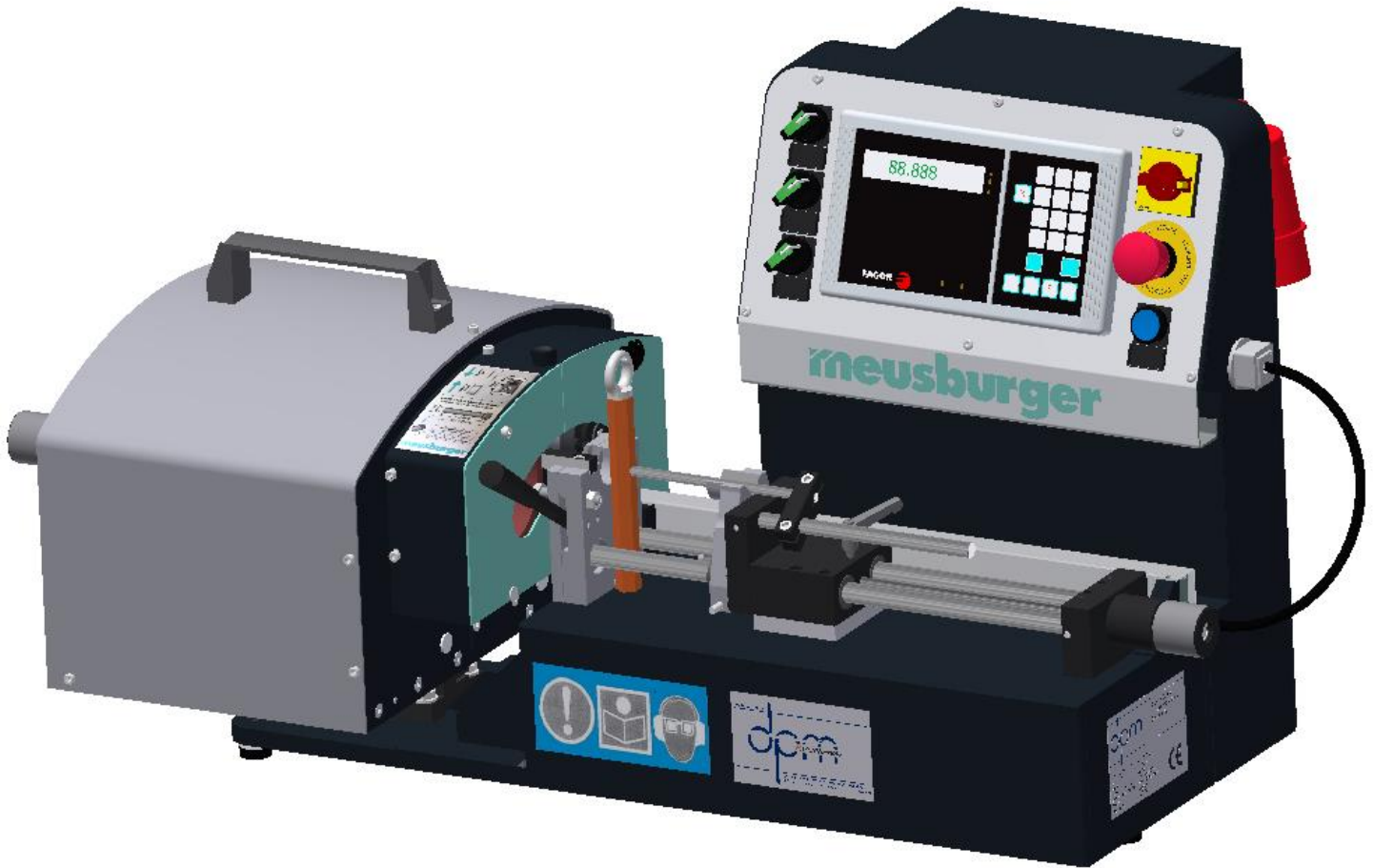


Operating Manual GMT 6000 - Precision cutting machine



Changes reserved!

No. 300.00.00550

Preface

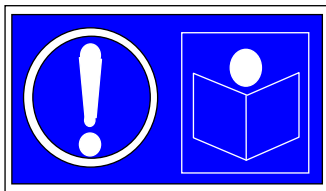
The information contained in this manual ensures that the dpm ejector cutting unit is operated safely, properly and efficiently. Following the explanations, notices and regulations:

prevents hazards and faults,

reduces repair costs and downtimes

increases reliability and the service life

of the machine. The operator must ensure that persons tasked with using, maintaining and repairing the dpm ejector cutting unit read the manual. The manual must be kept at hand in the place where the machine is used.



Not being familiar with or not observing this manual can give rise to hazards to persons!

This manual must be read carefully before the ejector cutting unit is commissioned. The instructions, particularly the safety instructions, must be followed!

This manual applies only to the "ejector cutting unit" indicated on the cover page and specified in the section on "Suitability". Before it is used outside its described field of application, it is essential to consult

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Otherwise any warranty, liability and accessory liability claims shall be void.

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Issue: 09 February 2018 Author: W. Ertel



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1 Notes about the operating manual

1.1 Note, terms, symbols

Safety	Safety regulations for safe, risk-free use of the ejector cutting unit
Operation	Information about the suitability, use, function, operation, variants and accessories
Commissioning	Information on the operation of the machine
Control	Explanation of the control elements, description of handling
Maintenance	Work that must be done for the purpose of safe operation, to maintain functional capability and to avoid hazards or faults
Faults	Explanation of the causes of faults and how to remedy them
Appendix	Illustrations, standard maintenance instruction, sample of an inspection report in accordance with the directives of the employer's liability insurance association

1.2 Pictograms

The machine and this manual carry labels that warn of hazards, stipulate or command particular actions and point out special information. It is essential to follow the notices and regulations that these highlight!



Danger!

Warning about a dangerous situation. There is a direct risk of a serious accident if the regulations and instructions are not observed!



Warning!

Warning about a possibly dangerous situation! Not following the instruction can give rise to accident risks!



Caution!

Warning about a possibly dangerous situation or damage. Not following the instructions can give rise to accident risks or damage to the ejector cutting unit.



Command!

A particular action is stipulated! Not following the command can give rise to a dangerous situation or damage!



Note!

Supplementary information about particular circumstances, explanations, descriptions, cross references, explanations of special activities or functional processes. Not following the instruction can give rise to damage. There is no accident risk.

2 Correct use in accordance to the instructions (*intended use*)

2.1 Use of the machine

Machine tool for cutting and surface grinding of cylindrical and stepped ejector pins, flat ejectors, profile stamps, punching dies, ejector bushes etc. The grinding wheels are driven by two three-phase asynchronous motors with squirrel-cage rotors by a toothed belt drive. The force exerted by the workpiece on the grinding wheel is always radial. The cup wheel can be aligned by a puller diamond and set with an adjusting screw until the wear limit is reached. The workpiece is held in place by a spring clamping prism and positioned with a stop. A linear unit with screw spindle adjustment and visual digital output facilitates the exact (0.01 mm) positioning/advance of the workpiece before cutting (separation) and subsequent surface grinding.

3 Safety

3.1 Safety directives and regulations



The following general safety regulations must be followed:

Commissioning, operation and maintenance only **after briefing and instruction by the owner and knowledge of the operating manual.**

Commissioning, operation and maintenance only by trained and qualified personnel (protective goggles and safety shoes are mandatory)

When switching on the machine, the direction of rotation of the cup wheel must be clockwise and that of the cutting wheel must be counter-clockwise, see also instructions under **5.2 Connections of the machine**

Only switch on once you have checked the safety devices function correctly.

Do not tamper with any safety devices or bypass, deactivate or remove them.

The accident prevention regulations must be observed, and all working methods that can jeopardise **work safety** are prohibited.

3.2 Safety hazards



Potential hazards if the operating manual is not followed:

If the machine is not operated, maintained or repaired in accordance with the safety regulations, or if it is operated improperly or misused, the result is




- **Hazards to the health** of operating personnel
- **Hazards to the machine** and other property belonging to the operator
- **Impairment of the machine's efficient functioning.**

If the regulations laid down in the operating manual are not observed, the manufacturers shall not be liable for the resulting damage and consequential losses!

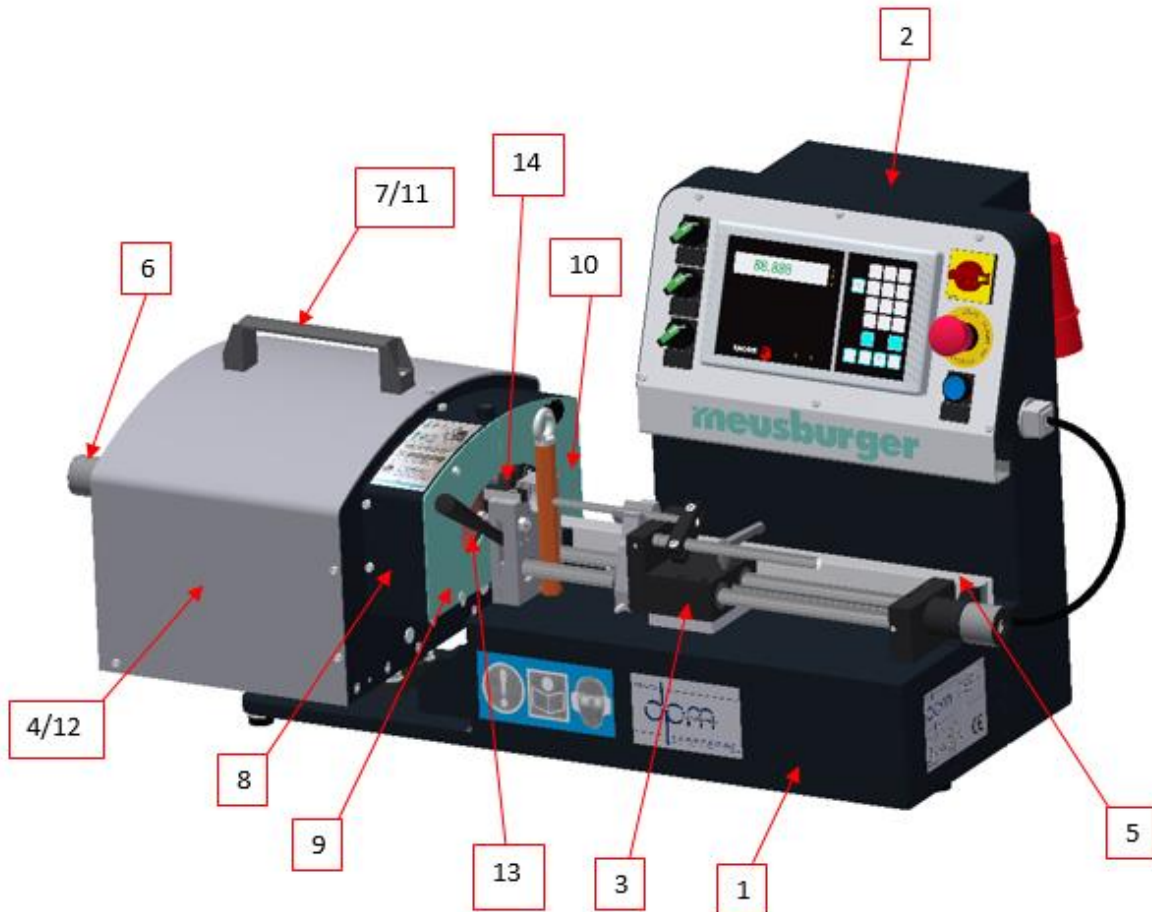
Safety hazards can occur from:

- Working at the machine without a protective cover on the grinding wheel, (unauthorized changes to the safety devices are not permitted).
- The two grinding wheels rotating in the incorrect direction
- The rotating grinding wheels when working at the machine (there is a risk of clothes, long hair or gloves being pulled into the machine).
- Force applied to the grinding wheels in the axial direction. (There is a risk of breakage of the grinding wheels).
- Operating the rocker mechanism (there is a risk of crushing between the rocker and its base).
- Working on the machine without protective goggles (danger from flying metal chips and grinding dust).
- Removing the cut-off workpiece parts (risk of burning)
- Parts can be thrown out if the grinding wheels are defective. (risk of injury).
- Inserting the shaft into the spring prism (risk of crushing fingers).
- Risk from electrostatic charging of components, personnel touching contact charged parts.
- Working at the electronic box or motor housing by touching live parts during operation. Risk from damaged lines or cables. Only trained electricians may carry out such work.
- Do not operate the machine in hazardous areas.
- Switching on the machine with the workpiece inserted
- Transportation of the machine - personal safety measures appropriate to the total weight of the machine must be taken. Additionally, the personnel must be informed about any loose or moving parts of the machine before transport. (Only trained and instructed personnel are permitted to transport the machine).
- The main switch must be switched off for maintenance, inspection or cleaning of the machine.

