

Operations Manual



www.cantekamerica.com



DWM

Drawer Assembly Clamp

Please ensure you have your serial number available when contacting us for parts or service.

Cantek America Inc. | 1.888.982.2683 | **Parts:** sales@cantekamerica.com | **Service:** service@cantekamerica.com

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Introduction

DOUCET MACHINERIES INC. is a manufacturer of high quality machinery for the woodworking industry.

Our mission is to provide quality products and services that will satisfy our customers' expectations while maintaining a work environment that is motivating for each and every one.

Your equipment was designed and built by a team of specialists and will help you produce top quality products for many years to come.

About This Manual

This manual is included with your equipment in order to help you with its set-up, operations and troubleshooting. It also includes detailed instructions on how to order spare parts for it.

The information found in this manual is up-to-date and accurate at the time of printing.

Your equipment may differ slightly due to improvements or other modifications. Some custom features may not be included in this manual. If your equipment incorporates custom features, please refer to the Client Design and Specifications section inserted as an add-on to this document.

Functional Overview

The drawers press Drawer Master is ideal for mass production as well as single unit production. It offers robust construction and easy tuning of high volume machines, at a lower cost. The Drawer Master allows assembly of all types of dovetail joints, joggles joints or tenons and slots. Its angled working plane allows assembling the caissons. It is equipped with double action pneumatic cylinders that can apply pressure progressively; which facilitates the bottom's insertion in the lateral grooves. Its mobile stop is held by a long range triangular structure that splits the clamping pressure evenly, on the whole surface of the drawers caissons. The press opening setting is done with a simple positioning lever. The progressive clamping is done using a push button; it gives the operator full control and flexibility for tasks execution. The double push button closing mechanism of the press keeps the operator's hands outside of the risk zone.

Policy and Guarantee

Doucet's Commitment

Doucet Machineries Inc. is a Machinery Designer, Manufacturer and Integrator dedicated to fulfilling the machinery needs of the Secondary Wood Processing Industry.

Since 1974, thousands of Cabinet Makers, Furniture Manufacturers, Flooring Mills, Decorative Moulding Fabricators and Engineered Wood Products worldwide have included Doucet's machines in their manufacturing process.

Warranty Card

Our machines and their components are thoroughly inspected at all stages of production, and every machine has been assembled and checked before shipping, so as to prevent any defect in workmanship or material.

Except on selected Clamping and Assembling Equipment Models, which carry a 3-year Extended Warranty*, Doucet's obligation under this warranty is limited to repairing or replacing any part which, within twelve months after the date of shipment, shall prove, in our opinion, to be defective. Any such part should be shipped, with prepaid transportation expenses, to our factory or to any service center designated by us, so that we may replace it. Doucet assumes no liability for labor charges incidental to the adjustment, service, repair, removal or replacement of parts or other losses, or for repair expenses made outside its factory, except when made following Doucet's prior consent.

This warranty does not apply to the repair or replacement of parts that failed as a result of abuse and/or misuse. In addition to Doucet's warranty, a large number of off-the-shelf components such as electronic, electric, hydraulic and pneumatic components are covered under their respective manufacturers' product warranty. In most instances, you may obtain local and on-the-spot replacement from a service depot located in your area. In the absence of a local service, Doucet will provide replacement in the form of an exchange and file the claim under said manufacturer's warranty. Doucet reserves the right to decline liability in case of repairs done and replacement parts purchased elsewhere without prior consent.

The text above which describes Doucet's commitments is the only valid commitment and warranty policy regarding our products, and any other type of warranty written or verbal will not be considered as valid.

Information on Health and Safety

Precautions

Fonctionnement

- Avoid overloading. This machine is designed for a specific load.
- Handle with care. Any violent shock could misalign or even damage the machine.

Installation



Very Important: Always anchor the machine to the floor.

Avoid placing this machine in a location exposed to:

- Very high humidity
- High temperature

Maintenance



Warning

During any task performed around this machine, all present individuals should wear safety boots, glasses, gloves and a helmet. All operators must respect sound safety standards of the country in which the machine is located.



Warning







Follow lockout procedures before servicing to avoid injuries, turn off the machine and all peripheral units before performing any type of reparation on it.














Warning

Risk of accident! Incorrect handling can lead to severe injury and equipment damage. Therefore, any type of task must be carried out exclusively by authorized personnel who are trained and familiar with the working methods of the machine while keeping the safety instructions in mind.

Safety Symbols

Symbol	Description	Symbol	Description
	<p>Warning</p> <p>Rotating shaft</p> <p>Do not operate without the guard</p>		<p>Warning</p> <p>Do not operate without the guard</p> <p>Replace guard before operating the machine</p>
	<p>Warning</p> <p>Crush hazard</p> <p>Keep hands clear</p> <p>Follow lockout procedures before servicing</p>		<p>Warning</p> <p>Do not step or stand on this surface</p>
	<p>Warning</p> <p>Crush hazard</p> <p>Keep hands clear</p> <p>Follow lockout procedures before servicing</p>		<p>Warning</p> <p>Only authorized personnel may service this equipment</p> <p>See manual for additional safety information</p>

 <p>©1999 HCS, Inc. 800-748-0241 No. 10160-130</p>	<p>Warning</p> <p>Skin injection hazard</p> <p>Protect hands and body from high pressure fluids</p> <p>Relieve pressure before disconnecting hydraulic lines or any other line and tighten all connections before applying pressure</p> <p>In case of an accident or skin injection, seek immediate medical attention</p> <p>Failure to follow this warning can result in amputation or serious injury</p>	 <p>©1999 HCS, Inc. 800-748-0241 No. 10160-130</p>	<p>Warning</p> <p>Access restricted to authorized personnel only</p> <p>Serious bodily injury may occur</p>
 <p>©1999 HCS, Inc. 800-748-0241 No. 25108-430</p>	<p>Warning</p> <p>Moving lift</p> <p>Keep feet clear during operation</p> <p>Only authorized personnel may service lift</p>	 <p>©1999 HCS, Inc. 800-748-0241 No. 10160-130</p>	<p>Warning</p> <p>Stay clear of this area when the machine is operating</p> <p>Follow lockout procedures before servicing</p>
 <p>©1999 HCS, Inc. 800-748-0241 No. 11108-430</p>	<p>Warning</p> <p>Requires the machine to be completely stopped</p> <p>Push the stop button and wait until the rotation has stopped before opening the door</p> <p>Keep hands clear of the machine until all movement has stopped</p>	 <p>©1999 HCS, Inc. 800-748-0241 No. 10160-130</p>	<p>Warning</p> <p>Pinch point</p> <p>Keep hands clear of rollers</p> <p>Follow lockout procedures before servicing</p>
 <p>©1999 HCS, Inc. 800-748-0241 No. 10160-130</p>	<p>Warning</p> <p>Moving parts can crush and cut</p> <p>Keep hands clear while operating the machine</p>	 <p>©1999 HCS, Inc. 800-748-0241 No. 11253-130</p>	<p>Warning</p> <p>Impact hazard</p> <p>Stay clear of the transfer area during machine operations</p> <p>Follow lockout procedures before servicing</p>

