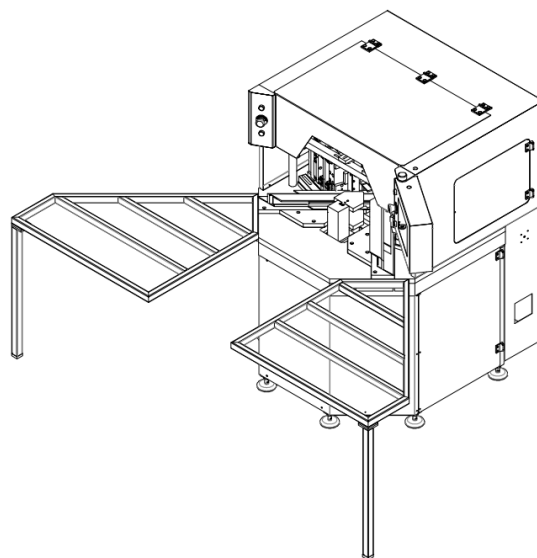
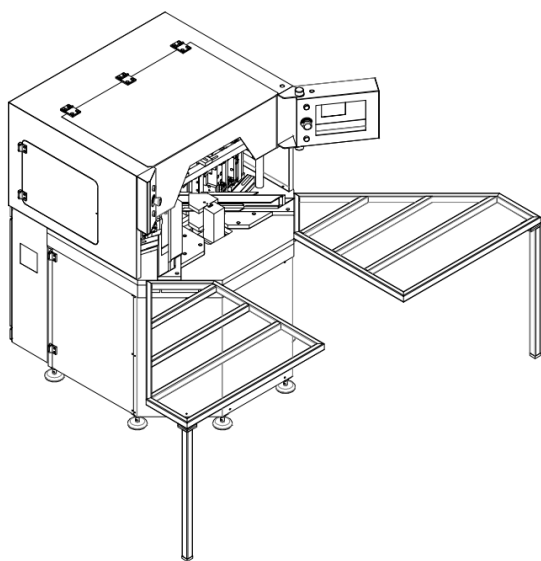




CNC Corner Press



User manual

Contents

Company	4
SAFETY INFORMATION	5
General information	5
Authorized personnel	5
Staff obligations	5
Hazards while using the machine	6
Use according to specifications.....	6
SAFETY INSTRUCTIONS.....	7
Meaning of Symbols and Signs Used.....	7
General information	8
Safety and Warning Labels and Their Meanings	10
Protective Equipment	13
Staff Training	14
Machine operation	14
Safety Precautions During Normal Operation	14
Dangers from Electrical Energy.....	15
Dangers from the Pneumatic System.....	15
Points of particular danger	16
During cleaning.	16
During the replacement of the press blades.....	16
Clamping during baling.	16
SAFETY AREA	17
Emergency stop.....	17
Personal Protection	17
Protection against contact with live parts.....	17
Modifications to the machine	17
Copyright	17
Transport instructions	18
TECHNICAL INFORMATION	18
Machine information	18
Connection information	18

Weight and dimensions	18
Operating temperature of the environment.....	20
Electric.....	20
Pneumatics	21
Installation floor	22
Controls	22
Main switch	22
Emergency stop button	22
Start button (Green)	23
Clamping Buttons (Orange)	23
Orange signal lamp (left)	23
USB Slot	23
MAINTENANCE, REPAIR AND CLEANING	24
Maintenance plan.....	24
Grease Fittings	25
SCREEN OPERATION	26
Home Screen (PRESSING)	26
During pressing	27
Pop-up notifications	27
PROGRAMS	28
CLAMPS	29
REGISTERED PROFILES (Add new profiles).....	30
BARCODE SCANNER	30
COUNTERBLOCK	31
Machine does not move after pressing the start button	32
V-MES	33
PRESS KNIVES	34
Removal and installation of right and left press blades.....	34
Standard knife set	35
Side supports	35
MAXIMUM DIMENSIONS PROFILE	36
MOVEMENT OF THE AXES.....	37

Company

Calvet

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Web: www.calvet.eu

 A circular icon containing a lowercase letter 'i', representing information.	When corresponding with Calvet, please always provide the type of your machine, the serial number and the year of manufacture. Read the instructions carefully before using the CNC corner press. This manual is an original technical document, prepared by Calvet, and is recommended as reference.
--	--

SAFETY INFORMATION

General information

	Read the user manual carefully and make sure you understand everything before using the device.
---	---

For the safe and trouble-free operation of the machine, it is imperative to know and apply the basic safety rules.

This manual contains the most important information you need to operate the machine safely.

All personnel working with this machine must follow this user manual and strictly comply with the safety instructions. In addition, please comply with the applicable rules and regulations for the prevention of accidents in the workplace.

Authorized personnel

The owner is obliged to ensure that only authorized personnel work with this machine. Authorized personnel meet the following conditions:

- Is familiar with the regulations on occupational safety and accident prevention.
- Has received appropriate training for operating this machine.
- Has read, understood and confirmed the warning information in the Safety Manual.

	It is the owner's responsibility to periodically verify that the operating staff is aware of the safety regulations in place.
---	---

Staff obligations

Before starting work, the personnel assigned to the machine must:

- Strictly adhere to the rules on occupational safety and accident prevention;
- Have read the warnings in the "Safety Information" section of this manual;
- Confirm with their signature that they understand this information.

Name: Date:

Signature:

Hazards while using the machine

The **CNC corner press** is designed based on expert knowledge and established technical safety standards. The machine may only be used for:

- Safe operating condition

Improper use of the machine may result in injury, as well as damage to the machine or other property of the owner or third parties.

Use according to specifications

The **CNC corner press** is designed exclusively for pressing (joining) aluminium profiles at an angle of 90 degrees, within the limits indicated on the machine and specified in the technical data.

Any other use is considered improper. Calvet / Artikon cannot be held liable for any damage, loss or injury resulting from incorrect or unauthorized use.

Specification use also includes the following obligations:

- Compliance with all information in this user manual
- Carrying out planned inspection and maintenance work

SAFETY INSTRUCTIONS

Meaning of Symbols and Signs Used

The symbols and signs used in this manual (and listed below) are intended to indicate hazardous situations. They warn the user of possible risks and contribute to the safe use of the machine.

DANGER	
	This symbol indicates a high risk and is represented by the color red. Ignoring this warning could result in death or serious bodily injury.

WARNING	
	This symbol indicates a moderate risk and is represented by the color orange. Ignoring this warning could result in serious bodily injury.

ATTENTION	
	This symbol indicates a low risk and is represented by the color yellow. Ignoring this signal may result in minor or secondary injuries.

INFORMATION	
	This symbol provides tips and useful information to help you make the most of the machine's functions.

General information

- The user manual should always be located in close proximity to the machine so that the operator can access it at all times.
- Do not stand under the machine during loading and unloading.
- Before use, check that all protective devices are correctly installed and functioning properly.
- Only personnel who have been appointed and trained for these activities are allowed to work on the machine.
- The control panel may only be operated by designated and trained personnel.
- The correct placement of profiles on the machine is the responsibility of the operating personnel.
- Operating personnel must wear the necessary personal protective equipment (PPE).
- All safety devices must be checked regularly before starting work.
- Safety devices should only be removed:
 - After the machine has come to a complete stop.
 - After measures have been taken to prevent an unexpected restart of the machine.
- Make sure that the use of the machine does not endanger people in the vicinity.
- The machine should be inspected at least once per shift for visible damage and that the safety precautions are correct.
- No modifications may be made to the electrical and pneumatic system of the machine.
- Work on the electrical and pneumatic systems may only be carried out by qualified personnel.
- Repairs and maintenance must never be carried out during machine operation.
- In the event of malfunctions, the user may not intervene himself; malfunctions must be fixed by a Calvet technician.
- The machine must never be used without an earth connection.
- Before starting maintenance, repair or cleaning work, the main switch of the machine must be switched off and protected against restarting.