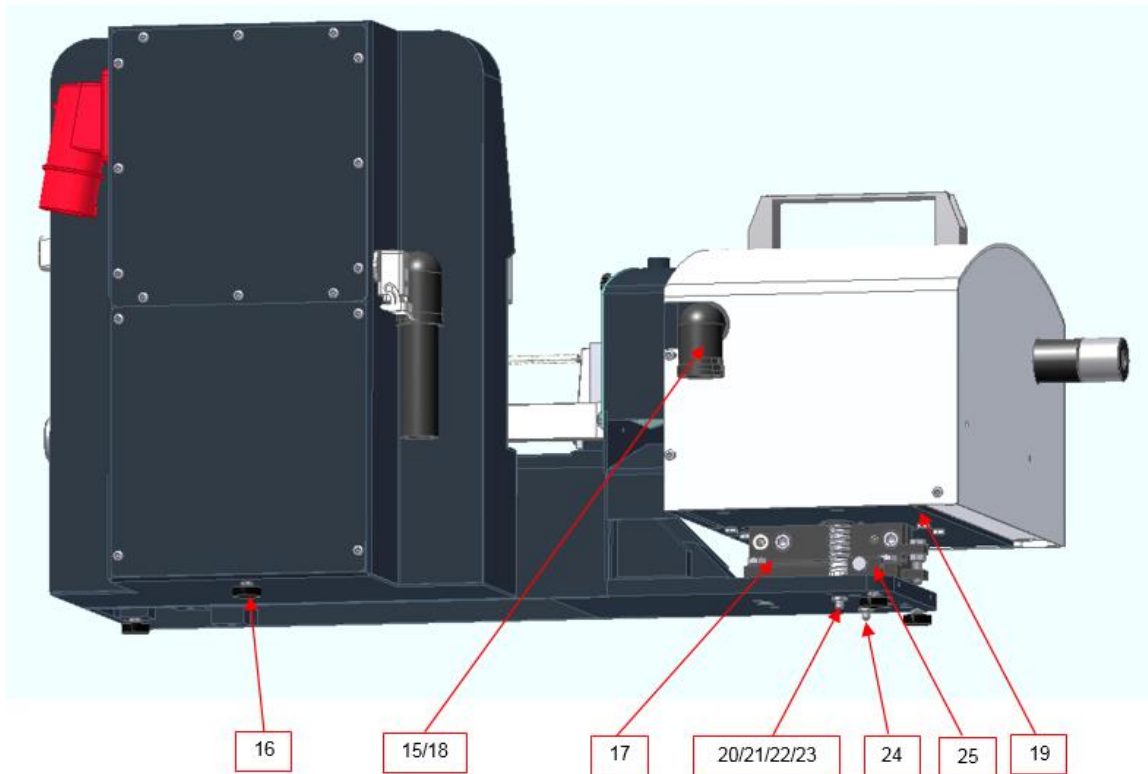
3.3 Safety symbols and safety markings of the ejector cutting unit

1	Mandatory instruction		Disconnect first, then work on the electrical installation.
2	Mandatory instruction		Wear ear protection, Wear protective goggles, First read the operating manual, then activate!
4	Warning		There is a risk of electric shock

4 Overall view

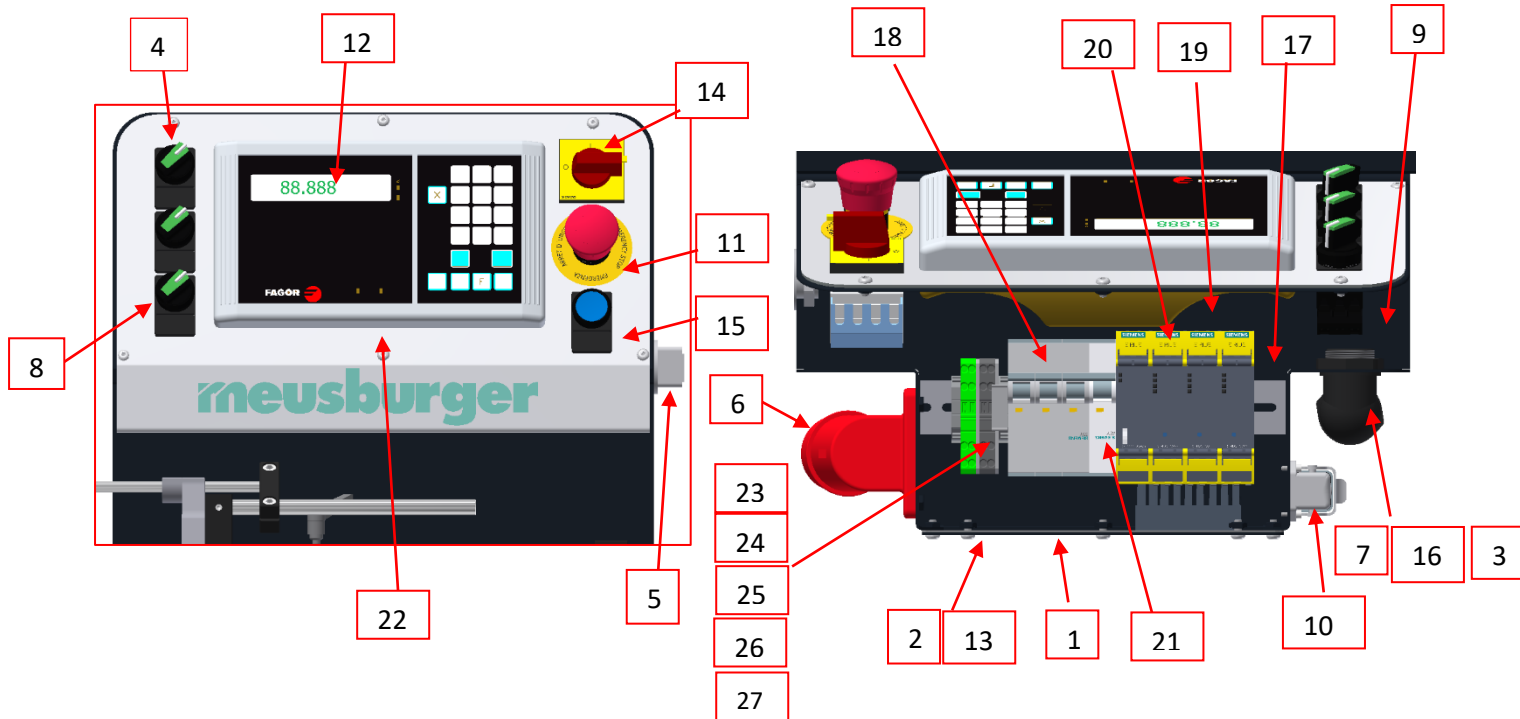


1) 300.00.00398 (1x) Base	5) 060.30.905 (1x) Glass scale MKT 37	9) 300.00.00392 (1x) Disc cover	13) 050.01.2971 Cup wheel
2) 300.00.00370 (1x) Complete control cabinet	6) 300.00.00174 (1x) Longitudinal adjustment (cup wheel)	10) 300.00.00392 (1x) Disc cover	14) 050.01.2972 Cutting wheel
3) 300.00.00403 (1x) Linear unit	7) 050.01.2744 (1x) Handle	11) 300.00.00387 (1x) Holding rail for handle	
4) 300.00.00462 (1x) Cover	8) 300.00.00390 (1x) Cover for complete grinding wheel	12) 050.01.2953 Insulation for cover	



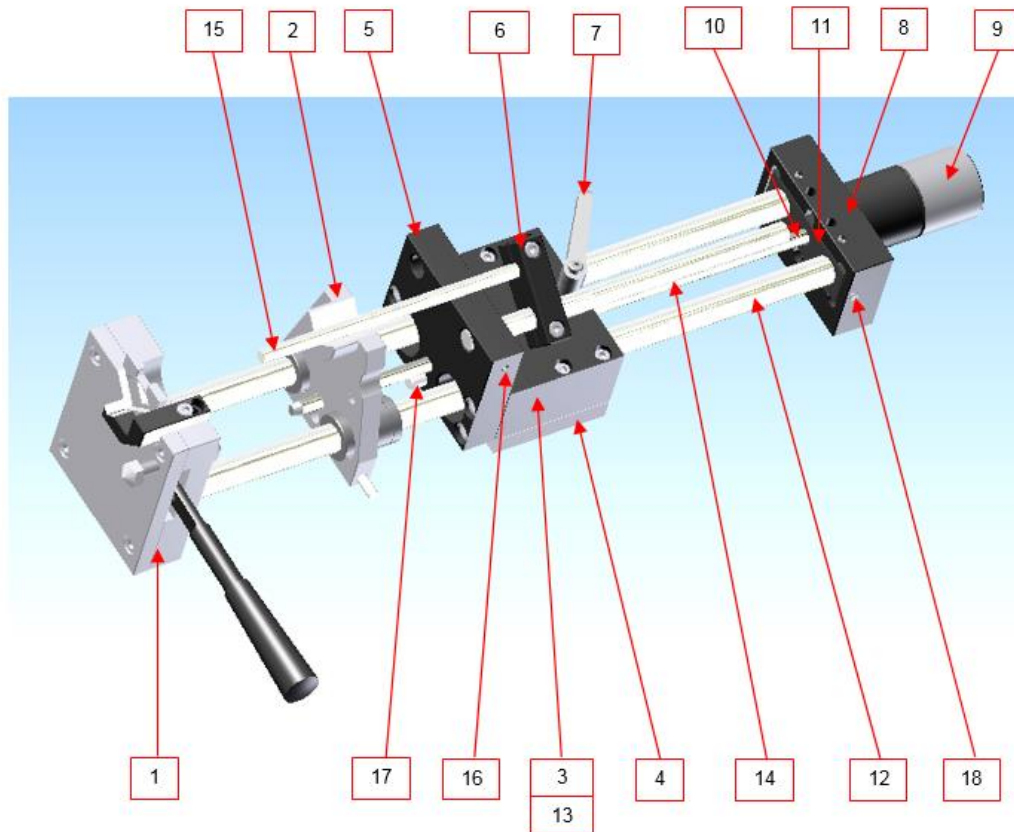
15) 050.01.2750 (1x) Corrugated pipe fitting 90°	19) 300.00.00433 (1x) Complete drive console	23) 300.00.00437 (2x) Bracket
16) 050.01.2886 (4x) Rubber-metal stop	20) 300.00.00452 (1x) Spring retainer, long	24) 300.00.00451 (1x) Spring retainer, short
17) 300.00.00359 (1x) Adjustable spindle mount	21) 050.01.2928 (2x) Pressure spring	25) 300.00.00372 (2x) Adjusting block
18) 060.80.279 (1x) Counter nut M32x1.5	22) 300.00.00436 (2x) Spring bearing	

4.1 Complete control unit



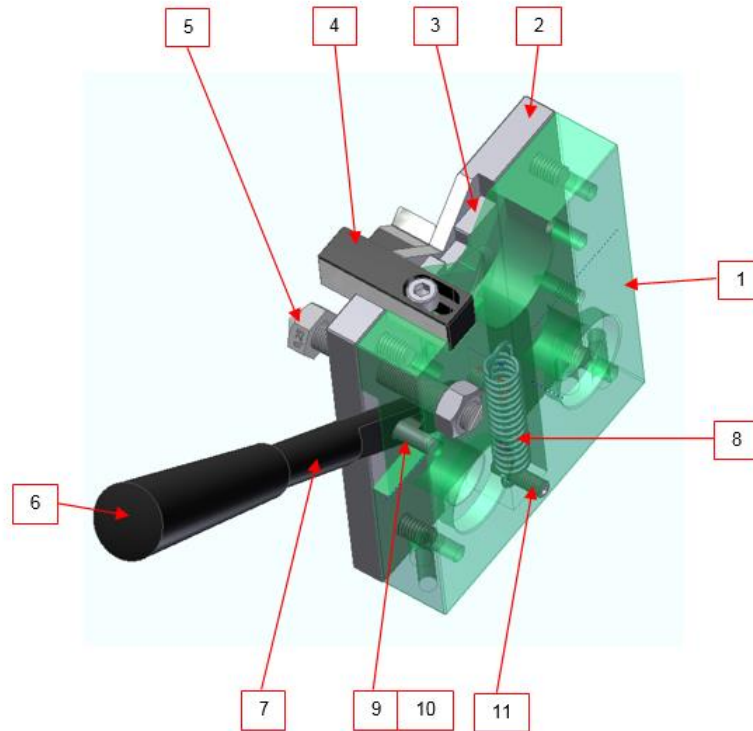
1) 300.00.00355 (1x) Bottom cover	9) 300.00.00360 (1x) Control cabinet housing	17) 060.80.008-200 (1x) DIN rail 35x7.5	25) E061.03.00160 (2x) Battle plate, grey
2) 300.00.00367 (1x) Electrics box cover	10) E061.04.00001 (1x) Mounting case, angled	18) E061.12.00303 (1x) 3-pin circuit breaker	26) E061.03.00150 (2x) 4-wire circuit terminal 2,5mm ²
3) 050.01.2750 (1x) Corrugated pipe fitting 90°	11) 061.13.00262 (1x) Emergency stop pushbutton	19) E061.24.14000 (1x) Safety relay	27) E061.03.09050 (1x) Group tag holder
4) 061.13.00384 (3x) Illuminated toggle switch	12) 060.30.904 (1x) Innova Display	20) E061.24.14001 (3x) Sirius motor starter	
5) 061.51.12111 (1x) Cable gland	13) 300.00.00368 (1x) Dichtung El.-Box	21) E061.12.00002 (1x) 1.pin circuit breaker	
6) E061.04.70000 (1x) CEE-plug	14) E061.09.00003 (1x) Main / emergency-stop switch	22) 300.00.00426 (1x) Operating Panel, angled	
7) 050.01.2751 (1x) Corrugated pipe PUR NW 29	15) 061.13.01024 (1x) Illuminated pushbutton, blue	23) E061.03.09000 (2x) End clamp TS 35	
8) 061.52.02040 (4x) Tag labelling	16) 060.80.279 (1x) Counter Nut M32x1.5	24) E061.03.00154 (2x) 4-wire circuit terminal 2,5mm ²	

