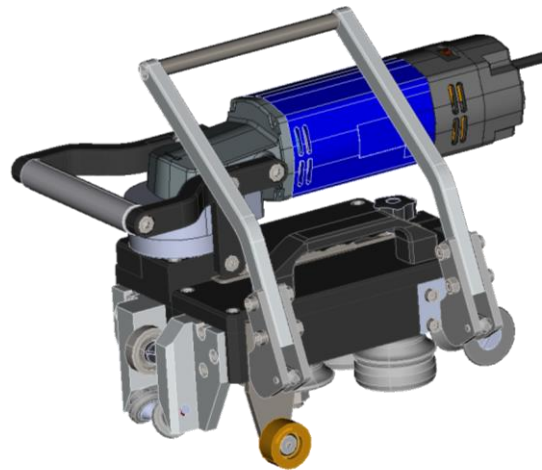


Original operating instructions of the Seaming Machine for BEMO standing seam profiles types: N65 / N50 / VF65



Type II (esma)

**Read carefully and
keep for future use!**


| | | | | |
|---|---------------|---------|----------|--|
|  | Date of issue | Version | Imprint: | BEMO SYSTEMS GmbH Max-Eyth str. 2 74532 Ilshofen- Eckartshausen |
| | 04.04.2024 | 03 | | |

TABLE OF CONTENTS

| | | |
|-----------|---|-----------|
| 1. | IMPORTANT BASIC INFORMATION | 4 |
| 1.1 | EQUIPMENT COMPONENTS AND CONTENT OF DELIVERY | 4 |
| 1.2 | SERVICE ADDRESS | 4 |
| 1.3 | LEGAL NOTICES | 5 |
| 2. | SECURITY | 6 |
| 2.1 | SYMBOLS USED IN THE OPERATING INSTRUCTIONS | 6 |
| 2.2 | GENERAL SAFETY INSTRUCTIONS FOR POWER TOOLS | 8 |
| 2.2.1 | <i>Safety instructions for the working area</i> | 8 |
| 2.2.2 | <i>Electrical Safety</i> | 8 |
| 2.2.3 | <i>Personal safety</i> | 8 |
| 2.2.4 | <i>Careful handling and use of power tools</i> | 9 |
| 2.2.5 | <i>Service</i> | 10 |
| 2.3 | DEVICE-SPECIFIC SAFETY INSTRUCTIONS | 11 |
| 2.4 | RESIDUAL RISKS | 12 |
| 3. | DESCRIPTION OF THE MACHINE | 13 |
| 3.1 | SECURITY | 13 |
| 3.2 | INTENDED USE | 14 |
| 3.3 | FORESEEABLE MISUSE | 14 |
| 3.4 | DUTY TO TAKE CARE AND REQUIREMENTS FOR THE SEAMING MACHINE OPERATOR | 15 |
| 4. | TECHNICAL DATA | 16 |
| 4.1 | NOISE AND VIBRATION INFORMATION | 16 |
| 4.2 | NOISE LEVEL | 16 |
| 4.3 | VIBRATION | 16 |
| 5. | TRANSPORT | 17 |
| 6. | PUTTING INTO OPERATION | 18 |
| 6.1 | SAFETY INSTRUCTIONS DURING PUTTING INTO OPERATION | 18 |
| 6.2 | REPLACING THE SEAMING ROLLERS | 18 |
| 6.3 | HEIGHT ADJUSTMENT OF THE SUPPORT ROLLERS | 19 |
| 7. | OPERATION | 20 |
| 7.1 | SAFETY INSTRUCTIONS | 20 |
| 7.2 | BEFORE THE SEAMING PROCESS | 20 |
| 7.2.1 | <i>Preparation of BEMO-sheets</i> | 20 |
| 7.2.2 | <i>Security of the seaming machine</i> | 21 |
| 7.2.3 | <i>Use of the seaming machine on roofs</i> | 21 |
| 7.2.4 | <i>Use of the seaming machine on facades</i> | 21 |
| 7.2.5 | <i>Placing of the seaming machine on the standing seam</i> | 22 |
| 7.2.6 | <i>Setting of the seam thickness</i> | 22 |
| 7.3 | CONNECTION OF THE SEAMING MACHINE | 23 |
| 7.4 | SWITCHING ON AND THE PROCESS OF SEAMING | 23 |
| 7.4.1 | <i>Safety instructions when seaming</i> | 23 |
| 7.4.2 | <i>Process of seaming</i> | 23 |
| 8. | MAINTENANCE AND CLEANING | 26 |
| 8.1 | SAFETY INSTRUCTIONS | 26 |
| 8.2 | REGULAR MAINTENANCE | 26 |
| 8.3 | SERVICE | 26 |

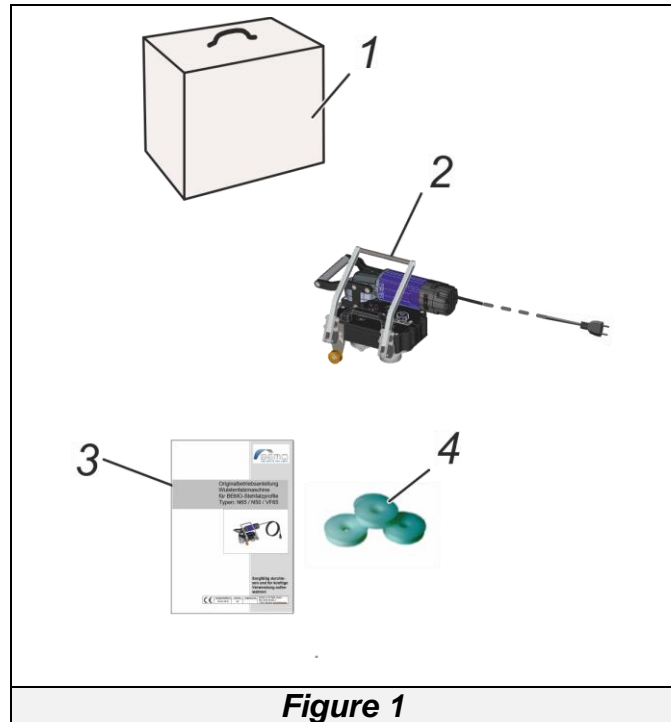
| | | |
|-----|-----------------------|-----------|
| 8.4 | SERVICE ADDRESS | 27 |
| 9. | STORAGE | 28 |
| 10. | DISPOSAL | 29 |

1. Important basic information

1.1 Equipment components and content of delivery

Please check the following contents of the packaging:

| Pos. | Description |
|------|---|
| 1 | Transport box |
| 2 | The seaming machine for BEMO standing seam profiles |
| 3 | Operating instructions |
| 4 | Plastic roller set (4 rollers) for coated BEMO standing seam profiles |



If parts or components are not included in the scope of delivery or the machine is damaged, please contact us immediately (see service address below).

