



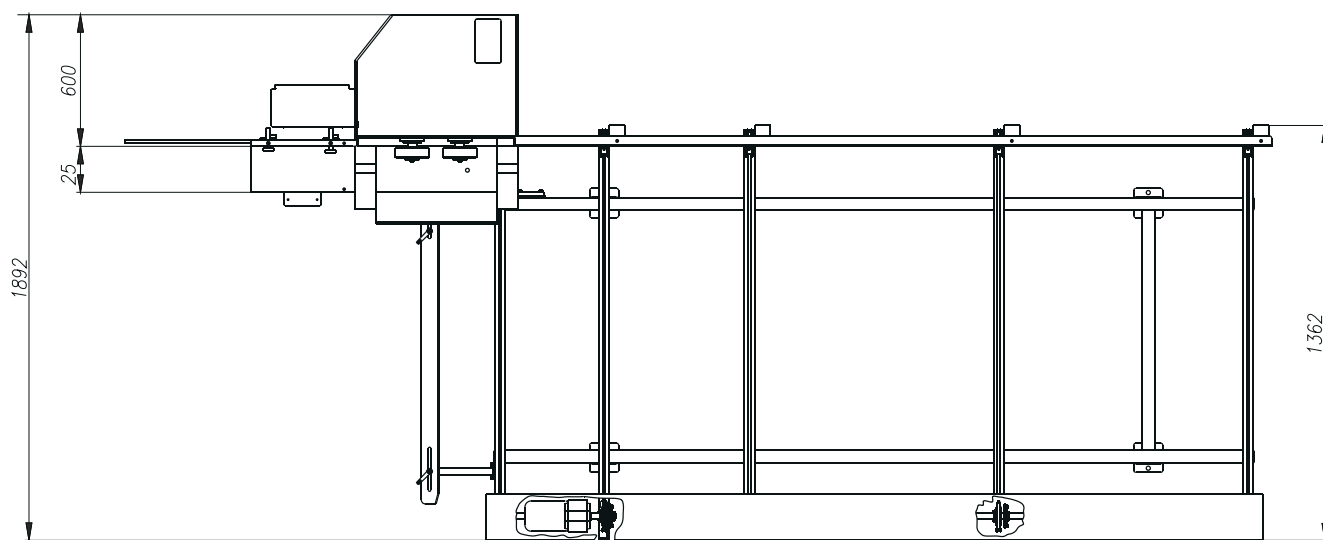
User Manual

 **FEED MASTER IF-80**

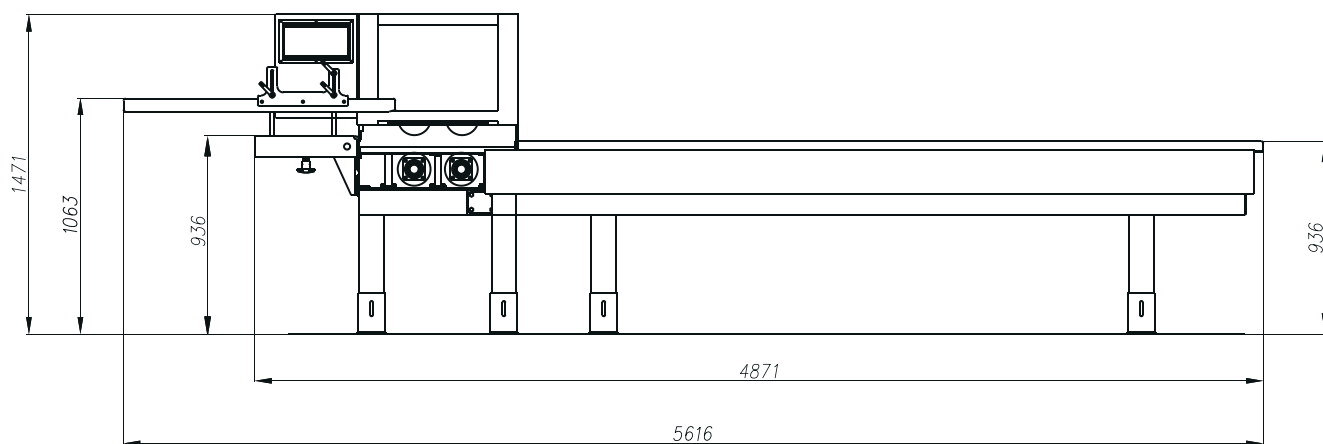
FEED MASTER IF-80

Overall dimensions

Length	5616 mm
Width	1892 mm
Height	1471 mm
Table Height	936 mm
Approx. Weight	850 Kg
Pneumatic Pressure	6 bar



