

USER MANUAL

F SERIES POWER FOLDER

CIDAN
CIDAN MACHINERY GROUP

Original instructions

91700002, rev 1.1

CIDAN
MACHINERY GROUP

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1. PRODUCT LIABILITY

Limitation of Liability:

(a) IN NO EVENT SHALL CIDAN BE LIABLE TO BUYER OR ANY THIRD PARTY FOR ANY LOSS OF USE, REVENUE OR PROFIT OR LOSS OF DATA OR DIMINUTION IN VALUE, OR FOR ANY CONSEQUENTIAL, INDIRECT, INCIDENTAL, SPECIAL, EXEMPLARY, OR PUNITIVE DAMAGES WHETHER ARISING OUT OF BREACH OF CONTRACT, TORT (INCLUDING NEGLIGENCE) OR OTHERWISE, REGARDLESS OF WHETHER SUCH DAMAGES WERE FORESEEABLE AND WHETHER OR NOT CIDAN HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES, AND NOTWITHSTANDING THE FAILURE OF ANY AGREED OR OTHER REMEDY OF ITS ESSENTIAL PURPOSE.

(b) IN NO EVENT SHALL CIDAN'S AGGREGATE LIABILITY ARISING OUT OF OR RELATED TO THIS AGREEMENT, WHETHER ARISING OUT OF OR RELATED TO BREACH OF CONTRACT, TORT (INCLUDING NEGLIGENCE) OR OTHERWISE, EXCEED THE TOTAL OF THE AMOUNTS PAID TO CIDAN FOR THE EQUIPMENT SOLD HEREUNDER.

(c) The limitation of liability set forth in Section (b) above shall not apply to (i) liability resulting from CIDAN's gross negligence or willful misconduct and (ii) death or bodily injury resulting from CIDAN's acts or omissions.

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2. INTRODUCTION

2.1. DOCUMENT DESCRIPTION

This operation and maintenance manual describes the safe operation and maintenance of F26, F32, F32 USA, F41, FS26, FS32, FS41, FS26 PLUS, FX32 PLUS, FS41 PLUS, FX26 PLUS, FX32 PLUS, FX41 PLUS, FX26, FX32, FX41.

WARNING! Save this document for future reference. Speak to CIDAN Machinery if you lose this document.

WARNING! Read and understand the manual before you use the product.

2.1.1. UNITS

Both the metric system and the imperial system are used in this document to describe the different measurement units. The metric system is stated first, followed by the imperial system.

2.1.2. RELATED DOCUMENTS

- Control system manual, refer to information provided by CIDAN Machinery.
- Pre installation and transportation guide, refer to information provided by CIDAN Machinery.
- Order confirmation document, refer to information provided by CIDAN Machinery.
- Electrical schematic, refer to information provided by CIDAN Machinery upon delivery.

NOTE! Speak to CIDAN Machinery if you do not have the documents.

2.2. PRODUCT DESCRIPTION

2.2.1. INTENDED USE

This product is intended for the folding procedure of metal sheets made of steel, stainless steel and aluminum. Do not use other materials as this can cause damage to the product.

CAUTION! Do not use the product to straighten sheet metal, to bend flat or round bars, or to fold thicker sheets than specified. Do not use the product for tasks that are not intended.

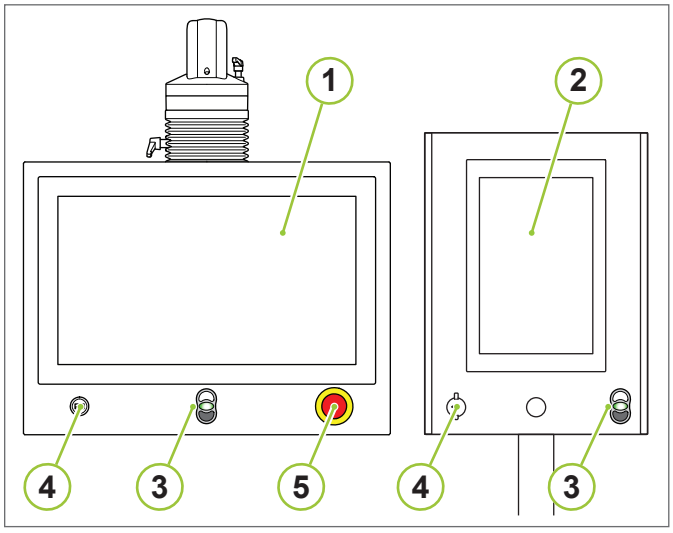
Do not modify the product and do not use spare parts that are not approved by CIDAN Machinery. All maintenance must be done according to the instructions in this manual.

CAUTION! CIDAN Machinery cannot guarantee that the product fulfills the intended use if the requirements described above are not met.

2.2.2. PRODUCT DELIVERY

Make sure that the delivery includes everything specified in you order confirmation.

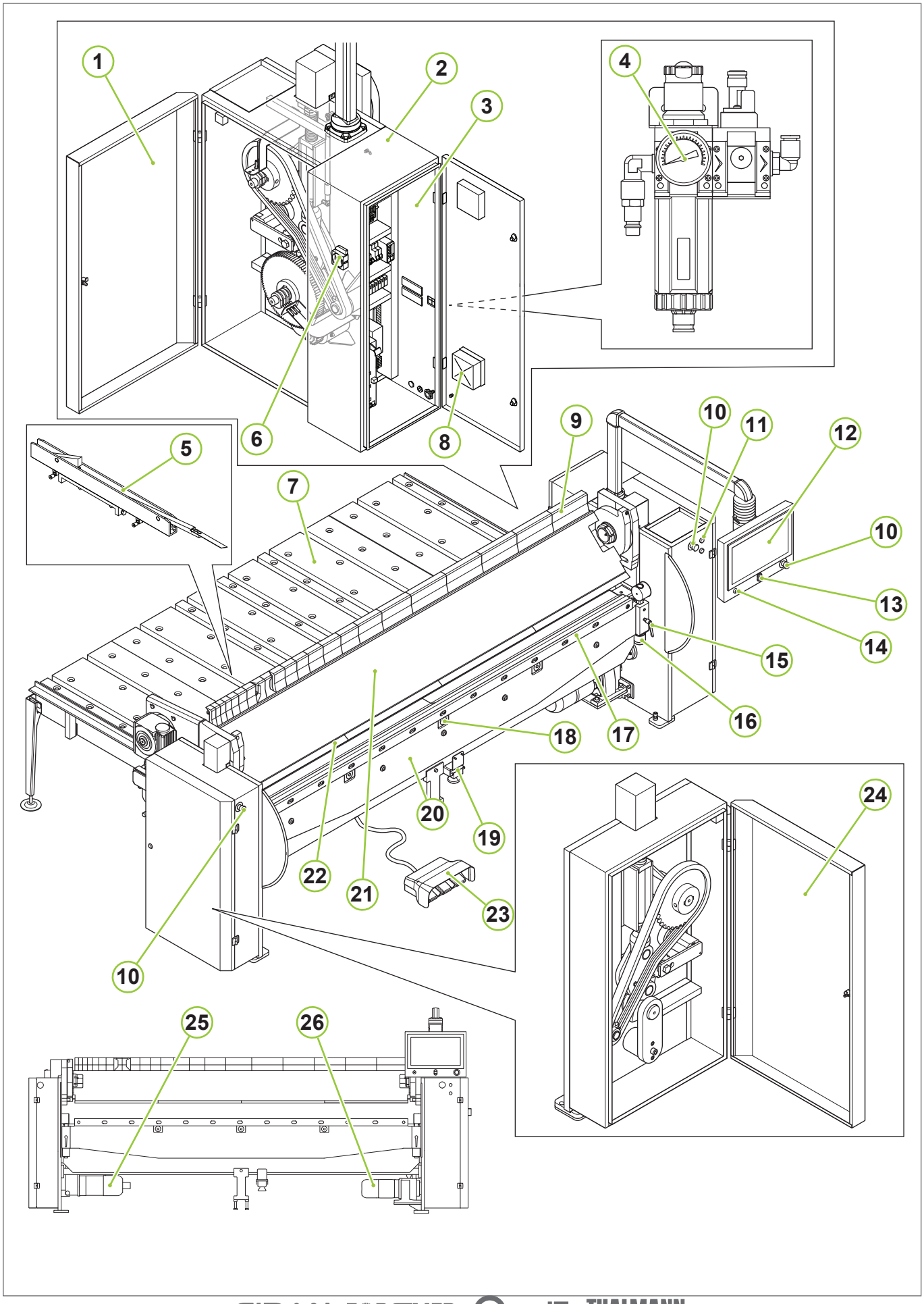
2.3. CONTROL PANEL OVERVIEW



1. Monitor for nuLink control system.
2. Monitor for EasyLink control system.
3. Start button (green) and stop button (red).
4. USB port.
5. Emergency stop button.

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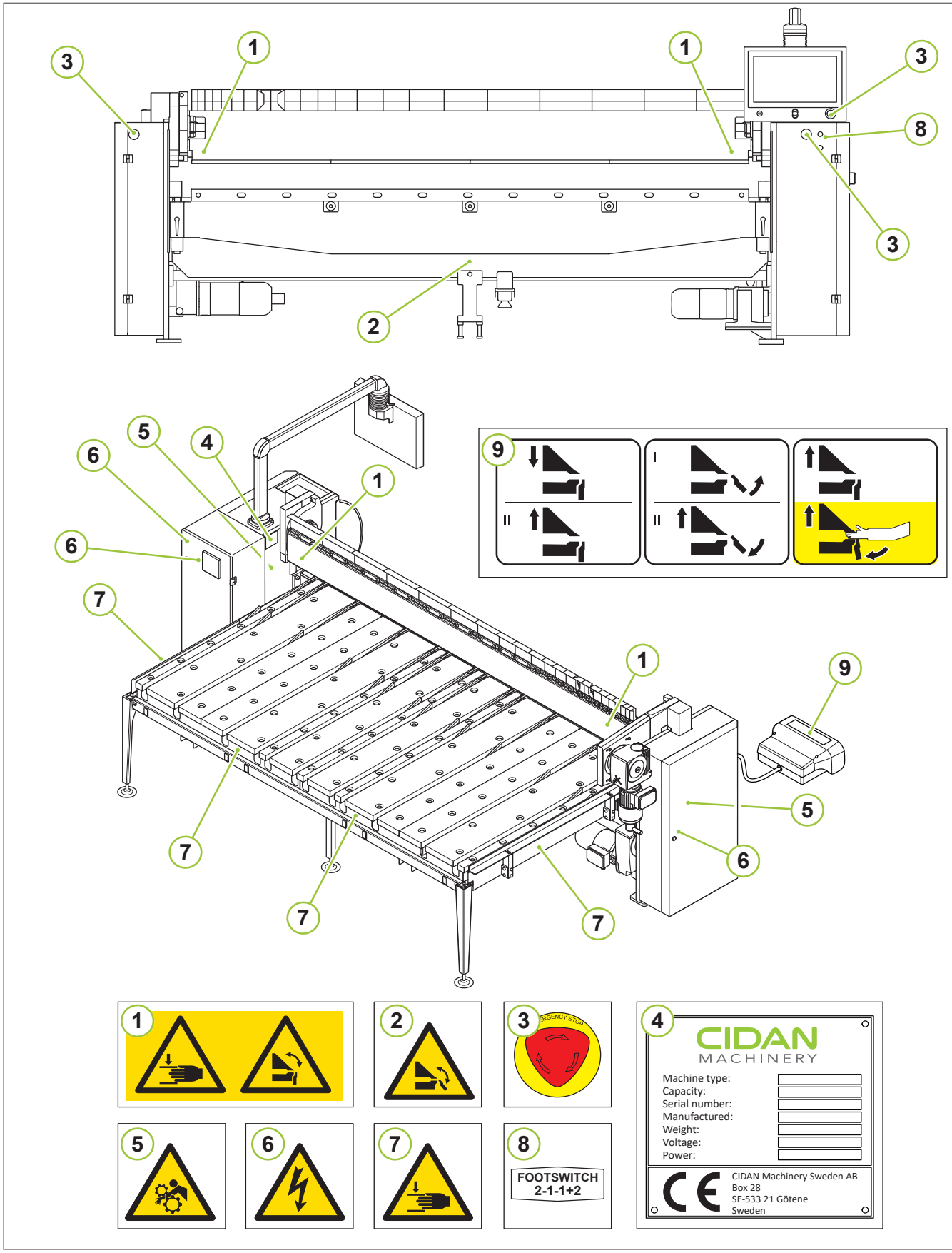
2.4. PRODUCT OVERVIEW



PART	OPERATION
1. Mechanical cabinet (right frame)	
2. Type plate	
3. Electrical cabinet	
4. Pneumatic valve with manometer	
5. Back gauge station	Sets the position of the back gauge.
6. Main switch	
7. Back gauge	
8. Fan filter	
9. Box tools	
10. Emergency stop buttons	
11. Footswitch selector	
12. Control system	Monitors the product according to the set programs.
13. Start button (green) and stop button (red) for nuLink control system	
14. USB port for nuLink control system	
15. Locking handle	Locks the folding beam after height adjustment.
16. Adjusting nut	Sets the height of the folding beam.
17. Folding beam tool	
18. Adjustable crowning	Sets the crowning of the folding tool.
19. Floor scanner (optional)	
20. Folding beam	Moves up and down to fold the material.
21. Clamping beam	Moves up and down to keep the material in position during folding. Rotates to change between straight rail and box tools (FX only).
22. Straight rail	
23. Foot pedal unit	Controls the movement of the clamping beam and folding beam.
24. Mechanical cabinet (left frame)	
25. Drive motor, folding beam	Generates movement to the folding beam.
26. Drive motor, clamping beam	Generates movement to the clamping beam.