1.2 Service address

| | |
|-------------------|--|
| Telephone: | +49 (0)7904 29899 60 |
| Email: | sales@bemo.com |
| Address: | BEMO SYSTEMS GmbH Max-Eyth str. 2 74532 Ilshofen-Eckartshausen |

1.3 Legal Notices



These operating instructions - neither as a whole nor in extracts-may be reproduced, distributed, modified, transferred, translated into another language or otherwise used electronically or mechanically without the express written permission of **BEMO SYSTEMS GmbH**.








BEMO SYSTEMS GmbH is not liable for damages resulting from the fact that the Operating instructions have not been observed or only partially observed.

2. Security





2.1 Symbols used in the operating instructions

The following symbols and signal words are used in this operating manual. These symbols should make the reader aware of the text of the safety note next to it.



| Symbol | Signal word | Definition | Consequences |
|---|-------------------|---------------------------------|--|
|  | DANGER! | Imminent danger | Death or serious injury |
| | WARNING! | Potentially dangerous situation | Possible death or serious injury |
| | CAUTION! | Less dangerous situation | Slight or minor injuries |
|  | ATTENTION! | Potentially damaging situation | Damage to the machine, its environment and the product |

| Symbol | Signal word | Definition |
|---|-----------------|--|
|  | NOTE! | Identifies information that helps to better understand machine operations. |
|  | NOTICE! | A special behavior or activity for the safe handling of the machine. |
|  | NOTICE! | Read the operating instructions! |
|  | NOTICE! | Pull the mains plug! |
|  | WARNING! | This symbol indicates the danger of dangerous electrical voltage. Imminent danger to the life and health of persons (serious injury or death). |
|  | WARNING! | Warning: risk of stumbling! |
|  | WARNING! | Warning: entanglement hazard! |

Symbols used in the operating instructions (continued)

| | | |
|---|-----------------------|---|
|  | <p>STOP!</p> | <p>This symbol indicates a prohibition.</p> |
|  | <p>NOTICE!</p> | <p>This symbol requires to wear safety shoes.</p> |
|  | <p>NOTICE!</p> | <p>This symbol requires to wear a helmet.</p> |
|  | <p>NOTICE!</p> | <p>This symbol requires to wear hearing protection.</p> |

2.2 General safety instructions for power tools

| | |
|---|--|
|  | <p>WARNING! Read all safety warnings and all instructions. Failure to follow the safety instructions and instructions may result in electric shock, fire and / or serious injury. Keep all safety instructions and directions for the future.</p> |
|  | |

The term "**power tool**" used in the safety notes refers to power tools powered by the mains (with mains cable).

2.2.1 Safety instructions for the working area

Keep your working area clean and tidy.
Untidiness and unlit at the working areas can lead to accidents.

Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.
Power tools create sparks which may ignite the dust or fumes.

Keep children and bystanders away while operating a power tool.
Distractions can cause you to lose control of the equipment.

Do not leave the power tool to run unattended.
Do not leave the power tool until it has been switched off and completely stopped.

2.2.2 Electrical Safety

The plug of the equipment must match the plug socket. Never modify the plug in any way. Do not use any adapter plugs

together with earthed equipment.
Unmodified plugs and matching outlets will reduce the risk of electric shock.

Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators.
There is an increased risk of electric shock if your body is earthed or grounded.

Keep the equipment away from rain, dirt or humidity.
Water entering a power tool will increase the risk of electric shock.

Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.
Damaged or entangled cables increase the risk of electric shock.

When operating a power tool outdoors, use an extension cord suitable for outdoor use.
Use of a cord suitable for outdoor use reduces the risk of electric shock.

If the operation of the power tool is not possible in a humid environment, use a ground fault interrupter (FI).
The use of a ground fault interrupter reduces the risk of electric shock.

2.2.3 Personal safety

Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.
A moment of inattention while operating power tools may result in serious personal injury.

Avoid accidental starting. Ensure the switch is in the off position before you connect it to the power supply, accommodate or carry it.

Carrying power tools with your finger on the switch or plugging in power tools that have the switch on can lead to accidents.

Remove any adjusting key or wrench before turning the power tool on.

A wrench or a key left attached to a rotating part of the power tool may result in personal injury.

Do not overreach. Keep proper footing and balance at all times.

This enables better control of the power tool in unexpected situations.

Do not allow yourself to be complacent by habit gained through frequent use of the equipment and disregard the basic safety principles of the equipment.

Careless activity can cause serious injury within a fraction of a second.

Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.
Loose clothes, jewelry or long hair can be caught in moving parts.

2.2.4 Careful handling and use of power tools

Do not force the power tool. Use the correct power tool for your application.

The correct power tool will do the job better and safer at the rate for which it was designed.

Do not use the power tool if the switch does not turn it on and off.

Any power tool that cannot be controlled with the switch is dangerous and must be repaired.



Disconnect the plug from the power source before making any adjustments, changing accessories, performing maintenance and cleaning or moving the equipment away.

Such preventive safety measures reduce the risk of starting the power tool accidentally

Store idle power tools out of the reach of children. Do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.

Power tools are dangerous in the hands of untrained users.

Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the operation of the power tool. If damaged, have the power tool repaired before use.

Many accidents are caused by poorly maintained power tools

Keep cutting tools sharp and clean.

Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control

Use the power tool, accessories and tool bits etc., in accordance with these instructions and in the manner intended for the particular type of power tool.

Take into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.

Do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Power tools are dangerous in the hands of untrained users.

In the switched-on mode, only hold the device by the handles. Keep handles dry,

clean and free from oil and grease. *Slippery handles do not allow safe handling and control of the power tool in unexpected situations.*

2.2.5 Service

Have your power tool repaired only by qualified personnel using original spare parts.