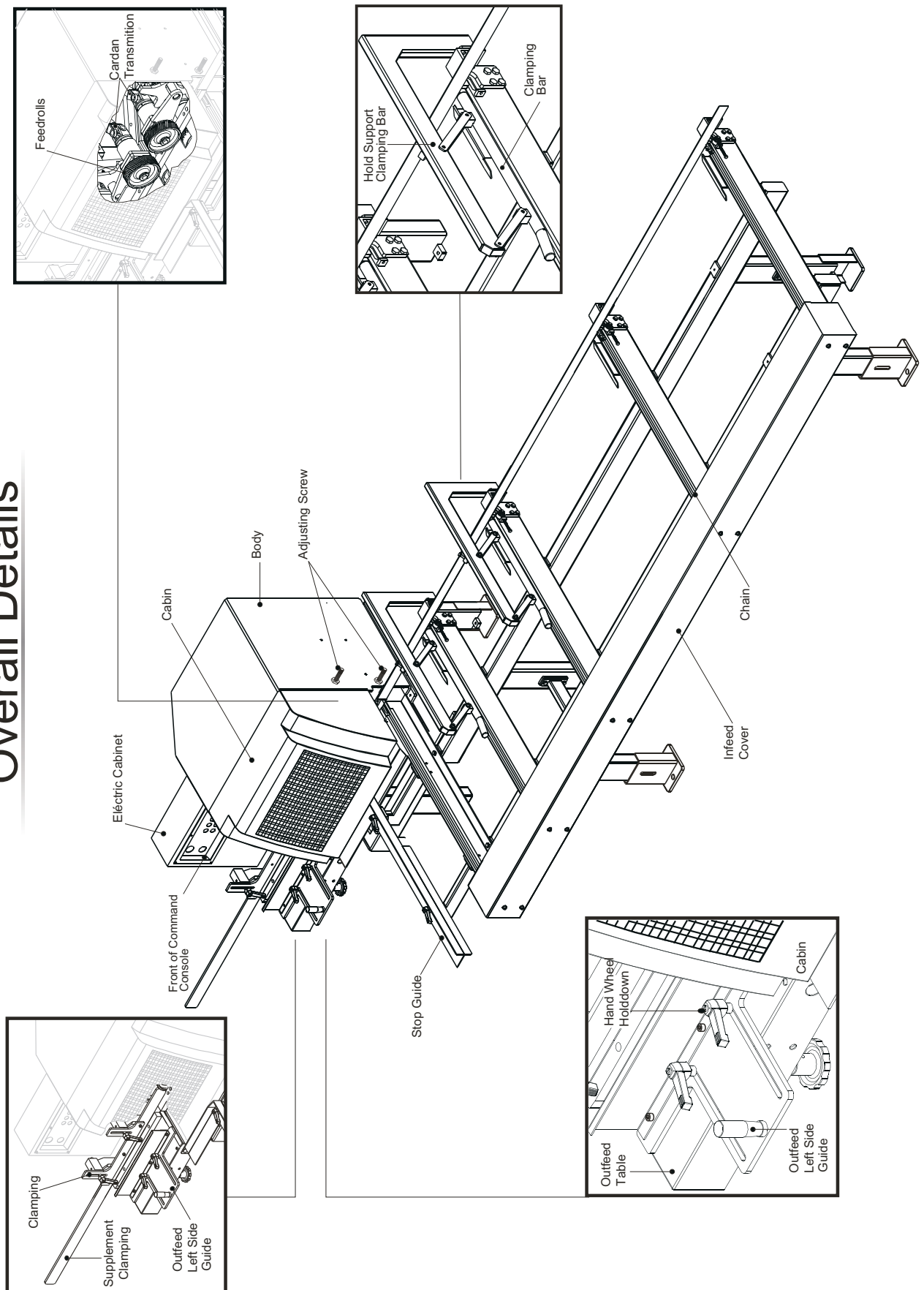
View in Plant



Front View

FEED MASTER IF-80

Overall Details



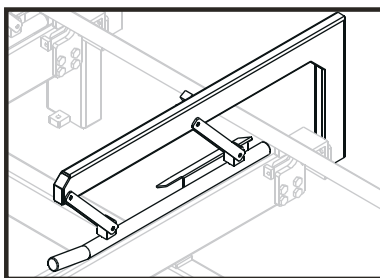
FEED MASTER IF-80

Working Process

This machine feeds wood blocks by means of a feeding chain system up to a halt against the “long guide”, where a infrared sensor turns on the feedrolls that drive the block into the molder. When no more blocks are detected by the infrared sensor, the feedrolls set back until the feeding chain system carries through the next piece to be detected so that the entire cycle starts once again until all the blocks are transferred onto the molder.

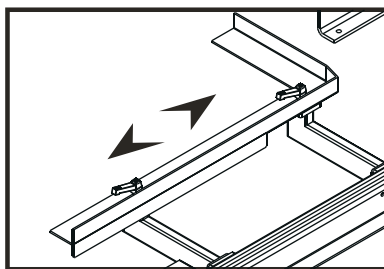
Setup

For a proper setup of FEED MASTER IF-80 proceed as follows:



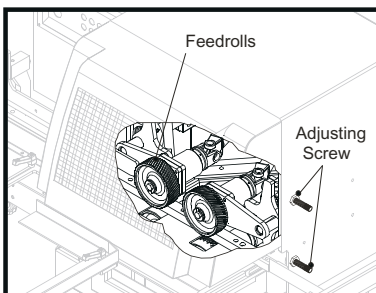
Adjusting The Holddown Bar

The feeder is equipped with a holddown bar located behind the feeding chains that prevents the blocks from piling up as they advance toward the Long Guide. To this end, a stopper rod regulates the height of the rollers to adjust to different block dimensions.



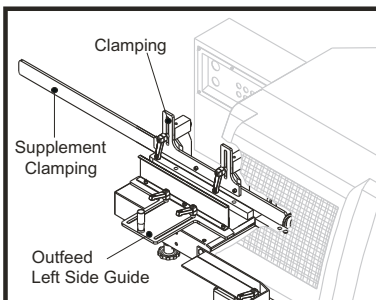
Adjusting Stop Guide

The stop guide regulates the in-feeding blocks before entering the feedroll area according to their width. This is done with a wood sample of similar width to the blocks being transported; this sample is position between the stop guide and the long guide to adjust the stop guide with a 5mm clearance between the guide and the wood sample to avoid excessive friction that may prevent block advancement.



Adjusting Feedrolls

Feedrolls adjustment is carried out with a wood sample the same width as the blocks to be transported. Place the sample under the feedrolls and adjust the stop screws on either side of the structure (1 on the right and 2 on the left side) until desired height is achieved.



Adjusting the Outfeed Left Side Guide and Holddown

This is the last adjusting prior to starting up the machine. The outfeed left side guide should be adjusted up to the sample edge to ensure a good alignment with the molder's infeed table; the holddown should rests on the upper face of the sample.

FEED MASTER IF-80

Introduction

Congratulations! You have acquired a Feeder Linares FEED MASTER IF-80. This machine has been developed and manufactured with the highest standard regarding functioning and quality control, and with extreme attention to both accuracy and detail, using state-of-the-art technology and highly specialized technicians. For this reason, we can only tell out customers to expect the best from this machine for many years to come.