4.2 Complete linear unit – 300.00.00403



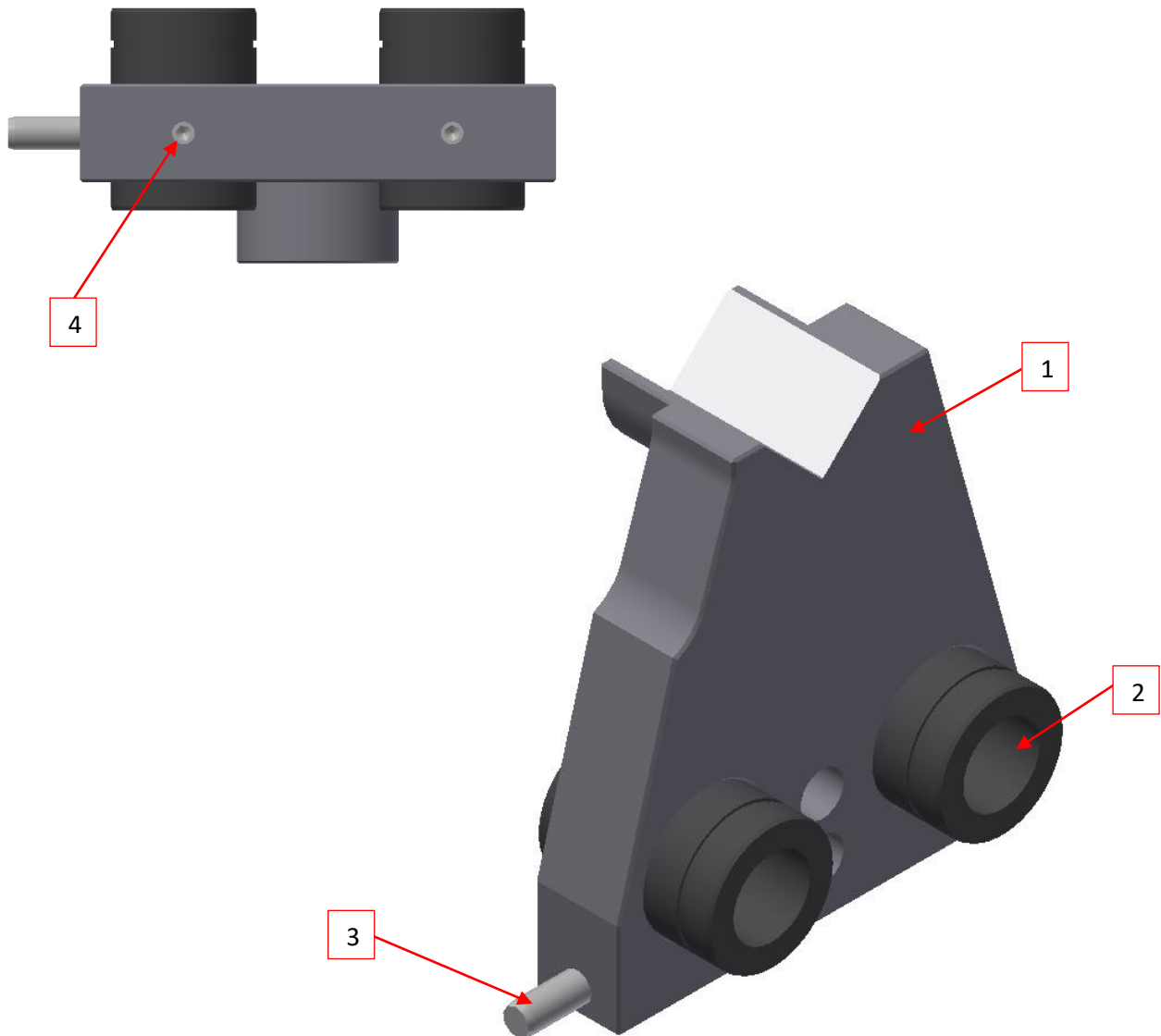
1) 300.00.00382 (1x) Clamping prism	7) 050.01.2713 (1x) Clamping lever	13) 050.01.2718 (4x) Ball lining Ø16
2) 300.00.00401 (1x) Support prism	8) 300.00.00379 (1x) Carriage guide bracket, outer part	14) 050.01.2715 (1x) Hardened precision shaft Ø12h6
3) 300.00.00173 (1x) Carriage base	9) 300.00.00174 (1x) Length adjustment	15) 050.01.2716 (1x) Hardened precision shaft Ø8h6
4) 300.00.00386 (1x) Monitoring car holder	10) 300.00.00466 (1x) Shaft for length adjustment	16) Threaded pin (1x) ISO 4026-M6x16
5) 300.00.00166 (1x) Carriage face plate	11) 300.00.00009 (1x) Carriage guide bracket, inner part	17) Hardened cylinder pin (1x) ISO 8734-8x50
6) 300.00.0456 (1x) Stop part	12) 050.01.2714 (2x) Hardened precision shaft Ø16h6	18) Threaded pin (6x) ISO 4026-M6x8

4.3 Clamping prism – 300.00.00382



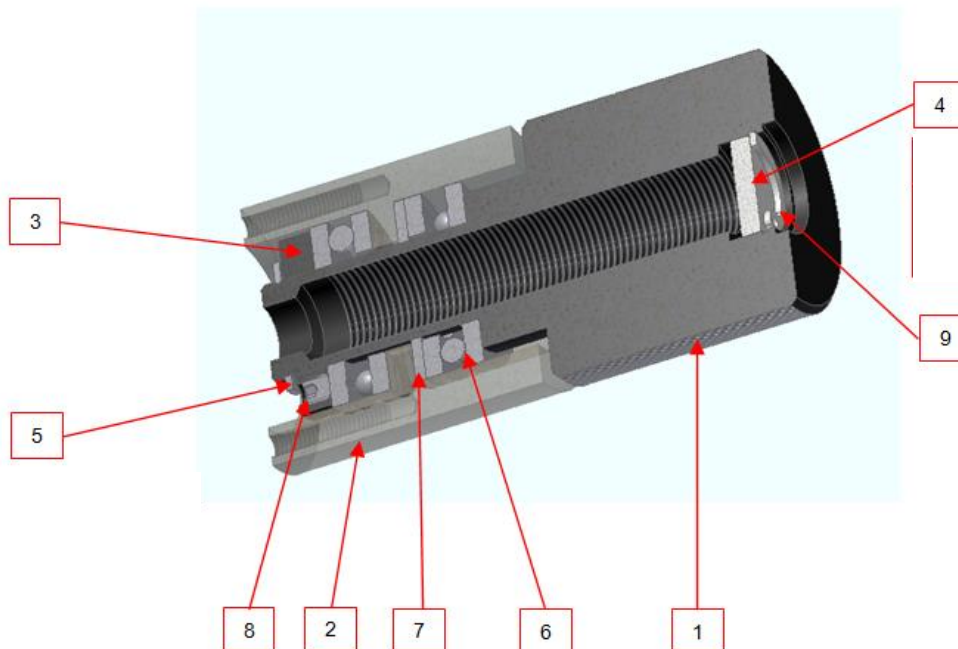
1) 300.00.00380 (1x) Clamping prism base plate	5) 050.01.2770 (1x) Dressing diamond	9) Hardened cylinder pin (2x) ISO 8734-5x24
2) 300.00.00162 (1x) Push-pull device guide	6) 050.01.2712 (1x) Cone handle	10) Hardened cylinder pin (1x) ISO 8734-5x10
3) 300.00.00161 (1x) Push-pull device	7) 300.00.00036 (1x) Lever	11) Threaded pin (1x) ISO 4026-M5x16
4) 300.00.00163 (1x) Support	8) 050.01.2892 (1x) Control spring $\varnothing 10 \times 35.3 \times \varnothing 1.4$	12) Threaded pin (1x) ISO 4026-M5x16

4.4 Support prism – 300.00.00401



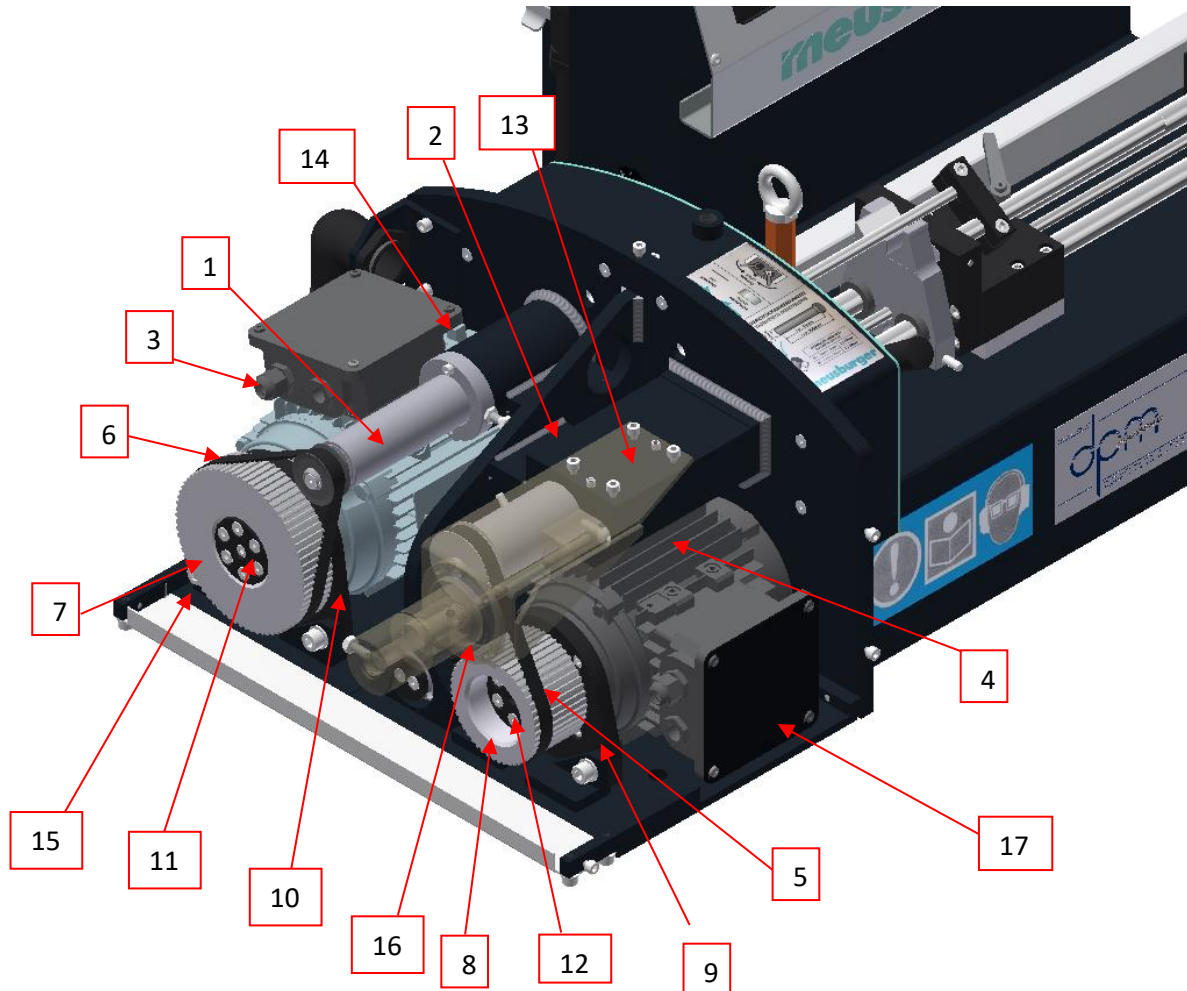
1) 300.00.00402 (1x) Support prism plate	3) Hardened cylinder pin (1x) ISO 8734-6x20
2) 050.01.2718 (2x) Bushing	4) Hexagon socket set screw with truncated cone (2x) ISO 4026 M5x8 – 45 H 2x