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2.5. SYMBOLS ON THE PRODUCT



1. Warning; crushing of hands and risk of crush injury.
2. Warning; risk of crush injury.
3. Emergency stop button.
4. Machine data plate.
5. Warning; moving parts.
6. Warning; electricity.
7. Warning; crushing of hands.
8. Footswitch positions. Shows position 2, 1 and 1+2.
9. Pedal unit positions. Shows position 1 and 2 for left pedal, middle pedal and right pedal.

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3. SAFETY

3.1. INTRODUCTION

WARNING! You must read and understand all safety instructions before you work or stay in the vicinity of the product. Keep the manual near the product for future reference and as a safety precaution.

WARNING! If you do not obey the safety instructions given in this manual, it can cause serious personal injury or damage to the product. CIDAN Machinery is not liable for personal injury or damage caused by work that deviates from the instructions given in this manual.

WARNING! If the product does not work as expected, do not use the product. Speak to CIDAN Machinery for support.

3.1.1. SAFETY DEFINITIONS

WARNING! Warning is used if there is a risk of personal injury or death for the operator or persons that work near the product.

CAUTION! Caution is used if there is a risk of damage to the product.

NOTE! Note is used to give information that is good to have in a certain situation.

3.1.2. PERSONAL PROTECTIVE EQUIPMENT

WARNING! Use personal protective equipment during commissioning, operation and maintenance of the product to decrease the risk of personal injury. The product and working material contain sharp edges.



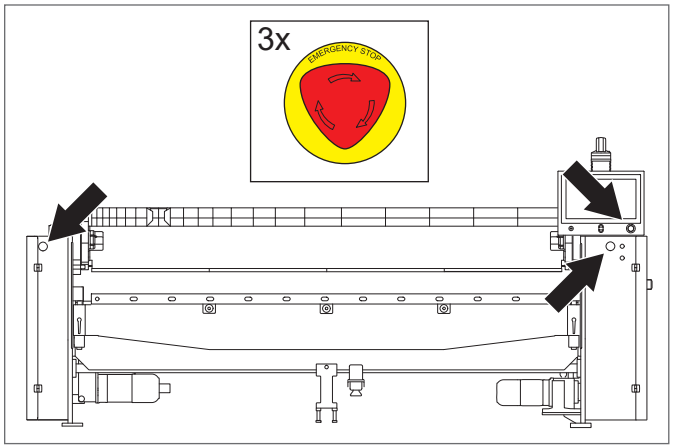
Use the approved personal protective equipment that follows:

- Hearing protection
- Protective gloves
- Protective footwear

3.2. SAFETY EQUIPMENT

3.2.1. EMERGENCY STOP BUTTONS

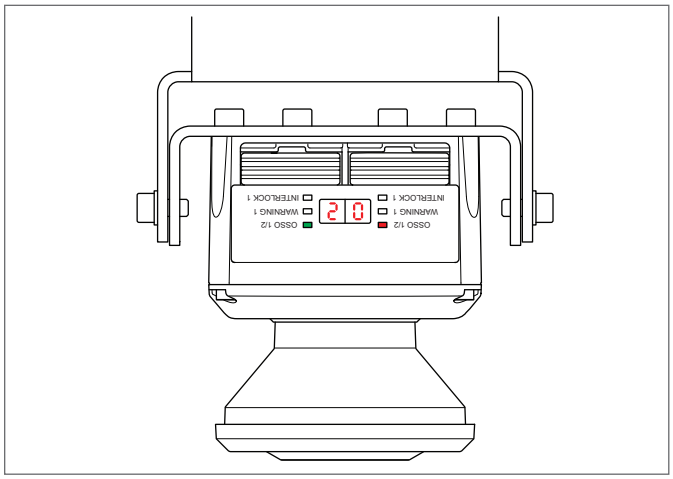
The product has 3 emergency stop buttons that can be used if it is necessary to stop the product immediately. The emergency stop buttons are located on the left and right frame, and on the control panel.



3.2.2. FLOOR SCANNER (OPTIONAL)

WARNING! If the product does not have a floor scanner installed, it is not approved to operate the product from the back gauge side of the product.

The floor scanner is installed on the folding side of the product and identifies movements from persons or objects within the risk area of the product. If movement is detected, the product stops automatically. Refer to "3.6. The risk area" on page 10 for more information.



3.3. SAFETY FOR INSTALLATION



WARNING! Read and understand the warning instructions that follow before installation of the product.

- Only installation personnel approved by CIDAN Machinery are approved to perform installation procedures on the product.
- Only a certified electrician is approved to connect the power supply to the product.
- The owner of the product is responsible to establish routines and regular checks to ensure there is no risk for falling, slipping of stumbling accidents around the product.
- The owner of the product is responsible to ensure that the work environment has sufficient lighting around the product.
- Do not do any installation procedures or adjustments to the product without a written approval from CIDAN Machinery. Activities that are not approved may void the warranty.

3.4. SAFETY FOR OPERATION



WARNING! Read and understand the warning instructions that follow before operation of the product.

- Only personnel authorized by CIDAN Machinery, with training and expertise in accordance with the safety instructions, are approved to operate and be near the product.
- Make sure that the product is approved for operation by CIDAN Machinery and that all parts are properly installed.
- Be aware of the risk area around the product. Do not enter the risk area when the product is in operation. Risk of personal injury. Refer to "91700002, rev 1.1" on page 1 for details.
- Make sure that no person enters the risk area during operation of the product.
- Do not use a product from the back gauge side if a floor scanner is not installed. Refer to "3.2.2. Floor scanner (optional)" on page 8 for details.
- For dual operator procedures, the product must have 2 interconnected pedal units installed and both operators must stay on the same side of the product. Speak to CIDAN Machinery for more information.
- Risk of crush injuries, do not put any body parts between moving parts.
- Risk of crush injuries, do not set the opening height of the clamping beam higher than necessary to release the metal sheet.
- Do not sit during operation.
- The operational sound level is <70 dB. During folding procedures, the sound level may exceed 70 dB.



CAUTION! Read and understand the caution instructions that follow before operation of the product.

- Do not leave tools or other objects on the product before operation. These can cause damage to the product.
- Do not perform folding procedures that requires greater force than the capacity of the product.

3.5. SAFETY FOR MAINTENANCE



WARNING! Read and understand the warning instructions that follow before maintenance of the product.

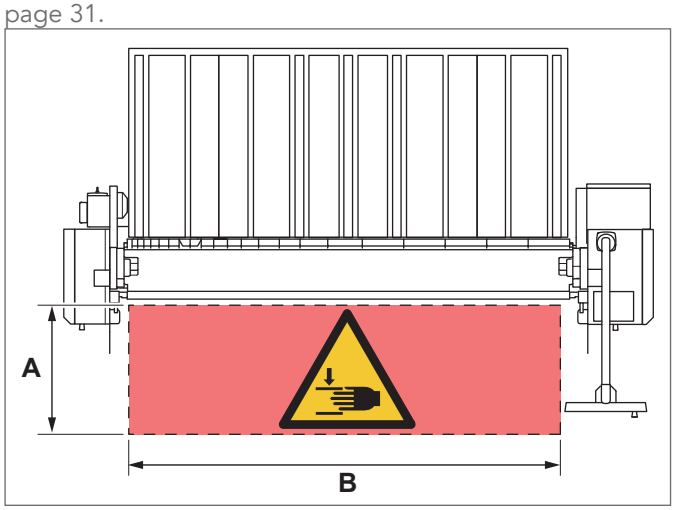
- Only authorized personnel with training and expertise in accordance with the safety instructions are approved to do maintenance on the product.
- Put the power switch to the off position and lock the power switch according to local regulations before you do maintenance in the electrified systems.
- Vent the pneumatic system before you do maintenance on pressurized systems.
- Be aware of components preloaded with springs. These can cause personal injury.
- Disconnect the quick coupling for incoming air when you do maintenance on the pneumatic system.

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3.6. THE RISK AREA

WARNING! Risk of crush injuries within the risk area. Make sure that persons not involved in the operation stay outside the risk area during operation.

The risk area defines an area on the folding side of the product, where the risk of crush injuries are greater. The depth (A) of the risk area is 80 cm/ 2.6 ft. The width (B) of the risk area is defined by the working length of the specific product model. Refer to "11. Technical data" on page 31.



4. LIFTING, TRANSPORTATION AND STORAGE

4.1. TO PREPARE THE PRODUCT FOR TRANSPORTATION OR LIFTING

WARNING! Persons involved in transportation of the product must be certified for transportation of heavy machinery. This procedure can cause serious injury or death.

1. Speak to CIDAN Machinery for support regarding transportation or lifting of the product.
2. Provide the supplied pre-installation and transportation guide to the persons involved in the transportation and lifting of the product.

Note! The pre-installation guide is supplied from CIDAN Machinery before delivery.

TO PREPARE THE PRODUCT FOR STORAGE

WARNING! Transportation and lifting must be performed by persons certified for transportation of heavy machinery. Refer to "11. Technical data" on page 31 for product weight.

- Make sure that the product is not put in storage outdoors in different weather conditions. This can cause damage to the product.
- Make sure that the product is put in storage in a closed environment with a temperature range of 15-30 C°, with a maximum variation of +/- 5 C° during the day.

5. PRE INSTALLATION

5.1. TO PREPARE FOR INSTALLATION

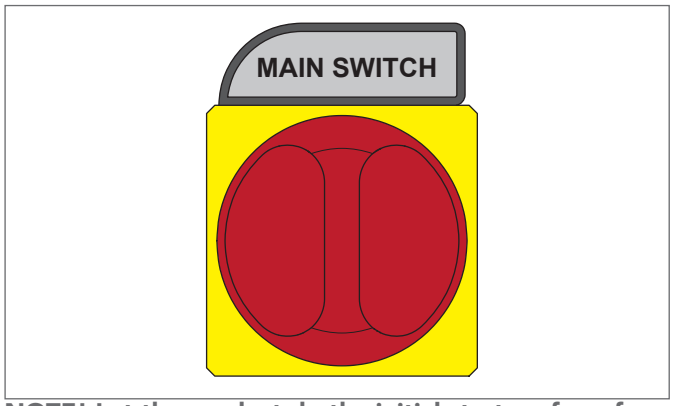
To prepare for installation of the product, refer to the pre-installation and transportation guide supplied before delivery of the product. Speak to CIDAN Machinery for support.

6. OPERATION

WARNING! Read and understand the safety chapter before you use the product.

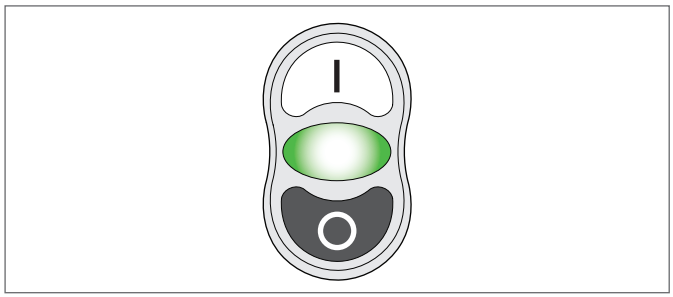
6.1. TO START THE PRODUCT

1. Do a check of all emergency stop buttons and make sure that they are not pushed in. Refer to "3.2.1. Emergency stop buttons" on page 8 for the location of the emergency stop buttons.
2. Make sure that there are no tools or materials, such as metal sheets, on the product.
3. Make sure that the product has sufficient air pressure. Refer to "8.8. To do maintenance on the pneumatic valve" on page 23.
4. Make sure that no persons or objects are in the risk area. Refer to "3.6. The risk area" on page 10 for more information about the risk area.
5. Make sure that the pedal unit is outside of the risk area.
6. Make sure that you have the correct personal protective equipment. Refer to "3.1.2. Personal protective equipment" on page 8.
7. Set the main switch to the ON position. Refer to "2.4. Product overview" on page 5 for the position of the main switch.



NOTE! Let the product do the initial start-up for a few minutes.

8. Press the green start button on the electrical cabinet or on the control panel. Refer to "2.4. Product overview" on page 5 for the location of the start buttons.



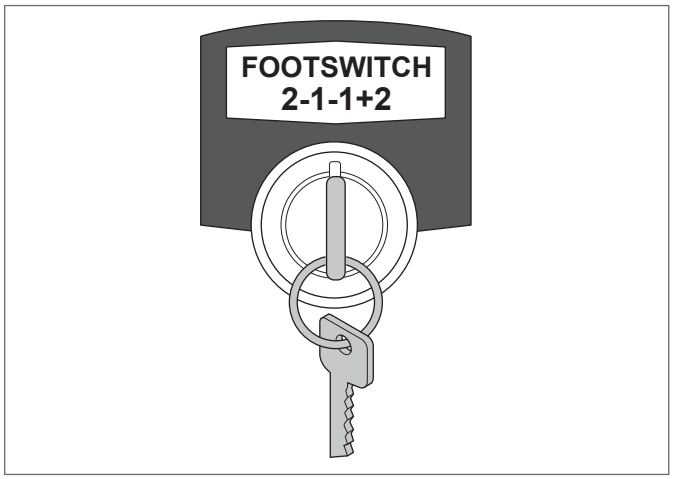
6.2. TO CHOOSE OPERATION CONDITIONS

The product can be operated in several conditions. It is possible to operate the product from the folding side or from the gauging side of the product. It is also possible to choose single operation or dual operation.