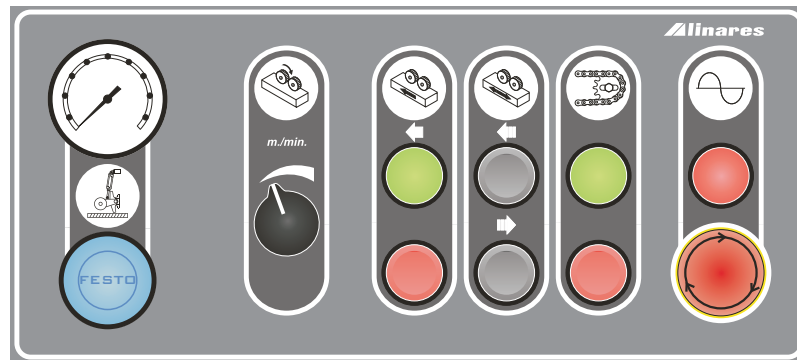
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FEED MASTER IF-80

Control Panel

FEED MASTER IF-80 is equipped with a practical, easy-to-read control panel with pushbuttons and clear signs to its different functions that are detailed below:



This sign indicates feeder status. The red light on indicates electric tension in the panel and that the pushbuttons are enabled. The emergency stop button is in the lower area of the panel; when it has been pushed to re-start working it has to be turned clockwise.



This sign refers to the operation of the feeding chains; to start them up push the green pushbutton, the pilot light goes on indicating that the feeding chains are operating. To stop the feeding chains push the red pushbutton right under the green pushbutton, then the pilot light goes off.



This sign refers to the pushdown forward / backward function of the feedrolls; this function is very useful when setting up the machine or to remove a particular block. To activate this function keep down the pushbutton to the desired direction indicated by the arrow.



This sign refers to the feedroll operation. Once the feeder is set up, press the green pushbutton to start the feedrolls; the pilot light in the pushbutton goes on. To stop rotation press the red pushbutton; the pilot light goes off.



This sign refers to the speed changers. After the feedrolls have been started by turning the knob clockwise the rollers turn faster and they slow down as the knob is turned anti-clockwise.



This sign refers the Pneumatic Pressure Regulator that controls the feedroll pressure against the blocks. This consists in a regulating command and an indicating dial. Pressure to the feedrolls is regulated according to type and width of the pieces being transported.
Use filtered and dry air compressed only.

FEED MASTER IF-80

- FEED MASTER IF-80 should be operated by qualified personnel only. Operators must comply with safety rules recommended.
- Modifications to FEED MASTER IF-80 are strongly discouraged: these can endangered operator physical safety and good working conditions of the machine.
- Never operate this machine with the hood open, except when setting up procedures are being carried out.
- Special care should be taken when cleaning the feeder with compressed air due to chips and splinters being accidentally shot out. Clean out chips and splinters with a brush before using the compressed air system.
- Do not place any object over the feeder or nearby.
- Do not wear loose clothes when operating this machine. (scarves, neckties, neckerchiefs, etc are strongly discouraged)
- Button up jackets in front and at the wrists.
- Do not wear wristwatches and/or bracelets of any sort when operating this machine.
- Confine long hair.

Safety Signs



This sign indicates possible risk of electric shock. The main electrical connection must be laid by specialized personnel.



Utilizar Protección Ocular debido al riesgo de impactos de virutas astillas

Use Eye protection.

This sign indicates that hands should be away from mobile parts in the machine.

FEED MASTER IF-80

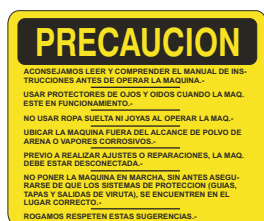
Safety Signs



This sign indicates possible risk of electric shock. The main electrical connection must be laid by specialized personnel.



This sign warns of the presence of electrical failure.



Read carefully the Safety Instructions contained in this manual prior to attempting to operate the machine.

FEED MASTER IF-80

Accessories List

Part: 65-06-00 Subassembly Accessories IF-80.

Part	Description	Quantity
65-06-01	Subassembly COMMERCIALLY IF-80	1
Com-01-003	Allen Wrench 3 mm	1
Com-01-005	Allen Wrench 5 mm	1
Com-01-006	Allen Wrench 6 mm	1
Com-01-008	Allen Wrench 8 mm	1
Com-01-010	Allen Wrench 10 mm	1
Com-01-1.5	Allen Wrench 1.5 mm	1
Com-01-2.5	Allen Wrench 2.5 mm	1
Com-01-014	Allen Wrench 14 mm	1
Com-01-017	Allen Wrench 17 mm	1
Com-01-030	Combine Wrench 30 mm	1
65-06-02	Subassembly. Accessories IF-80	1
2009	Top Roller Tilted	2