4.5 Length adjustment – 300.00.00174

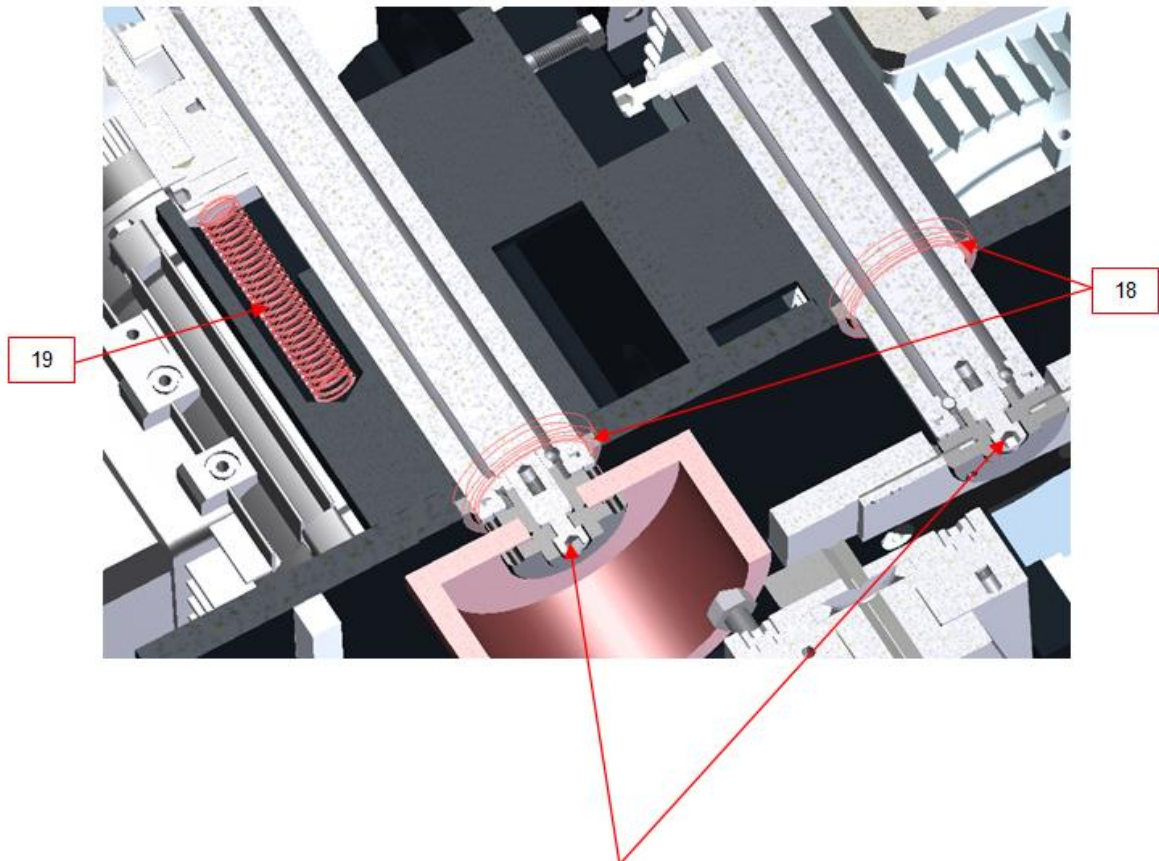


1) 300.00.00175 (1x) Adjustment bush	5) Retaining ring (1x) DIN 471 - 15x1	9) Retaining ring (1x) DIN 472 - 15x1
2) 300.00.00011 (1x) Support	6) Axial deep groove ball bearings (2x) 050.31.910 (Ø15 x Ø28 x 9)	
3) 300.00.00014 (1x) Washer disc	7) 050.01.2899 adjusting washer (1x) Ø15 x Ø28 x 1	
4) 300.00.00396 (1x) Washer	8) Threaded pin (3x) ISO 4026-M4x4	

4.6 Pivoting motor base



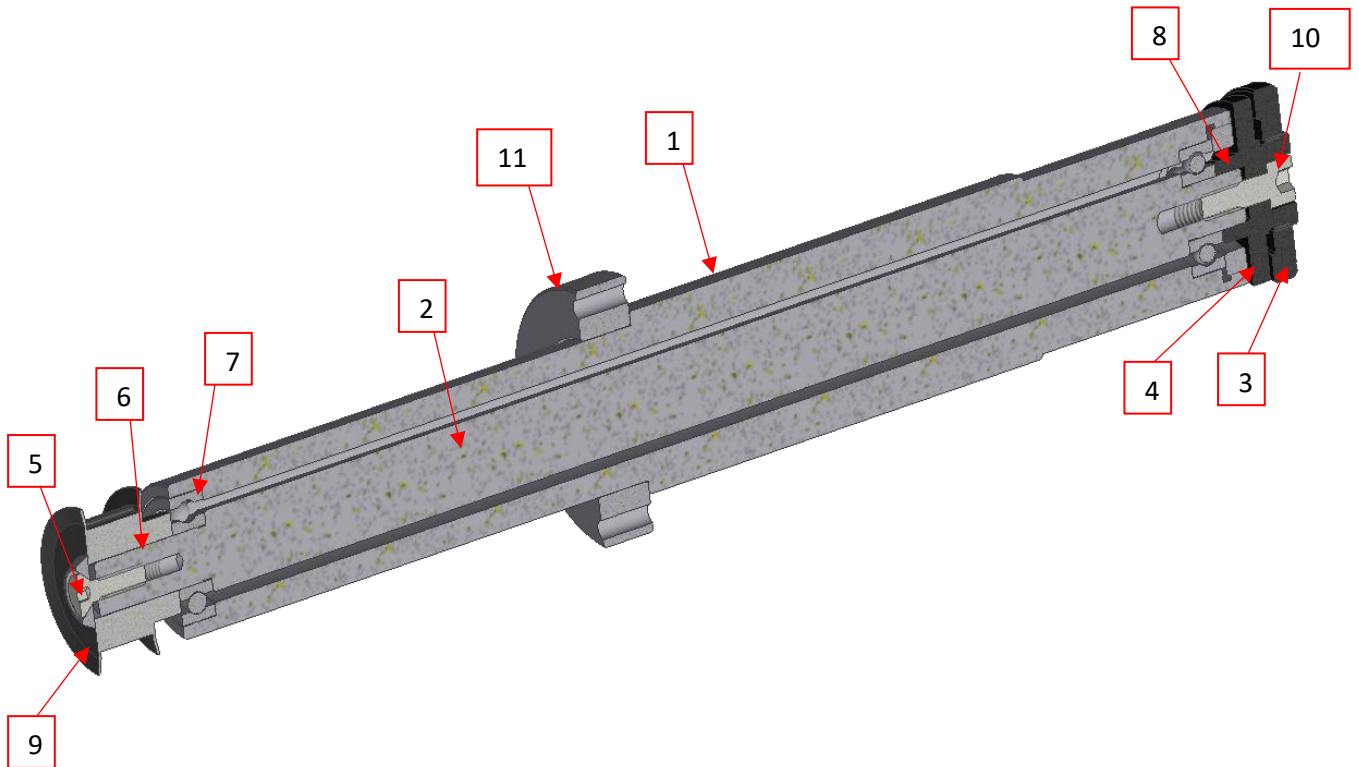
1) 300.00.00409 (1x) Cutting wheel grinding spindle	7) 300.00.00194 (1x) Pulley T5/Z72	13) 300.00.00352 (1x) angel f. adjustment
2) 300.00.00407 (1x) Cup wheel grinding spindle	8) 300.00.00186 (1x) Pulley T5/Z48	14) 300.00.00412 (1x) Stop ring
3) 060.07.051 (1x) Three-phase asynchronous motor 0,75 kW	9) 300.00.00427 (1x) Mounting flange f. motor kl.	15) 300.00.00423 (1x) Perforated sheet
4) 060.07.050 (1x) Three-phase asynchronous motor 0,37 kW	10) 300.00.00428 (1x) Mounting flange f. motor gr.	16) 300.00.00063 (1x) Delivery agent
5) 050.01.2747 (1x) Toothed belt T5 Z78	11) 300.00.00195 (1x) Connecting washer	17) 300.00.00235 (1x) Engine cover
6) 050.01.2746 (1x) Toothed belt T5 Z90	12) 300.00.00187 (1x) Connecting washer	18) 050.01.2748 (2x) Scraper Ø40xØ48,6x7
		19) 300.00.00094 (1x) Scraper Ø14 x 1 x 160



Info! M6 bolts glued with VBA 2M70 (Meusburger)!

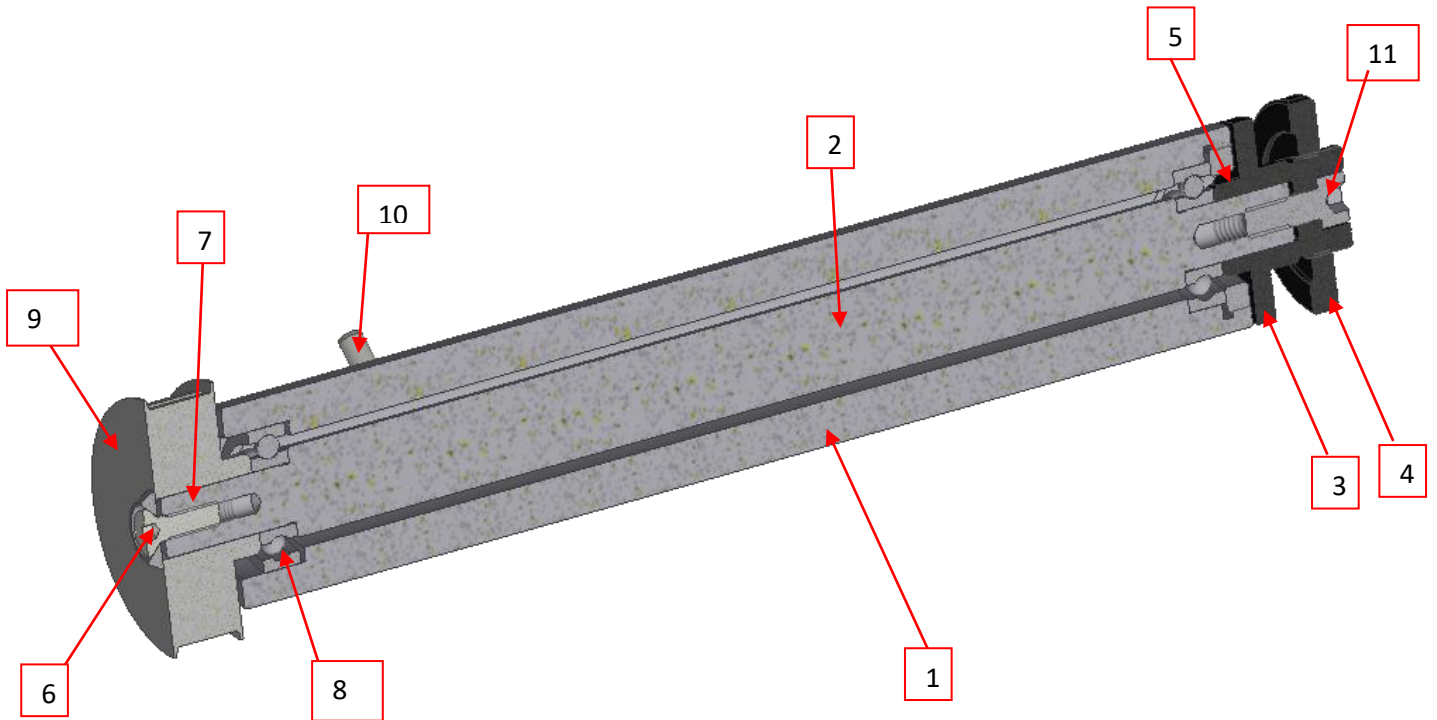
Cylinder head screw M6 14Nm tightening torque!

