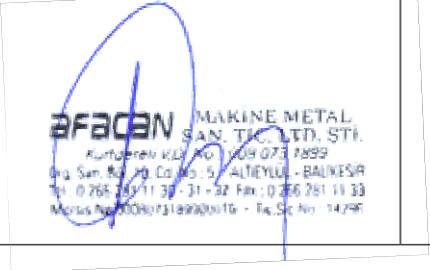




## **OPERATION AND MAINTENANCE MANUAL FOR F22 AND F24 HYDRAULIC CUTTING MACHINE**

**READ THIS MANUAL AND MAKE SURE YOU  
UNDERSTAND HOW THE MACHINE WORKS BEFORE  
OPERATING THE MACHINE**

# WARRANTY DOCUMENT

PRODUCT NAME	HYDRAULIC IRON CUTING MACHINE	
SERIAL NUMBER		
WARRANTY DURATION	6 MONTHS	
	IT WILL BE FILLED BY THE MANUFACTURER	IT WILL BE FILLED BY THE END POINT SELLER
COMPANY NAME	AFACAN MAKİNE METAL SAN. TİC. LTD. ŞTİ.	
ROAD BILL NUMBER		
ROAD BILL DATE		
INVOICE NUMBER		
INVOICE NAME		
DELIVERY DATE TO USER		
STAMP, SING		

## WARRANTY CONDITIONS:

1. Warranty date begins with delivery date and it is 6 months.
2. The products and all its parts are under the manufacturing company.
3. If the product has fault tor broken, the duration passed in repairment is addet to warranty period. The repairment period is maximum 30 days.
4. If the product is not properly used or welded or repaired, the warranty will not be applied.
5. Wrong electricity connection makes warranty invalid.
6. Bending and cutting parts are out of warranty since they are used as consumables.

## CAUTIONS !

To prevent from serious injuries, the employers and owners must provide necessary protections and equipments for installations and operations. The employers and owners must also provide thorough training courses for the operators and they must carefully supervise all operations and obey the following safety regulations:

1. DO NOT LET UNTRAINED PERSON OPERATE THE MACHINE. THIS MACHINE CAN BE OPERATED ONLY BY THOSE WHO ARE WELL-TRAINED AND FULL UNDERSTAND THE FEATURES AND SPECIFICATIONS OF THE MACHINE AS WELL AS SAFETY RULES FOR OPERATING THE MACHINE.
2. DO NOT PUT ANY PORTION OF YOUR BODY ON ANY MOVING COMPONENT OF THE MACHINE. DO NOT ENTER THE WORK SPACE OF THE MACHINE UNLESS THE POWER OF THE MACHINE IS OFF. KEEP AWAY WHILE THE MACHINE IS OPERATING.
3. DO NOT WEAR LOOSE CLOTHING OR GLOVES SINCE THEY MAY BE TANGLED IN THE MACHINE. TIGHTEN YOUR CLOTHES, ESPECIALLY THE CUFFS.
4. MAKE SURE THAT THE FLOOR WHERE THE MACHINE AND THE OPERATOR STAND ARE STURDY

Model	<b>F22</b>	<b>F24</b>
Engine Brand	<b>VOLT / GAMAK</b>	<b>VOLT / GAMAK</b>
Engine Power	<b>1.5 kW</b>	<b>2.2 kW</b>
Power	<b>220V</b>	<b>220V</b>



### MAINTENANCE:

#### ALWAYS KEEP THE MACHINE CLEAN

Remove the dust and scraps on the machine	Daily
Oil the nozzles	Daily
Renew the hydraulic oil (Oil no: 46 or equivalent one.)	6 months
Check the oil level	Once a week
Remove the dust and scraps on the machine	Daily

## SPECIFICATIONS:

Cutting Capacity	22 mm	24 mm
Voltage	220 V	220 V
Power	2 HP (1,5 kW)	3 HP (2,2 kW)
Weight	85 Kg	110 Kg
Dimension	720 x 390 x 430	720 x 390 x 445
Output Rotation	1500 RPM	1500 RPM
Rotation	1500 RPM	1500 RPM
Production Date		
Serial No		

Always decide how many pieces to cut according to the following table and the table on the machi

