INSTRUCTION MANUAL

“TRANSLATION OF THE ORIGINAL INSTRUCTIONS”

This manual is to be kept for future reference and must always accompany the machine.

TYPE

S-08

MODEL

SC 2C

SEGA-SQUADRATRICE

SQUARING CIRCULAR SAW FOR WORKING WITH WOOD AND MATERIAL WITH SIMILAR PHYSICAL CHARACTERISTICS



Read this manual in its entirety before using the machine for the first time. Failure to follow the instructions given in this manual can lead to death or serious injury.

- Ed. 03-2025 / Rev. 0.1 EC 00L0922313A EN-GB

THIS MANUAL IS THE PROPERTY OF SCM GROUP S.P.A. - ANY REPRODUCTION, EVEN PARTIAL, IS PROHIBITED

Manufacturer	SCM Industria SpA
Address	Via Valdicella, 7 - 47892 Gualdicciolo (RSM) - San Marino
Importer	
Importer's address	
Name	SEGA-SQUADRATRICE
Name	SQUARING CIRCULAR SAW FOR WORKING WITH WOOD AND MATERIAL WITH SIMILAR PHYSICAL CHARACTERISTICS
Brand	SCM
Year of manufacture	
Serial number	
Client:	
Type	S-08
Model	SC 2C
Composition	
Work order	
Type of document	Instruction manual
Document code	00L0922313A
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DICHIARAZIONE “CE” DI CONFORMITÀ

(AI SENSI DELL’ AII.IIA DELLA DIRETTIVA 2006/42/CE E DICHIARAZIONE “UE” AI SENSI DI ALTRE DIRETTIVE APPLICABILI)

EC DECLARATION OF CONFORMITY

(IN COMPLIANCE WITH ATT. IIA OF THE DIRECTIVE 2006/42/EC AND “EU” DECLARATION AND IN COMPLIANCE WITH OTHER APPLICABLE DIRECTIVES)

IL FABBRICANTE *THE MANUFACTURER*	**SCM Industria SpA** **Via Valdicella, 7 - 47892 Gualdicciolo (RSM) - San Marino**

DICHIARA CHE LA
DECLARES THAT THE

MACCHINA: *MACHINE:*	***Sega circolare squadratrice per la lavorazione del legno e di materie con caratteristiche fisiche simili*** ***Circular saw squaring machine for machining wood and material with similar physical characteristics***		
MARCA: *BRAND:*	**SCM**	*N° DI SERIE* *SERIAL NUMBER*	***XXXXXX***
TIPO: *TYPE:*	**S-08**	*ANNO DI COSTRUZIONE:* *YEAR OF CONSTRUCTION:*	***XXXX***
MODELLO: *MODEL:*	**SC 2C**		

È CONFORME A TUTTE LE DISPOSIZIONI PERTINENTI DELLE SEGUENTI DIRETTIVE:
COMPLIES WITH ALL THE RELEVANT REQUIREMENTS OF THE FOLLOWING DIRECTIVES:

2006/42/CE	***2006/42/EC***
2014/30/UE	***2014/30/EU***

ORGANISMO NOTIFICATO CHE HA EFFETTUATO L’ESAME CE DI TIPO ***NOTIFIED BODY THAT EXECUTED THE EC TYPE-EXAMINATION***	**KIWA CERMET ITALIA S.p.A (n. 0476)** **Via Cadriano, 23** **40057 Cadriano di Granarolo (BO) - ITALY**
NUMERO DI ATTESTATO D’ESAME CE DI TIPO ***EC ASSESSMENT REPORT NUMBER TYPE***	**C21E485**

PERSONA AUTORIZZATA A COSTITUIRE IL FASCICOLO TECNICO: *PERSON AUTHORISED TO COMPILE THE TECHNICAL FILE:*	**SCM GROUP S.p.A.** **Via Emilia, 77 - 47921 Rimini (RN) - Italy**

IL RAPPRESENTANTE DELEGATO DEL FABBRICANTE
THE MANUFACTURER'S DELEGATED REPRESENTATIVE

Place, Date

XXXXXXXX

(IT) DICHIARAZIONE IN LINGUA ORIGINALE
(EN) TRANSLATION OF THE DECLARATION IN ORIGINAL LANGUAGE

NOTICE

The "EC"/"EU" declaration of conformity, provided by the manufacturer with the machine, is printed on anti-counterfeiting paper and it must always accompany the machine.

FACSIMILE

1 Warnings

NOTE

the machine must be checked as soon as it arrives. If it is damaged or if certain parts are missing, write to the shipping company highlighting the problem found and inform your supplier immediately.

DANGER

remember that this machine has been designed for professional use and it must be used only by expert operators who have been adequately trained to use it and aware of the health and safety regulations.

SAFETY OVER ALL

WORK AREA SAFETY

- The work area must be well lit (minimum recommended lighting intensity 500 LUX) and have enough space to ensure that work and maintenance can be carried out without hindrance and ensure the operator is always outside potential danger zones.
- The flooring must be level, well maintained and free from any loose materials (such as offcuts and shavings) and must not be slippery.
- The work zone must only be occupied by the machine operator.
- The operator shall never stay in the trajectory where eventual splits or tool parts are ejected.
- If along this trajectory there is another work station (that is another machine) or a passage for persons, immediately install proper protective barriers.
- DO NOT allow children, pets or any unauthorised personnel into the work area.
- The machine may not operate in explosive rooms.

ELECTRICAL SAFETY

- The plugs of the machines must match the socket. Never change the plugs in any way.
- DO NOT use adapters for plugs on machines with grounding.
- Avoid touching surfaces with grounding with the body.
- DO NOT USE the machine in DANGEROUS ENVIRONMENTS.
- DO NOT use machines in humid, wet locations or where there are flammable or harmful fumes.
- If the use in a humid environment cannot be avoided, use a residual current device (RCD) as the safety device to provide protection against electrocution and electrical fires.
- DO NOT tamper with the cable. Never use the cable to transport, pull or disconnect the machine.
- Keep the cable away from heat, oil, sharp edges or mobile parts.
- Use an extension with grounding, adequately sized for the machine amperage.
- The cables with grounding reduce the risk of electrical shock.
- Under-sized cables create excessive heat.
- Always replace damaged extensions.

PERSONAL SAFETY

Ultimately, safety is in the hands of the operator. There is a certain degree of risk whenever any kind of machine tool is used and this should never be forgotten.

- Always work with the maximum attention on what you are doing.
- Do not use the machine under the influence of alcohol, drugs or sleep inducing medication.
- Wear PERSONAL PROTECTION EQUIPMENT (PPE) before starting to work.
- Always protective goggles.
- In case of long machining breaks or machine stops set the main switch to "OFF/0".
- The operator must never leave the machine unattended when it is running.
- Before starting the machine make sure that on the worktable or inside the guard there are no wood residues or parts which do not relate to the working.
- Remove any wrench or adjustable wrench before starting the machine.
- Get into the habit of checking that no tool (wrenches and adjustable wrenches) has been left on or inside the machine, before starting it.
- The machine must only be used by properly instructed personnel.
- Operator training must include information concerning the dangers associated with use of the machine and the relevant safety precautions.
- Do not ignore the safety principles due to a familiarity with the operations, due to a frequent use of the machine.
- Always disconnect the machine from the supply sources before performing maintenance operations.
  Make sure that the switch is in the OFF position before reconnecting.
- DO NOT exaggerate. Keep stability and balance at all times.

MACHINE SAFETY: OPERATION AND MAINTENANCE

- DO NOT force the machines. Work at the speed that the machine or the accessory has been designed for.
- The tools shall be fitted and set when the machine is off, STILL TOOLS and with proper instruments (gauge, comparator).
- Do not leave unused tools where children and untrained people may reach them.
- DO NOT use the machine if you are not an authorised and trained operator.
- It is FORBIDDEN to use the machine in any way other than that for which it has been designed or any way other than described in this manual.
- DO NOT use the machine without the protection provided for each job or to remove parts of it (IT IS FORBIDDEN to disassemble fixed and mobile shelves and bypass the safety micro-switches).
- DO NOT use the machine differently from the indications described above.
- DO NOT handle the tools without individual protective equipment (not supplied by SCM) for the hands and forearms.
- DO NOT use the machine without individual protective equipment from noise (ear plugs) (not supplied by SCM).
- DO NOT use the machine without extraction.
- DO NOT use the machine without having assessed the need to use individual protective equipment (not supplied by SCM) in relation to wood dust (we recommend the use of individual protective equipment: hard wood dust is carcinogenic).
- DO NOT use the machine if the area around the machine is not flat, well maintained and free of loose material (e.g. shavings and rejects).
- DO NOT machine different materials from the ones that the machine has been designed for and that are not set out in this manual.
- DO NOT work materials with different dimensions from those for which the machine has been designed and which are not indicated in this manual.
- DO NOT make modifications to the machine.
- DO NOT allow children, pets or any unauthorised personnel into the work area.
- DO NOT use tools not included in standard EN847-1:2017 or of a size not compatible with the machine technical specifications.
- IT IS FORBIDDEN to use tools that are not suitable for the work piece.
- Before fitting any tool, check that the contact surfaces are clean, free of marks and perfectly flat.
- Keep handles and grip surfaces dry, clean and free of oil and grease.

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2.1 Importance of the instruction manual

Aim

The instruction manual provides the user with all the information necessary to operate the machine safely.

The machine is accompanied by:

- "original instructions", in Italian
- "translation of the original instructions", in the language of the country of destination

Notes for use

WARNING

Before using the machine, "authorized operators" for use and maintenance must read and understand this instruction manual.

- The manufacturer declines any responsibility for damages to people, animals or property resulting from the non-compliance with the warnings and operating methods described in this manual.
- Some images in this manual may not correspond to the actual machine configuration. This does not impact on the validity of the information provided and does not impact on the operator's safety.

NOTE

- The instructions manual must always be available. If there are any doubts or difficulties in understanding the instruction manual, contact the manufacturer. Understanding it incorrectly can compromise the safety of the authorized operators.

About the manual

NOTICE

This manual is an integral part of the machine: it must be stored for future reference and must always accompany the machine, even if it is transferred to a third party.

NOTE In case of loss or deterioration of the instruction manual, request a copy from the Manufacturer indicating the identification data of the document (code, edition) and the serial number of the machine.

The instruction manual contains proprietary information.

Reproduction and/or disclosure in whole or in part, in any form, without the manufacturer's written authorization is prohibited.

2.2 Machine Identification

Plate is marked with the identification data for the machine. Please quote this data when making technical enquiries or ordering spare parts.

The plate is placed on the base and contains the following data:

- DESIGNAZIONE = Short and standard description of the machine name and its function
- MARCA = Commercial brand
- TIPO = Machine type
- ANNO = Year of production
- N° SERIE = Serial number
- Kg = Weight in kilograms
- Un V = Voltage rated in volts
- ~ = Phases number (alternate current)
- In A = Nominal current in amperes
- f Hz = Electrical frequency in hertz
- Icc. kA = Short circuit breaking capacity of the protective device in kiloamperes
- W.D. = Wiring diagram number
- MODELLO = Machine model
- COMP. = Machine version
- REF. = Internal reference

It is a good idea to write down the machine identification data on this page for ready reference.

The plate also indicates the manufacturer's company name and full address and, if necessary, the EC marking.

2.2.1 Machine identification plate



NOTE The machine is identified by the words engraved on the metal plate on the machine's base.

2.3 Documentation supplied with the machine

The documentation supplied with the machine consists of:

- Instruction manual in paper copy (this one)
- Spare parts catalogue
- Electrical diagram
- Pneumatic diagram (if present)
- User and programming manual (if available)
- EC declaration of conformity* (See FACSIMILE)
- Technical generic documentations of machine components is not necessarily included

"CE" literally means "Conformité Européene" ("European Conformity").

With the "EC declaration of conformity", the manufacturer certifies complete compliance of the line with the relevant provisions of the "Machinery Directive" applicable upon it being placed on the market.

The machine is subject to The provisions set out in Annex IV of Directive 2006/42/CE.

In the event of modifications, tampering or alterations of the line or parts of the line that are unauthorised by the manufacturer, the "EC declaration" shall cease to be valid.

NOTE The pneumatic and electrical diagrams are for the exclusive use by specialised personnel appointed by the manufacturer, therefore they only show the information in Italian and English.

NOTICE

All the documentation supplied with the machine, with particular reference to this manual, to the EC declaration of conformity, plus the electrical and pneumatic diagrams, must obligatorily accompany the machine should it be sold to another user.

NOTICE

*THE "EC DECLARATION OF CONFORMITY" IS DRAWN UP IN SINGLE COPY, IT MUST ALWAYS REMAIN WITH THE OWNER OF THE MACHINE AND IT MUST BE STORED WITH THE MACHINE: the original copy, printed on watermarked paper, is provided.

The EC declaration of conformity refers to the machine, complete with all its possible configurations based on the list of options in the catalogue.

NOTE the devices on the price-list can change at Manufacturer’s discretion

2.4 Technical support

The technical support service provides information and support via telephone, in writing and training and maintenance interventions.

Contact information

When writing or phoning SCM Industria SpA for any reason concerning the machine, always supply the following information:

- Machine type
- Machine model
- serial number
- Voltage and frequency
- Date of purchase
- name of dealer from whom machine was purchased
- Detailed description of any faults found
- detailed information on the machining tasks to be executed
- Period of use - number of hours of operation

Technical Support Service

Address: SCM GROUP S.p.A. **-** Via Valdicella, 7 - 47892 Gualdicciolo (RSM) - San Marino
Web - site: www.scmgroup.com
Spare Parts Office (IT): Tel. +39 0541 674706
E-mail: spareparts@scmgroup.com
Technical Support Service: Tel. +39 0541 700100
E-mail: scm_service@scmgroup.com

NOTICE

Use only original spare parts SCM. The manufacturer will not be responsible for any damages due to the use of non-original spare parts.

2.5 Consultation notes - Abbreviations - Acronyms - Glossary

Layout of the pages

The top contains:

- the company logo
- the number of the chapter
- the description of the chapter;

The bottom contains:

- the machine model (if present)
- the machine type (if present)
- the serial number (if present)
- the edition and revision of the Instruction Manual
- the page number

SC 2C - Instruction manual Ed. 03-2025 / Rev. 0.1 EC - ©2026 SCM Industria SpA

Abbreviations - Acronyms

Par.	Chapter	**ca.**	about
CC	Continuous current	**AC**	alternate current
NC / CNC	Numeric Control	**EN**	European Norm
DX - R	right	**SX - L**	left
D -φ	diameter	**PPE**	Personal Protective Equipment
E.M.	of the electrospindle	**.**	.
Fig.	Figure	**H**	height
min.	minimum	**max**.	maximum
MDF	Medium Density Fiberboard.	**Ref**.	Reference
No.	number	**pos**.	position
OPT	optional	**STD**	standard
page	page	**par**.	paragraph
PC	Personal Computer	**a.s.l.**	above sea level
PES	expert person	**PAV**	warned person
o.s.	operating system	**sw**	software
UPS	Uninterruptible power supply unit	**.**	.
<	“Less than..." symbol "	**>**	"Greater than..." symbol "
≤	"Equal to, less than..." symbol "	≥	"Equal to, greater than..." symbol "

Glossario

Workpiece	Means the element to be machined in the material indicated in the chapter "Machinable materials"

NOTICE In the manual the definition “SCM”, “Manufacturer” replace the complete name SCM Industria SpA.

2.6 Symbols in the instruction manual

NOTE The present manual applies to all versions of machines. Instructions and information applicable only to a particular version or versions are indicated with a Note or symbol.

Symbol	Description
	Indicates that the information is specifically for : **ASSIGNED OPERATOR**
	Indicates that the information is specifically for : **TRANSPORT OPERATOR**
	Indicates that the information is specifically for : **MECHANICAL MAINTENANCE OPERATOR**
	Indicates that the information is specifically for : **ELECTRICAL MAINTENANCE OPERATOR**
	Indicates that the information is specifically for : **COMPANY SAFETY MANAGER**
	Indicates that the information is specifically for : **MANUFACTURER'S TECHNICIAN**



DANGER

Indicates a danger with a high risk probability that if not avoided will lead to death or serious injuries.



WARNING

Indicates a danger with a medium risk probability that if not avoided could lead to death or serious injuries.



CAUTION

Indicates a danger with a low risk probability that if not avoided could lead to moderate or light injuries.



NOTICE

Information to prevent damages to the machine

NOTE Neutral and positive information that emphasizes or adds information to the main text. Provides information that can only be applied in special cases.

Symbols

	Machine user
	Users cannot enter this zone with the machine functioning or switched on
	Ear protective equipment must be used
	Eye protective equipment must be used
	Hands protective equipment must be used
	Respiratory tract protective equipment must be used.
	**MACHINE OFF**: Before performing any type of maintenance and/or adjustment operation on the machine, cut off all the supply sources (electrical and pneumatic). Make sure that the machine is actually stopped and that it cannot be started accidentally (main switch in position “0” and padlocked and compressed air valve closed and padlocked).
	**PROHIBITED**: indicates manouvres, commands or others that cannot be carried out as they can create very dangerous situations for persons and damage the machine.
	**OPTIONAL**: devices available only on request
	Special devices, not included in the price list, available only upon specific request and after technical verification.

2.7 Plates on the machine

SPECIALISED PERSONNEL

The operator must pay attention to the signs and plates fixed on the machine.

Ensure that the labels are always clearly visible. Replace any labels which are damaged or illegible. Always observe the safety labels on the machine.

The signals and plates must be regularly inspected and cleaned in order maintain them clearly legible.

If the signs and the plates are not clearly legible, contact the manufacturer to replace them.

If they need to be replaced, proceed as follows:

- Remove the old sign or plate.
- Clean the zone with detergent.
- Position the new sign or plate in the same position of the one removed.

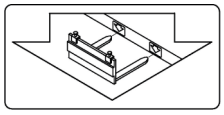
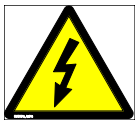
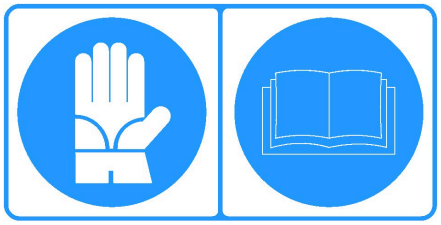
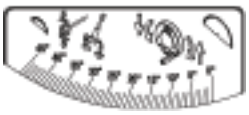
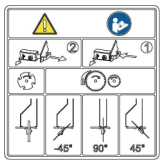
FIG.	REF.	SIGNAL	TYPE	DESCRIPTION
A			**Information**	Sign indicating fork insertion point for lifting machine with a fork lift truck.
B	**Ap01a**		**Danger**	Electrocution
D	**Ai03b**		**Information**	Indication of electricity disconnecting switch
E			**Compulsory**	Wear gloves to handle the tools Read the manual and follow the manufacturer's instructions
F			**Information**	Blades dimensions plate
L	**Ai08b**		**Information**	Lifting points
M			**Information**	Locking symbol

FIG.	REF.	SIGNAL	TYPE	DESCRIPTION
S			**Information**	Saw\scorer adjustment plate
T			**Information**	Safety warnings plate: protection suspended

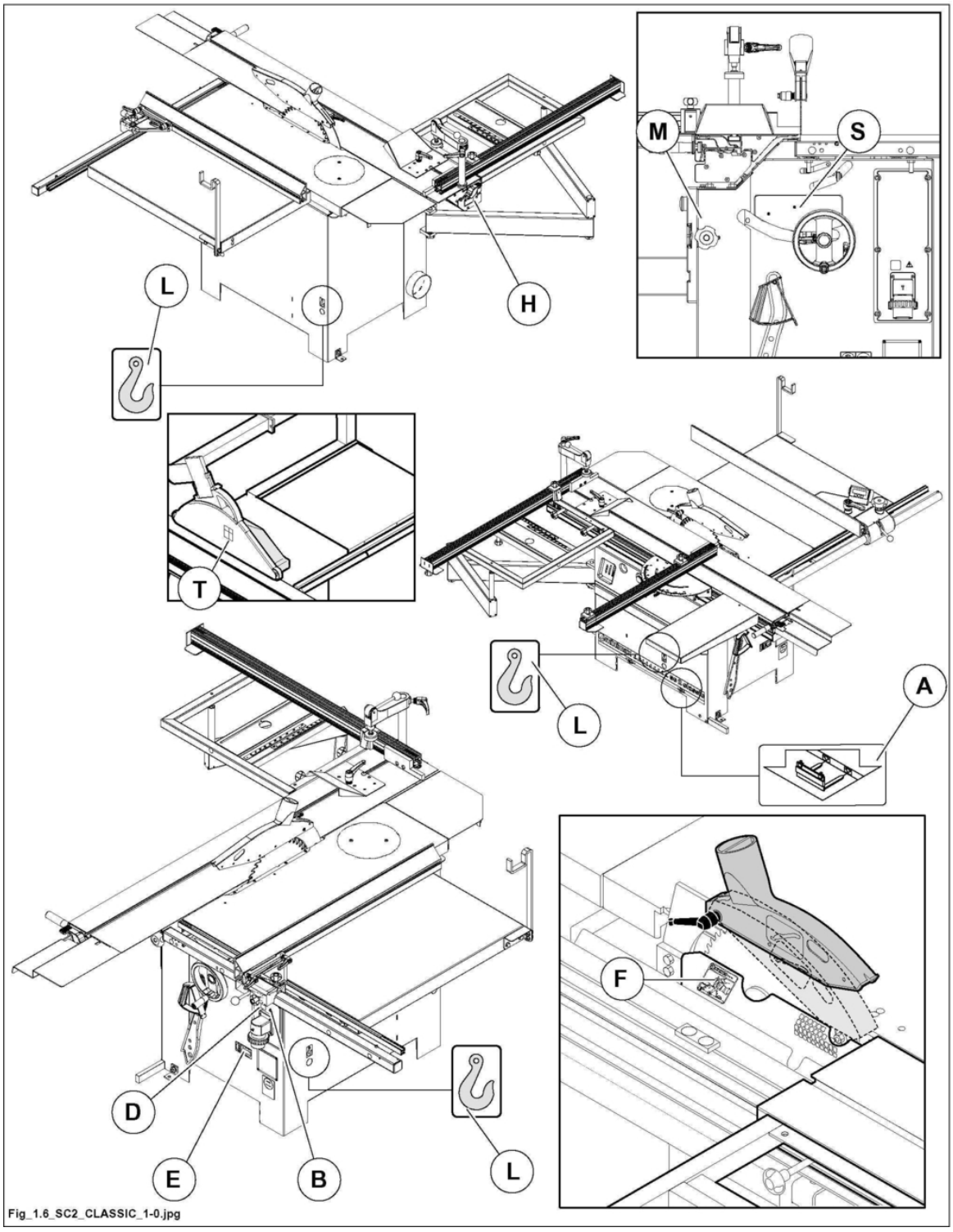


Fig_1.6_SC2_CLASSIC_1-0.jpg

2.8 DESCRIPTION OF THE MACHINE

The machine is a circular saw with tilting blade for machining wood. It is fitted with an aluminium sliding table with square up frame and parallel guide. The machine may be fitted with a scorer that prevents chipping of the veneered panels during the cutting phase.

The references and description of the main organs of the machine are provided for the purpose of preliminary and rapid familiarisation with any further citation within this publication. Please pay attention to the following descriptions:

NOTE

the machine devices, described in points 1), 2) and 7), are not available on the "COMPACT" version, whilst the one described in point 16) is present as standard.

- 1) **RULE FOR SQUARE CUTS**
- 2) **GUARD FOR THE BLADES**
- 3) **SAW - SCORING SAW UNIT**
- 4) **ALUMINIUM SLIDING TABLE**
- 5) **CONTROL PANEL**
- 6) **WORKTABLE**
- 7) **SUPPORT FRAME**
- 8) **PRESSER**
- 9) **WOOD PUSHER**
- 10) **ADDITIONAL TABLE ON PIECES OUTFEED SIDE**
- 11) **RULE FOR PARALLEL CUTS**
- 12) **ADDITIONAL WORKTABLE**
- 14) **SAW GUIDE UNIT WITH MICROMETRIC RACK ADJUSTMENT (SLIDING ON CYLINDRICAL SECTION GUIDE)**
- 15) **SLIDING TABLE BLOCKAGE**
- 16) **ANGLED CUTS DEVICE**
- 17) **SAW LIFTING**
- 18) **SAW TILTING**
- 19) **REVERSIBLE STOPS**
- 21) **ANGLED CUTS DEVICE EXTENSION**
- 22) **WOOD STOP UNIT**
- 23) **SAW GUIDE UNIT WITH MICROMETRIC RACK ADJUSTMENT (VERSION WITH DIGITAL DISPLAY)**
- 25) **SCORING SAW ADJUSTMENT**
- 26) **SET OF TOOLS AND WRENCHES FOR USE AND MAINTENANCE**
- **(00) - Tablet support device** OPT

(**) - FIXED GUARDS THAT CAN BE REMOVED FOR MAINTENANCE OR CLEANING

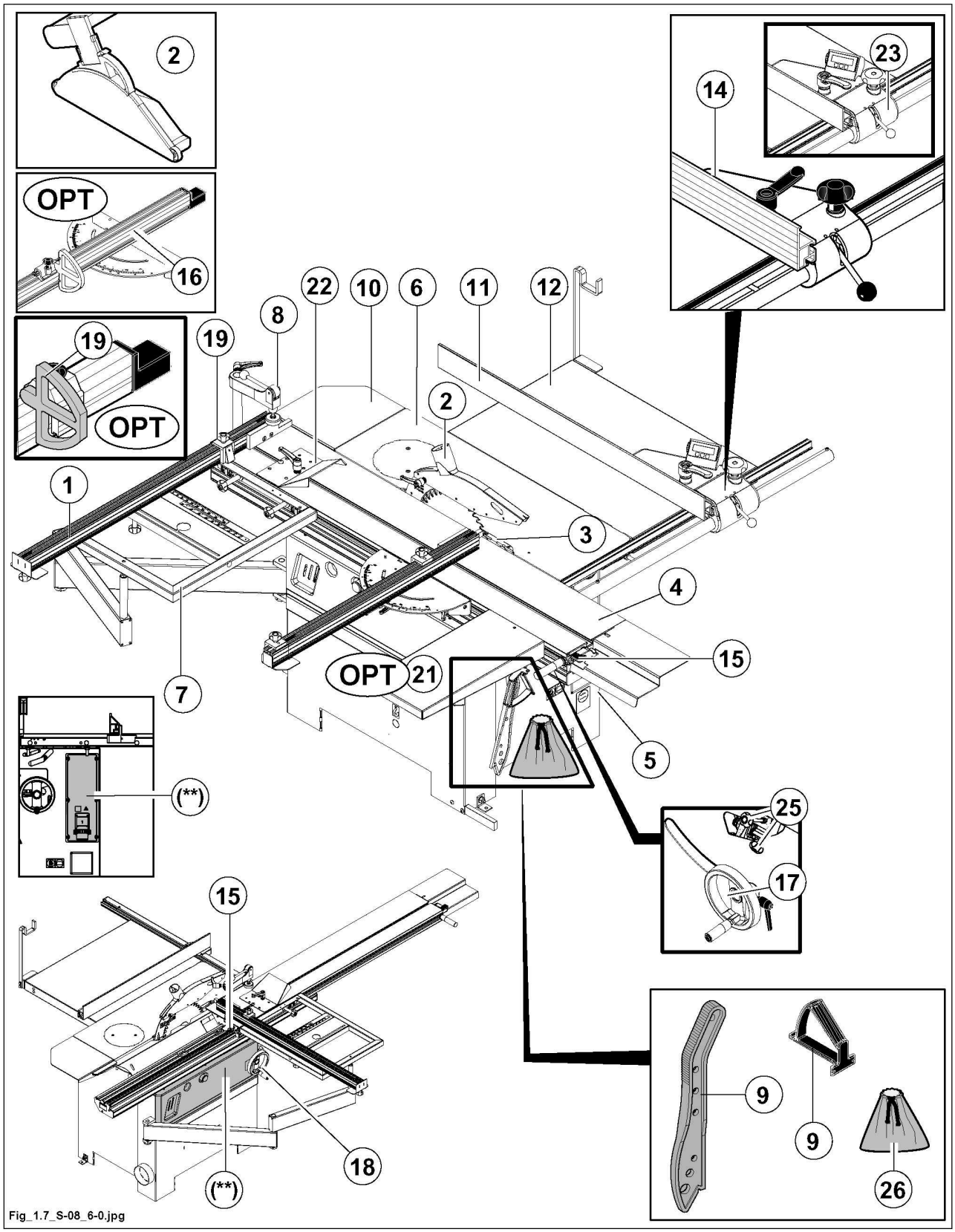


Fig_1.7_S-08_6-0.jpg

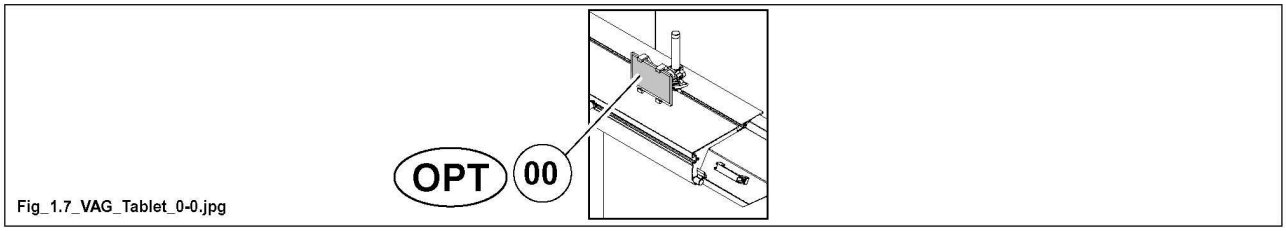


Fig_1.7_VAG_Tablet_0-0.jpg

2.9 Environmental conditions

The environment conditions required are:

- relative humidity: Max 50% at 40 °C (higher relative humidity values are allowed at lower temperatures: for example 90 % at 20 °C)
- temperature with the machine operating: Min. + 10°C ; Max + 35°C
- temperature with the machine off: Min. + 5°C ; Max + 35°C
- altitude: max 1000 a.s.l. (at higher altitudes, consult Manufacturer)

NOTE The electrical equipment resists the effects of transport and storage temperatures in the range between -25 ° C and +55 ° C (up to +70 ° C for periods of time not exceeding 24 h).Under different conditions, take appropriate precautions to protect it.

Sufficient lighting must be provided, general or localised at the workstation, min. 500 LUX.

NOTICE

A clear working area around the machine is fundamental for safety: the floor must be flat (a cement industrial floor), well-kept and free of material, e.g. shavings, scraps, etc.

The machine is designed for use indoors in industrial environments.

PROHIBITED

The machine cannot be started in environments classed as potentially explosive in accordance with European Directive "99/92/EC".

NOTICE

For proper functioning, it is advisable to use the machine in an environment with temperatures between 18° and 30° C and relative humidity between 30% and 65%.

2.10 Intended use and machining allowed

NOTICE

This machine is intended for continuous production processes ("continued production use") .

The intended use of the machine is to perform cutting operations.

It is forbidden to use the machine for purposes other than those intended, as it could pose risks to the health and safety of the operators and compromise the performance and life of the machine.

Uses that, for example, involve the use of materials not expressly indicated by the manufacturer, or that involve exceeding the machine's limits (e.g. machining pieces of minimum/maximum dimensions that do not fall within those indicated in this manual) are not allowed.

2.10.1 Machinable materials

The machine has been designed to machine pieces consisting of:

- solid wood
- material with similar physical specifications to wood[1]

1 wood based materials such as panels in particles, panels in wooden fibre and plywood, included when covered with profiles/edges/laminates in plastic or light alloys, solid wood covered with profiles/edges/laminates in plastic or light alloys, cork, stiff rubber, plastic[2].

2 Examples of plastic materials: thermoplastic materials, thermoplastic resins, thermosetting resins, phenol and polyvinyl chloride (PVC).

WARNING

Machining is prohibited with a tool other than a circular saw blade and without the use of the protections provided with this machine.

The pieces machined must be without foreign bodies (e.g. nails, stones, metal parts, etc.).

DANGER

It is forbidden to work with materials different from those indicated above: it can affect the health and safety of people and cause damage to the machine.

NOTICE

A specific mask that ensures the stability of the piece during cutting is used for cutting flat and curved pieces.

NOTE

For any requirement or advice on cutting plastic materials or aluminium alloys, contact the tool manufacturer or the local SCM dealer.

1 (1)
2 (2)

2.10.2 Tools

Saw blades

Only saw blades manufactured in compliance with the requirements of EN 847-1:2017 must be used.

The machine has been designed to only use tools fed manually(1), marked MAN in compliance with EN 847-1:2017, and suitable for the type of material used.

(1) *Manual feed means guiding the pieces:*

- *by hand*
- *with sliding trolley pushed by hand*
- *with feeder*

Rotation speed



WARNING

Do not exceed the maximum rotation speed marked on the tools.

Observe the dimensional limits of the tools for which the machine is designed, which are set out in this Instruction Manual.

Tools technical specifications

Use only sharp tools.

NOTE



NOTICE

Exposure to noise and dust



NOTICE

The type of tools can affect exposure to noise: we recommend using low-noise tools.

The maintenance level of the tools can affect the exposure to dust.

2.10.2.1 Tools: safe working practices

General information

The tools must be used only by trained and experienced personnel with a knowledge of how to use and handle tools.

Circular saw blades

The circular saw blades whose body is cracked must be scrapped (repair is not allowed).

Handling

To avoid injuries, the tools must be handled in accordance with the guidelines provided by the manufacturer.

The safe handling requires the use of devices such as transport hooks, correct handles, frames (e.g. for circular blades), boxes and carriages.

The use of protective gloves improves the grip on the tool and further reduces the risk of injury.

Installing and locking tools and their parts

- The tools and tool bodies must be locked so as not to come loose during their operation.
- When fitting the tools pay attention that the locking is performed with the hub or the locking surface of the tool and that the cutting surfaces are not in contact with each other or with the locking parts.
- The fixing screws and nuts mus be tightened with the appropriate wrenches.
- The wrench cannot be extended and do not tighten with hammer blows.
- The locking surfaces must be cleaned to remove dirt, grease, oil and water.
- The locking screws must be tightened according to the instructions.
- Install the tools so that the work in the correct rotation direction.

Tool set up

During set-up, check that there is no contact between non-rotating tools and any workpiece clamping device or machine part;

Maximum speed

Do not exceed the maximum rotation speed marked on the tools. The speed interval, where declared, must be complied with.

NOTE For the correct selection of the tool rotation speed, in relation to the type of tool and material being machined, we recommend also referring to the parameters supplied by the tool manufacturer.

Use and storage of tools and tool holders (if present)

Use the adequate cutting and feed speed of the tools to reduce the wear of the tools and extend their life.

Return the tools in their holders at the end of the machining.

At the end of machining:

- Return the tools in their holders.
- Remove the tool holder cone from the spindle and replace it with a clean tool holder cone without tool at ambient temperature, closed with the locking grub screw, to protect the conical seating on the electrospindle spindle from dust and impurities.

Cleaning

The tools and tool holders (if present) must be cleaned regularly.

The light alloy parts of the tools must be cleaned, for example from resin, only with solvents that have no effect on the mechanical characteristics of these materials.

Tool maintenance

The tools maintenance, for example repairs or sharpening, must be allowed only based on the instructions of the tool manufacturer.

NOTE For example: after tool maintenance it must be guaranteed that the tools comply with the balance requirements as indicated in 5.1.8 of EN 847-1 and 6.3.2 of ISO 21940-11. The spare parts must comply with the specifications of the original spare parts supplied by the manufacturer.

2.11 Incorrect use that can be reasonably expected

- DO NOT use the machine if you are not an authorised and trained operator.
- It is FORBIDDEN to use the machine in any way other than that for which it has been designed or any way other than described in this manual.
- DO NOT use the machine without the required guards for every machining process or removing part of the guards (DO NOT disassemble the fixed and mobile guards, bypass the safety microswitches)
- DO NOT use the machine in ways that differ from those described above (see par. "Intended use and machining allowed").
- DO NOT use the machine in environmental conditions that differ from the ones indicated above (see par. " Environmental conditions")
- DO NOT handle the tools without individual protective equipment (not supplied by SCM) for the hands and forearms.
- DO NOT use the machine without individual protective equipment from noise (ear plugs) (not supplied by SCM).
- DO NOT use the machine without extraction.
- DO NOT use the machine without having assessed the need to use individual protective equipment (not supplied by SCM) in relation to wood dust (we recommend the use of individual protective equipment: hard wood dust is carcinogenic).
- DO NOT use the machine if the area around the machine is not flat, well maintained and free of loose material (e.g. shavings and rejects).
- DO NOT machine different materials from the ones that the machine has been designed for and that are not set out in this manual (see par. "Machinable materials").
- DO NOT machine materials of dimensions that the machine has not been designed for and that are not set out in this manual (see par. "Dimensions of workpiece to be thicknessed").
- DO NOT feed small pieces without the piece pusher (see par. "Wood pusher").
- DO NOT use tools not included in standard EN847-1 or of a size not compatible with the machine technical specifications.
- DO NOT make modifications to the machine.
- DO NOT allow children, pets or any unauthorised personnel into the work area.
- IT IS FORBIDDEN to use tools that are not suitable for the work piece.

NOTE

Performing modifications, voids the machine's Declaration of Conformity.

For damages deriving from improper use the user is solely responsible.

PROHIBITED

DO NOT use the machine without having first checked that the safety protections have been installed correctly and secured with the devices required and in the way indicated in this manual. Before every use, with the machine off and tools stopped, try to move the protection to ensure it is installed correctly and fixed completely.

2.12 ⚠ RESIDUAL RISKS

There is a certain degree of risk whenever any kind of machine tool is used and this should never be forgotten.

Ultimately, safety is in the hands of the operator.

This machine complies with the safety standards in force and has the very latest safety features.

These protections are effective as long as they are properly used and kept in efficiency.

Even if the safety prescriptions are kept and the machine use occurs in accordance with the rules described in this handbook, the following risks may rise:

- Contact with the standstill or rotating tool.
- Contact with rotating members (belts, pulleys, chains ...).
- Kickback of the workpiece or of its parts (splits): never stop in the position corresponding to the trajectory of possible split ejection.
- Ejection of tool inserts: never stop in the position corresponding to the trajectory of possibile split ejection.
- Electrocution from contact with live parts
- Contrary direction of tool rotation due to wrong electric connection.
- Danger due to wrong working position of the operator.
- Danger caused by the wrong tool fitting.
- Possible squashing of the hands, with the fixed parts of the machine, during the sliding table motion.
- The machine can cause fires during operation. Fire hazard from sparks in the event of contact between rotating tools and foreign bodies.
- In the event of a power failure, the tool can continue to rotate beyond the maximum switch-off time.
- Dust inhalation in case of working without suction.

WARNING

Some factors that influence exposure to dust are:

- regular maintenance of the tools, the machine and the extractor system;
- the type of material being processed;
- connection to the extractor outlets;
- correct adjustment of the protections / extractor outlets;
- the connection of the machine with an external suction system, which guarantees the parameters indicated in the instructions for use.

DANGER

OPT

If there is no power supply the electronic brake does not work. CAUTION! MOVING TOOLS. Do not insert hands in the danger area.

Danger due to exposure to machine noise. Some factors which influence noise are:

- Correct tool selection
- Correct speed selection
- Tool and machine maintenance
- the type of material being processed
- Correct use of hearing protection.

2.13 Personnel training

It is obligatory that all operators receive adequate training for the use, adjustment and function of the machine.

Machine operators must read the handbook and pay particular attention to safety warnings, more specifically, operators must have an understanding of:

In particular:

a) The principles of the right use and operation of the machine.
b) How to handle the work-pieces during machining.
c) Using the pusher supplied with the machine.
d) Position of the hands with respect to tools, before, during and after maintenance.
e) The right selection of the tools.
f) The piece feed to the tool which shall occur in the contrary direction to the spindle rotation direction.
g) The selection of the proper spindle speed required by the tool.

Operators must also be informed vis-à-vis risks associated with using the machine and the precautions that need to be taken. They must be instructed to carry out periodic inspection of safety guards/devices.

NOTE

A suitable padlock must be procured to lock the main power switch.

The keys are the responsibility of the qualified, authorised operator.

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2.14 ⚠ Safety warnings

1. Carefully read this instructions manual completely before starting the machine.
2. Read the safety info plaques attached to the machine and observe the relevant information.
3. The machine must only be used by properly instructed personnel.
4. Operator training must include information concerning the dangers associated with use of the machine and the relevant safety precautions.
5. The operator must receive training and instruction on proper use of safety devices.
   Moreover he must be trained to regularly check these guards and safety devices.
6. The operator must never leave the machine unattended when it is running.
7. The machine is designed for use by one operator.
8. This machine has been constructed to offer maximum safety together with maximum performance.
9. Any unauthorised modification of the machine exonerates the manufacturer from liability vis-à-vis any resulting damages.
10. Do not use the machine under the influence of alcohol, drugs or sleep inducing medication.

Ultimately, safety is in the hands of the operator. There is a certain degree of risk whenever any kind of machine tool is used and this should never be forgotten.

2.14.1 ⚠ Personal safety

1. Before starting the machine the operator must have read and understood this handbook.
   Your eyes are the best safety device you have: carefully look before moving.
2. Certain objects about your person could cause accidents, therefore remove rings, watch, and bracelet; make sure your sleeves are secured or buttoned tightly around your wrist, remove your tie it could dangle down and catch in part of the machine, tie back hair securely with hair bands, elastic bands, clips etc., wear safety boots recommended by the safety standards in all countries over the world.

ALWAYS WEAR THE FOLLOWING INDIVIDUAL PROTECTIVE EQUIPMENT (IPE) (NOT SUPPLIED BY SCM**) BEFORE STARTING TO WORK:**

A - Proper aprons, e.g: aprons made of double leather with synthetic fiber cloth insertion (not supplied by SCM**) to protect the operator in case of splinters ejection.**

B - Goggles to protect eyes (or use suitable screens).

C - Proper means for ear protection. (ear muffs and plugs etc.).

D - Proper measures against dust inhalation (masks).

E - Gloves for use when handling the blades.

F - Shoes with steel toe caps and rubber soles.

2.14.2 ⚠ Security in the machine

DANGER

Always fasten the machine to the floor.

1. Proceed with the utmost caution before starting any job and periodically inspect safety guards/devices.
   Follow the instructions for grounding the machine's electrical system.
2. Never start the machine without having properly closed the covers in the area for blade and belt change.
3. Before starting the machine make sure that on the worktable or inside the guard there are no wood residues or parts which do not relate to the working.
4. Never machine pieces too small/big for machine capacity.
   See paragraph "Dimensions of workpiece to be thicknessed" for dimensions.
   Ensure that the pushers are intact and efficient.
5. Do not process machine pieces with defects (deflections, clefts, knots, metallic parts: like nails, screws etc).
6. The assembly and adjustment of the protections and the reference fences must be performed with the machine off.
7. Work must only be carried out with safety guards correctly positioned and in good working order:
   the machine must not be used if these conditions are not met.
8. In case of long pieces use roller tables or table extensions (not supplied by SCM).
9. The dust extraction hood must be connected to the extraction system.
   Work only with the intake system inserted.
10. Test machinings, to check the correct adjustments of the tool cannot be performed without the necessary protections.
11. Do not try to remove waste or other parts of the workpiece from the work area while the machine is machining
12. Push the work piece forwards by using a proper pusher or feeder.
13. After a given working period the transmission belts may become slack; this may cause an increase of the time required to stop the tool.
    Immediately re-tension them, as described in paragraph " Belt stretching".
14. Periodically remove shavings and dust to avoid the risk of fire - always perform this operation with the machine switched off.

DANGER

in case of long machining pauses or machine stops remove the power supply cable socket.

DANGER

In the switches with electronic brake (OPT), even with the motor stopped, the motor is not galvanically disconnected from the mains. The switch supplies the motor with voltage even after it is switched off.

DANGER

when cutting round or irregular-shaped pieces crossways, the piece must be secured from rotating with a shaped guide or suitable supports and a blade for crossways cuts.

PROHIBITED

DO NOT use the machine without having first checked that the safety protections have been installed correctly and secured with the devices required and in the way indicated in this manual. Before every use, with the machine off and tools stopped, try to move the protection to ensure it is installed correctly and fixed completely.

2.14.3 Tools safety

1. Before fitting any tool, check that the contact surfaces are clean, free of marks and perfectly flat.
2. The tools shall be fitted and set when the machine is off, STILL TOOLS and with proper instruments (gauge, comparator).
3. Ensure that the tools are perfectly balanced, sharpened and accurately tightened.
   Not sharp tools reduce not only the quality of the finished piece but they increase the piece kickback danger.
4. Mount the tools in the right machining direction.
5. For fastening the saw blade to the spindle, the use of rings or bushes not prescribed by SCM is forbidden.
6. Never use deformed saw blades and do not exceed the speed limit indicated on them and prescribed by the tool manufacturer or by SCM.
   Make sure that the dimensional limits and the specifications of the tools suitable for the machine have been stored.
7. Use only tools in accordance with EN 847-1 Norm and proper for manual feed.
   - Use suitable tools to work on the type of material you want to cut.
   - For the use, adjustment and repair, please follow the instructions of the tool manufacturer.
8. Before starting the machine make sure that the tools do not touch the parts of the machine.
9. Start machining only when the tools have reached their operating speed.

2.14.4 Working area safety

The work area must be well lit (minimum recommended luminous intensity 500 LUX) and have enough space (see Par. "Work area") to work and perform maintenance operations comfortably, so that the operator is always outside a possible danger zone.

The flooring must be level, well maintained and free from any loose materials (such as offcuts and shavings) and must not be slippery.

The work zone must only be occupied by the machine operator.

The operator shall never stay in the trajectory where eventual splits or tool parts are ejected (see Par. "Work area").

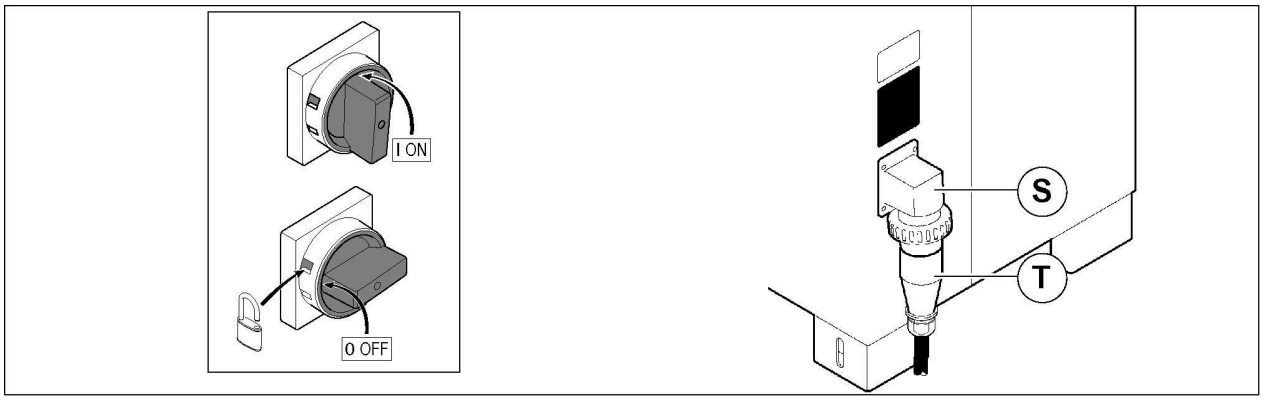
If along this trajectory there is another work station (that is another machine) or a passage for persons, immediately install proper protective barriers.

2.14.5 Safety during maintenance

Disconnect the electrical power supply before carrying out the maintenance operations.

Strictly follow the indications provided for the frequency of the controls and maintenance of devices subject to checks and/or wear.

1. Stop the machine to carry out adjustments or to demount any machine, turn the main switch to zero and lock it, then indicate it by a sign.
   The operator who carries out the machine set up, maintenance and cleaning shall keep the key.
2. Before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S.



3. Stop the machine completely before cleaning and before removing any protection components for maintenance.
4. General cleaning of the machine (especially work tables) and the surrounding floor area is an important safety factor.
5. Regularly carry out cleaning and maintenance operations: remove chips and dust to avoid fire risk.
6. Use proper gloves for handling the tools.
7. The tools require a regular maintenance: when necessary replace them.
8. In case of any trouble concerning the machine, the guards and the tools, it is necessary to immediately take the proper measures.