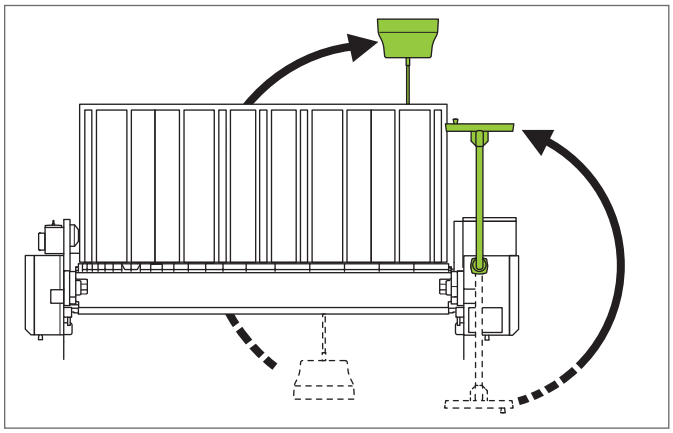
6.2.1. TO SET THE PRODUCT FOR GAUGING SIDE OPERATION

NOTE! Gauging side operation is not permitted if the product does not have a floor scanner installed.

1. Set the footswitch selector to position 1. Refer to "2.4. Product overview" on page 5 for the location of the footswitch selector.

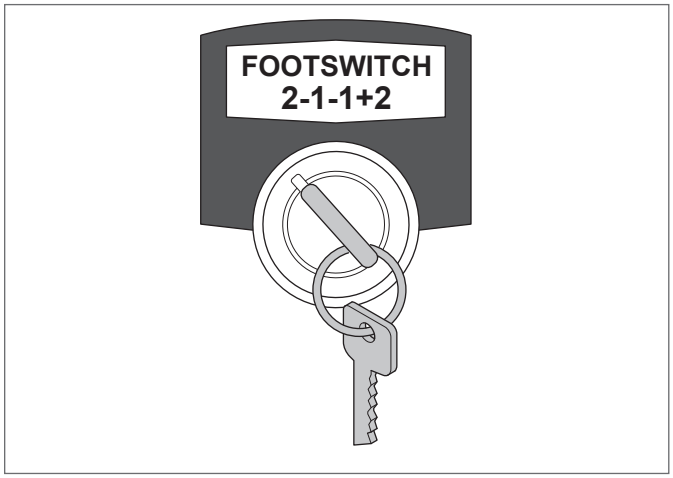


2. Move the control panel and the foot pedal unit to the gauging side of the product.



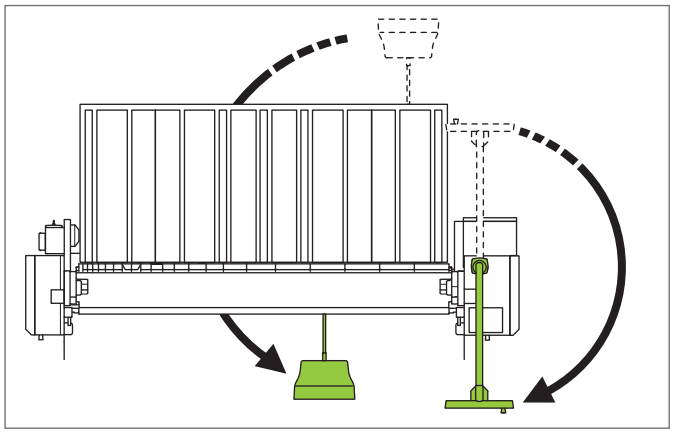
6.2.2. TO SET THE PRODUCT FOR FOLDING SIDE OPERATION

1. Set the footswitch selector to position 2. Refer to "2.4. Product overview" on page 5 for the location of the footswitch selector.



2. Move the control panel and the foot pedal unit to the folding side of the product.

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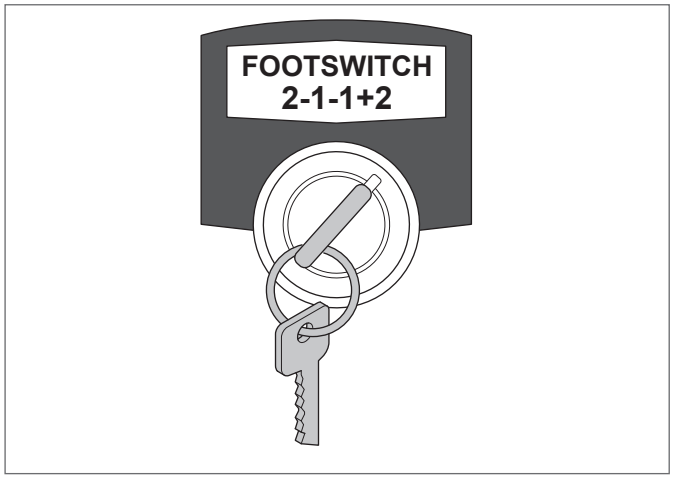


6.2.3. TO SET THE PRODUCT FOR DUAL OPERATION

NOTE! The product must have 2 pedal units installed for dual operation.

NOTE! Gauging side operation is not permitted if the product does not have a floor scanner installed.

1. Set the footswitch selector to position 1+2. Refer to "2.4. Product overview" on page 5 for the location of the footswitch selector.

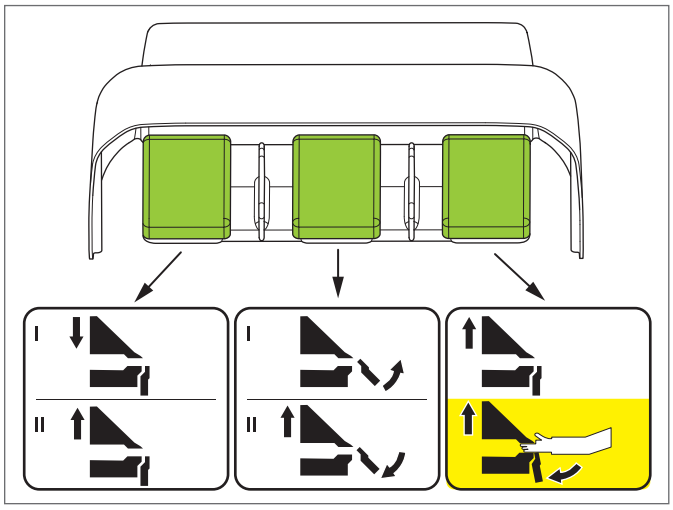


2. Move the control panel and foot pedal units to the side of the product of which the operation is performed. Refer to "6.2.1. To set the product for gauging side operation" on page 11 and "6.2.2. To set the product for folding side operation" on page 11.

NOTE! Both pedal units must be pressed at the same time during dual operation.

6.3. TO USE THE PEDAL UNIT

The pedal unit has 3 pedals. The left pedal and the middle pedal have 2 different positions. The right pedal has 1 position.



6.3.1. TO USE THE LEFT PEDAL

- Press the pedal down with normal force to position I, to make the clamping beam go down.

NOTE! The clamping beam stops automatically at a set safety stop. Release and press the pedal again to continue the motion until the clamping pressure has been reached.

- Press and hold the pedal down with force to position II, to initiate an emergency stop of the clamping beam.

NOTE! Position II is reached when you hear and feel a click from the pedal. An emergency stop of the clamping beam means that the clamping movement is stopped, and that the clamping beam moves up as long as the pedal is pressed.

6.3.2. TO USE THE MIDDLE PEDAL

- Press the pedal down with normal force to position I, to start the operation of the folding beam.

NOTE! During manual operation the folding beam moves up to fold the metal sheet. Refer to the control system manual for information on manual operation.

- Press and hold the pedal down with force to position II, to initiate an emergency stop of the folding beam.

NOTE! Position II is reached when you hear and feel a click from the pedal. An emergency stop of the folding beam means that the folding movement is stopped, and that the folding beam moves to its initial position. The clamping beam moves up as long as the pedal is pressed.

6.3.3. TO USE THE RIGHT PEDAL

- Press the right pedal with normal force to move the clamping beam up.

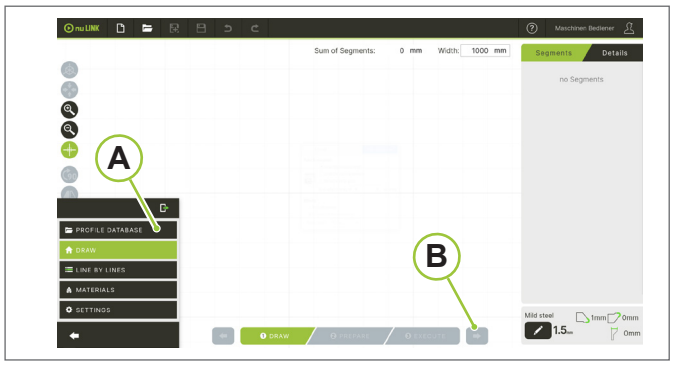
- Press and hold the right foot pedal. The bending beam returns to its starting position, and the clamping beam will move upward until the pedal is released.

NOTE! During manual operation the folding beam moves down to fold the metal sheet. Refer to the control system manual for information on manual operation.

6.4. TO FOLD A SHEET WITH NULINK

WARNING! Read and understand the safety chapter before you use the product. Refer to "3. Safety" on page 8.

1. Start the product. Refer to "6.1. To start the product" on page 10.
2. Select a profile for the folding procedure.
   A. Press the House symbol on the lower left corner on the control system monitor.
   B. Press the Profile Database button (A).



   C. Select the profile for the folding procedure.

NOTE! To create a new profile, refer to the manual for the control system.

3. Press the right arrow (B) to go to Execute mode.
4. Press the Start button (C) to go to Run mode.



5. Start the reference sequence.
   A. Push the left pedal to position I. Refer to "6.3. To use the pedal unit" on page 12 for more information about how to use the pedal unit.
   B. Put the metal sheet on the table.
   C. Push the metal sheet carefully until it reaches the back gauge stops.

WARNING! Keep body parts and objects away from moving parts during the whole folding procedure. Risk of crush injuries.

NOTE! Put a sheet of metal with the same thickness between tools that are not in operation, for best result of the folding procedure.

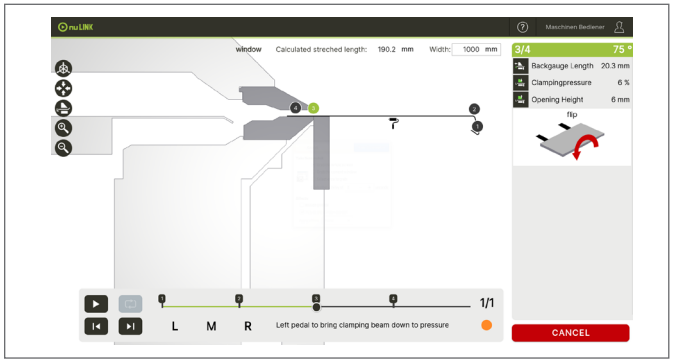
   D. Lower the clamping beam to the 6 mm safety stop.
   E. Make sure again that the metal sheet is against the back gauge stops.
   F. Clamp the metal sheet with the left pedal.

NOTE! The product stops automatically according to the profile program.

   G. Leave the risk area of the product. Refer to "3.6. The risk area" on page 10 for more information about the risk area.
6. Use the middle pedal to fold the metal sheet.

WARNING! Do not hold the metal sheet during the folding procedure.

7. Look at the control system monitor for instructions on how to move the metal sheet during the folding procedure.



NOTE! The folding beam and clamping beam move to their initial positions automatically after the folding procedure is finished.

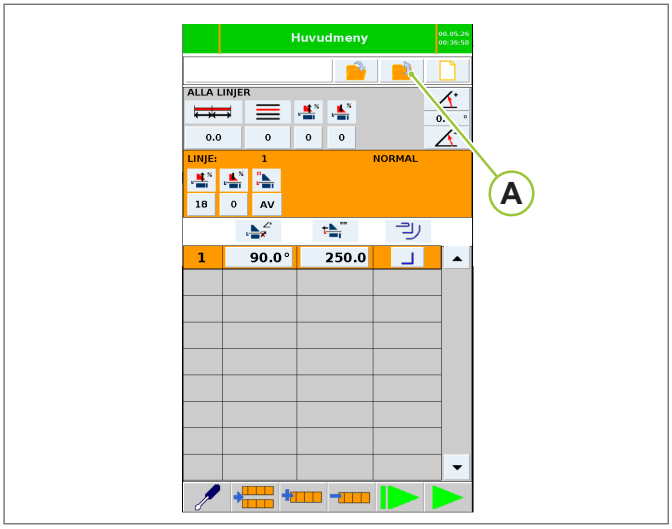
NOTE! For information about error messages on the control system monitor, refer to the control system manual.

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6.5. TO FOLD A SHEET WITH EASYLINK

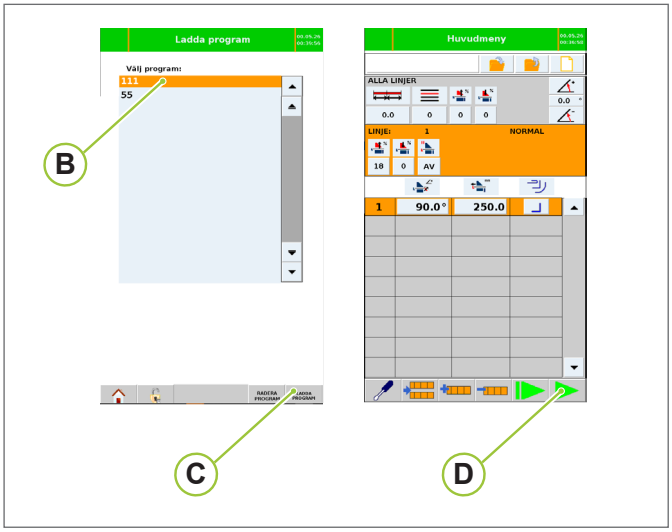
WARNING! Read and understand the safety chapter before you use the product. Refer to "3. Safety" on page 8.

