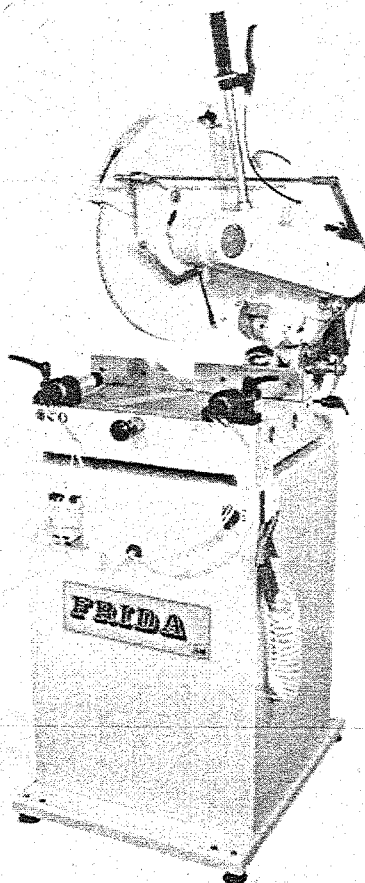





**FRIDA**



**INSTRUCTION MANUAL**

ENGLISH

	Cutting off machine mod. <b>FRIDA</b>	REV. 00
	Instructions for maintenance and use	Date 30/05/2005

## 1 GENERAL INFORMATION

The firm LGF will not be responsible for eventual damages caused by a wrong use of the machine deriving from:

- use for functions which are not described in this hand-book;
- bad or wrong maintenance;
- repairs which are not described in this hand-book;
- use of the machine in explosive places.


**This machine was designed and built exclusively for working aluminium and must be used according to Chapter 1.2.1. Any other use different from what described is forbidden and involves some risks.**

For any necessity or direction, apply to the nearest dealer or to the manufacturer

Dealer:

Fabricator:

LGF s.n.c.  
Via Togliatti, 81  
47827-VILLA VERUCCHIO -ITALY  
Tel.0541/677315 - Fax.0541/678752  
Int. web site: [www.lgf.it](http://www.lgf.it)  
e-mail: [info@lgf.it](mailto:info@lgf.it)

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### **MACHINE'S CONFORMITY**

#### **Declaration of conformity**

The company **L.G.F. s.n.c.**  
Via Togliatti, 81  
47826 - VILLA VERUCCHIO - ITALY  
Tel. 0541/677315 - Fax. 0541/678752


declare on its own responsibility that the cutting off machine mod. **FRIDA** with no. ....to which this declaration refers, is in conformity with the safety rules foreseen by the EEC Directives no. 89/392, 91/368 & 93/44, 73/23, 93/68-89/336, and it has been built respecting the following armonized rules: EN 292-1, EN 292-2 & EN 60204-1, EN 294, EN349, EN 418.

Date

**L. G. F. s.n.c**


Signature

Canuti Luciano

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## 2 GENERAL INDICATIONS

Keep this manual in good condition and near the machine.

### 2.1 PREMISE

In writing this manual we have taken in consideration all the operations making part of a normal use and regular maintenance of the machine. Therefore for a correct and good use of it, it is necessary to follow the following instructions.

The use of the machine must be permitted exclusively to authorized personnel only and trained.

**PAY ATTENTION:** we recommend not to make any repair or intervention not indicated. All the operations demanding disassembly of particulars of the machine must be performed by the authorized technical personnel.


### 2.2 WARRANTY

This machine has a guarantee of 12 months starting from the invoice date. This includes the free replacement of all the mechanical parts showing defect of materials or of fabrication.

In the guarantee are not included the electrical and electronical components. Moreover are not covered the breakdown or defects due to external factors, maintenance errors, improper use of the machine, use of the machine in conditions of overloading, natural wear, errors of assembly or other causes not attributable to us.

The shipment of the material in replacement is intended ex our works. The machine delivered, even if in warranty, shall be sent free port.

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## 2.3 SENDING OF THE CORRESPONDENCE

For any correspondence, written or telephonical with the dealer or the factory referring to the machine, it is necessary to give the following information:


- machine modell
- batch number
- voltage and frequence of the machine
- name of the dealer from whom you bought the machine
- description of the eventual defect encountered
- description of the type of machining performed
- hours of working per day

Send to:

## 2.4 MACHINE IDENTIFICATION

The machine model is indicated on the plate situated on the front part of the basement as well as the identification of the same which indicates the following data:

- Batch number
- Year of fabrication
- Name of the fabricator

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### 3 TRANSPORT AND INSTALLATION

Your cutting machine mod. **FRIDA**, will be delivered to you by your authorized forwarder. Check immediately the conformity of the material and the good condition of it.

#### 3.1 MACHINE UNLOADING

Before unloading the machine, free it from all the parts that for transport or packing exigencies are leaned over it. Therefore the machine unloading from the truck can be done in the following way.

The machine is equipped with blocks keeping it lifted from the ground. So you can easily lift it with a lifter, inserting the forks under the basement and trying to balance the weight which is of 120 kos

#### 3.2 PLACEMENT

Choose the most comfortable position as regards the length of the pieces to work, the connections to the electric line, to the air, and the maintenance.

Check the solidità of the floor surface (preferibly in material not deformable, we advice a floor in concrete) so that the payment can find a uniform support in the points of contact..


Insert the 4 feet anti vibrations (which are in the tool box) in the appropriate holes on the basement of the machine. To level it, screw or unscrew these feet.

**N.B.:** For the transport, the machine is oiled and greased. Therefore ungrease the working table and the protections.

#### 3.3 WHAT TO DO IF THE MACHINE ARRIVED DAMAGED

1. Naturally the forwarder is coverei by an insurance with which you will be refunded in case the machine arrives damaged
2. Once contested the damage, within 2 days you must comunicate it through registered letter to the dealer.
3. write also to the fabricator a request of eventual spare parts, that will be sent to you c.o.d. the invoice of this parts, together with eventual costs for assembling, must be reimbursed to you from the insurance company.

**Attentino:** all the goods travels to the risk of the customer.

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## 4 SAFETY

### 4.1 USE AND COUNTER INDICATIONS

The machine is for a professional use and has been conceived and studied to perform operations of cutting on aluminium and PVC. The degree of protection of the electric installation is IP 54. For eventual damages derived from a different use, the only responsible is the user.

### 4.2 GENERAL INDICATIONS FOR THE SAFETY

In writing this manual we have taken in consideration all the functions which are needed for a correct maintenance, optimizing the use of the machine.

Therefore read carefully until the end this manual, before starting the machine.


This machine has been built to offer the maximum safety together with the best performances.

The greater safety is in your hands, using any type of machine you run some risks and you must remember this.

**ATTENTION:** to prevent contacts of electric current, injuries or damage of fire you must always follow the safety indications here written. Read and follow these indications before using the machines.