 <p>HCB, Inc. 800-749-0241 No. 90788-180</p>	<p>Warning</p> <p>High voltage</p> <p>Disconnect power before servicing the machine or panels</p>	 <p>©1998 HCB, Inc. 800-749-0241 No. 11868-130</p>	<p>Warning</p> <p>Rotating shaft</p> <p>Do not operate without the guard</p> <p>Follow lockout procedures before servicing</p>
 <p>©1998 HCB, Inc. 800-749-0241 No. 10075-130</p>	<p>Warning</p> <p>Rotating blade hazard</p> <p>Do not operate without the guard</p> <p>Follow lockout procedures before servicing</p>		<p>Warning</p> <p>Heavy object</p> <p>Use lifting devices when removing for servicing</p>
 <p>©1998 HCB, Inc. 800-749-0241 No. 10068-130</p>	<p>Warning</p> <p>Crush hazard</p> <p>Keep hands clear</p> <p>Follow lockout procedures before servicing</p>		

Safety Rules

General Safety Rules

1. Keep the work area clean. Cluttered work areas are susceptible to accidents. Make sure to always clean and tidy it.
2. The work area should be well lit. Working in poor lighting can be dangerous. If necessary, install additional lighting devices.
3. Do not place unnecessary objects on any table except for the material to be processed.
4. Do not remove any guard except when performing machine maintenance, replacing a part or adjusting a mechanism.
5. To avoid affecting the machine's performance, use only replacement parts supplied by the manufacturer. After maintenance, be sure to return the machine to its original condition.
6. To avoid an accidental start, when the job is finished or the machine is not in use, remember to turn off the

fuse (or to unplug the power wires). If the switch is equipped with a key, lock it, remove the key and store it in a safe place.

Safety Operation Rules

1. Before operating the machine, the operators must be trained accordingly.
2. The maintenance personnel must be well trained before performing machine maintenance duties.
3. For your safety, read the instructions manual carefully before operating the machine. Learn its uses, operation instructions and limitations as well as its specific potential dangers.
4. Carry out machine maintenance, parts replacement or adjustments only when the machine is powered off and has stopped running.
5. Do not alter the machine (including fitting with other parts or accessories) without its manufacturer's authorization.
6. All parts, accessories and safety guards equipped on the machine have specific and important functions. To prevent injuring the operator or damaging the machine, do not remove any part or guard.
7. Do not replace machine elements with parts and accessories that are not produced or approved by the machine's manufacturer (includes cutter arbor, cutter, saw blades screws, etc.).
8. Do not force the machine. It will do the job safely and smoothly as it is supposed to.
9. The gaps and openings on the machine are used for air ventilation to avoid overheating. Therefore, do not shield or cover them.
10. Use the right tools to adjust or service the machine.
11. In case of abnormal running, machine damage or malfunction, stop the operation immediately and carry out the troubleshooting sequence.
12. Keep your hands away from the running saw blades and cutters while the machine is operating.
13. While performing maintenance, part replacement or adjustments on the machine, before making it run again, be sure to remove your hands from the transmission parts (such as chains, chain wheel and belt).
14. Properly adjust the machine according to wood materials variations.
15. Do not stand on the machine to avoid unexpected danger.
16. Once the power is turned off, clean and arrange the work area before leaving.

Safety Rules Before Operation

1. Do not wear loose clothing that could get caught in moving parts.
2. Before operating the machine, remove neckties, rings, bracelets or other jewelry. Wear covering hairnet to contain long hair.
3. Before operating the machine, make sure to wear safety footwear and work clothes.
4. Always use safety glasses.
5. To protect the operator's hearing, ear protection should be used.
6. Before operating the machine, use tools to check if all cutters, saw blades, guards and parts are in place and tightened securely.
7. When inspecting the machine, if any cutter, saw blade, guard or part is damaged, do not start the machine until the damaged item is repaired or replaced.
8. Before starting the machine, make sure there is no one left in the operating area. Also, it is necessary to pay attention to the safety of other employees.

Safety Rules During Operation

1. Once the machine is started, the operator must not leave his post. After the machine is turned off, he must wait for it to come to a complete stop before leaving his post.
2. Remain at a safe distance from the machine.
3. When the machine is operating, always pay attention and remain vigilant.
4. When the machine is running, do not try to adjust parts or dismantle any guards.
5. Do not force feed material to the machine. Feed it according to the advised frequency.
6. In order to avoid danger caused by rebounds of broken material, the operator should not stand in front of the machine. He should stand either on the right or left side of the table.
7. When the machine is running, do not place your hands or any tool on or under the table.
8. During the operation, if any abnormal sound or trouble occurs, stop the machine immediately, then inspect and repair it.
9. During the operation, if you need to take out edge material, chips or check the cutter or saw blade, always remember to turn off the machine and wait until the cutter (saw blades) has come to a complete stop.

10. When the work materials' sizes (height and thickness) are changed, properly adjust the machine, and then tighten the adjusted parts securely.
11. All pressure switches (or relief valves) have been properly set before shipment. In order to ensure the operator's safety, do not adjust them.
12. In order to avoid injury by crushing or cutting, do not place your hands in the cutting areas.

Safety Rules for Electrical Control

1. Install the electric control circuits and switches according to the electrical regulations.
2. Apply only the specified power source and voltage as shown on the attached labels.
3. The machine comes with proper grounding devices, which must be connected to avoid the danger of electric shock. Always remember that improper grounding is a potential danger.
4. For your safety, the grounding and troubleshooting for all electrical and electronic devices are performed only by qualified technicians who are properly trained and have adequate knowledge and skills.
5. The power cords should be mounted in an area away from passageways and paths used for transporting equipment.
6. Do not connect several power cables to a fuse or exceed its rated current capacity; otherwise fire or electric shock may occur.
7. Make sure there is no fissure on the cable cover for all power source cables and interval circuit wires. If any is broken, replace it with a new one to avoid an electric shock.
8. Before starting the machine, check for any damaged electrical or electronic parts.
9. When replacing the computer or electronic components, make sure they conform to the manufacturer's specifications and functions including colour coding. Any improper replacement part may result in fire, electric shock or other hazard.
10. Do not alter any electrical control circuit unless authorized to do so by the machine's manufacturer.
11. When the machine is equipped with a microcomputer or computer controller, do not alter the built-in programs or other application programs or softwares unless authorized to do so by the machine's manufacturer.
12. Do not insert any object into the switches, junction box, etc. It could touch the contact terminal, resulting in a short circuit, a fire or an electric discharge.