F22 CUTING CAPACITY

Piece (PCS)	1	2	3	4	5
45 kg/mm <sup>2</sup>	Ø22	Ø14	Ø12	Ø10	Ø8
65 kg/mm <sup>2</sup>	Ø18	Ø12	Ø10	Ø8	Ø6
85 kg/mm <sup>2</sup>	Ø14	Ø10	Ø8	Ø6	Ø5

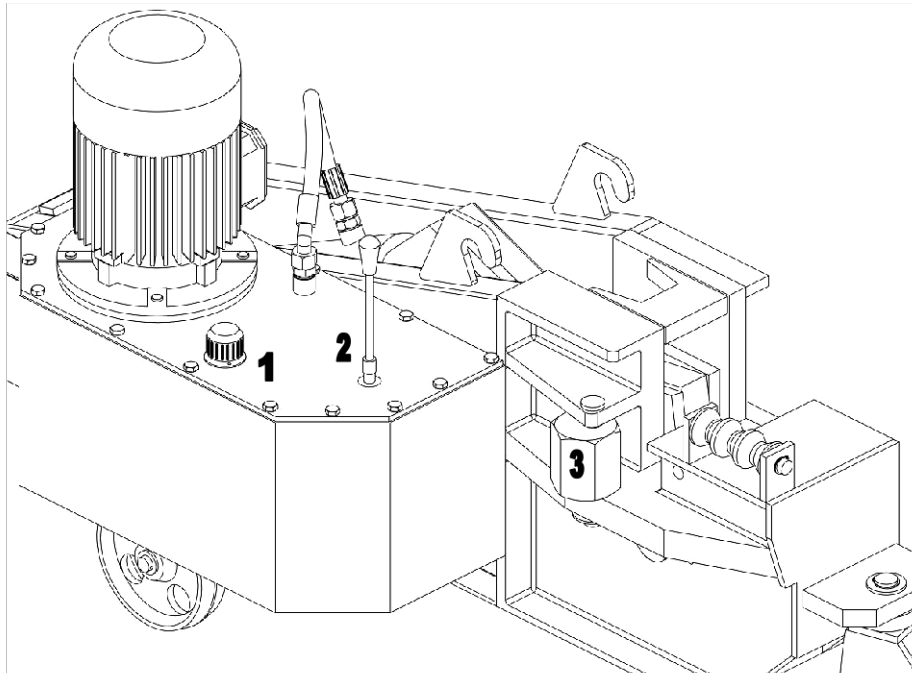
○ : Round Material

F24 CUTING CAPACITY

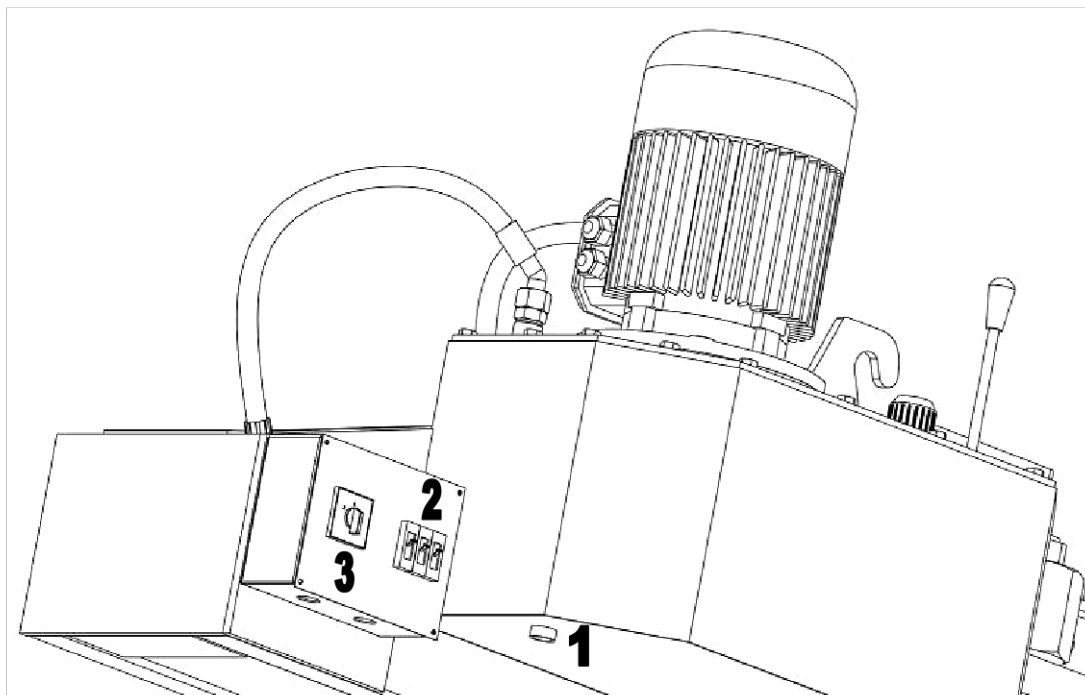
iece (PCS)	1	2	3	4	5
45 kg/mm <sup>2</sup>	Ø24	Ø16	Ø14	Ø10	Ø8
65 kg/mm <sup>2</sup>	Ø22	Ø14	Ø12	Ø8	Ø6
85 kg/mm <sup>2</sup>	Ø18	Ø14	Ø10	Ø6	Ø6