- In addition, the main air supply must be shut off, the air pressure reduced and also protected against reactivation.
- Never touch the cables inside the machine.
- The emergency stop button may only be used in an emergency.
- All safety and warning labels on the machine must always be clearly visible.
- Worn transmission parts should be replaced with new parts immediately.
- Do not lean against or apply force to the control panel.
- The machine must always be properly maintained and adjusted; Working with a defective machine is not permitted.
- The machine should only be used in a closed environment.
- The machine must not be used in damp or wet areas.
- No heater should be placed closer than 3 metres to the machine.
- Only use original spare parts.
- The machine should be cleaned regularly.
- Artikon / Calvet reserves the right to make changes to devices, components, parts and hardware of the machine without prior notice.

	It is the user's responsibility to provide the necessary locks to prevent unauthorized engagement of the main switch (electrical) and pneumatic components.
---	--

WARNING	
	Artikon / Calvet does not accept any liability for problems arising from the removal or disassembly of the security devices used.

Safety and Warning Labels and Their Meanings

This symbol indicates that:



The machine must not be operated without reading the user manual and meeting the necessary conditions.



Safety goggles must be worn to protect the eyes from dust and splinters.



Hearing protection must be worn to prevent hearing damage in the future.



Protective gloves should be worn when changing tools and profiles to protect the hands.



A compressed air gun must be connected to the air outlet in question.



The connection is the grounding line.



Informative descriptions about the machine again



Warns of possible health risks or permanent damage to people.



There is electricity available at the location.



Warns of possible crushing hazards.



Warns of cutting hazards when changing blades and indicates that the blades must be completely stationary during the change.



The material is fragile, must be kept upright and protected from rain and moisture (appears on the outer packaging).

This symbol refers to the data and rating plate of the machine.

CE		ARTIKON		CE	
Model		CM 722		Seri No	
				01-2024	
Air Consump		4 lt / cyc.		6-8 Bar	
2.2 kW		380 Volt		50 Hertz	
LENGTH 1165		WIDTH 1120		HEIGHT 1800	
				WEIGHT 1120	
ARTIKON MAKINA SANAYI ve TIC. A.Ş email : info@artikonmakina.com.tr web : www.artikonmakina.com.tr MADE IN TURKIYE					



Protective Equipment

Before starting each operation, the following protective equipment must be present on the machine and function correctly:

- Lockable main switch to prevent unwanted and unauthorized operation of the machine
- Emergency stop button
- Pressure gauges and air pressure sensors to check for connected compressed air supply

The removal of safety equipment is only permitted in the following cases:

- When the machine has come to a complete stop
- After adequate safety measures have been taken to prevent the machine from being restarted

If optional equipment is installed on the machine, the responsibility for the correct installation of the protective equipment lies with the owner.



It is the user's responsibility to provide the necessary interlocks to prevent unauthorised engagement of the electrical disconnect switches.

Staff Training

- Only Calvet technicians are allowed to carry out work on the machine.
- The work areas for which personnel are authorized must be clearly and completely separated, such as: setup/installation, assembly-disassembly, commissioning, operation, programming, maintenance, repair and cleaning.
- Entry-level and apprentice employees may only work on the machine under the supervision of an experienced and trained member of staff.

Machine operation

The warranty is void in the event of any modification to the software of the machine without the prior written consent of Artikon / Calvet.

This provision applies in particular to the following changes made by the customer:

- Operating system changes
- Installation of a new operating system
- Installation of random software (such as Office programs such as Word, Excel or games)
- Driver Installation
- Deleting or modifying system files
- Adding additional hardware

Safety Precautions During Normal Operation

- Do not operate the machine if the safety devices are not fully functional.
- Before switching on the machine, make sure that activating the machine will not endanger other employees in the vicinity.
- At the beginning of each shift, check that all safety devices are visually undamaged and functioning correctly.

Dangers from Electrical Energy

- Only authorized personnel may carry out work on the main body of the electrical installation.
- The electrical parts of the machine should be checked regularly. Loose connections should be secured and damaged cables should be replaced immediately.
- The control box must always be locked. Only authorized personnel should open the cabinet with a key or appropriate tools assigned to them.
- When working on the electrical parts of the machine, a second person must always be present at the main circuit breaker to immediately cut off the power supply if necessary.

ATTENTION	
	If the power supply in which the machine is used fluctuates by more than $\pm 10\%$, a voltage regulator must be used. If this is not complied with, Artikon / Calvet cannot be held liable for any malfunctions or problems resulting from this.

Dangers from the Pneumatic System

ATTENTION	
	The working pressure of the machine is a minimum of 6 and a maximum of 8 bar. Only authorized personnel are allowed to carry out work on the compressed air network, Artikon / Calvet cannot be held liable for any malfunctions or problems resulting from this.

Points of particular danger

During cleaning.

ATTENTION	
	Before you start cleaning the CM 721 Corner Press, make sure that the machine cannot move by moving the main switch to the "0" position. To prevent unauthorized switching on of the machine, lock the main switch with a padlock.

During the replacement of the press blades.

ATTENTION	
	Never put your hands in the working area of the blades while the machine is in operation. To prevent unauthorized starting of the machine, switch off the main switch and lock it with a padlock.
	Always wear protective gloves when working on the machine, especially when cleaning or changing the blades.

Clamping during pressing.

ATTENTION	
	The clamps hold the profile during pressing as soon as the counter block is in position. The clamps are operated with a secure pressure to keep the profile firmly in place. During pressing, the entire working pressure is placed on the clamps.
	Keep in mind that there is a risk of crushing here. Take extra care and keep your hands far away from the clamps.

SAFETY AREA

Emergency stop



The emergency stop button must be used to safely stop the machine in emergency situations. The location of the emergency stop button is shown above.

Personal Protection

Protection against contact with electrical parts

Before maintenance, repair and cleaning work on the machine is started.

Modifications to the machine

Parts of the machine that no longer function properly must be replaced immediately. Only use original spare parts and consumables from Calvet.

If non-original Calvet parts or consumables are used, the manufacturer does not accept any liability or warranty claims.

Copyright

Calvet owns the copyright of this user manual. This manual is intended for use by the operator and associated personnel only.

Calvet is constantly working to improve and develop its products and therefore reserves the right to change technical documents without prior notice.

	The information published in this document is periodically reviewed and necessary corrections will be published in the next edition.
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Transport instructions

Contact Calvet every time the machine is moved.

