



Model 710



Model 730



Model 720

**700 Series
Finishers
Operation
Manual**

700 Series Finisher Machinery Manual

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**EC DECLARATION OF CONFORMITY OF
MACHINERY / ELECTRICAL APPARATUS TO THE
SUPPLY OF MACHINERY (SAFETY) REGULATIONS 2008 AND THE
ELECTROMAGNETIC COMPATIBILITY (EMC) REGULATIONS 2006**

- 1 Standard Engineering Ltd. of 10 Garrard Way, Telford Way Industrial Estate South, Kettering, NN16 8TD is the manufacturer of the following machine: -

- 2 Model
Serial No.

- 3 This machine complies with the requirements of "The Supply of Machinery (Safety) Regulations 2008" and the Machinery Directive 2006/42/EC.

- 4 This apparatus conforms with the requirements of EN 50081-2 in respect of Electromagnetic Emission.

- 5 This machine complies with the relevant essential Health & Safety requirements

- 6 The person authorised to sign the declaration on behalf of the Company is the Managing Director

Date of Issue: 6.4.18

Keith Malyon
Managing Director

Machine

Model 700 / 710 / 720 / 730 Finishing Machine

Markings

The machine is marked with the following: -

Name and address of manufacturer, machine series, serial number and year of manufacture.

**Standard Engineering Ltd.
10 Garrard Way, Telford Way Industrial Estate South
Kettering, Northamptonshire, England, NN16 8TD**

C.E. Mark: -

C.E. _____

Markings on the front flap: -

“Switch off and allow tools to stop turning before lifting the flap.”

Markings at the scourer dust entrances: -

“SPARK GUARD - PLACE OVER RELEVANT VENT IF THERE IS ANY DANGER OF METAL SPARKS ENTERING THIS M/C! NO KEYS!”

Marking at the Emergency Stop button: -

“Emergency Stop”

Electrical Marking at rear of machine: -

“This machine MUST be earthed”

Electrical data: -

Phase	1	Phase	3
Volts	230	Volts	400
Amps	25	Amps	9
Load	3.88kw	Load	3.88kw
Hz	50	Hz	50

Machine

Model 700 / 710 / 720 / 730 Finishing Machine

Markings - continued

Marking for the bag shaker activator: -

“Bag shaker operating knob.”

Electrical safety marking under front flap: -

“Tested for electrical safety”

Mass of machine - 390kilos

Dimensions: -

700 / 710 / 720 Finishers

1232mm W (plus additional 150mm for manual tumble on brush section)
x 780mm D x 1720mm H

730 Finisher

1232mm W (plus additional 150mm for manual tumble on brush section)
x 780mm D x 1480mm H

Handling

Push back the front of the machine at a point above the centre of gravity (approx. 900mm high and 600mm in from the left of the machine) to lift the front base, and insert a lifting device under one end of the machine.

Use lifting device to raise one end of the machine and insert roller.

For short distance movement push at end of machine on roller (s). For longer distance movement insert wheeled trolley or set of corner wheels, and remove roller (s)

When in position required, reverse the above procedure.

Commission

The machine shall stand firm and level. Use suitable packing material as necessary to level, balance and secure the machine.

Position machine at least 100mm - 150mm from a rear wall to enable the filter bag to remain clear of the wall when inflated.

The machine shall be connected by a competent person to the electrical power supply and earthed through a suitable, lockable isolator conforming to IEC 204/EN 60204. The electrical data are given on a plate attached to the machine, and are as follows: -

Model 700 / 710 / 720 / 730 with Manual Brush & Pad Turret

	1-phase	3-phase
Volts	230V	400V
Amps	25 amps	9 amps
Hz	50Hz	50Hz

Model 700 / 710 / 720 / 730 with Electrical Brush & Pad Turret

	1-phase	3-phase
Volts	230V	400V
Amps	25 amps	9 amps
Hz	50Hz	50Hz

External Electrical Conductors are colour-coded as follows: -

1-phase		3-phase	
Earth	Green/Yellow	Earth	Green/Yellow
Neutral	Light Blue	Neutral	Light Blue
Live	Brown	Live	Brown
		Live	Black
		Live	Grey

(Pre - 2008) External Electrical Conductors are colour-coded as follows: -

1-phase		3-phase	
Earth	Green/Yellow	Earth	Green/Yellow
Neutral	Light Blue	Neutral	Light Blue
Live	Brown	Live	Red
		Live	Yellow
		Live	Blue