2.15 Emergency conditions

DANGER

In the case of flooding of the room where the machine is housed, disconnect the electricity and pneumatic supplies immediately. Before starting work, have the machine checked by a specialised technician.

DANGER

In case of fire, immediately disconnect the electrical power supply and intervene using suitable fire extinguishers directing the jets at the base of the flames. Even if the machine has suffered no apparent damage, before restarting work have the machine checked by a specialised technician.

DANGER

if there is a mechanical block follow the following instructions to release the machine safely:

- **isolate the machine electrically (to isolate the machine electrically rotate the main electrical switch to the “0” position and padlock it; disable the uninterruptible power supply, if one has been installed on the machine; if the machine is fitted with a plug socket connection, unplug the plug of the power supply from the socket);**
- **contact the manufacturer's SERVICE centre (see Par. "Technical support").**

There must be enough space around the machine, as described in the paragraph "Work area", to allow a fast exit in the event of danger.

This machine must not be operated in explosive environments.

2.16 REMOVAL - STORAGE - SCRAPPING

When removing the machine disconnect it from the electrical power supply and follow the instructions in the lifting paragraphs.

In case of extended inactivity of the machine, disconnect it from the electrical system. Thoroughly clean it, as already described for ordinary cleaning, and coat the work and sliding tables and the tool holder spindles with anti-rust protection. Do not store the machine in humid environments and protect it from atmospheric agents.

The machine is manufactured with non-toxic or harmful materials; in case of scrapping separate the ferrous materials from the plastic materials and scrap respectively.

2.16.1 Dismantling the device

The machine is manufactured with non-toxic or harmful materials; in case of scrapping separate the ferrous materials from the plastic materials and scrap respectively. We recommend contacting a specialised and authorised company, in compliance with the applicable laws and standards.

The operators moving the machine and the maintenance personnel must wear the IPE required for the risks involved with the type of use and in compliance with the applicable laws and standards.

To move and transport the machine refer to the instructions in section "Installation" .

3 Safety and emergency stop devices

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3.2 Arrangement and description of safety devices..... 38

3.1 Arrangement and description of emergency devices

Emergency equipment consists of special devices whereby operators can promptly stop the machine if necessary or in case of danger.

DANGER

Emergency devices must never be removed or disconnected for no reason whatsoever.

A	Emergency push-button
	It causes an immediate emergency stop.

SPECIALISED PERSONNEL

Periodically, check that the devices, listed above, are efficient.

DANGER

Any anomalies found during the control of these devices, must be reported promptly to the manager , who will put the machine out of service and call the Support Service. SCM

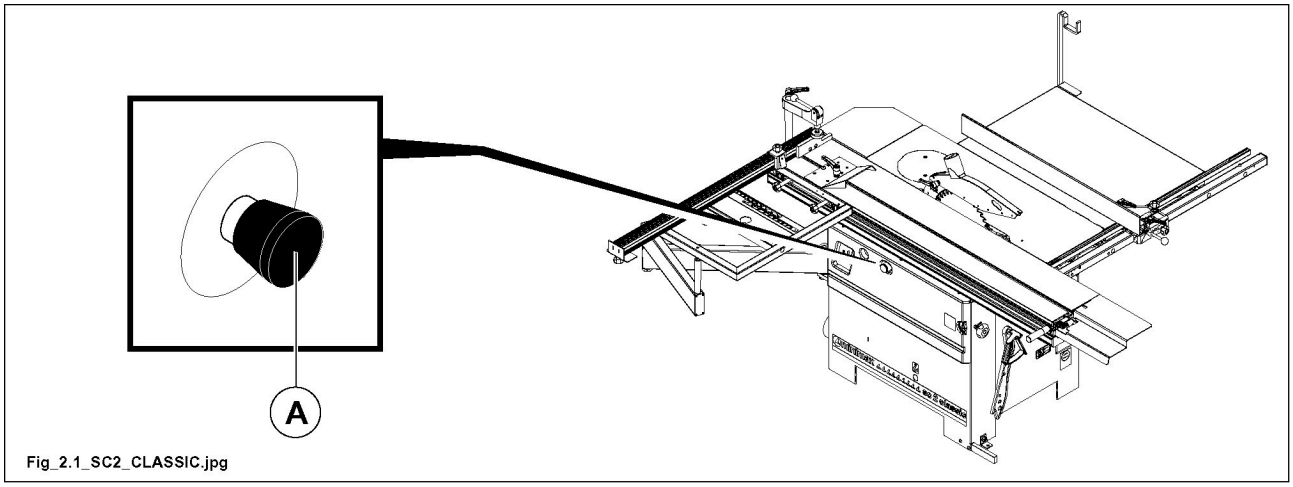


Fig_2.1_SC2_CLASSIC.jpg

3.2 Arrangement and description of safety devices

Safety devices are special accident-prevention guards whereby the machine is protected against possibly dangerous situations.

DANGER

Safety devices must never be removed or disconnected for no reason whatsoever.

Description

ERROR	Thermal switch It connects and disconnects the supply voltage to the machining unit.
B	Lower blade change zone safety panel
C	Limit switch fitted on the side of saw unit guard To stop the machine after opening the guard and to ensure that with guard (B) open, the motor can not be started.
D	Switch with electronic brake (OPT) It acts directly on working unit.
E	Suspended blades safety panel OPT The guard is made of material (aluminium + polycarbonate) so that the saw blade is not damaged if it touches the guard
E1	Blades safety panel

NOTE

protection suspended on the blades with fitting for aspiration (E) Ø 80 mm, it is not available on the "COMPACT" version.

SPECIALISED PERSONNEL

Periodically, check that the devices, listed above, are efficient.

DANGER

Any anomalies found during the control of these devices, must be Reported promptly to the manager , who will put the machine out of service and call the SCM Support Service.

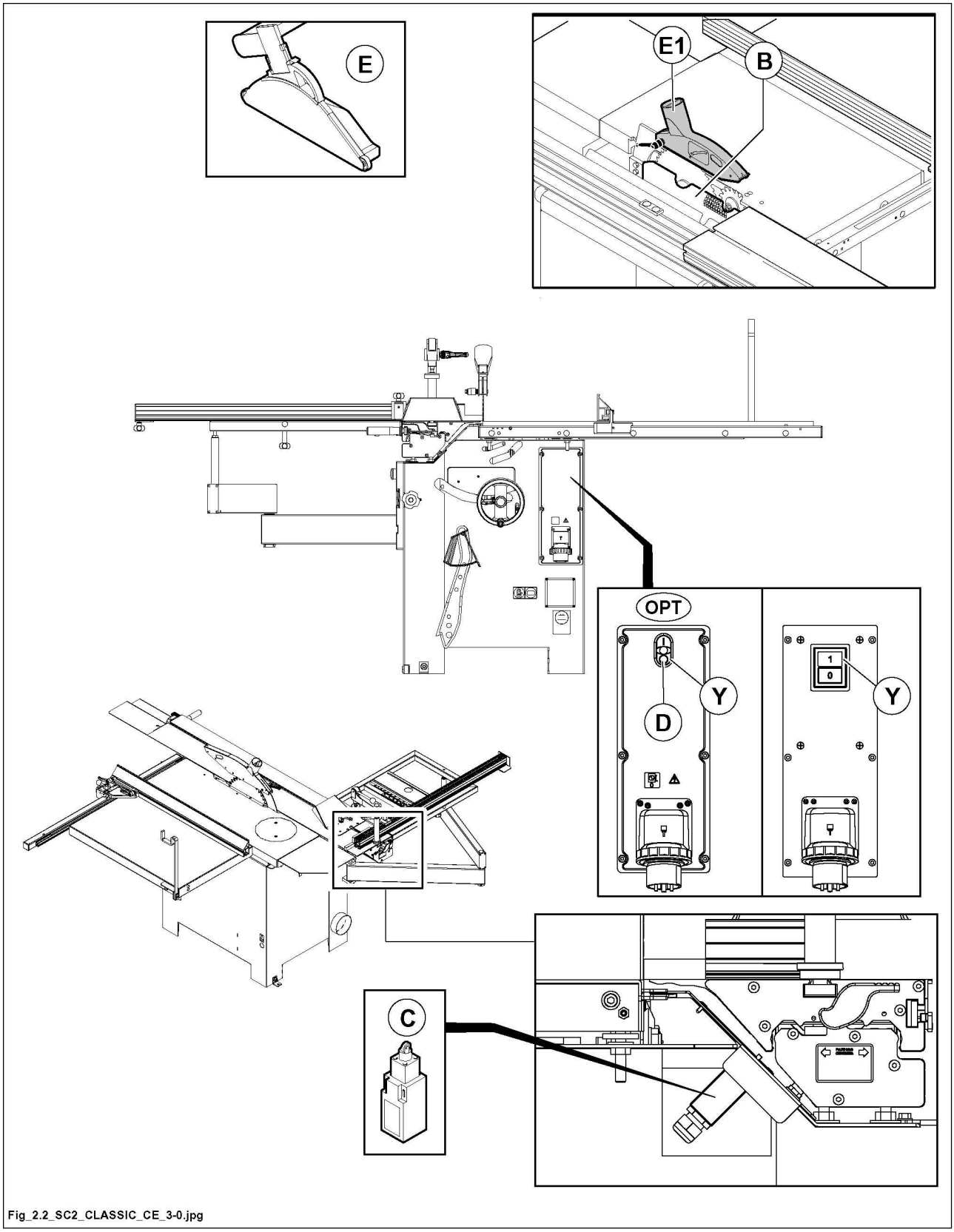


Fig_2.2_SC2_CLASSIC_CE_3-0.jpg

4 Technical specifications

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4.1 Dimensions of workpiece to be thicknessed

DIMENSIONS OF WORKPIECE TO BE MACHINED			
Max. cutting Height (90° blade position)	With a Ø 315 blade	90	mm
Max. cutting Height (45° blade position)	With a Ø 315 blade	63	mm
Max. cutting Height (90° blade position)	With a Ø 300 blade	82.5	mm
Max. cutting Height (45° blade position)	With a Ø 300 blade	57	mm
Max. cutting Height (90° blade position)	With a Ø 250 blade	62	mm
Max. cutting Height (45° blade position)	With a Ø 250 blade	40	mm
Maximum length	When squaring	1600	mm
Maximum width	For parallel guide cutting	900	mm
Maximum width OPT	For parallel guide cutting	1270	mm

NOTE
in the "COMPACT" version the only cutting width available, to the parallel guide, is 700 mm.

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4.2 Technical data

GENERAL TECHNICAL SPECIFICATIONS

Fixed table dimensions		1020 x 325	mm
Sliding table dimensions		1600 x 270	mm
Saw blade inclination		from 90° to 45°	
Maximum saw blade diameter		Øi 30 x 315	mm
Minimum saw blade diameter		Øi 30 x 250	mm
Maximum projection at 90°	With a 315 mm blade	100	mm
Maximum projection at 45°	With a 315 mm blade	78	mm
Maximum projection at 90°	With a 300 mm blade	92.5	mm
Maximum projection at 45°	With a 300 mm blade	73	mm
Maximum projection at 90°	With a 250 mm blade	68	mm
Maximum projection at 45°	With a 250 mm blade	55	mm
Saw blade rotation speed		3500	rpm
Saw blade stop time:		less than 10 seconds	
Scoring saw blade rotation speed		8000	rpm

Motors

Power of saw motor (three-phase):	50 Hz	4.0	kW

Technical Data: see motor identification plate
Type of service: S6 – 40% (exempt from energy efficiency restrictions set out by regulation (EC) 640/2009)
Service conditions: (see " Environmental conditions")

Net weight: see identification plate on the machine
Voltage and frequency of operation see identification plate on the machine

EXTRACTION TECHNICAL SPECIFICATIONS

Extraction inlet under table diameter	Ø 120	mm
Diameter of the extractor outlet on the protection guard (separated from the riving knife)	Ø 60	mm
Diameter of the extractor outlet on the hanging safety guard (separated from the riving knife) OPT	Ø 80	mm
Extractor air speed: dry shavings (humid shavings)	20 (28)	m/sec
Suction air flow (Ø 120 + Ø 60)	1018 (1425)	m³/h
Suction air flow (Ø 120 + Ø 80) OPT	1176 (1647)	m³/h
Vacuum value inside the fitting under the table [Ø 120 mm]	4179 (8191)	Pa
Extractor outlet vacuum on the safety guard (fixed to the riving knife) [Ø 60 mm]	1510 (2960)	Pa
Extractor outlet vacuum on the hanging safety guard (separated from the riving knife) [Ø 80 mm] OPT	1800 (3528)	Pa

4.3 Standard accessories

Table extensions
Squaring frame with extension arm and extendable aluminium rule with stops
(not available on the "COMPACT" version)
Fence for parallel cuts with micrometric adjustment
Sliding table in aluminium alloy with sliding guides
Eccentric clamping arm
Tile-shaped stop
1 Riving knive
N° 2 Brackets (for anchoring the machine to the floor)
Wood pusher
Wood pusher handle
Main motor direct start up
Transformer for auxiliary circuit 110 V
Overload cutout protection
Blade unit manual lifting and tilting
Guard for saw blade and scorer with suction hood of 60 mm diameter
Suction hood Ø 120 mm, on the rear frame side
Device for angular cuts (available as standard on the "COMPACT" version)
Set of tools and wrenches for use and maintenance

NOTE
In the "COMPACT" version the only cutting width available, to the parallel guide, is 700 mm.

4.4 Optional accessories

Sliding table attachment
Saw guide unit with micrometric rack adjustment (sliding on cylindrical section guide) - version with digital display
Tablet support device
Cutting width with parallel guide 1270
Device for oblique cuts
Suspended saw guard with Ø 80 mm diameter suction pipe junction
(not available on the "COMPACT" version)
Switch with electronic brake
Saw motor power (three-phase) - S6 / 40%:

- ..... 5 kW - 50 Hz

Saw motor power (single-phase) - S6 / 40%:

- ..... 2.2 kW - 50 Hz

Scoring unit

4.5 Noise levels

DECLARED DUAL-NUMBER NOISE EMISSION VALUES in accordance with ISO 4871

Operating conditions:		Circular sawblade cut		(in accordance with: EN ISO 19085-1:2017)*	
Description of sizes measured		Reference norm	Uncertainty K	Circular sawblade cut	
	Operator positions			**VSA**	**LAV**
Lop: Level of sound pressure at operator position dB(A) and peak level [dB(C)]	INFEED	EN ISO 11202:2010	4 dB	79	91 [110]
Lw: power of sound level emitted: dB(A)		EN ISO 3744:2010	2 dB	88	105
The maximum istantaneus noise level pressure is under 130 dB (C).					
VSA: idle working without suction			**LAV** : at work		

DANGER

The measured sound levels are emission values and cannot necessarily be taken as safe workplace levels. Although there is a correlation between the emission levels and the exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors influencing the actual level of worker exposure include duration of exposure, the characteristics of the workplace, other sources of emission (e.g. the number of machines installed and other adjacent machinery). The permitted exposure values may also vary from country to country. The user should take all this into account to improve evaluation of the associated risks and dangers.

Some factors which reduce exposure to noise:

- correct tool choice (see Par. "Tools")
- correct speed selection (where adjustment is possible);
- tool and machine maintenance
- correct use of hearing protection.
- type of material machined.

4.6 Dust emission

DUST EMISSION	
Operating conditions – CUT	
Reference norm: **BG-GS-HO- 05**	Dust emitted [mg/m^3]
Operator station	< 2

DANGER

HARD WOOD DUST IS HARMFUL.

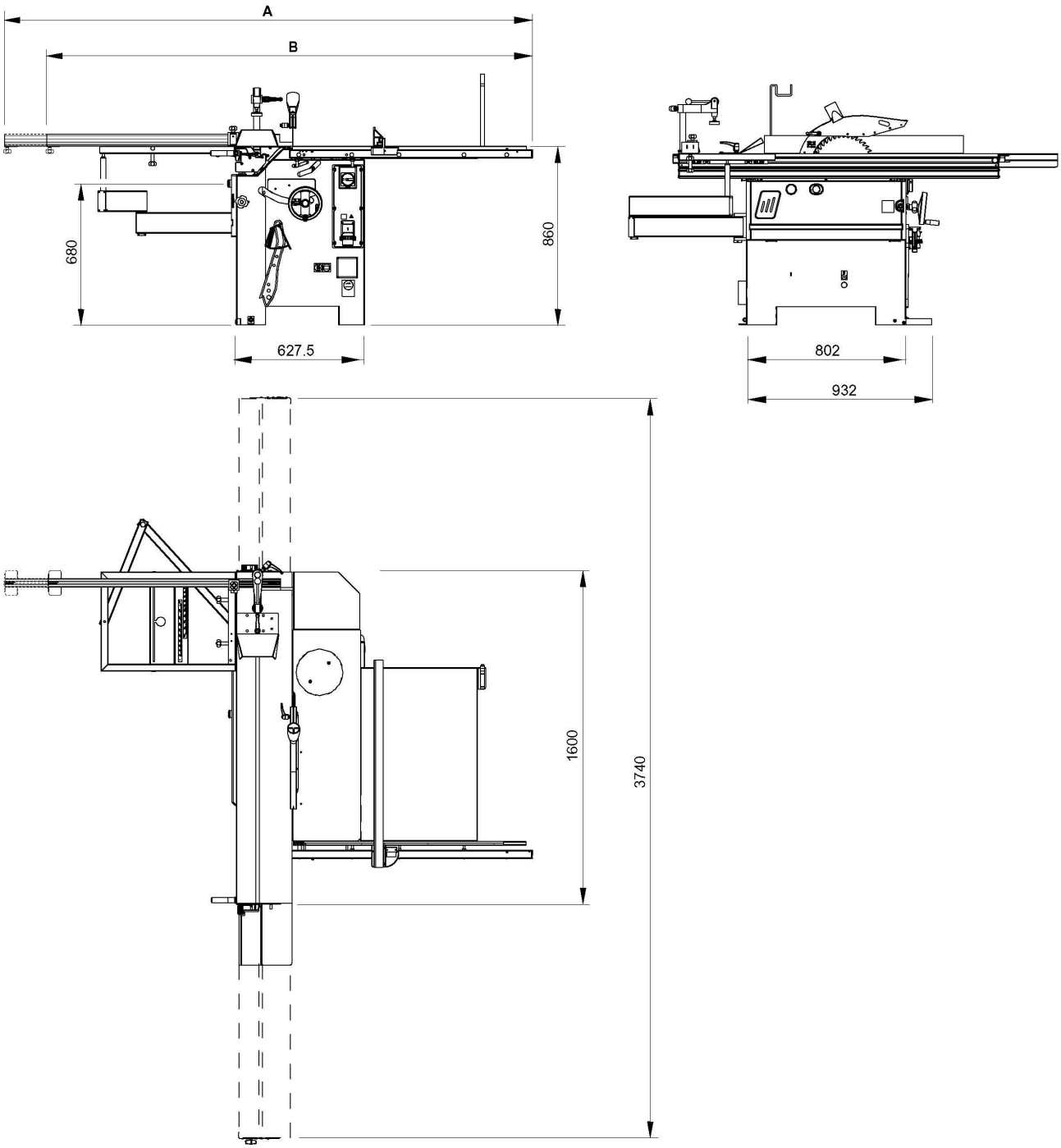
PROHIBITED

DO NOT USE COMPRESSED AIR.

DANGER

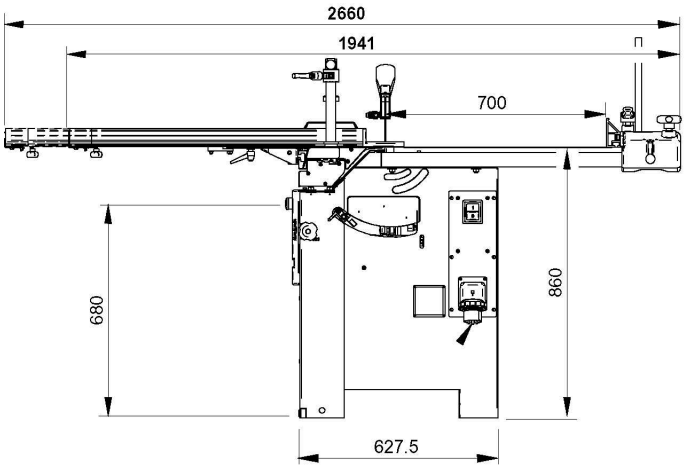
the dust extraction hood must be connected to the extraction system. Work only with the intake system inserted.

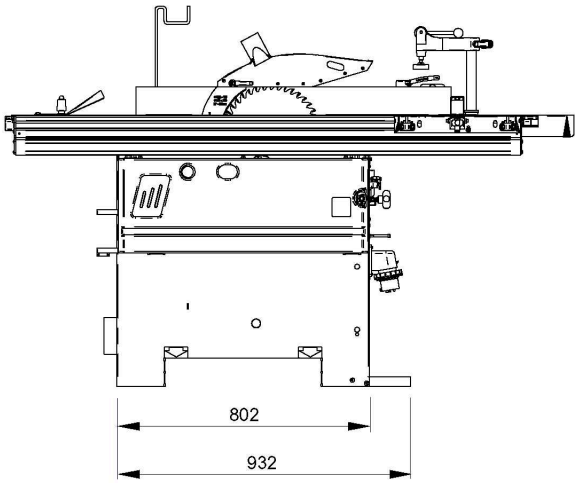
4.7 Encumbrance dimensions

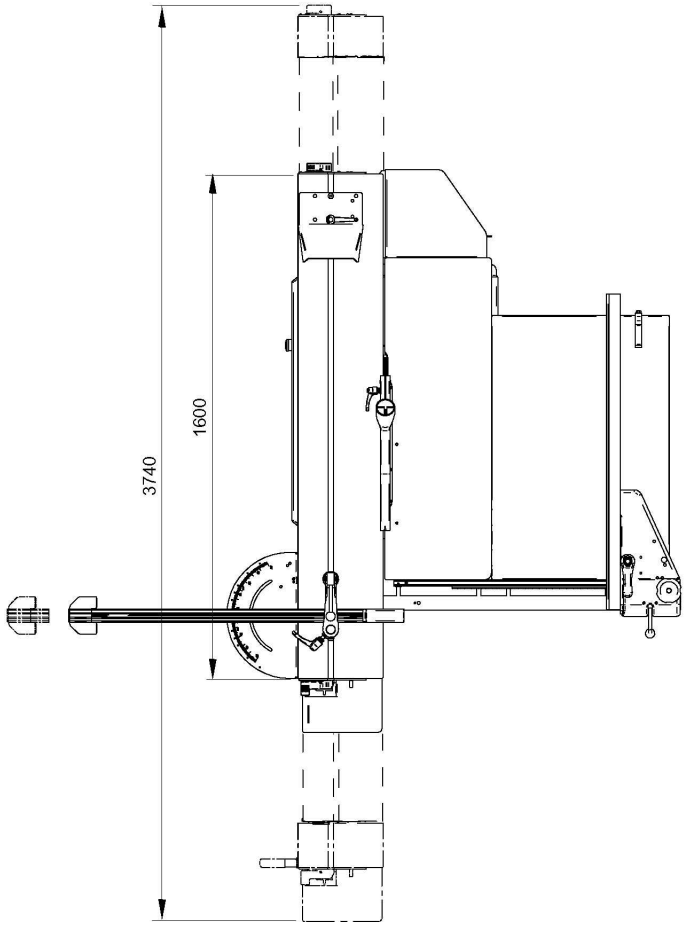


A = 2420 With cutting width 900 mm on parallel guide
B = 2840 With cutting width 900 mm on parallel guide
A = 2780 With cutting width 1270 mm (OPT) on parallel guide
B = 3200 With cutting width 1270 mm (OPT) on parallel guide

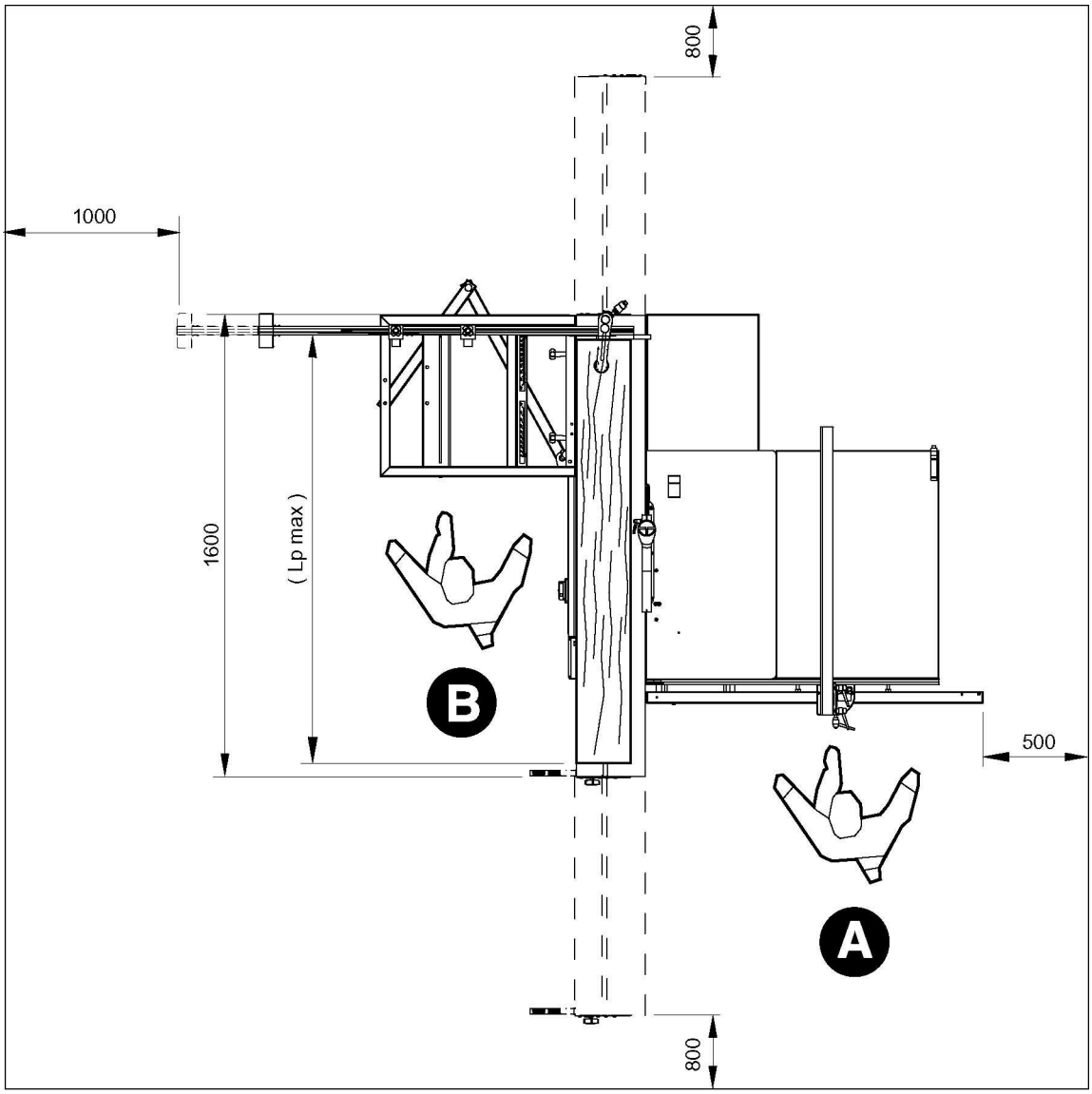
"SC 2C COMPACT"







4.8 Work area



B = Sliding table machining	Parallel cutting = A

SPECIALISED PERSONNEL

the measures above indicated are to be considered as the free room of the working area.

SPECIALISED PERSONNEL

Lp max = Max. workpiece length

DANGER

The machine is designed for use by one operator.

5 Installation

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5.1 Unloading the machine

NOTE

The machine package indicates:

- the weight to lift
- the hookup areas

DANGER

during loading and unloading, avoid knocks to prevent damages to persons or things. Make sure no one is standing under the overhung load and/or within the bridge crane working range during machine lifting and handling.

Before unloading the machine, remove all the parts used for transport or packaging.

DANGER

- **The machine must be unloaded with a crane or other lifting equipment by hooking the cables as shown in the figure.**
- **Ensure that the crane, cables or lift truck have a capacity equal to or greater than the weight of the machine.**

If a bridge crane or a crane is available, proceed as follows:

- prepare three slings(C) with an adequate length and lifting capacity (minimum sling length 2000 mm);
- lift the slings and position them as is shown in the figure;
- fasten the slings to the bridge crane (D) having adequate lifting power;
- move the bridge crane by small steps to allow the slings (C) to settle, until optimum stability conditions are reached;
- lift carefully and slowly, without causing the load to swing, and place the machine in the selected setting.

If hoisting is carried out with a lift truck A, proceed as follows:

- Provide a fork lift truck (A) having suitable carrying capacity;
- Insert the forks (B) as per the figure keeping them alongside the two feet (E) and check that these protrude at least 15 cm from the rear part of the base.

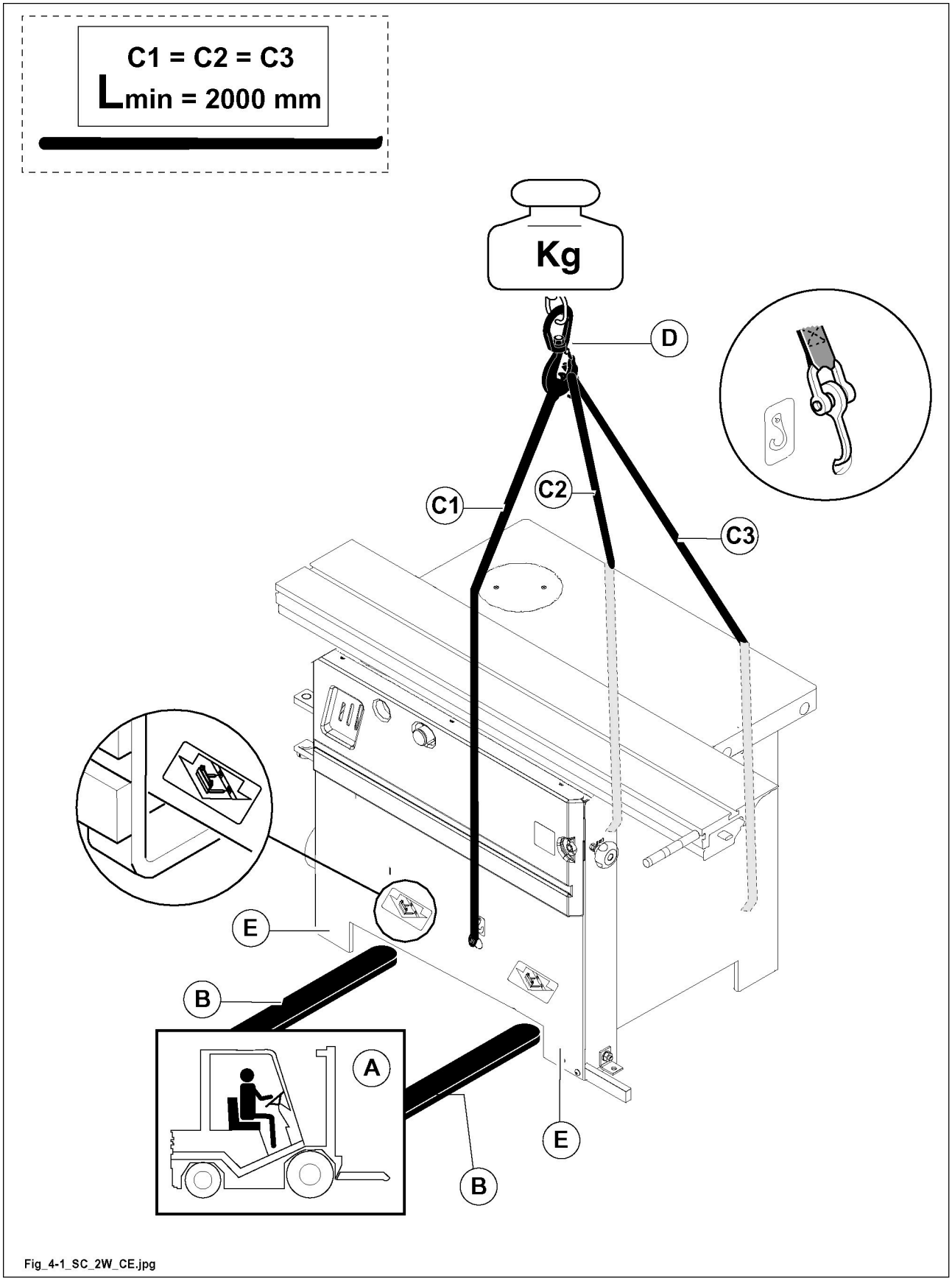


Fig_4-1_SC_2W_CE.jpg

5.2 Positioning

The position where to install the machine shall be well lightened (at least 500 LUX), proper for the connection to the power line, to the suction system and for maintenance operations.

DANGER

During the machine positioning bear in mind that when machining long workpieces, there must be sufficient space to avoid creating possible crushing points against fixed parts of the location, such as walls, columns, etc. (see "Work area").

Check that the floor is solid enough to support the base at the contact points uniformly. We recommend a concrete flooring and do not recommend an asphalt flooring.

We recommend positioning steel plates between the feet and the flooring, with anti-vibration material, if necessary.

DANGER

it is strongly recommended that the machine is fixed to the floor. Fix the supplied angles (B) to machine feet (A) and fix on ground by means of expansion bolts (C) (not supplied).

Some machine parts are greased and oiled.

Before starting working carefully degrease the working areas as well as the guards with not dangerous solvent.

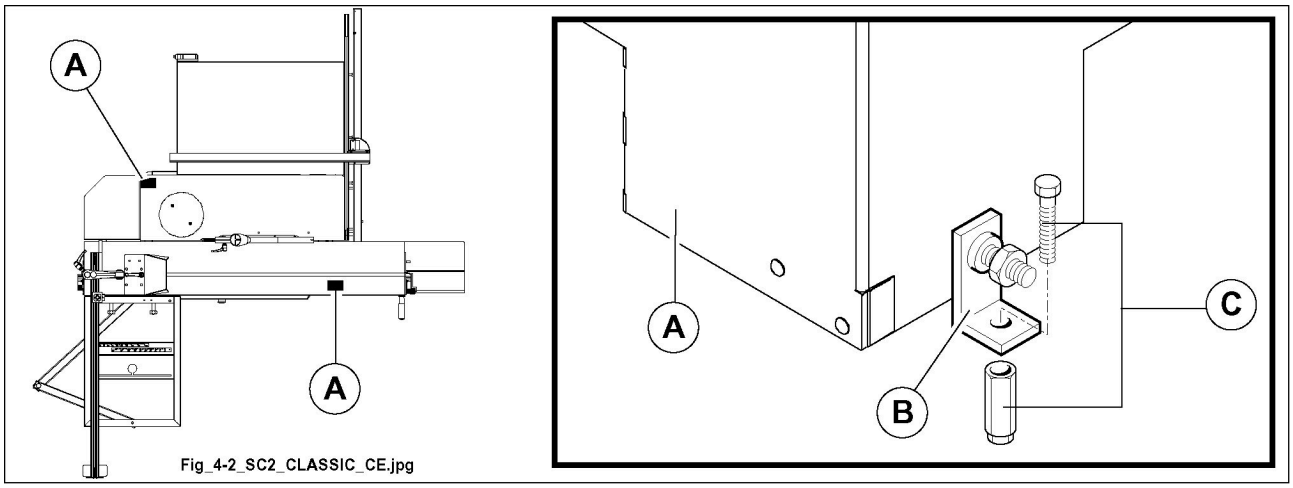


Fig_4-2_SC2_CLASSIC_CE.jpg

5.2.1 Anti-overturning foot - Installation

Open the hole already prepared (T), as illustrated.

- Mount the foot support (A) through the screws (B).

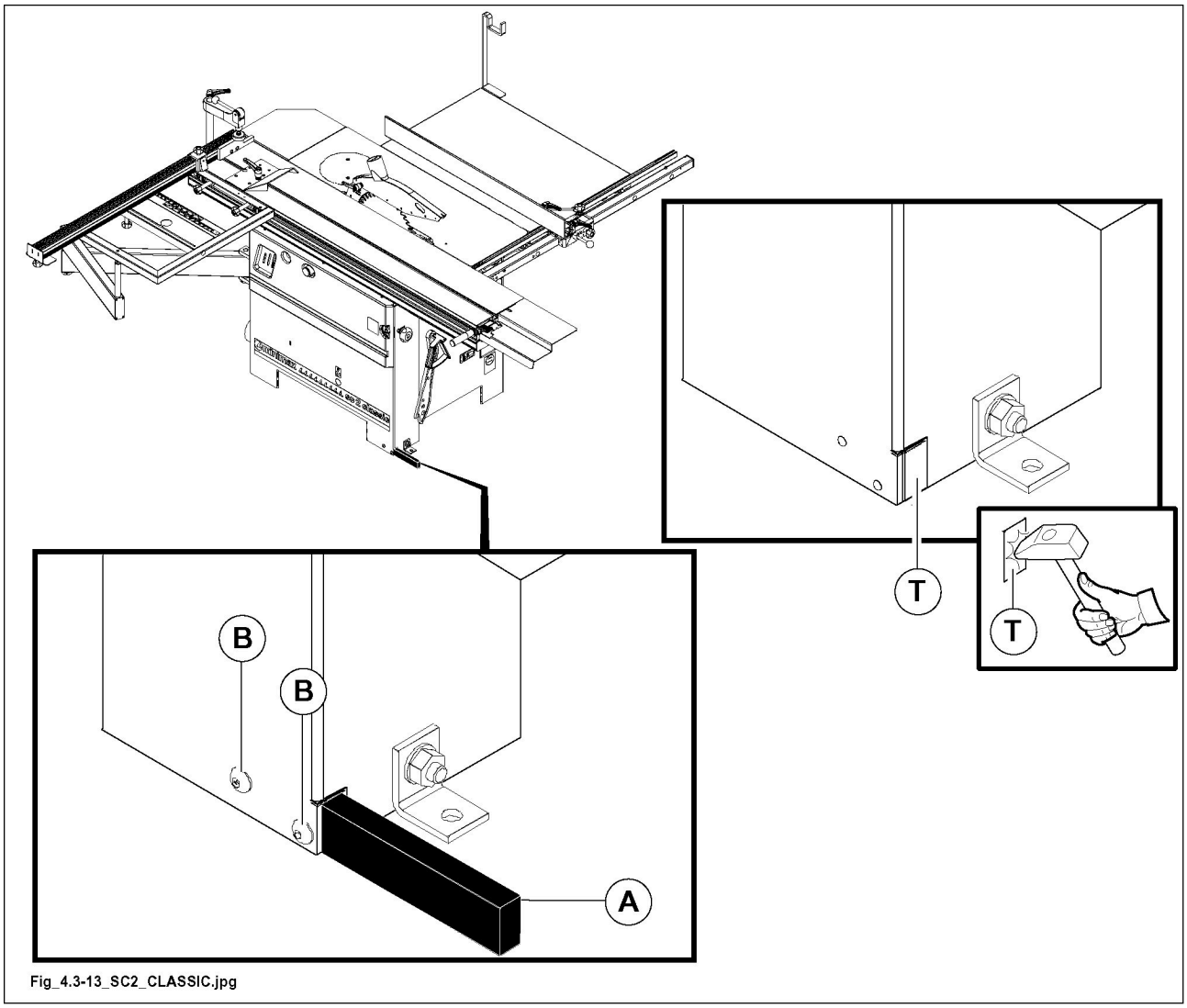


Fig_4.3-13_SC2_CLASSIC.jpg

5.3 Fitting parts removed for transport requirements

For packaging and transport reasons some parts are shipped unassembled.

1. Before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket) from the plug on the machine.

Padlock keys must only be in the possession of the person carrying out the machine adjustment, maintenance or cleaning work.

5.3.1 Table support device assembly on the sliding table OPT

- Install the column (N) with the tablet holder (E) inserting the gib (R) in the sliding table groove (C).
- Use the handle (D) to free the tablet holder device, move to the desired position in the sliding table groove and block it.
- Loosening the handle (B) releases the ball joint (S) so that you can adjust its orientation.
- Finally loosen the handle (A), to move the tablet support device (E) to the desired height and then block it.

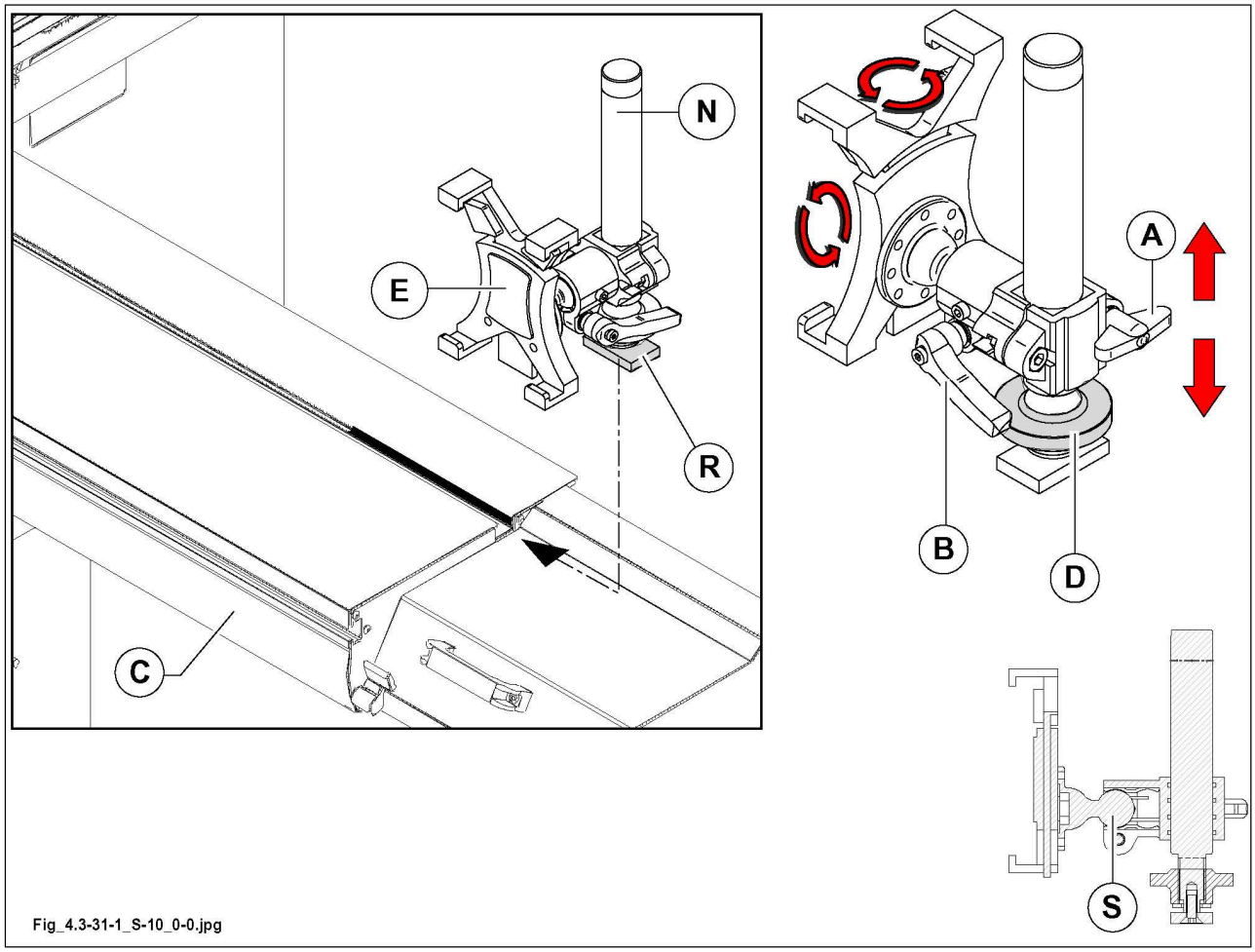


Fig_4.3-31-1_S-10_0-0.jpg

NOTE

To use the tablet support device (E) correctly refer to the attached manual.

5.3.2 Sliding table table - installation

Proceed as follows:

- Remove the blocking sheet metal (A) from the slide right side.
- Tighten the screw (B) in the fixed part of the carriage, under the slide.
- Position the blocking lever (C) in the seating (S) of the closure cap (D).
- Move the closure cap (D) close to the slide (right side), make sure that the tables are aligned and tighten the 4 screws (E). If the grub screw (F) on the lever (C) prevents the operation described above, unscrew the grub screw (F) as required.
- Tighten the grub screw (F) making sure that it is inserted in the hole of the pin (G).
- Remove the blocking lever sheet from the opposite side of the sliding table.
  The lever (G) is used to block the sliding table in the standby position (sliding table closed), and in the position to load the piece being machined (sliding table fully to the right limit switch).

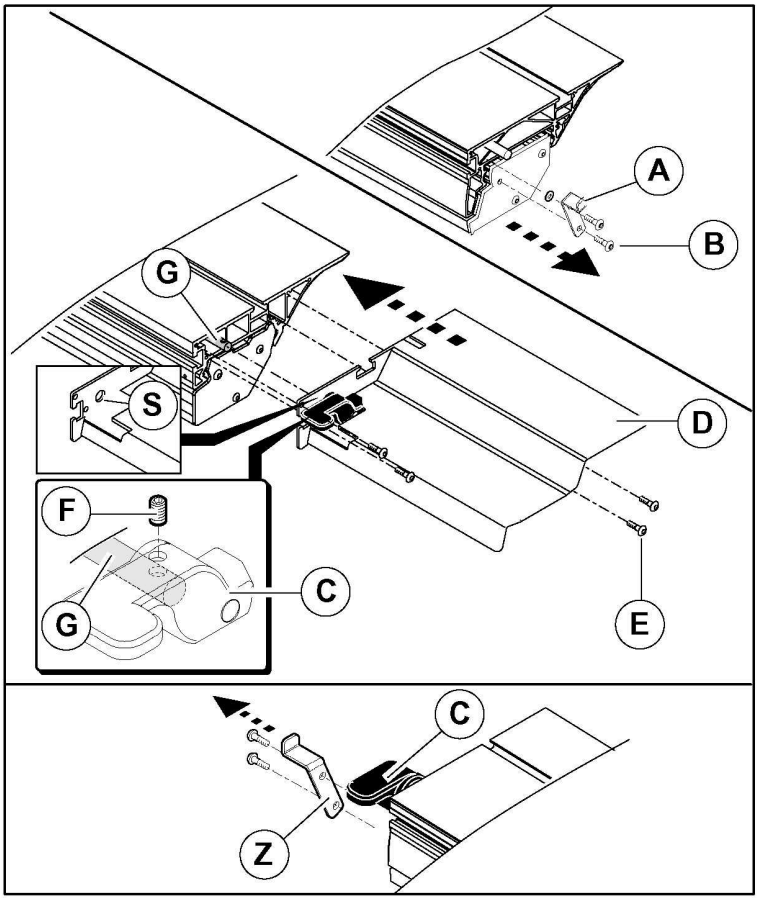


Fig_4.3-11_LAB-300P_1-0.jpg

5.3.3 Fitting the saw blade

DANGER

Use proper gloves for handling the saw blade.

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S.

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

To fit or replace the saw blade, proceed as follows:

1. move the saw unit fully upwards (with a tilting of 90°).
2. Position the squaring frame (A) as shown in the figure and move the sliding table (H) fully to the right.
3. Open the protection (N).
4. Insert the pin (B), in the accessories pack, inside the hole of the saw shaft pulley.

   NOTE
   A safety limit switch guarantees that motor cannot be started when the guard (N) is open.

   NOTE
   the locking nut (C) of the saw blade is counter-clockwise; to unscrew it turn it clockwise.

5. Loosen the lock nut (C) using a 24 mm hex wrench and remove flange (D).
6. In sequence mount the saw (E), the flange (D) and the nut (C) (to prevent any vibration, thoroughly clean the flanges before mounting the saw blade).
7. Tighten the nut using the 24 mm wrench and the pin (B).
8. Adjust the height position of the riving knife (F) by loosing the nut (G) so that the distance between knife and blade is between 3 and 8 mm. (**THE ADJUSTMENT COULD BE EASIER WITH THE BLADE FULLY OUT OF THE TABLE**).

   CAUTION
   For safety reasons it is obligatory to close the guard (N), otherwise:

   - the machine does not start.
   - The guard interferes with the sliding table motion.

DANGER

Adjust the position of the riving knife so that its distance from the saw blade is between 3 and 8 mm.