1. Start the product. Refer to "6.1. To start the product" on page 10.
2. Select a program for the folding procedure.
   A. Press the folder Open (A) on the Main menu.



NOTE! To create a new profile, refer to the manual for the control system.

   B. Select a program (B).
   C. Press the button Load program (C).
3. Press the Start button (D).



4. Start the reference sequence.
   A. Push the left pedal to position I. Refer to "6.3. To use the pedal unit" on page 12 for more information about how to use the pedal unit.
   B. Put the metal sheet on the table.
   C. Push the metal sheet carefully until it reaches the back gauge stops.

WARNING! Keep body parts and objects away from moving parts during the whole folding procedure. Risk of crush injuries.

NOTE! Put a sheet of metal with the same thickness between tools that are not in operation, for best result of the folding procedure.

   D. Lower the clamping beam to the 6 mm safety stop.
   E. Make sure again that the metal sheet is against the back gauge stops.
   F. Clamp the metal sheet with the left pedal.

NOTE! The product stops automatically according to the profile program.

   G. Leave the risk area of the product. Refer to "3.6. The risk area" on page 10 for more information about the risk area.
5. Use the middle pedal to fold the metal sheet.

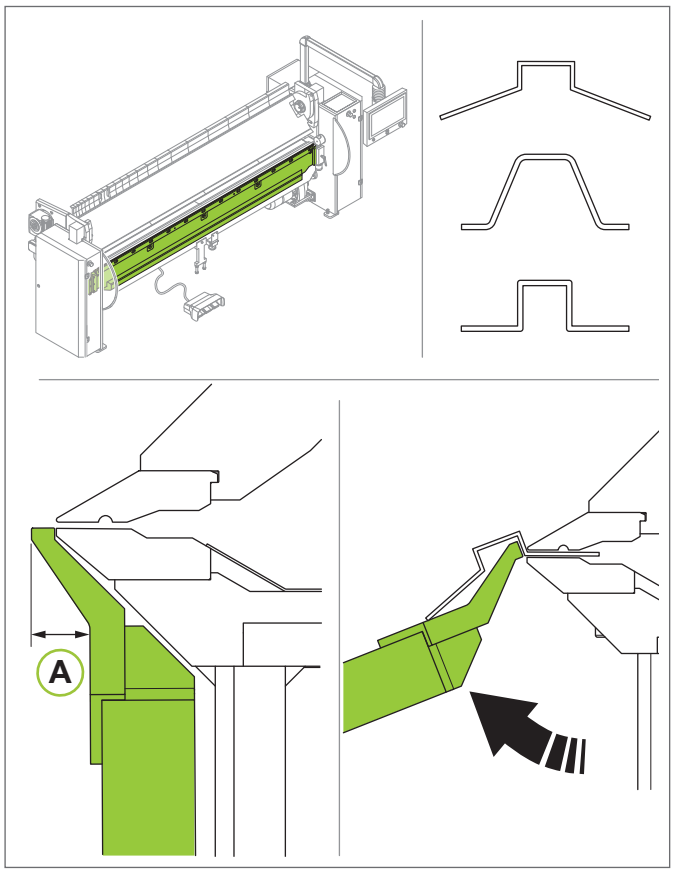
WARNING! Do not hold the metal sheet during the folding procedure.

NOTE! The folding beam and clamping beam move to their initial positions automatically after the folding procedure is finished.

NOTE! For information about error messages on the control system monitor, refer to the control system manual.

6.6. TO FOLD A SHEET WITH XSPACE (OPTIONAL)

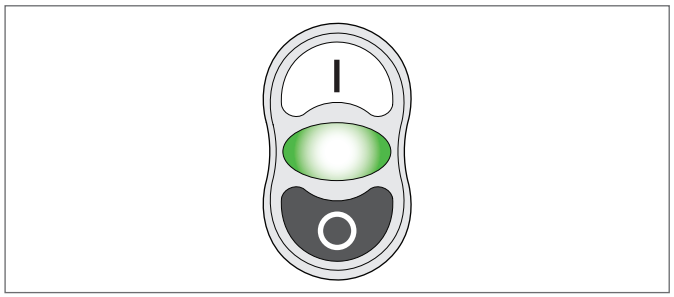
XSPACE is an optional accessory for more complex folding procedures. The XSPACE folding beam and folding tool create extra space (A) below the folding point that gives you the option to fold Z profiles and hat profiles without collision. Refer to "11. Technical data" on page 31 for folding capacity. Speak to CIDAN Machinery for more information.



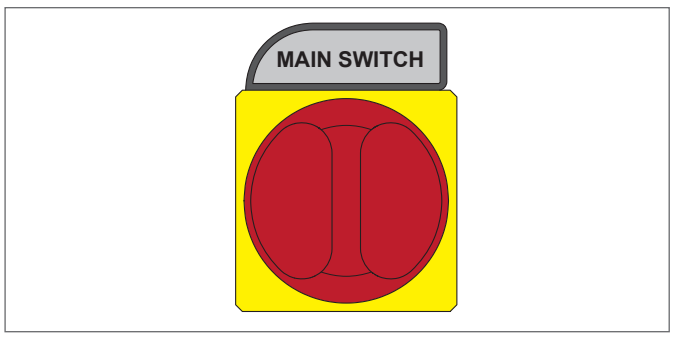
6.7. TO STOP THE PRODUCT

6.7.1. TO STOP THE PRODUCT DURING NORMAL OPERATION

1. Press the red stop button on the electrical cabinet or on the control panel. Refer to "2.4. Product overview" on page 5 for the position of the stop button.



2. Set the main switch to the OFF position. Refer to "2.4. Product overview" on page 5 for the position of the main switch.



6.7.2. TO STOP AND RESET THE PRODUCT IN AN EMERGENCY

1. Press at least 1 of the 3 emergency stop buttons on the product to stop the product in its current position. Refer to "3.2.1. Emergency stop buttons" on page 8 for the location of the emergency stop buttons.

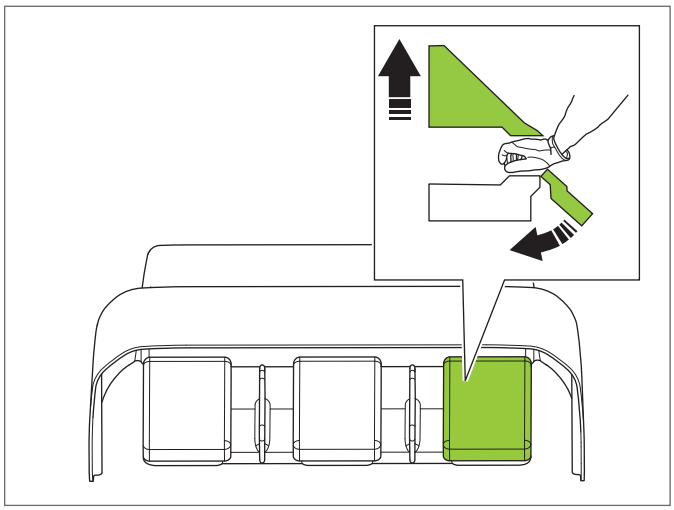
WARNING! When an emergency button is pressed, the product stops in its current position and it is not possible to operate the product.

2. Reset the product.
   A. Make sure that all emergency buttons are set to their original position.
   B. Press the start button on the electrical cabinet or the control panel. Refer to "2.4. Product overview" on page 5 for the location of the start buttons.
   C. Push applicable pedal to position II to release the applicable beam. Refer to "6.3. To use the pedal unit" on page 12.

6.7.3. TO STOP THE PRODUCT IF A CRUSH INJURY OCCURS

WARNING! Do not press the emergency stop buttons if a crush injury occurs.

1. Press and hold the right foot pedal. The bending beam returns to its starting position, and the clamping beam will move upward until the pedal is released.



WARNING! Do not press the wrong pedal, it can cause personal injury or death.

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7. ADJUSTMENTS

7.1. THICKNESS CHART FOR SHEETS AND RAILS

The table shows the smallest rail thickness for the specified sheet thickness.

MATERIAL THICKNESS MILD STEEL 400 N/MM²		<0.028	0.039	0.047	0.051	0.071	0.079	0.098	0.118	INCH
		<0.7	1.0	1.2	1.5	1.8	2.0	2.5	3.0	MM
MODEL	**RAIL THICKNESS**									
F26	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	15 mm (0.591”)	X	X	X	X					
	20 mm (0.787”)	X	X	X	X	X				
	25 mm (0.984”)	X	X	X	X	X				
F32	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	15 mm (0.591”)	X	X	X	X					
	20 mm (0.787”)	X	X	X	X					
	25 mm (0.984”)	X	X	X	X					
F41	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	15 mm (0.591”)	X	X	X						
FS26, FX26	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	12 mm (0.472”)	X	X							
	15 mm (0.591”)	X	X	X	X					
	20 mm (0.787”)	X	X	X	X	X	X			
	25 mm (0.984”)	X	X	X	X	X	X	X		
FS32, FX32	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	15 mm (0.591”)	X	X	X						
	20 mm (0.787”)	X	X	X	X	X	X			
	25 mm (0.984”)	X	X	X	X	X	X			
FS41, FX41	7 mm (0.276”)	X								
	10 mm (0.394”)	X	X							
	15 mm (0.591”)	X	X	X						
	20 mm (0.787”)	X	X	X	X	X	X			
	25 mm (0.984”)	X	X	X	X	X	X			
XSPACE	10 mm (0.394”)	X	X							
	12 mm (0.472”)	X	X							
	25 mm (0.984”)[1]	X	X	X	X	X				

[1]CAUTION! DO NOT EXCEED THE MAXIMUM CAPACITY OF THE PRODUCT.

7.2. TO CHANGE THE FOLDING BEAM RAIL

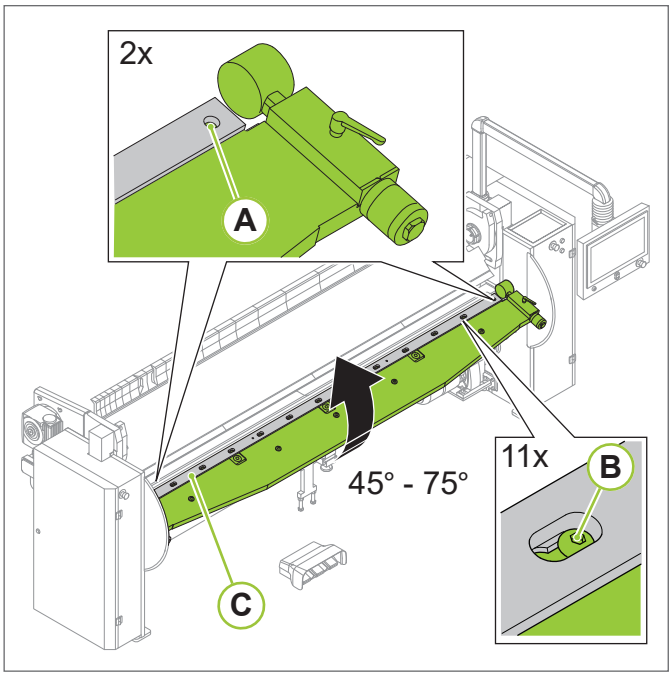
WARNING! Use protective gloves to prevent personal injury from sharp edges, and protective shoes to prevent personal injury from falling objects.

NOTE! Refer to "7.1. Thickness chart for sheets and rails" on page 16 to decide which folding beam rail is necessary for the operation.

1. Set the folding beam rail to 45°-75°.

WARNING! Adjust the folding beam rail to prevent that the bending rail falls and causes personal injury.

2. Remove the locking screws (A) with an 8 mm hex wrench.

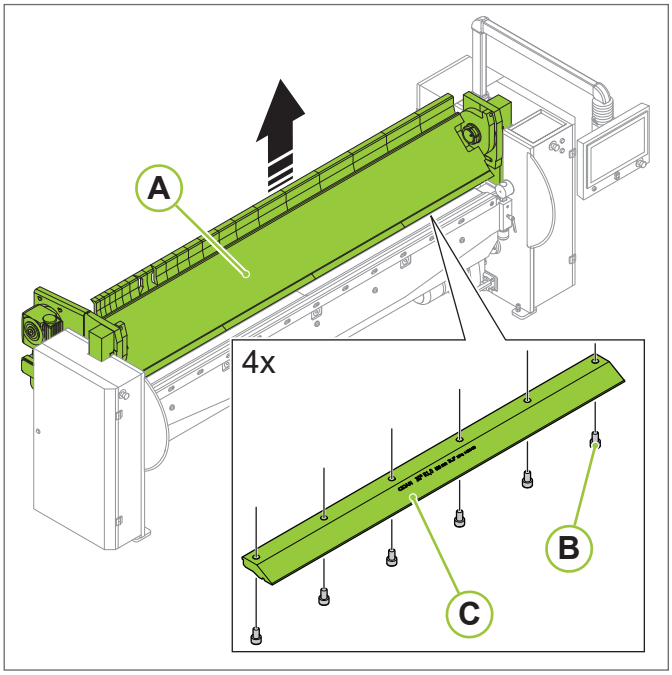


3. Loosen, but do not remove, the mounting screws (B) that hold the bending rail to the folding beam.
4. Move the bending rail (C) to the side and remove it from the folding beam.
5. Install the new bending rail to the mounting screws and move the bending rail to the side to lock it in position.
6. Install the 2 locking screws and tighten them.
7. Tighten the mounting screws.

7.3. TO CHANGE THE STRAIGHT RAIL

WARNING! Use protective gloves to prevent personal injury from sharp edges, and protective shoes to prevent personal injury from falling objects.

1. Move the clamping beam (A) to the highest position. Refer to "2.4. Product overview" on page 5 and "6.3. To use the pedal unit" on page 12.