1. **Use of glasses.** Always use glasses, if you do cuttings creating dust, use a mask.
2. **Working clothes.** When you work, always use the appropriate clothes and avoid the use of large clothes and sleeves too large.
3. **Avoid dangerous positions.** Take care of finding yourselves in a safe position that allows you to maintain a good equilibrium
4. **Order on the working place.** Disorder on the workign place involves ranger of accidents.
5. **Fix the piece.** Make sure that the piece to work is blocked with a clamp or in any case still. Always work keeping the machine with both hands.
6. **Pay always attention when you work** During any operation, don't be distracted. A distraction could cause an accident.
7. **Environment conditions** Do not expose the machine to the rain. Do not use it in damp or wet environments. Always work in places with a good lighting. Do not use the machine near inflammable liquids or gas.
8. **Do not overload the tool.** Work better and in safety if you observe the power of the plate.
9. **Tool choice.** Do not use weak tools (in power) or accessories demanding too high power. Do not use tools for aims and works for which they are not destined.



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10. **Maintain properly the tools.** To work well and in a safe way, maintain the tools sharpened and proper. Follow the prescriptions of assistance and the indications of the tools change. Regularly check the cable and in case of damages, make it replace by qualified personnel. Check regularly the cables of extension and replace them if they are damaged. The side handles must be dry and without oil or grease.


**ATTENTION:** Check that the tool is not damaged. Bifore using the machine, check carefully the effience and the perfect functioning of the safety devices and of parts eventually damaged. Check the functioning of the mobile parts, that must be free and check that there aren't parts broken. All the other parts must be mounted in a correct way. Check all the other conditions which could influence the regular functioning of the machine.

Safety devices or damaged parts must be repaired or replaced by a Centre of Assistance.

11. **Replacement working tools.** Before repairing and changing the tools, always disconnect the plug from the current intake.
12. **Attention** for your safety, use only tools or accessories mentioned in the instructions of use or offered in the appropriate catalogues. The use of accessories or tools different and not recommended in the instructions of use or in the catalogues, can cause accidents.
13. **Keep the tools in a safe way.** Put the tools in a dry and safe place and in a way that children cannot reach them.
14. **Make the tools repair by qualified personnel.** This machine is in conformity to the current safety rules. Each repair must be performed exclusively by authorised centres of assistance.
15. **Safeguard from electrification.** Avoid contacts with objects with earthing, for instance pipes, coolers, etc....
16. **attention to the cable.** Lift the machine from the side of the cable and do not use it to disconnect the plug from the intake. Avoid too high temperatures, oils and corners
17. **Cables of extension to the open air.** To the open air use only cable of extension admitted and marked.
18. **Children** Do not leave the third people touch the machine or the cables. Keep them away from the working place

### 4.3 INDIVIDUAL PROTECTION DEVICES

- Gloves
- Glasses (DL n°277 del 15.08.91 e Direttive 80/605 e 88/642 CEE).
- Cap, plugs or helmet against the noise.
- Avoid clothes with big sleeves
- Do not wear rings, bracelets and watches.

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#### 4.4 YOUR SAFETY

1. The operator must have the minimum age prescribed by the law and must have knowledge of how to work on machines for working aluminium.
2. the experience teaches that the things you wear can cause injuries: take off the ring, the watch and the bracelet; strenghten the sleeves around the wrists buttoned them in a safe way; take off the tie; keep your hair picked up, use appropriate shoes prescribed all around the world.
3. always use glasses or protective screens for your eyes.
4. always use gloves.
5. always use shoes anti sliding.

#### 4.5 MAINTENANCE

The maintenance must be performed by competent people. The various operations for the ordinary and extraordinary maintenance are indicated to the final pages of this manual


It is compulsory always to put at 0 the switch of general electric feeling when you have to adjust the machine or disassemble any protection, signalling this operation with a panel well visible.

An important safe factor is the cleaning of the machine, of the working tables, of the floor and surrounding environment. Before starting the machine, make sure that there aren't other people making operations of maintenance.

#### 4.6 RESIDUAL RISKS

In spite of the safety instructions adopted, residual risks can remain.

- The blade, turning at high speed, despite the precautions taken, can be lauched away if badly locked. So pay attention in locking the blade.
- A prolonged sonorous exposure can cause damage to your health.

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## 4.7 ELECTRICAL CONNECTION AND GROUNDING

The electrical connection and the checks here indicated must always be done by an electrician following the norms EN 60204-1.

Make sure that the electric line of the factory is dimensioned so that it can stand the power of the machine and check that the voltage corresponds to that of the machine.

Note: the ideal working condition for the machine is to give the precise voltage written in the data of the plate, anyway it can adapt to higher or lower voltages for a tolerance of +/- 5%.

(ex.: a machine with voltage V=380 has a tolerance which goes from 360 to 400 Volts).

Outside this tolerance you must adjust the voltage of feeding

Read on the machine identification plate the value of the total current absorbed (Amp.).

**Consult the table here mentioned to use the correct section of cables and to install above the machine fuses of type "DELAYED".**

AMPERE ABSORBED	SECTION OF THE CABLES	DELAYED FUSES
From 3 to 6	2,5 mm	10 A
From 6 to 10	2,5 mm	10 A
From 10 to 14	4 mm	16 A

Electrically insulate the machine and connect the 3 cables (phases) to the terminals L1, L2, L3.

Connect the cable yellow-green (earth) to the terminal (PE) or marked by the symbol and the cable of neutral, if requested, to the terminal N.

Strengthen with care the press-cable P ; check that the rotation sense of the blade is correct, starting the machine as described afterwards.


If the blade doesn't turn in the correct direction, you must:

- Take off the tension to the line
- Invert two phases
- Try again the sense of rotation, which must be in clockwise direction.