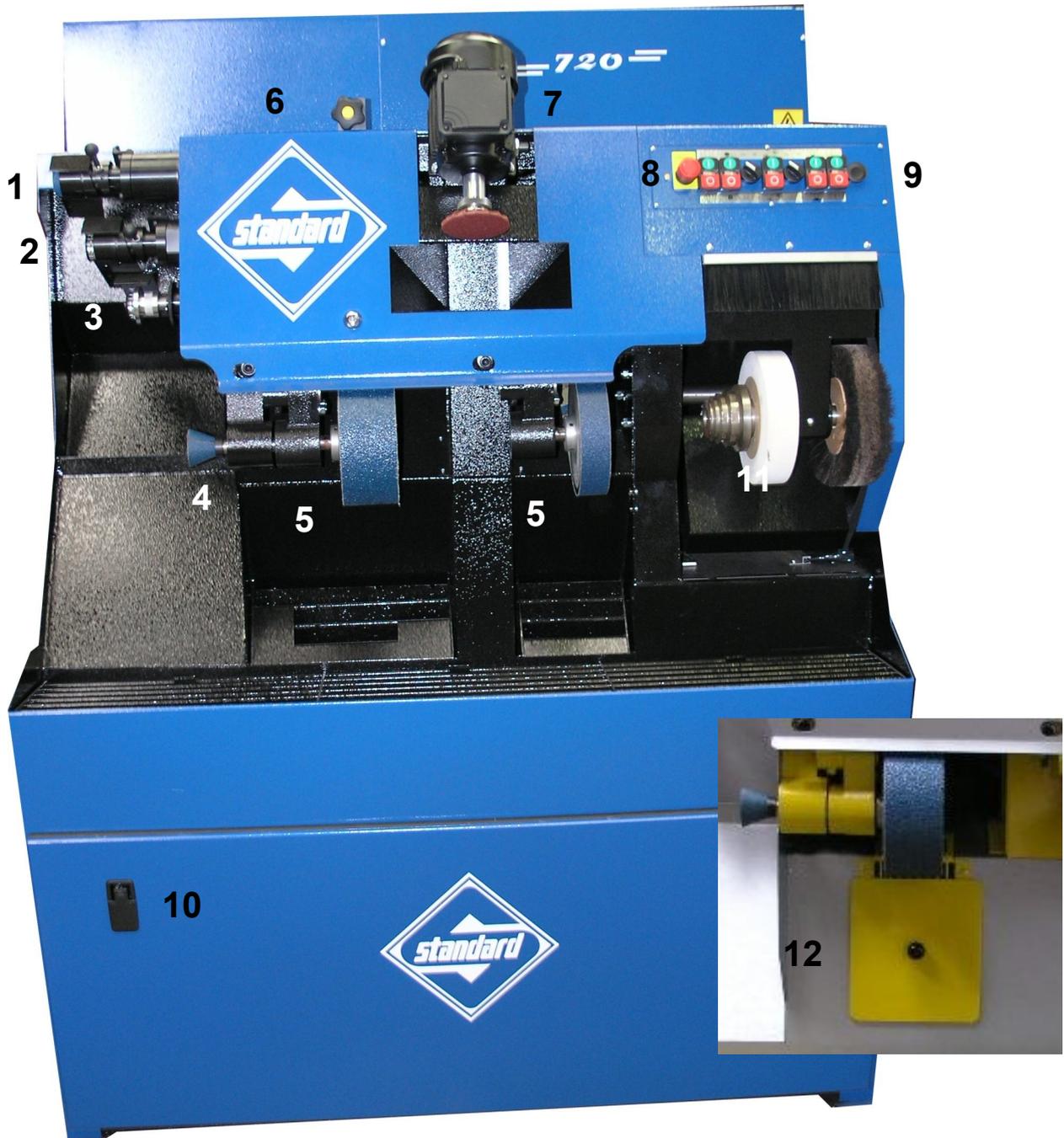
Internal Electrical Conductors are colour-coded as follows: -

Earth	Green/Yellow
Neutral	Light Blue
Live Power Circuit	Black
Live Control Circuit	Red

For 3-phase machines only, check for correct mains phase connection by testing the Naumkeag. This should run clockwise when viewed from below.

Machine Data

The machine is designed for use in the manufacture and repair of footwear, orthopaedic footwear and leather and imitation leather goods. The machine is generally as per the following photograph: -

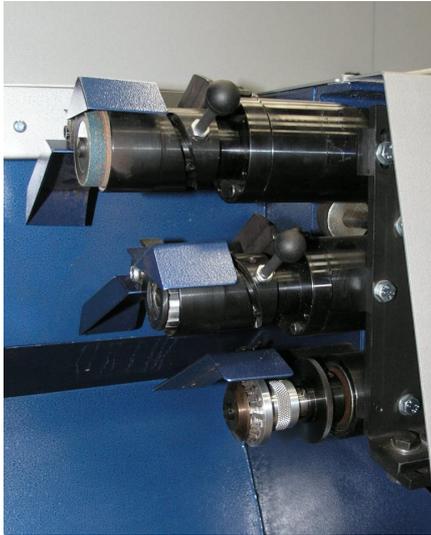


- 1 Heel Roll (if fitted)
- 2 Toppiece Trimmer
- 3 Forepart Trimmer
- 4 Breaster
- 5 Scouring Bands
- 6 Filter Bag Shaker

- 7 Naumkeag (not Model 730)
- 8 Emergency Stop
- 9 Starter Buttons
- 10 Access to Dust Collection Trays
- 11 Brush & Polishing
- 12 Spark Guard (Models 710/730)

Safety Features

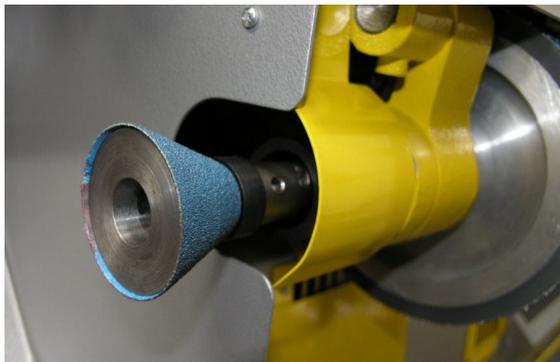
The machine must only be used with all safety devices and guards in place and adjusted correctly to reduce any risk.