2. Hold the straight rail segment and remove the mounting screws (B) of the straight rail segment with an 8 mm hex wrench.

WARNING! Hold the rail segment to prevent that it falls and causes personal injury.

4. Remove the rail segment (C).
5. Install the new rail segment and partially attach the mounting screws.

CAUTION! Do not install the mounting screws fully.

6. Tap the rail segment on the contact surface with a plastic hammer and tighten the mounting screws simultaneously.

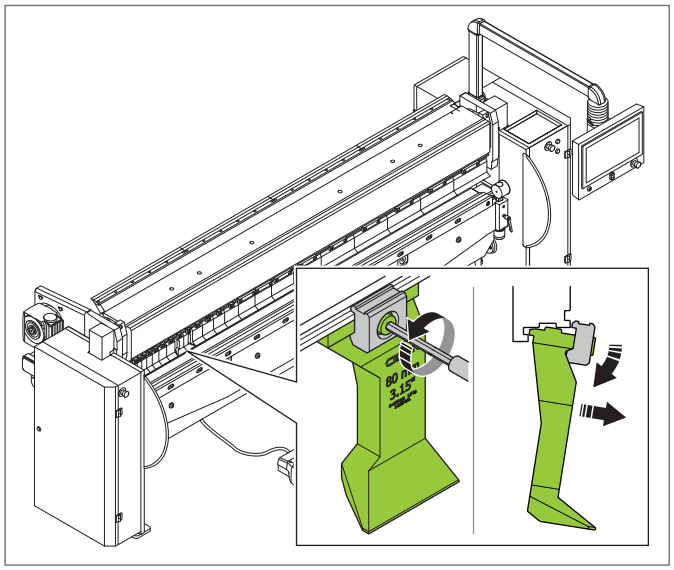
7.4. TO CHANGE THE BOX TOOLS (OPTIONAL)

The control system decides when it is necessary to change combi beam tools, and what combi beam tool should be used. The combi beam automatically stops in its top position when it is necessary to change combi beam tools. The program resumes when the rotation has stopped.

1. Turn the locking screws of the bracket 2,5 turns to loosen them. Use a 5 mm hex wrench.

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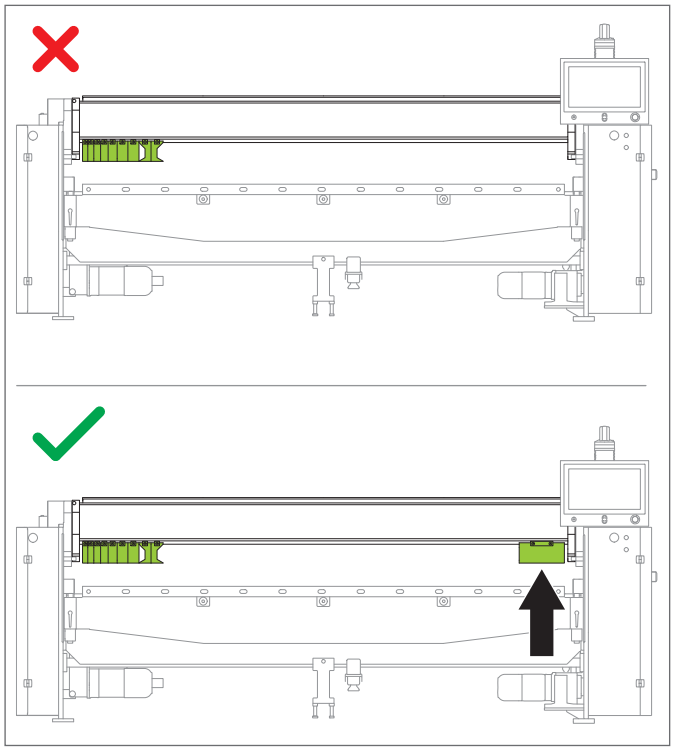
WARNING! Be careful when you loosen the locking screws. Risk of personal injury if the Box tools fall.



2. Push the Box tool down and tilt it away from the clamping beam to move or remove the Box tool.

CAUTION! For folding procedures done on short metal sheets, Box tools must be left on each end of the combi beam, to prevent skewed load of the product.

CAUTION! Do not install the Box tools further out than the normal working width of the product.

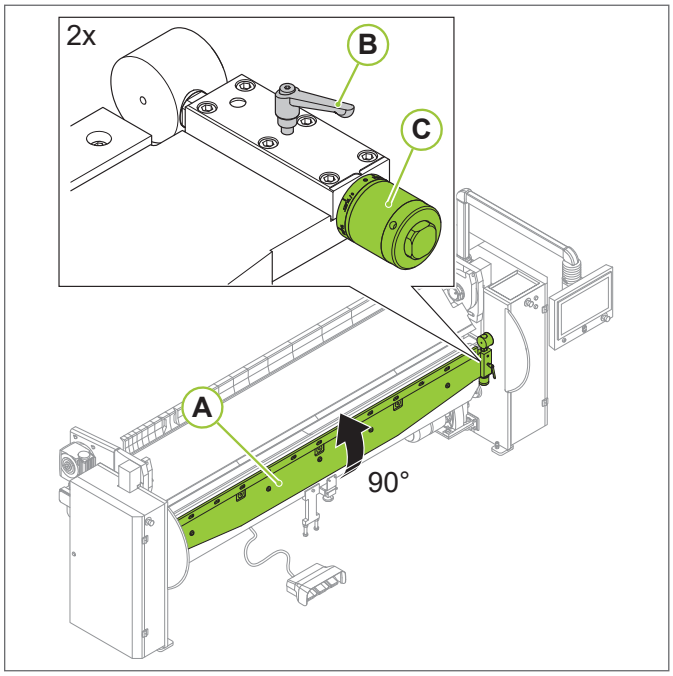


3. If it is necessary, install a new Box tool.
4. Tighten the locking screws to the bracket. Use a 5 mm hex wrench.

7.5. TO ADJUST THE FOLDING BEAM TO THE SHEET THICKNESS

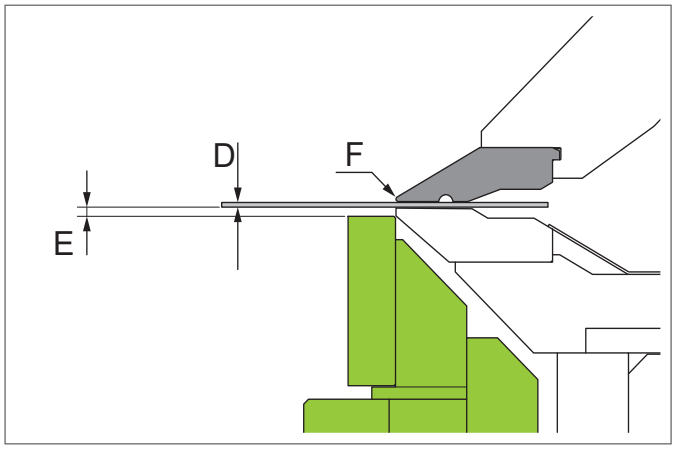
NOTE! This instruction is not applicable to PLUS products.

1. Position the folding beam (A) to 90° to relieve the weight.



2. Loosen the handles (B).
3. Turn the adjusting nuts (C) on both sides of the folding beam to set the correct sheet thickness.

CAUTION! The upper edge of the folding tool to the upper edge of the lower rail must be at least the sheet thickness (D) during folding operations up to 90°. During folding operations over 90°, increase the dimension (E) with regards to the radius (F) of the straight rail.

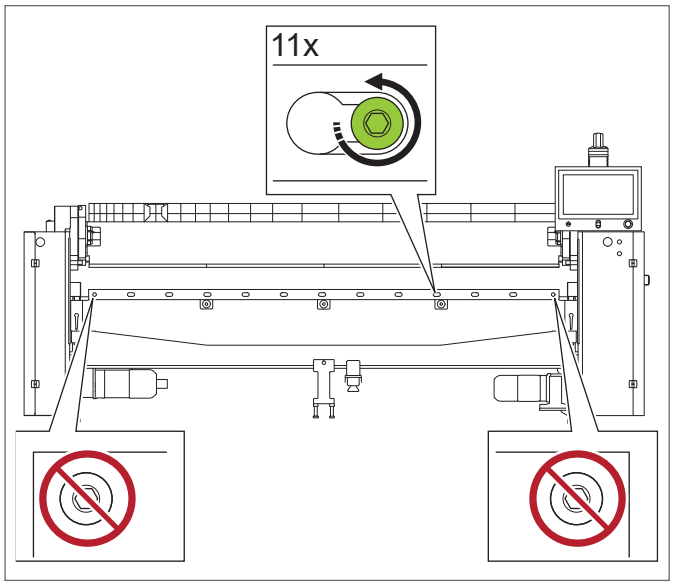


4. Set the folding beam to the vertical position.
5. Make sure that the folding beam touches the adjusting nuts.
6. Tighten the handles (B).

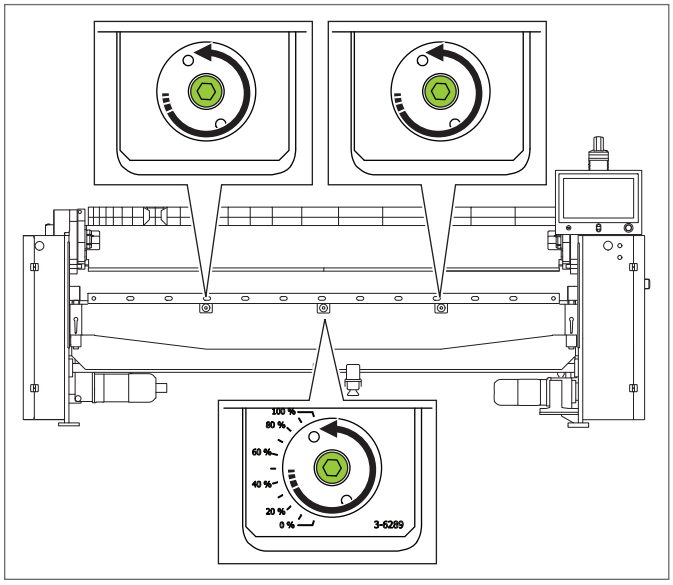
7.6. TO SET THE MANUAL CROWNING

The folding beam rail has manual crowning installed with eccentrics on the front side of the folding beam.

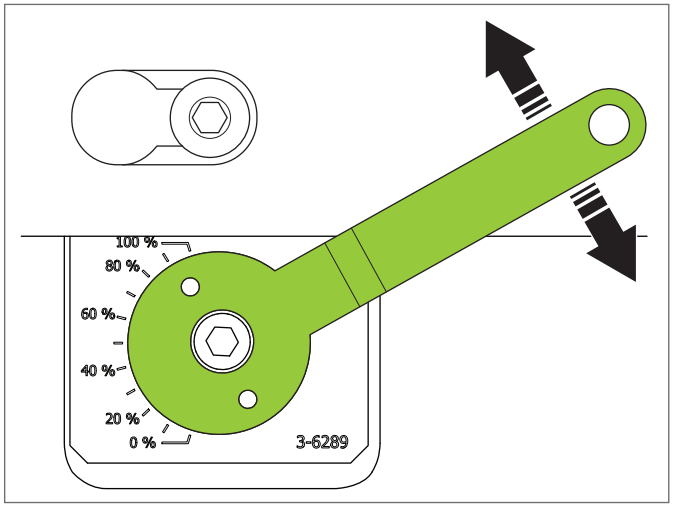
1. Loosen all screws on the front beam rail except the outermost screws on each end. Use an 8 mm hex wrench.



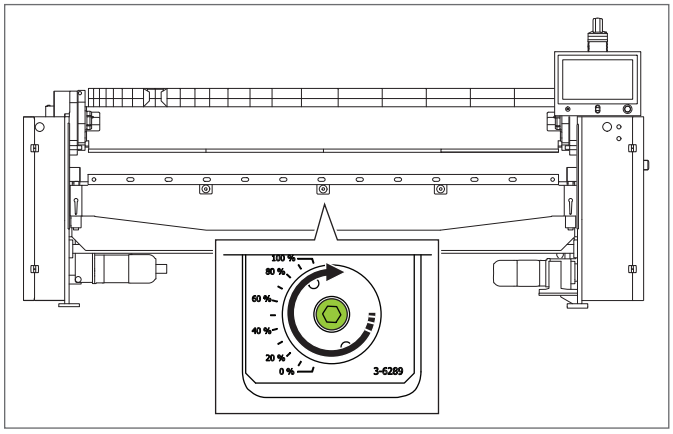
2. Loosen the screws in the middle on all of the eccentrics. Use an 8 mm hex wrench.



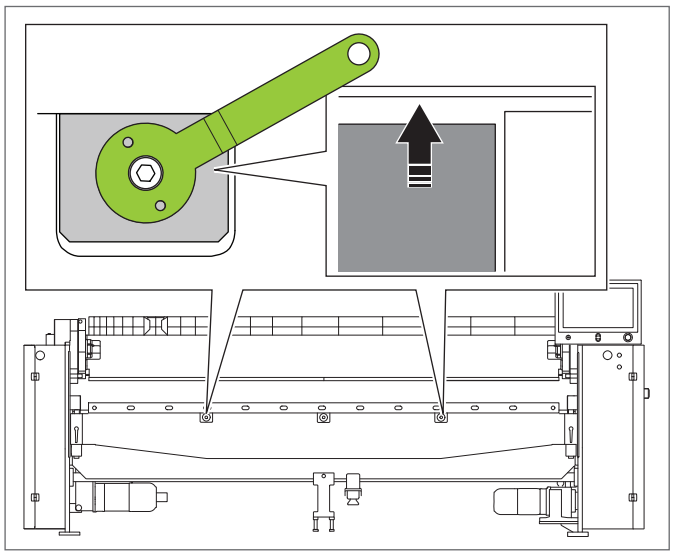
3. Loosen the tension on all eccentrics with the provided tool.
4. Adjust the manual crowning with the tool.