## 4.8 PNEUMATIC CONNECTION

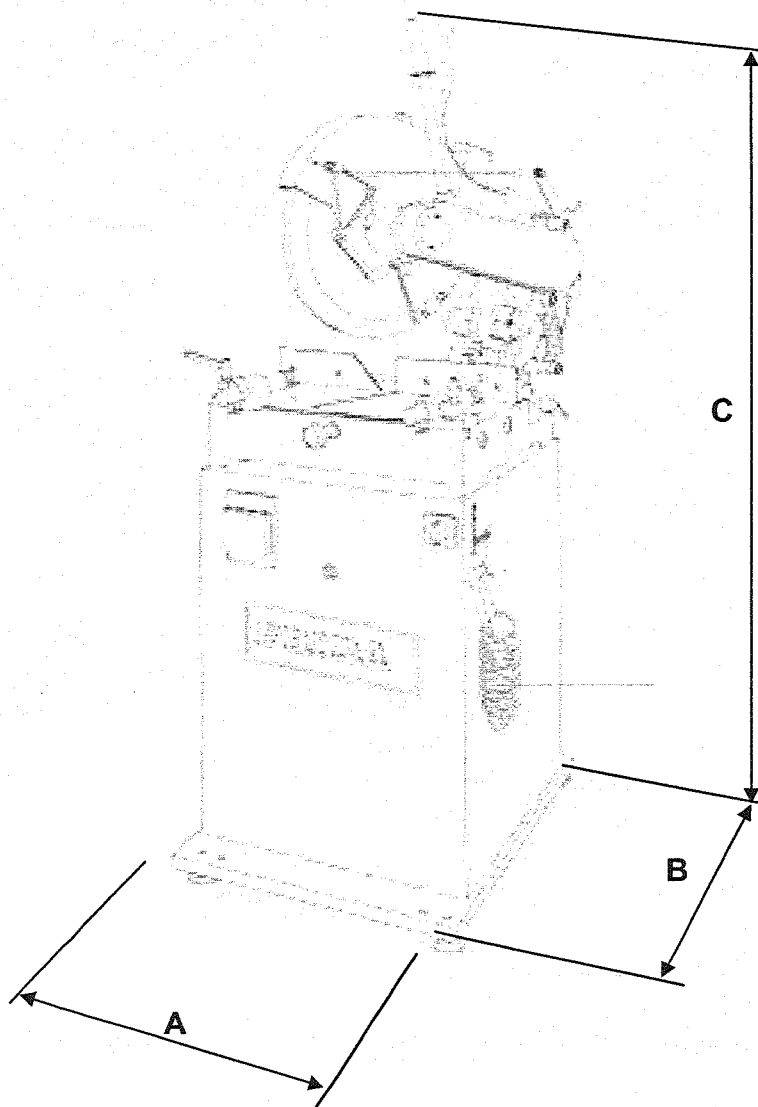
You make the pneumatic connection inserting in the appropriate plug above the group FR a flexible pipe with diameter 8 mm

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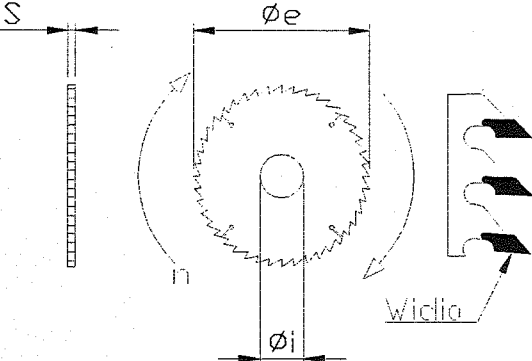
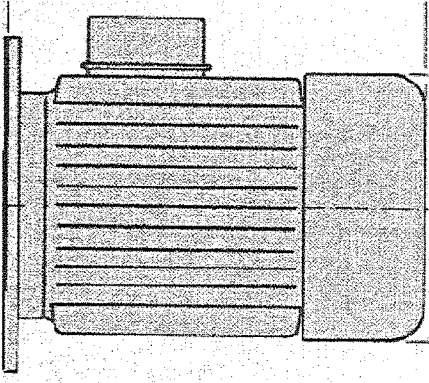
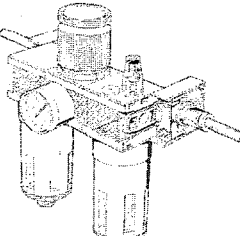
## 5 DESCRIPTION OF THE MACHINE AND SPECIFICATIONS

### 5.1 OVERALL DIMENSIONS

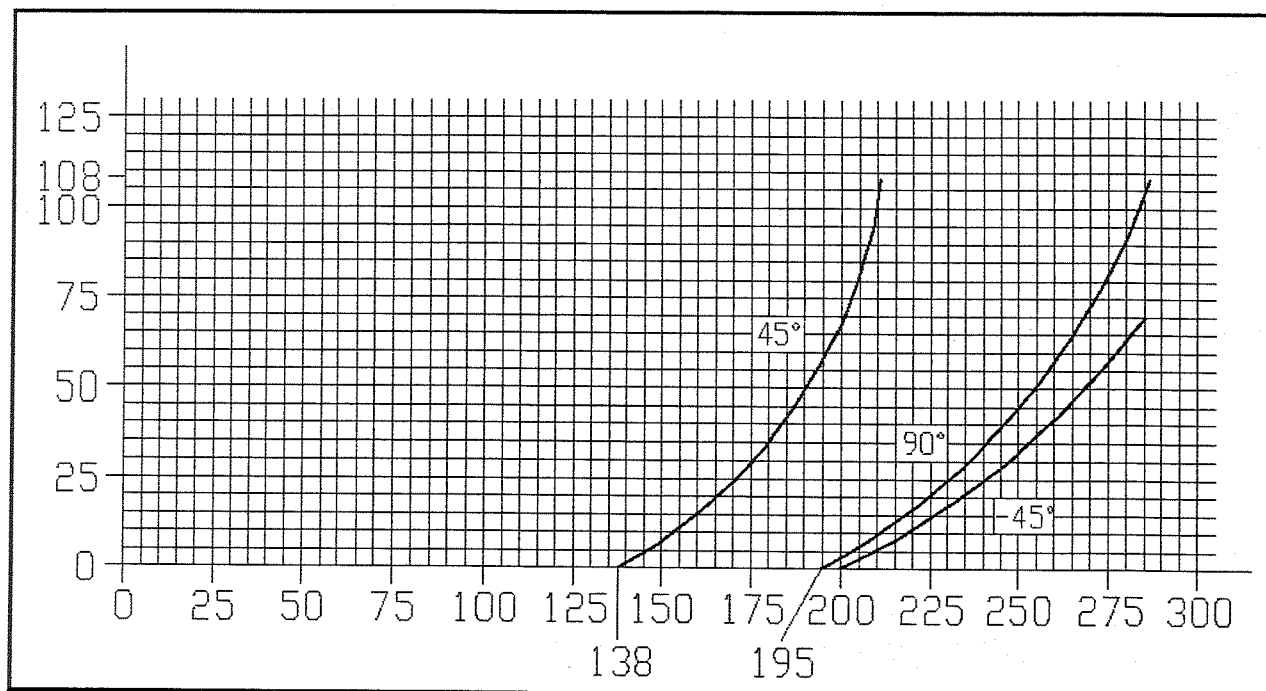


**A = 550**  
**B = 850**  
**C = 1460**  
**PESO = 138 Kg**

## 5.2 TECHNICAL FEATURES

	$\varnothing_e$ [mm]	400	
	$\varnothing_i$ [mm]	30	
	S [mm]	4	
	Z [denti]	96	
	Vt [m/s]	66,5	
	n [G/min]	3190	
	N [KW]	1,5	
	n [G/min]	2800	
		3	
	Hz	50	
	A [380 V]	3,5	
	A [220 V]	5,2	
	p [bar]	6,5	

### 5.3 CUTTING DIAGRAM




### 5.4 STANDARD EQUIPMENT

Pneumatic clamps  
Automatic lubrication  
Service spanners

### 5.5 OPTIONALS:

TCT sawblade Ø 400 mm

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## 5.6 NOISE LEVELS

Acoustic emission of the single head cutting off machine mod. **FRIDA** according to the norms uni 7712, iso 7960.