The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

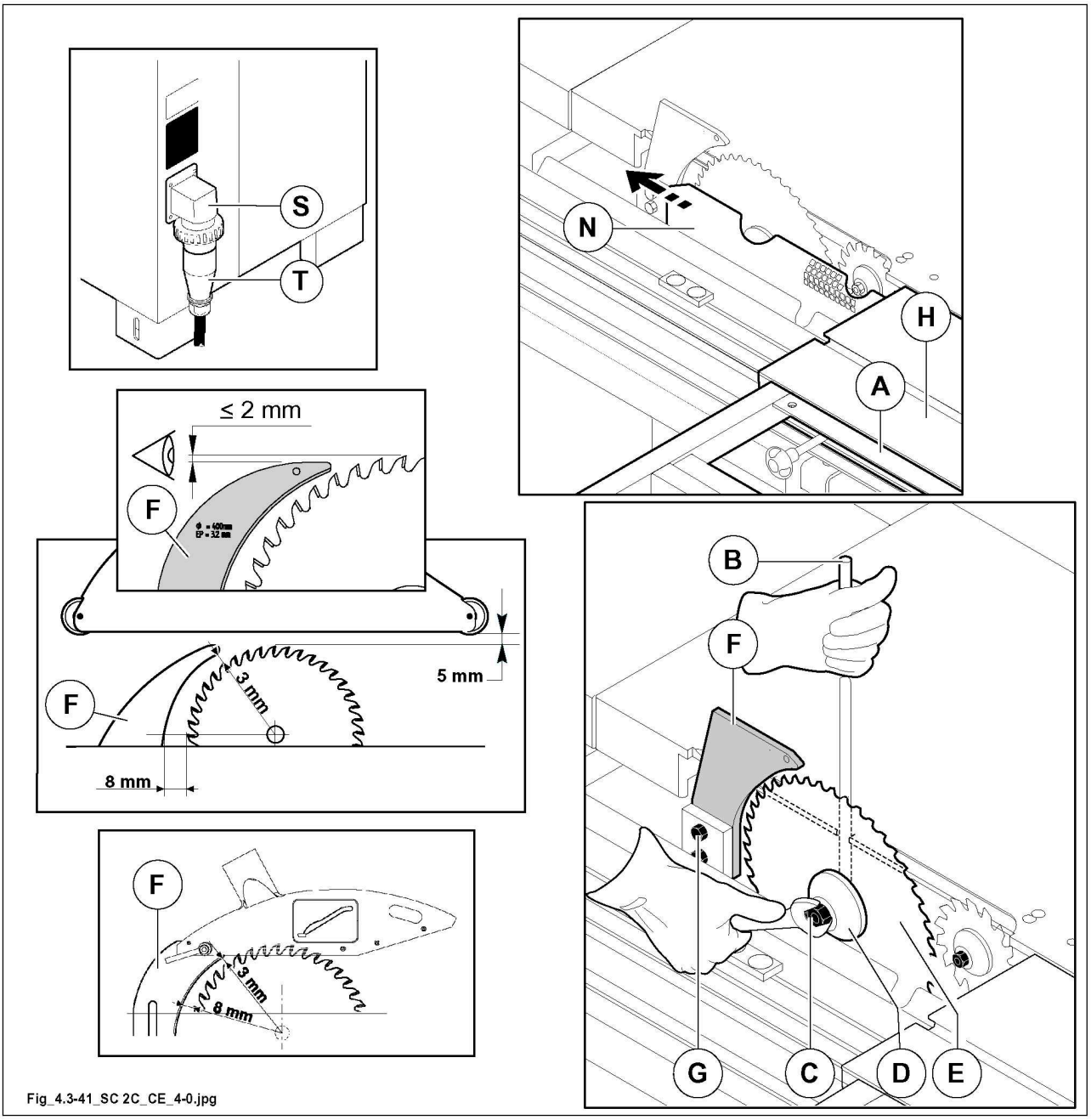


Fig_4.3-41_SC 2C_CE_4-0.jpg

5.3.4 Fitting the guard for saw blade and scorer

- Raise the saw unit by rotating the handwheel (A).
- Remove the spacer blocks (S) inside the guard (C).
- Insert the guard (C) in the hole (D) and tighten the handle (E).

DANGER

Never remove this guard: it shall be fitted in order to cover the saw blade as much as possible.

NOTE

The machine is always equipped with 1 riving knife. Fit the guard to the riving knife according to saw blade diameter (you have to consider the reference elements engraved on the riving knife).

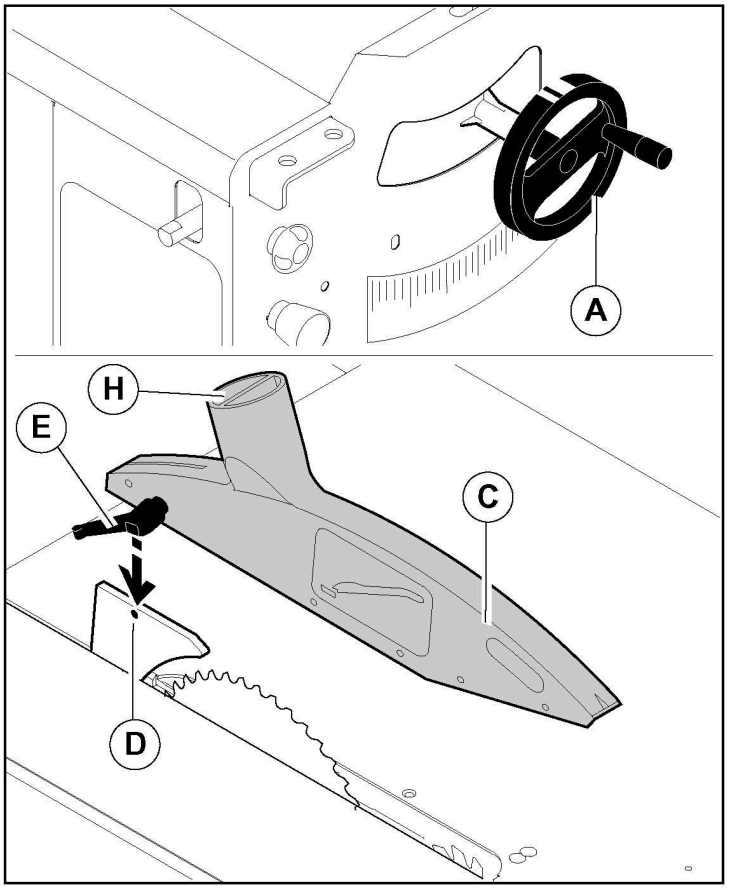
DANGER

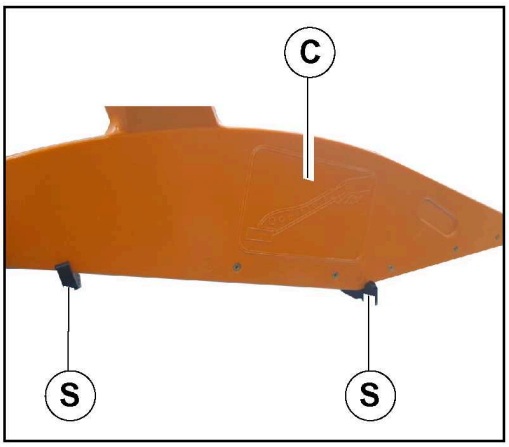
adjust the position of the riving knife (see Par. " Riving knife adjusting") so that its distance from the saw blade is between 3 and 8 mm (see example in the figure). The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

Connect the sawdust/shavings extractor intake (H) to the extraction system using hoses with a matching diameter.

PROHIBITED

With this protective hood, it's strictly forbidden to carry out not-through cuts.





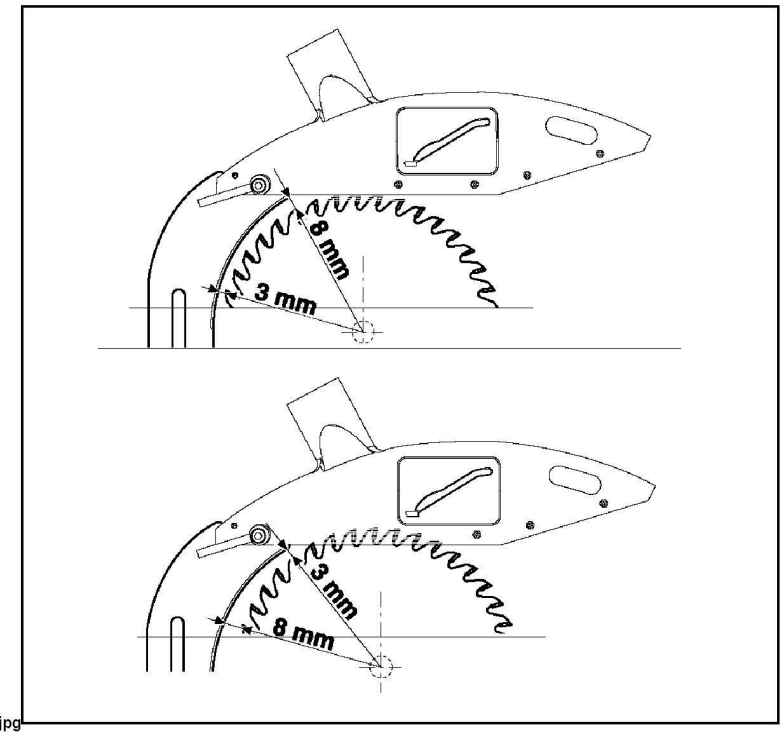


Fig_4.3-12_SC_3W_CE_1-0.jpg

5.3.5 Fitting the fence for parallel cuts

DANGER

All fitting and demounting operations require 2 persons.

The round guide bar (H) can arrive disassembled for transport requirements.

SPECIALISED PERSONNEL

do not loosen the nuts (D) as they are adjusted by our technicians to the correct positioning of the cylindrical guide nor remove a washer.

Unscrew and remove the nut and a washer (E1) from the studs (C) of the round bar (H) (see det. 1).

1. Insert the stud bolts (C) in the respective holes, placing the nuts (D) against the table (B).
2. Insert the washer and nut (E1) on the respective studs (C).
3. Tighten the nuts (E1).

The round support bar of the guide for parallel cuts is installed. Now you can proceed with the installation of the rear extension table (see Par. " Fitting the rear additional table").

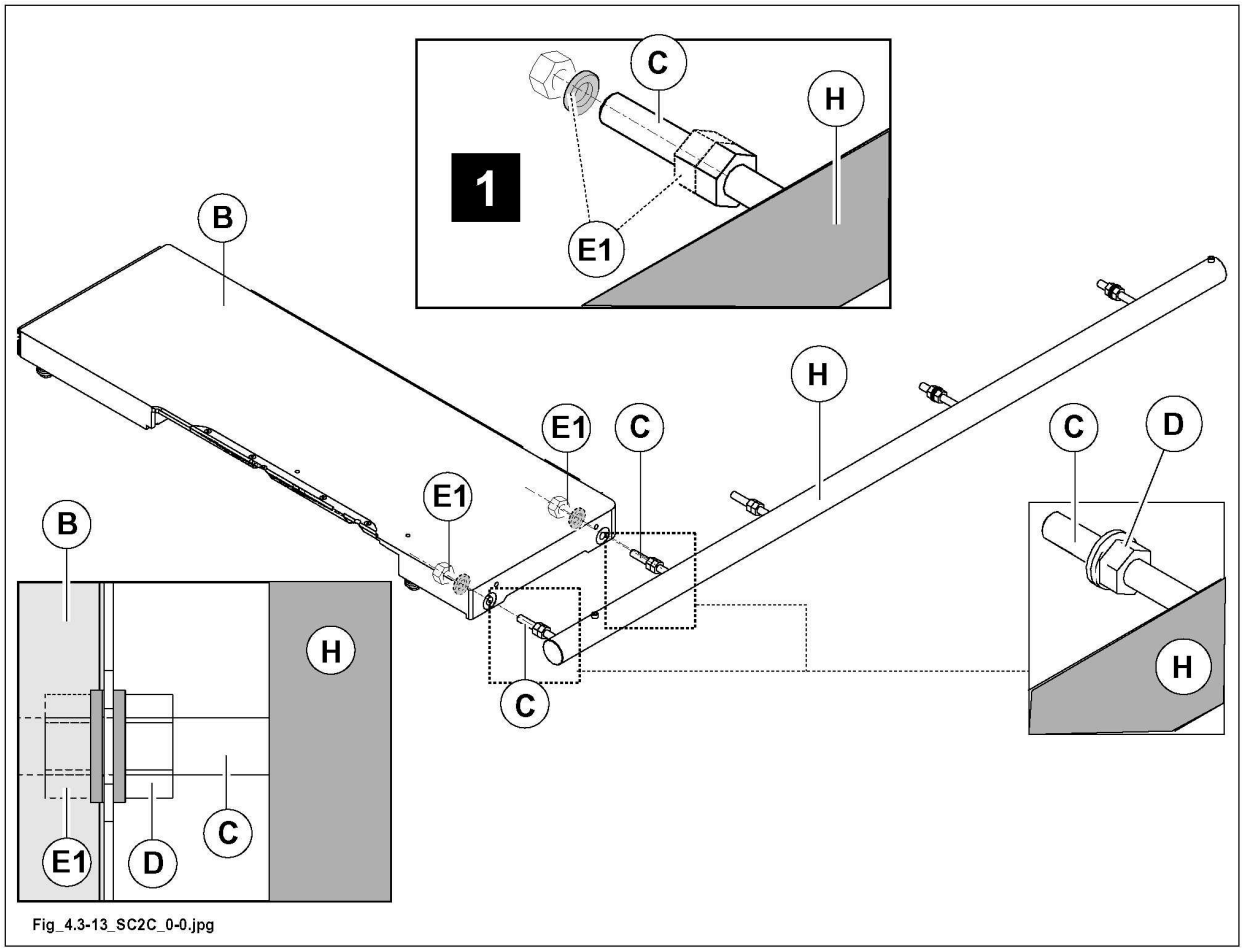


Fig_4.3-13_SC2C_0-0.jpg

5.3.6 Fitting the additional tables

DANGER

All fitting and demounting operations require 2 persons.

5.3.6.1 Fitting the rear additional table

There are two tables of different sizes:

940x837 OPT	Max. cutting width:	1270 mm
565x837	Max. cutting width:	900 mm

NOTE

in the "COMPACT" version there is only one additional table of dimensions:

565x837	Max. cutting width:	700 mm

Unscrew and remove the nuts and washers (Q) from the studs (S) of the round bar (H) (see det. 1).
ADDITIONAL TABLE FOR 900 mm CUT
and TABLE FOR CUTS 700 mm (only on the "COMPACT" version)

1. Secure the additional table (A) to the work table (B) as follows:
   - loosen the screws (C) that are already screwed to the table (B);
   - move the extension table (A) close to the worktable (B) so that the head of the screws (C) enters in the slots (1) and the studs (S) on the round bar (H) in the holes (2); to make the operation easier, if necessary, remove the screws (C) and re-insert them immediately after having positioned the table (A).
2. Adjust the extension table with the grub screw (F).
3. Secure the additional table (A) to the worktable (B) screwing the screws (C).
4. Manually tighten the nuts (M) against the extension table (A) paying attention not to bend the guide (H).

   Insert the washers and nuts (Q) and tighten.
5. Check the linearity of the guide (H) and adjust, if necessary, with the nuts (M).

ADDITIONAL TABLE FOR 1270 mm CUT OPT

1. Secure the additional table (A) to the work table (B) as follows:
   - loosen the screws (C) that are already screwed to the table (B);
   - move the extension table (A) close to the worktable (B) so that the head of the screws (C) enters in the slots (1) and the studs (S) on the round bar (H) in the holes (2); to make the operation easier, if necessary, remove the screws (C) and re-insert them immediately after having positioned the table (A).
2. Fix the leg (D) to the extension table (A) by screwing the screws (E) after having removed the nuts (K) used to block them during the transport.
3. Adjust the levelling screw (L).
4. Secure the additional table (A) to the worktable (B) screwing the screws (C).
5. Manually tighten the nuts (M) against the extension table (A) paying attention not to bend the guide (H).

   Insert the washers and nuts (Q) and tighten.
6. Check the linearity of the guide (H) and adjust, if necessary, with the nuts (M).

- Move the table (P) close to the extension table (A) so that the last stud (S) of the round bar (H) enters in the corresponding hole (3).
- Fix the table (P) to the surface (A) using the screws (C) and align it perfectly with the surface (A) (check alignment using a rule).
- Adjust the extension table with the grub screw (G).
- Manually tighten the nut (M) against the table (P) paying attention not to bend the guide (H).
  Insert the washers and nut (Q) and tighten.
- Check the linearity of the guide (H) and adjust, if necessary, with the nuts (M).
- Fix the angle section (X) to the table (A) using the screws (T) and align it perfectly to the table (A) (check alignment with a reference rule).

NOTE

the table (P) is not available on the "COMPACT" version.

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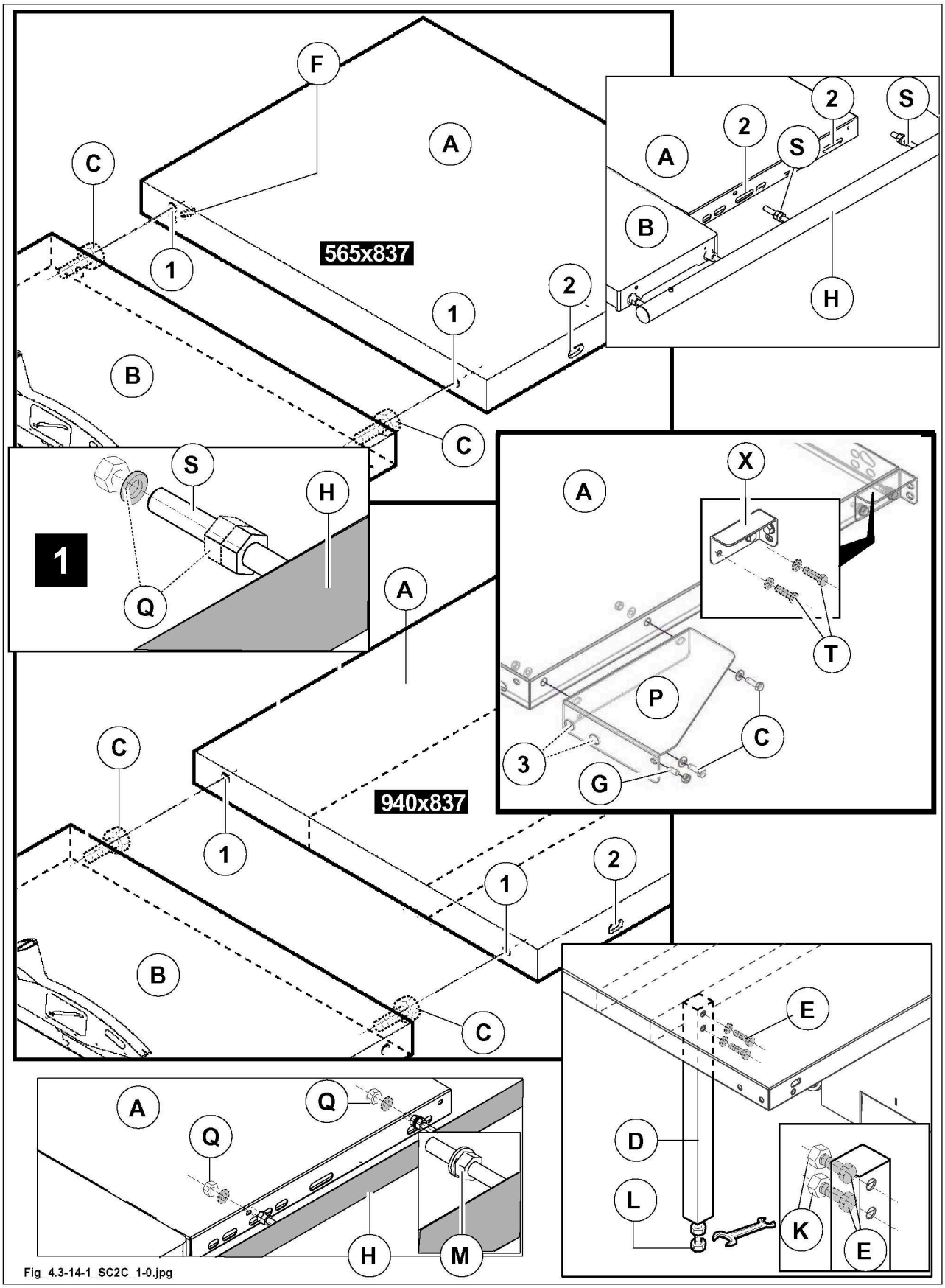


Fig_4.3-14-1_SC2C_1-0.jpg

5.3.6.2 Fitting the additional table at exit side

To install the table (A) on the left side of the worktable (B) proceed as follows:

- loosen (or remove them if necessary) the screws (C);
- install the table (A) moving it up to the worktable (B) so that the sheet metal (G) can slide between the two sheet metal parts (F) and the heads of the screws (C) are positioned in the slots (1, 2)
- tighten the screws (C) and align the table (A) perfectly with the tables (B, E) using the grub screws (D);
  the grub screws (D) with the respective blocking nuts are already fitted in the holes (H) on the back of the sheet metal (L). To make it easier to adjust the table (A) we recommend removing the nuts from the adjustment grub screws and, after having aligned the tables, fit them back on to prevent any loosening.

SPECIALISED PERSONNEL

check alignment using a reference rule (R).

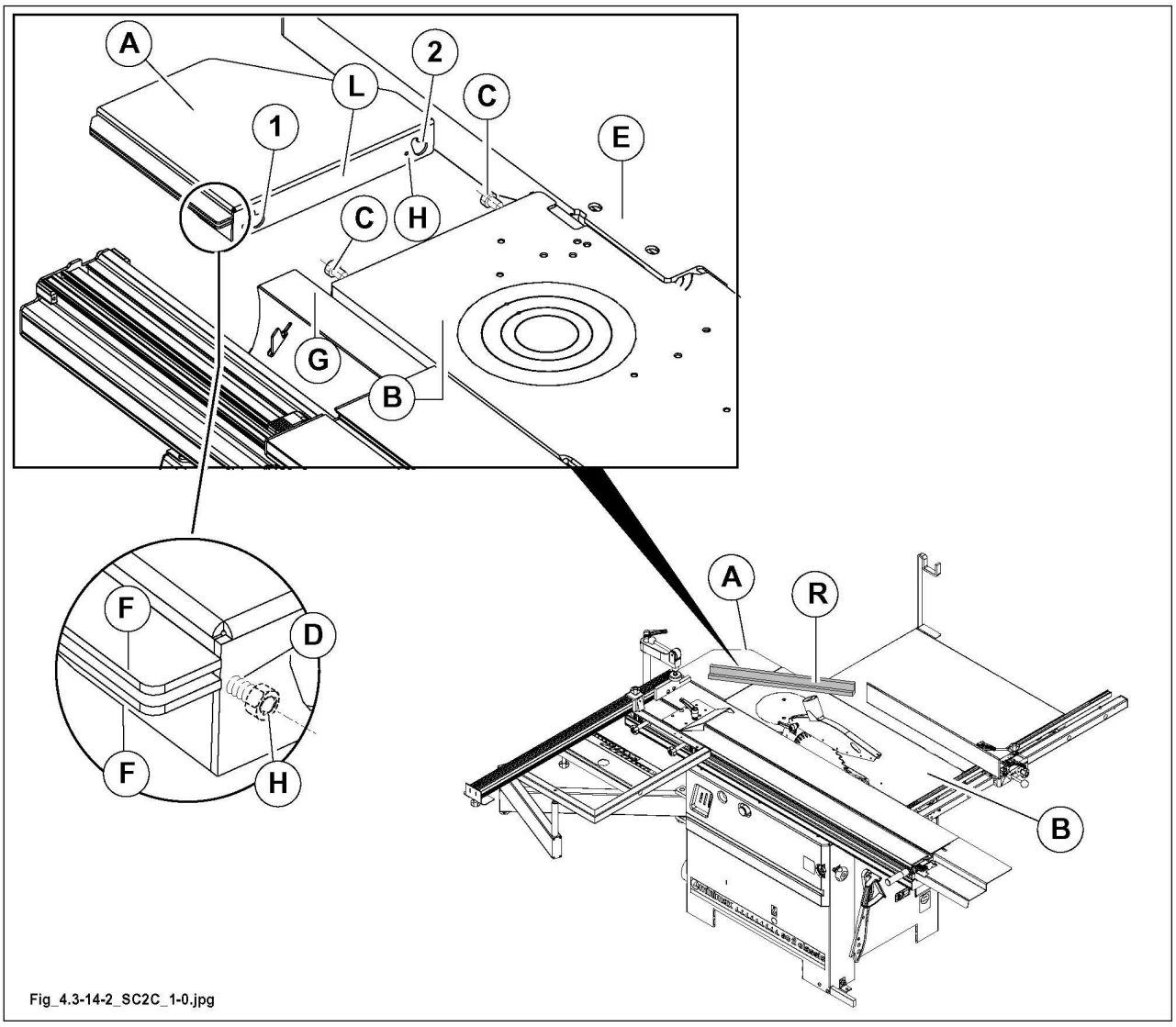


Fig_4.3-14-2_SC2C_1-0.jpg

5.3.7 Fitting the supporting frame

NOTE
not available on the "COMPACT" version.

NOTE
For transport reasons the frame is demounted from the machine.

DANGER
block the carriage (A) with the lever (N).

- Insert the support (B) in the front groove of the wagon (A).
- Position the flag (G) as shown in the figure; rest the frame (D) on the support (B) inserting the two pads (H) in the groove of the sliding table and the screw (F) in the hole (E).

NOTE
The screw (D) must sit perfectly in the special hole underneath the frame (D).

- Use a reference rule to level the table (D), if necessary, by using screw (F) through the hole (E).
- Tighten the knobs (C).
- Insert the column (L) with the presser (M) in the groove of the slide carriage (A), and position it along the carriage where it is most convenient and rotate it clockwise to block it.
- When the sliding table (A) is not being used block it with the lever (N).

The table is already registered; to make further adjustments proceed as follows:

- loosen the knobs (C);
- loosen the screws (P) and use the grub screws (Q) to adjust the height.
- **Tighten the screws (P) and the knobs (C).**

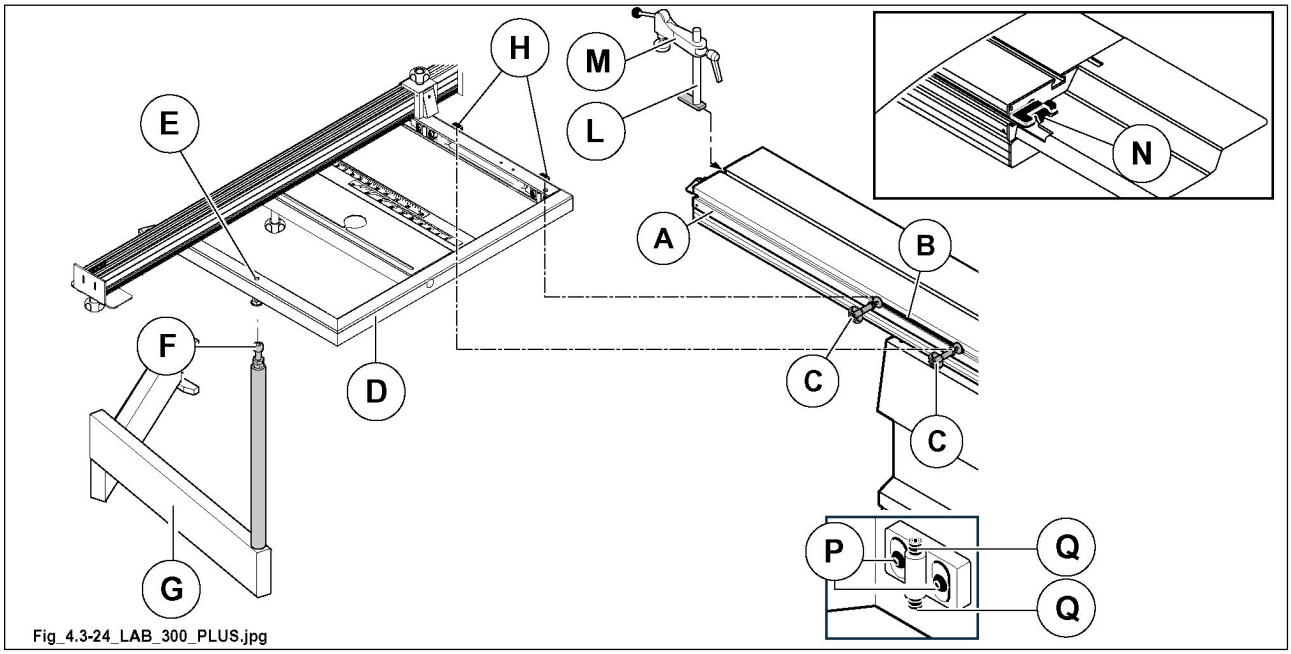


Fig_4.3-24_LAB_300_PLUS.jpg

5.3.7.1 Fitting the rest rule

NOTE
not available on the "COMPACT" version.

Ⓐ - Installation for 90° cuts

1. Rest the telescopic rule on the table (A) inserting the fulcrum (C) (in the lower part of the square rule) in the hole (R) of the square frame.

   Loosen and insert the knob (F) in the slot (T) through the hole (D).
2. Position the telescopic rule so that the pin (C) goes against the gib (L) (the gib is blocked and positioned in the groove in the lower part of the rule); the gib (L) is adjusted by our technicians, so that the telescopic rule can be positioned quickly at the right distance from the saw blade (only at the position at 90°).
3. Position the telescopic rule so that the pin (E) goes against the device (S).
4. Tighten the knob (F).

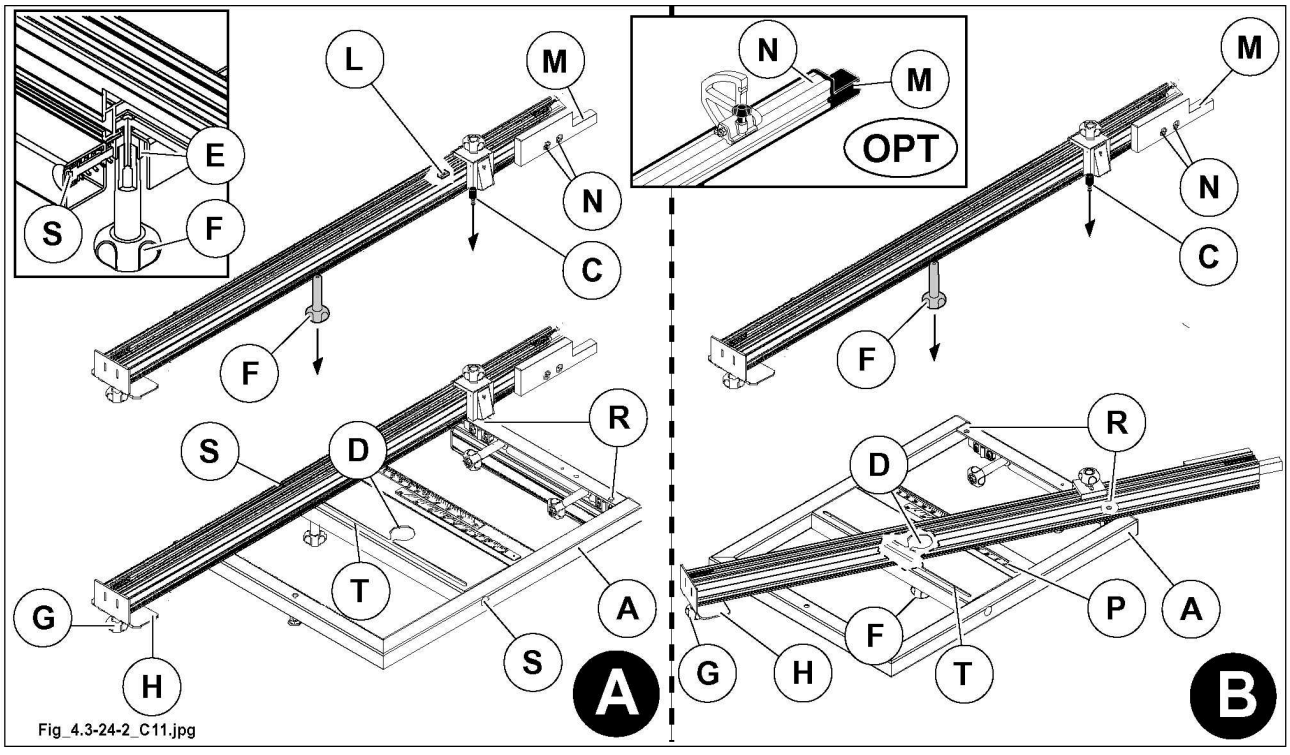
Ⓑ - Installation for tilting cuts

1. Rest the telescopic rule on the table (A) inserting the fulcrum (C) (in the lower part of the square rule) in the hole (R) of the square frame.

   Loosen and insert the knob (F) in the slot (T) through the hole (D).
2. For use, position the ruler referring to the plate (P).
3. Tighten the knob (F).

   The ruler is fitted with an extractable telescopic extension (H), which may be lengthened as required after loosening the knob (G). When the splinter guard (M) is worn, bring it up against the saw blade by loosening the two screws (N).

Ⓐ = Installation for 90° cuts	Installation for tilting cuts = Ⓑ



5.3.8 Device for angled cuts installation OPT

NOTE
available as standard on the "COMPACT" version.

1. Insert the stud bolt (N) with the presser (E) into the groove of the sliding table (C);
2. Mount the ruler assembly (A) inserting the gib (R) in the groove of the sliding table (C);
3. Tighten the levers (G).
4. Release the handle (F).
5. Position the ruler assembly at the right distance from the saw blade; at a 90o angle send the ruler assembly to stop up against the gib (L); the gib (L) is adjusted by our technicians and serves to quickly position the ruler assembly at the right distance from the saw blade.
6. To make angular cuts turn the ruler assembly (A) using index (D) as a reference.
7. Block by tightening handle (F).
8. Position the presser up against the ruler assembly ensuring that the washer (Q) is inserted into the groove.
9. Rotate the stud bolt (N) clockwise to block.

The table is already registered; to make further adjustments proceed as follows:

- loosen the levers (G);
- use the grub screws (S) to adjust the parallelism to the sliding table;
- loosen the screws (T) and use the grub screws (U) to adjust the height.

When the clip guard (M) is worn, bring it up against the saw blade by turning the blocking screws.

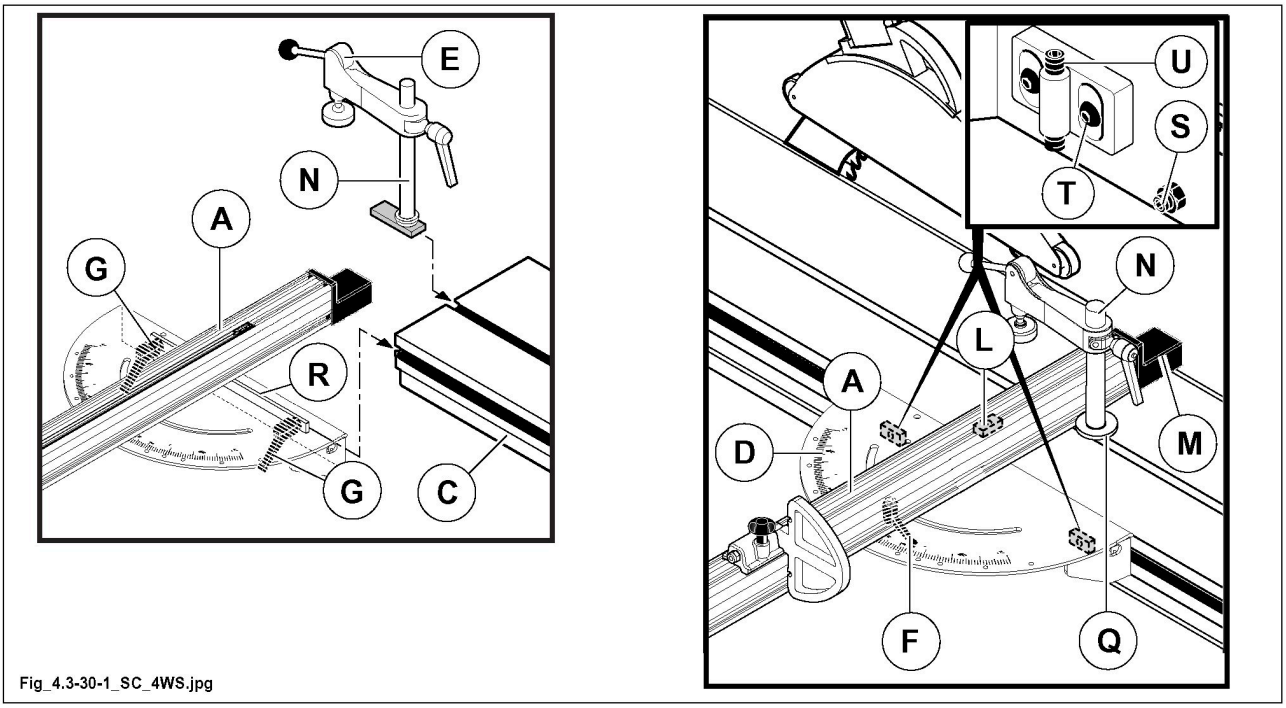


Fig_4.3-30-1_SC_4WS.jpg

5.3.9 Installation of the additional table on the sliding table to support large panels OPT

Proceed as follows:

1. Install the table (A) inserting the gib (B) in the groove of the sliding table (C).
2. Tighten the levers (D).
3. The table is already adjusted. For further adjustments use the grub screws (E) (levelling) and the screws (F)(height).

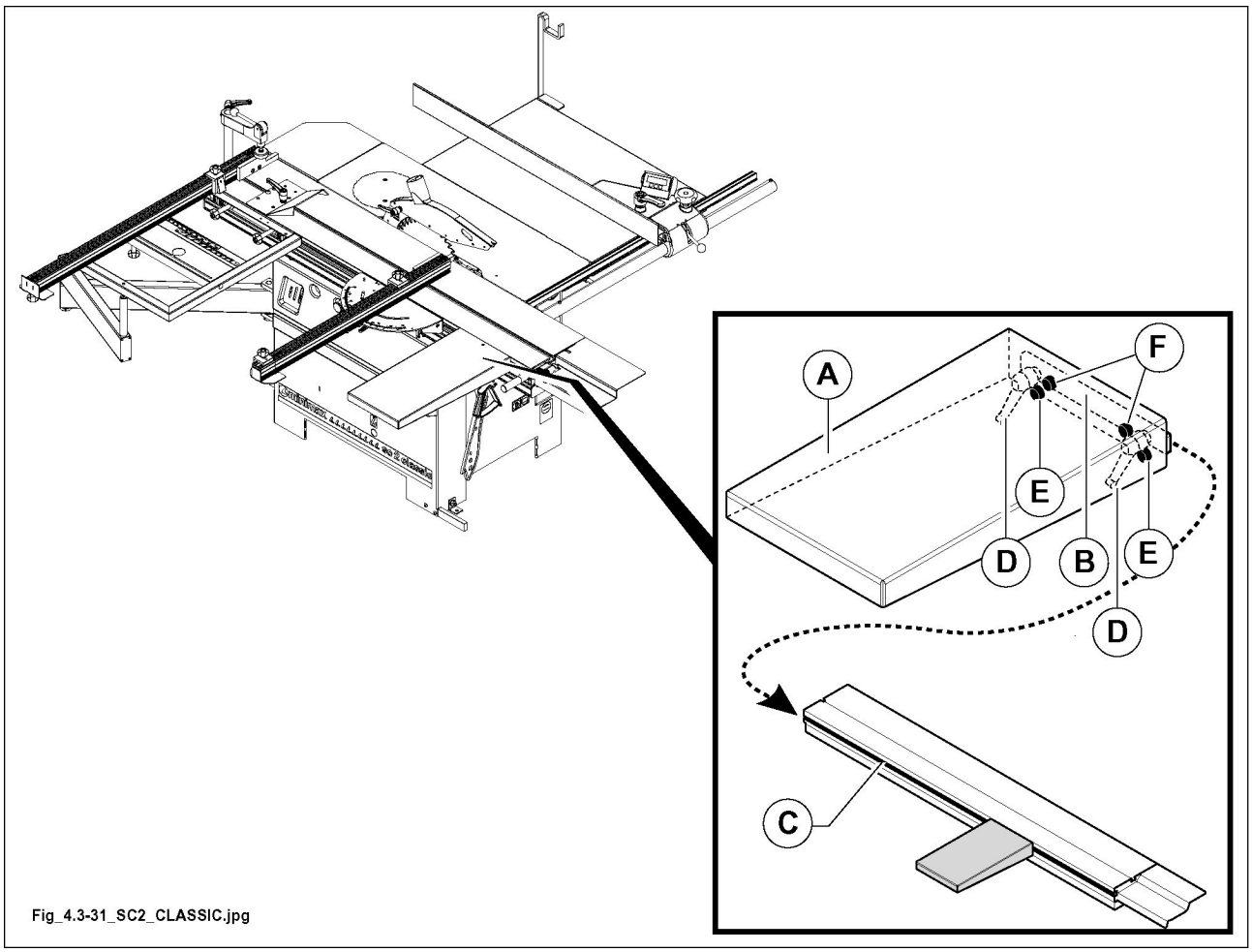
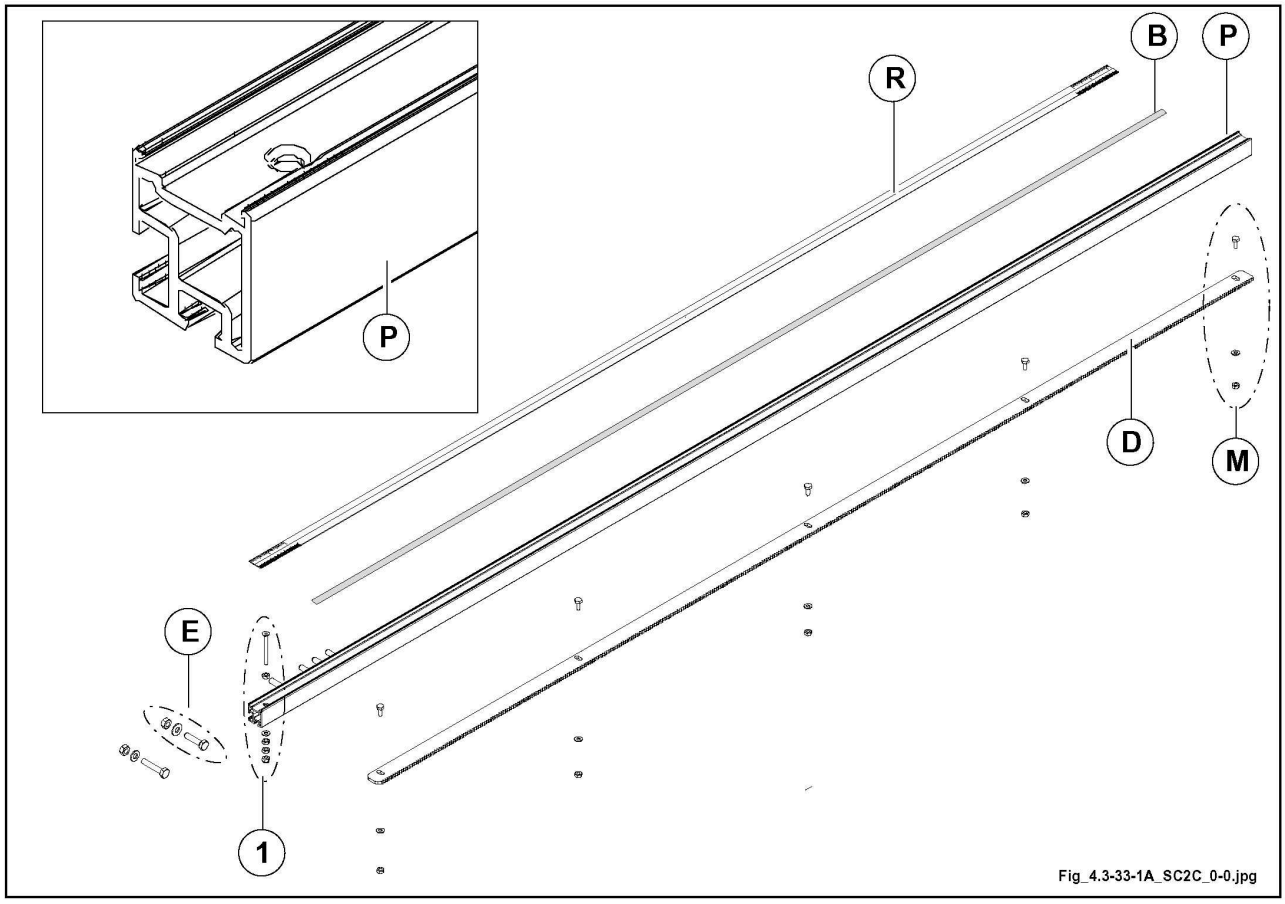


Fig_4.3-31_SC2_CLASSIC.jpg

5.3.10 Installation of the saw guide unit with micrometric adjustment

Before assembling the saw guide unit with micrometric adjustment, you must assemble the sub-unit consisting of tube section (P) and the parts supplied with the machine and illustrated below.

- screw, washer and nuts to secure the plate (R);
- P -aluminium profile to support and fix to the worktables the reading device, plate (R), and the micrometric rack adjustment (D);
- R -cutting width measurement (metre) plate;
- B - adhesive magnetic band (supplied only if there is the digital display (OPT));
- D -rack for the micrometric adjustment of the saw guide unit;
- E -screws, washers and nuts to secure the device to the rear tables of the machine;
- M -screws, washers and nuts to assemble the rack (D) to the aluminium profile (P).



To assemble proceed as follows:

STEP - 1 -

- Insert the screws (M) in the groove of the profile (P).
- Install the rack (D) and, after having aligned it to the end (Ye) of the profile (P), block it with the washers and nuts (m1) .

STEP - 2 -

- Insert the screw (1) in the hole (F) of the profile (P) and screw it fully on the nut (d1).
- Then, on the projecting stem under the profile (P) of the screw (1), insert the washer and screw the nut and lock nut (d2).
- Finally screw in, at the end of the screw stem (1), the self-locking nut (d3) (it will be used as wrench grip to facilitate the loosening and tightening of the nuts (d2). Operation necessary to release the plate (R) and block it again after having positioned it on the correct cutting width).

STEP - 3 -

- Insert the plate (R) in the seating on the profile (P).
- Align the "0", measurement metre origin, with the end (Yi) of the profile (P).
- Turn (counterclockwise) the self-locking nut (d3) until the head of the screw (1) blocks the sliding of the plate (R). Tighten the nuts (d2) so that the washer is against the lower face of the profile (P).

NOTE

if the length of the plate (R) exceeds the length of the profile (P), use suitable scissors to cut the excess part at the end (Ye) of the profile.