TECHNICAL INFORMATION

Machine information

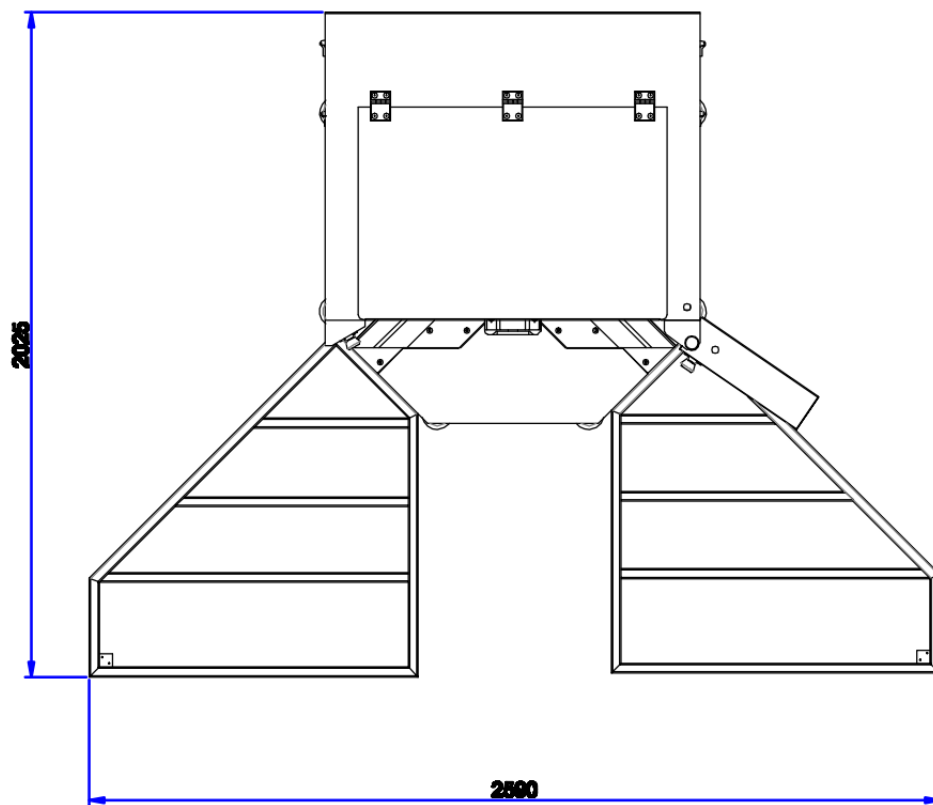
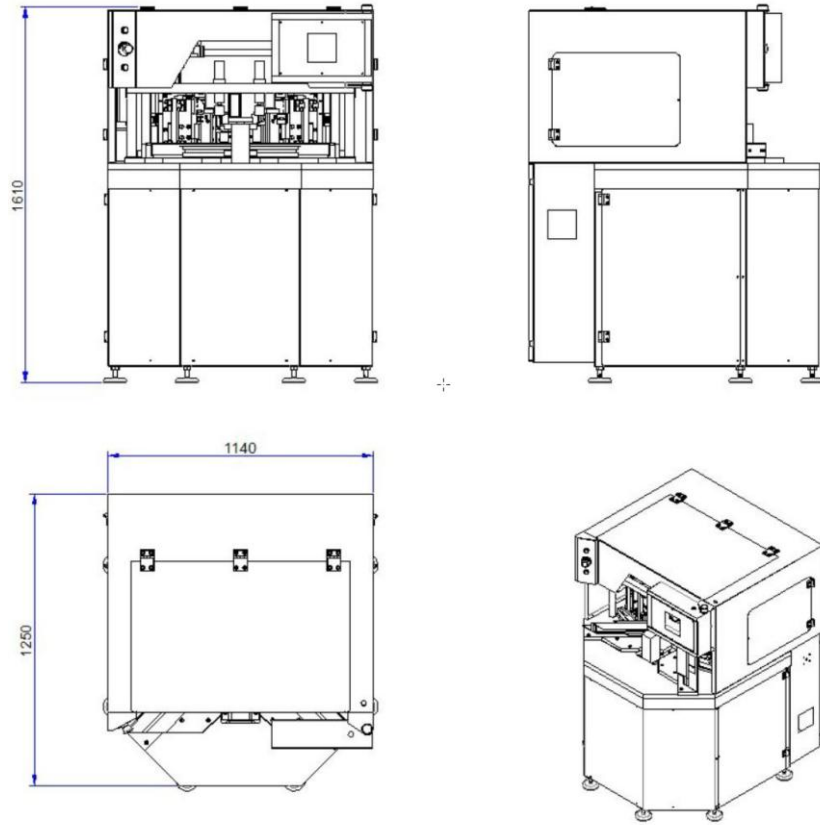
Name	Corner press
Type	CM-721
Serial number	Refer to the license plate on the side of the machine

Connection information

Electric	400V, 3 phase, 50-60Hz
Power	2.2 kW
Compressed air	6 – 8 bar
Air consumption	4 lt / cycle

Weight and dimensions

Length	1165 mm
Width	1120 mm
Height	1800 mm
Weight	1100 kg



Operating temperature of the environment

The machine should be installed in a dry place, protected from frost and sub-zero temperatures.

The permissible ambient temperature is between **10°C and 30°C**.

At temperatures above **30°C**, additional cooling of electrical and electronic components is required.

Electric

- The fuse on the electrical installation of the machine must be 3 x 16 A.

The machine operates on 3-phase 400 V. The color coding of the cables is as follows, according to the applicable standards:

- Phase 1: Black
- Phase 2: Grey
- Phase 3: Brown
- Neutral Conductor: Blue
- Earthing: Yellow green

The machine uses a 5-pin plug (3 phases + 1 neutral conductor + 1 earth) according to the IP44 standard. The socket must also meet this standard.

Pneumatics

- The connection of the machine to the pneumatic system is done via the lubrication unit located on the left side of the machine.
- The pneumatic system to which the machine is connected must be continuously supplied with compressed air between 6 and 8 bar.
- The colors of the pneumatic hoses on the machine are:

- Blue: suction hose
- Black: blow-off hose

1. Unlock the pressure control head:
Pull up on the control knob to unlock it.
2. Adjust the pressure Turn clockwise to increase the pressure. Turn to the left (counterclockwise) to decrease the pressure.
3. Set the correct pressure: Use the pressure gauge to set the pressure between 6 – 8 bar.
4. Re-lock the pressure control head:
When the correct pressure is set, push the button back down to lock it.



Installation floor

It is very important for the performance and accuracy of the machine that the surface on which the machine is placed is as flat as possible.

If the floor is not level, the machine must be aligned and balanced using the adjustable machine feet.

Controls

Main switch

The main switch is the switch that makes it possible to supply the machine with power or to completely shut off the power supply.

This is located at the rear to the right of the machine.



Emergency stop button

The emergency stop button ensures that the machine can be stopped safely. The machine is equipped with two emergency stop devices. There is a stop button. In the event of a malfunction or emergency, the machine must be stopped by pressing the emergency stop button so that all dangerous movements of the machine are immediately stopped.

The machine remains in the off position until the emergency stop button is released. The emergency stop button must not be used as a standard way to stop the machine. The emergency stop button should only be used when absolutely necessary, as too frequent use may have negative effects on some electrical components.



Start button (Green)

The start buttons are located below the emergency stop button. These buttons will light up when a process is in progress or when an action is required.

1. Buttons flashing:

An active process is in progress (e.g. homing).

2. Buttons light up completely:

A manual action is required, such as:

- Press a button
- Two-hand operation: Press and hold both buttons at the same time

Clamping Buttons (Orange)

Work in the same way as the home buttons

1. Flashing:

A process with the clamps or counter block is in progress

2. Fully illuminated:

A manual action is required (such as closing/opening clamps or positioning counter block) Perform action by pressing the button or use two-hand control (if applicable)

Orange signal lamp (left)

Provides information about the status of the machine.

1. Flashes:

One or more axes have gone over their limit.

2. Lights up continuously:

The emergency stop is pressed.



Caution: Always check both situations before restarting the machine.

USB Slot

For connecting a USB stick.

Usage:

When updating the screen.

When updating the library of profiles

Reading the profiles figures.



ATTENTION	
	Do not remove the USB until the update is complete and close the dust cover securely.