<b>ALLUMINIUM</b>	<b>IN VACUUM</b>	
	Medium value of the sonorous level measured	Lmp = 75,1 dB (A)
	Value of the sonorous level in the working position measured	Lmp = 81,3 dB (A)
	Factor of environmental correction	K = 1 dB (A)
	Medium value of the correct sonorous level	Lpc = 74,1 dB (A)
	Value of sonorous level in the correct working position	Lpc = 80,3 dB (A)
	<b>LOADED</b>	
	Medium value of the sonorous level measured	Lmp = 86,3 dB (A)
	Value of the sonorous level in the working position measured	Lmp = 91,1 dB (A)
	Factor of environmental correction	K = 1 dB (A)
	Medium value of the correct sonorous level	Lpc = 85,3 dB (A)
	Value of sonorous level in the correct working position	Lpc = 90,1 dB (A)

Sometimes if you make several activities associated to the use of the machine, this can cause physical discomfort and weariness. For example, if you are engaged in extra working activities involving sonorous exposures, you are more at risk.

The working conditions, as for example the insonorisation of the working place, have an important role on your health and wellness.


Some factors that influence the real level of exposures are:

- the duration of the exposure
- machines working besides.
- The type and features of the building.

Moreover the noise can be limited with some precautions:

- Decreasing the number of revolutions of the machine
- With a low feeding,
- A good fixing of the piece,
- A good state of the tools,
- And above all using the appropriate acoustic protections

A prolonged exposure over 85 dB(A) can cause health problems. We recommend in any case the use of the appropriate systems of protection, previously listed

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## 6 USE AND ADJUSTMENTS

### 6.1 ACTIVATION RELEASE HEAD

**ATTENTION :** During the use of the machine, never remove the protections and make sure that they are always efficient.

The machine is equipped with a blocking that avoid the pendular movement of the head and block in safety position (see Fig. 1 part. A).

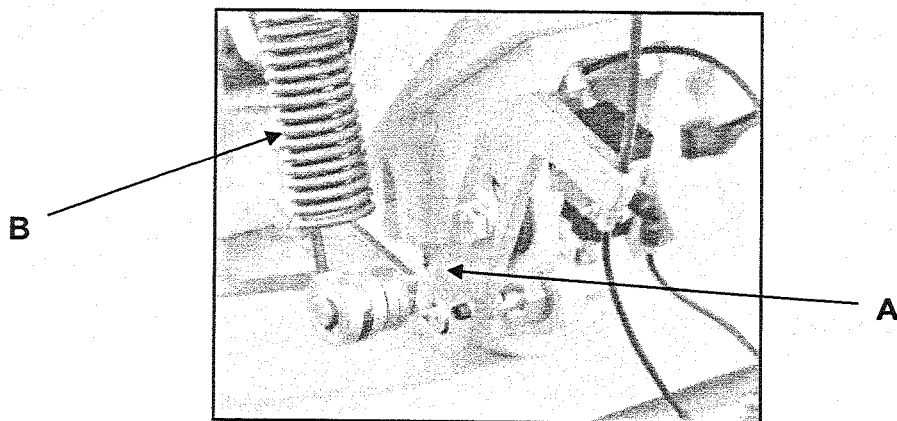


Fig. 1

The arm holding the saw and the motor is kept in rest position, lifted by a spring (see Fig. 1 part. B).

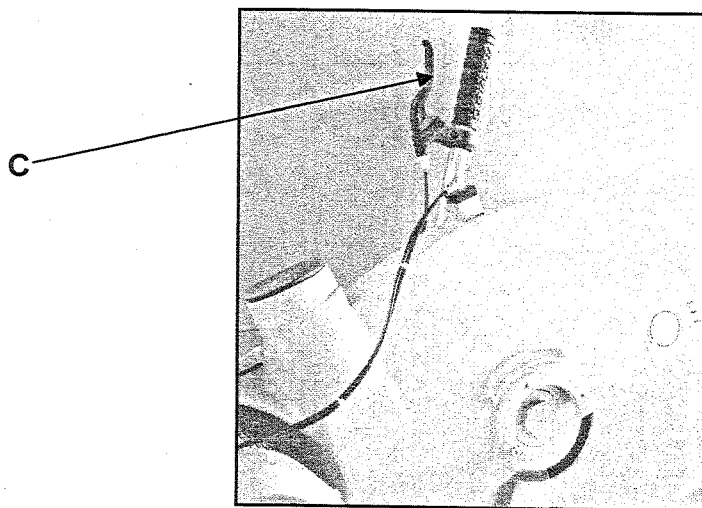



Fig. 2

In rest position (with the arm lifted) the blade is completely covered from the lower protection which discovers pulling the release handle (Fig. 2 part. C) and lowering the head.



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## 6.2 PROCEDURE TO START THE BLADE

To activate the blade, operate as follows.

1. check the connection of the machine to the electric line and to the air. This shall never go under 6 BAR of pressure.
2. Activate the blocking of the pneumatic clamps through the selector situated on the front side of the machine (Fig. 3 part. **A**).

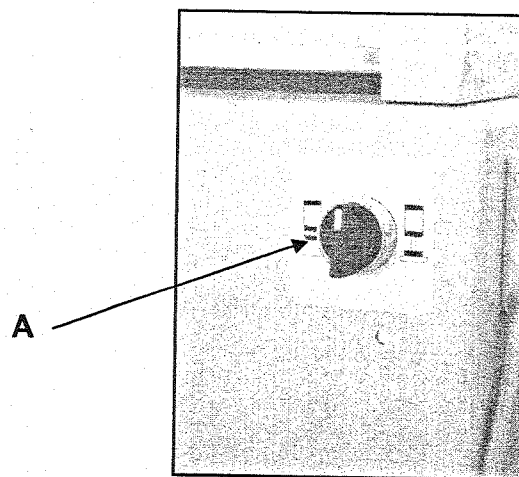


Fig. 3

3. Turn the switch situated on the front left side of the machine (Fig. 4 part. **B**) turning it in position 1 . At this point, check the rotation sense of the blade, which must correspond to that indicated from the arrow on the carter of protection (Fig. 5 part. **D**).

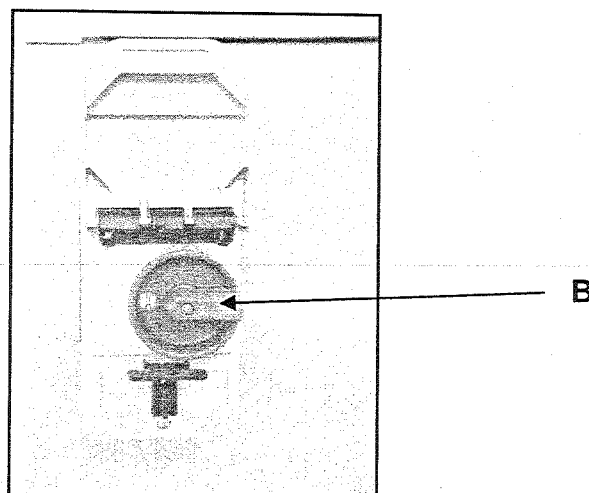



Fig. 4

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4. To proceed to the execution of the cut, release the safety stop of the head, operating on the lever situated on the handle for the blade descent (Fig. 5 part. **C**).