NOTE

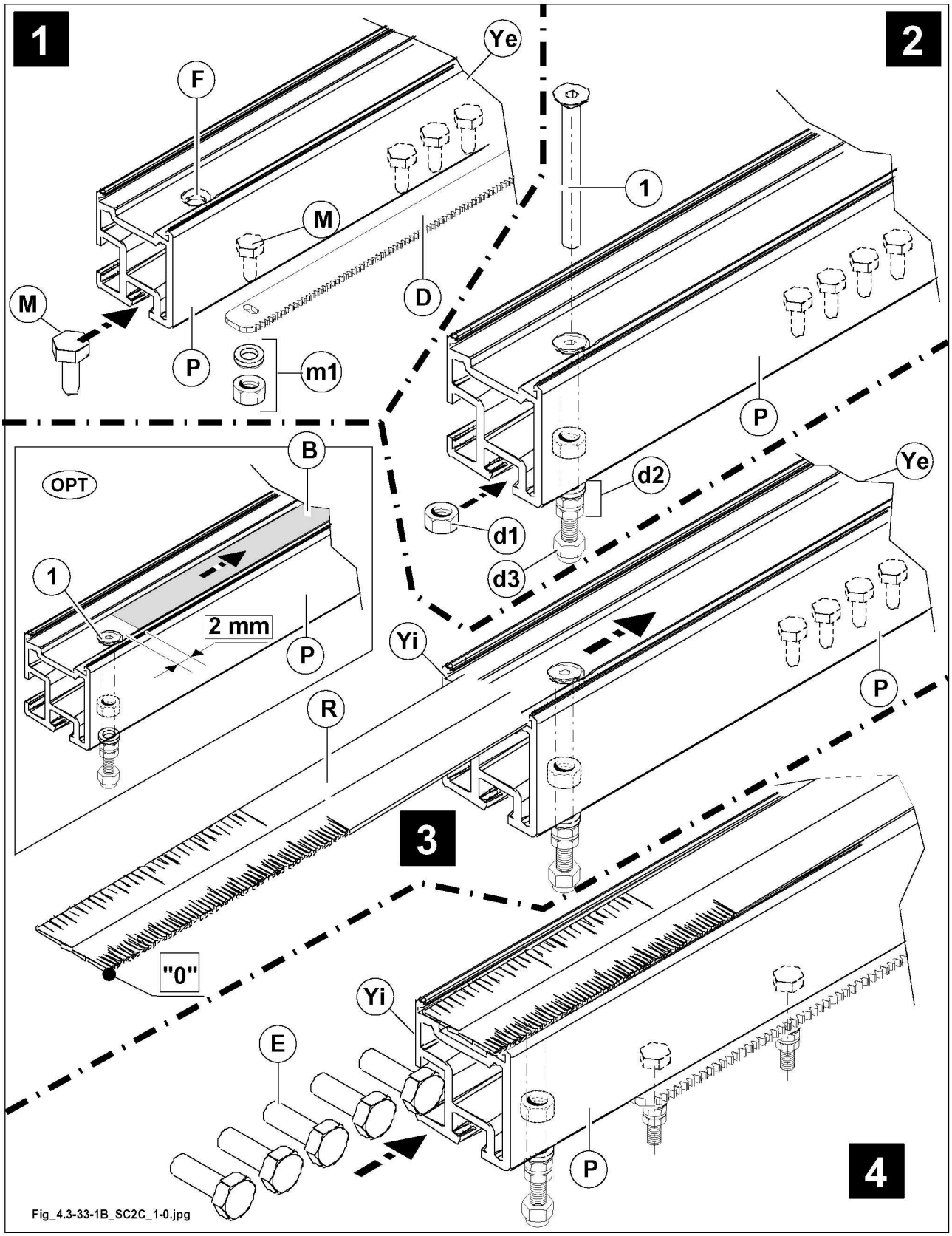
if there is the digital display OPT the adhesive magnetic band (B) must be inserted as indicated below:

- use a clean and dry cloth to remove any residue of dust and dirt from the surface of the profile (P), magnetic band application seating (B).
- Position one end of the magnetic band (B) at about 2 mm from the head of the screw (1) and, after having removed the protective film of the adhesive, apply the band (B) along the whole length of the profile (P).
- Use adequate scissors to cut the excess part at the end (Ye) of the profile.

After having applied the magnetic band (B) install the plate (R) by following the indications provided in STEP - 3 - .

STEP - 4 -

- Insert the screws (E), in the seating of the profile (P), from the end (Yi).


1
2
3
4
F
Ye
M
M
P
m1
D
1
P
B
OPT
1
2 mm
P
d2
d1
d3
Ye
Yi
R
P
"0"
Yi
E
P
Fig_4.3-33-1B_SC2C_1-0.jpg

NOTE

once the unit (P) has been assembled, as described above, you can assemble it on the machine with the indications below.

1. Position the tube (P) with the millimetre rule in line with the worktables and secure it in the holes (S) with the screws (E) with relative washers and nuts; (loosening the screws (E) with relative washers and nuts, the tube (P) with millimetre rule can move in parallel with the worktables).

SPECIALISED PERSONNEL

the washers (W) have a different external diameter. The ones with a smaller diameter (Wi) must be used on the screws (Eg) that secure the tubular section (P) on the cat iron table.

2. Check with a test cut that the width of the panel matches the reading on the plate (R); if necessary, adjust the correct positioning by loosening the fixing screw (T) and repositioning the plate (R).

Insert the guide unit as indicated in the figure and tighten the screw (A).

In the version with display OPT the magnetic strip (B) must be adjusted so it is at a maximum distance of 0.8 mm from the sensor (C) along its entire length; then adjust the correct height position of the tube (with rack) (P).

After assembly, set the display as indicated in the adjustments in chap. "Readers or displays" .

Adjusting the rack

- Adjust the rack (D) where there are the screws (M):
  loosen the screws (M);
- lower the knob (I), push the rack against the pin (L) and tighten the screws (M).

(Use the micrometric adjustment knob (I) to move the guide and position it at the screws (M) that secure the rack (D) - profile (P). If the rack (D) and the pin(L) do not engage correctly, proceed with the adjustment as described above).

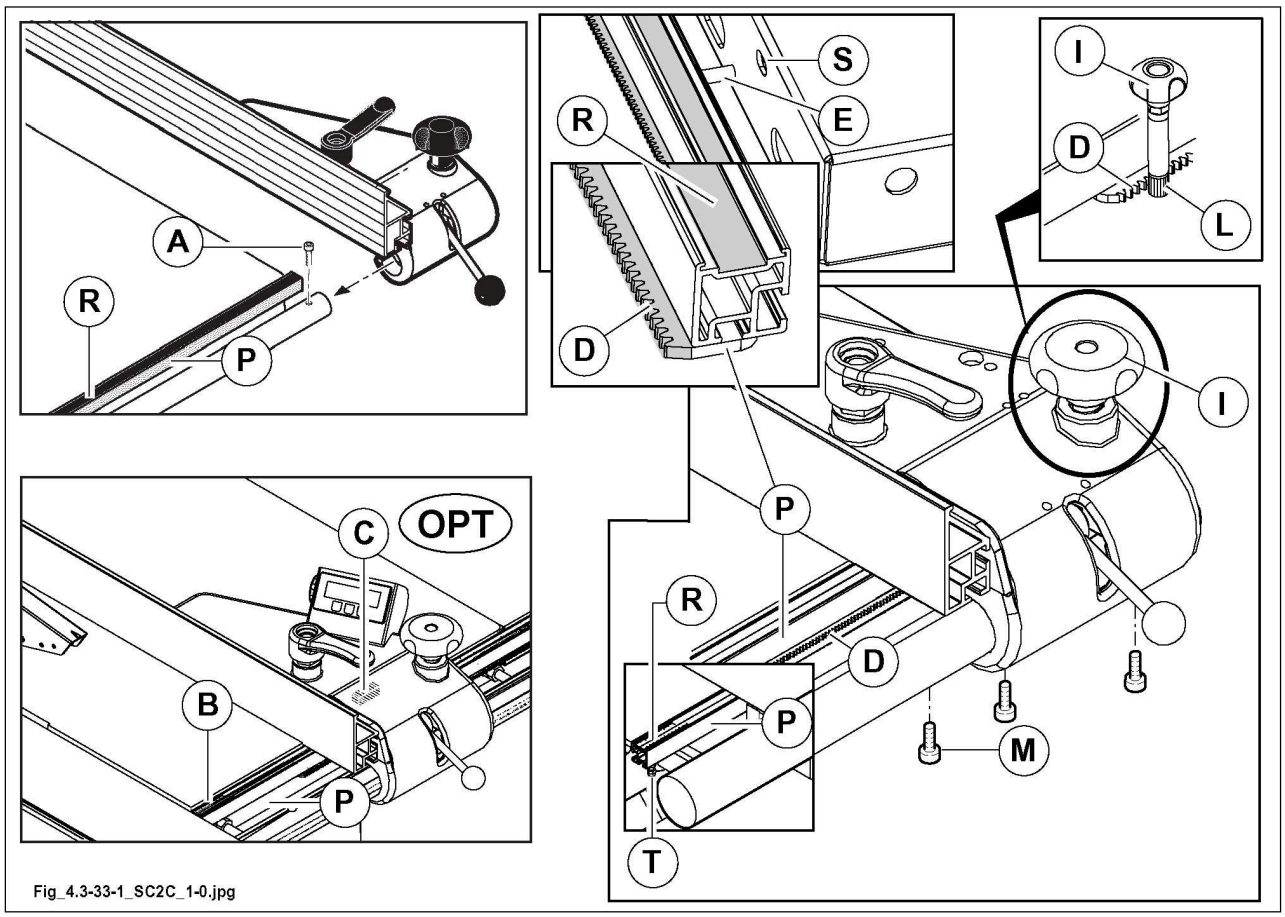


Fig_4.3-33-1_SC2C_1-0.jpg

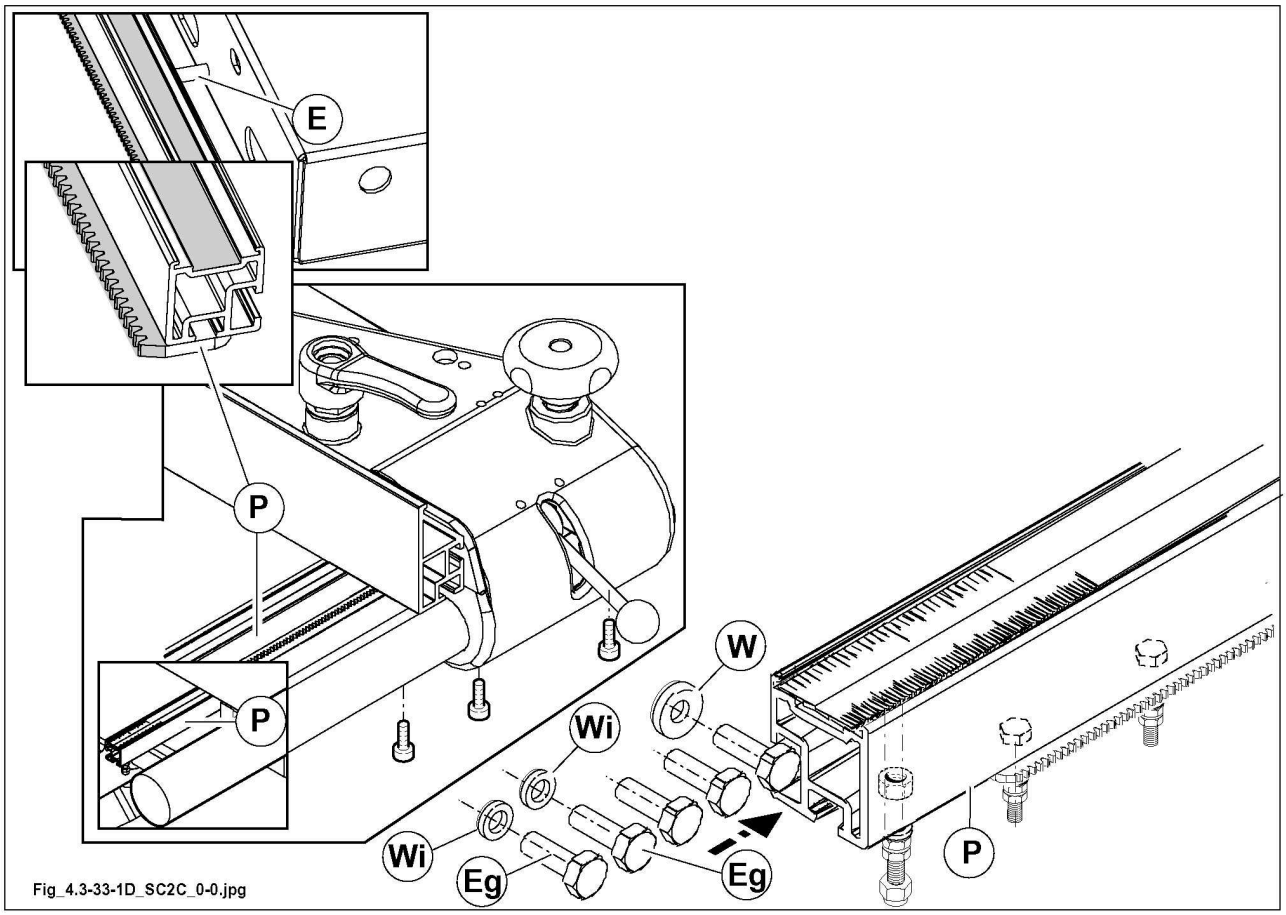


Fig_4.3-33-1D_SC2C_0-0.jpg

STEP - 5 -

Once the parallel guide unit has been installed, measure the PRESET quota (P) as shown below.

- Move the guide towards the saw blade at the limit switch position.
- Place the rule (R) with the vertical side (W) facing the piece (on the display press ENTER until the symbol appears ⌞ .
- Use a rule to measure the actual distance (P) between the blade (L) and the side (W) of the rule (R) facing the piece.

The value (P) measured will be the PRESET datum to enter in the display (V) by following the indications below:

- press ENTER and abs/incr simultaneously for 3 seconds.
- **rES** appears on the display.
- Press ENTER until the message **rEF** appears.
- Press abs/incr and the PRESET value (P) measured.
- Press SET to shift one decade to the right.
- Press to confirm ENTER.
- To exit press ENTER repeatedly.

At this point press ENTER and SET at the same time.

- The previously entered PRESET value appears on the display.

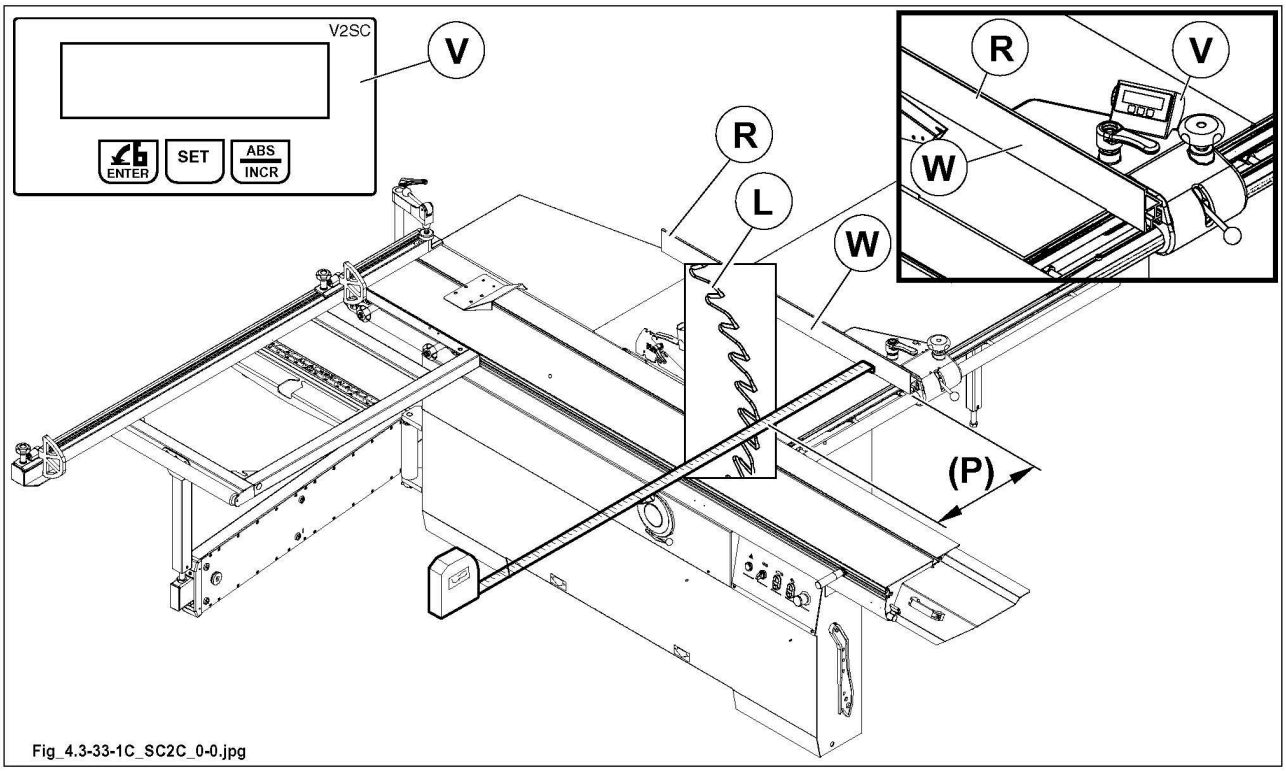
NOTE

move the guide away from the blade and check how the quota that appears on the display changes.

if the quota INCREASES the setting is correct.

If the quota DECREASES the count direction of the sensor must be changed from "**dir dn**" to "**dir UP**" **or vice versa** as indicated in point D) of Par. " For skilled operators authorized by SCM" .

After assembly, set the display as indicated in the adjustments in chap. "V2SC" .


V2SC
V
ENTER
SET
ABS
INCR
R
L
W
(P)
R
V
W
Fig_4.3-33-1C_SC2C_0-0.jpg

5.3.11 Scoring unit assembly OPT

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S.

To fit the scoring unit, proceed as follows:

1. Disassemble the saw blade as indicated in Paragraph" Fitting the saw blade".
2. Remove the front cover (Z).
3. Completely lower the saw assembly and tilt it to 45° (see chapter"Using and adjusting on the blade unit").
4. Mount the unit (A) on the saw support.
5. Tighten the nut (D) to lock the scoring unit (A).
6. Disassemble the part (E) and the plate (S).
7. Assemble the lifting knob (1) and the translation knob (2).
8. Mount the spring (N) on the scoring unit.
9. Fit the pulley (P) on the saw arm.
10. Install the pulley (Q) in the saw shaft.
11. Fit the pulley-bracket assembly (belt tensioner) (G) on the saw arm, fixing it with the screw (V) but without locking it.

    Check that the pulleys (P) and (R) are perfectly aligned with the pulley (Q) and if necessary insert spacers.
12. Fit the screw (M) to engage the tensioning spring (X) of the scoring belt.
13. Assemble the belt (H) respecting the path and the steps indicated in the figure.
14. Fit the saw blade as indicated in Paragraph " Fitting the saw blade" and the scoring blade as indicated in the next Paragraph.
15. Reassemble the front cover (Z).
16. Fit the new plate (W) and reposition the part (E).

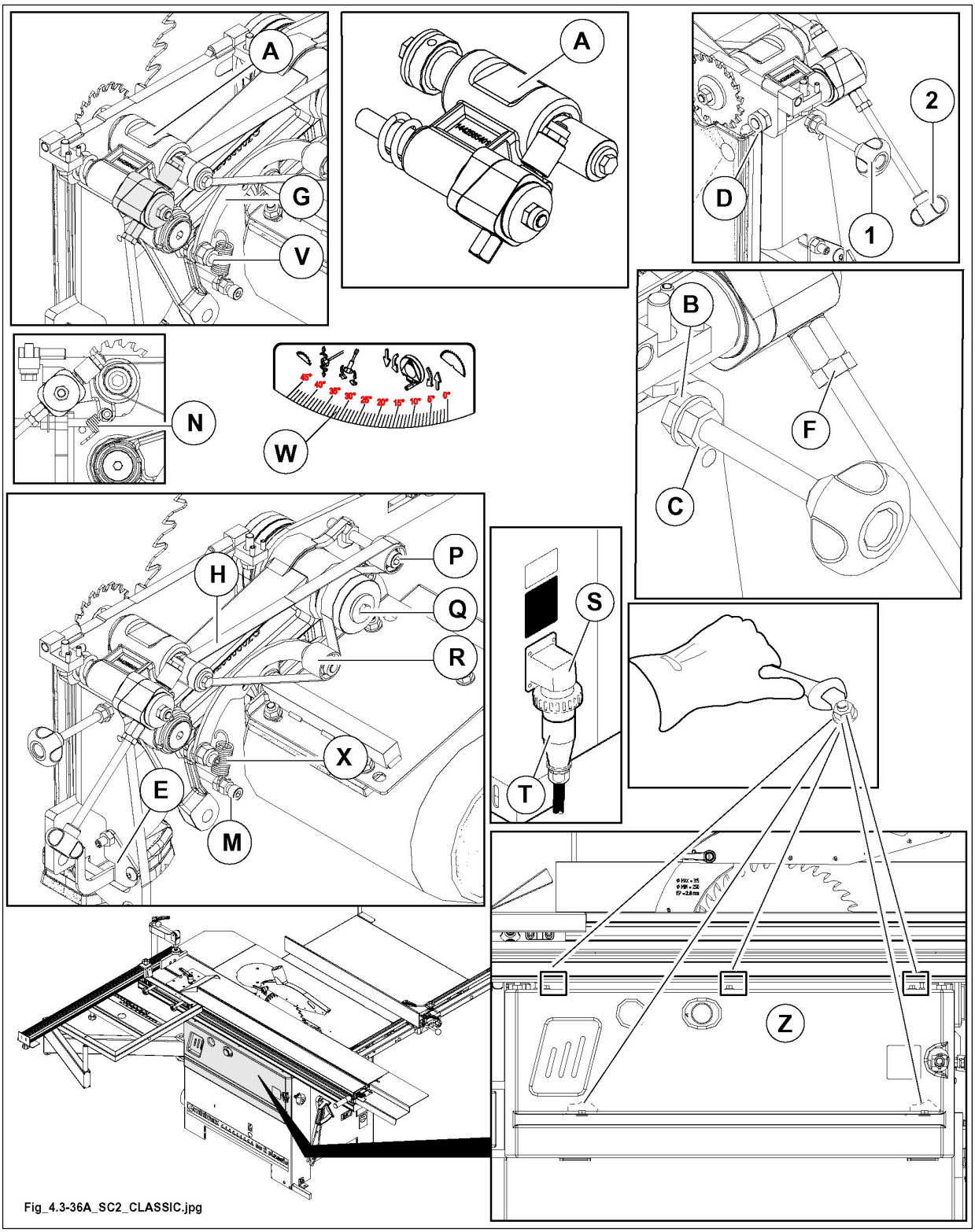
NOTE

fit the lifting knob (1) and adjust it using the nuts (B, C) as indicated below:

- screw the knob (1), lift the scoring blade until it protrudes by 3 mm on the worktable.
- Bring the nut (B) against the saw support and block it in place with the washer and nut (C).
- Assemble the translation knob (2) and block it using the nut (F).

NOTE

The correct engraver belt tension is assured by the spring (X) and it does not require any adjustment.



5.3.12 Fitting the scorer

DANGER

Use gloves for handling the scorer blade.

Before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S.

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

To fit or replace the scorer blade, proceed as follows:

1. position the squaring frame (A) as shown in the figure and move the sliding table (H) fully to the right.
2. Open the guard (N).
3. Insert pin (B) in the blade-holding flange hole.

   NOTE

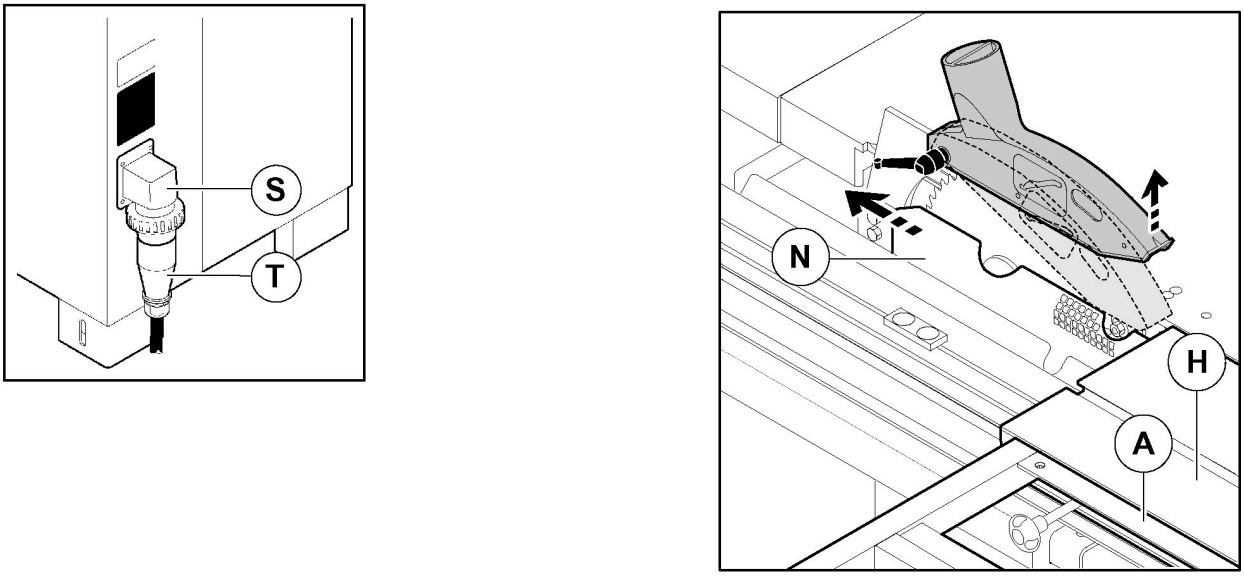
   a safety limit switch guarantees that motor cannot be started when the guard (N) is open.

4. Loosen the lock nut (C) using a 13 mm hex wrench and remove flange (D).
5. Assemble, by following this sequence, these parts: blade (E) with the teeth opposed to the ones of the saw, flange (D) and nut (C).
6. Tighten the nut using the 13 mm wrench and the pin (B).

DANGER

For safety reasons it is obligatory to close the guard (N), otherwise:

- **The machine does not start.**
- **The guard interferes with the sliding table motion.**



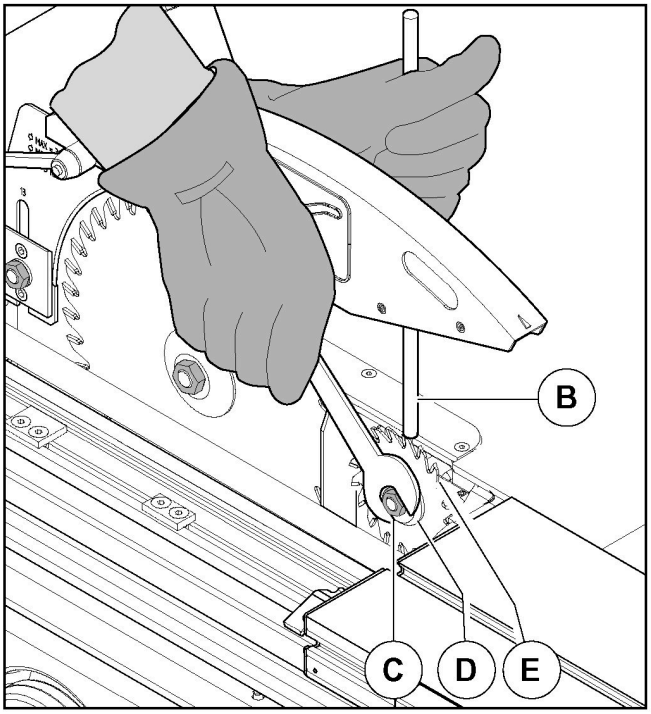


Fig_4.3-45_SC2-CLASSIC.jpg

5.3.13 Fitting the suspended guard

OPT

Guard to be used for not- through cuts (blind cuts) beside the standard workings.

NOTE

not available on the "COMPACT" version.

DANGER

2 persons are required for fitting the guard or just one person with the help of a hoist.

- Fix the arm (A) to the work table (L) with the screws (E).
- Install the arm (F) to the arm (A) with the screw (G).
- Block the closure of the joint with the screw (H).
- Install the blades guard (M) on the arm (F) with the screws (P).
- Raise and lower the guard with the handle (R) using the lever (S).

DANGER

the stop (Q) must be inserted into the LOWER hole (C).

DANGER

the guard has been adjusted at factory so that with the saw blade of max diemter the lfiting of the bottom guard edge does not exceed 5 mm above the highest tooth of the saw blade, never tamper it.

- The device is supplied with two types of guard (U) and (T), one for cuts with the 90° saw and one for cuts with tilting saw.

DANGER

When working with the 90° saw always use the guard (U).

When using the tilting saw install the guard (T).

NOTE

Lift or lower the hood with the handle (R) and the lever (S) based on the thickness of the wood.

DANGER

Never remove the guard.

Before starting to work, ensure that the guard is resting against the workpiece and, at the end of the operations, lower it until it comes into contact with the table.

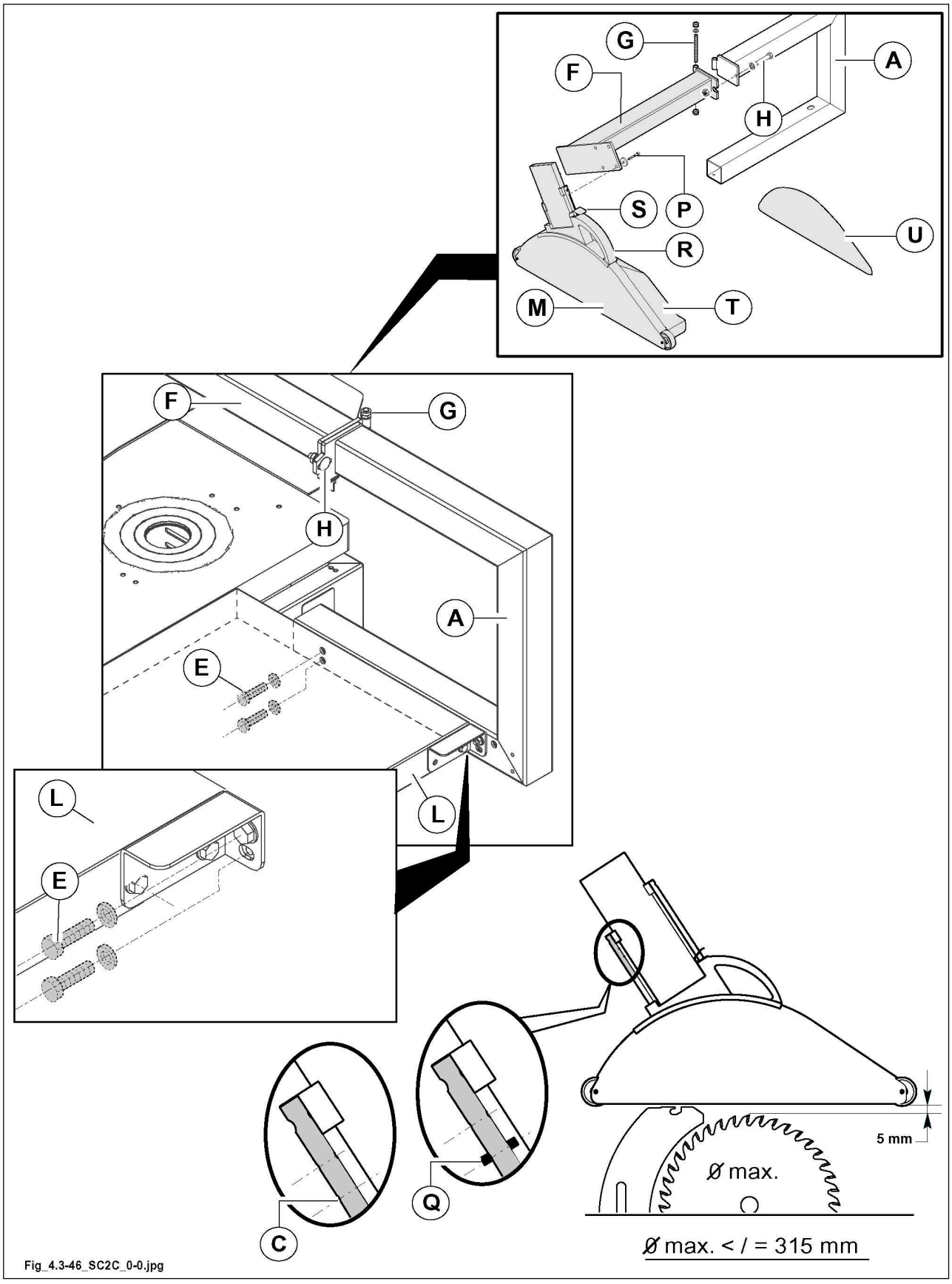


Fig_4.3-46_SC2C_0-0.jpg

5.4 Electrical installation

NOTICE

The installation operations must be performed by SCM specialised technical personnel or personnel authorised by the manufacturer.

5.4.1 Requisites for the electricity supply system

DANGER

the electric connection and subsequent controls must be carried out by a specialised electrician, referring to the wiring diagram supplied with the machine.

DANGER

OPT

Switches with electronic brake cannot be connected to:

- **curent generators, emergency generators, gensets**
- **electronic mains transformers**
- **static inverters**
- **mains voltages with non-conforming sinusoidal shape.**

INTRODUCTION

SPECIALISED PERSONNEL

For proper connection it is always mandatory to refer, in addition to the following, also to the wiring diagram and the plate on the electric panel of the individual machine.

The electrical panels of the machines are suitable to be powered to a single/three-phase network with/without neutral as indicated in the machine/plate electric panel/LAYOUT.

If the power supply voltage at the final client is different to the indications on the machine plate/electrical panel plate/ LAYOUT, see the "machine electrical power supply specifications" section.

The input and connection of the power supply line inside the electrical panel must be carried out in compliance with the following instructions:

- attesting the cables to the input terminals of the main disconnection device of the electrical panel or, where present, to the connection terminal board located upstream of the switch (as also indicated in the electrical diagram)
- so as not to compromise the degree of protection IP54 of the electrical panel declared by the manufacturer by NOT drilling holes in the electrical panel carpentry;
- respecting the radii of curvature as indicated by the cable manufacturer;
- complying with the laying limits as indicated by the cable manufacturer;
- using the tightening torque indicated on the wiring diagram of the machine;
- without mechanically damaging the switch and the cable itself.

SPECIFICATIONS OF THE ELECTRICAL SUPPLY OF THE MACHINE

- Distribution systems allowed: type TN-S / TN-C.
- Phases number (~) and neutral conductor: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Nominal voltage (Un) and tolerance when different from +/- 6%: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Voltage interruption: Power supply voltage interrupted or reset for a time not exceeding 3 ms, at any moment of the power cycle with more than 1 s between two successive interruptions.
- Voltage gaps: not exceeding 20 % of the peak supply voltage for more than one cycle with more than one second between two successive gaps.
- Frequency (f) and tolerance when different from +/- 1%: see the indications on the machine plate/electrical panel plate/LAYOUT.
- Nominal machine current (In): see the indications on the machine plate/electrical panel plate/LAYOUT.
- Short circuit seal (Icc): see the indications on the machine plate/electrical panel plate/LAYOUT.
- Minimum neutral conductor section: see the indications on the electrical diagram/LAYOUT.
- Minimum earthing protection conductor section: see the indications on the wiring diagram/LAYOUT.

NOTE

The LAYOUT can be provided as a separate document, attached to the machine instruction manual, or integrated with it.

NOTICE

When the distribution system and/or the supply voltage at the customer's premises are different from those provided for the machine, the following prescriptions apply:

- Distribution system type TN-C / TN-S in the presence of voltages other than those provided for the machine: the use of an autotransformer or transformer is required (not provided for in the standard supply unless otherwise agreed).
- IT type distribution system: it is mandatory to use a three-phase transformer regardless of the supply voltage (not provided for in the standard supply unless otherwise agreed).
- TT type distribution system: in order to avoid disturbances and malfunctions it is mandatory to use a three-phase transformer regardless of the supply voltage (not provided for in the standard supply unless otherwise agreed).

The supply of a transformer/auto-transformer is ALWAYS understood as:

1. Component not included in the standard supply and an integral part of the distribution system of the installation site.
2. Component external to the machine and not an integral part of it.
3. Component to be connected and protected by the client.

MACHINE PROTECTION AGAINST INDIRECT CONTACTS:

The machine is equipped with a grounded earth circuit to the PE terminal.

It is up to the customer to complete the protection against indirect contact.

To this end, the customer must:

1. Use a qualified professional for the project and a qualified installer (both with the necessary requirements according to local legislation).
2. If there is a TN-S distribution system, install a differential current device (RCD) on the supply line with the following minimum specifications:
   - adjustable both in current and intervention time.
   - suitable for recognizing continuous or high frequency fault differential currents.
   - positioned outside the machine electrical panel
3. If there is a TN-C distribution system, install a differential current device (RCD) with the characteristics indicated in point 2, after separating THE PEN conductor into the respective PE and N conductors upstream of the RCD itself.

DANGER

The installation of inadequate differential protection devices may result in unwanted untimely interventions during the use of the machine.

Any damage of any kind resulting from untimely interventions cannot be attributed to the Manufacturer of the Machine.

NOTE

Remember that in environments with greater fire risks, as expressed in IEC60364-4-42, to ensure the protection against fires caused by currents dispersed to the ground, the maximum value of the differential triggering current must be 300mA.

NOTICE

The protection against such risks is the responsibility of the Customer who, for this purpose, will have to use specialized personnel (electrician, installation personnel of electrical systems).

The CUSTOMER must COMPLETE the measures to guarantee the protection against electrocution risks due to indirect contacts, even if the machine includes an internal grounding system as far as the PE terminal.

MACHINE PROTECTION AGAINST OVERCURRENTS

All branch circuits of the machine are protected against overcurrents (overload and short circuit).

It is up to the customer to ensure protection against short circuit overcurrents of the Feeder

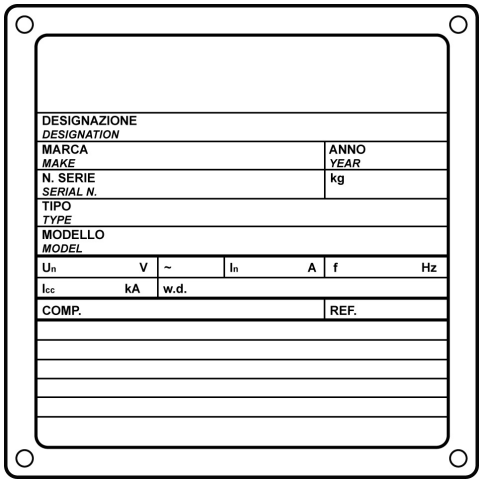
(part of the circuit between the general disconnecting device of the machine and the bypass circuits).

To this end, the customer must:

1. Use a qualified professional for the project and a qualified installer. (Both with the necessary requirements according to local laws).
2. Protect the Feeder by installing a three-wire fuse supply line with the following minimum specifications:

- Quick type.
- Compatible with the Icc value required for the machine.
- Positioned outside the machine electrical panel
- A size not exceeding that shown in the table.

COORDINATION OF POWER LINE PROTECTIONS	
Nominal machine current (In) (A)	**Fuse type Quick Maximum size allowed (A)**
0 → 10	12
11 → 14	16
15 → 18	20
19 → 22	25
23 → 28	32
29 → 36	40
37 → 46	50
47 → 54	63
55 → 76	80
77 → 92	100
93 → 110	125
111 → 145	160
146 → 190	200
191 → 230	250
231 → 300	315
301 → 380	400
381 → 500	500



A

Voltage (Volt), current (I=ampere) are indicated on the machine identification plate.
When supplying with a transformer, see the transformer plate data.

SPECIALISED PERSONNEL

If the power cables extend from above, do not pass them near the monitor or PC.
Moreover do not use the electrical cabinet walls as a support for fixing the power cables.

MACHINE OVERVOLTAGE PROTECTION

The machine is NOT protected against overvoltages.

The electrical system may be subject to overvoltages caused by manoeuvres or faults on the electrical system or of atmospheric origin (phenomena of direct or indirect electrocution of the structure in which it is located or of the electrical line from which the machine is powered).

In the absence of specific requests or requirements from the customer, the Manufacturer of the machine cannot be held liable for damage to the electrical equipment of the machine caused by overvoltages of any kind.

NOTE

The auto-transformers provided by the manufacturer are equipped with "neutral" line.

5.4.2 Electrical power and earth connection

DANGER

Before making the connection, disconnect the main line switch. Always check that the electrical cable used for the machine connection is not live.

Connect the machine to the electrical system as follows:

- arrange the power cord near the socket (A) that is supplied;
- connect the 3 phases to terminals L1-L2-L3 ;
- connect the yellow-green earth cable, to terminal (PE / ⏚);
- connect the socket (A) to the plug (B).

5.4.3 Checking the connection is correct

DANGER

CAREFUL WITH THE ELECTRICAL CONNECTION Incorrect rotation of the tool causes danger to the operator and damage to the product. Start the machine for a fraction of a second and check that the saw blade (S) turns clockwise (and the scoring blade (A), if present, counterclockwise); if the rotation is not correct, cut off the power supply immediately and invert two of the three phases on the terminals (L1-L2-L3).

CAUTION

If the machine is connected with a mobile power supply cable, use a rubber flexible cable marked with H07RN-F or A07RN-F. The relative plug-in socket must comply with the standard DIN 49463 and the international standards IEC 309-1 and IEC 309-2.

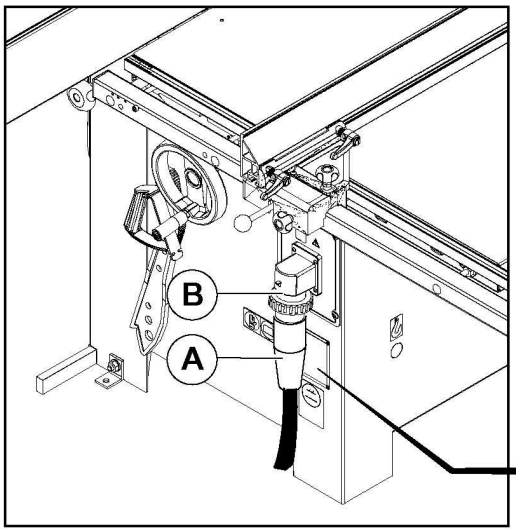
DANGER

(OPT)

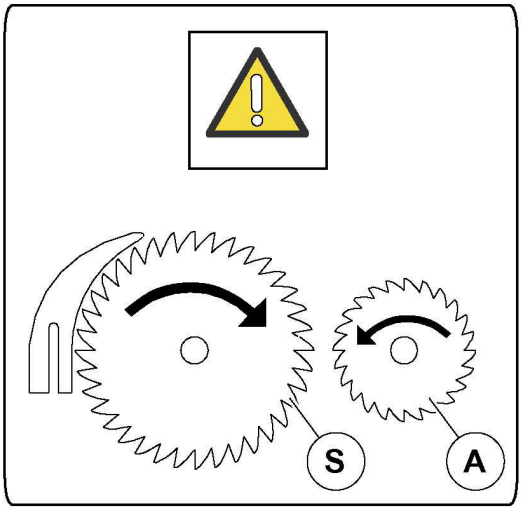
in the switches with electronic brake, even with the motor stopped, the motor is not galvanically disconnected from the mains. The switch supplies the motor with voltage even after switching off; in case of long machining pauses or machine stops remove the power supply cable socket.

NOTE

the documentation with wiring diagram and certificates is inside the accessories case.







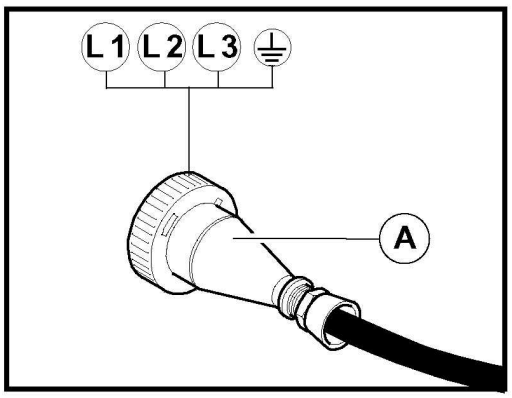


Fig_4.4_SC_2C_CE_1-0.jpg

5.5 Connection to the suction system

DANGER

The machine must be connected to the suction system in order to function correctly and safeguard the operator. Always work with the suction system in operation.

CAUTION

The extraction system must comply with UNI EN 12779:2016 or EN 16770:2018.

NOTE

Always start the suction system and the operator assembly motor at the same time.

DANGER

When working with materials other than wood, take the appropriate precautions to prevent the chips from damaging the suction system.

NOTE

Connect the exhaust pipes to the suction system with hoses of proper diameter.

we recommend that the suction sleeve is arranged out of the suction hood in order to avoid clogging caused by chips.

The suction pipe fitting should not hinder the operator during the woodworking process.

NOTE

protection suspended on the blades with fitting for aspiration (B) Ø 80 mm, it is not available on the "COMPACT" version.

Connect the hose to the suction port (**A**) diameter 120 mm, (**C**) diameter 60 mm / (**B**) OPT diameter 80 mm.
Clamp it with the proper metallic clip to ensure the contact between suction hood and hose.

Suction air flow

(**A + C**)	The suction system shall ensure a flow equal to 1018 m³/h at a flow speed at least of 20 m/s - chips dry (1425 m³/h --> 28 m/s - chips wet).
(**A + B**) OPT	The suction system shall ensure a flow equal to 1176 m³/h at a flow speed at least of 20 m/s - chips dry (1647 m³/h --> 28 m/s - chips wet).

These values must be checked before starting work.

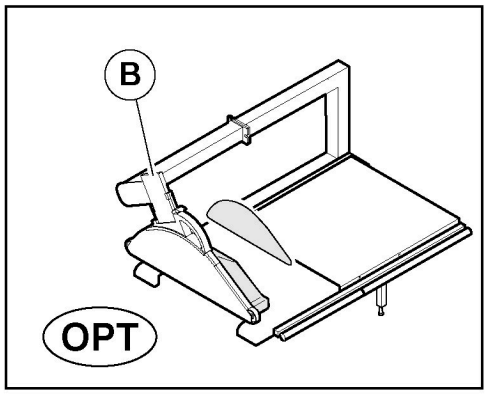
If other machines are connected to the central system, perform a test when all the suction systems are running.

Good suction operation reduces the risk of inhalation of dust.

The operator must be informed about the risks caused by exposure to dust (see Par. "Dust emission") and the factors that influence its exposure.

Certain factors that reduce the emission of dust in the work environment are:

- regular maintenance of the tools, the machine and the extractor system;
- correct speed selection (where adjustment is possible);
- type of material machined
- importance of local aspiration on each operating unit (dust collection at source)
- correct adjustment of earmuffs and deflectors
- correct use of personal protection equipment (PPE).



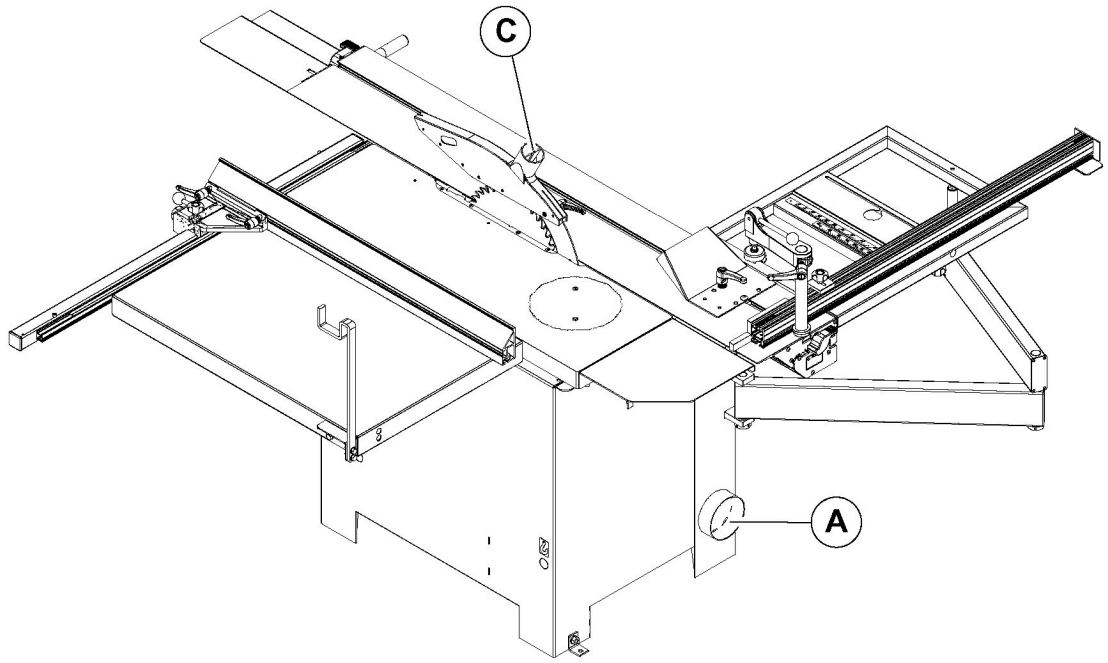


Fig_4.5_SC2_CLASSIC.jpg

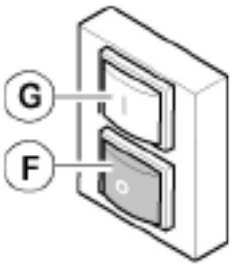
NOTE

Use flexible hoses in antistatic and self-extinguishing material to connect the machine to the extraction system. This prevents the formation of electrical discharges due to the accumulation of static electricity (which could compromise the correct functioning of the machine's electronic components) and hinder the propagation of flames in the event of a fire.

