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CONFORMITY STATEMENT

Constructor: VALIANI

Via delle Regioni 305/307/309 – 50052 Certaldo FI ITALIA

Manual mat (mountboard) cutter machine denominated ASTRA.

I FRANCO VALIANI undersigned owner of the manufacturing company declare under my own responsibility that the machine to which this manual refers complies with:

- **Directive 2006/42/EC on machinery (D.L. 17/2010).**

Certaldo, FI December 2001

Stamp and Signature



Preface

The assembly, use and maintenance standards that are described in this manual will ensure the machine's best long lasting performance.

We suggest you to read and follow the instructions carefully before starting the machine.

We are available to offer you all the assistance that you may require and we also wish to remind you that the non-observance of the instructions included in this manual will entail the loss of warranty.

The company reserves its right to carry out modifications in order to improve machine functioning.

For further details or any problem, please contact our company

CEE standards

This manual has been written in accordance with the regulations of the CEE DIRECTIVE 89/392-91/368-93/44-93/68 as indicated in the machine design definition, the use instructions are an integral part of the machine.

The criteria used for writing comply with the regulations of the EN -192 EUROPEAN STANDARD and in particular, point 1.7.4 89/392 "USE INSTRUCTIONS" (instructions, general requirements and nature of the instructions).

THE INSTRUCTIONS INCLUDED IN THIS MANUAL ARE ADDRESSED TO THE USERS



The instructions reported in this manual are important for your safety. They are identified differently according to the risk factor.

ATTENTION ! This type of warning indicates a recall to the implementation of safety practices, or it calls attention to unsafe behaviors that could cause personal injury.

Identification plate



VALIANI

**COSTRUZIONI MECCANICHE
DI FRANCO VALIANI & C. s.n.c.**

50052 CERTALDO (FI) - ITALY - Via delle Regioni, 305/307/309
Tel. (0)**571/666598** - Fax (0)**571/663454**

MOD.
YEAR
SERIAL N°





Machine user obligations

Legislative decree N°626-Implementation of directive 89/391 CEE regarding the improvement of workers' safety and health in the workplace

Art.5 Workers' obligations

Point 2

2b) Workers must use machinery, equipment, tools, dangerous substances and compounds, means of transportation and work equipment, as well as safety devices, correctly;

2c) they must use the protective devices placed at their disposal correctly;

2d) they must immediately inform their employer, the manager or appointed head of the malfunctioning deficiencies of the means and devices listed in points **b)** and **c)**, as well as of other possible dangerous conditions that they discover, endeavoring, in the case of an emergency, within their area of expertise and possibilities, to directly eliminate or reduce such deficiencies and dangers, informing the workers' safety representative;

2e) they must not remove or modify the safety, signaling or control devices without authorization;

2f) they must not carry out operations or maneuvers on their own initiative that are not within their area of expertise or that might place their own safety or that of other workers at risk;

1 INTRODUCTION

Astra was conceived and produced by Valiani as a manual matcutter for matboard of varying thickness from 1.25 mm to 3mm. It is extremely easy to use and entirely manual.

1.1 Warranty conditions

Our Company guarantees that its products are built in an efficient manner and that they do not have defects in manufacturing and materials.

This warranty is valid for a year starting from the date of purchase, if the "Warranty coupon" is sent filled out in its entirety within 10 days from the setting at work of the machine. The warranty is limited to free of charge replacement or repair of the part which, within the above-mentioned time, shall be returned to us free of charge and if we find it to actually be defective in materials and/or manufacturing. Any other direct or indirect damage is not included in the warranty. In particular, the failure of our products whenever their lack of or defective operation can be attributed to incorrect installation or to negligent or improper use is not included in the warranty and is not our responsibility (except for replacement or repair of defective parts under the terms and conditions mentioned above). The manpower necessary to carry out the part's removal and reinstallation (or equivalent credit) is not included in the warranty. Before returning goods to VALIANI, contact our offices for authorization.

VALIANI will supply the spare parts whenever technical assistance is requested. Transfers, board and lodging for the personnel used and fees per hour will have to be paid separately.

N.B.: the descriptions and illustrations in this manual are solely suggestions. For more detailed information, please contact our sales office. VALIANI reserves the right to make modifications to the products that it deems necessary at any time and without warning.



!!! ATTENTION !!!

**COMPLETE AND RETURN THIS COUPON WITHIN 10 DAYS FROM
INSTALLING THE MACHINE.**

WARRANTY COUPON AND ACKNOWLEDGMENT OF THE MANUAL

Model _____ Serial _____
N° _____

Company _____

Street _____

Z.I.P. Code _____ City _____

Date of Purchase _____ Retailer _____

Signature _____

The owner declares that he/she accepts the warranty conditions, that he/she has verified that the machine operates correctly and that he/she has read and understood this manual in its entirety.

WARNINGS AND INSTRUCTIONS

1.2 General terms

This instruction manual aims to help the reader become acquainted with the machine and learn how to use it for its intended purpose.

It also contains important advice for safe, cost saving use.

The operators must comply with all the regulations included in order to avoid dangers and therefore use the machine in a reliable, safe, time saving and long lasting way.

This manual is to be kept near the machine and available for the operators and for whoever uses the machine, such as personnel that is in charge of commissioning, transportation, cleaning, ordinary maintenance interventions, disposal of process residuals, checks and inspections.

The user must check the machine at least once a day (at the beginning of the cutting operation) in order to determine errors or variations that can endanger safety and stability (evaluating the performance of the machine while it is operating); he is therefore also obliged to inform the persons in charge.