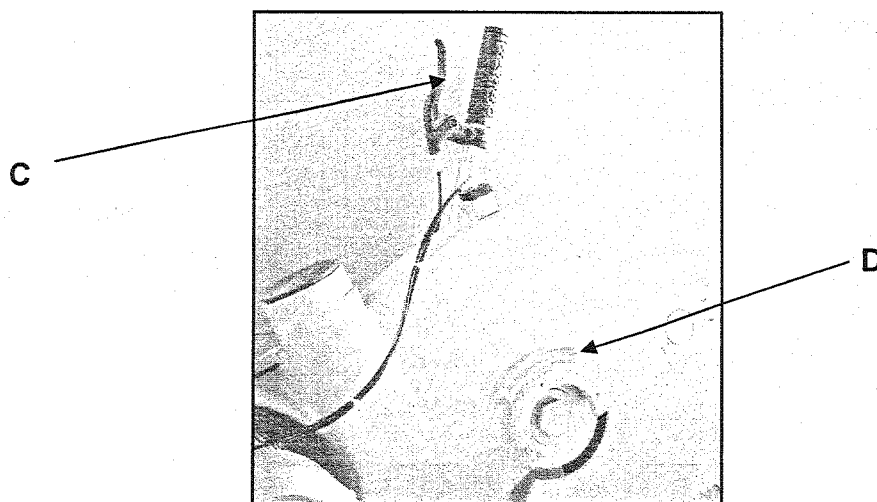



Fig. 5

**N.B.:** If you don't close before the clamps, operating on the start switch, the blade doesn't activate.

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### 6.3 ADJUSTMENT AND LUBRICATION

On the superior part of the carter where is located the blade, there is a lubricator that with its jet mix air-lubricant, cools the blade during the cut.

Through the adjusting screw situated on the body of the lubricator (Fig. 6 part. **A**) it is possible to adjust the quantity of the liquid emitted

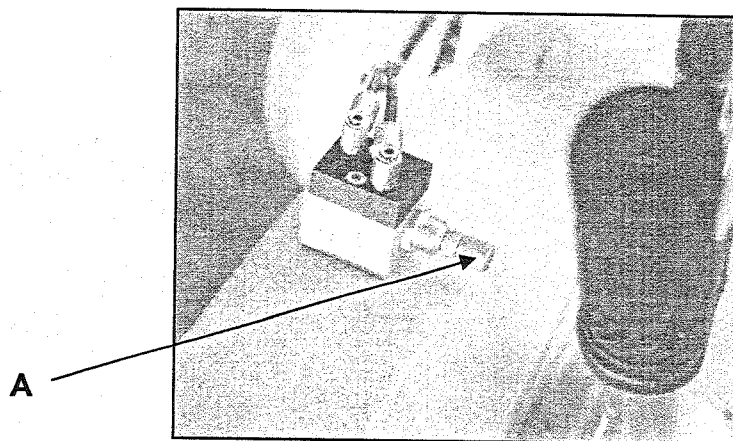


Fig. 6

In the rear part of the basement, there is the plastic bottle which acts as reservoir for the liquid, which must be filled each time this is necessary (Fig. 7 part. **B**).

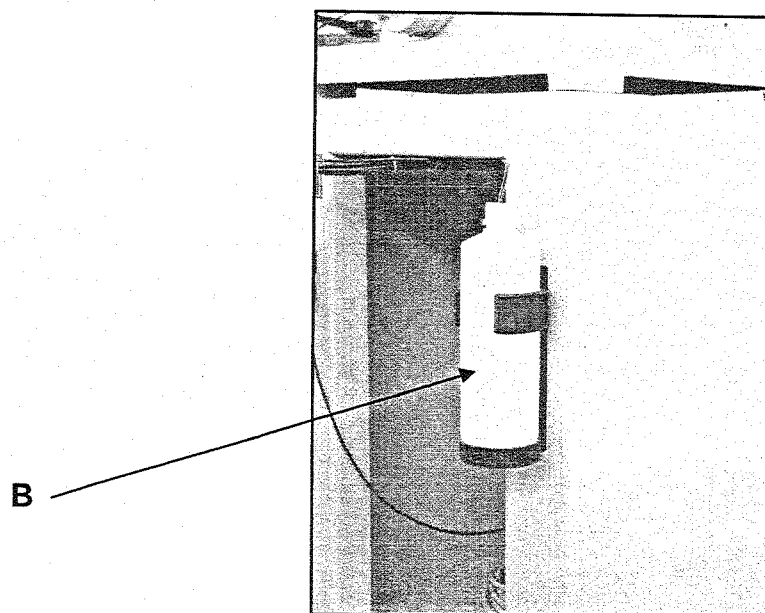



Fig. 7

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## 6.4 BELT TENSIONING

Using the machine, you will need to tension the transmission belts. This is necessary to restore the time of stop of the blade, which must happen within 10 seconds. Follow then this procedure.

1. release the motor loosening the lever in Fig. 8 part. **C**.
2. move the motor toward the rear part of the machine, increasing in this way the belts tension.
3. Block again the lever that you previously loosed and test the time of stop of the blade, to check the efficiency of the tensioning
4. if the time is still over the 10 seconds, repeat the procedure.

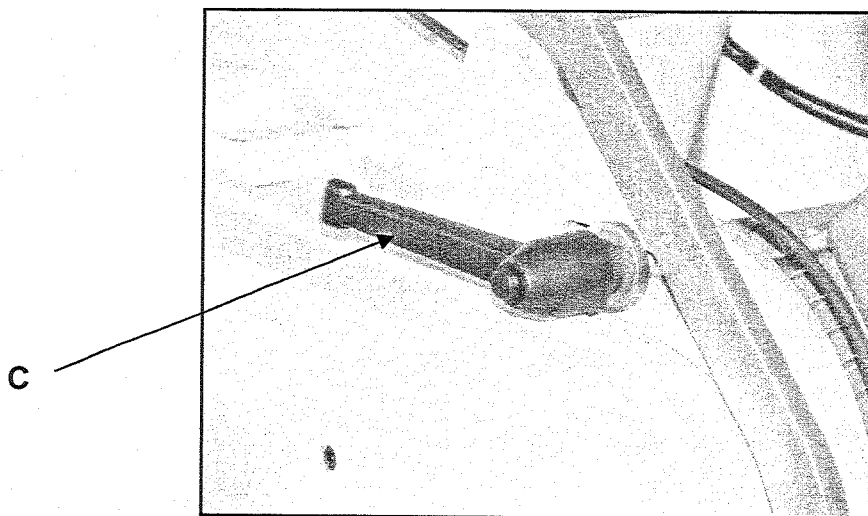



Fig. 8

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## 6.5 HOW TO DISASSEMBLE THE BLADE

To replace the blade, operates as follows.