6 Commands

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6.2 Emergency buttons..... 95
6.3 general controls before machine starting..... 96
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6.1 Control board

Ref.	Image	Description / Function	Use and/or indication
1		Motor start/stop pushbutton. OPT	 = Press the pushbutton to start the motor.  = Press the pushbutton to stop the motor.
2		**Emergency pushbutton**. Cuts off the motor power supply with intervention of brakes, when present.	Pressed down: machine in emergency. Reset by turning the pushbutton in the direction of the arrow.
3		**Main switch with overload.** It connects and disconnects the supply voltage to the machining unit.	With the white button **G** pressed the unit is supplied. With the white button **F** pressed the unit stops.

6.2 Emergency buttons

In case of danger if you press an emergency button any function of the machine is locked.

Emergency buttons present on the machine are:

- on the front of the machine (1)

NOTE

Periodically press the emergency buttons to check whether they are efficient.

SPECIALISED PERSONNEL

do not use the emergencies to stop the machine when operating in normal conditions.

DANGER

Any anomalies found during the control of these devices, must be reported promptly to the manager , who will put the machine out of service and call the electrical, mechanical maintenance personnel or the SCM Support Service..

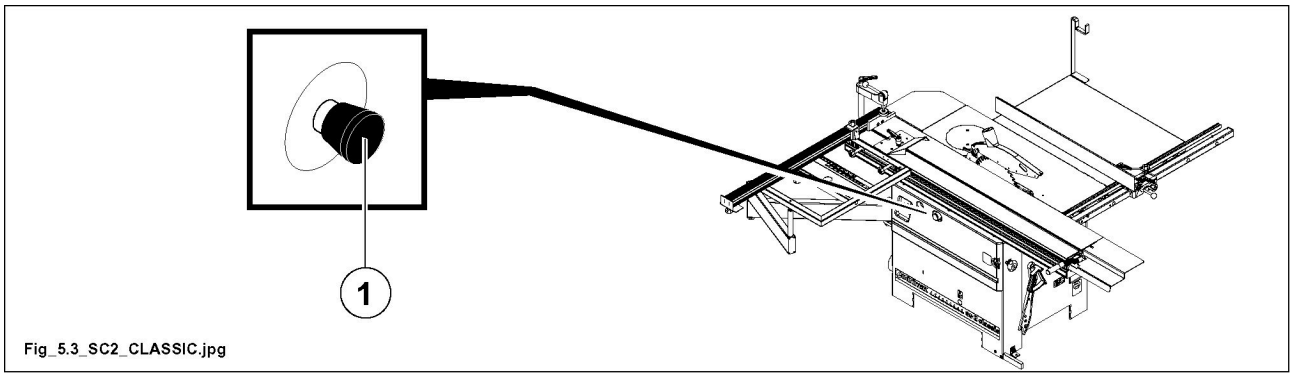


Fig_5.3_SC2_CLASSIC.jpg

6.3 general controls before machine starting

Check:

- the machine is connected to the extraction system
- the emergency stop buttons are off (reset the buttons where necessary)

DANGER

Any anomalies found during the control of these devices, must be reported promptly to the manager , who will put the machine out of service and call the electrical, mechanical maintenance personnel or the SCM Support Service..

NOTE

Make sure that the speed indicated is proper for the tool fitted to the saw spindle.

PROHIBITED

Do not modify or exclude any of the circuits or devices installed.

6.4 Machine start-up - shutdown

NOTE
Perform the checks set out in paragraph " general controls before machine starting".

Machine Start procedure

- Press the pushbutton (E) to start the saw motor

Machine Stop procedure

- To stop the saw blade press button (D);

DANGER

with single-phase motor

DO NOT restart the machine immediately after a stop command. Wait for at least 30 s. before starting the start procedure.

DANGER

avoid short switching cycles.

When starting and stopping the machine frequently, the buildup of heat produced by the electronic braking device can damage the motor and the actual device or generate alarms in its control logic.

DANGER

OPT

if there is no power supply the electronic brake does not work.

CAUTION! MOVING TOOLS. Do not insert hands in the danger area.

After the third unsuccessful attempt to brake (stopping time of more than 10 seconds) or after a braking attempt of more than 14 seconds, the electronic brake would block automatically thus avoiding the starting of the selected function. Disconnect the power supply to the machine to rest the function. If the problem remains, contact SCM.

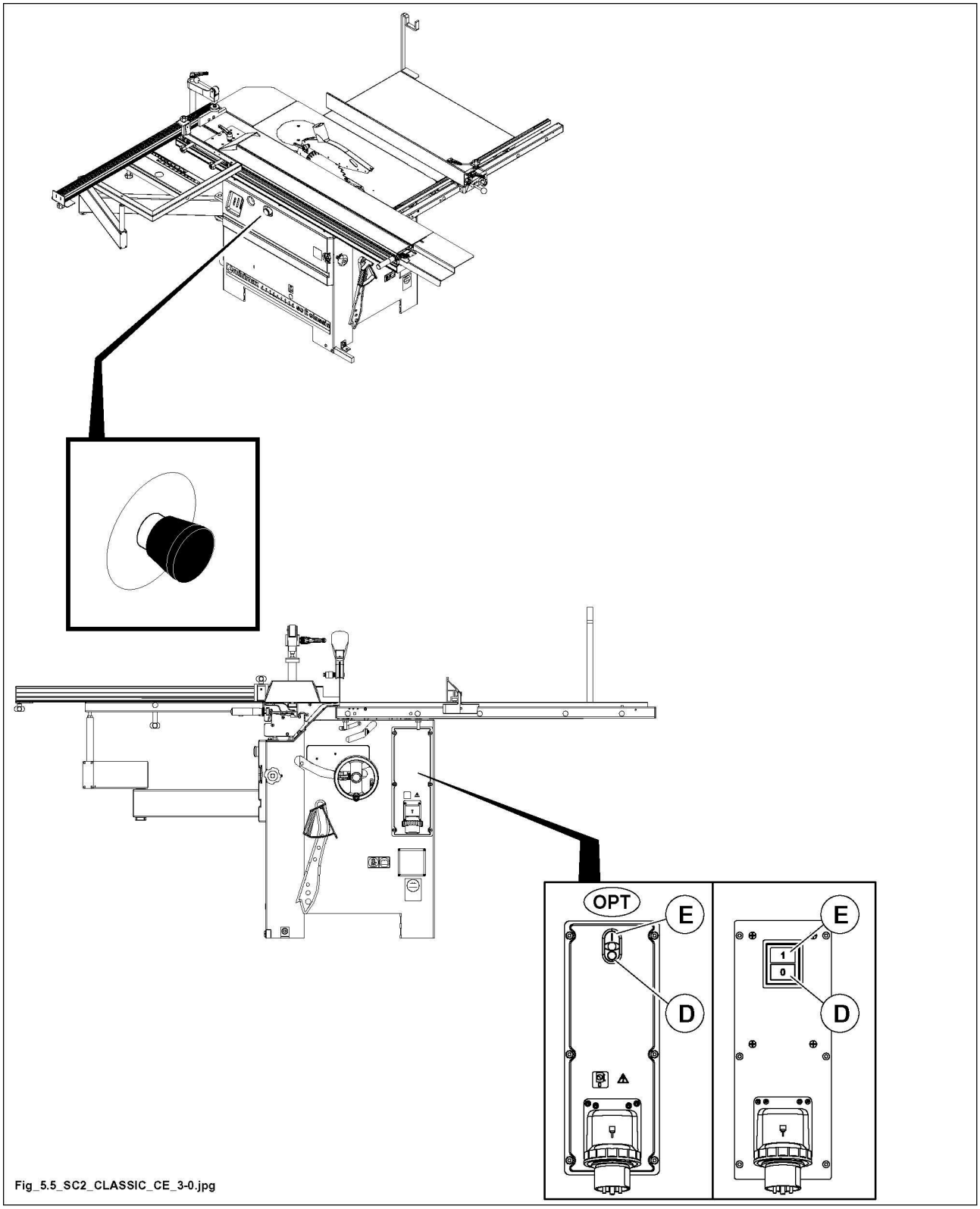


Fig_5.5_SC2_CLASSIC_CE_3-0.jpg

DANGER

in case of long machining pauses or machine stops remove the power supply cable socket.

7 Using and adjusting on the blade unit

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7.1 Riving knife adjusting

DANGER

do not work with bare hands; wear safety gloves.

NOTE

The machine is always equipped with 1 riving knife.

DANGER

Always fit the proper riving knife (supplied).

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug (S).

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

1. Move the saw unit fully upwards (with a tilting of 90°).
2. Position the squaring frame (A) as shown in the figure and move the sliding table (H) fully to the right.
3. Open the guard (N).
4. Adjust riving knife (F) height by loosening the nut (G).

DANGER

adjust the position of the riving knife so that its distance from the saw blade is between 3 and 8 mm.

The dividing knife is in the right position when the saw guard covers a part of the cutting edge of the saw blade.

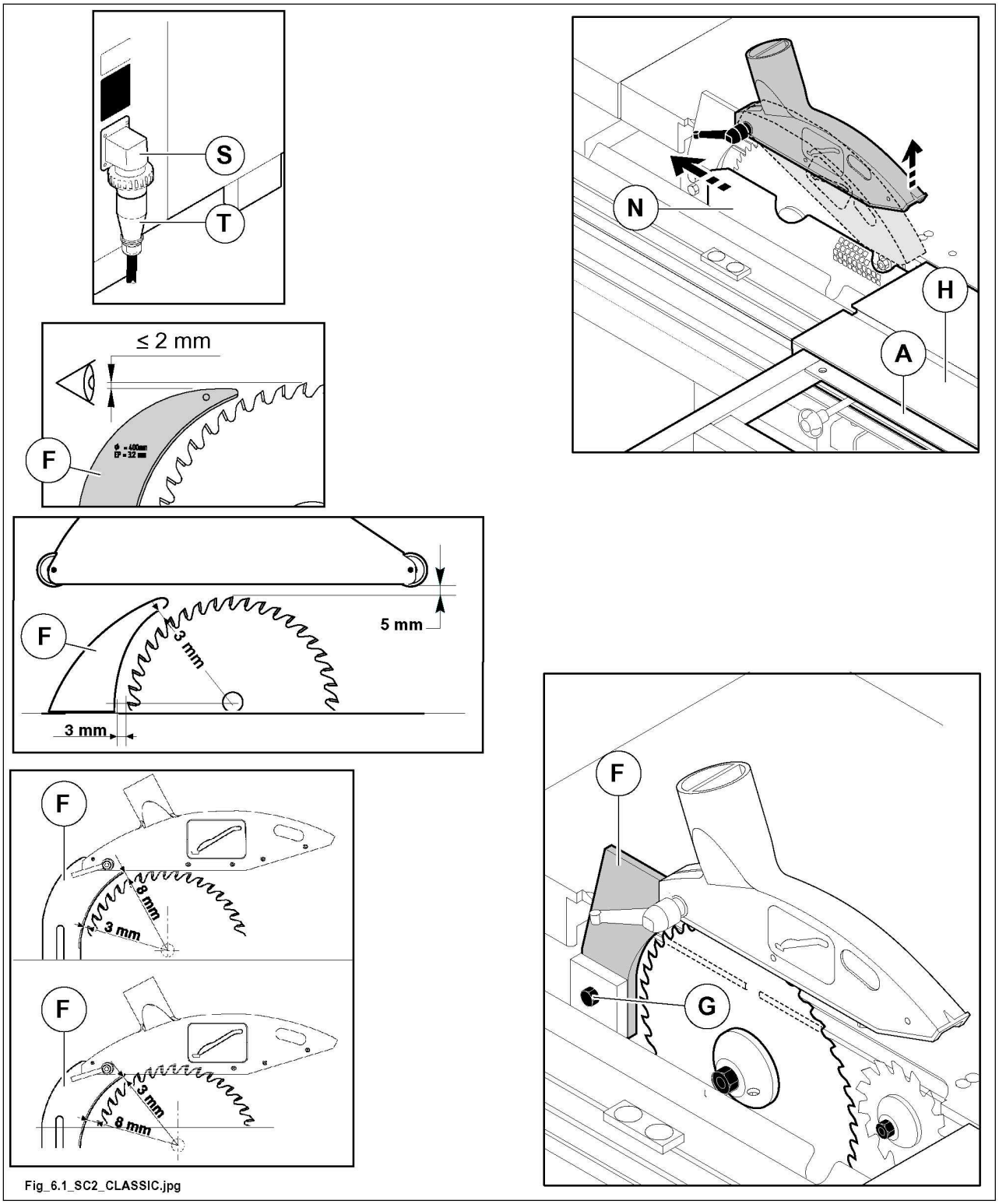


Fig_6.1_SC2_CLASSIC.jpg

7.2 Axis positioning

7.2.1 Height adjusting of the saw unit

- Fit the handwheel (E) on the pin (F) and turn it to adjust the height of the saw assembly.

NOTE
The saw blade height is right when it exceeds the piece thickness 1-1.5 cm

PROHIBITED
With protective hood fixed to the riving knife, it's strictly forbidden to carry out not-through cuts.

7.2.2 Saw blade tilting

SPECIALISED PERSONNEL
when inclining the saw blade from 90° to 45°, first lower the engraving blade to prevent interference with the wagon and saw table.

1. Insert the handwheel (E) in the pin (H).
2. Loosen the knob (G) and turn the handwheel to adjust the inclination of the saw-engraver assembly.
3. Read the saw blade inclination value on the index (L).
4. Tighten the knob (G) when the adjustment is complete.

With suspended guard OPT

NOTE
not available on the "COMPACT" version.

The device is supplied with two types of guard (F) and (C), one for cuts with the 90° saw and one for cuts with tilting saw.

SPECIALISED PERSONNEL
when working with the 90° saw, always use the guard (F).
When using the tilting saw install the guard (C).

To replace the rear side (F) with the side (C):

- Press the emergency button.
- Raise the guard (D) to the limit switch and remove the rear side (F).
- Insert the wide side (C, supplied).
- Adjust the blade tilting according to the angle you want to achieve.

NOTE
Lift or lower the hood with the handle (R) and the lever (S) based on the thickness of the wood.

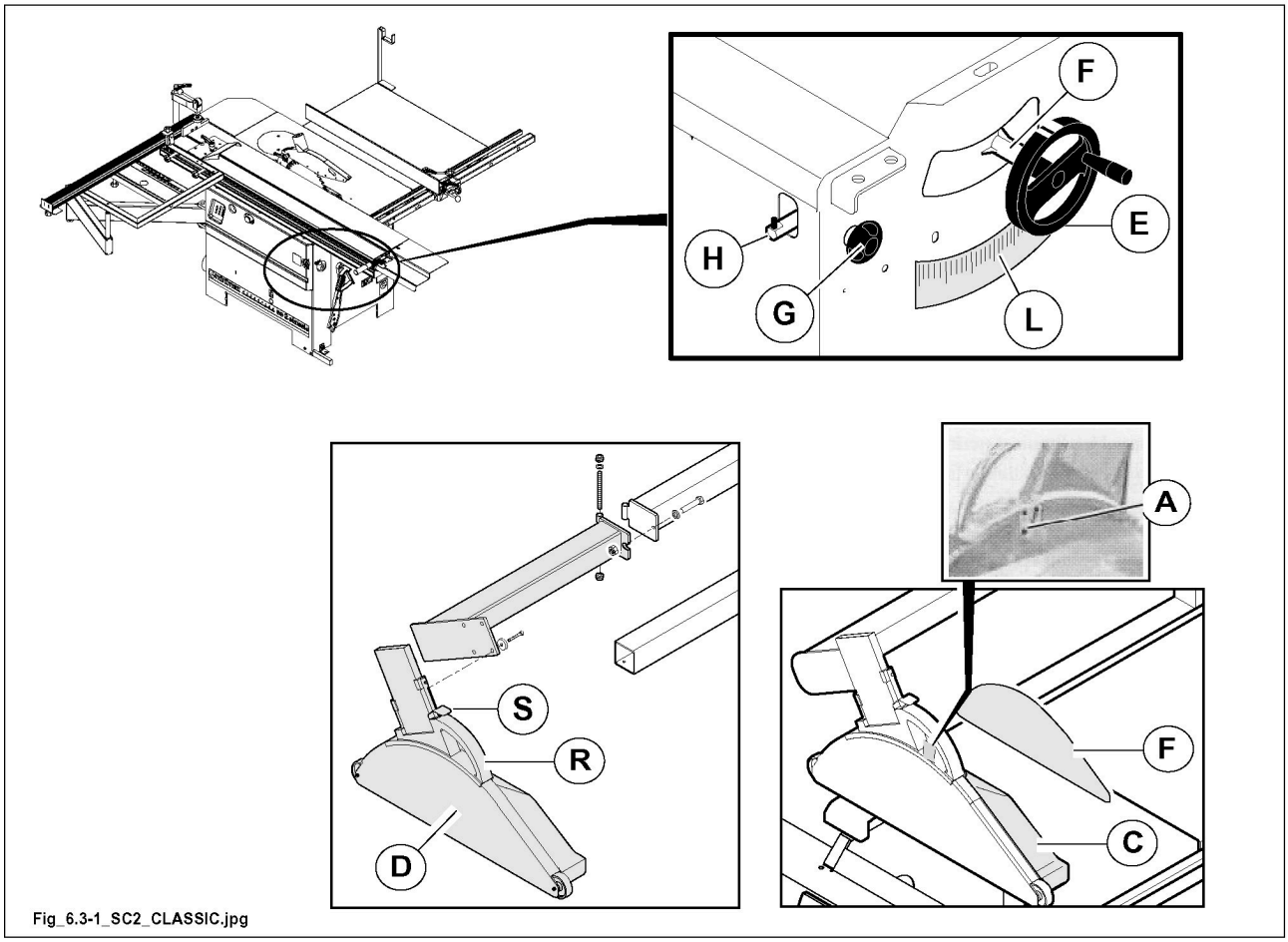


Fig_6.3-1_SC2_CLASSIC.jpg

7.3 SCORING SAW ADJUSTMENT

SPECIALISED PERSONNEL

for cutting ennobled wood, use of the engraver (A) is indispensable to prevent chipping.
The scoring saw must be positioned so that it produces a cut of 1-1.5 mm.
When it is not necessary to use the scorer, lower the scorer to the end of stroke under the table.

7.3.1 Vertical adjustment

Proceed as follows if it is necessary to adjust scorer positioning with respect to the saw:

- adjust the height of the scoring saw with the knob (L).

7.3.2 Aligning the scorer with the saw blade

You have to carry out some cutting tests.

- Adjust the alignment of the scoring unit with the saw by turning the knob (N).

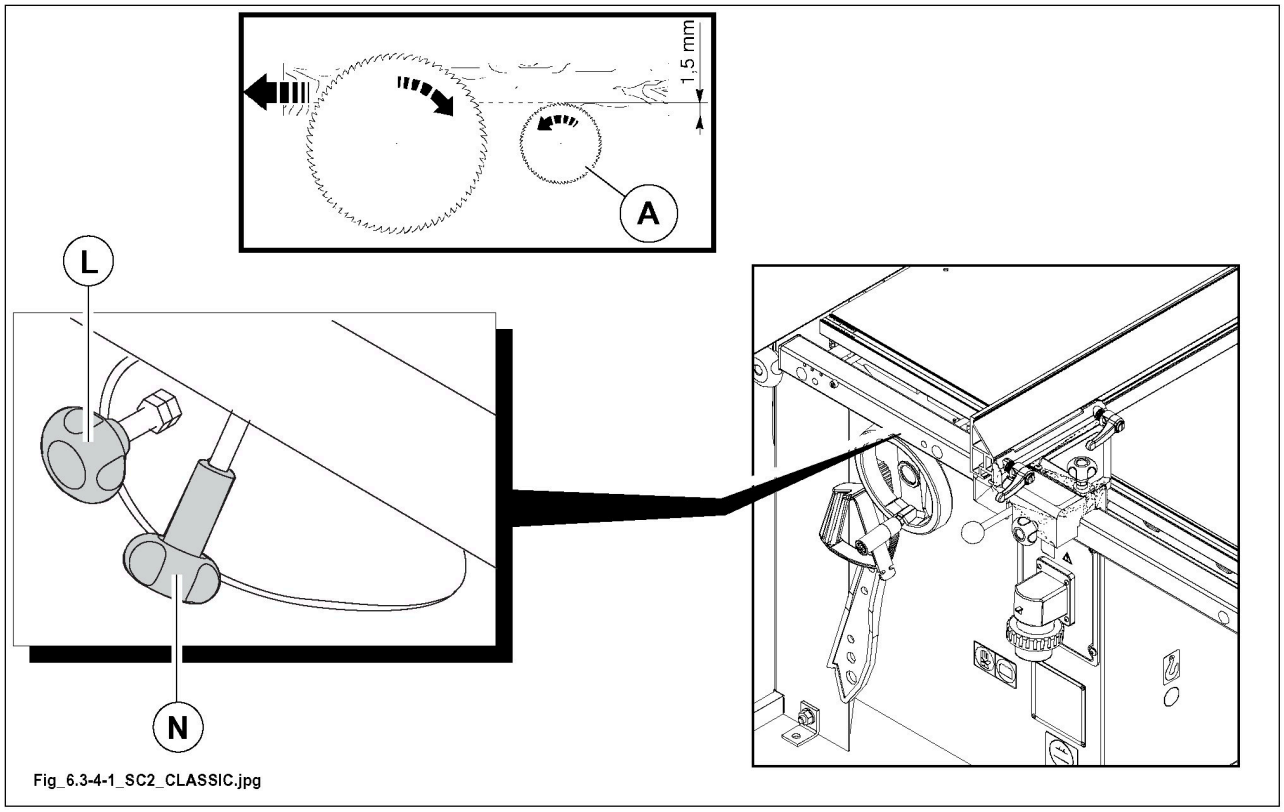


Fig_6.3-4-1_SC2_CLASSIC.jpg

7.4 Correct use for circular saw

SPECIALISED PERSONNEL

first make sure that the machine does not vibrate. Do not try to take off the material when the cut has already started; proceed with a continuous and uniform speed.

Workpiece feeding towards the blade (especially where there are knots) should not be too fast (feeding speed should be in accordance with workpiece thickness). Do not let workpieces stop between the saw fence and the blade.

DANGER

always remove any trimmings produced during machining because trimmings interposed between the blade and the saw table might damage the machine or be a source of danger for the operator.

Before removing, switch off the machine and wait for the saw blade to stop.

- Avoid contact of the tips against metallic objects.
- When necessary sharpen the saw blade.
- Often clean the steel body and the tips with proper liquid products. Let the saw blade in the bath, then clean it with brush: don't use metallic brushes.
- Choose the toothing by bearing in mind that for a good cut at least 2-3 teeth must cut at the same time (A). If only one tooth cuts (B) the cut will not be satisfactory.
- Whenever this is possible, it is also critical to lift the blade until the whole tooth cutting part protrudes from the wood thickness.

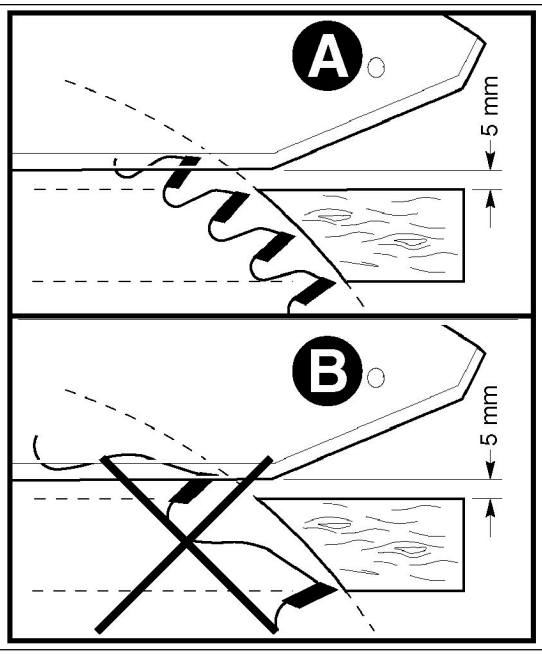


Fig_6.4_SC_2W.jpg

7.5 Grooves with saw blade

DANGER

Maximum work piece thickness: h = 40 mm

Maximum groove depth: S = h/2 mm

PROHIBITED

IT IS FORBIDDEN to cut a groove only on a partial section of the panel.

The machining must be performed on the entire length of the panel.

IT IS FORBIDDEN to disassemble the divider knife.

DANGER

The machine has been designed to only use tools fed manually (marked "MAN"), compliant with standard EN 847-1 and suitable for the type of material used.

DANGER

When working with small pieces, work the piece by making use of a wood pusher.

Exclude the scoring saw by lowering it below the saw plane.

PROHIBITED

It is FORBIDDEN to perform this task with the saw blade tilted.

To make a groove with a saw blade, proceed as follows.

With guard fixed to the riving knife

DANGER

- **before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S.**

- Remove the guard P from the riving knife by loosening the handle (E) (see Par. " Guard adjusting");
- adjust riving knife (F) height by loosening the nut (G);
- prepare a protection (B, not supplied by the manufacturer) made with "machinable material e.g. light alloys, plywood, polyamide, polypropylene, or other plastic material with similar specifications), and with the dimensions indicated.

DANGER

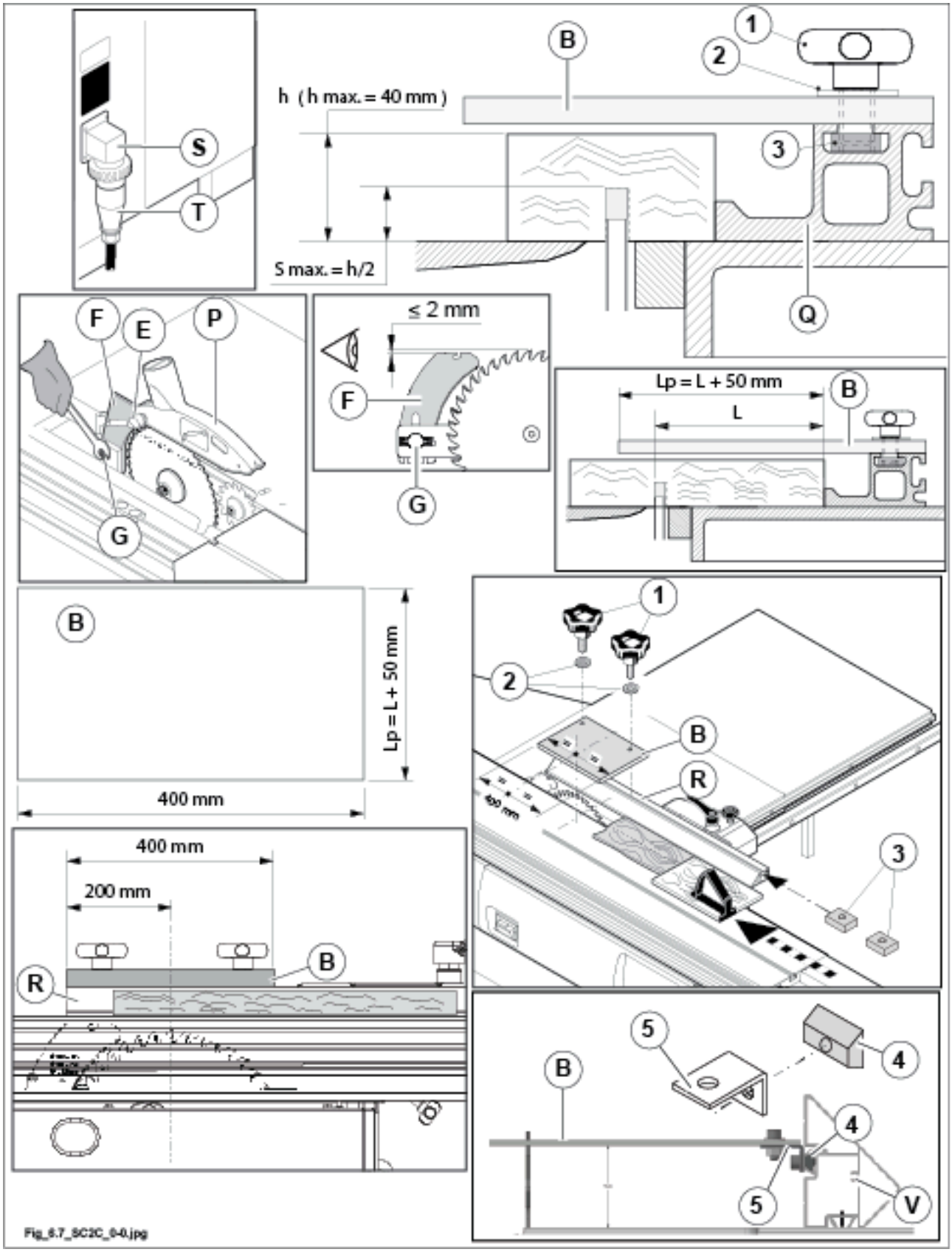
the protection (B) must be wide enough to prevent access to the blade.

If "L" is the machining quota, the width of the protection must be:

- **Lp = L + 50 mm (Lp min. = 200 mm)**

Secure the guard (B) to the rule (R) for the parallel cut, as shown in the figure, using the fixing devices (shown in the figure):

- (1, 2 NOT supplied by the manufacturer), (3, supplied by the manufacturer) for rule with square groove (Q).
- (4, 5 supplied by the manufacturer) for rule with (V) groove.


S
T
h (h max. = 40 mm)
S max. = h/2
B
1
2
3
Q
F
E
P
G
≤ 2 mm
Lp = L + 50 mm
L
400 mm
200 mm
R
4
5
V
Fig_8.7_SC2C_0-0.jpg

Once the machining is competed, reassemble the protection (P) on the riving knife (F) (see Par. " Fitting the guard for saw blade and scorer").

DANGER

adjust the position of the riving knife (see Par." Riving knife adjusting") so that its distance from the saw blade is between 3 and 8 mm (see example figure).

PROHIBITED

IT IS FORBIDDEN to use the machine without the protection provided for each job or to remove parts of it (IT IS FORBIDDEN to disassemble fixed and mobile shelves and bypass the safety micro-switches).

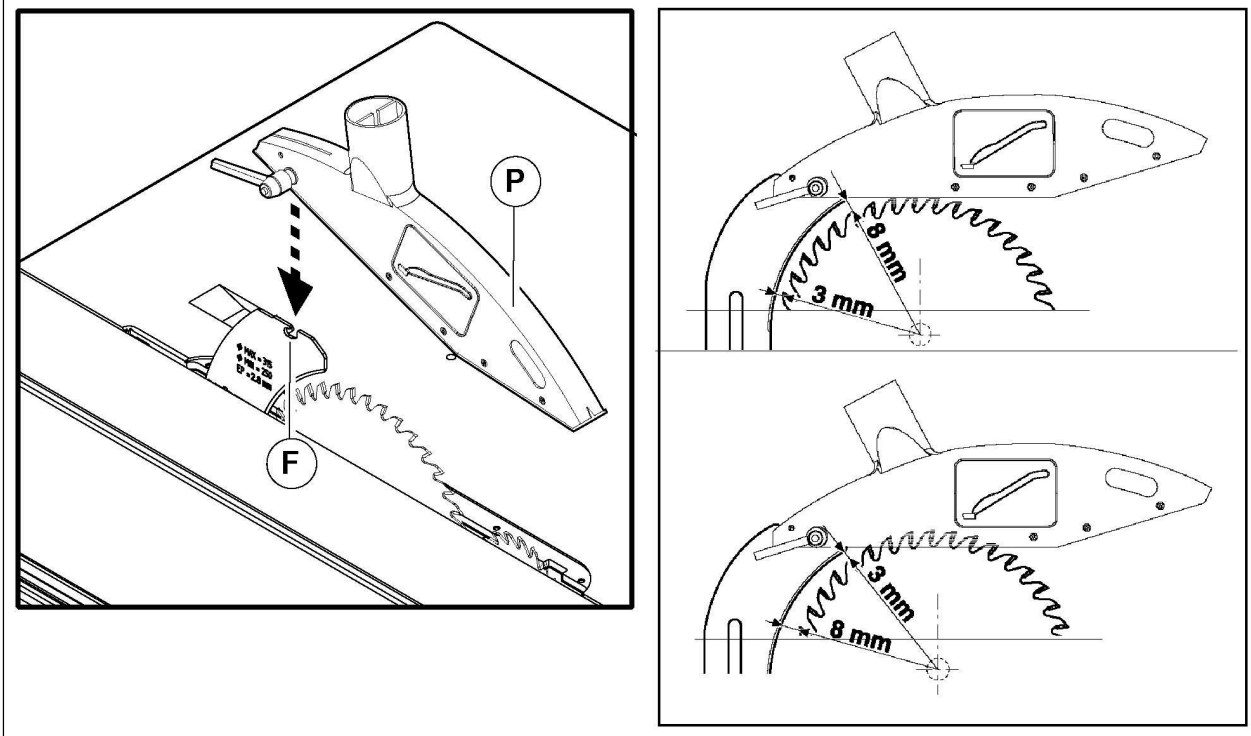


Fig_6.7bis_SI315_400_ELITE_S.jpg

With suspended guard

OPT

NOTE

not available on the "COMPACT" version.

- Place the line for parallel cuts at the desired distance;
- adjust the cutting height of the saw blade; the maximum depth of the slot must not exceed half the thickness of the worked wood.

DANGER

never remove the guard.

Before starting to work, ensure that the guard is resting against the workpiece and, at the end of the operations, lower it until it comes into contact with the table.

PROHIBITED

IT IS FORBIDDEN to use the machine without the protection provided for each job or to remove parts of it (IT IS FORBIDDEN to disassemble fixed and mobile shelves and bypass the safety micro-switches).

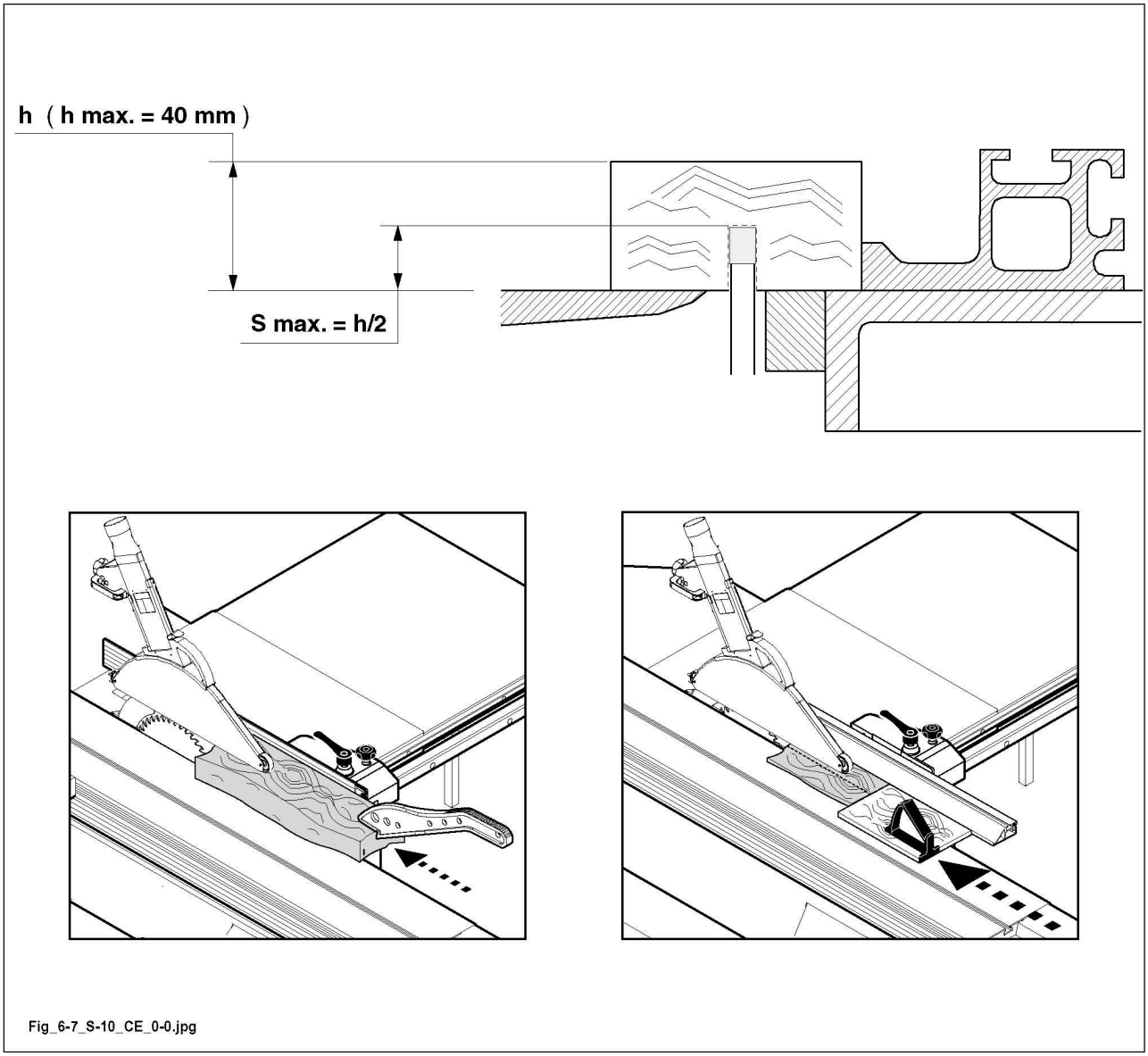


Fig_6-7_S-10_CE_0-0.jpg

7.6 Guard adjusting

- Lock the handle (E) so as the safety guard (D) is coupled to the dividing knife
- Using the handle (F), raise or lower the safety guard until it reaches the desired position, depending on the thickness of the wood to be cut (the distance between the guard and the wood must be 2 - 3 mm). This position will be maintained
- The guard is made of such material so that in case of contact with the suction hood, the saw blade is not damaged
- Two wood ledges fixed down, inside the guard, serve to protect the sides
- The guard is adjusted to cover the top teeth of the saw blade at least 8 mm

PROHIBITED

With this protective hood, it's strictly forbidden to carry out not-through cuts.

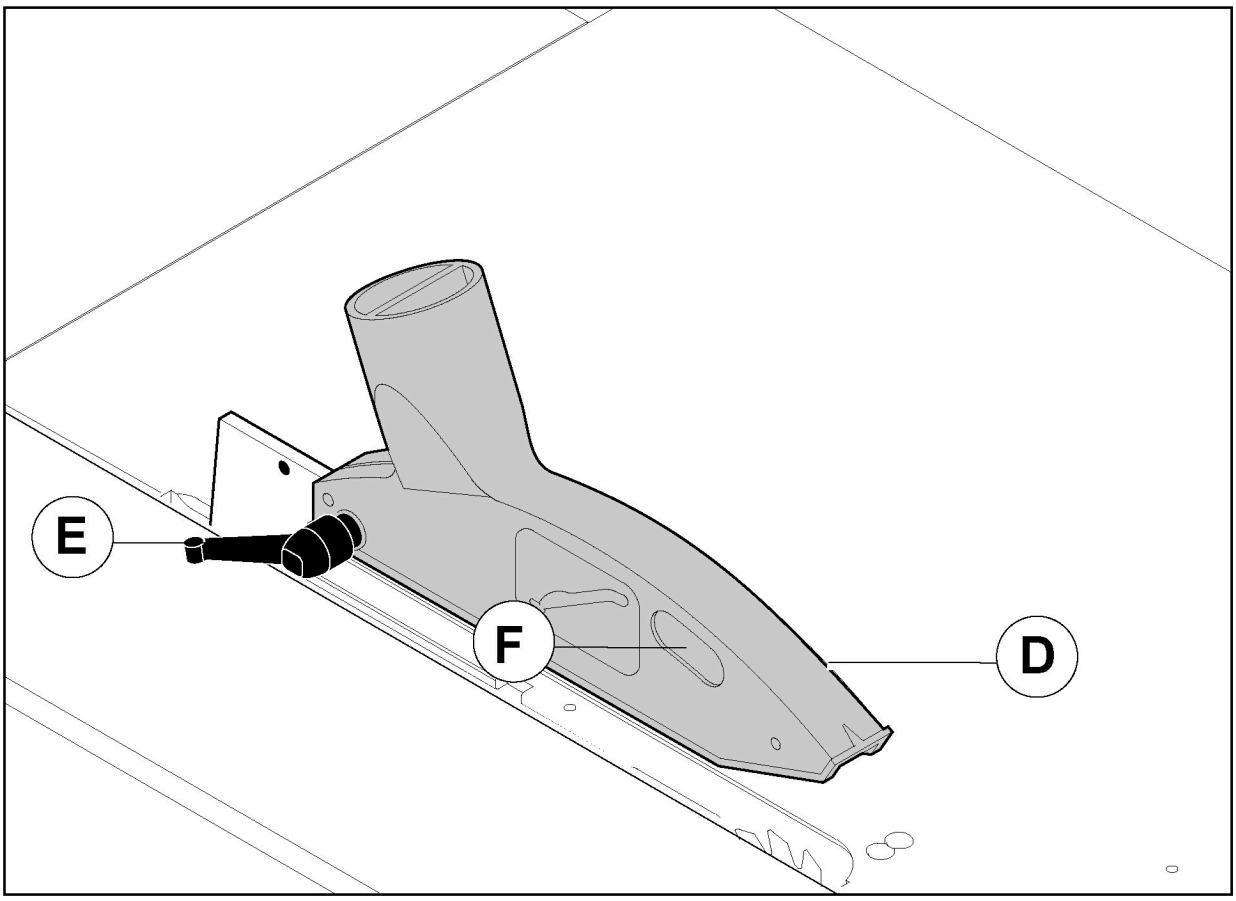


Fig_6.8_SC_2W.jpg

7.7 Description of hanging guard

OPT

NOTE
not available on the "COMPACT" version.

This guard can be adjusted simply by raising or lowering the handle (5).

DANGER

Never remove the guard.

Before starting to work, ensure that the guard is resting against the workpiece and, at the end of the operations, lower it until it comes into contact with the table.

PRESENTATION

The hanging guard is made by the following parts:

- 1 - Guard for saw blade and scorer
- 3 - Support arm
- 4 - Side which may be replaced with wide side for oblique cuts
- 5 - Height adjustment handle
- 6 - Spring for vertical guard movement
- 7 - Side blockage device
- 8 - Fitting for suction pipe
- 10 - Aluminium strips
- 11 - Wide side for oblique cuts

DESCRIPTION

With the handle (5) holding the spring (6) down, lift and lower parallel with the table the guard (1) which will maintain the selected position.

The guard is made of material (aluminium + polycarbonate) which may be machined so that the saw blade is not damaged if it touches the guard.

Two aluminium ledges (10 fig. 6.9) are fixed down inside the guard to protect the sides.

The front and rear side are made of transparent polycarbonate (3 mm thickness) so that the saw blade is visible during the working.

For oblique cuts use the wide rear side panel (11) supplied with the machine.

To replace it :

1. Raise the guard (1) and remove the rear side (4).
2. Insert the wide side (11, supplied).

The guard is equipped with fitting (8, 80 mm diameter) for connection to centralized suction system.

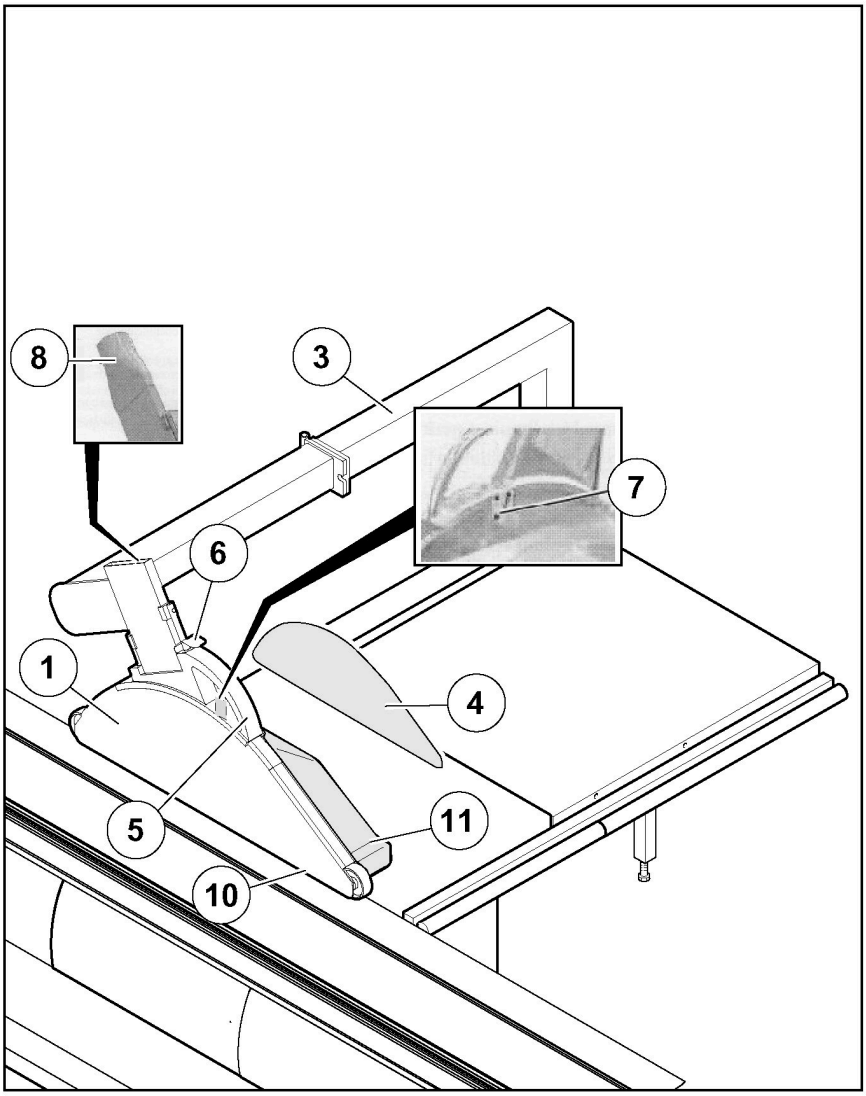


Fig_6.9_SC_4WS.jpg

7.8 Hanging guard adjusting

OPT

NOTE
not available on the "COMPACT" version.

- With the handle (5) holding the spring (6) down, lift and lower parallel with the table the guard (1) which will maintain the selected position.
- Raise or lower the safety guard until it reaches the desired position, depending on the thickness of the wood to be cut (the distance between the guard and the wood must be 2 - 3 mm). This position will be maintained.

Otherwise apply to Technical Service of SCM **dealer.**

NOTE
We recommend to keep the guard always clean and to periodically check its conditions.
Keep the guard resting on the table, when the machine is off.

DANGER
Never remove the guard.

