00	mm
Conveyor Speed without Jump	5,0	30,0	m/min
Conveyor Speed with Jump	5,0	20,0	m/min
UP Jump Distance	2,00	10,00	mm
Down Jump Distance	2,00	10,00	mm
Total Km Counter	100,000		Km

End of Mask Setting

BLADES DIAMETER : The blades have originally a diameter of 100 mm. After resharpening, this diameter is reduced. The minimum acceptable value is 98,00 mm.

PCB SIZE : Minimum 100 X 100 (4" x 4"), maximum 650 X 650 (24" x 24") mm.

EDGE-PIN DISTANCE : It could be within 5 and 50 mm (0,2" - 2"). Optimum is with 10 mm (0,4").

EDGE-CLAMP DISTANCE : It could be within 5 and 50 mm (0,2" - 2"). Optimum is with 10 mm (0,4").

PCB THICKNESS : From 0,6 to 2,40 mm (0,024"-0.094")

CORE : from 0,20 to 3,00 mm (0,0065"-0,12")

CONVEYOR SPEED : without jump 5-30 mt/min
 with jump 5-20 mt/min

UP JUMP DISTANCE : It is the minimum and maximum distance for a movement along the Y-axis with the blades UP.

DOWN JUMP DISTANCE : It is the minimum and maximum distance for a movement along the Y-axis with the blades DOWN.

DATABASE DIRECTORIES SET-UP

By this mask it is possible to preset 15 different databases to use to save or load scoring programs. For each one of the 15 database it is possible to specify a proper path to access different directories on the HD, the floppy or the net.

The #15 is set by default as the floppy disk A:

To create a new database , just write the complete path on an empty line , select it clicking the proper square and press CREAT NEW DB.

It is always necessary to specify the complete path as follow :

C:/DIR1/DIR2/..../DIRN