4.7 Grinding spindle / cutting wheel – 300.00.00409



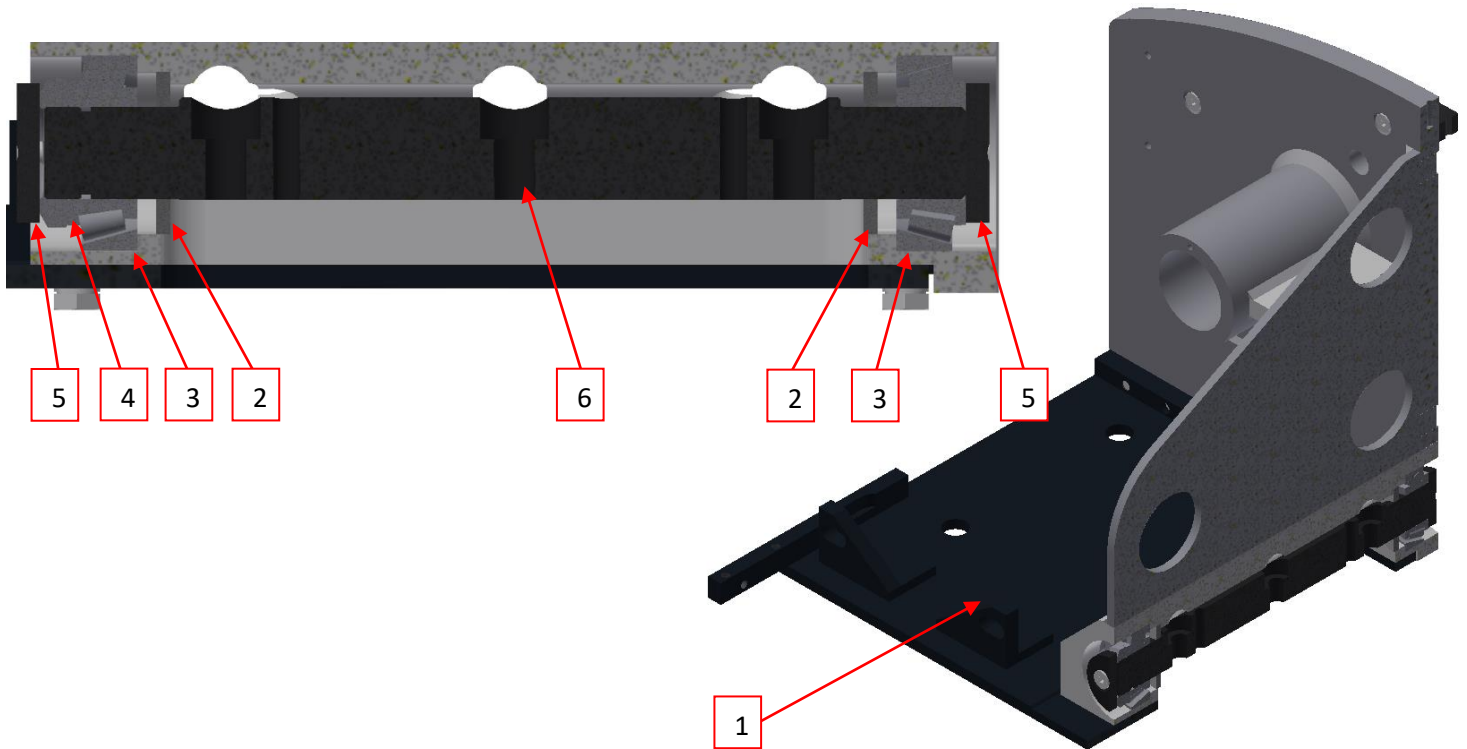
1) 300.00.00408 (1x) Grinding spindle sleeve	5) 300.00.00055 (1x) Washer	9) 300.00.00182 (1x) Toothed belt pulley T5 Z19
2) 300.00.00048 (1x) Grinding spindle shaft	6) Fitting key (1x) DIN 6885 A4x4x18	10) Cylinder head bolt ISO 4762 M6x16-12.9 (1x)
3) 300.00.00393 (1x) Clamping nut	7) 050.31.015 (2x) deep groove ball bearings DIN 625 SKF 6001-2RS1	11) stop ring (1x) 300.00.00412
4) 300.00.00050 (1x) Disc flange, inside	8) 300.00.00052 (1x) Threaded ring	

4.8 Grinding spindle / cup wheel – 300.00.00407

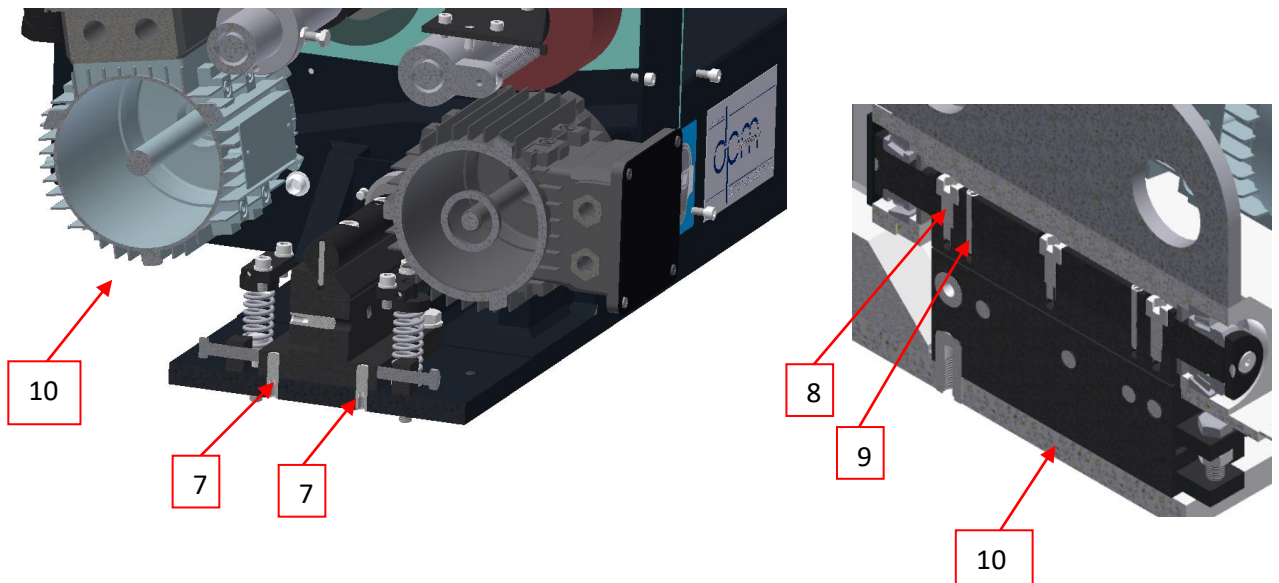


1) 300.00.00045 (1x) Grinding spindle sleeve	5) 300.00.00052 (1x) Threaded ring	9) 300.00.00185 (1x) Toothed belt pulley T5 Z30	
2) 300.00.00406 (1x) Grinding spindle shaft	6) 300.00.00055 (1x) Washer	10) Cylindrical pin hardened (ISO 8734-5x16) (1x)	
3) 300.00.00223 (1x) Disc flange inside, Left-handed	7) Adjusting spring (1x) DIN 6885 A4x4x18	11) 050.01.2887 (1x) ISO 4762 M6x16-12.9 Left-hand thread	
4) 300.00.00394 (1x) Clamping nut, left-hand thread.	8) 050.31.015 (2x) Deep groove ball bearings DIN 625 SKF 6001-2RS1		

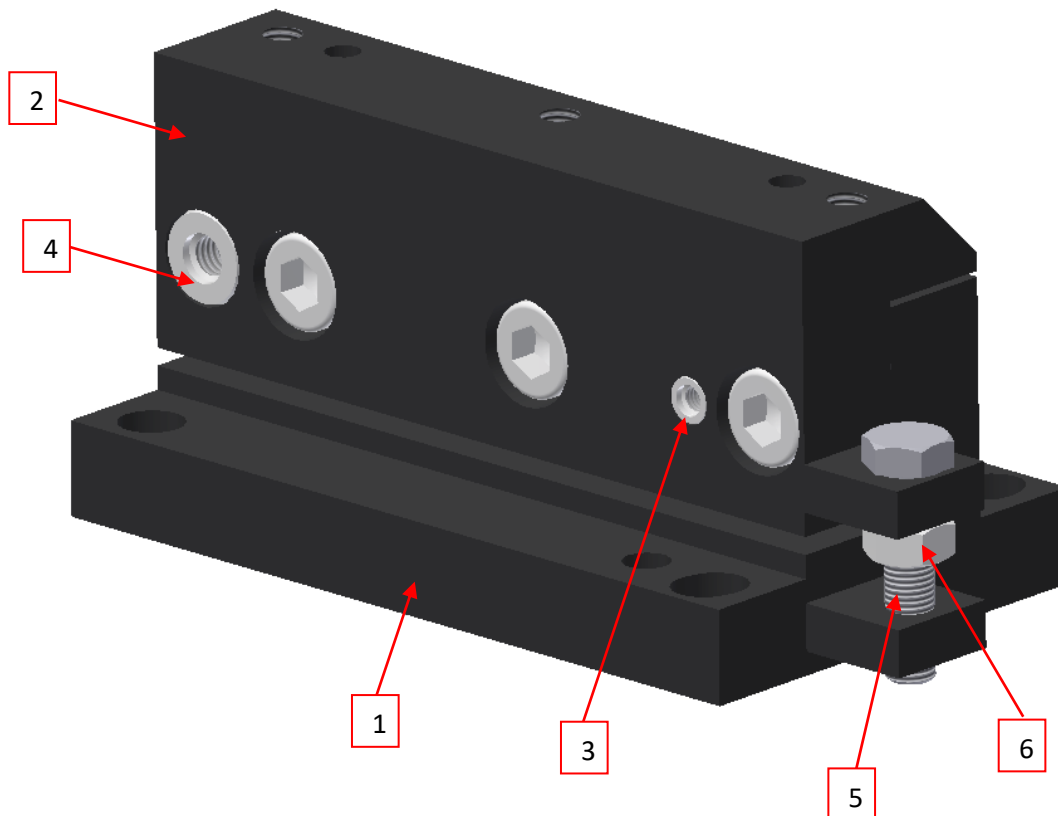
4.9 Rocker bearing



1) 300.00.00433 (1x) ASY drive bracket	4) 050.01.3010 (1x) Locknut	7) ISO 8735-8x30 (2x) Cylinder Pin
2) 300.00.00004 (2x) Rubber ring Ø35x20x3	5) 300.00.00146 (2x) washer	8) ISO 4762 M8x20 (3x) Cylinder head screw
3) 050.31.911 (2x) Kegelrollenlager, DIN 720 SKF	6) 300.00.00371 (1x) shaft	9) ISO 8735-6x30 (2x) Cylindrical pin
10) 300.00.00550 DPM-Double-Grind		



4.10 Spindle bearing – 300.00.00359



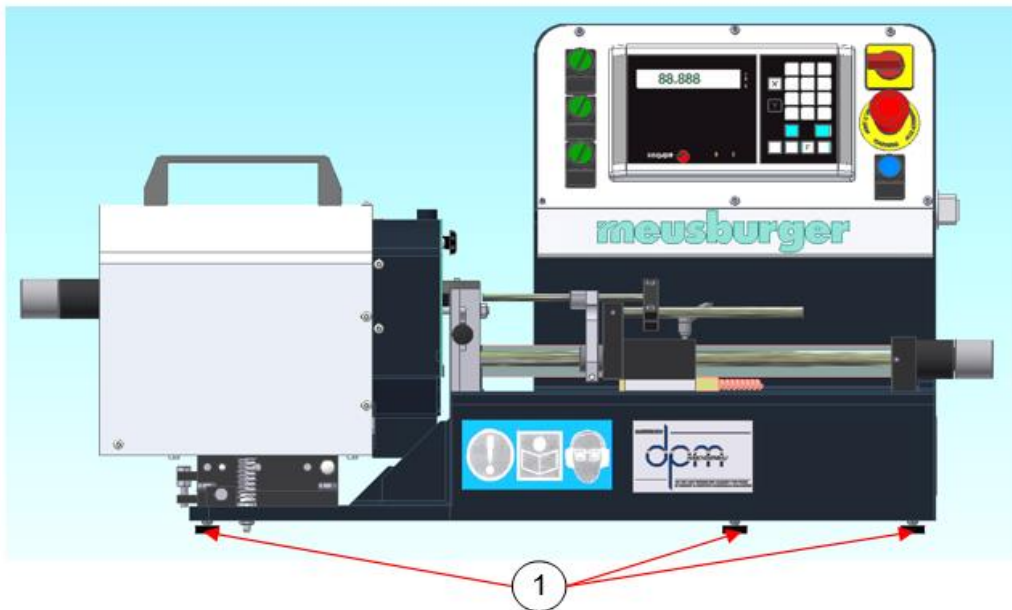
1) 300.00.00357 (1x) Base holder	4) ISO 8735-16x40 Cylinder pin (1x)	
2) 300.00.00358 (1x) Top section holder	5) 050.01.2896 (1x) Hexagon screw M8x1x35 DIN 961	
3) ISO 8734-8x30 (1x) Cylinder pin	6) 050.01.2897 / DIN 934 (1x) Hexagon nut M8x1	