This will ensure that the safety of the power tool is maintained.

Use only original parts of BEMO SYSTEMS GmbH for repair and maintenance.

Use of accessories or spare parts that are not intended for this purpose may result in electric shock or injury.

2.3 Device-specific safety instructions

| | |
|--|---|
| | <p>STOP! The seaming machine is not splash-proof according to IP 20. Working in the rain is not permitted!</p> |
| | <p>STOP! Working on sheet metal roofs in the event of rain and snow is not permitted according to DIN 18339 accident prevention regulations.</p> |
| | <p>CAUTION! Risk of entanglement due to rotating rollers on the underside of the machine. Always use only the handles to reach the machine when it is switched on!</p> |
| | <p>WARNING! Risk of entanglement and crushing due to rotating gears if the lever is not closed. The lever must be closed before switching on the machine!</p> |
| | <p>NOTICE! Ear Protection must be worn! Exposure to noise can cause hearing loss.</p> |
| | <p>ATTENTION! Risk of tripping and falling due to cables while working. When working, always remove the power cord and extension cord from the back of the unit.</p> |

| | |
|--|---|
| | <p>WARNING! The machine must never be operated without protection. It is essential to secure the machine against falling by means of a rope adapted to the weight of the machine. Control the machine additionally during the seaming process.</p> |
|--|---|

| | |
|--|---|
| | <p>ATTENTION! The machine may only be used for the profiles specified in the technical data. The application to other profiles is not permitted.</p> |
|--|---|

The machine may only be operated, maintained and repaired by qualified personnel trained by BEMO System GmbH. This staff must be specifically informed of the hazards that occur. The accident prevention regulations must be strictly observed.

The seaming rollers must be designed at least for the speed specified on the power tool.
Seaming rollers running at over speed can fly apart and cause injury.

Never place the power tool, which is switched on, against the seam to be processed.

Move the switch to the "0" position before removing the plug from the socket.

If the power tool is later reconnected to the mains, it will prevent the machine from starting up unintentionally and reduce the risk of accidents.

Unused power tools must be kept safe, in dry locked rooms and unreachable for children!

To identify the power tool, the housing must not be drilled.

*The protective insulation will be broken.
Use adhesive labels.*

Do not use the power tool with a damaged cable. Do not touch the damaged cable and pull the mains plug, if the cable is damaged while working.

Damaged cables increase the risk of electric shock.

Before each use, check the power tool for wear out. The electric tool must be able to be completely closed via the lever and the seaming rollers must be securely mounted.

If the power tool falls, check if it is damaged.

After you have checked the power tool, keep yourself and other persons standing near away from it and allow the machine to run at maximum speed for a minute.

Only adhesive labels may be used to mark the machine.

The machine must not be drilled in for this purpose.

Regularly clean the ventilation slots of the machine. The motor fan draws dust into the housing and excessive accumulation of powdered metal may cause electrical hazards. Do not use the machine near flammable materials. Sparks can ignite these materials

Use the two handles on the machine when inserting it onto the standing seam profile.

Make sure that the working area is

always sufficiently illuminated. Never work without lighting or at twilight.

If the machine gets jammed, turn off it immediately

2.4 Residual risks

Although this operating manual contains detailed information on safe working with the machine, it contains certain residual risks, which cannot be completely excluded by safety measures. Therefore, always operate the machine with the necessary caution!

3. Description of the machine

3.1 Security



NOTICE!

Read all safety warnings and all instructions.

Failure to follow the safety instructions and instructions may result in electric shock, fire and / or serious injury.

Keep all safety instructions and directions for the future.

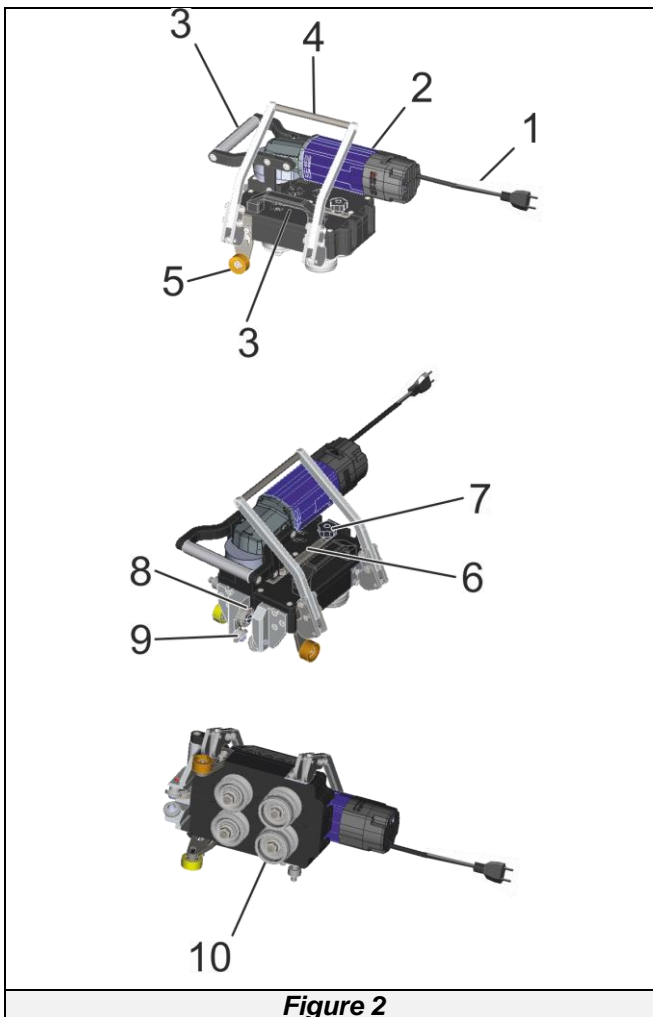


Figure 2

| Pos. | Description |
|------|---|
| 1 | Mains connection cable with plug 230V / 50 Hz (110 V / 60 Hz) |
| 2 | Motor with on/off switch and speed control |
| 3 | Handles for mounting and dismounting of the seaming machine on the BEMO standing seam |
| 4 | Lever |
| 5 | The support rollers |
| 6 | Setting angle |
| 7 | The clamping screw of setting angle |
| 8 | Rolls for rounding |
| 9 | Rolls for rounding |
| 10 | Seaming roll (total 4 pcs) |

3.2 Intended use

The seaming machine is determined for the close of the **standing seam profile types N65 / N50 / VF65** for sheet metal roofs and facades of the **BEMO SYSTEM GmbH**. The machine may only be used in the procedure described in this operating manual. The **machine** is not intended for a type of use other than that described above - this is considered as inappropriate use.