5. Tighten the screw on the middle eccentric.

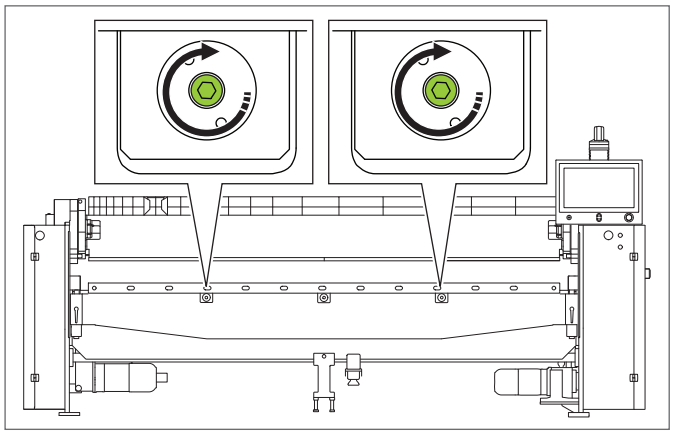


6. Turn the other eccentrics to touch the rail without force.

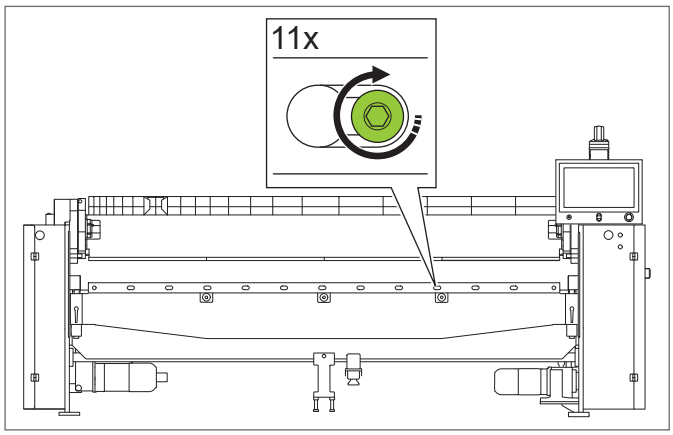


NOTE! These eccentrics operate as support.

7. Tighten the screws for each eccentric.



8. Tighten all rail screws.



8. MAINTENANCE

8.1. TO PREPARE FOR MAINTENANCE

WARNING! Read and understand the safety chapter before you do maintenance on the product.

Do the safety procedures that follow before you do maintenance on the product.

1. Set the main switch to OFF to stop the power supply to the product.
2. Disconnect the incoming air supply to vent the pneumatic system.
3. If repairs or service are necessary, speak to CIDAN Machinery for support.

8.2. MAINTENANCE SCHEDULE

NOTE! Order an annual product inspection to keep the warranty during the first 24 months of the life cycle of the product. Further annual inspections are also recommended to keep optimal performance. Speak to CIDAN Machinery for more information.

ACTION	EACH DAY	EACH WEEK	EACH MONTH	EACH 160 HOURS	EACH 3 MONTHS	EACH 500 HOURS	EACH 6 MONTHS	EACH YEAR
Clean around the product and back gauge	X							
Do a check of the emergency stop buttons			X					X*
Do a check of the floor scanner	X							
Do an inspection of the pedal unit	X							X*
Do maintenance on the pneumatic valve							X	X*
Do an inspection of the pans of the back gauge					X			
Do an inspection of the cables and hoses under the back gauge					X			
Lubricate the eccentric drive gearwheel				X				
Lubricate the drive shafts, main bearings, combi rotation and chains.						X		
PLUS models: lubricate folding beam main bearing		X						
Clean and lubricate the linear guides and ball screw.								X
Do a check of the main switch			X					X*
Do a check of the start button			X					X*
Do a check of the pedal unit cable	X							X*
Do an inspection of the cooling fan and filter					X			X*
Do a functional test of the folding procedure	X							X*
Do maintenance on the mechanical cabinets								X*
Make sure that the product is level								X*
Level the back gauge								X*
Do a check of the parallellalism of the back gauge								X*

*** Done by CIDAN Machinery during annual inspection.**

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8.3. TO CLEAN AROUND THE PRODUCT

1. Make sure that there are no objects or tools left on the product or in the risk area.
2. Make sure that it is not possible to slip or fall around the product.
3. Clean the floor around the product and any other area that has dust or dirt.
4. Clean the back gauge from dirt and dust with a lint-free cloth. Refer to "2.4. Product overview" on page 5 for the position of the back gauge.
5. Make sure that safety signs and risk area markings on the floor are not damaged. For replacement of safety signs, speak to CIDAN Machinery.

8.4. TO DO AN INSPECTION OF THE EMERGENCY STOP BUTTONS

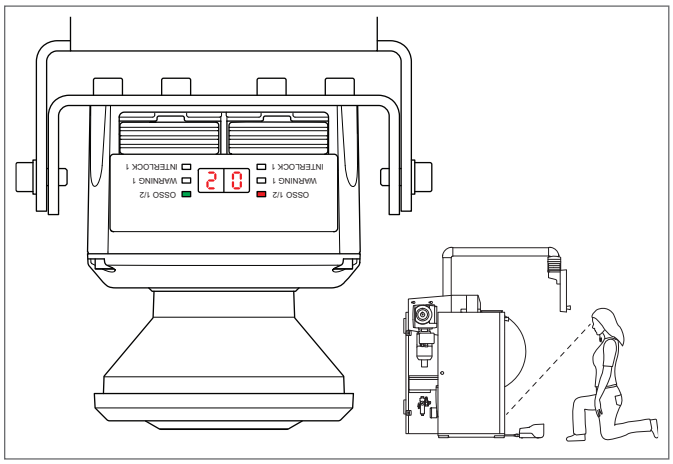
NOTE! Repeat this procedure for each emergency stop button on the product.

1. Start the product. Refer to "6.1. To start the product" on page 10.
2. Push the emergency stop button. Refer to "2.4. Product overview" on page 5 for the location of each emergency stop button.
3. Make sure that an alarm has appeared on the screen of the control system.
4. Turn the emergency stop button clockwise to deactivate it.

8.5. TO DO AN INSPECTION OF THE FLOOR SCANNER

1. Make sure that no person or object is in the risk area of the product. Refer to "3.6. The risk area" on page 10.
2. Start the product. Refer to "6.1. To start the product" on page 10.
3. Make sure that the light of the floor scanner is green. Refer to "2.4. Product overview" on page 5 for the location of the floor scanner.

CAUTION! If the light is red and there is no person or object in the risk area, the product does not operate correctly. Speak to CIDAN Machinery for support.



4. Move into the risk area and make sure the light goes red.

8.6. TO DO AN INSPECTION OF THE PEDAL UNIT

1. Start the product. Refer to "6.1. To start the product" on page 10.
2. Set the control system to the run menu. Refer to the control system manual.
3. Press the left pedal to position I and make sure that the clamping beam moves down.
4. Press the left pedal to position II and make sure that the clamping beam moves up.
5. Press the left pedal to position I until the clamping beam reaches the safety stop.
6. Press the left pedal to position I again until the clamping pressure has been reached.
7. Press the middle pedal to position I and make sure that the folding procedure is done.
8. During the folding procedure, press the middle pedal to position II and make sure that the folding beam stops and moves to its initial position, and that the clamping beam moves up for as long as you press the pedal.
9. Press the right pedal and make sure that the clamping beam moves up for as long as you press the pedal.

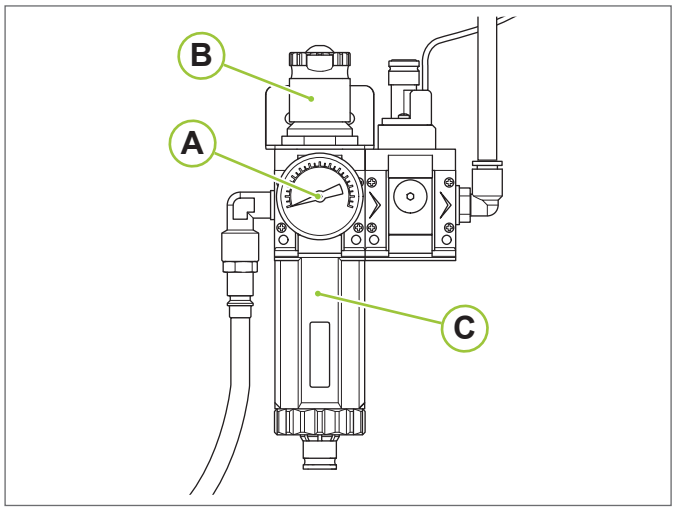
WARNING! If the pedals do not operate as expected, stop the product and disconnect the power supply. Speak to CIDAN Machinery for support.

8.7. TO DO A FUNCTIONAL TEST OF THE FOLDING PROCEDURE

Follow the procedure "6.4. To fold a sheet with nuLink" on page 13 or "6.5. To fold a sheet with EasyLink" on page 14 to do the functional test. If the product does not operate correctly, speak to CIDAN Machinery for support.

8.8. TO DO MAINTENANCE ON THE PNEUMATIC VALVE

1. Inspect the pressure that shows on the manometer (A) at the filter regulator. The pressure should show 6 bar/87 psi. If the pressure is incorrect, adjust the pressure as follows:



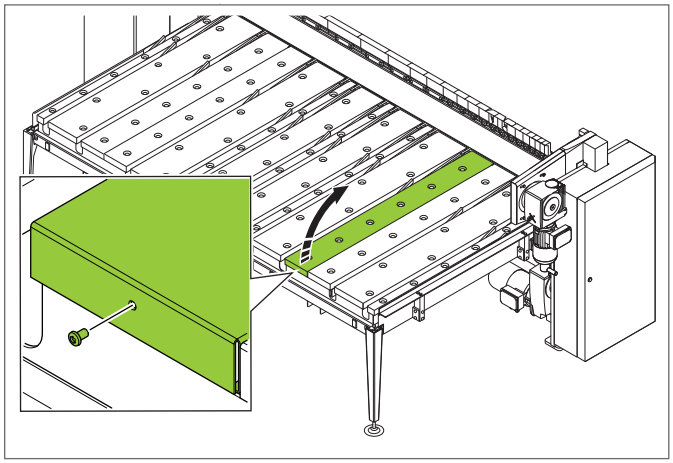
   A. Pull the adjustment knob (B) up to unlock it.
   B. Rotate the adjustment knob until the correct value shows in the manometer.
   C. Push the adjustment knob down to lock it.
2. Clean the cup (C) under the pneumatic valve.
   A. Depressurize the pneumatic system.
   B. Turn the lower part of the pneumatic valve counterclockwise to remove it.
   C. Remove and clean the cup under the pneumatic valve.

CAUTION! If there is water in the cup, it could mean that there is a problem that can cause product failure. Speak to CIDAN Machinery for support.

   D. Install the cup and the lower part. Turn the lower part clockwise.

8.9. TO DO AN INSPECTION OF THE PANS OF THE BACK GAUGE

1. Remove the screws from the pan with a Torx 30 key.



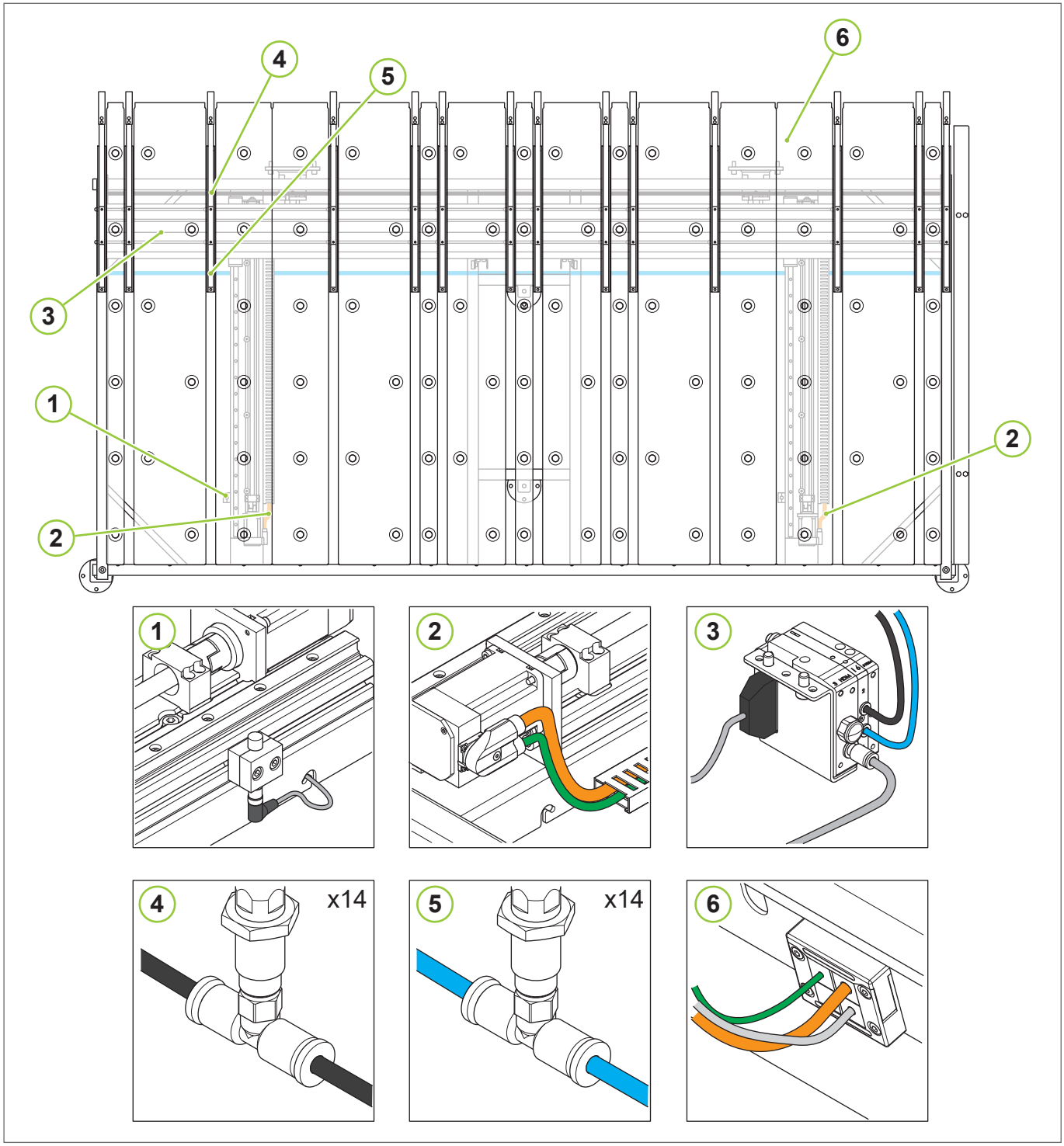
2. Lift each pan and inspect the pan for damage and deformation. Replace pans if it is necessary.
3. Install each pan and attach the screw.