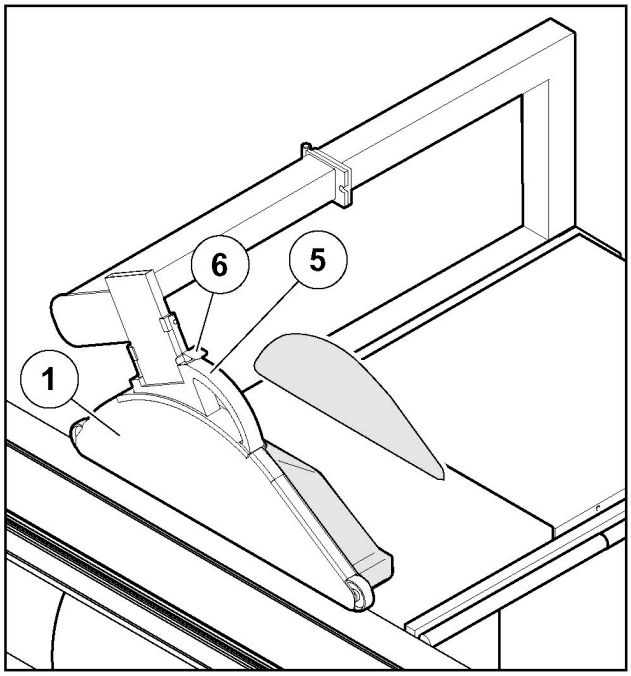


Fig_6.11_SC_4WS.jpg

8 Using and adjusting the support frame and parallel guide

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8.1 Splinter guard adjustment

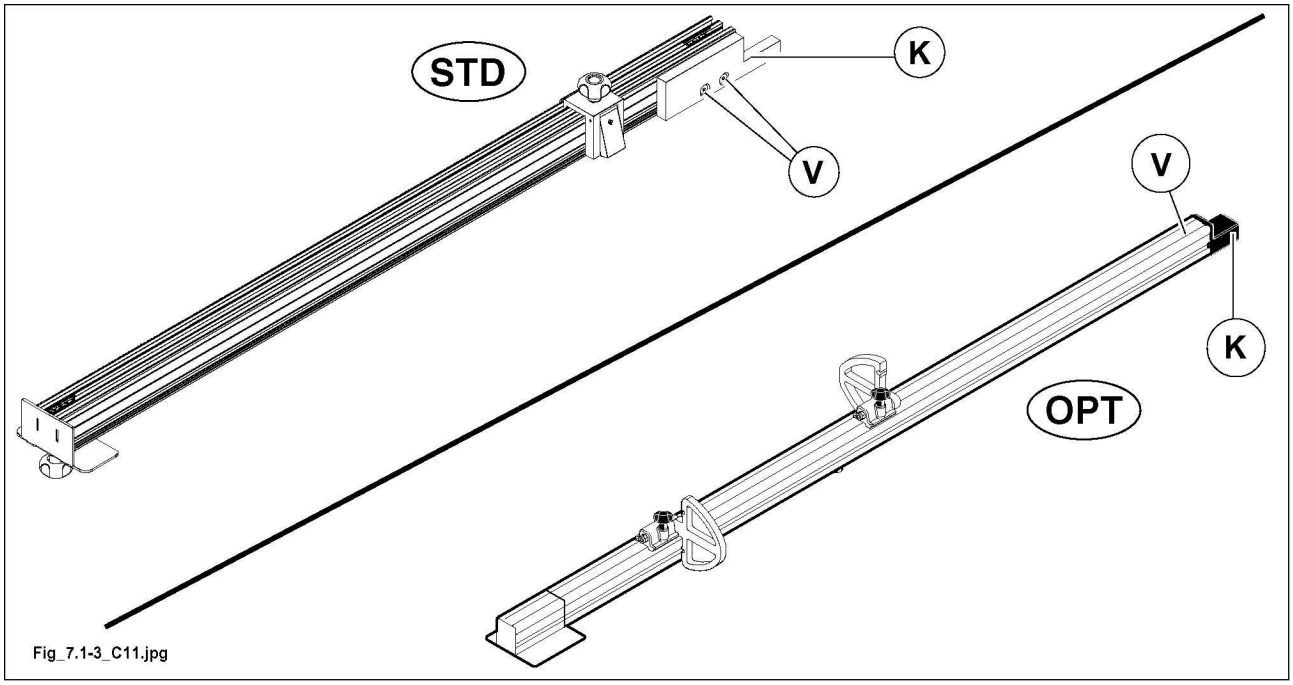
NOTE
not available on the "COMPACT" version.

STD

It is possible to the splinter guard (K) more than once without having to move the entire supporting rule.
Loosen the screws (V), slide the splinter guard (K) towards the blade, tighten the screws and trim the guard again.
If necessary replace it see Chapter "Maintenance".

OPT

It is possible to the splinter guard (K) more than once without having to move the entire supporting rule.
Loosen the screw (V), slide the splinter guard (K) towards the blade, tighten the screw and trim the guard again.
If necessary replace it see Chapter "Maintenance".



8.2 Using the telescopic rule

NOTE
not available on the "COMPACT" version.

A - for 90° cuts

1. Position the telescopic ruler in such a way that the pin (C) fits into place against the gib (L). The gib (L) is adjusted by our technicians and is used to rapidly position the telescopic ruler at the right distance from the saw blade (only at a 90° position).
2. Position the telescopic rule so that the pin (E) goes against the device (S).
3. Tighten the knob (F).
4. To use position the stops (B) using the metric rule (P) as reference.

B - for tilting cuts

1. For use, position the ruler referring to the plate (P).

   Tighten the knob (F).

   The ruler is fitted with an extractable telescopic extension (H), which may be lengthened as required after loosening the knob (G).

   (STD) : when the splinter guard (M) is worn, bring it up against the saw blade by loosening the two screws (N). **The telescopic rule is supplied with the stops (B). These can be positioned quickly for resting or pushing machining, by removing them from the rule and reassembling them on the opposite side.**

   (OPT) : when the splinter guard (M) is worn, bring it up to the saw blade by loosening the grub screw (N). **The telescopic rule is supplied with the stops (B). They can quickly be positioned for resting or pushing machining by simply tipping them over.**

A = for 90° cuts	for tilting cuts = B

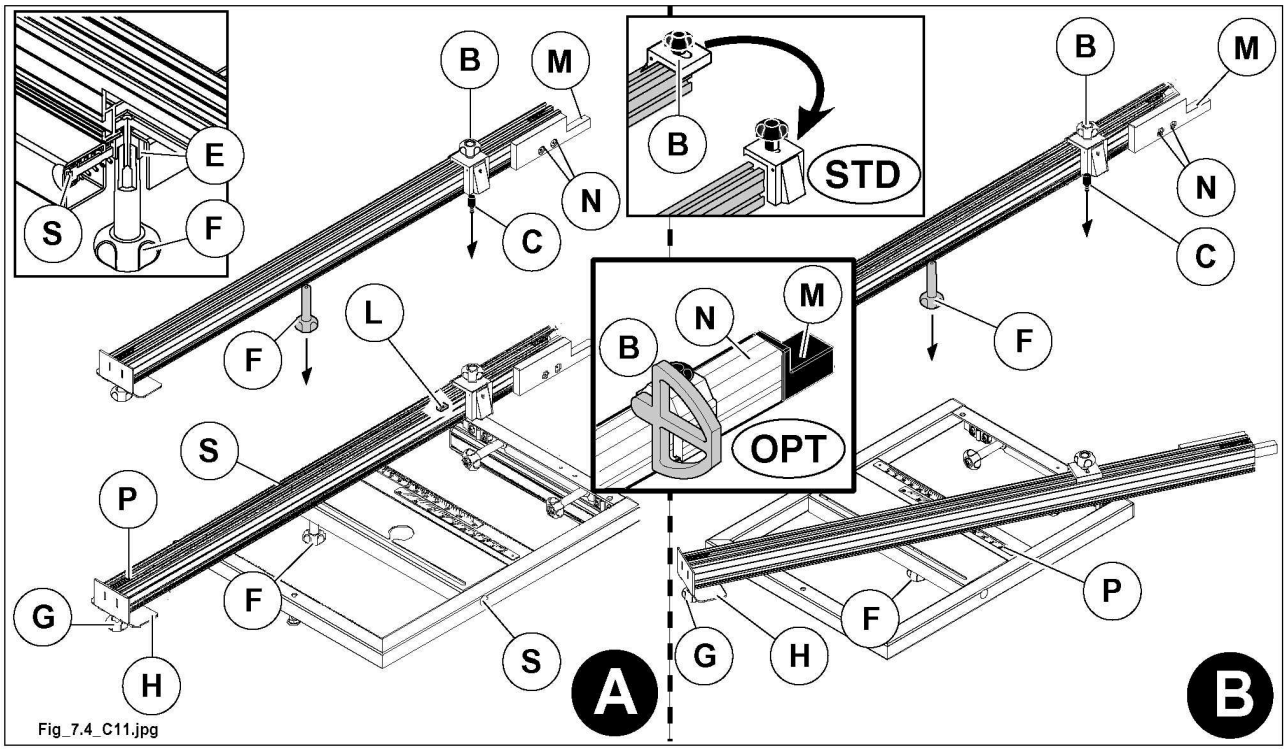


Fig_7.4_C11.jpg

8.3 Manual fence for parallel cuts

Saw guide unit with micrometric rack adjustment (sliding on cylindrical section guide).

8.3.1 Setting to zero the fence for parallel cuts

1. With motors off lift the saw guard;
2. Release the parallel cuts guide unit (D) using the handle (L) and move it so as to read a value (example 200 mm) between the edge (R) of the rule facing the blade and the graduated rule positioned beneath it (N);
3. Measure the distance between saw blade and parallel fence;
4. Loosen the nuts (M) and move the millimetre rule (N) so as to read, on the edge (R) of the rule, the same value as previously measured with the metre.
5. Lock the guide unit using the handle (L)
   Lower the guard and carry out a test cut;
6. Tighten the nuts (M).

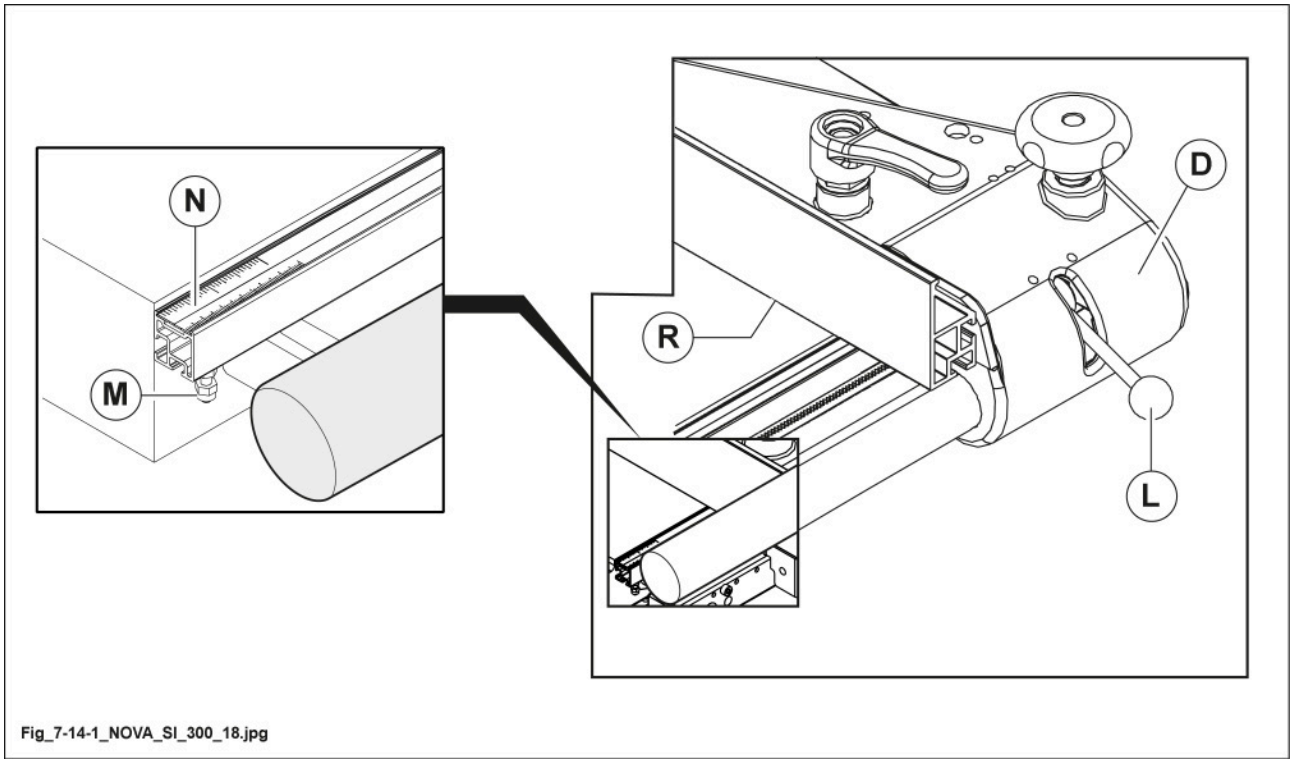


Fig_7-14-1_NOVA_SI_300_18.jpg

8.3.2 Working

It is used for parallel cuts with cutting width up to 900 mm (standard width) and 1270 mm upon request.

NOTE
in the "COMPACT" version the only cutting width available, to the parallel guide, is 700 mm.

The rule (R) can be moved longitudinally after releasing the lever (P); retighten the lever each time after positioning it.
The parallel rule shall be adjusted in longitudinal direction, so that the workpiece can not lock between rule and riving knife.

DANGER
The front extremity of the rule must never protrude beyond the end of the plane on the side (F), but must reach an imaginary line (G) that starts from the first tooth of the blade and slides forward by 45°. This is to prevent the saw teeth from gripping the work-piece and projecting it towards the operator.

The rule (R) may assume 2 different positions after having loosened the lever P.
1. Vertical position with the side (W) facing the work-piece;
2. Horizontal position (O) for for cutting thin work-pieces and angled cuts.

DANGER
In this position, it is possible to move the work-piece forward using the pusher (H) supplied with the machine.

DANGER
To avoid interference between the blade and line (R), be very careful when: the line is in a horizontal position, or when the blade is tilted.

3. Re-tighten the lever (P) at the end of every positioning;

To increase or decrease the distance between the fence and the saw blade operate as indicated below.

- Release the lever (X);
- slide the guide unit (T) manually, while referring to the metric ruler (E).

Carry out the micrometric adjustment proceeding as follows:

- pushing the knob (Y) and rotating it.
- Tighten the lever (X fig. 7.14-2) when the adjustment has been made.

DANGER
Before starting machining, make sure that the guard is resting on the work piece.

DANGER
Using the longitudinal guide (2) to avoid kickbacks during the transversal cut.
(4) = direction of piece feed.
During cuts with the transversal guide (3), the front end of the longitudinal guide (2) must be positioned before the front end of the blade (1) or not in contact with the piece.

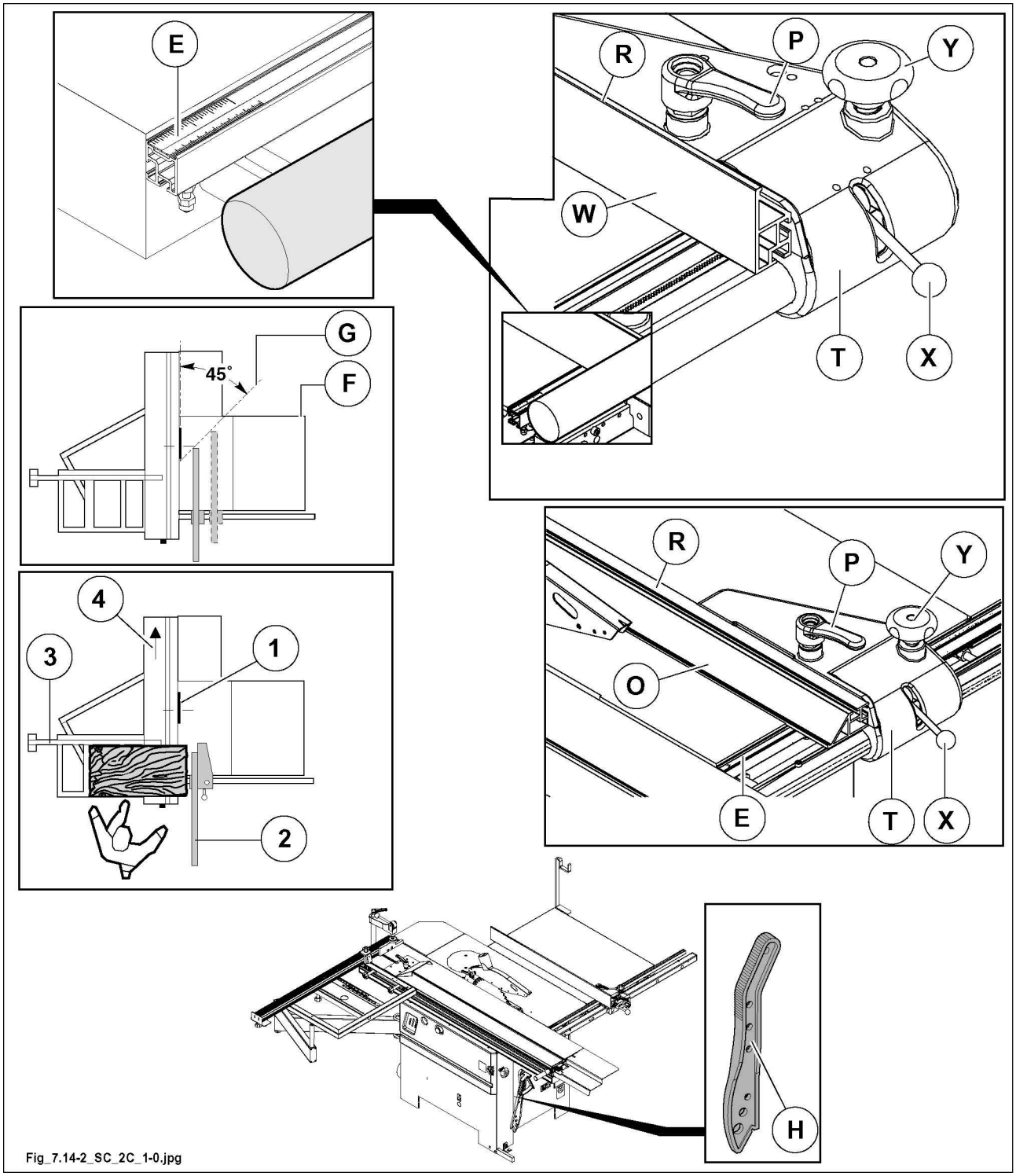


Fig_7.14-2_SC_2C_1-0.jpg

DANGER

When for the execution of a peculiar working, the operator is obliged to put his hands near the tools, for safety reasons a proper pusher shall be used to move the work piece forwards, to push it against the fence or to remove it after the cutting (see chapter "Wood pusher").

USING THE PUSHERS

DANGER

Before starting to work, ensure that the guard (D) is resting against the work piece and, at the end of the operations, lower it until it comes into contact with the table.

To avoid getting too close to the blades with your hands, use the pusher (H) supplied with the machine.

After using this device return to its seating.

When you have to cut small workpieces and you have to push against the fence, you must use the pushers supplied with the machine.

The handle (A) is supplied with the machine and may be used with pushers of various dimensions (see Chapter"Wood pusher").

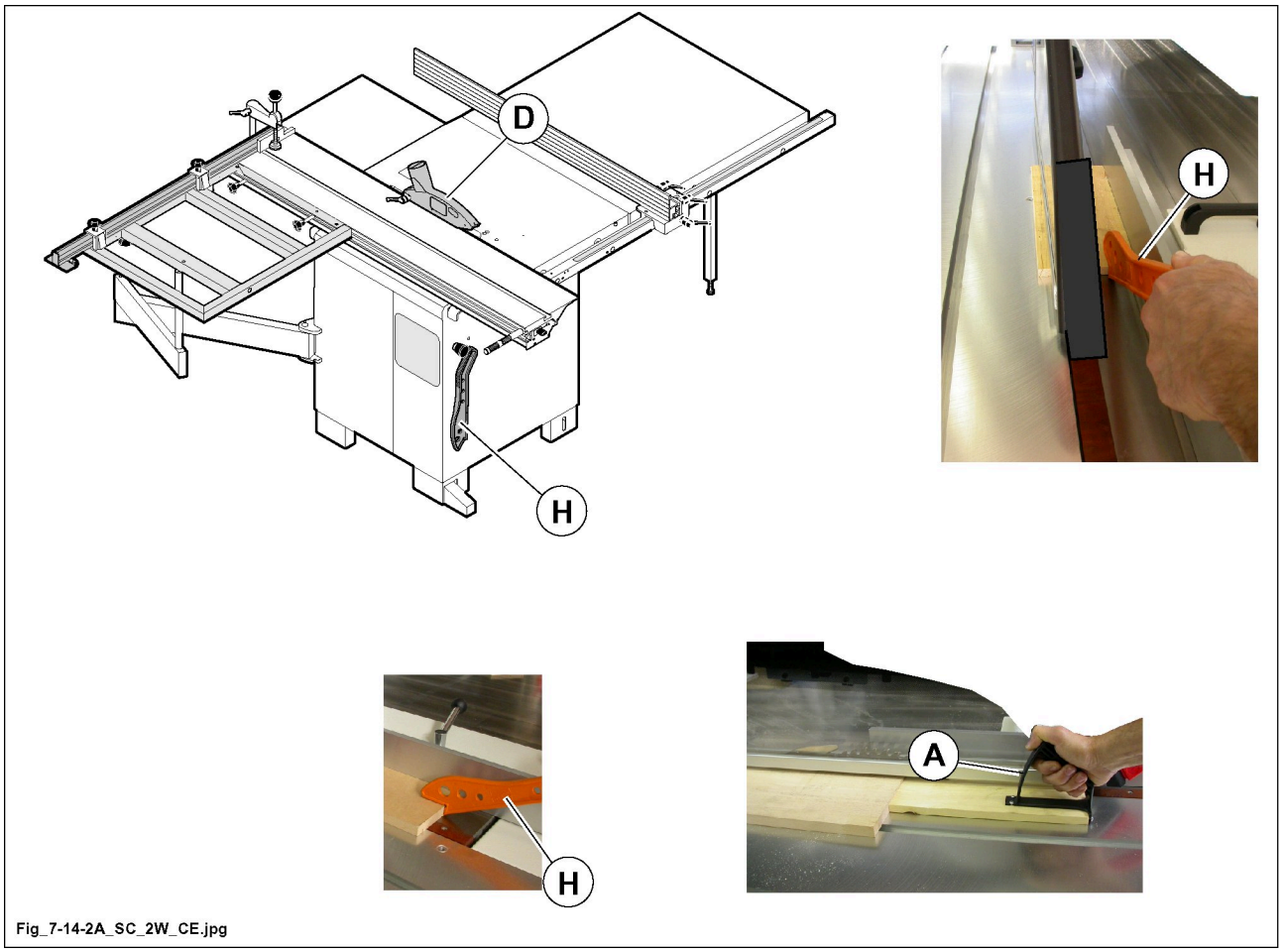


Fig_7-14-2A_SC_2W_CE.jpg

8.4 Manual fence for parallel cuts with electronic position reader on magnetic band

OPT

8.4.1 Resetting Operation

1. Move the guide towards the saw blade at the limit switch position.
2. Press the ENTER and SET keys simultaneously on the viewer (V) (the pre-set quota appears) and verify that the ☐ symbol is displayed.
3. Move the blade guide away to reach a value on the display (e.g.: 200) with reference to the vertical line.
4. Carry out a test cut and take the actual measurement of the piece obtained.
5. If there is a difference between the value set and the actual value, add or subtract the difference to or from the preset value (see chap. "Readers or displays").
   Example:
   Quota set 200
   Actual quota of piece cut 200.5
   Preset quota 1330.0
   Correct the preset quota to 1330.5:
6. To zero the millimetre rule (N) see paragraph" Setting to zero the fence for parallel cuts".

8.4.2 Working

It is used for parallel cuts with cutting width up to 900 mm (standard width) and 1270 mm upon request.

NOTE
in the "COMPACT" version the only cutting width available, to the parallel guide, is 700 mm.

The rule (R) can be moved longitudinally after releasing the lever (P); retighten the lever each time after positioning it.
The parallel rule shall be adjusted in longitudinal direction, so that the workpiece can not lock between rule and riving knife.

DANGER
The front extremity of the rule must never protrude beyond the end of the plane on the side (F), but must reach an imaginary line (G) that starts from the first tooth of the blade and slides forward by 45°. This is to prevent the saw teeth from gripping the work-piece and projecting it towards the operator.

The rule (R) may assume 2 different positions after having loosened the lever P.
1. Vertical position with the side (W) facing the piece (on the display, press the key ENTER until the symbol appears).
2. Horizontal position (O) for cutting thin work-piece and angled cuts (on the display press the ENTER key until the symbol appears).

DANGER
In this position, it is possible to move the work-piece forward using the pusher (H) supplied with the machine.

DANGER
To avoid interference between the blade and line (R), be very careful when: the line is in a horizontal position, or when the blade is tilted.

3. Re-tighten the lever (P) at the end of every positioning;

To increase or decrease the distance between the fence and the saw blade operate as indicated below.

- Release the lever (X);
- manually slide the guide unit (T) with reference to the metric rule (N) or the display (V).

Carry out the micrometric adjustment proceeding as follows:

- pushing the knob (Y) and rotating it.
- Tighten the lever (X fig. 7.14-2) when the adjustment has been made.

DANGER
Before starting machining, make sure that the guard is resting on the work piece.

DANGER
Using the longitudinal guide (2) to avoid kickbacks during the transversal cut.
(4) = direction of piece feed.
During cuts with the transversal guide (3), the front end of the longitudinal guide (2) must be positioned before the front end of the blade (1) or not in contact with the piece.

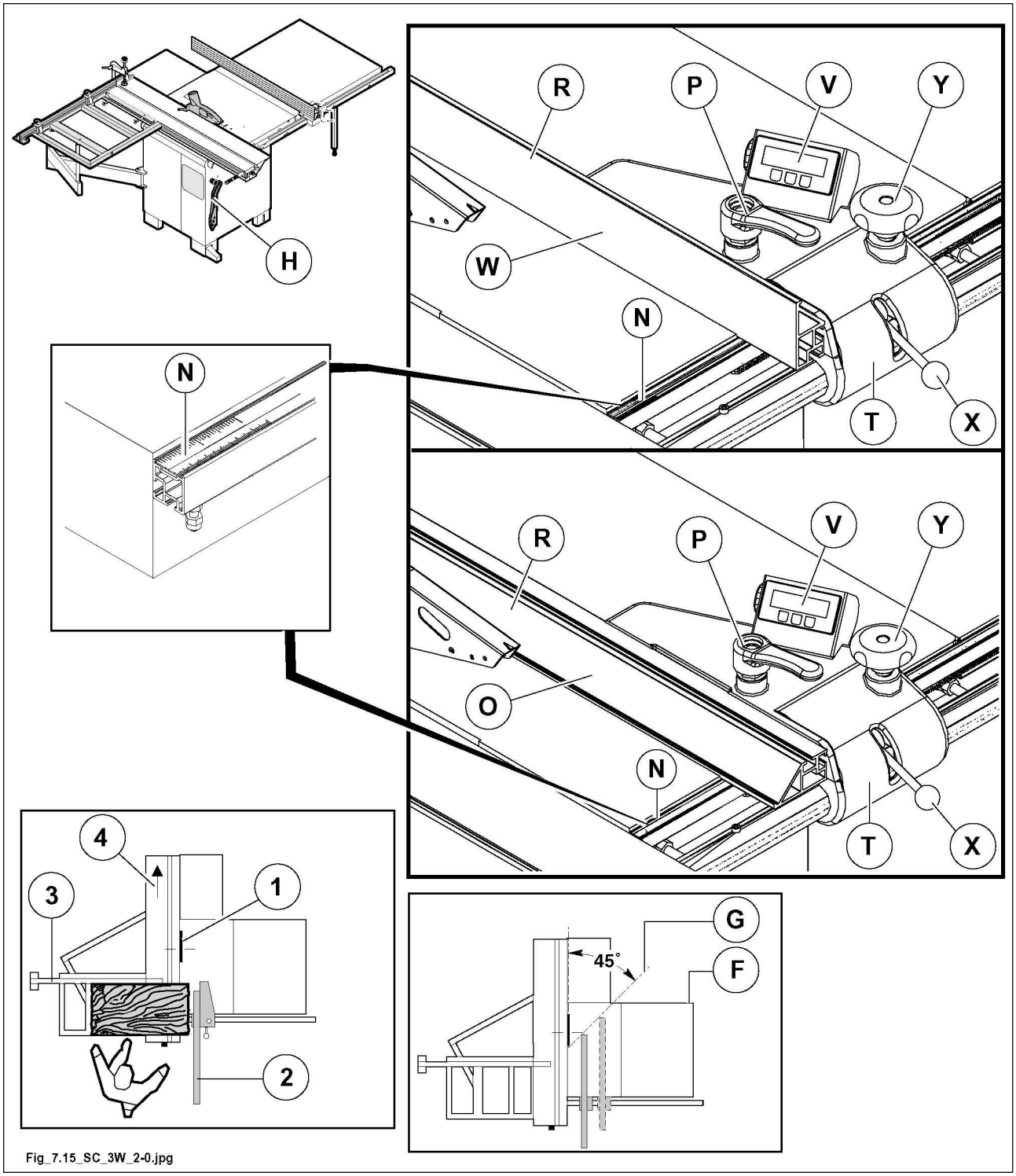


Fig_7.15_SC_3W_2-0.jpg

SPECIALISED PERSONNEL

if the line (R) needs to be replaced, proceed with:

- 1) the line change as indicated at the start of this paragraph;
- 2) the programming of the display as indicated in Chap. "Readers or displays".

DANGER

When for the execution of a peculiar working, the operator is obliged to put his hands near the tools, for safety reasons a proper pusher shall be used to move the work piece forwards, to push it against the fence or to remove it after the cutting (see chapter "Wood pusher").

USING THE PUSHERS

DANGER

Before starting to work, ensure that the guard (D) is resting against the work piece and, at the end of the operations, lower it until it comes into contact with the table.

To avoid getting too close to the blades with your hands, use the pusher (H) supplied with the machine.

After using this device return to its seating.

When you have to cut small workpieces and you have to push against the fence, you must use the pushers supplied with the machine.

The handle (A) is supplied with the machine and may be used with pushers of various dimensions (see Chapter"Wood pusher").

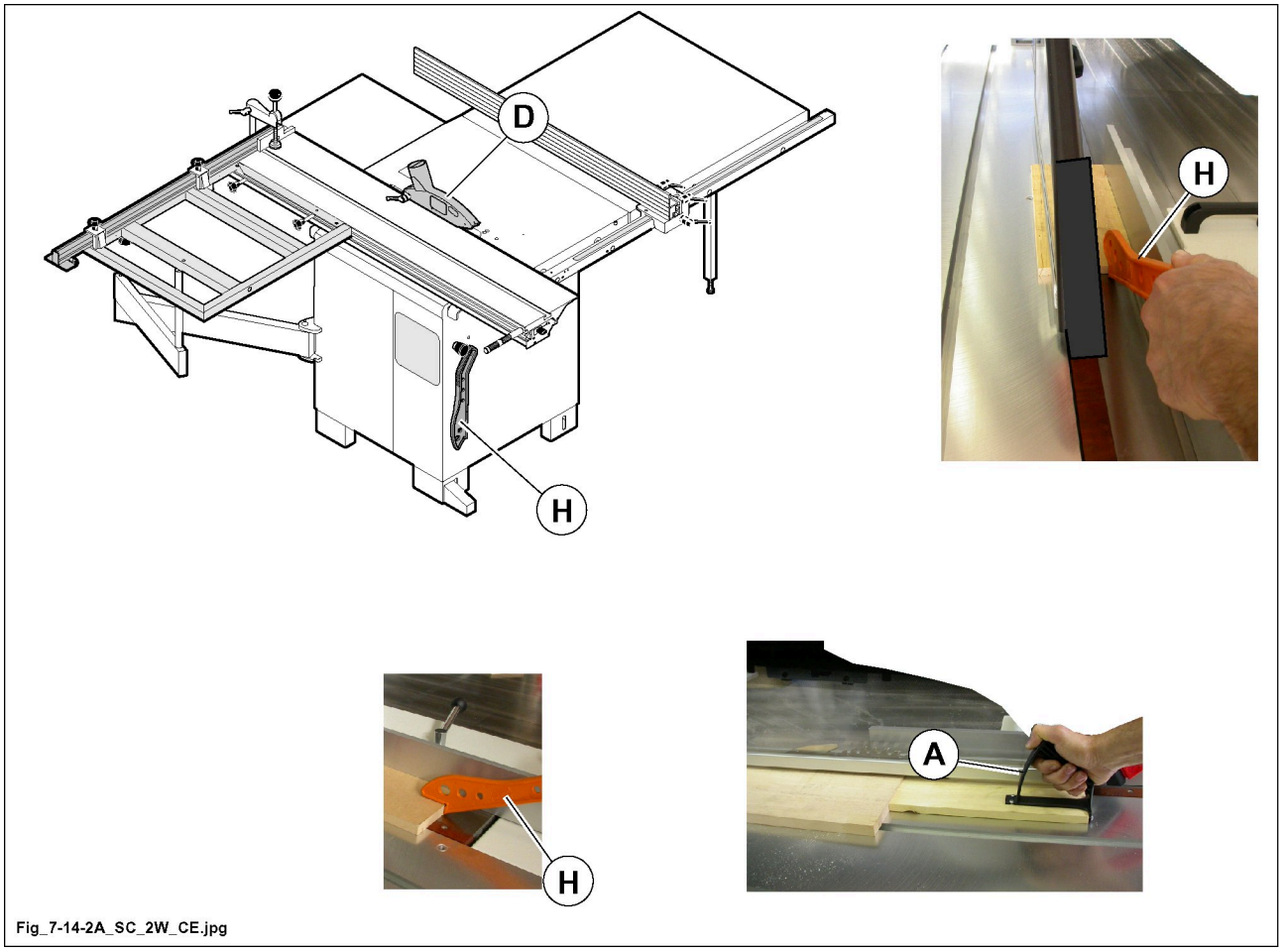


Fig_7-14-2A_SC_2W_CE.jpg

8.5 Use of sliding table and frame for large panels

8.5.1 Aluminium sliding table

The aluminium sliding table moves on high precision slideways made of hardened steel in order to ensure the uniform and smooth motion with small friction, necessary for obtaining precise cuts.

Use the lever (A) to lock and release the sliding carriage:

1. Lever raised - carriage locked
2. Lever lowered - carriage released

The sliding table may be locked in 2 points:

- the lever (A) is used to block the sliding table in the standby position (sliding table closed), and in the position to load the piece being machined (sliding table fully to the right limit switch)

Fasten the following devices:

- Insert the column rod (D) in the groove on the carriage, mount the arm (E) on the column and secure it in position by locking the handle (F)
- Mount the tile stop (G) by inserting the rod in the groove on the carriage and locking the handle (H)
- Mount the handle (L, included in the accessory kit) in the desired position on the carriage and screw it into place

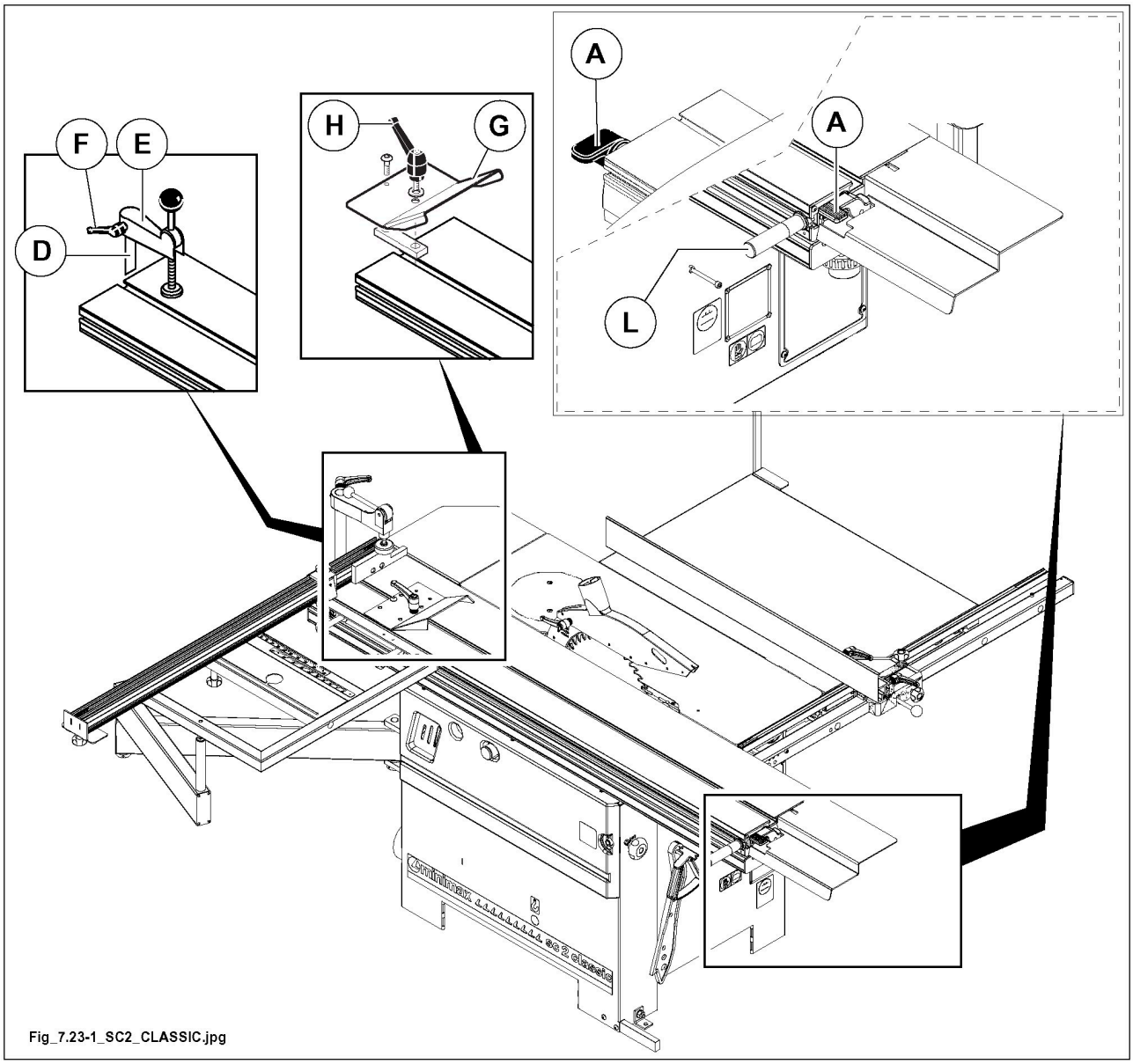
The structure of device (G) permits to perform precision stops also in pieces having an irregular stop surface.

DANGER

To move the sliding table ALWAYS use handle L:

DANGER

Move the carriage by the handle only (L) so as to avoid possible crushing hands against fixed parts.


A
A
L
H
G
F
E
D
Fig_7.23-1_SC2_CLASSIC.jpg

8.5.2 Use of the presser unit

DANGER

To ensure a strong panel clamping, the foot shall be at a 1 mm height from the panel surface before lowering the lever.

- Use the lever (H) to lower the foot (L) and secure the work-piece in position.

Wood stop unit

- Move the stop (G) to the required position.
- Tighten handle (A) hard after adjustment.

NOTE

the structure of device (G) permits to perform precision stops also in pieces having an irregular stop surface.

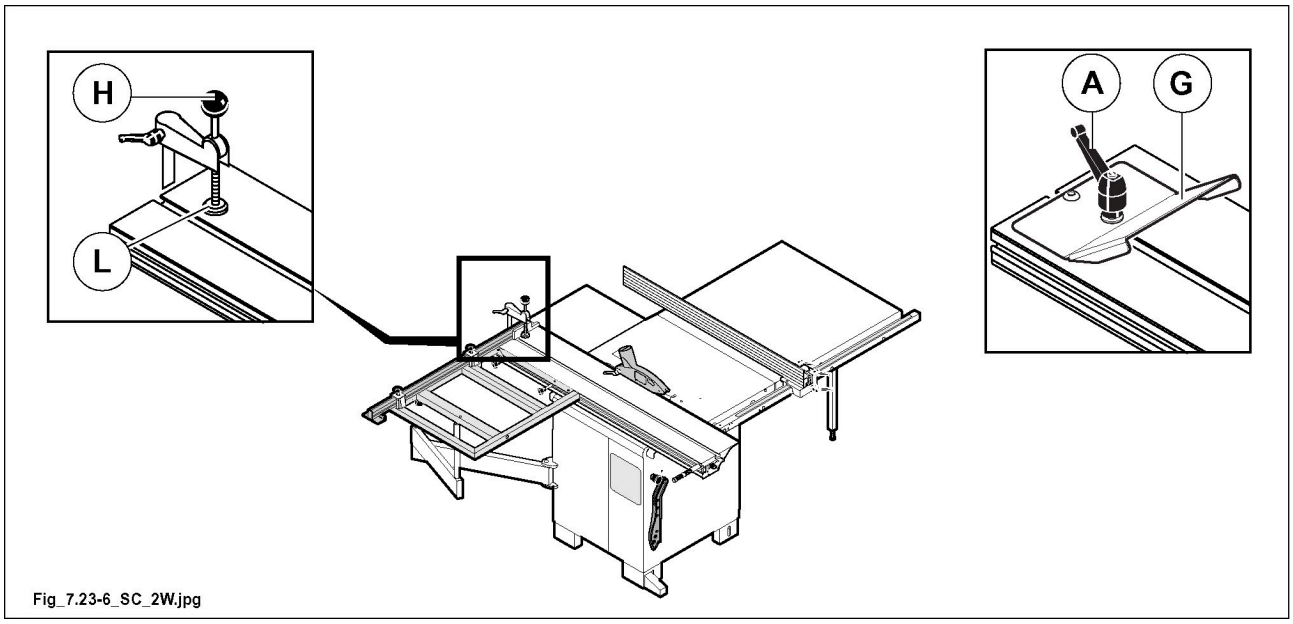


Fig_7.23-6_SC_2W.jpg

8.6 Example: longitudinal cut

The choice of the method to use to make a cut with the circular saw depends on the dimensions of the wood to be machined and the type of machining to be carried out. For cutting ennobled wood, use of the engraver (OPT) is indispensable to prevent chipping. When the engraver (OPT) is not needed, lower it completely underneath the table.
Adjust the saw and engraver (OPT) as described in Chap. "Using and adjusting on the blade unit" .

DANGER

always secure the workpiece with the presser when using the sliding table. Always use supports when machining panels having great dimensions.

NOTE

in the "COMPACT" version the square frame and the telescopic aluminium rule with stops are not available.

8.6.1 First cut

When machining large panels, position the telescopic rule and the square up frame in pushing (see figure); with this position the maximum cutting length is obtained.

1. Open the sliding table completely as in the figure and secure it in position using the lever (B).
2. Place the piece to be trimmed on the carriage and on the frame as shown in the figure.
3. Release the handle (F) and slide the tile stop (D) into the groove so that it comes to rest against the work-piece.
4. Lock the handle (F).
5. Position the presser unit (E) close to the work-piece.
6. Release the carriage using the lever (B).

DANGER

Move the work-piece against the blade (already set at the desired height) by pushing the carriage using the handle (C).

When loading the piece onto the sliding table, take care not to knock the saw blade.

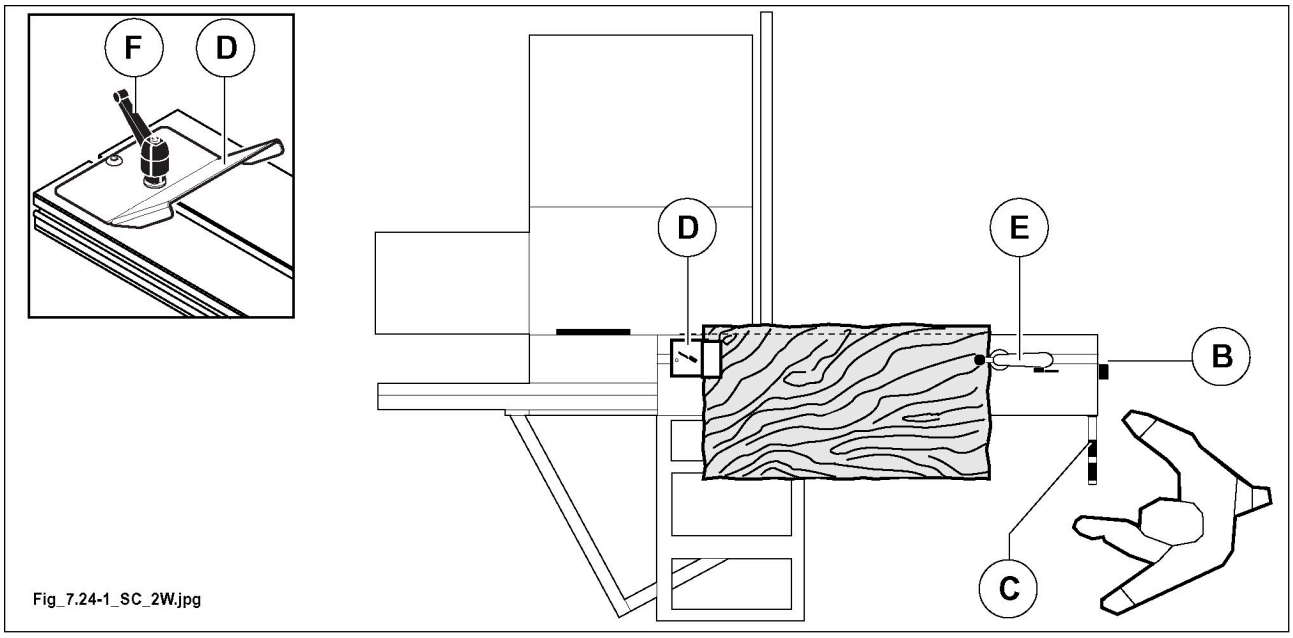


Fig_7.24-1_SC_2W.jpg

8.6.2 Second cut (squaring)

- Open the sliding table completely as in the figure and secure it in position using the lever (L).
- Rotate the panel by 90°. Place the trimmed side (A) against the aluminium rule, secure it with the part clamp (G) and execute the new cut (B).

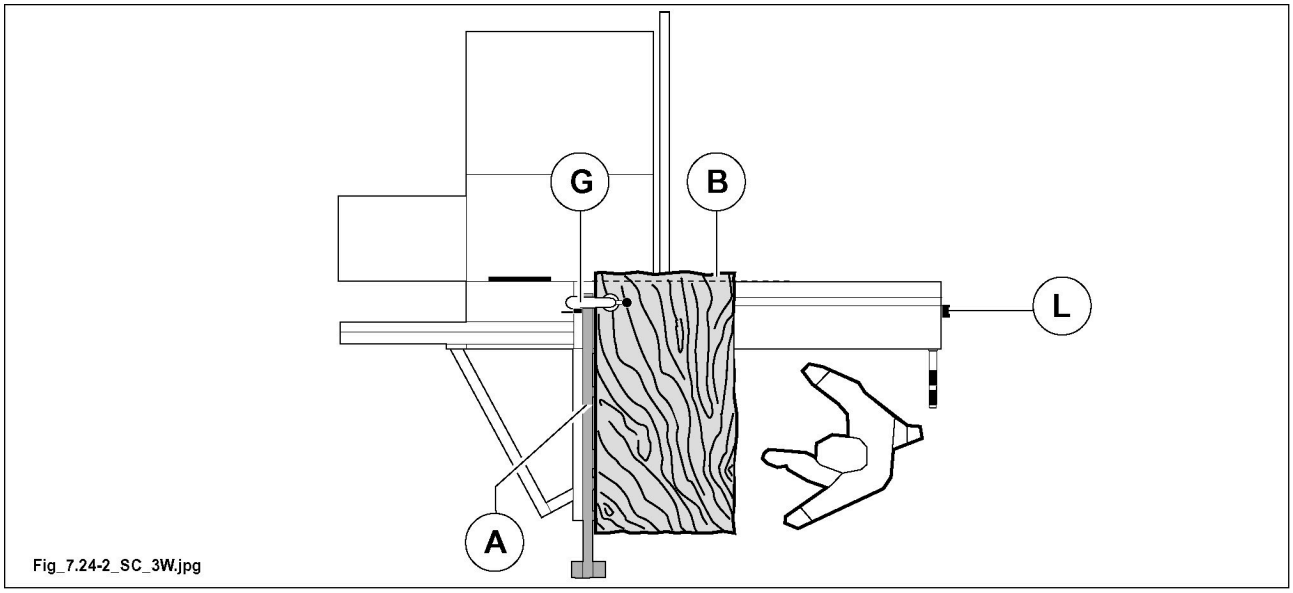


Fig_7.24-2_SC_3W.jpg

8.6.3 Third cut

- Open the sliding table completely as in the figure and secure it in position using the lever (L).
- Rotate the panel by 90° again. Place the newly cut side (B) against the aluminium rule, the trimmed side (A) against the stop (T) on the rule (positioned at the cutting quota), secure it with the part clamp (G) and execute the cut (C).