Trimmer V-belt Guards

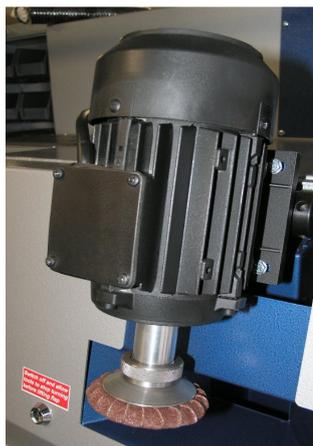
Trimmer Tool Guards

Trimmer Ventilation Inlet



Breaster Guard (inner and outer)

Ventilation inlets to enable dust to be Extracted from scouring operation



Naumkeag Guard on shaft (a protective sleeve prevents accidental gripping of the naumkeag shaft)

Naumkeag Ventilation Inlet

The Emergency Stop will stop all electronically controlled equipment on the finisher. To reset, the red knob must be twisted and released.



Thereafter all electrical controls must be restarted as required.

Electrical Controls of 710

Safety Features - continued



Brush / Pad Drive Belt Guard

Brush and Pad Ventilation Inlet

Noise

With all tools operating and the dust extraction system operating the noise emission at a point 1.6 metres high and 1 metre from the centre line of the machine will be in the region of 80-82dB(A)

Dust

The dust extraction system provides an air flow velocity at the face of each dust capturing duct when all ducts are open and all tools are operating as follows: -

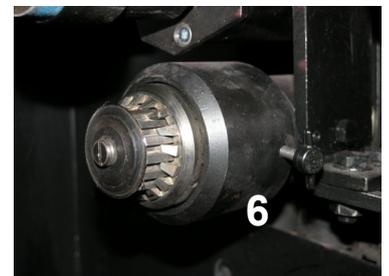
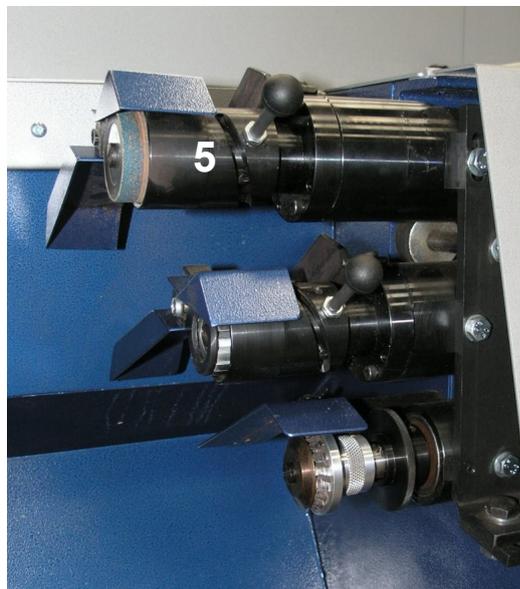
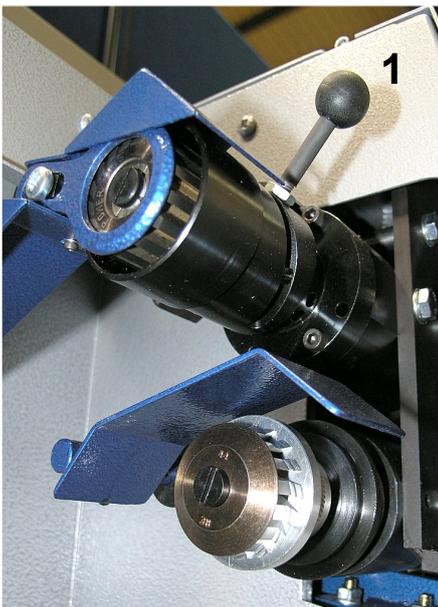
Naumkeag	1.5 mps
Trimmer Section	7.0 mps
LH Scouring Band	6.5 mps
RH Scouring Band	4.5 mps
Polishing Section	2.6 mps

Use of the Machine Part 1

Manual Controls - mechanical which can be operated when mechanism running or stationary.



- 1 Toppiece Cutter Guide Screw
- 2 Band Alignment Screw x 2
- 3 Brush & Pad Turret Positioning handle
- 4 Dust Extraction Cover (710/730)
- 5 Optional Toppiece Scouring Roll Guide (fitted as standard on Model 720)
- 6 Old-style Adjustable Forepart Trimmer Adjustment Lever