MAINTENANCE, REPAIR AND CLEANING

ATTENTION	
	In order to ensure the performance of the machine and occupational safety, it is mandatory to carry out maintenance, repair and cleaning work at the regular times recommended for the machine. To ensure that the machine runs smoothly, the following must be strictly observed: • Correct and appropriate use • Regular and careful execution of cleaning work • Timely and accurate execution of maintenance work

	The recommendations and warnings in the user manual and all documents supplied with the machine must be observed.
---	---

	The following oils are used and recommended for lubricating machine parts: • Lubrication unit: "Shell Morlina 10" High Performance Circulation Oil • Lubrication points (nipples): "Shell Rhodina Grease RL3" Multi-Purpose Industrial Grease Oil
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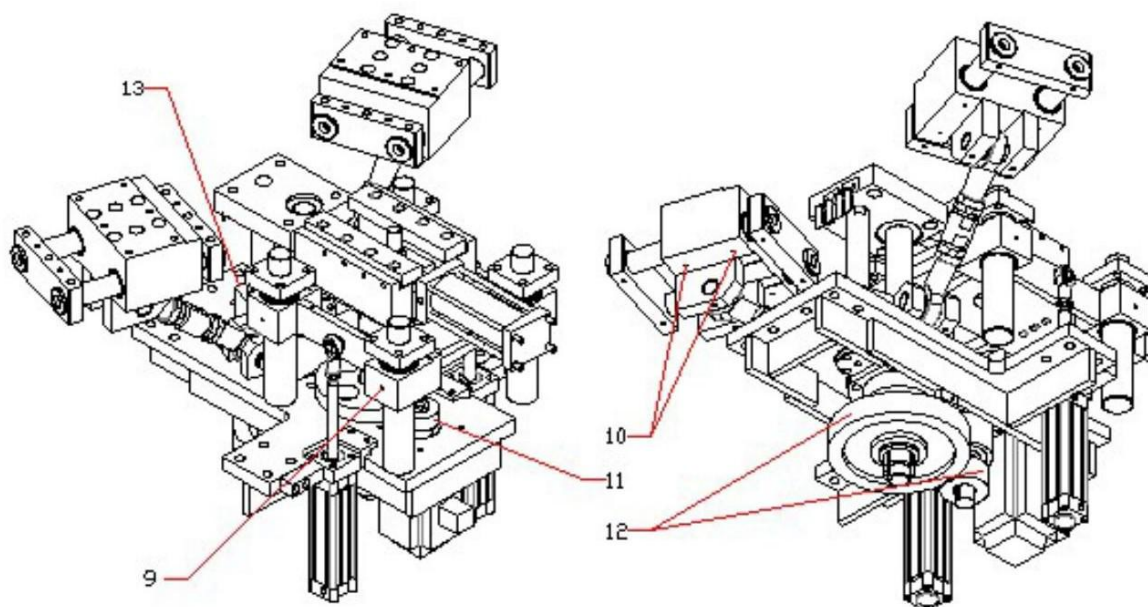
Maintenance plan

No.	Name	Activity	Time	Description
1	General machine	Cleaning	Weekly	Cleaning the machine, blowing off, cleaning, ...
2	Safety	Testing	Daily	Testing the emergency stops
3	Gears, bearings and drive	Lubrication	Annually	Lubrication of gears, bearings and drives
4	Pneumatic	Control	Annually	Checking for cracks in compressed air line

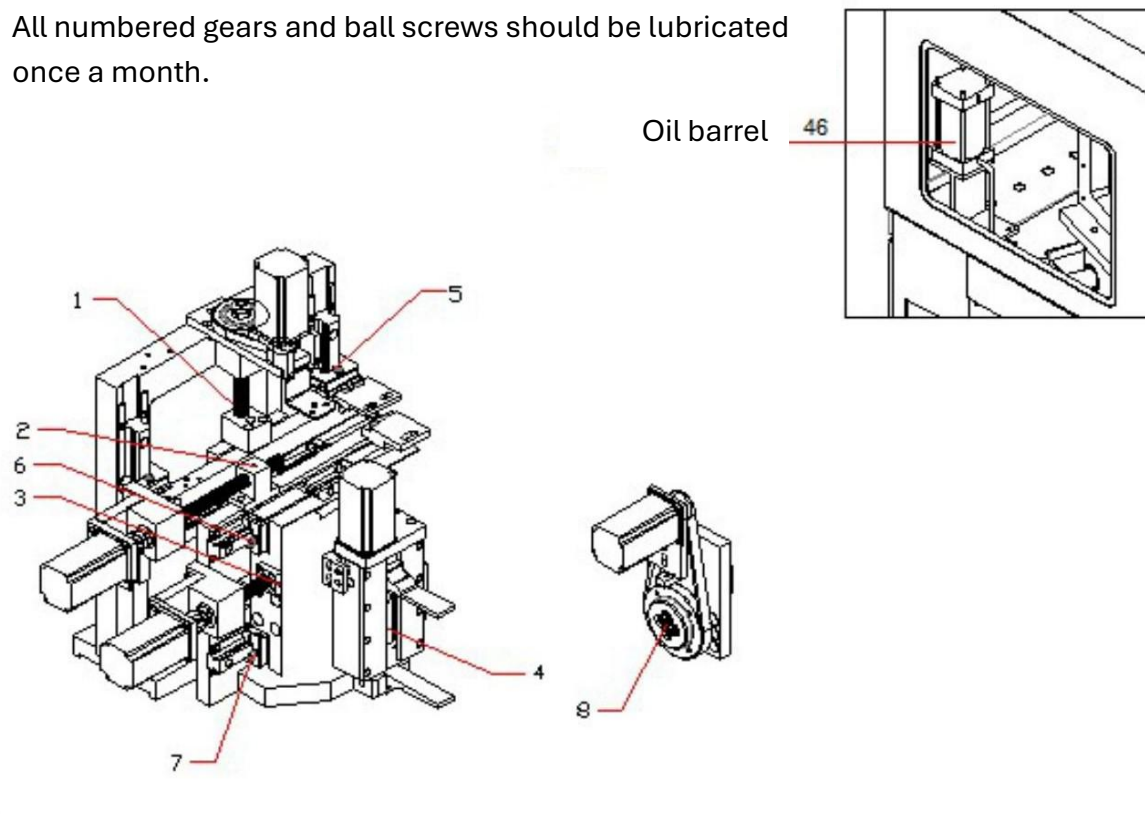
	The maintenance and repair information provided is for a single-shift work schedule. When working in multiple shifts, maintenance intervals must be shortened. To ensure continuity of machine performance and occupational safety, it is recommended to carry out a general maintenance on the machine every year.
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Grease Fittings

All numbered gears and ball screws should be lubricated once a month.