○ : Round Material

## OVERVIEW :



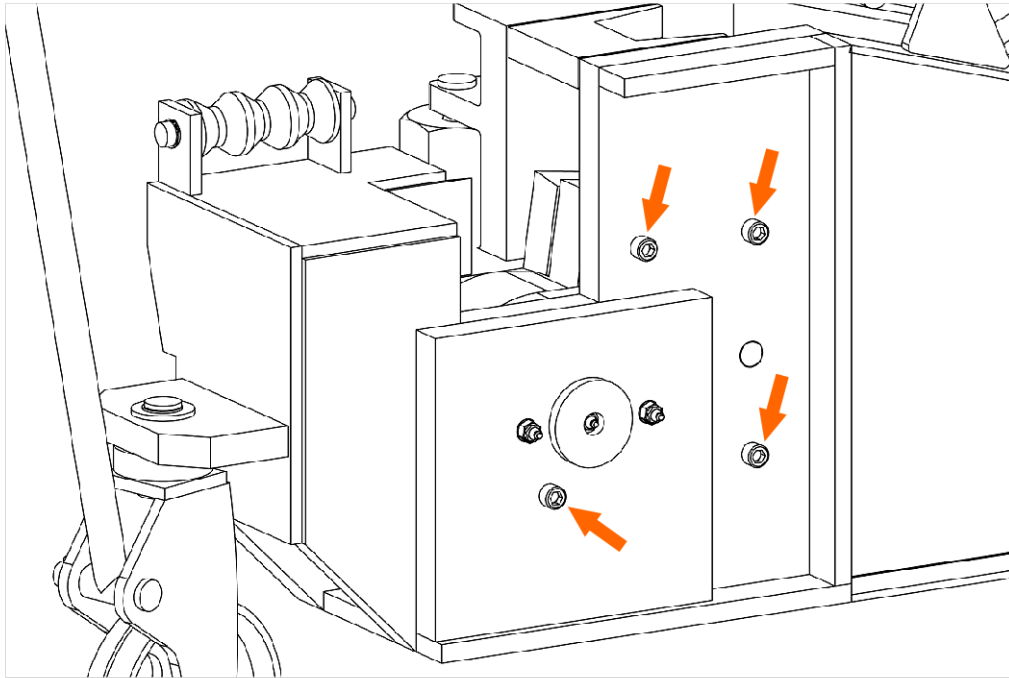
1	Oil-in Tap	To add up oil. The advised oil is 46 No. hydraulic oil
2	Control Lever	It works backward and forward to operate the machine
3	Base	It arranges the gap to cut different size iron bars



1	Oil-Out Tap	To pour out the oil in order to renew it.
2	Main Power Switch and fuse	
3	Power Switch	It turns on and turns off the machine