4.11 Technical Data

Weight	120 kg
Dimensions (L x W x H)	970 x 540 x 520 mm
Electrical connection	2x 400 V
Motor power, cutting	0.75 kW
Motor power, grinding	0.37 kW
Cutting wheel speed	10700 rpm
Cup wheel speed	4400 rpm
Cutting wheel Ø	100/20x1 mm
Cup wheel Ø	100/20x50 mm
Grinding range Ø	1-20 mm
Stop Ø ejector head	≥ 3mm
Workpiece length, direct reading	370 mm
Max. workpiece length	460 mm

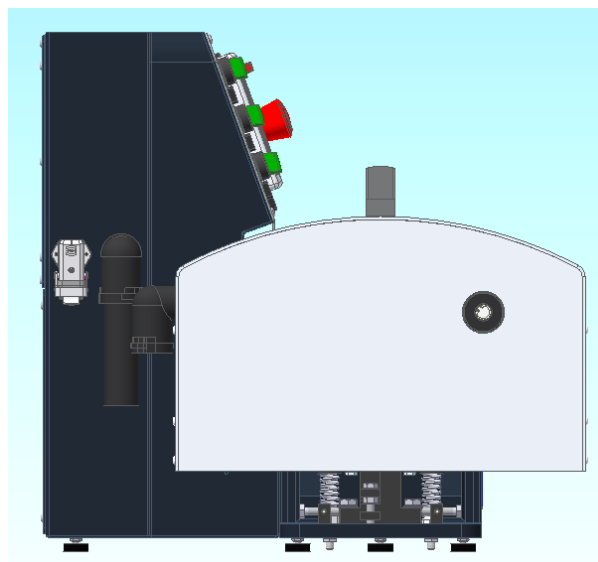
5 Operation

5.1 Setting up the machine

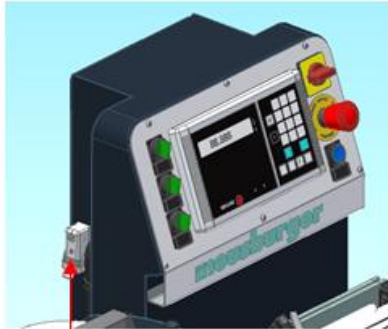


1 Device foot

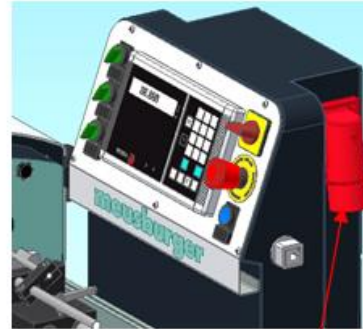
- Place the machine on a level surface (e.g., substructure GMT 60002 or work bench).
- Make sure that the machine is only standing on its four legs.
- Allow sufficient space in the front and rear of the machine to ensure the rocker mechanism is not blocked.



5.2 Machine connections

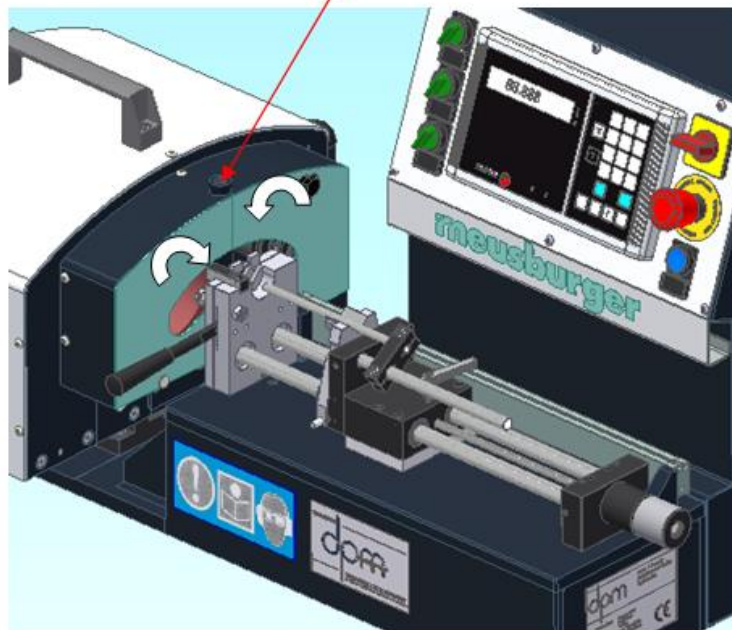


3A mounting case
230V/16A 50Hz for
coolant pump



Threaded connection
G 1/4" for coolant supply

Cekon plug
400V/16A 50Hz with
phase inverter

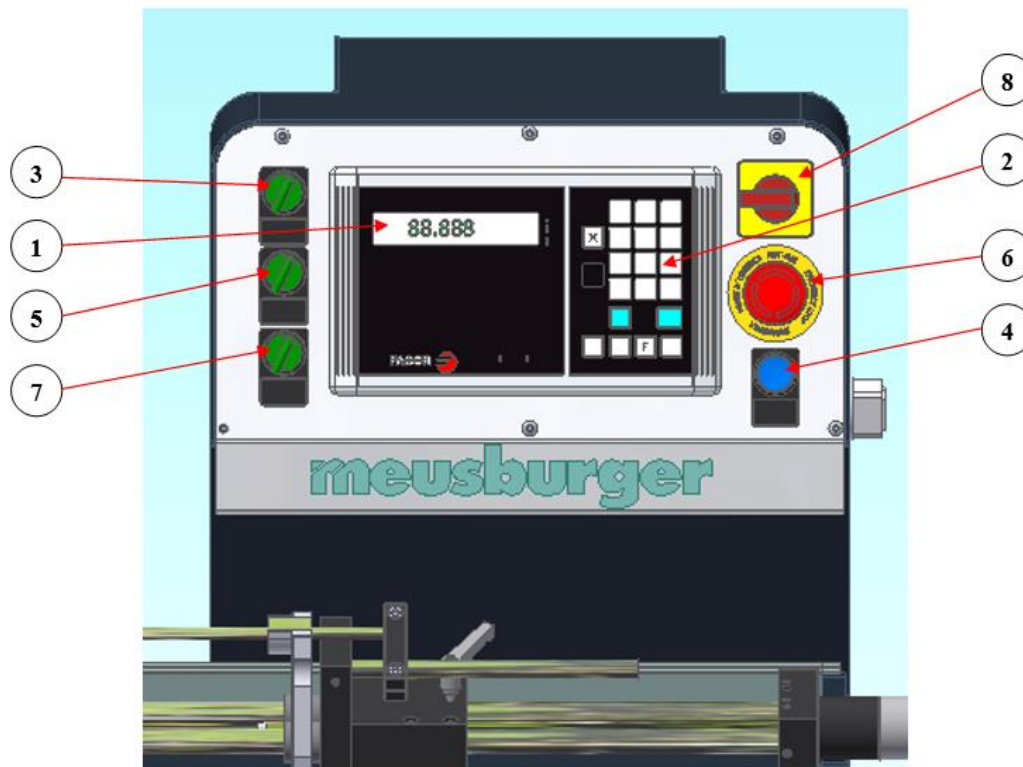


Note!

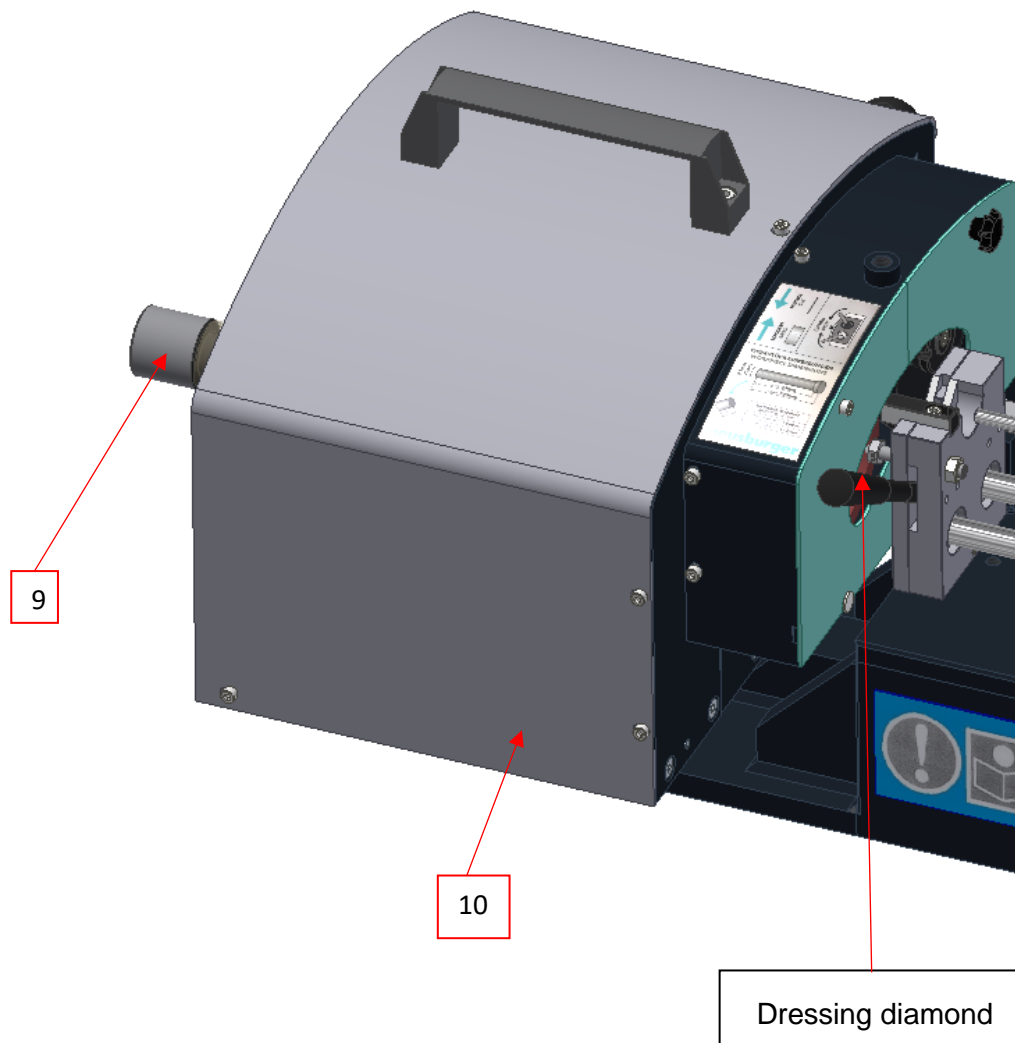
When you first turn on the machine, make sure the grinding wheel has the correct direction of rotation. If this does not correspond to the direction shown above, the rotating field must be changed by turning the phase inverter at the Cekon plug. **Caution:** This may only be done by trained electricians!