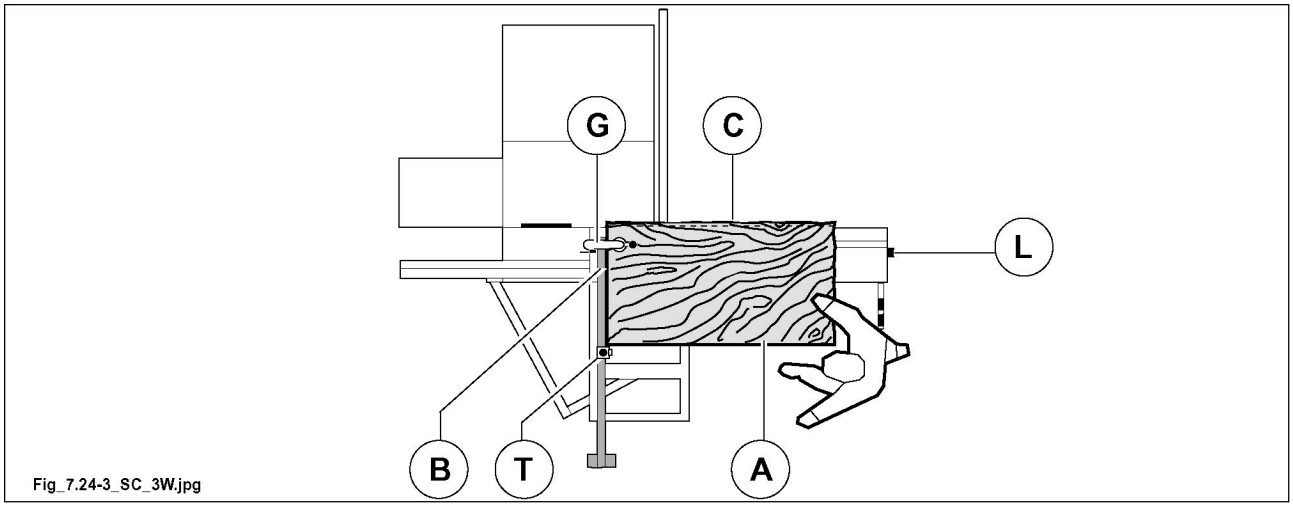


Fig_7.24-3_SC_3W.jpg

8.6.4 Fourth cut

- Open the sliding table completely as in the figure and secure it in position using the lever (L).
- Rotate the panel by 90° again. Place the newly cut side (C) against the aluminium rule, the side (B) against the stop (T) on the rule (positioned at the desired cutting quota), secure it with the part clamp (G) and execute the cut (D).

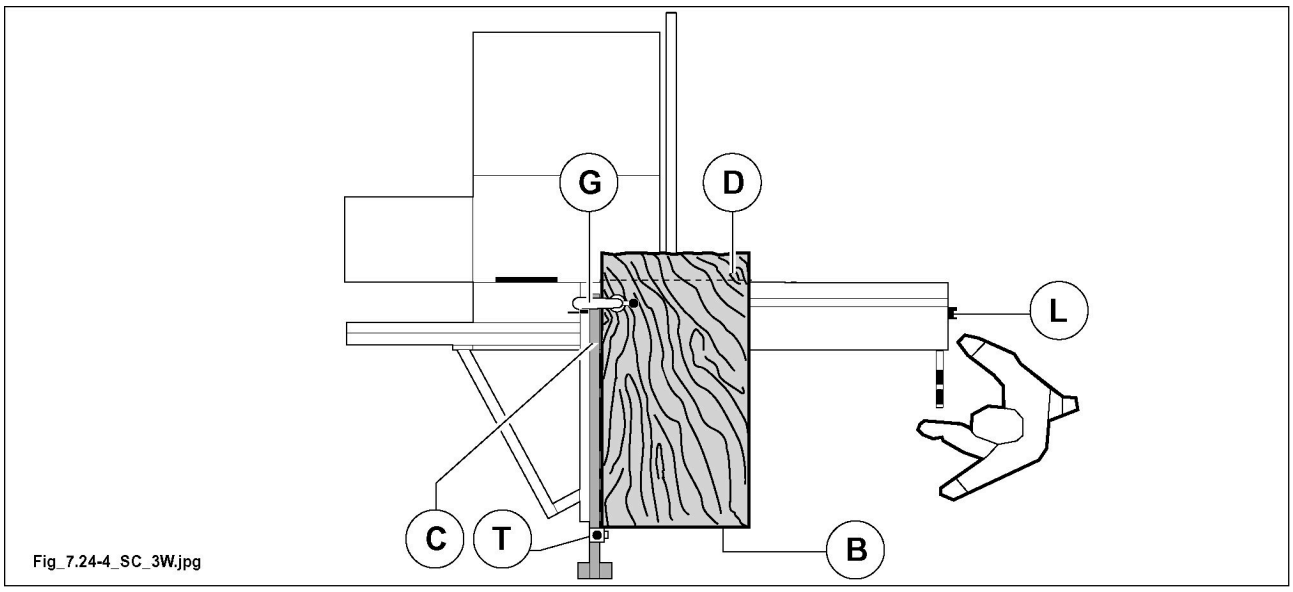


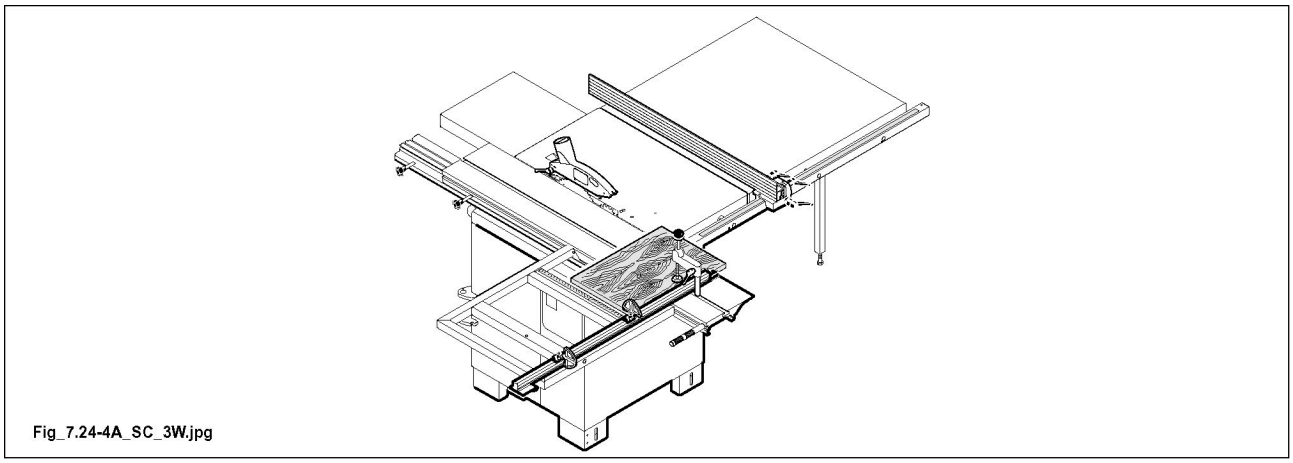
Fig_7.24-4_SC_3W.jpg

NOTE

to cut smaller size panels it is 'easier to work with the telescopic rule against the piece (see figure).

DANGER

working against the fence, with the graver on (OPT), should be carried out with the utmost care because scorer rotation is executed at the same time as workpiece feeding which causes it to be carried along.

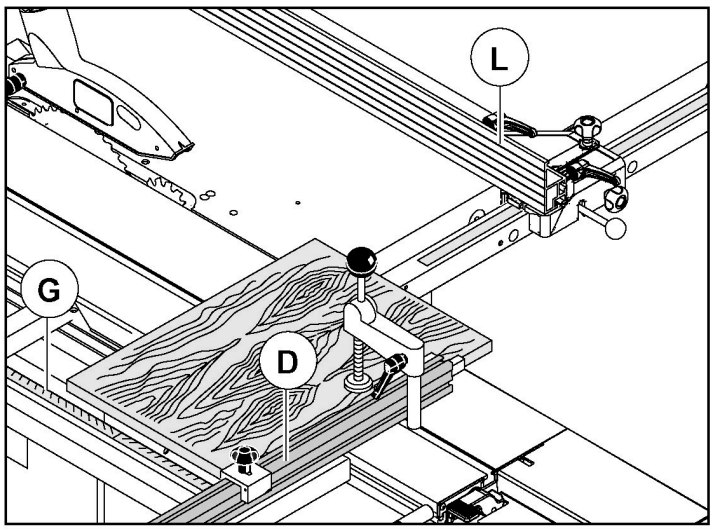

Fig_7.24-4A_SC_3W.jpg

NOTE

when the size of the panel allows it, it is preferable to make the first two cuts on the squaring machine (Par. " First cut" - " Second cut (squaring)") and make the remaining sides with the parallel guide (L).

Small panels may also be cut with the device for angled cuts illustrated in figure (supplied on request).

For cuts at an angle with respect to sliding table stroke, position the telescopic guide (D) or the angled cuts device OPT (E) based on the tilting required, using the millimetre rule (G) or (H) as reference.



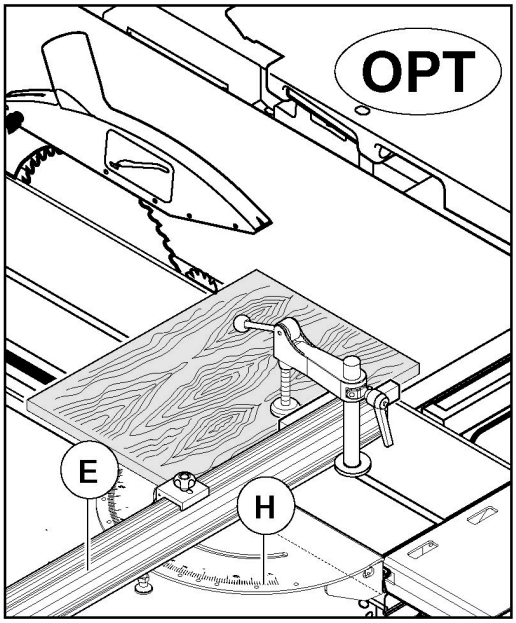


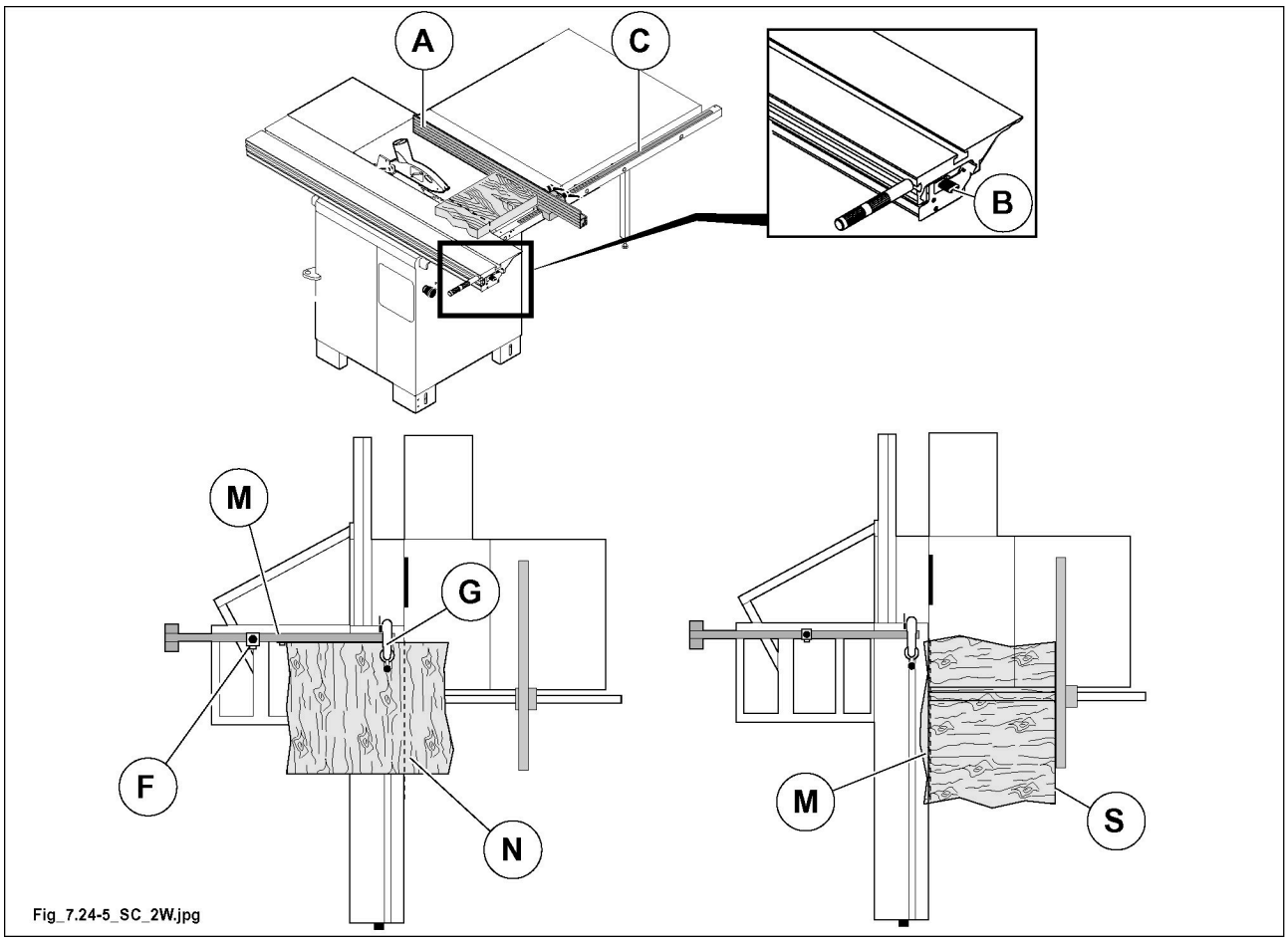
Fig_7.24-4B_SC2_CLASSIC.jpg

8.6.5 Cut for obtaining pieces with opposite sides parallel

To perform parallel cuts use the guide (A). To position and adjust, follow the instructions in Par. "Manual fence for parallel cuts" o Par. " Manual fence for parallel cuts with electronic position reader on magnetic band" .

Position the sliding table as shown in the figure and lock it with the knob (B). To position the workpiece against the guide (A), use the millimetre rule (C).

1. Execute the trimming cut (S) as described above (first cut).
2. Place the machined part (S) against the aluminium rule for parallel cuts (positioned at the desired cutting quota) and execute the parallel cut (M).
3. Rotate the panel by 90°, placing the trimmed part (M) against the rule as in the figure.
4. Lock the panel in position using the presser (G) and execute the third cut (N).
5. Rotate the panel by 180° so that the side (N) rests against the stop (F), which has already positioned at the desired quota.
6. After locking the panel in position using the presser (G), execute the last cut.



DANGER

the front extremity of the rule must never protrude beyond the end of the plane on the side (F), but must reach an imaginary line (G) that starts from the first tooth of the blade and slides forward by 45°. This is to prevent the saw teeth from gripping the work-piece and projecting it towards the operator.

DANGER

Using the longitudinal guide (2) to avoid kickbacks during the transversal cut.

(4) = direction of piece feed

During cuts with the transversal guide (3), the front end of the longitudinal guide (2) must be positioned before the front end of the blade (1) or not in contact with the piece.

DANGER

never put the hands near the saw blade-engraver; always use a pusher.

The machine is supplied with a pusher (R) and with a knob (Q). The knob (Q) may be applied to pushers of different size, screwing it on with the screws provided.

Depending on the dimensions of the piece to be machined, select the most suitable type of pusher:

- A - Use for tall and narrow pieces.
- B - Use for short and narrow pieces.

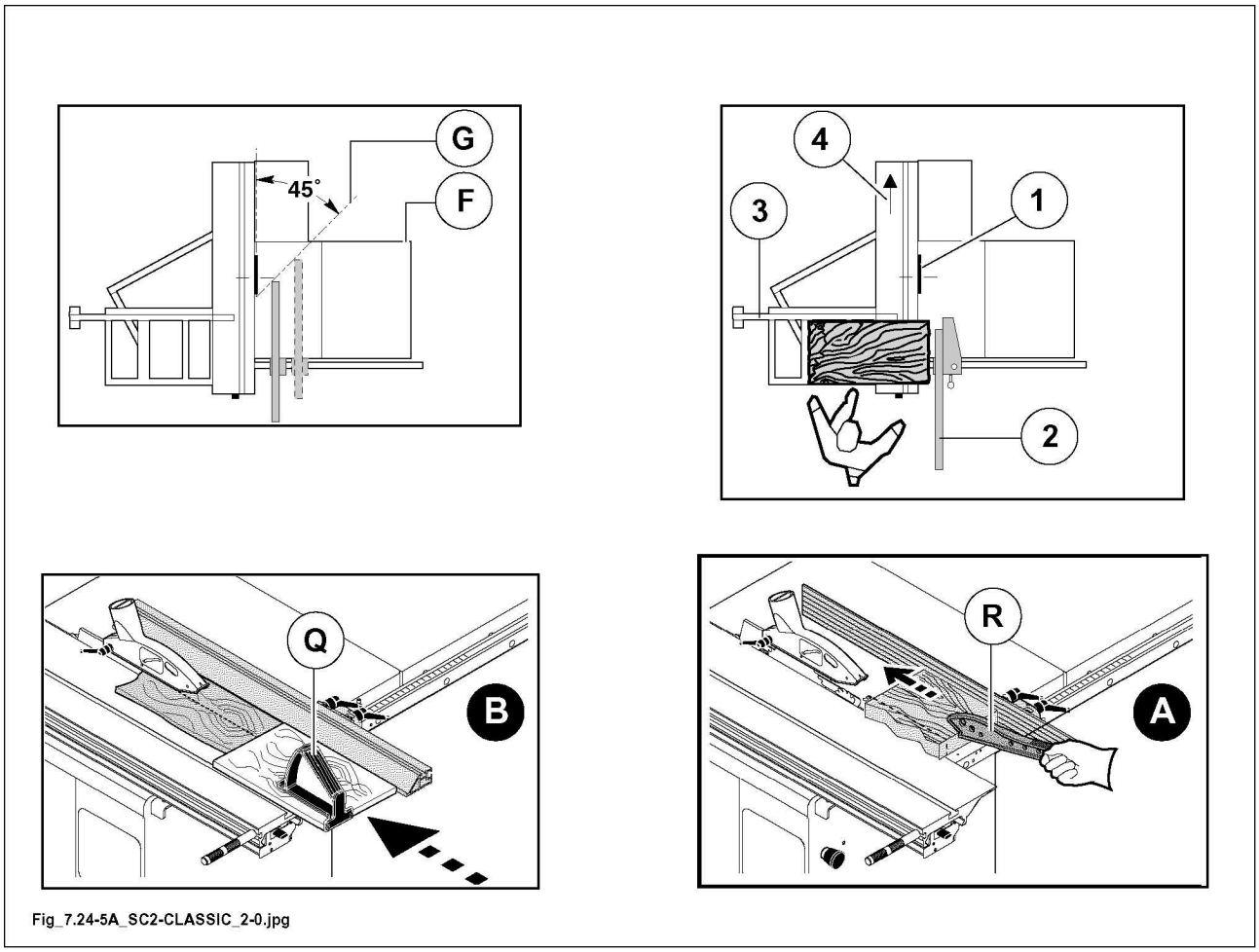


Fig_7.24-5A_SC2-CLASSIC_2-0.jpg

8.7 Rule adjusting for oblique cuts

- To make oblique cuts on the panels, unscrew the knob (L) to change the position on the rule (R).
- To use, position the rule referring to the plate (P) and tighten the knob (L).

NOTE

the ruler is fitted with an extractable telescopic extension (H), which may be lengthened as required after loosening the knob (G).

When the chip guard (M) is worn, bring it up to the saw blade by loosening the grub screw (N).

STD

When the splinter guard (M) is worn, bring it up against the saw blade by loosening the two screws (N). The telescopic rule is supplied with the stops (B). These can be positioned quickly for resting or pushing machining, by removing them from the rule and reassembling them on the opposite side.

OPT

When the chip guard (M) is worn, bring it up to the saw blade by loosening the grub screw (N). The telescopic rule is supplied with the stops (B). They can quickly be positioned for resting or pushing machining by simply tipping them over.

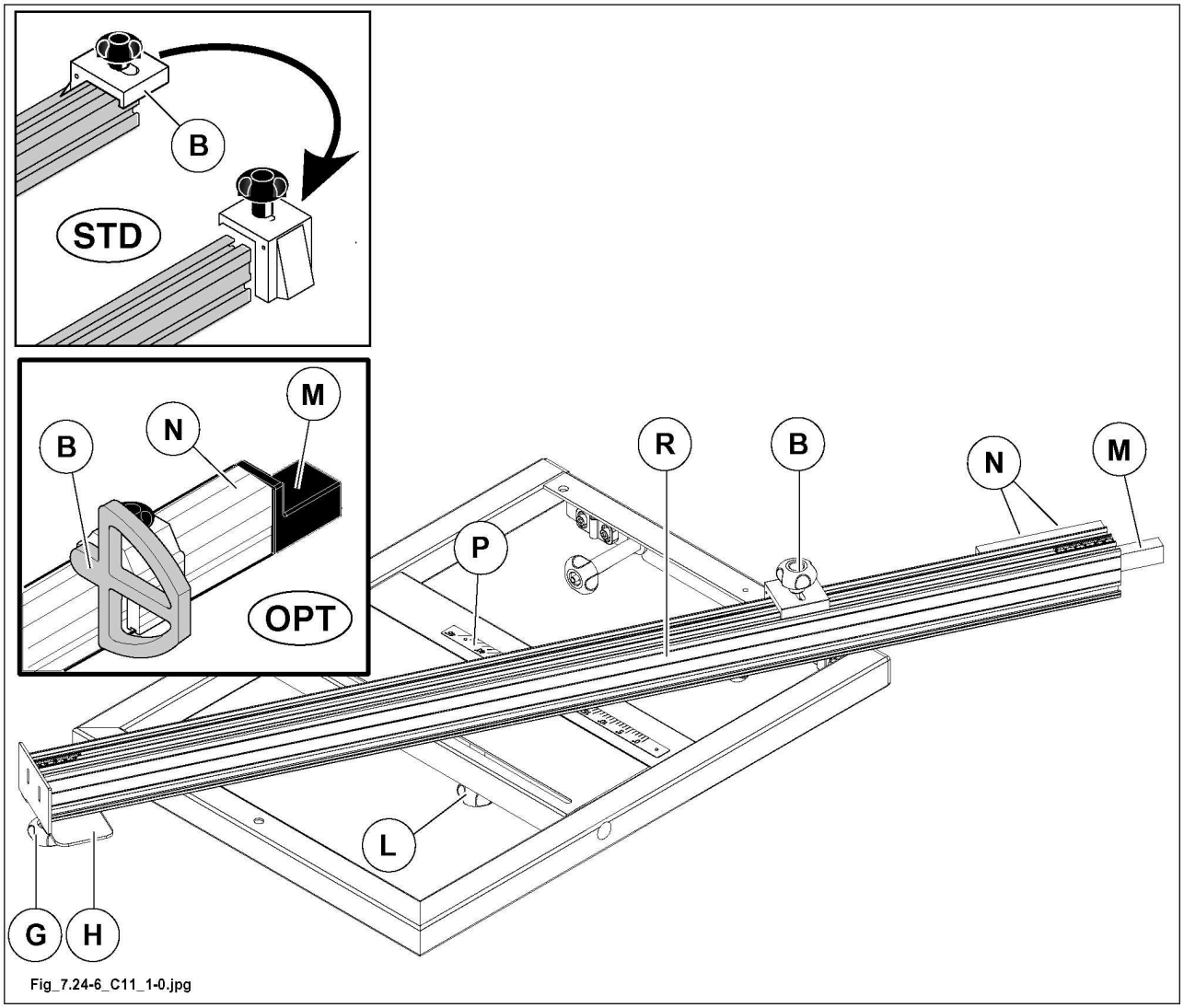
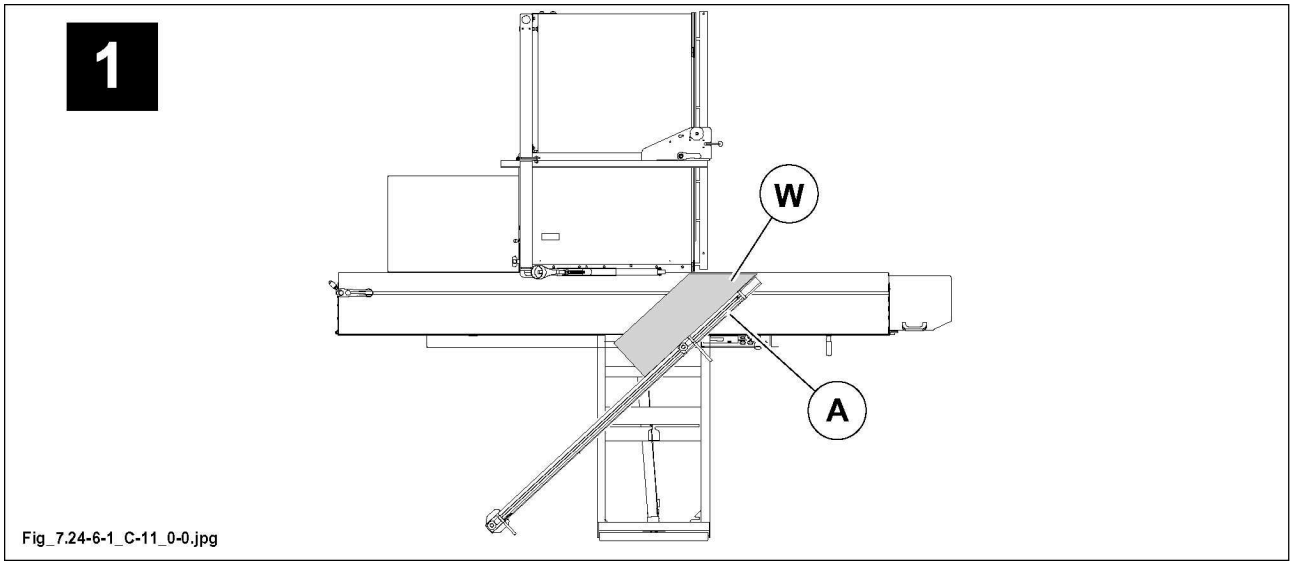


Fig_7.24-6_C11_1-0.jpg

8.7.1 Example of rule positioning for oblique cuts

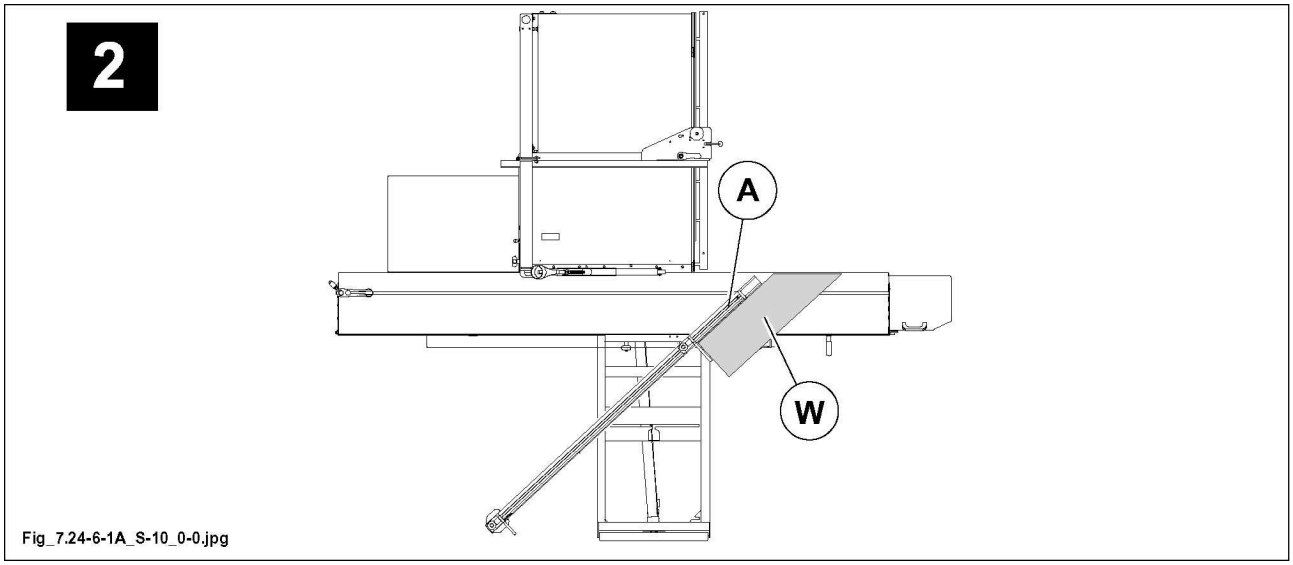
Cutting position **1** : the panel (W) is pushed by the rule (A)

•



Cutting position **2** : the panel (W) is against the rule (A)

•



8.8 Additional rule for oblique cuts with millimeter rule OPT

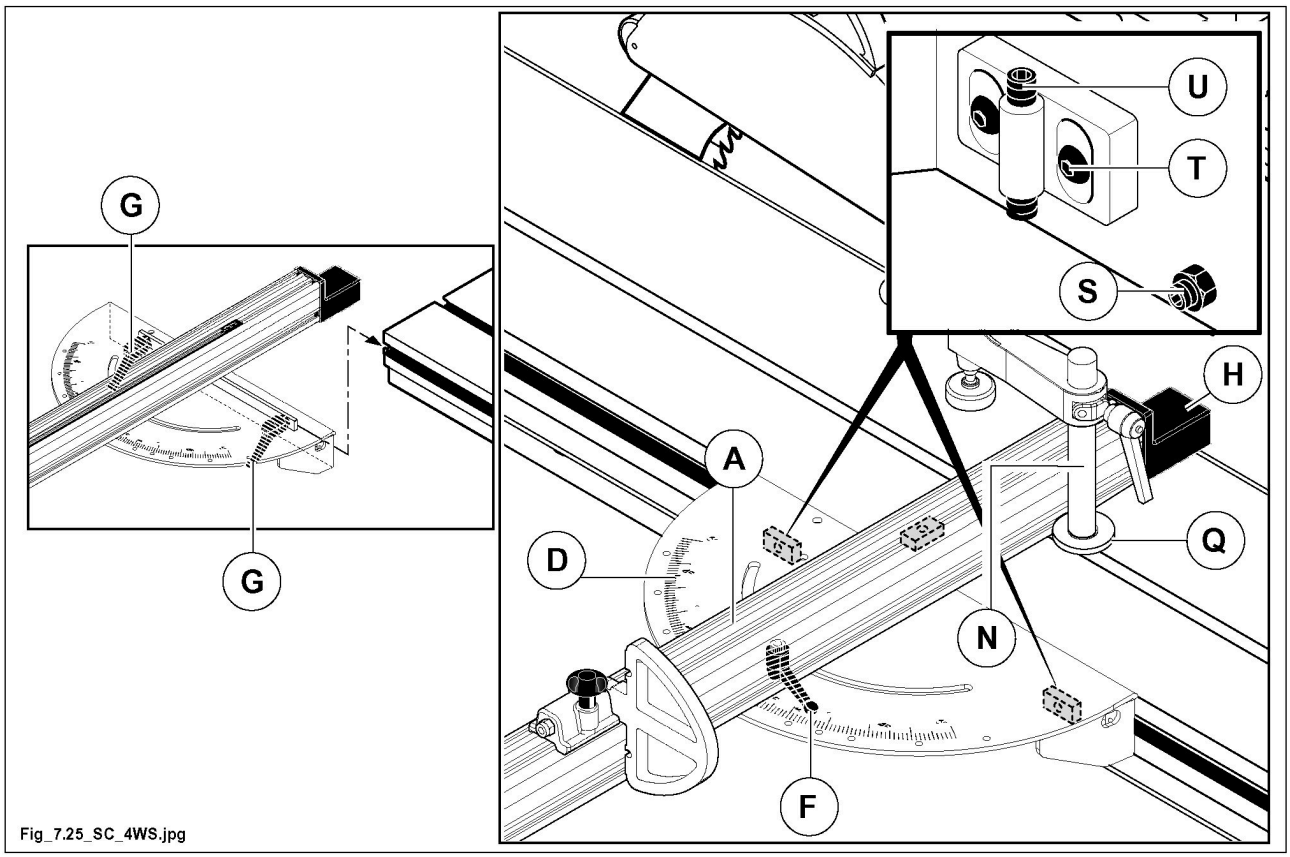
NOTE
available as standard "STD" on the "COMPACT" version.

1. Release the rule unit by turning (counterclockwise) the column (N);
2. loosen the handle (F);
3. position the rule unit at the correct distance from the saw blade;
4. to make angular cuts turn the ruler assembly (A) using index (D) as a reference;
5. block by tightening the handle (F);
6. position the presser up against the ruler assembly ensuring that the washer Q is inserted into the groove;
7. block the rule unit by turning (clockwise) the column (N).

The table is already registered; to make further adjustments proceed as follows:

- loosen the levers (G);
- use the grub screws (S) to adjust the parallelism to the sliding table;
- loosen the screws (T) and use the grub screws (U) to adjust the height.

NOTE
when the splinter guard (H) is worn, move it after having loosened the fixing screws.



9 Wood pusher

9.1 Wood pusher..... 142

9.1 Wood pusher

DANGER

When for the execution of a peculiar working, the operator is obliged to put his hands near the tools, for safety reasons a proper pusher shall be used to move the workpiece forwards, to push it against the fence or to remove it after the cutting.

Use the pusher (H) supplied, or:
handle (A) is supplied for this purpose and can be applied to pushers (D) of different size by means of screws (B and C).

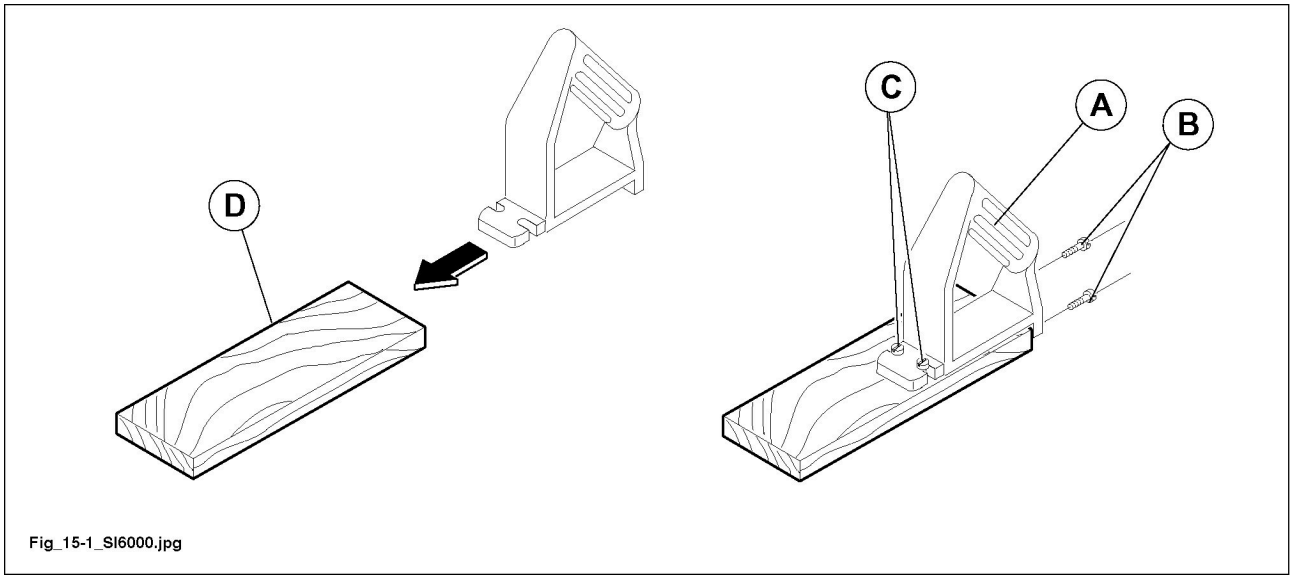


Fig_15-1_SI6000.jpg

Using a powerful dust aspirator unit clean:

- the pusher (H).
- The handle (A).

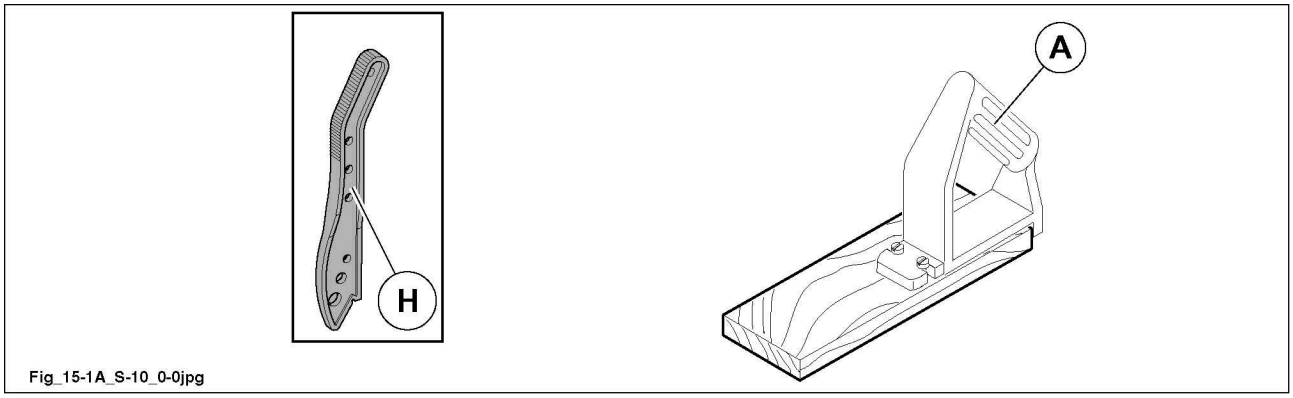


Fig_15-1A_S-10_0-0jpg

NOTE

in case of loss or breakage of the devices contact the manufacturer's SERVICE (Par. "Technical support").

10 Readers or displays

10.1 V2SC....144
10.1.1 General....144
10.1.2 Technical data....144
10.1.3 Instructions for the operator....145
10.1.4 Messages on the V2SC display....146
10.1.5 For skilled operators authorized by SCM....146

10.1 V2SC

OPT

10.1.1 General

- Magnetic sensor directly fitted.
- Display LCD.
- Measure setting by means of keyboard.
- mm / inch / degree conversion.
- Programmable counting reverse.
- Signaling on the display: battery is down.
- Error message: max. distance between sensor and band surpassed.
- Hardware inibition to protect the fixed data you have entered.

10.1.2 Technical data

TECHNICAL DATA			
Battery power supply (type LR 14)	1.5	Vdc	
Maximum sensor speed	5	m/sec	
Max. distance sensor-band	2	mm	
Tool precision	+/- 0.1	mm	
Operating temperature	0 / + 50	° C	

NOTE
the maximum distance allowed between the sensor and the magnetic band is 2.0 mm along the whole stroke. A greater distance would lead to an incorrect reading by the display.

10.1.3 Instructions for the operator

A) To recall the pre-set measure:

- press ENTER and SET simultaneously.

B) Absolute / incremental mode selection:

- press ABS INCR to select incremental mode.
- The display is reset automatically and the ◀◀◀ symbol appears.
- Press ABS INCR again to return to absolute mode.

NOTE
in incremental mode the display does not carry out the zero setting.

C) To modify the pre-set measure:

- press ENTER and ABS INCR at the same time for 3 seconds.
- **rES** appears on the display.
- Press ENTER until the message **rEF** appears

and then a number that matches the Preset value set (see point 5 of Par. " Installation of the saw guide unit with micrometric adjustment").

- Press ABS INCR to modify the value (if necessary).
- Press SET to shift one decade to the right.
- Press to confirm ENTER.
- To exit press ENTER repeatedly.

D) Fence position selection:

- press ENTER to select the position of the rule:
- Alternatively, the symbol ⌊ or ⌋ appears on the display.
- The display shows the updated measurement.

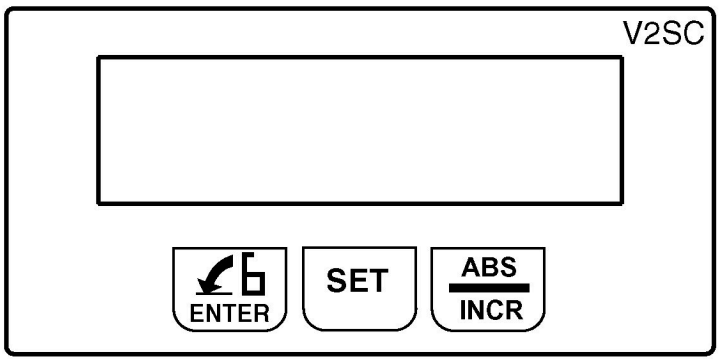


Fig_16-3_SC_31_CE_CLA.jpg

10.1.4 Messages on the V2SC display

1. NO TAPE..... indicates that the distance between reading sensor and magnetic band is too large or the sensor cable is broken.
   To reset move the sensor close to the band or replace the reader.
2. The ▭ symbol indicates the battery is low.
   To reset replace the battery.
3. Flashing numerical values: indicates a temporary detachment of the sensor from the band. Move the sensor close to the band, move the guide to “0” and reset the display.

NOTE
The internal parameters are not lost when the battery is removed.

10.1.5 For skilled operators authorized by SCM

Programming the parameters in the internal memory

To access the internal display memory press ENTER and ABS/INCR simultaneously for approximately 3 seconds.

A) The following is displayed:

- **rES**
  and then a number corresponding to the reader resolution type.
- Press ABS/INCR to modify the resolution (if necessary):
  0.1 = resolution in mm
  0.001 = resolution in inches
  FrEE = resolution for angular measuring.
- Press to confirm ENTER.

B) On the display you see:

- **corFAc**
  and then a number (1.00000) set at factory corresponding to the factor for multiplying the sensor pulses.
- Press ABS/INCR to modify the factor (if necessary).
- Press SET to shift one decade to the right.
- Press to confirm ENTER.

C) The following is displayed:

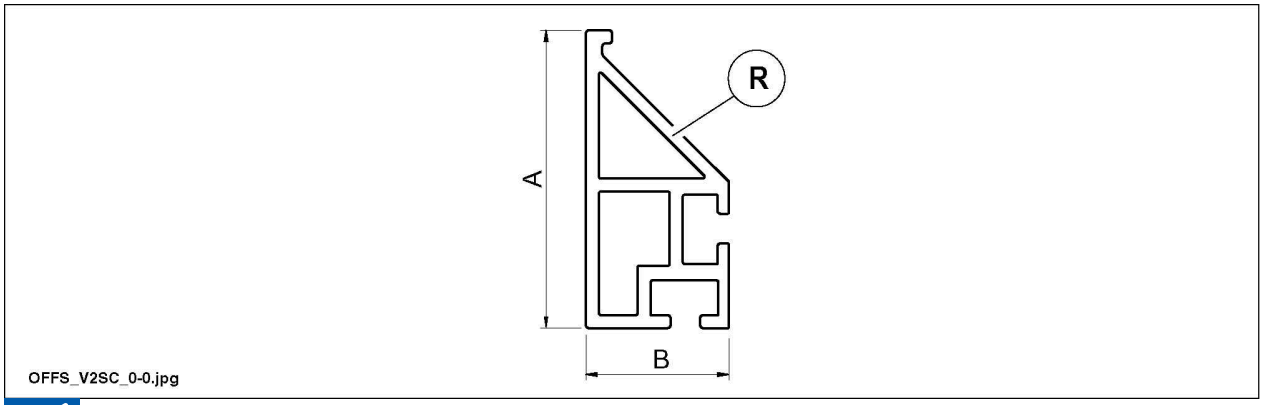
- **rEF**

  and then a number that matches the Preset value set (see point **5** of Par. " Installation of the saw guide unit with micrometric adjustment").
- Press ABS INCR to modify the value (if necessary).
- Press SET to shift one decade to the right.
- Press to confirm ENTER.

The following appears on the display:

- **OFFS**

  and, then, a number set in the factory, corresponding to the difference between (A-B) the two sides of the fence.



SPECIALISED PERSONNEL

if the line(R) is replaced with a new line, the new quotas (A and B) must be measured and the difference (A - B) calculated. The number found is the new "OFFS" factor to enter, preceded by the "minus" sign (e.g. --0047.0), as indicated below.

Selecting the position of the rule:

- press ENTER to select the position of the rule;

  The symbol ⌊ must appear on the display.
- Press ABS INCR to modify the factor (if necessary).
- Press SET to shift one decade to the right.
- Press to confirm ENTER.

NOTE

at this point check whether the electronic reader has been calibrated correctly.

Proceed as indicated below

With reference to SIDE - **1** - of the figure,

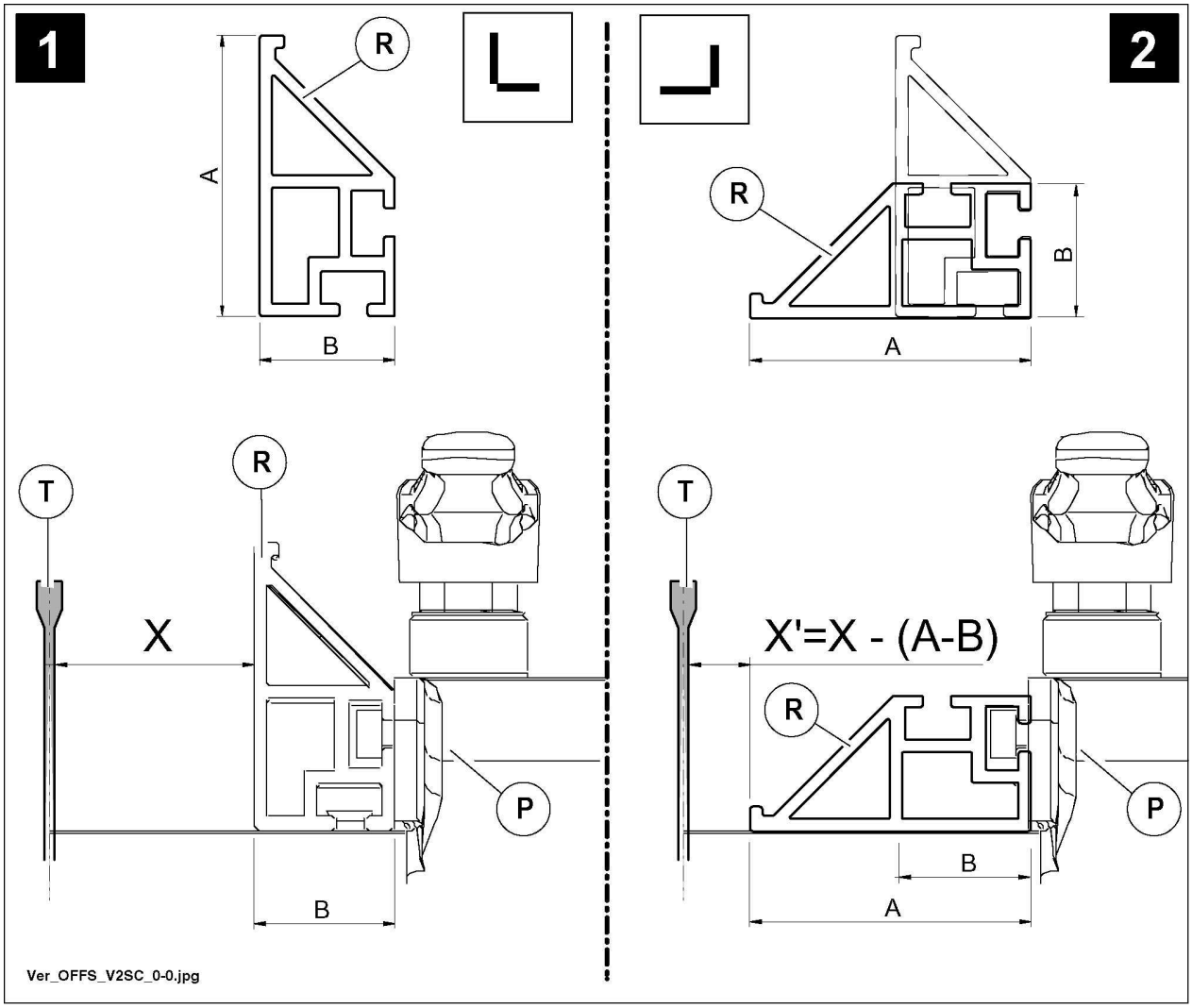
- press ENTER to select the position of the rule (R). The symbol ⌊ must appear on the display.
- Move the parallel guide (P) towards the saw blade (T) at the limit switch position.
- Read on the display the distance X between the rule (R) and the saw blade (T).

With reference to SIDE - **2** - of the figure,

- with the parallel guide (P) in the limit switch position, towards the saw blade (T), press ENTER to select the position of the rule (R).
- The symbol ⌋ must appear on the display and the updated quota, with a value of: X' = X - (A - B).

Example:

  - quota: A = 150
  - quota: B = 60
  - reading measured: X = 300
  - reading displayed: X' = X - (A - B) = 300 - (150 - 60) = 210



NOTE

if the number displayed does not match the value X' = X - (A - B) enter the OFFS parameter again as indicated previously in point C).

D) On the display you see:

- **dir UP**
  or
- **dir dn**
  corresponding to the sensor counting direction appear on the display.



NOTE

move the guide away from the blade and check how the quota that appears on the display changes.

if the quota INCREASES the setting is correct.

If the quota DECREASES the count direction of the sensor must be changed, from "dir dn" to "dir UP" or vice versa.