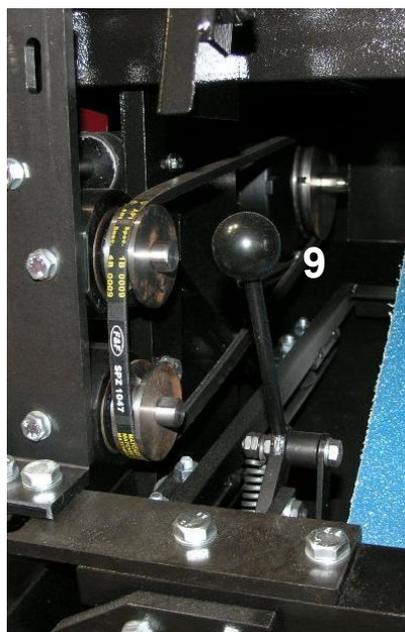


Use of the Machine Part 2 - continued

Manual Controls - **mechanical must only be operated when the machine is switched off and isolated.**



- 6 Upper Waste Tray
- 7 Main Waste Tray
- 8 Dust draw sealing levers (in sealed position) This may vary for older models
- 9 Band tension release lever x 2 (ensure front flap is lifted and secured with gravity restraint)



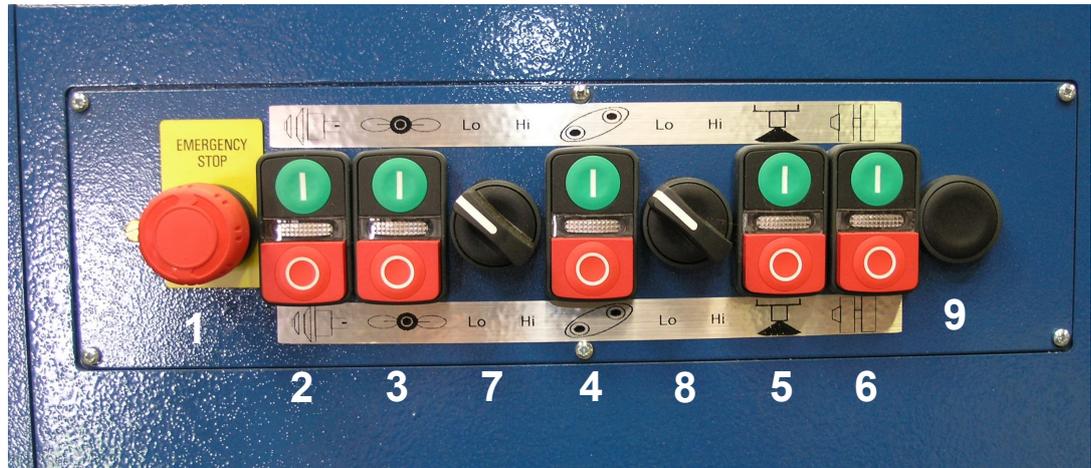
Use of the Machine Part 3

Manual Controls - Electrical

Model 710

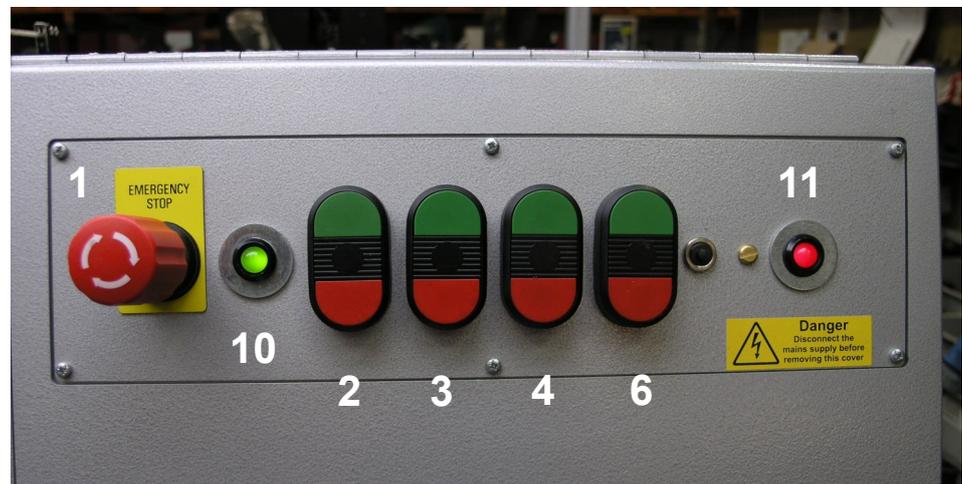


Model 720



Model 730

Green button activates the tool, whilst the lower red button stops the electrical power



- | | | | |
|---|----------------------------|----|-------------------------------------|
| 1 | Emergency Stop Button | 7 | Extraction Hi / Lo (Model 720) |
| 2 | Cutters Control | 8 | Scourer Hi / Lo (Model 720) |
| 3 | Extraction fan control | 9 | Button for Electric Tumble (option) |
| 4 | Scourer / Breaster control | 10 | E/Stop deployment indicator (730) |
| 5 | Naumkeag control | 11 | Power to M/C indicator (730) |
| 6 | Brush Pad control | | |

In case of emergency, push the Emergency Stop button which immediately cuts off the electrical power from all the rotating tools. To be able to use the machine again the E/Stop needs to be rotated, until it “clicks” out.

Use of the Machine Part 3

Important measures to be aware of: -

Danger areas which MUST be switched off when not in use: -

- **Abrasive Bands**
- **Trimming Tools**
- **Breasting Cone**
- **Naumkeag**
- **Brushes**
- **Pads**

Note that the wearing of loose clothing including sleeves and ties should be avoided. Long hair should be controlled.