1. Release the self-blocking nut (Fig. 9 part. **A**) to release the tie-rod activating the disappearing protection

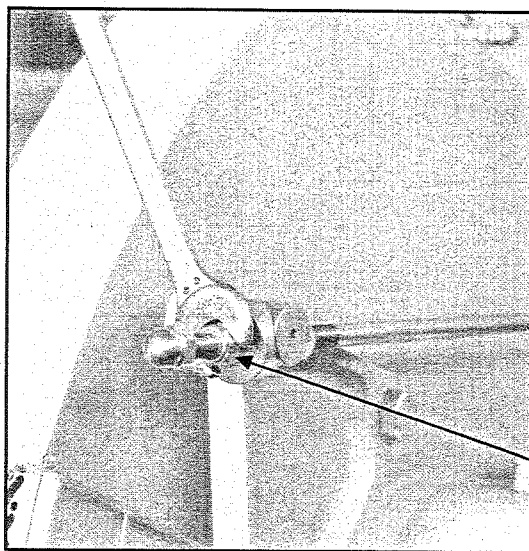


Fig. 9

2. remove the rod from the pivot fixed on the connecting rod at parallelogram, then lift manually the yellow protection, discovering the blade to insert more easily the spanner 36mm in the blocking screw (Fig. 10 part. **B**).

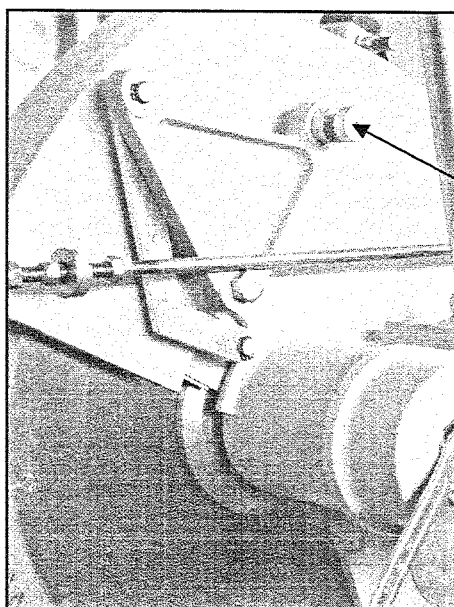



Fig. 10

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- Remove the transparent protection (Fig. 11 part. **C**) making it turn after having removed two of the three fixing screws.

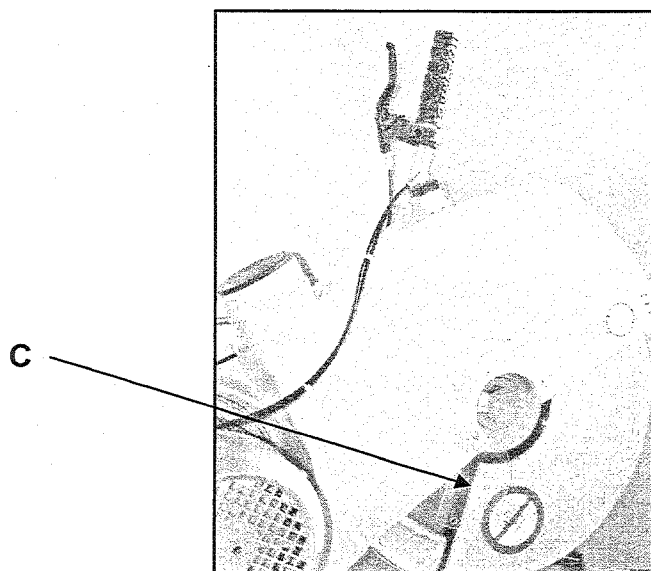


Fig. 11

- Remove the lower blade protection (Fig. 12 part. **E**) to facilitate the removal of the blade from its seat.

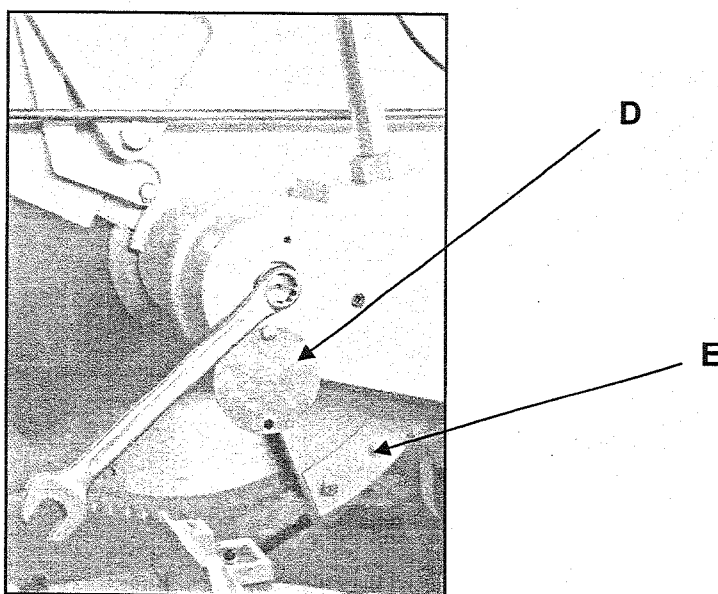



Fig. 12

- Discover the nut allowing the blocking of the shaft, unscrewing one of the screws fixing the corresponding metal cover (Fig. 12 part. **D**). Insert a spanner of 17mm to contrast the unscrewing of the blade flask screw.

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6. Using a spanner of 36mm , looswn the blade flask screw, making a traction in clockwise direction (Fig. 13 part. **G**) keeping firm the contrast spanner (Fig. 13 part. **F**), unscrew the screw and remove the flask to be able to extract the blade from the shaft.

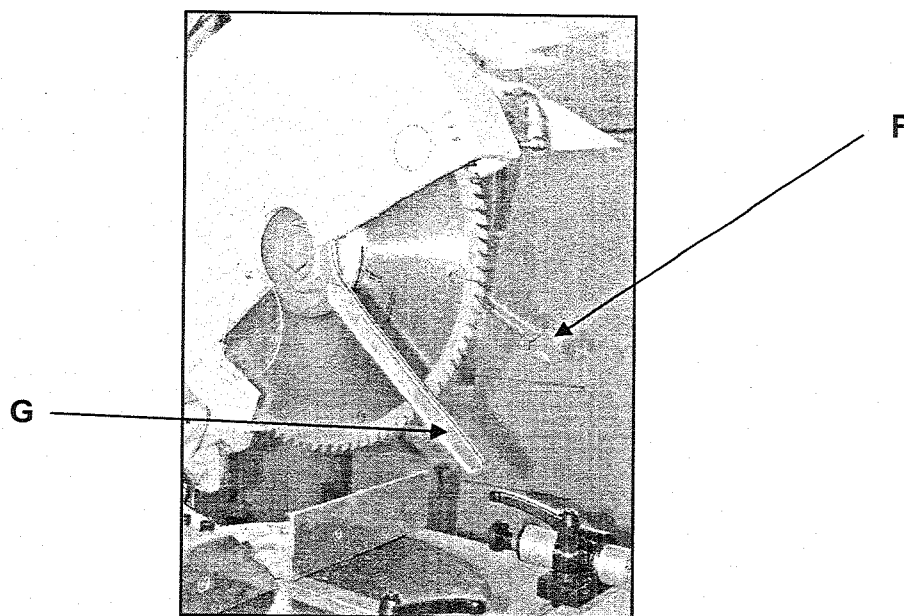



Fig. 13

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## 6.6 ADJUSTMENT OF THE ARM TILTING