- Press ABS INCR to modify the value (if necessary).
- To confirm and exit the parameter settings, press ENTER.

The last measure displayed appears on the display.

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11.1 Machine Cleaning

DANGER

All cleaning operations are to be carried out by the machine operator or by skilled technician.

DANGER

OPT

In the switches with electronic brake, even with the motor stopped, the motor is not galvanically disconnected from the mains. The switch supplies the motor with voltage even after it is switched off.

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug (S).

DANGER

Use gloves when handling the tools.

PROHIBITED

DO NOT USE COMPRESSED AIR; by blowing with a strong air jet (see figure) chips,dust and dirt of any type may enter into the moving members, so the machine is no more efficient.:

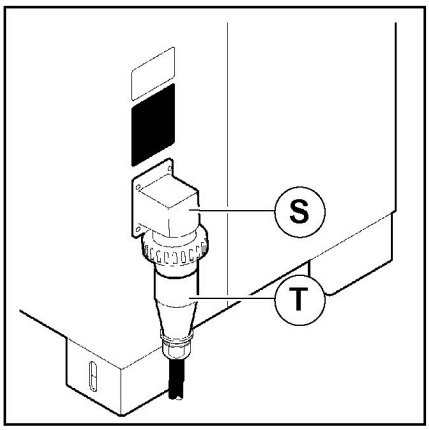




Fig_20-1_LAB_300_PLUS.jpg

The general cleaning of the machine maintains its performance unchanged over time and represents an important safety factor.

NOTE

The frequency of cleaning interventions is determined by the room in which the machine is installed and by the machined material.



Fig_20-1A_SI6000.jpg

Rules for the correct cleaning of the machine

DANGER

ensure that the fixing devices of the safety protections are kept clean and perfectly efficient in order to guarantee their correct assembly. Ensure that the fixing holes are clean, especially the blind threaded holes on the horizontal surfaces, that are more prone to fill with shavings and dust.

Using a powerful dust aspirator unit clean:

- the tables and all cavities where you see chips and dust.
- Suction hoods (T) by checking that the are no occlusions.
- With the carriage in position 1 (at infeed), then in position 2 (at outfeed), clean the lower guides and, in particular, the points indicated by the arrows (H), to a depth of 15 cm.
- Squaring frame guides (A).
- Width guide bar (L).
- Carriage and rail sliding guides (S) and (B).
- Groove (C), tile-shaped stop and presser with a brush or cloth drunken with not dangerous solvent.

Then by using a cloth or a brush drunken with a proper and not dangerous product,

Clean all moving parts specially the ones exposed to the resin and dust.

DANGER

Do not oil, do not grease:

- **carriage and rail sliding guides (S) and (B).**

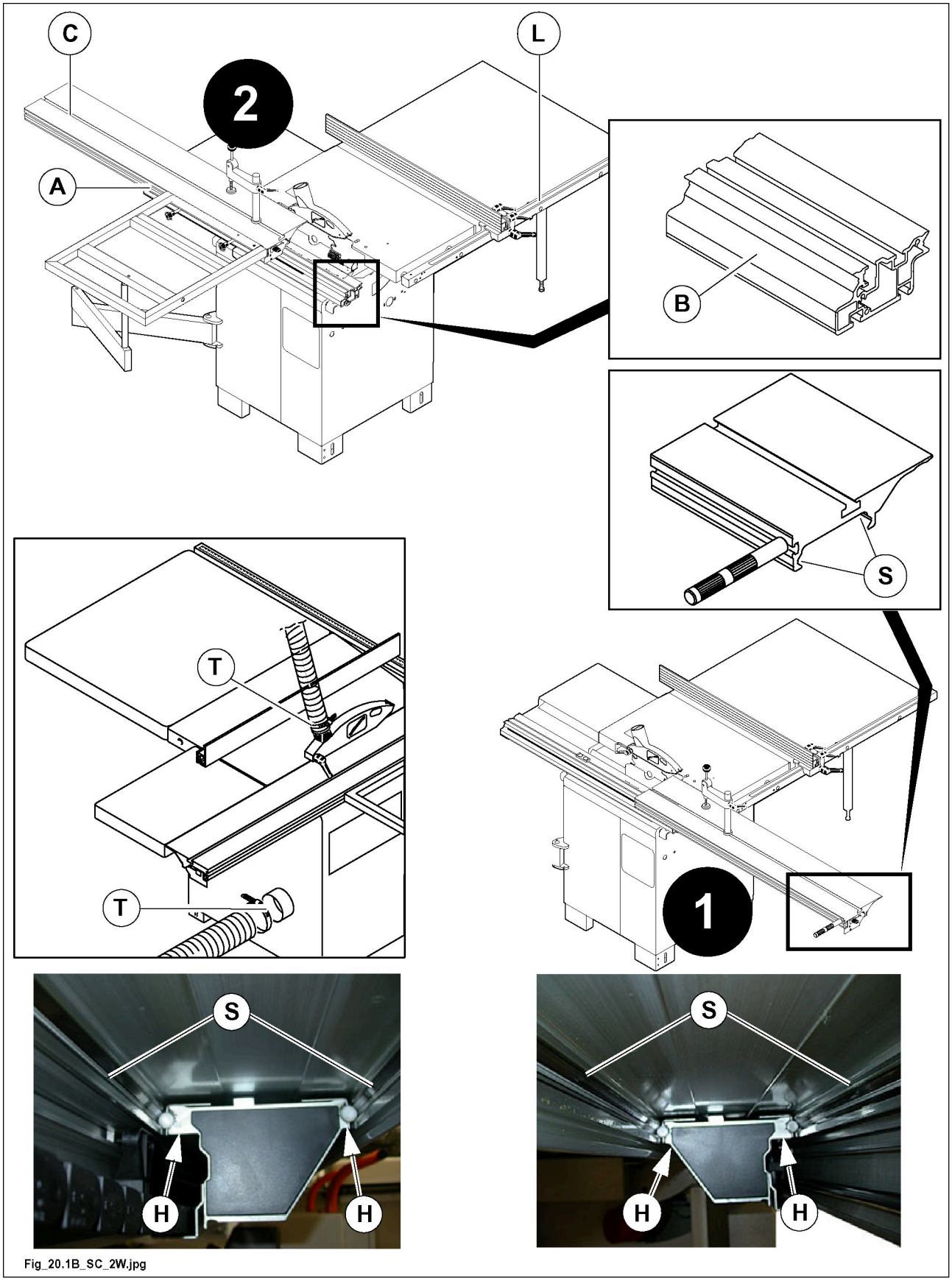


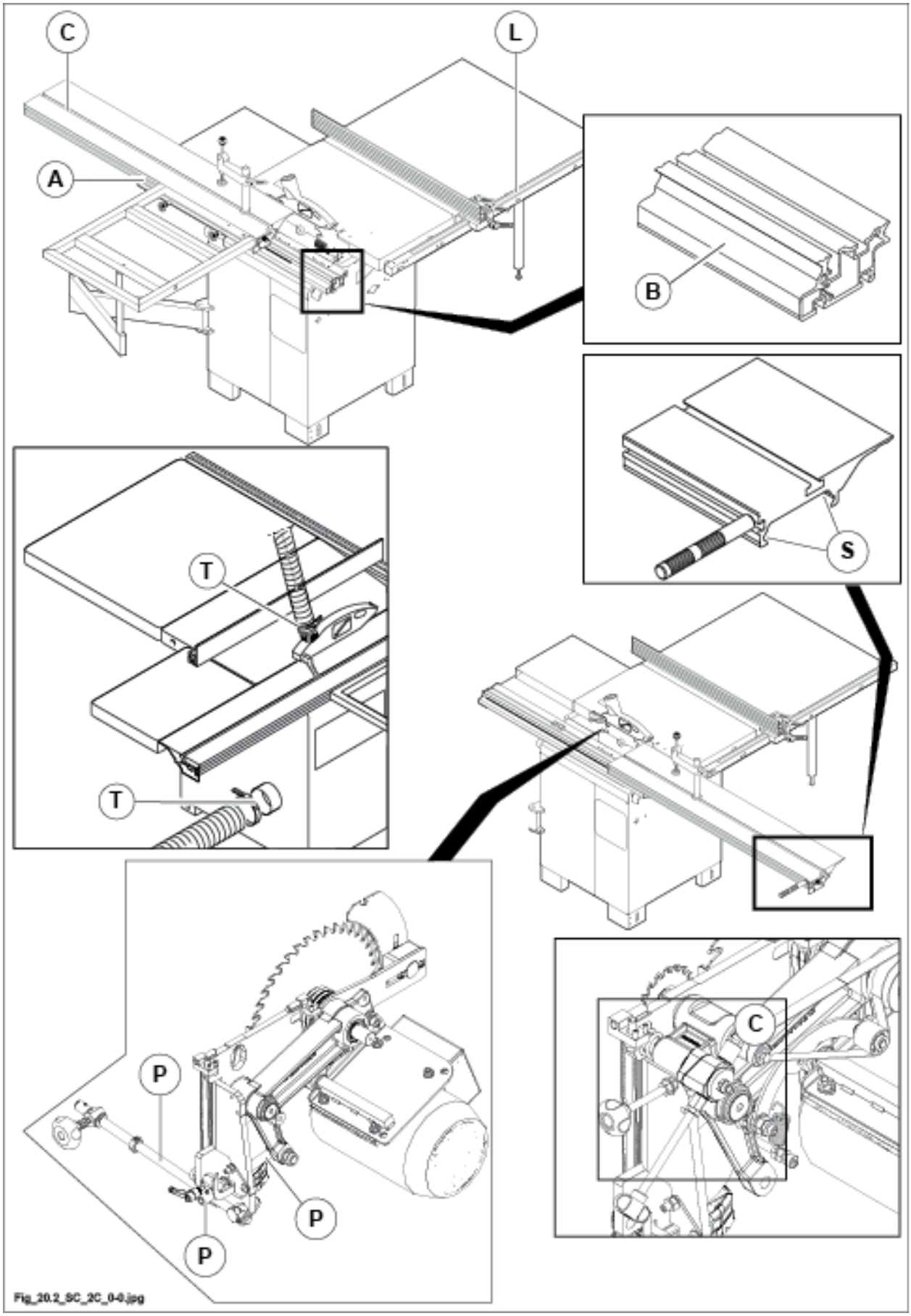
Fig_20.1B_SC_2W.jpg

11.2 PROGRAMMED MAINTENANCE

Regular maintenance is essential for achieving the best performance and safe operation.

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
General machine cleaning	Visual inspection	Daily	• Use an aspirator to remove dust or shavings (see Par. " Machine Cleaning").
Carriage sliding guides (S)	Visual inspection	Weekly	• Use an aspirator to remove dust or shavings (see Par. " Machine Cleaning"). • Clean with a cloth or brush soaked in a suitable product which is not dangerous. • **Do not oil or grease.**
Squaring frame guides (A)	Visual inspection	Daily	• Use an aspirator to remove dust or shavings (see Par. " Machine Cleaning"). • Clean with a cloth or brush soaked in a suitable product which is not dangerous
The sliding guides (B) of the rail	Visual inspection	Weekly	• Use an aspirator to remove dust or shavings (see Par. " Machine Cleaning"). • Clean with a cloth or brush soaked in a suitable product which is not dangerous. • **Do not oil or grease.**
Extractor hoods cleaning (T)	Visual inspection	Weekly	• Disconnect the flexible tubes from suction hoods, check that there are no occlusions and clean by sucking.
Width guide bar (L)	Visual inspection	Daily	• Use an aspirator to remove dust or shavings (see Par. " Machine Cleaning"). • Clean with a cloth or brush soaked in a suitable product which is not dangerous.
Scoring unit mechanisms (C) OPT	Visual inspection	Every 2 weeks	Remove any dust using an aspirator and grease (see Par. " Lubrication").
Lifting and tilting screws (P)	Visual inspection	Weekly	• grease (see Par. " Lubrication").
Saw transmission belts	Check tensioning and wear	Weekly	• Tension correctly (see Par. " Belt stretching") or replace if necessary (see par. " Replacing the belts").

DESCRIPTION	INSPECTION	FREQUENCY	ACTION
Scoring saw transmission belts OPT	Check tensioning and wear	Weekly	• Tension correctly (see Par. " Belt stretching") or replace if necessary (see par. " Replacing the belts").
Safety and emergency devices (see Chap."Safety and emergency stop devices")	Visual check and check operation	Every 2 weeks	• Perform stop tests (see Par. " Safety devices check").
Safety circuit	20 years		Contact the manufacturer


C
L
A
B
S
T
T
P
P
P
C
Fig_20.2_SC_2C_0-0.jpg

11.3 Lubrication

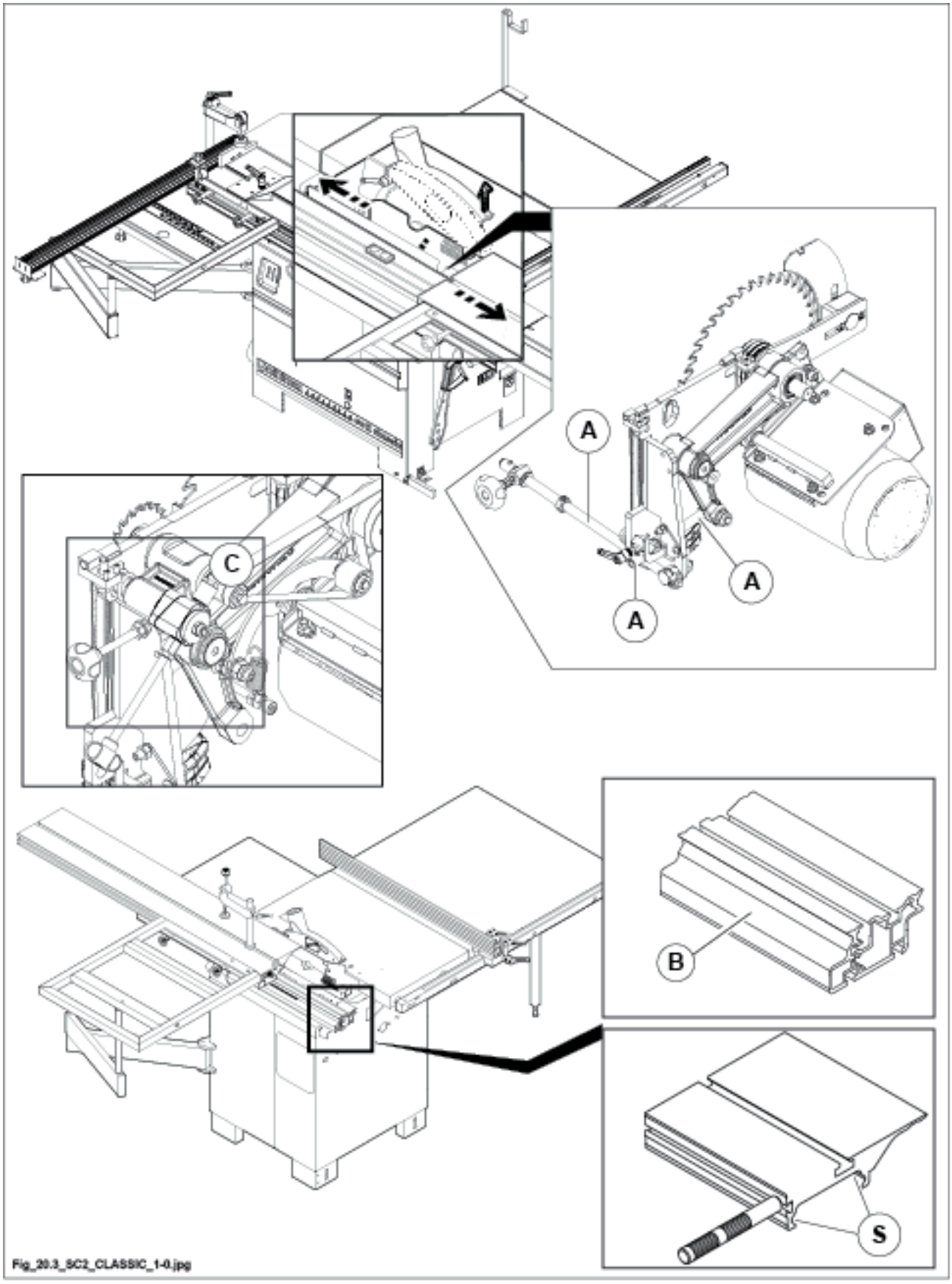
Correct lubrication will extend the machine life and ensures better performance.
Each week, lubricated with type of grease:
1. Tilting and lifting screws (A).
2. Engraver mechanisms (C) OPT .

DANGER

Do not oil, do not grease:
- **carriage and rail sliding guides (S) and (B).**

NOTE
- As all bearings are sealed and lubricated-for life, they do not require any maintenance;
- for replacement, request these bearings directly from our Spare Parts Office.
- bearings of other brands, with corresponding abbreviations, are NOT suitable for use.

NOTE
- Protect all belts and pulleys to avoid contamination with oil.


A
A
A
C
B
S
Fig_20.3_SC2_CLASSIC_1-0.jpg

11.4 Safety devices check

The machine is equipped with safety devices described in Chapter "Safety and emergency stop devices" which ensure the safe machine operation.

Every 2 weeks check the controls for emergency stops with a test.

With the machine under normal operating conditions press the emergency buttons arranged on the machine one at a time.

The motor shall stop.

Every 2 weeks check that micro switches on the bottom saw blade guard:

with open guard, the saw motor shall not start.

NOTE

- The belt slackening may cause an increase of the braking time, therefore make sure that the belts are tensioned and in good conditions (see par." Belt stretching" Or)(maximum" Replacing the belts")(maximum stop time 10s).

Regularly check the efficiency of the guards and the good state of the plates, especially those with a yellow background.

DANGER

The responsible technician is to be informed about eventual troubles during the test; in that case he shall shut off the machine and apply to SCM Technical Service of dealer.

Every 20 years, it is mandatory to review the integrity of the safety circuit by contacting the manufacturer.

11.4.1 Spare parts that affect the operator's health and safety

The previous section "Checking safety devices" “ ” indicates the operations that the user must carry out and their frequency. These operations are designed to identify any failures in the machine’s safety systems.

NOTE

If a failure is found the user must contact the technical support centre authorised by SCM.

PROHIBITED

never attempt any work on the devices unless otherwise indicated in this manual

The SCM's technical support centre will identify which component of the safety system that must be replaced and will replace it (or provide instructions on how to proceed).

NOTE

the user (or one of his specialised technicians) is authorised to carry out only the interventions described in this instructions manual.

DANGER

for every maintenance intervention USE ONLY ORIGINAL SPARE PARTS provided by SCM (manufacturer).

The manufacturer will not be responsible for any damages due to the use of non-original spare parts.

NOTE

the entire electrical/electronic system of the machine is functional to the machine's safety.

The user is therefore NOT AUTHORISED to perform any repair/replacement intervention of electrical and electronic components, apart from any indicated in this manual.

DANGER

The user must comply with the replacement intervals of the various safety devices, by contacting the SCM technical support service to identify the correct spare part and installation (unless indicated otherwise in this manual).

SPARE PARTS THAT CAN BE INSTALLED BY THE USER

NOTE

in the spare parts catalogue the letter "C" indicates the codes of spare parts which affect operator health and safety.

These spare parts can be installed by expert personnel instructed by the user.

DANGER

for all other spare parts contact the SERVICE of the Manufacturer's Dealer/Agent or contact the Manufacturer's SERVICE directly.

11.5 Replacing the belts

DANGER

check the belt tension after the first 10 hours of machine operation.

Do not overstretch the belts not to overload the bearings.

Excessive tension causes the belts to stretch, overheating and rapid destruction of the belts. At least once a week check the stop time of the saw blade; if the stop time exceeds 10 seconds tension or replace the belt (if it is ruined) as indicated in the paragraphs below.

After the adjustments have been made, check the stopping time again.

11.5.1 Saw blade spindle

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug (S);

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

DANGER

use proper gloves for handling the tools.

Remove the front guard (F) to access the belt and proceed as indicated below:

1. Remove the saw blade as indicated in par. "Fitting the saw blade" .
2. Completely lower the saw unit and tilt it to 45° (see chapter"Using and adjusting on the blade unit").
3. Loosen the screw (B).
4. Push the motor upwards and tighten the screw (B).
5. Proceed with the replacement of the belts.
6. Re-tighten the screw (B) and tighten the belts (see Par. " Belt stretching").
7. Tighten the screw (B).
8. Remove the saw blade as indicated in par. "Fitting the saw blade" .
9. Reassemble the front guard (F).

NOTE

If only one belt is wear, you have to replace all belts.

PROHIBITED

- Never pair belts of different makes;
- Never use a new belt and an old one, because in that case the new belt transmits the entire power by itself and so it is damaged in short time.

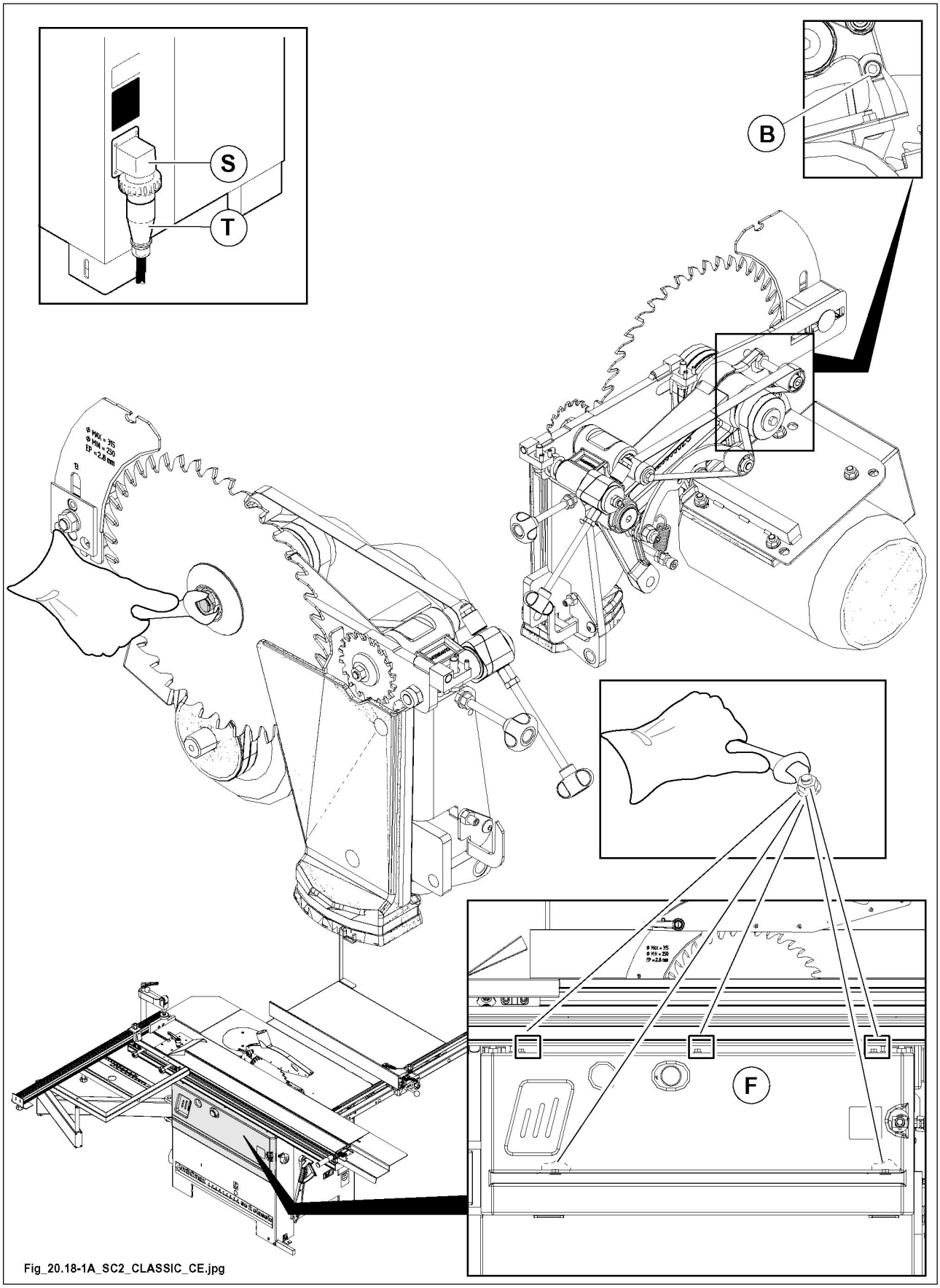


Fig_20.18-1A_SC2_CLASSIC_CE.jpg

11.5.2 Scorer spindle

OPT

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug S;

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

DANGER

use proper gloves for handling the tools.

Remove the front guard (F) to access the belt and proceed as indicated below:

1. Remove the saw blade as indicated in par. "Fitting the saw blade" .
2. Completely lower the saw unit and tilt it to 45° (see chapter"Using and adjusting on the blade unit").
3. Loosen the belt tensioner (E) and remove the belt; assemble the new belt in the same way and turn it manually, making sure that it is positioned in the centre of the pulleys.
4. Remove the saw blade as indicated in par. "Fitting the saw blade" .
5. Reassemble the front guard (F).

NOTE

The correct engraver belt tension is assured by the spring (G) and it does not require any adjustment.

NOTE

the scorer belt remains always stretched by the motor weight.

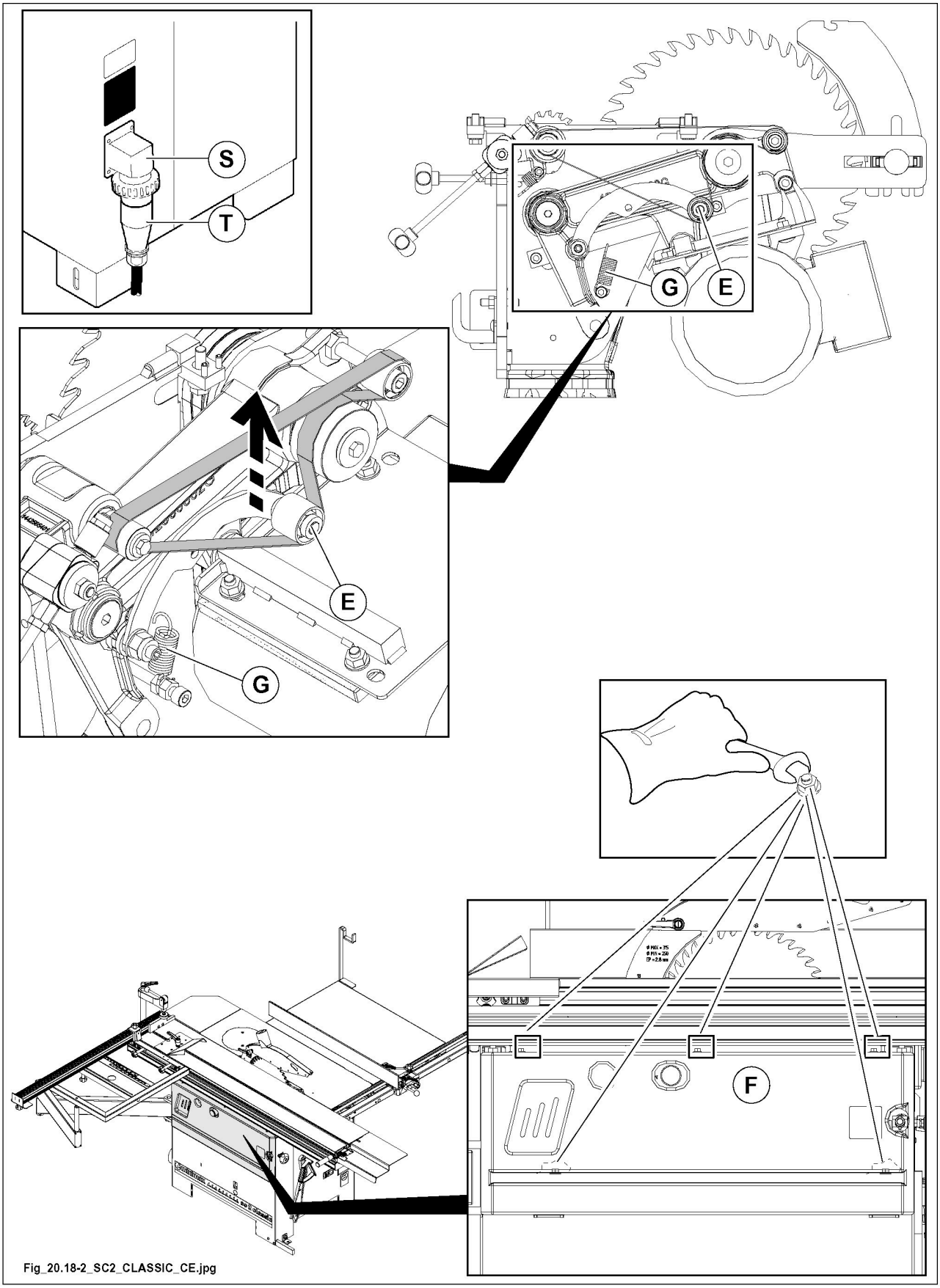


Fig_20.18-2_SC2_CLASSIC_CE.jpg

11.6 Belt stretching

DANGER

check the belt tension after the first 10 hours of machine operation.

Do not overstretch the belts not to overload the bearings.

Excessive tension causes the belts to stretch, overheating and rapid destruction of the belts. At least once a week check the stop time of the saw blade; if the stop time exceeds 10 seconds tension or replace the belt (if it is ruined) as indicated in the paragraphs below.

After the adjustments have been made, check the stopping time again.

11.6.1 Saw blade spindle

DANGER

before performing any operation, cut off the electrical supply and disconnect the power supply cable (socket T) from the plug (S);

DANGER

WAIT UNTIL THE SAW BLADES ARE STILL.

DANGER

use proper gloves for handling the tools.

Remove the front guard (F) to access the belt and proceed as indicated below:

1. Remove the saw blade as indicated in par. "Fitting the saw blade" .
2. Completely lower the saw unit and tilt it to 45° (see chapter"Using and adjusting on the blade unit").
3. Loosen the screw (B).
4. Push the motor downwards and tighten the screw (B).
5. Remove the saw blade as indicated in par. "Fitting the saw blade" .
6. Reassemble the front guard (F).

DANGER

DO NOT use the machine without the required guards for every machining process or removing part of the guards.

NOTICE

excessive belt tightening will cause both functioning failures and early belt wear. By exerting a force **P** in the middle of a belt, the latter must have a yielding **f** as shown in the table.

Force P		Yielding f (mm)
N	Kp	
24 - 26	2.4 - 2.6	3 - 4

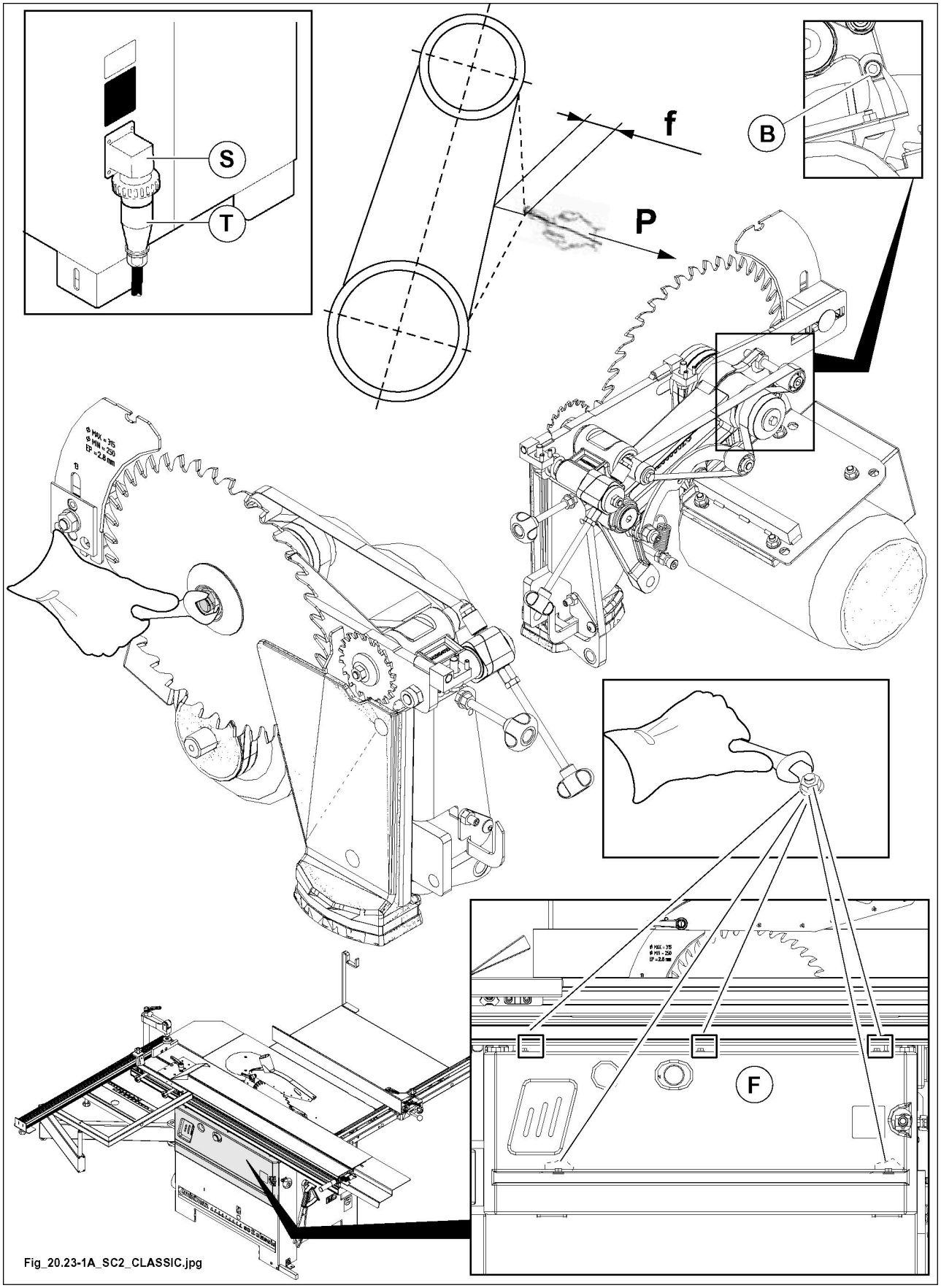


Fig_20.23-1A_SC2_CLASSIC.jpg

11.6.2 Scorer spindle

OPT

NOTE
the correct belt tension is assured by the spring (G) and it does not require any adjustment.

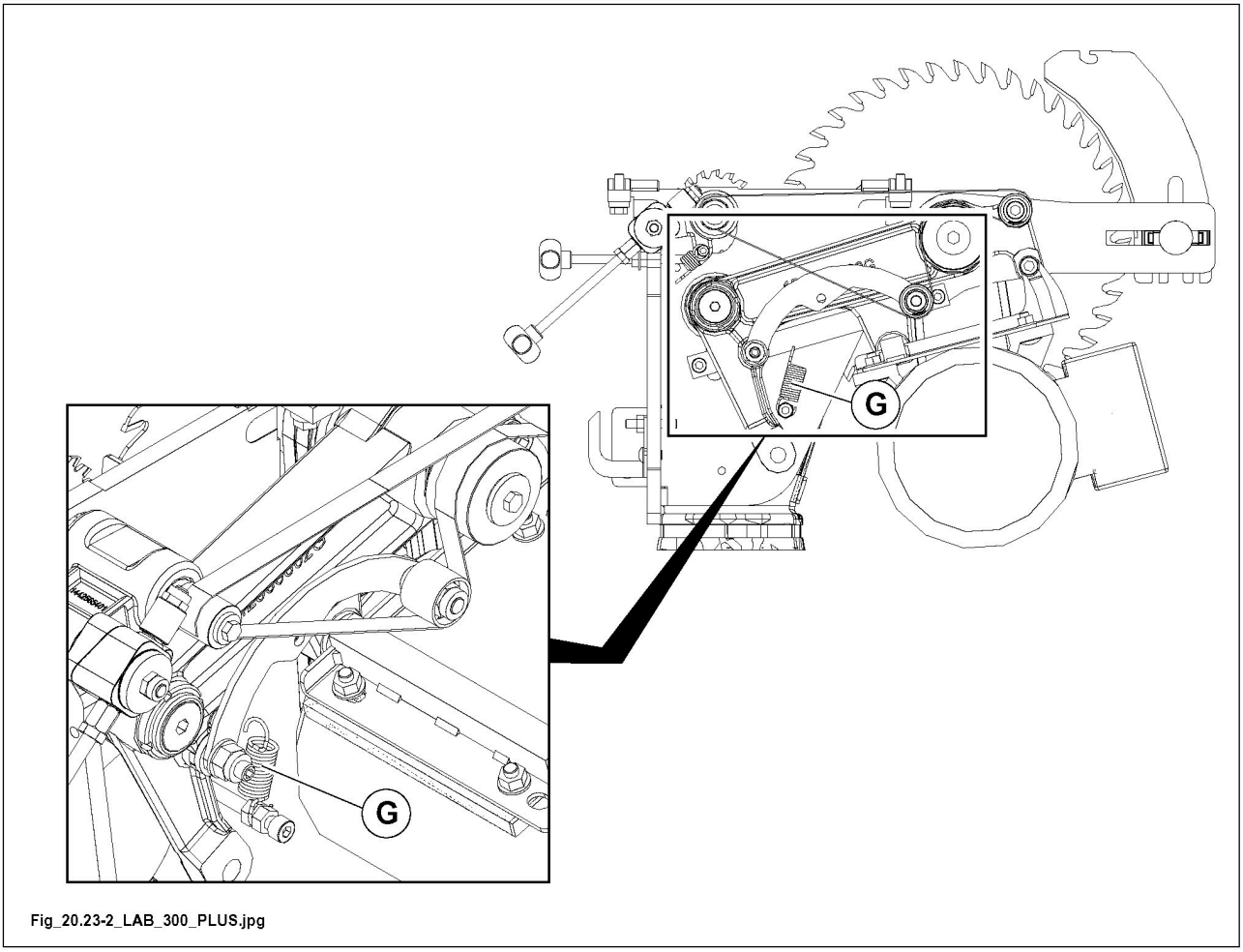


Fig_20.23-2_LAB_300_PLUS.jpg

11.7 Making the parts which get worn

11.7.1 Replacing the chip breaker

Rule for square cuts

If it is necessary to replace the wooden part (M), contact:

- to SCM dealer;
- or to SCM Spare Parts Department,

or reconstruct it using beech wood, by using the measurements shown in the figure.
To replace the worn splinter guard, unscrew the screws (X).
Reassemble the new splinter guard and tighten the screws (X).

NOTE
for the adjustments see sect. " Splinter guard adjustment"

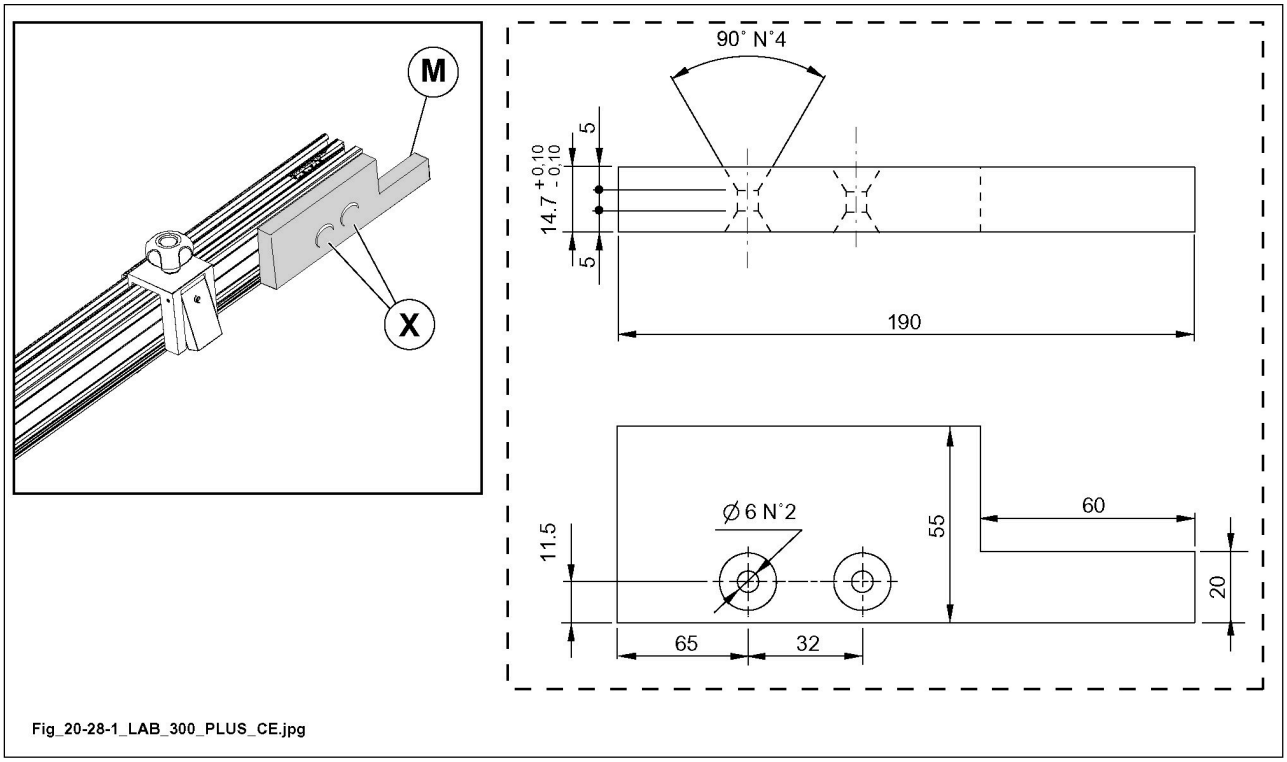


Fig_20-28-1_LAB_300_PLUS_CE.jpg

11.8 Problems - Causes - Solutions

This section indicates some solutions for problems that may arise while using the machine.
It is important to intervene only after having read everything related to the problem in detail, whether it is found in the following pages or in the rest of the manual.
In case of troubles not described here, contact the Technical Service SCM.

PROBLEM	CAUSES	REMEDIES
The machine does not start.	No electrical energy on one or more phases of the line.	Check that there is voltage in the three phases in the laboratory.
	The fuses of the auxiliary circuit are interrupted or the fuse block cover is open.	Close the fuse block cover (located inside electric cabinet). If the machine does not start: 1- Open the fuse block cover. 2- Check the integrity of fuse, if necessary, replace them.
	Emergency (E) on.	Switch off the emergency button by turning it.
	Electronic brake blocked	Disconnect the power supply to the machine to rest the function. If the problem remains, contact your Dealer SCM .
	Overload switch (A) triggered because: • excessive current absorption caused by improper machine use (work too heavy in relation to motor power) • cable too small for motor power (see electrical connection specifications chap." Electrical installation") • voltage drop caused by the excessive length of the power cable • short circuit in the electric system.	Resolve the problem, wait for the overload switch to cool down and start the machine again.
The machine stops during machining.	No electrical energy on one or more phases of the line.	Check that there is voltage in the three phases in the laboratory.
	The fuses of the auxiliary circuit are interrupted or the fuse block cover is open.	Close the fuse block cover (located inside electric cabinet). If the machine does not start: 1- Open the fuse block cover. 2- Check the integrity of fuse, if necessary, replace them.
	The saw motor belt is loose or ruined.	Tension the belt or change it following the instructions in paragraph " Belt stretching" or " Replacing the belts".
	Operation too demanding in relation to the motor power.	Wait for the cooling of the thermal cut out protection. Reactivate it after a few minutes.
The motor rotates but the saw blade stops when it is in contact with the piece.	The saw motor belt is loose or ruined.	Tension the belt or change it following the instructions in paragraph " Belt stretching" or " Replacing the belts".

PROBLEM	CAUSES	REMEDIES
The panel slides with difficulty during cutting (it is tight between the guide and the blade) or is not cut with the sides parallel.	The parallel cutting fence is badly positioned (this must be parallel with the blade with a slight opening exit of 0.10 mm).	Contact our technical service (see telephone number in "Technical support").
The rule does not position itself correctly at 90°.	The C-stops of the row are not adjusted correctly.	Use the screw G to adjust the stops until the rule is positioned correctly at 90° (see figure).

NOTE
in the "COMPACT" version the square frame and the telescopic aluminium rule with stops are not available.

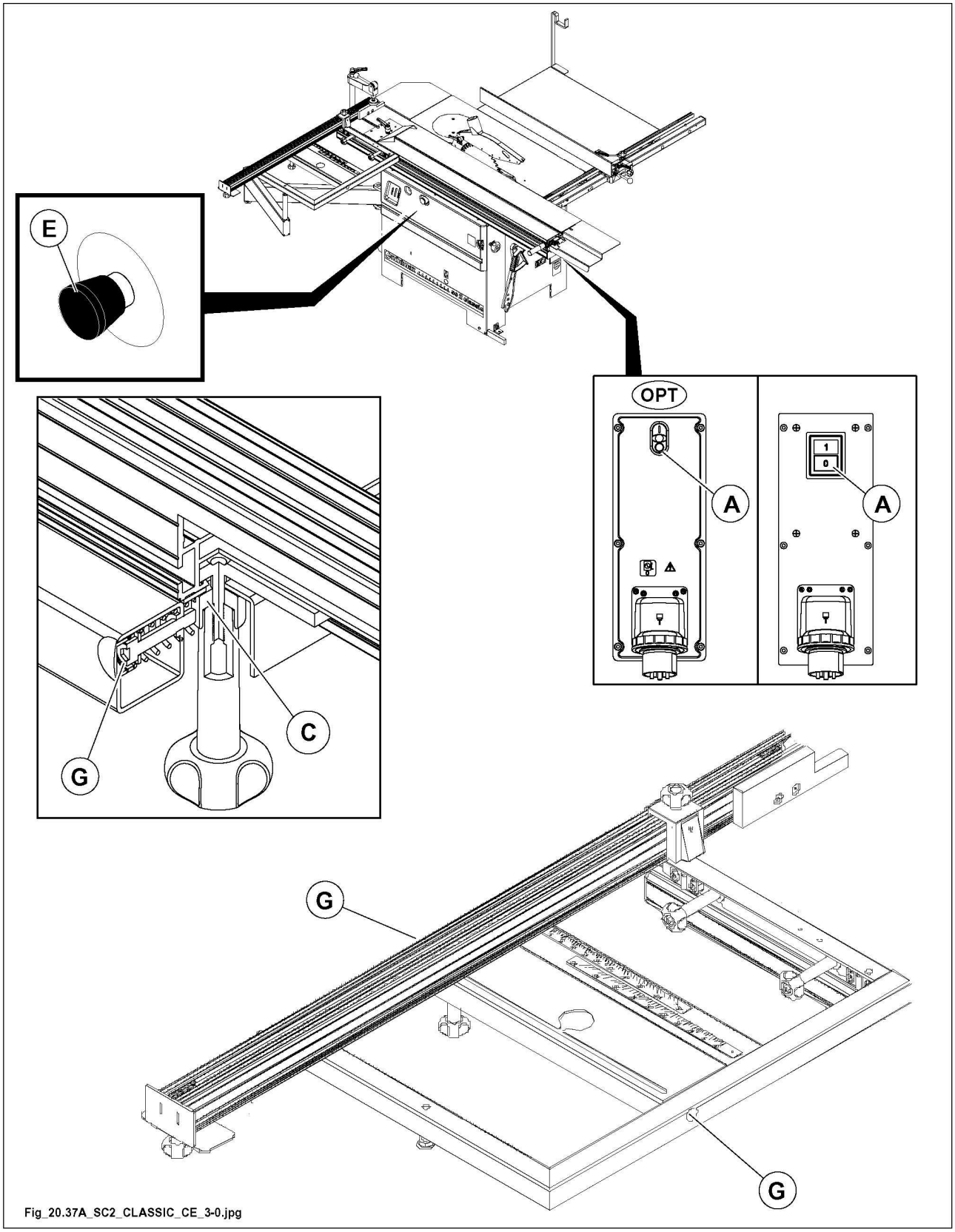


Fig_20.37A_SC2_CLASSIC_CE_3-0.jpg

11.9 Unscheduled maintenance

All operations not expressly listed in this manual, such as:

1. operations due to faults in the components or electric motors
2. interventions due to faults in the mechanical components

are considered as unscheduled maintenance operations.

Such operations require specific skills and must be performed by qualified personnel authorised by the machine manufacturer.

DANGER

never attempt to make repairs or makeshift replacements as this could cause serious dangers for exposed persons and for the machine.



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SC 2C

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