The intended use also includes observing all the instructions in this operating manual, in the assembly instructions for BEMO SYSTEMS standing seam profiles and observing the maintenance work. **BEMO SYSTEMS GmbH** is not liable for damage caused by incorrect use or failure to observe these operating instructions!

3.3 Foreseeable misuse

- Failure to observe the instructions in Chapter **Intended use 3.2**
- Machine is operated by untrained artisans or amateurs. Training / instruction by other persons or by a company other than BEMO SYSTEMS GmbH is not permitted.**
- Machine is not monitored during the seaming.
- The machine is not connected to the safety cable before use and the safety cable is not attached or connected to the operator.
- The lever is not closed before switching on the machine.
- Getting on the machine with your feet.
- Operation / use of the machine in case of rain or snow.
- Processing of profiles other than those specified in these operating instructions.
- Transporting of the machine or the carrying case as a floating load.
- Work overhead.
- Loss of control over the machine.
- Use of the machine in a potentially explosive area.
- Use of non-original spare parts.

- ❑ A reflexive behavior of the user operating the machine in case of a malfunction, a misconduct or a breakdown.
- ❑ Carelessness and lack of concentration of personnel working on the machine.
- ❑ Failure to follow these operating / assembly instructions

3.4 Duty to take care and requirements for the seaming machine operator



NOTICE!

Non-slip safety shoes must be worn!



NOTICE!

Ear Protection must be worn!



NOTICE!

Visit the training by **BEMO SYSTEMS GmbH**



NOTICE!

Read these operating instructions and the installation instructions for the BEMO standing seam profiles!



NOTICE!

Secure seaming machine with a safety cable before you start the seaming process!



NOTICE!

All work on roofs and facades must comply with the relevant occupational safety guidelines and safety regulations!

4. Technical Data

| Description | Seaming machine for BEMO standing seam profiles |
|---|---|
| Connection | 230 V / 50 Hz (110V / 60 Hz) |
| Input power | 1050 W |
| Adjustable rotation speed of drive axle | 180 – 700 r.p.m |
| Dimensions (L x W x H) | 340 x 250 x 270 mm |
| Weight | 12 kg |
| Safety class | II |
| Permissible ambient temperature: | -10°C to + 50°C |
| Allowed relative humidity: | 90% at 30°C and 65% at 50°C |
| Profiles allowed for the work | BEMO standing seam profiles N65 / N50 / VF654 |

4.1 Noise and vibration information

4.2 Noise level

The measurements were carried out on a technically comparable machine.

The A-rated noise level of the machine is typically:

| | |
|-----------------------------------|-----------|
| Sound Pressure Level (L_{pa}) | 85 dB (A) |
| Measurement Uncertainty K | 3dB(A) |



Hearing protection must be worn!

4.3 Vibration

Triaxial vibration emission value is determined according to EN 60745.

| | |
|---|------------------------|
| Vibration emission value a_h | 2.5 m / s ² |
| Measurement Uncertainty K | 1.5 m / s ² |
| The vibration level specified in these operating instructions has been measured according to a measurement method standardized in EN 60745 and can be used for device comparison. | |

The vibration level will change in accordance with the use of the machine and may in some cases be higher than the value indicated in these instructions. The vibration load could be underestimated if the machine is used regularly in such a way.

Note:

For an accurate estimation of the vibration load during a certain working period should also be taken into account the time in which the device is switched off or running, but is not actually in use. This can significantly reduce the vibration load over the entire working period. Define additional safety measures to protect the operator from the effects of vibrations such as: maintenance of electric and insertion tools, keeping hands warm, organization of work processes.

5. Transport

Seaming machine must be transported to the place of use in the transport box.

**WARNING!**

The seaming machine must always be transported in the transport box. Never transport the transport box to the place of use as a floating load.

6. Putting into operation

6.1 Safety instructions during putting into operation

| | |
|--|---|
| | <p>WARNING! Accidental start of the machine can result in injuries! Always pull the plug out of the socket before making adjustments to the machine, changing accessories or moving the machine away.</p> |
| | |

| | |
|--|--|
| | <p>WARNING! Observe the mains voltage! Before putting the machine into operation check whether the mains voltage and frequency indicated on the type label match the data of your mains power supply. Never install damaged power cable. Damaged power cable must be replaced immediately by an expert.</p> |
|--|--|

6.2 Replacing the seaming rollers

Steel rollers are mounted on the machine at delivery as standard. For the use of the machine with **coated BEMO Systems GmbH standing seam profiles**, the four steel rollers (1) must be disassembled and the plastic rollers (4) must be used as follows:

- Loosen the nuts (2) with a hexagon key and remove them together with tooth lock washers (3)
- Pull the steel rollers in the direction of the arrow (1)
- Slide the rollers to the relative axis. To fully insert the rollers, they may have to be twisted slightly, so that the key (5) fits into the groove of the roller.

- Slide the lock washers (3) back onto the axle and secure the rollers over the nuts (2) again.