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8.10. TO INSPECT THE CABLES AND HOSES UNDER THE BACK GAUGE

Refer to the overview illustration that follows for the location of cables and hoses connected to the back gauge.

1. Remove the pans. Refer to "8.9. To do an inspection of the pans of the back gauge" on page 23.
2. Make sure that there is no damage, discolor or burned cables or hoses.
3. Make sure that cables and hoses do not get caught in moving parts of the product.
4. Make sure that all cables and hoses are connected.



8.11. LUBRICATION

8.11.1. TO LUBRICATE PRODUCT PARTS

1. Make sure that the product is stopped and the power is off before you lubricate the parts. Refer to "6.7. To stop the product" on page 15.
2. Use food grade lubricant Mobil SHC Polyrex 462 or equivalent for all lubrication parts.
3. Use Mobil SHC Polyrex 462 or equivalent chain spray for all chains.

8.11.2. TO LUBRICATE THE FOLDING BEAM MAIN BEARING ON PLUS MODELS

NOTE! To lubricate the folding beam main bearing on the PLUS models, the product must be in operation for parts the procedure. Refer to point 11 under "8.11.3. Lubrication points overview" on page 25 to locate the lubrication point.

1. Make sure the product operates.
2. Start a program in Line-by-Line.
3. Make the folding beam go slowly up to a 90-degree angle with the Jog function. Refer to the nuLink manual for details.
4. Press the emergency stop button on the electrical cabinet or on the control panel to stop the product fully so that it cannot operate during lubrication.



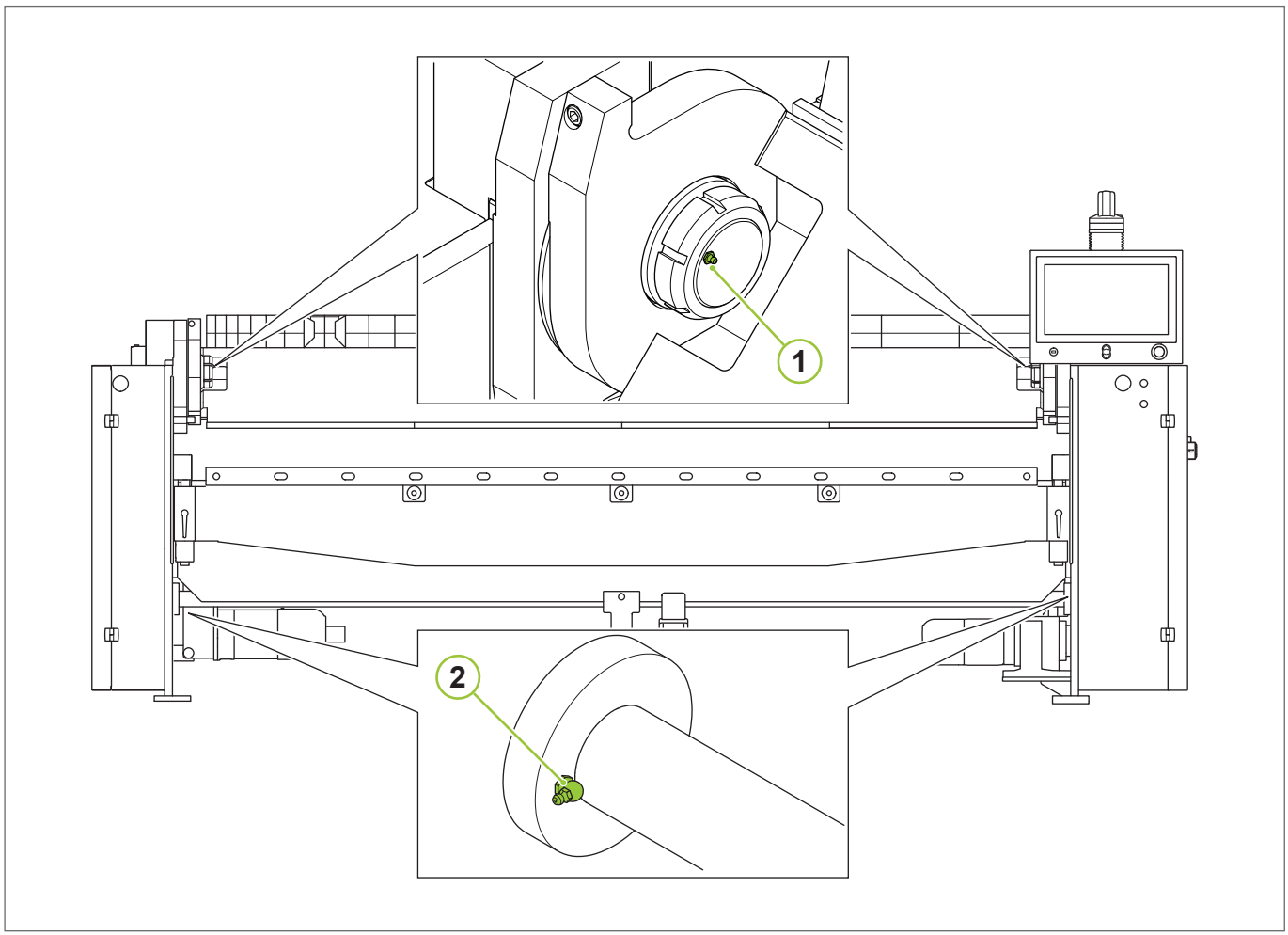
WARNING! Risk for personal injury if the product is in operation when lubricating.

5. Open the side stands on the left side and right side.
6. Apply lubricant to the folding beam main bearing on both sides until all joints are lubricated.
7. Close the side stands on the left side and right side.
8. Start the product and reset the emergency stop button. Follow the prompts on the display touch screen to make the folding beam go slowly down into normal position.
9. Stop the program.
10. Stop the product.

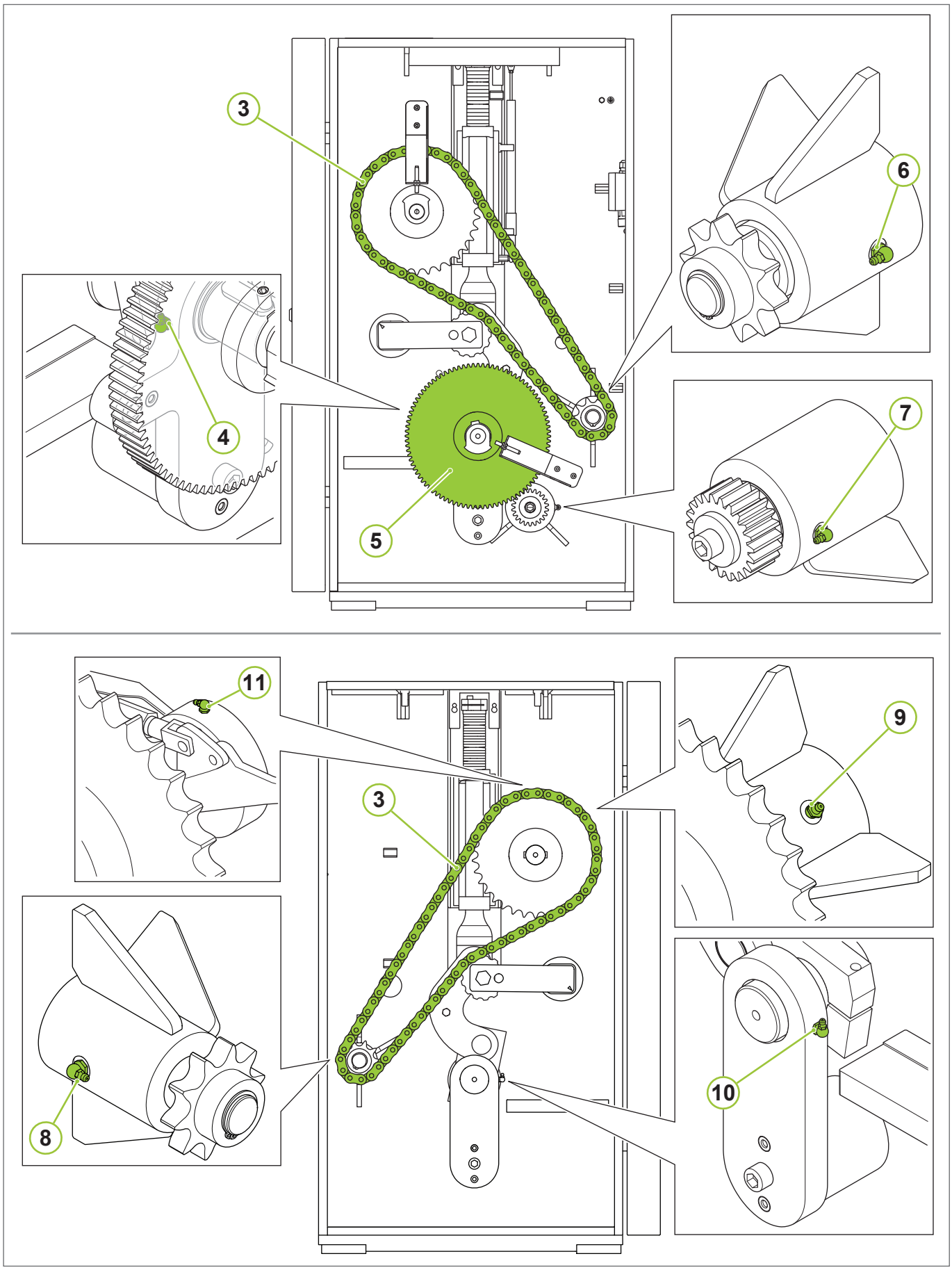
8.11.3. LUBRICATION POINTS OVERVIEW

Refer to the overviews that follow to locate each lubrication point of the product. Refer to "8.11.4. Lubrication intervals" on page 28 for the correct lubrication interval.

1. Combi rotation
2. Inner eccentric drive shaft
3. Chains
4. Outer eccentric drive shaft
5. Eccentric drive gearwheel
6. Folding beam drive shaft
7. Eccentric drive main bearing
8. Folding beam drive shaft
9. Folding beam main bearing
10. Outer eccentric drive shaft
11. PLUS models: Folding beam main bearing


1
2

EN



8.11.4. LUBRICATION INTERVALS

POINT NUMBER	LUBRICATION POINT	FS, FX	F	LEFT SIDE	RIGHT SIDE	MOBIL SHC POLYREX 462	CHAIN OIL	EACH HOURS
1	Combi rotation	X		1 point	1 point	X		500
2	Inner eccentic drive shaft	X	X	1 point	1 point	X		500
3	Chains	X	X	1 point	1 point	X	X	500
4	Outer eccentric drive shaft	X	X	1 point	1 point	X		500
5	Eccentric drive gearwheel	X	X		1 point	X		160
6	Folding beam drive shaft	X	X	1 point	1 point	X		500
7	Eccentric drive main bearing	X	X		1 point	X		500
8	Folding beam drive shaft	X	X	1 point	1 point	X		500
9	Folding beam main bearing	X	X	1 point	1 point	X		500
10	Outer eccentric drive shaft	X	X	1 point	1 point	X		500
11	PLUS models: Folding beam main bearing	X		1 point	1 point	X		50

NOTE! Lubrication point 11 has frequent lubrication intervals.

8.12. TO DO MAINTENANCE ON THE ELECTRICAL SYSTEM

8.12.1. TO DO AN INSPECTION OF THE MAIN SWITCH

1. Set the main switch to the ON position and make sure that the power supply is on. Refer to "2.4. Product overview" on page 5 for the location of the main switch.
2. Set the main switch to the OFF position and make sure that the power supply is off.
3. Open the electrical cabinet and make sure that no parts are damaged or loose.