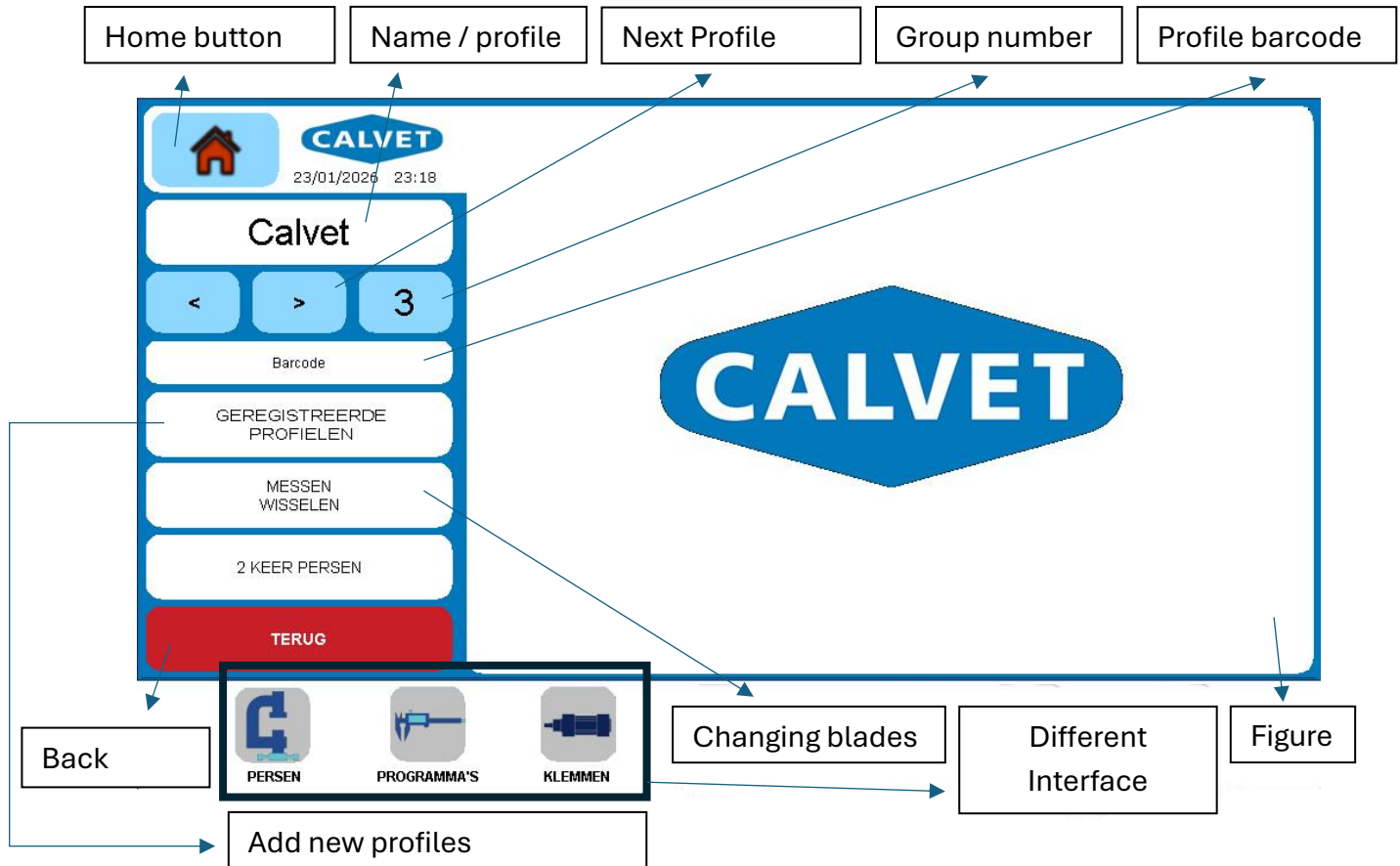


All numbered gears and ball screws should be lubricated once a month.



SCREEN OPERATION

Home Screen (PRESSING)



Group number:

This is the number that is associated with the group of profiles. For example: profiles with the same press settings are placed under the same group number. (Please refer to the bundle provided)

Profile barcode:

Here you enter the linked barcode number that has been linked to the profile.

ATTENTION	
	Back button: This is NOT an emergency stop! This button steps out of the machine's current action.

Reference button:

You have to press this button when starting the machine. With this, the axes record their reference points. Once this is successful, the button will light up green. If you press emergency stop, you will have to perform this process again.

During pressing

On the screen, you will come across different views that you have to follow step by step.

- **Orange spheres:** These are buttons that need to be operated. When these light up, it indicates that you need to press them.
- **Foot Pedal:** Displayed with an icon with an arrow. This clearly indicates whether the pedal should be **pressed** or **released**.

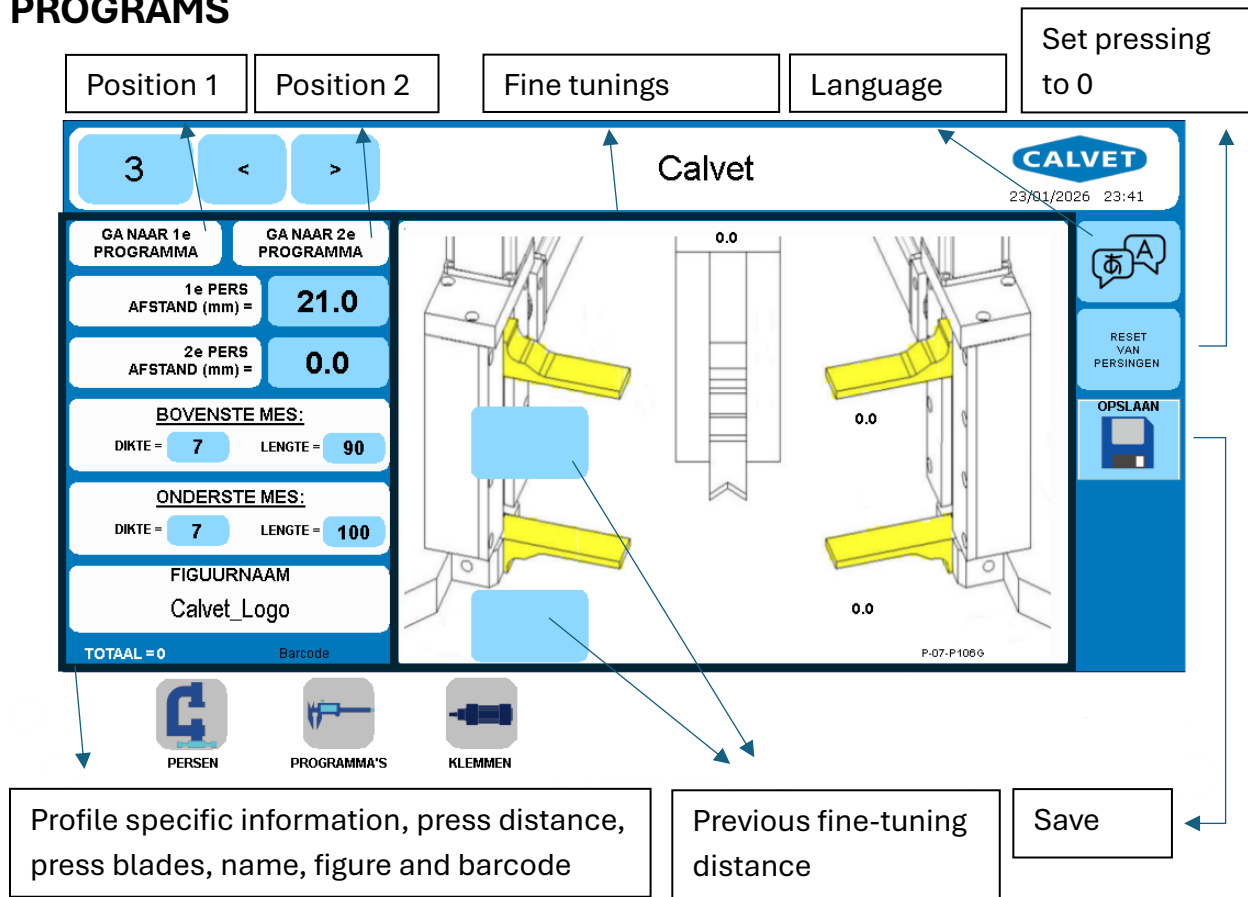
Follow the visual prompts on the screen to operate the machine correctly and safely.

Pop-up notifications

While using the machine, pop-up notifications may appear on the screen. These pop-ups appear in specific actions or situations and contain important information or instructions.