13. Do not let any liquid into the electrical equipment, because it could damage the electronic components or cause a short-circuit.

Product Specifications

Machine Characteristics

Overall Dimensions:

DWM-36	DIM
Height	57"
Width	37"
Length	66"
Floor Area	203 SQUARE FEET

DWM-42	DIM
Height	57"
Width	37"
Length	72"
Floor Area	222 SQUARE FEET

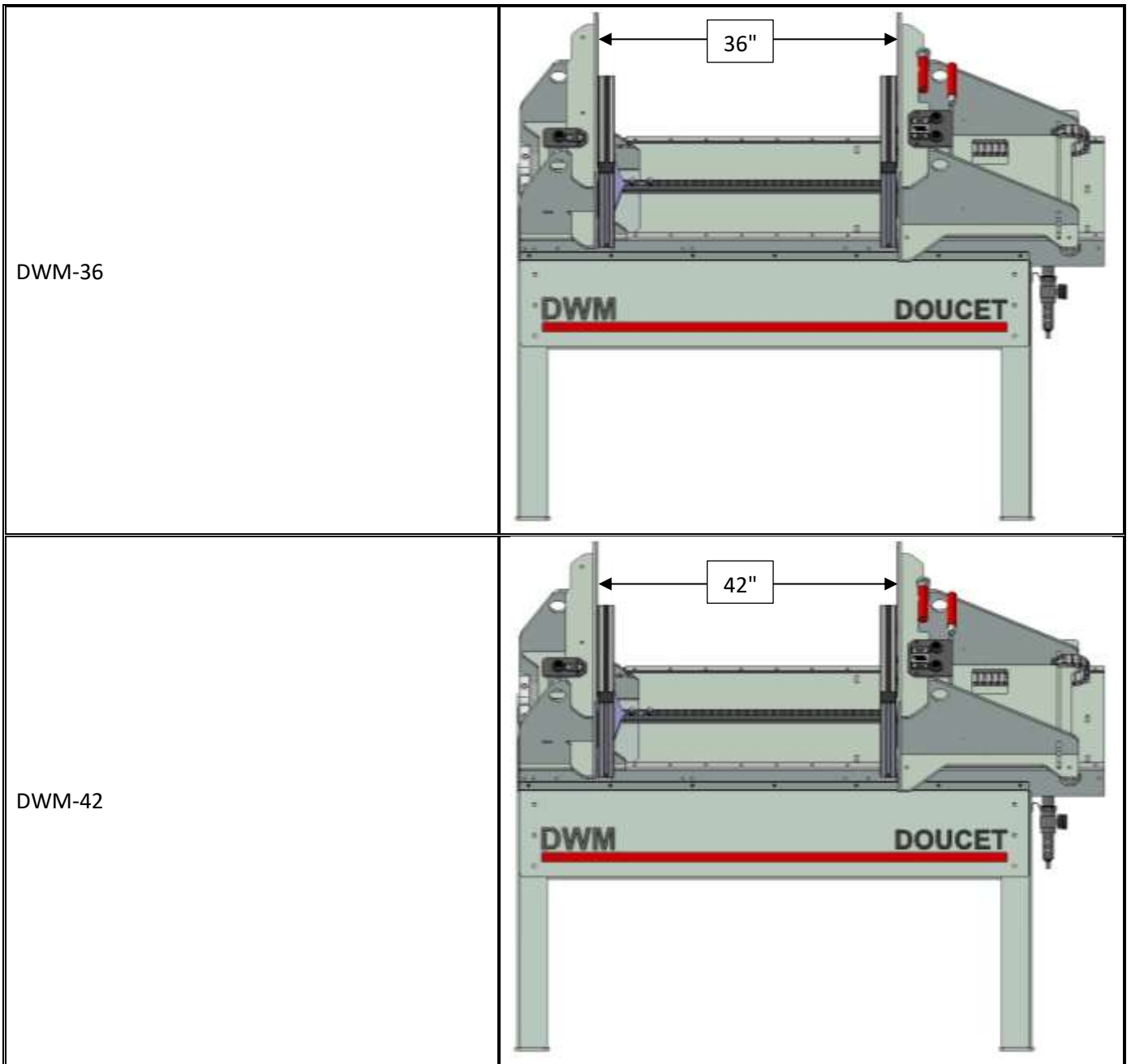
Product Dimensions:

Dimension	DWM-42 Max	DWM -36 MAX	Min
Width	24"	24"	N/A
Length	42"	36"	4"
Thickness	10"	10"	N/A

Air Consumption

Description	SCFM	Pipe	Pressure
Counter-pressure Governor			57 psi
Fr	5		60 psi

Diagram

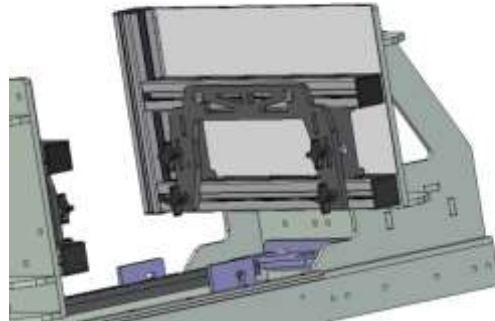


The Drawer Master can be equipped with different accessories, like extensions for drawers of 4" and 6", the hybrid low profile drawer bottom stop plate and pivoting vertical stop plate.

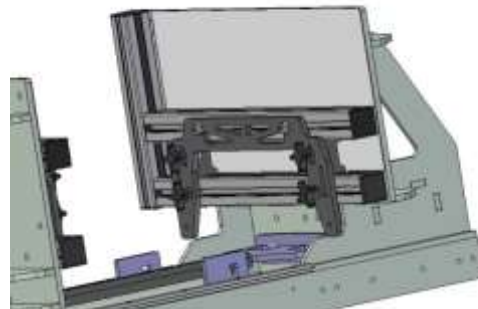
4" and 6" extensions (option)

Useful to maintain work ergonomics and maximize 4" or 6" high drawer components access. Among other things, the increases are useful to assemble 4" or 6" high drawers mounted "bottom below", used with the rotating vertical bumper.