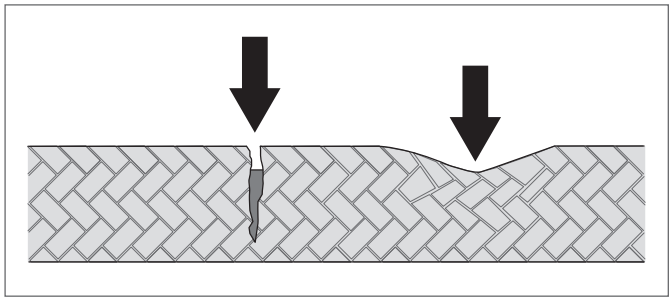
8.12.2. TO DO AN INSPECTION OF THE START BUTTON

1. Set the main switch to the ON position. Refer to "2.4. Product overview" on page 5 for the position of the main switch.
2. Make sure that the emergency stop buttons are not activated.
3. Press the start button and make sure that the product starts. Refer to "2.4. Product overview" on page 5 for the position of the start button.

8.12.3. TO DO AN INSPECTION OF THE PEDAL UNIT CABLE

1. Use a lint-free cloth to clean the pedal unit cable from dirt and dust.
2. Do an inspection of the pedal unit cable for damage or deformation.

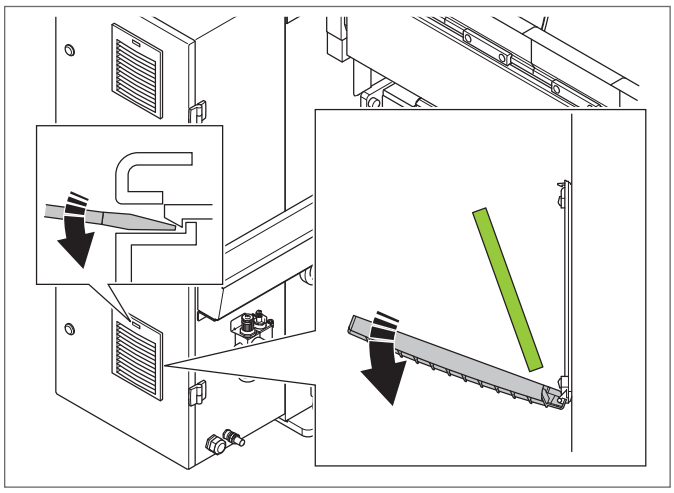
CAUTION! Do not use a product with a damaged pedal unit cable.



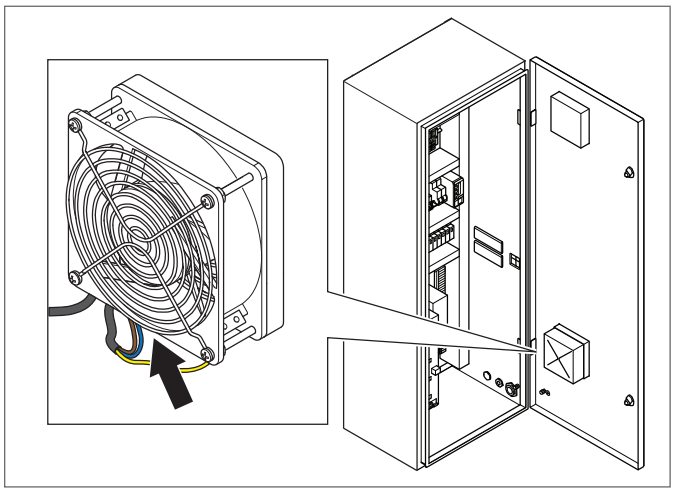
3. Replace the cable if it is necessary.

8.12.4. TO DO AN INSPECTION OF THE COOLING FAN AND FILTER

1. Use a flathead screwdriver to bend down the locking tap on the filter frame.



2. Open the filter frame.
3. Replace the filter.
4. Close the filter frame.
5. Open the electrical cabinet.
6. Inspect the cable fitting to the cooling fan for damage.



CAUTION! Replace the cable if it is burnt or smells burnt.

9. DISPOSAL

9.1. TO DISCARD THE PRODUCT

Discard the product according to local regulations.

10. TROUBLESHOOTING

Speak to CIDAN Machinery if the product shows signs of malfunction or damage, or if a maintenance inspection is not approved.



WARNING! Do not use a product that is damaged or has a malfunction.

11. TECHNICAL DATA

		F26	F32	F32 (US)	F41
Weight kg/lb		2502/5516	2898/6388	3366/7421	4100/9839
Weight back gauge, kg/lb	BASIC	203/448	232/511	232/511	276/608
	FLEXIBLE	338/475	380/838	380/838	548/1208
Working length, mm/in.		2600/102	3200/126	3200/126	4100/161
Folding capacity, standard folding beam	Steel, mm/in. [1]	1.75/0.07	1.5/0.06	1.5/0.06	1.25/0.05
	Stainless steel, mm/in. [2]	1.1/0.04	0.9/0.04	0.9/0.04	0.8/0.03
	Aluminum, mm/in. [3]	2.6/0.1	2.2/0.09	2.2/0.09	2.0/0.08
Folding capacity, XSPACE folding beam	Steel, mm/in. [1]	1.75/0.07	1.5/0.06	1.5/0.06	1.25/0.05
	Stainless steel, mm/in. [2]	1.1/0.04	0.9/0.04	0.9/0.04	0.8/0.03
	Aluminum, mm/in. [3]	2.6/0.1	2.2/0.09	2.2/0.09	2.0/0.08
Measurements	Length, mm/in.	3658/144	4258/168	4258/168	5158/203
	Depth, mm/in. [4]	1871/74	1871/74	1871/74	1871/74 [4]
	Height, mm/in.	1955/77	1955/77	1955/77	1955/77
Opening height, clamping beam, mm/in.		150/6	150/6	150/6	150/6
Motor clamping beam, kW		0.75	0.75	1.5	1.5
Motor folding beam, kW		1.1	1.1	1.1	2.2
Maximum pressure, kN		100	100	140	100
Air pressure, bar		6	6	6	6
Voltage, 3-phase, 50 Hz, V		400	400	230 (60 Hz)	400
Fuse, A	EasyLink	16	16	-	16
	nuLink	20	20	16	20

1 Ultimate tensile strength 400 N/mm²/400 MPa
2 Ultimate tensile strength 600 N/mm²/600 MPa
3 Ultimate tensile strength 200 N/mm²/200 MPa
4 With motor-driven 1050 mm BASIC back gauge
5 With motor-driven 1550 mm FLEXIBLE back gauge

		FS26	FS32	FS41
Weight kg/lb		2950/6504	3393/7480	4100/9039
Weight back gauge, kg/lb	BASIC	203/448	232/511	276/608
	FLEXIBLE	338/475	380/838	548/1208
Working length, mm/in.		2600/102	3200/126	4100/161
Folding capacity, standard folding beam	Steel, mm/in. [1]	2.5/1	2.0/0.08	2.0/0.08
	Stainless steel, mm/in. [2]	1.6/0.06	1.2/0.05	1.2/0.05
	Aluminum, mm/in. [2]	3.7/0.1	3.0/0.1	3.0/0.1
Folding capacity, XSPACE folding beam	Steel, mm/in. [1]	2.0/0.08	1.5/0.06	1.5/0.06
	Stainless steel, mm/in. [2]	1.2/0.05	1.0/0.04	1.0/0.04
	Aluminum, mm/in. [2]	3.0/0.1	2.25/0.09	2.25/0.09
Measurements	Length, mm/in.	3645/144	4195/166	5145/203
	Depth, mm/in. [5]	2215/88	2215/88	2215/88
	Height, mm/in.	1955/77	1955/77	1955/77
Opening height, clamping beam, mm/in.		150/6	150/6	150/6
Motor clamping beam, kW		1.5	1.5	1.5
Motor folding beam, kW	EasyLink	1.5	1.5	-
	nuLink	2.2	2.2	2.2
Maximum pressure, kN		140	140	140
Air pressure, bar		6	6	6
Voltage, 3-phase, 50 Hz, V		400	400	400
Fuse, A	EasyLink	16	16	16
	nuLink	20	20	20

1 Ultimate tensile strength 400 N/mm²/400 MPa
2 Ultimate tensile strength 600 N/mm²/600 MPa
3 Ultimate tensile strength 200 N/mm²/200 MPa
4 With motor-driven 1050 mm BASIC back gauge
5 With motor-driven 1550 mm FLEXIBLE back gauge

		FS26 PLUS	FS32 PLUS	FS41 PLUS
Weight kg/lb		3260/7187	3487/7688	4166/9185
Weight back gauge, kg/lb	BASIC	203/448	232/511	276/608
	FLEXIBLE	338/475	380/838	548/1208
Working length, mm/in.		2600/102	3200/126	4100/161
Folding capacity	Steel, mm/in. [1]	2.5/1	2.0/0.08	2.0/0.08
	Stainless steel, mm/in. [2]	1.6/0.06	1.2/0.05	1.2/0.05
	Aluminum, mm/in. [3]	3.7/0.1	3.0/0.1	3.0/0.1
Measurements	Length, mm/in.	3645/144	4195/166	5145/203
	Depth, mm/in. [5]	2215/88	2215/88	2215/88
	Height, mm/in.	1955/77	1955/77	1955/77
Opening height, clamping beam, mm/in.		150/6	150/6	150/6
Motor clamping beam, kW		1.5	1.5	1.5
Motor folding beam, kW		2.2	2.2	2.2
Maximum pressure, kN		140	140	140
Air pressure, bar		6	6	6
Voltage, 3-phase, 50 Hz, V		400	400	400
Fuse, A		20	20	20

1 Ultimate tensile strength 400 N/mm^2/400 MPa
2 Ultimate tensile strength 600 N/mm^2/600 MPa
3 Ultimate tensile strength 200 N/mm^2/200 MPa
4 With motor-driven 1050 mm BASIC back gauge
5 With motor-driven 1550 mm FLEXIBLE back gauge

		FX26	FX32	FX41
Weight kg/lb		3180/7011	3648/8042	4434/9775
Weight back gauge, kg/lb	BASIC	203/448	232/511	276/608
	FLEXIBLE	338/475	380/838	548/1208
Working length, mm/in.		2600/102	3200/126	4100/161
Folding capacity, standard folding beam	Steel, mm/in. [1]	2.5/1	2.0/0.08	2.0/0.08
	Stainless steel, mm/in. [2]	1.6/0.06	1.2/0.05	1.2/0.05
	Aluminum, mm/in. [3]	3.7/0.1	3.0/0.1	3.0/0.1
Folding capacity, XSPACE folding beam	Steel, mm/in. [1]	2.0/0.08	1.5/0.06	1.5/0.06
	Stainless steel, mm/in. [2]	1.2/0.05	1.0/0.04	1.0/0.04
	Aluminum, mm/in. [3]	3.0/0.1	2.25/0.09	2.25/0.09
Measurements	Length, mm/in.	3645/144	4195/166	5145/203
	Depth, mm/in. [5]	2215/88	2215/88	2215/88
	Height, mm/in.	1955/77	1955/77	1955/77
Opening height, clamping beam, mm/in.		150/6	150/6	150/6
Motor clamping beam, kW		1.5	1.5	1.5
Motor folding beam, kW	EasyLink	1.5	1.5	-
	nuLink	2.2	2.2	2.2
Maximum pressure, kN		140	140	140
Air pressure, bar		6	6	6
Voltage, 3-phase, 50 Hz, V		400	400	400
Fuse, A	EasyLink	16	16	16
	nuLink	20	20	20

1 Ultimate tensile strength 400 N/mm^2/400 MPa
2 Ultimate tensile strength 600 N/mm^2/600 MPa
3 Ultimate tensile strength 200 N/mm^2/200 MPa
4 With motor-driven 1050 mm BASIC back gauge
5 With motor-driven 1550 mm FLEXIBLE back gauge

		FX26 PLUS	FX32 PLUS	FX41 PLUS
Weight kg/lb		3260/7187	3742/8250	4500/9921
Weight back gauge, kg/lb	BASIC	203/448	232/511	276/608
	FLEXIBLE	338/475	380/838	548/1208
Working length, mm/in.		2600/102	3200/126	4100/161
Folding capacity	Steel, mm/in. [1]	2.5/1	2.0/0.08	2.0/0.08
	Stainless steel, mm/in. [2]	1.6/0.06	1.2/0.05	1.2/0.05
	Aluminum, mm/in. [3]	3.7/0.1	3.0/0.1	3.0/0.1
Measurements	Length, mm/in.	3645/144	4195/166	5145/203
	Depth, mm/in. [5]	2215/88	2215/88	2215/88
	Height, mm/in.	1955/77	1955/77	1955/77
Opening height, clamping beam, mm/in.		150/6	150/6	150/6
Motor clamping beam, kW		1.5	1.5	1.5
Motor folding beam, kW		2.2	2.2	2.2
Maximum pressure, kN		140	140	140
Air pressure, bar		6	6	6
Voltage, 3-phase, 50 Hz, V		400	400	400
Fuse, A		20	20	20

1 Ultimate tensile strength 400 N/mm^2/400 MPa
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EN

12. ACCESSORIES

12.1. BOX TOOLS

MODEL	MM/ IN.	35 1.38"	40 1.57"	45 1.77"	50 1.97"	60 2.36"	70 2.76"	75 2.95"
FX26	2600/ 102.4	1	1	1	1	1	1	1
FX32	3200/ 126	1	1	1	1	1	1	1
FX41	4100/ 161.4	1	1	1	1	1	1	1

MODEL	MM/ IN.	80L 3.15"	80R 3.15"	90 3.54"	100 3.94"	125 4.92"	150 5.91"	200 7.87"	250 9.84"	300 11.8"
FX26	2600/ 102.4	1	1	1	2	1	2	1	1	3
FX32	3200/ 126	1	1	1	2	1	2	1	1	5
FX41	4100/ 161.4	1	1	1	2	1	2	1	1	8

NOTE! A tool 200 mm/7.87 in. long weighs 5.3 kg/11.7 lbs.

12.2. SPARE PARTS

For applicable spare parts, speak to CIDAN Machinery.

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CIDAN MACHINERY GROUP

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