	Always read these notifications carefully and follow the steps indicated. This ensures the smooth, safe and correct operation of the machine. Ignoring these notifications can lead to error messages or unwanted behavior of the machine.
---	---

PROGRAMS



The screenshot shows the 'PROGRAMS' menu of the CNC Corner Press. At the top, there are buttons for 'Position 1', 'Position 2', 'Fine tunings', 'Language', and 'Set pressing to 0'. The main menu area includes a '3' button, navigation arrows, and a 'Calvet' title. Below this, there are sections for 'GA NAAR 1e PROGRAMMA' and 'GA NAAR 2e PROGRAMMA'. The '1e PERS AFSTAND (mm)' is set to 21.0, and the '2e PERS AFSTAND (mm)' is set to 0.0. There are also fields for 'BOVENSTE MES' (DIKTE = 7, LENGTE = 90) and 'ONDERSTE MES' (DIKTE = 7, LENGTE = 100). The 'FIGUURNAAM' is 'Calvet_Logo', and the 'TOTAAL' is 0. A 'Barcode' field is also present. On the right side, there are buttons for 'RESET VAN PERSINGEN' and 'OPSLAAN'. At the bottom, there are icons for 'PERSEN', 'PROGRAMMA'S', and 'KLEMMEN'. Annotations with arrows point to various elements: 'Position 1' and 'Position 2' point to the top buttons; 'Fine tunings' points to the '3' button; 'Language' points to the 'Language' button; 'Set pressing to 0' points to the 'Set pressing to 0' button; 'Calvet' points to the title; '23/01/2026 23:41' points to the date and time; 'RESET VAN PERSINGEN' points to the reset button; 'OPSLAAN' points to the save button; 'Profile specific information, press distance, press blades, name, figure and barcode' points to the main menu area; 'Previous fine-tuning distance' points to the '1e PERS AFSTAND (mm)' field; and 'Save' points to the 'OPSLAAN' button.

Position 1 and 2

These are the preset pressing distances that the blades will take up during pressing.

Fine adjustment

With this function, the position of the press blades can be precisely adjusted. The value **"Previous fine adjustment distance"** indicates which adjustment was previously made. When the arrows are pressed, the machine immediately performs the adjusted movement.

Profile specific information

In this menu, the pressing distances can be adjusted for profiles that e.g.: a deeper pressing. In addition, the profile name and visual information about the press blades can also be entered here.

	This information is for information purposes only and does not affect the operation of the machine.
---	--

CLAMPS

Activating and deactivating the clamps, H/L pressure valve for safety pressure

Extension time from counter block without

Operating counter block, up / down and front / behind also the blockade for making counter block stand still

High/low pressure valve

The high/low pressure valve ensures that the clamps first clamp at a safe, lower pressure. This significantly reduces the risk of crushing.

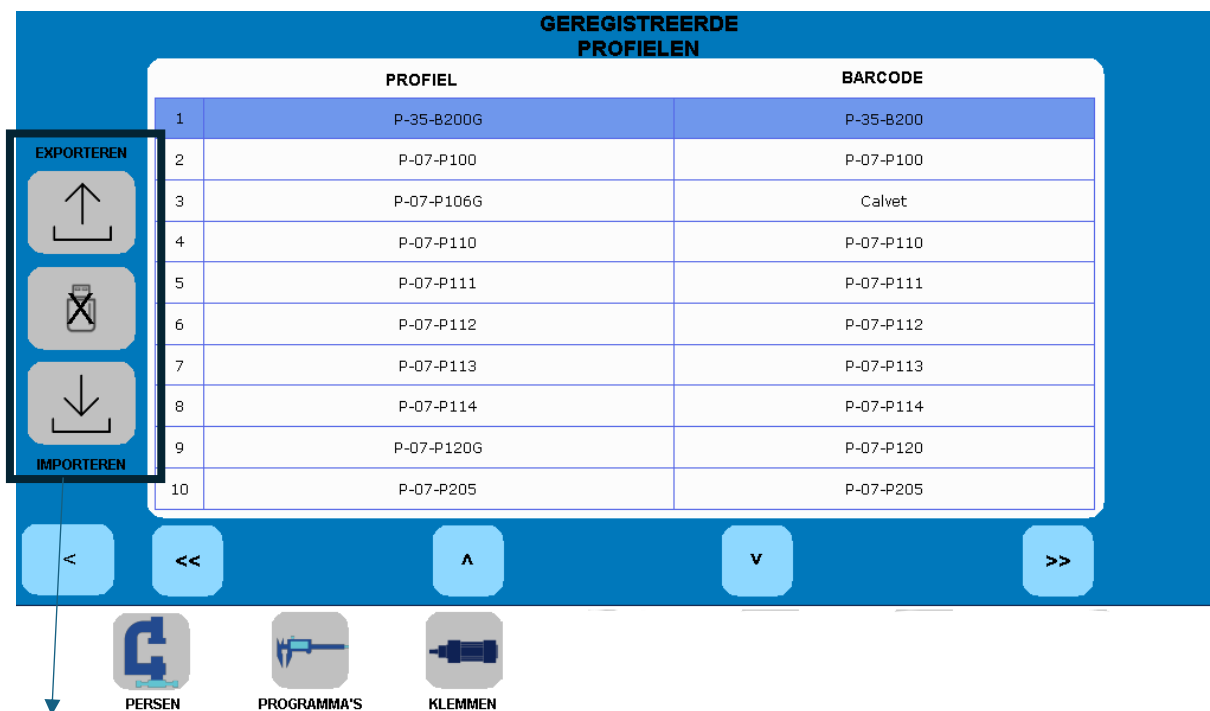
Blockage at counter block

The blockage at the counter block ensures that the counter block stays firmly in place during pressing, so that it cannot move backwards.

Extension time

A safe default value is set for the extension time to ensure that every profile, regardless of thickness, is clamped correctly and securely.

REGISTERED PROFILES (Add new profiles)



Reading new profiles / writing profiles

USB usage for profile updates

Insert the USB stick containing the new profiles into the USB port of the machine. Then choose **"Export to USB"** or **"Transfer to Machine"**. The system will automatically read or write the data to the USB stick or machine.

Password: 1731

Make sure the USB flash drive is pre-formatted before adding a new program or profile. This prevents error messages and saves time when looking for problems with the USB.

BARCODE SCANNER

The barcode scanner is offered as an optional feature. This function makes it possible to automatically recall the desired program by entering the barcode information for the "Name" field in the lists section of the screen.

	This allows a profile to be easily and quickly recognized and loaded via the barcode.
---	--

COUNTERBLOCK

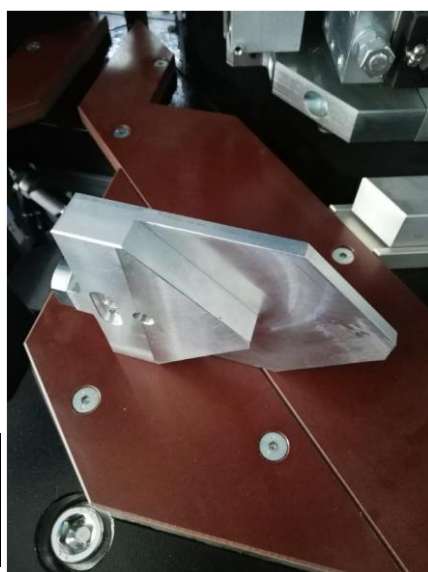
The V-blocks are mounted as single or double, depending on the type of profile to be pressed. The upper and lower counter block can be moved separately via the screen / manually with an Allen key 4.