### 6.6.1 ERROR 0° ARM TILTING

If the arm holding the motor in 0° position is not perfectly perpendicular with the working table, adjust the register (Fig. 14 part. **A**) situated on the right side of the support

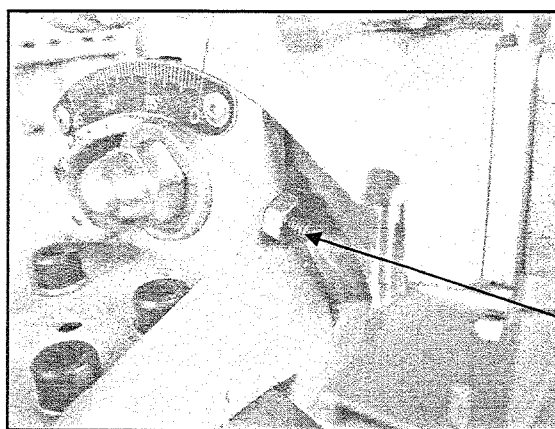


Fig. 14

### 6.6.2 ERROR 45° ARM TILTING

If the angle of tilting of the arm holding the motor, in 45° position is not correct, adjust the register (Fig. 15 part. **B**) situated on the left side of the support.

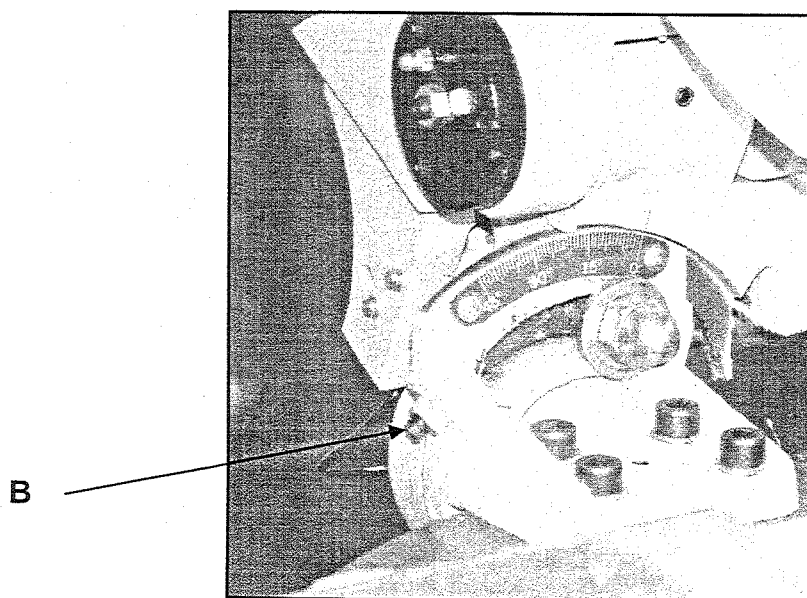



Fig. 15



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### 6.6.3 INCOMPLETE CUT

If the blade doesn't cut completely the piece, adjust the lowering of the arm holding the motor operating on the register (Fig. 16 part. **C**) situated on the lower side of the support. Pay attention that the blade doesn't touch the turning table

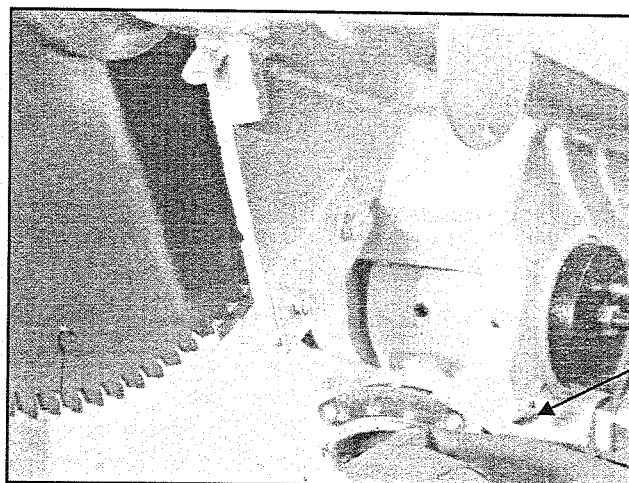



Fig. 16

	Cutting off machine mod. <b>FRIDA</b>	REV. 00
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## 6.7 ADJUSTMENT OF THE ANGLES

The turning table can be tilted to the right or to the left in 4 fix positions: 15°, 22°30', 30, 45° and in central position at 90°.

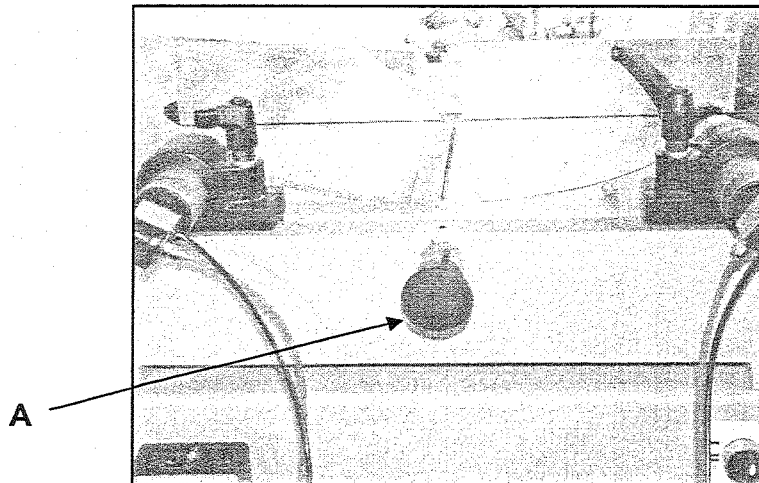


Fig. 17

The release of the table for the rotation is made pulling the central pommel (Fig. 17 part. **A**) and loosening the two handles situated on the right and left side of the machine top (Fig. 18 part. **B** Fig. 19 part. **C**).

Once released, turn the table and read the desired angle on the graduated scale printed on the top.

Block in the desired position, making the pommel return in its seat (Fig. 17 part. **A**).