Wear safety eye protectors to prevent eye injury from particle ejection from abrasive tools, etc.

Do not grind metal objects on the scouring band / cone / pad areas

Fire due to incandescent particles or molten material igniting dust within the dust extraction system. Note that this risk can be reduced by covering the extraction holes under the scouring rolls when incandescent particles and / or molten materials are being produced.

When the machine is not in use it is recommended that it is completely switched off and isolated.

Adjustment and Maintenance

Always ensure the machine is completely switched off and isolated before carrying out any adjustment and maintenance work, i.e. band changing, breaster, naumkeag, trimmer cutters, dust removal, filter bag changing, brush, pad and edge iron replacement.

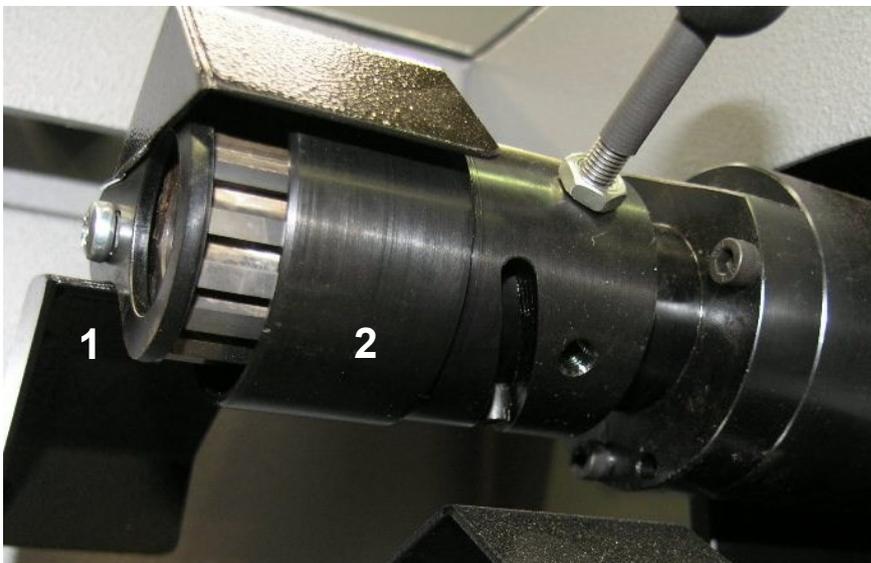
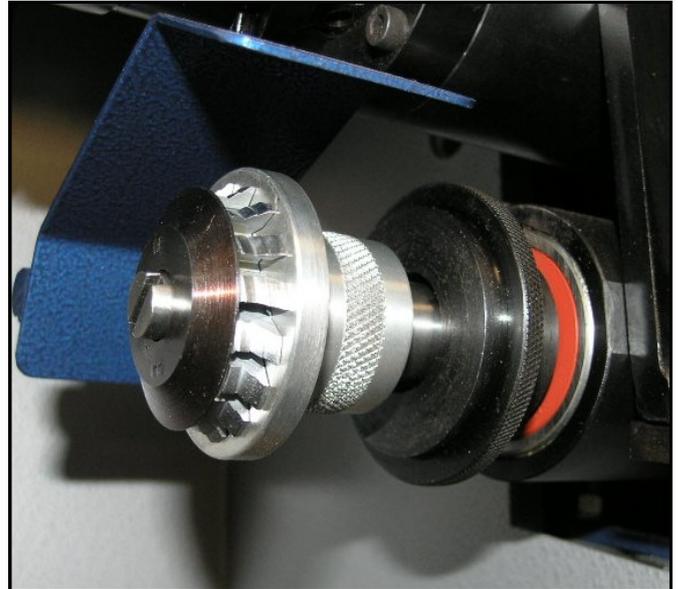
Trimming Section

Forepart Trimmer

The Forepart Trimmer is fitted on a bayonet and can be removed by turning in a clockwise direction.

Replace cutter by removing the left-hand binding screw, and withdrawing from expanding thimble. Reassemble new cutter using reverse procedure.

Assemble on the machine in anti-clockwise direction.



Toppiece Trimmer

The Toppiece trimmer has an edge guard (1) which is adjustable. It also has a sliding guard (2) which is adjustable to heel widths whilst the machine is running. To remove cutter take off the edge guard (1). Loosen and remove the left-hand threaded binding screw and washer.

Insert new cutter and reassemble using reverse procedure.

Additional and Optional Trimmer Section Items

Always ensure the machine is completely switched off and isolated before carrying out any adjustment and maintenance work.