ATTENTION	
	Before moving the blocks, you must first loosen the set screws on the V-blocks.

If you move the blocks without first loosening the set screws, the coupling piece will be heavily loaded. As a result, they will bend and no longer tighten firmly.

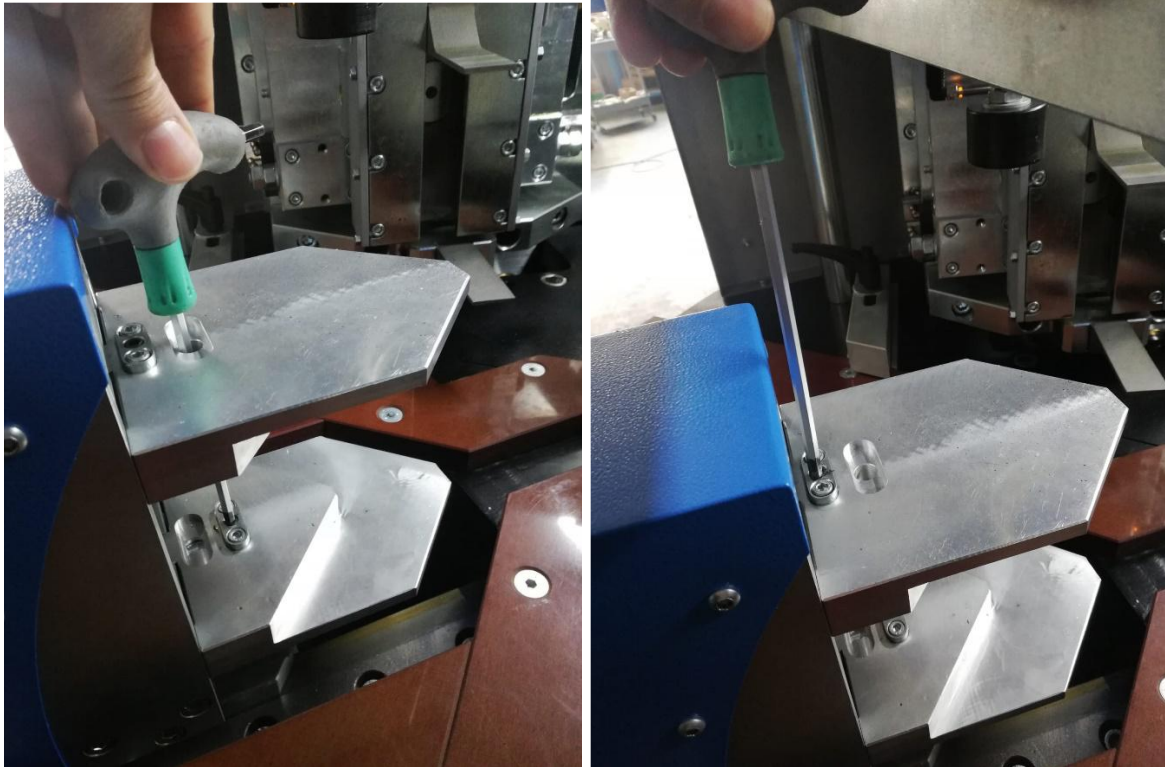
The upper and lower counter blocks are supplied as standard with the machine. Depending on the type of profile, these can be mounted straight or reversed. The mounting direction depends on the profile and can be chosen by the user.

	For clarity of the image, we recommend leaving counter blocks How they are included.
---	--



In that case:

Manual	Automatic
First, loosen the set screw.	First, loosen the set screw.
/	Then press the reference button.
/	Wait for the machine to return to the zero position.
Only then can you recreate the settings.	Only then can you recreate the settings.
Don't forget to tighten the set screws properly after the adjustments.	Don't forget to tighten the set screws properly after the adjustments.



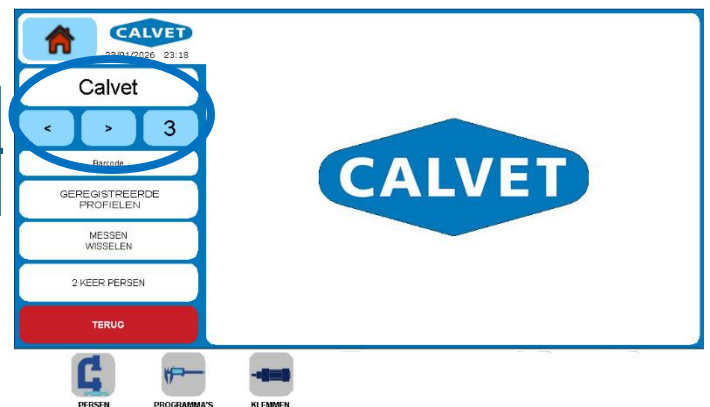
Machine does not move after pressing the start button

If the machine does not move after pressing the start button, it may be due to the fact that the machine thinks that no active program has been loaded.

Solution:

1. Select a different profile from the list.
2. After that, return to the desired profile.

This situation usually arises because the synchronization between the screen and the PLC has not been complete or not on time.



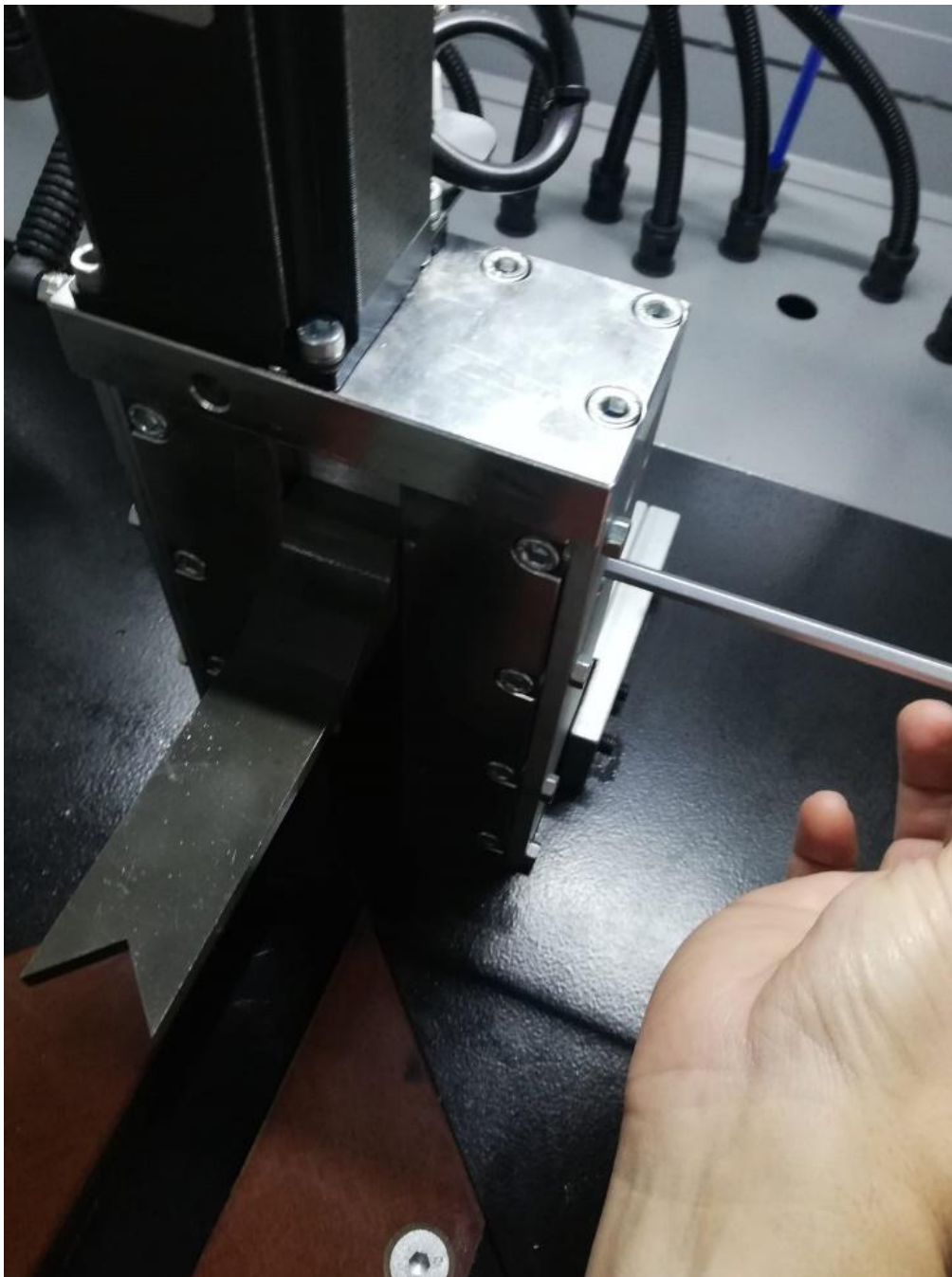
This is a known and harmless problem, and reloading the profile usually fixes it right away.