5.3 Controls and displays

The machine has the following controls and displays



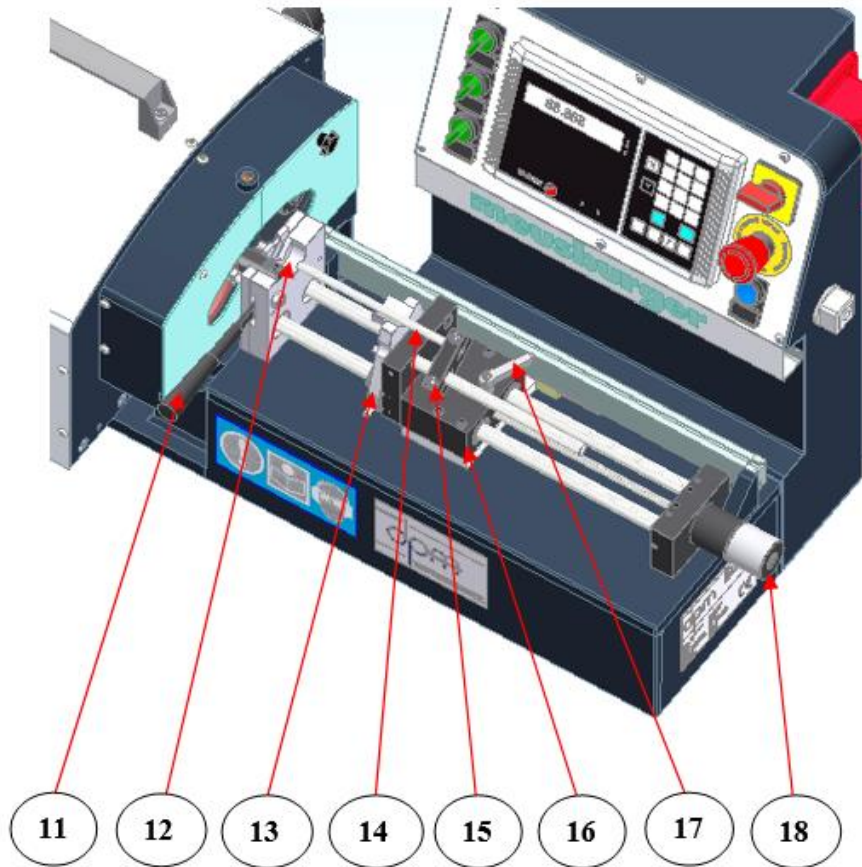
- 1 Digital display preset to 1/100 - millimetre division
- 2 Control for setting and configuring the display
- please observe separate instructions from the Fagor company
- 3 Cutting wheel on/off toggle switch
- 4 Acknowledge emergency stop illuminated pushbutton
- 5 Surface grinding machine (cup wheel) on/off toggle switch
- 6 Emergency stop mushroom pushbutton
- 7 Coolant pump on/off toggle switch (only for wet grinding unit)
- 8 Main switch



9 Adjusting screw for dressing the cup wheel

Caution! Set only when the motor is running, otherwise the belt breaks!

10 Rocker mechanism



- 11 Workpiece clamping lever
- 12 Clamping prism
- 13 Support prism
- 14 Stop shaft
- 15 Fixing screw for the stop shaft
- 16 Carriage
- 17 Clamping lever for carriage
- 18 Fine adjustment for carriage

Do not use force to turn beyond the stop!

5.4 Switching on

- 1) Connect the machine to the 400V/AC power supply
- 2) Turn main switch (8) to position "I"
- 3) Enable the drives by pressing the illuminated pushbutton (4). When the drives are enabled it lights up blue
- 4) Turn toggle switch to the right for cut-off grinding and/or surface grinding (3)/(5). The toggle switch is lit green during activation.
→ The workpiece must not be inserted!

5.5 Switching off

- 1) Turn toggle switch to the left for cut-off grinding and/or surface grinding (3)/(5). The green light in the toggle switch goes out.
- 2) Caution: The discs continue to run for approx. 5 secs
- 3) Turn main switch (8) to position "O"

5.6 Dressing the grinding wheel

- 1) Switch on the grinding spindle (see 5.4)
- 2) Move the grinding wheel in front of the dressing diamond by pressing and pulling on the handle of the rocker mechanism (10).
- 3) Position the grinding wheel at the dressing diamond by rotating the adjusting screw (9)
- 4) Repeat the rocking motion and the positioning until the grinding wheel is cleanly disconnected.

5.7 Inserting a workpiece

- 1) When machining $\varnothing 1\text{mm}-\varnothing 20\text{mm}$, first start the cutting wheel or the cup wheel before the workpiece is inserted because the rocker mechanism oscillates place and therefore the inserted part can collide with the grinding wheels.
- 2) Press down the clamping lever (11). The push-pull device pushes itself upward.
- 3) With the clamping lever pressed, place the workpiece through the mounting hole in the push-pull device onto the support prism (12).
- 4) Guide the clamping lever (11) downwards until the workpiece is held by the push-pull device.

5.8 Referencing "obtaining zero position"

- 1) Switch on the grinding wheel (see 5.4)
- 2) Release the carriage clamp with the clamping lever (17).
- 3) Adjust the stop shaft (14) by releasing the two fixing screws (15) on the prism.
- 4) Push the stop shaft with carriage (16) to just (approx. 1 mm) before the grinding wheel and fix with the clamping lever (17).
- 5) Move the grinding wheel in front of the stop shaft (14) by pressing and pulling on the handle of the rocker mechanism (10).
- 6) Using the fine adjustment (18), place the stop shaft on the grinding wheel and slightly "scratch" it.
- 7) Digital display "Reference", see manual from Fagor, Chapter 2.3
- 8) Release the clamping lever (17) on the carriage and move it freely toward the rear until the clamping mechanism is free to accept a workpiece.
- 9) Insert the workpiece (see 5.7)
- 10) With the stop shaft on the carriage (16), push the workpiece shortly before the desired cutting size (approx. 0.5mm). To do this, keep the push-pull device open by pressing the clamping lever (11).
- 11) Fix the clamping lever for the carriage (17) and set the carriage to the required cutting size using the fine adjustment (18).

5.9 Cut-off grinding

- 1) Switch on the cutting wheel (see 5.4)
- 2) Obtain zero (reference) (see 5.8)
- 3) By pulling the rocker mechanism, attach the cutting wheel to the workpiece and draw it through quickly.
- 4) **Please note:** The workpiece is now approximately 0.1-0.3mm longer than shown on the digital display

5.10 Surface grinding

- 1) Switch on the grinding wheel (see 5.4)
- 2) Press the rocker mechanism to move the grinding wheel over the workpiece and overtighten 3-4 times until there are almost no more flying sparks.
- 3) Switch off the grinding wheel(s) (see 5.5/(1)) and remove the workpiece.

5.11 Emergency stop

- 1) The emergency stop (6) can be pressed at any time and switches off the power to the drives.
- 2) The green lights of the toggle switch (3)/(5) of the grinding wheels and the blue lights on the illuminated pushbutton (4) go out.
- 3) **Caution:** The grinding wheels continue to run for approx. 5 secs.

5.12 Acknowledge the emergency stop

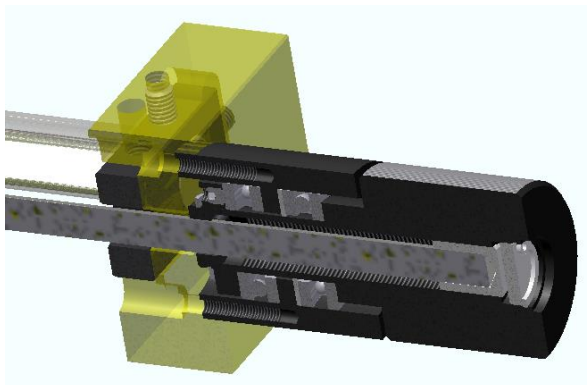
- 1) Before re-commissioning after an emergency stop, the operator must ensure that the cause for the emergency stop has been eliminated in full!
- 2) Unlock the emergency-stop mushroom pushbutton by turning it clockwise.
- 3) Turn the toggle switch (3)/(5)/(7) to the left (only for wet grinding unit)
- 4) Enable the drives by pressing the illuminated pushbutton (4). When the drives are enabled it lights up blue The machine is now ready for operation again.

6 Care and maintenance

Maintenance, repair and troubleshooting measures:

- The ejector cutting unit should be regularly serviced and cleaned by a skilled expert.
- The machine bearings are permanently lubricated and do not require any maintenance.
- It is strictly prohibited to blow out the machine with compressed air because the sanding dust may settle in the mechanisms.
- The carriage guide and the support prism must only be cleaned using a dry cloth.

Adjustment

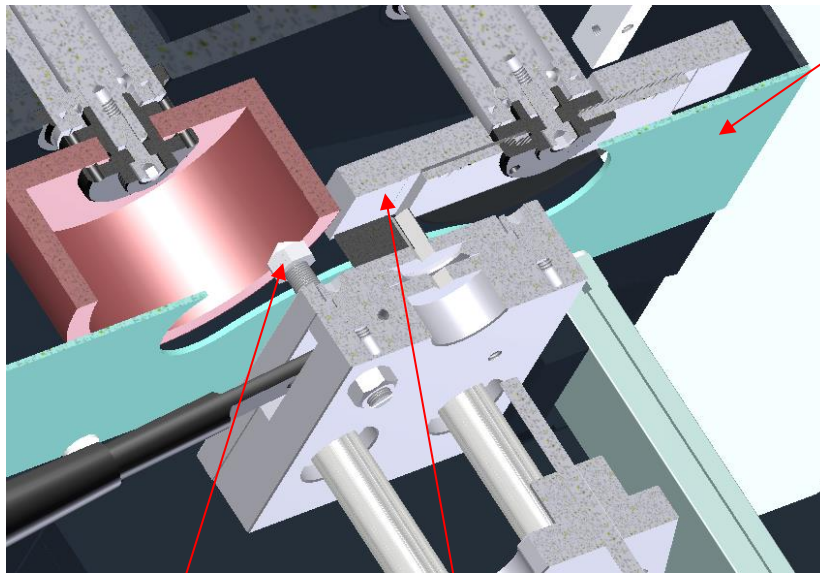


The length adjustment and the cup wheel adjustment should be oiled semi-annually.

The retaining ring and the washer are removed for this, and the thread is oiled with VLS 250 (Meusburger). Then the washer and the retaining ring are re-inserted.

Caution: Only adjust the cup wheel when the motor is running, otherwise the belt will break!

Diamond setting for dressing the cup wheel (with adjustment plate)



Disassemble the right disc cover!

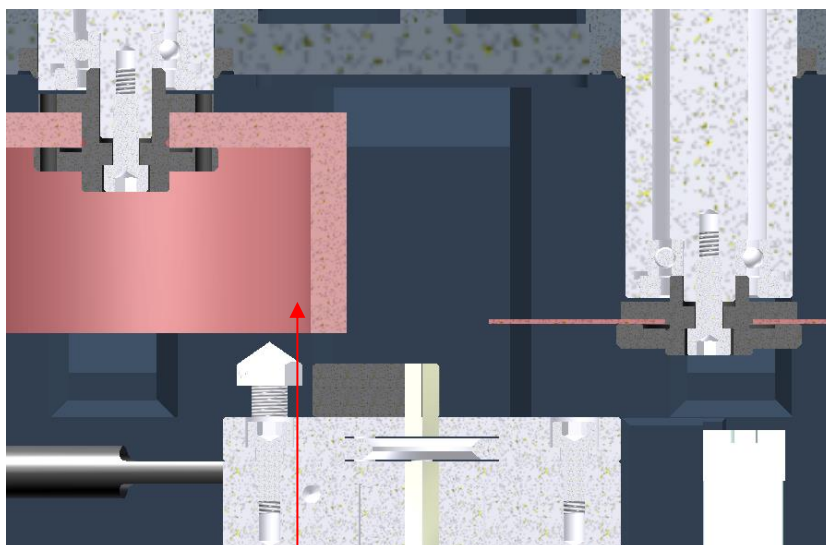
To set the dressing diamond to the desired position relative to the cutting wheel, the adjustment plate (optional) is screwed on to the spindle instead of the cutting wheel. The possible adjustment size is 0.1mm or 0.15mm to the cutting wheel. The adjustment plate should be mounted accordingly. Now, using the rocker function, the adjustment plate is drawn to the dressing diamond and this is screwed on and then secured with the tip up to the set surface. **Caution! After the adjustment is made, the cutting wheel and the disc cover must be re-mounted!**

Dressing diamond

300.00.00411 Adjustment plate for dressing diamond (optional)

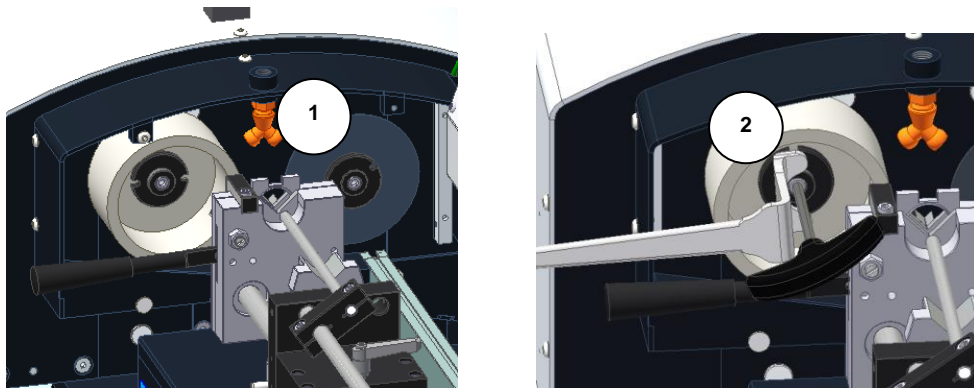
Caution: Only adjust the cup wheel when the motor is running, otherwise the belt will break!