Increase of 4"



Increase of 6"



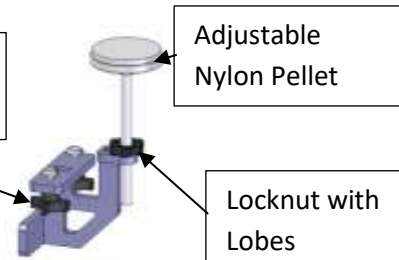
Hybrid Bottom Support (optional)

The Hybrid Bottom Support can help support the bottom of the drawer to be assembled as "above bottom" or "below bottom" in most case. The two clamping plates make the support more versatile.

Bottom supports usage eliminates the need to align the bottom of the drawer in its perimeter groove and, at the same time, contributes to reducing the assembling time.

Adjustment is done without tool. You simply need to unblock adjustment using locknut with lobes.

Fixating Plate Montage 1



Adjustable Nylon Pellet

Locknut with Lobes

Fixating Plate Montage 2



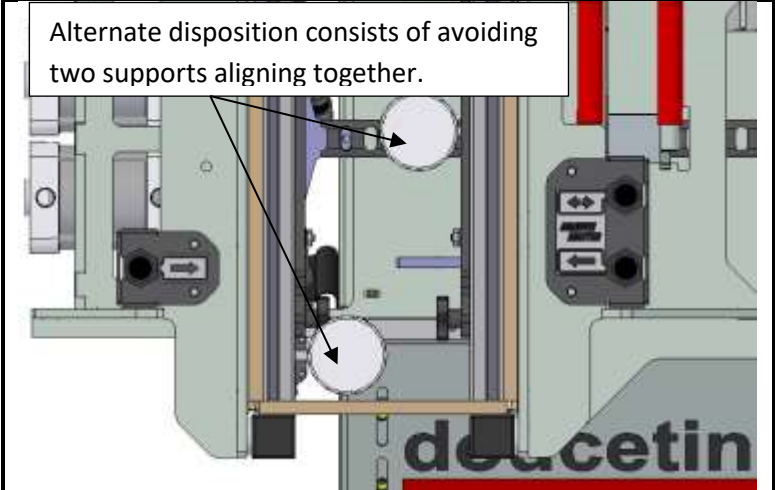
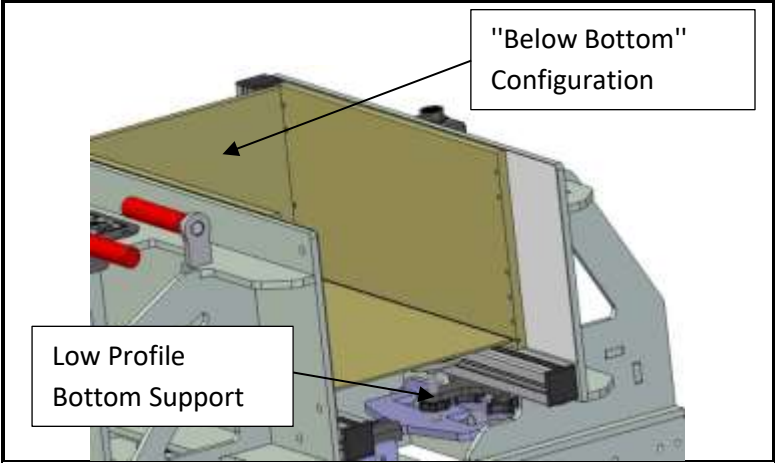
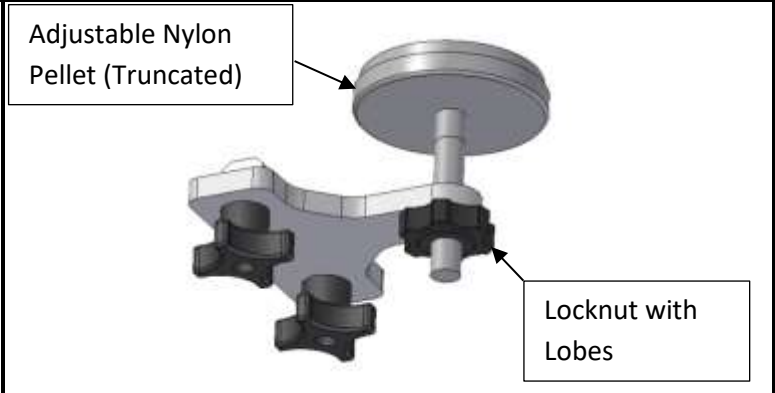
Low Profile Bottom Support (optional)

The Low Profile Bottom Support is only useful to the support in restrained areas, like for supporting the bottom of a drawer in "bottom below" configuration without using extensions.

Some precautions are needed to prevent damaging the bottom supports, like proceeding to an alternate disposition, allowing maximizing to-be-assembled drawer dimensions variety without interference.

Warning

Usage of bottom supports limits the width of the smaller drawer to 10½". Assembling a smaller drawer can damage the Drawer Master's supports.



Pivoting Vertical Support (optional)

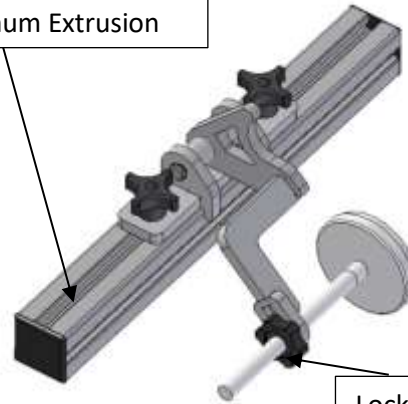
Pivoting vertical support is only used in "bottom below" configuration. It vertically supports the back of the drawer in order to eliminate the need to align or pre-insert the back part of a drawer on its left side. The pivoting vertical support saves montage time and ensures correct assembling of the back part.

The pivoting support can be elevated during insertion of the first components, then lowered when inserting the back part of the drawer, and finally elevated when extracting the assembled drawer.

The pivoting vertical support is equipped with its own aluminum extrusion used as a rough adjustment slide and as a support for locknut with lobes adjustable nylon pellets for the final adjustment.

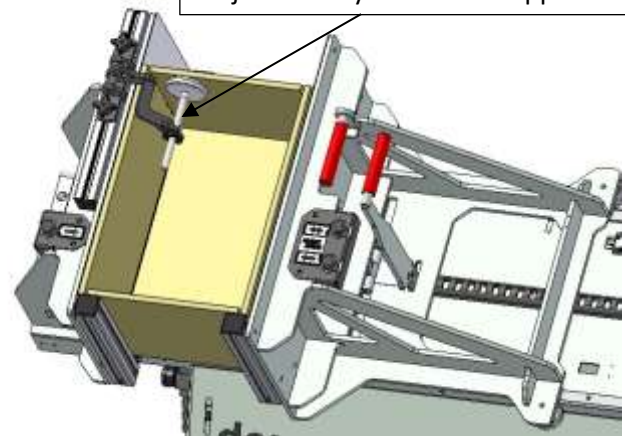
Note: Using riser blocks will be necessary to the assembling of drawers lower than 10" high.