It is also mandatory to follow the use instructions described below.

The machine is equipped protection devices that improve safety conditions: their removal (total and/or partial), tampering or disassembly is absolutely forbidden.

However the machine has a residual risk due to the blades located on the cutting head.

Be extremely careful especially when cleaning.



The manufacturer declines all responsibilities due to damages caused by any arbitrary modification carried out on the safety devices and on any part of the machine structure.

Besides the instructions included in this manual, the user is also obliged to comply with current safety standards.

1.3 Safety standards

Attention: the non-observance of the safety standards can jeopardize machine safety and therefore cause accidents to persons and/or damage the machine.

1. The machine is to be used by trained personnel.
2. Personnel in charge must carefully read the instructions for use before using the machine.
3. The machine is to be used only for the intended use.
4. **Do not carry out repairs or additional maintenance, part replacement or machine modifications without having been previously authorized by the manufacturer.**
5. For repairs use only spare parts that are explicitly authorized by the manufacturer.
6. The operator is in charge of checking the efficiency of all the protection systems foreseen before use.
7. The machine has been designed and manufactured in accordance with all the safety regulations. However, it is always necessary to avoid hazardous behavior that can be dangerous.

2 GENERAL INFORMATION

2.1 Machine description

The machine described in this manual is the Astra mat cutter for cutting a various types of matboard form 1.25 mm to 3 mm thick. Please respect this value in order to avoid breaking the cutting head and putting safety at risk.

The machine is supplied with measuring stops, and an easy to use blade holder to help you set up the cut.

The cutting head slides on four ball bearings which glide on two sturdy non-warping tempered steel tracks constantly cleaned by two small brushes placed beneath it.

2.2 Technical data

Machine technical data:

<i>Work surface in aluminum</i>	Astra 120 Astra 150	1200x800 mm / 47.25"x31.50" 1500x1000 mm / 59.00"x39.37"
<i>Dimensions (X.Y.H.) VOLUME</i>	Astra 120 Astra 150	1500x500x120 mm / 59.05"x19.68"x4.72" 1800x500x120 mm / 70.86"x19.68"x4.72"
<i>Weight</i>	Astra 120 Astra 150	Ca Kg 26 / 57.2 lbs Ca Kg 30 / 66 lbs
<i>Cutter</i>		Cutting head with 45° and 90°



2.3 Installation and terms of use

The customer will carry out the installation by following the instructions in this manual. The machine must rest on a stable, smooth surface making sure the guides are kept clean and well lubricated.

2.4 Transportation

2.4.1 Transportation and handling instructions

Transportation can be carried out in three ways:

- by container -



- by truck-



- by air mail -



**Check the box as soon as it arrives.
If the packaging is damaged accept the goods on condition.**

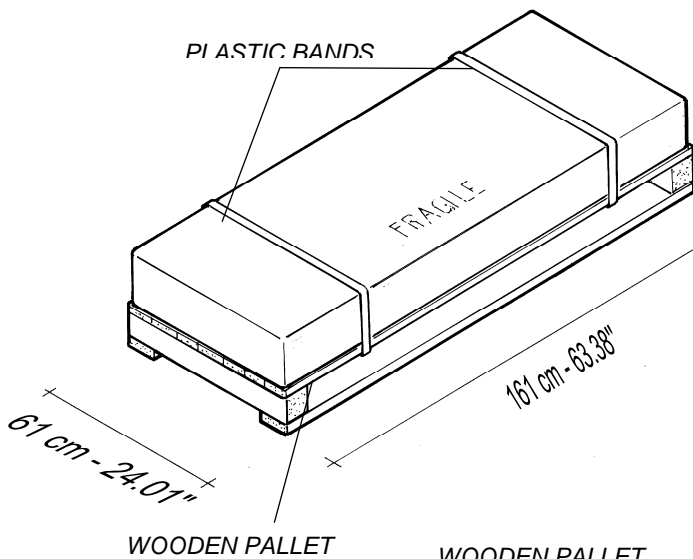
In these three cases in order to avoid damages during transportation the same type of packaging is provided. CORRUGATED CARDBOARD BOX SECURED WITH PLASTIC BANDS ON A WOODEN PALLET OF THE SAME DIMENSIONS.

The box contains the structure of the assembled machine, the extension and a spare blade kit.



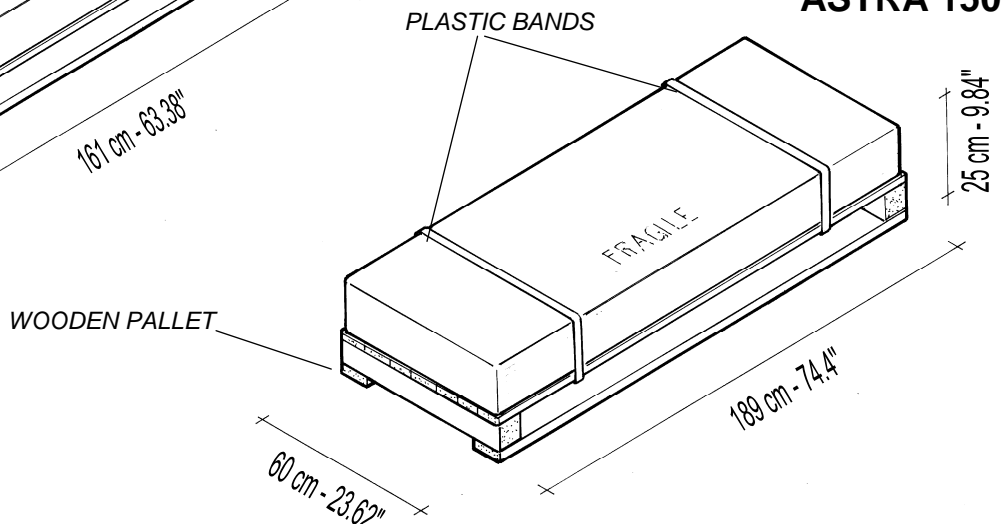
ATTENTION! Lift the box in two people.