V-KNIFE

To remove the V-blade, loosen the set screw with Allen wrench 5 on the right side, as shown in the picture.



The blade must be in the reference position (home position) in order to remove it safely.



PRESS KNIVES

Removal and installation of right and left press knives

The press blades are removed by loosening the adjustment screw with Allen key 5 (as shown in the figure).



The upper blade will only enter the disassembly position when the machine is in the reference position (home) or has been pressed on "change blades".

ATTENTION



After removing the blade, the adjusting screw must be re-tightened in the idle position.

Do not let the adjusting screw hang loose if no blade is fitted. This can lead to damage to the bearing surface inside the blade holder.



Standard knife set

The machine comes standard with a set of 12 blades, consisting of:

- 2 pieces of 3 mm – length 90 mm
- 2 pieces of 3 mm – length 100 mm
- 2 pieces of 5 mm – length 90 mm
- 2 pieces of 5 mm – length 100 mm
- 2 pieces of 7 mm – length 90 mm
- 2 pieces of 7 mm – length 100 mm

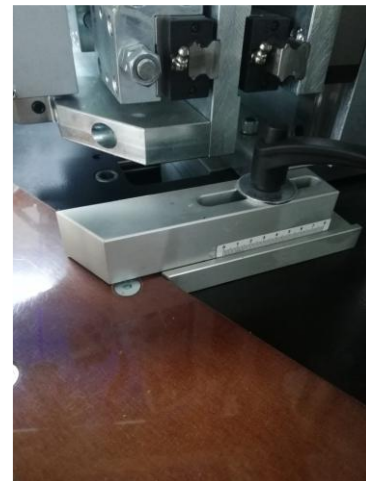
	In general, the 100 mm blades are mounted at the bottom and the 90 mm blades at the top.
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	When the cutting edge of the press blades is worn out, they can be turned over and reused on the other side. This doubles the lifespan of the blades.
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Side supports

There are two side supports on the right and left side of the machine's trespa plates.

These supports are intended to accurately center the profile to be pressed. For correct pressing operation, the profile must be centered symmetrically.

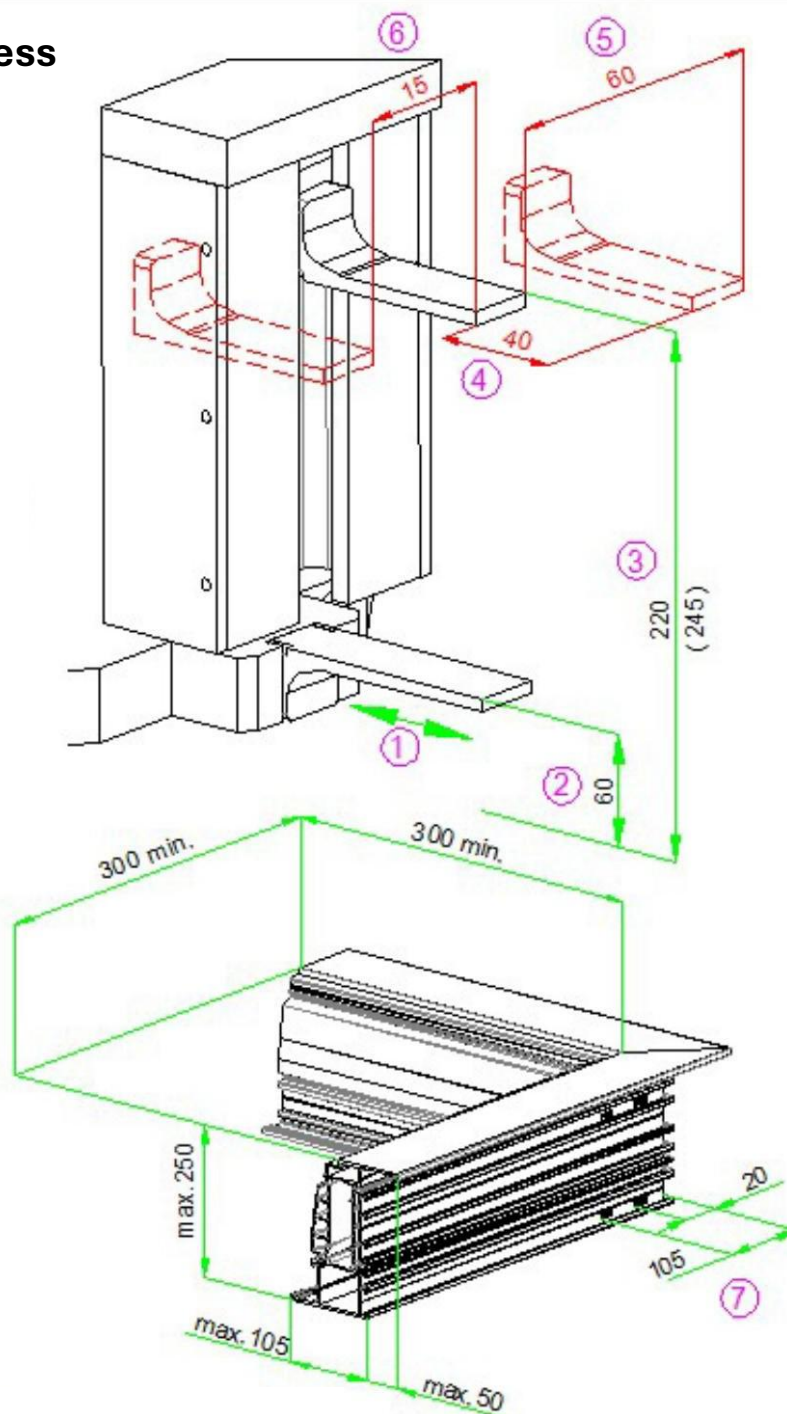


ATTENTION	
	If the profile is not properly centered, the pressing will be too deep on one side and insufficiently deep on the other.

	Make sure you adjust the side bolsters correctly to ensure an even and flawless press.
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MAXIMUM DIMENSIONS PROFILE

CNC Corner Press



1. Press movement
2. Lower pressing knife vertical movement
3. Upper pressing knife vertical movement
4. Upper presser knife forward movement
5. Upper press knife backward movement
6. Upper press knife forward movement
7. Automatic double pressing without moving profile

MOVEMENT OF THE AXES