Aluminum Extrusion



Locknut with Lobes

Adjustable Nylon Pellets Support



Unloading, Assembling and Installing the Equipment

Unloading



Warning

Handle with care. Any violent shock could unbalance the machine and even damage it.

Handle at all times with proper lifting equipment and appropriate tools for installation. When unloading the clamp, leave the machine on its wooden support and slide it to the ground with a forklift at the right installation spot.



Delivery Inspection



Warning

Carefully unload the machine and remove its components from the shipping container. Make sure the machine has not been damaged during the shipping phase.

Note: Report any damage or missing parts immediately to your local **Doucet Machineries Inc.** distributor.

Unpacking

Storage and Handling

Storage



Warning

Do not install the machine in an area subject to direct sunlight or rain.

1. Keep proper ventilation around the work area. Install additional ventilating equipment if air ventilation around work site is poor.
2. Do not install the machine in a location with an ambient temperature of under 0°C or over 45°C.
3. Keep the machine away from any heat dissipation device or heat source.
4. Do not install the machine near a water source or in a humid area, as these locations may cause instability, or damage the computer or the electronic components.
5. Do not install the machine near a corrosive liquid or gas equipment.
6. The installation site should be well lit. If necessary, install additional lighting equipment.
7. Wood dust and chips may be produced when the machine is performing cutting operations; therefore, a dust collection system or a dust collector should be connected to the machine (for its type, dimensions and airflow volume, refer to the machine's installation instructions).
8. This machine uses pneumatic systems to operate. In case of insufficient air or even lack of air, the machine will not start. It should be connected to an air compressor or an air-powered circuit.

Handling



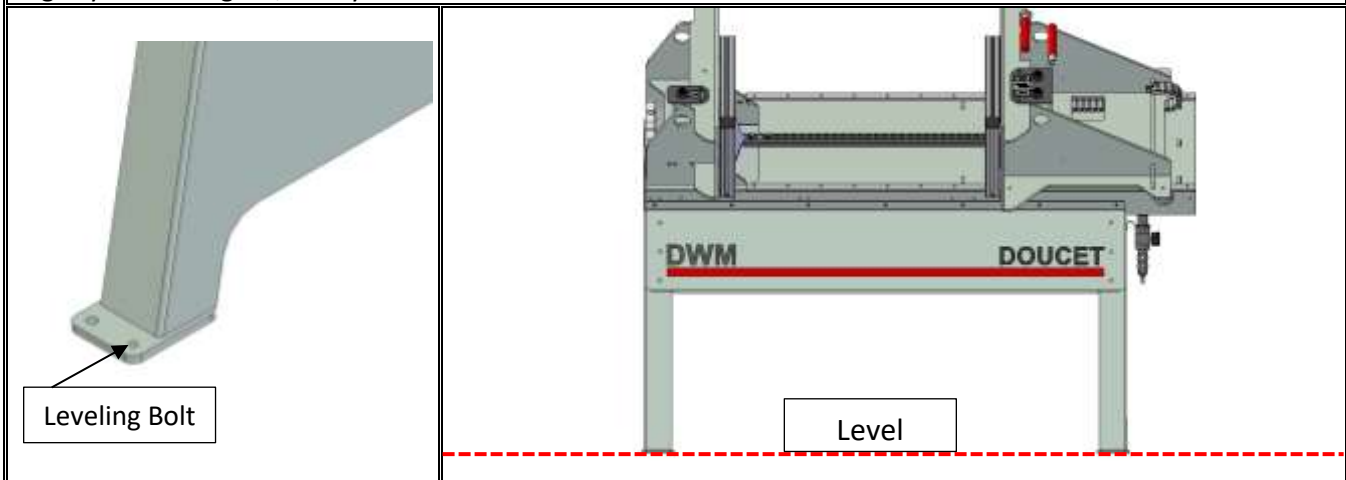
Warning

Handle with care. Any violent shock could unbalance the machine and even damage it.

Leveling

Level the machine using the leveling bolts provided near the anchor points. Check its flatness as you go, using a level.

The Drawer Master is adjusted at the center of its work height. It is possible to either level, lower or raise the legs by $\pm 1\frac{1}{4}$ using a $\frac{7}{6}$ " key.



Pneumatic Connection

The Drawer Master works pneumatically using two air pressure, the difference between both pressures being the pressure differential. The pressure differential required is of 3 psi for an adequate functioning. Using two pressure regulators, the drawer clamp uses a different pressure from the two juxtaposed sides of the pneumatic cylinder pistons.

Settings for the two pressure regulators (by default)

1. Counter-pressure 57 psi governor
2. Fr 60 psi

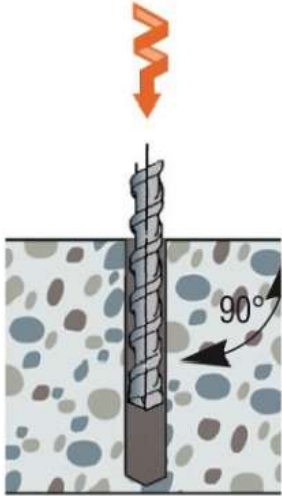
Note: For an optimal functioning, the counter-pressure must be of $3 \text{ psi} \pm 1 \text{ psi}$ of the main pressure.



Permanent Installation

When the frame is assembled, you'll simply need to fix it to the floor at the intended location. Position and mark the anchor points on a straight floor or one that has received a grout as required (concrete floor).

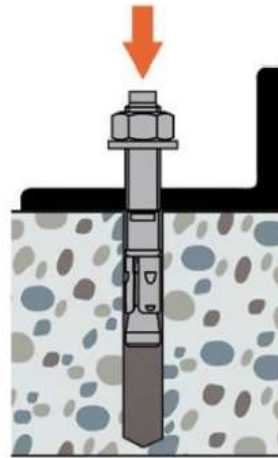
Prepare 3/8 " anchors (not supplied).