ASTRA 120



Cut the plastic bands in order to open the box.

ASTRA 150



WEIGHT:	
Astra 120	35 kg / 77lbs
Astra 150	40 Kg / 88lbs

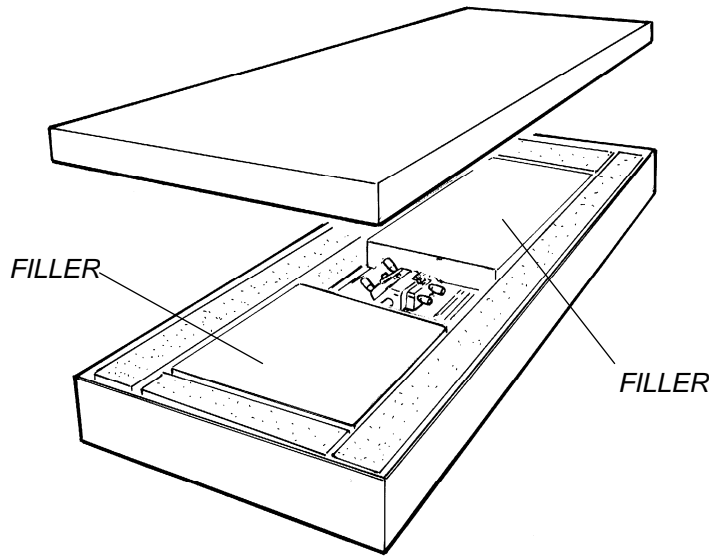


3 INSTALLATION

1. **OPENING THE BOX:** Remove the filler, then the base of the machine and the extension that is secured to the bottom of the box with tape. Make sure that the machine was not damaged during transportation, in this case immediately notify the transportation service.



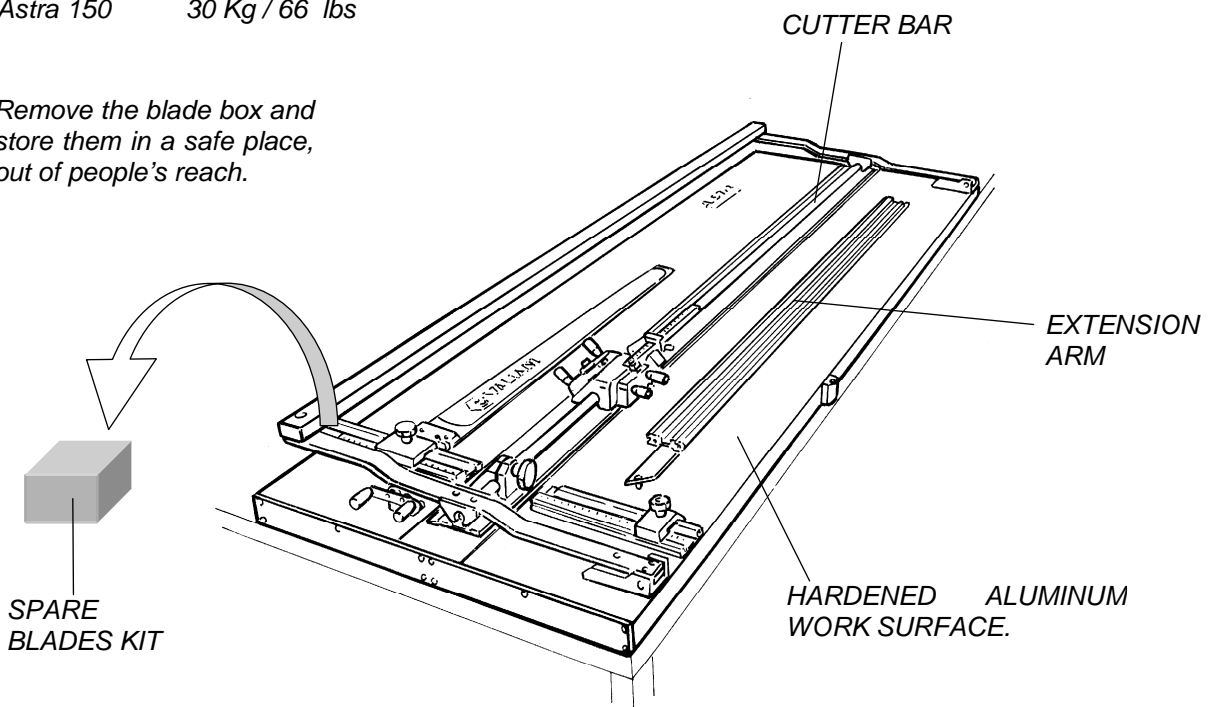
ATTENTION! Lift in two people when placing the box on an appropriate surface.