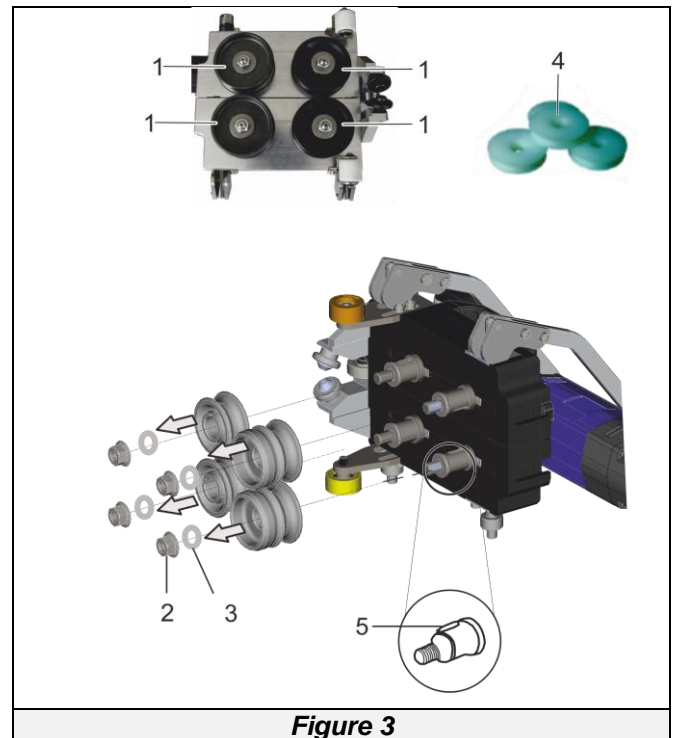


Figure 3

| | |
|--|---|
| | <p>ATTENTION! After changing the seaming rollers, they must be checked for correct fit and correct installation. After inserting the seam rollers, perform a test run at maximum speed.</p> |
|--|---|

6.3 Height adjustment of the support rollers

Depending on the height of the standing seam profiles it may be necessary to adjust the support rollers (5) in the height on both sides of the seaming machine.

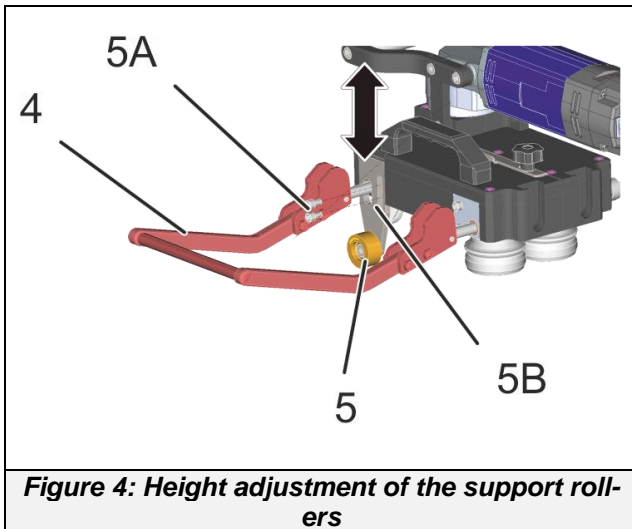


Figure 4: Height adjustment of the support rollers

- Open the lever (4) fully for it.
- Loosen the two Allen screws (5A) on both sides of seaming machine, and move the suspension (5B) for the bearing rollers, depending on the height of the standing seam profile, up or down. Then reattach the related suspension with support rollers and (4) close the lever again.

7. Operation

7.1 Safety instructions

| | |
|--|---|
| | Ear Protection must be worn! |
| | The seaming machine may only be used by mechanic trained at BEMO SYSTEM GmbH! |
| | All work on roofs and facades must comply with the relevant occupational safety guidelines and safety regulations! |
| | Working on sheet metal roofs in the event of rain and snow is not permitted according to DIN 18339 accident prevention regulations! |
| | <p>WARNING! The seaming machine must necessarily be secured with a rope against falling when working on roofs and facades. Control the machine during the seaming process.</p> |
| | <p>WARNING! The lever must be closed before switching on the seaming machine. The lever may not be opened again until the machine has been switched off before.</p> |
| | <p>WARNING! Never place anything on the machine. Do not pull, push or press on the machine from above. The operator must be protected against falling when working with the machine on roofs or facades.</p> |

7.2 Before the seaming process

7.2.1 Preparation of BEMO-sheets

The BEMO sheets must be prepared accordingly before seaming. For this purpose, the first 20-30 cm must be pre-seamed with the BEMO hand seaming tool before seaming with the seaming machine.



Figure 5: Preparatory seaming with hand seaming tool

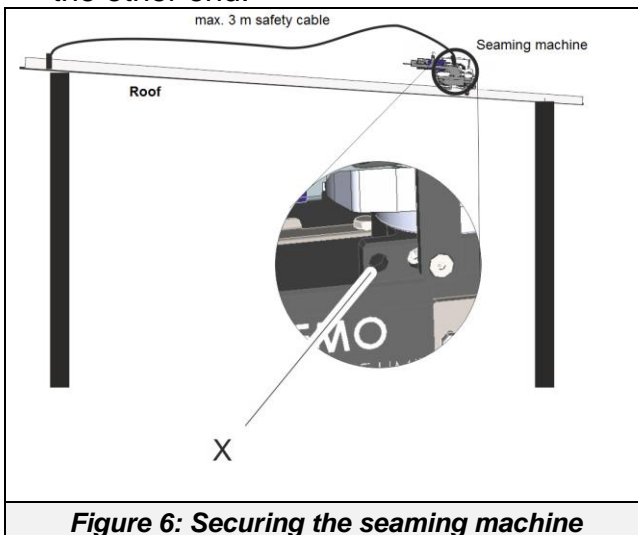
For more information on the installation and preparation of the BEMO sheets, please refer to the ***Installation instructions of BEMO STANDING SEAM***

7.2.2 Security of the seaming machine

| | |
|--|---|
| | <p>WARNING! The seaming machine must never be used on roofs and facades without supervision and security. Under no circumstances should the machine fall from the roof / facade.</p> |
|--|---|

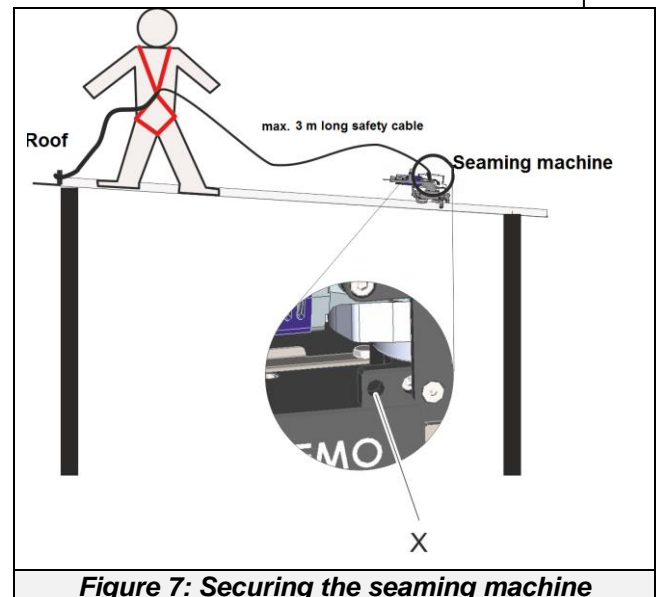
7.2.3 Use of the seaming machine on roofs

- Secure the safety cable to the hole (X) of the **seaming machine** by means of snap hooks and secure it to the roof at the other end.