Diamond setting for dressing the cup wheel (without adjustment plate)



Place the dressing diamond approx. 0.1mm before the cutting wheel

Caution! Only work with the emergency stop actuated!
Replacing the grinding wheel (cutting wheel/cup wheel)



Function:

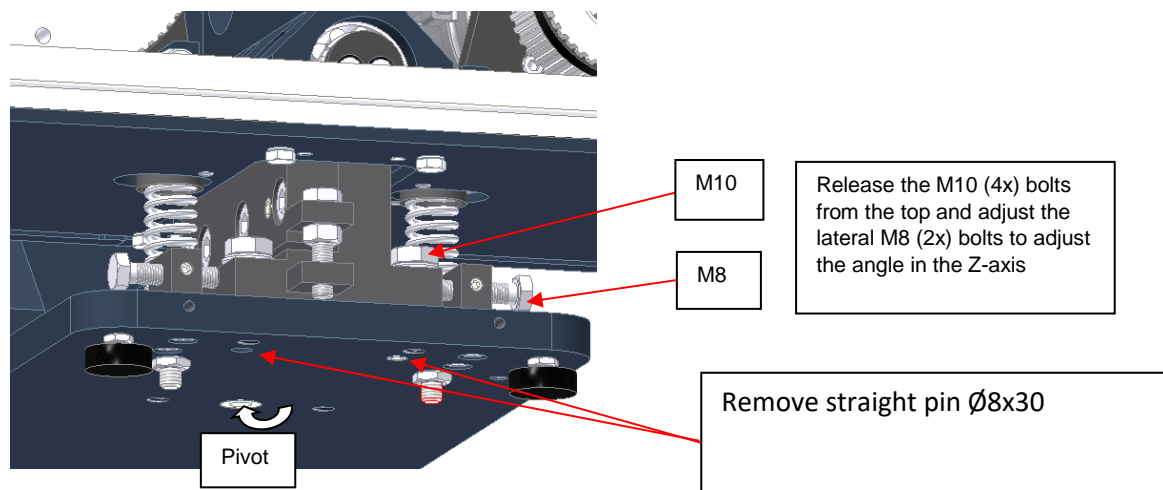
(Fig. 1) Disassemble the front covers.

(Fig. 2) Hold the hex key sw5 and loosen the 2-punched disk with its corresponding angled key to replace the grinding wheels.

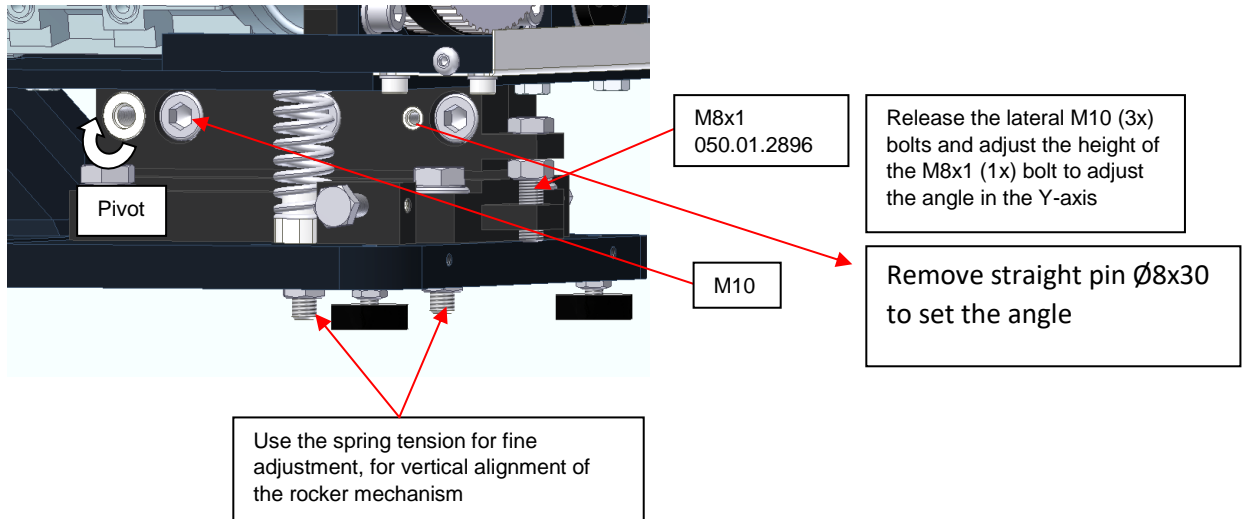
(cup wheel - left-hand thread / cutting wheel - right hand thread) The covers must then be re-mounted!

Caution! Only work with the emergency stop actuated!

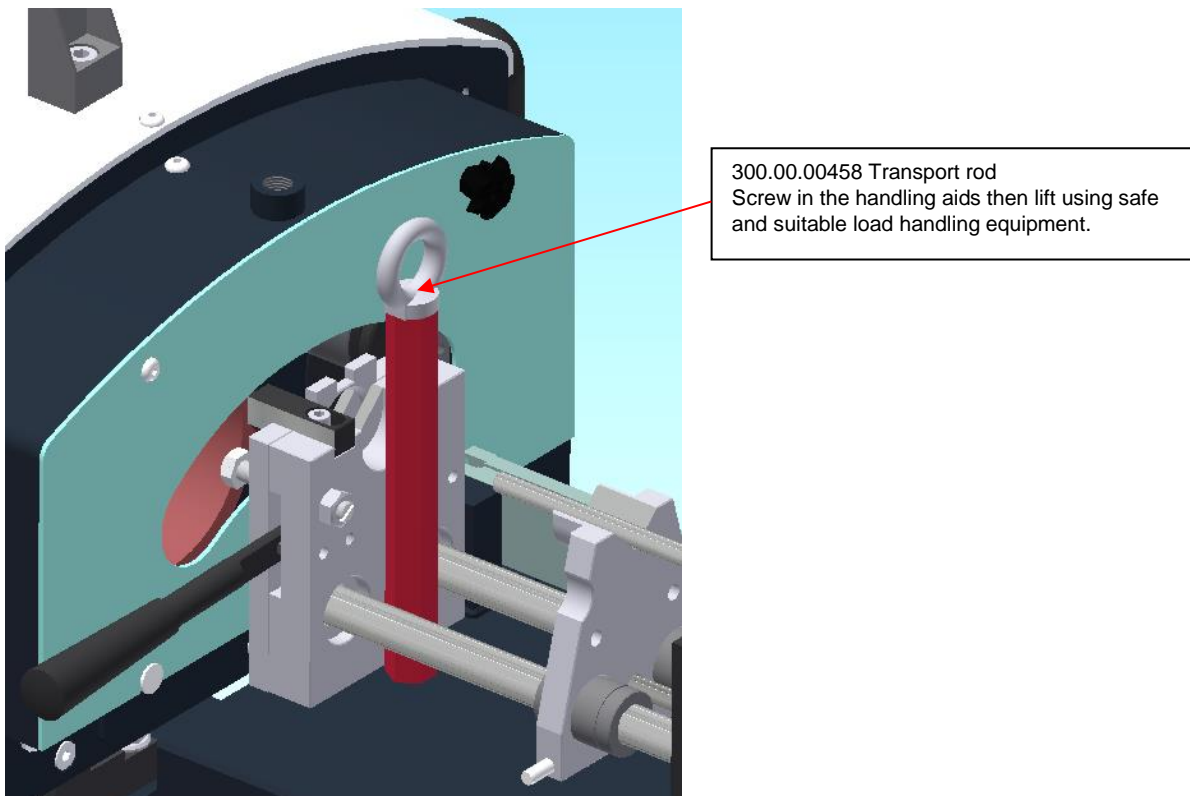
Adjusting the angle of the drive console in the Z-axis



Adjusting the angle of the drive console in the Y-axis








Transporting the machine



7 Spare parts list

Order number	Designation	Picture
300.00.00403	Complete linear unit	
300.00.00382	Complete clamping prism	
050.01.2716	Stop shaft Ø8x175mm	
300.00.00173	Carriage base	
050.01.2718	Ball linings	
300.00.00174	Length adjustment	
050.01.2713	Clamping lever	
300.00.00409	Cutting wheel grinding spindle	
050.01.2972 Meusburger V72710	Standard cutting wheel Ø100x1xØ20 (VP. 10 pcs)	
300.00.00407	Cup wheel grinding spindle	
050.01.2971 Meusburger V72810	Cup wheel Ø100x50xØ20	
050.01.2746	Toothed belt (cutting wheel)	

050.01.2747	Toothed belt (cup wheel)	
060.07.051	Motor (cutting wheel)	
060.07.050	Motor (cup wheel)	
060.30.904	Innova 10I-B display	
060.30.905	Glass scale MKT 37	
050.01.2928	Pressure spring 20 x 64,20 Wire Ø2.8mm	
300.00.00050	Disc flange, inside (cutting wheel)	
300.00.00393	Clamping nut (cutting wheel)	
300.00.00394	Clamping nut, left-hand thread (cup wheel)	
050.01.2887	Hex bolt ISO 4762 - M6 x 16, left-hand thread	
300.00.00223	Disc flange inside, left-hand thread (cup wheel)	
300.00.00094	Pressure spring Ø14 x Ø1 x 160 (cup wheel adjustment)	
050.01.2748	Scraper Ø40xØ48.6x7	

050.01.2976	Connection nipple 1/4"	
050.01.2977	Y-connector 1/4"	
050.01.2770	Dressing diamond	
050.01.2892	Control spring Ø10x 35.3x Ø1.4 (clamping prism)	
300.00.00458	Transport rod	

8 Zubehör



Meusburger
V 32860 / 35 / 180 / A

Two-hole nut driver, straight
050.01.2961



Meusburger
V 32860 / 35 / 200 / C

Two-hole nut driver, angled
050.01.2962



Meusburger
V 30030 / 3 / 100

Hex wrench
SW 3x100 050.01.2963



Meusburger
V 30030 / 5 / 150

Hex wrench
SW 5x150 050.01.2973



300.00.00243
Sonderschlüssel

9 Declaration of Conformity

as per EC Machinery Directive 2006/42/EC, Annex II 1. A

Manufacturer

Daum und Partner Maschinenbau GmbH
Am Lauerbühl 2
88317 Aichstetten, Germany
Tel. +497565/9408-0

A person resident in the community who is authorized to compile the technical documents

Daum und Partner Maschinenbau GmbH
Am Lauerbühl 2
88317 Aichstetten, Germany

Description and identification of the machine

Product / commodity	Series product
Model	Cutting off/surface grinding machine
Serial number	300/_____/_____
Machine number	300.00.00550
Project number	M _____
Trade designation	GMT 6000 precision cutting machine
Order	M _____
Function	Either the cutting wheel and/or the cup wheel are driven by two three-phase asynchronous motors to cut or surface grind the workpiece. The workpiece (e.g. ejector or punching die) is fixed by a spring-loaded stop prism and positioned by a stop. A digital gage, referenced (adjusted to zero) by scratching the workpiece, visualizes the possible advance/positioning for the cut and ensures this to 0.01 mm exactly.

Positioning is done by turning the adjusting screw on the rear end of the linear unit.

We expressly declare that the machine complies with all the valid provisions in the following EC directives.

2006/42/EC	Directive 2006/42/EC of the European Parliament and of the Council of 17th May 2006 on machinery, and amending Directive 95/16/EC (new version) (1)
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Reference from the applied harmonised standards as per article 7 paragraph 2

EN ISO 12100:2010-11	Safety of machinery - General principles for design - Risk assessment and risk reduction (ISO 12100:2010)
EN 614-1:2006+A1	Safety of machinery - Ergonomic design principles - Part 1: Terminology and general principles
EN ISO 13850:2008	Safety of machinery - Emergency stop function - Principles for design (ISO 13850:2006)
EN 60204-1:2006+A1	Safety of machinery - Electrical equipment of machines - Part 1: General requirements (IEC 60204-1:2005 + A1:2008)

Reference from other applied technical standards and specifications

DIN EN 62079:2001-11	Preparation of instructions - Structuring, content and presentation
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Aichstetten, Germany, 09/12/2015

Place, date



Signature
Mark-Oliver Daum
Managing Director

10 Fault report fax

Company:	Date:
Street:	Tel.:
Town/City:	Fax:
Department:	Created by:

Repair order to DPM Telefax No.: +49 (0)7565 940 850

DPM Machine No.: _____ . _____ . _____

The following listed faults/errors have occurred:

Description of fault:			
Technician is requested: Yes <input type="checkbox"/> No <input type="checkbox"/>	Fault correction was successful: Yes <input type="checkbox"/> No <input type="checkbox"/>	Date, signature: Person responsible.	