NETT WEIGHT:

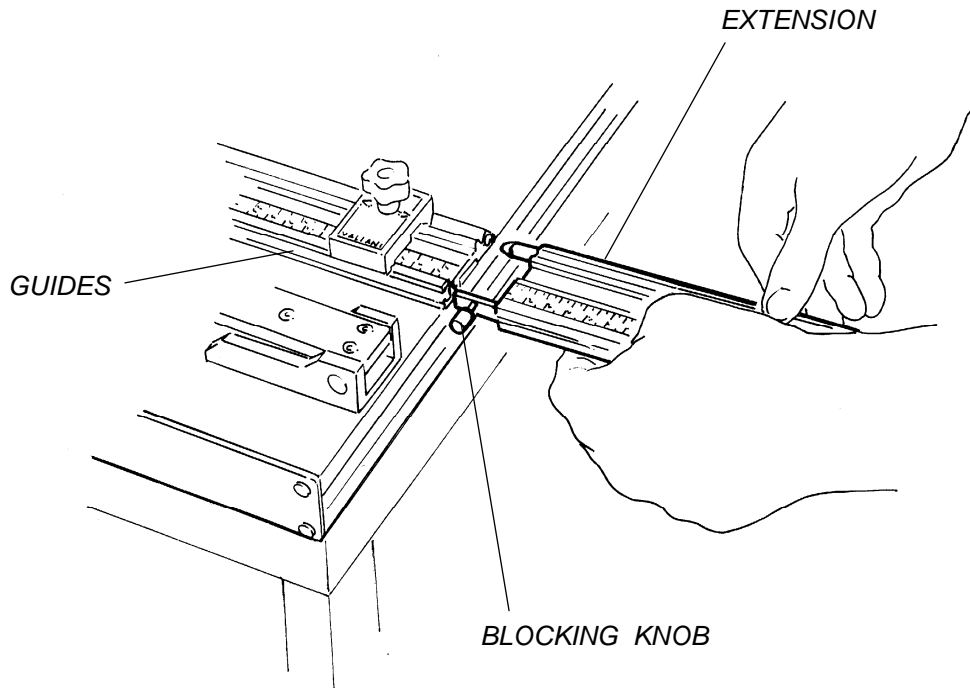
Astra 120	26 kg / 57.2 lbs
Astra 150	30 Kg / 66 lbs

Remove the blade box and store them in a safe place, out of people's reach.

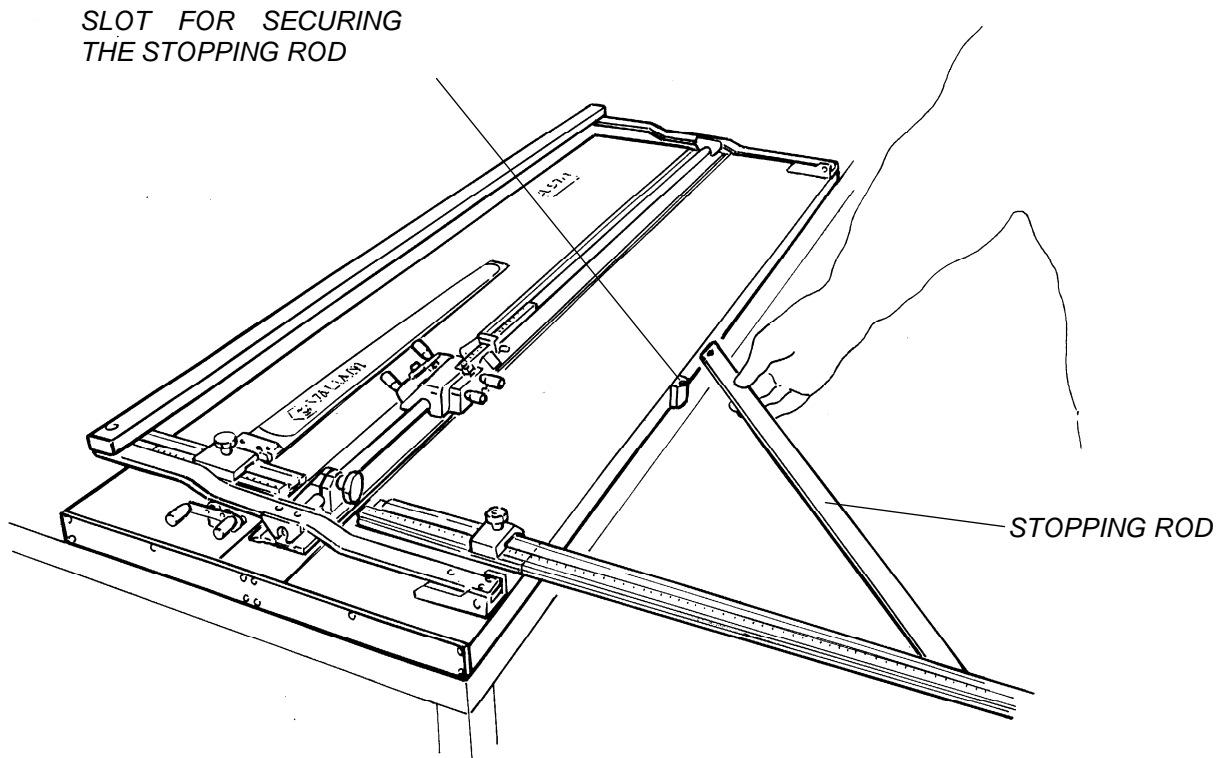




2. ATTACHING THE EXTENSION ARM TO THE WORK SURFACE: *Fit the extension arm in the appropriate slots and fasten it by turning the knob.*



3. SECURING THE EXTENSION TO THE WORK SURFACE: *After having connected the extension arm to the work base secure it by placing the stopping rod in the appropriate slot which is halfway down the aluminum base.*



N.B.: *For space saving reasons you may remove the extension.*

4 USE/OPERATION

The following paragraph will explain the proper use of the machine. Please follow these instructions in order to avoid dangerous situations. The manufacturer declines any responsibility for damages to people or things arising from improper use of the machine.