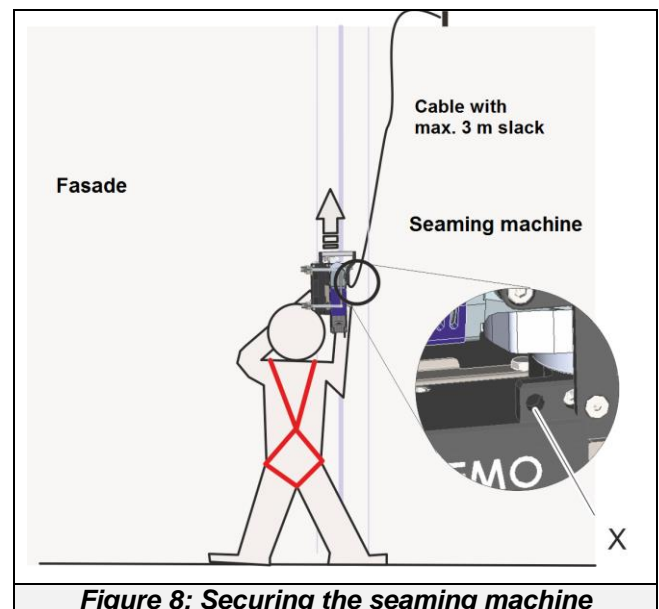
or:

- Connect one end of a 3 m long safety cable to the seaming machine's hole (X) by means of snap hooks, the other end to the **operator** secured to the roof. Control and follow the machine during the seaming process.



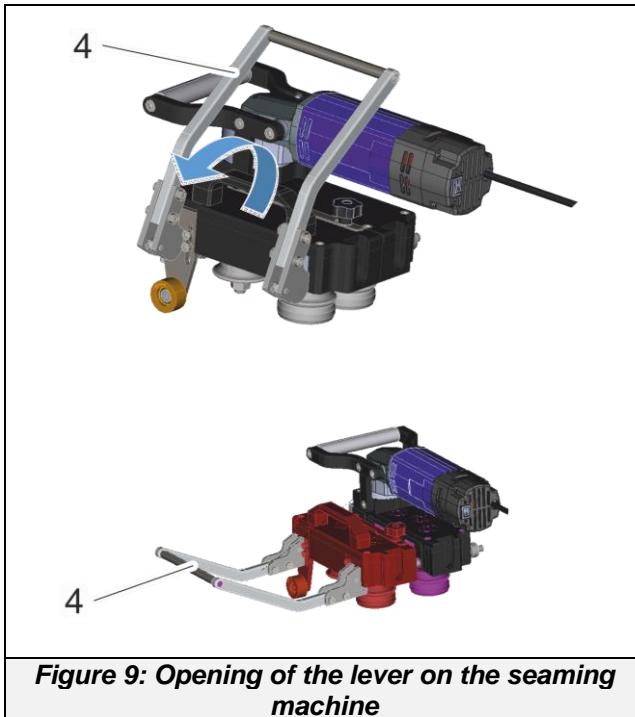
7.2.4 Use of the seaming machine on facades

Secure the seaming machine with a safety cable from above, with max. 3.0 m through the slope over the snap hook to the hole (X)

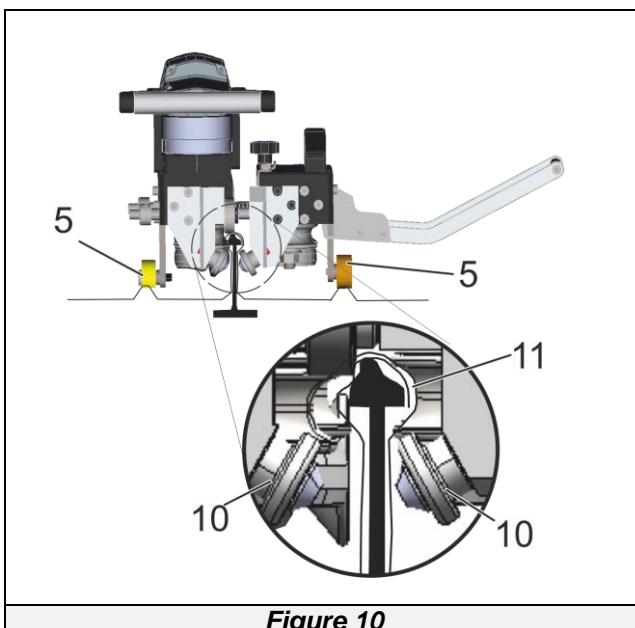


7.2.5 Place WUFA on standing seam

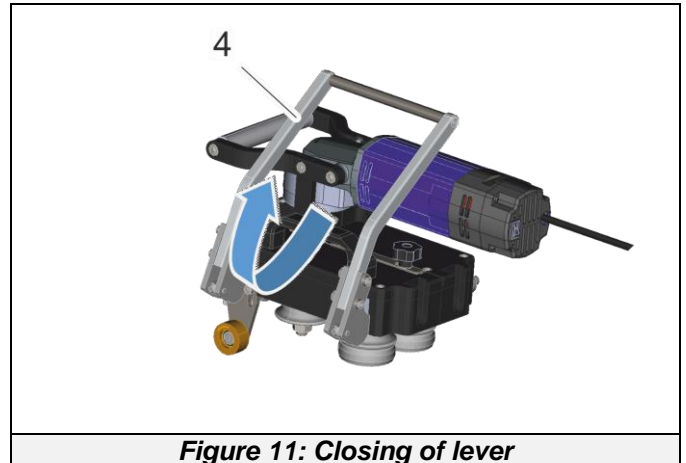
- Open the lever (4) on the seaming machine (4).