Block the two handles (Fig. 18 part. **B** Fig. 19 part. **C**) previously loosed to avoid vibrations during the cut.

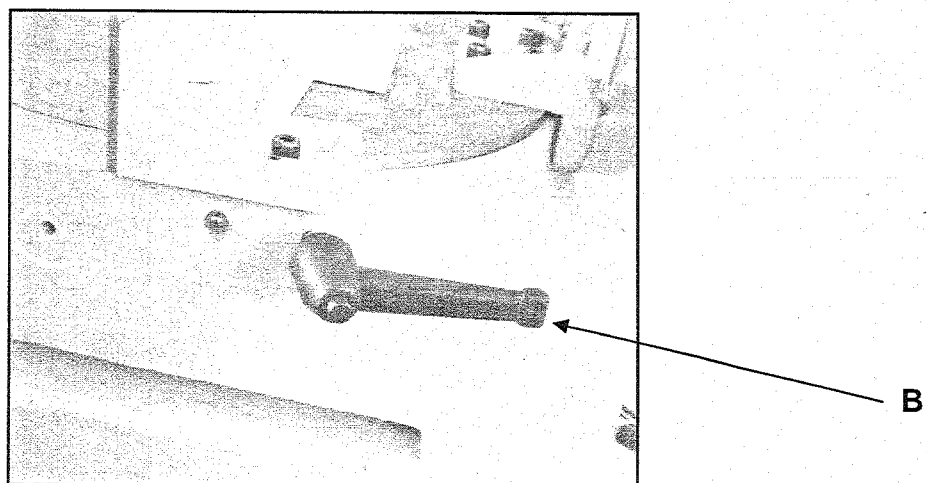



Fig. 18

	Cutting off machine mod. <b>FRIDA</b>	REV. 00
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For the cuts at intermediate degrees, always release the table, using the central pomel (Fig. 17 part. **A**) and block in position using only the two levers situated on the sides of the machine (Fig. 18 part. **B** Fig. 19 part. **C**).

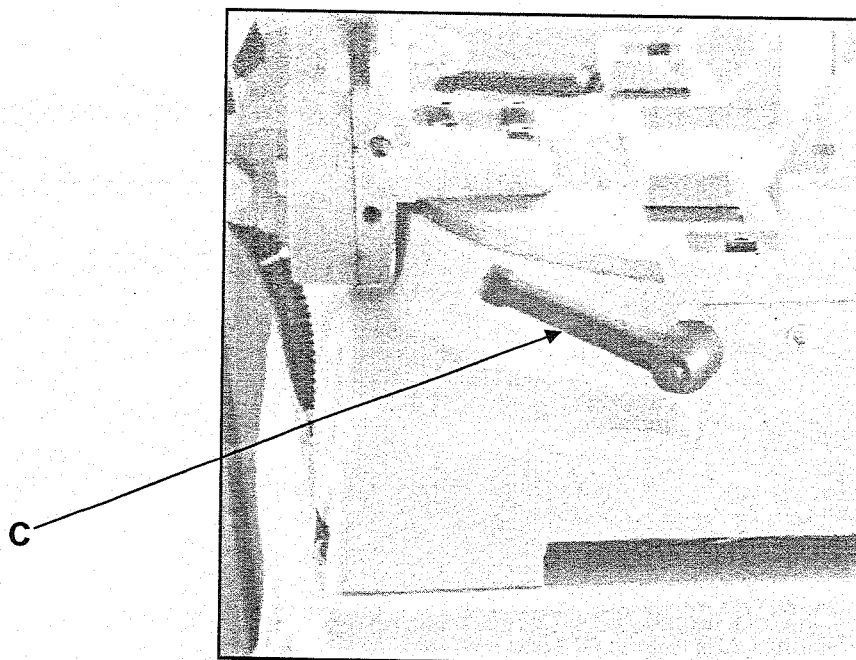



Fig. 19

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## 6.8 CLAMPS ADJUSTMENT

The clamps adjustments can be done along the transversal direction and along the depth of the working table.

Make reference to Fig. 20.

Releasing the levers (part. **A**), it is possible to move all the support. In this way the shifting happens along the X direction.

Moreover, making the cylinder slide inside the support, it is possible to adjust the pistons position along the direction Y.

The pistons inside the support and the supports self move independently one from another.

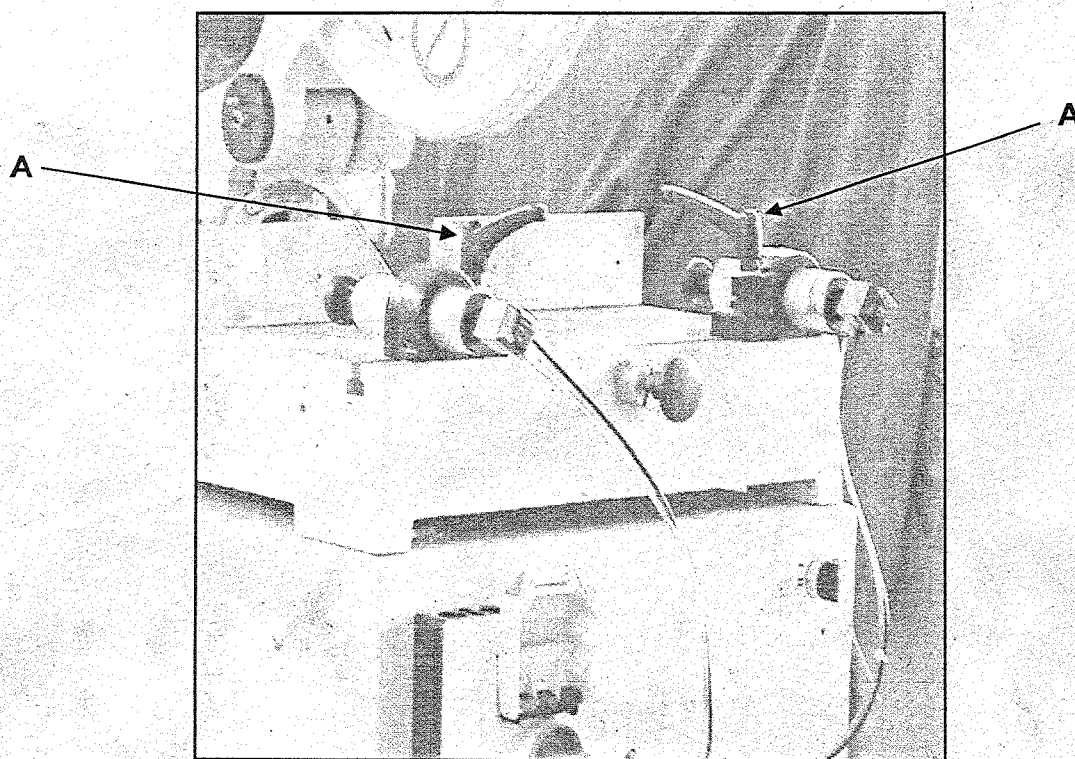


Fig. 20