4.1 Machine use

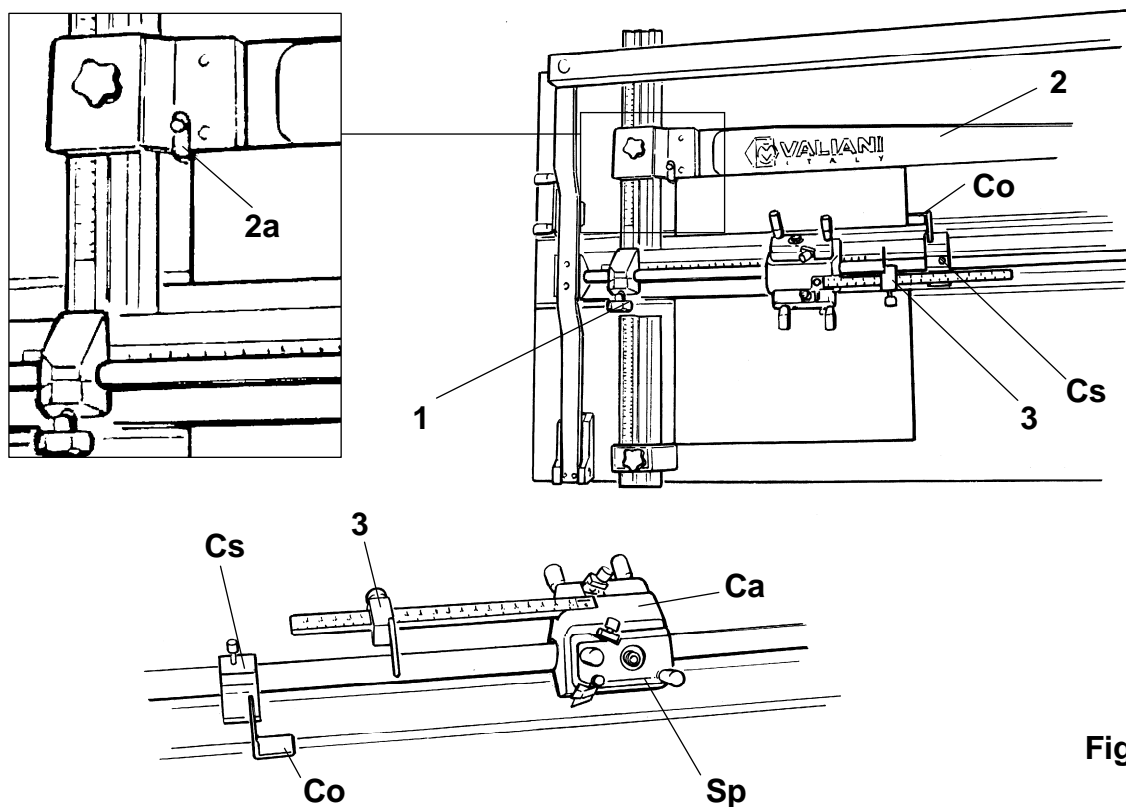


Fig. 5.1a

You make your cuts working the matboard facedown

- **Place a slipmat in position with 1.25 mm to 3mm thickness in order to protect the machine and to obtain a clean cut.**
- Position the matboard and establish the border measurement 1-2-3.
- Place the matboard against stop 2 and 2a.
- **It is important that the matboard is aligned for its length on stop 2**, this way we will be sure that the corners will be cut perfectly.
- Make the stop 3 connect to the movable stop **Cs**, by means of the magnet.
- Slide the carriage until the mat blocking stop **Co** touches the beginning of the matboard.
- Rotate the blade support **Sp** until the end of its run, then pull the carriage **Ca** until stop 1.
- Rotate the matboard by 90° and repeat the same procedure for the other cuts, making sure the magnets on the movable stop **Cs** connect to the stop 3 which determines the starting point of the cut.