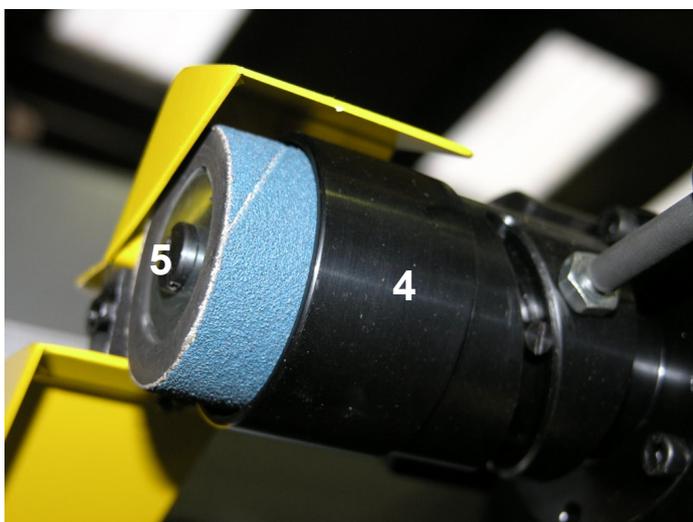
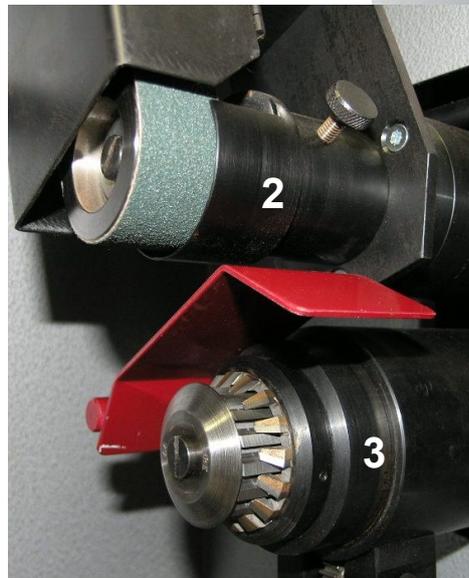
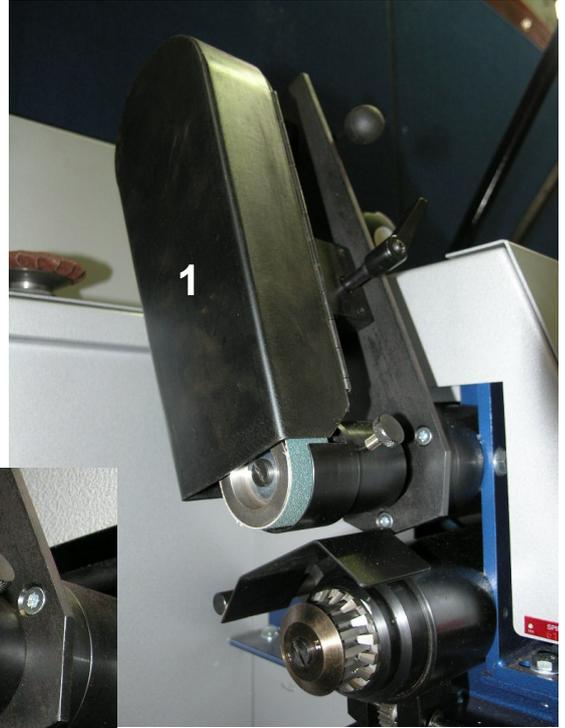
The Toppiece Scouring Band

AKA "The Mini Band"

The Mini Band has a guard over the band (1). It also has a sliding guide (2), which is adjustable to heel widths whilst the machine is running.

The Adjustable Forepart Trimmer (3)

To remove the cutter and shield loosen and remove the left-hand binding screw and withdrawn. Replace with new cutter.



The Toppiece Scouring Roll

AKA "The Mini Roll"

The Mini Roll has a sliding guide (4), which is adjustable to heel widths whilst the machine is running.

To remove the mini-roll loosen and remove the left-hand binding screw (5) Replace band by same procedure.

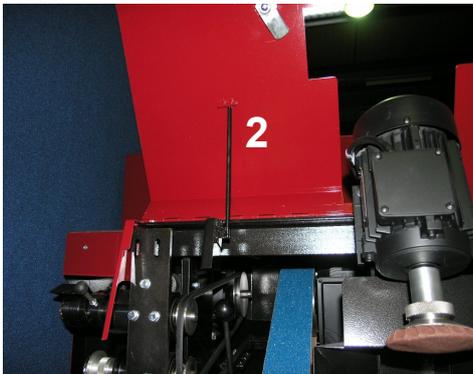
Always ensure the machine is completely switched off and isolated before carrying out any adjustment and maintenance work.

The Scouring Section

The Heel Breaster

The Heel Breaster is mounted on a bayonet fitting. To remove hold the breaster shaft with the tommy bar (in kit), loosen and remove the left-hand binding screw and withdraw breaster. Replace the breaster by the same method.

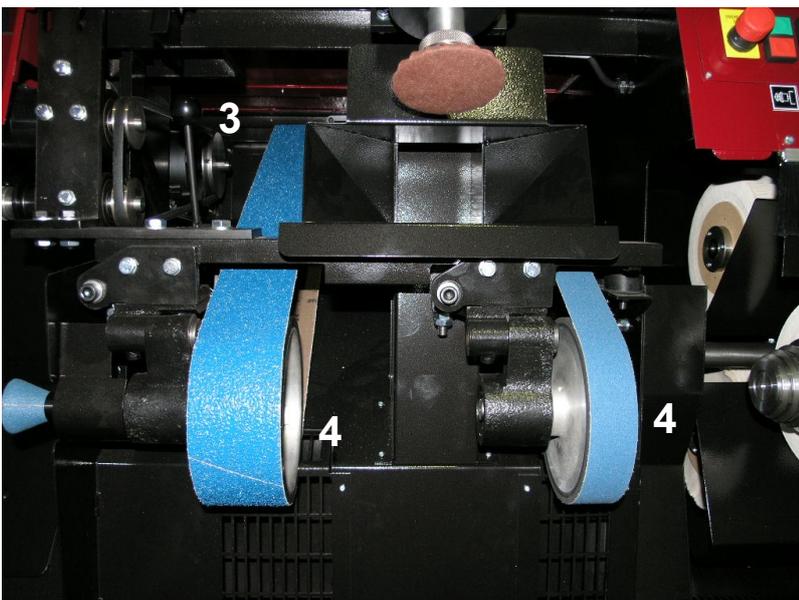
Hole for tommy bar as shown (1)