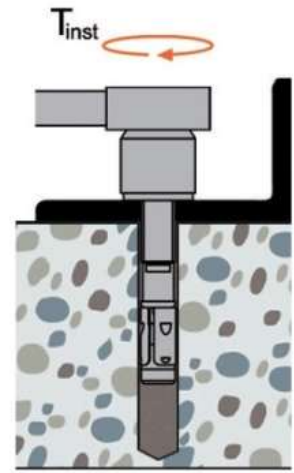
Drill a hole



Dust the hole



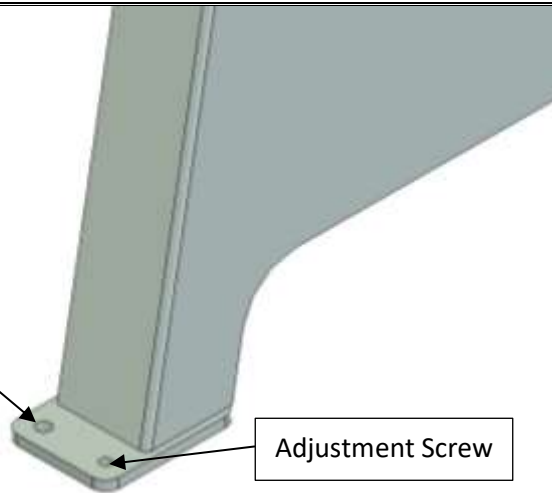
Mount the anchor through the fixture



Apply the tightening torque

Solidify the machine to the ground while controlling its flatness with a level. Adjust if necessary.

Anchoring Hole



Adjustment Screw

Adjustments and Preparation

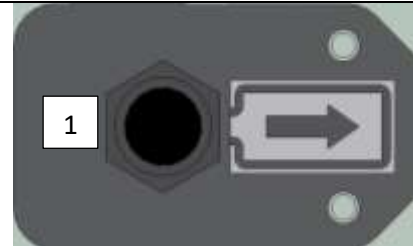
User Interface

The Drawer Master is equipped with three pneumatic buttons, the first **(2)** activating the clamp's opening, and the other two **(1)** needing the two hands of the operator to activate the clamping. The two-hands activating system allows secure drawers assembling. The mobile stop moves on the rail and is equipped with a double-handle system for fast release of the oblong anchoring and for moving of the stop depending on the desired length of the drawer. Generally, we need to anticipate 1" of opening more than the length of the drawer to be assembled. The maximum stroke is of 2".

The drawer clamp is equipped with a pneumatic system that activates full clamping automatically when we maintain the two clamping buttons **(1)** pressed and the mobile stop ceases moving against the drawer.

Full clamping is momentary, only activated when pressing the buttons **(1)**. Full clamping automatically becomes permanent when the mobile stop ceases its movement, and it's only after one or two seconds that the maintained pressure is applied.

Note: The maintained pressure is activated as soon as the pneumatic system stops purging the counter-pressure air and doesn't make any leak sound.



Start-up**Warning**

It is necessary to visually inspect the machine before proceeding with the first machine test.

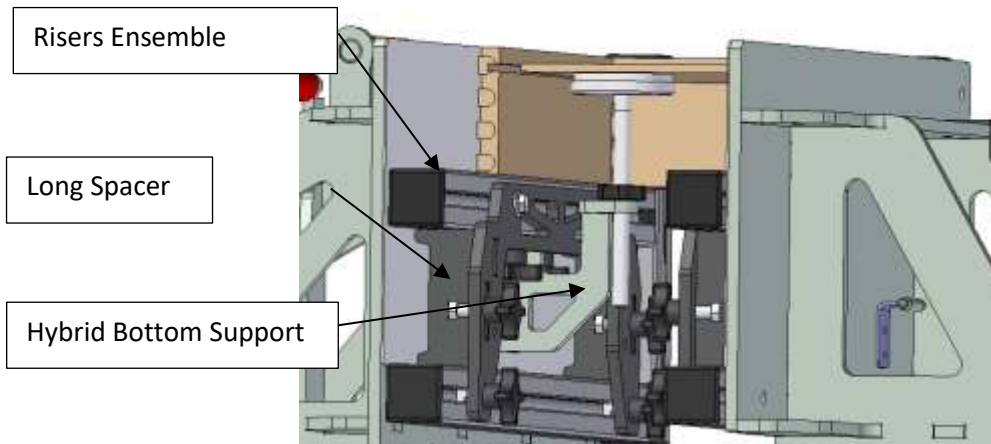
First step: Determine the required montage depending on drawer type

For example, a 4" high dovetail drawer in "above bottom" configuration

Second step: Usage of appropriate accessories (optional)

Use risers and long spacers for a 4" high montage.

Add two hybrid bottom supports and adjust corresponding to the physical dimensions of the drawer.



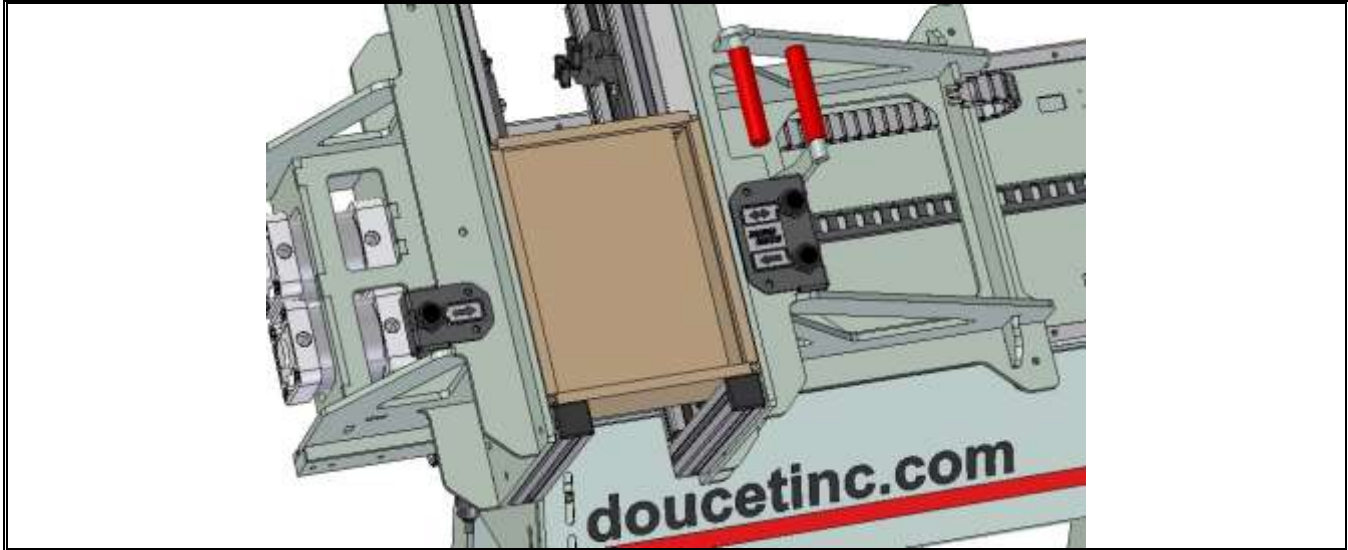
Third step: Assembling dovetail drawer

** apply glue to the dovetails of the drawer's sides beforehand

Insert the front part of the drawer as well as the left side by pre-aligning the two parts. Anticipate 1" more than the drawer's length for the clamp's opening.