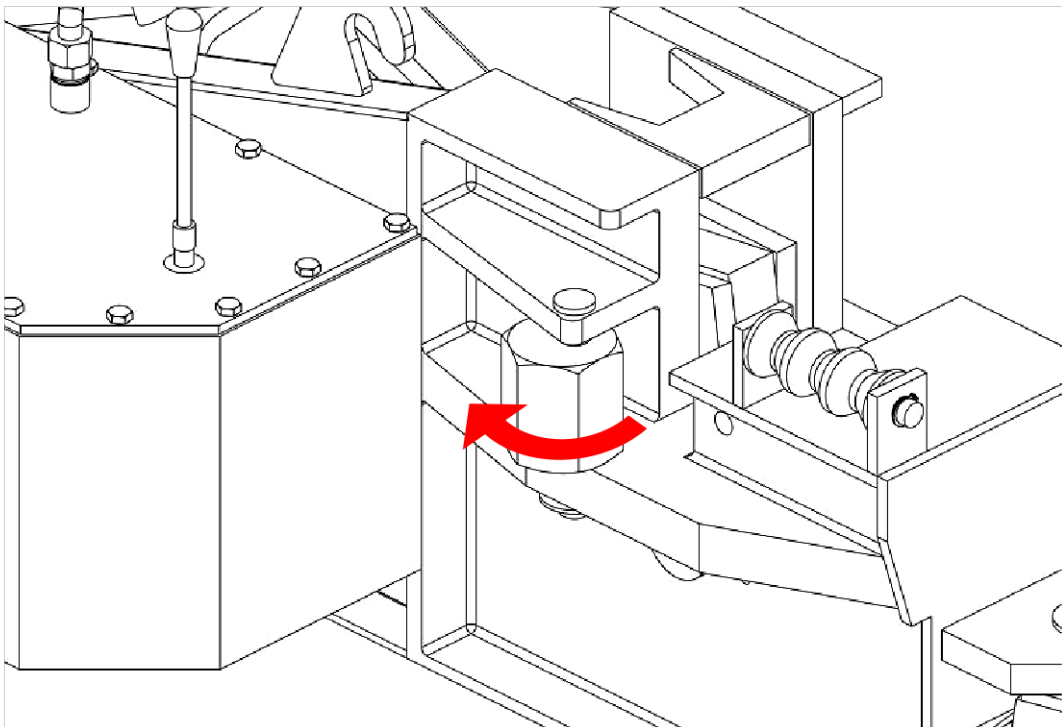
**OPERATING THE MACHINE:**

1. Before the operation, tighten the bolts seen in the following picture (Picture 3).



(Picture 3)

2. And also arrange the base according to the iron bars to be cut. This arrangement is vitally important for blades of the machine (Picture 4).



(Picture 4)

## TROUBLESHOOTING:

PROBLEM	POSSIBLE SOLUTION	DESCRIPTION
Machine is not working	Check both the main switch and power switch is on	
	Check the electrical connection, main cable.	Remove all the connections and put them again
	Check the electricity 220 V	Check 3 phases
	Advise an electricity specialist	
	Make sure that the oil level is fine	
	Turn the main switch to other direction.	There may be reverse electricity connection. Turn the main switch to the other direction and retry to operate the machine
Machine makes too much noise and works hardly	Make sure there is nothing that prevents machine's working	
	Check the cable cord.	If it is too long, shorten the cord and try again. The advised cord length is 50 meters.
	Check the motor.	If it is too hot, there could be a problem with the motor and hydraulic pump
	Check the oil	In time, the oil loses its specialty. It is needed to be renewed periodically. On hot weathers, the oil becomes thin and it may affect the machine performance
	Check the blades	Blades may become worn out or the blade bolts are loosed. Change with the new one or change the cutting side and tighten the bolts,
Machine leaks hydraulic oil		Hydraulic machines leak some oil. It is natural. But if it leaks too much, maintenance is needed. Tighten the joints where the oil may leak.
		It may also be caused by the felts of the hydraulic cylinder. If it is the case they should be renewed in time.

- Be sure that the blades bolts are also tightened.
- Turn on main switch and power switch. **NOTE THAT POWER SWITCH WORKS 2 DIRECTIONS, RIGHT AND LEFT. SELECT THE PROPER DIRECTION ACCORDING TO THE ELECTRICITY CONNECTION OTHERWISE MACHINE MAY NOT OPERATE.**
- Be sure that it is not used very long cable for the electricity. The advised maximum cable length is 50 meters.
- Put the iron bar to be cut and by using control lever forward and backward, cut the iron bar. Do not force the machine after finishing the cutting backward or forward direction unnecessarily. This action will force the hydraulic system itself.
- After release the control lever, the hydraulic piston will go back spontaneously. If you want it go back fastly, you may also use the control lever backward direction to shorten the time to go backward position.
- IMPORTANT:** The machine has many oil nozzles put on different places. For less maintenance, failure and breakdown, **OIL THE MACHINE DAILY.**
- DO NOT PUT ANY PORTION OF YOUR BODY ON ANY MOVING COMPONENT OF THE MACHINE. DO NOT ENTER THE WORK SPACE OF THE MACHINE UNLESS THE POWER OF THE MACHINE IS OFF. KEEP AWAY WHILE THE MACHINE IS OPERATING.**