4.2 Setting the blade depth

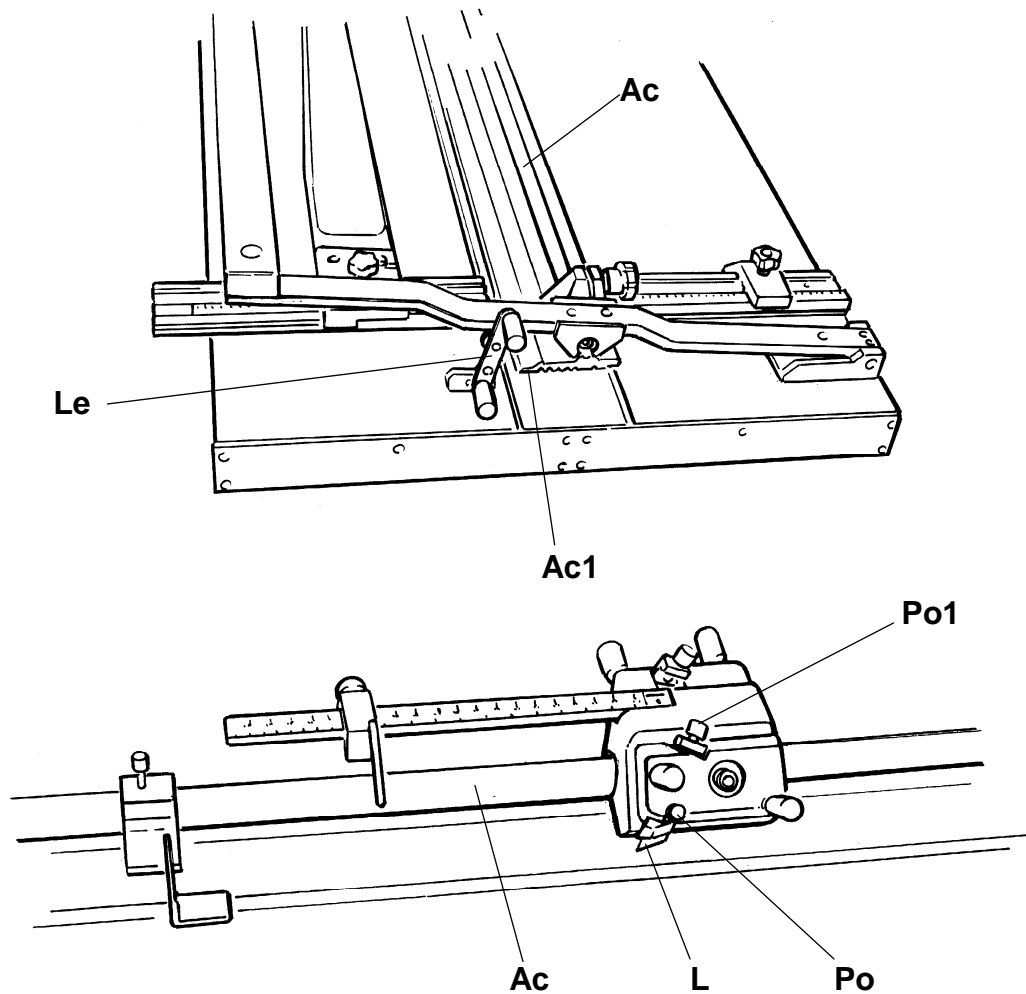


Fig. 5.2a

- Lift the cutter bar **Ac** using the lever **Le** and place the matboard to be cut in position up to the border **Ac1** and lower the cutter bar and begin working.
- Loosen the knob **Po**.
- Rotate the knob **Po1** place above the blade holder **PI**; clockwise to decrease the depth counterclockwise to increase it.
- Tighten the bolt **Po** to block the blade **L** and obtain a straight cut.
- Rotate the blade support **PI** by 45° until the end of its run, so that the tip of the blade cuts about 1 mm into the slipmat placed underneath the matboard you are cutting.
- This can be done on the 45° head as well as the 90° head.

N.B: An incorrect blade depth setting can cause errors in cutting.

4.2.1 Bevel Cutting

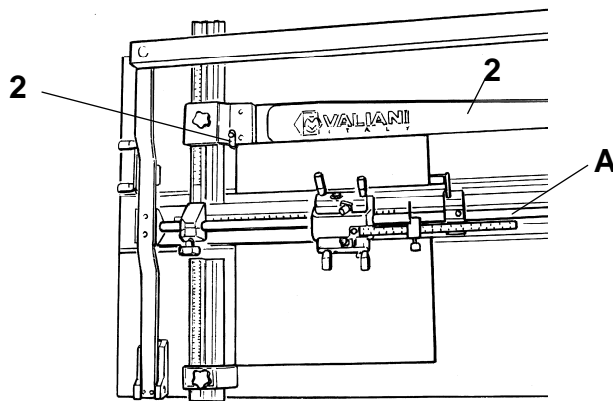


Fig.

- Make a normal cut, setting the measurements of where you want to place the cut.
- Once you have made the cut, move the squaring arm (stop 2) until you reach the end of its run. (towards the zero) placing the knob and the stop **2a** internally.
- Take the internal part of the matboard, we turn it with the good side face up and we align it against the squaring arm (stop 2) in this case very close to **Ac**.
- Make the cut, which will have a light 45° bevel of the internal matboard.
- Make the bevel cut. Secure the two matboards with adhesive tape, obtaining the desired effect.

4.2.2 Changing the blades



ATTENTION! Be very careful when changing the blade! Danger of being cut!

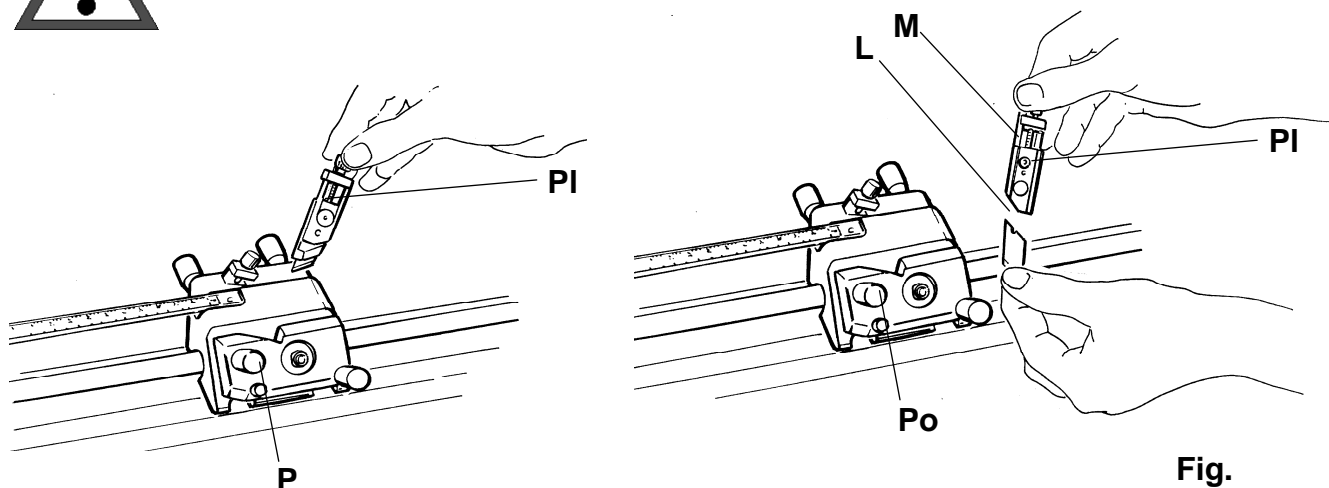


Fig.