Scouring bands

Firstly, on models which have a front mounted Naumkeag motor, make sure this motor is lowered before opening the front machine flap.

To change the bands unlock and lift the front cover and secure by means of the flap prop (2). Pull tension levers (3) forward. Slip the old band off the rear driving pulley and front contact wheels (4). Replace bands ensuring it will run in the same direction as arrow printed on the inside of the band. Re-tension the bands by releasing the tension levers.



Lower the front cover and re-lock. Spin bands by hand to ensure that there is approximate band alignment. Switch on the machine and adjust band alignment by means of the adjusting screws with the large tommy bar provided.

The Naumkeag Motor

On Models which feature a front mounted Naumkeag Motor, it can be adjusted for optimum working position by means of a pivot nut and either a bar or spanner.

A replacement naumkeag paper can be fitted by unscrewing the top nut (2) and plate away from the pad.

Replace a new paper by the same procedure. Only replace the paper when the machine is switched off and isolated.



Simple Machinery Maintenance & Tips

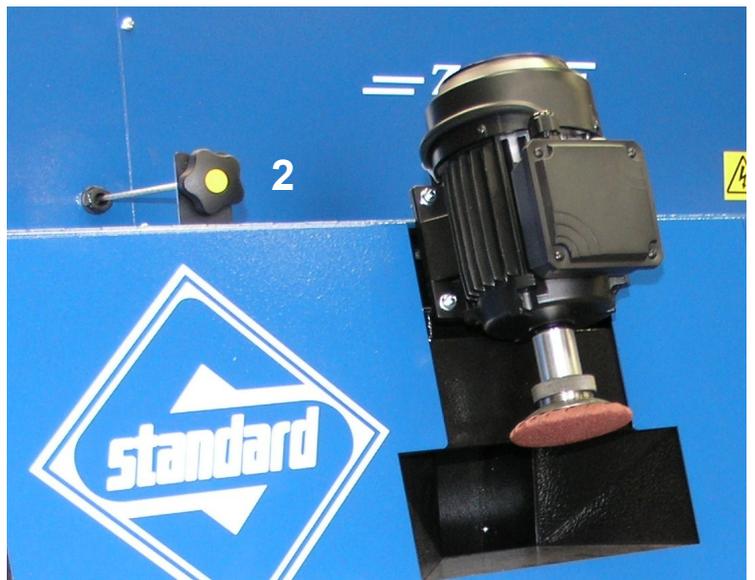
The 700 Series of finishers will give many years of effective service provided the operator employs a few simple maintenance regiments: -

Dust and Extraction

The 700 series extraction system relies on the extraction of dust from the working area through the fan impeller into the lower of two waste trays (1) via the filter bag fitted to the rear of the machine. If this filter bag becomes clogged up with dust the suction will greatly diminish.

To help move as much of the dust through the system and into the waste collection tray we strongly recommend pulling on the bag shaker cable (2) several times during the working day (whilst the extraction motor is OFF). This action encourages most of the dust and fine particles to fall into the waste tray. This tray should be emptied at the end of the working day. The machine must be switched off and isolated before releasing the tray.

The metre per second (m.p.s.) extraction rates given at the front of this manual are standard rates across the range of machines and during the machine operation when all dust ports are open. To increase extraction rates at the required machine section deploy the included shield (s) at vents not in use.



Noise

It is worth noting that the noise of any finishing machine does not occur separate from its environment. For example, a room with tall ceilings can echo the noise produced. Similarly, a wooden floor may reverberate the sound produced. A sloping floor may effect the operational quality.

Poorly maintained machinery may become noisier over time. Not replacing blunt cutters or worn bands can increase the effort being expended by the finisher and thus create more noise.

The noisiest part of the finisher is the wide scouring band. To ensure this part of the machine is running at optimum efficiency please ensure that there is no build-up of particles on the rear pullies and front contact wheels. These particles can greatly increase the running noise of the and section.

Simple Machinery Maintenance & Tips

Noise - continued

Other methods of noise reduction on the 700 range of finishers can be such things as: -

- Fitting the 75mm wide scouring band with a 40grit band rather than a 24grit band. This reduces the harshness of the tooth of the band cutting through the air, and consequently the noise generated
- Fitting anti-vibration matting under the machinery (available from Standard)
- Do not leave the finisher running unnecessarily

Standard recommend a service visit every 1-2 years to ensure the machine is running as best it can, and the replacing of the filter bag approximately 24 months (or less if the machine is in a particularly busy environment) to give optimum performance.