- Place the open machine on BEMO standing seam, so that support rolls (5) have contact with the sheet and the seaming rolls (10) are enclosing the big eye (11).

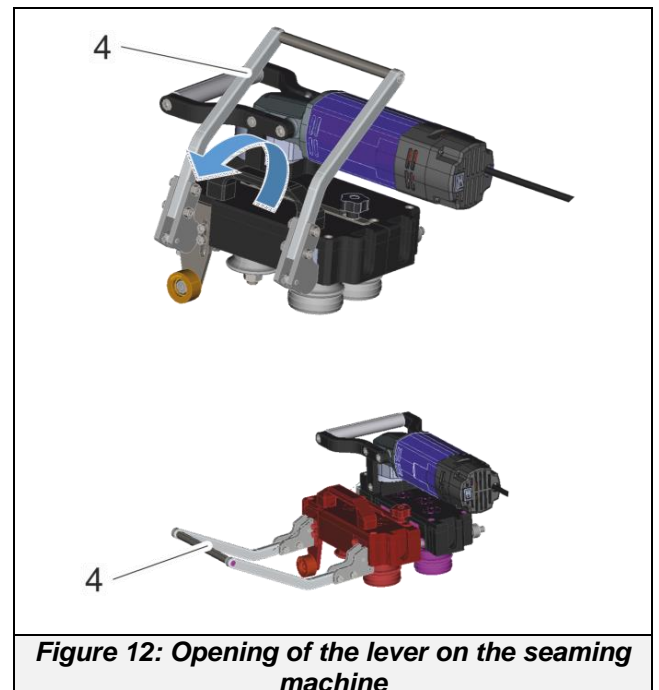


- Close the lever (4) completely again.



7.2.6 Setting of the seam thickness

- Open the lever (4) on the seaming machine.



- Loosen the clamping screw (8) slightly.

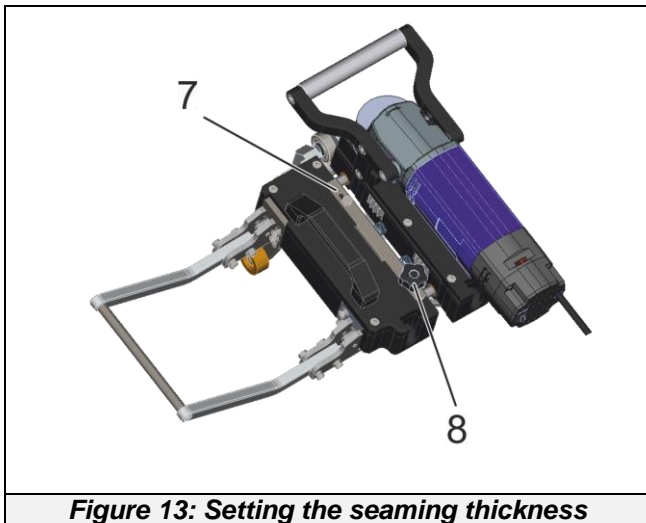


Figure 13: Setting the seaming thickness

- To adjust the seaming thickness, the gap plate (7) can be placed accordingly. Then close the clamping screw again.
- Close the lever (4) completely again.

7.3 Connection of the seaming machine

The seaming machine should be connected to 230V / 50 Hz via the plug (1)

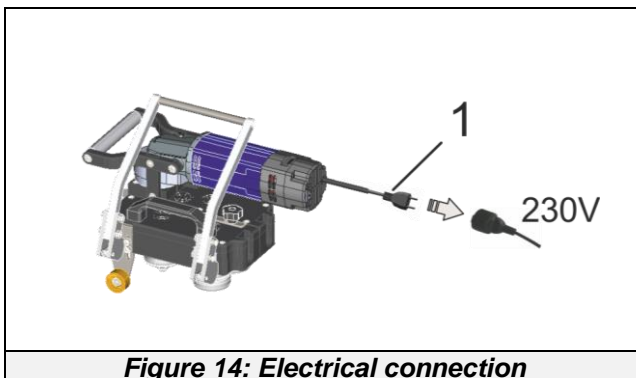


Figure 14: Electrical connection

7.4 Switching on and the process of seaming

7.4.1 Safety instructions when seaming



WARNING!

The machine runs automatically after switching on. Do not walk nearby the sheets and never place them on the machine. Make sure that the work area is free of tripping hazards.



CAUTION!

Always grab the seaming machine on two handles. If both hands hold the machine, they cannot get between the folding rollers.



WARNING!

Never move the switched on machine to the standing seam to be seamed.



WARNING!

When working, always remove the power cord and extension cord from the back of the unit.



WARNING!

Make sure that the machine is secured with the securing cable.

7.4.2 Seaming performance

- Set the speed using the setting wheel (A) on the smallest stage (180 U/min, – the drive axle). The speed can be adjusted up to max. 700 rpm.

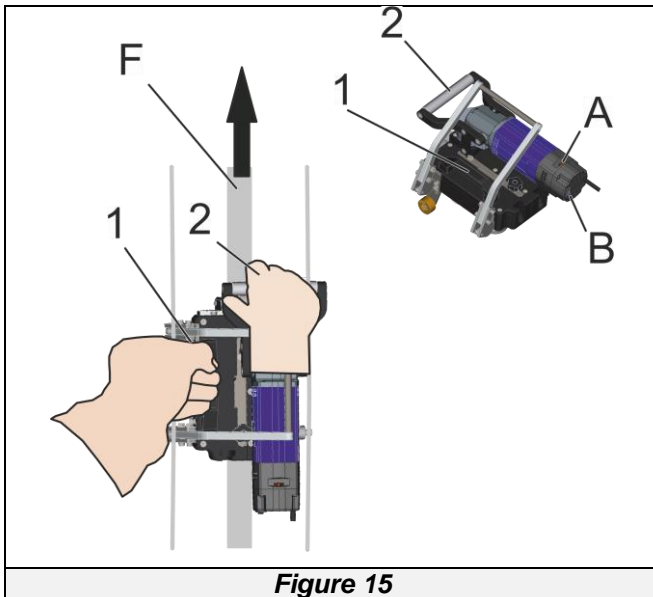


Figure 15

- If necessary, the machine must be operated with both hands for the subsequent seaming operation, i.e. one Hand on the handle (1) and the other Hand on the handle (2) (handle directly on the driving engine).