- Loosen the knob **Po**.
- Remove the blade support **PI**.
- Change the blade **L** which will be held in place by the magnet **Ma**.
- Once you have changed the blade, reinsert the blade support **PI** and tighten the knob **Po**.



4.3 Maintenance and repair

You must periodically carry out maintenance and minor repairs.

- clean the work surface by removing scraps at least twice a week
- Lubricate with silicone spray the sliding parts, especially the cutter bar, once every six months.



ATTENTION! When cleaning the cutting head. Do not get too close to the blades. The blades can cause hand injuries.

For out of the ordinary maintenance, piece substitutions and modifications you must contact the manufacturer:

VALIANI s.r.l

Via delle Regioni, 305,307,309 – 50052 Certaldo (FI).

5 FAULT FINDING/ERRORS

The points below indicate the most common error/cause situations with relative interventions to carry out in the case of machine malfunctioning.

For any problem other those described please contact the manufacturer.

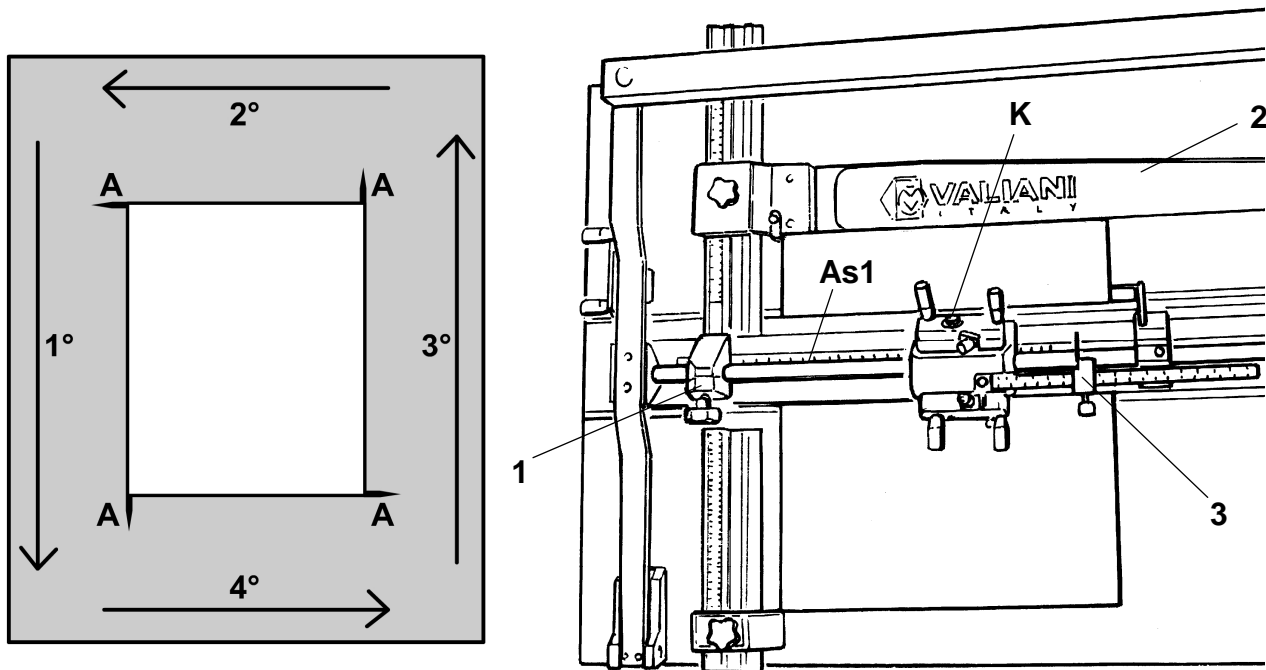
What to do if you do not achieve a perfect cut:

- 1) **The blade overcuts the ending point**
- 2) **The blade overcuts the starting point**
- 3) **The blade undercuts the corners**



1) The blade overcuts the ending point

IMPORTANT: Do not unscrew the nut K.



N.B. The millimetric rulers are blocked by a spring below. By exerting a slight pressure on them we can move them and make corrections.

In this case move the stop upwards (if the stop 1 was positioned at 5cm and the overcut was about 2mm, you will move to 5.2cm.)

You make another cut putting stop 2 at 5cm, the stop 1 at 5.2cm and stop 3 at 5cm.