Fire Prevention - Methods of reducing fire risk includes: -

- Clear all scraps of leather and rubber from both machine waste trays every evening.
- Machine not to be used to scour metal! The only exception being heels with metal pins. Show caution and deploy spark guards provided to scour these as the sparks from this action can ignite leather debris inside the body of the finisher. In this instance the particles can smoulder for hours before catching on fire.

Nomex Filter Bags

All of our machinery is now fitted, as standard, with the Nomex version of our traditional filter bags. This material will resist burning for many hours, and even, then is likely to “scorch” or melt rather than catch fire. This will give the operator far more time to remove himself and his customers from the shop, and advise the relevant authorities.

Fire Knock Out Canister

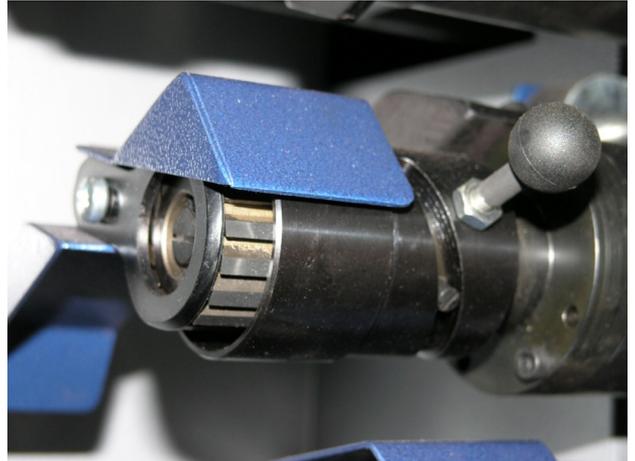
If your machine is fitted with this message it indicates that the finisher is fitted with “Fire Knock Out”. This is a canister fitted within the filter bag, which, should it be introduced to naked flames will explode, releasing fire extinguishing agents to prevent the fire from spreading. This canister will only detonate when introduced to burning material and is otherwise inert and safe.



Simple Machinery Maintenance & Tips

Checking of the setting of the Heel Cutter

Before commencing use of the heel cutter ensure the heel cutter guide is set to your operational requirements. The guard should be as close to the cutter as possible, and lined flush to the area of the cutter at between “3 and 6 O’clock”. To move the guard loosen the bolt to the rear, adjust to suit and tighten.



Cleaning the Machine

Household proprietary cleaners are ok to use provided they are not bleach based. Multi-purpose cleaning products should be acceptable and safe to use.

Bearings running hot?

Hot running of bearings can sometimes be an issue for the first week or two of regular use before they settle down. If in doubt after this period please contact our Service Desk on 01536 517 070.

Brush Section

A monthly oil or WD40 between the tumble brush boss and the machine body will aid the continued smooth performance of the tumble section.



Standard recommend a service visit every 1-2 years to ensure the machine is running as best it can, and the replacing of the filter bag approximately 24 months (or less if the machine is in a particularly busy environment) to give optimum performance. During the service our engineer will check the noise and dust emissions. He will ensure all motors are running well and that the cutters, bands and brushes are all fine. He will also check the condition of the filter bag.

700 series - Common Consumables and Parts

Scouring

WA14758	1500mm x 75mm x 24Grit Scouring Band
WA14749	1500mm x 40mm x 80Grit Scouring Band
POW183330323	Naumkeag Cap 90.G60
POW144705338	Naumkeag Rubber 510150140 for the above Cap
WA14767	Breaster Cone 50x20x40 60G
WBAZ432	Breaster Centre
WBAZ433	Breaster locking ring
WBAZ434	Breaster Adaptor
WBSD551	Left Hand Round Head Screw for tool attachment

Optional Scouring Items

WBAZ445	Mini Roll COMPLETE
WA14772	Mini Roll 80G scouring roll
WA14732	Mini Band 25 x 600 x 80 Grit (if mini-band fitted)

Cutters

WBFM1719A+	Forepart cutter adaptor (needs the cutter)
WA06033	3mm C374-1C-45 CZA-366E Cutter (6 Iron)
WA06036	5mm C374-1C-45 CZA-266E Cutter (10 Iron)
WA06040	8mm C374-1C-45 CZA-278E Cutter (16 Iron)
WA06042	10mm C374-1C-45 CZA-284E Cutter (20 Iron)
	(Other sizes available - up to 14mm)
POW202001806	18mm Steel Heel Cutter
POW202090183	18mm Heel Trimmer Tungsten Widia Cutter
WBFM4411	AFT Cutter complete
WBFM4417CPTE	New Style TCT Groover on bayonet
WBFM4418CPTE	New Style TCT Groover on short bayonet (TSR)
WA06137ASS	WBAZ 451 TCT Groover Cutter Blade (new spec)

Brushes / Pads / Contact Wheels etc

GOT89999026	WBAZ 385 Machine Brush
WA06139	WBAZ 414 Linen Waist Pad
WA06104	WBAZ 238 Cotton Mop
WA06153	WBAZ 419 Contact Wheel 75mm
WA06152	WBAZ 420 Contact Wheel 40mm

Filter Bags

WA09112	Dustbag – Fire Retardant
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