Starting current limitation:

The seaming machine has a starting current limitation. The electronically controlled soft start ensures smooth start of the machine.

Temperature-Dependent Overload Protection:

To protect from overheating, the safety electronics switches to cooling mode when a critical temperature is reached. The machine continues then to run at lower speed and the constant electronics is deactivated. After a cooling time of about 10 - 20 seconds the machine is ready for operation again. The machine must be switched off and switched on again to activate the constant electronics.

In the case of a warmed-up machine, the temperature-dependent overload protection reacts correspondingly earlier.

Under Voltage Protection / Restart Protection:

In the event of a short-term failure of the supply voltage (e.g. when the mains plug is pulled, non-stable supply network, etc.), the

machine stops. After the supply voltage has been restored, the machine must be switched off and switched on again. The machine is then ready for operation.

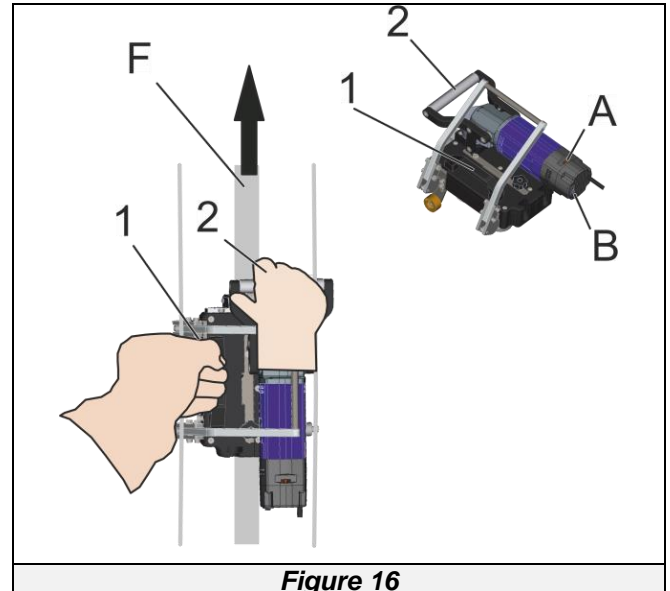


Figure 16

- Use the on-off switch (B) to turn on the machine. The machine then moves independently in the direction of the arrow.
- The seaming machine must be constantly monitored by the operator during the seaming process. The speed control (A) can be used to set the travel speed faster or slower.
- Switch off the seaming machine via the on-off switch (B) once it has reached the end of the standing seam (F).
- After opening the lever (4) the seaming machine can be removed from the standing seam.



Figure 17: Opening of the lever on the seaming machine

8. Maintenance and cleaning

8.1 Safety instructions



NOTICE!

Unplug the power cable before working on the machine.



DANGER!

Work on the electrical system of the machine may only be carried out by an electrical workshop

8.2 Regular Maintenance

- Wipe plastic parts regularly with a cloth that does not contain any detergent.
- Always keep the machine and the ventilation slots of the driving engine clean to ensure good and safe operation.
- Check the machine regularly for wear. In the case of wear and tear please contact **BEMO SYSTEMS GmbH**. Only original wear parts from **BEMO SYSTEMS GmbH** may be used.
- Check the safety cable regularly to secure the machine. Replace it immediately if it is damaged.
- Check the incoming cable for its undamaged condition. If the cable is damaged, it must be renewed or replaced immediately by an electrical workshop.
- Clean the closing area (**S**) after each use of the machine and if it is dirty.

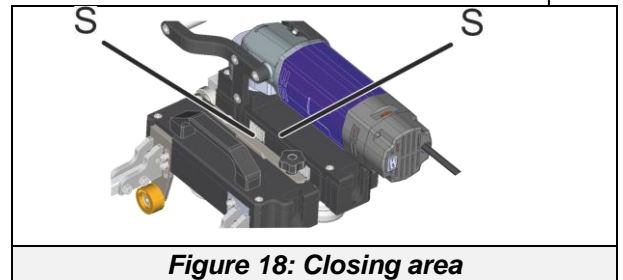


Figure 18: Closing area

- Clean the gears and seaming rollers if they are dirty. Lubricate the gears and rollers with following oil: Berner multi oil or WD40. Alternatively, comparable products can be used. Regular cleaning and proper storage are decisive for the service life of the seaming rollers
- After approximately 200 hours of operation, the carbon brushes should be checked or replaced. In addition, clean the motor housing and replace the grease filling in the gearbox housing. When coal is used, the machine switches off automatically. For this purpose please contact **BEMO SYSTEMS GmbH**.
- In order to maintain the protective insulation, the machine must undergo a safety check. This work must only be carried out by an electrical workshop.
- In the event of bad seaming results, please contact **BEMO SYSTEMS GmbH**.
- In the event of unreadable or damaged labels on the machine, they must be replaced immediately. Contact immediately **BEMO SYSTEMS GmbH** in this case.
- Replacement of seaming rollers
See the description in the **Chapter 6.2**.

8.3 Service

- In the event of malfunction, please contact **BEMO SYSTEMS GmbH**.
- In the case of worn carbon brushes or after use over a longer period of time (1

year), the machine must be sent to **BEMO SYSTEMS GmbH** for inspection and thorough cleaning.

8.4 Service address

| | |
|-------------------|--|
| Telephone: | +49 (0)7904 29899 60 |
| Email: | sales@bemo.com |
| Address: | BEMO SYSTEMS GmbH Max-Eyth str. 2 74532 Ilshofen-Eckartshausen |

9. Storage

Regular cleaning and proper storage are important for the service life of the seaming machine. The clean, dry and oiled seaming machine must be stored in the transport box.

10. Disposal



Recycling of raw materials instead of waste disposal. Equipment, accessories and packaging should be treated in an environmentally compatible way for re-use. The plastic parts are marked for the recycling process.



Do not dispose of power tools in household waste.

According to the European directive 2002/96/EC for used electric and electronic devices and according to national regulations, all used power tools must be collected separately and treated in an environmentally compatible way for re-use.