Insert the right side by doing its pre-alignment with the front part of the drawer, slide the bottom (from top to bottom) in place, and then insert the back part using the same precautions as with the front part.

Press the two buttons marked with an arrow oriented towards the drawer until complete assembling of the drawer, and then free the assembled drawer by pressing the button with opposing arrows.



Adjustments

The Drawer Master uses air as an energy source. A minimum debit of 5 CFM is enough to power the clamp. The tightening pressure required to assemble a 10" high drawer with dovetail joints only requires 40 psi (470 lbf), although the main pressure is adjusted at 90 psi (910 lbf) in factory, in order to assemble even tighter tolerance joints. The factory presets will suit 99.9% of the drawers assemblings, a higher pressure being an exception.

Improper Use of the Machine



Warning

Any usage that is different in any way or form than the correct use stipulated by Doucet is prohibited and considered as non-conforming. In the event of non-conforming usage, any claim for compensation to the manufacturer or his agents, whatever the form, is invalid. Only the user bears the responsibility for damages incurred for improper use.

Maintenance and Cleaning

Safety Precautions



Warning

To avoid any injury or physical damage, disconnect the machine's power cable, along with the ones of any associated units before undertaking any repair.



Warning

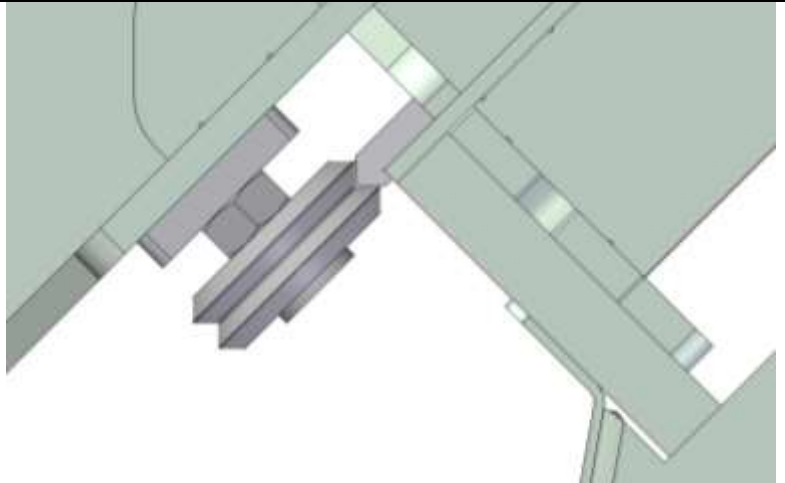
Risk of accident! Incorrect handling can lead to severe injury or equipment damage. Therefore, this machine's tasks must be carried out exclusively by authorized personnel who are trained and familiar with the machine's routine while taking the safety instructions into account.

Preventive Maintenance

Descriptions	Daily	Weekly	Monthly	Others
Remove water from the water separator of the air intake.	✓			
Verify the system's air pressure (60 psi).	✓			
Verify the pneumatic systems' pressure.		✓		
Verify the connections.			✓	
Tighten all nuts and bolts on moving parts.			✓	

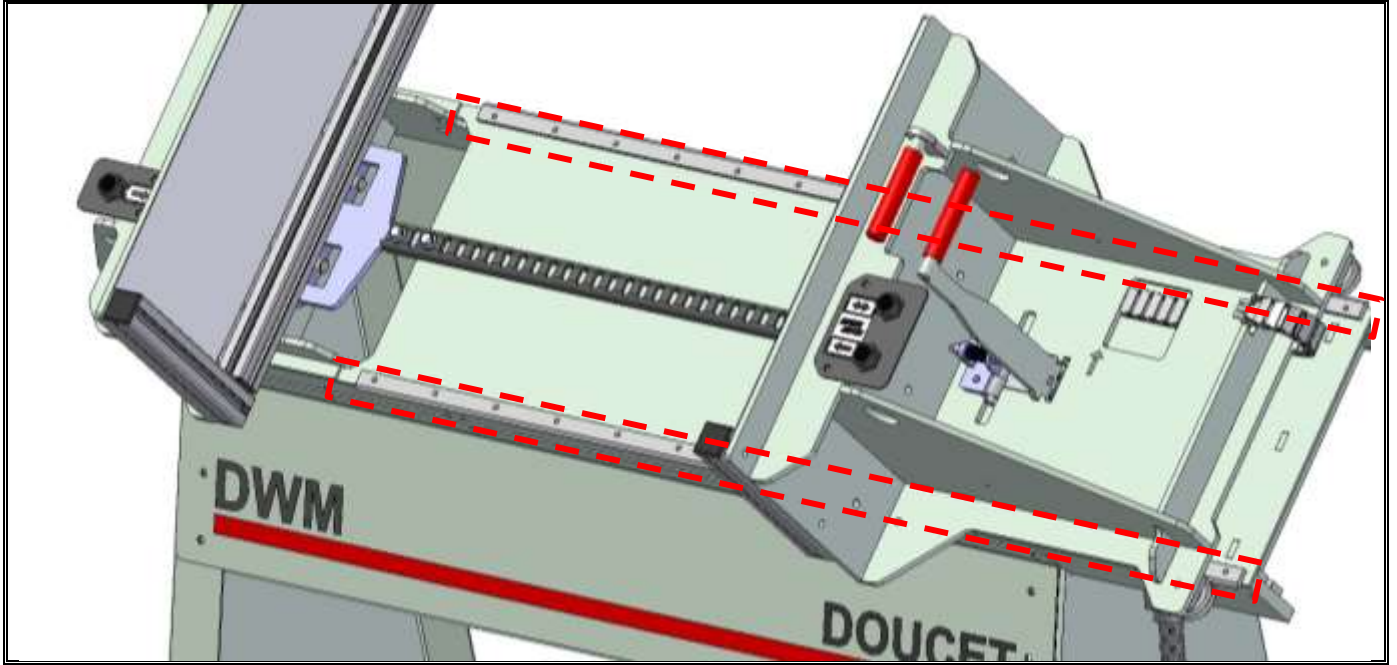
<p>Keep the pneumatic hose chain away from any object that may harm its full course.</p>	<p>✓</p>			
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Maintenance Adjustments and Replacement Parts