**KOLLU DEMİR KESME MAKASLARI3**  
**BOLT CUTTERS**  
**БОЛТОВЫЕ РЕЗКИ**  
قطع التبراس



**DEMİR BÜKME ANAHTARLARI**  
**BENDING TOOLS**  
**ИНСТРУМЕНТЫ ДЛЯ ГИБКИ**  
أدوات الانحناء

**OTURAK DEMİR KESME MAKASLARI**  
**BOLT CUTTERS**  
**БОЛТОВЫЕ РЕЗКИ**  
قطع التبراس



**PARKE TAŞI - ÇİNİ - KESME MAKASI**  
**PAVING STONE CUTTER**  
**РЕЗАК ДЛЯ ТРОСИТЕЛЬНОГО КАМНЯ**  
تمهيد الحجر القاطع



**PRATİK ETRİYE KIVIRMA KOLLARI**  
**PRACTICAL STIRRUP BENDERS**  
**ПРАКТИЧЕСКИЕ СТРУКТУРА**  
أدوات التقلب العملية



**BASİT ETRİYE KIVIRMA KOLLARI**  
**SIMPLE STIRRUP BENDERS**  
**ПРОСТЫЕ ГИБКИ ДЛЯ ПЕРЕМЕШИВАНИЯ**  
أدوات التقلب البسيطة



**KLASİK ETRİYE KIVIRMA KOLLARI**  
**CLASSICAL STIRRUP BENDERS**  
**КЛАССИЧЕСКИЕ СТРУКТУРЫ**  
آلات تقليب كلاسيكية



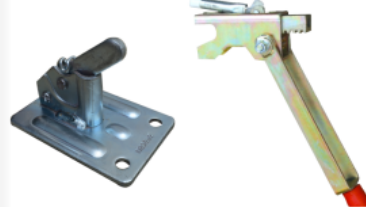
**GÖNYE APARATI**  
**REBAR BENDING TOOL**  
**Инструмент для гибки ребра**  
أداة ثني الحديد التسليح



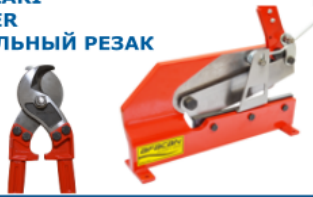
**ZİNCİRLİ BORU ANAHTARLARI**  
**CHAIN PIPE WRENCH**  
**КЛЮЧ ДЛЯ ЦЕПНОЙ ТРУБЫ**  
سلسلة أنابيب الربط



**ÇİROZ VE ANAHTARI**  
**RAPID CLAMP**  
**БЫСТРЫЙ ЗАЖИМ**  
النقطة السريعة



**SAC & KABLO KESME MAKASLARI**  
**SHEET METAL & CABLE CUTTER**  
**ЛИСТОВЫЙ МЕТАЛЛ И КАБЕЛЬНЫЙ РЕЗАК**  
قاطع الصفائح المعدنية والكابلات



**DÖVME ÇELİK KERPETEN & KESER**  
**TOWER PINCER & DROP FORGED ADZE**  
**БАШНЯ-ЩИПКА И КОВАНАЯ**  
برج الكماشة & إسقاط مزورة



**BENZİNLİ ASFALT KESME MAKİNESİ**  
**GASOLINE ASPHALT CUTTING MACHINE**  
**МАШИНА ДЛЯ РЕЗКИ БЕНЗИНОВОГО АСФАЛТА**  
آلة قطع الأسفلت بنزين



**DEMİR BÜKME MAKİNELERİ**  
**REBAR BENDING MACHINES**  
**СТАНКИ ДЛЯ ГИБКИ СТАНОК**  
ماكينات ثني حديد التسليح



**HİDROLİK DEMİR KESME MAKİNELERİ**  
**HYDRAULIC REBAR CUTTING MACHINES**  
**ГИДРАВЛИЧЕСКИЕ СТАНКИ ДЛЯ РЕЗКИ**  
مكان قص الحديد الهيدروليكي



**PROFİL DEMİR KESME MAKİNESİ**  
**PROFİLE CUTTING MACHINES**  
**СТАНКИ ДЛЯ РЕЗКИ ПРОФИЛЯ**  
ماكينات قص بروفيل