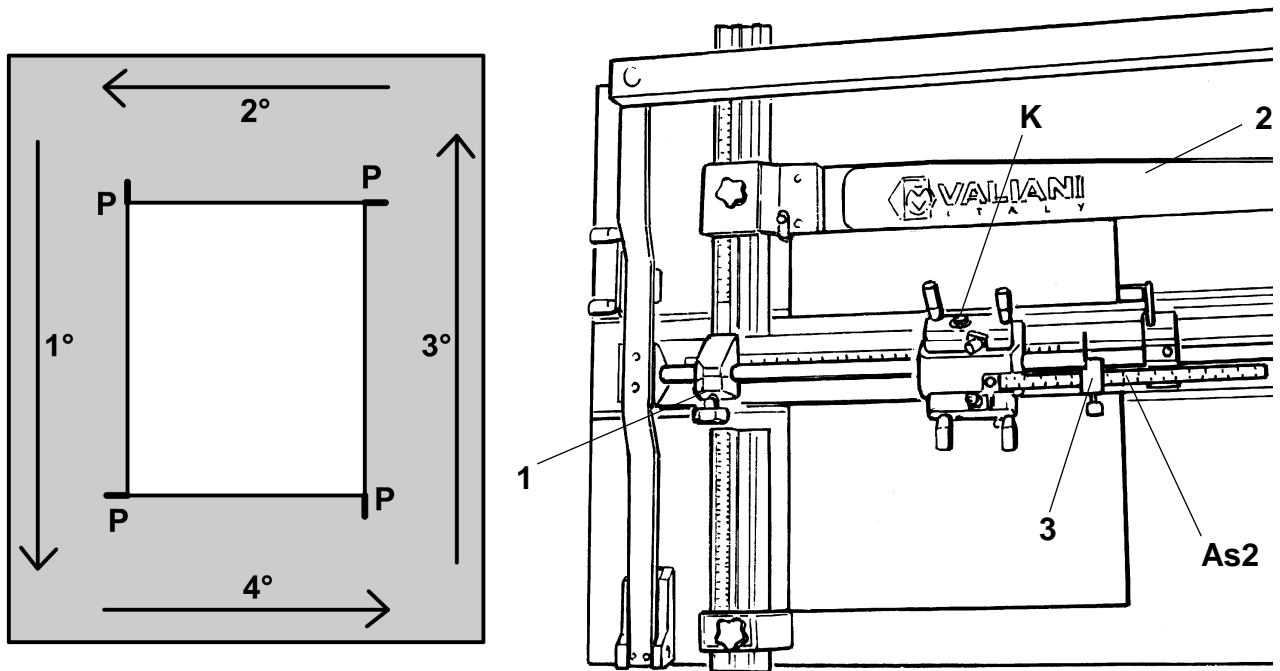
If you get a perfect cut then move the ruler **As1** until the indicator of stop 1 reads 5cm.

If this is not the case, repeat the procedure slightly moving the value of stop 1 until you achieve perfect corners.



2) The blade overcuts the starting point

IMPORTANT: Do not unscrew the nut K.



In this case you must move the stop **3** towards the top (eg, if the stop 3 was at 5cm and the overcut was of 2 mm, you will move the stop to 5.2 cm).

You make another cut placing the stop **2** at 5cm and the stop **3** at 5.2.

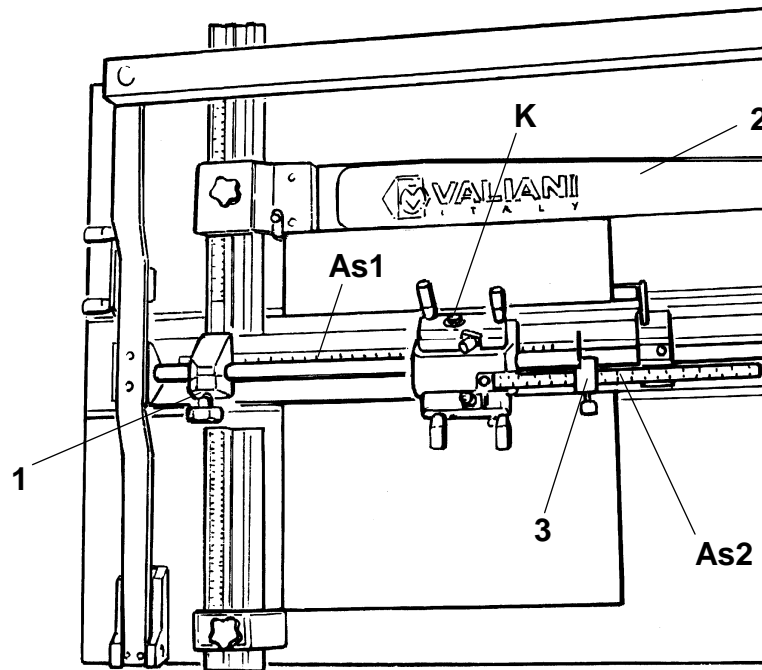
If you obtain perfect results, you will move the measuring arm **As2** until the indicator on the stop **3** reads 5cm.

If this does not occur, repeat this procedure moving slightly the stop **3** until you obtain perfect angles.



3) The blade undercuts the corners.

IMPORTANT: Do not unscrew the nut K.



In this case you will have to establish whether the error is caused by an error of the stop **1** or by the stop **3** or by both.

To fix this error follow the instructions on page 22 (point one) and page 23 (point 2) moving the stops in the appropriate direction.

6 SPARE PARTS

This manual includes tables with the list of components of the machine.

For maintenance purposes we also provide:

- Repair key
- Set of spare blades

Every part is identified by a number (also see in the reference drawing) and by a technical code.

The customer can request a spare part by filling out the request form and sending it to the manufacturer.



MANUAL DELIVERY LETTER

Manufacturer: VALIANI

Via delle Regioni, 305,307,309 – 50052 Certaldo FI

Machine data

Type

Model

Serial #

**The manufacturer delivers to
.....
the above mentioned machine along with the use manual and spare parts booklet.**

Date:

Signature