<p>Every 6 months, verify "V" eccentric wheels clearance of the mobile stop's bottom part. An excessive clearance allows rotating the "V" wheels manually without the stop moving during its verification.</p> <p>Note: Top "V" wheels are concentric, so they do not need adjusting.</p>	
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Lubrication

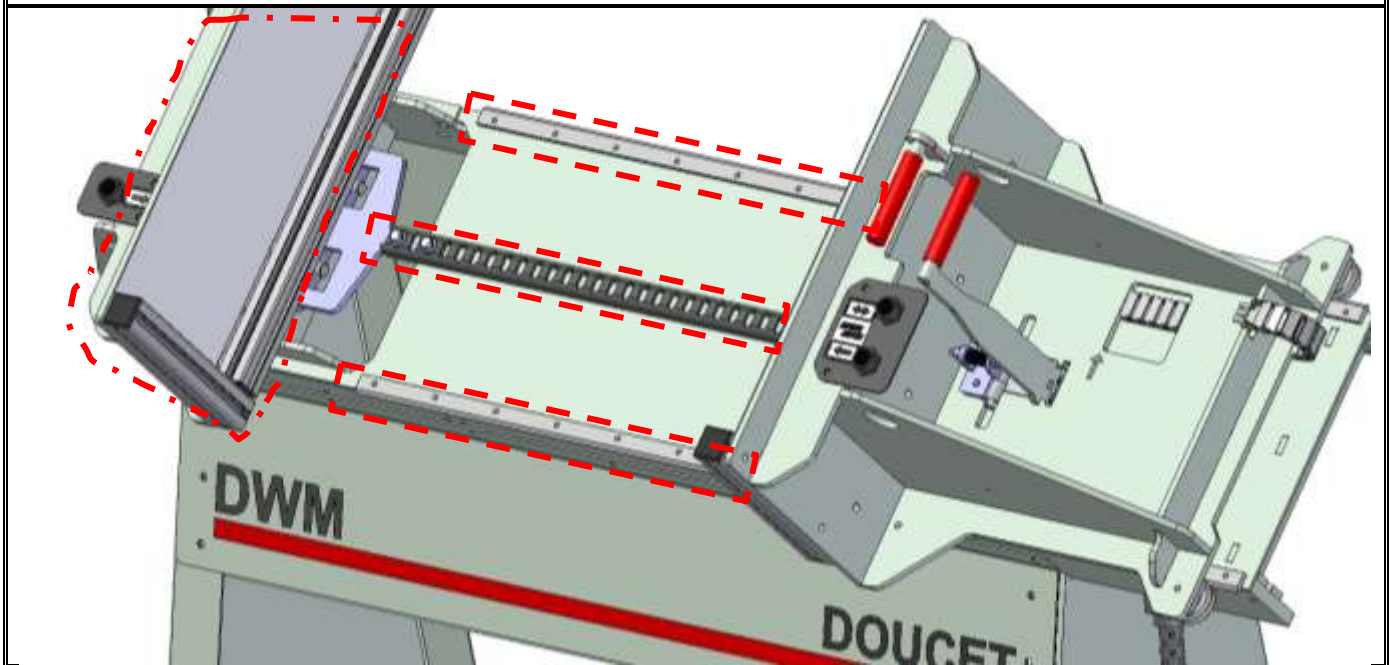
<p>Generally, each ball bearing is sealed and do not need lubrication. To lubricate them, follow the maintenance schedule. Use appropriate oil and grease, depending on the bearing manufacturer's recommendations.</p>
<p>Verify and lubricate the "V" rails monthly using a PTFE-based (Teflon) aerosol lubricant. We recommend the "Slick 50 one Lube".</p>



Cleaning

Having a safe and clean environment is important for the qualified person to be able to do their job properly. To adjust any part of the machine, you will need to follow the procedure in the next section. This machine should be cleaned every day by sweeping or vacuuming dust (**never use a jet of compressed air, because it could cause bearings contamination**). Tighten all bolts and nuts, and proceed with a visual inspection for the first month of operation.

For better functioning, keep the drawer clamp tidy and clean glue residues using a plastic scraper in order to prevent damaging the clamp.



Troubleshooting

Actions in Case of Malfunction



Warning

To avoid personal injuries or physical damage, disconnect the power supply from the machine and other related units before attempting any repair.



Warning

To avoid personal injuries or physical damage, disconnect the air supply from the machine and other related units before attempting any repair.



Warning

Risk of accident! Improper repairs can lead to severe personal injuries or physical and property damage. Therefore, repairs must be carried out exclusively by authorized personnel who are trained and familiar with the machine's tasks routine, keeping the safety instructions in mind.



Warning

In case of a malfunction which would represent a potential danger to persons, objects or the safety of the operation, immediately stop the machine with the **red emergency "Stop" button**. In addition, disconnect the power supply from the machine and secure it against unintended start-ups. Immediately notify those responsible of taking new incidents into account at your workplace. Have the nature and extent of the incident verified by specialized personnel, so that the causes can be investigated and the damages repaired.

Problems, Causes and Solutions

Problems	Causes	Solutions
While tightening, when the tightening buttons are released, the mobile stop moves by itself.	<ul style="list-style-type: none"> • Not enough counter-pressure. 	<ul style="list-style-type: none"> • Make sure main pressure is 2 to 5 psi higher than the counter-pressure.
The drawer isn't completely closed off, or doesn't assemble at all.		<ul style="list-style-type: none"> • Verify that there is enough main pressure (see gluing chart). • Verify the quality of the drawer in question's components.
The drawer cracks or is damaged during tightening.		<ul style="list-style-type: none"> • Verify if pressure is too high. • Verify machined joints' quality. • Make sure that the components are aligned properly before tightening.

Parts List and Parts Ordering Method

Ordering Procedures for Spare Parts

- Identify the part in this manual.
- Write the part and code numbers, quantity, description and the number of the diagram or drawing.
- The model and serial number of your machine must be included.
- Call or fax the order to your Doucet local distributor or send it by email at: info@doucetinc.com.

Note:

- Following this simple procedure will enable us to give you faster and better service.
- Your machine is built by **Doucet** with standard components that are mostly available through **local suppliers**, or through your **Doucet distributor** or at **Doucet Machineries Inc.**

Reference Drawings

D060-806

D060-804

D060-791

D060-790

Pneumatic and Hydraulic Plans

D051-636